



# **Butler Installation Instructions Gammill Original Metal Frame Short Ended Carriage Version**

**Installation Addendum**

**Installing the Robot Mounting Bracket and  
the Idler Mounting Bracket**



## Butler Installation For Gammill

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<b>PARTS LIST</b>		
<b>Part Bag #</b>	<b>Contents</b>	<b>Picture</b>
<b>307-121000000001</b>	(1) 206-FGMLS0RB1D01 - Gammill Metal Frame Robot/Idler Bracket  (4) 220-P0GMLENDCB01 – Gammill Metal Frame Carriage End Caps  (4) #8-32 x 1.25" Pan Head Machine Screws  (8) #8 Plain Steel Washers  (4) #8-32 Steel K-Lock Hex Nuts  (2) M5 x 12mm Pan Head Machine Screws	
<b>307-M21000000001</b>	(1) 206-FGMLS0RB1D01 - Gammill Metal Frame Robot/Idler Bracket  (4) 220-P0GMLENDCB01 – Gammill Metal Frame Carriage End Caps  (4) #8-32 x 1.25" Pan Head Machine Screws  (8) #8 Plain Steel Washers  (4) #8-32 Steel K-Lock Hex Nuts  (2) F624ZZ Flanged Bearings  (1) M4 x 16mm Pan Head Machine Screw  (1) M4 Plain Steel Washer	



## Butler Installation For Gammill

### How To Install the Robot And Idler Pulley Brackets

Step 1:

Remove all four black endcaps on the rails of your carriage.

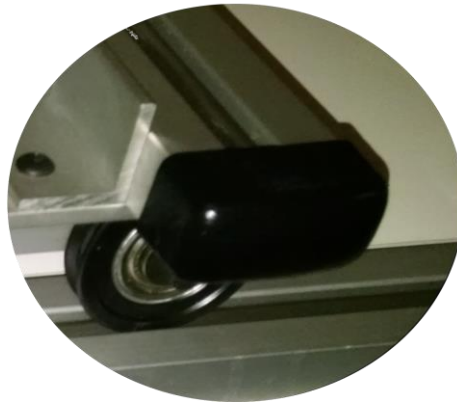


Figure 1

Step 2:

Using a #16 drill bit ( 0.177" ) drill holes in the following locations using the procedure outlined below. Note: The front of the carriage is on the right side of Figure 2.

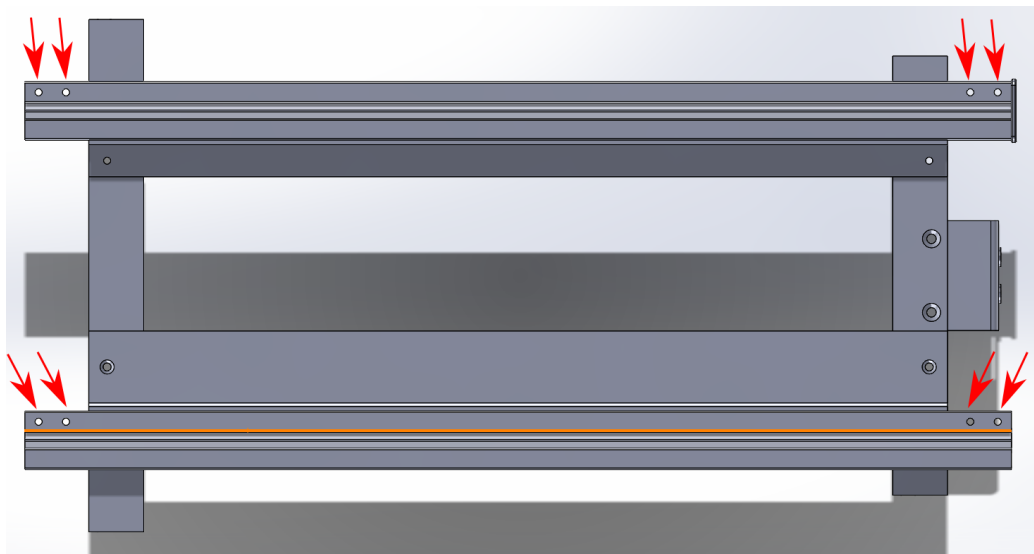


Figure 2



## Butler Installation For Gammill

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Mark the location of each of the holes shown above using the replacement endcaps in your kit. A representation of this part is shown in Figure 3.

