WARNING: function or procedure described in this manual is not to be performed. Always use extreme caution and common sense when maintaining and operating this product. If you are unsure about ANY function or procedure described in this manual, DO NOT operate. Contact STEPCRAFT product support for assistance.

WARNING: This is a desktop 3D-system that can hold tools with sharp blades that spin at very high RPM or tools getting really hot. Always use extreme caution and common sense when maintaining and operating this product. If you are unsure about ANY function or procedure described in this manual, DO NOT operate. Contact STEPCRAFT product support for assistance.

WARNING: Always ensure you are operating the tool a safe distance, 3 feet (1 meter), away from yourself and others.
CONTENTS

1  General notes.................................................................................................................................................6
  1.1  Information and explanations for the operating instructions .................................................................6
  1.2  Additional instructions / manuals ...............................................................................................................6
  1.3  Description of the machine .......................................................................................................................6
  1.4  Intended use ...............................................................................................................................................7

2  Safety ...............................................................................................................................................................7
  2.1  General notes...............................................................................................................................................7
  2.2  Responsibility of the operator and working safety ....................................................................................7
  2.3  Personal protective equipment ..................................................................................................................8
  2.4  Environmental conditions ..........................................................................................................................8
  2.5  Commissioning of the system control and the system-guided tools ......................................................8
  2.6  Operator ....................................................................................................................................................9
  2.7  Emergency-Stop switch .............................................................................................................................9
  2.8  Remaining risk .........................................................................................................................................9

3  Structure and function ..................................................................................................................................9
  3.1  Designation and functions of the component parts ..................................................................................9

4  Commissioning ...............................................................................................................................................10
  4.1  Installing the machine ...............................................................................................................................10
  4.2  Environmental conditions ........................................................................................................................10
  4.3  Electrical connection of the machine .........................................................................................................11
  4.4  Optional accessory ....................................................................................................................................11
    4.4.1  System-guided tools ..........................................................................................................................11
    4.4.2  Additional accessory ..........................................................................................................................11
  4.5  Machine table ..........................................................................................................................................12

5  Machine operation .........................................................................................................................................12
  5.1  Operator ....................................................................................................................................................12
  5.2  Work piece ..............................................................................................................................................12
  5.3  System-guided tools ................................................................................................................................13
    5.3.1  Drilling / milling spindle .....................................................................................................................13
    5.3.2  Cutting knife .......................................................................................................................................13
    5.3.3  Hot cutter .........................................................................................................................................13
    5.3.4  Engraving point / plotter pen ............................................................................................................13
    5.3.5  3D print head ...................................................................................................................................13
  5.4  Emergency-stop switch ..............................................................................................................................14
  5.5  Operation of the system / operating elements .........................................................................................14
1 **GENERAL NOTES**

1.1 **INFORMATION AND EXPLANATIONS FOR THE OPERATING INSTRUCTIONS**

This manual serves to make you familiar with a desktop CNC-/3D-system and to impart you all necessary information which you require in order to be able to operate the machine safely and professionally.

This manual is applicable for the desktop CNC-/3D-systems STEPCRAFT 210, STEPCRAFT 300, STEPCRAFT 420, STEPCRAFT 600 and STEPCRAFT 840, hereafter referred to as STEPCRAFT.

Please read this manual completely before the first commissioning of your machine.

**CAUTION:** In order to minimize the risks of injury and/or material damages please only commission the machine and the corresponding control when you are sure that you have completely understood these instructions!

Please contact us for any further questions. Please find our contact data on item 10.3 of these instructions.

Please always keep these instructions nearby the machine. You should always have them readily to hand when you want to look up something.

**CAUTION:** Please only use this machine according to its intended use (refer to item 1.4).

We cannot be held liable for persons or material damages which are caused by using the machine other than the intended use, handling which does not comply with the common use of a CNC machine or if safety regulations are not obeyed (refer to item 2).

In case of lacking maintenance (refer to item 8) and/or wrong operation of the individual components your warranty claims are omitted.

We reserve the right to perform future technical enhancements on the machine and its components.

1.2 **ADDITIONAL INSTRUCTIONS / MANUALS**

**NOTICE:** Beside the operating instructions there are two additional documents available:

- Assembly manual – refer to this document if you must assemble the machine or if you need to assemble a spare part
- First steps – refer to this document before you operate the machine the first time. The document explains the installation process of the software and guides you to your first work piece (milling).

**CAUTION:** If you are not familiar with computerized tools you should go through the First steps guide step by step BEFORE first commissioning.

1.3 **DESCRIPTION OF THE MACHINE**

The STEPCRAFT machines are desktop CNC-/3D-systems for machining wood, plastics or nonferrous metals. The systems are based on a specially developed aluminum extrusion containing numerous functions (e.g. guiding, drive, protection against dust, etc.). It is very stable and torsion-resistant due to its angular shape.

The machine has three axes which are offset by 90°. In this way it is possible to travel to any point within the working range. Each axis is equipped with a stepper motor and a reference switch. The stepper motor precisely drives the mobile axes elements by means of a threaded spindle. It is possible to use the control in order to adjust the position of the axis with the help of the reference switch.

The machine table consists of a High Pressure Laminate (HPL) with a thickness of 8.0 mm. You can fix the work piece directly on the table with the clamping system delivered.

The STEPCRAFT-System consists of different central components. In order to use a ready-to-operate CNC machine the following additional components are required:

1. Control / main board (integrated, see connection panel on the back of the machine) with USB- or parallel module
2. System-guided tools with a shank diameter of 43.0 mm / 1.69 inch, e.g. a milling spindle, drag knife, 3D print head, or any other tool with a shank diameter of less than 43 mm / 1.69 inch with a suitable clamping adapter, i.e. CNC plotter pen.
3. Control software with cycle direction output signals, i.e. WinPC-NC or UCCNC
4. Suitable PC
5. Connection cable

Please find further information for optional accessory under item 5.6 of these instructions.

1.4 INTENDED USE

The STEPCRAFT machine series is designed for private users (e.g. model-makers) and piece productions or productions of small series in the industrial area. It is not suitable for the production of large series or to integrate it in production lines.

