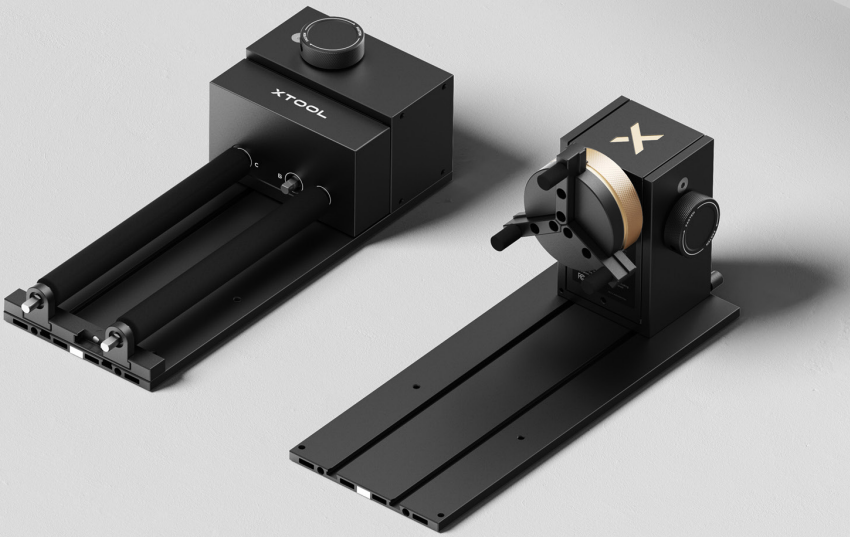
XTOOL

Rotary Attachment 3

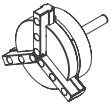


Quick Start Guide

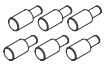
Contents

* The English version is the original instructions verified by the manufacturer.

List of items



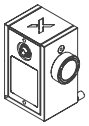
Jaw chuck



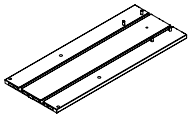
Cylindrical jaw

T-shaped jaw

Jaw chuck components

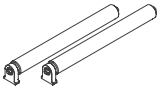


Power module

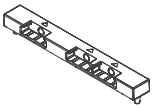


Main baseplate

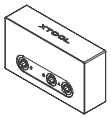
Height-extension module



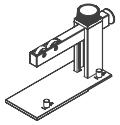
Roller components



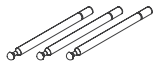
Holder for roller components



Roller transmission module

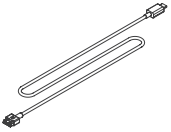


Support module



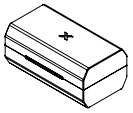
Stud components

Mini level



Connection cable

Tape measure



Storage box

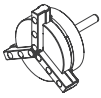
Safety Instructions

Quick Start Guide

See **support.xtool.com/article/1936** for details about how to use the tape measure and the connection cable.

To process workpieces in batches, the following materials can be purchased separately.

Supplementary jaw chuck components:

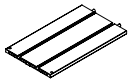


Jaw chuck

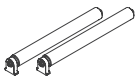
Cylindrical jaw

T-shaped jaw

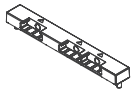
Roller extension components:



