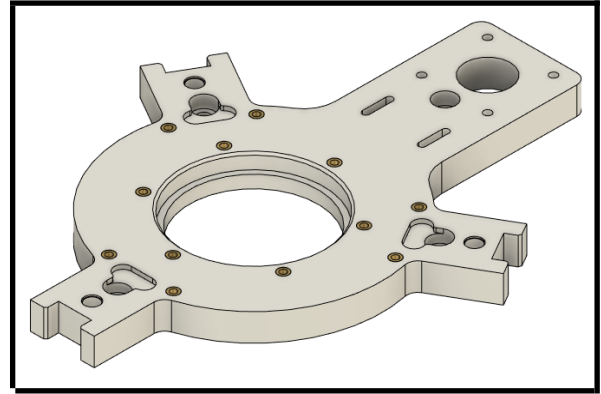
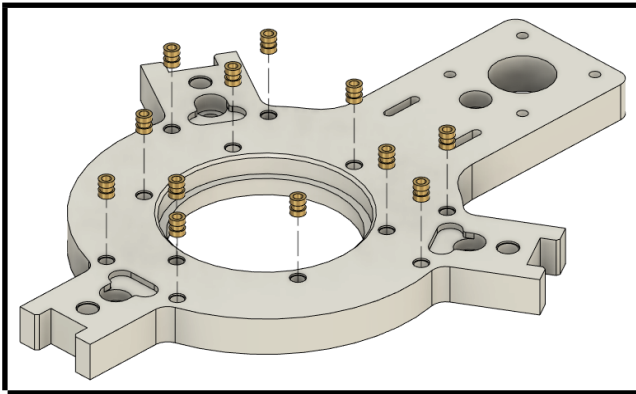
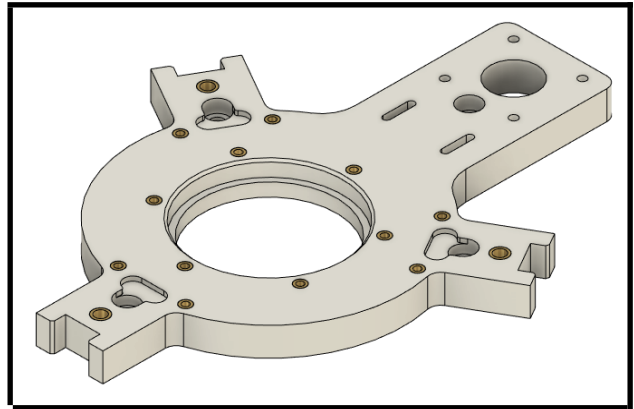
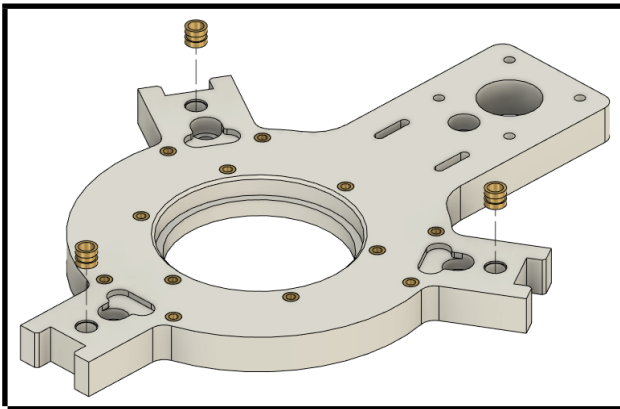