The torsion-resistant structure allows to process plastic materials, wood and non-ferrous metals. The following manufacturing methods are possible:

- Machining, i.e. milling, plotting, cutting, engraving, scratching
- Generative manufacturing process like 3D printing
- Every type of process that requires a precise 3D positioning, i.e. measuring, dosing

2 SAFETY

Beside the general safety precautions and warnings there are additional safety notes important to consider.

2.1 GENERAL NOTES

**CAUTION:** Please read this manual completely before the first commissioning of your machine! Any person operating this machine must have read these instructions! In order to minimize the risks of injury and/or material damages only operate the machine and the corresponding control when you are sure that you have completely understood the instructions!

Please do not hesitate to contact us for any further questions. Please find our contact data in item 10.1 of these instructions.

Please always keep these instructions nearby the machine. You should always have them readily to hand when you want to look up something.

**WARNING:** Please only use this machine according to its intended use (refer to item 1.3). If the machine is not used as intended there is a risk for persons and of material damages!

**NOTICE:** It is not allowed to modify and/or retrofit the machine unless this has been expressively authorized by us in individual cases.

The STEPCRAFT is designed and constructed according to the currently applicable state-of-the-art.

2.2 RESPONSIBILITY OF THE OPERATOR AND WORKING SAFETY

When you operate the machine you should have the minimum age of 14 years and be technically experienced.

Always keep children out of the vicinity of this product well out of the reach of children.

Being the operator you are responsible that you have read and understood all relevant operating instructions of the machine and all relevant accessories and to keep them nearby the machine.

**CAUTION:** You have to make sure that you operate the machine only when it is in a technically proper status.

**WARNING:** The emergency-stop switch and if applicable other safety equipment must always be well attainable and operable.

**CAUTION:** Being the operator you have to wear the personal protective equipment described under item 2.3 when you work on the machine.
WARNING:
- In particular when performing setting works on the machine or the control or on the system-guided tools, i.e. milling spindle, 3D print head, please disconnect the machine from the mains!
- Do not touch the insertion tools or motors as they can become extremely hot during use.
- Always make sure to have sufficient clearance to the mobile parts (guiding, milling cutters, shafts) and never grasp with your hand into the machine. This may result in severe injuries!
- Never hold the work piece (in order to measure it to process it or for any other purposes) while the machine is running. There is a high risk of injury!
- Never hold the work piece to be processed only with the hand but always firmly clamp the work piece. Otherwise there is a high risk of injury!

Depending on the field of application of the machine (private or industrial use) please observe the correspondingly applicable regulations for occupational safety, safety and accident prevention as well as environmental protection.

2.3 PERSONAL PROTECTIVE EQUIPMENT

WARNING: While working with the machine, wearing of safety glasses as well as safety gloves is prescribed and necessary!
- Safety goggles (to protect the eyes against chips flying off at high speed, etc.)
- Protective gloves (to protect the hands against cuts, abrasions, etc.)

Furthermore do not wear any clothes which might get caught in the machine (ties, scarves, shawl, wide sleeves, etc.) and do not wear any jewelry in particular no long chains and rings.

CAUTION: Milling jobs can cause a lot of noise. Wear hear protection to protect the ears against hearing damages!

2.4 ENVIRONMENTAL CONDITIONS

The machine is only suitable to be operated inside!

NOTICE: Position the machine on a solid plane substructure in order that is stands safely and can neither slip nor tilt over.

Make sure that there is sufficient space around the machine in order that you can work comfortably and that the machine can fully extend to its traveling paths. Also keep sufficient clearance to possibly nearby positioned machines.

Provide for sufficient illumination of the machine site and the working place surrounding the machine.

Place the PC which controls the machine nearby the machine so that you can have an eye on both.

All instructions for the machine and its components must be nearby.

Always avoid water exposure to all equipment not specifically designed and protected for the purpose. Moisture causes damage to electronics.

Store the system and all components in a dry and warm environment between 18°C to 25°C, from 64°F to 77°F respectively.

2.5 COMMISSIONING OF THE SYSTEM CONTROL AND THE SYSTEM-GUIDED TOOLS

WARNING: In order to safely and professionally commission the electronic control of the system and possibly additionally built-in components, please imperatively read the operating instructions of the individual components completely before the first commissioning of the whole system.

WARNING: Always check the emergency-stop switch before operating the machine (see item 2.7) and don’t rely on the start/stop function of the control software exclusively.

Check if the individual components are perfectly connected with each other before the first commissioning and in regular intervals later on.
Furthermore, check before each use of your machine if it is supplied with current and if required if the compressed air is working perfectly.

**NOTICE:** Don’t connect the machine to the computer if you don’t intend to use the machine.

**CAUTION:** Always ensure all clamping accessories for insertion tool, machine guided tool and work piece are secure before use.

### 2.6 OPERATOR

The person operating the machine should be no less than 14 years old and technically experienced. All persons operating the machine must have completely read and understood all relevant operating instructions. Each operator must get familiar with the electronic control of the machine as well as with the used control software before the first use of the machine.

**WARNING:** Each operator must have personal protective equipment.

Each operator must operate the machine and its components with due prudence and due expertise which is necessary for the use of CNC controlled milling machines.

### 2.7 EMERGENCY-STOP SWITCH

The emergency-stop switch is located at the front side of the machine (refer to the schematics under item 3.1 of these operating instructions).

The Emergency-Stop is released by pressing the switch. In this way the power supply of the control is interrupted. Furthermore, the control software receives the signal to stop the working process. The machine stops immediately.

**WARNING:** The emergency-stop switch can only affect the standstill of all components if they are connected. This is ensured if you use the milling spindles and the controller made by STEPCRAFT.

**CAUTION:** If you use any third party products such as e.g. another controller you are responsible yourself to connect the Emergency-Stop switch professionally with your controller. Otherwise there is a risk for persons and material damages! Also if you would like to use a system-guided tool like a milling spindle of another supplier which is equipped with a separate ON/OFF switch and is NOT controlled via the PC you have to make sure that it is professionally connected to the emergency-stop switch.

**WARNING:** If you do not observe this it will continue running even if you actuate the emergency-stop switch. Also here there is a risk for persons or material damages!

Please do not hesitate to contact us for any further questions!

Please find further information regarding the Emergency-Stop switch under item 5.4 of these instructions.

