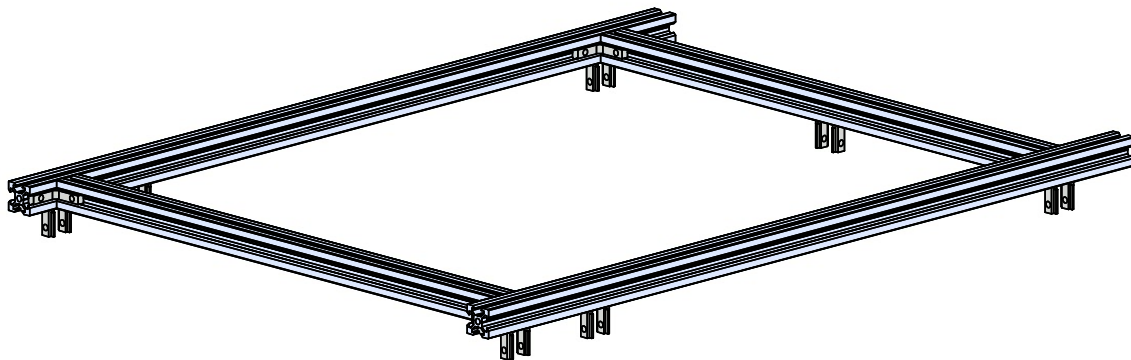


2

1

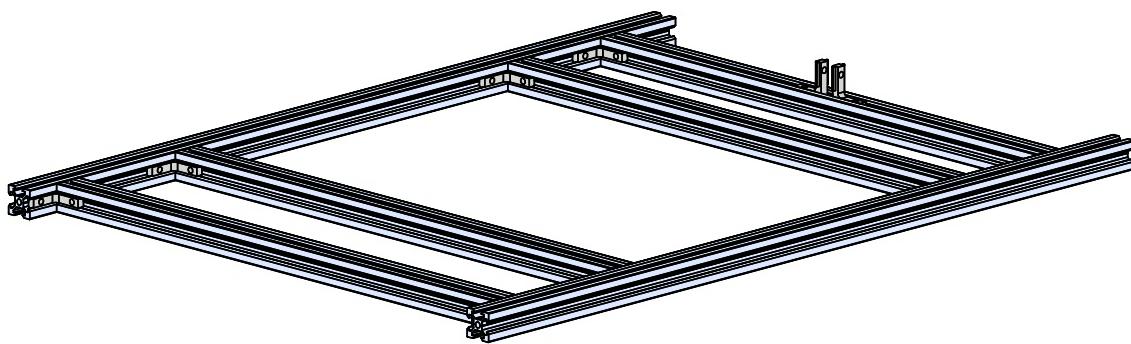
B

B



A

A



### Outer Frame Assembly and Alignment



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

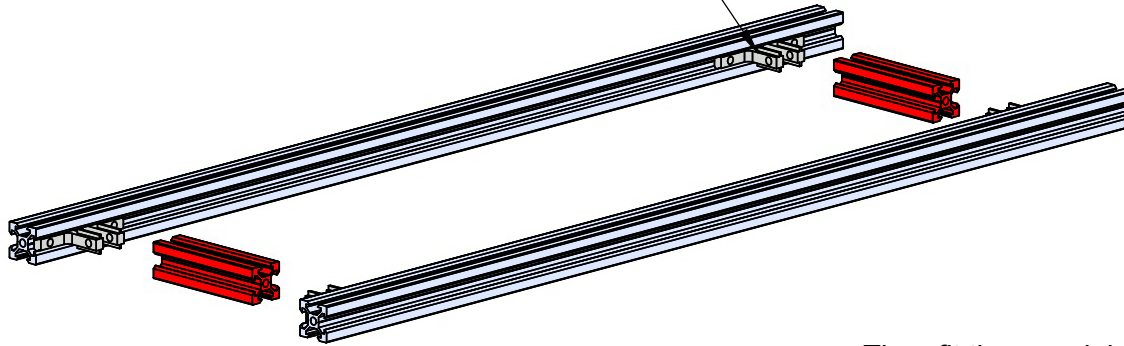
SCALE: 1:5

SHEET 1 OF 11

2

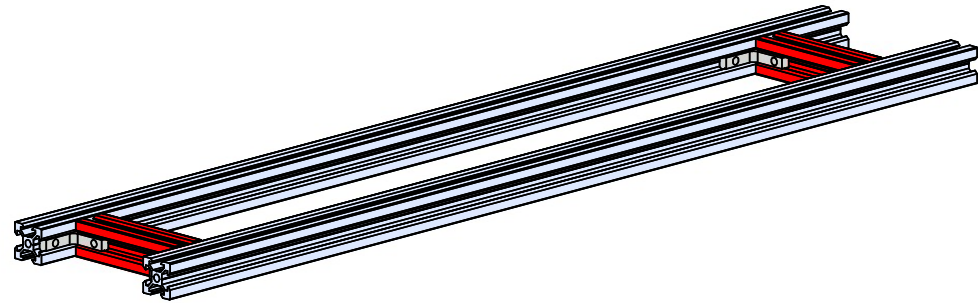
1

First slide 4 brackets into each side of the long extrusions.



