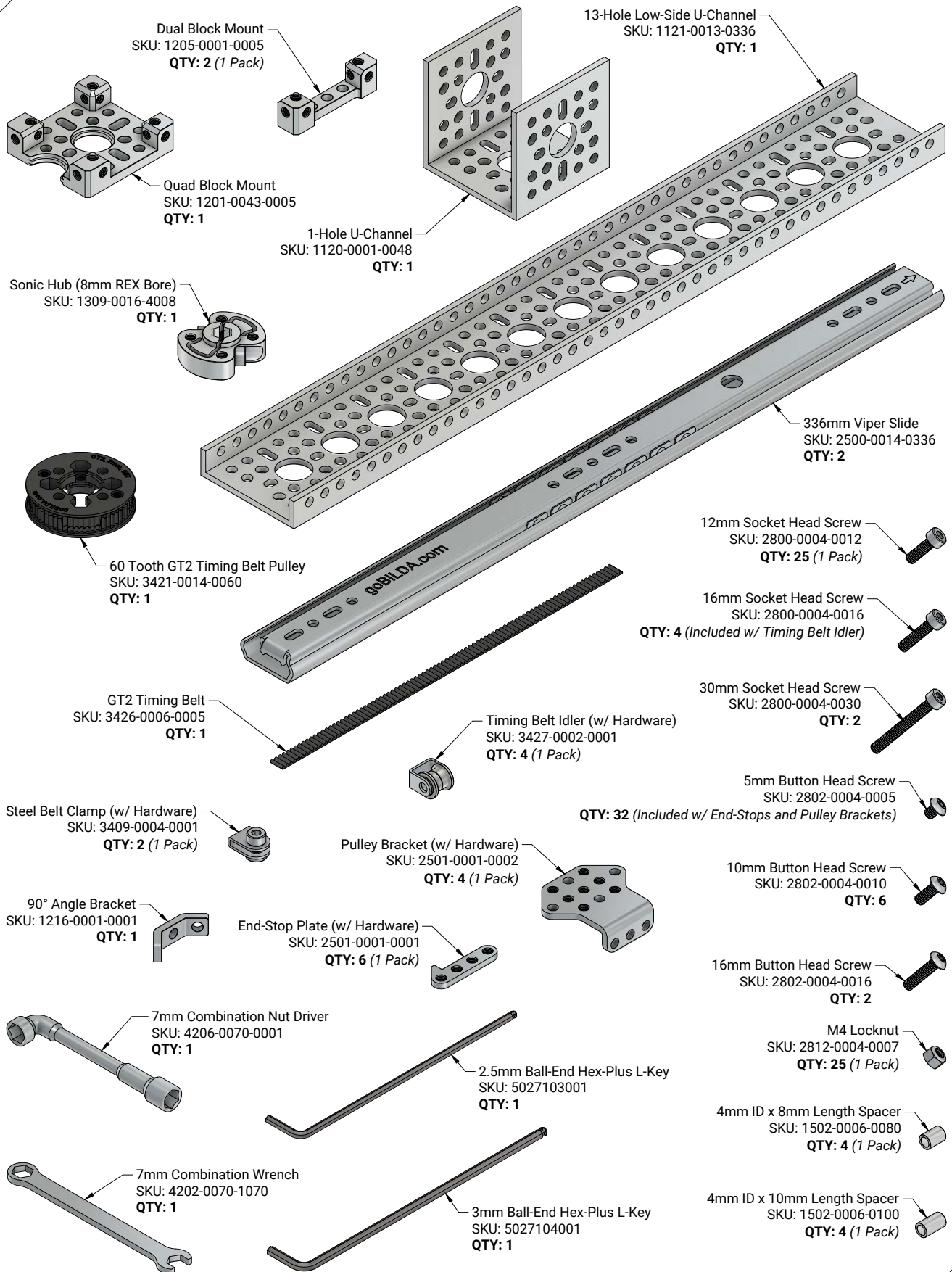




Assembly Instructions for
2 Stage Viper-Slide Kit (Belt-Driven, 336mm Slides)
SKU: 3210-0003-0002

