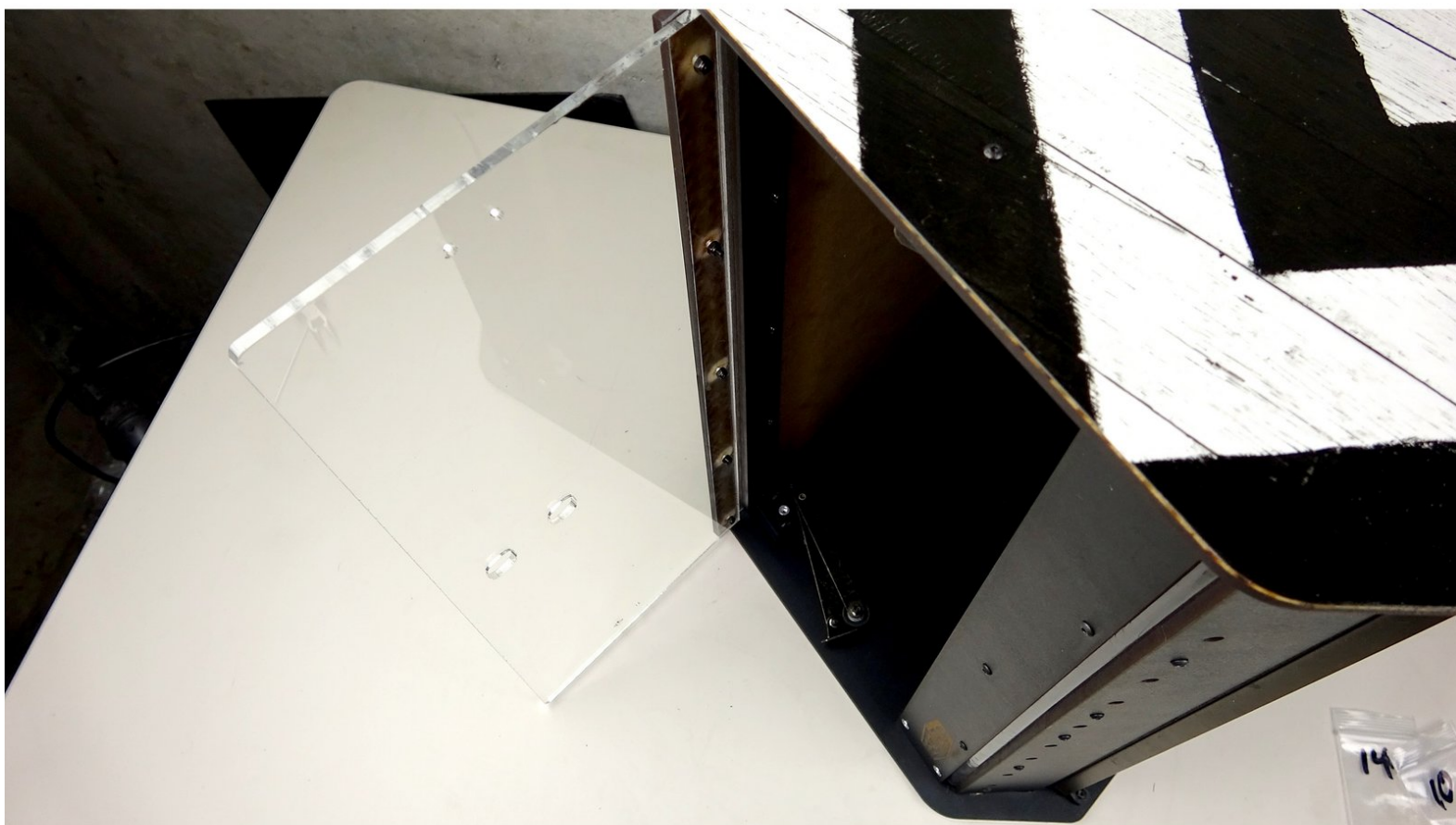


Repkord

STAGE 6 - Front Acrylic Assembly

Written By: Pooch



Step 1 — Parts and Pieces



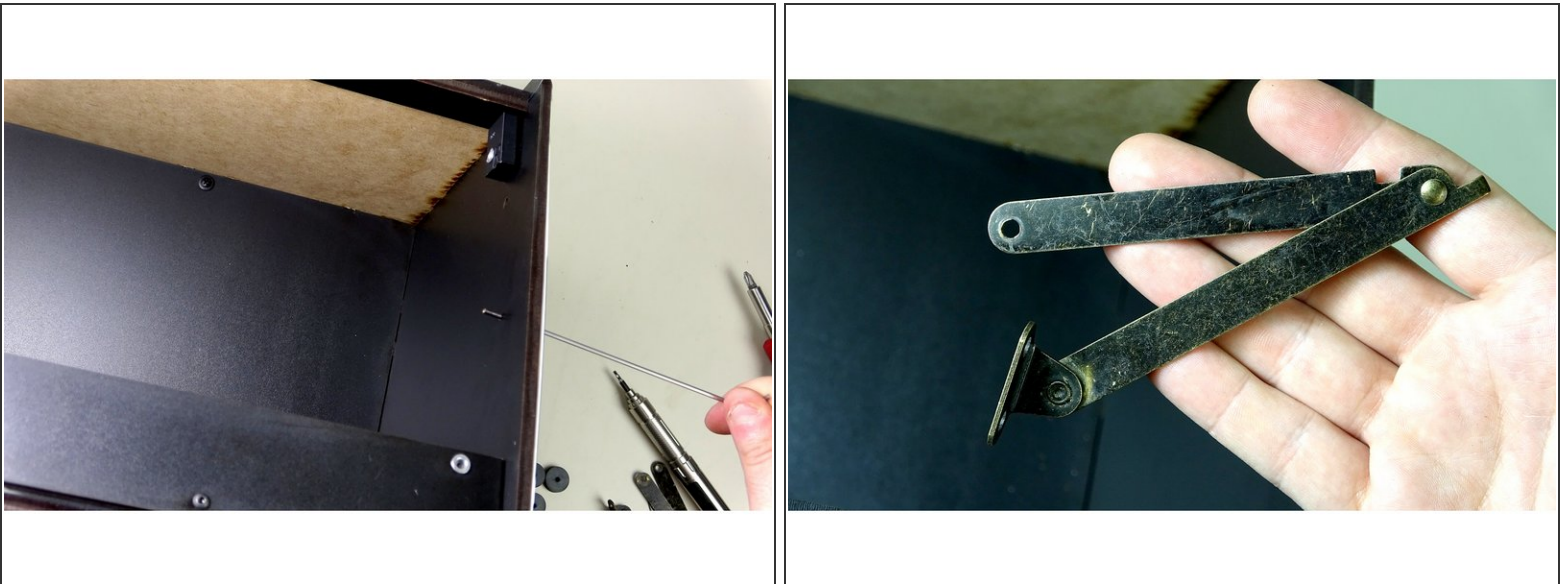
- Lid Stay Hinges (One complete, one missing the end mount)
 - 25mm Bolts, Washers, Nylock Bolts.
 - Laser Cut Circular Standoffs
 - One 3D Printed Bushing from the roller parts bag.
 - 10mm Bolt, Nylock, washers
 - Loose End Mount
- i** For the Seal Kit the 4x Laser etched spacers will be integrated into the NEW 3D Printed parts installed earlier.

