

# #prep Y assembly 01-B: Heated Bed Sandwich

*IF you don't have the **Heated Bed upgrade**, you're on a wrong page.*

## Title: Attach the Clips and Stand-Offs

You'll Need

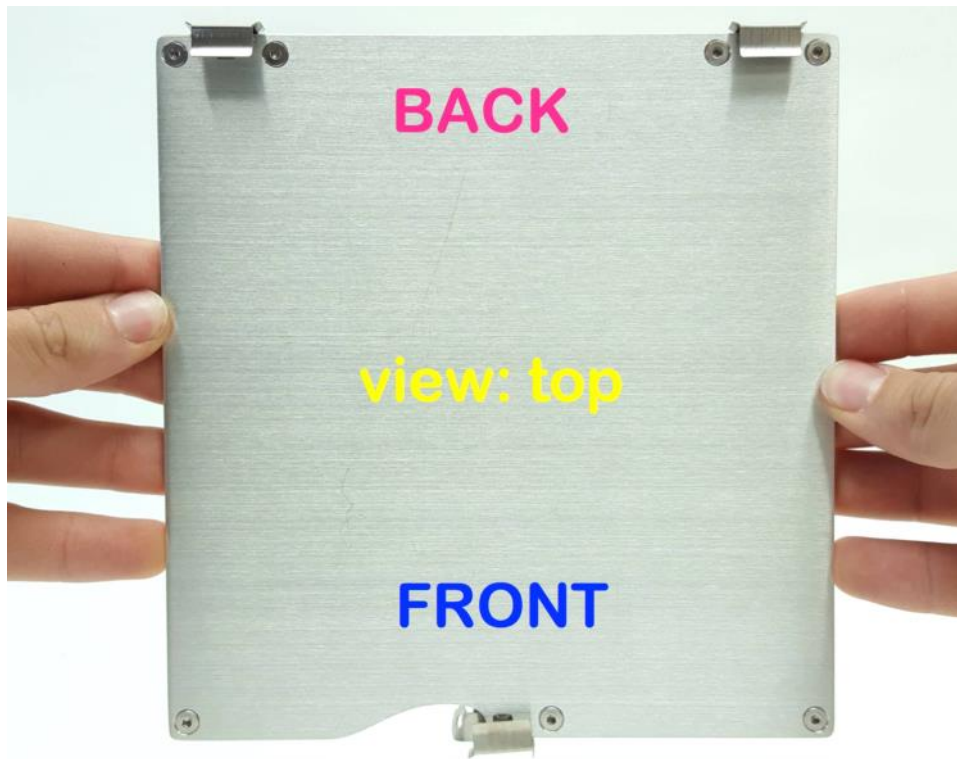
Aluminum base

Bed clips (3)

M3x8 flathead screws (7)

Stand-offs (4)

M3 regular washers (2)