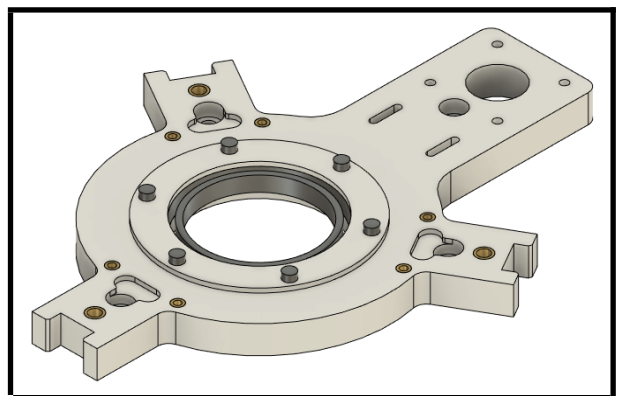
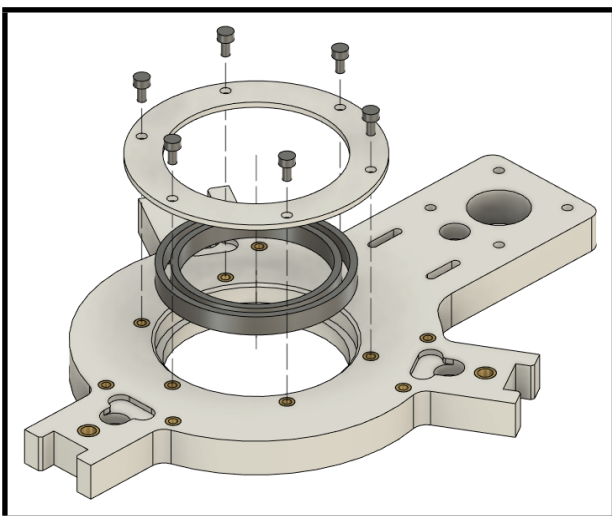
1. Insert 12x M3x6 (or similar) heat-set inserts into BASE-BRACKET.



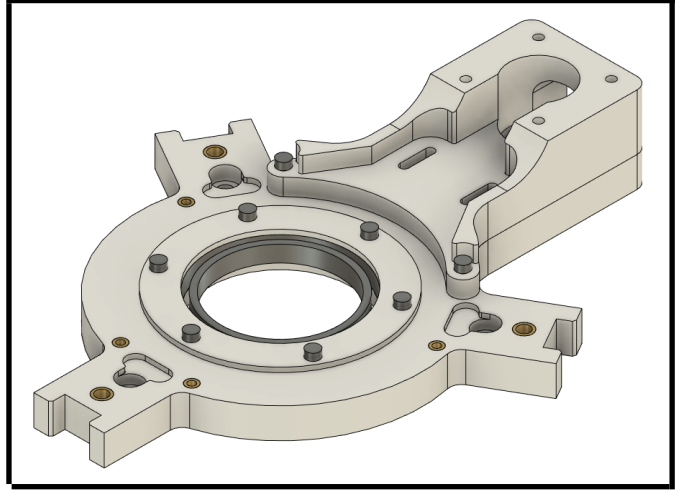
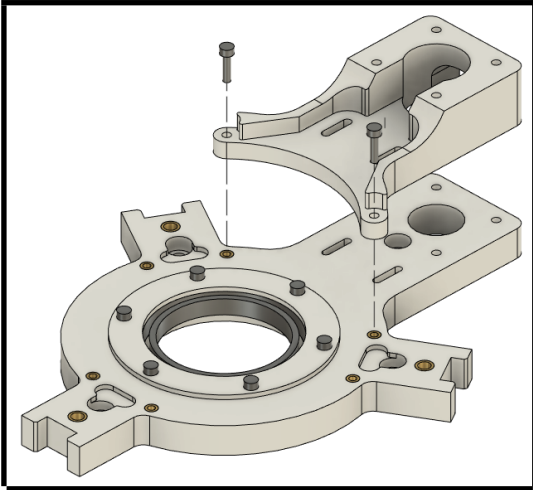
2. Insert 3x M5x6 (or similar) heat-set inserts into BASE-BRACKET.



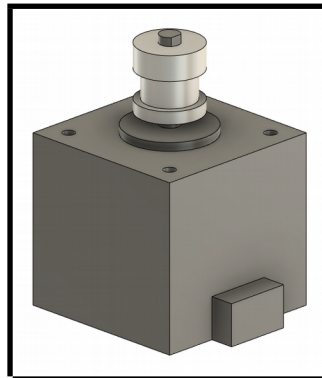
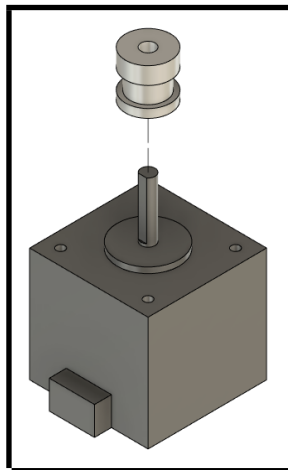
3. Insert 61810 bearing into BASE-BRACKET and clamp with BASE-BEARING-CLAMP and 6x M3x6 (or similar) screws.



