

We are continually working to improve our documentation. Until we can print revised editions, please take note of the list below specifying things that have changed since this manual has been printed.

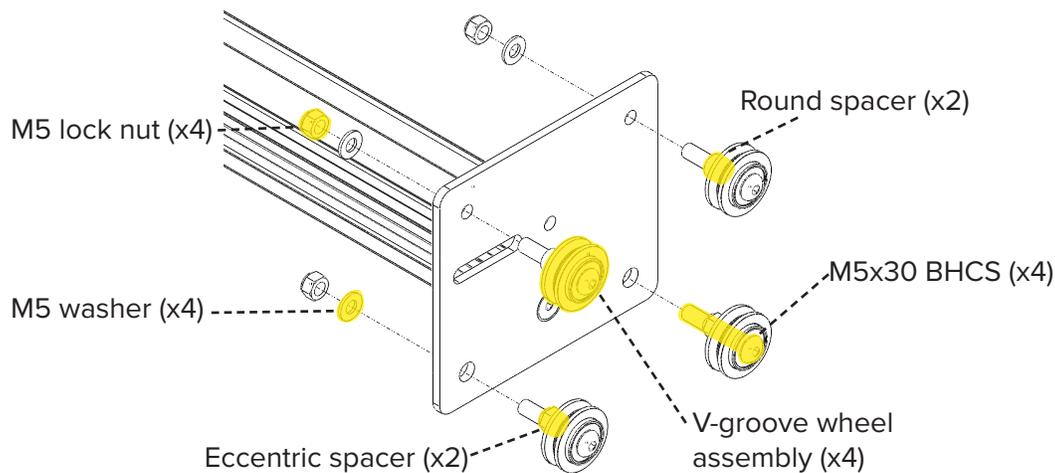
STEP	COMMENTS
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Please refer to [Gigabot® Panduit Sizes sheet](http://wiki.re3d.org), available at wiki.re3d.org

- B15** The bed frame cross rail Panduit is now 9.25" instead of 11.75"
- D3** Rear upper cross rail uses 7.25" Panduit instead of 8"
- E2** Lower right common rail uses 29" Panduit instead of 30"
- E4** Lower left common rail uses 27.5" Panduit instead of 11.75"
- F9** Rear vertical common rails (both right and left) no longer use the same size Panduits. Left uses a 1"x1"x30" Panduit while right uses 0.5"x0.5"x30"
- F28** Front right corner vertical common rail uses 29" Panduit instead of 31.5"
- H1** Right electrical box upright uses 31" Panduit instead of 31.5"
- I5** Upper Z limit switch uses 2.375" Panduit (5.25" for XL) instead of 3.25"

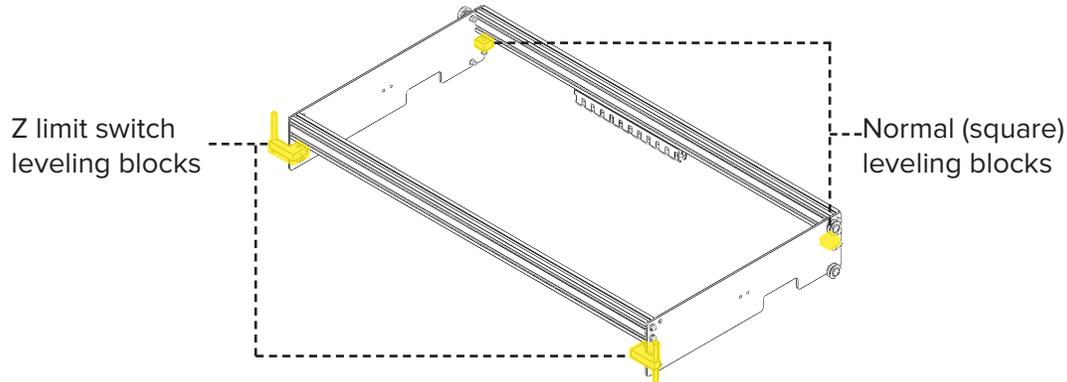
Do not use the Bill of Materials (BOM) from pages 5-15. Instead, please refer to the packing list that is included with your GB3 kit.

