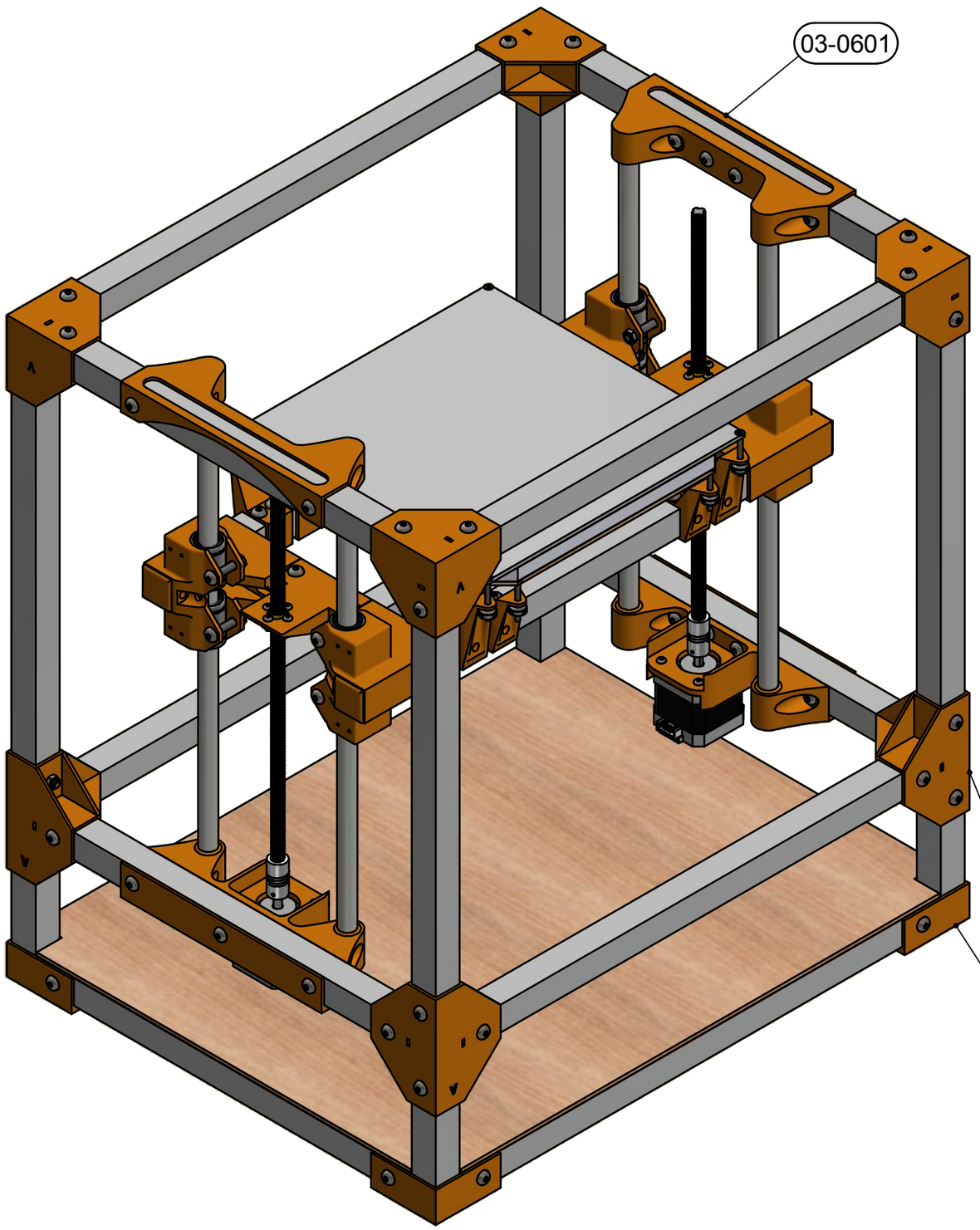

Parts List				
POS.	QTY.	PART NUMBER	DESCRIPTION	MATERIAL
1	1	01-0000	Heated bed assembly	
2	1	02-0000	Frame assembly	
3	2	03-0000	Z-axis assembly	

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. Slide the center bars with the stepper motors all the way down to release the smooth rods.
2. Remove the smooth rods from the brackets.
3. Turn the frame 180 dgs (Top facing down).
4. Take the Heated bed assy and also turn it 180 dgs, glass facing down.
   Be sure the text "ULTRBASE" will be facing to the right front when the frame is turned back later.
5. Slide the smooth rods into the LM12UU bearings.
6. Position the smooth rods back in part 03-0601, including the heated bed assy.
7. Let the Heated bed assy gently rest on part 03-0601.
8. Slide the center Aluminium extrusions back into place, locking the smooth rods in part 03-0600.
9. While the frame is facing top down, get the corner part for the electronics cabinet and take measurements if it fits on all 4 corners.
   Alternitive you can measure 85mm between the aluminium extrusions.
10. There should be roughly 1mm of free play between part 02-0601 and 02-0602.
11. Mark the holes of parts 02-0601 (start just with 1, when fastened in place, do the next).
12. Drill the holes for parts 02-0601 (all the way thru the aluminium extrusions and screw them in place with M5 bolts and nuts.
13. Do the next 02-0601 untill all 4 are done, be sure all are on the same distance from part 02-0602.
14. Test the Heated bed, it should move without fricting over the entire length of the smooth rods.

14a. If you removed the bottom cover, you should place it back now.
14b. While the frame is facing top down, remove the entire bottom frame part.
   This can be done as the feet are not bolted in place and are guides for the vertical extrusions.
14c. Place the bottom cover back between the vertical extrusions
14d. Place the bottom part of the frame back into place, continue with 15.

15. Turn the frame 90 degrees so the frame is on it's back side.
16. Screw the T8-8 nuts in the corresponding brackets, do not fully tighten the screws.
17. Drive the T8-8 rods thru the T8-8 nuts and lock them in the couplers.
18. Turn the frame back so it is resting again on the bottom.
19. With use of the T8-8 Rods, drive the Heated bed assy all the way down.
20. Fasten the T8-8 nuts in place.

	Project: Open source		Dimensions: In mm (U.N.O.)
	Client: 3D Print Creations		Scale: No Scale
	Internal Rev		Projection
	Created by: 3D_PP	First issue: 23-9-2018	
Description: The HUM Box V2 Heatbed on z-axis assy			For Assembly see
Project no.: Drawing nr.: 3D Printer		Chapter - Sheet nr.: 03-0001	Material

Prepared by 3D Print Creations Centre (Size A3) / Sheet 1 of 1

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