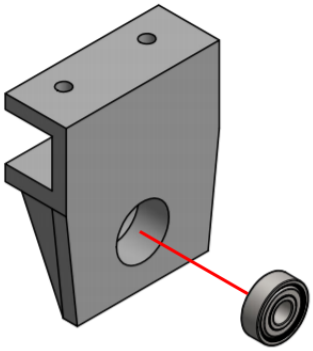
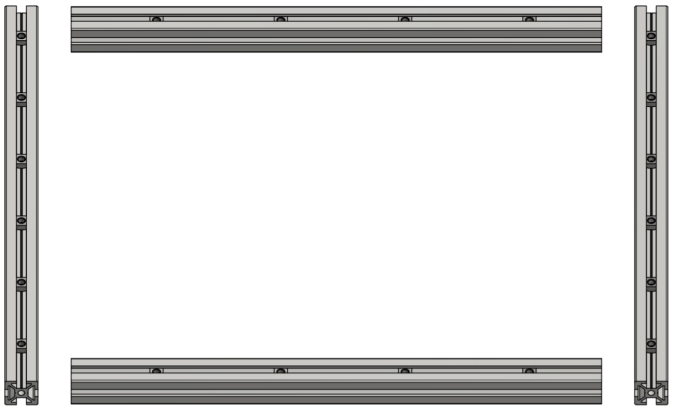
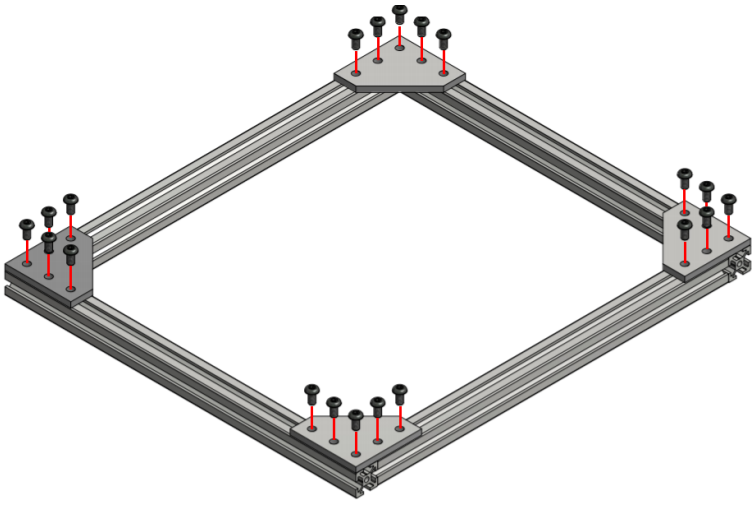


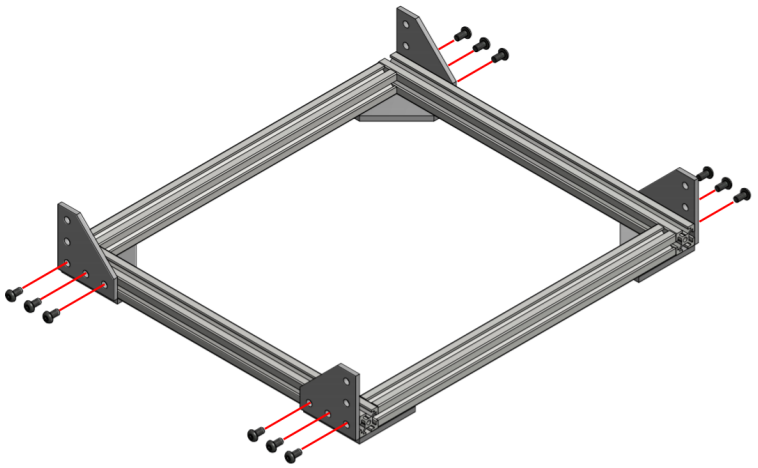
(1) Press a **608 Bearing** into **Y-Idler**



