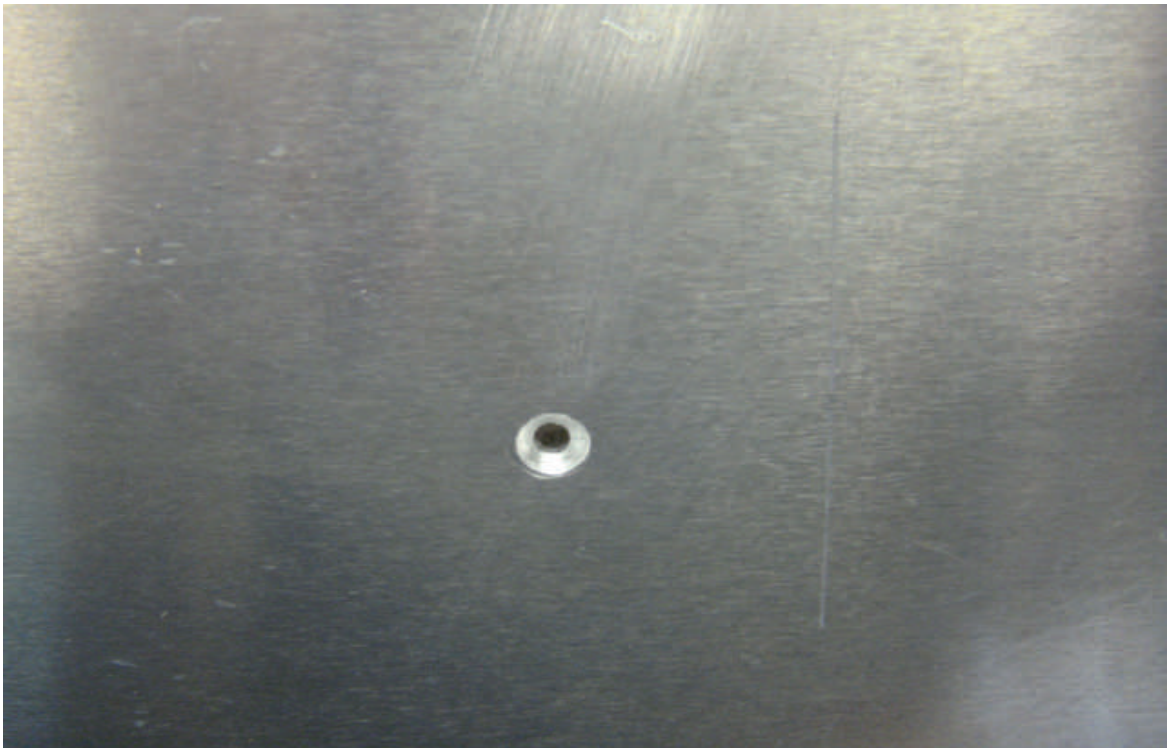


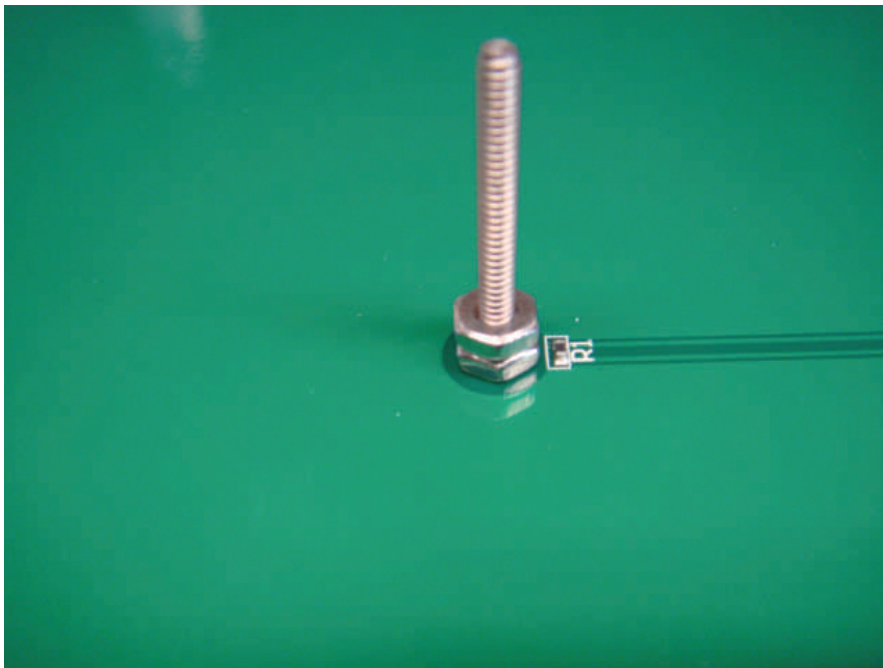
1. **Disconnect Heater cable**
2. **Remove front Y Tensioner Pulley shoulder screw and remove bearing. This will allow the belt to stay assembled to Build Table Assembly.**
3. **Remove Y axis guide bars and remove Build Table Assembly from Rigid-bot**
4. **Remove the 4 adjuster screws /springs and set the Bottom Assembly aside.**
5. **Remove the Heater from the Build Plate.**
6. **Re-attach the Build Plate to the Bottom Assembly without the springs and heater. I did this to make sure I did not damage the Heater PCB.**
7. **Enlarge the center hole using a 0.113" drill (#33), and drill through the lower Plate, making sure that you don't drill through the Belt.**
8. **Remove the Build plate.**



