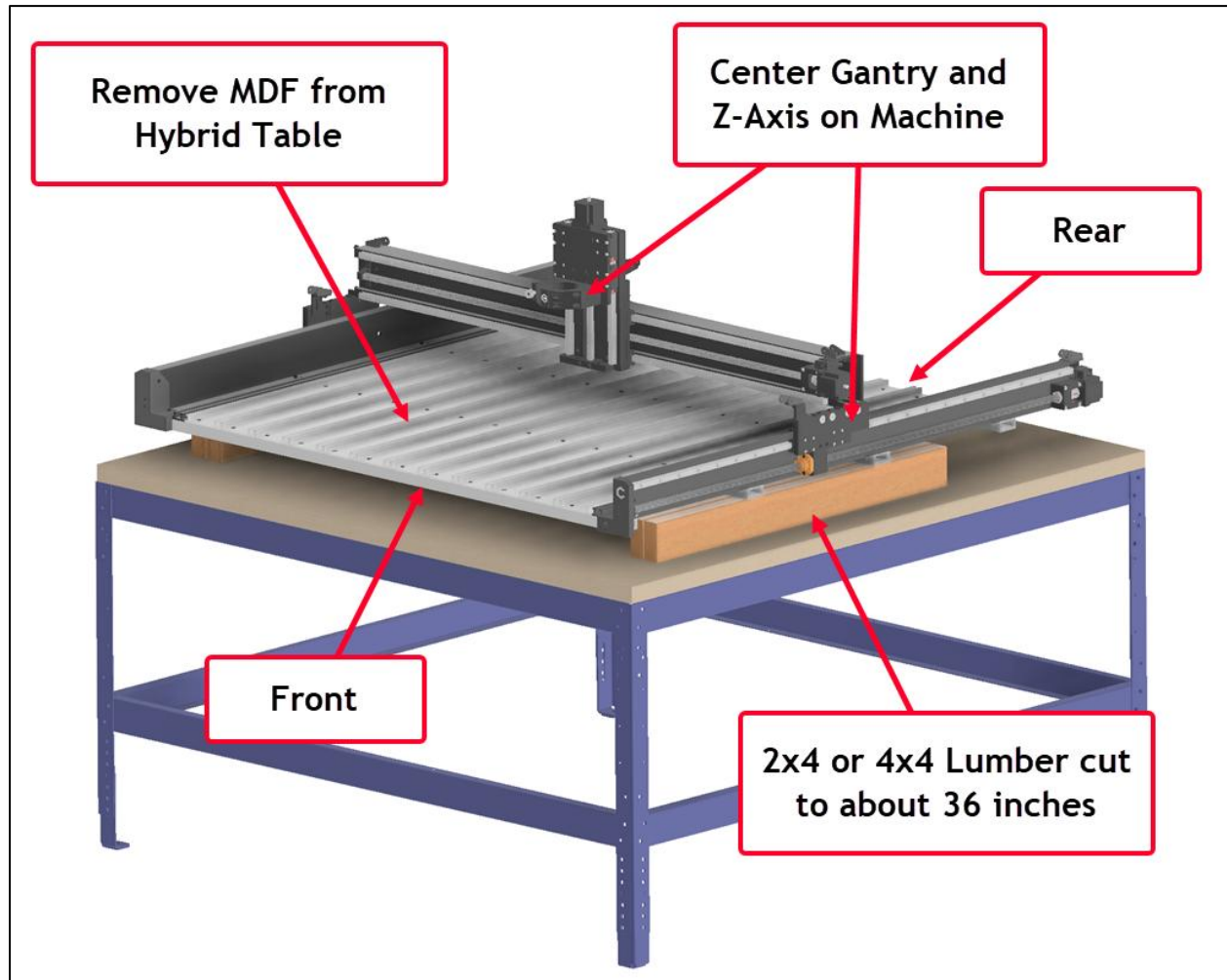
