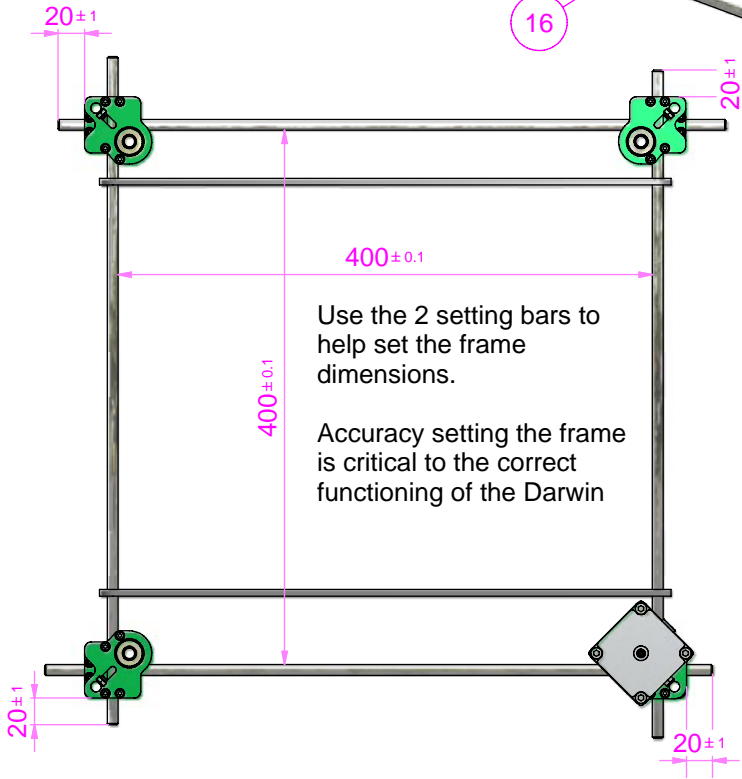
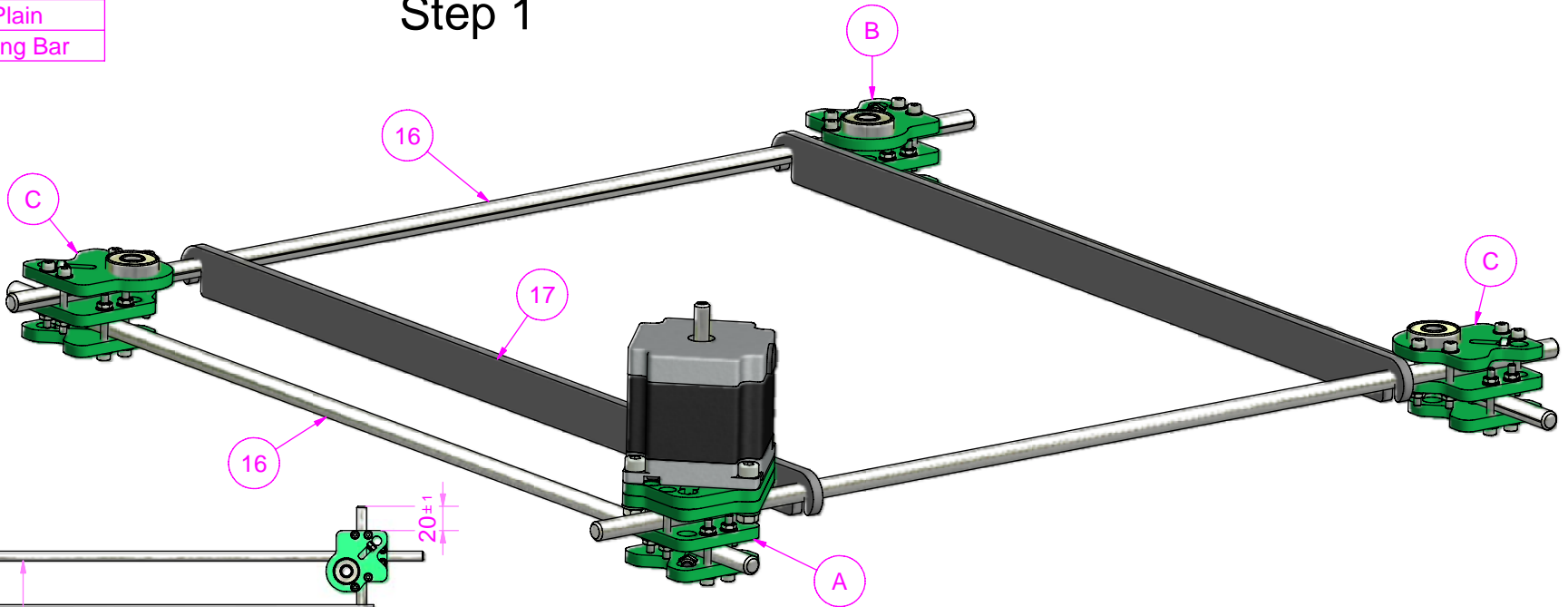



Base Frame inc Z Motor		
ITEM	QTY	PART NUMBER
A	1	Corner Z Motor
B	1	Corner Bttm L
C	2	Corner Bttm R
16	4	8Ø 500mm Plain
17	2	400mm Setting Bar

Step 1



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Parts List		
ITEM	QTY	PART NUMBER
D	3	Z Idler Rod
E	1	Z Drive Rod
16	4	8Ø 500mm Plain
18	4	Foot Setting Jig
Step 1	1	Cartesian Base Frame inc Z Motor