Extension baseplate



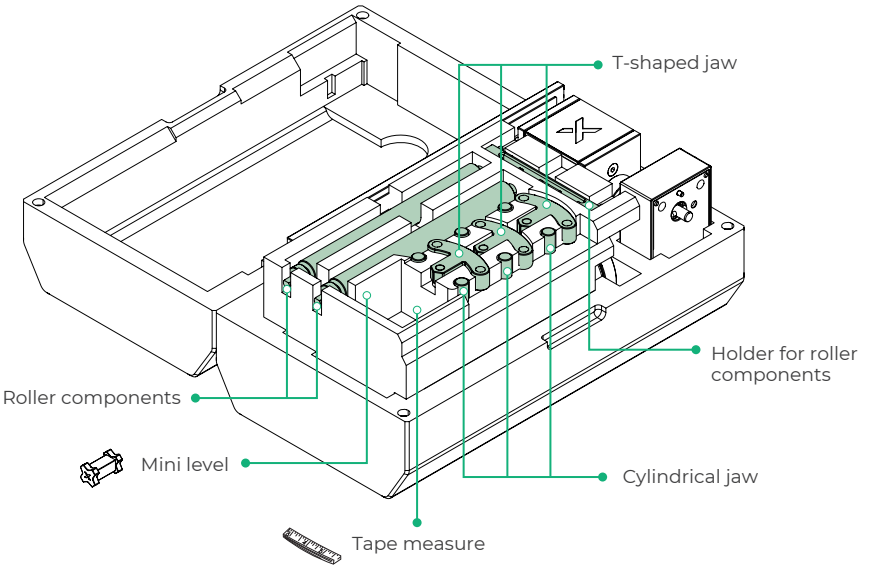
Roller components



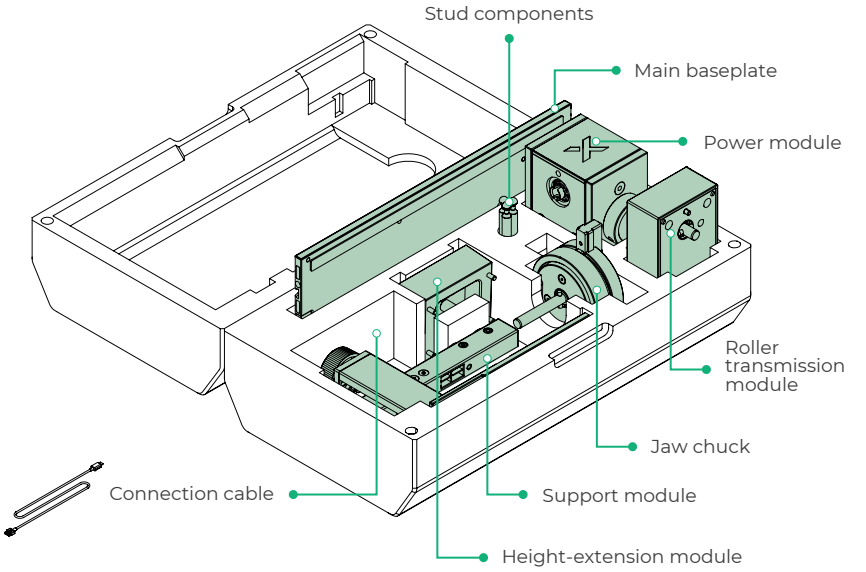
Holder for roller components

Storage box layout

Top layer

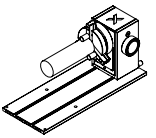
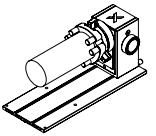
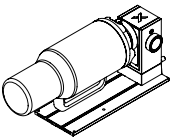
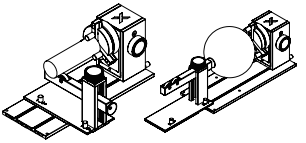
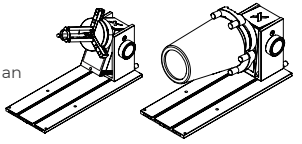
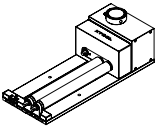
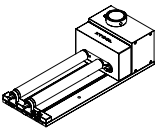
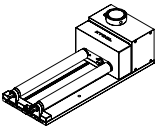


Bottom layer



Use xTool Rotary Attachment 3

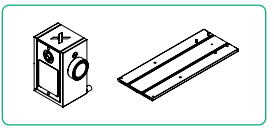
Introduction to processing modes

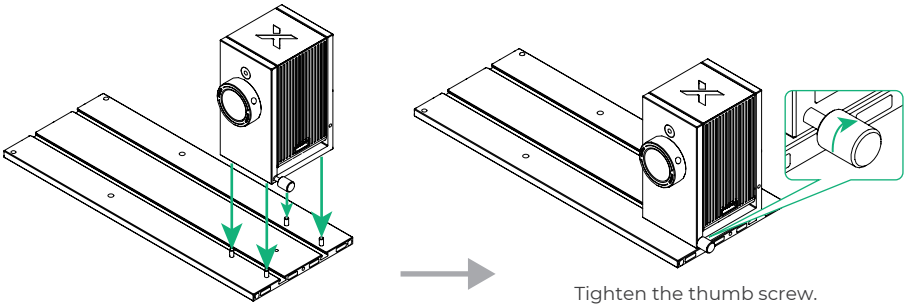
Processing mode	Object to be processed	Assembly form
Jaw chuck mode Suitable for processing cylindrical objects, spherical objects, and rings	Cylindrical objects (5 mm ≤ d ≤ 95 mm, "d" stands for diameter)	Hold the workpiece using cylindrical jaws 
	Large or smooth-surfaced cylindrical objects (55 mm ≤ d ≤ 125 mm)	Hold the workpiece using T-shaped and cylindrical jaws 
	Large-volume cylindrical objects (55 mm ≤ d ≤ 130 mm), such as tumblers	Use the height-extension module 
	Cylindrical and spherical objects	Maintain the workpiece's position using the support module 
	Rings and conical cups	Process the workpiece at an angle 
Roller mode Suitable for processing cylindrical objects	Cylindrical objects (5 mm ≤ d ≤ 45 mm)	Level S 
	Cylindrical objects (40 mm ≤ d ≤ 70 mm)	Level M 
	Cylindrical objects (60 mm ≤ d ≤ 100 mm)	Level L 

Jaw chuck mode

Preparations

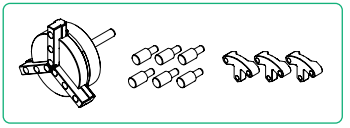
1 Fix the power module on the main baseplate.



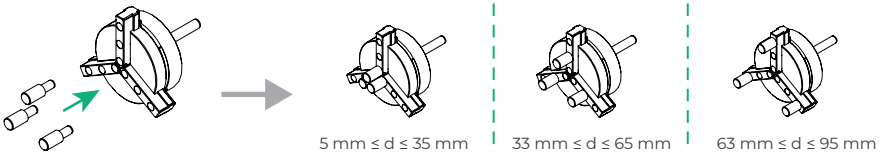


Tighten the thumb screw.

