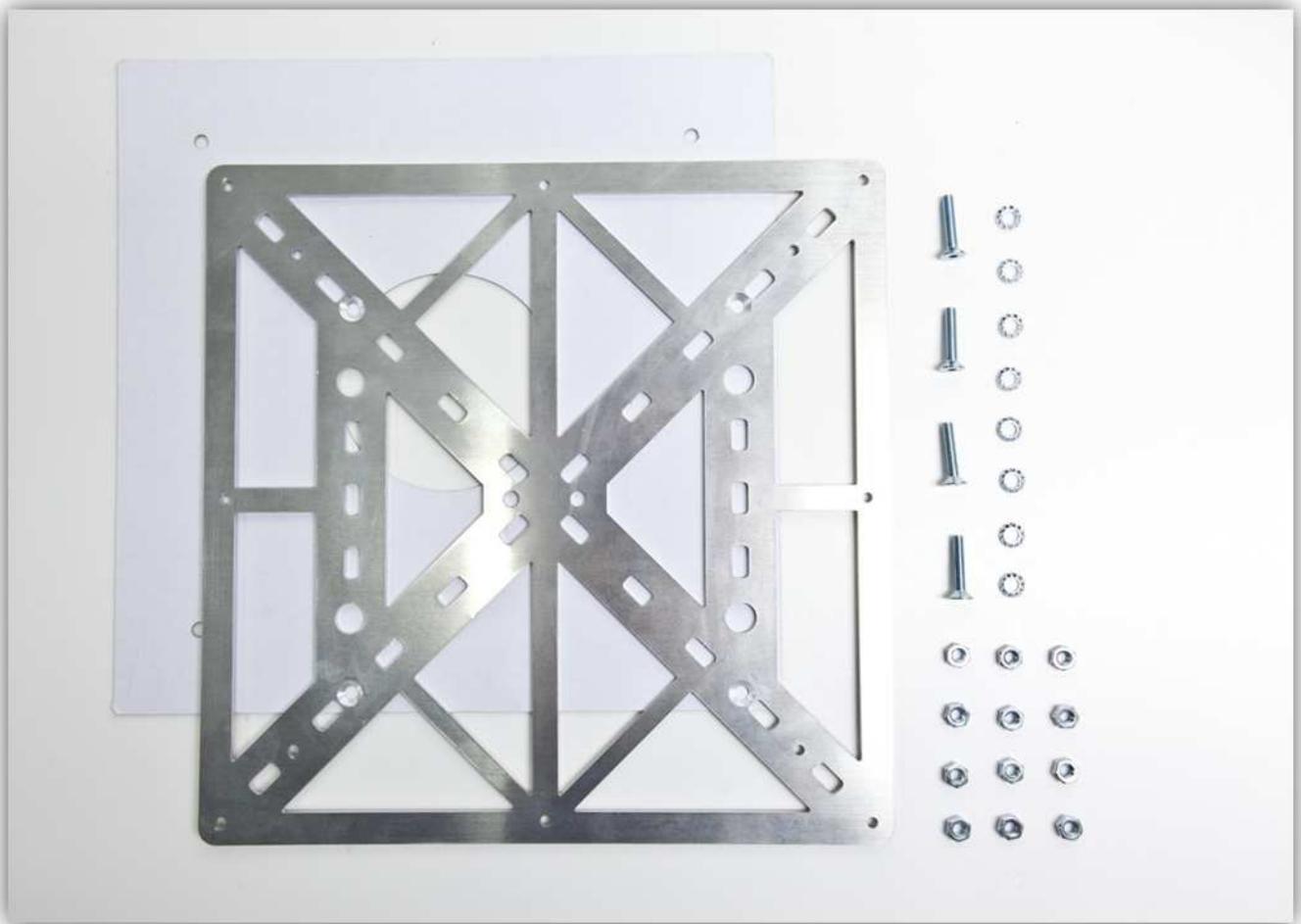
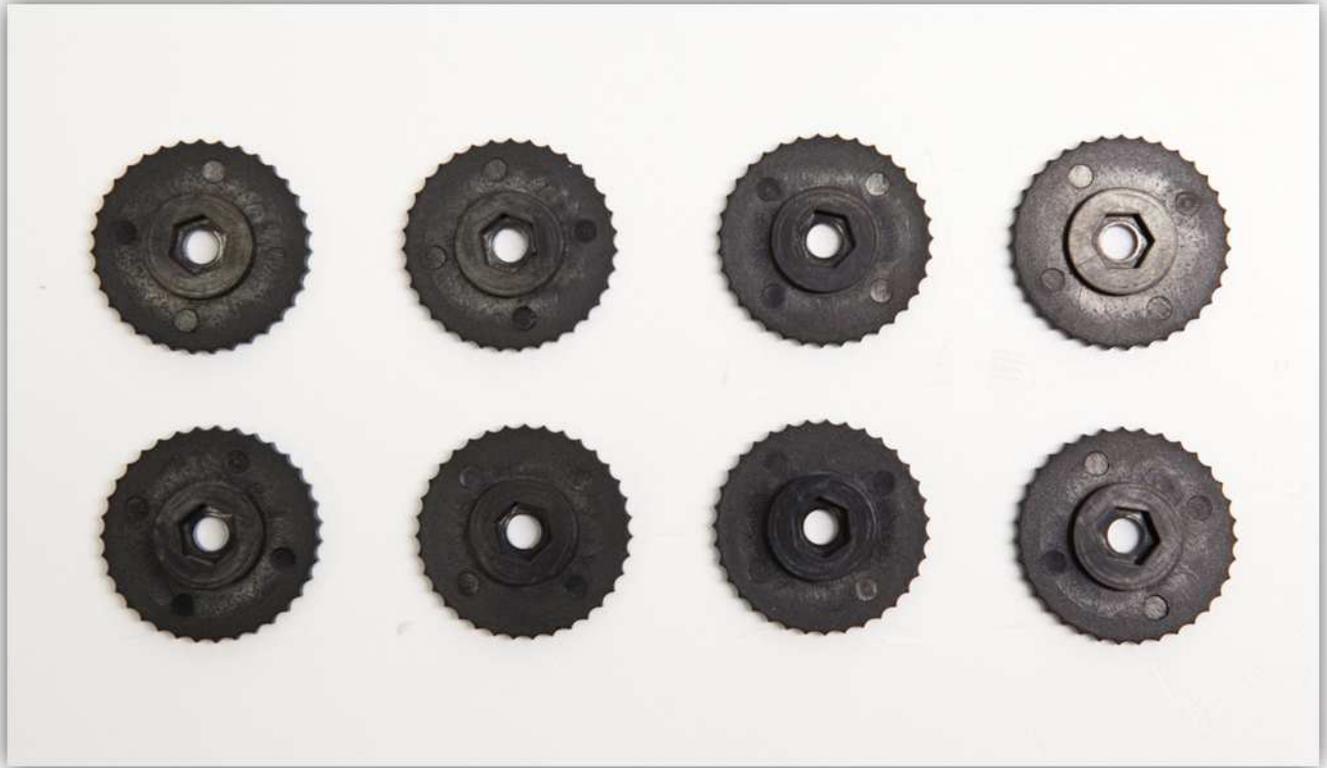


## 010 – ASSEMBLING THE HEATED BED

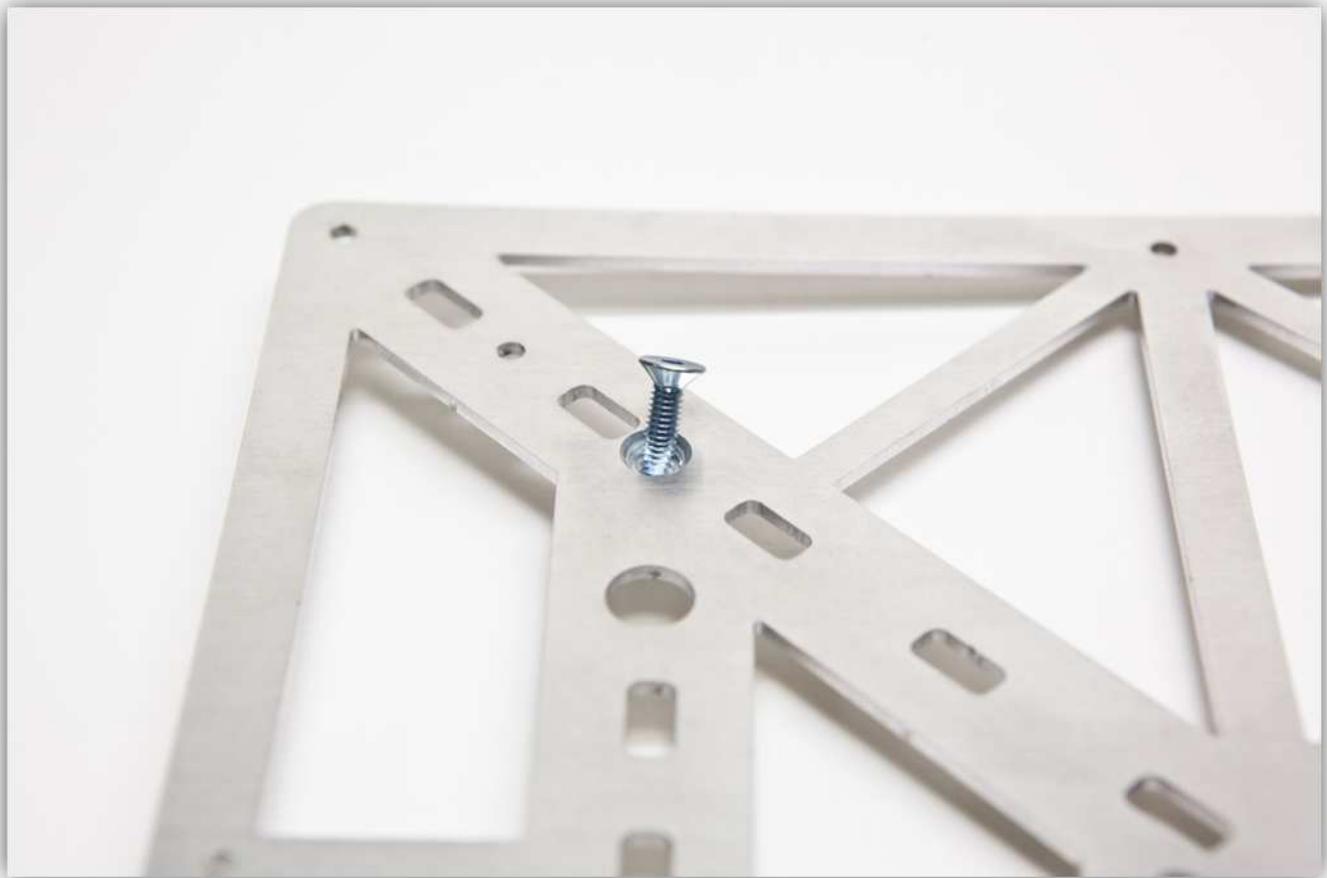
Take all the parts out of the bag labelled with 32.