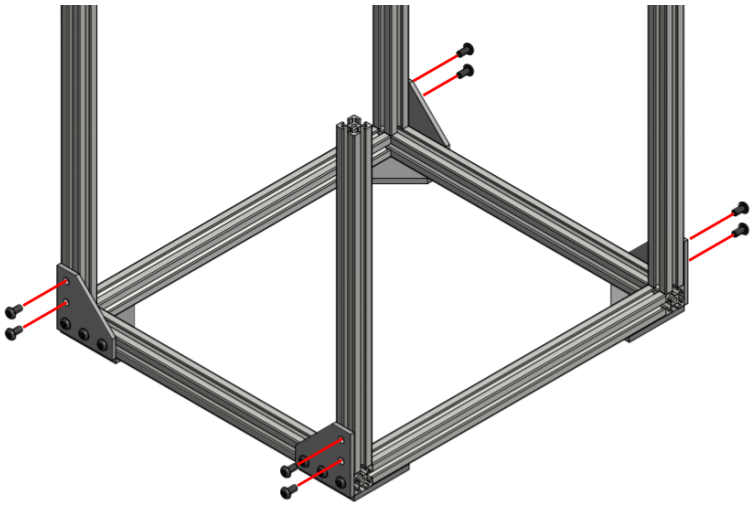
(2) With **Qty. 4 2020-320** extrusion lengths laid out as pictured, insert **Qty. 4 M5 Slot Nuts** into each of the two horizontal extrusion lengths, and **Qty. 6 M5 Slot Nuts** into each of the two vertical extrusion lengths.



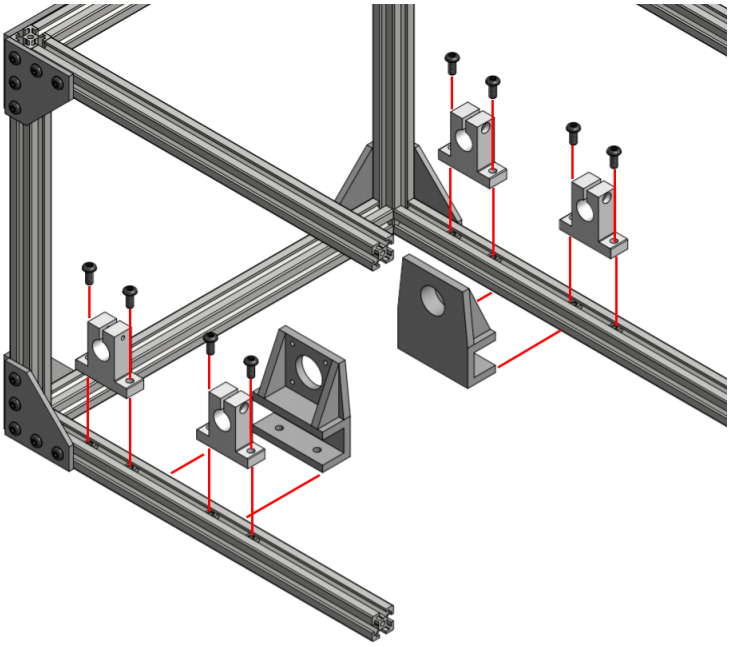
(3) Bringing the lengths together and squaring the corners, add **Qty. 4 L-plate Brackets** to the corners and fasten in place with **Qty. 5 M5x10 BHCS** each. If using a square or protractor that provides enough accuracy, tighten fully. Otherwise, leave just loose enough to adjust extrusion by hand as needed.