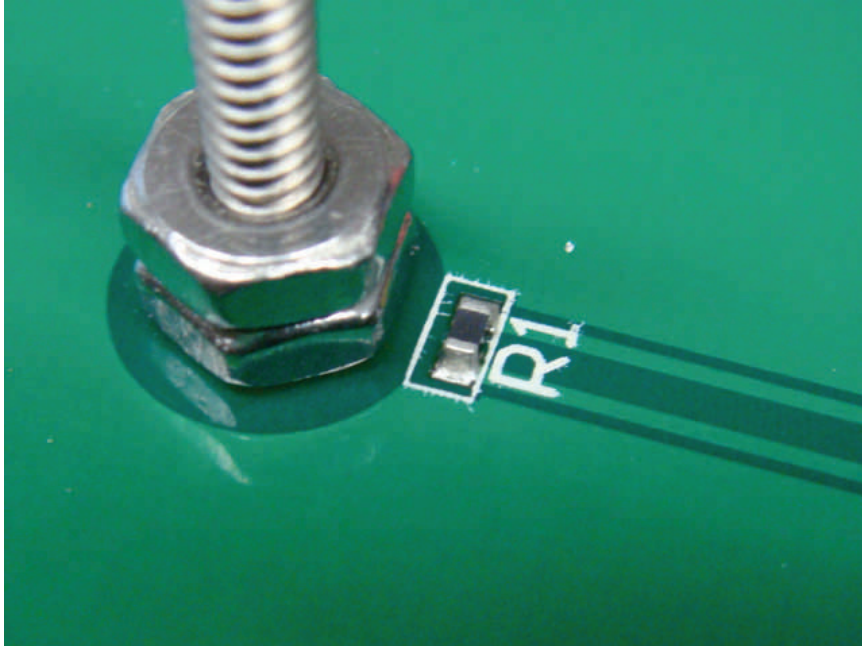
9. **Countersink the Build Plate center hole from the top to fit a #4 screw. Test fit the screw to make sure the head is below the top surface.**



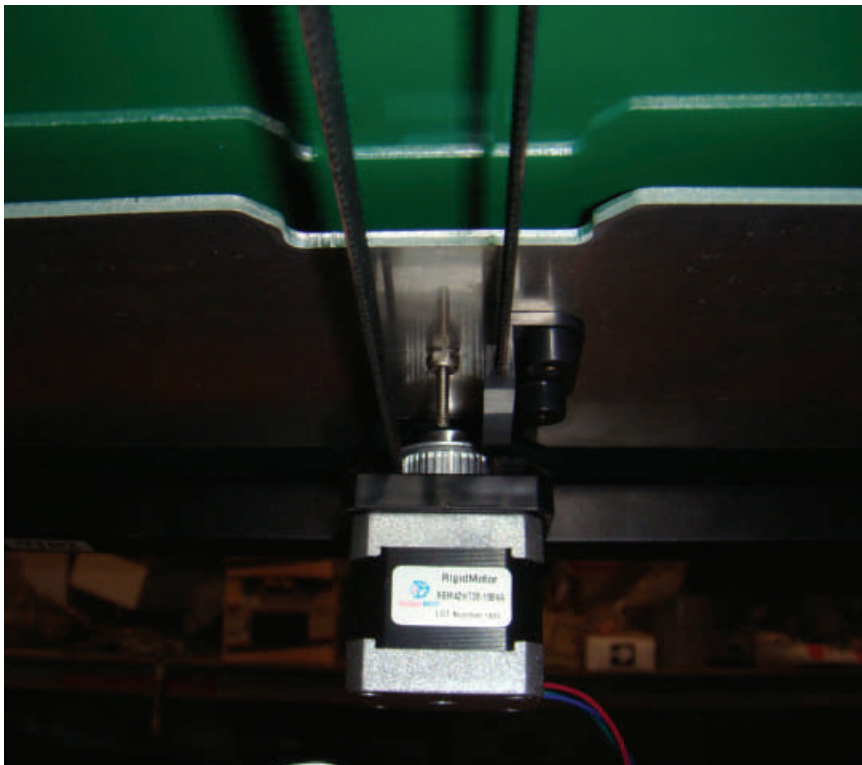
10. Enlarge the lower plate hole that was just drilled to 5/32". This will allow the pull down screw to slide freely through the lower plate.
11. Re-install the Heater PCB replacing the center screw with a #4-40 x 1.25 lg Flat head CR screw. (Shorter may work, but I had these)



12. Install a 4-40 nut and tighten (be careful not to over-tighten and damage the PCB).
13. Install a second 4-40 nut and lock it to the first nut.
14. Be careful not to damage the resistor. (see next page)



15. Reassemble Build Assembly with the new adjusting screw sticking thru the Assembly and install a 4-40 locking nut. Leave it loose for now.
16. Reassemble the Rigidbot and Level the Build table extents.
17. When the Head assembly moves to the center, tighten the esna nut from the bottom to obtain Hot end clearance.



**Note: Several leveling iterations may be required to obtain a relatively flat surface.**