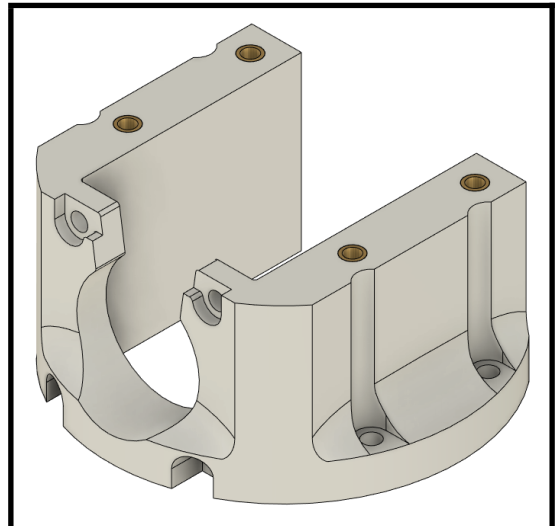
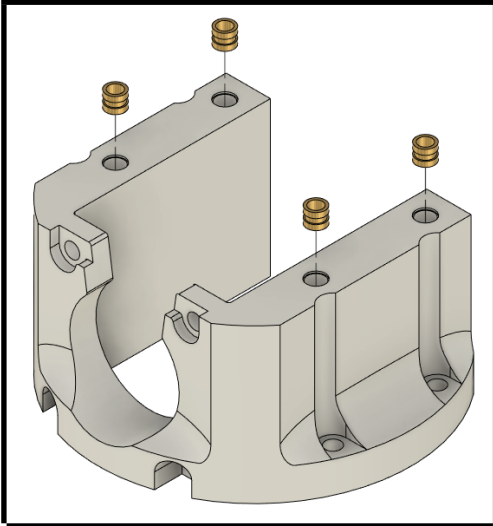
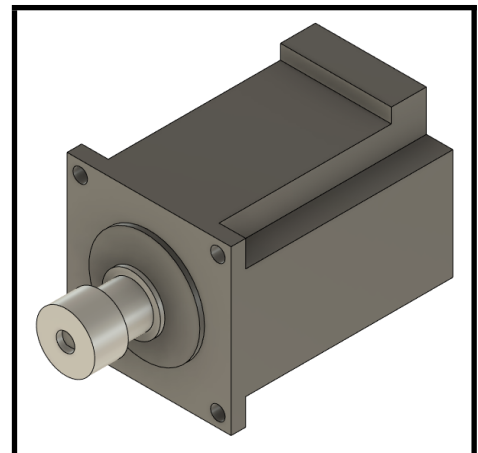
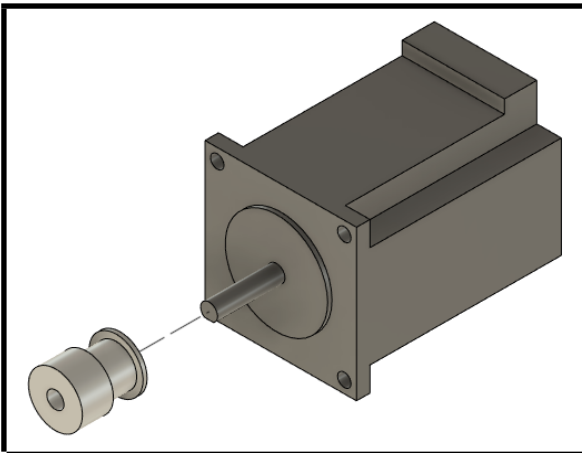


