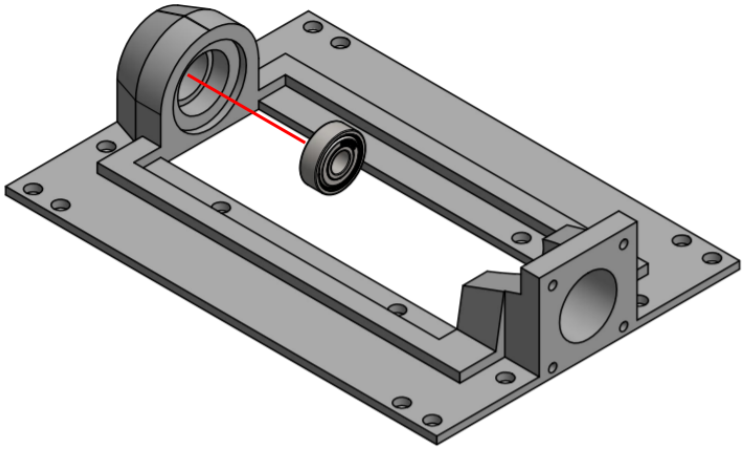
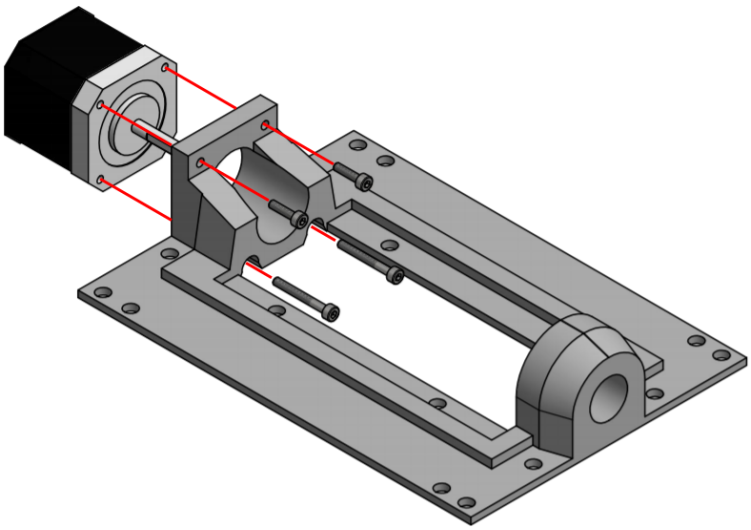
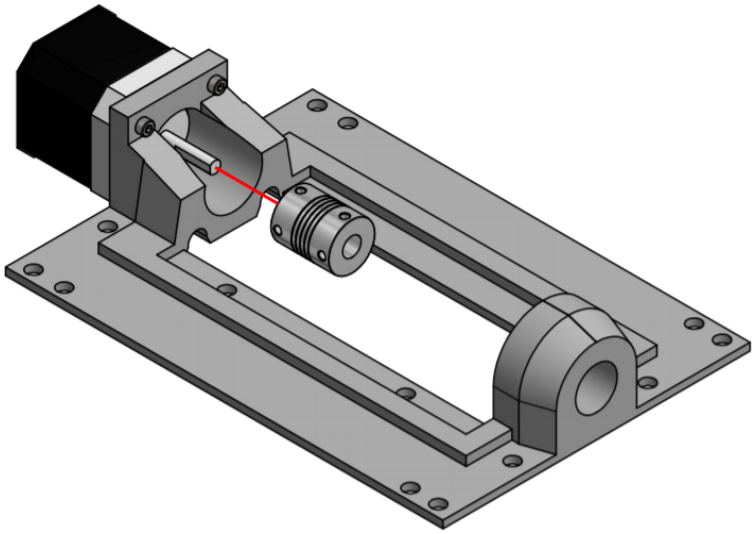


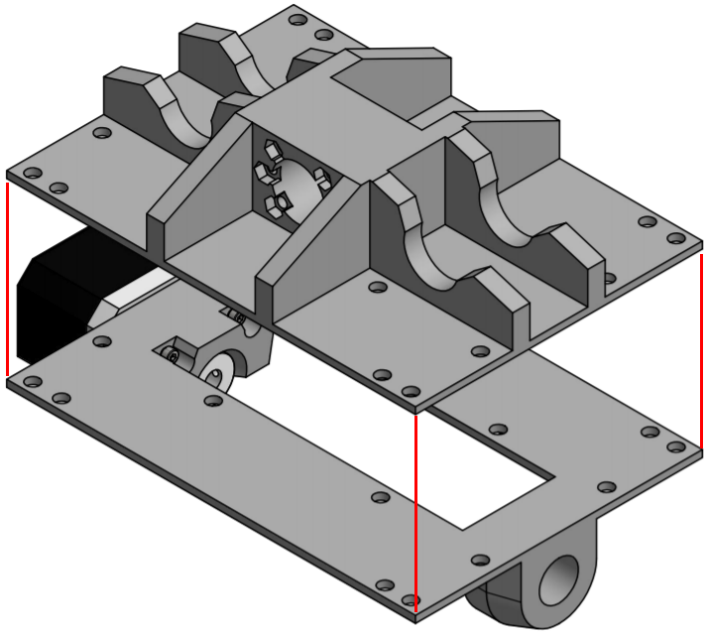
(1) Insert a **608 Bearing** into **XCarriageBot**



