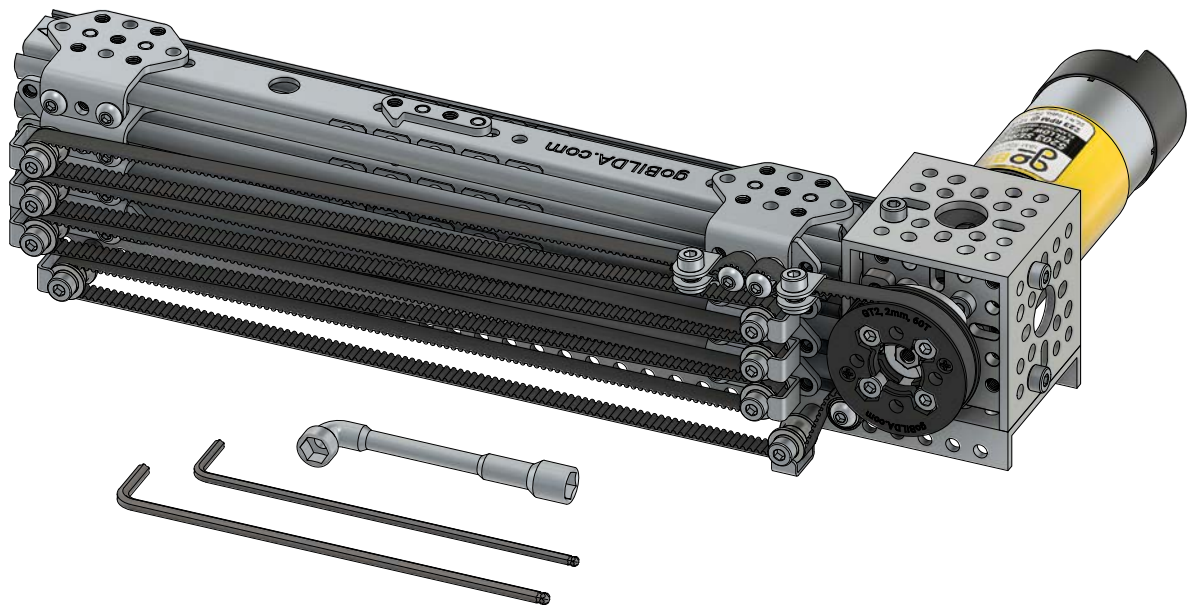
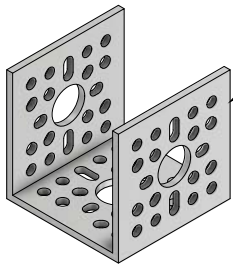




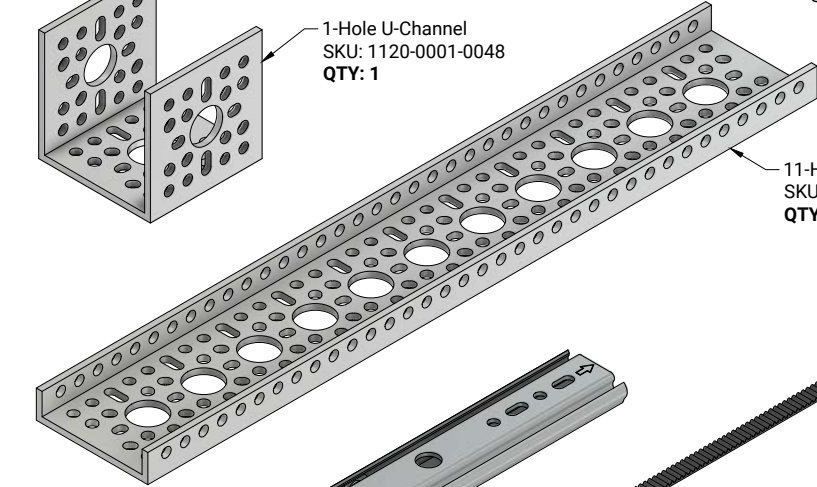
Assembly Instructions for
4 Stage Viper-Slide Kit (Belt-Driven, 240mm Slides)
SKU: 3210-0004-0004



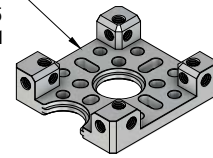
Kit Contents:



