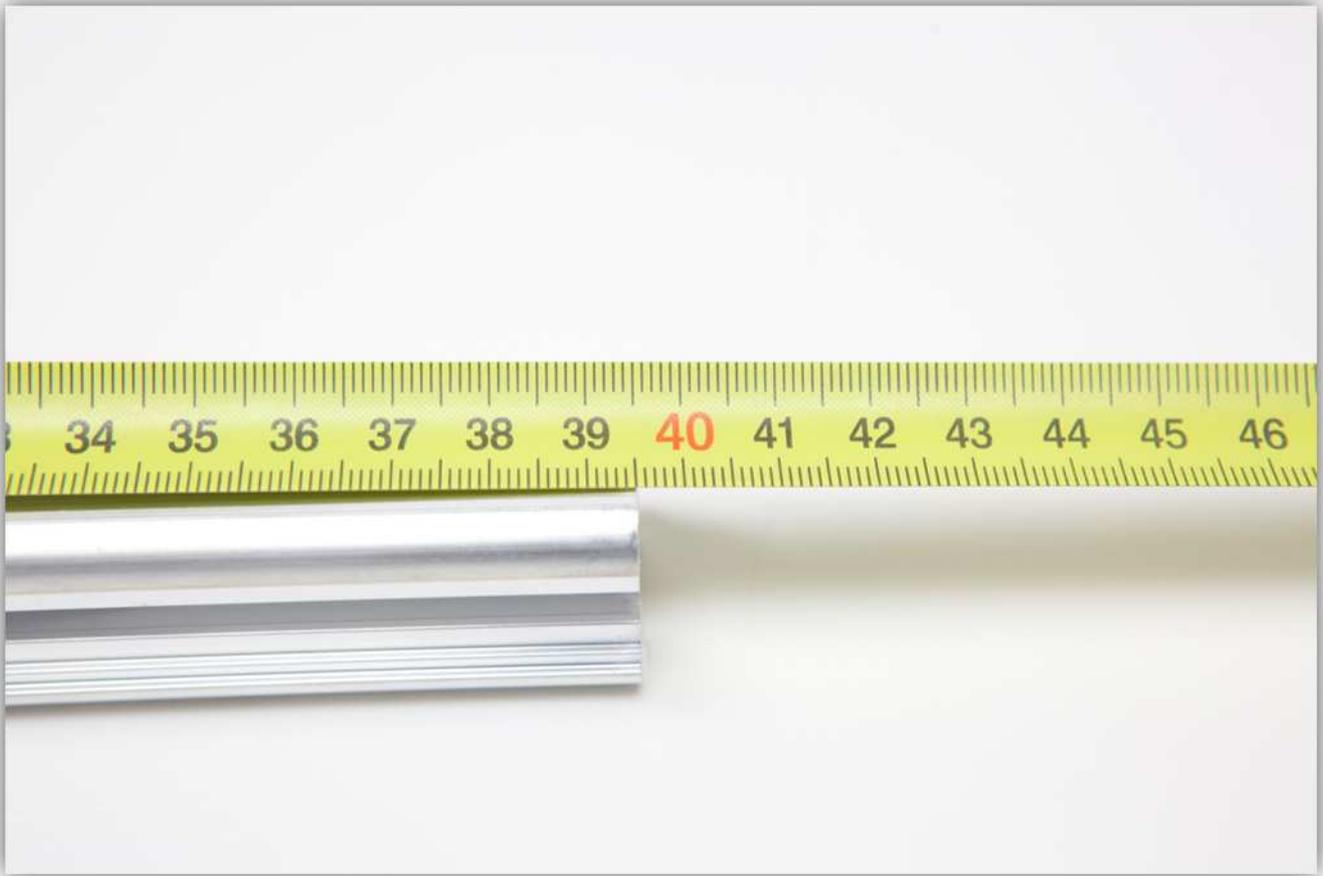


006 – ASSEMBLING THE EXTRUDER ARM

Take one ALUMINIUM PROFILE of 395 mm (15.6") out of the box.



Take the FAN HOLDER BRACKET out of the bag labelled with 25, also take 4 square M5 nuts (bag 16) and 2 ANGULAR MOUNTS (bag 14).