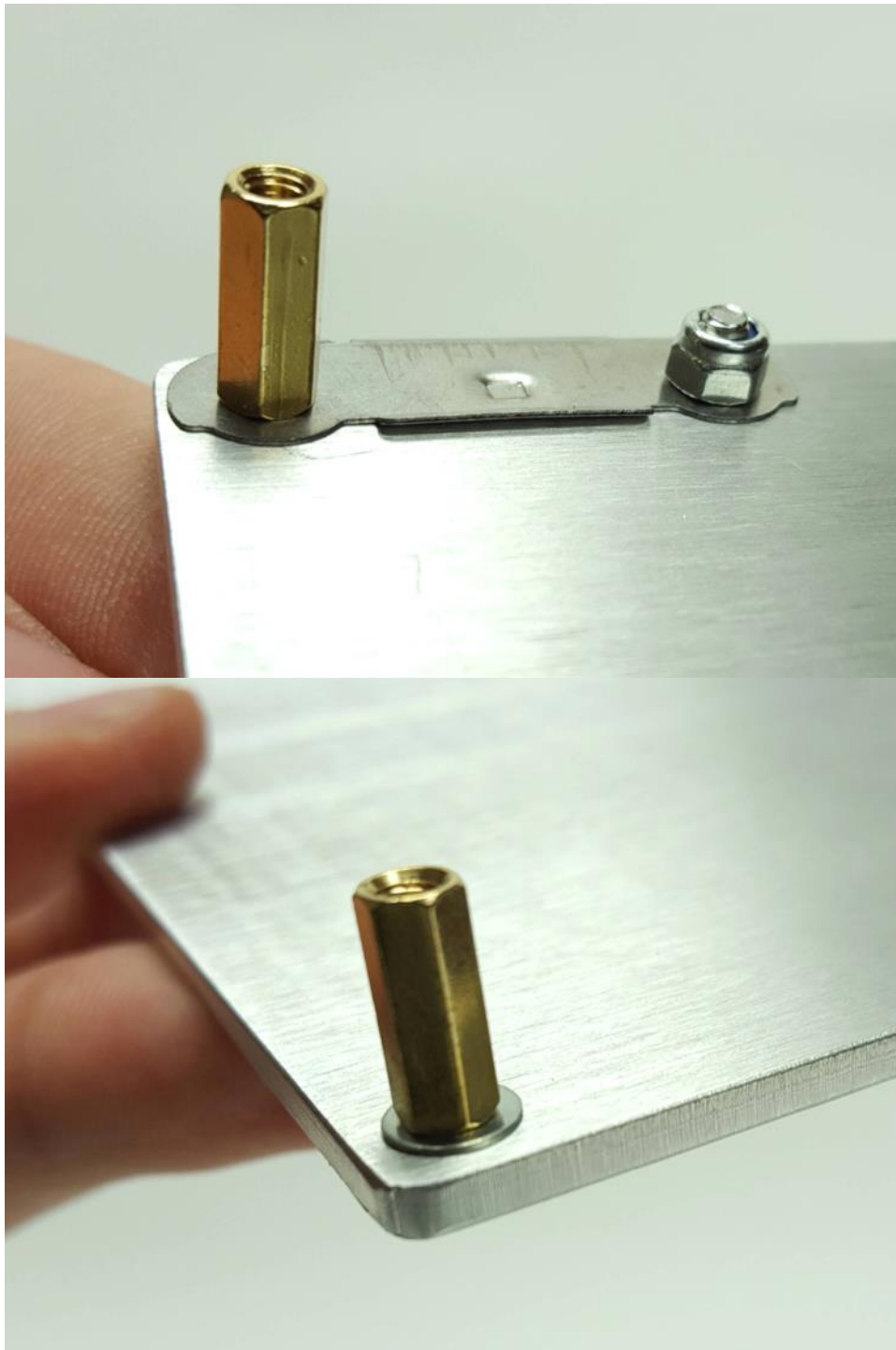




In short, use the hardware to attach two clips in the back and one in front. Read on for more detailed instructions.



Attach the clip that is bent in the middle in front. Use only one screw and leave it a bit loose so that the clip can swivel open and close.



All the spacers go in corners.

In the back, use the spacers in corners in place of the M3 nylocks.

**In front**, put one regular **M3 washer** underneath the spacer (these washers offset the thickness of the clips used in the back).

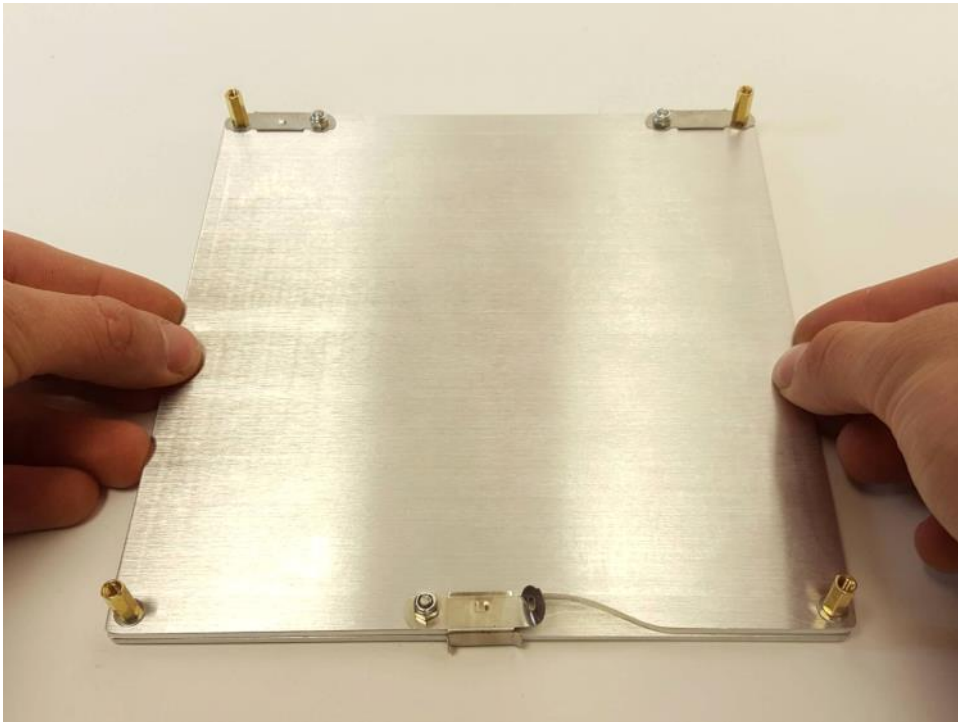
There are no washers between the locknuts and the clips - the clips themselves function as washers.

Tighten all of these well.