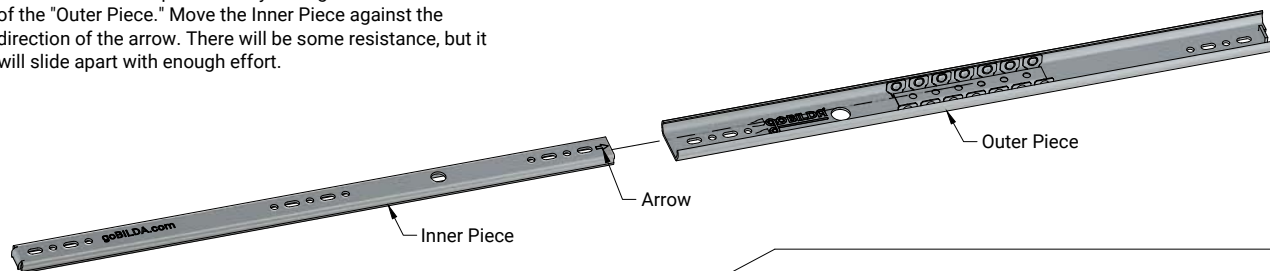


Kit Contents:

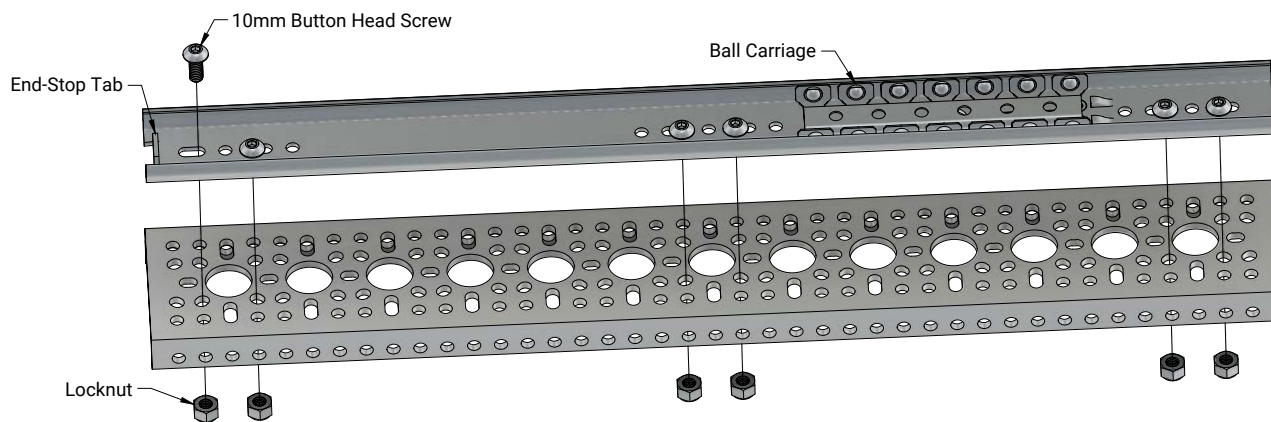


STEP 1:

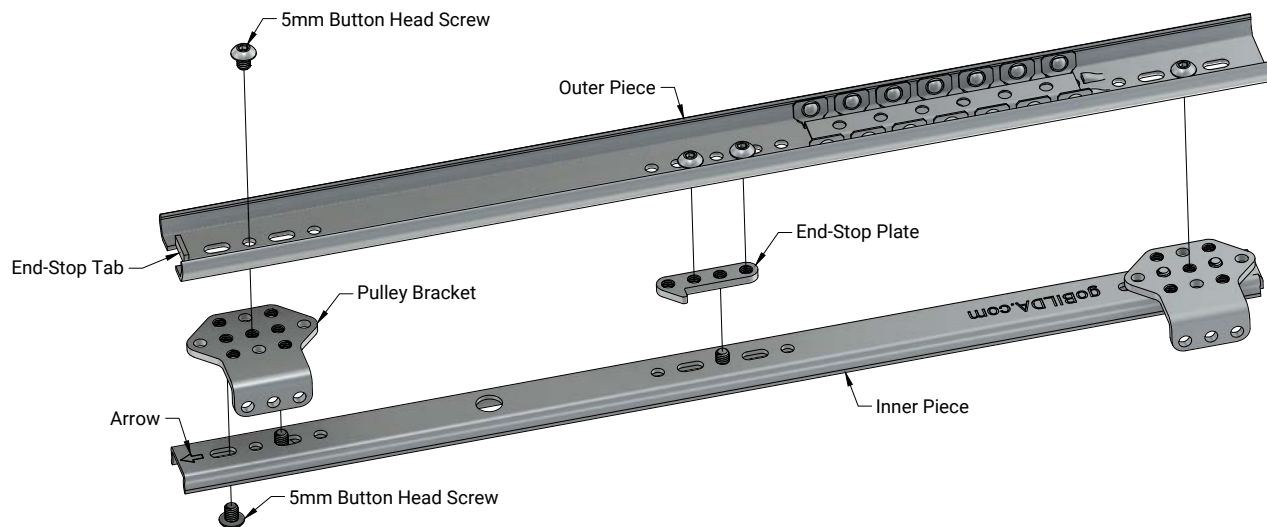
Disassemble **two** Viper Slides by sliding the "Inner Piece" out of the "Outer Piece." Move the Inner Piece against the direction of the arrow. There will be some resistance, but it will slide apart with enough effort.