Slide the 2 ANGULAR MOUNTS into one end of the ALUMINIUM PROFILE of 395 mm (15.6").



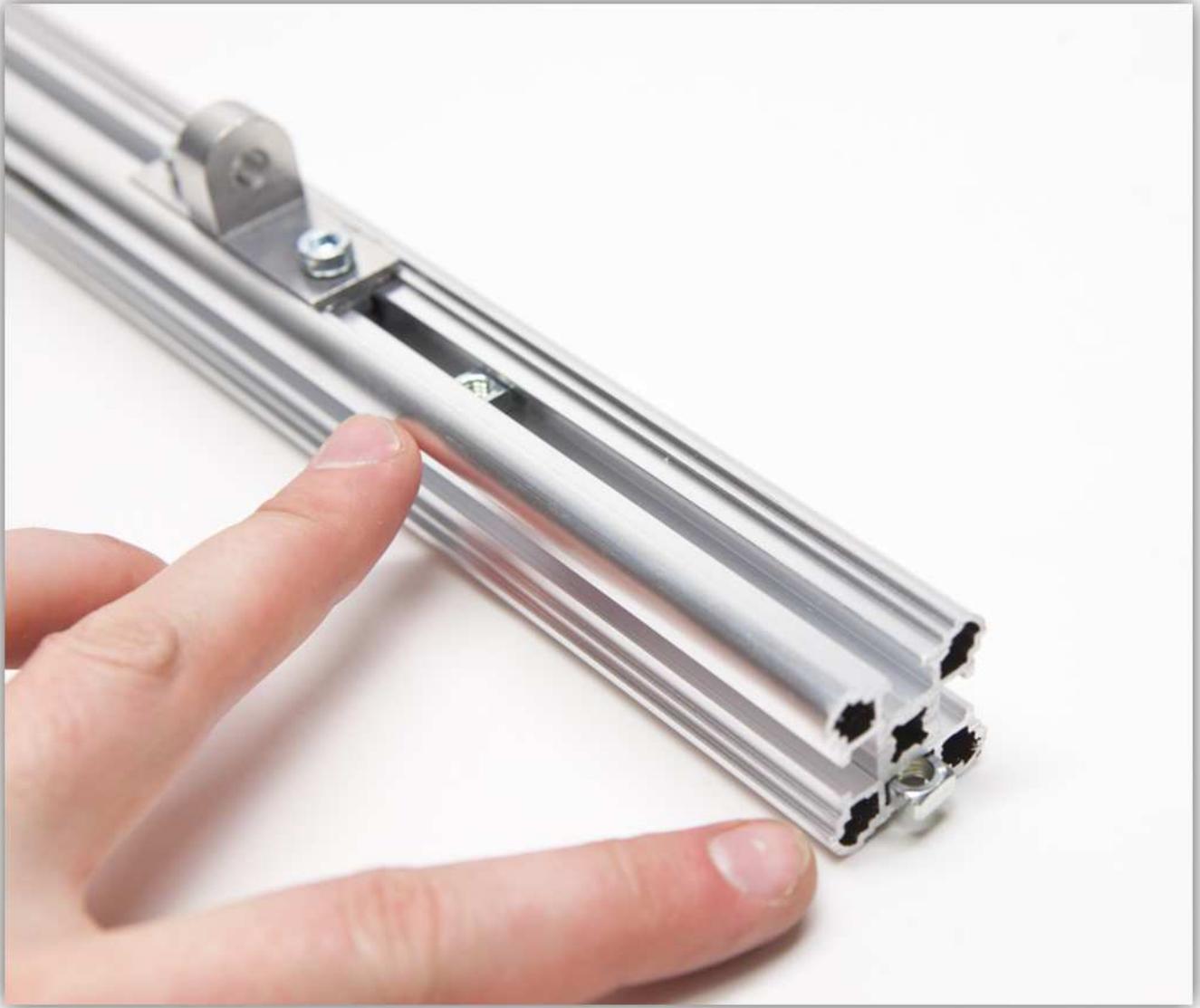
Slide 2 square M5 nuts into the ALUMINIUM PROFILE as shown in the picture below.



