



# How to Glue an X Carriage





## TOOLS:

- [Devcon 5 Minute Epoxy](#) (1)
  - [LM8 Bearing](#) (4)
  - [Paper Towel](#) (1)
  - [Millers Tool](#) (1)
  - [Dummy X Assembly](#) (1)
  - [Printed X Carriage](#) (1)
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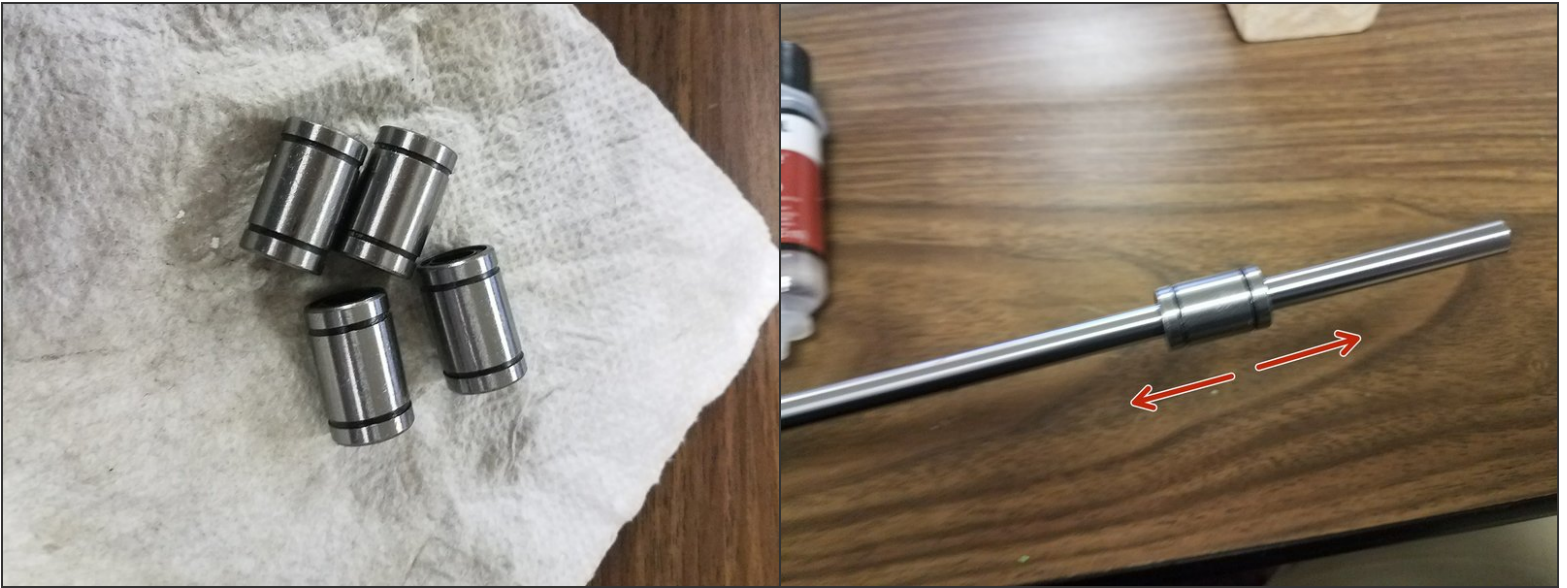
## Step 1 — Setup



- i** Important note: Make sure you have gathered all materials required for this job before starting.
- Some of the Steps are time sensitive, do not begin unless you can see the whole project though to the end. Please read the whole project before beginning.
  - Setup the X Assembly mockup that you will be using as a frame for this job. You will need it later. Ensure that you have all the rods you will need for the project, 3 x carriages can be drying at a time.



## Step 2 — Hardware Check



- Open the Lm8 Bearing and wipe off any Oil on them, oil can prevent the Epoxy from bonding Properly
- Check your LM8 Bearings on on of the smooth rods to ensure that it moves well

**⚠ It is critical that you can move the bearing easily without much resistance on the rod, if you use bad bearings the whole part will be ruined and the printer that uses it will not function well if at all.**

### Step 3 — Test Printed Piece



- Dry fit your 4 bearings into the Cleaned X carriage.
- Run the rods that you will use to dry the part through the piece with the bearing in place, ensure a smooth run of the rods.
- Remove the test fit bearings
  - ⓘ The Bearings should basically be loose in the housing and fall out if turned over.