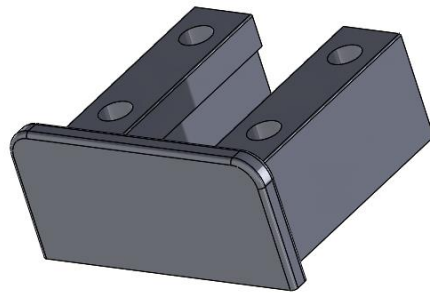


Figure 3

Insert each endcap into the four ends of your carriage rails

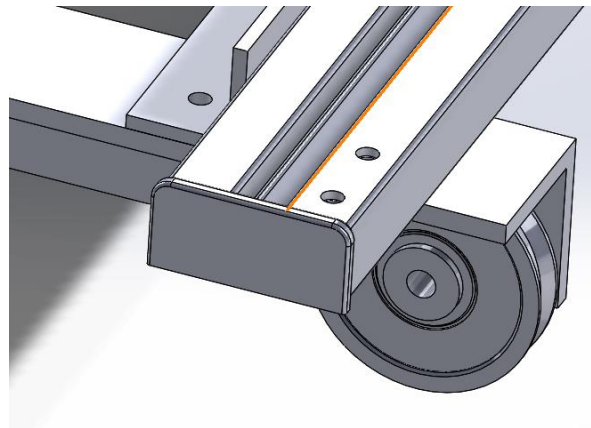


Figure 4



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Using a 1/8" metal punch through the endcap mounting holes, mark the location of the holes that are to be drilled. While there are four holes through each endcap, be mindful that you will only be using two holes for each one. Take extra care and frequently refer to Figure 2 in order to make sure you are drilling in the right place.

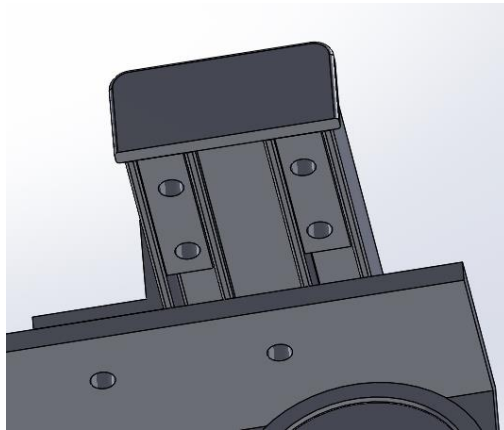


Figure 5

When the holes are drilled your carriage should resemble Figure 2.

### Step 3:

With the provided endcaps inserted into the carriage rail ends, attach the Robot Mounting Bracket using the included #8-32 x 1.25" machine screws and #8-32 nuts. This is illustrated in Figure 6.

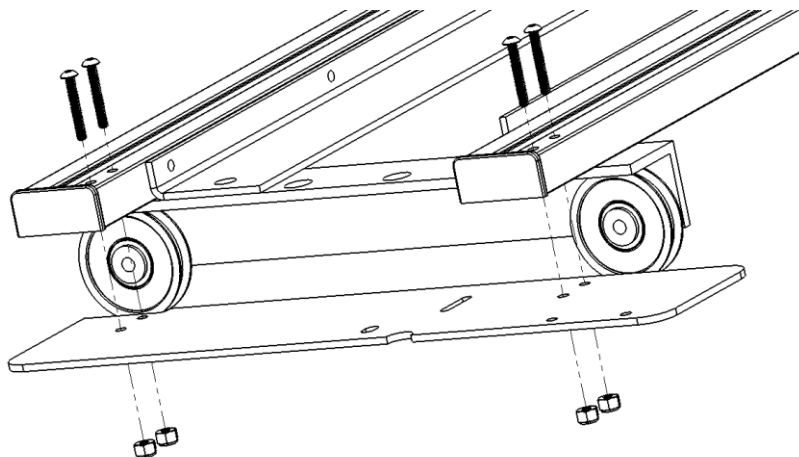


Figure 6 (Carriage Front. Magnetic stop has been omitted for clarity)



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### Step 4:

Again, with the provided endcaps inserted into the carriage rail ends, attach the Idler Mounting Bracket to the rear of the carriage using the provided #8-32 x 1.25" machine screws and #8-32 hex nuts. See Figure 7.