Slide the FAN HOLDER BRACKET and 1 square M5 nut into the ALUMINIUM PROFILE. **Notice the orientation of each part.**



Now insert another square M5 nut on the opposite side of the fan holder bracket. **Notice the orientation.**



Now slide the ALUMINIUM PROFILE into the BEARING CLAMP Z SMALL piece.



Now slide the two ANGULAR MOUNTS into the Z CARRIAGE. Be careful that while doing this, none of the square M5 nuts slide out of the angular profile.



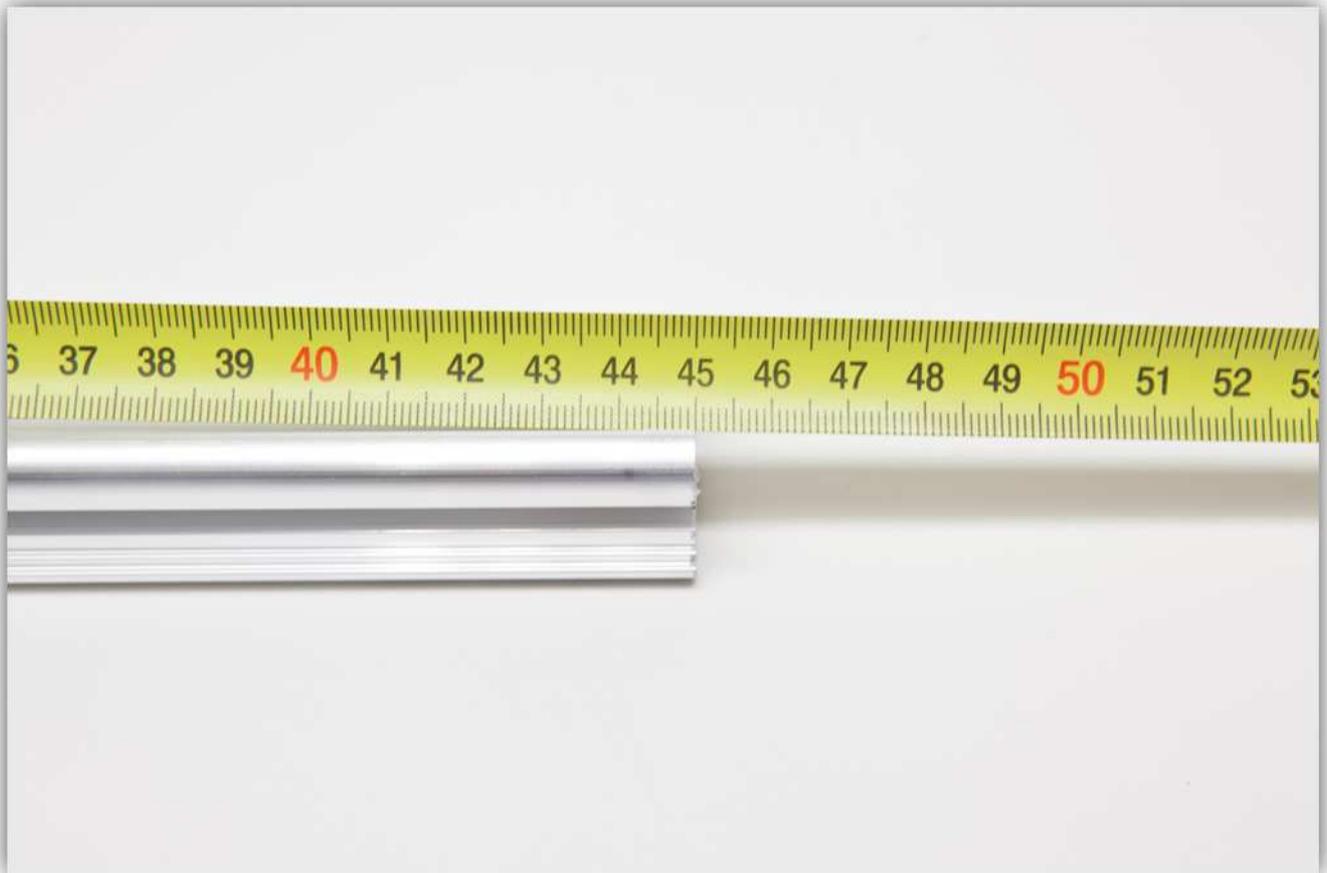
Make sure there is about 5 mm of a gap from the top of the Z CARRIAGE and the top of the ANGULAR MOUNT.