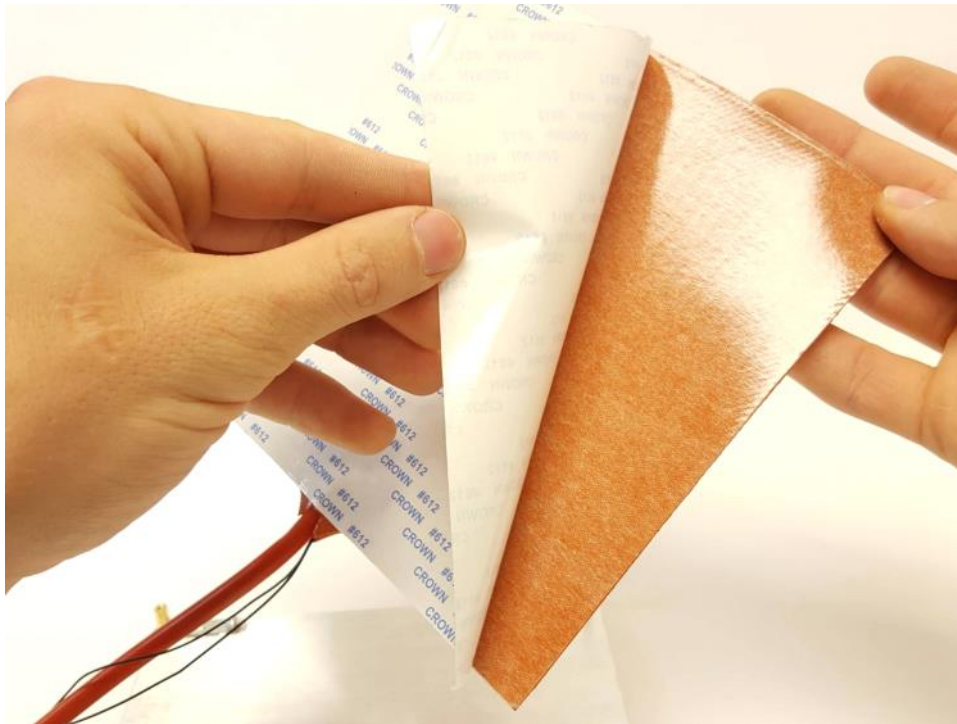
Title: Silicone Heater



Insert the aluminum build plate.  
This way, the clips won't be in the way.



Turn the assembly upside down.



Peel the adhesive backing of the silicone heater.



Stick the heater onto the bottom of the bed assembly.  
Make sure the wires are exiting on the same **left** side as in the picture. (Sorry. Hidden under my left hand.)  
Press the heater down gently but firmly.  
Tip: Try to stick the heater as far back as possible.



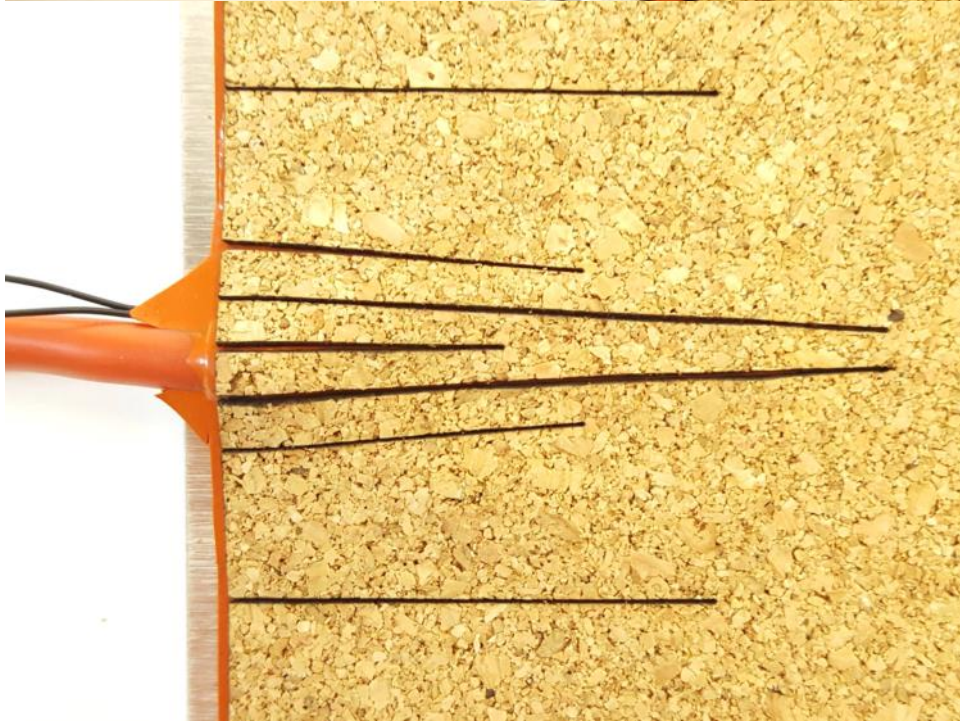
In the front, you may end up with a slight overlap between the front clip and the heater. That's ok.

#### Title: Cork Insulation



Peel the backing off the cork insulation.

