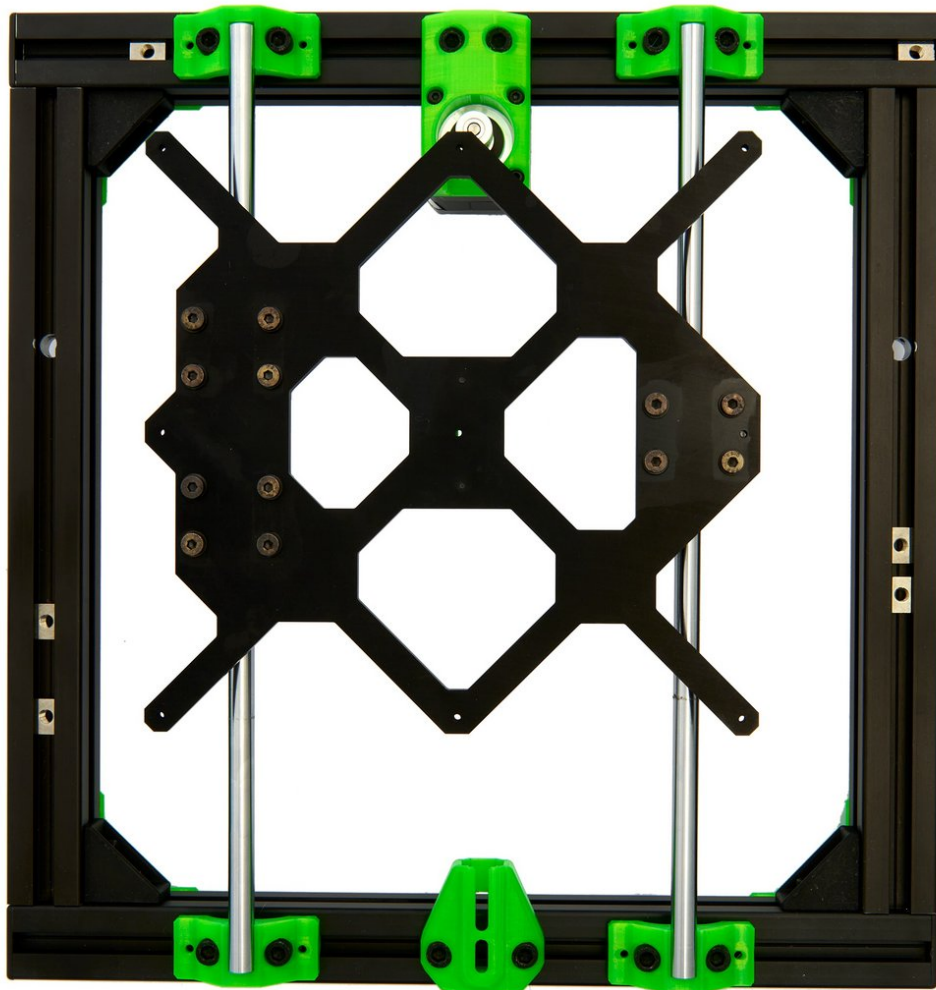


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03.1. Assembly and Installation of the Heatbed Carriage for MK52-Blocks

Written By: Katja Aller

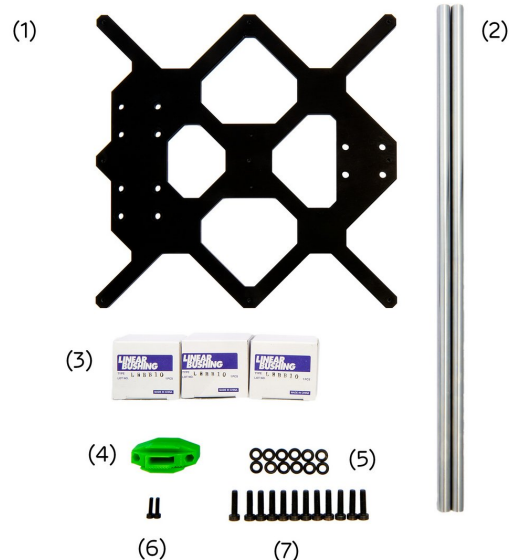


Step 1 — Required Tools



- (1) [2.5x100mm Hexagon Ballpoint Screwdriver](#)
- (2) [3.0x100mm Hexagon Ballpoint Screwdriver](#)
- (3) [5.0x100mm Hexagon Ballpoint Screwdriver](#)
- (4) [Synco Lube](#)
- (5) Injector
- (6) 10mm y-Alignment Tool