2 Assemble the jaw chuck components.



Method 1: Suitable for processing common cylindrical objects

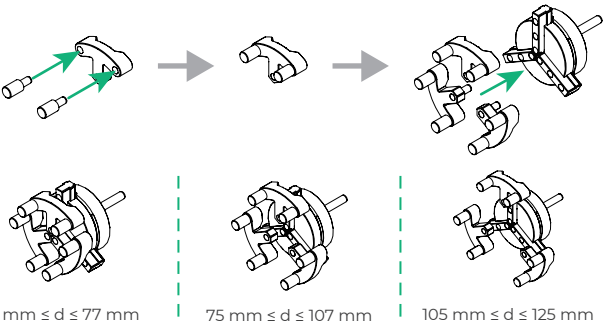


5 mm ≤ d ≤ 35 mm

33 mm ≤ d ≤ 65 mm

63 mm ≤ d ≤ 95 mm

Method 2: Suitable for processing large or smooth-surfaced cylindrical objects



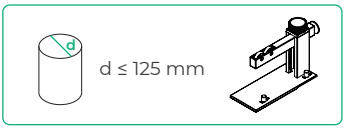
55 mm ≤ d ≤ 77 mm

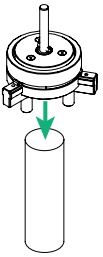
75 mm ≤ d ≤ 107 mm

105 mm ≤ d ≤ 125 mm

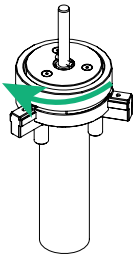
Process cylindrical objects

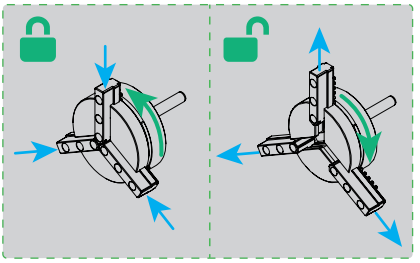
1 Put the workpiece on a table. Place the jaw chuck against the workpiece as illustrated, with its jaws surrounding the outside of the workpiece.



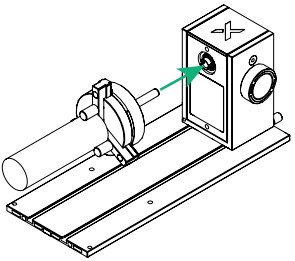


2 Rotate the knob to secure the workpiece.

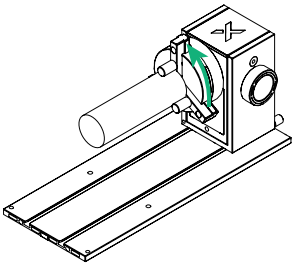




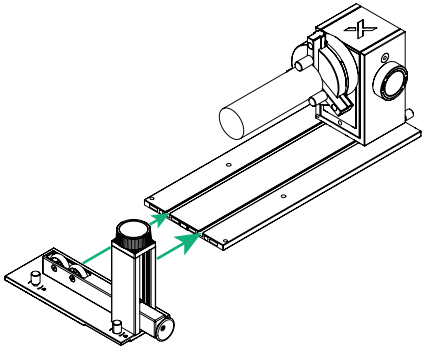
3 Insert the jaw chuck components into the power module.



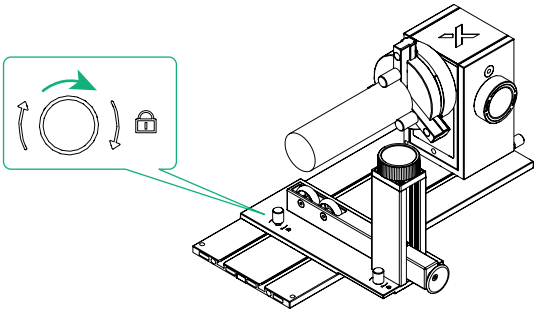
4 Rotate the jaw chuck components until you hear a click.



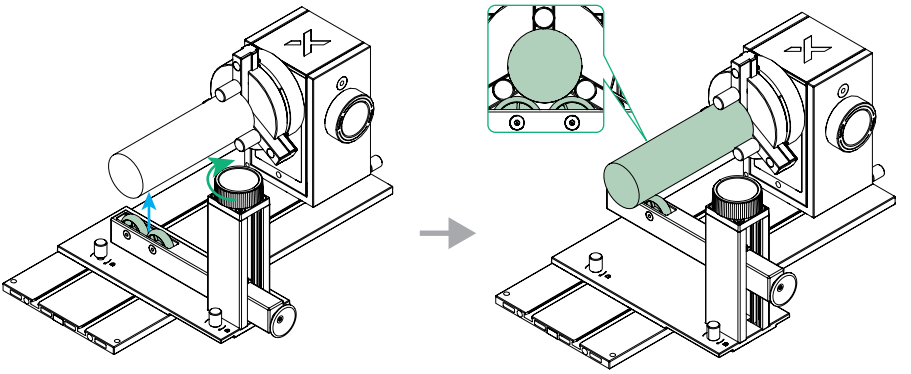
5 Slide the support module into the main baseplate.



6 Rotate the knob clockwise to hold the support module in position.

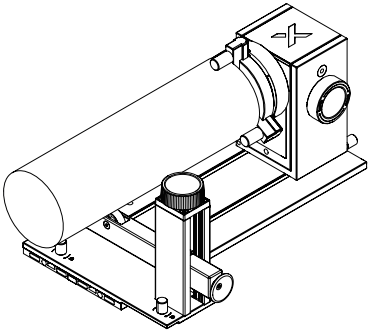


7 **Rotate the knob to adjust the height of the two wheels on the support module until they touch the workpiece.**

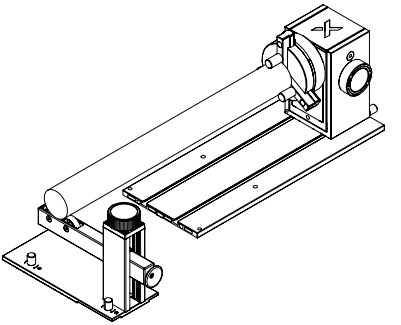


If the workpiece is long, there are two methods to use the support module.