Exploded View

Then fit the remaining parts together as shown above without tightening down any screws. Lay the loose assembly on a flat surface.



Assembled View

Note that only one side of these Inside Corner Brackets slides in all the way.

Exact locations don't matter yet.

The short red extrusions are for squaring the frame and will be removed later.

ITEM NO.	DESCRIPTION	QTY.
1	604mm long TSlot Extrusion	2
2	Interior Inside Corner Bracket	8
3	74mm Temporary TSlot Extrusion for Squaring	2

### Upper Frame Squaring Setup

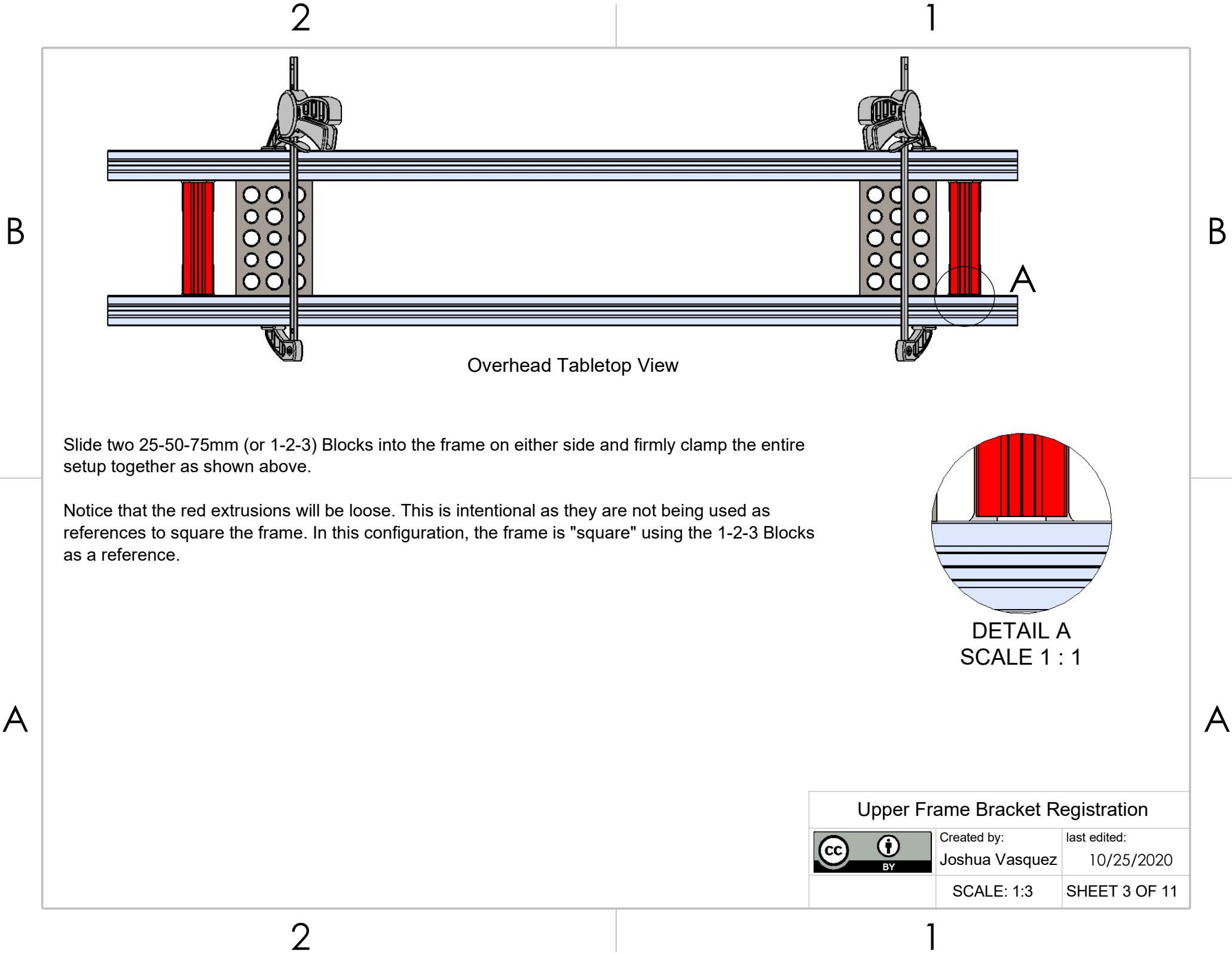



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

SCALE: 1:4

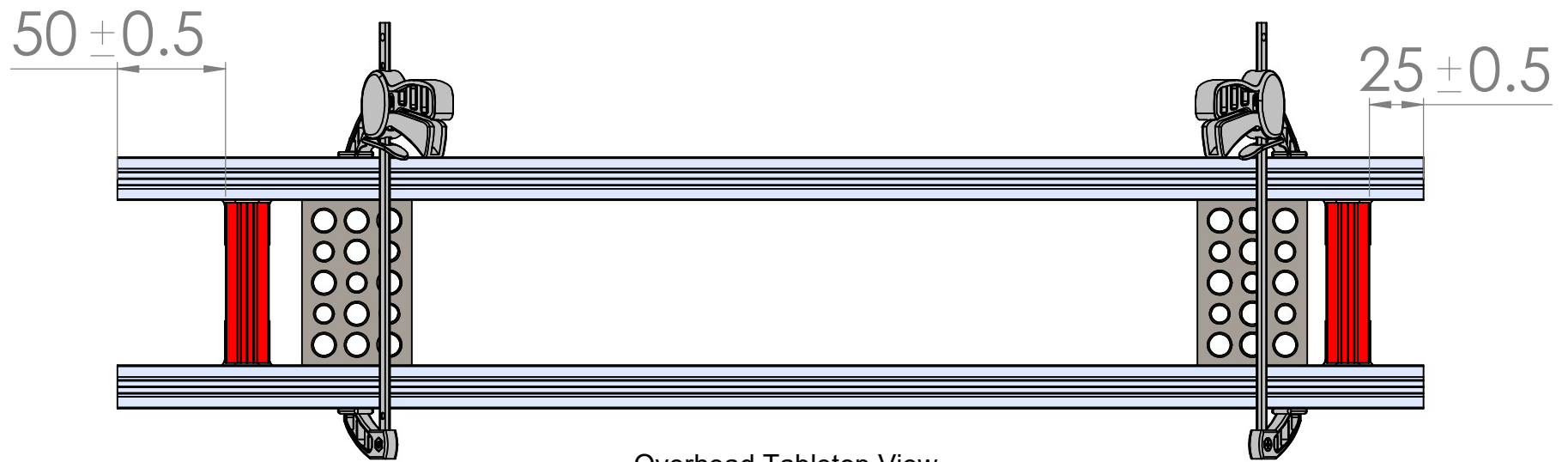
SHEET 2 OF 11



Upper Frame Bracket Registration		
	Created by: Joshua Vasquez	last edited: 10/25/2020
	SCALE: 1:3	SHEET 3 OF 11

B

B



Overhead Tabletop View

Using Calipers as a reference, adjust the red extrusions such that they match the dimensions shown above. Note that bracing the entire assembly against a loose extrusion may make this dimension easier to measure as shown below. When they are in the proper location, fasten down all 16 screws in the inside corner brackets. This procedure will fix the brackets in the correct location.



