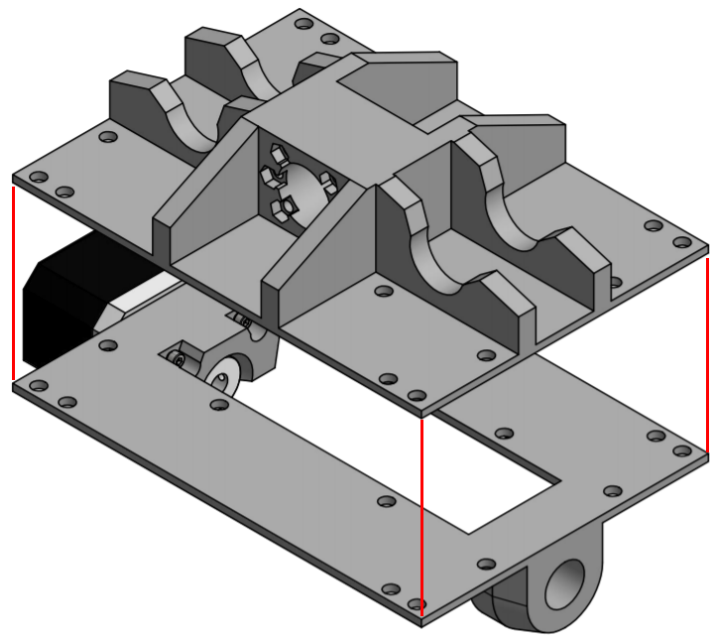
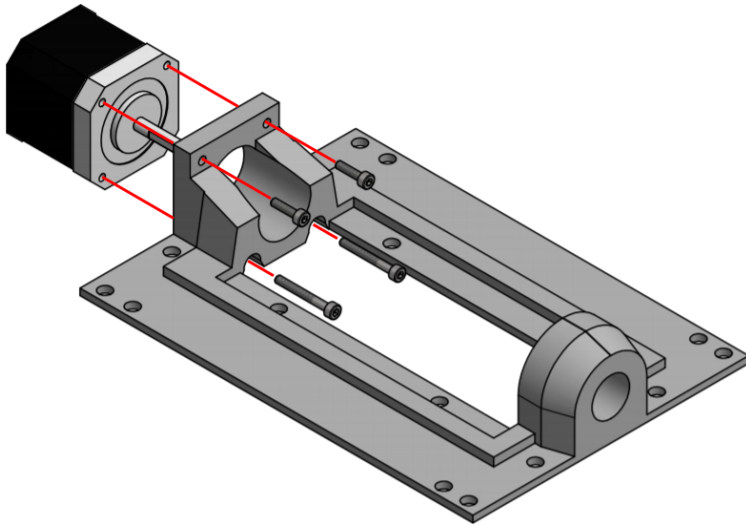


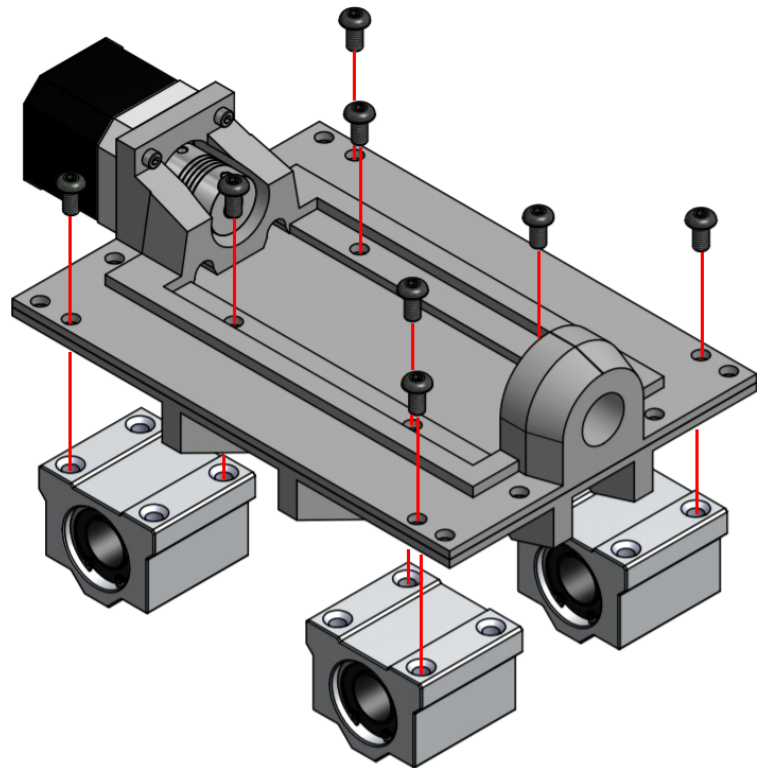
(1) Insert a **608 Bearing** into **Y-Carriage-Lower**