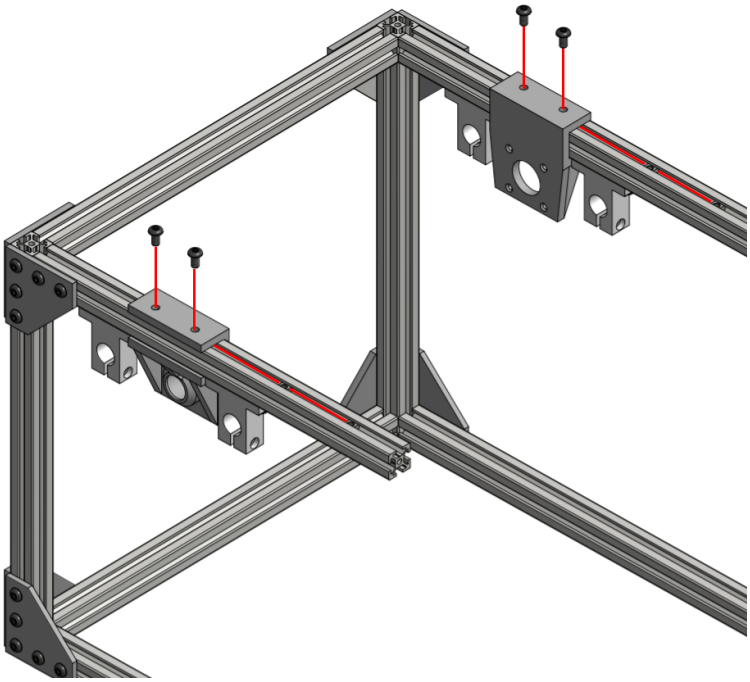
(4) With the assembly turned upside down, slide **Qty. 6 M5 Slot Nuts** into the two accessible outside edges. Then loosely attach **Qty. 4 L-plate Brackets** to the corners of the assembly using **Qty. 3 M5x10 BHCS** fastened to the Slot Nuts for each.



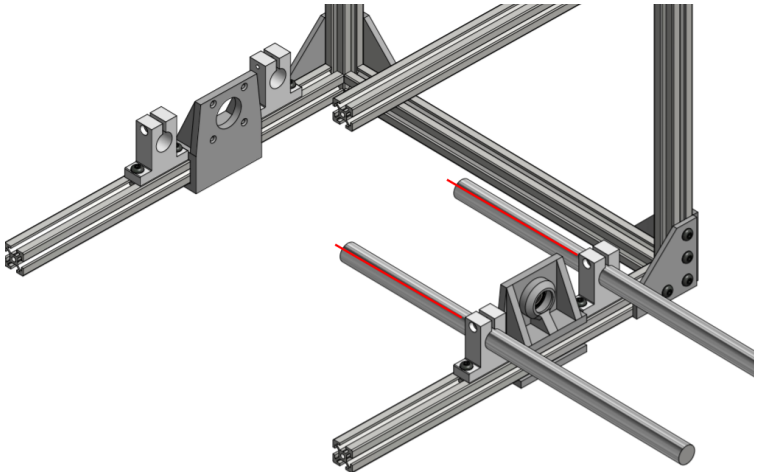
(5) Set **Qty. 4 2020-320** extrusion lengths upright, attached to the corner brackets by **Qty. 2 M5 Slot Nuts** and **Qty. 2 M5x10 SHCS** each, attaching them one at a time. If using a square or protractor that provides enough accuracy, tighten fully. Otherwise, leave just loose enough to adjust extrusion by hand as needed.



(6) With the assembly flipped on its side, insert **Qty. 4 M5 Slot Nuts** on each of the 'top' slots of the two bottom, accessible lengths. Loosely fix **Qty. 2 SK16 Shaft Supports** to each of these lengths using **Qty. 4 M5x12 BHCS** anchored to the Slot Nuts. Loosely set **Y-Idler** and **Y-Motor** in place as spacers between the Shaft Supports, and set the innermost SK16's approximately 40mm from their respective corners.



(7) Flip the assembly over once again. With access to the top extrusion slots add **Qty. 2 M5 Slot Nuts** to each length. Guide the slot nuts into place below **Y-Idler** and **Y-Motor**, aligning with the mounting holes. Fix **Y-Idler** and **Y-Motor** in place with **Qty. 2 M5x10 BHCS** through each.



(8) Flip the assembly over again. Press **Qty. 2 16x350mm Linear Shafts** through the **SK16 Shaft Supports** on the side with **Y-Idler** attached. Only press the shafts approximately half way towards the opposite side, and only tighten the Shaft Support retention grubs enough to keep the Linear Shafts in place.