A

## Upper Frame Bracket Fixturing



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

SCALE: 1:3

SHEET 4 OF 11

2

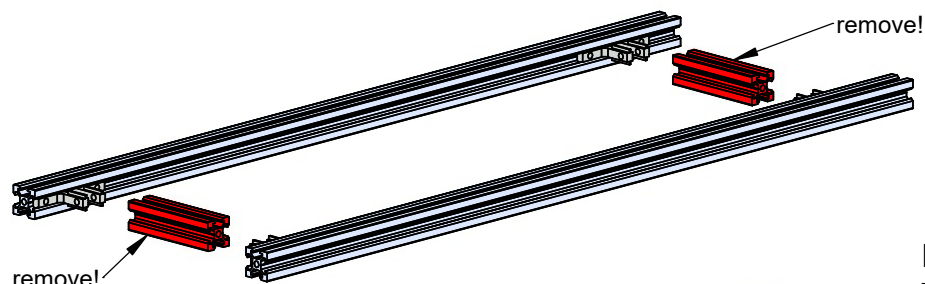
1

B

A

2

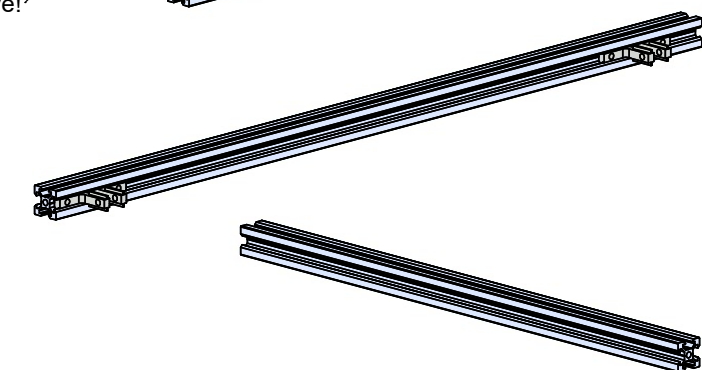
1



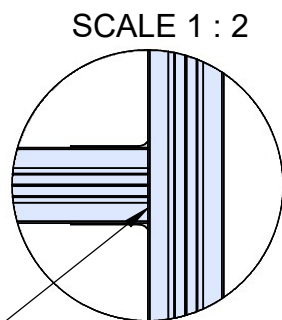
Remove the clamps and 1-2-3 blocks. Then loosen only the 8 screws connecting the red extrusions. Leave all other screws tightened.

Install the 409mm TSlot Extrusions in place of the Red Extrusions. Tighten them down securely.

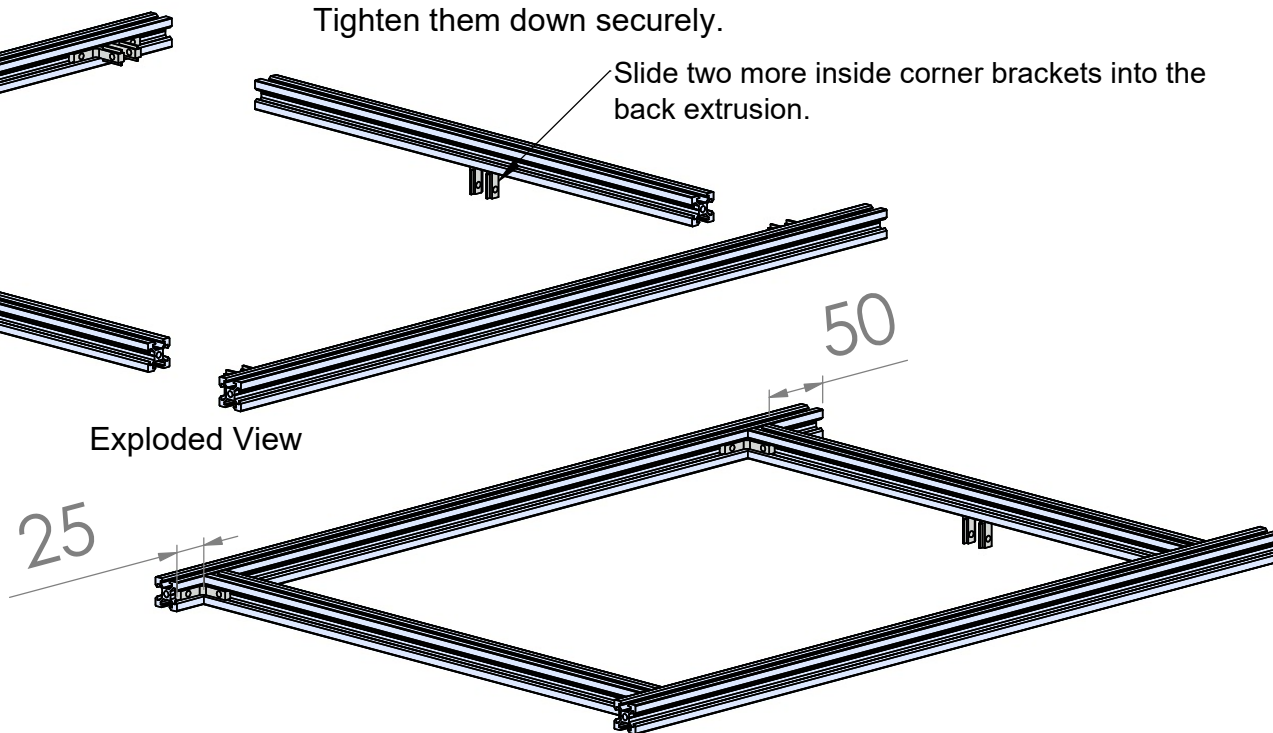
Slide two more inside corner brackets into the back extrusion.



Exploded View



All four connecting surfaces should *completely* touch each other without any noticeable air gap.



Assembled View

Assuming your 409mm TSlot Extrusions were cut to identical lengths, your frame should now be square!

Set this frame aside for now.