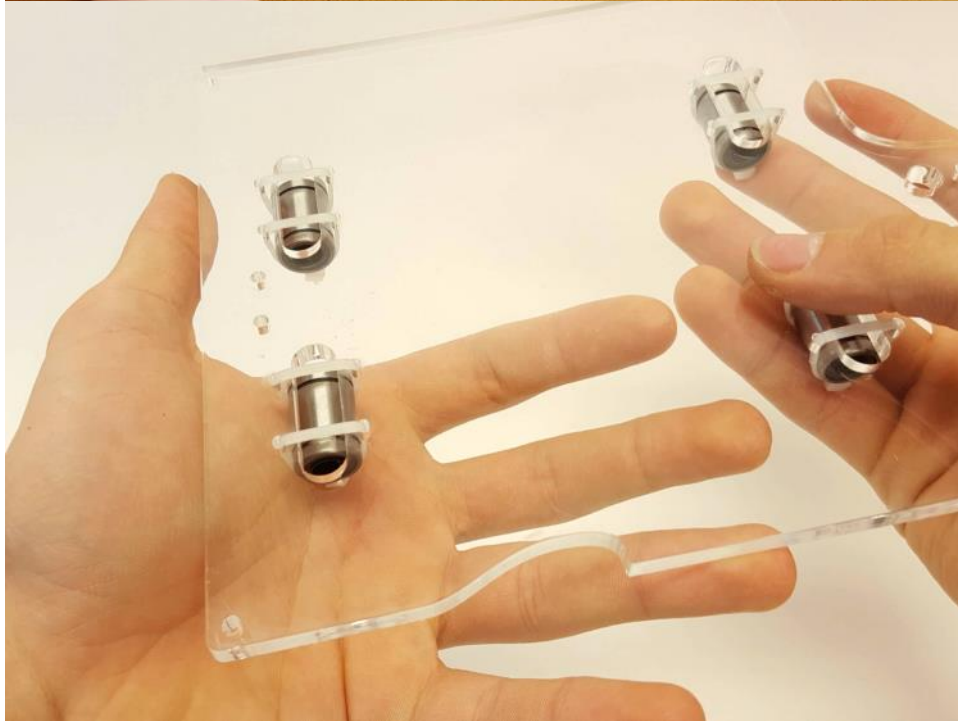
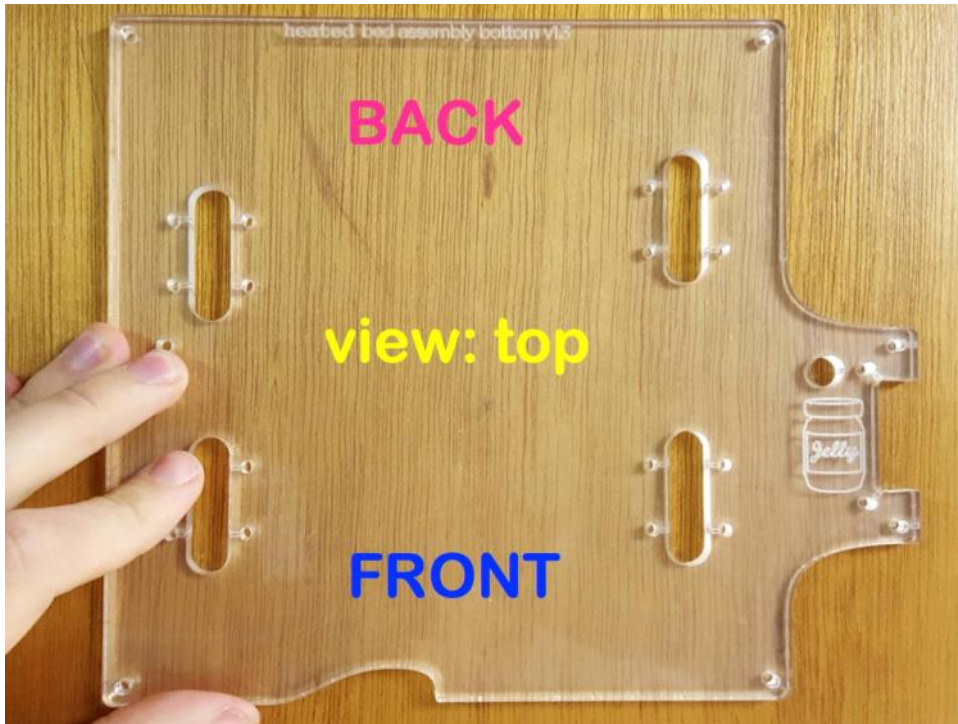




Stick it onto the silicone heater. There will be about 1mm gap on all sides. The cuts-slots in the cork will help you follow the bumpy contours of the heater wiring. Start by firmly pressing on all the flat parts of the cork, and carefully finish up with the wire area.