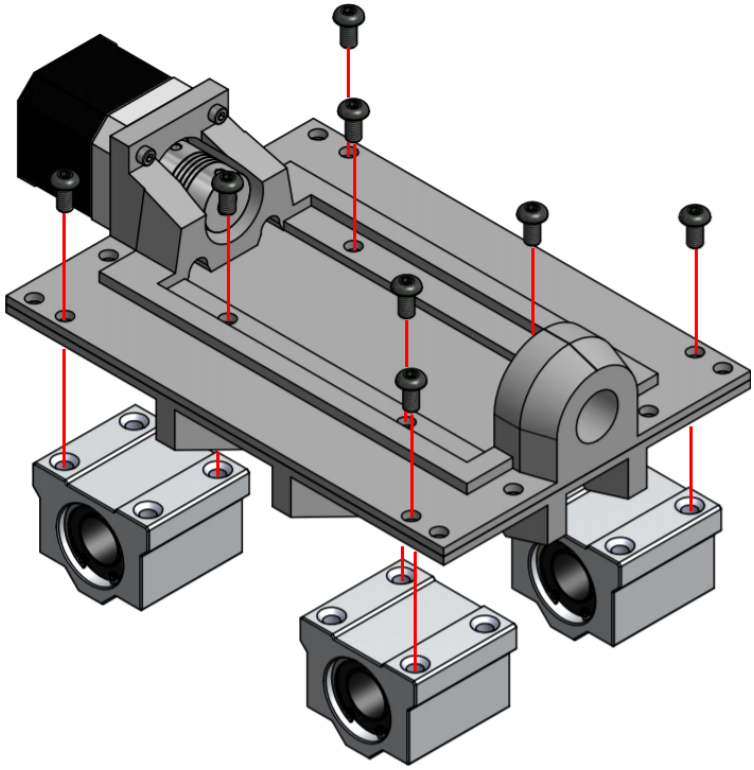
(2) Fasten a **NEMA17 Stepper Motor** to **XCarriageBot** using **Qty. 2 M3x12 SHCS** and **Qty. 2 M3x25 SHCS** (using a **2.5mm driver**)



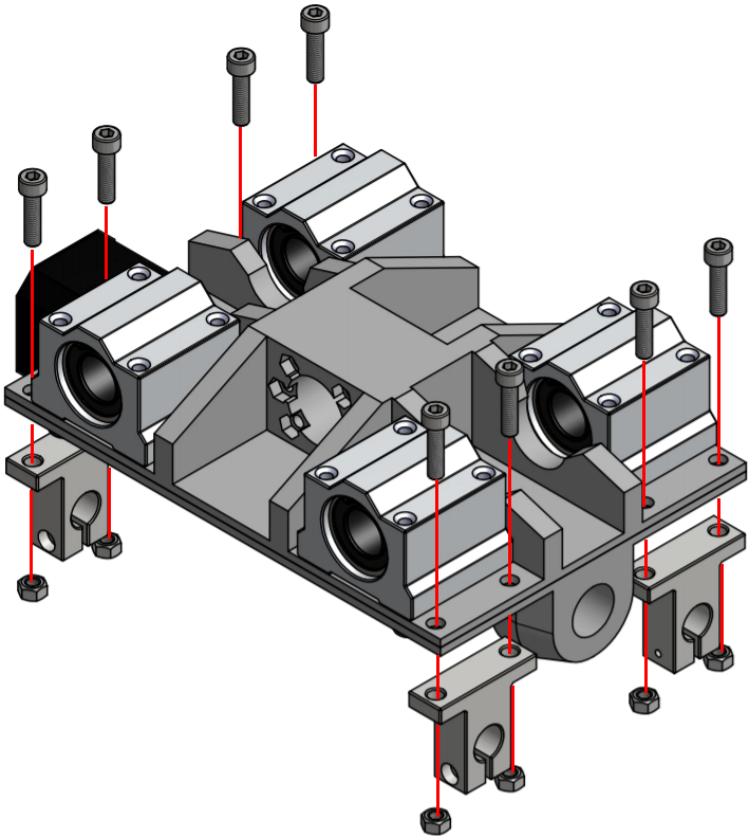
(3) Loosely place a **5x8mm Shaft Coupling** on the shaft of the **NEMA17 Stepper**. Do not tighten.