Step 2

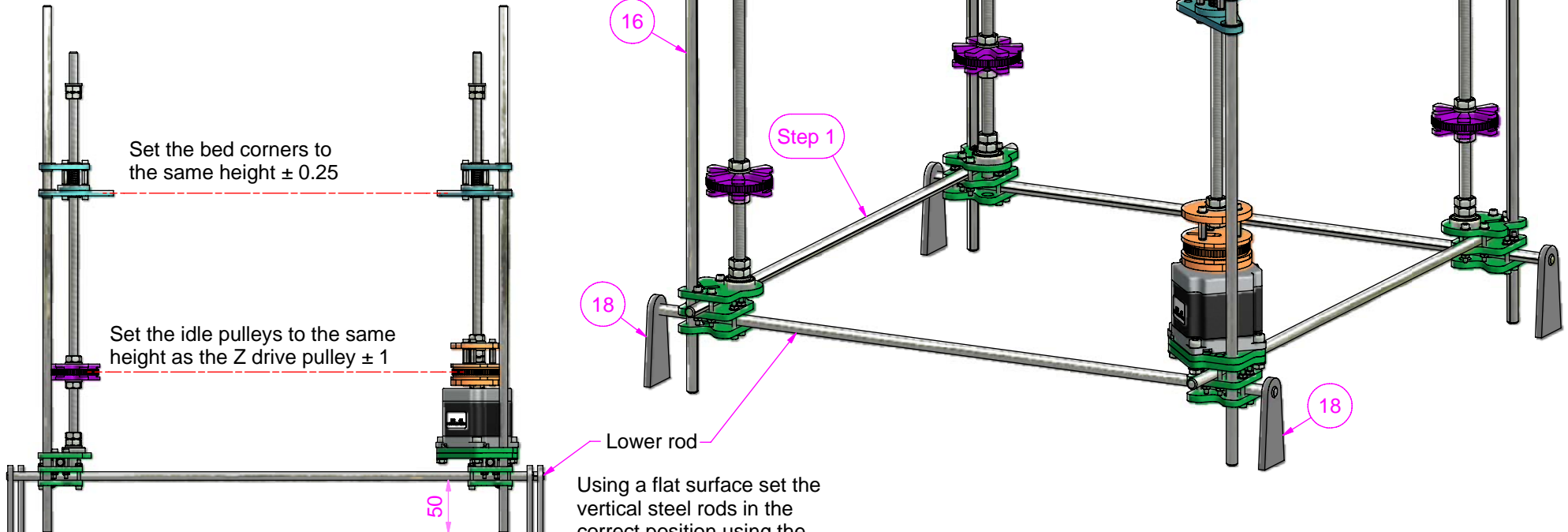
Set the vertical 8Ø slide bars first and lock into position with the corner block grub screws, then fit the Z idler rods check that the bed corners drive up and down the slide bars with virtually no force required to move them


