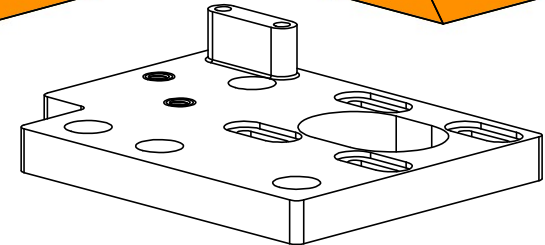
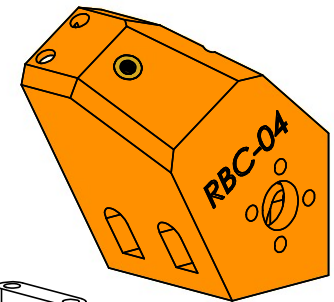
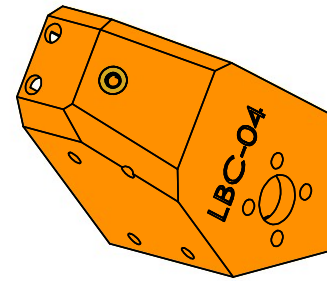
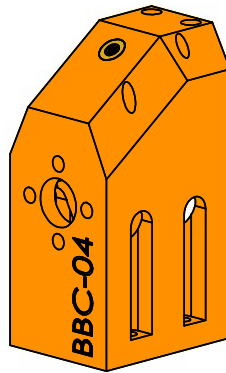
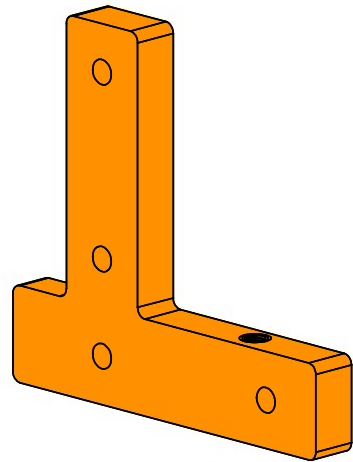


2

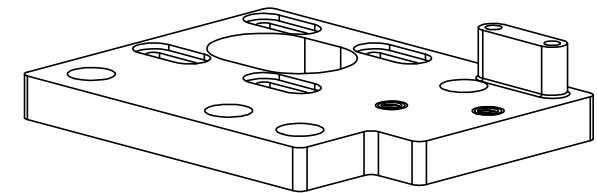
1

B

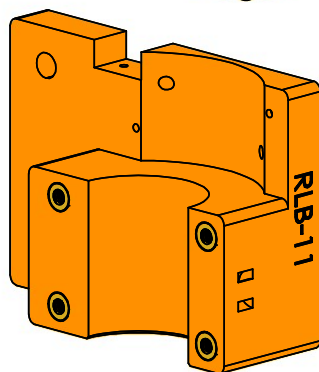
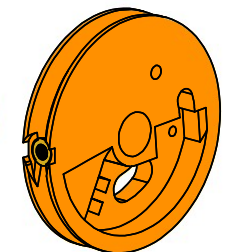
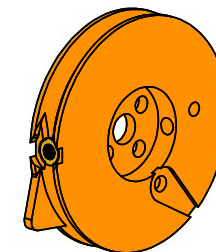
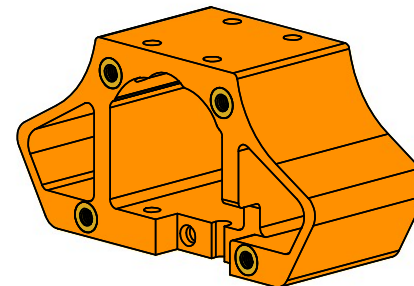
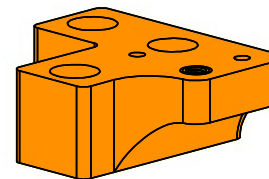
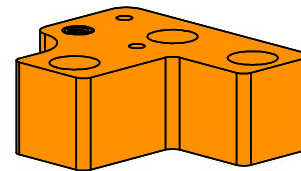
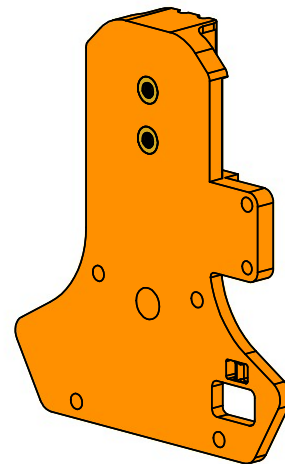
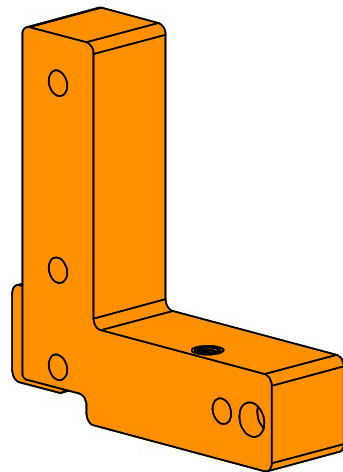
B