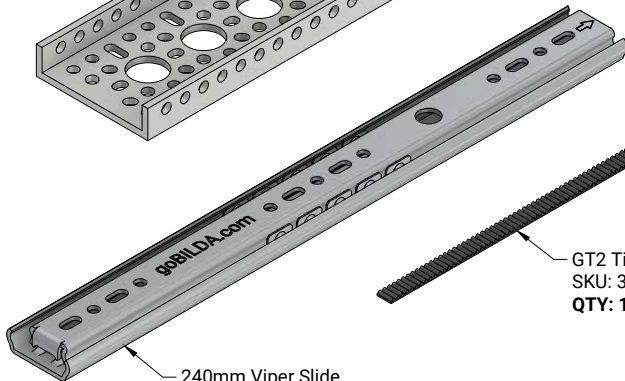
1-Hole U-Channel
SKU: 1120-0001-0048
QTY: 1



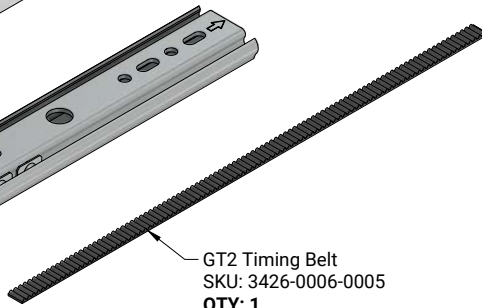
11-Hole Low-Side U-Channel
SKU: 1121-0011-0288
QTY: 1



Quad Block Mount
SKU: 1201-0043-0005
QTY: 1



240mm Viper Slide
SKU: 2500-0010-0240
QTY: 4



GT2 Timing Belt
SKU: 3426-0006-0005
QTY: 1

8mm Socket Head Screw
SKU: 2800-0004-0008
QTY: 3

12mm Socket Head Screw
SKU: 2800-0004-0012
QTY: 15

30mm Socket Head Screw
SKU: 2800-0004-0030
QTY: 3

End-Stop Plate
SKU: 2501-0001-0001
QTY: 12

4mm Button Head Screw
SKU: 2802-0004-0004
QTY: 7

5mm Button Head Screw
SKU: 2802-0004-0005
QTY: 39

Pulley Bracket
SKU: 2501-0001-0002
QTY: 8 (2 Packs)

Timing Belt Idler (w/ Hardware)
SKU: 3427-0002-0001
QTY: 8

10mm Button Head Screw
SKU: 2802-0004-0010
QTY: 7

Belt Clamp (w/ Hardware)
SKU: 3409-0004-0001
QTY: 2

16mm Button Head Screw
SKU: 2802-0004-0016
QTY: 3

7mm Combination Nut Driver
SKU: 4206-0070-0001
QTY: 1

90° Angle Bracket
SKU: 1216-0001-0001
QTY: 1

Locknut
SKU: 2812-0004-0007
QTY: 12

2.5mm Ball End Hex-Plus L-Key
SKU: 5027103001
QTY: 1

Idler Arm (w/ Hardware)
SKU: 1524-0001-0002
QTY: 1

8mm Spacer
SKU: 1502-0006-0080
QTY: 2

3mm Ball End Hex-Plus L-Key
SKU: 5027104001
QTY: 1

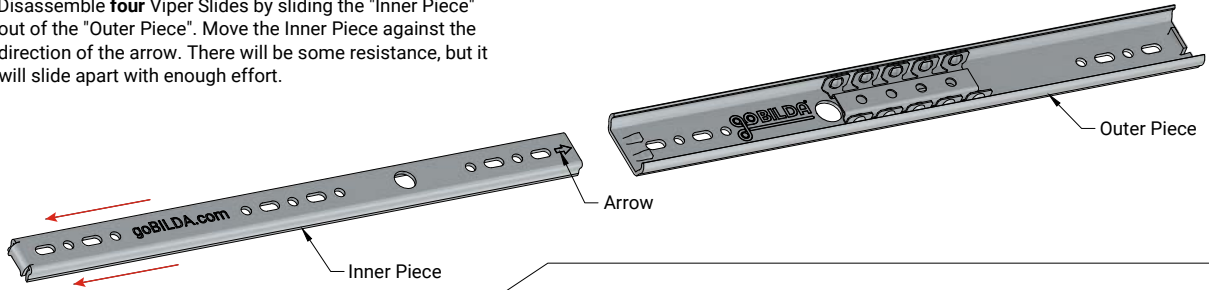
GT2 Timing Belt Pulley
SKU: 3421-0016-0060
QTY: 1