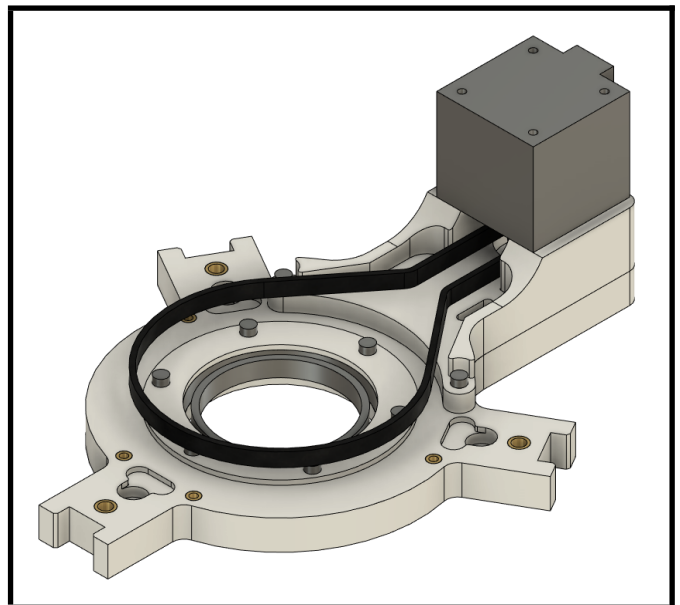
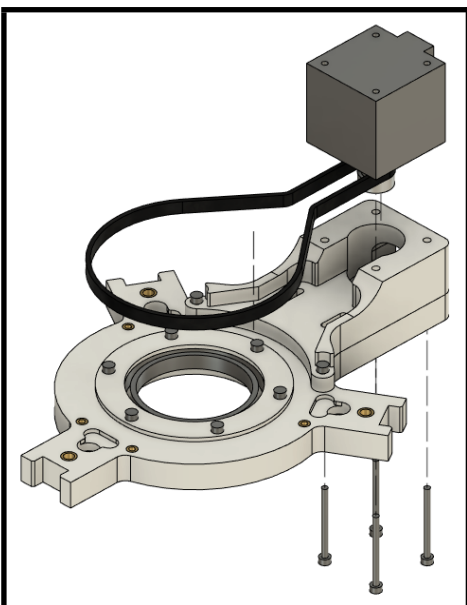
4. Fix BASE-STEPPER-BRACKET to BASE-BRACKET using 2x M3x12 (or similar) screws.



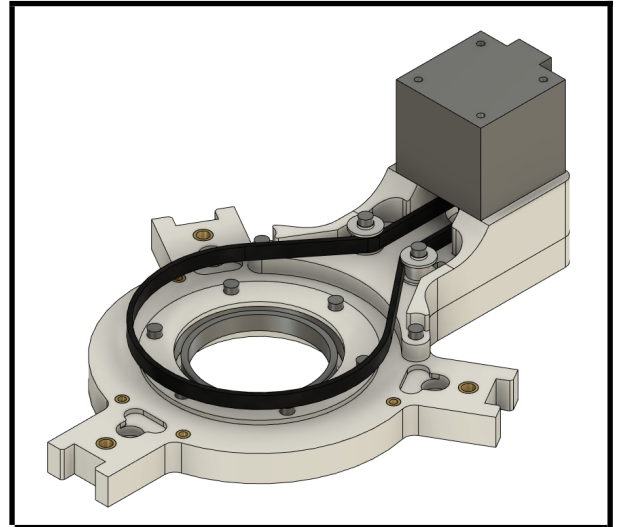
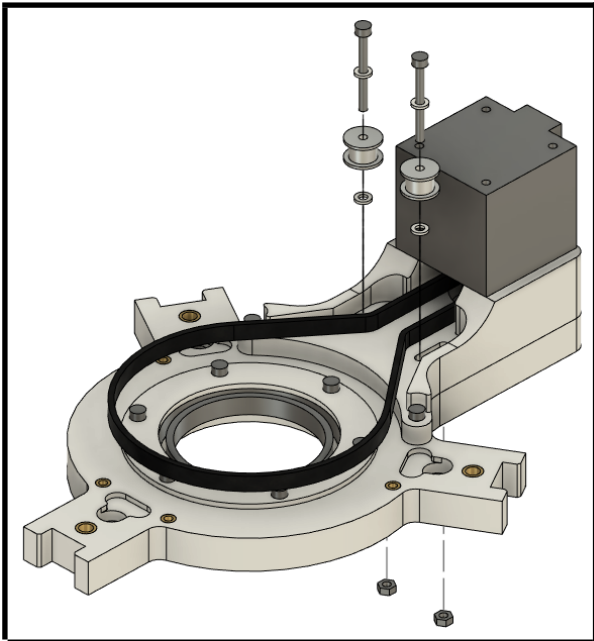
5. Fix GT2-20T pulley to Nema 17-40 stepper in the orientation shown below, with the top of the pulley spaced 2 mm below the top of the stepper shaft.



