



# CEB Press: Structural Components Assembly

This guide explains how to install the primary and secondary arms, the feet, the legs, the brick-holder plate, and the dirt-keeper plate to the main frame. This is to be done after you have finished all of the steps in the fabrication section on the wiki.

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 **TOOLS:**

- Angle grinder (1)
- C-Clamps (1)
- MIG welder (1)
- Socket set and ratchet, or various wrenches (1)
- torch (1)
- Vise clamps (1)

 **PARTS:**

- 3/4"x1.5" bolt (16)

*Primary arms to frame: 4, secondary arms to primary: 4, dirt keeper plate to primary arms: 4, Brickholder plate to primary arms: 4*

- 3/4" nuts (17)

*Primary arms to frame: 4, secondary arms to primary: 4, dirt keeper plate to primary arms: 4, Brickholder plate to primary arms: 4*

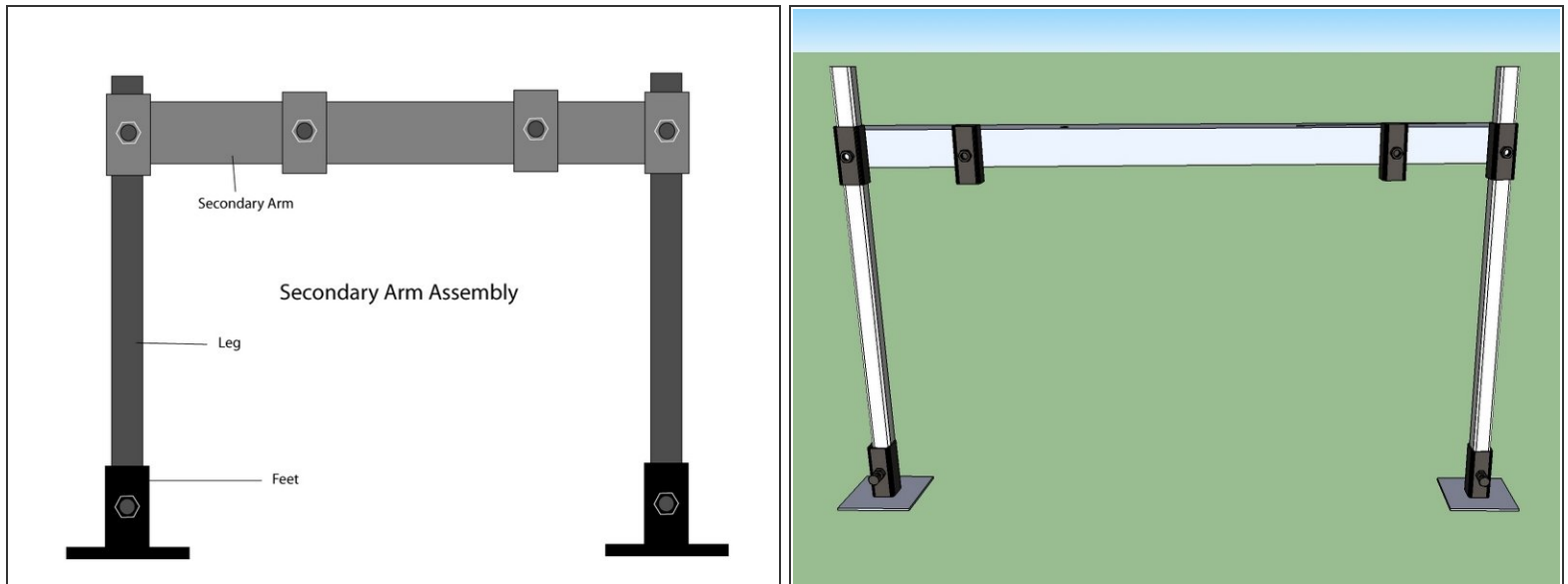
- 3/4" washers (16)