10mm Spacer
SKU: 1502-0006-0100
QTY: 2

8mm REX™ Sonic Hub
SKU: 1309-0016-4008
QTY: 1

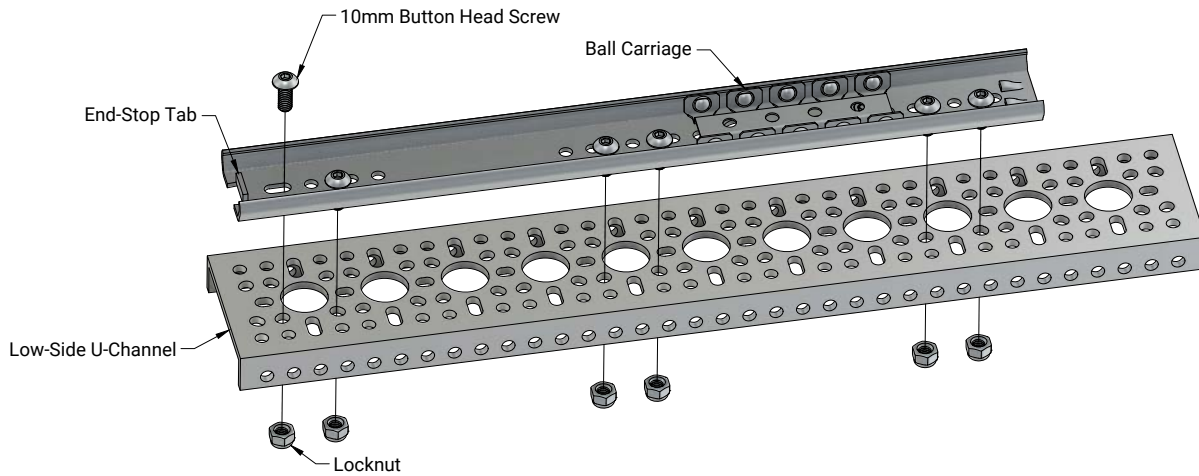
STEP 1:

Disassemble **four** 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:

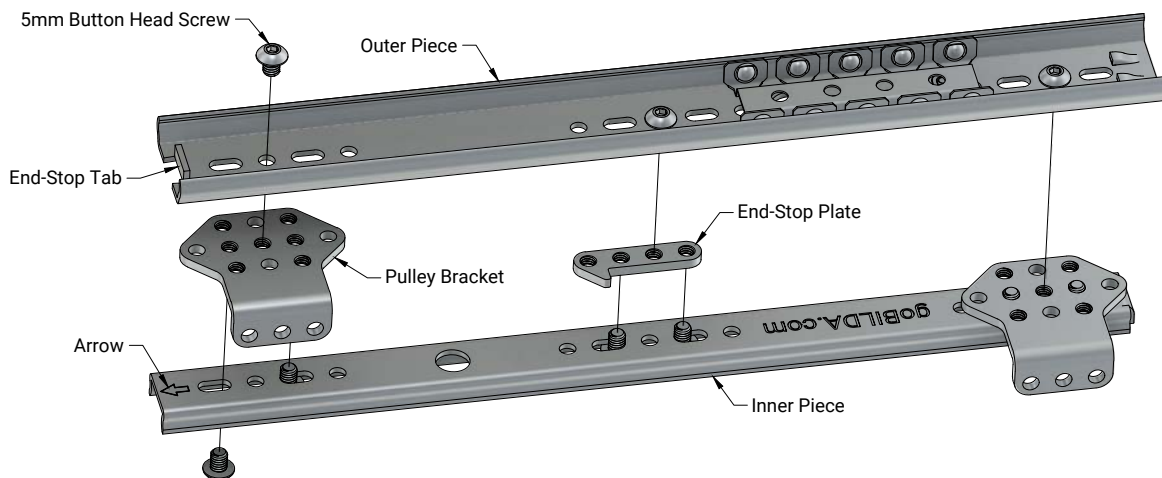
Fasten **one** Outer Piece to **one** 11-Hole Low-Side U-Channel with **six** 10mm Button Head Screws and **six** Locknuts. Slide the Ball Carriage to access the holes in the middle. Note the Location of the "End-Stop Tab" is on the left-hand side when mounting the Low-Side U-Channel as shown.