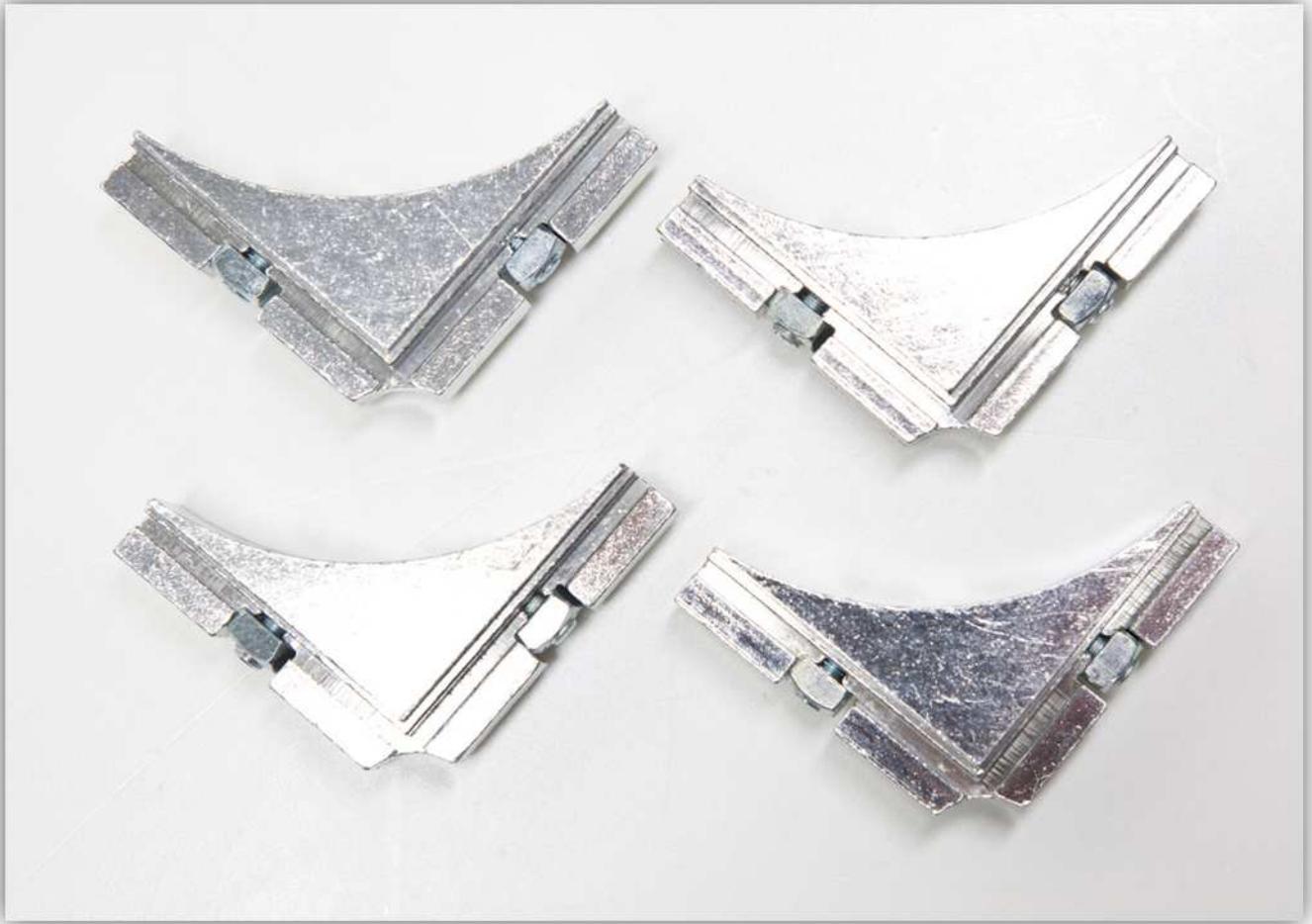
Tighten all the bolts on the ANGULAR MOUNTS.