ITEM NO.	DESCRIPTION	QTY.
1	409mm TSlot Extrusion	2
3	Interior Inside Corner Bracket	2

### Upper Frame Assembly



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

SCALE: 1:5

SHEET 5 OF 11

2

1

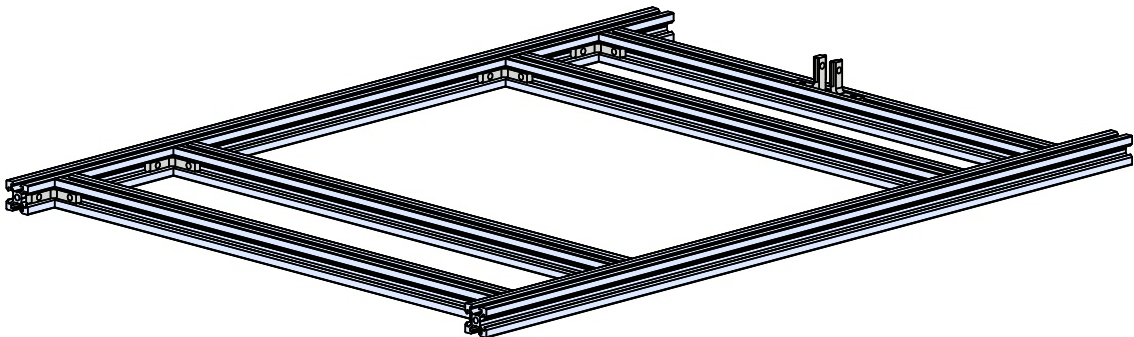
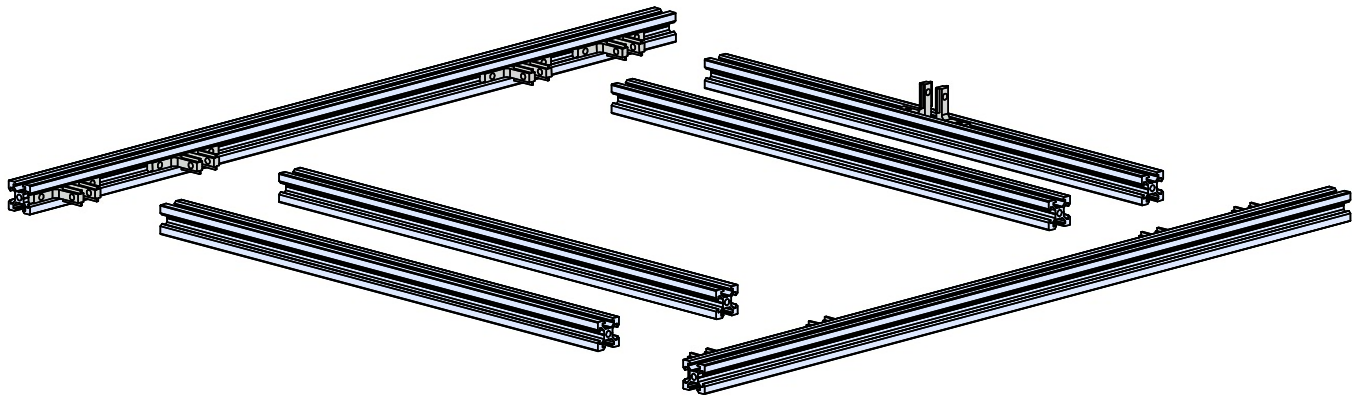
2

1

Like before, assemble the entire lower frame without fastening down any set screws.

B


B



A

A

ITEM NO.	DESCRIPTION	QTY.
1	409mm TSlot Extrusion	4
2	604mm long TSlot Extrusion	2
3	Interior Inside Corner Bracket	18

Lower Frame Loose Assembly		
	Created by:	last edited:
	Joshua Vasquez	10/25/2020
SCALE: 1:5		SHEET 6 OF 11