- A8** Wheel assembly now no longer uses lock washer or hex nuts. Instead, they use an M5 flat washer and M5 lock washer for each wheel. They also are assembled using an M5x30 BHCS. (See below)

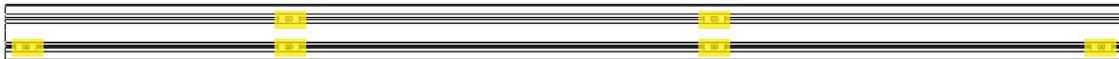


- A9** Mark eccentric spacer on narrow side for reference. Place on plate with mark facing OUT--this sets the wheels at their widest spacing
- A17** Trolley should have arrived fully assembled and with the X-axis belt attached. There is no need to do any disassembly of the trolley.
- A19** Instead of removing the front wheels, simply slide the trolley onto the bridge rail (the idler pulley should not be installed yet). If you have already installed the pulley, you can also loosen the front wheels of the trolley and work the trolley onto the rail. Once it is mounted, retighten the front wheels.
- A20** Omit this step
- A21** The idler pulley is attached with the following hardware in this order: M5x45 into rail, (on the other side of the rail) 3 M5 flat washers onto the M5x45 with dull side pointed towards rail, idler pulley onto washers with recessed face towards rail, 1 M5 washer on pulley with shiny side towards bearing, 1 M5 lock washer with some red grease to prevent thread galling.
- A23** Follow convention from A8 to install wheels
- A26** Place 1 M5 flat washer each between the head of the M5x45 BHCS and the rail. Do not overtighten this or you risk stripping the threads in the plastic motor block.

- A28** Omit this step (trolley is assembled).
- A29** Omit this step (trolley is assembled).
- B4** Front cross rail receives both Z limit switch leveling blocks. Fasten as stated.

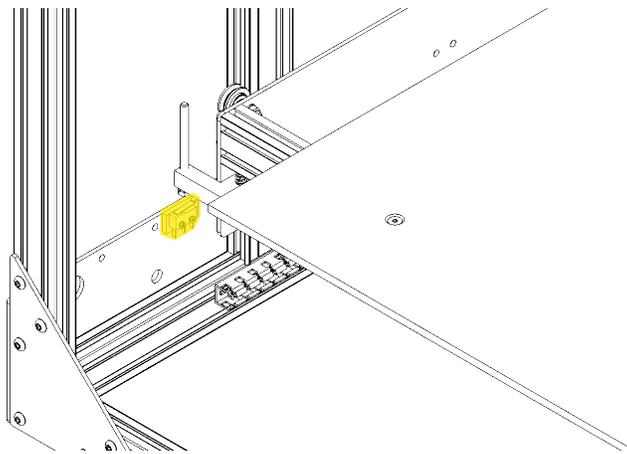


- B5** Back cross rail receives both normal leveling blocks. Fasten as stated. (See above)
- B9** Instead of the normal leveling block, this is the lower Z limit switch leveling block. The M5x70 screw here should have the head pointing down instead of up.
- B13** Instead of the limit switch leveling block, this should be the normal leveling block.
- B15** The bed frame Panduit is a #2 sized 9.25" Panduit, NOT 11.75".
- B17** Follow convention from A8 to install wheels.
- C6** Instead of M5x12 BHCS and 2 washers, assemble the corner brackets with M5x10 BHCS and no washers.
- D3** This is a #2 size 7.25" Panduit, NOT 8".
- D15** Omit this step - the 4 T-nuts in this row will be used for Filament Detection units.
- D16** The guide rod is 8.5" long and should be assembled without the "rear filament guide shelf". Install to the frame using a M5x10 BHCS and M5 flat washer.
- D18** There are 6 T-nuts used here instead of 4.