Set the bed corners to the same height ± 0.25

Set the idle pulleys to the same height as the Z drive pulley ± 1

50

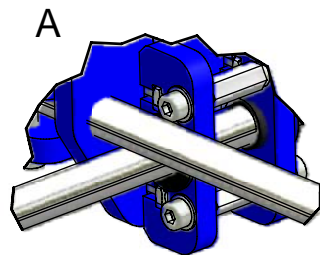
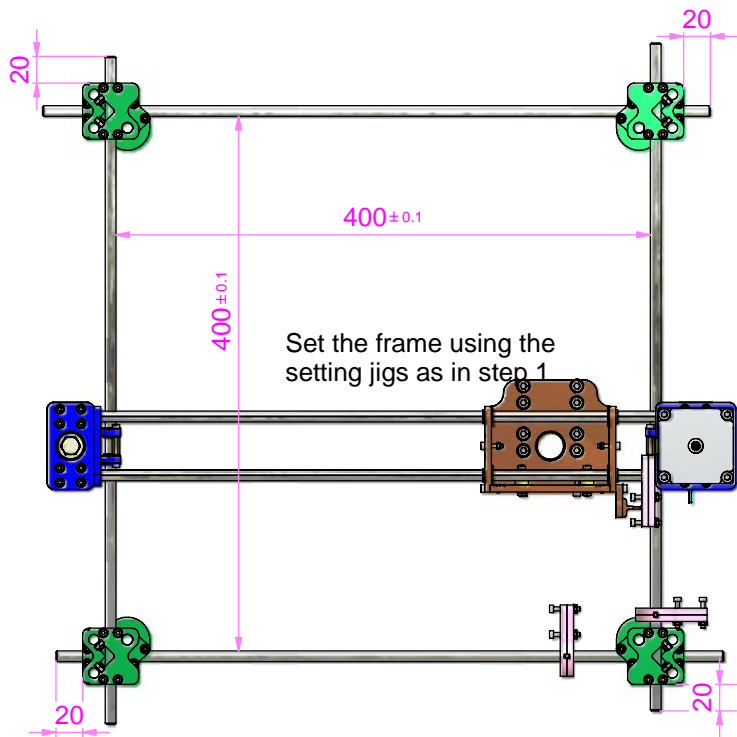
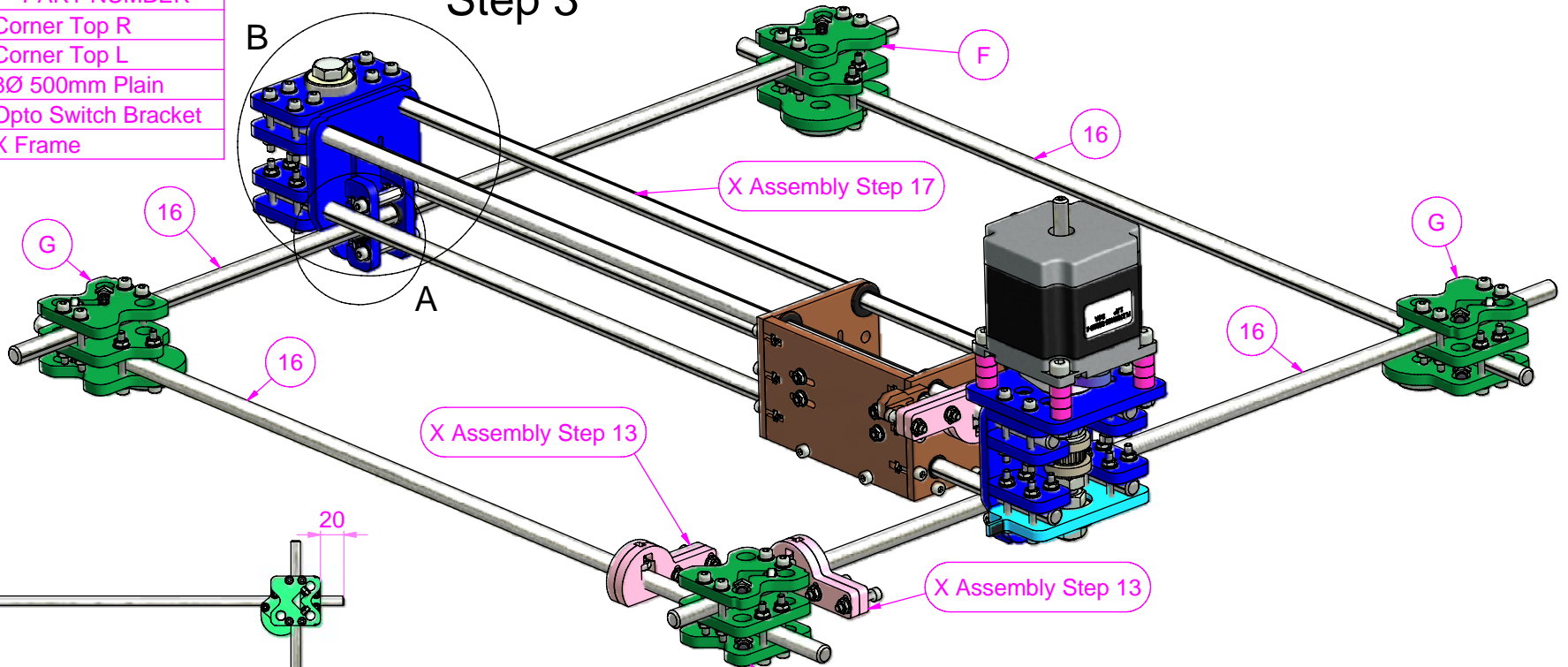
Lower rod
Using a flat surface set the vertical steel rods in the correct position using the foot setting jigs on the lower 2 of the 4 base frame steel rods



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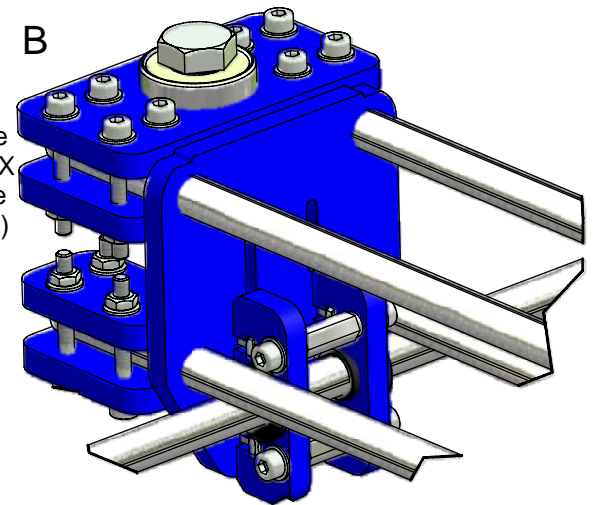
Top Frame		
ITEM	QTY	PART NUMBER
F	2	Corner Top R
G	2	Corner Top L
16	4	8Ø 500mm Plain
X Assembly Step 13	2	Opto Switch Bracket
X Assembly Step 17	1	X Frame

Step 3



Once the frame is set to 400 x 400 adjust the X frame slide adjusters (X Assembly step 11) so that X frame rails are in contact with the top frame. There should be no play at all between these rails but the bars must still slide easily against each other. Care in setting these rails is critical.

After setting the slide adjusters tighten the idle bearing plates onto the X rods make sure they are tight to the rod plate (42) but not putting any bending load on the top frame