**STEP 2 (Bottom Stage Subassembly):**

Fasten **one** Outer Piece to **one** 13-Hole Low-Side U-Channel with **six** 10mm Button Head Screws and **six** Locknuts. You will need to slide the Ball Carriage to access the holes in the middle. Align the "End-Stop Tab" with the left-hand side of the Low-Side U-Channel as shown.

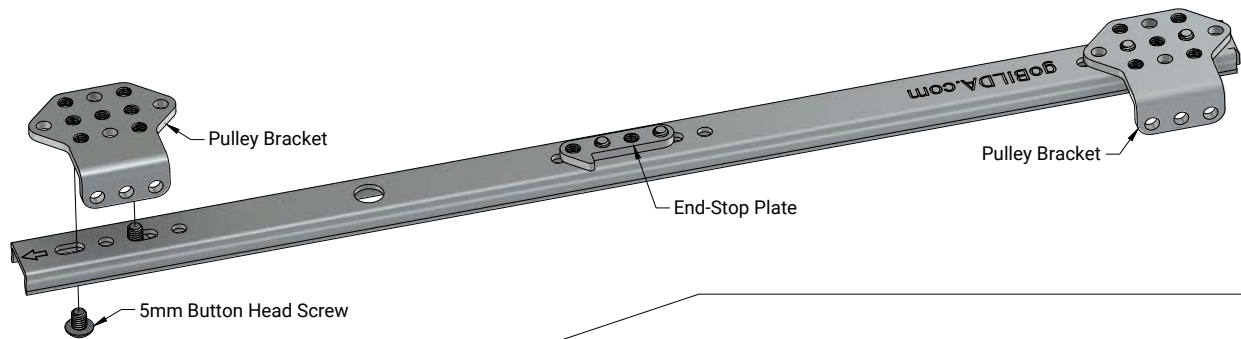
**STEP 3 (Middle Stage Subassembly):**

Build a new subassembly by using **nine** 5mm Button Head Screws and fastening **one** Outer Piece and **one** Inner Piece to **two** Pulley Brackets and **one** End-Stop Plate in the positions shown. Note that the "End-Stop Tab" on the Outer Piece should align with the "Arrow" on the Inner Piece as shown.



STEP 4 (Top Stage Subassembly):

Build another new subassembly by attaching **two** Pulley Brackets and **one** End-Stop Plate to the remaining Inner Piece with **five** 5mm Button Head Screws as shown.



STEP 5:

Slide the Middle Stage Subassembly on to the Bottom Stage Subassembly. Note the positions of the End-Stop Tabs for this step. Continue sliding until this first stage assembly is fully extended. This action aligns the Ball Carriage with the working range of the slide (**FIGURE 5-A**).