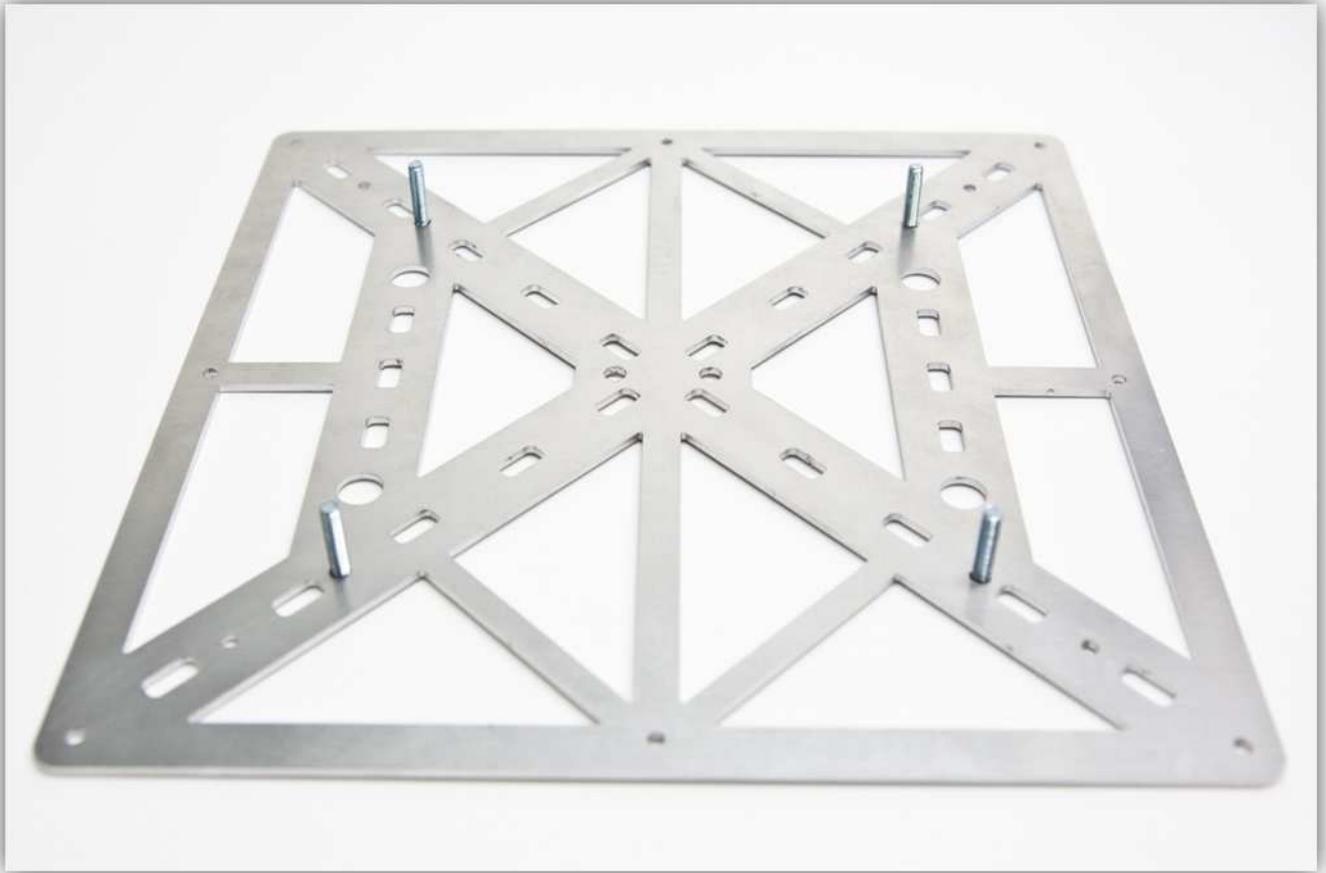


Now take the pieces as shown in the picture below out of the bag with all the plastic parts (THUMB SCREWS)

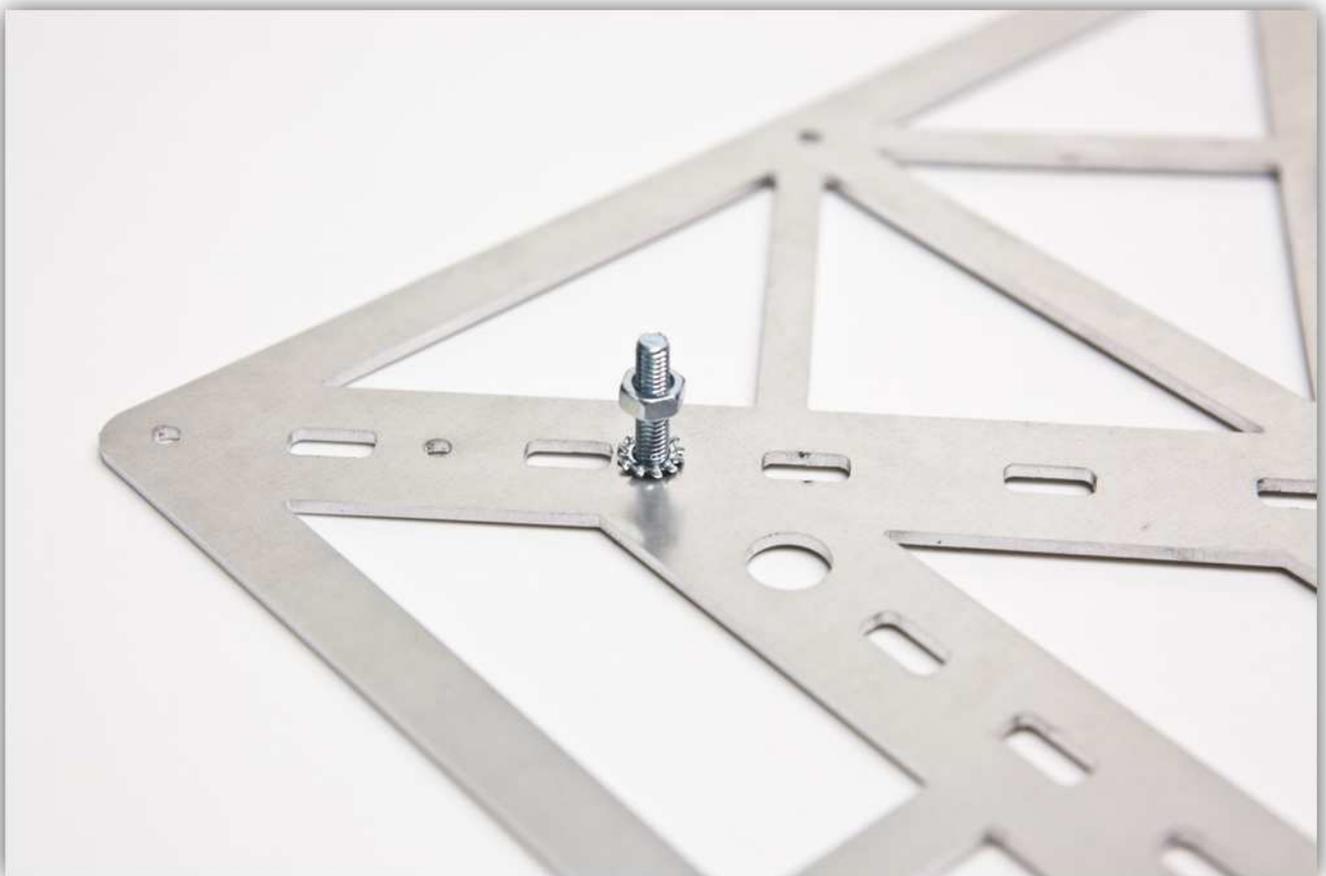


Take the 4 countersunk M4 bolts and put them through the BED PLATE.