### 2.8 REMAINING RISK

**CAUTION:** In spite of all preventive measures there is always a remaining risk for persons and material. Therefore, operate the machine and its components circumspectly and carefully!

Make sure that you are working concentrated and that you are not tired.

Do not operate the machine and its components if you are under the influence of medication, alcohol or drugs.

### 3 STRUCTURE AND FUNCTION

#### 3.1 DESIGNATION AND FUNCTIONS OF THE COMPONENT PARTS

1 = Machine table to fix work pieces on it using a suitable fixture
2 = Attachment bracket for the machine table
3 = Integrated clamping system to fix appropriate sheet material
43.0 mm / 1.69 inch tool seat e.g. for milling spindle, hot cutter, engraving point
4 = X-axis guiding for driving and axis guiding
5 = Y-axis guiding for driving and axis guiding, incl. inspection flap for cleaning and maintenance
6 = Z-axis guiding for driving and axis guiding
7 = Step motor X-axis to move the slide of the X-axis
8 = Step motor Z-axis to move the slide of the Z-axis
9 = Emergency-Stop switch to stop the machine quickly (only in emergency situations)
10 = Cable collector to cover X- and Z-motor/limit switch cable
11 = Backside of the machine with connector block for power supply and computer

4 COMMISSIONING

4.1 INSTALLING THE MACHINE

The machine must be positioned on an absolutely level even working table so that it stands safely and can neither slip nor tilt over.

All mobile parts of the machine must have sufficient space in order that they can be moved without collisions.

The cable duct of the system-guided tool e.g. the milling spindle must be designed in a way that the spindle cable is not being clamped between the guide ways of the machine.

It is necessary to well attain and operate the machine.

CAUTION: It is in particular necessary to reach the Emergency-Stop switch at any time; it must not be obstructed.

Provide for sufficient illumination of the machine site and the working place surrounding the machine.

Place the PC which controls the machine nearby the machine so that you can have an eye on both.

4.2 ENVIRONMENTAL CONDITIONS

Install the machine in a closed room.

Keep the environmental temperature of the machine dust-free. Too high dust loading can cause damages on the system.

The humidity should be within normal limits for humidity content inside. Protect the machine against wetness and humidity.

The perfect environmental temperature for the system is from 18°C to 25°C, from 64°F to 77°F respectively.
In particular protect the controller against overheating by avoiding direct sun radiation or indirect heating up nearby a radiator.

4.3 ELECTRICAL CONNECTION OF THE MACHINE

The connection of the stepping motors, the end switches and the emergency-stop switch has to processed conform to the construction manual enclosed.

The low-voltage plug of the power supply has to be connected to the connection socket of the unit control at the backside of the machine.

The computer will be connected to the desktop 3D-system with an USB- or parallel connection cable. The necessary socket is located at the backside of the machine, too. Depending on the variant of interface module there is either an USB- or a parallel socket.

The LED lights of the unit control are visible from the outside. The LED lights flash in case of:

<table>
<thead>
<tr>
<th>Control light</th>
<th>Impact</th>
</tr>
</thead>
<tbody>
<tr>
<td>LED1</td>
<td>System ok / power amplifier switched on / emergency-stop switch switched off</td>
</tr>
<tr>
<td>LED2</td>
<td>Power on / 5V DC</td>
</tr>
</tbody>
</table>

4.4 OPTIONAL ACCESSORY

CAUTION: If you use any accessory which was not made or sold by STEPCRAFT please check if it is compatible with your system before the first use.

In case of doubts please contact the corresponding manufacturer, if required.

4.4.1 SYSTEM-GUIDED TOOLS

CAUTION: Please read the operating instructions of every single system-guided tool before use!

In addition please observe the following items:

The machine is equipped with a 43 mm / 1.69 inch tool holder with a thickness of 10 to 12 mm, of 0.39 to 0.48 inch respectively. The supply line of the system-guided tool (if applicable) is fixed to the cable collector of the X-/Z-axis and there it is forwarded by means of a "flying" guiding.

Please imperatively make sure that the supply line is long enough and won’t be clamped anywhere.

The following original system-guided tools are available today:

<table>
<thead>
<tr>
<th>Accessory</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>HF-spindle</td>
<td>Spindle for milling and engraving for a huge variety of materials, i.e. wood, plastic or non-ferrous metals like brass or aluminum</td>
</tr>
<tr>
<td>3D print head</td>
<td>Head for generative manufacturing with plastic filament like PLA or ABS. Type of process: Fused Deposition Modeling (FDM)</td>
</tr>
<tr>
<td>Cutter holder / foil knife</td>
<td>Tool for cutting foils and paper</td>
</tr>
<tr>
<td>Hot cutter</td>
<td>Cutter for styrofoam. Works with a hot wire.</td>
</tr>
<tr>
<td>CNC pen</td>
<td>Special holder for ball pens to draw on paper, fabric etc.</td>
</tr>
<tr>
<td>Engraving point</td>
<td>Tool is to able to scratch minimum details in plastic, brass, copper, aluminum, steel, high-grade steel</td>
</tr>
</tbody>
</table>

4.4.2 ADDITIONAL ACCESSORY

When using accessories please always make sure to have the additional operating instructions of the corresponding products and check if the parts are compatible to the STEPCRAFT desktop 3D-system and to the control before using them for the first time.

The following original accessories are available:
## Accessory Description

<table>
<thead>
<tr>
<th>Accessory</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tool length sensor</td>
<td>Sensor to measure the bottom edge of the end mill in a spindle</td>
</tr>
<tr>
<td>Circular table and tailstock</td>
<td>4th axis CNC milling to process cylindrical work pieces</td>
</tr>
<tr>
<td>Exhaust adapter</td>
<td>Collector for dust and chips</td>
</tr>
<tr>
<td>Heating bed*</td>
<td>Heated machine table for 3D printing, necessary for ABS plastic</td>
</tr>
<tr>
<td>Vacuum table*</td>
<td>Machine to fix thin materials like foils, plastic sheets</td>
</tr>
<tr>
<td>Clamping accessories</td>
<td>Variety of clamping accessories like adapters, steel vices, rubber work piece holder, aluminum T-slot table</td>
</tr>
</tbody>
</table>

*Third party supplier

### 4.5 MACHINE TABLE

The machine table consists of a High Pressure Laminate (HPL) with a thickness of 8.0 mm / 0.31 inch.

