

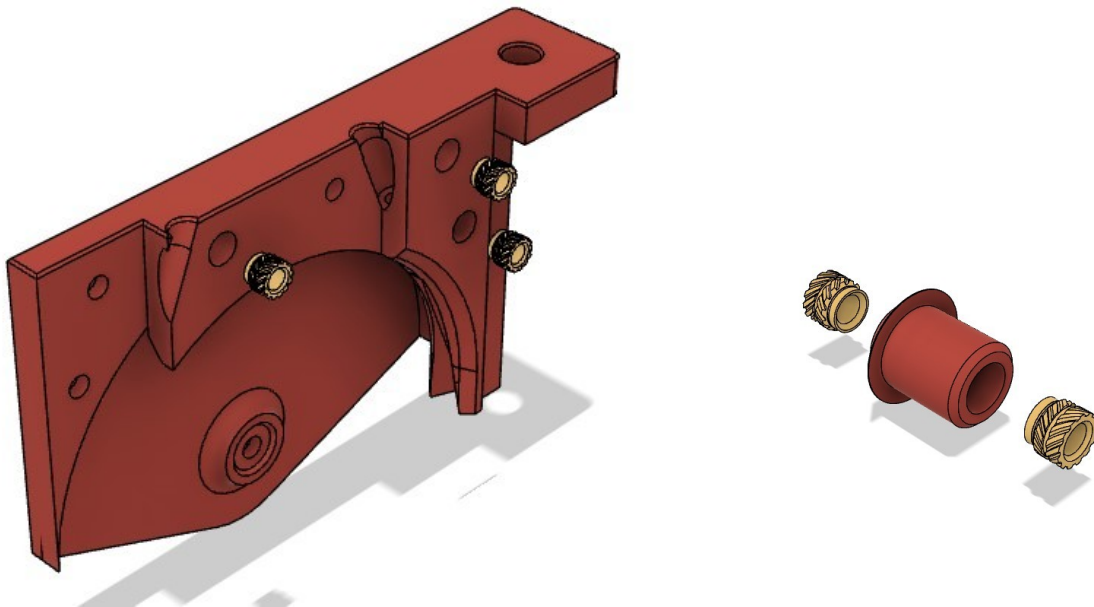
Metal Buffer Assembly Instructions

Prepare Parts

Tap both ends of each aluminum extrusion using a M5x0.8 tap (about 8-10mm deep)
Clear filament path in both halves of top assembly with a 2mm drill bit

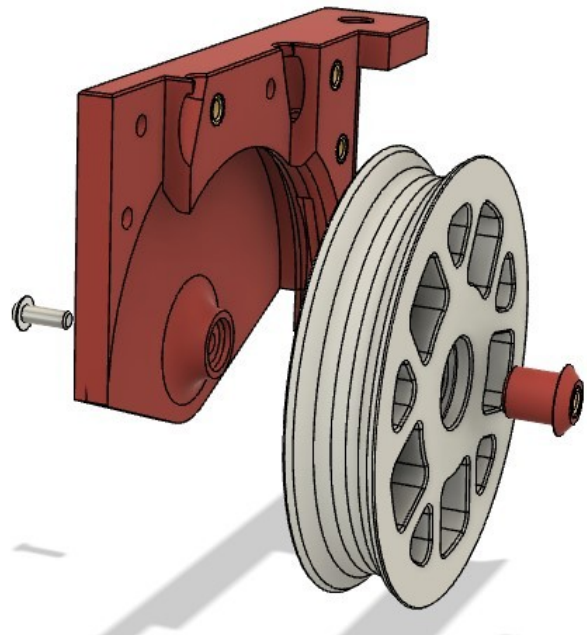
Install heat-set inserts

Install 3 inserts in each half of top assembly and 2 inserts in axle



Install wheel and axle

Place wheel, bearing-side down, on top half with deepest hub (5mm depth)
Insert axle (oriented as shown) through bearing center and affix with M3 x 8 BHCS

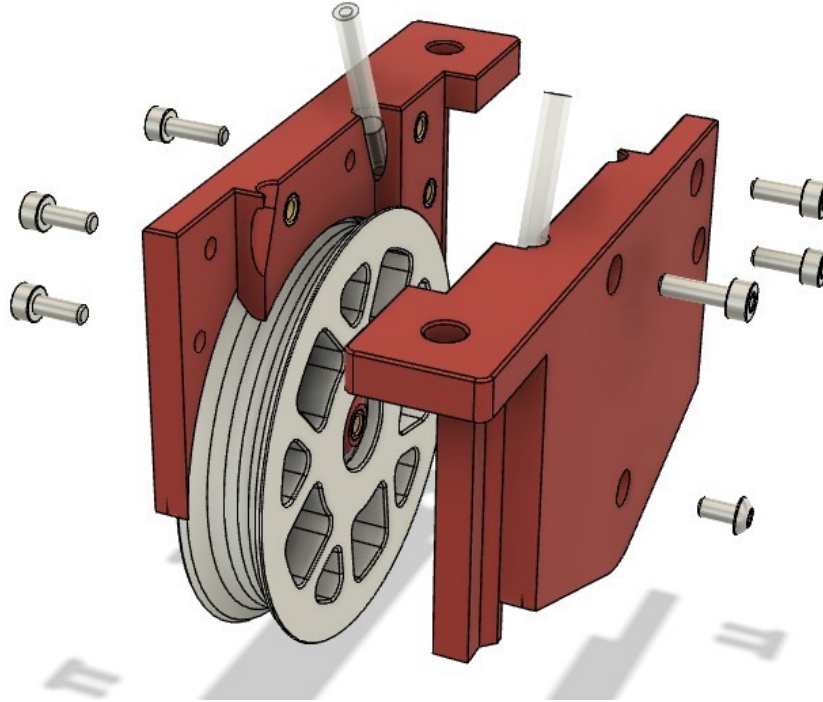


Assemble top of buffer

Insert PTFE tubes in each half of top, firmly seating in pockets

Carefully fit halves together and affix with two M3 x 8 and one M3 x 10 SHCS on each side

Affix to axle through lower hole with a M3 x 6 BHCS



Final assembly

Attach top assembly to aluminum extrusion with two M5 x 10 BHCS

Attach bottom with two M5 x 6 BHCS