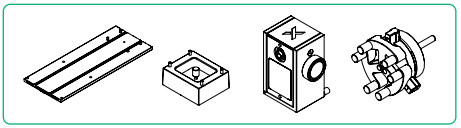
Method 1: Slide the support module into the main baseplate and hold it in position



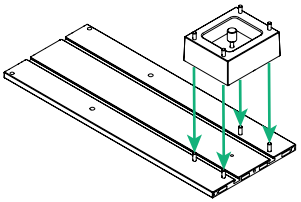
Method 2: Place the support module outside the main baseplate



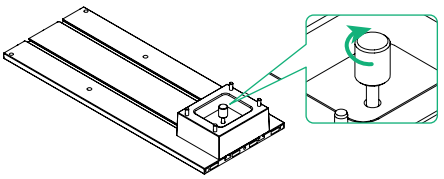
If the workpiece is large in volume, such as mugs and tumblers, you can use the height-extension module.



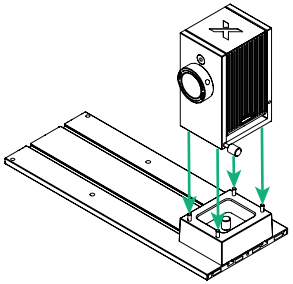
1 Install the height-extension module onto the main baseplate.



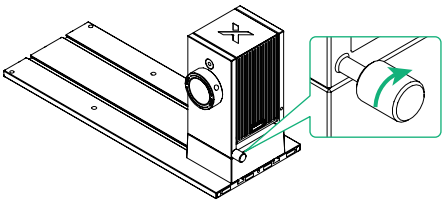
2 Tighten the thumb screw on the height-extension module.



3 Install the power module onto the height-extension module.



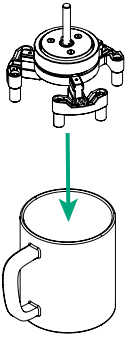
4 Tighten the thumb screw on the power module.



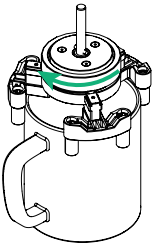
d ≤ 125 mm

Before processing, ensure that the mug's handle does not touch the laser module when it rotates during processing. It is recommended that you place the mug with its handle facing downward.

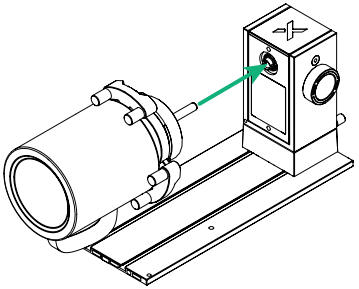
1 **Place the mug on a level table, and place the jaw chuck against the mug with the cylindrical jaws outside the mug. This external clamping method is suitable for processing cups with slippery outer walls and heavy weight, or inclined inner walls, such as mugs.**



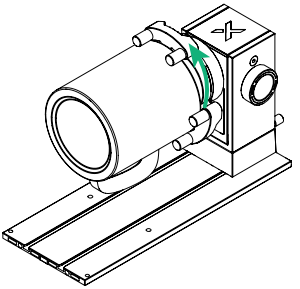
2 **Rotate the knob on the jaw chuck to secure the mug.**

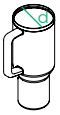


3 **Insert the jaw chuck components into the power module.**



4 **Rotate the jaw chuck components until you hear a click.**

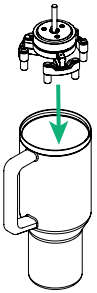




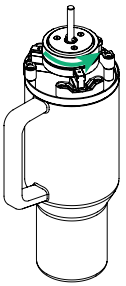
d ≤ 130 mm

Before processing, ensure that the tumbler's handle does not touch the laser module when it rotates during processing. It is recommended that you place the tumbler with its handle facing downward.

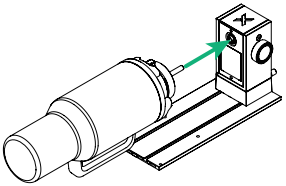
1 **Place the tumbler on a level table, and place the jaw chuck against the tumbler with the cylindrical jaws inside the tumbler. This internal clamping method is suitable for processing cups with rough outer walls, straight inner walls, and light weight, such as tumblers.**



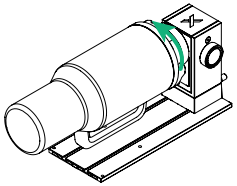
2 **Rotate the knob on the jaw chuck to secure the tumbler.**



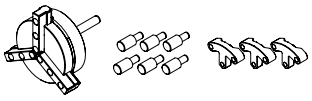
3 **Insert the jaw chuck components into the power module.**



4 **Rotate the jaw chuck components until you hear a click.**

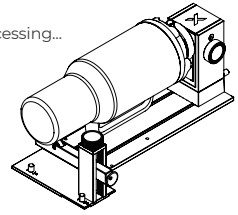


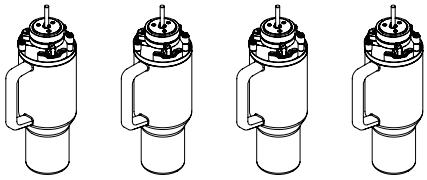
To process workpieces in batches, the supplementary jaw chuck components can be purchased separately.