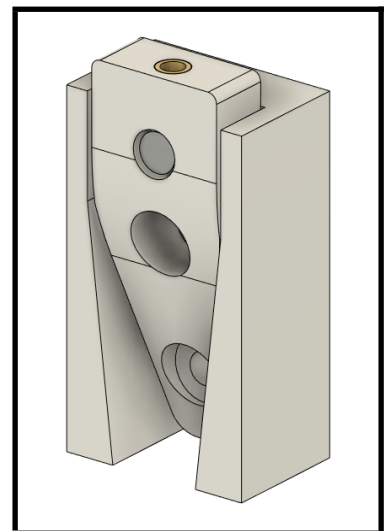
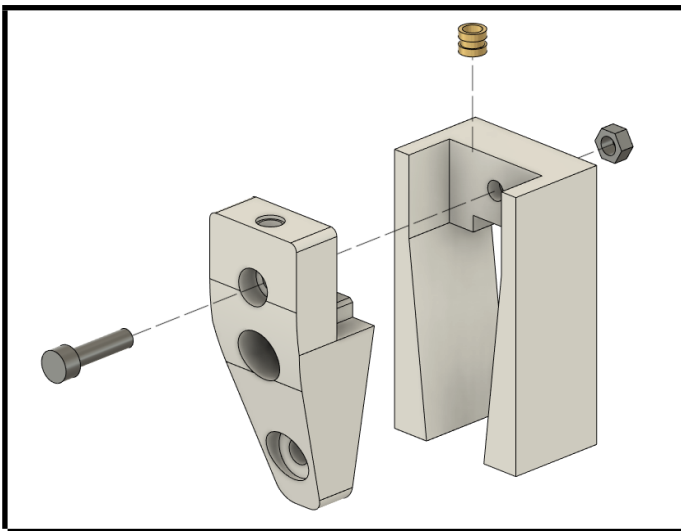
6. With GT2-400 mm belt placed over GT2-20T pulley, fix Nema 17-40 stepper to BASE-STEPPER-BRACKET using 4x M3x35 screws.



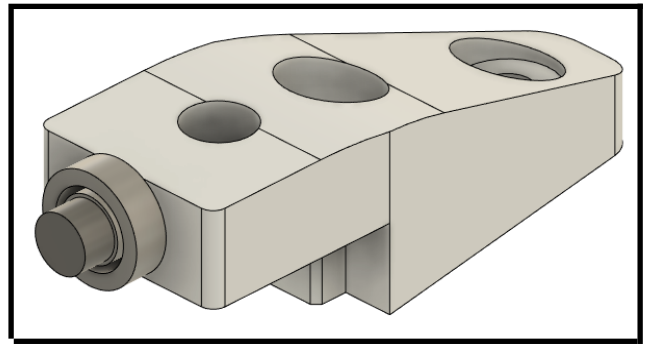
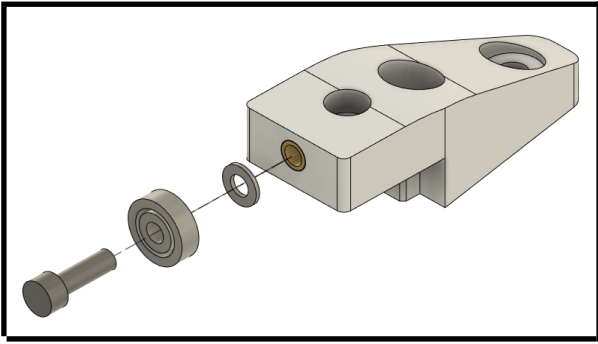
7. Install 2x GT2-16T idlers by fixing them to the 2x slots on BASE-STEPPER-BRACKET using M3x30 screws and M3x1 spacers (custom 3d printed) both between GT2 idlers and BASE-BRACKET and M3x30 screws and GT2 idlers, and lightly secure with M3 hex nuts from below BASE-BRACKET.