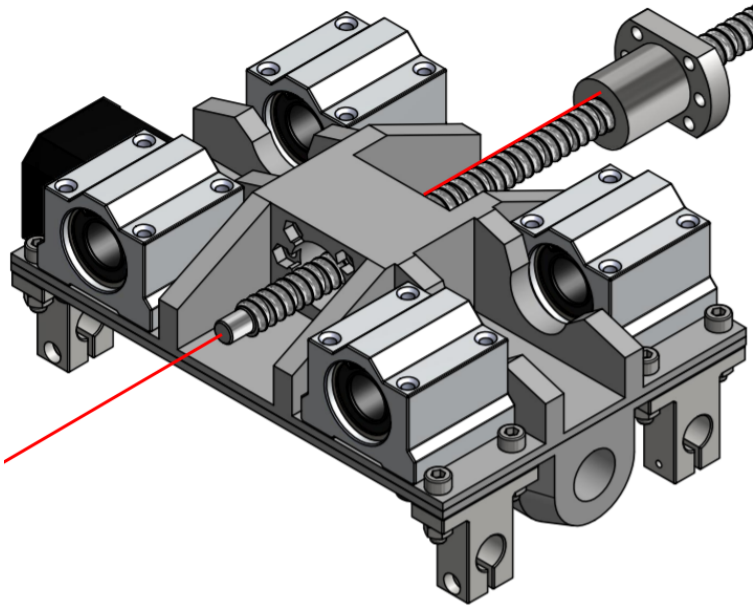
(4) Flip **XCarriageBot** over and align **XCarriageTop**, placing it in the orientation pictured above



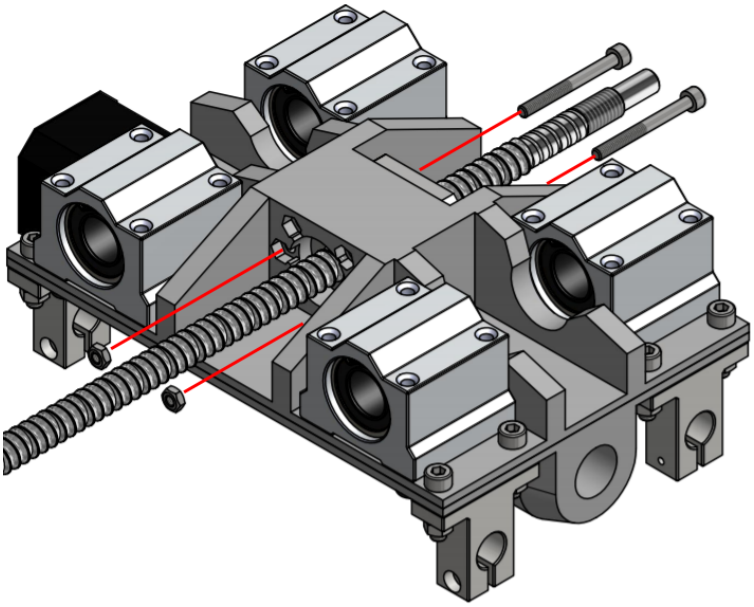
(5) Working between both sides of **XCarriageBot** and **XCarriageTop**, fasten **Qty. 4 SC16UU Pillow Bearing Blocks** to the parts using **Qty. 8 M5x10 BHCS** (using a **3mm driver**)



(6) Working between both sides of the assembly, fasten **Qty. 4 SK12 Shaft Supports** to the assembly using **Qty. 8 M5x20 SHCS** and **Qty. 8 M5 Hex Nuts** (using a **4mm driver**). To allow ease of access, make sure that the **M5x20 SHCS** are fastened from the top and that the grub screw holes on the **SK12 Shaft Supports** are oriented towards the outside of the assembly as pictured.



(7) Press a **SFU1204-300mm** into the retainer on **XCarriageTop** from the right



(8) Secure the **SFU1204-300mm** in place tightening **Qty. 2 M4x45 SHCS** through the bushing and mount to **Qty. 2 M4 Hex Nut** in the opposing recesses (using a **3mm driver**)
(Optionally you may install Qty. 6 of each fastener at the provided points to ensure additional strength and rigidity)

This is the completed X-Carriage Assembly. Set aside for integration of the Z-carriage later on.

NOTE: THESE ARE ROUGH UNFORMATTED INSTRUCTIONS DESIGNED FOR REVIEW AND PROOFING BY THE DEVELOPMENT COMMUNITY ONLY.

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