Now take the last ALUMINIUM PROFILE it should be one of 450 mm (17.7").



Take 4 ANGULAR MOUNTS out of bag 14.



Slide 2 ANGULAR MOUNTS on each end of the ALUMINIUM PROFILE.



Slide this assembly in the top of the frame.





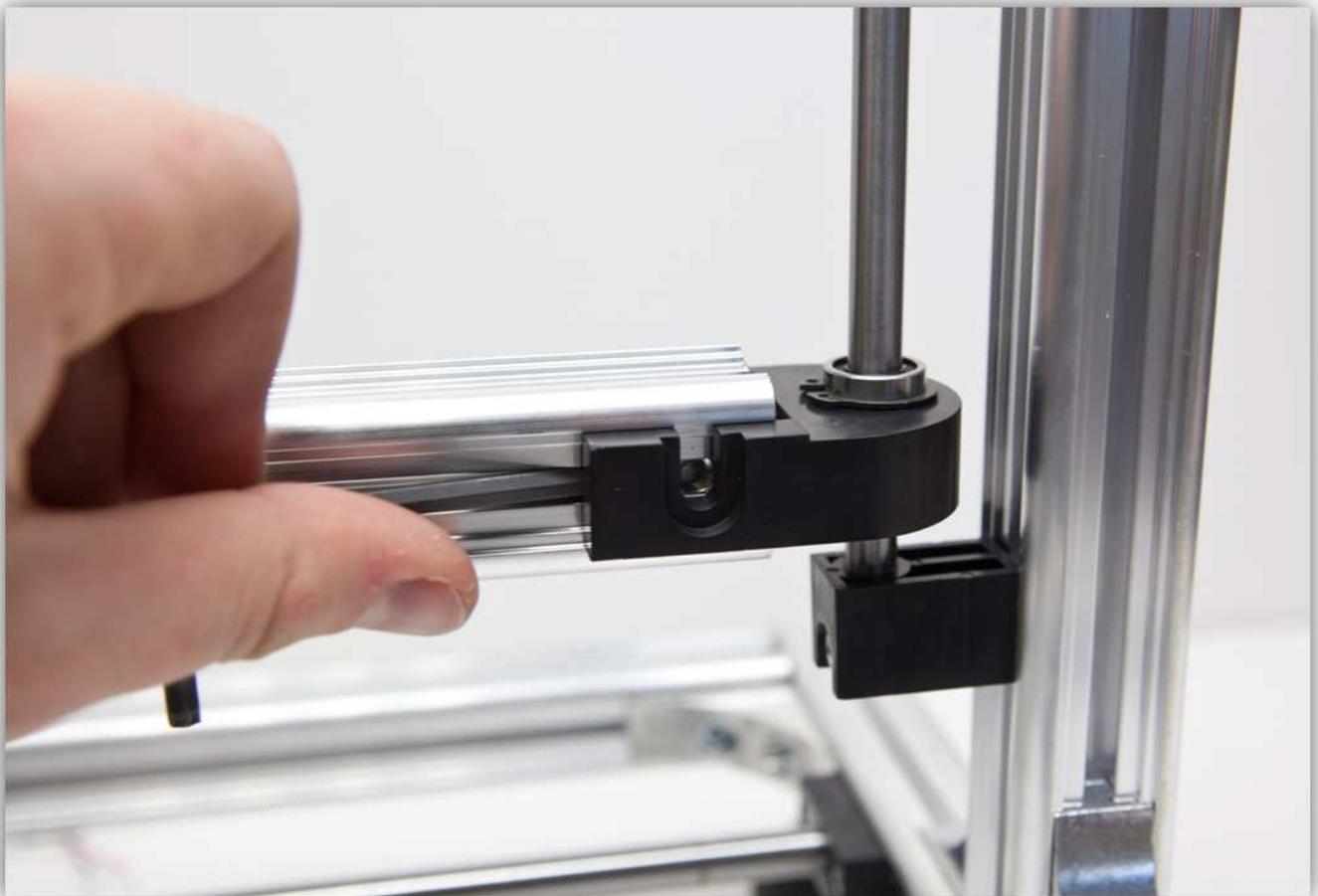
Slide the ALUMINIUM PROFILE down until the tops of the ANGULAR MOUNTS are flush with the tops of the frame.