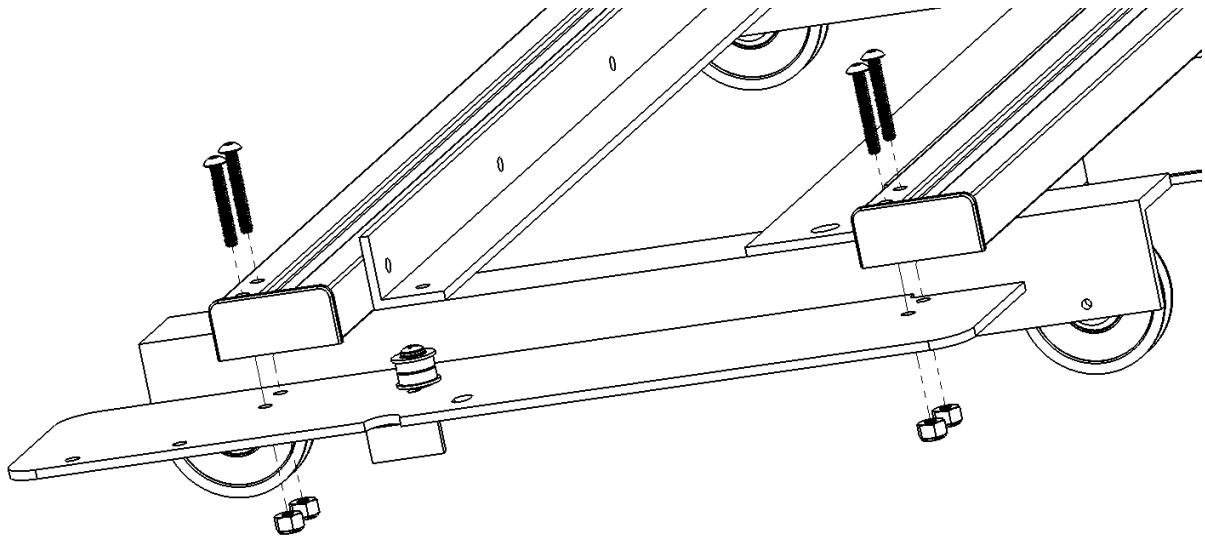


Figure 7



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### Step 5:

Attach the Butler Robot Motor Box to the Robot Mounting Bracket using the included M5x12mm machine screws.