(Deprecated) Jubilee 2.0.2 and earlier.



(Deprecated) Jubilee 2.0.2 and earlier.



A

A

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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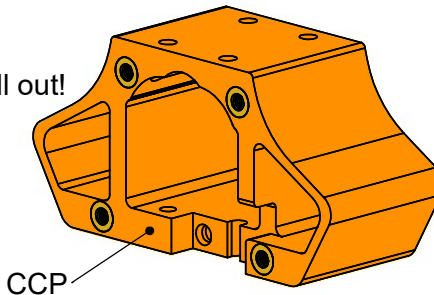
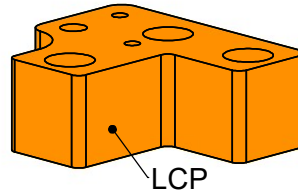
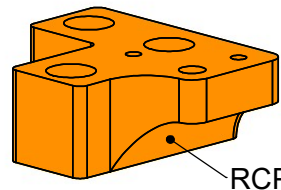
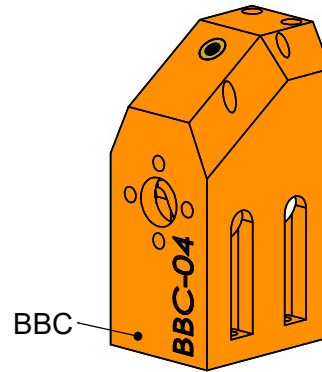
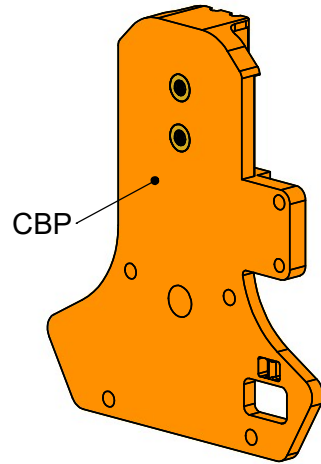
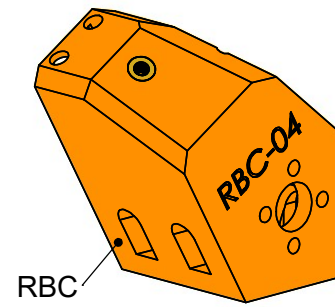
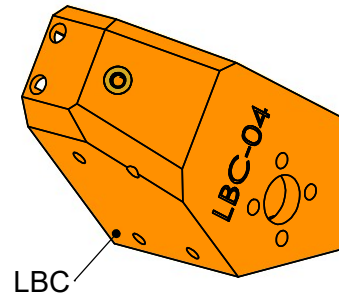
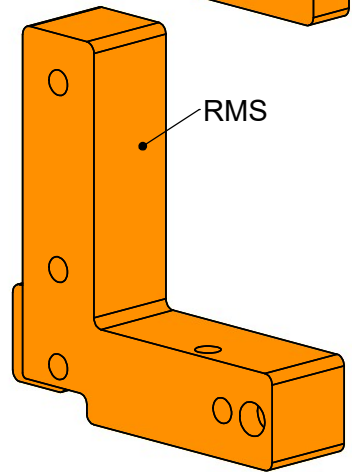
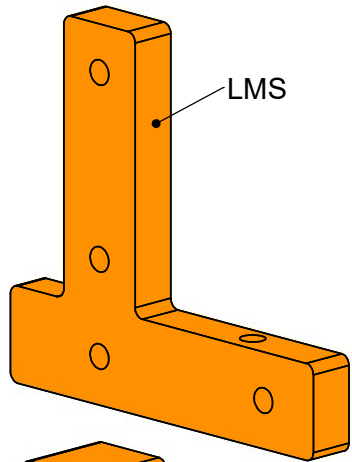
SCALE: 2:3

