Installing the CrossFire Pro Drag Chain Mounts

Bill of Materials

1] One set of Drag Chain mounts.

Email jim@felich.com to order a set for $85 including shipping.

OR download the STL files and print them yourself.

OR order from Shapeways for $144.64.



1 x Cable Guide Mount for X-ax.
Gray PA12 Glass Beads
$13.05



1 x Cable Guide Mount X-axis
White Natural Versatile Plastic
$60.75



1 x Cable Guide Mount Y-axis
Gray PA12 Glass Beads
$42.61

ORDER SUMMARY

Items (3)	$116.41
Processing	$6.99
Shipping	$8.99
Tax 9.25%	$12.25
Total:	**$144.64**

2] Three 15mm x 20mm 1-Meter long Drag Chains.

You will join these together to make two proper length drag chains.

https://www.amazon.com/LMioEtool-Plastic-Carrier-Length-Connectors/dp/B07QYM8XQ7/ref=pd_rhf_ee_s_rp_c_1_4/132-1450616-7539916?_encoding=UTF8&pd_rd_i=B07QYM8XQ7&pd_rd_r=42bc951c-ec44-4ccf-aa7f-a88bc7f76091&pd_rd_w=02udl&pd_rd_wg=NZ1KD&pf_rd_p=e7689c0c-effa-447b-90f6-431e8090e282&pf_rd_r=G062X596W7QRECG5PYR7&psc=1&refRID=G062X596W7QRECG5PYR7

3] Two 10-24 x 1.25” cap screws.

These replace the screws holding the X-axis cross-feed nut in place.

4] One ¼-20 x .75” screw

This attaches the Y-axis mount to the Y-axis rail.

5] One 6-foot Extension Cable to extend the Z-axis cable.

https://www.amazon.com/Serial-Extension-Female-Straight-Through/dp/B07B4T699J/ref=pd_lpo_147_t_1/147-7965901-3852948?_encoding=UTF8&pd_rd_i=B07B4T699J&pd_rd_r=a73b6c58-1ede-405e-ab2e-067e56ca42c3&pd_rd_w=RKodc&pd_rd_wg=fsC8z&pf_rd_p=7b36d496-f366-4631-94d3-61b87b52511b&pf_rd_r=GFEXV22688G689DZ3YZS&psc=1&refRID=GFEXV22688G689DZ3YZS

6] Four to twelve 6-32 x 5/8” screws.

These are to hold down the ends of the drag chains. Use as many as you like.

7] Small cable ties.

These are to hold the extension cable connection together and to dress up the drag chain installation.