The machine table can be easily replaced. It is possible to pull out the table to the front by removing the attachment bracket with the two relevant screws (see item 3.1, position 2).

Dimensions of the original machine table:

<table>
<thead>
<tr>
<th>Typ of machine</th>
<th>Length</th>
<th>Width</th>
<th>Thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm / inch</td>
<td>mm / inch</td>
<td>mm / inch</td>
</tr>
<tr>
<td><strong>STEPCRAFT 210</strong></td>
<td>290</td>
<td>222</td>
<td>8 / 0.31</td>
</tr>
<tr>
<td></td>
<td>11.4</td>
<td>8.3</td>
<td></td>
</tr>
<tr>
<td><strong>STEPCRAFT 300</strong></td>
<td>380</td>
<td>234</td>
<td>8 / 0.31</td>
</tr>
<tr>
<td></td>
<td>14.96</td>
<td>9.21</td>
<td></td>
</tr>
<tr>
<td><strong>STEPCRAFT 420</strong></td>
<td>500</td>
<td>324</td>
<td>8 / 0.31</td>
</tr>
<tr>
<td></td>
<td>19.69</td>
<td>12.76</td>
<td></td>
</tr>
<tr>
<td><strong>STEPCRAFT 600</strong></td>
<td>680</td>
<td>444</td>
<td>8 / 0.31</td>
</tr>
<tr>
<td></td>
<td>26.77</td>
<td>17.48</td>
<td></td>
</tr>
<tr>
<td><strong>STEPCRAFT 840</strong></td>
<td>920</td>
<td>627</td>
<td>8 / 0.31</td>
</tr>
<tr>
<td></td>
<td>36.2</td>
<td>24.2</td>
<td></td>
</tr>
</tbody>
</table>

### 5 MACHINE OPERATION

#### 5.1 OPERATOR

**WARNING:** The improper operation of the machine and its components can result in severe injuries or material damages. Therefore, please observe the accident prevention regulations!

CAUTION: Before the first use of the machine each operator must have read and understood the existing instructions for the whole system (machine, system-guided tool, control, software).

#### 5.2 WORK PIECE

The work piece can be directly fixed on the machine table by means of the integrated clamping system.

Alternatively e.g. a steel vice can be fixed on the machine table.

In case of through-milling (cutouts) it is recommended to position a MDF plate with a thickness of 6.0 mm / 0.24 inch underneath the work piece in order to avoid damages on the machine table.

**NOTICE:** The work piece should be sufficiently fixed in order to avoid unintentional slipping while processing it.

**WARNING:** Never hold the work piece only with the hand during the processing. There is a severe risk of injury!
Admissible work piece size:

<table>
<thead>
<tr>
<th>Type of machine</th>
<th>Clamping length</th>
<th>Clamping width</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEPCRAFT 210</td>
<td>290 mm / 11.4 inch</td>
<td>210 mm / 8.3 inch</td>
</tr>
<tr>
<td>STEPCRAFT 300</td>
<td>380 mm / 14.96 inch</td>
<td>222 mm / 8.74 inch</td>
</tr>
<tr>
<td>STEPCRAFT 420</td>
<td>500 mm / 19.69 inch</td>
<td>312 mm / 12.28 inch</td>
</tr>
<tr>
<td>STEPCRAFT 600</td>
<td>680 mm / 26.77 inch</td>
<td>432 mm / 17.01 inch</td>
</tr>
<tr>
<td>STEPCRAFT 840</td>
<td>920 mm / 24.2 inch</td>
<td>615 mm / 36.2 inch</td>
</tr>
</tbody>
</table>

5.3 **SYSTEM-GUIDED TOOLS**

**CAUTION:** Please observe the corresponding operating instructions of your individual tool!

![WARNING: Never touch the tool then the system is running! There is a severe risk of injury like cuts, abrasions, skin burns etc.]

5.3.1 **DRILLING / MILLING SPINDLE**

**CAUTION:** Switch off the drilling / milling spindle by pressing the corresponding switch (if available) and secure it against restarting. If the drilling / milling spindle is equipped with a proper mains plug please disconnect it from the mains!

**CAUTION:** Always take the milling cutter out of the milling motor when working on the work piece (e.g. clamping, replacing) otherwise there is a risk that you get injured when touching the milling cutter!

![WARNING: Never touch the end mill! There is a severe risk of injury like cuts, abrasions, skin burns etc.]

5.3.2 **CUTTING KNIFE**

**CAUTION:** Always take the blade out of the cutting knife when working on the work piece (e.g. clamping, replacing) otherwise there is a risk that you get injured when touching the blade!

**NOTICE:** Never touch the tool then the system is running! There is a risk of injury like cuts etc.

5.3.3 **HOT CUTTER**

**CAUTION:** Switch off the hot cutter by pressing the corresponding switch (if available). If the hot cutter is equipped with a proper mains plug please disconnect it from the mains!

![WARNING: Never touch/draw the red-hot wire! There is a severe risk of injury like skin burns etc.]

5.3.4 **ENGRAVING POINT / PLOTTER PEN**

**NOTICE:** Always take the engraving point out of the tool holder when working on the work piece (e.g. clamping, replacing) otherwise there is a risk that you get injured when touching the engraving point!

5.3.5 **3D PRINT HEAD**

**CAUTION:** Switch off the 3D print head by pressing the corresponding switch (if available) and secure it against loosing hot filament. If the 3D print head is equipped with a proper mains plug please disconnect it from the mains!

![WARNING: Never touch/draw the 3D print head! There is a severe risk of injury like skin burns etc.]
NOTICE: Use additional handheld tools to remove hot filament from the machine table or the print head. Never touch/draw the hot print head there is a severe risk of injury!

5.4 EMERGENCY-STOP SWITCH

The Emergency-Stop switch is located at the front side of the machine (refer to the schematics under item 3.1 of these instructions).

If you press the switch the Emergency-Stop is released. The machine stops immediately (imperatively refer to item 2.7 of these instructions).

NOTICE: Only press the Emergency-Stop switch in emergency situations!