**Title: Attach the Bearings**



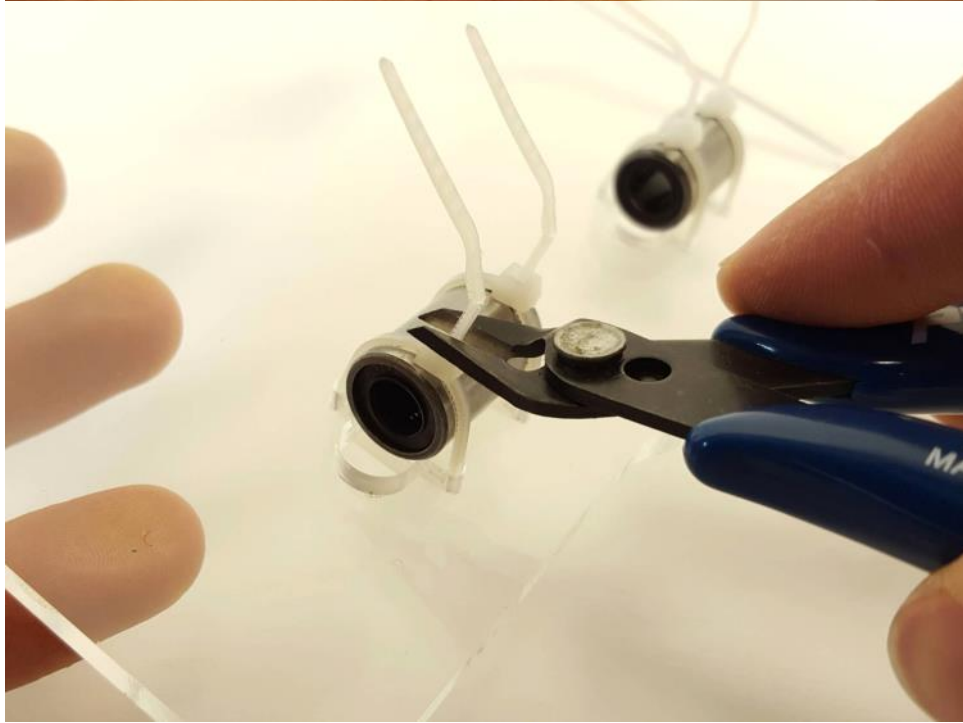


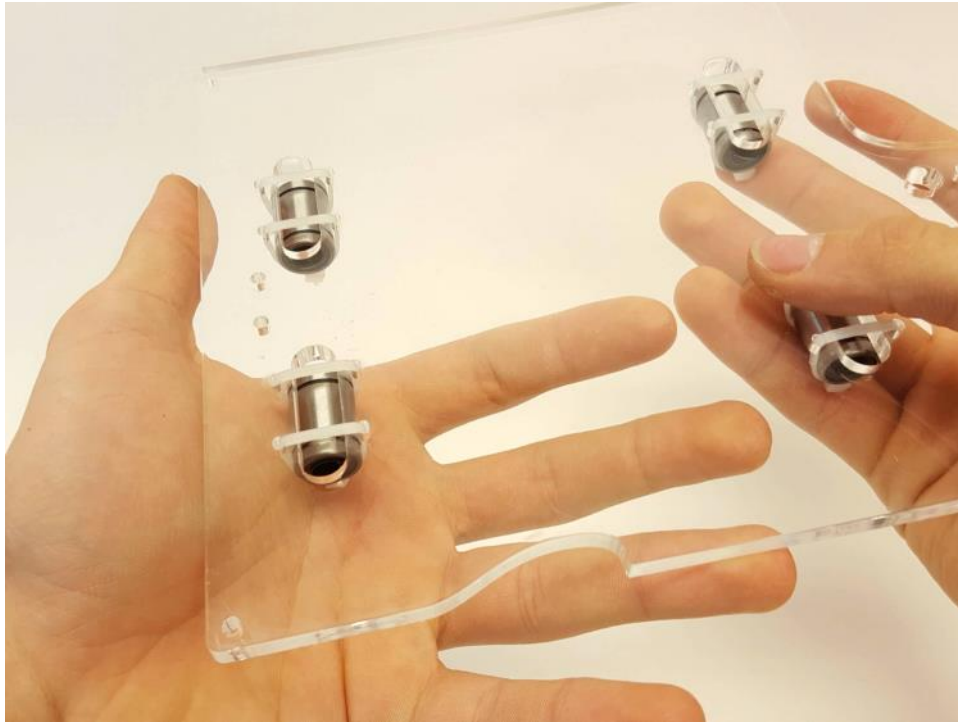
Now let's attach four bearing on the bottom of the acrylic base.  
Note: The pictures in this guide mostly feature a pre-production acrylic plate with no etchings. Yours is nicer (like the one shown here)!



Peel the protective layer off the acrylic base.