## Step 1 — Position the main frame



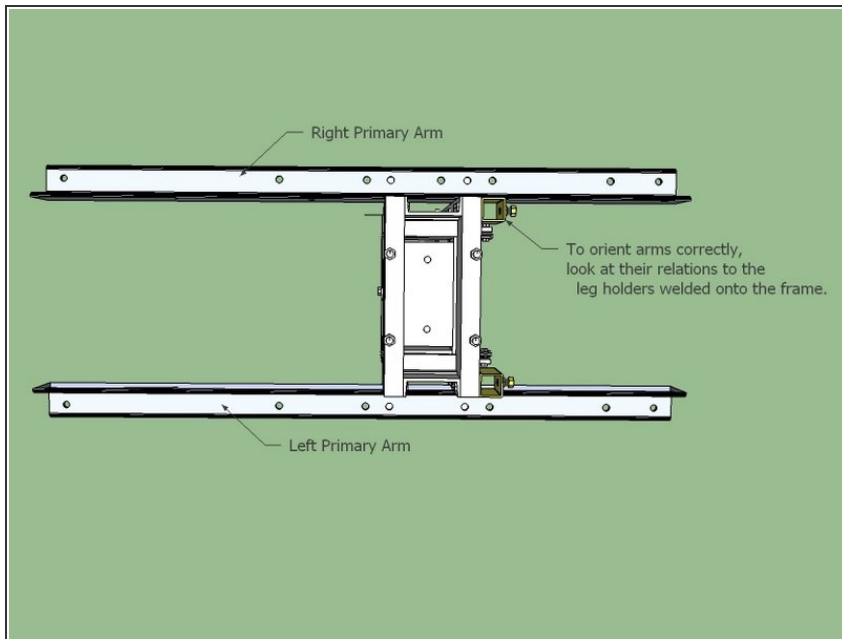
- Set the main frame somewhere on level ground where you have access to a welder and torch and where you have at least an 8' radius of empty space. The CEB takes up a lot of room!
- Set it so the cylinder pin is near the ground.

## Step 2 — Assemble the Secondary Arms



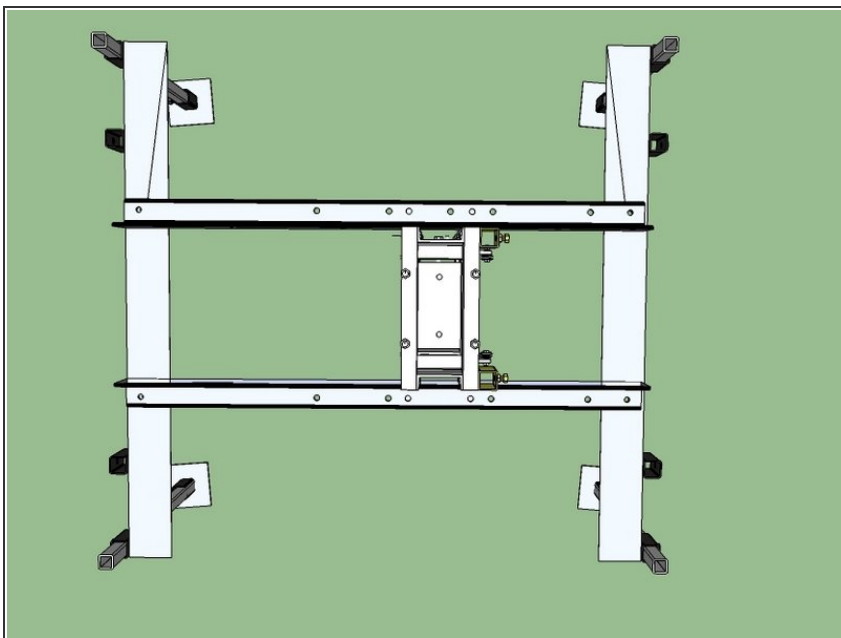
- Gather the secondary arms, the legs and the feet.
- Onto the end of each leg, tighten a foot to one of its ends. Get the bolt tight enough so it won't fall off.
- Insert one leg/foot into each of the outside leg holders on the secondary arms.
- Adjust the height so that the top of the secondary arms will be very close to the height at the bottom of the primary arms.
- Tighten the bolts in the leg holders so they are snug, but not too tight.

