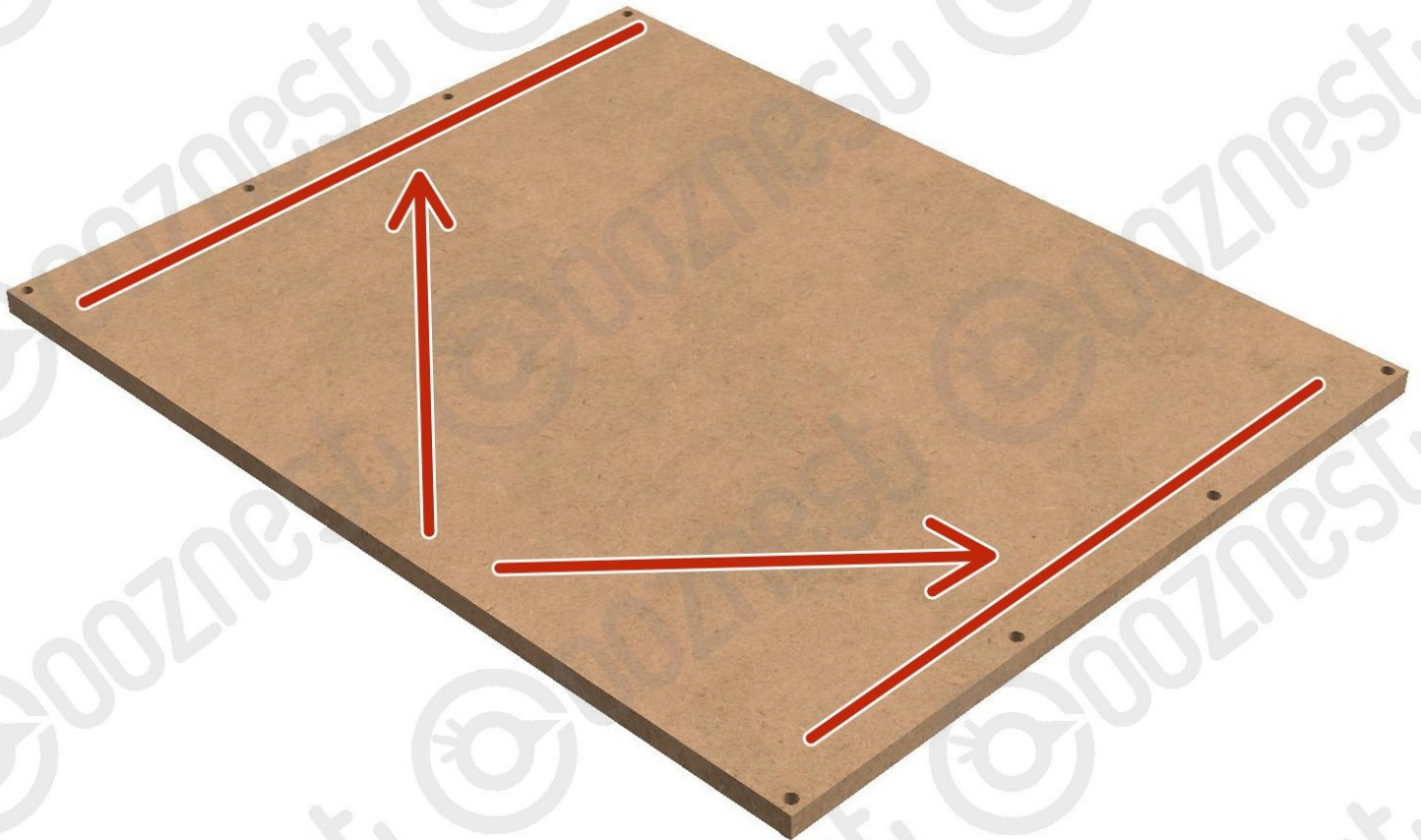


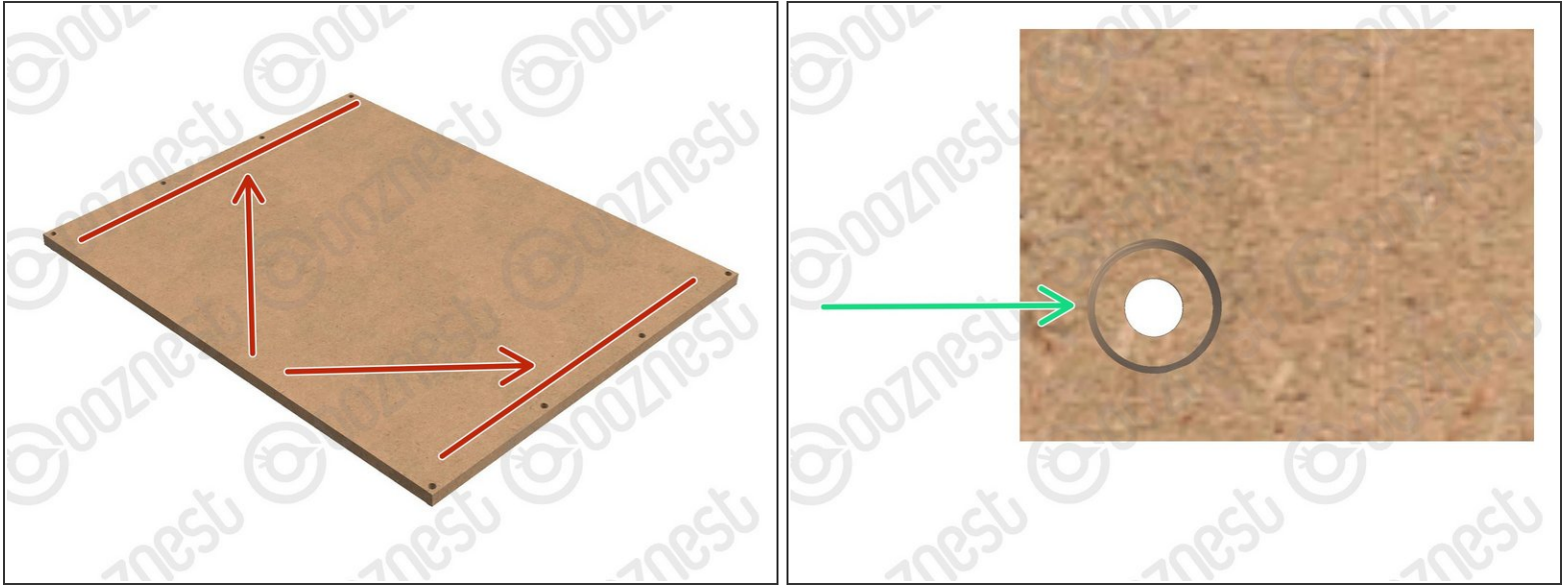


## 3. Spoilerboard

Written By: Ryan Christy

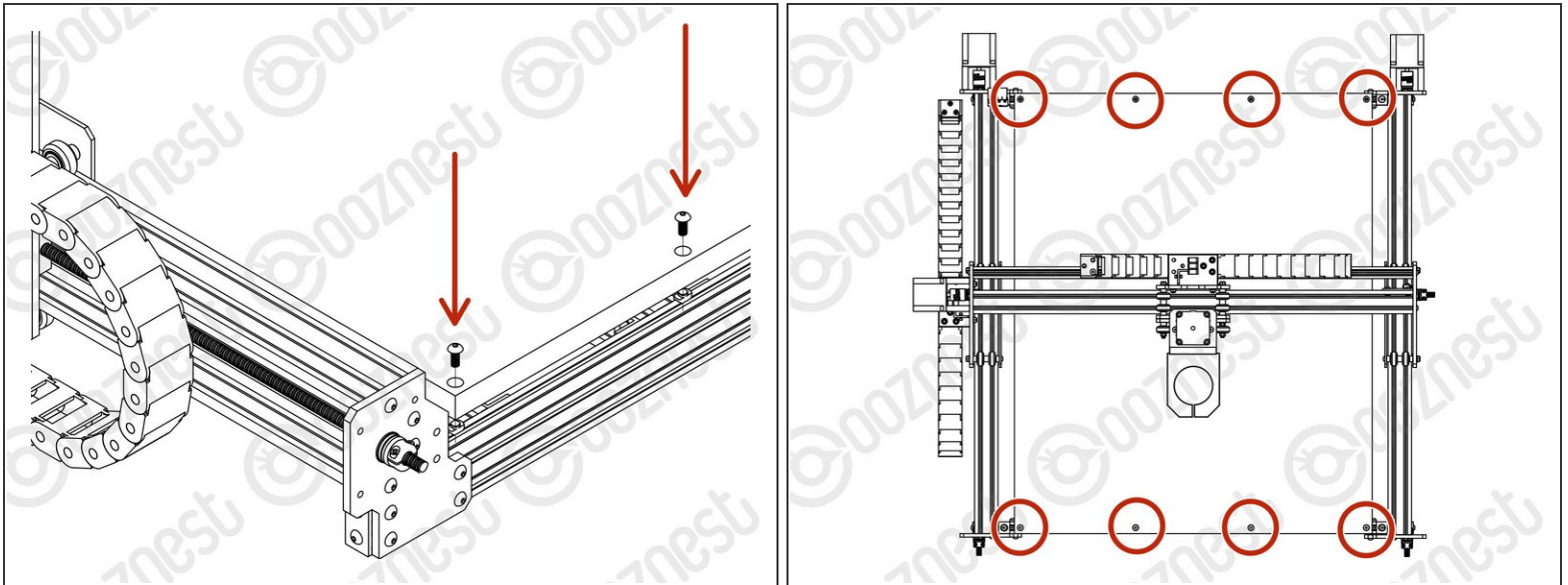


## Step 1 — Preparing the Spoilerboard



- We recommend using 18mm MDF for the Spoilerboard. This will give a maximum cut depth the whole way through of 44mm.
- Cut the Spoilerboard to size following the dimensions given here: [here](#)
- ① For the 1500x1500mm ideally you should try and source a 10' x 5' sheet of 18mm MDF.
- At each end of the Spoilerboard, 10mm in from the edge, drill four 5mm Diameter Holes. One in each corner, and then evenly spaced in the middle.