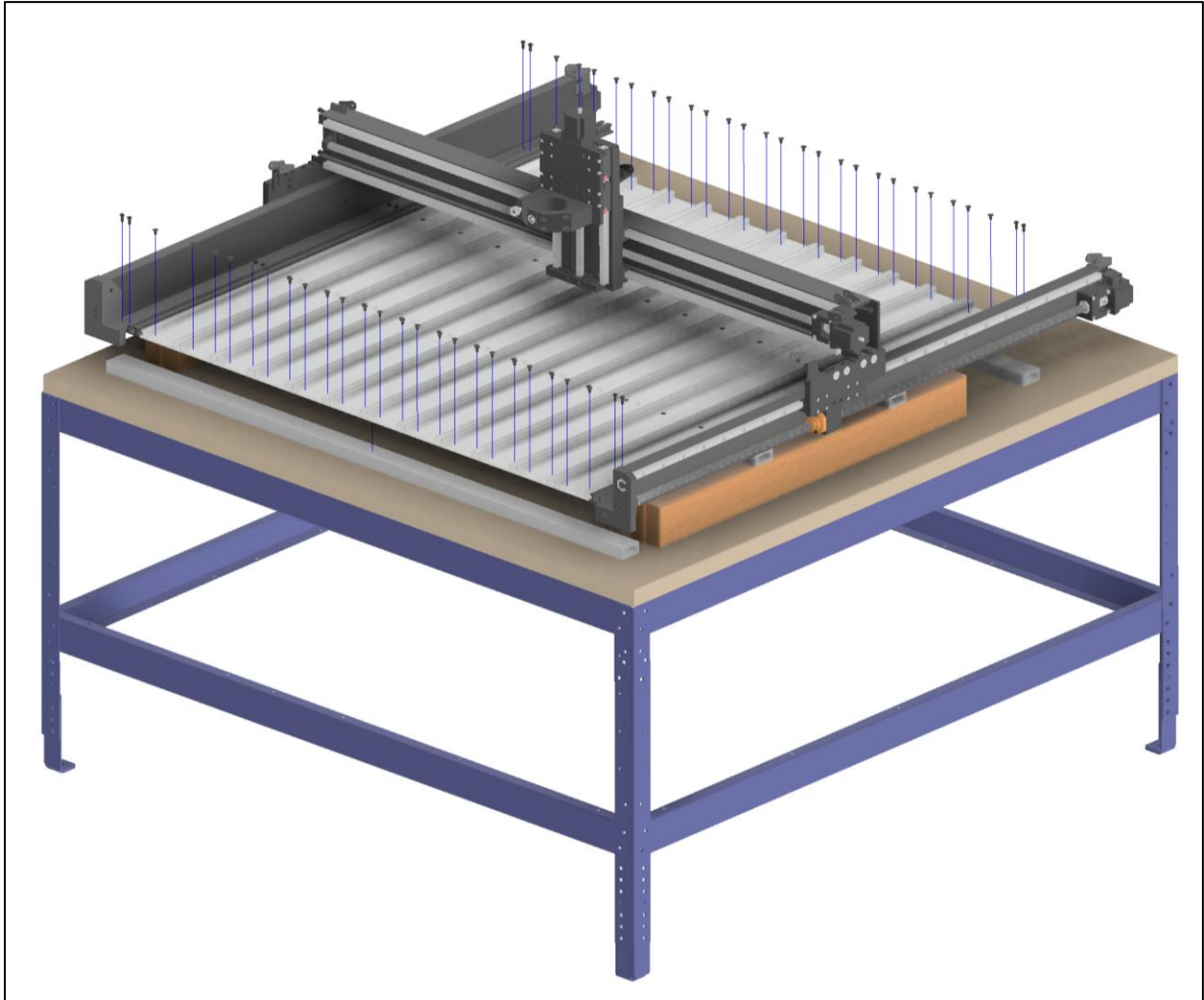