SHEET 1 OF 5

2

1

B



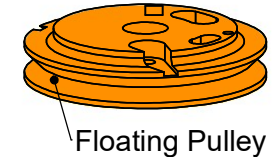
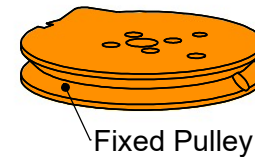
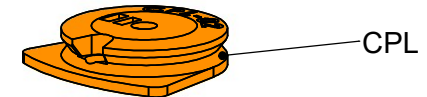
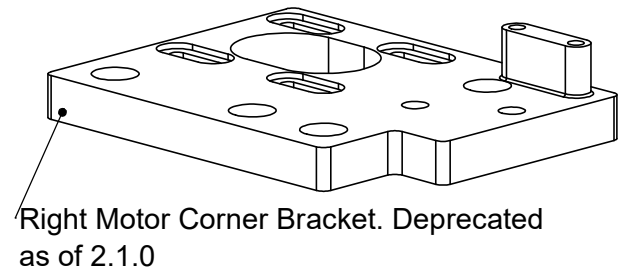
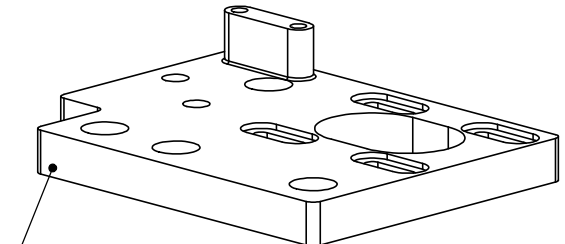
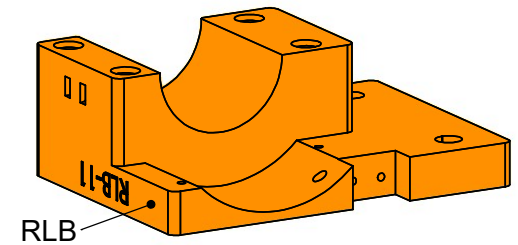
Collect the following parts shown here. Note that part "ID"s are embedded directly on the part.

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	4
M3 Tapered Heat Set Insert	24

1



Part Inspection



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SCALE: 2:3

SHEET 2 OF 5

B

A

2

2

1

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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SCALE: 3:4

SHEET 3 OF 5

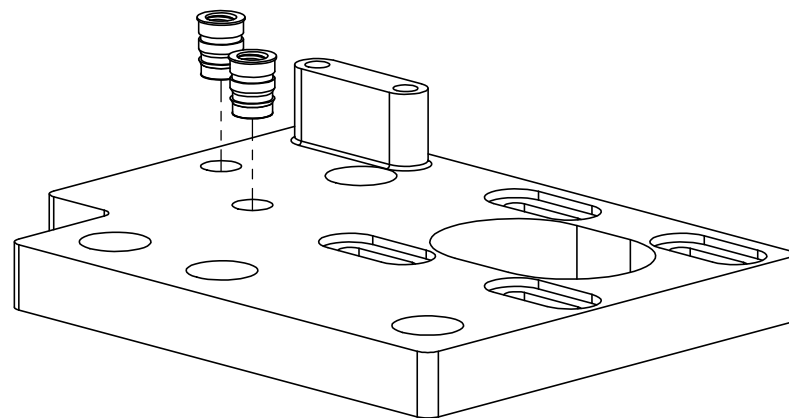
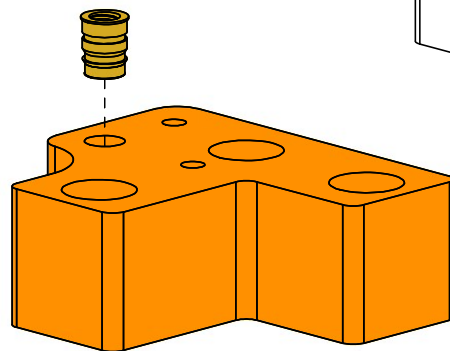
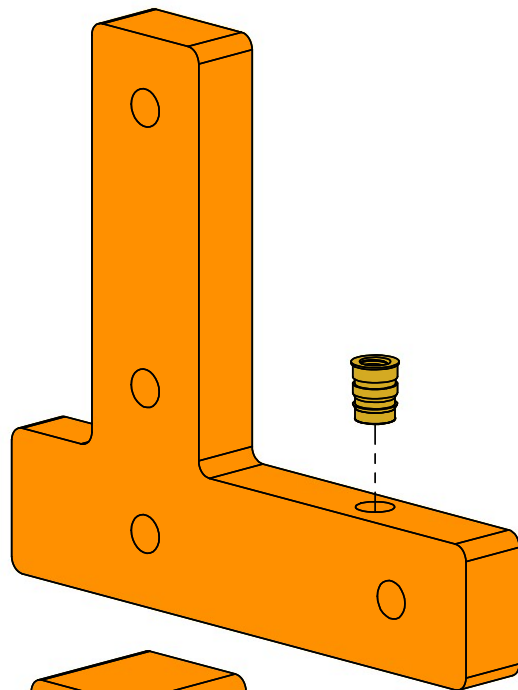
2