Step 2 — Installing the Right Lid Stay Hinge (Standard Kit)



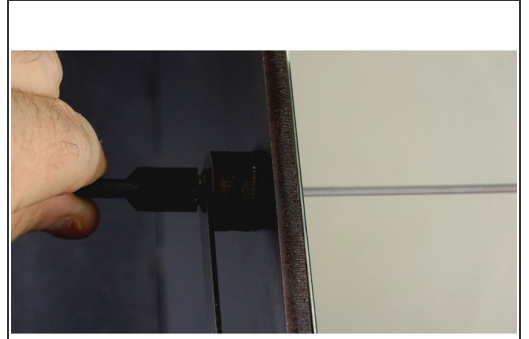
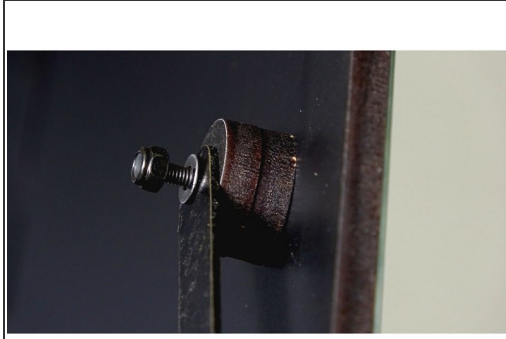
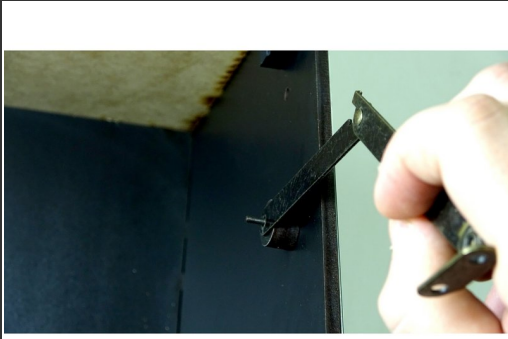
- Insert a 25mm Bolt through the right Graphic side panel, to inside of the inner compartment.
- Place two of the Laser Cut standoffs on the bolt.
- Grab the Hinge that has the end mount already attached.

Step 3 — Installing the Right Lid Stay Hinge (Sealed Kit)



- Insert a 25mm Bolt through the right Graphic side panel and the Seal bar(not pictured), to the inside of the inner compartment.
- Grab the Lid Hinge with the end mount intact. It The second picture shows the orientation that it will be installed.

Step 4 — Installing the Right Lid Stay Hinge (Standard Kit)



- Place the Hinge over the bolt, followed by a washer.
 - ⓘ Pay close attention to the orientation of the Hinge. It should fold upward like in the first picture.
 - Place a nylock nut on the bolt and tighten down just enough to make contact with the arm.
- ⚠ Do NOT tighten to the point the arm does not move.**
- ⓘ For the Seal Kit the 4x Laser etched spacers will be integrated into the NEW 3D Printed parts installed earlier.

Step 5 — Installing the Right Lid Stay Hinge (Sealed Kit)



- Place the arm onto the bolt, followed by a washer.
- Secure into place using a nylock nut.

⚠ Tighten down just enough to make contact with the arm. Do NOT tighten to the point the arm does not move.

i The last picture is of the standard kit, but shows proper arm orientation.