## Prepare Machine



1. Remove all MDF from Hybrid table
2. Center Gantry in the Y direction
3. Center Z-Axis in the X direction
4. Lift right side of machine
5. Place 36" 2x4 on edge below both center baseframe members
6. Lift left side of machine
7. Place 36" 2x4 on edge below both center baseframe members

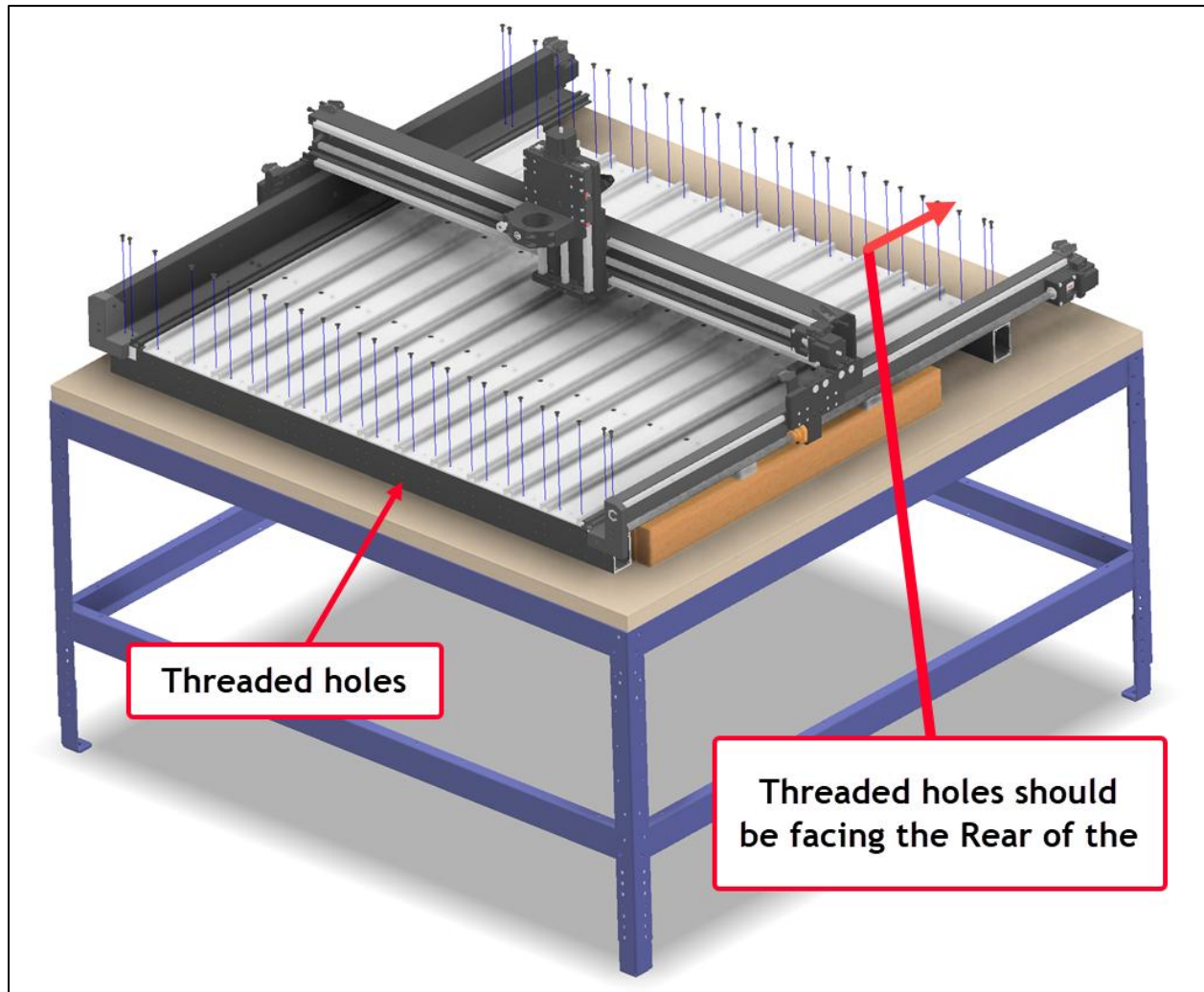
## Remove Front and Rear Baseframe Members



1. Remove M6x16 BHCS from front position of Y-Right and Y-Left Assemblies
2. Remove M6x12 FHCS from first row of Hybrid Table
3. Remove M6x16 BHCS from rear position of Y-Right and Y-left Assemblies
4. Remove M6x12 FHCS from last row of Hybrid Table