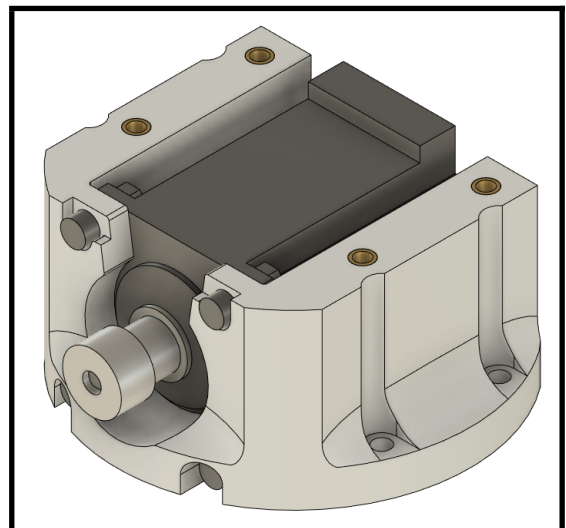
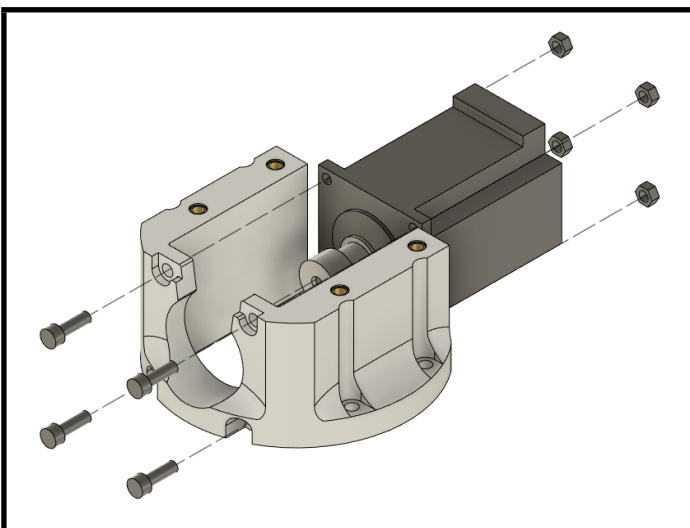
1. Insert 4x M5x6 (or similar) heat-set inserts into ART1-STEPPER-A-BRACKET.



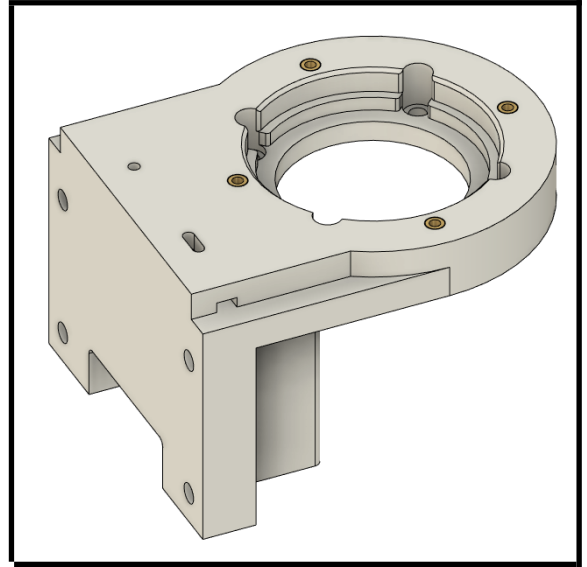
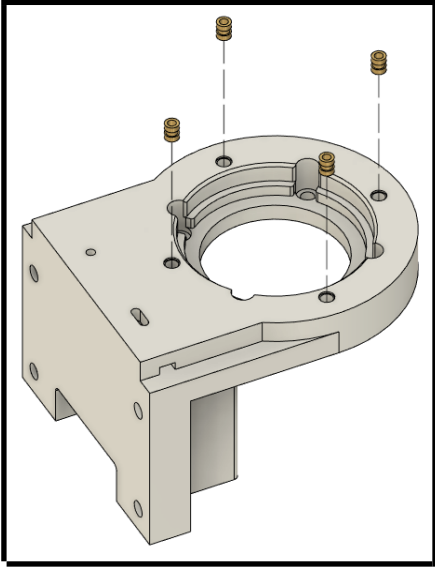
2. Attach HTD-3M-16T pulley to Nema 23-76, leaving approximately 2 mm spacing between the pulley and the stepper body.