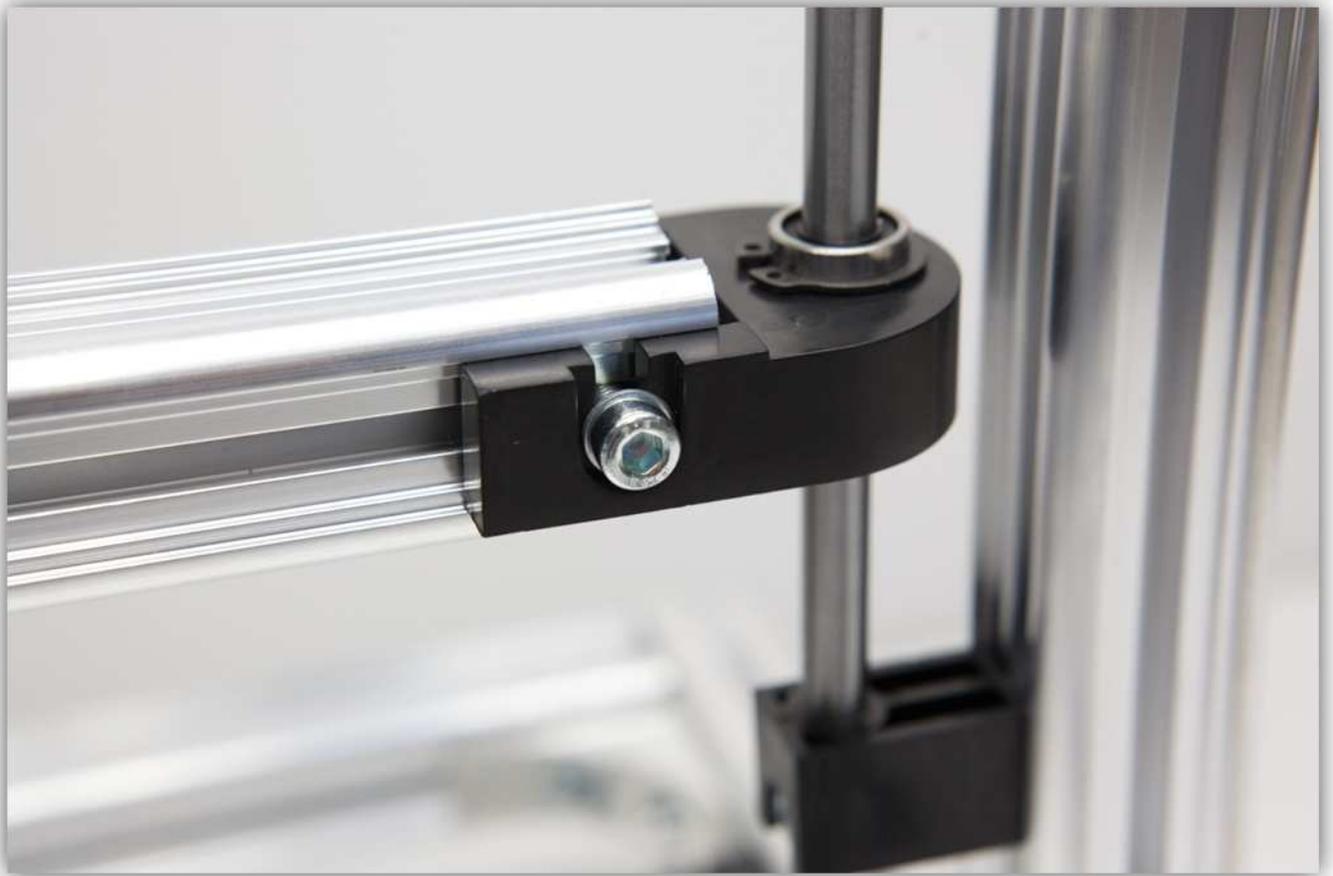
Tighten all the bolts on the angular mounts.