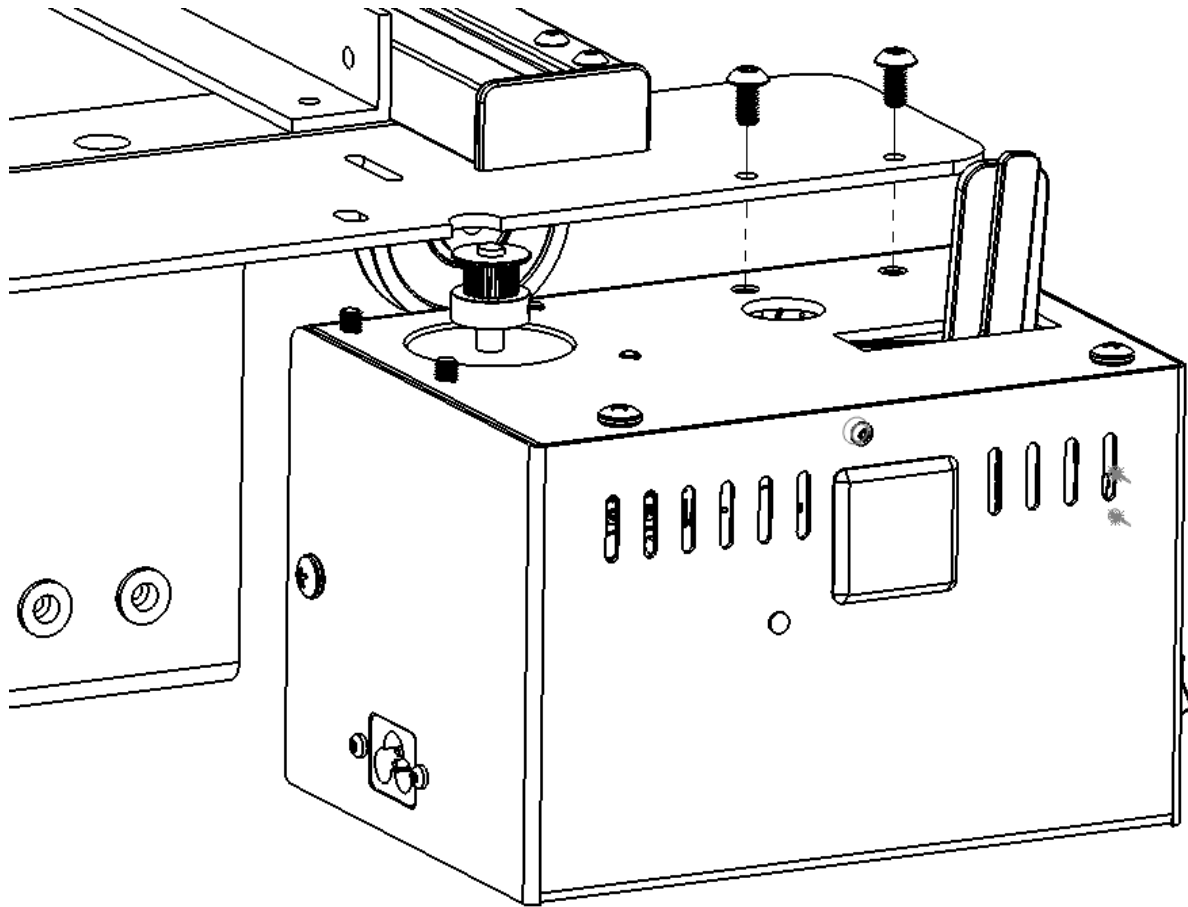


Figure 8

Make sure that the pulley on the robot and the pulley on the Idler Bracket are in line. See Figure 9 for reference. If all is in order, continue your installation using the original instructions that came with your Butler Robot.



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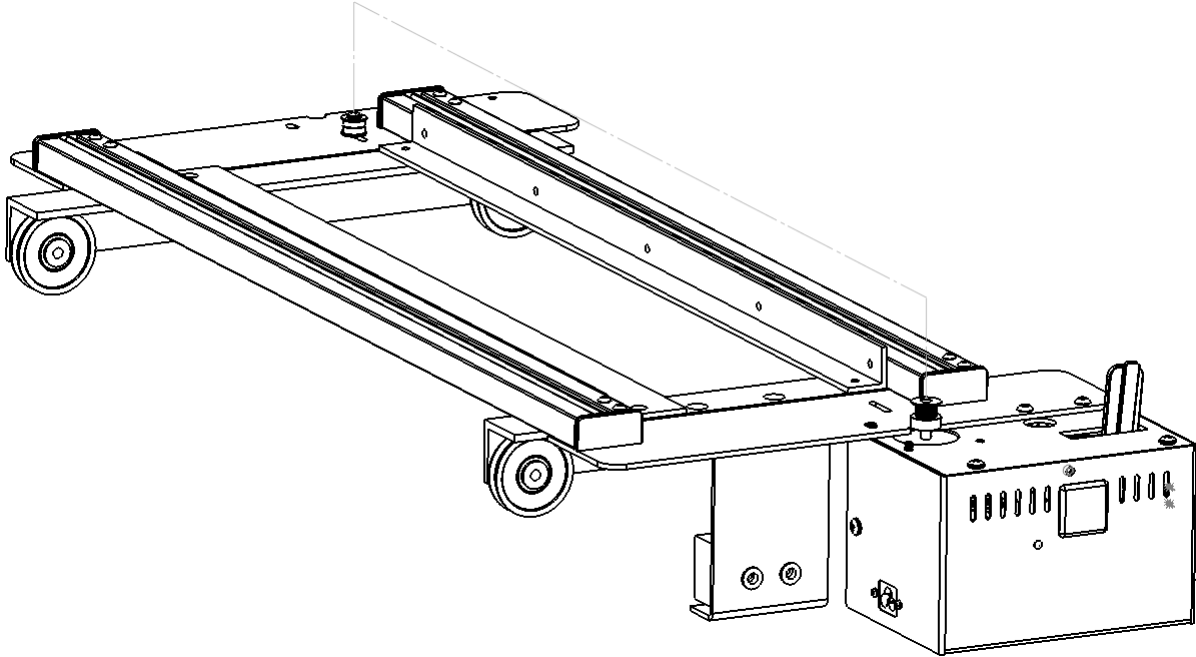


Figure 9



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