If the switch is pressed it results in an immediate machine standstill and can result in step losses and data losses.

A controlled stopping of the machine can only be performed by means of the control software.

In order to undo the Emergency-Stop status turn the Emergency-Stop switch to the right. Thus the control is reactivated. The working process has to be restarted.

5.5 OPERATION OF THE SYSTEM / OPERATING ELEMENTS

The whole system is controlled and operated by means of a computer or laptop (PC).

The minimum requirements are:
- Processor / CPU with 1 GHz
- 32 or 64 bit operating systems Windows® XP, Vista, 7 or 8
- USB 2.0 interface (no hubs / no USB connection cable longer than 5m / 15 ft.)
- Standard PC peripheral devices (monitor, graphic card etc.)
- Deactivation of power saving function, hard disk shutdown, frequency reduction

WARNING: Please completely read the manual of your control software before the first commissioning and make sure that you understood everything.

For any further questions regarding the control software please contact the corresponding software developer.

5.6 OPTIONAL ACCESSORY

Please find additional accessories in our online shop at www.stepcraft-systems.com or www.stepcraft.us of your STEPCRAFT such as:
- System-guided tools, e.g. drilling / milling spindle, cutting knife, plotter pen, engraving point, hot cutter, 3D print heads
- Extension of the modular unit control e.g. the 4th axis module together with the CNC rotary table
- Grooved plate (aluminium) or systems for mounting and clamping e.g. bench vice, clamping claws
- Tools for drilling / milling and many more

6 TECHNICAL DATA

6.1 DIMENSIONS AND WEIGHT

<table>
<thead>
<tr>
<th>Type of machine</th>
<th>Overall size (Length x Width x Height)</th>
<th>Travel distance (Length x Width x Height)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEPCRAFT 210</td>
<td>340 x 342 x 350 mm</td>
<td>210 x 210 x 40 mm</td>
<td>11.0 kg</td>
</tr>
<tr>
<td></td>
<td>13.39 x 13.47 x 13.78 inch</td>
<td>8.3 x 8.3 x 1.57 inch</td>
<td>20.5 lbs</td>
</tr>
<tr>
<td>STEPCRAFT 300</td>
<td>430 x 345 x 410 mm</td>
<td>300 x 210 x 80* mm</td>
<td>13.0 kg</td>
</tr>
<tr>
<td></td>
<td>16.93 x 13.58 x 15.75 inch</td>
<td>11.81 x 8.27 x 3.15</td>
<td>20.5 lbs</td>
</tr>
<tr>
<td>Type of machine</td>
<td>Overall size (Length x Width x Height)</td>
<td>Travel distance (Length x Width x Height)</td>
<td>Weight</td>
</tr>
<tr>
<td>-----------------</td>
<td>--------------------------------------</td>
<td>------------------------------------------</td>
<td>--------</td>
</tr>
<tr>
<td></td>
<td>inch</td>
<td>inch</td>
<td>kg</td>
</tr>
<tr>
<td>STEPCRAFT 210</td>
<td>552 x 440 x 510 mm</td>
<td>420 x 300 x 140 mm</td>
<td>15.0</td>
</tr>
<tr>
<td></td>
<td>21.46 x 17.13 x 15.75 inch</td>
<td>16.54 x 11.81 x 3.15 inch</td>
<td>24.5</td>
</tr>
<tr>
<td>STEPCRAFT 300</td>
<td>737 x 558 x 510 mm</td>
<td>600 x 420 x 140 mm</td>
<td>19.0</td>
</tr>
<tr>
<td>to STEPCRAFT 840</td>
<td>28.74 x 21.77 x 15.75 inch</td>
<td>23.62 x 16.54 x 3.15 inch</td>
<td>35.6</td>
</tr>
<tr>
<td>STEPCRAFT 420</td>
<td>968 x 745 x 510 mm</td>
<td>840 x 600 x 140 mm</td>
<td>31.0</td>
</tr>
<tr>
<td></td>
<td>38.1 x 29.3 x 20.08 inch</td>
<td>11.81 x 8.27 x 3.15 inch</td>
<td>57.66</td>
</tr>
</tbody>
</table>

* For constructional reasons the travel distance of the Z-axis is getting reduced at the end positions of the X-axis by 10 mm / 0.39 inch.

6.2 DRIVE OF THE MACHINE

The axes of the machine are driven by means of bipolar stepper motors. All used motors have 1.8°/full step. They are connected to the drive shafts via axial coupling.

The machine is equipped with round threaded spindles TR8x2 with a feed/rotation of 2.0 mm (STEPCRAFT 210) or TR10x3 with a feed/rotation of 3.0 mm (STEPCRAFT 300 to 840).

<table>
<thead>
<tr>
<th>Type of machine</th>
<th>Thread (X Y Z)</th>
<th>X-axis</th>
<th>Y-axis</th>
<th>Z-axis</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEPCRAFT 210</td>
<td>8x2 mm</td>
<td>1,4 A</td>
<td>1,8 A</td>
<td>1,4 A</td>
</tr>
<tr>
<td>STEPCRAFT 300</td>
<td>10x3 mm</td>
<td>1,4 A</td>
<td>1,8 A</td>
<td>1,4 A</td>
</tr>
<tr>
<td>to STEPCRAFT 840</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