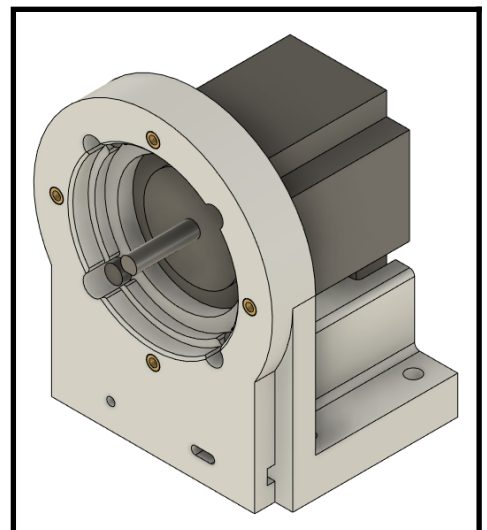
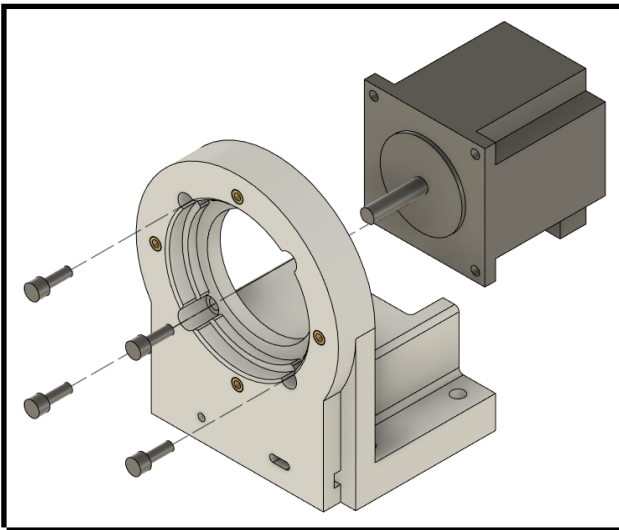
3. Attach Nema 23-76 stepper to ART1-STEPPER-BRACKET-A using 4x M5x16 (or similar) screws and M5 hex nuts. Note orientation of stepper cable connector (facing upwards).



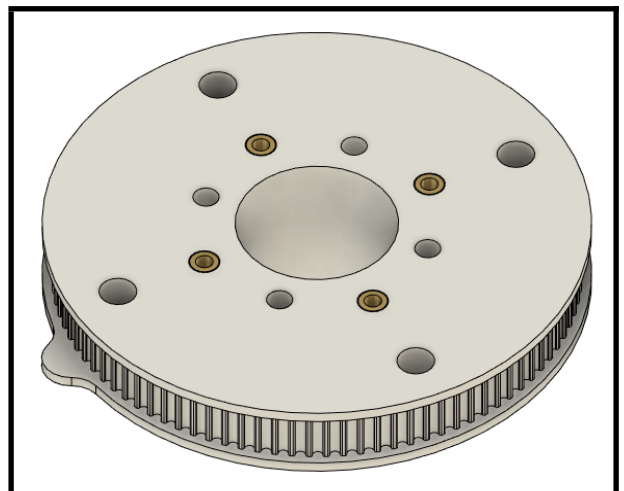
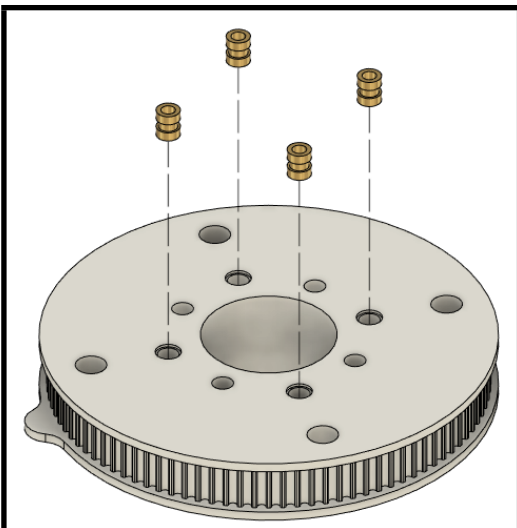
4. Insert 4x M3x6 (or similar) heat-set inserts into ART1-STEPPER-BRACKET-B.