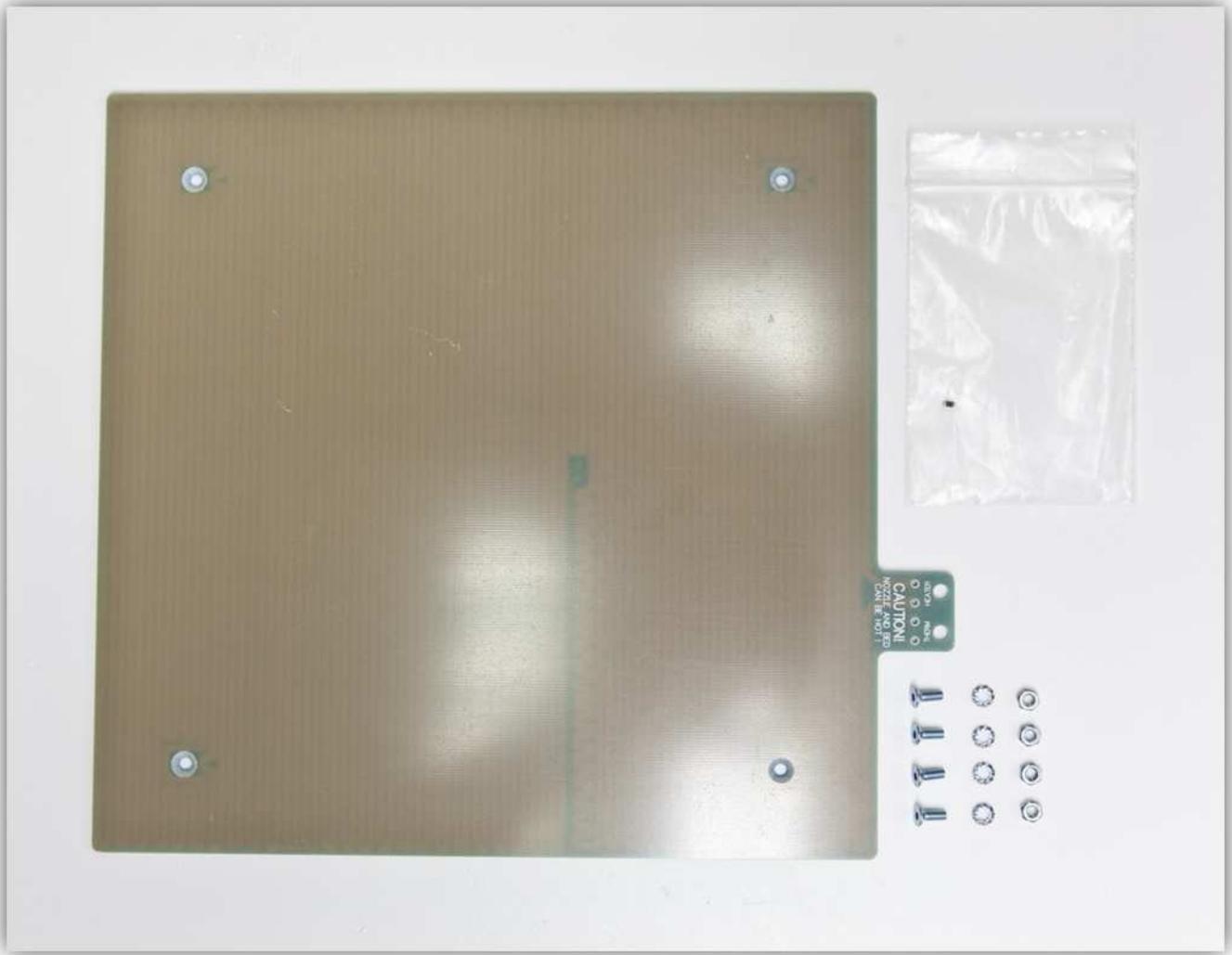
Use 4 M4 toothed washers and 4 M4 nuts.



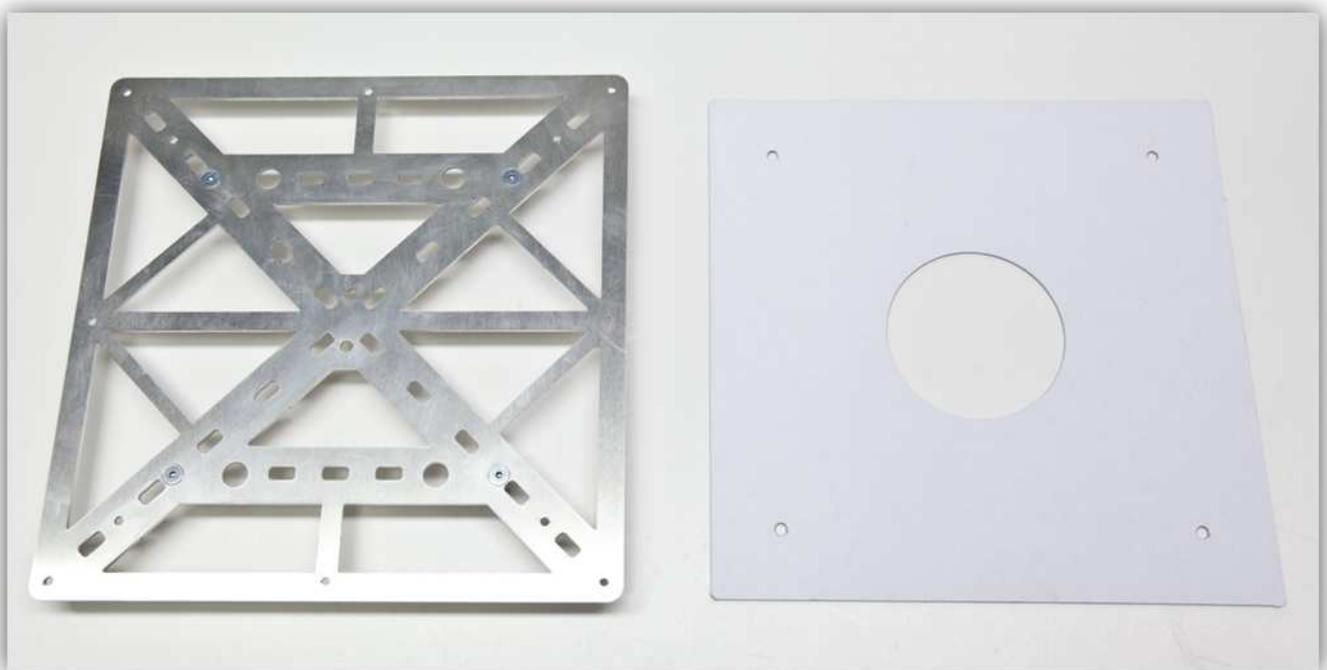
Tighten all these bolts firmly.



Take all the parts out of the bag labelled with 33. **Take extra care with the bag with the small NTC thermistor.**

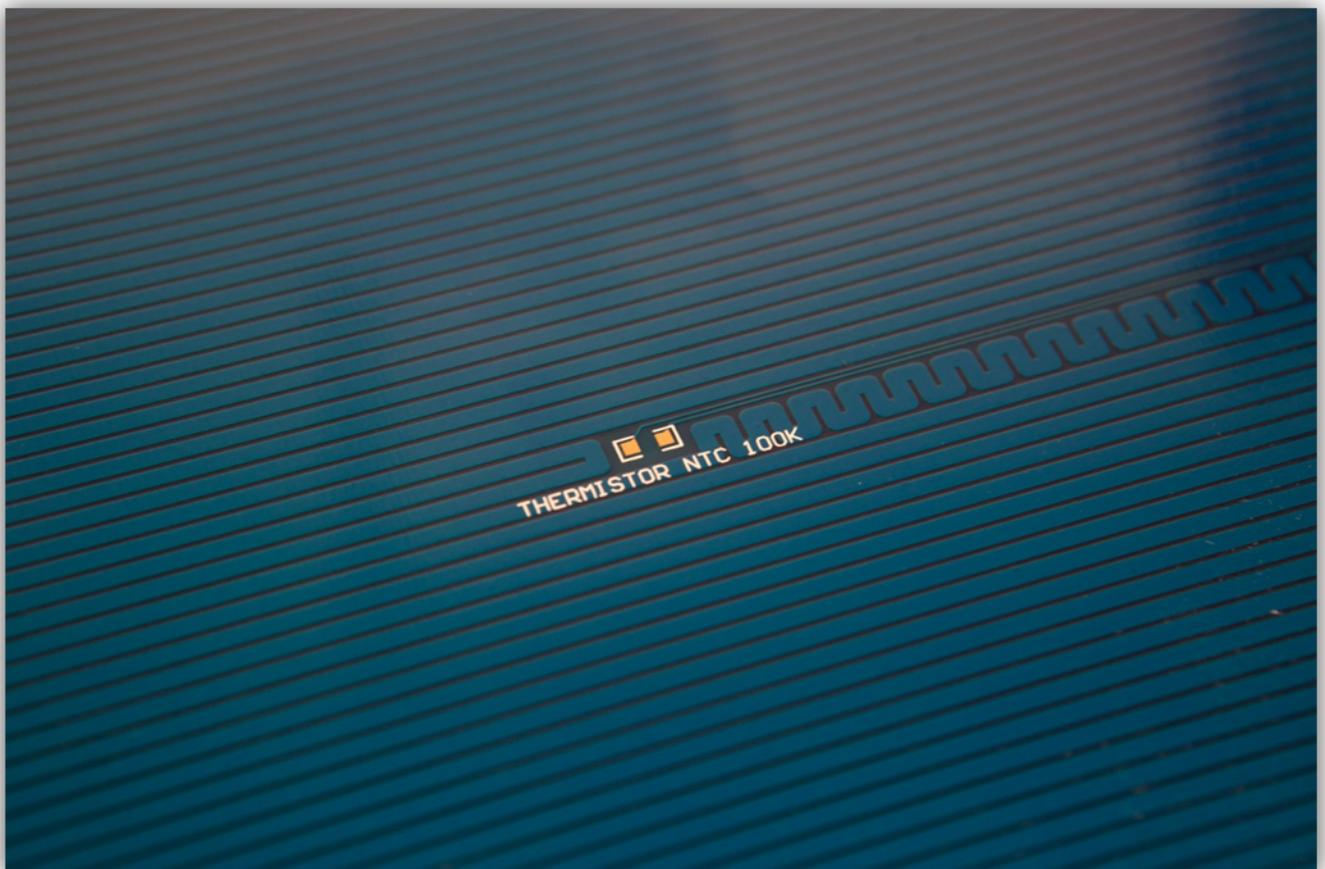


Lay the CARDBOARD ISOLATOR on top of the BED PLATE and align the holes. **Watch the orientation of the bedplate carefully.**