STEP 3 — Middle Stage Subassembly:

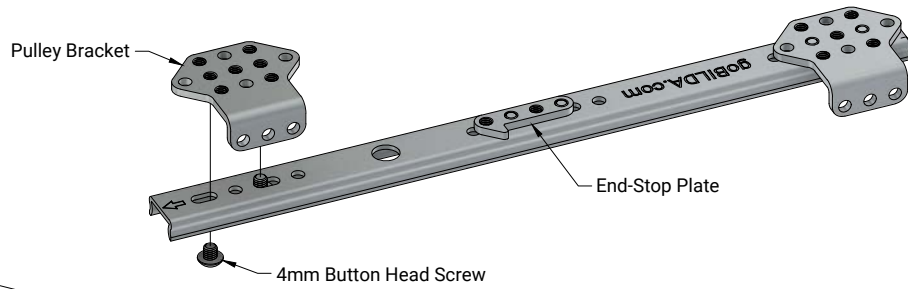
Build a new subassembly by using **nine** 5mm Button Head Screws to fasten **one** Outer Piece and **one** Inner Piece to **two** Pulley Brackets and **one** End-Stop Plate in the positions shown. Note that the End-Stop Tab on the Outer Piece should align with the Arrow on the Inner Piece as shown.

Repeat this step twice to build three identical Middle Stage Subassemblies.



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 **six** 4mm Button Head Screws as shown.



STEP 5:

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

Repeat this process and install the remaining two Middle Stage Subassemblies.

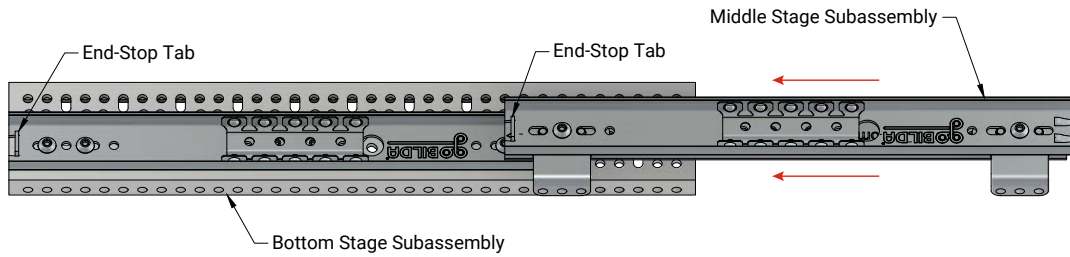
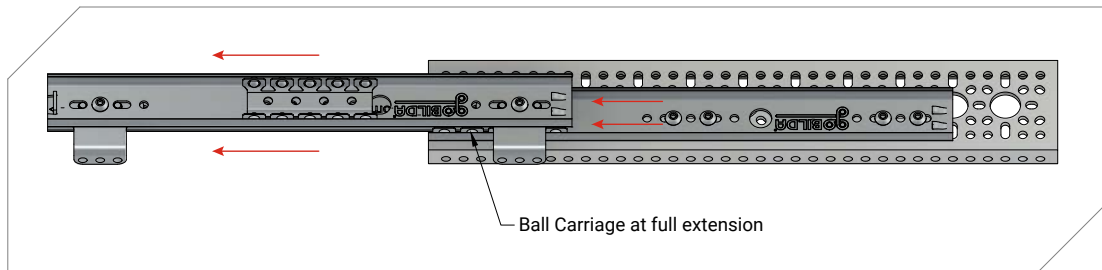
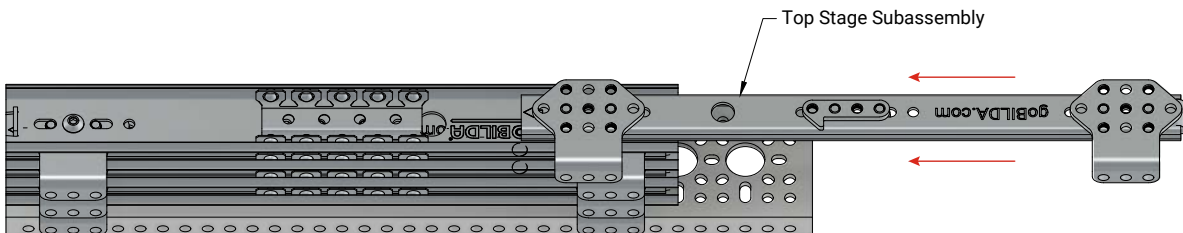


FIGURE 5-A



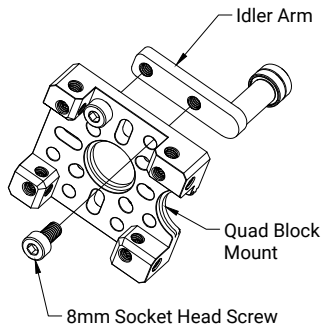
STEP 6:

Add the Top Stage Subassembly using the same procedure from **STEP 5**.