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Sizing the Drag Chains

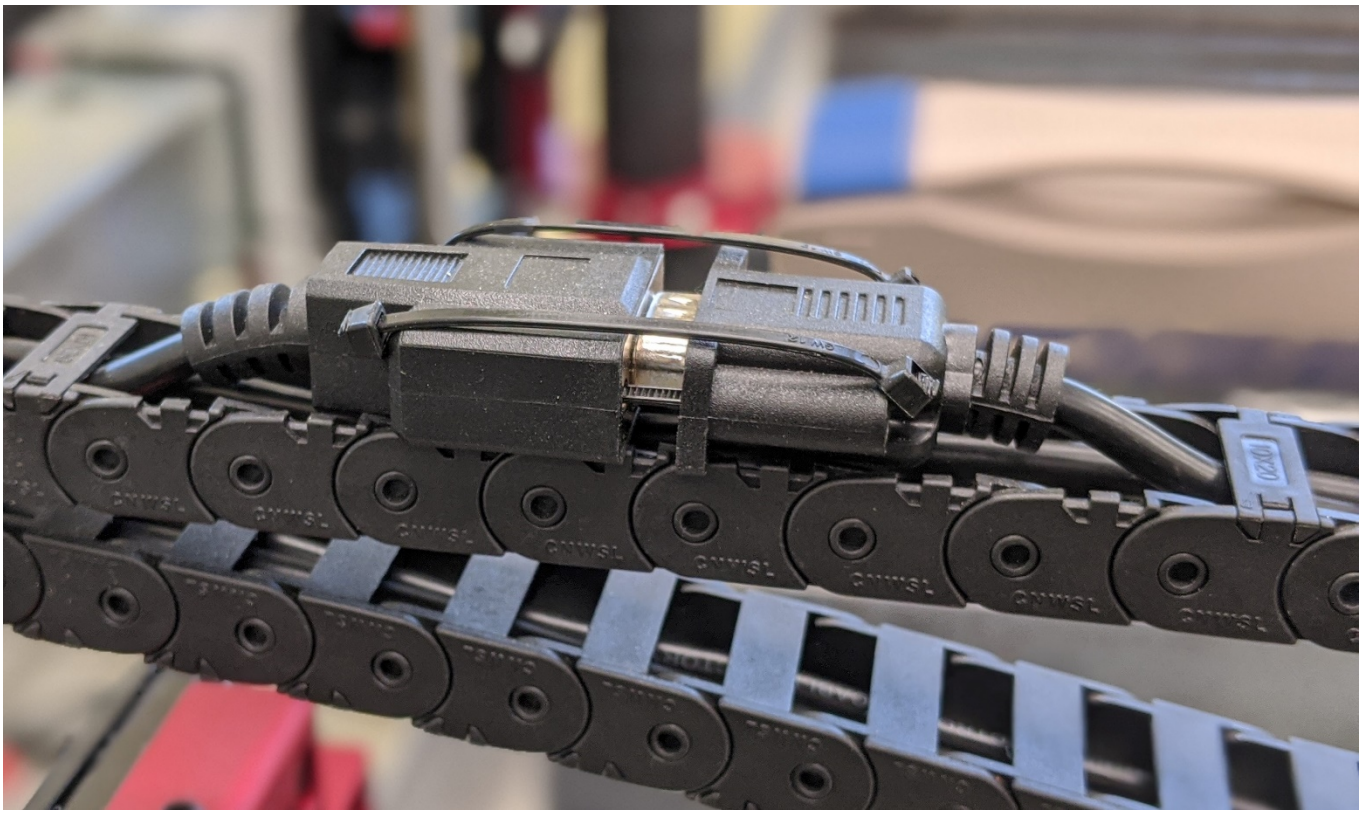
Determine the length needed for the X-axis and Y-axis drag chains. The length will be determined by the actual chains you purchase. The minimum bend radius varies from one brand to another.

Allow adequate length for bends at both ends.

The chains snap apart easily so experiment until you are satisfied.

Open the chains before you mount them and load the cables after the chains are installed.

Be certain to secure the extension cable connection with tie wraps as shown.