Step 2 — Assembling the Parts



- (1) [y-Carriage for Heated Bed MK52 with LHBB10](#)
- (2) [2x y-Rods 360mm](#)
- (3) [3x LHBB10 Bushings with Pillow Block](#)
- (4) y-Belt Holder
- (5) [12x M5 Washer](#)
- (6) [2x M3x12mm Hexagon Socket Head Cap Screws](#)
- (7) [12x M5x18mm Hexagon Socket Head Cap Screws](#)

Step 3 — Greasing the LHBB10 Bearings



- Open the Super Lube tube and screw the supplied injector onto it.
- Place the LHBB10 bushing on the injector and spread the grease inside.
- ⓘ The bearing is sufficiently greased when the grease oozes out at the ends of the bushing.
- Repeat these steps for the other two LHBB10 bushings.

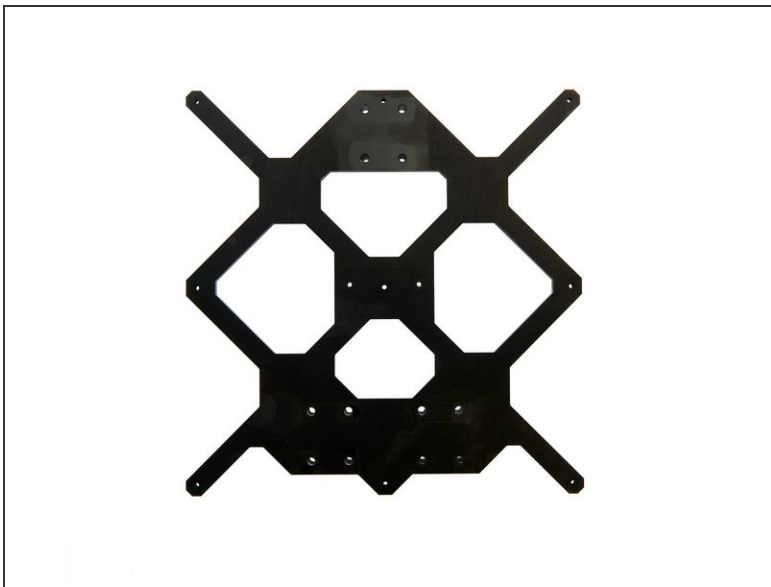
Step 4 — Installing the LHBB10 Bushings (1 / 2)



- Position the three greased bushings under the holes in the y-slide.

⚠ Make sure that the side of the y-slide is facing down with the chamfer and facing up with the edge.

Step 5 — Installing the LHBB10 Bushings (2 / 2)

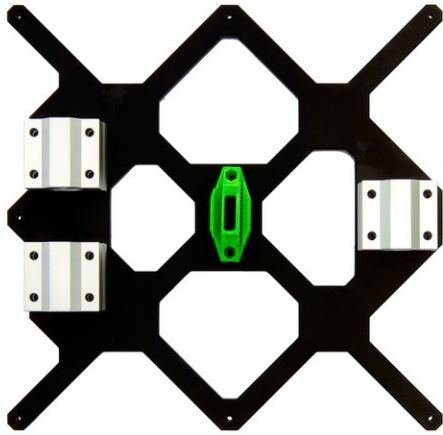


- Use **4x M5 Washers** and **4x M5x18mm Head Cap Screws** to loosely attach the LHBB10 ball bearings to the y-carriage.