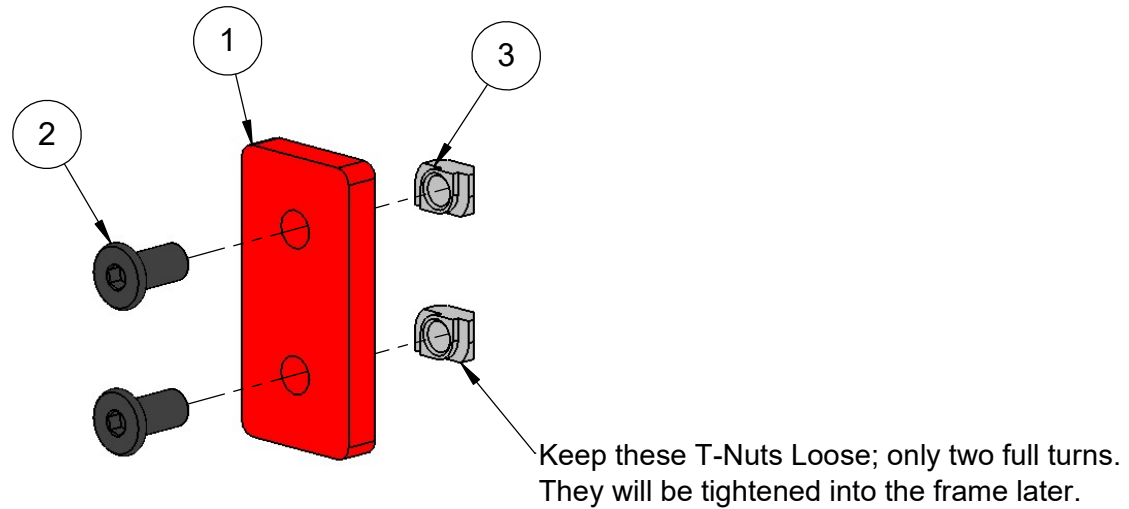
2

1

B

B

Make 8 of the following assemblies.



A

A

ITEM NO.	DESCRIPTION	QTY.
1	Outer Frame Squaring Plate	8
2	M5 Buttonhead Screw, 10mm long	16
3	M5 Drop-In T-Nut for 20x20 Extrusion	16