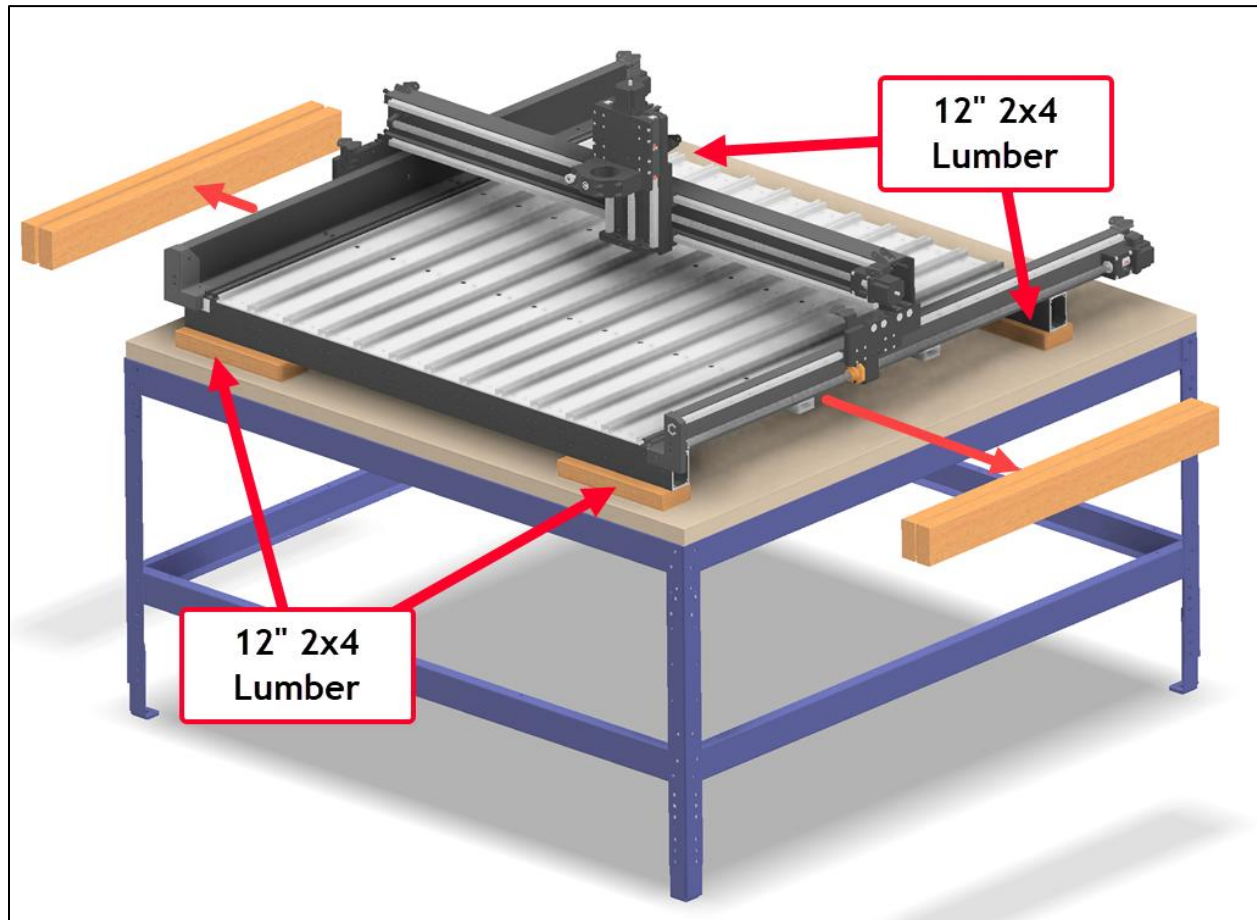
*Note: DO NOT use power tools while attaching hardware. Using a 4mm Hex key is the safest and most reliable way to attach the baseframe members.*

## Install Front and Rear Baseframe Members



1. Note threaded hole placement on front and rear members
2. Lift baseframe member up to meet bottom of Y Assemblies
3. Using 2 x M6x16 BHCS, loosely attach **Front** baseframe member to Y-Right Assembly
4. Using 24 M6x12 FHCS, loosely attach front row of Hybrid Table
5. Using 2 x M6x16 BHCS, loosely attach **Rear** baseframe member to Y-Left Assembly
6. Using 24 M6x12 FHCS, loosely attach rear row of Hybrid Table