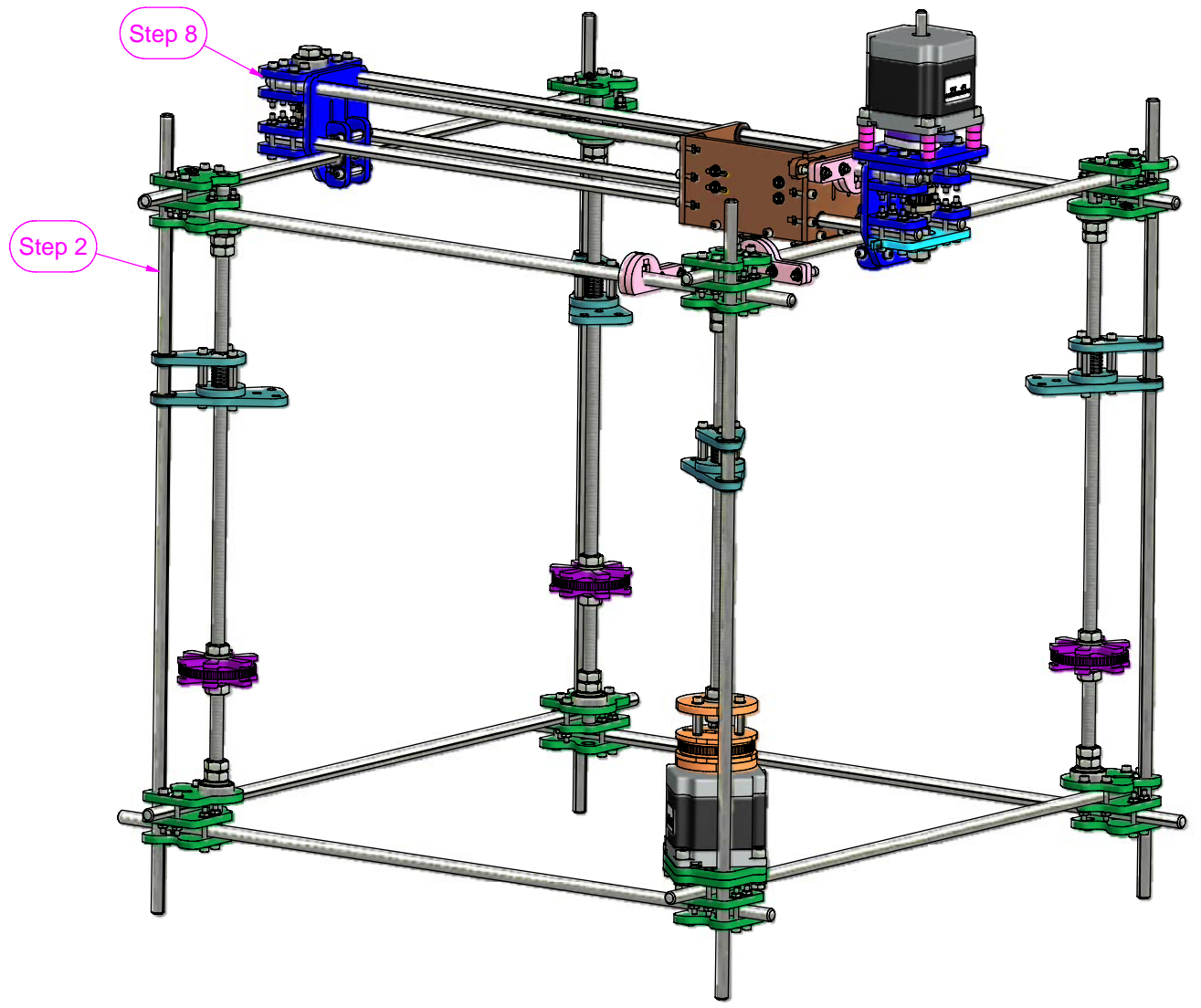
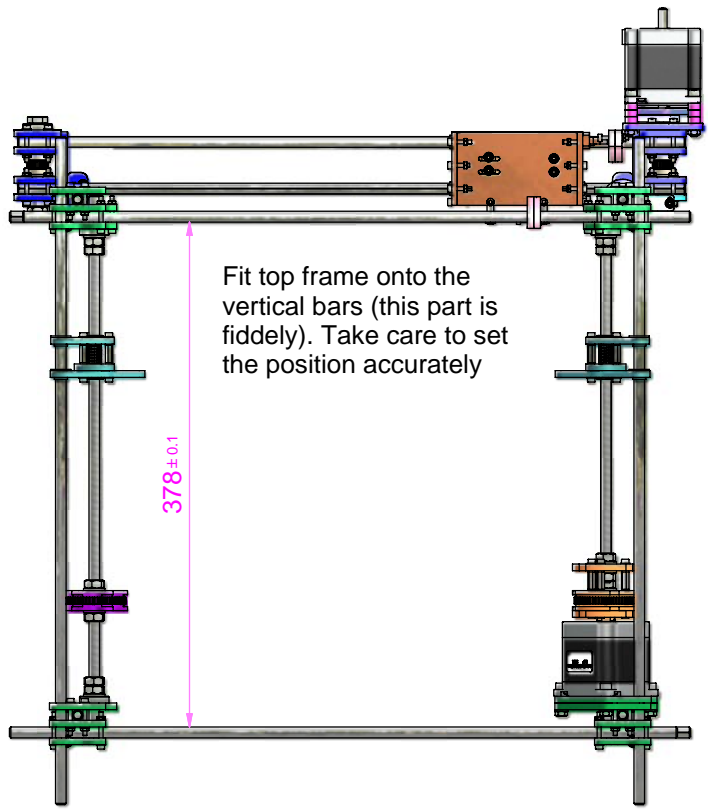
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Parts List		
ITEM	QTY	PART NUMBER
Step 2	1	Cartesian Base Frame & Verticals
Step 8	1	Cartesian Frame & X Axis

Step 4

D
C
B
A

D
C
B
A



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A

A

6

5

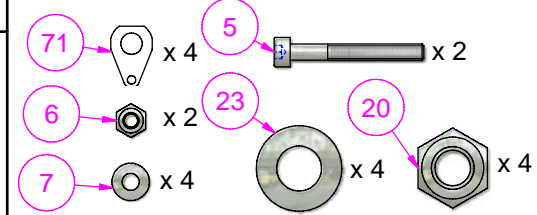
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3