### Squaring Bracket Assembly



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

SCALE: 1:1

SHEET 7 OF 11

2

1

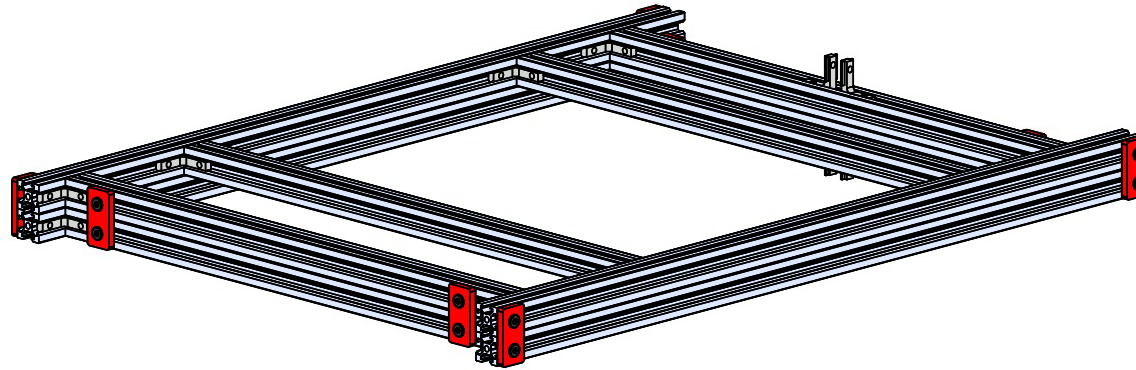


2

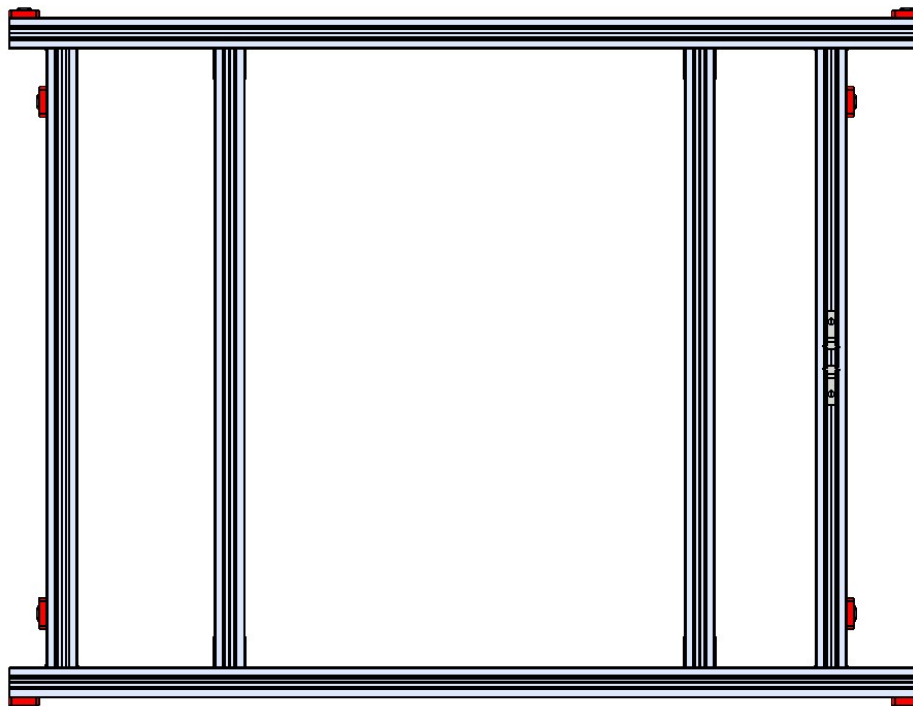
1

Join the prior frame with the loose frame "back-to-back" such that the dangling corner brackets do not interfere with each other. Then install the 8 plate assemblies into the corner and tighten them down such that the frame is "pulled" into the shape by the frame from the prior step.

Note: This process is made easier by dangling the frame over a table such that the corner brackets do not prevent the frame from resting flat on the table surface.