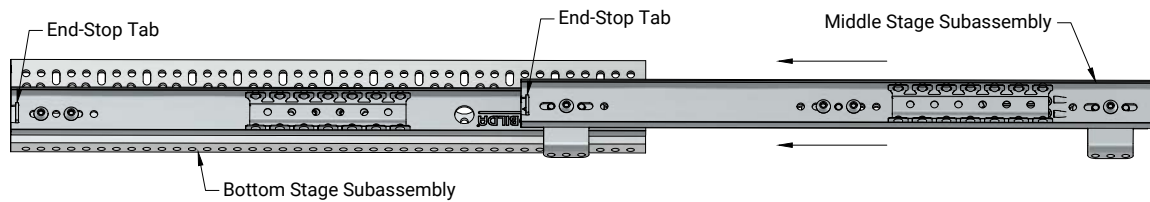
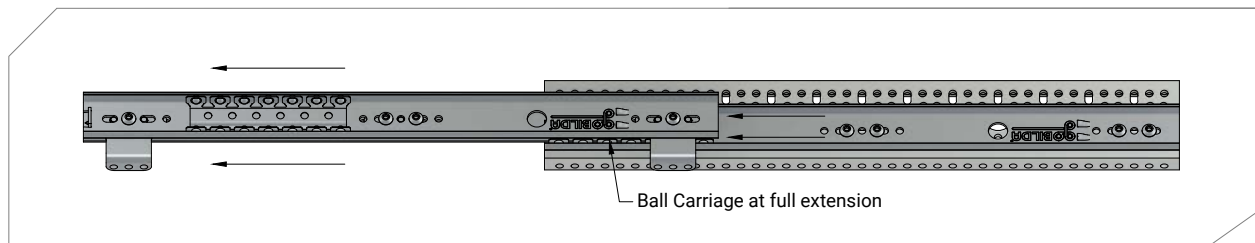
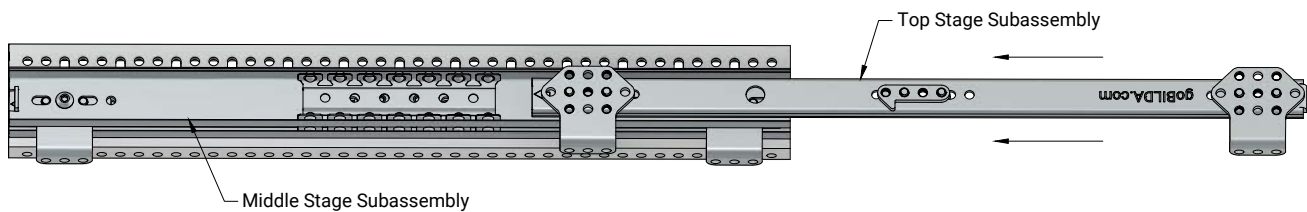


FIGURE 5-A



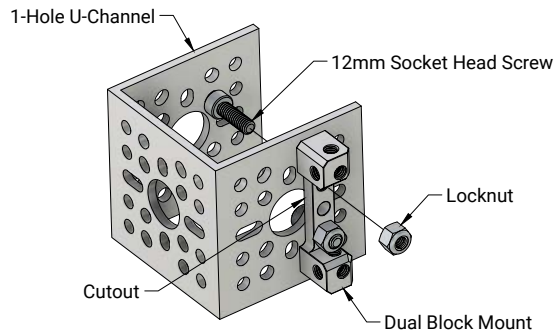
STEP 6:

Using the same procedure, add the Top Stage Subassembly to the Middle Stage Subassembly.

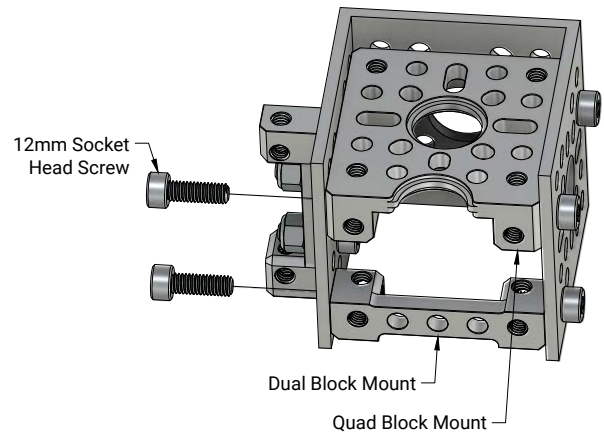


STEP 7:

Starting with **one** 1-Hole U-Channel, fasten **one** Dual Block Mount as shown with **two** 12mm Socket Head Screws and **two** Locknuts. The Dual Block Mount fastened to the outside of the U-Channel should align the "Cutout" nearest to the central 14mm hole.

