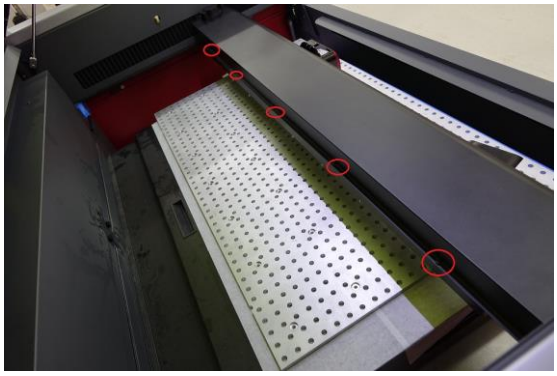
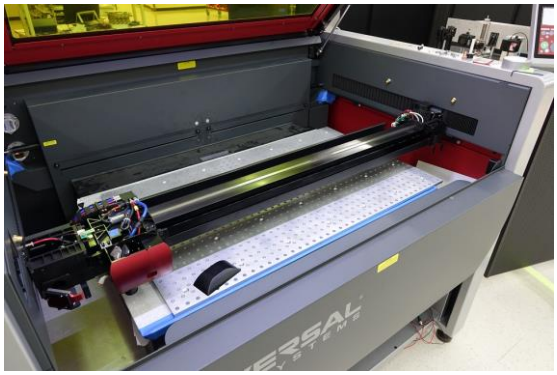
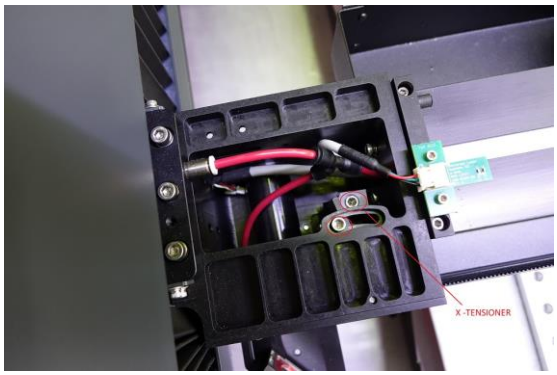
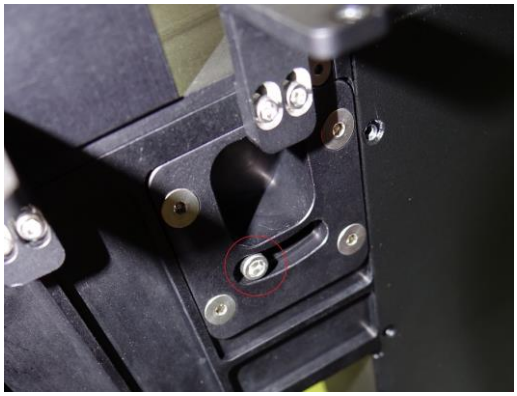
Instructions for tensioning X and Y Axis of XLS Machine.

X Axis:

1. Remove motion system cover by removing the 7 screws located in the back.
   1.1.
   1.2. 
2. Use the belt tension meter to verify the frequency (tension). To measure the X axis tension the carriage must be pushed all the way to the left or right side of the rail.
   2.1.
   2.2. 
3. Loosen the 2 #8 screws (one on top and one on bottom). Use the other #8 screw to increase the belt tension. The belt tension should be 35-40 hz with the carriage pushed all the way to one side. Once this is done, tighten the 2 bolts again and back the tensioner wedge off by 1/8th turn to prevent deformation on the delrin.
   3.1. 

3.2. 

Y Axis:

4. Remove both upper side panels using the T shaped latches. Remove both lower side panels by removing the 2 #10 screws located on each side.
   4.1.
   
5. Use the belt tension meter to verify the frequency (tension). To measure the Y axis tension you must use the top of the belt loop. This belt length is constant so the X axis position does not matter. The tension meter can be used at an angle to get at the belt to measure the tension.
   5.1.
   
6. Use the ¼" bolt to increase the tension of the Y axis belt. The belt tension should be 45-50 hz. If there is no gap left the belt tension cannot be increased and a tooth will need to be removed from the belt.
   6.1.

6.2.