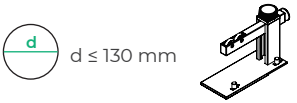
During processing, you may use the supplementary jaw chuck components (purchased separately) to prepare other workpieces for processing. After processing, remove the processed workpiece and jaw chuck components from the power module. Next, insert the jaw chuck components that are installed with a new workpiece into the power module. Rotate the jaw chuck components until you hear a click. You can now continue with the processing.

Processing...

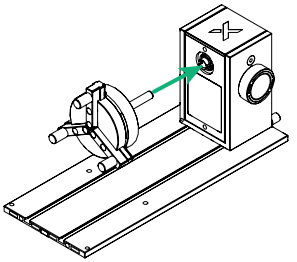




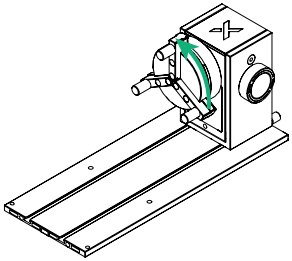
Process spherical objects



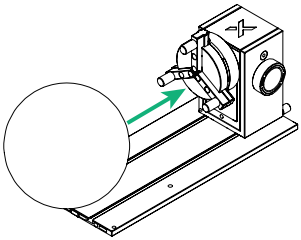
1 Insert the assembled jaw chuck components into the power module.



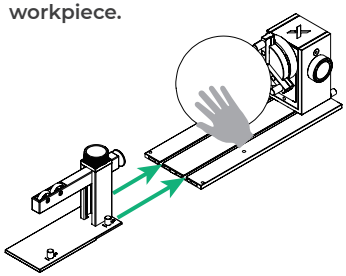
2 Rotate the jaw chuck components until you hear a click.



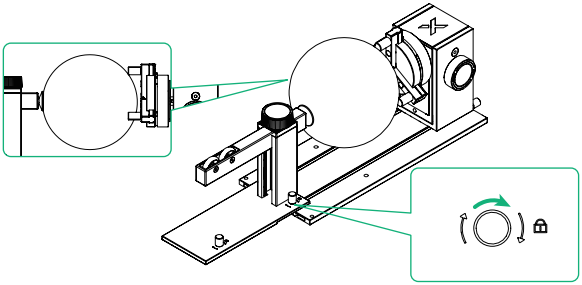
3 Place one side of the workpiece against the jaws.



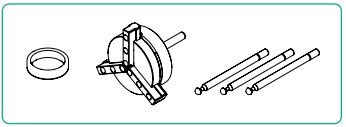
4 Slide the support module into the main baseplate, with its bell mouth against the other side of the workpiece.

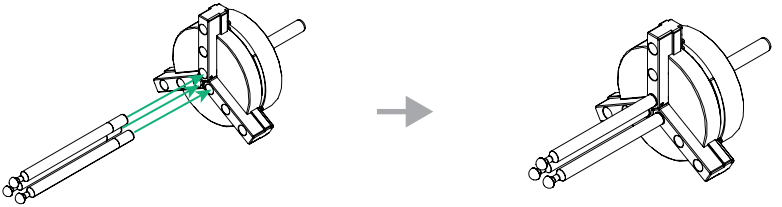


5 Rotate the knob clockwise to hold the support module in position.



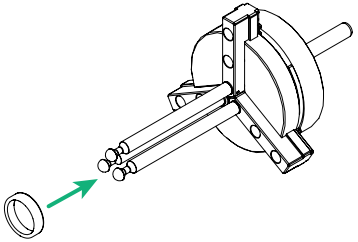
Process rings



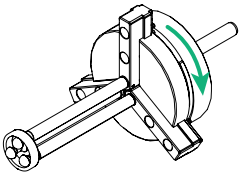


To process the outer surface of a ring, follow the steps below.

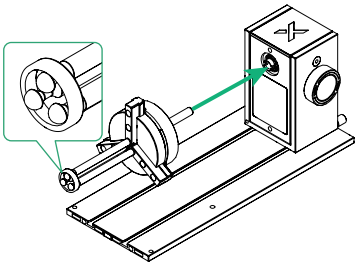
1 Place the ring onto the stud components.



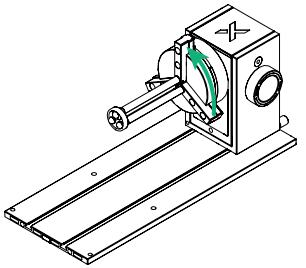
2 Rotate the knob to secure the ring.



3 Insert the jaw chuck into the power module.

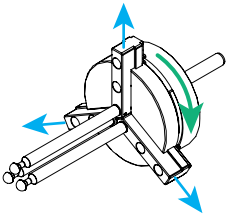


4 Rotate the jaw chuck until you hear a click.

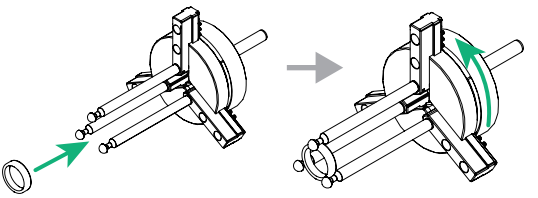


To process the inner surface of a ring, follow the steps below.

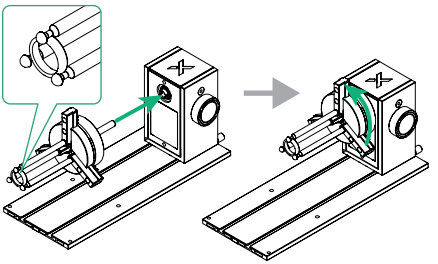
1 Rotate the knob on the jaw chuck.



