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These parts have Heat-Set Inserts installed in them. This guide will walk you through the *Plate Press Technique* to install them correctly without any expensive tools.

Parts with Heat Set Inserts



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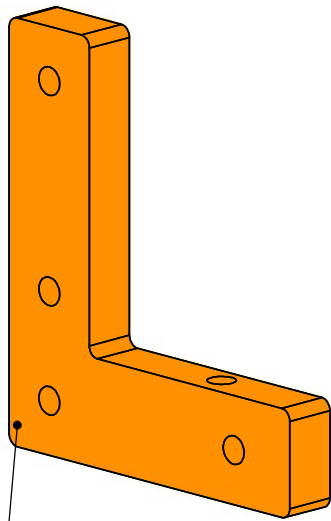
SHEET 1 OF 5

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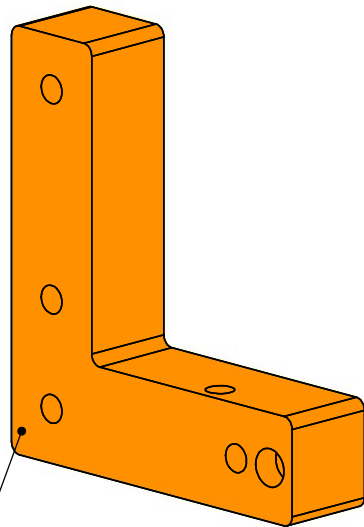
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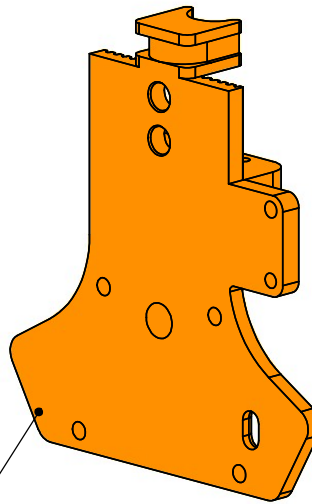
B



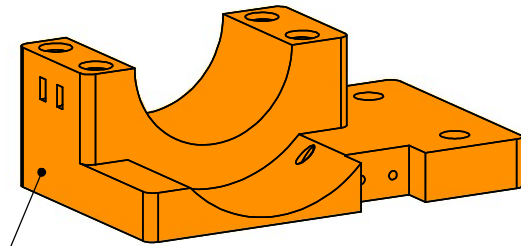
Left Motor Corner Bracket Spacer



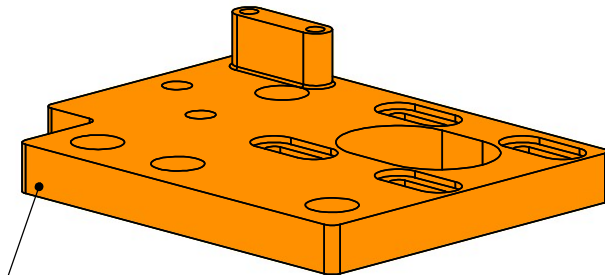
Right Motor Corner Bracket Spacer



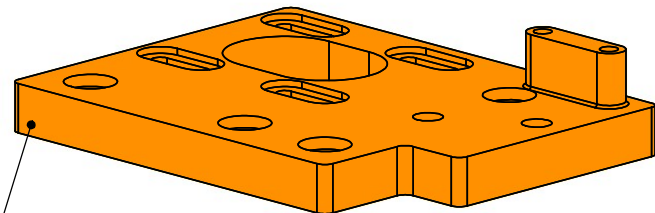
Carriage Back Plate



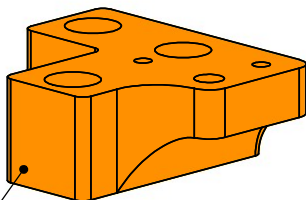
Lock Actuator Base Plate



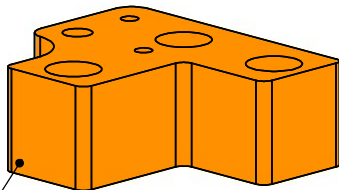
Left Motor Corner Bracket



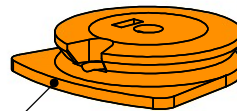
Right Motor Corner Bracket



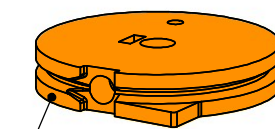
Right Double Pulley Corner Bracket



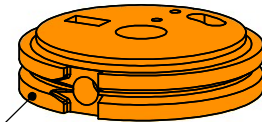
Left Double Pulley Corner Bracket



Carriage Pulley



Fixed Half-Pulley



Floating Half Pulley Underside

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Collect the following parts above. Ensure that each part was printed with 6 perimeter layers; otherwise, inserts will melt through the perimeter walls and fall out!