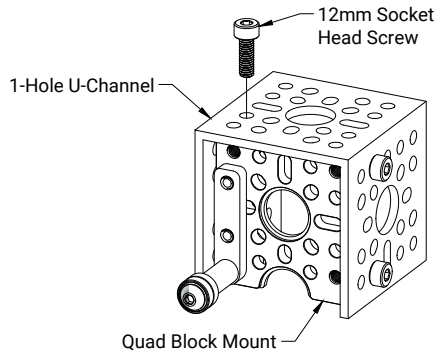
STEP 7:

Attach **one** Idler Arm to **one** Quad Block Mount using **two** 8mm Socket Head Screws (Included with Idler Arm.)



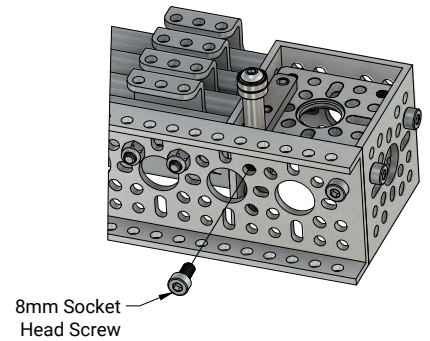
STEP 8:

Starting with **one** 1-Hole U-Channel, attach the subassembly from **STEP 7** with **three** 12mm Socket Head Screws as shown.



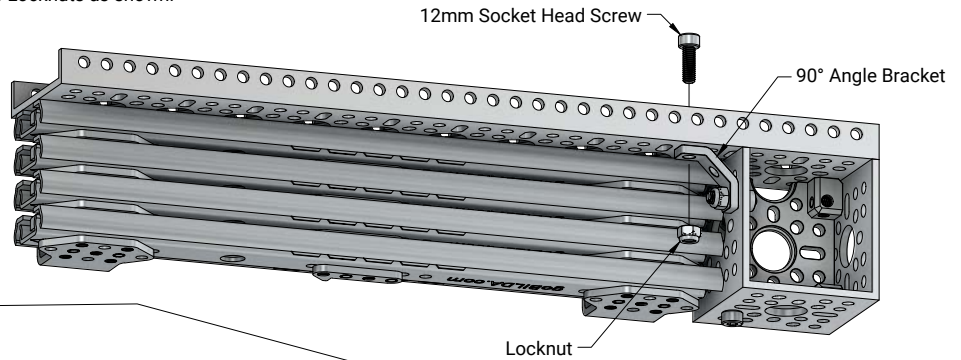
STEP 9:

Fasten the subassembly from **STEP 8** to the 11-Hole Low-Side U-Channel with **two** 8mm Socket Head Screws as shown.



STEP 10:

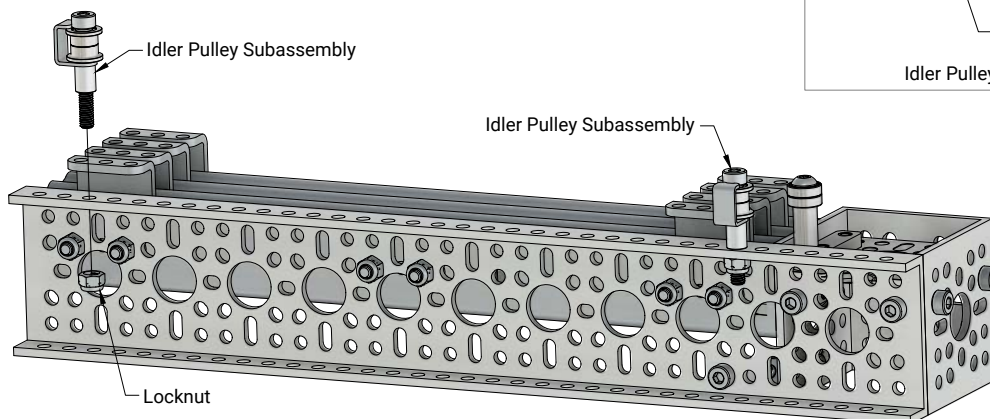
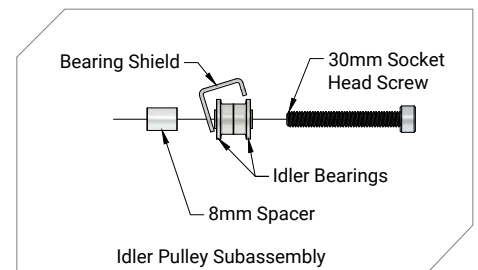
Fasten **one** 90° Angle Bracket between the 11-Hole Low-Side U-Channel and the 1-Hole U-Channel with **two** 12mm Socket Head Screws and **two** Locknuts as shown.