## Preparing for Center Baseframe Members

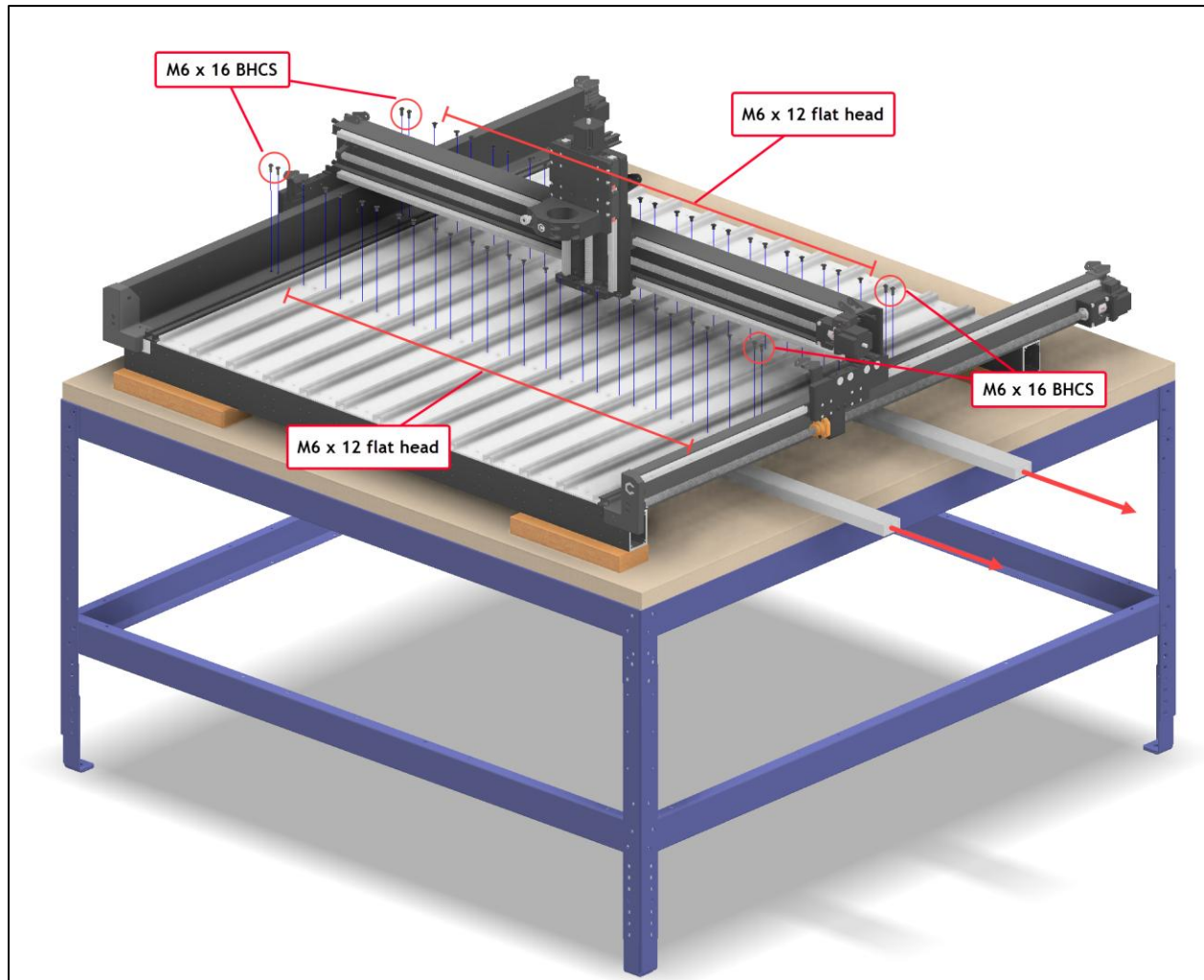


**Before continuing tighten fasteners across the front and rear baseframe members.**

*Note: DO NOT use power tools while attaching hardware. Using a 4mm Hex key is the safest and most reliable way to attach the baseframe members.*

1. Lift all 4 corners of machine and place 12" 2x4 lumber to raise platform
2. Remove 36" 2x4 lumber from below center baseframe members
3. Ensure your machine is stable and continue to next step