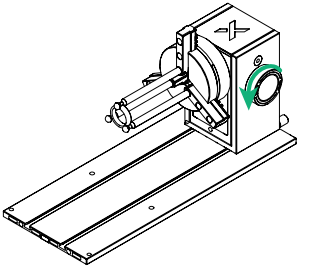
2 Hold the ring using the stud components, then rotate the knob to secure the ring.



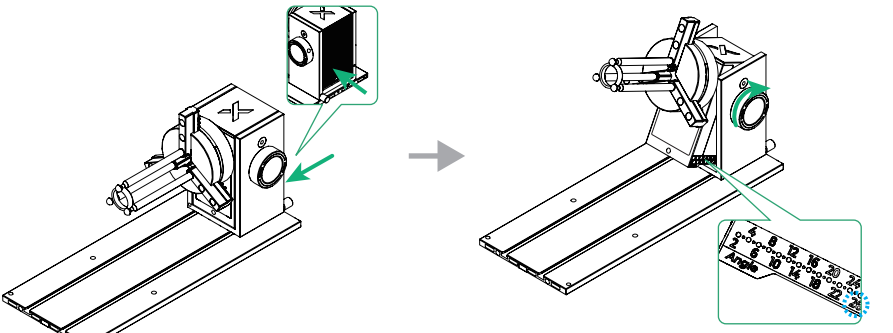
3 Insert the jaw chuck into the power module, then rotate the jaw chuck until you hear a click.



4 Rotate the side knob counterclockwise to unlock the angle adjustment function of the power module.



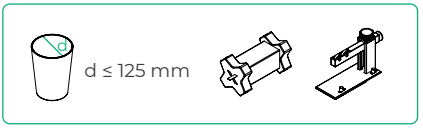
5 Adjust the angle of the power module to its maximum (26°), then rotate the knob clockwise to lock the angle.



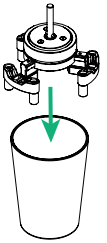
Adjustable angle ≤ 26°

Process other rotating objects

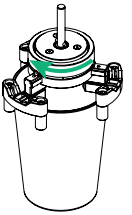
In manual mode, when dealing with a rotating object that has a regular inclined surface (such as a conical cup), you can use a mini level to ensure the surface to be processed is parallel to the ground before proceeding with the operation.



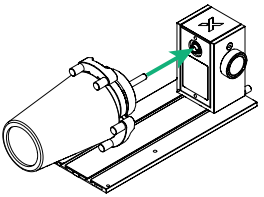
1 Place the conical cup inside the cylindrical jaws.



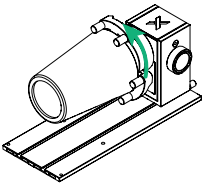
2 Rotate the knob on the jaw chuck to secure the conical cup.



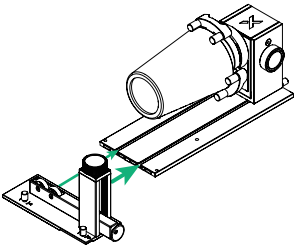
3 Insert the jaw chuck components into the power module.



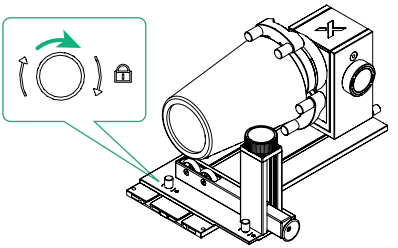
4 Rotate the jaw chuck components until you hear a click.



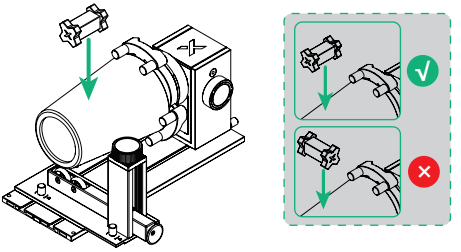
5 Slide the support module into the main baseplate.



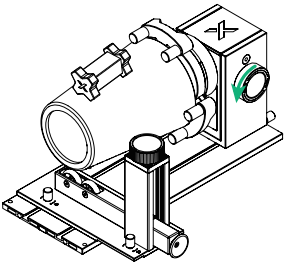
6 Rotate the knob clockwise to hold the support module in position.



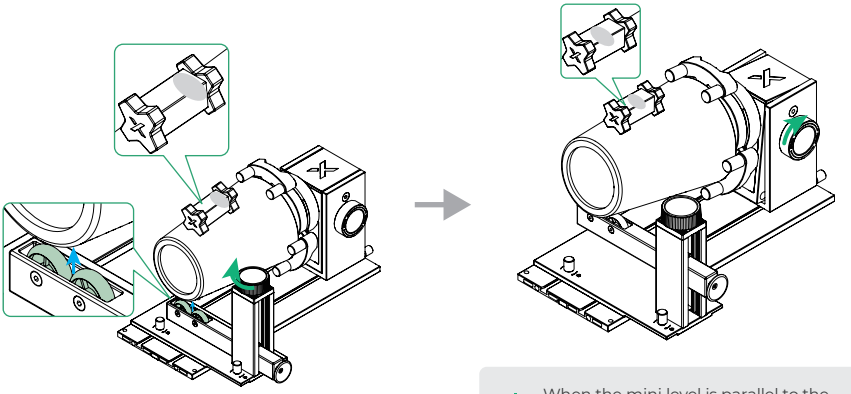
7 Place the mini level on the conical cup.