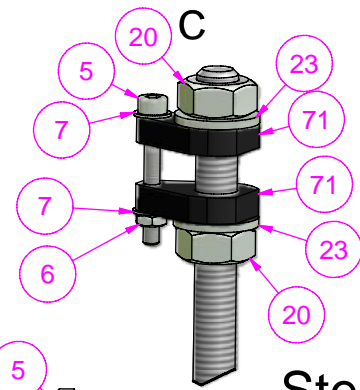
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1

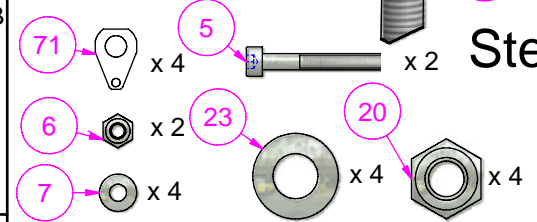
650mm Diagonal Tie 2 off		
ITEM	QTY	PART NUMBER
5	2	M3 x 25 Cap Head BZP
6	2	M3 Nut Full BZP.ipt
7	4	M3 Washer BZP
20	4	M8 Nut Full BZP
23	4	M8 Washer BZP
71	4	Diagonal Tie Plate Mk2
72	1	M8 650mm Threaded



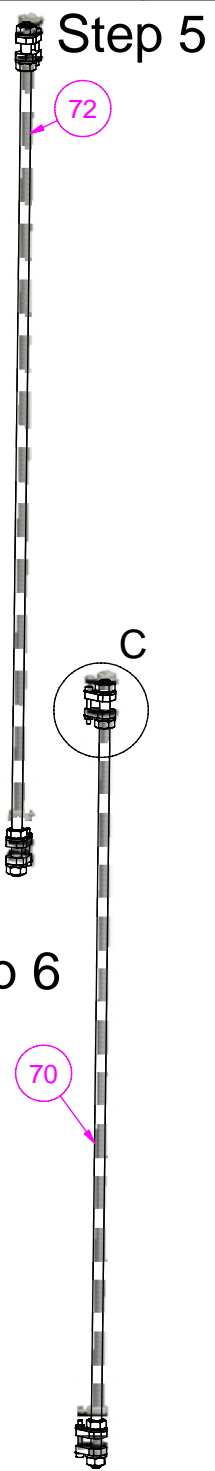
Loosely assemble the diagonal tie rods



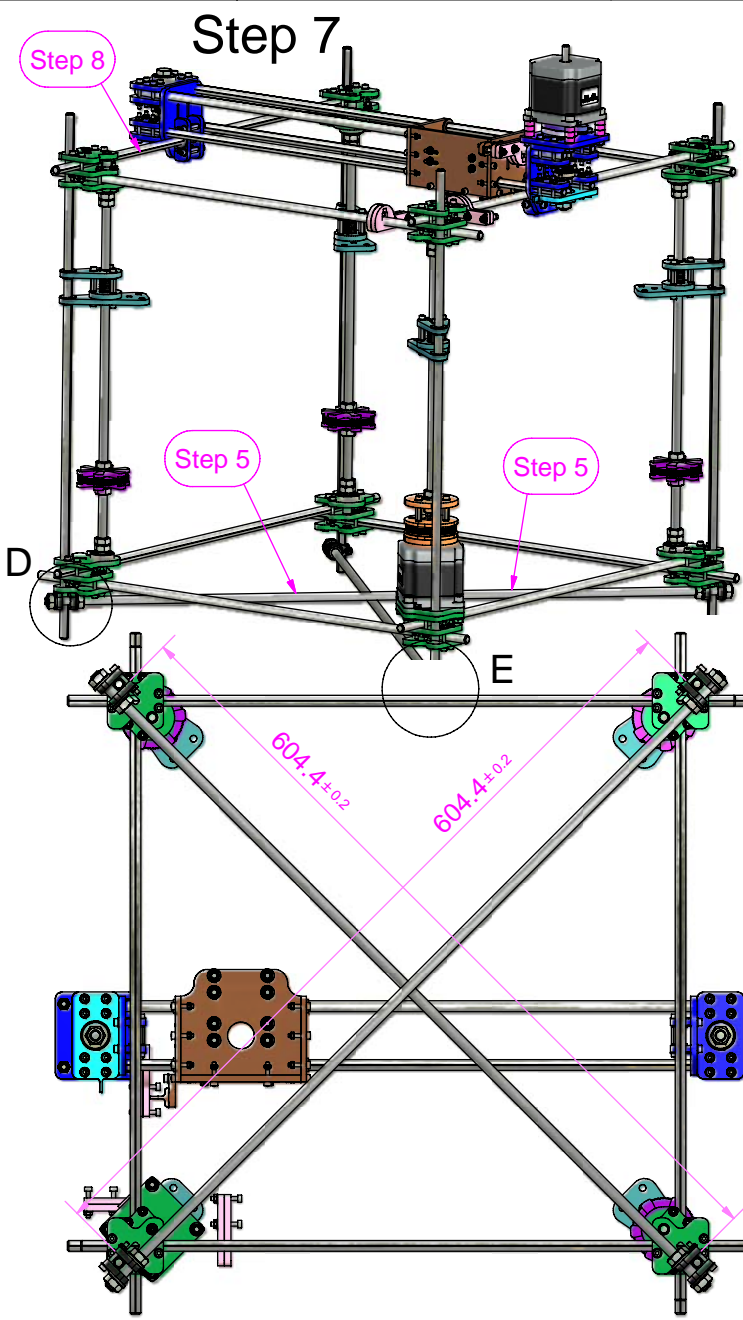
Step 6



600mm Diagonal Tie 8 off		
ITEM	QTY	PART NUMBER
5	2	M3 x 25 Cap Head BZP
6	2	M3 Nut Full BZP.ipt
7	4	M3 Washer BZP
20	4	M8 Nut Full BZP
23	4	M8 Washer BZP
70	1	M8 600mm Threaded
71	4	Diagonal Tie Plate Mk2



