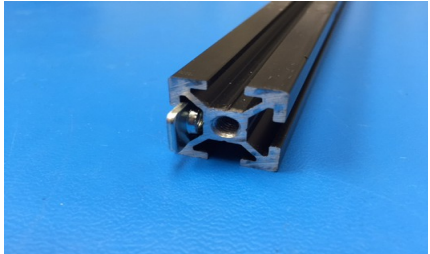
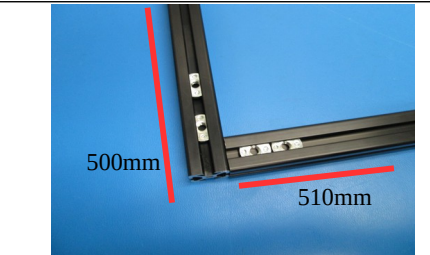


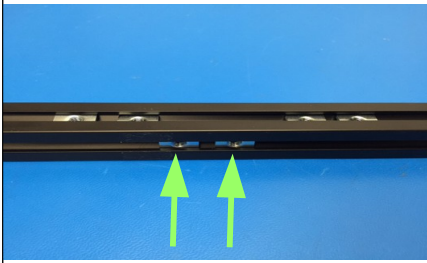
LulzBot TAZ 6.0 Frame

Step Pictures		Gather Tools and Parts
3mm Hex driver Squaring fixter		4x- 500mm Aluminum Extrusion, M5 threaded one end 4x- 510mm Aluminum Extrusion, ends not threaded 41x- M5 T-Nut 32x- M5x10 BHCS 32x- M5 Washer, Black 8x- Corner gussets
Gather tools		

LulzBot TAZ 6.0 Frame

Step Pictures		Front Frame assembly
		Install four (4) T-Nuts into one side of a 500mm aluminum strut, position the T-Nuts so there are two (2) at each end of the strut; repeat for a second 500mm strut
T-Nut installation orientation	500mm threaded end alignment	Install four (4) T-Nuts into one side of a 510mm aluminum strut, position the T-Nuts so there are two (2) at each end of the strut; repeat for a second 510mm strut
		Place the four (4) struts with the T-Nut side up
500mm/ 510mm frame alignment (arrows show Tnuts)	Four (4) T -Nuts per corner, Top slot	Arrange each of the 500mm struts parallel to each other and with their threaded ends at the same end oriented toward yourself
		Place each of the 510mm struts between the 500mm struts so the 510mm struts align with the side and end of the 500mm strut (T-Nut sides should still be up)
Additional T-Nuts on Top slot of the bottom extrusion	500mm/ 510mm frame alignment	Insert two (2) T-Nuts into the inside slot of the bottom 510mm strut, these will be used later in the assembly.
		Place a corner gusset at each of the strut intersections; Loosely secure each gusset with (4) M5X10 BHCS and (4) M5 black washer.
		Place one corner joint into a known square location, such as a squaring table; ensure the corners are square and the ends are flush; Secure each of the gusset screws are tightened to 4 ft-lbs (5.4NM); repeat this for each corner.

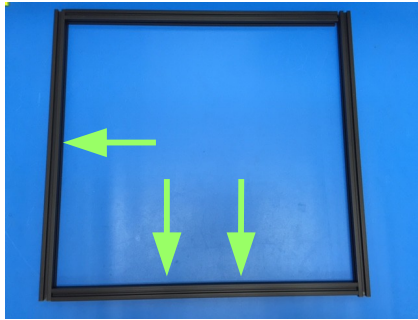
Step Pictures



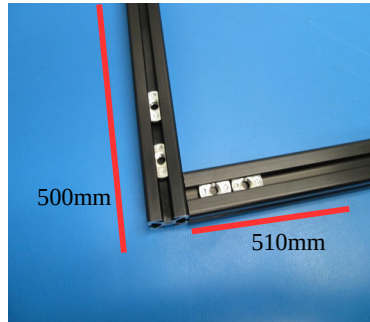
Back frame- Additional T-Nuts, Inside slot, right side



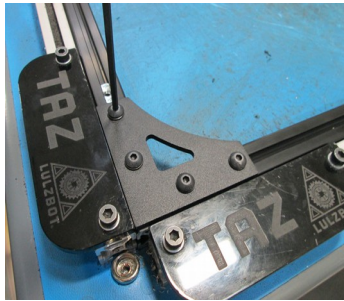
Back frame- Additional T-Nut, Top slot, left side



500mm/ 510mm frame alignment



Back frame- Additional T-Nut, Top slot, left side



500mm/ 510mm frame alignment

Back Frame assembly

Install four (4) T-Nuts into one side of a 500mm aluminum strut, position the T-Nuts so there are two (2) at each end of the strut; repeat for a second 500mm strut

Install four (4) T-Nuts into one side of a 510mm aluminum strut, position the T-Nuts so there are two (2) at each end of the strut; repeat for a second 510mm strut

Place the four (4) struts with the T-Nut side up

Arrange each of the 500mm struts parallel to each other and with their threaded ends at the same end oriented toward yourself

Place each of the 510mm struts between the 500mm struts so the 510mm struts align with the side and end of the 500mm strut (T-Nut sides should still be up)

Insert two (2) T-Nuts into the inside slot of the bottom 510mm strut, these will be used later in the assembly.

Place a corner gusset at each of the strut intersections; **Loosely secure each gusset** with (4) M5X10 BHCS and (4) M5 black washer.

Place one corner joint into a known square location, such as a squaring table; ensure the corners are square and the ends are flush; Secure each of the gusset screws are tightened to 4 ft-lbs (5.4NM); repeat this for each corner.