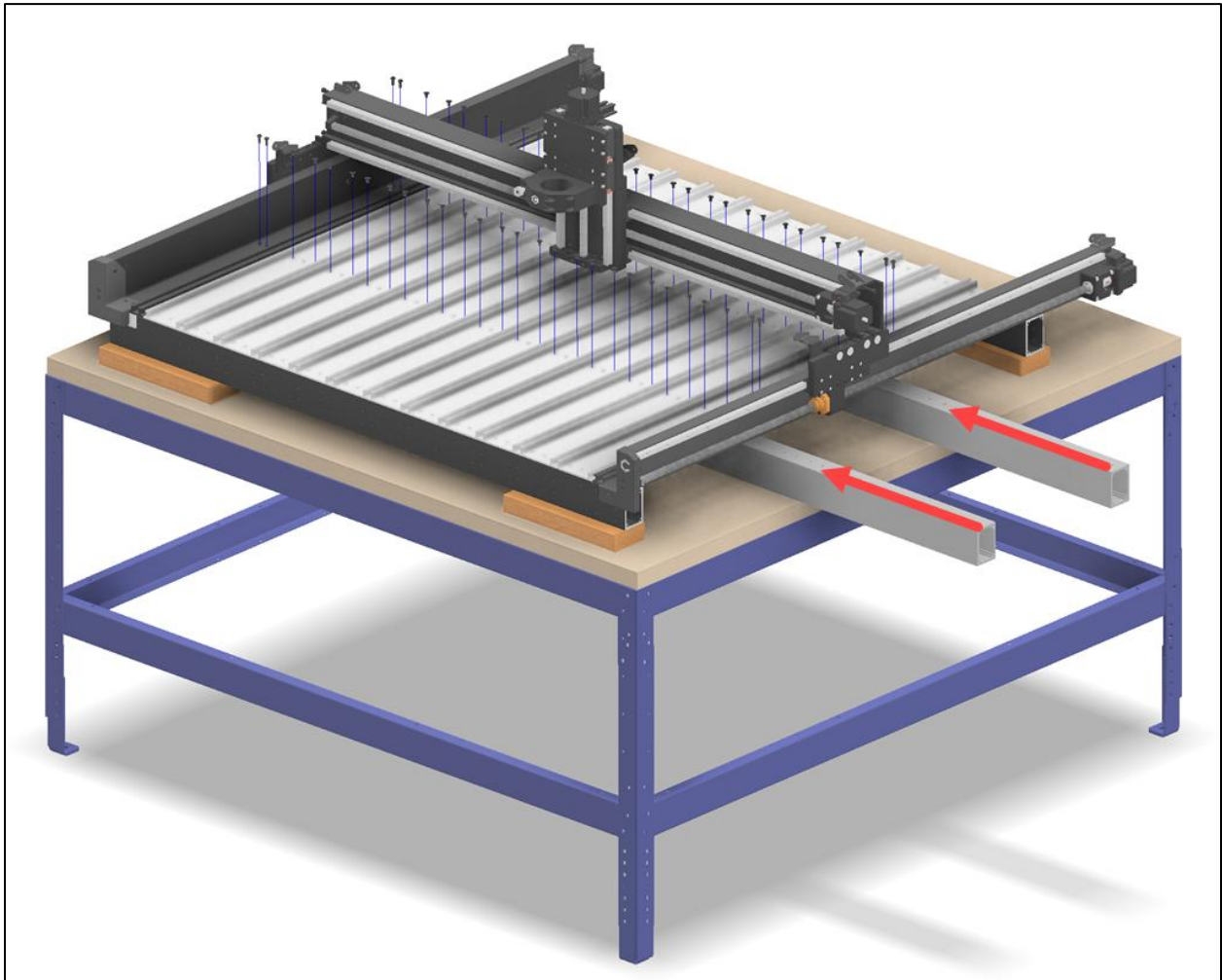
## Removing Center Baseframe Members



1. Remove M6x16 BHCS from Y-Left and Y-Right assemblies attaching baseframe
2. Remove M6x12 flat head screws from Rows 2 and 3 of Hybrid Table
3. Slide old baseframe members out from under machine