1

Install the following Long **M4** Heat Set Inserts from the directions shown such that they are flush with the surface they are installed into.

B

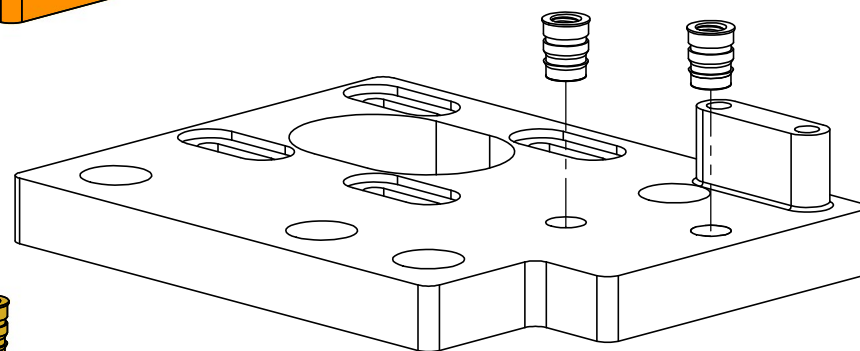
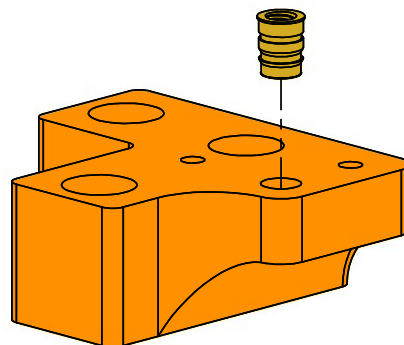
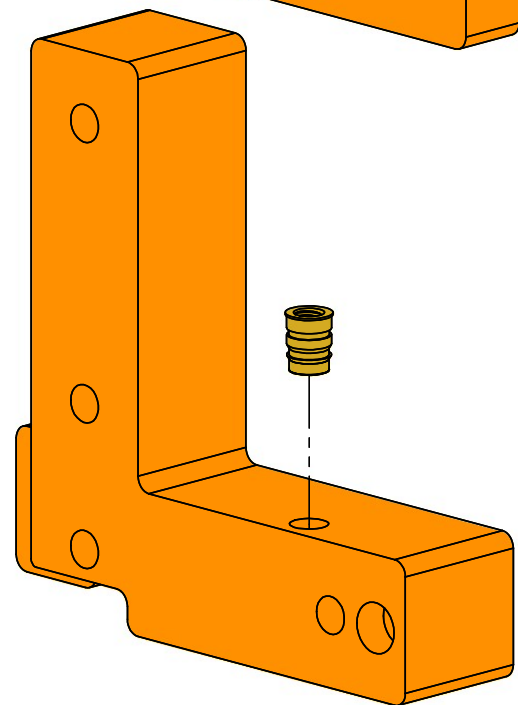
B



Jubilee 2.0.2 and before
uses this part.

A

A



Jubilee 2.0.2 and before
uses this part.