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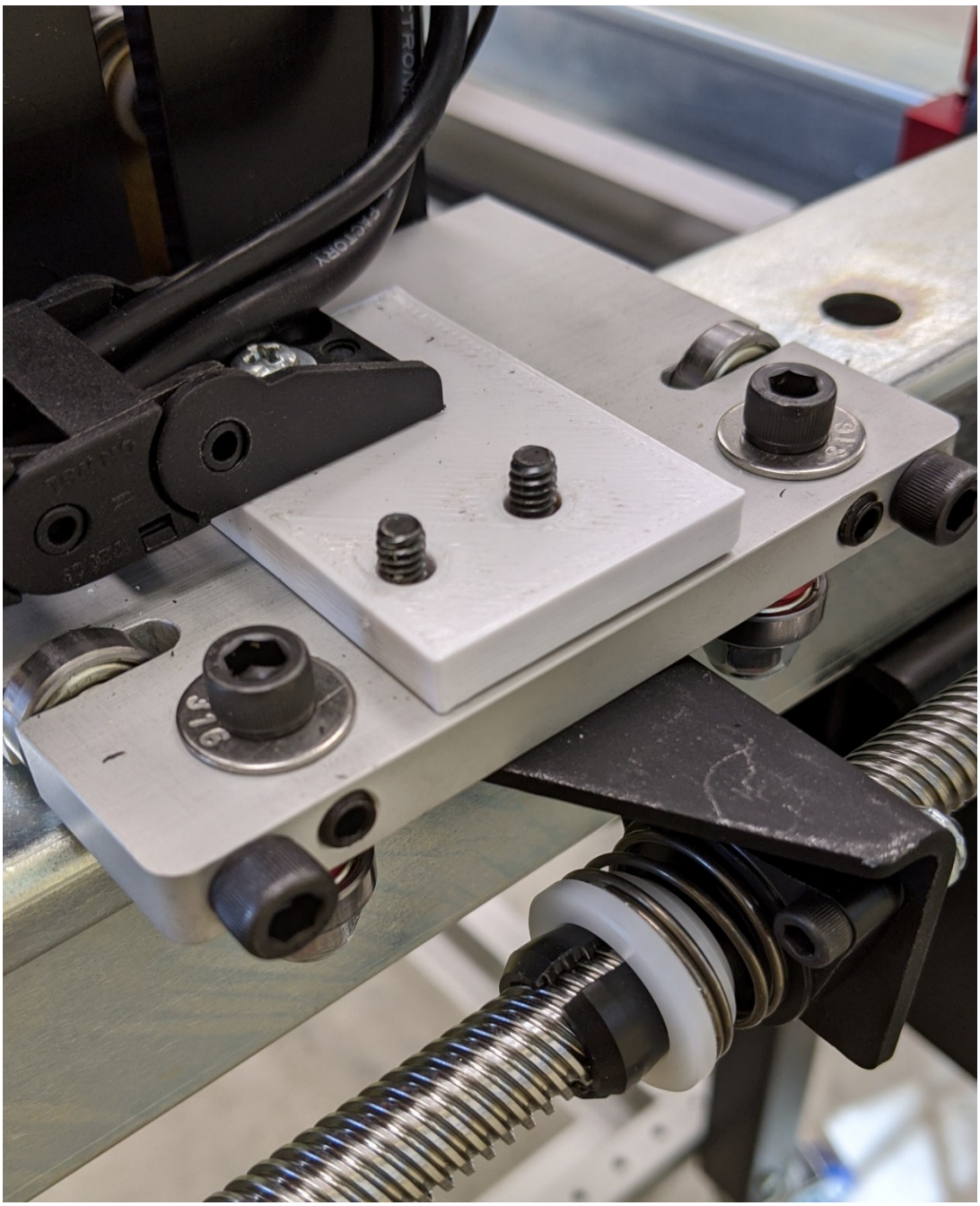
Mounting the X-axis Drag Chain Mount on the X-axis carriage.

Replace the 10-24 x ½" cap screws holding the X-axis Lead Nut Mount 10-24 x 1.25" cap screws.

The mount is placed on the protruding screws and held in place with two 10-24 locknuts.

There is a 6-32 threaded hole in the mount for attaching the X-axis Drag Chain.

The photo shows the mount prior to installing the locknuts.