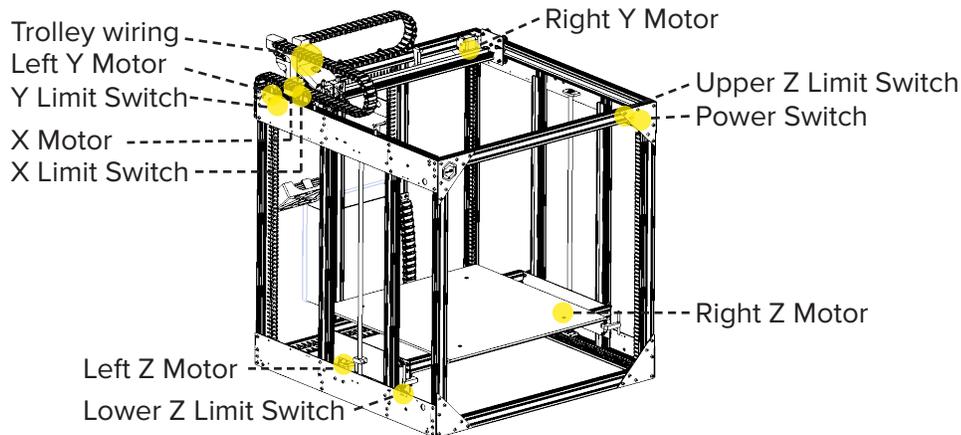


- D25** There are 6 T-nuts used here instead of 4. (See above)
- E2** This Panduit is the #2 size 29" Panduit, NOT the 30".
- E4** This is the #1 Size 24" Panduit.
- E6** This is the #4 size 30" Panduit.
- E8** Instead of M5x12 BHCS and 2 washers, assemble the corner brackets with M5x10 BHCS and no washers.
- F4** After placing the upper side plate assemblies on each side, install the Z upright alignment fixtures to the top and bottom of the Z uprights, using them to properly space the uprights (the fixtures should fit snugly). Fully fasten the upper side plate assembly to the Z uprights before removing the alignment fixtures. Repeat for the other side ([Step is demonstrated in the "Squaring the Frame" video at 14:30](#))
- F9** The right side rear corner rail uses a #1 size 30" Panduit, while the left side rear corner rail uses a #3 size 30" Panduit.
- F19** This graphic shows the old GB2 bridge assembly, but the method for mounting the bridge assembly is the same.
- F20** This graphic shows the old GB2 bridge assembly, but the method for mounting the bridge assembly is the same.
- F22** Follow the same steps as in A21 to install idler pulleys to each runway rail.

- F28** This is the #2 size 29" Panduit.
- F37** Install the M5x45 BHCS with 1 M5 flat washer each between the head of the screw and the rail. Do not over-tighten these, or you risk stripping out the threads in the plastic motor block.
- G9** Instead of adding grease to the nut cup, deposit a small bead of grease along the length of the ACME threaded rod. Moving the bed up and down during operation will spread the grease onto the threads.
- H1** This is a #2 size 31" Panduit.
- I1-I6** These steps are misnumbered. The steps shown only say C1, but they should number I1 to I6.
- I3** Pg. 82, bottom step. Lower Z limit switch is now mounted on the front of the lower left side plate.
- J2** Separate X & Y cable carrier coils into 8 link segments to better manage the wires. It is better to do trolley wiring and cable carrier installation simultaneously as seen in the GB3 wiring videos on our [YouTube channel](#).
- K2** If using a single extruder w/ single filament detection, FD 2 wire will be included anyway. You will need to short the FD2 limit switch wire using a jumper wire. It is recommended to insulate the connection with electrical tape.
- L3** Limit switch should be placed on the same side as the X motor cable connection.
- L9** The lower Z limit switch is now placed in the front left corner of the bot.