- For each hole drill a 10mm diameter countersink, 11mm deep.

## Step 2 — Fixing the Spoiler Board



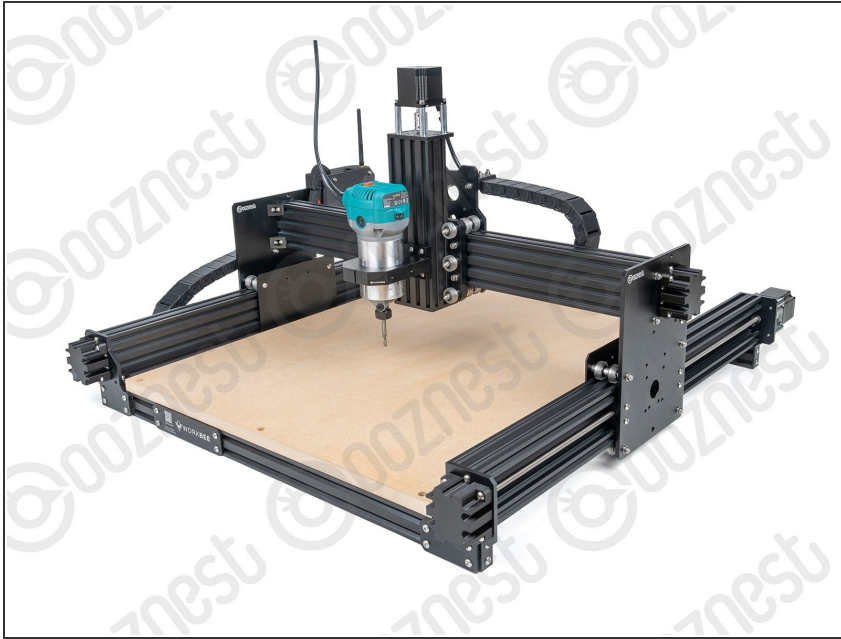
- Using 8 x M5-Button-Head-Bolt-12mm and 8 x M5-Drop-In-Tee-Nut secure the Spoilerboard to the front and back Extrusion-A's.

**⚠ Make sure the M5-Drop-In-Tee-Nuts are engaged with the slot on Extrusion-A.**

- i** A good technique, is to tighten, then loosen the bolt, then tighten, each time tightening a bit more. This helps the M5-Drop-In-Tee-Nut to engage with the slot.
- i** Once you have the Spoilerboard in place you use a variety of methods to hold down your projects.

  - The UJK System from [Axminster](#) is very good.
  - Or you can also do a [pronged tee nut system](#).

## Step 3 — Machine Complete



- ❗ Congratulations you have finished building your Original WorkBee Z1+ CNC Machine.
- ❗ Your journey into the world of CNC has only just begun.
- Whats Next?
  - Finish [Assembling Your Original WorkBee XYZ Touch Probe](#) From Step 5 onwards.
  - ⚠ Then read the [Safety Instructions](#).
  - Complete your [First Project](#)

Thanks for following the guide. Any issues, please contact us!