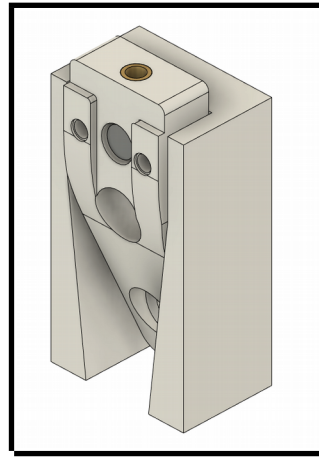
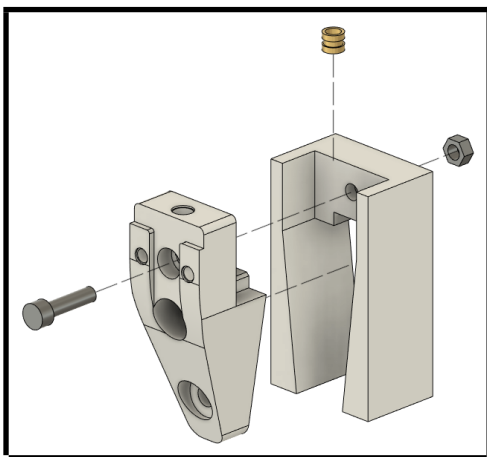
8. Insert M5x6 (or similar) heat-set insert into BASE-FOOT-A. Can use BASE-FOOT-FIXTURE to support BASE-FOOT-A vertically while doing so. Repeat again for second BASE-FOOT-A part.



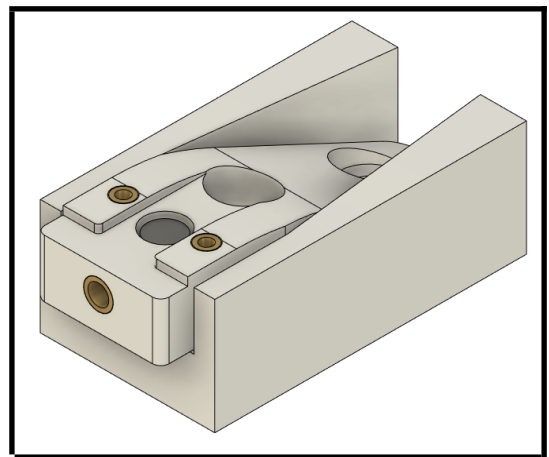
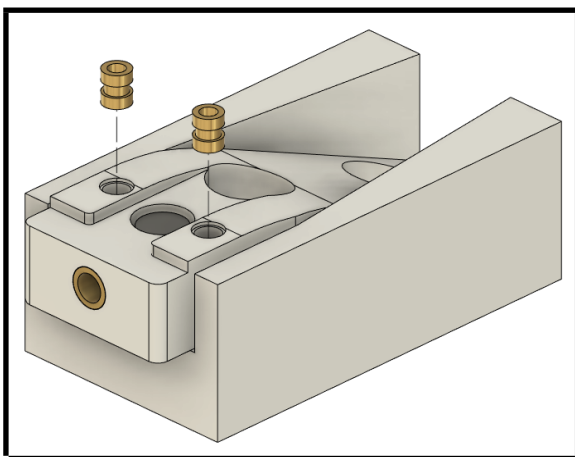
9. Fix 623-ZZ bearing to BASE-FOOT-A, with M5 washer at interface, using M5x16 (or similar) screw. Repeat again for second BASE-FOOT-A part.