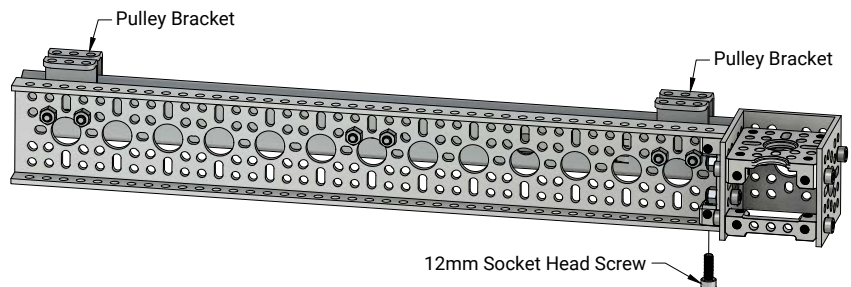
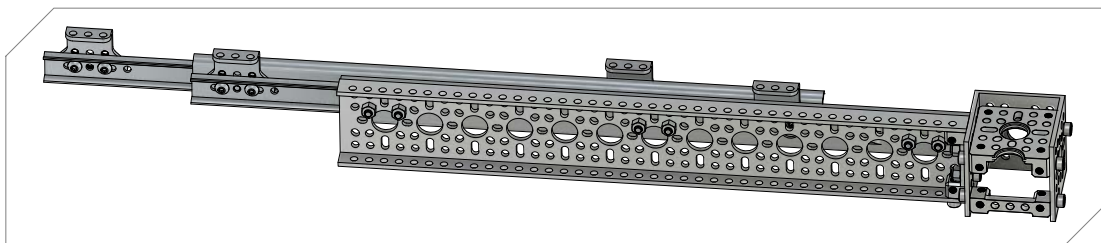
**STEP 8:**

Fasten **one** Quad Block Mount and **one** Dual Block Mount in the positions shown with **five** 12mm Socket Head Screws. Note that there should be only three screws fastened into the Quad Block Mount as shown.

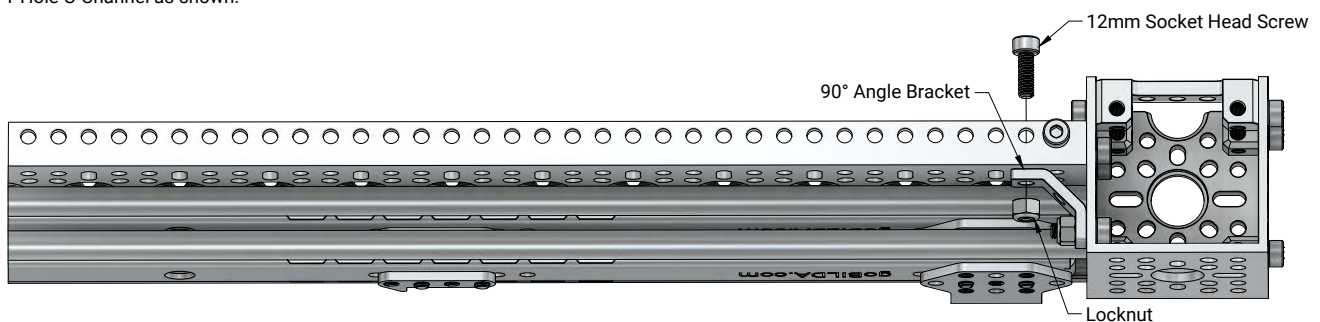
**STEP 9:**

Fasten the subassembly from **STEP 6** to the Dual Block Mount on the side of the 1-Hole U-Channel with **one** 12mm Socket Head Screw. Ensure that the Pulley Brackets are facing up as shown.

Check to make sure that the slides extend before continuing to the next step. **FIGURE 9-A** shows how the slides will move if they are oriented correctly.

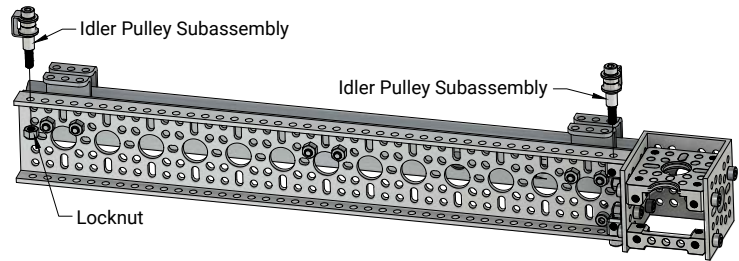
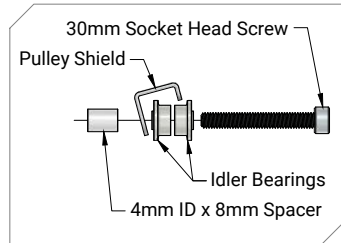
**FIGURE 9-A****STEP 10:**

Using **two** 12mm Socket Head Screws and **two** Locknuts, fasten **one** 90° Angle Bracket between the Low-Side U-Channel and the 1-Hole U-Channel as shown.