Step 5



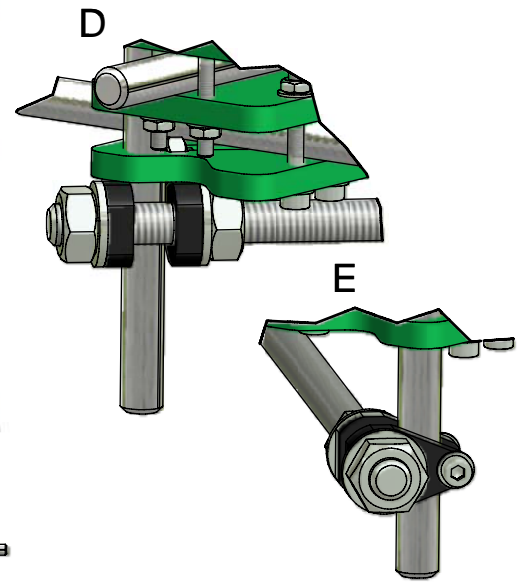
Step 7

Step 8

Step 5

Step 5

Parts List		
ITEM	QTY	PART NUMBER
Step 8	1	Cartesian Frame & X Axis
Step 5	2	Diagonal Tie 650mm



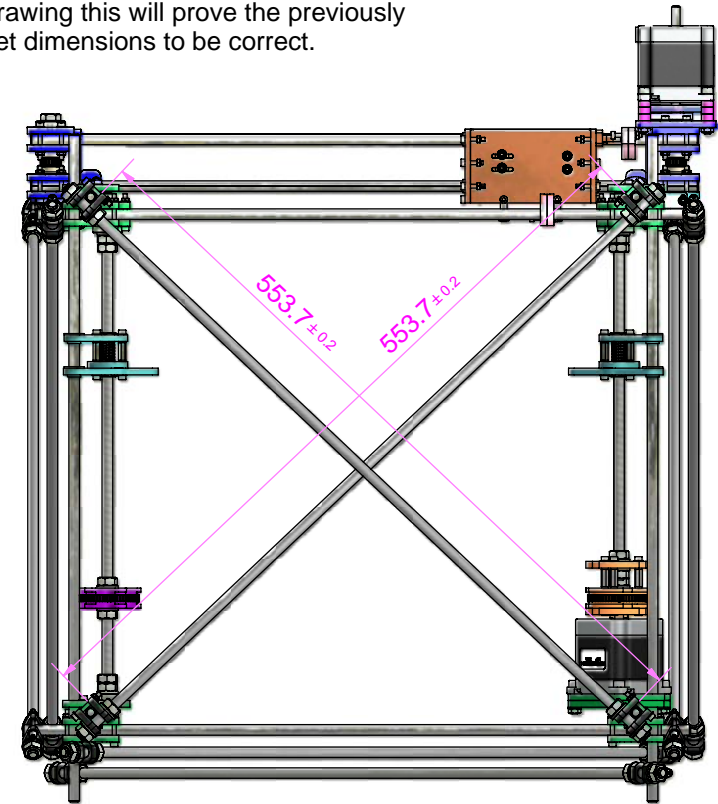
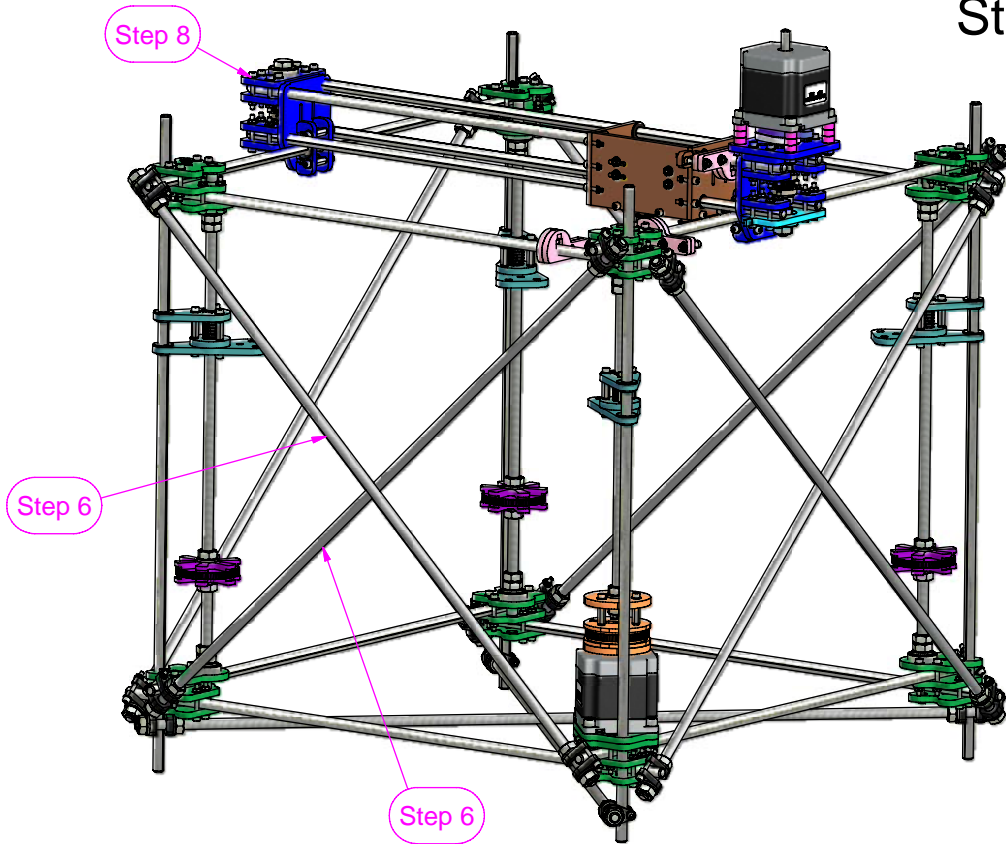
Set the diagonal tie rods such that they just touch in the middle with out creating a bend in each other. Once fitted adjust the length of each tie rod so they are equal to within ± 0.25 of each other. Try to achieve the dimensions shown on the drawing this will prove the previously set dimensions to be correct.


