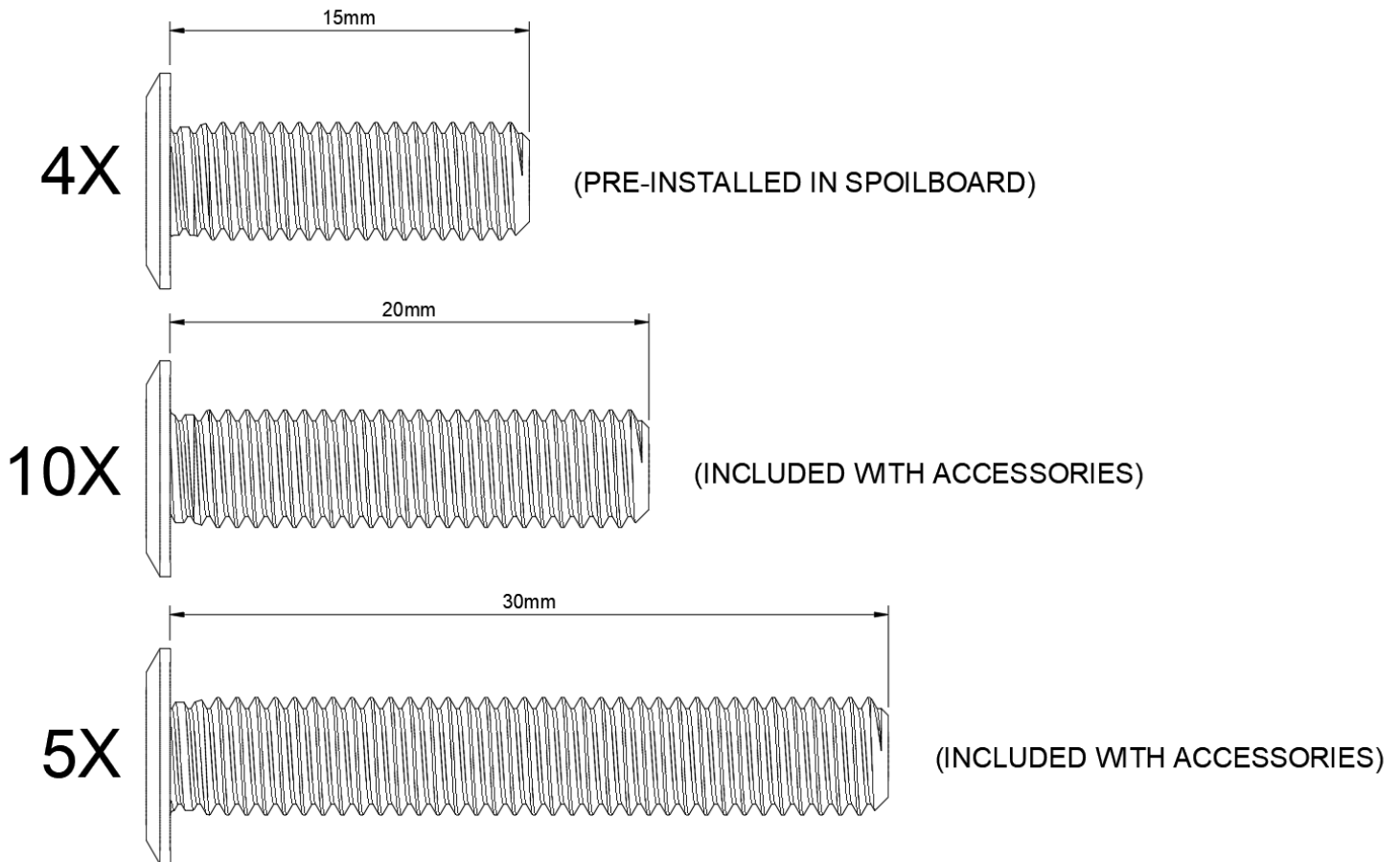


SMW Fixture Plate Installation

Makera Z1 Fixture Plate [S2180, S2181]

1. Installation Hardware

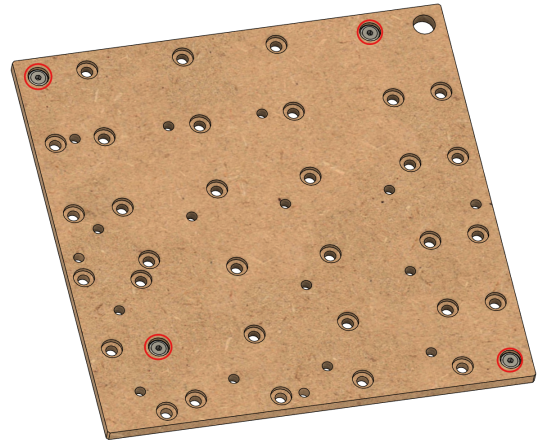
Before installing your fixture plate, note the (3) sizes of M5 bolt included with your machine:



Installation will require (5) M5 bolts. We recommend sourcing (5) 15mm long socket head screws (e.g. [McMaster 91290A231](#)), however using the (4) included 15mm bolts and (1) included 20mm long screw is acceptable - see step 4.

2. Remove the Spoilboard

The MDF spoilboard is secured to your Z1's bed with four 15mm long M5 bolts. Removing these allows lifting the spoilboard off to expose the machine's bed.



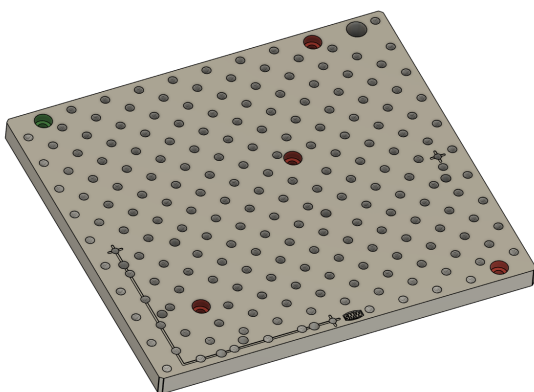
3. Clean All Mounting Surfaces

Ensure both the Z1's bed and the underside of the fixture plate are free from burrs, chips, and other debris.

4. Install Fixture Plate

Place the fixture plate onto the Z1's bed. The SMW logo should be facing out towards the machine's door with the clearance hole at the top right of the fixture plate for the toolsetter.

Install the (5) mounting bolts (*leave them finger tight for now*). We recommend using five 15mm long M5 screws for securing - should you choose to use only the four included 15mm bolts and one 20mm long bolt, please follow the below configuration:



(1) 20mm Bolt (top left hole) - will protrude the bottom of the bed ~3mm.
Ensure this is acceptable for your machine.

(4) 15mm Bolts - note that anything longer than 15mm will **not** fit in the center hole.

5. Tram Fixture Plate

The final step is to align the fixture plate's hole pattern with your machine's X & Y axes. In depth text and video instructions are available [here](#) (or see QR code).

For smaller fixture plates, it's often easier to use the front edge of the fixture plate instead of the vise shown in our setup video.