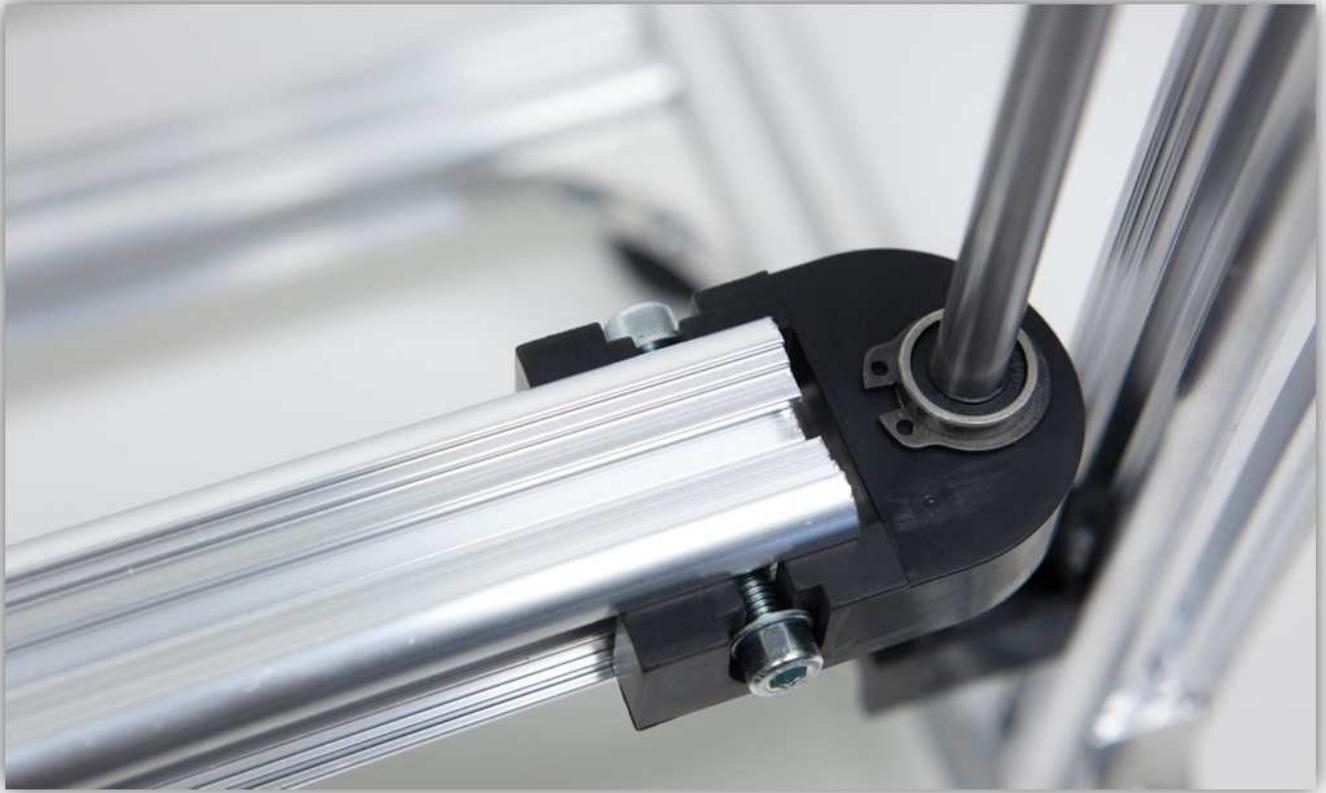


Slide the two square nuts on the opposite of each other in the extruder arm towards the BEARING CLAMP Z SMALL piece.



Use the 2 M5 bolts and 2 M5 washers to screw the BEARING CLAMP Z SMALL piece to the EXTRUDER ARM.





Tighten these bolts while making sure the Z CARRIAGE and the EXTRUDER ARM move freely.