ⓘ The bushings should still be easy to move.

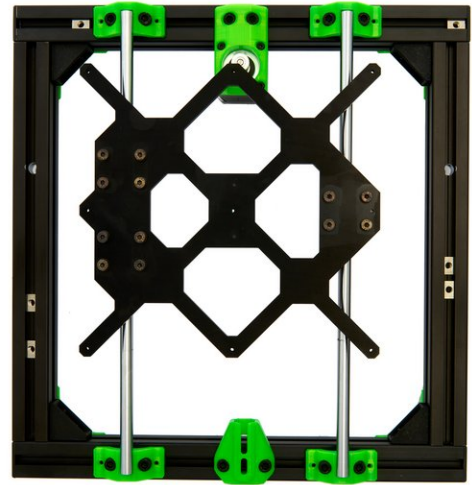
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Step 6 — Installing the y-belt holder



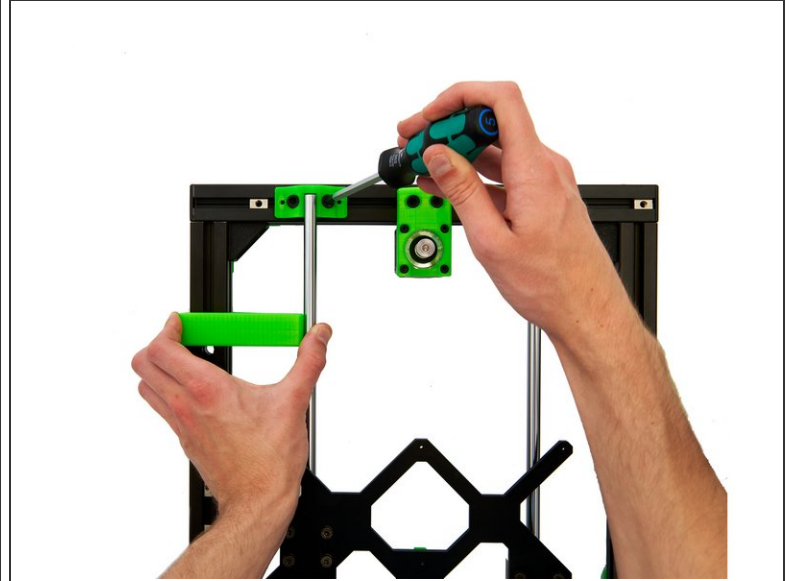
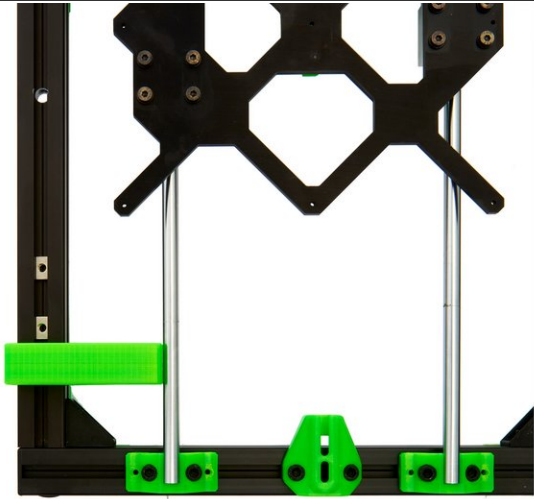
- Place the y-belt holder on the y-carriage as shown in Fig. 1.
⚠ Make sure that the toothed side of the y-belt holder points to the side with 1 ball bearing.
- Screw on the y-belt holder from below with **2x M3x12mm socket head cap screws** .