6.3 OTHER SPECIFICATIONS

<table>
<thead>
<tr>
<th>Type of machine</th>
<th>Clamping surface (X Y)</th>
<th>Working space (X Y Z)</th>
<th>Passage height</th>
<th>Torsional stiffness (20N) (X Y Z)</th>
<th>Repeatability</th>
<th>Programmable resolution</th>
<th>Backlash</th>
<th>Maximum speed</th>
<th>Spindle</th>
<th>Linear guide</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEPCRAFT 210</td>
<td>222 x 290 mm 8.74 x 14.42 inch</td>
<td>210 x 210 x 40 mm 8.27 x 8.27 x 1.57 inch</td>
<td>95 mm 3.74 inch</td>
<td>0.07 mm – 0.12 mm</td>
<td>+/- 0.04 mm</td>
<td>0.005 mm</td>
<td>approx. 0.08 mm (with software adjustable to 0.00 mm)</td>
<td>1.800 mm/min 70.87 inch/min Round-Thread spindle 8x2 STEPCRAFT-aluminium profile (EN AW-</td>
<td></td>
<td></td>
</tr>
<tr>
<td>STEPCRAFT 300</td>
<td>222 x 380 mm 8.74 x 14.96 inch</td>
<td>210 x 300 x 80* mm 8.27 x 11.81 x 3.15 inch</td>
<td>115 mm 4.53 inch</td>
<td>0.06 mm – 0.11 mm</td>
<td>+/- 0.04 mm</td>
<td>0.005 mm</td>
<td>approx. 0.08 mm (with software adjustable to 0.00 mm)</td>
<td>3.000 mm/min 118.11 inch/min Round-Thread spindle 10x3 STEPCRAFT-aluminium profile (EN AW-</td>
<td></td>
<td></td>
</tr>
<tr>
<td>STEPCRAFT 420</td>
<td>312 x 500 mm 12.28 x 19.69 inch</td>
<td>300 x 420 x 140* mm 11.81 x 16.54 x 5.51 inch</td>
<td>175 mm 6.89 inch</td>
<td>0.06 mm – 0.11 mm</td>
<td>+/- 0.04 mm</td>
<td>0.005 mm</td>
<td>approx. 0.08 mm (with software adjustable to 0.00 mm)</td>
<td>3.000 mm/min 118.11 inch/min Round-Thread spindle 10x3 STEPCRAFT-aluminium profile (EN AW-</td>
<td></td>
<td></td>
</tr>
<tr>
<td>STEPCRAFT 600</td>
<td>432 x 680 mm 17.01 x 26.77 inch</td>
<td>420 x 600 x 140* mm 16.54 x 23.62 x 5.51 inch</td>
<td>175 mm 6.89 inch</td>
<td>0.09 mm – 0.13 mm</td>
<td>+/- 0.05 mm</td>
<td>0.005 mm</td>
<td>approx. 0.08 mm (with software adjustable to 0.00 mm)</td>
<td>3.000 mm/min 118.11 inch/min Round-Thread spindle 10x3 STEPCRAFT-aluminium profile (EN AW-</td>
<td></td>
<td></td>
</tr>
<tr>
<td>STEPCRAFT 840</td>
<td>612 x 920 mm 24.09 x 36.22 inch</td>
<td>600 x 840 x 140* mm 23.62 x 33.07 x 5.51 inch</td>
<td>175 mm 6.89 inch</td>
<td>0.10 mm – 0.14 mm</td>
<td>+/- 0.05 mm</td>
<td>0.005 mm</td>
<td>approx. 0.08 mm (with software adjustable to 0.00 mm)</td>
<td>3.000 mm/min 118.11 inch/min Round-Thread spindle 10x3 STEPCRAFT-aluminium profile (EN AW-</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
**Drive**
- Stepper motors

**Tool holder**
- Ø 43 mm / 1.69 inch (optional smaller diameters)

**Overall size**
- 340 mm x 350 mm x 13.39 x 13.58 x 13.78 inch
- 430 mm x 350 mm x 21.65 x 16.93 x 20.08 inch
- 550 mm x 510 mm x 28.74 x 22.44 x 20.08 inch
- 730 mm x 570 mm x 38.19 x 29.53 x 20.08 inch

**Weight**
- 11 kg / 24.25 lbs
- 13 kg / 28.66 lbs
- 15.0 kg / 33.07 lbs
- 19.0 kg / 41.89 lbs

**Machine table**
- HPL

**Color**
- STEPCRAFT orange, Aluminum, white

**Input voltage (AC)**
- 100 – 240 V

**Output voltage (DC)**
- 19 V

**Power consumption**
- 90 W

**Interface**
- USB or parallel

---

*For constructional reasons the travel distance of the Z-axis is getting reduced at the end positions of the X-axis by 10 mm / 0.39 inch.*

### 6.4 SPARE PARTS

All parts of the machine and control can be purchased individually as spare parts.

Please contact us directly. Please find our contact data on item 10.3 of these instructions.

Please keep your machine data ready at hand when ordering spare parts.

### 6.5 PIN ASSIGNMENT CHARTS OF UNIT CONTROL / OPTIONAL MODULES

#### 6.5.1 PARALLEL PORT LPT-ADAPTER (X1)

Connection of the computer to the unit control via parallel module (optional):

<table>
<thead>
<tr>
<th>Signal</th>
<th>Pin</th>
</tr>
</thead>
<tbody>
<tr>
<td>Relay 1</td>
<td>1</td>
</tr>
<tr>
<td>Direction X</td>
<td>2</td>
</tr>
<tr>
<td>Step X</td>
<td>3</td>
</tr>
<tr>
<td>Direction Y</td>
<td>4</td>
</tr>
<tr>
<td>Step Y</td>
<td>5</td>
</tr>
<tr>
<td>Direction Z</td>
<td>6</td>
</tr>
<tr>
<td>Step Z</td>
<td>7</td>
</tr>
<tr>
<td>Direction 4th axis</td>
<td>8</td>
</tr>
<tr>
<td>Step 4th axis</td>
<td>9</td>
</tr>
<tr>
<td>Tool length sensor</td>
<td>10</td>
</tr>
<tr>
<td>Emergency stop</td>
<td>11</td>
</tr>
<tr>
<td>Reference switch X/Y/Z</td>
<td>12</td>
</tr>
<tr>
<td>Reference switch 4th axis</td>
<td>13</td>
</tr>
</tbody>
</table>
### 6.5.2 Connector external signals / Sub-D 15 (X2)

Connection of external devices to the unit control:

<table>
<thead>
<tr>
<th>Signal</th>
<th>Pin</th>
</tr>
</thead>
<tbody>
<tr>
<td>Relay 2</td>
<td>14</td>
</tr>
<tr>
<td>n.a. (In)</td>
<td>15</td>
</tr>
<tr>
<td>Relay 3</td>
<td>16</td>
</tr>
<tr>
<td>n.a. (Out)</td>
<td>17</td>
</tr>
<tr>
<td>GND</td>
<td>18-25</td>
</tr>
<tr>
<td>PE</td>
<td>shed</td>
</tr>
<tr>
<td>5V/VCC</td>
<td></td>
</tr>
</tbody>
</table>