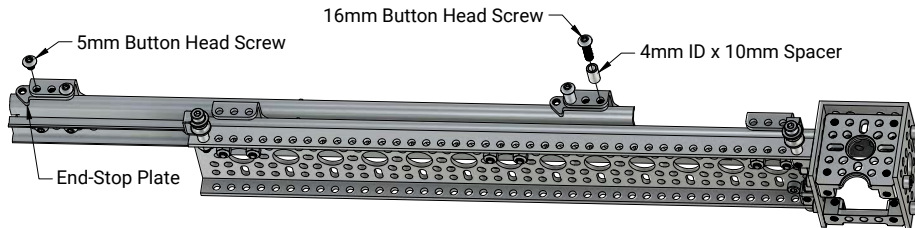
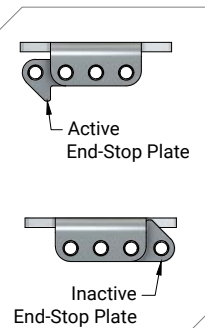


STEP 11:

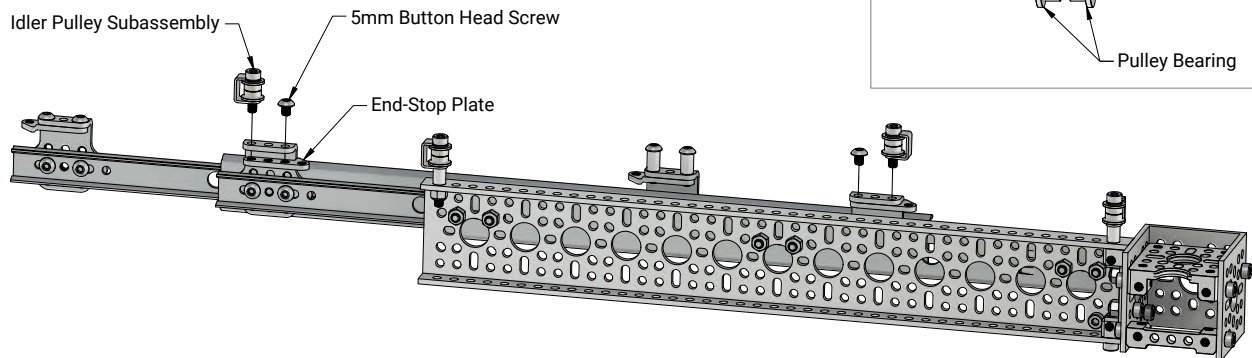
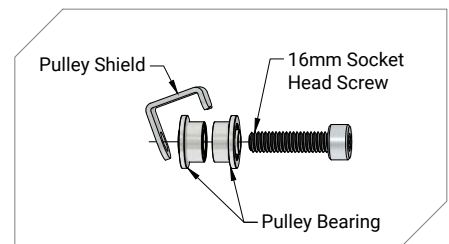
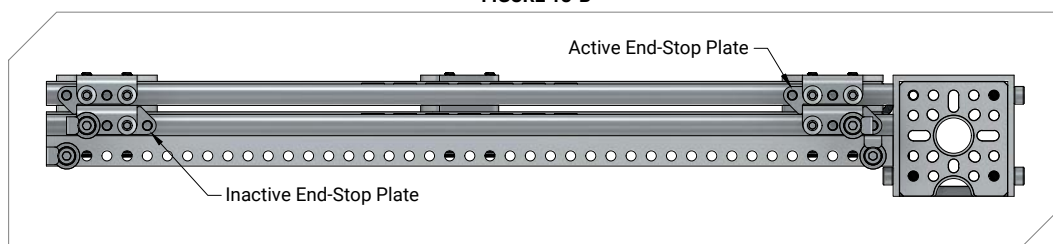
Assemble two Idler Pulley Subassemblies (**FIGURE 11-A**) using **two** 30mm Socket Head Screws, **two** Timing Belt Idlers, and **two** 4mm ID x 8mm Spacers. Fasten these subassemblies to the side of the 13-Hole Low-Side U-Channel in the positions shown. One Idler Pulley subassembly threads into **one** Locknut on the left-hand side, while the other threads into the Dual Block Mount on the right-hand side.