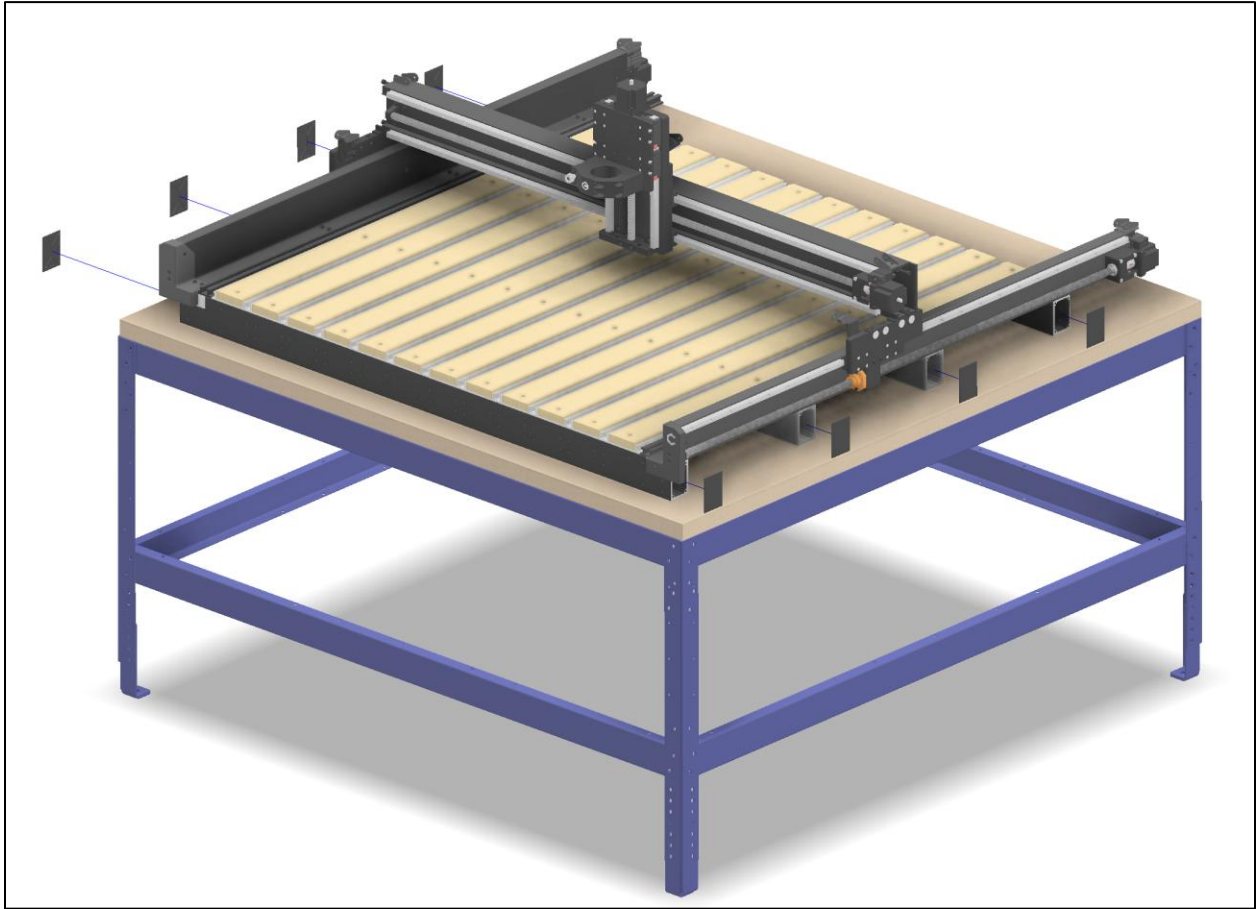
## Install Center Baseframe Members



1. Slide center baseframe members below machine
2. Loosely attach to Y-Right and Y-Left assemblies using M6x16 BHCS
3. Loosely attach to Hybrid Table using M6 x 12 flat head screws
4. After all screws installed loosely, fully tighten screws through Y-Right and Y-Left Rails. The fully tighten screws through Hybrid Table.

*Note: DO NOT use power tools while attaching hardware. Using a 4mm Hex key is the safest and most reliable way to attach the baseframe members.*

## Finishing Up



1. Using M6 x 20mm SHCS, reinstall MDF to Hybrid Table
2. If you are not installing the Table Leg kit: install Baseframe endcaps.