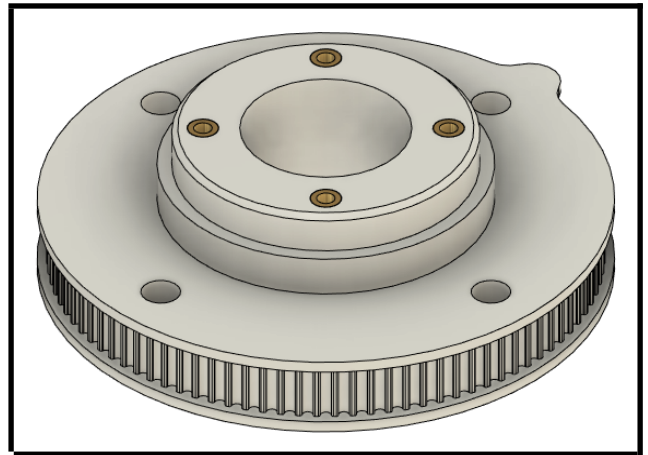
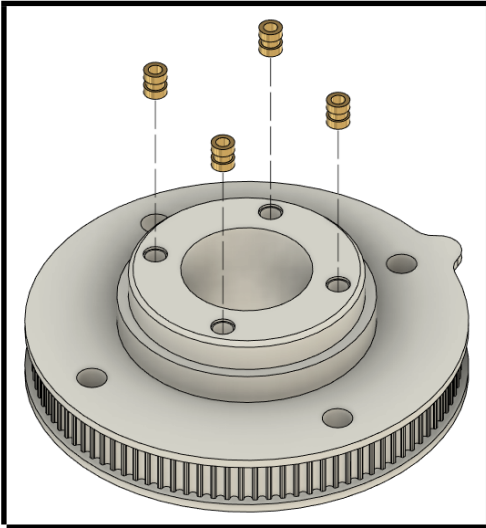
5. Attach Nema 23-57 stepper to ART1-STEPPER-BRACKET-B using 4x M4x12 (or similar) screws.



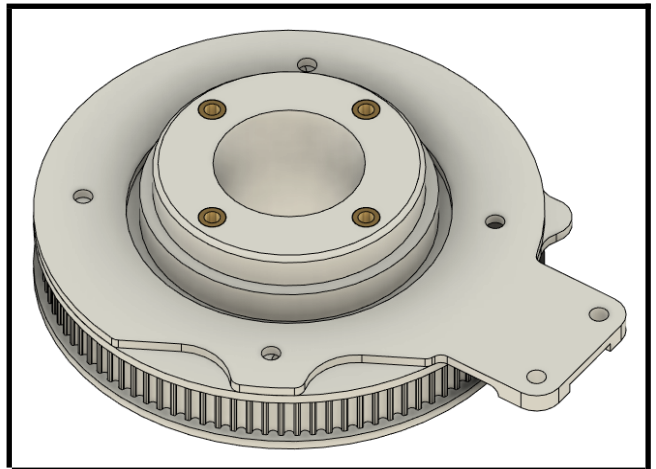
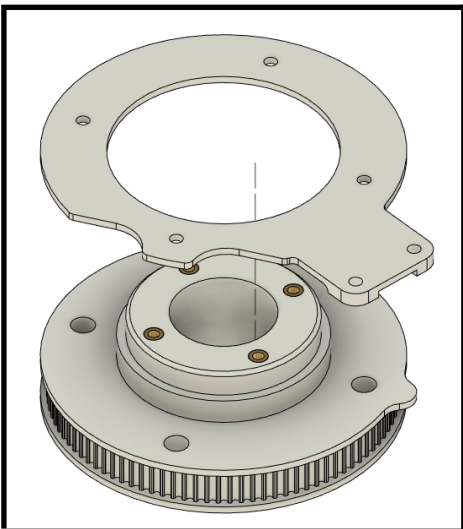
6. Insert 4x M3x6 (or similar) heat-set inserts into ART1-GEAR-B.