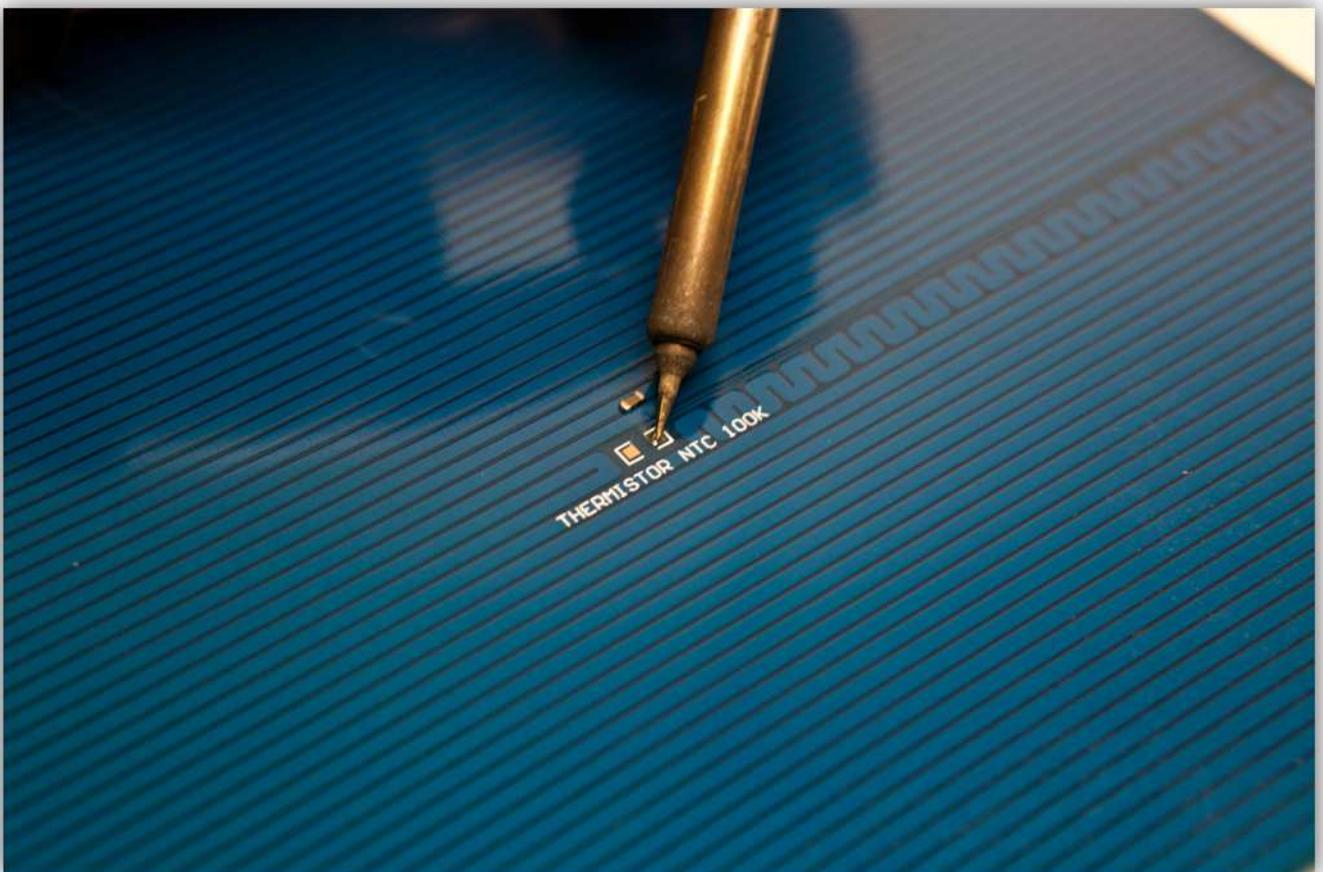


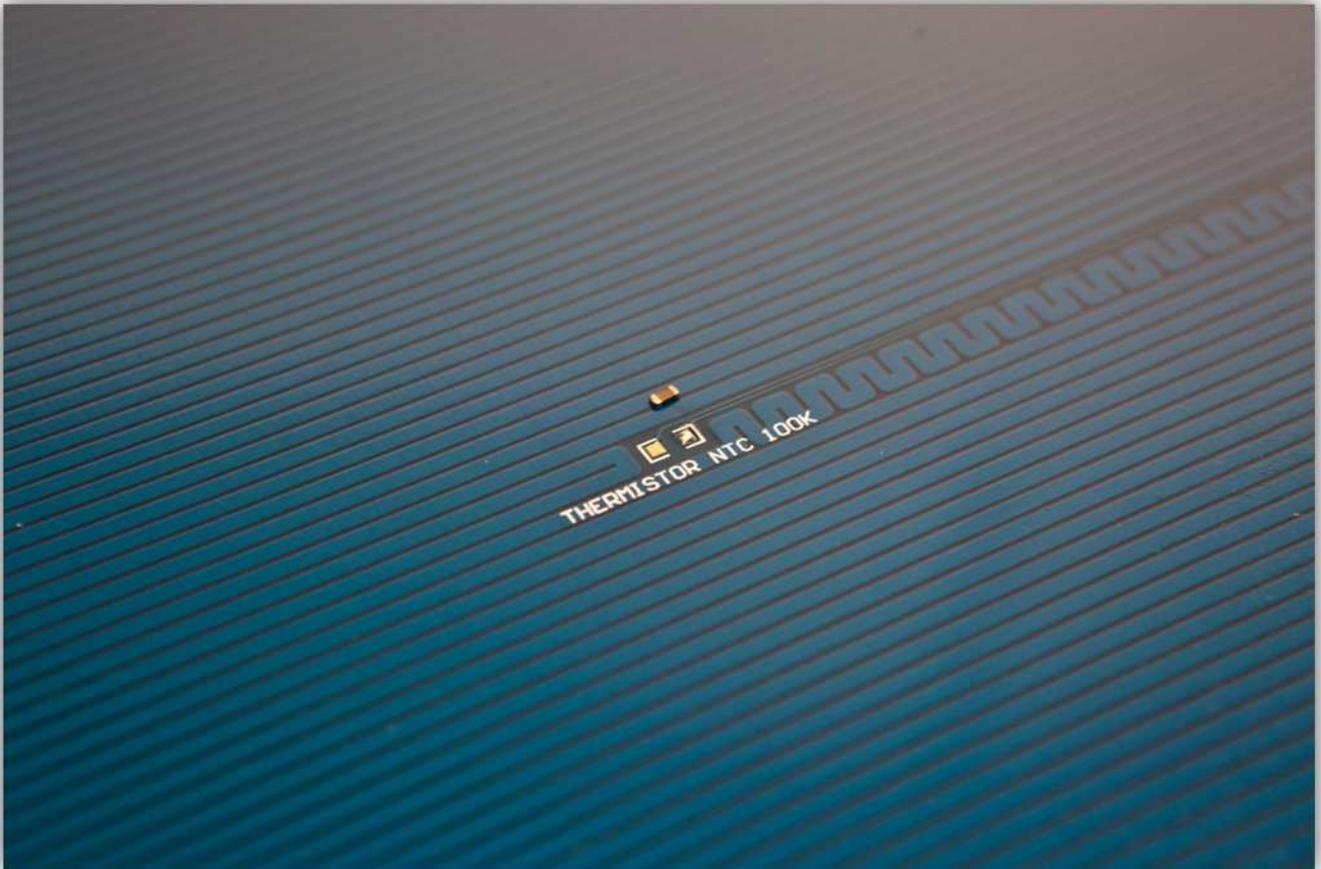
Now take the HEATED BED PCB and the NTC THERMISTOR.



