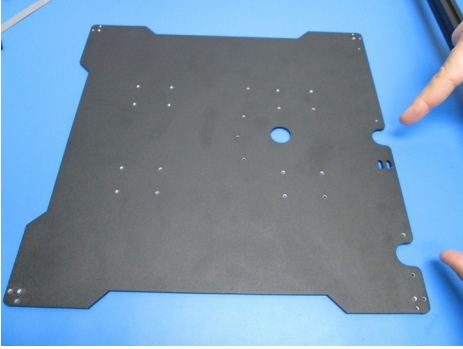




# Bed Assy Sub

## Gather Parts and Tools

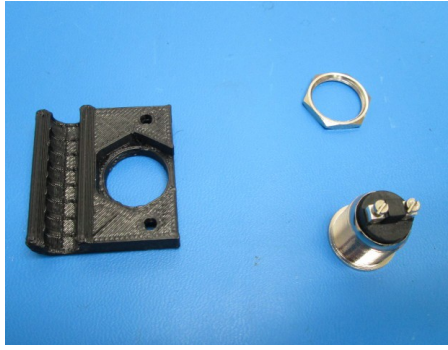
Step Pictures		Gather Parts and Tools
	5.5mm Nut driver 1.5 mm Hex driver 2.0mm Hex driver	<b>Parts</b> 1x- Z switch mount (PP-GP0216) 1x- Wiper Mount (PP-GP0231) and Wiper pad 4x- Bearings Holder (PP-GP0233) (with bearings installed) 4x- Bed corners (PP-GP0221) 1x- Y belt mount (PP-GP0222) 1x- Bed plate 4x- Bed standoffs 1x- Momentary switch and retention nut 2x- SPDT switches 1x- M3x16 FHCS 30x- M3x8 BHCS 4x- M2x10 SHCS 1x- M3x10 30x- M3 black washers 4x- M2 washers
	Tools	

## Y bed plate top side assembly

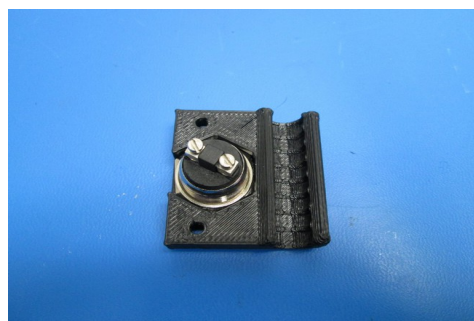
Step Pictures		Y bed plate top side assembly
		<p>Place the bed plate flat, be sure it indexed as shown.</p> <p>Loosely attach the bed corner and standoff with two (2) M3X8 BHCS and two (2) M3 Black washers to each of the four (4) bed corners to the plate. These will be tightened later when the bed is attached.</p> <p>Using two (2) M3X8 BHCS and two (2) M3 Black washers loosely attach the wiper mount to the plate as shown. These will be tightened later when the bed is installed.</p>
Plate orientation	Bed corner installation	
		
Wiper mount		

Y bed plate bottom side assembly

Step Pictures



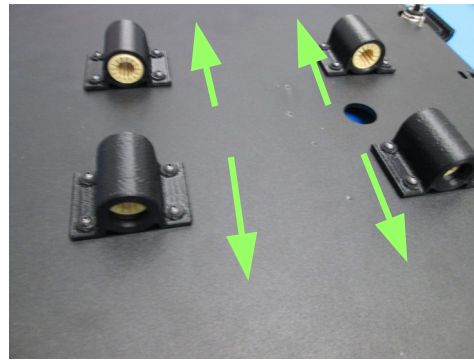
Z switch mount parts



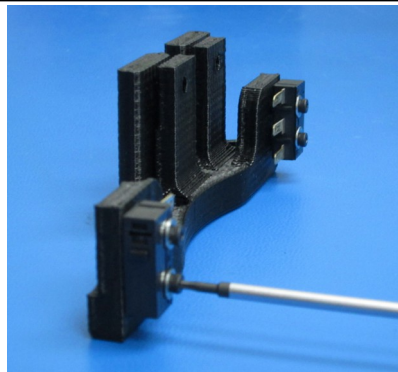
Z- Switch assembly



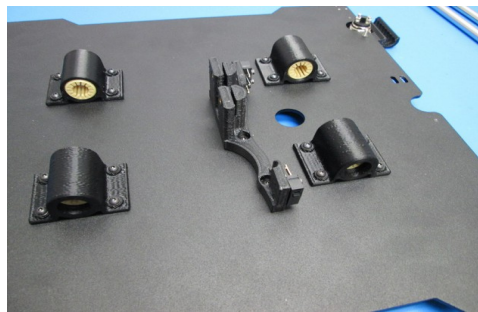
Z switch mounted



Secure Y bearings to plate with bearing flanges facing out



Install 2 SPDT switches to the Y Belt mount, see switch orientation



Install and secure Y end plate/ motor side (note orientation)

Y bed plate bottom side assembly

Flip the plate over;

Install the momentary switch into the Z mount switch, the switch should be free of movement

Correct the orientation of the two switch contacts to a perpendicular orientation to the cable pathway (seen to the right of the switch)

Loosely secure the Z switch mount to bed plate. Use one (1) stainless M3X16 FHCS towards the inside of the plate, one (1) M3X10 BHCS and one (1) M3 Black washer on the other side. These will be tightened later when the bed is installed.

Loosely secure the Y bearings to the assembly using sixteen (16) M3X8 BHCS and sixteen (16) M3 black washers

Install two (2) SPDT switches using two (2) M2x10 SHCS, secured to hand tight, and two (2) M2 washers onto each end of the Y belt mount with wiring terminals facing each other and the switch actuator away from the plate

Install the belt mount as shown using four (4) M3X8 BHCS, tightened to 3 in-lbs (~.35 N-m), and four (4) M3 Black washers making sure the long switch side is toward wiper mount side of the bed plate.