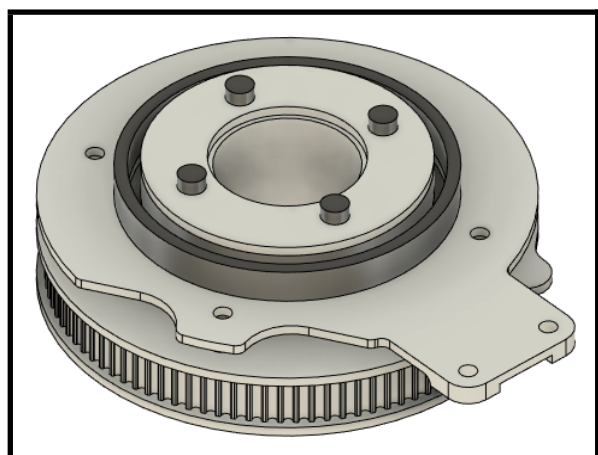
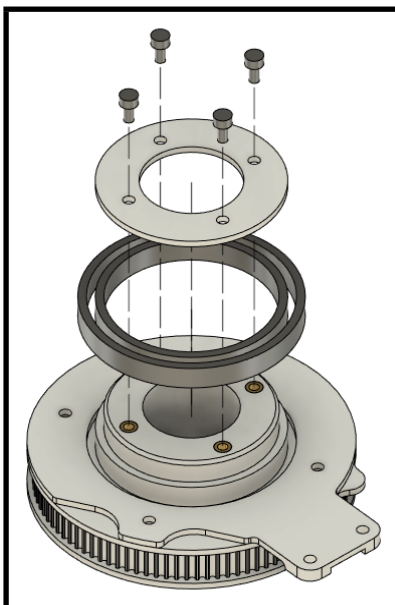
7. Turn over ART1-GEAR-B and insert 4x M3x6 (or similar) heat-set inserts.



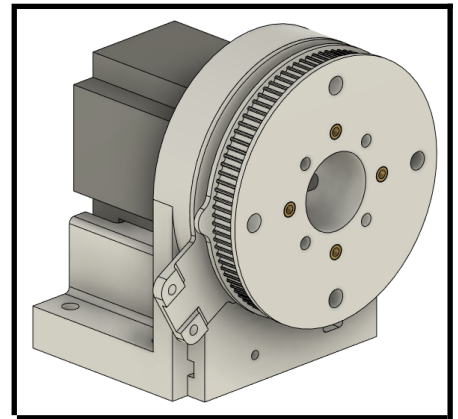
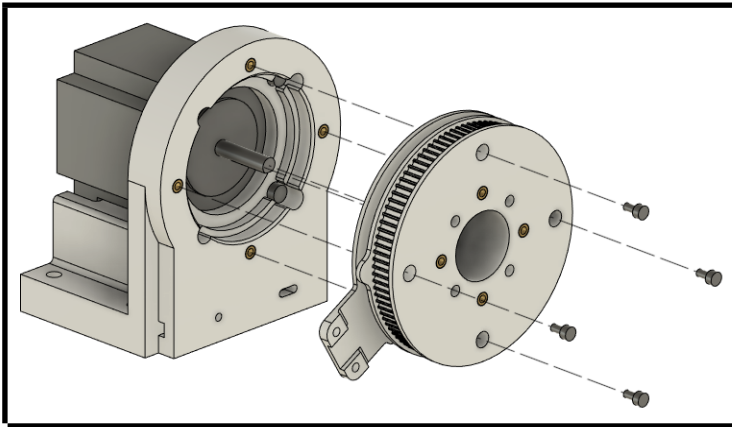
8. Place ART1-BEARING-CLAMP-B on ART1-GEAR-B in orientation as shown below.