### 6.5.3 Connector 4th axis / Sub-D 9 (X101)

Connection of motor and reference switch of the 4<sup>th</sup> axis (optional):

<table>
<thead>
<tr>
<th>Signal</th>
<th>Pin</th>
</tr>
</thead>
<tbody>
<tr>
<td>Winding 1A</td>
<td>1</td>
</tr>
<tr>
<td>Winding 1B</td>
<td>2</td>
</tr>
<tr>
<td>n.a.</td>
<td>3</td>
</tr>
<tr>
<td>n.a.</td>
<td>4</td>
</tr>
<tr>
<td>Reference switch 4th axis</td>
<td>5</td>
</tr>
<tr>
<td>Winding 2A</td>
<td>6</td>
</tr>
<tr>
<td>Winding 2B</td>
<td>7</td>
</tr>
<tr>
<td>n.a.</td>
<td>8</td>
</tr>
<tr>
<td>GND</td>
<td>9</td>
</tr>
<tr>
<td>PE</td>
<td>shed</td>
</tr>
</tbody>
</table>
7 TRANSPORTATION / STORAGE

7.1 TRANSPORTATION

NOTICE: Please observe that the machine is very heavy and bulky when transporting it.
If necessary transport the machine with the help of a second person.
Please only use suitable transportation vehicles and carriers for transportation.

| WARNING: Never lift heavy loads above people! |

7.2 PACKAGING

When you do not want to reuse the packaging material of the machine and of its components please separate it
according to the disposal conditions on site and take it to a collection center for recycling or dispose of it.

7.3 STORAGE

If the machine or its components is not used for a longer time please note the following for the storage:
- Store the machine and the components only in closed rooms
- Protect it against humidity, wetness, cold, heat and direct sun radiation
- Store it dust-free, cover it, if required
- The storage place must not be subject to vibrations

8 MAINTENANCE

8.1 SAFETY

| WARNING: Before performing maintenance works on the machine switch it off and secure it against
unintended restarting by disconnecting the mains switch of the controller! |

| WARNING: Before you use a system-guided tool with its own mains plug disconnect it also! |

NOTICE: All maintenance works must only be performed by a technically experienced person.

| WARNING: In case of improper handling of the machine there is a high risk of injury! |

8.2 MAINTENANCE WORKS

NOTICE: Always thoroughly handle your STEPCRAFT in order to enjoy working with it for a long time. Regular
maintenance crucially influences the service life of your machine.
Therefore please perform the following maintenance:
Lubrication of linear tracks and lead screws must be carried out with supplied grease from STEPCRAFT: Klüber Microlube GL 261 or other with similar specifications.

Apply grease on positions marked as mentioned:

1. All guide areas have to be adequately greased before the machine can be put into service
2. After 20 operating hours wipe the guide area clean and apply grease again
3. Repeat step 2 if soiled but latest every 20 hours.

Also always keep the machine clean. Any accruing chips or other soiling should be sucked off or thrown away after each working step. Furthermore, please make sure that no chips or similar means get caught in the mobile parts.
9 MAJOR MALFUNCTIONS

9.1 BEHAVIOR IN CASE OF MALFUNCTIONS

**CAUTION:** If a malfunction occurs on the system which might cause person or material damages please immediately stop the working process by pressing the emergency-stop switch!

In case of slight malfunctions please stop the machine as usual using the control.

If you are not able to remedy the malfunction yourself please contact us by indicating the malfunction which occurred. Please find our contact data on item 10.3 of these instructions.

10 ANNEX

10.1 WARRANTY AND SERVICE CONTACT INFORMATION

<table>
<thead>
<tr>
<th>Country of Purchase</th>
<th>STEPCRAFT</th>
<th>Address</th>
<th>Phone No. / Email Address</th>
</tr>
</thead>
<tbody>
<tr>
<td>United States of America</td>
<td>STEPCRAFT Inc.</td>
<td>733 E Main St. Unit 3 Torrington, CT, 06790</td>
<td>+1 203 556 1856 <a href="mailto:info@stepcraft.us">info@stepcraft.us</a></td>
</tr>
<tr>
<td>Germany</td>
<td>STEPCRAFT GmbH &amp; Co. KG</td>
<td>Kalkofen 6 58638 Iserlohn Germany</td>
<td>+49 2371 974 8574 <a href="mailto:info@stepcraft-systems.com">info@stepcraft-systems.com</a></td>
</tr>
<tr>
<td>Rest of World</td>
<td>Local distributor</td>
<td>see <a href="https://www.stepcraft-systems.com/en/retail">https://www.stepcraft-systems.com/en/retail</a></td>
<td>see <a href="https://www.stepcraft-systems.com/en/retail">https://www.stepcraft-systems.com/en/retail</a></td>
</tr>
<tr>
<td></td>
<td>STEPCRAFT GmbH &amp; Co. KG</td>
<td>Kalkofen 6 58638 Iserlohn Germany</td>
<td>+49 2371 974 8574 <a href="mailto:info@stepcraft-systems.com">info@stepcraft-systems.com</a></td>
</tr>
</tbody>
</table>

10.2 MANUFACTURER

STEPCRAFT GmbH & Co. KG
Kalkofen 6
58638 Iserlohn
Germany

Phone: +49 (0) 2371 – 974 85 74
E-Mail: info@stepcraft-systems.com
Internet-Adresse: www.stepcraft-systems.com

10.3 TYPE PLATE

The type plate is at the left side of the machine on the inspection flap.

Example:

![Type Plate Image]
10.4 Copyright

The contents of these operating instructions are the intellectual property of the company STEPCRAFT. Forwarding or copying (also in excerpts) is not allowed unless we authorized it expressively in writing. Any infringements are prosecuted.

10.5 Limited Warranty

What this Warranty Covers

STEPCRAFT GmbH & Co. KG ("STEPCRAFT") warrants to the original purchaser that the product purchased (the "Product") will be free from defects in materials and workmanship at the date of purchase.

What is not covered

This warranty is not transferable and does not cover (i) cosmetic damage, (ii) damage due to acts of God, accident, misuse, abuse, negligence, commercial use, or due to improper use, installation, operation or maintenance, (iii) modification of or to any part of the Product, (iv) attempted service by anyone other than a STEPCRAFT authorized service center, (v) Product not purchased from an authorized STEPCRAFT dealer, or (vi) Product not compliant with applicable technical regulations.

