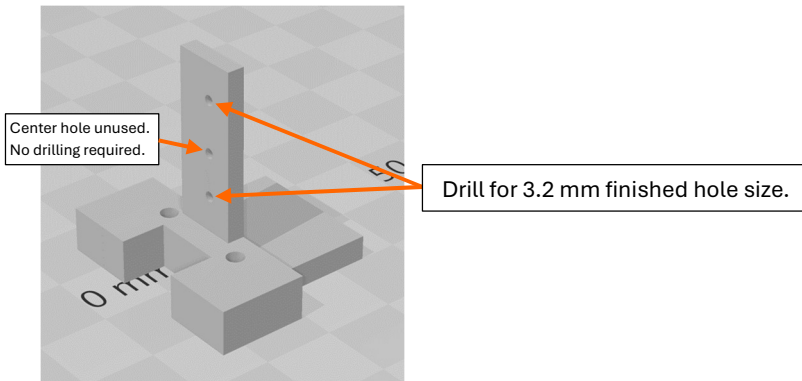


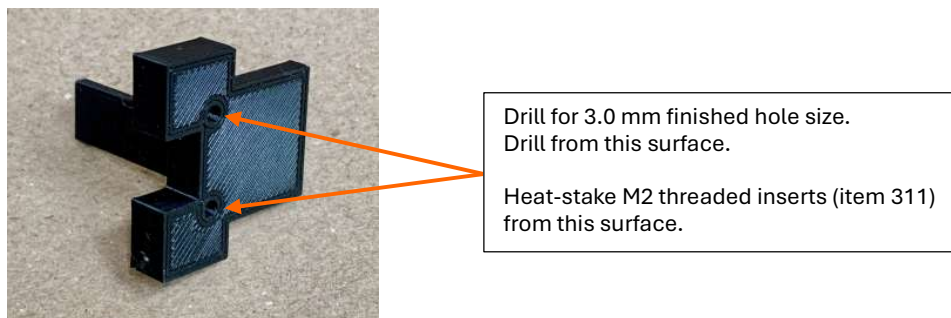
Secondary operations, microSD Card Carrier

After 3D printing, the microSD Card Carrier, item 204, needs the following secondary operations to be the fully completed part that can be attached to the front panel assembly.

- Confirm diameter and if necessary, drill holes through to the opposite surface in the 3D printed piece as shown in 2 places to produce a finished hole size of 3.2 mm.



- Confirm diameter and if necessary, drill holes through to the opposite surface in the 3D printed piece as shown in 2 places to produce a finished hole size of 3.0 mm. It is better to drill these holes from the flat surface most visible in the image below.



- Heat-stake M2 threaded inserts (item 311) into the 3.0 mm holes in the 3D printed piece in 2 places. A soldering iron set to 350° C with a pointed tip or a heat-staking tip can be used to gently press the threaded inserts into place.