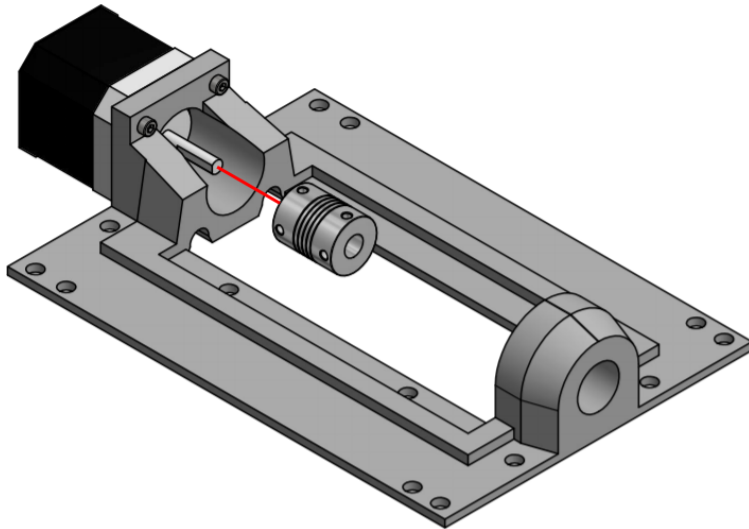
(4) Flip **Y-Carriage-Lower** over and align **Y-Carriage-Upper**, placing it in the orientation pictured above



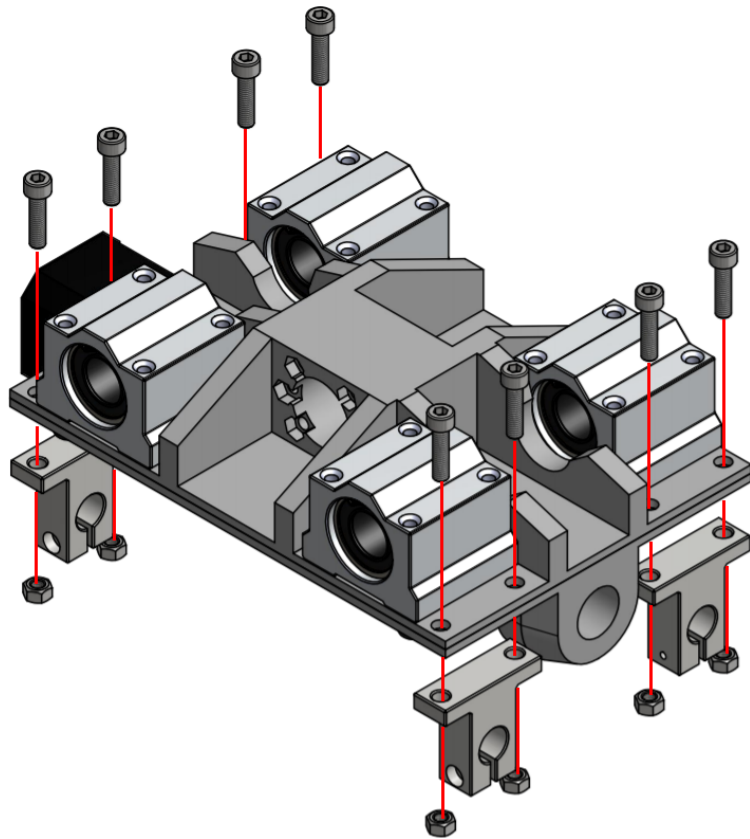
(2) Fasten a **NEMA17 Stepper Motor** to **Y-Carriage-Lower** using **Qty. 2 M3x12 SHCS** and **Qty. 2 M3x25 SHCS** (using a 2.5mm driver)



