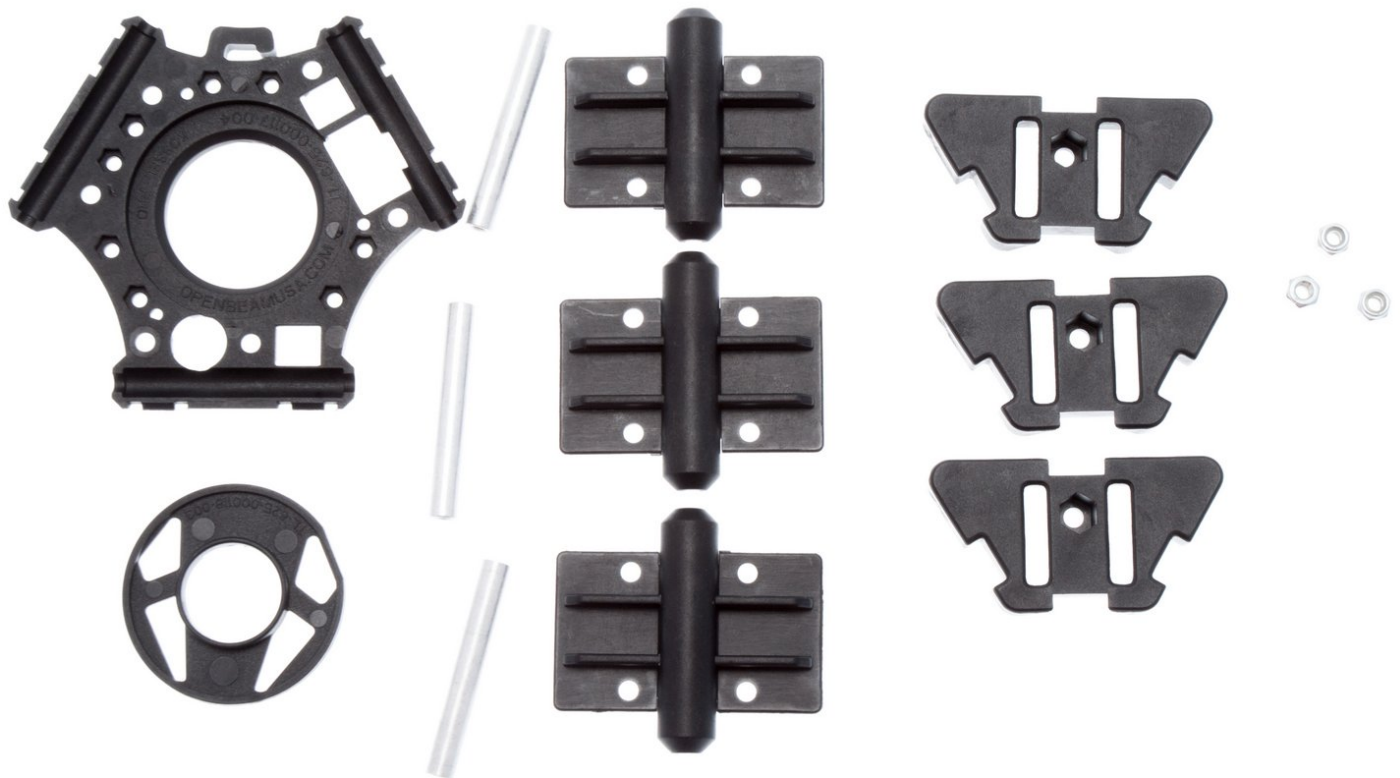


# ZT Automations, LLC

## 1) Pre Assembly Setup

Preparation of parts requiring time to set/cure.

Written By: Terence Tam



## INTRODUCTION

We'll start by prepping parts that require loctite/glue so that they have time to set.



### TOOLS:

- [Tube Of Loctite 410](#) (1)



### PARTS:

- [M3 Locknuts](#) (3)
- [Idler Sub Assembly Top/Bottom](#) (3)
- [M3 37mm Standoff](#) (3)
- [Ball Rail Carriage Top](#) (3)