2

1

M4 Insert Installations



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SHEET 4 OF 5

2

1

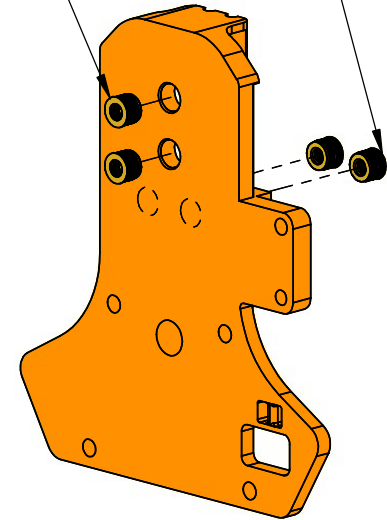
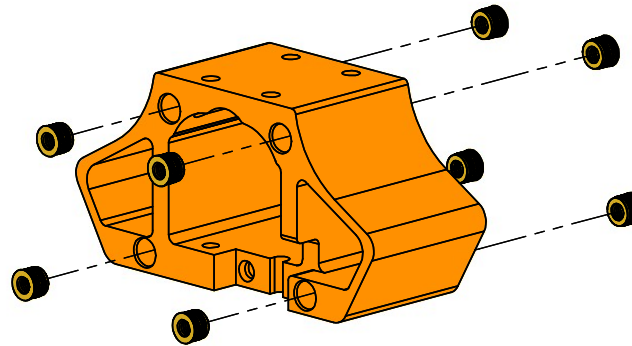
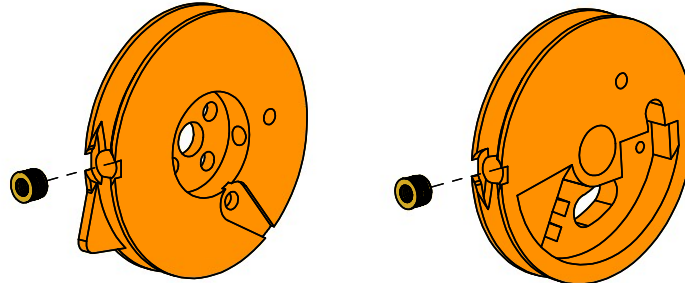
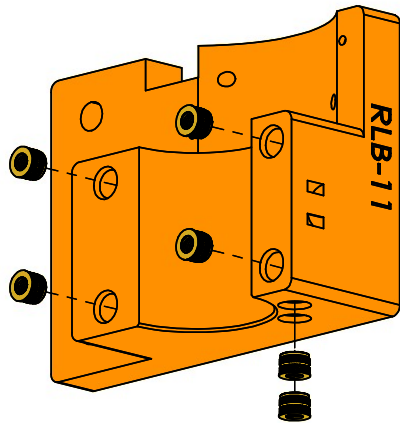
Install the following **M3** Heat Set Inserts from the directions shown below such that they are **flush** with the surface they are installed into.

These go in from the front!

These go in from the back!

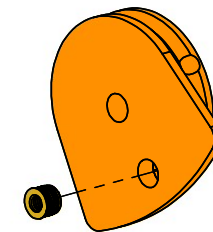
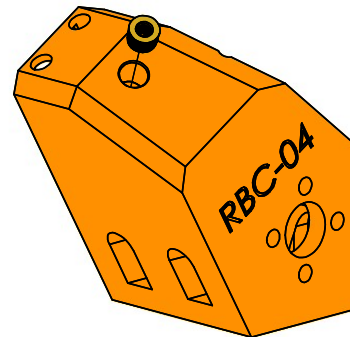
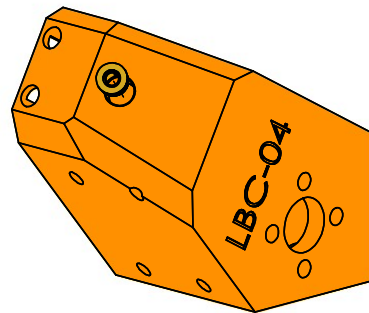
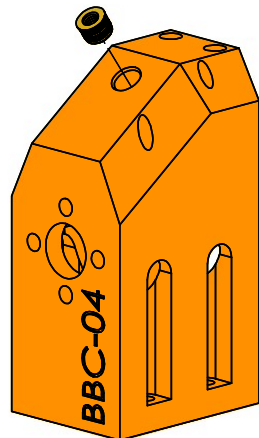
B

B



A

A



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

M3 Insert Installations



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SHEET 5 OF 5

2

1