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Parts List		
ITEM	QTY	PART NUMBER
Step 8	1	Cartesian Frame & X Axis
Step 6	8	Diagonal Tie 600mm

Step 8

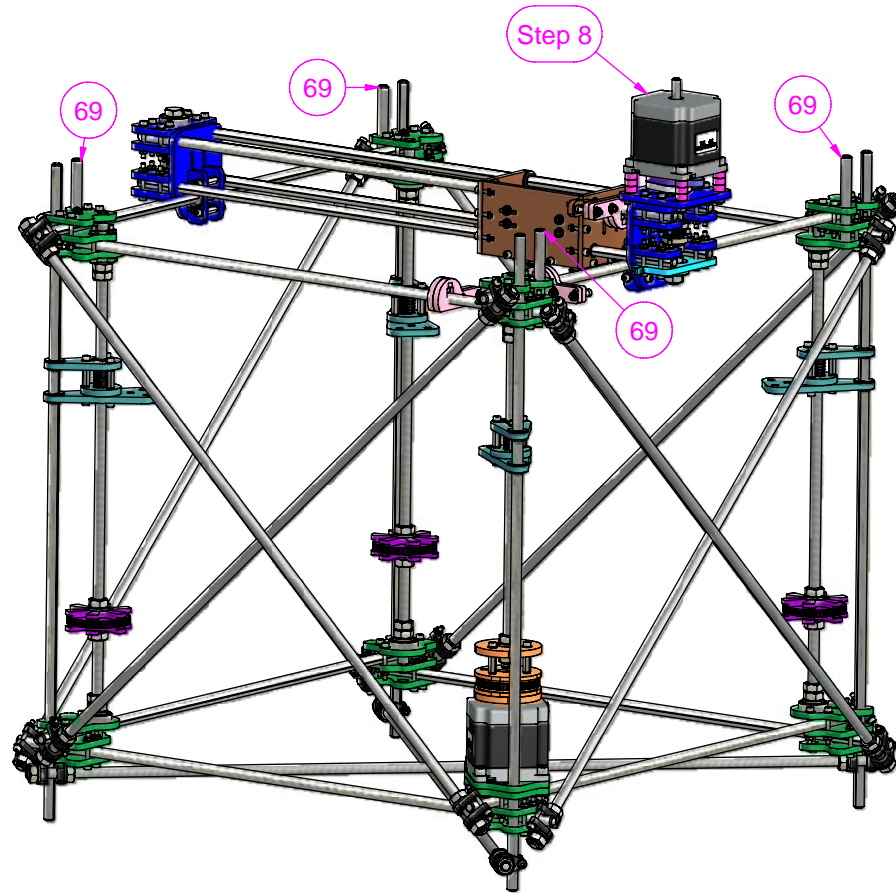
Set the diagonal tie rods such that they just touch in the middle with out creating a bend in each other. Once fitted adjust the length of each tie rod so they are equal to within ± 0.25 of each other on all 8 tie rods. Try to achieve the dimensions shown on the drawing this will prove the previously set dimensions to be correct.




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Parts List		
ITEM	QTY	PART NUMBER
69	4	8Ø 70mm Plain
Step 8	1	Cartesian Frame & X Axis