Step 7 — Installation of the y-carriage for LHBB10 (1 / 2)



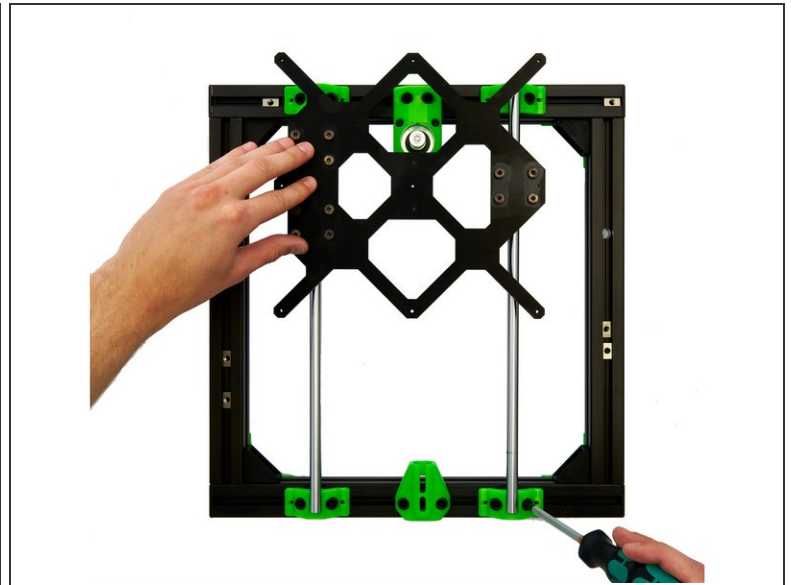
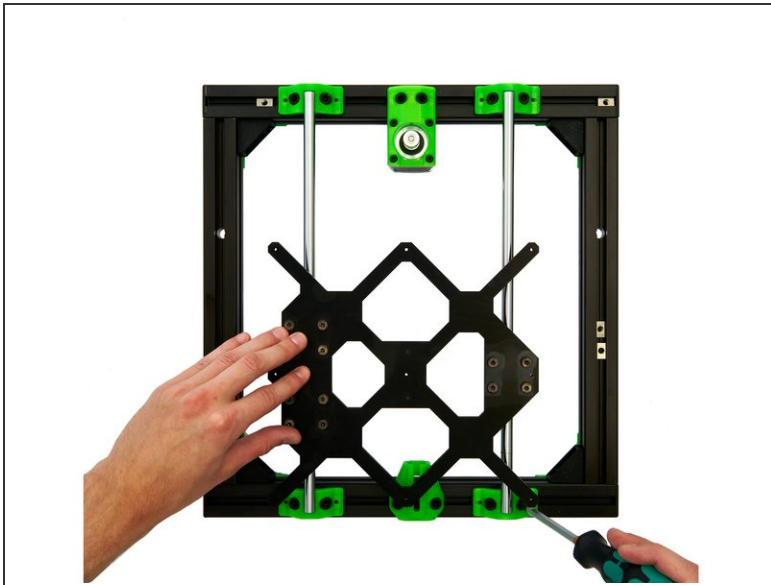
- Carefully slide the 2x y-rods through the three LHBB10 ball bearings and place them on the y-rod holders.
- ⚠ Make sure that the side of the y carriage with the two ball bearings is on the left side of the frame.**
- When the y-carriage is correctly aligned, press the rods into the four y-rod holders.

Step 8 — Alignment of the y-carriage (1 / 3)