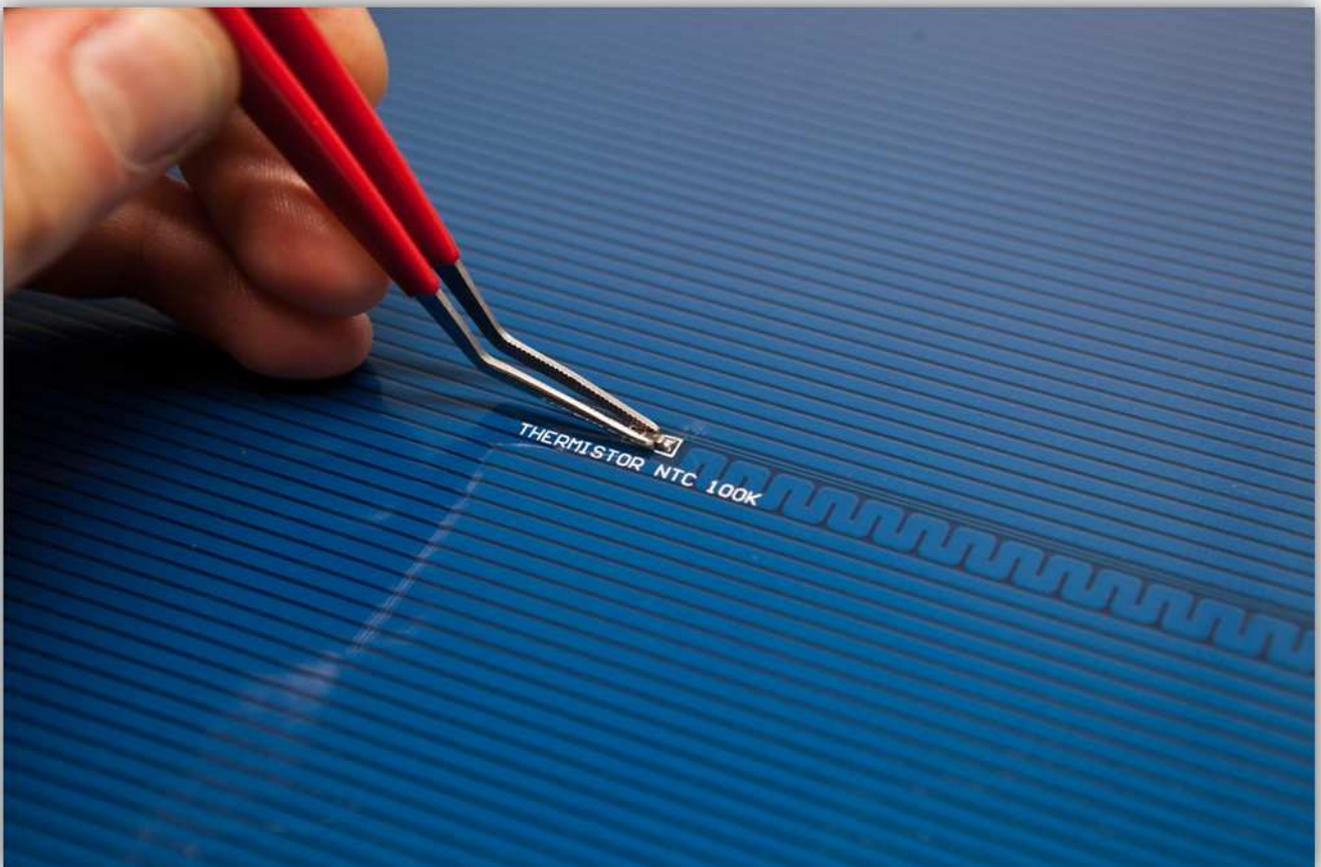


Tin one pad.



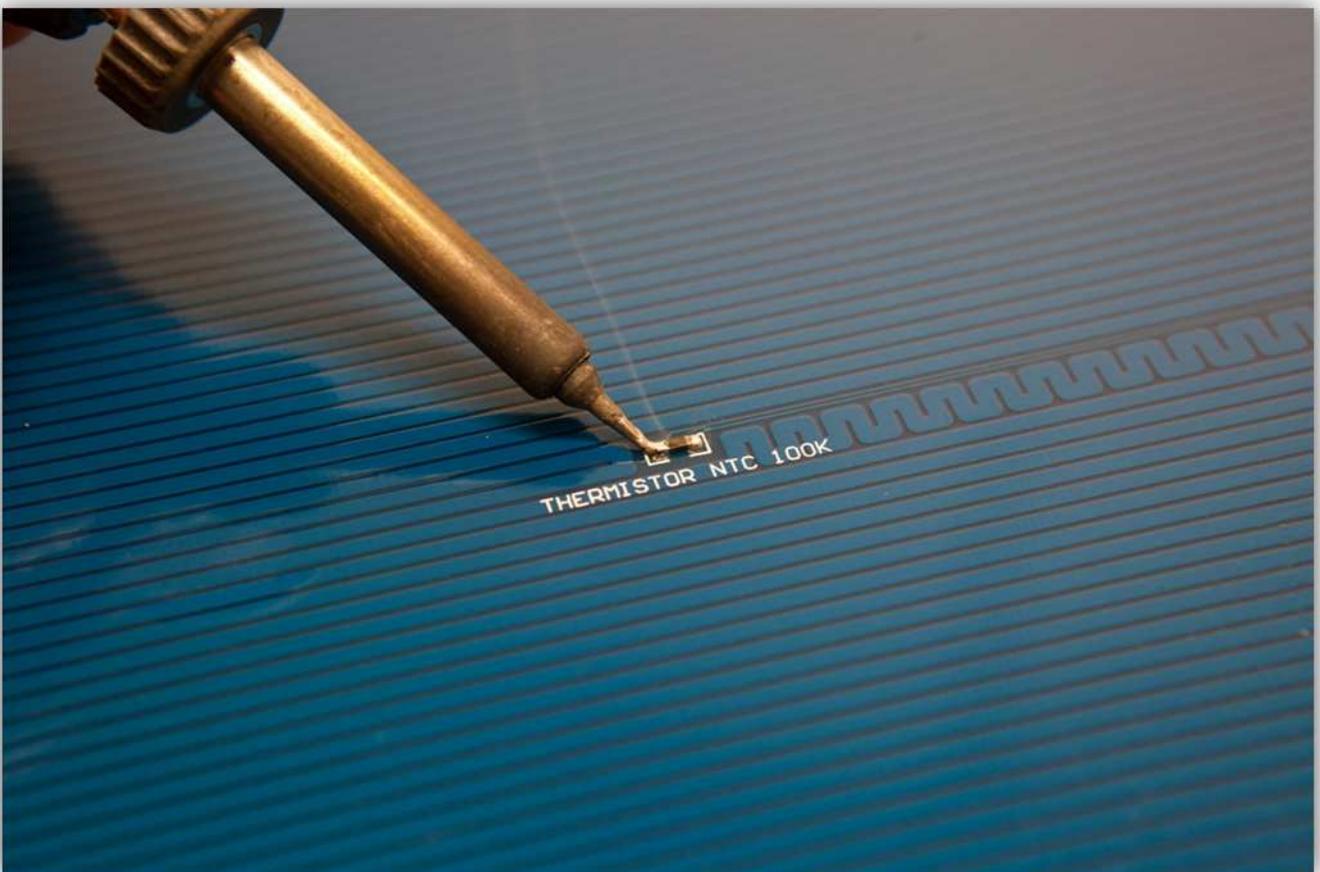


Place the NTC THERMISTOR with one side on the pad while you apply heat, it does not matter which side, a thermistor is not polarized. **Make sure you do not heat the thermistor for too long.**





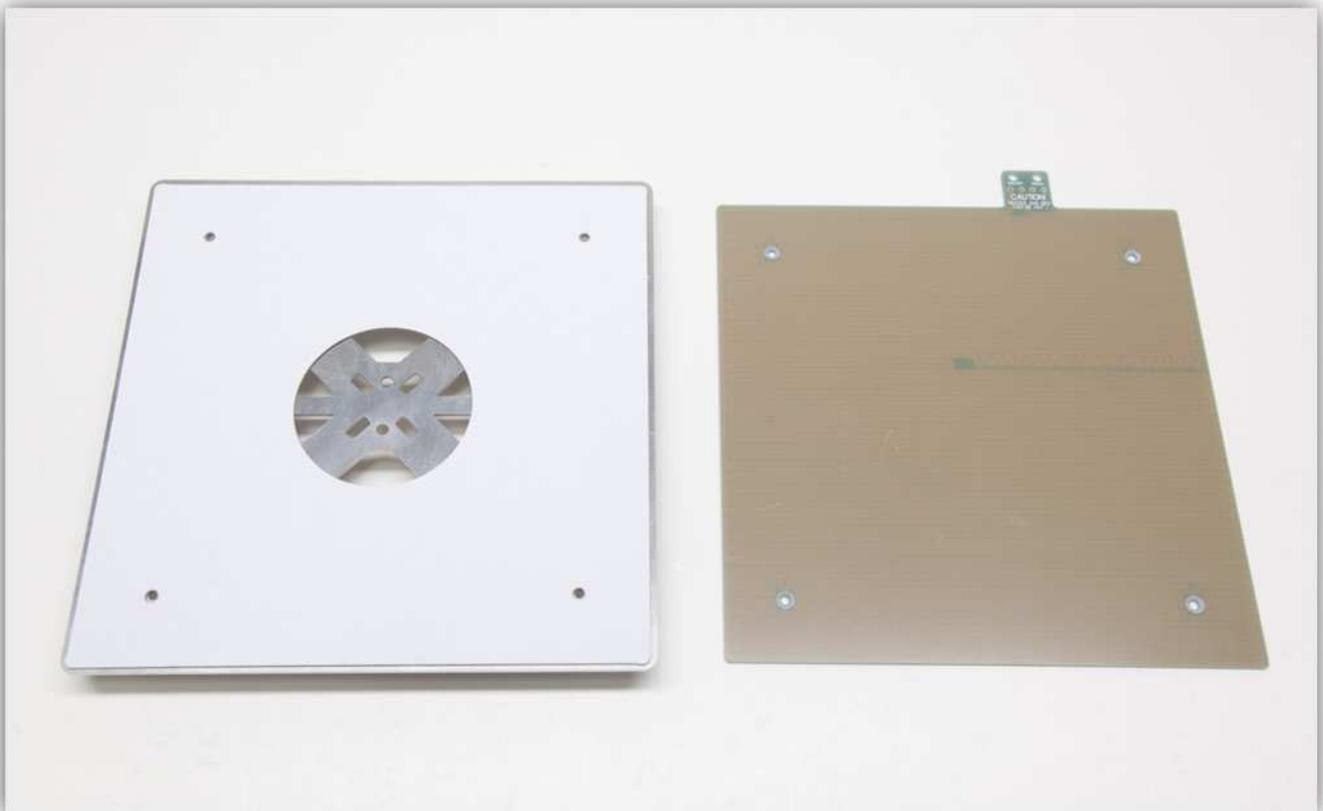
Now tin the other pad and other side of the NTC THERMISTOR.