FIGURE 11-A**STEP 12:**

Attach **two** End-Stop Plates to the upper stage Pulley Brackets with **two** 5mm Button Head Screws, **two** 16mm Button Head Screws, and **two** 4mm ID x 10mm Spacers. Align the End-Stop Plates in the "Active" configuration (**FIGURE 12-A**).

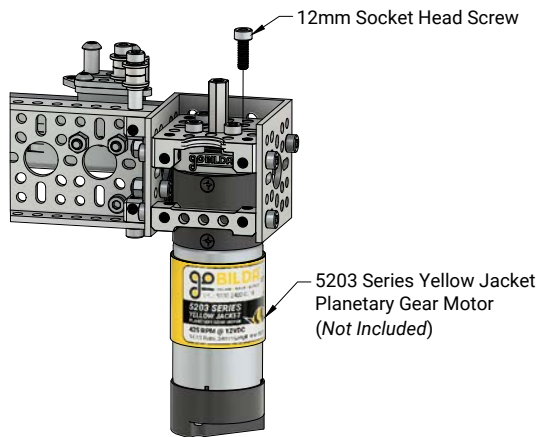
FIGURE 12-A**STEP 13:**

Assemble two Idler Pulley subassemblies with **two** 16mm Socket Head Screws and **two** Timing Belt Idlers (**FIGURE 13-A**). On the remaining Pulley Brackets, fasten two Idler Pulley Subassemblies and **two** 5mm Button Head Screws into **two** Inactive End-Stop Plates. Ensure that the Idler Pulley Subassemblies are fastened in the positions shown. **FIGURE 13-B** shows the correct orientation of all End-Stop Plate positions.

FIGURE 13-A**FIGURE 13-B**

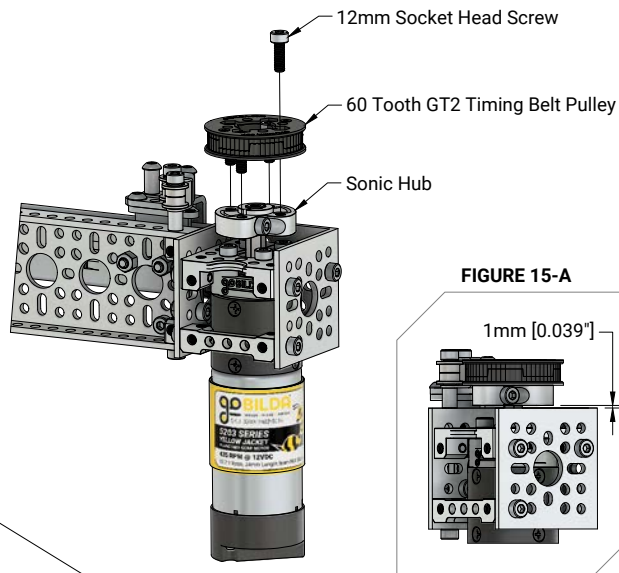
STEP 14:

Fasten **one** 5203 Series Yellow Jacket Planetary Gear Motor (*Not Included*) to the Quad Block Mount with **four** 12mm Socket Head Screws in the positions shown.

**STEP 15:**

Using **four** 12mm Socket Head Screws, fasten **one** 60 Tooth GT2 Timing Belt Pulley to **one** Sonic Hub. Slide the Sonic Hub on the output shaft of the 5203 Series Yellow Jacket Planetary Gear Motor (*Not Included*) and align the Timing Belt Pulley with the Timing Belt Idler (**FIGURE 15-A**). Tighten the Sonic Hub's Pinch Bolts completely.

Tech Tip: A credit card is approximately 1mm thick and can be helpful in spacing the Sonic Hub away from the U-Channel.

**Congratulations!**

Your 2-Stage Belt-Driven Viper Slide Kit is now assembled!
Watch this tutorial to learn how to rig your assembly.

<https://bit.ly/3J6Fn2q>