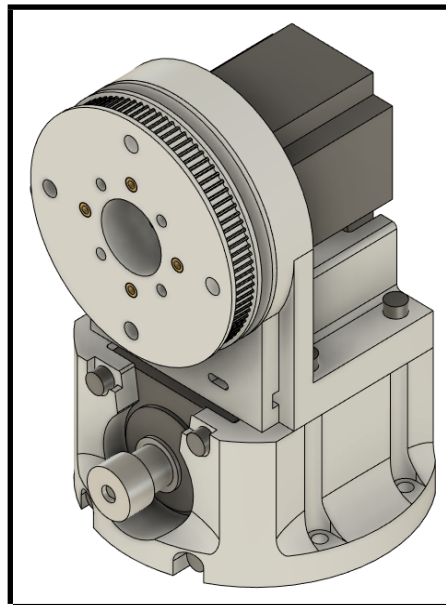
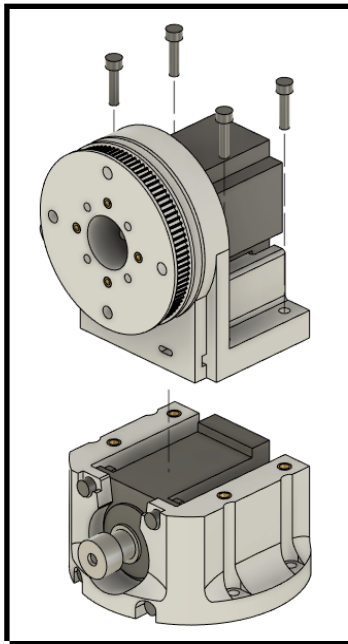
9. Attach 61810 bearing to ART1-GEAR-B and clamp using ART1-BEARING-CLAMP-A and 4x M3x6 (or similar) screws.



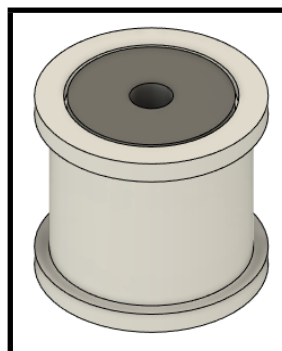
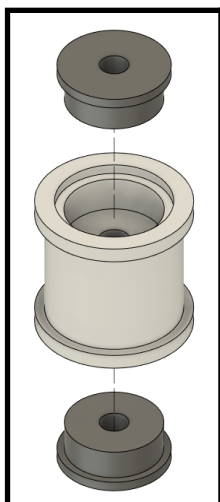
10. Insert pre-assembled 61810 bearing on ART1-GEAR-B into ART1-STEPPER-BRACKET-B and clamp by fixing ART1-BEARING-CLAMP-B to ART1-STEPPER-BRACKET-B using 4x M3x6 (or similar) screws.