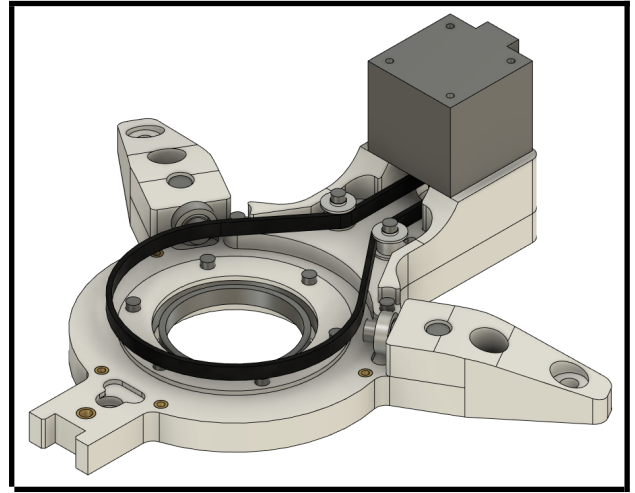
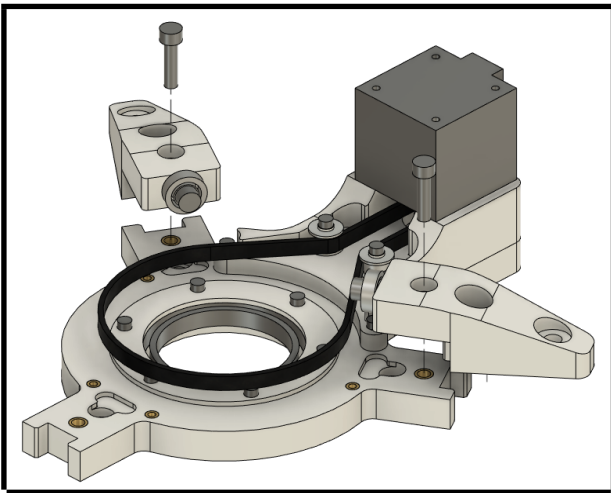
10. Insert M5x6 (or similar) heat-set insert into BASE-FOOT-B. Can use BASE-FOOT-FIXTURE to support BASE-FOOT-B vertically while doing so.



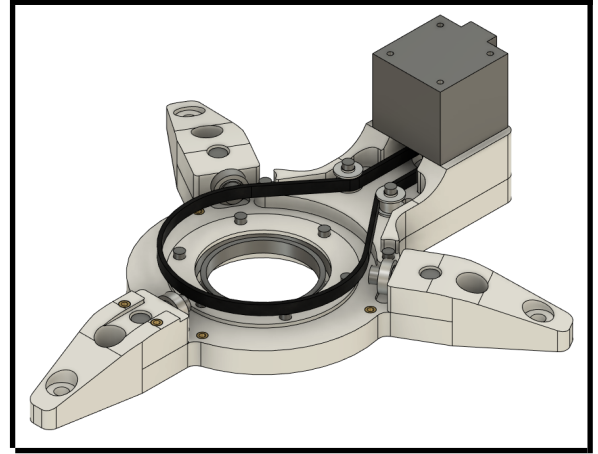
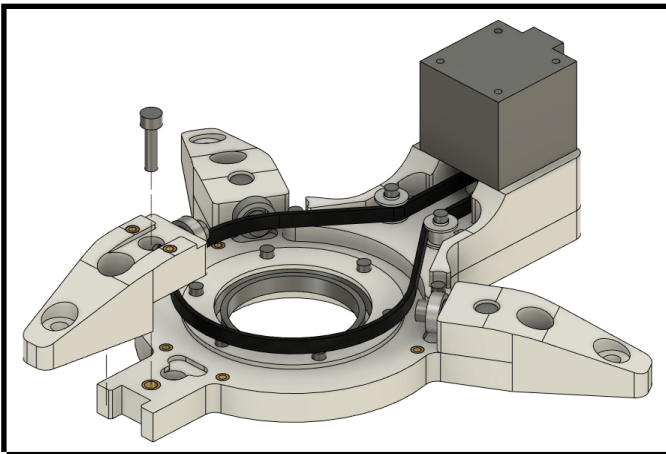
11. Insert 2x M3x6 (or similar) heat-set inserts into BASE-FOOT-B. Can use BASE-FOOT-FIXTURE to support BASE-FOOT-B horizontally while doing so.