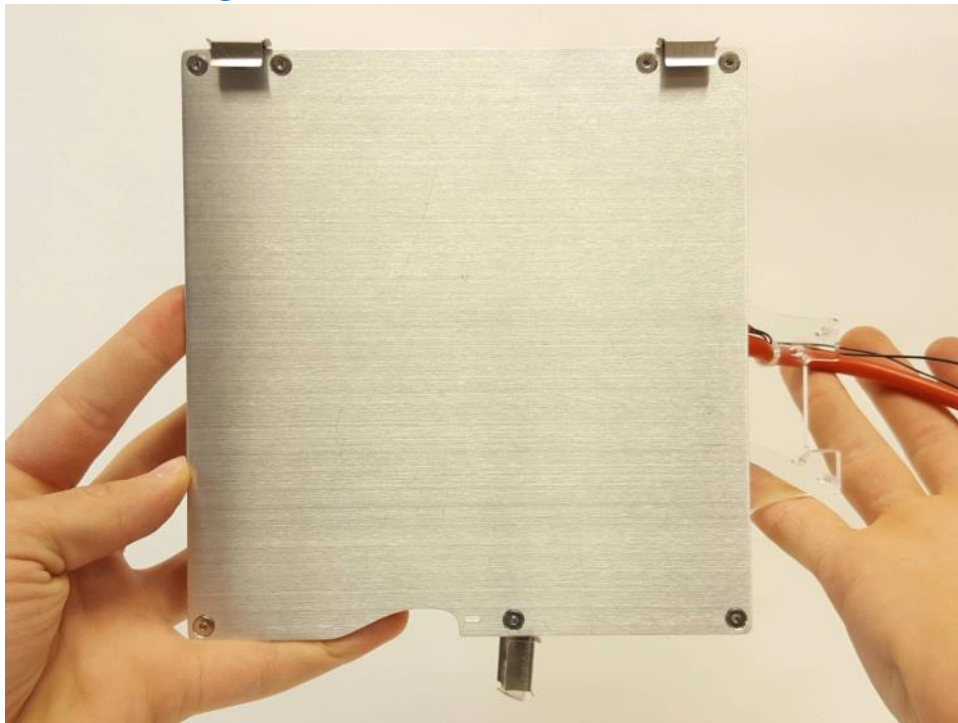






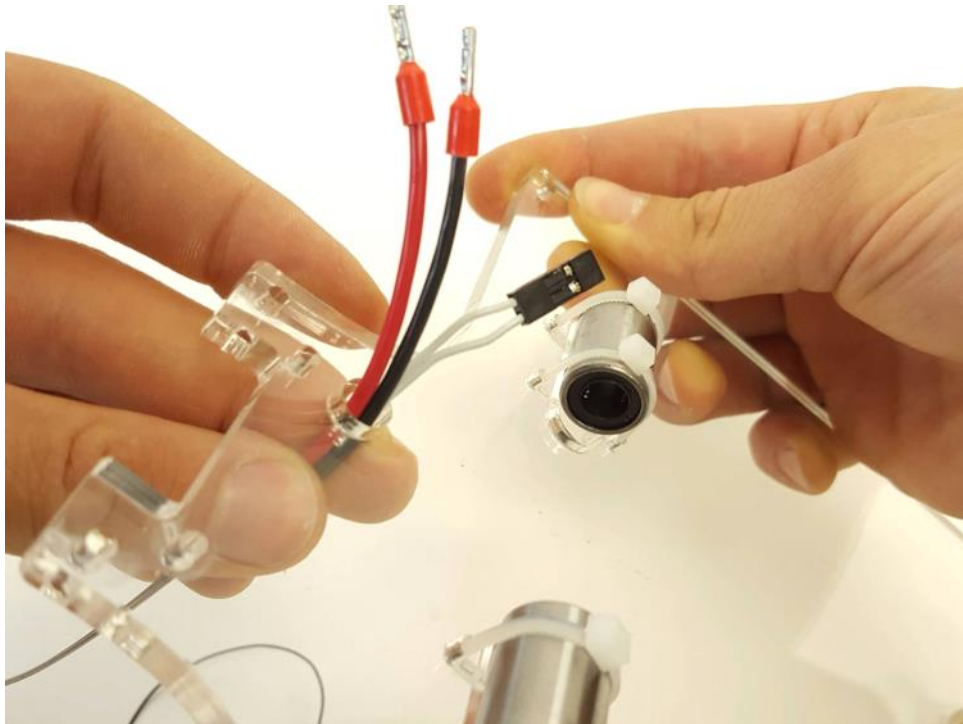
Attach the 4 bearings with eight 4" zip ties.  
Make sure the bearings are on the bottom when looking from front!  
Pro Tip: First thread in all the zip ties. Then put in all the bearings. Then tighten all the bearings with vise grip. It's more efficient than one-by-one.