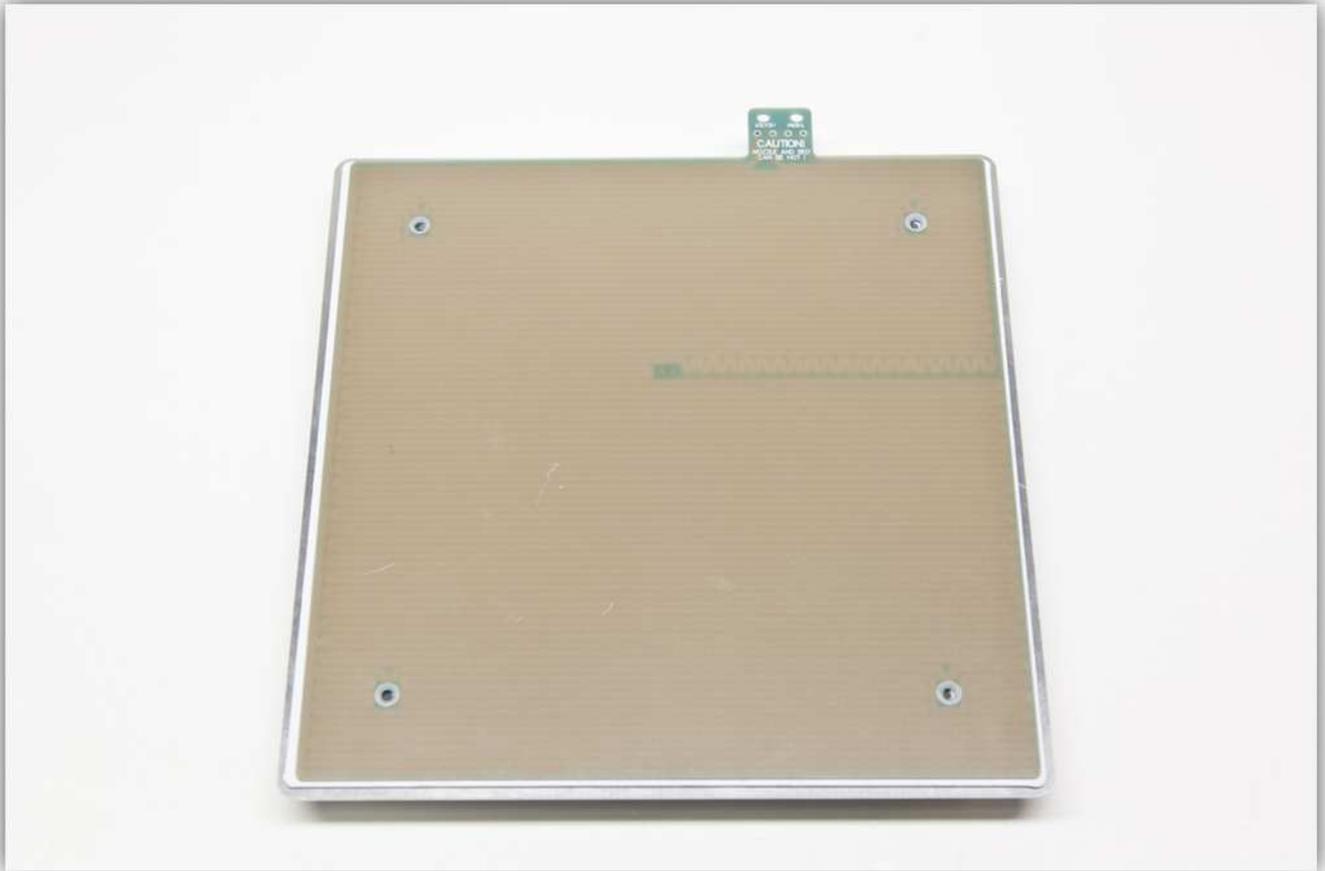


A soldered NTC THERMISTOR should look like this.



Place the HEATED BED PCB on the BED PLATE. **Watch the orientation carefully.**

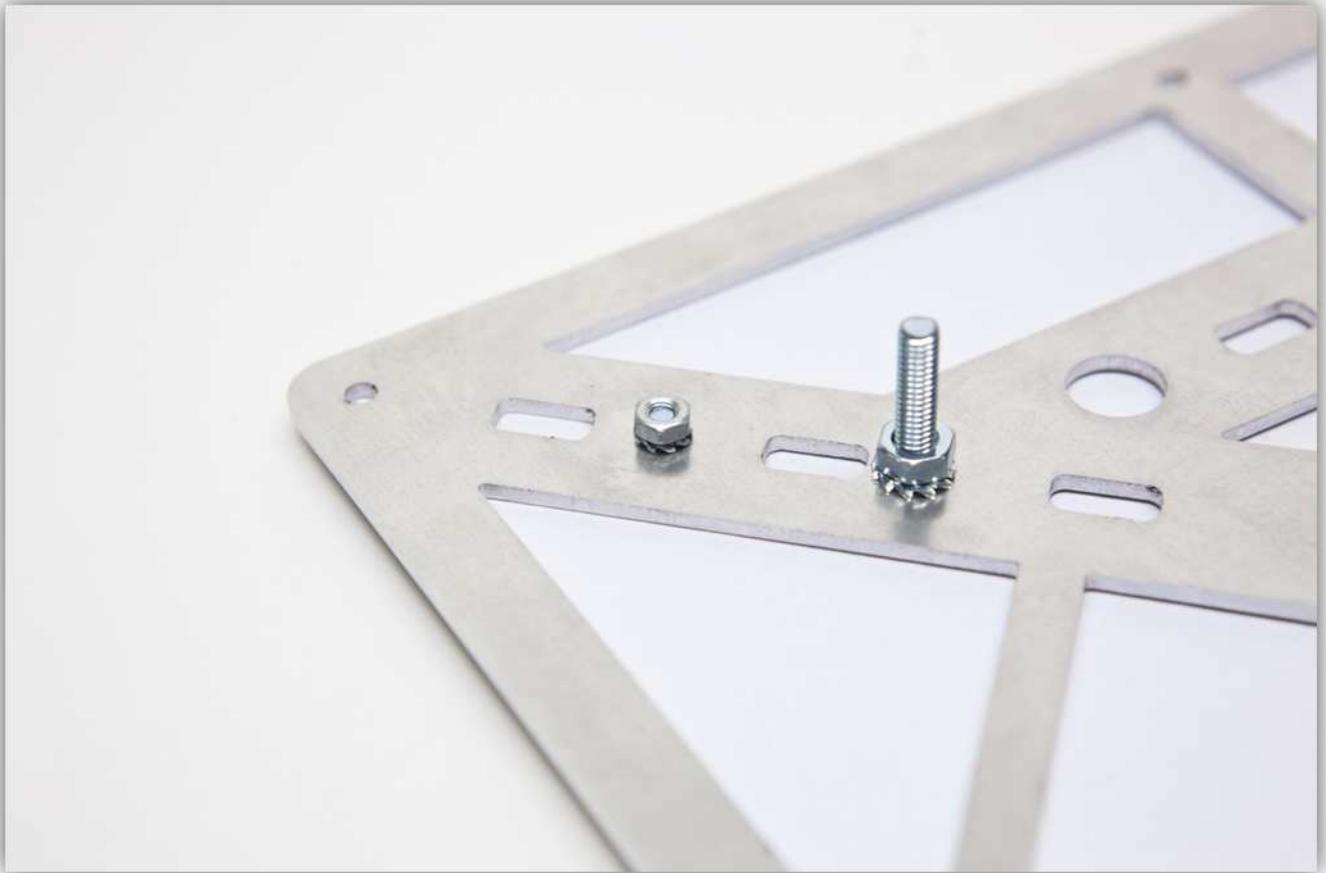




Insert the 4 countersunk M3 bolts in the 4 holes.



Use 4 M3 washers and 4 M3 nuts to secure the HEATED BED PCB to the BED PLATE.



Tighten these 4 bolts firmly.