STEP 11:

Assemble **two** 30mm socket head screws, **two** Timing Belt Idlers, and **two** 8mm spacers to build two Idler Pulley Subassemblies (**FIGURE 11-A**). Attach Idler Pulley Subassemblies using **two** locknuts to the side of the 11-hole Low-Side U-Channel in the positions shown.

FIGURE 11-A



STEP 12:

Attach **two** End-Stop Plates with **two** 5mm Button Head Screws, **two** 16mm Button Head Screws, and **two** 10mm Spacers as shown. Orient the End-Stop Plates to be in the "Active" configuration (**FIGURE 12-A**).

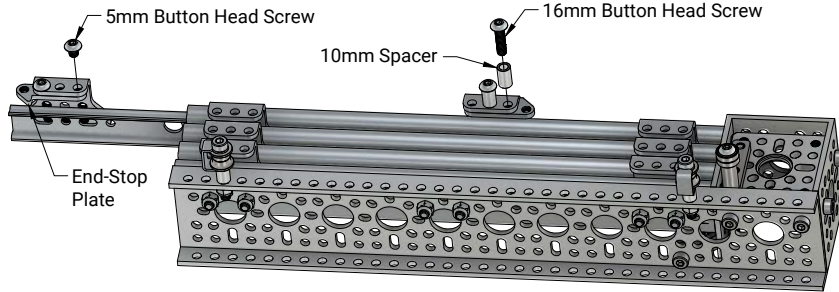
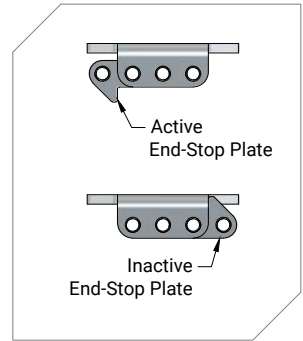


FIGURE 12-A



STEP 13:

Create six Idler Pulley Subassemblies using **six** 16mm Socket Head Screws (Included with Timing Belt Idlers) and **six** Timing Belt Idlers (**FIGURE 13-A**). On the remaining Pulley Brackets, fasten six Idler Pulley Subassemblies and **six** 5mm Button Head Screws onto the **four** Active End-Stop Plates and **two** Inactive End-Stop Plates as shown. **FIGURE 13-B** shows the correct orientation of all End-Stop Plate Positions.