In addition, you will need:

Required Inserts	
M4 Tapered Long Heat Set Insert	8
M3 Tapered Heat Set Insert	9

Part Inspection



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1) Heat up the Soldering Iron. (a special tip is recommended, but not required.)

2) With the insert pre-placed over the hole, gently touch the iron to the insert. Let the weight of the iron gently push the insert into the hole. This process should take about 10-15 seconds.

3) When the insert is about 90% inserted, remove the iron. Quickly either:

(a) flip the part upside down onto a heat resistant surface, or

(b) push any flat metal surface (such as a razor blade) onto the insert and push it completely down.

Wait 5 seconds for the insert to cool in this position.

4) That's it! Your insert is installed at the proper height and angle.

The Plate Press Technique Overview



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SHEET 3 OF 5

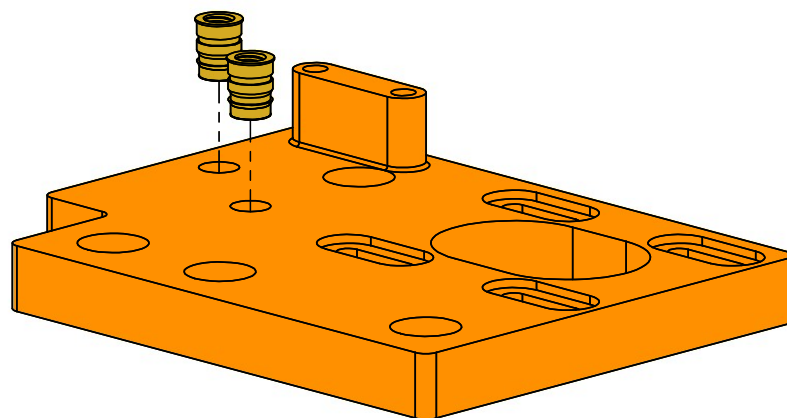
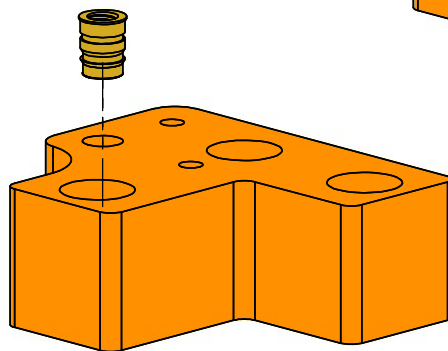
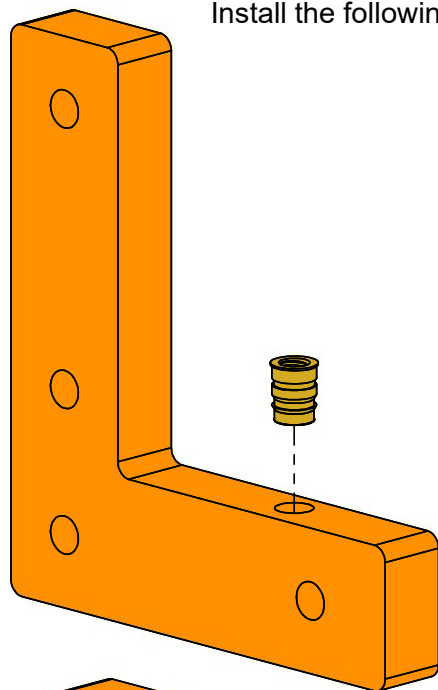
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Install the following Long **M4** Heat Set Inserts from the directions shown below.