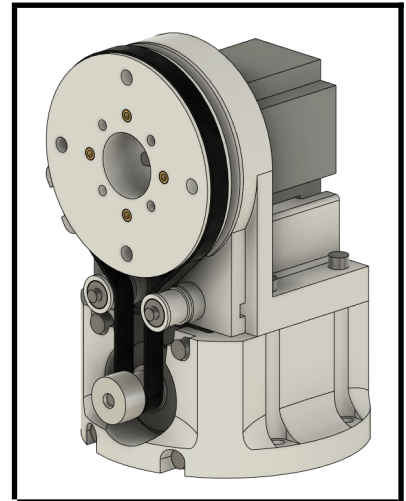
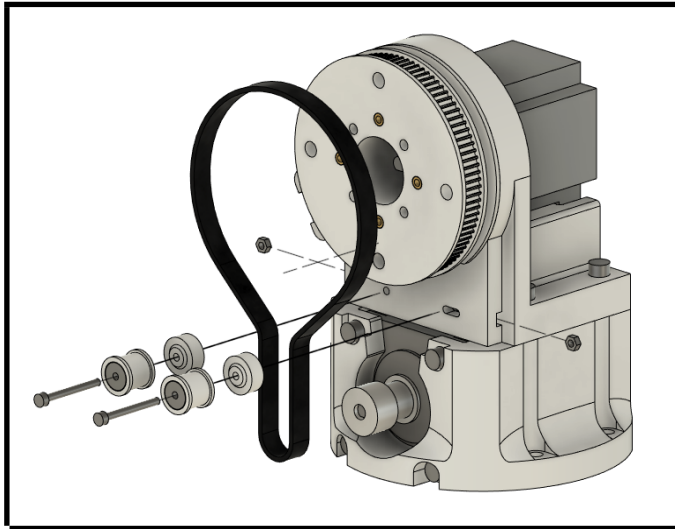
11. Place populated ART1-STEPPER-BRACKET-B on populated ART1-STEPPER-BRACKET-A and fix using 4x M5x20 (or similar) screws.



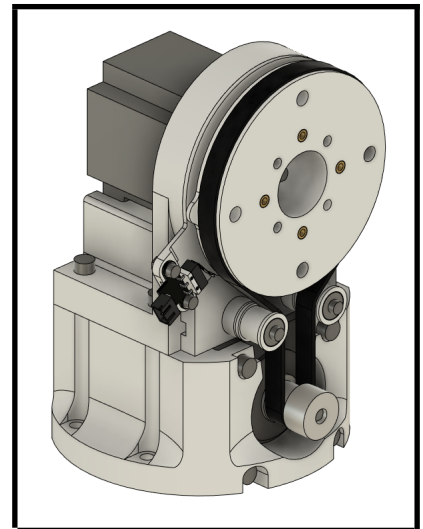
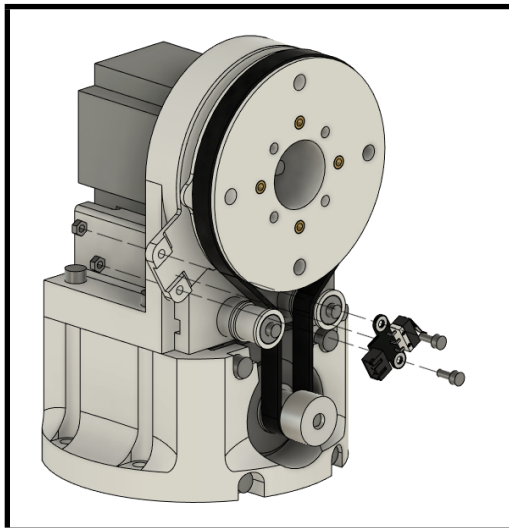
12. Insert 2x F623-ZZ bearings into HTD-3M-ILDER, and repeat again for second idler.