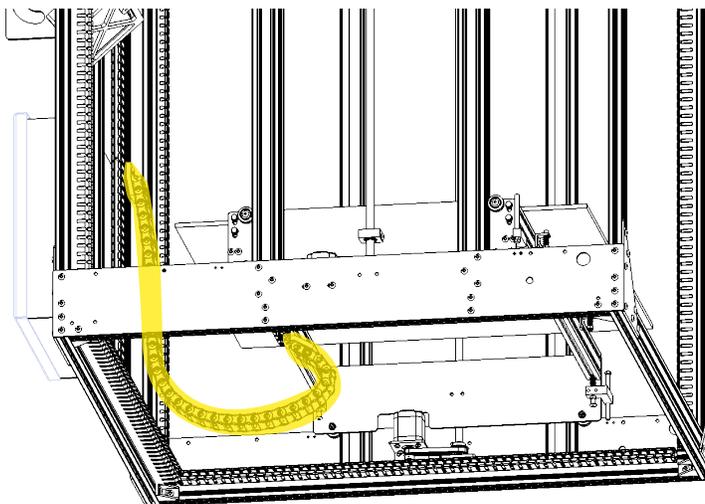


- L10** Graphic below is different now.

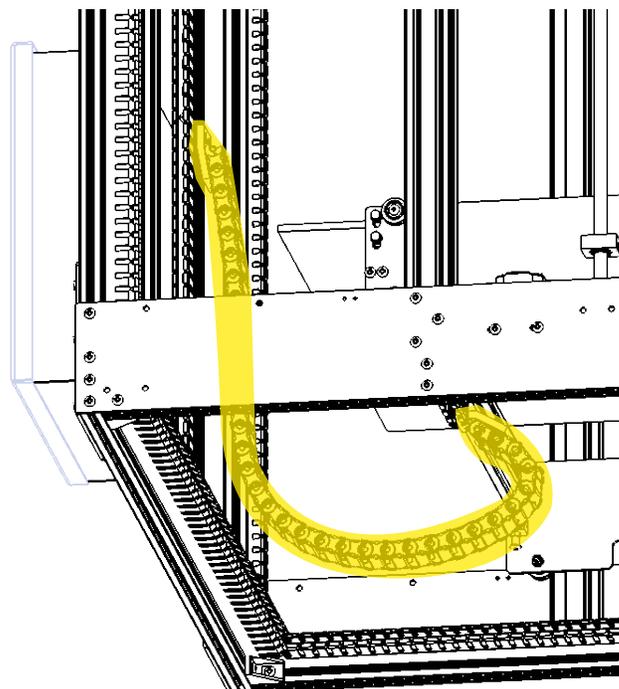


- M1** Spiralite no longer used--Omit this step and follow the step in M3.
- N3** Follow convention from A8 to install wheels.
- N5** Align the nut cups to the holes in the side plates by turning the MXL belt connecting the Z motors to the ACME threaded rods.
- N6** After the bot has been assembled, powered on, and homed, bring the bed down again until the bed side plates are about 2 to 3 mm from touching the Z motors (we suggest going to 590 then going to 600 in small increments. A bed distance of about 602mm should bring the side plates to the proper distance from the motors), then readjust the M5x70 hex head screw so it is actuating the lower Z limit switch. Also note that this leveling block is on the front left of the bed frame. [See a video of this general process on our YouTube channel](#).

- N7** Adjust the M5x70 screw so that 7/8" of thread is protruding from the bottom of the leveling block.
- N8** Make a mark on each cross rail 3.25" from the outside edge of the left bed side plate. Place the bed such that the left edge of the bed is flush with these marks. Make sure to orient the bed such that the wires point towards the rear of the frame.
- N10** Heated bed wires are already connected inside the box. Outside of the box, you will need to connect the ground wire to the heated bed using an M3 washer and M3x8 SHCS. Then connect the bed thermocouple wire and bed power wires. Route these into the bed frame Panduit. They will be routed into the Z cable carrier after homing the machine the first time. (See O10)
- N10** Heated bed wires are already connected inside the box. Outside of the box, you will need to connect the ground wire to the heated bed using an M3 washer and M3x8 SHCS. Then connect the bed thermocouple wire and bed power wires. Route these into the bed frame Panduit. They will be routed into the Z cable carrier after homing the machine the first time. (See O10)
- O7** Viki holder is now on the opposite side. Insert magic T-nuts into rear left vertical common rail instead.
- O8** Viki holder is now on the opposite side--installation is the same.
- O10** See the diagram below for another visual of cable carrier installation.



View from below



View from below



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