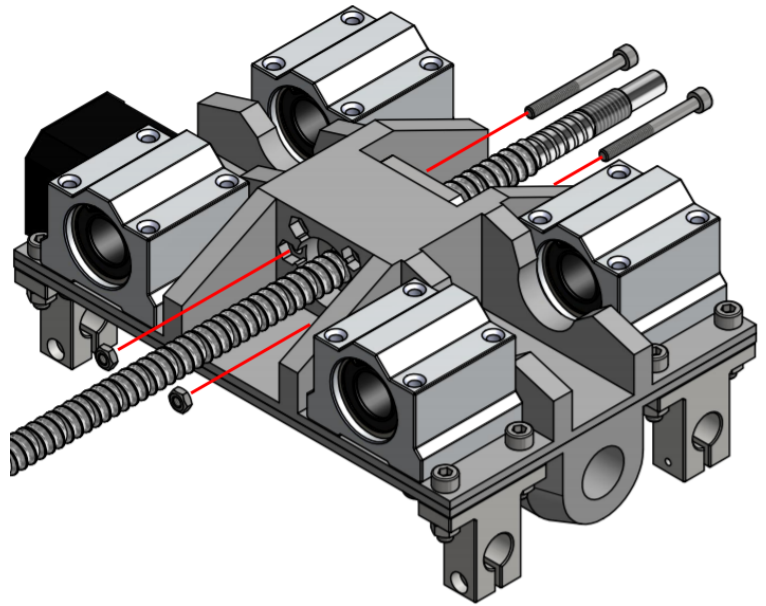
(5) Working between both sides of **Y-Carriage-Lower** and **Y-Carriage-Upper**, fasten **Qty. 4 SC16UU Pillow Bearing Blocks** to the parts using **Qty. 8 M5x10 BHCS** (using a 3mm driver)



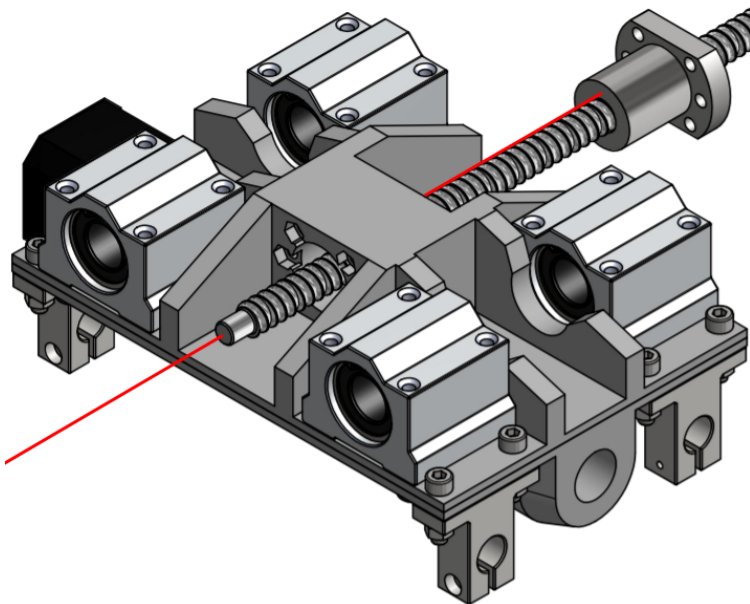
(3) Loosely place a **5x8mm Shaft Coupling** on the shaft of the **NEMA17 Stepper**. Do not tighten.



- (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.



- (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)



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