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## D200 - Replacing Sacrificial Table Surface

**Gerber FastFact #** 2024

**Supplied by:** Gerber Service

**Last Modified:** November 30, 2001

**Summary:** This document outlines the basic recommended procedure and important steps for replacing the sacrificial table surface of Dimension 200® series routers.

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### Removal of Sintra mats:

The first step is to remove the old table mats. This can be accomplished prying up the table mat, starting at one end, with a putty knife and peeling it off. This will leave some adhesive behind, which must be completely removed.

### Preparation of the aluminum table surface:

The adhesive can be removed with most any strong solvent\*. Once you have completely removed the adhesive, wash the table surface with a lint-free cloth and any ammonia-based window/surface cleaner. Go over the table again with a new lint-free cloth and 99% isopropyl alcohol. Your table is now ready to accept new mats.

**Note: If you wait more than 30 minutes before installing the new mats, you must repeat the last step (alcohol) in the table preparation before continuing.**

**\*Be sure to comply with any safety precautions of all chemicals.**

### Preparation of the new mats:

Before applying the two-sided tape to the mats, you must wipe them with a new lint-free cloth and 99% isopropyl alcohol. Once the mats are dry, apply the tape to each mat by cutting a length off the roll that is about 2+ inches longer than the mat using a squeegee. It is important that there are no air bubbles and that the tape is applied with maximum pressure. Trim off any excess.

### Installing the mats onto the table:

It is easy to tell where the old mats were—the aluminum surface will appear newer. Peel the liner off the tape, position the mat exactly where the old one was, and apply it to the aluminum slat. You should use a good amount of pressure to ensure that the tape will adhere properly to the aluminum, concentrating on the edges. Repeat this seven times and you've got a new tabletop.

### Milling the new tabletop:

Once you have installed all of the new mats, you'll need to skim-cut, or mill, the table to insure that it is perfectly flat. The *D200 mill* file is in the **rtp** folder under the **jobs** directory. It uses the ¾" table-surfacing

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tool that came in the D200 tool kit (P50569A), initialized to the table surface using the plexi-glass initialization gage. Position the router at 0,0 and run the file.

**If you have any questions, please call Gerber Service at (860) 644-6971.**