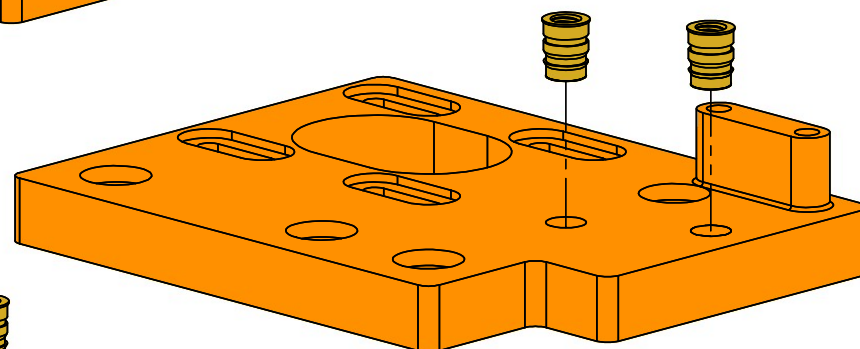
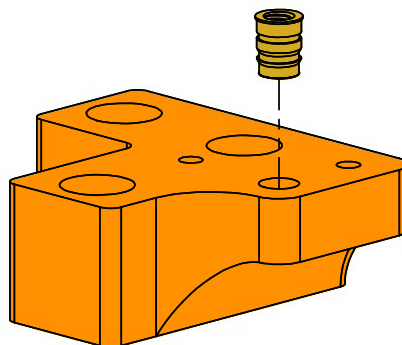
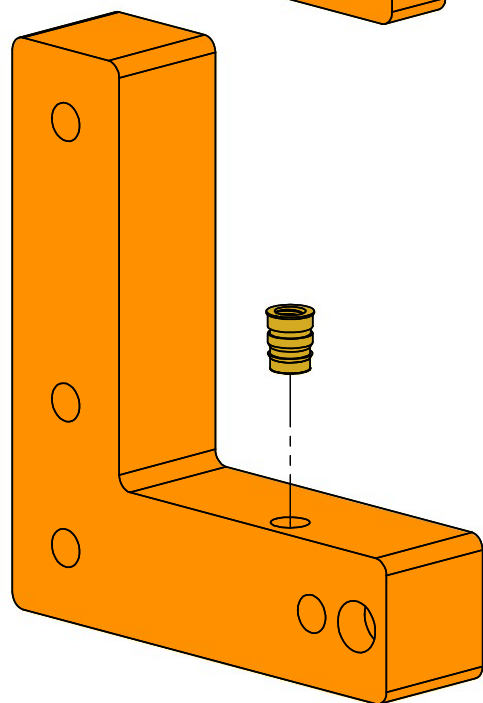
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M4 Insert Installations



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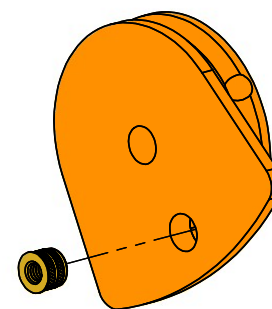
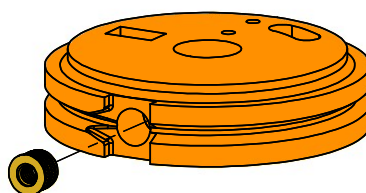
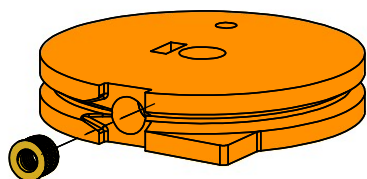
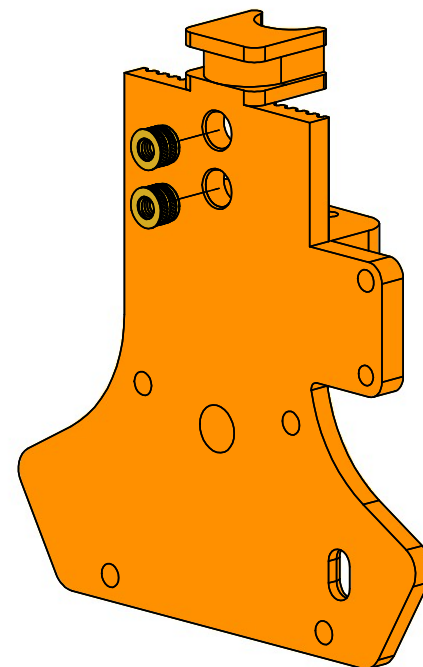
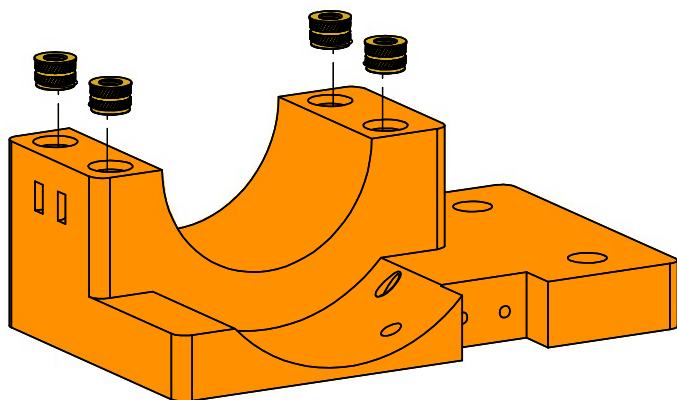
SCALE: 3:4

SHEET 4 OF 5

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Install the following **M3** Heat Set Inserts from the directions shown below.



That's it! Set all these parts aside for use in later instructions.

M3 Insert Installations



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SHEET 5 OF 5

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