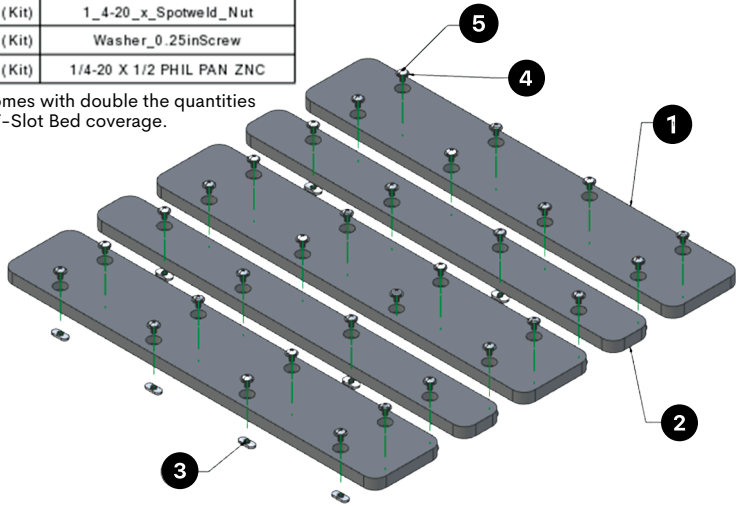


# SPOIL BOARD CONTENTS

## Spoil Boards for HD510 & HD520 Includes

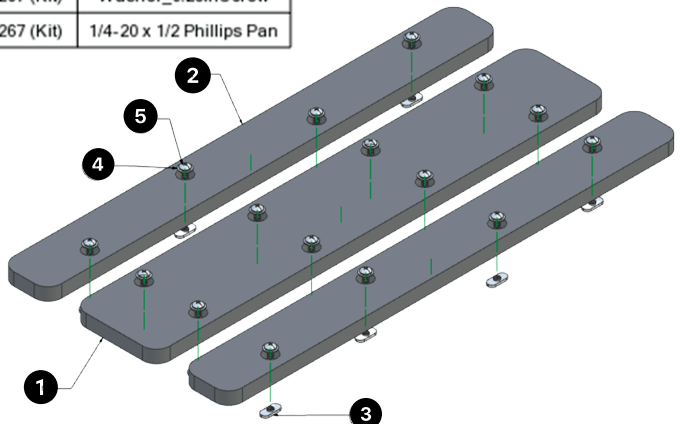
Item Number	Quantity	Part Number	Part Name
1	3	208302	S1 Slat
2	2	208303	S2 Slat
3	32	204267 (Kit)	1_4-20_x_Spotweld_Nut
4	32	204267 (Kit)	Washer_0.25inScrew
5	32	204267 (Kit)	1/4-20 X 1/2 PHIL PAN ZNC

The HD520 Spoil Board Kit comes with double the quantities listed here for full Aluminum T-Slot Bed coverage.



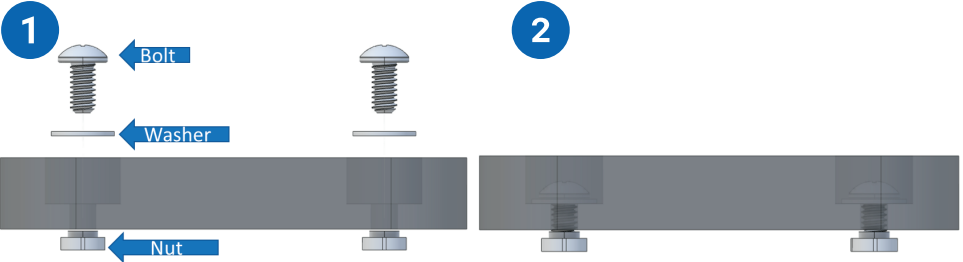
## Spoil Boards for HD500 Includes

Item Number	Quantity	Part Number	Part Name
1	1	208302	S1 Slat
2	2	208303	S2 Slat
3	16	204267 (Kit)	1_4-20 Spotweld_Nut
4	16	204267 (Kit)	Washer_0.25inScrew
5	16	204267 (Kit)	1/4-20 x 1/2 Phillips Pan



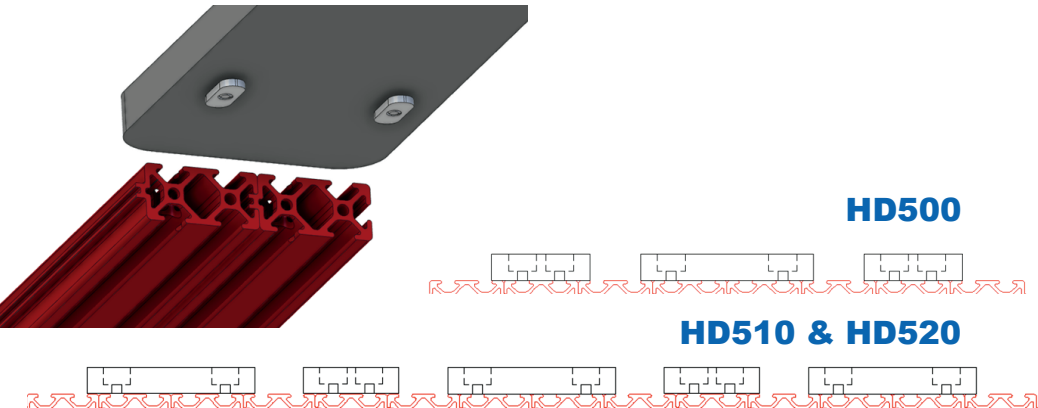
# SPOIL BOARD Installation

**Assemble the slats by attaching the bolts, washers, and nuts as shown below. Do not overtighten the nut, it will need to be loose to slide into the Aluminum T-Slot Bed on the SHARK CNC.**



## X Assembly

**Once all slats are prepared as described, slide them into the Aluminum T-Slot Bed on the SHARK CNC in the orientation shown below**



## Y Assembly

**When positioning the slats, insert a pointed bit into your router, then move the router to the front Y-axis travel of the SHARK CNC. Then position the edge of the slat to the tip of the bit. Once all slats are positioned, tighten all bolts to secure the slats to the Aluminum T-Slot Bed.**