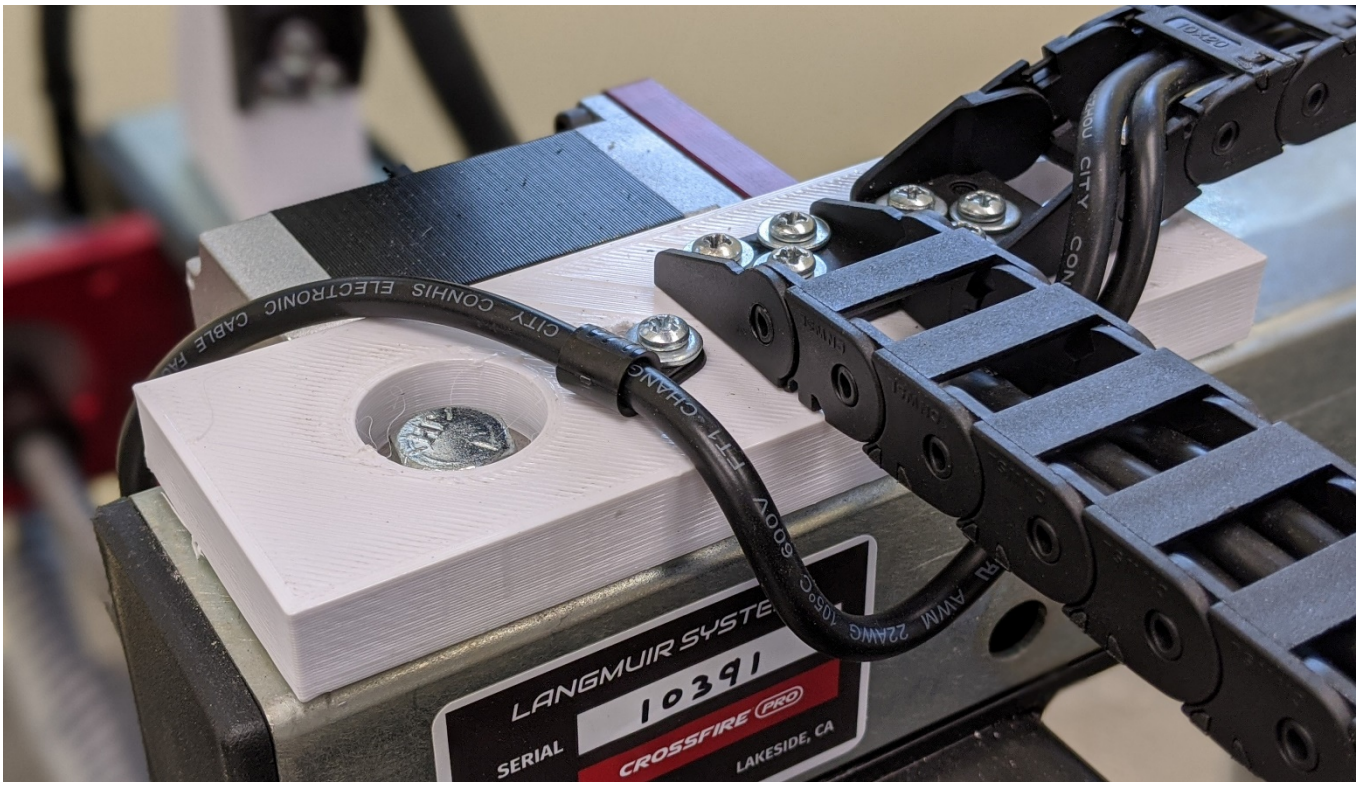
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Mounting the X/Y axis Drag Chain Mount on the X-axis rail