Clamp down the outer frame with the temporary red plates as shown below. This step will pull the lower frame into a configuration that matches the upper frame. Then clamp down the setscrews in the outer frame extrusions. (The inner extrusions will be clamped down later.)



### Upper/Lower Frame Registration



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

SCALE: 1:5

SHEET 8 OF 11

2

1



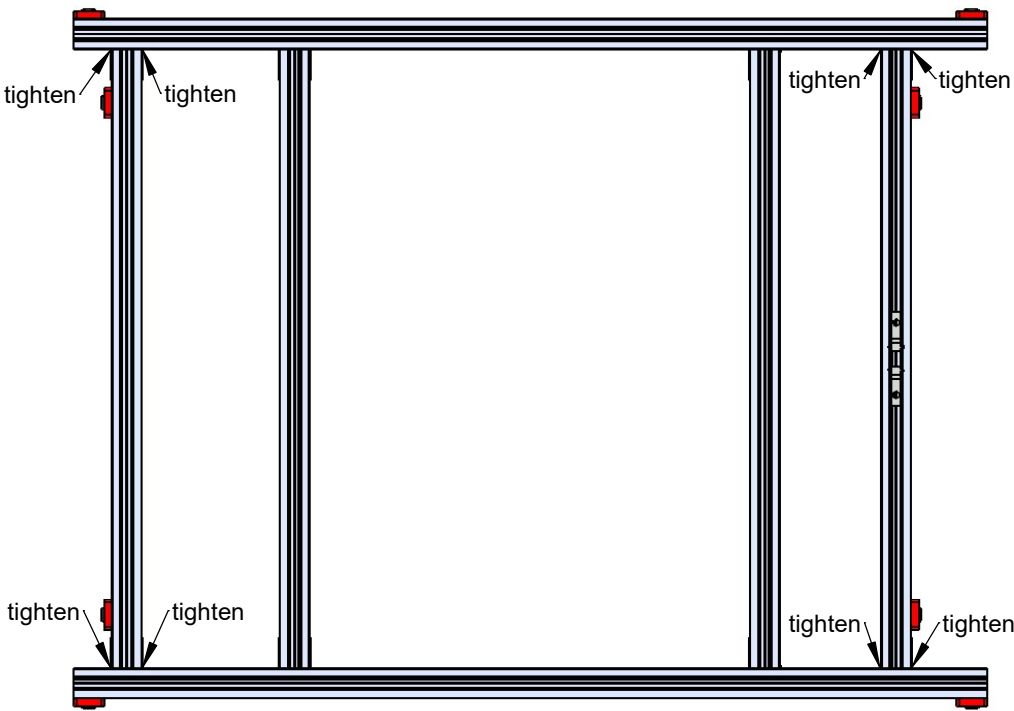
2

1

Now tighten down the setscrews in the outer frame extrusions on the frame that is still loose. (The inner extrusions will be clamped down later.)

B

B



A

A

2

1

Lower Frame Bracket Fixturing		
	Created by:	last edited:
	Joshua Vasquez	10/25/2020
	SCALE: 1:5	SHEET 9 OF 11

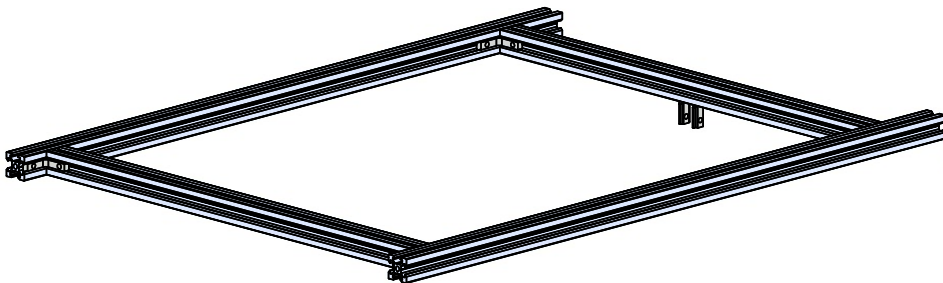
2

1

With the outer screws tightened on the lower frame, remove the temporary plates and separate the frames.