Step 9

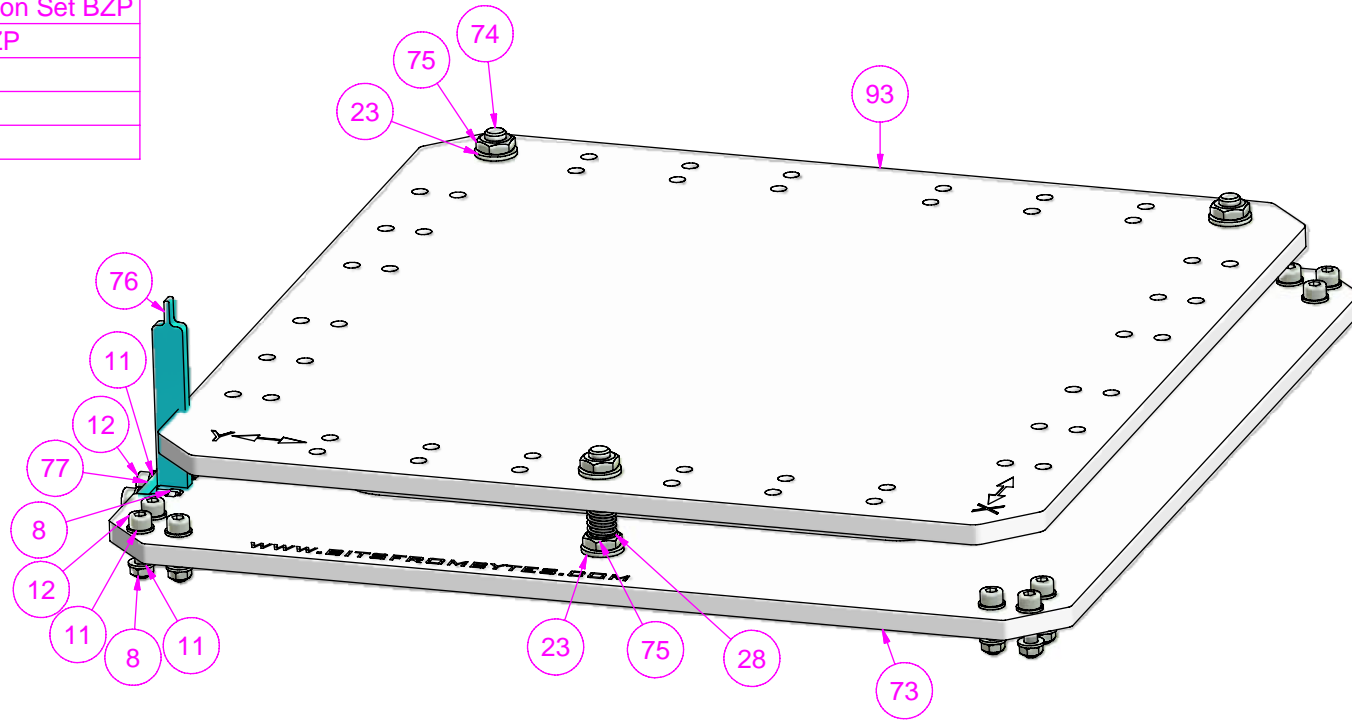



Set the 70mm bars level with the top of the vertical bars

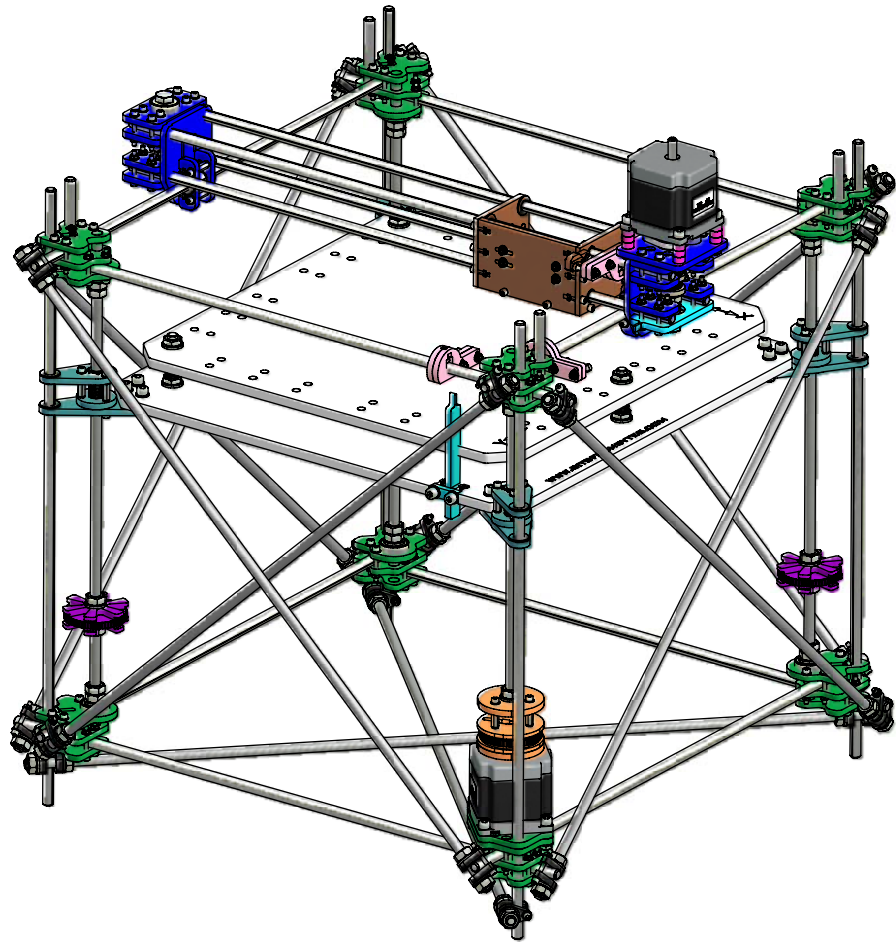
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Parts List		
ITEM	QTY	PART NUMBER
8	14	M5 Nut Full BZP
11	26	M5 Washer BZP
12	14	M5 x 20 Cap Head BZP
23	12	M8 Washer BZP
28	3	C2-4243-2M Spring
73	1	Bed Frame
74	3	M8 x 50 Hexagon Set BZP
75	6	M8 Nut Half BZP
76	1	Z Flag
77	1	Z Flag Clamp
93	1	Adjustable Bed

Step 10



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