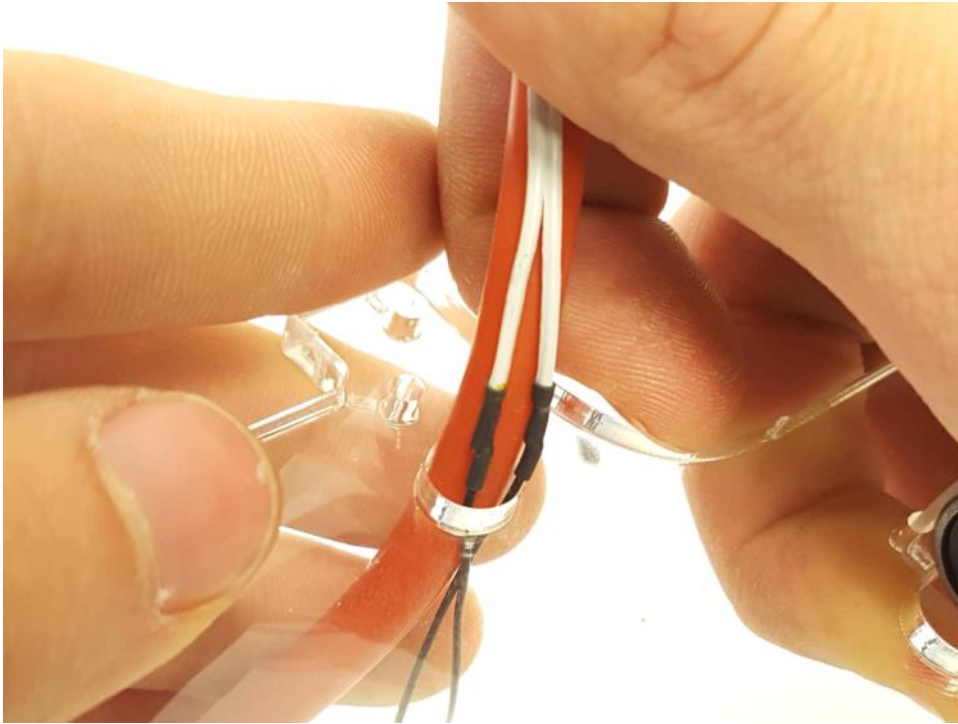
### Title: Put it Together



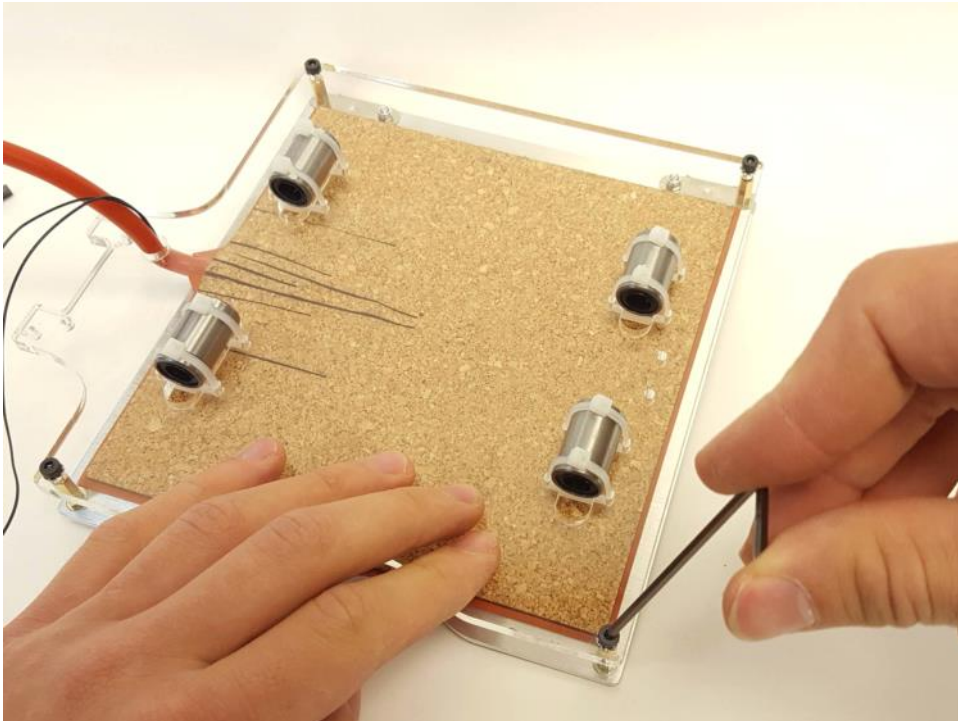


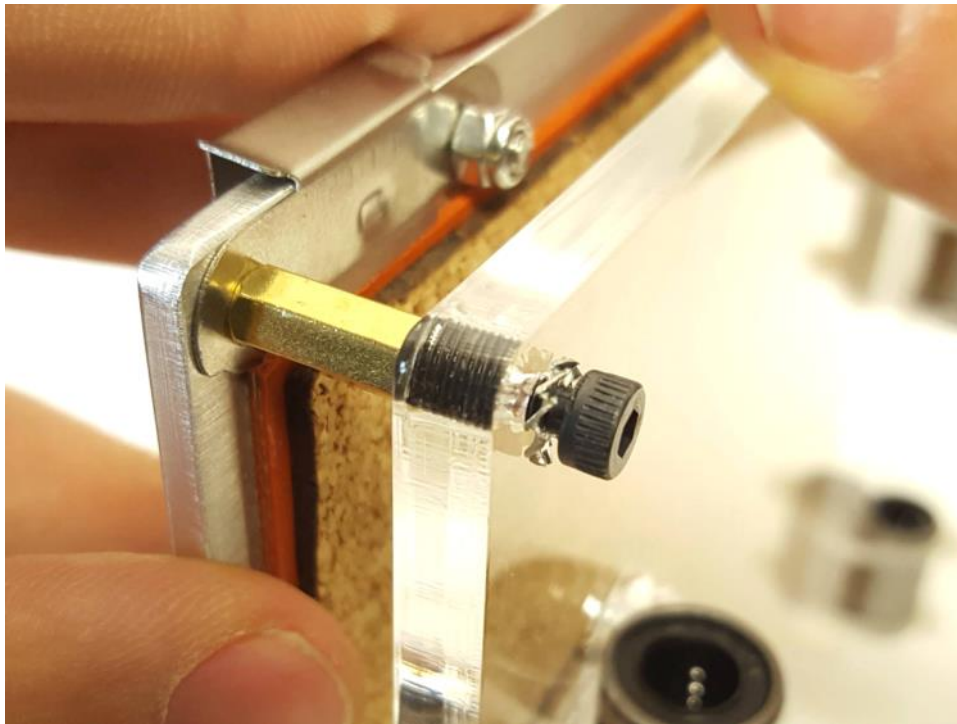
Final step is the put the acrylic base and the rest together.





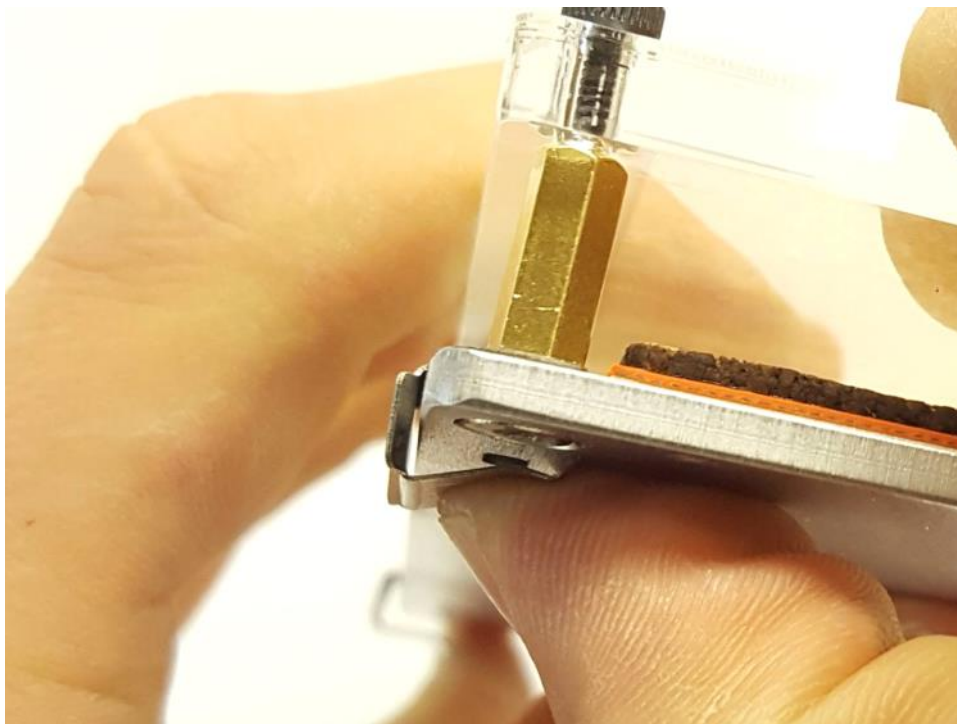
Start by pulling the heater wires through the acrylic base as shown in the picture. Be careful when pulling through the heat-shrunk connection point of the thin thermistor wire.