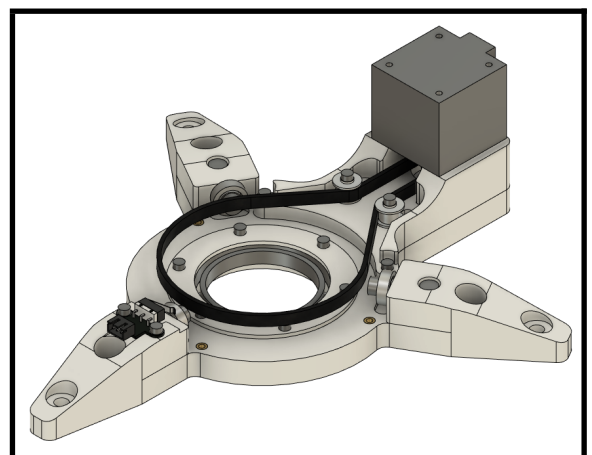
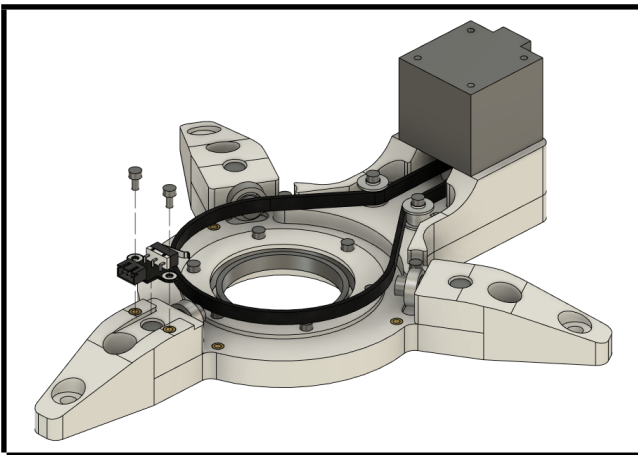
12. Fix 2x BASE-FOOT-A, pre-assembled with 623-ZZ bearings, to BASE-BRACKET using M5x20 screws.



12. Fix BASE-FOOT-B, pre-assembled with 623-ZZ bearing, to BASE-BRACKET using M5x20 screw.

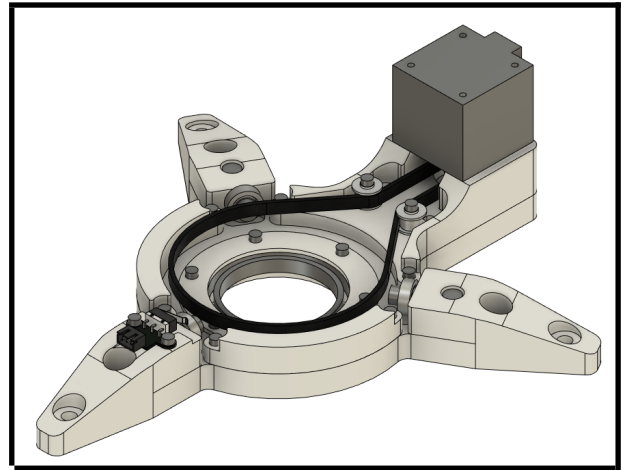
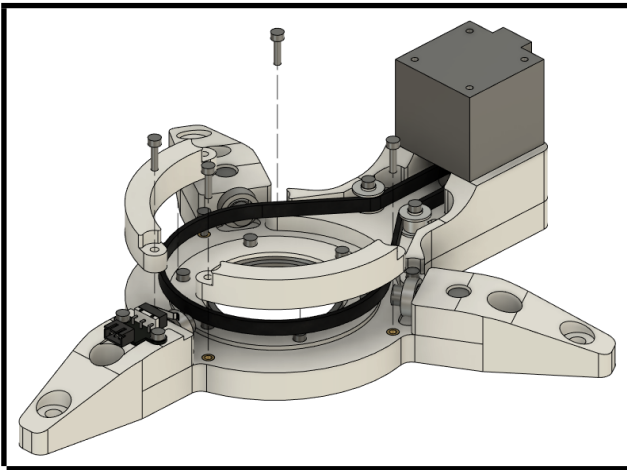


13. Fix limit switch to BASE-FOOT-B using 2x M3x6 screws (or similar).





14. Install 2x BASE-COVER-BRACKET to BASE-BRACKET and fix each with 2x M3x12 (or similar) screws.



15. BASE-LINK now assembled