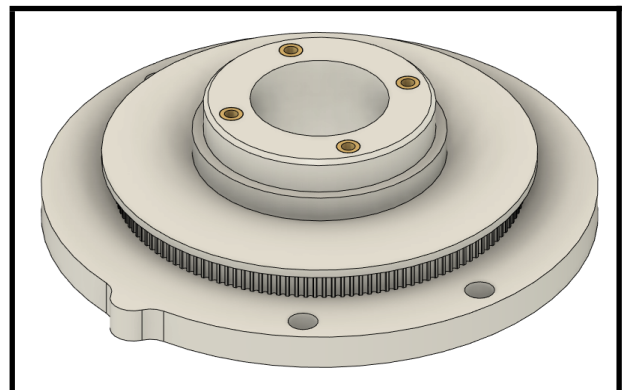
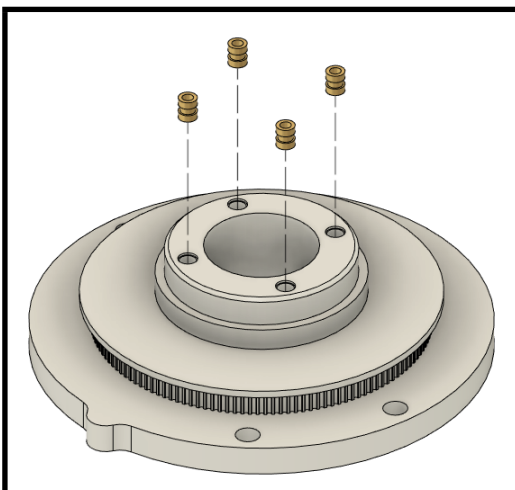
13. Install HTD-3M-390mm belt to HTD-3M-16T pulley and ART1-GEAR-B. Then install 2x ART1-IDLER-SPACER + 2x pre-assembled HTD-3M-IDLER and fix to ART1-STEPPER-BRACKET-B using M3x30 screws and M3 hex nuts.



14. Install limit switch to ART1-BEARING-CLAMP-A and fix with 2x M3x6 screws and 2x M3 nuts.

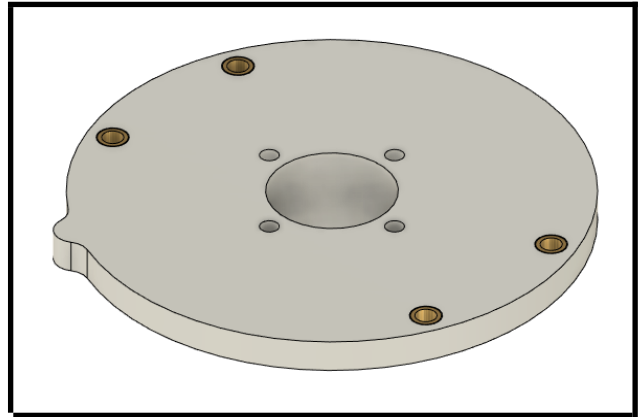
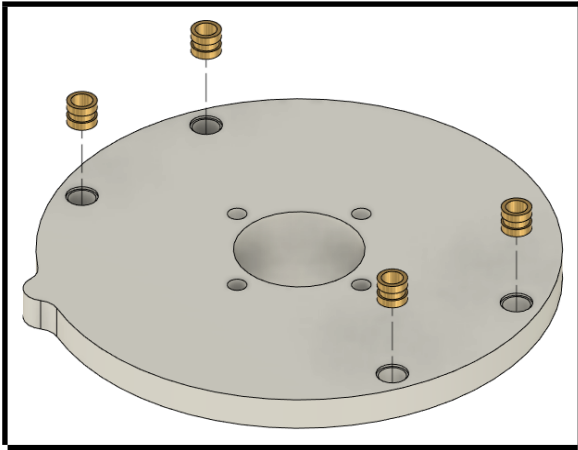


15. Insert 4x M3x6 (or similar) heat-set inserts into ART1-GEAR-A.





16. Turn over ART1-GEAR-A and insert 4x M5x6 (or similar) heat-set inserts.



17. Prepare to assemble shoulder link to base link by grouping together populated ART1-STEPPER-BRACKET-A and ART1-STEPPER-BRACKET-B sub-assembly, ART1-GEAR-A, ART1-BEARING-CLAMP-A, 4x M5x20 (or similar) screws and 4x M3x6 (or similar) screws.