8 Rotate the side knob counterclockwise to unlock the angle adjustment function of the power module.

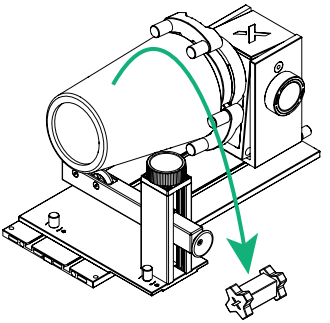


9 Rotate the knob to adjust the height of the two wheels on the support module until the mini level is parallel to the ground. Next, rotate the knob clockwise to lock the angle.

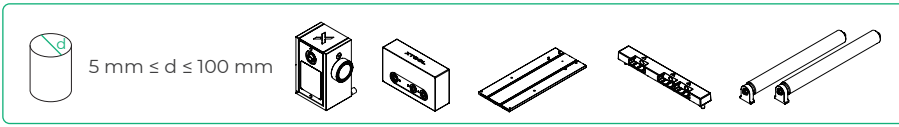


When the mini level is parallel to the ground, the bubble in the mini level is centered.

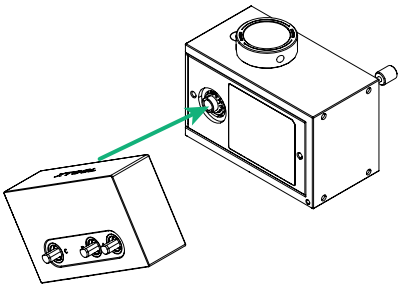
10 Remove the mini level from the conical cup.

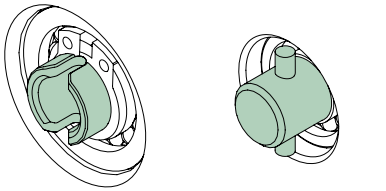


Roller mode

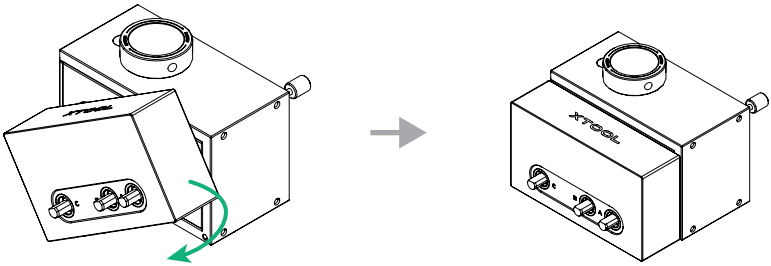


1 Insert the roller transmission module into the power module, aligning the highlighted parts.

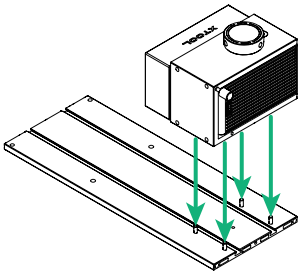




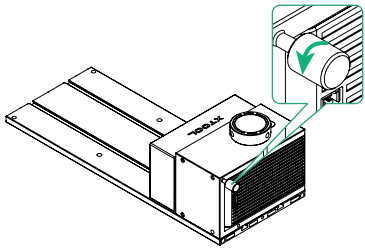
2 Rotate the roller transmission module until its bottom edge is parallel to the bottom edge of the power module.



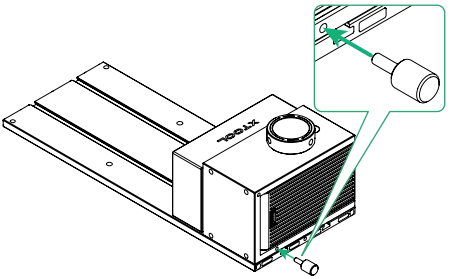
3 Place the power module and the roller transmission module on the main baseplate.



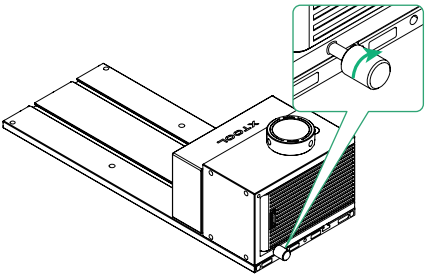
4 Unscrew the thumb screw.



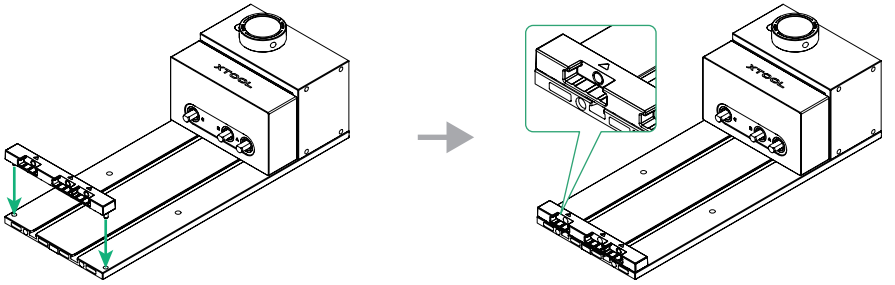
5 Screw the unscrewed thumb screw into another hole in the power module.