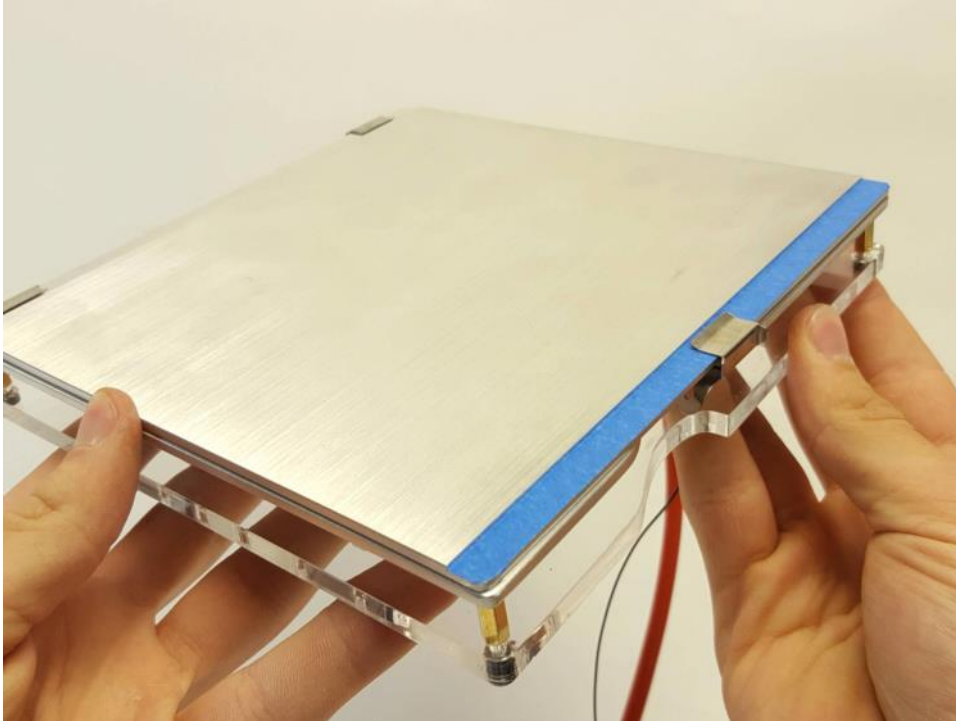
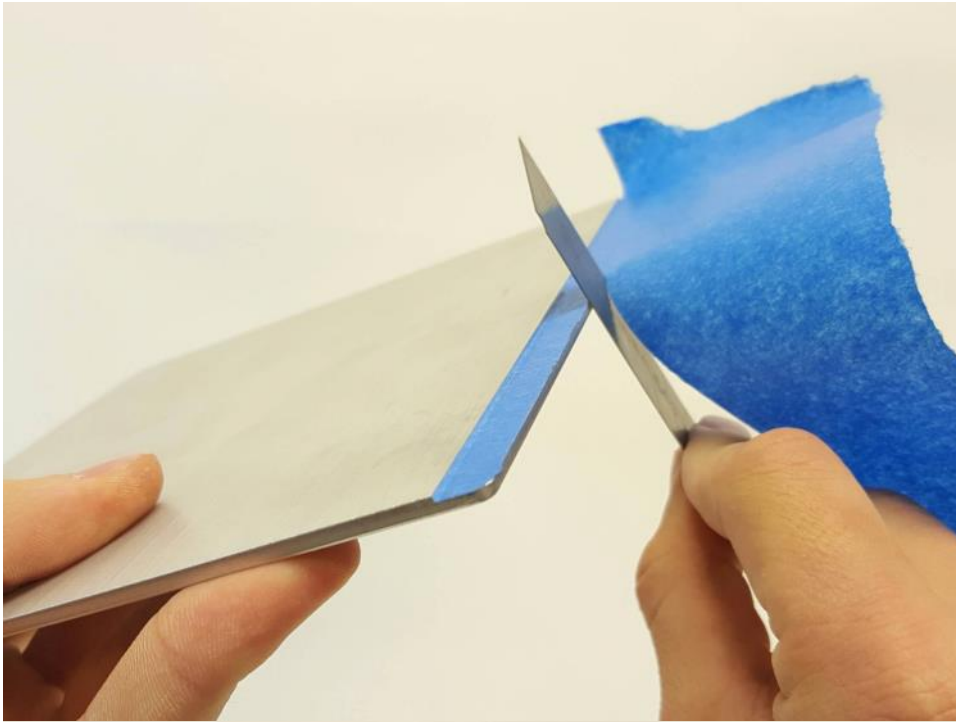




Secure the connection with four M3x10 cap screws and four serrated washers.  
Did I mention serrated washers?  
Only use the short shaft of the hex key - it gives you enough force and you won't overtighten the screws.

#### Title: Tip: Fixing a Loose Build Plate





Quick release build plate on heated platform sure is convenient (!), but it may come loose at times. To fix this issue, you can:

- re-compress the metal clips
- (Filip's favorite) put some blue tape onto the edge of the build plate. Use as many layers as needed. Success!

Title: Done!