Other than the express warranty above, STEPCRAFT makes no other warranty or representation, and hereby disclaims any and implied warranties, including, without limitation, the implied warranties of non-infringement, merchantability and fitness for a particular purpose. The purchaser acknowledges that they alone have determined that the product will suitably meet the requirements of the purchaser’s intended use.

Purchaser’s Remedy

STEPCRAFT’s sole obligation and purchaser’s sole and exclusive remedy shall be that STEPCRAFT will, at its option, either (i) service, or (ii) replace, any product determined by STEPCRAFT to be defective. STEPCRAFT reserves the right to inspect any and all product(s) involved in a warranty claim.

Service or replacement as provided under this warranty is the purchaser’s sole and exclusive remedy.

Limitation of Liability

STEPCRAFT shall not be liable for special, incidental or consequential damages, loss of profits or production or commercial loss in any way, regardless of whether such claim is based in contract, warranty, tort, negligence, strict liability or any other theory of liability, even if STEPCRAFT has been advised of the possibility of such damages. Further, in no event shall the liability of STEPCRAFT exceed the individual price of the product on which liability is asserted. As STEPCRAFT gas no control over use, setup, final assembly, modification or misuse, no liability shall be assumed nor accepted for any resulting damage or injury. By the act of use, setup or assembly, the user accepts all resulting liability. If you as the purchaser is advises to return the product immediately in new and unused condition to the place of purchase.

Law

These terms are governed by German law (without regard to conflict of law principals).

This warranty gives you specific legal right, and you may also have other rights. STEPCRAFT reserves the right to change or modify this warranty at any time without notice.

Warranty Services

Questions, Assistance, and Service

Your local STEPCRAFT store and/or place of purchase cannot provide warranty support or service. Once assembly, setup or use of the products has been started, you must contact your local distributor or STEPCRAFT directly. This will enable STEPCRAFT to better answer your question and services you in the event that you may need any assistance. For questions or assistance, please visit our website or call to speak to a product support representative (see item 10.1).
Inspection or Services

If this Product needs to be inspected or serviced and is compliant in the country you live and use the product in, please use the STEPCRAFT online service request submission process found on our website or call STEPCRAFT. Pack the product securely using a shipping carton. Please note that original boxes may be included, but are not designed to withstand the rigors of shipping without additional protection. Ship via a carrier that provides tracking and insurance for lost or damaged parcels, as STEPCRAFT is not responsible for merchandise unit it arrives and is accepted at our facility. When calling STEPCRAFT, you will be asked to provide your complete name, street address, email address and phone number where you can be reached during business hours. When sending product into STEPCRAFT, please include your contact details and a list of the included items, and a brief summary of the problem. A copy of your original sales receipt must be included for warranty consideration. Be sure your name and address are clearly written on the outside of the shipping carton.

Warranty Requirements

For Warranty consideration, you must include your original sales receipt verifying the proof-of-purchase date. Provide warranty conditions have been met, your product will be serviced or replaced free of charge. Service or replacement decisions are at the sole discretion of STEPCRAFT.

NON-Warranty Service

Should your service not be covered by warranty, service will be completed and payment will be required without notification or estimate of the expense unless the expense exceeds 50% of the retail purchase cost. Provided warranty conditions have been met, your product will be serviced or replaced free of charge. Service or replacement decisions are at the sole discretion of STEPCRAFT.

Non-Warranty Service

Should your service not be covered by warranty, service will be completed and payment will be required without notification or estimate of the expense unless the expense exceeds 50% of the retail purchase cost. By submitting the item for service you are agreeing to payment of the service without notification. Service estimates are available upon request. You must include this request with your items submitted for service. Non-warranty service estimates will be billed a minimum of ½ hour of labor. In addition you will be billed for return freight. STEPCRAFT accepts money orders cashier’s checks, as well as credit cards and PayPal payment. By submitting any item to STEPCRAFT for service, you are agreeing to STEPCRAFT’s Terms and Conditions found on our website (see item 10.1).

ATTENTION: STEPCRAFT service is limited to product compliant in the country of use and ownership. If received, a non-compliant product will not be serviced. Further, the sender will be responsible for arranging return shipment of the un-serviced Product, through a carrier of the sender’s choice and at the sender’s expense. STEPCRAFT will hold non-compliant product for a period of 60 days from notification, after which it will be discarded.

10.6 INSTRUCTIONS FOR DISPOSAL OF WEEE BY USERS OF THE EUROPEAN UNION

This product must not be disposed of with other waste. Instead, it’s the user’s responsibility to dispose of their waste equipment by handing it over to a designated collections point for recycling of waste electrical and electronic equipment. The separate collection and recycling of your waste equipment at the time of disposal will help to conserve natural resources and ensures that it is recycled in a manner that protects human health and the environment. For more information about where you can drop off your waste equipment for recycling, please contact your local office, your house-hold waste disposal or where you purchased your product.

10.7 RoHS, 2002/95/EG

We confirm that the machines of the STEPCRAFT series comply with the RoHS, 2002/95/EC
EC manufacturer's declaration of conformity

in terms of the directive 2006/42/EC, appendix II part 1 A

Manufacturer: Stepcraft GmbH & Co. KG
Kalkofen 6
58638 Iserlohn
Germany

Type of product: Desktop 3D-System

Type designation: Stepcraft 300 / 300 CK / 420 / 420 CK / 600 / 600 CK

Hereby we declare, that the machine named above is consistent with the following relevant regulations:

- EC machinery directive 2006/42/EC
- EC EMC directive 2004/108/EC
- The machine observes the protection targets of the EC low voltage directive (LVD) 2006/95/EC.

Applied harmonized standards, whose references have been published in the Official Journal of the European Communities:

EN 61029-1 11/2010 Safety of transportable motor-operated electric tools, Part 1: General requirements

Representative for the completion of the technical documentation is the signatory of this declaration.

This declaration becomes void, if not authorized modifications are made to the machine.

The EC manufacturer's declaration of conformity was issued

in: Iserlohn
on: 07-31-2013

by:

Peter Urban
(Managing director)

Markus Wedel
(Managing director)