



Parts List					
POS.	QTY.	PART NUMBER	DESCRIPTION	MATERIAL	LENGTH
1	2		Flexible Threaded Coupler 5-8 mm	Aluminum 6061	
2	4		Smooth Rod 12mm L=350	AISI SS 316 L	
3	2	03-0600	Z-Axis Support Bottom 2.0	PLA Plastic	
4	2	03-0601	Z-Axis Support Top 2.0	PLA Plastic	
5	1	03-0610	Alignment help	PLA Plastic	
6	2	17HS4401	Nema 17 42x42mm stepper motor		
7	8	ISO 7380-1 - M3 x 8	Hexagon Socket Button Head Screw	Stainless Steel	
8	8	ISO 7380-1 - M3 x 10	Hexagon Socket Button Head Screw	Stainless Steel	
9	34	ISO 7380-1 - M5 x 10	Hexagon Socket Button Head Screw	Stainless Steel	
10	2	T8-8	Lead screw nut	Brass, Soft Yellow	
11	2	T8x8	Lead Screw L=300	AISI SS 316 L	

Parts of the frame are used as visualisation.  
Pos 5 (it's displayed 4 times) you only need to print it once, unless you feel more comfortable then print it twice to use at the same time on the top and center to align 03-0600 and 03-0601.  
When aligning the parts, be sure to align them all from the same side.  
Position for alignment in the drawing is given from the front side of the printer.  
As in previous drawings, we used different bolts and nuts, galvanised steel versions.  
Remove the Cover for the bottom if you did not bolt it in place during the Frame assembly.

1. Take the right hand side of the printer.
2. Position 03-0600 and mark the holes on the outside of the frame, drill a hole with a 4mm drill
3. Use your M5 tap drill to cut the thread and fasten it with the M5x10mm screws.
4. Do the same with part 03-0601.
5. Take the left hand side of the printer.
6. Repeat step 2, 3 and 4 on the left hand side.
7. Mark all the holes on the inside of the printer.
8. Drill all holes with a 4mm drill bit
9. Use your M5 tap drill to cut the thread and fasten it with the M5x10mm screws.
10. Turn the frame 180 degrees over so the top of the printer is resting on your build surface.
11. Place the smooth rods (pos 2) all the way into 03-0601.
12. Slide the center Aluminium extrusion down so the smooth rods fit nice into 03-0600.
13. Measure the distance between the center and bottom (now top as the printer is up side down).  
The distance should be 85mm between the Aluminium extrusions.
14. Turn the frame 180 degrees back so the top is facing up again and remove the Smooth rods.
15. Slide the center Aluminium extrusion down
16. Mount the stepper motors in place with the connector facing inwards.
15. Mount the couplers onto the stepper motors.
16. Wait with the install of the T8x8 Lead Screw until the Heat bed assembly is placed.

Holes for the parts 02-0601 will be created with the release of the files for the electronic cabinet.  
Unless you want to make a second printer, save part 03-0610, else it is waste after parts 03-0600 and 03-0601 are bolted in place.

	Project	Open source		Dimensions
				In mm (U.N.O.)
	Client	3D Print Creations		Scale
				No Scale
Description	Internal Rev			Projection
	Created by	3D_PP	First issue	24-7-2018
The HUM Box V2 Z-axis assembly				For Assembly see 00-0000
Project no.		Chapter - Sheet nr.		Material
Drawing nr.: 3D Printer		03-0000		