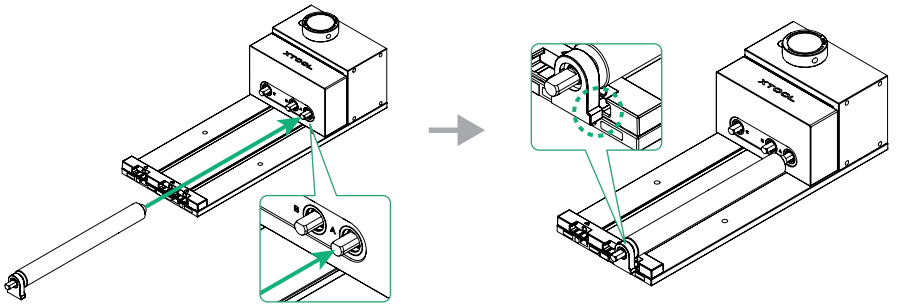
6 Tighten the thumb screw.



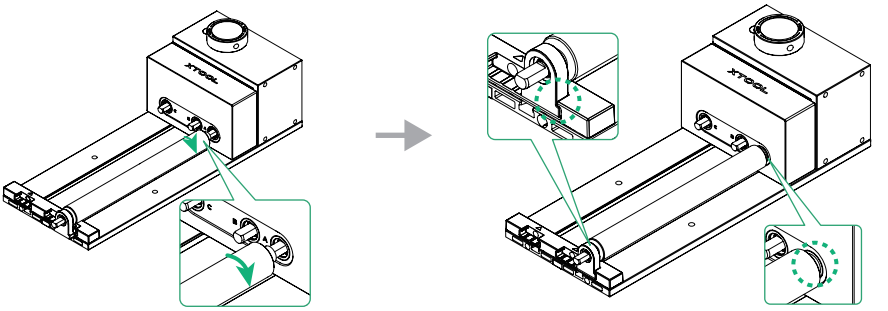
7 Place the holder for roller components on the main baseplate. Pay attention to the direction.



8 Install the roller components onto shaft A on the roller transmission module.

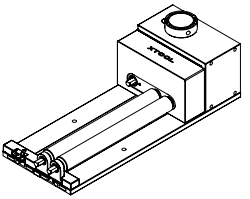


9 **Rotate the roller until it is installed onto shaft A. Ensure that both ends of the roller components are properly installed.**

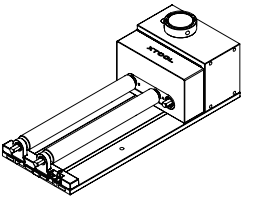


10 **Install the other roller components in the same way. Here are three scenarios depending on the workpiece's diameter.**

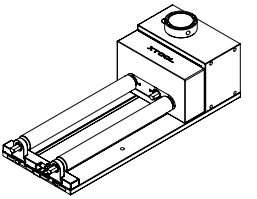
Scenario 1: Level S (roller components installed onto shaft A and shaft B)
5 mm ≤ d ≤ 45 mm



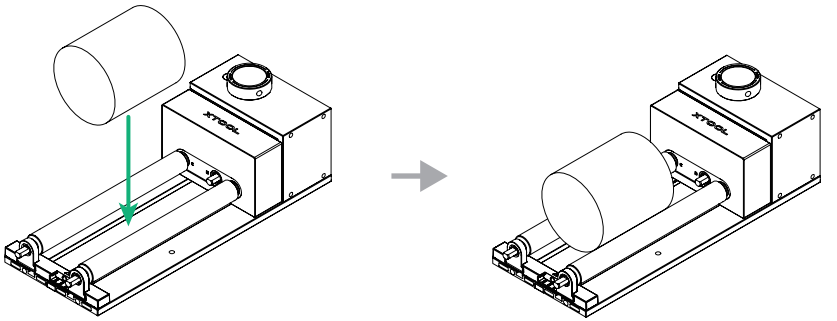
Scenario 2: Level M (roller components installed onto shaft B and shaft C)
40 mm ≤ d ≤ 70 mm



Scenario 3: Level L (roller components installed onto shaft A and shaft C)
60 mm ≤ d ≤ 100 mm

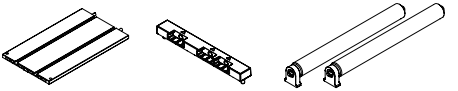


11 **Place the workpiece between the two rollers.**

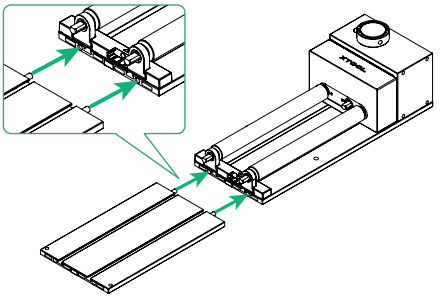


To process objects in batches, the roller extension components can be purchased separately.

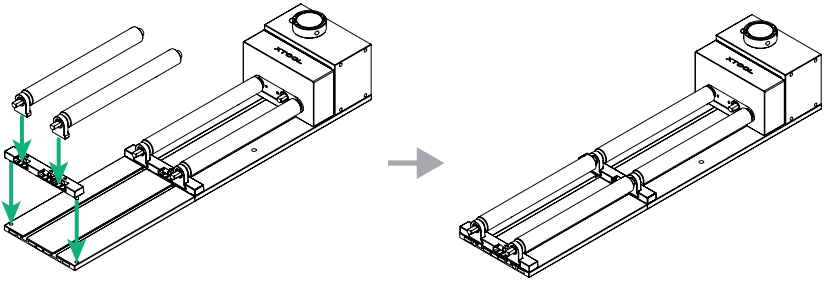
5 mm ≤ d ≤ 100 mm



1 Insert the extension baseplate into the main baseplate.



2 Refer to the earlier instructions to install the holder for roller components and the roller components.



3 Place the workpieces between the rollers.