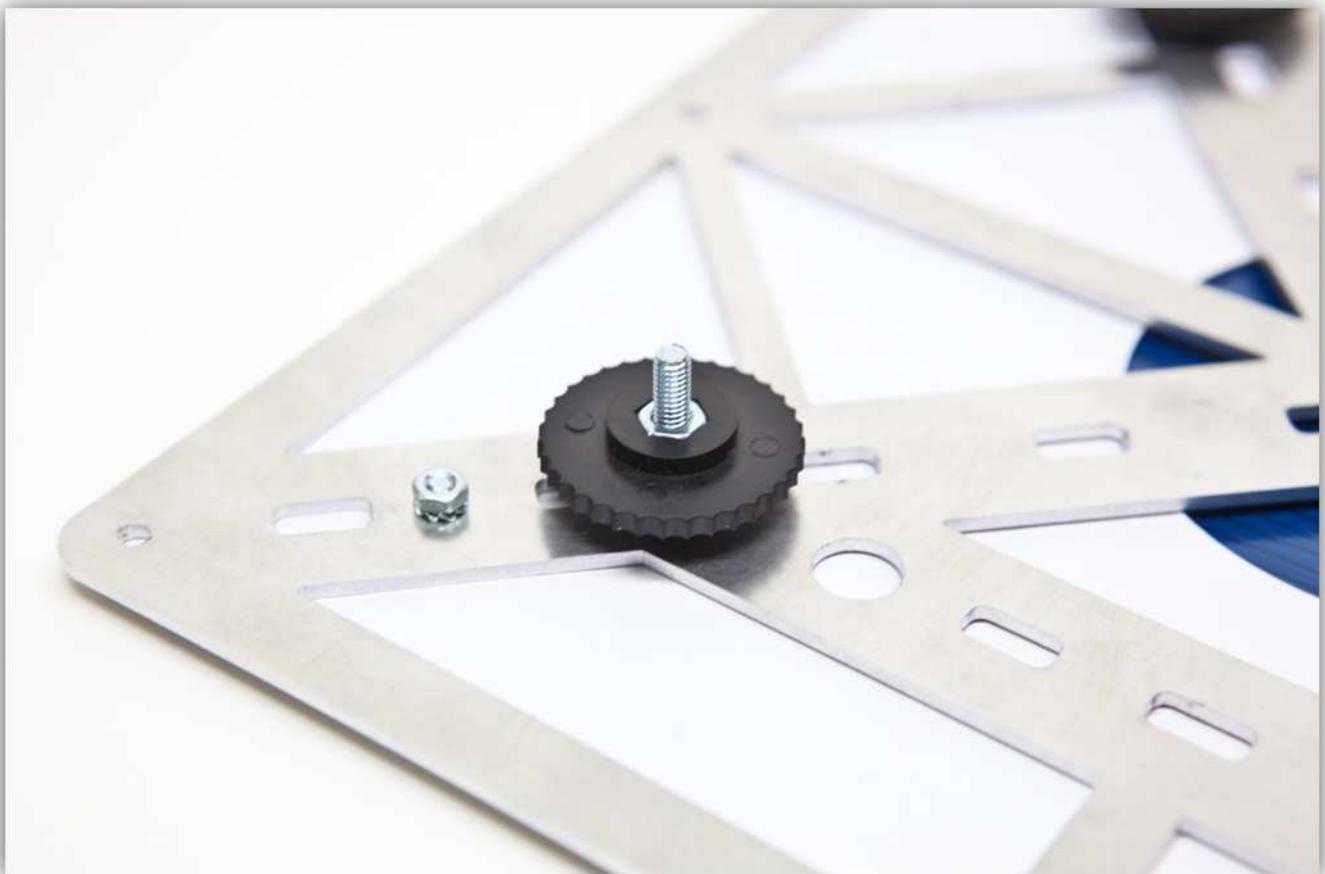


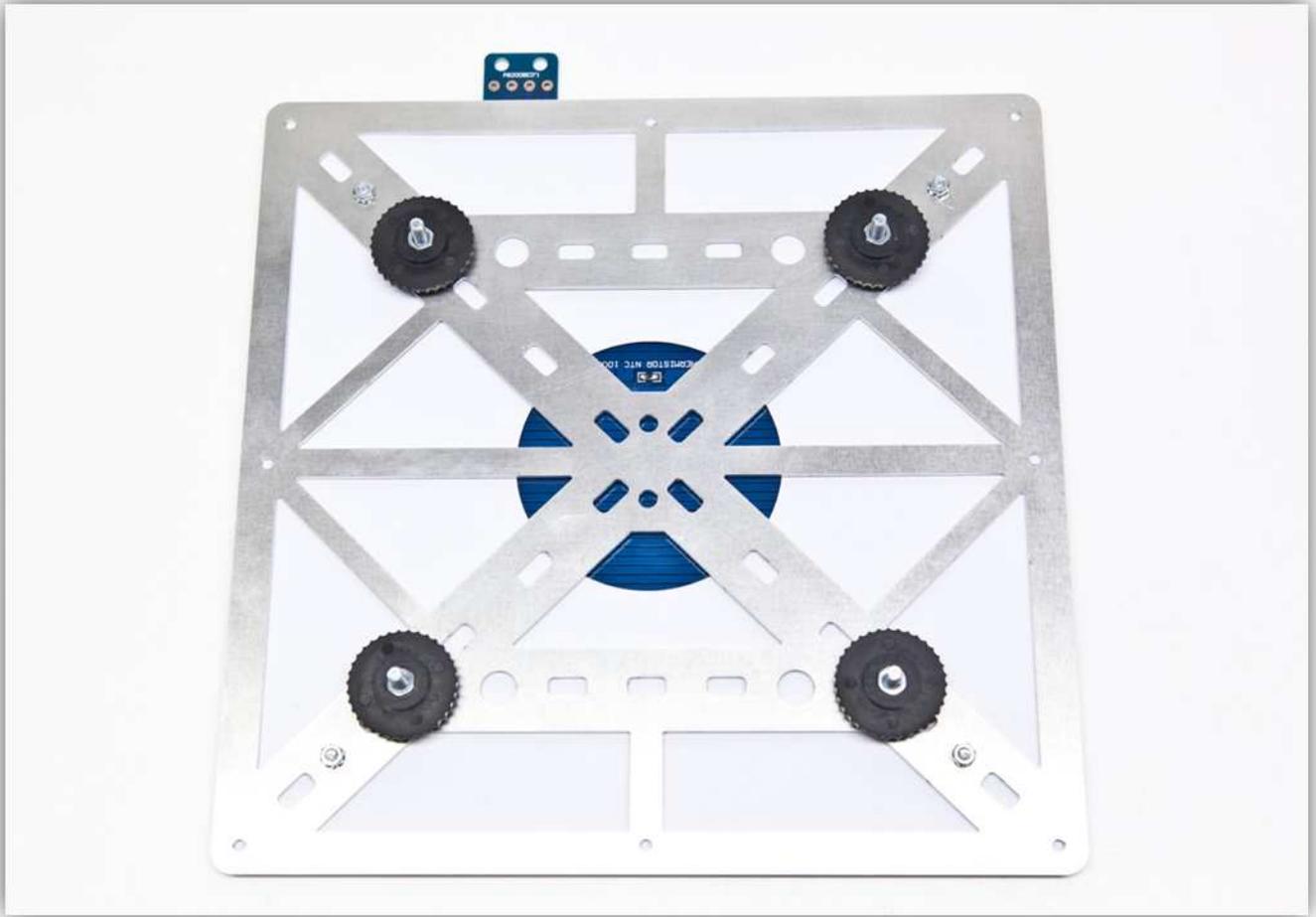
Insert an M4 nut into 4 THUMB SCREWS.