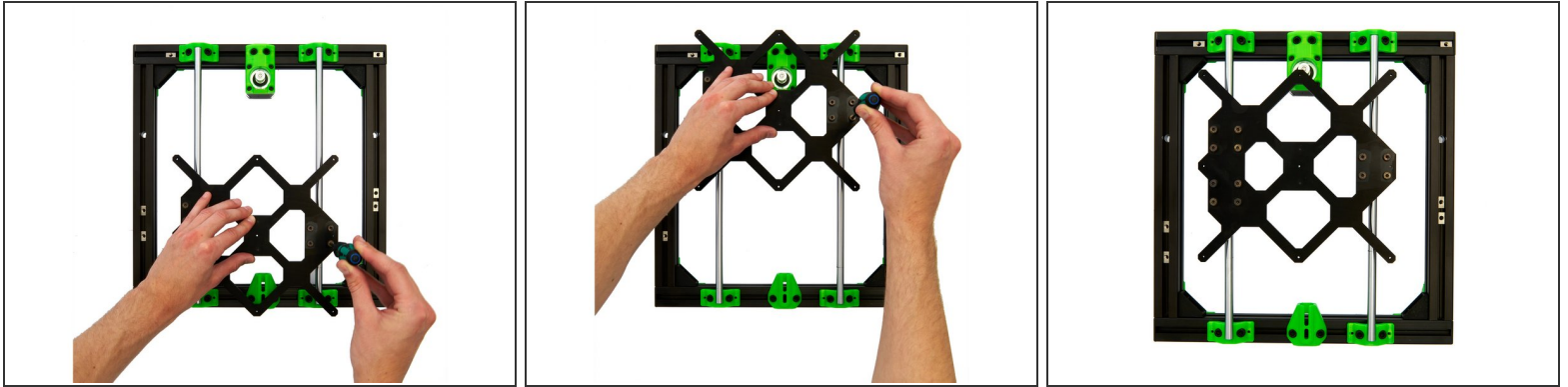
- Now place the 10mm y-calibration tool at the front of the left y-axis of the frame and press the rod against it.
- Then place the tool at the back on the left y-axis and press the bar against it here as well.
- Once you have correctly aligned the rod, fasten the **4x M6x12mm socket head cap screws** in the y-rod holders on the left front and left rear.

Step 9 — Alignment of the y-carriage (2 / 3)



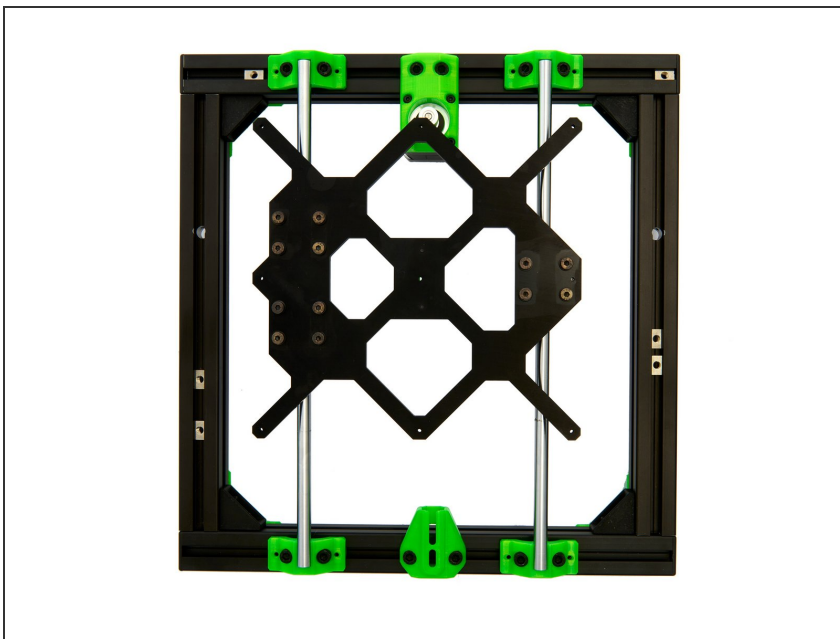
- Then move the y carriage to the very front and fasten the **2x M6x12mm socket head cap screws** in the y rod holder on the right front.
- Move the y carriage to the very rear and fasten the **2x M6x12mm socket head cap screws** in the y-rod holder at the right rear.

Step 10 — Alignment of the y-carriage (3 / 3)



- Move the y carriage back and forth. While doing so, gradually tighten the **12x M5x18mm socket head cap screws** on the LHBB10 ball bearings.
- ⓘ Keep moving the carriage back and forth to make sure it can move freely.
- ⓘ If the y-slide runs a bit out of round, both loosening and tightening the screws on the LHBB10 ball bearings several times and realigning the rods can help.

Step 11



- ⓘ The heating bed slide for MK52 block is now completely installed.
- ⓘ Continue with manual [04. Installation of the y-Belt](#).