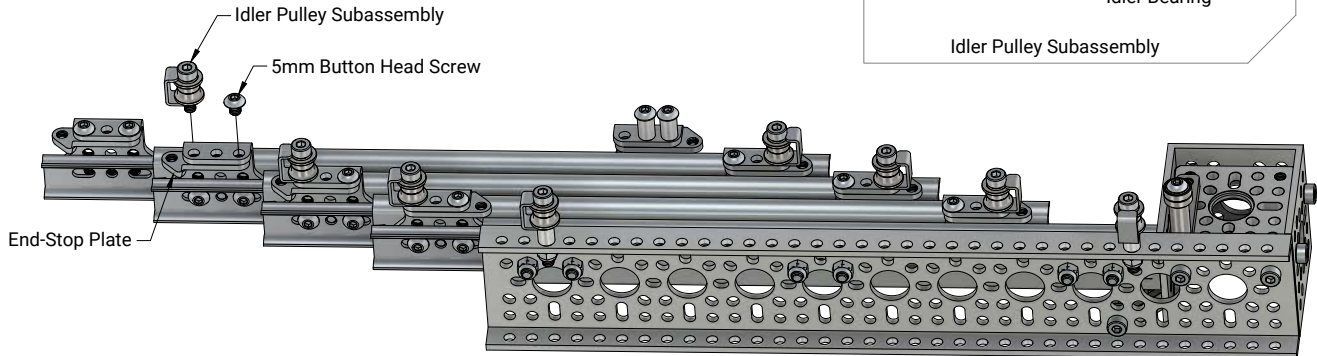


FIGURE 13-A

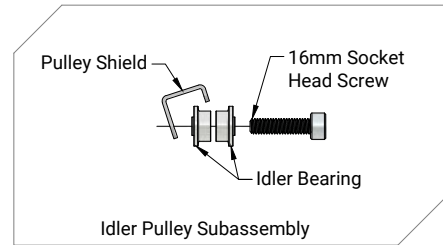
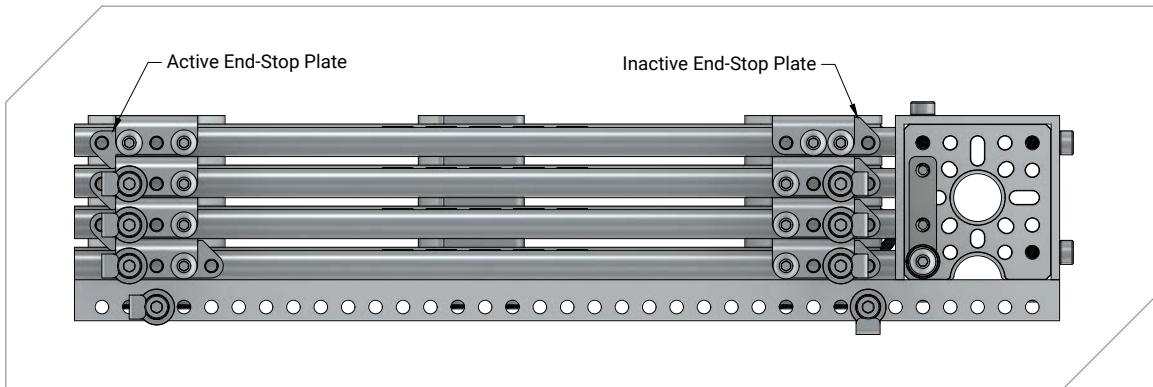
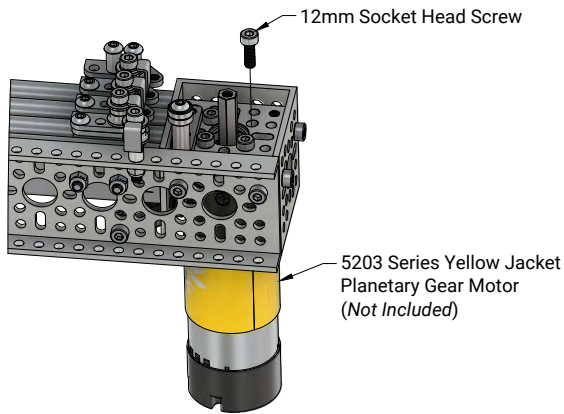


FIGURE 13-B



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** 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 GT2 Timing Belt Pulley with the Idler Arm ball bearings. (**FIGURE 15-A**). Tighten the Sonic Hub.

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

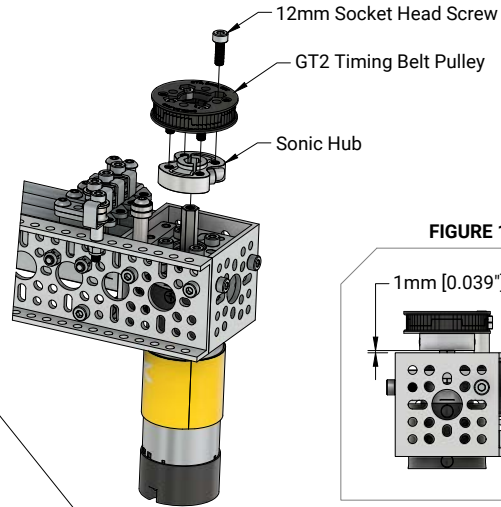
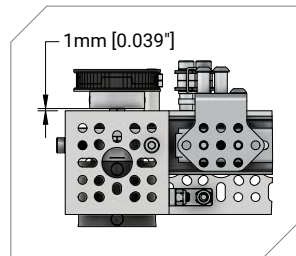


FIGURE 15-A



Congratulations!

Your 4-Stage Belt-Driven Viper Slide Kit is now assembled.
Watch this tutorial to learn how to rig your assembly:

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