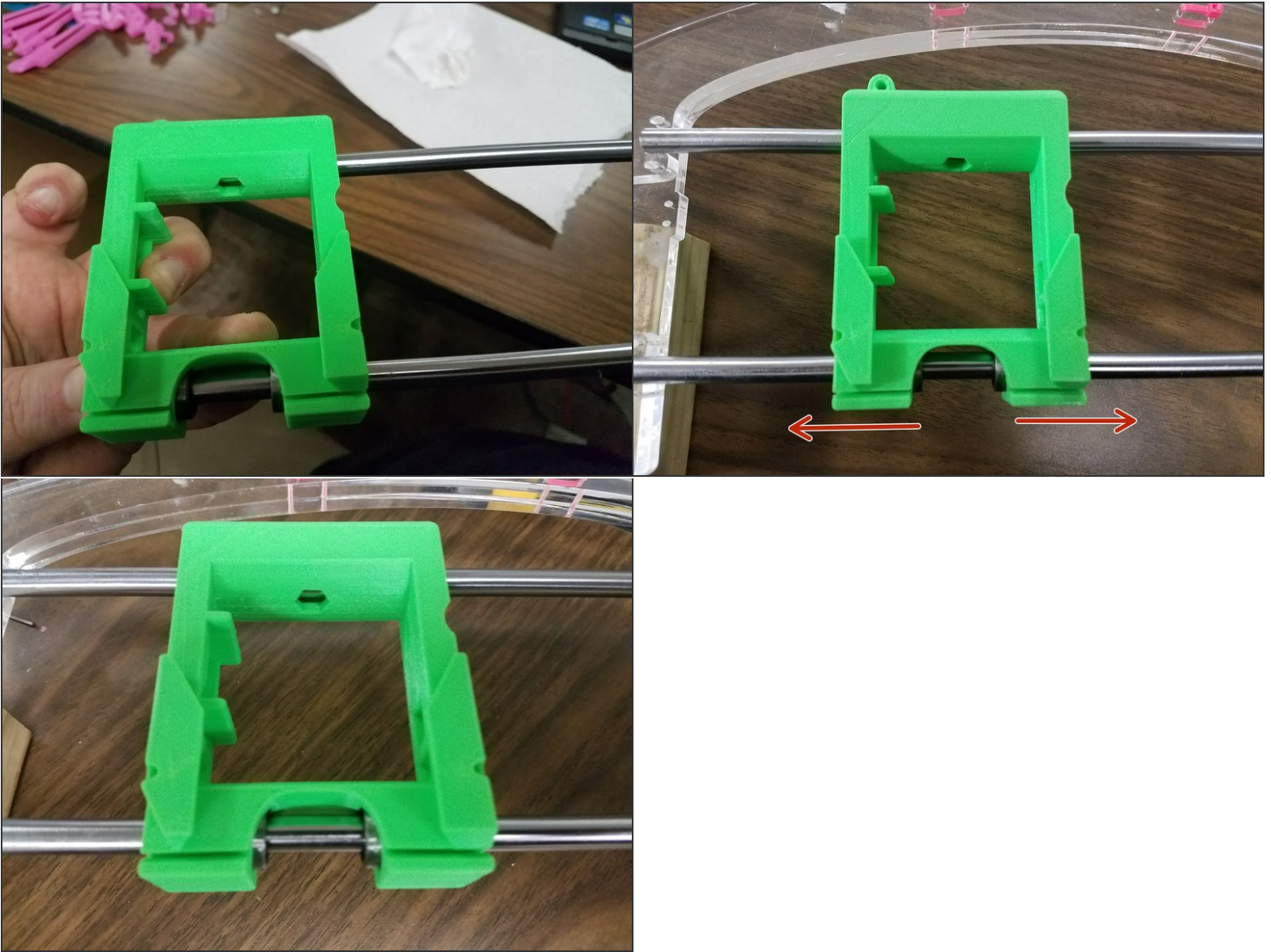
## Step 4 — Glue Bearings



- Mix a small to moderate amount of your Epoxy, enough to coat 4 bearings, and blend the epoxy together
- Using your mixing tool spread epoxy on one of the bearings on about half of the bearing all the way around it.
- Insert the Bearing Glue first into the X Carriage and fully insert it with a spinning motion to even disperse all the epoxy
- Wipe off any excess epoxy that is on the outside of the X Carriage with a small section of paper towel.
- Repeat this process for the remaining 3 bearings.



## Step 5 — Testing and Curing



- Once you have all the bearing inserted place the fully assembled X Carriage on the dummy X Assembly you setup earlier.
- Move the X carriage back and forth on the dummy setup to ensure that it moves smoothly.
  - ⚠ Make sure none of the bearings get pushed out while inserting the Rods or when you move the X Carriage.
- Please allow the assembled X Carriage to set for 1 hour so the epoxy may set, before removing from the Dummy Frame.
- ☑ We are using a 5 minute Epoxy, if you are using another glue you may have to allow the X Carriage to sit longer, as according to the cure time on the packaging of your glue.