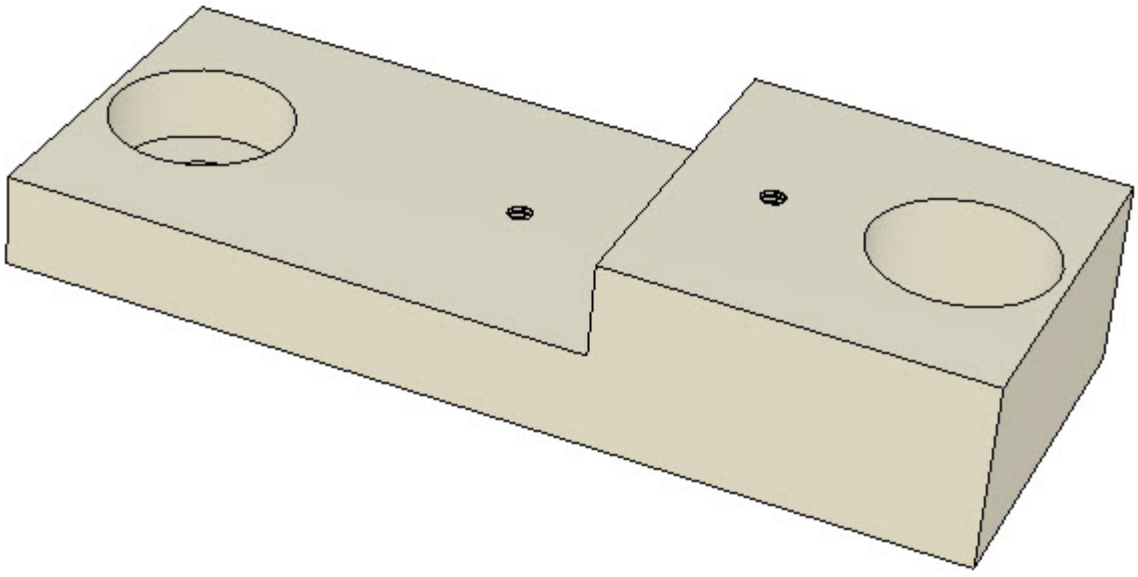
The X/Y axis mount is held in place by two existing 3/8” hex head cap screws.

There are two 6-32 threaded holes in this mount.
One holds one end of the X-axis Drag Chain and the other holds one end of the Y-axis Drag Chain.

Note: The Tube Spacers fit through the mount.



The above photo shows the Rev 1 Mount which is now replaced by the Rev 2.



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Mounting the Y-axis Drag Chain Mount on the Y-axis rail

The Y-axis mount requires a hole in the left Y-axis rail.

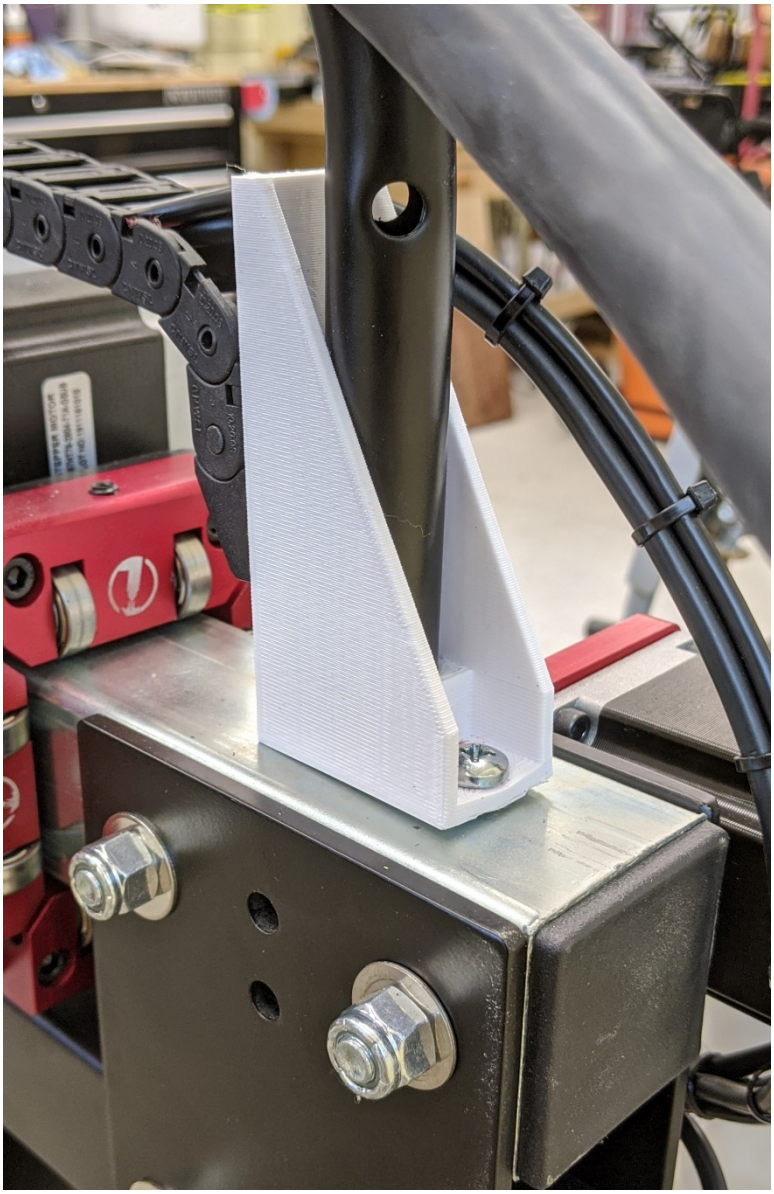
The Cable Support Tube must slide through the drag chain mount.