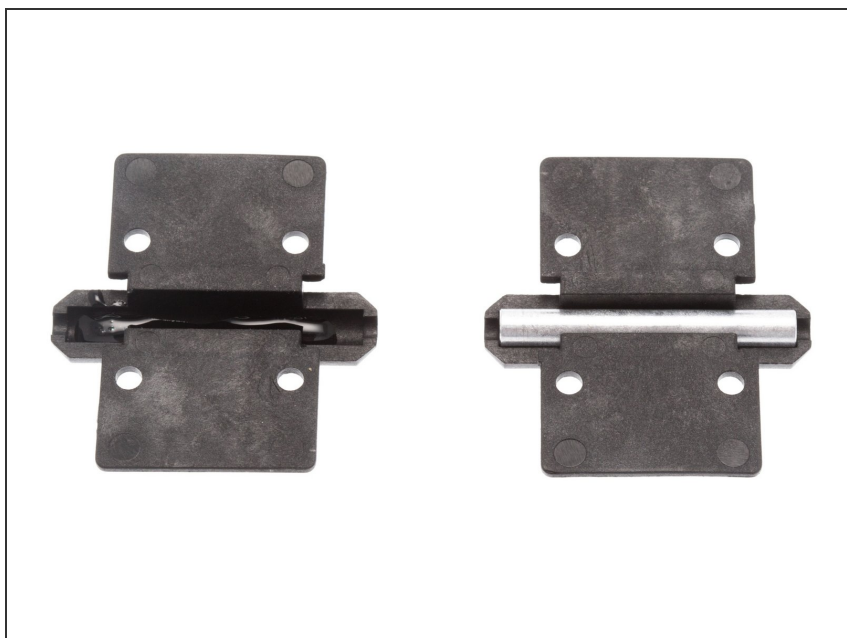
## Step 1 — Idler Block Prep



**⚠ Warning:** The Loctite 410 can be messy, we recommend covering your workspace with something disposable to protect it.

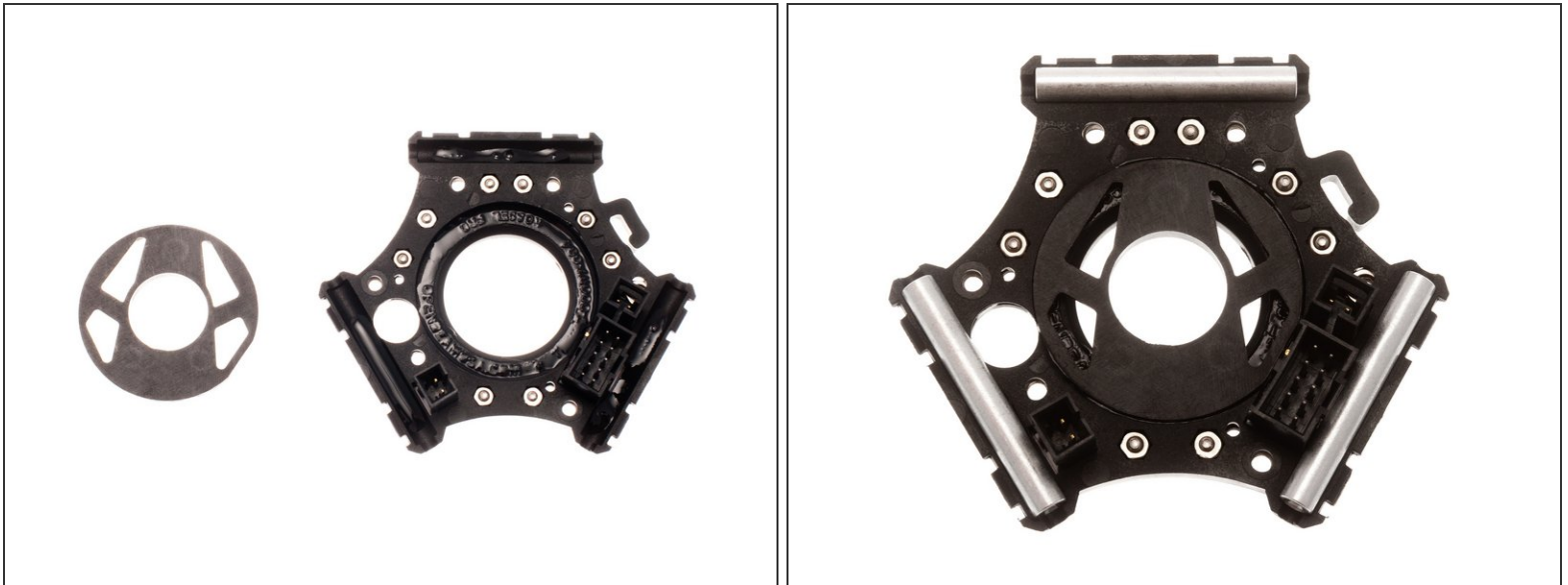
- Apply a thin layer of the Loctite 410 to the inside of the nut well.
- Gently slide an M3 Lock Nut into the nut well, ensuring that the locking side (the white ring) faces upward.
- Repeat for the remaining two Idler Subassemblies, for a total of three.

## Step 2 — Ball Rail Carriage Top Prep



- Apply a light line of Loctite 410 to the inside channel of the Ball Rail Carriage Top.
- Press an M3 37mm Standoff into the Loctite.
- Repeat for the two remaining Ball Rail Carriage Top, for a total of three.

### Step 3 — End Effector Prep



- Apply a thin line of Loctite 410 into each channel of the End Effector Bottom, and along the inside ring.
  - Press the End Effector Interior Duct into the center, paying careful attention to its alignment.
  - Press M3 37mm Standoffs into each channel.
- Set completed parts aside to cure.