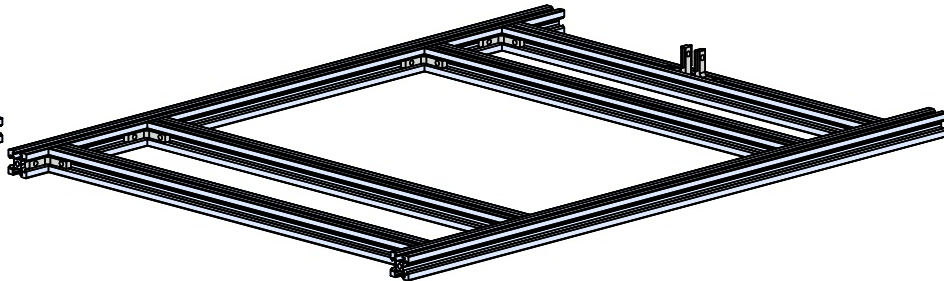
B

B



Upper Frame


Set this one aside.



Lower Frame

A

A

Separated Upper/Lower Frames		
	Created by: Joshua Vasquez	last edited: 10/25/2020
	SCALE: 1:6	SHEET 10 OF 11

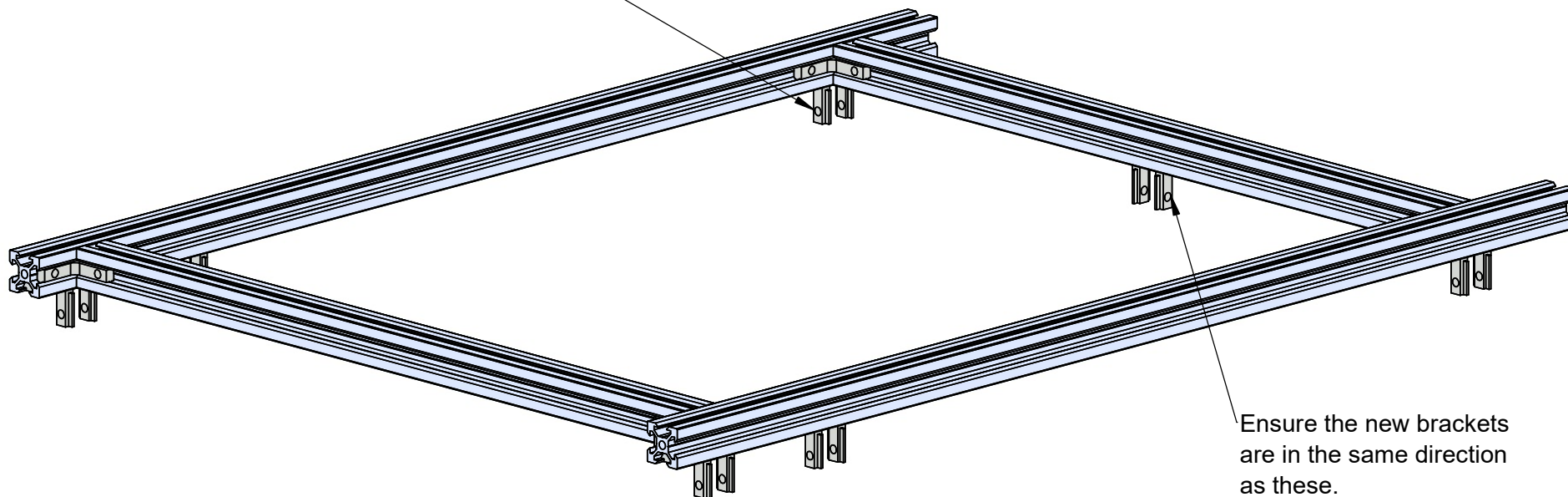
2

1

2

1

Slide 3 pairs of Inside-Corner Brackets (12 total) onto the bottoms side of each long extrusion. Loosely fasten them in the approximate locations shown so they do not fall out.



B

B

A

A

ITEM NO.	DESCRIPTION	QTY.
3	Interior Inside Corner Bracket	12
4	Upper Frame Assembly	1

### Upper Frame Bracket Loose Assembly



Created by:  
Joshua Vasquez

last edited:  
10/25/2020

SCALE: 1:3

SHEET 11 OF 11

2

1