

Recommended Tightening Torque of the Screws

Description	Thread size	Torque
Attachment of the threaded pin to the motor pinion	M3	0.7 Nm
Attachment of the ball bearing for belt tensioner to the basic body	M4	3 Nm
Attachment of the spacer to the bottom plate	M5	5.4 Nm
Attachment of the actuator to the bottom plate	M3	1.9 Nm
Attachment of the ball bearing to the belt tensioner basic body	M4	3 Nm
Attachment of the guide rail to the X-plate	M4	4 Nm
Attachment of the limit switch to the limit switch holder	M2	0.3 Nm
Attachment of the limit switchholder to the X-plate	M3	1 Nm
Attachment of the belt holder to the guide carriage plate	M3	1.1 Nm
Attachment of the feed holder block to the guide carriage plate	M4	4 Nm
Attachment of the guide carriage plate to the guide carriage	M4	4 Nm
Attachment of the motor holder and fan sheet to the feed holder block	M4	4 Nm
Attachment of the extruder holder to the elongation measuring strip	M5	5.4 Nm
Attachment of the holding plate for the end stop with elongation measuring strips to the guide carriage plate	M4	3 Nm
Attachment of the end stop to the holder plate for end stop actuation	M4	3 Nm
Attachment of the threaded pin to the small pinion on the actuator motor	M3	0.7 Nm
Attachment of the motor to the motor holder	M3	1.5 Nm
Attachment of the extruder to the extruder holder	M8	1.4 Nm
Attachment of the feed basic part to the motor holder	M4	3 Nm
Attachment of the actuator to the X-plate	M3	1.9 Nm
Attachment of the drag chain end piece to the holder for the end stop	M3	1.2 Nm
Attachment of the fan to the fan sheet	M2.5	0.7 Nm
Attachment of the ball bearing to the belt tensioner basic body	M4	3 Nm
Attachment of the guide rail to the Y-plate	M4	4 Nm
Attachment of the actuator to the Y-plate	M3	1.9 Nm
Attachment of the drag chain end piece to the holding block for the guide rail	M3	1.2 Nm
Attachment of the holding block for the guide rail to the Y-plate	M3	1.9 Nm
Attachment of the drag chain end piece to the Y-plate	M3	1.2 Nm
Attachment of the holder for the limit switch to the limit switch	M2	0.3 Nm
Attachment of the undertable holder to the limit switch holder	M3	1.1 Nm
Attachment of the undertable holder to the belt tappet angle	M3	1.1 Nm
Attachment of the drag chain end piece to the undertable	M3	1.2 Nm
Attachment of the undertable to the Y-plate with the guide carriage	M4	4 Nm
Attachment of the threaded circulation spindles to the Y-plate	M5	5.4 Nm
Attachment of the actuation for the end stop to the Y-plate	M4	3.4 Nm
Attachment of the hexagon threaded bolts for the limit switch actuation to the Y-plate	M3	1.1 Nm
Attachment of the installed bottom plate to the installed X-plate	M5	5.4 Nm
Attachment of the pinion to the ball circulation spindle	M3	0.7 Nm
Attachment of the left and right side parts	M4	4 Nm

Description	Thread size	Torque
Attachment of the small/large foot holder to the side parts	M4	4 Nm
Attachment of the rear cover to the side parts and bottom plate	M4	2.9 Nm
Attachment of the rear side covers and rear head cover to the side parts	M4	2.9 Nm
Attachment of the drag chain end piece to the operating cover	M3	1.1 Nm
Attachment of the operating cover to the side parts and bottom plate	M4	2.9 Nm
Attachment of the right and left sight protection cover to the side parts	M4	2.9 Nm
Attachment of the limit switch PCB to the X-plate	M2	0.3 Nm
Attachment of the earthing cable of line 20 to the undertable	M3	1.1 Nm
Attachment of the display PCB and keyboard PCB to the operating cover	M2	0.3 Nm
Attachment of the main PCB to the operating cover	M3	1.1 Nm
Attachment of the mains unit to the rear cover	M4	2.5 Nm
Attachment of the earthing cable to the bottom plate	M4	2.5 Nm
Attachment of the earthing cable of line 20 to the bottom plate	M4	2.5 Nm
Attachment of the bottom sheet to the foot holders	M3	1.1 Nm