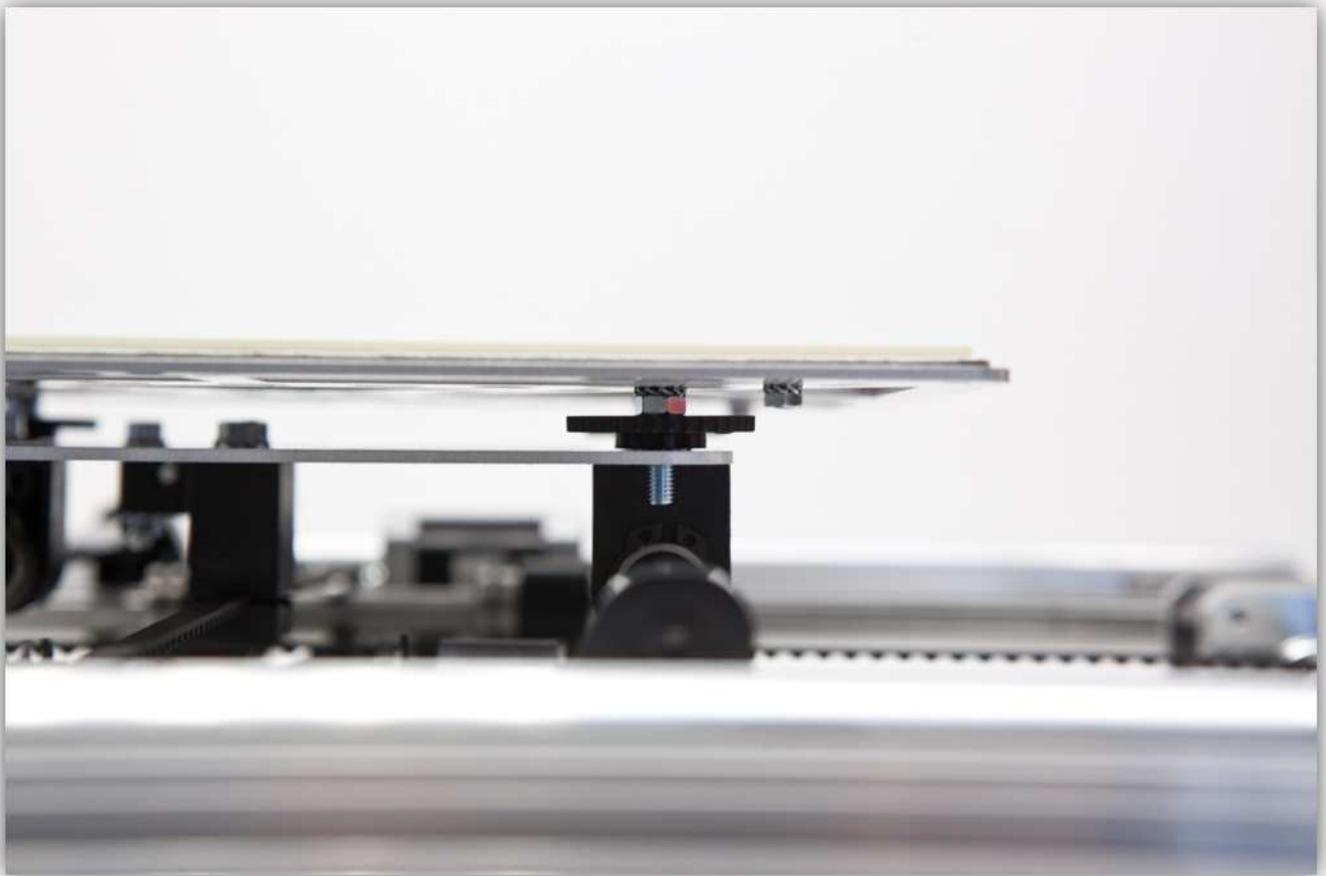
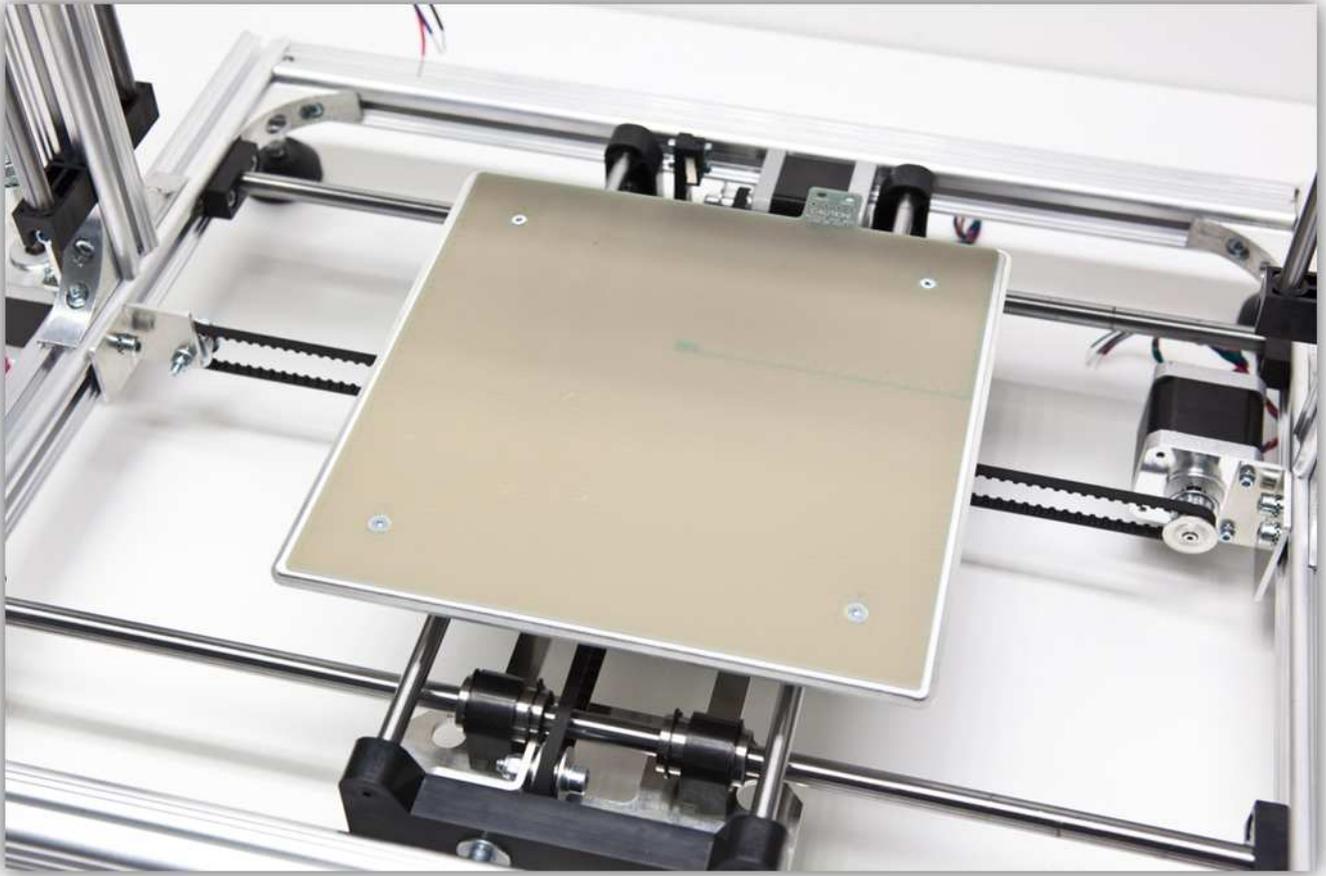


Screw these THUMB SCREWS onto the 4 BED PLATE bolts (all the way down).

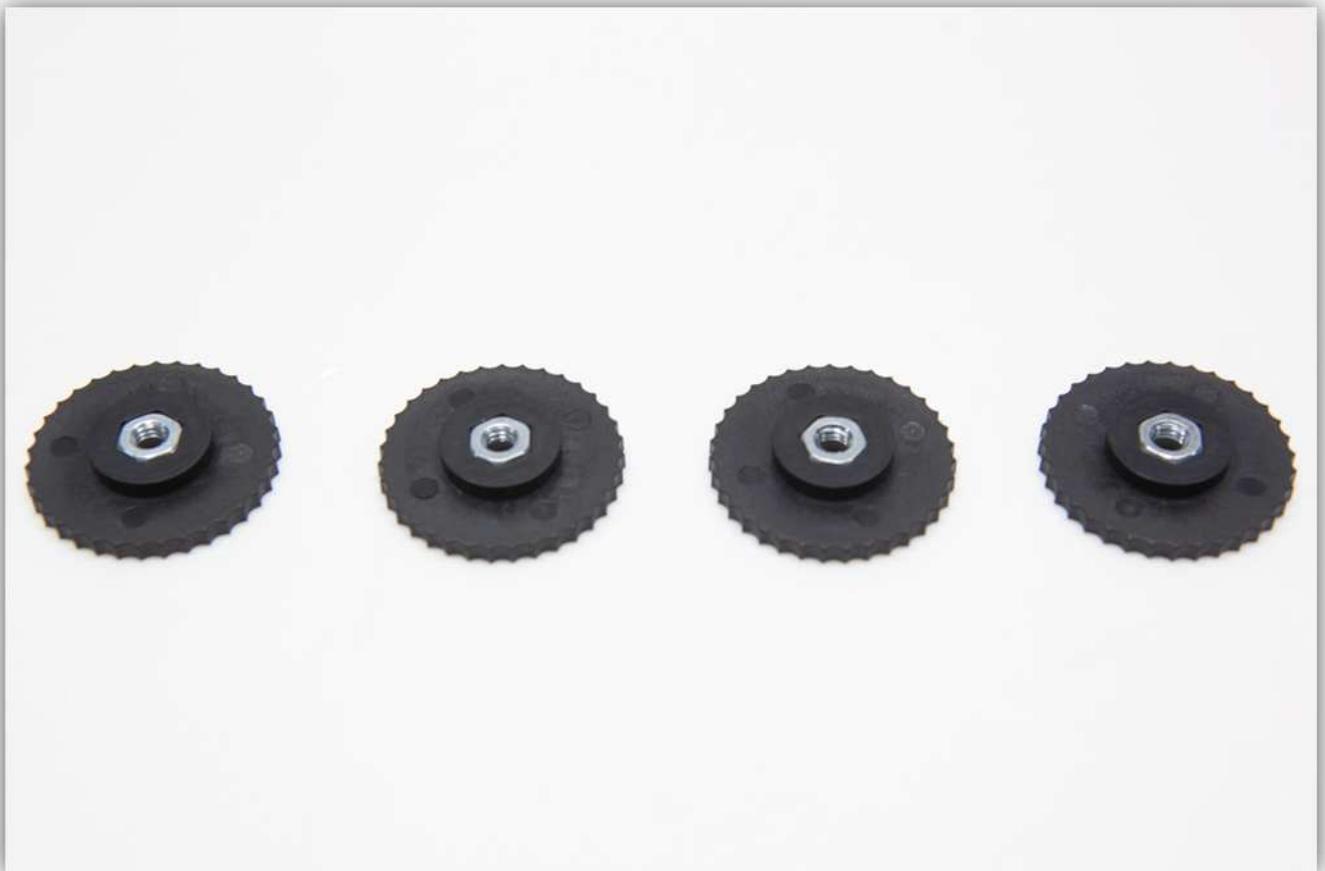




Now place the bed onto the X CARRIAGE. Make sure all the 4 bolts slide through the BED SUPPORT PLATE. **Notice the orientation.**



Insert an M4 nut into 4 THUMB SCREWS.



Put an M3 toothed washer on each of the THUMB SCREWS and screw these on each of the BED PLATE bolts as shown in the pictures below.