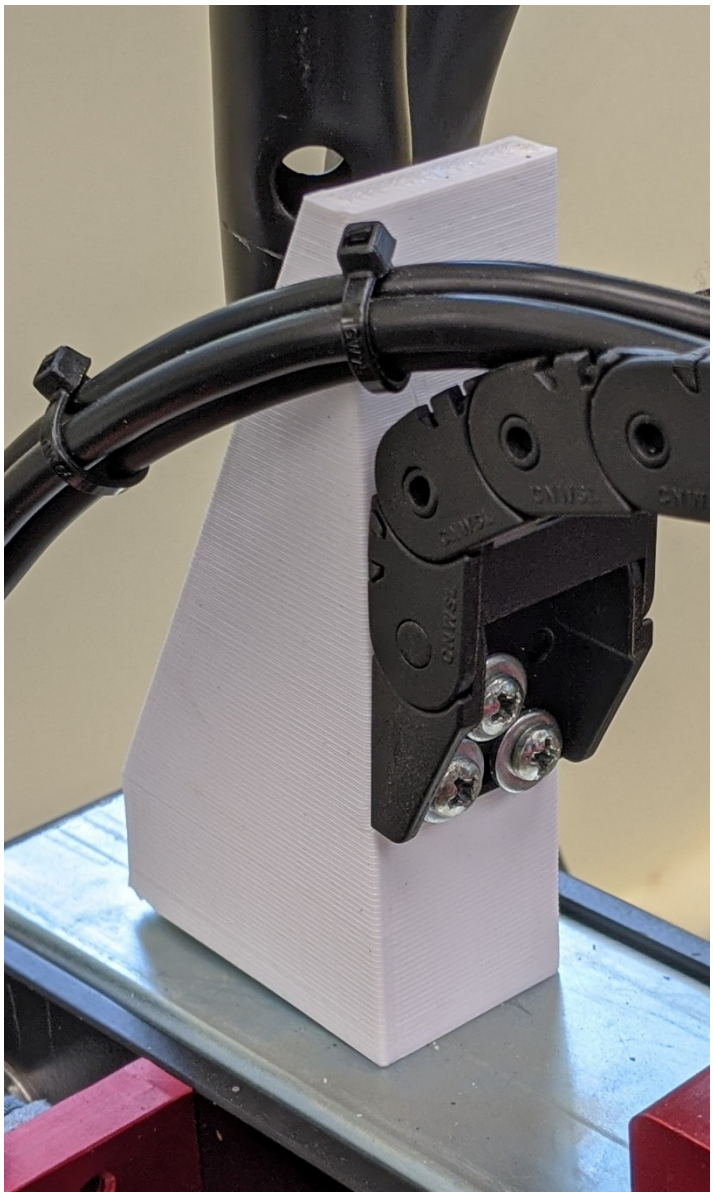
Use the Y-axis mount and the Cable Support Tube to locate the hole.

Drill and tap a ¼-20 hole

Attach the Y-axis drag chain mount with a ¼-20 x .75” screw.

Note: Because Drag Chains differ in minimum bend radius you will need to drill a hole in the face of the Y-axis mount to attach your Y-axis drag chain.





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The completed installation should look something like this.