### Step 3 — Place the Primary Arms



- Clamp them on the drawer members on the frame so that they are in the proper orientation. See image.
- If the machine is going to tip over, have a friend move the assembled secondary arms to support it so it doesn't tip.

### Step 4 — Attach the secondary arms to the primary arms

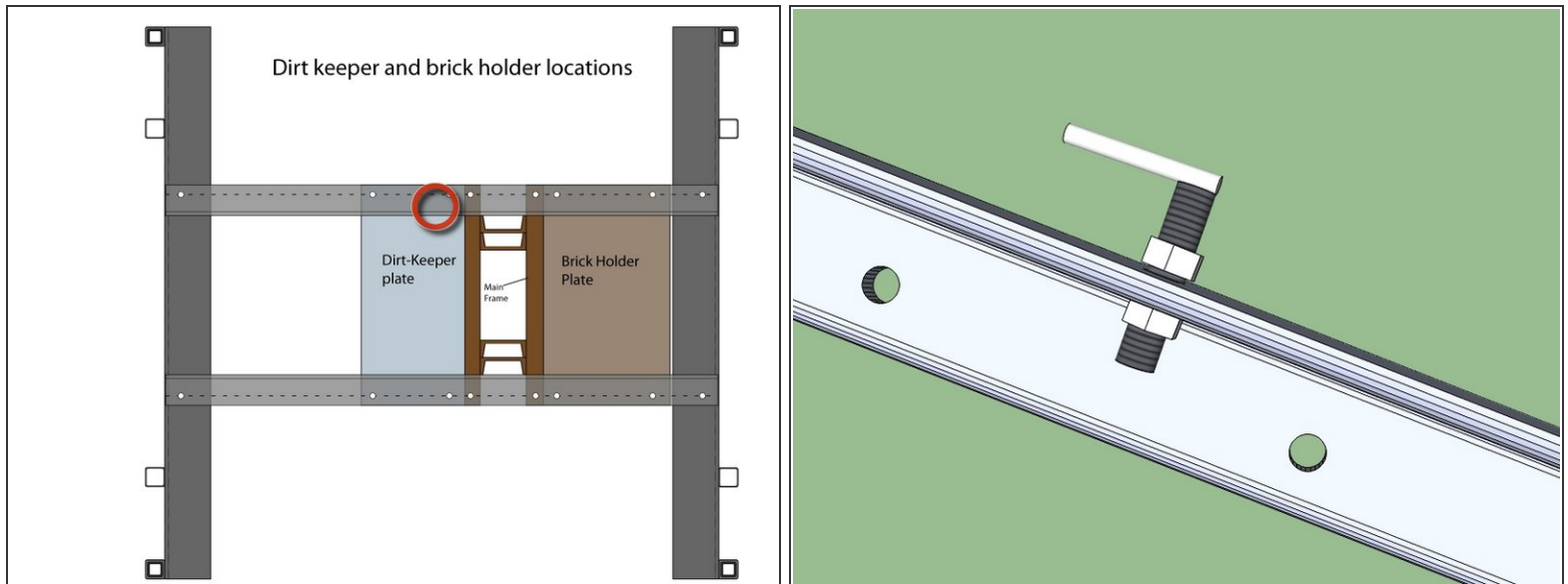


- Loosely bolt the 2 sets of arms together.
- You may need to loosen the clamps on the primary arms. This is OK.
- Make sure the arms are all square to each other.
- Tighten all bolts.
- Loosen the clamps attaching primary arms to the frame.
- Square the arms to the frame.

## Step 5 — Attach the primary arms to the frame



- Torch the holes in the frame through the holes in the primary arms.
- Make sure bolts go through all holes
- Remove the clamps and grind away any slag
- Bolt the primary arms to the frame.

**Step 6 — Install Brick Holder plate, Dirt keeper plate, and sensor holder**

- The plates go on the bottom side of the primary arms.
- If not all the bolts go through, torch away whatever is preventing it.
- Bolt them down so the bolt head is on the top. Tighten the nuts snug.
- Install the sensor on the right primary arm. Its location is circled in the diagram.