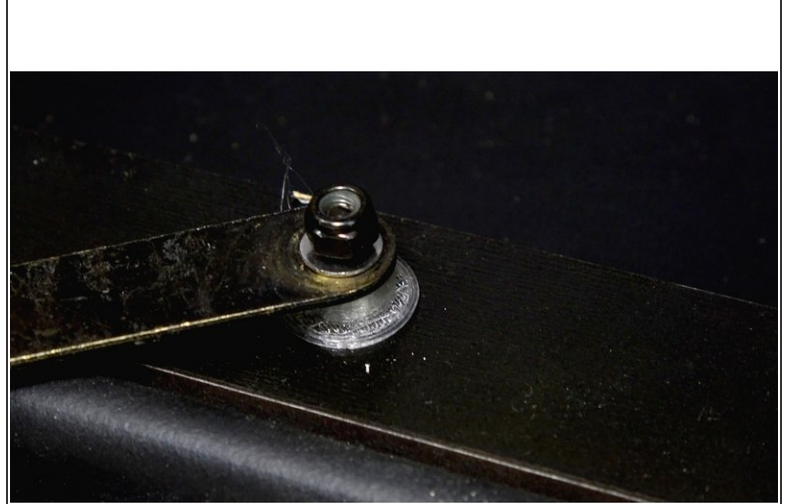
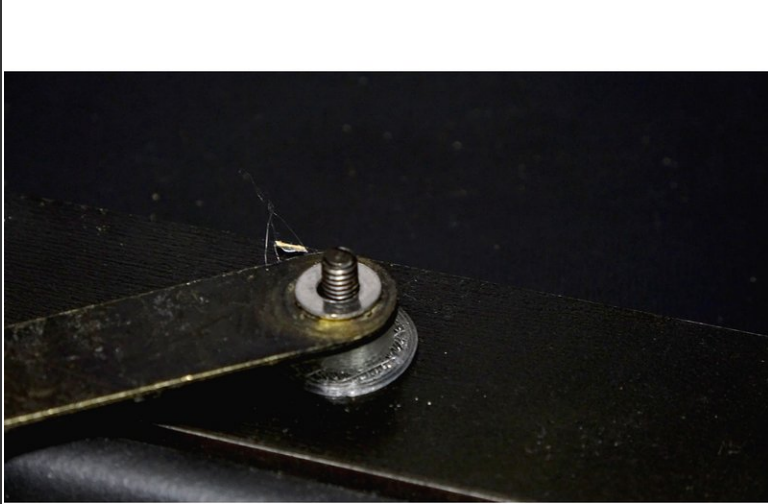
Step 6 — Installing the Left Lid Stay Hinge (Standard Kit)



- On the left side, insert a 25mm bolt like on the right side.
- Put two laser cut spacers over the bolt, followed by a 3D Bushing.
- Place the arm on the bolt, followed by a washer.
- Secure the arm in place with a nylock.

⚠ Tighten down just enough to make contact with the arm. Do NOT tighten to the point the arm does not move.

Step 7 — Installing the Left Lid Stay Hinge (Seal Kit)



- Insert **25mm** bolt through the graphic panel, through the seal bar.
- Place a 3D Bushing on the bolt.
- Put the arm on the bolt, followed by a washer.
- Secure the bar on with a Nylock.

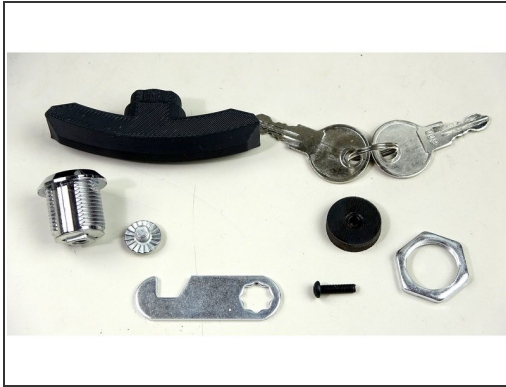
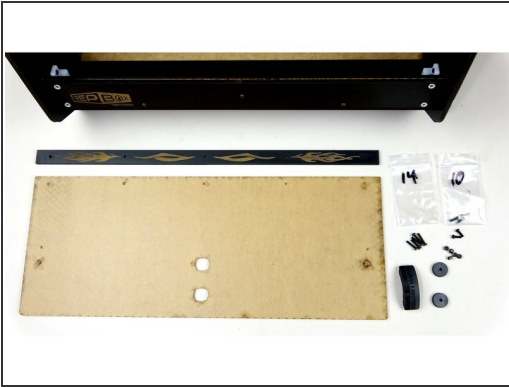
⚠ Tighten down just enough to make contact with the arm. Do NOT tighten to the point the arm does not move.

Step 8 — Installing the Left Hinge End Mount (Sealed and Standard kit)



- Insert a **10mm** bolt through the end of the left Hinge arm
- But a washer on the bolt, followed by the End Mount and another washer.
- Secure the End Mount in place with a nylock. Do NOT over tighten. It needs to move freely.
- Tuck both the left and right Hinge arms back into the interior of the box for now.


Step 9 — Acrylic Lid Parts



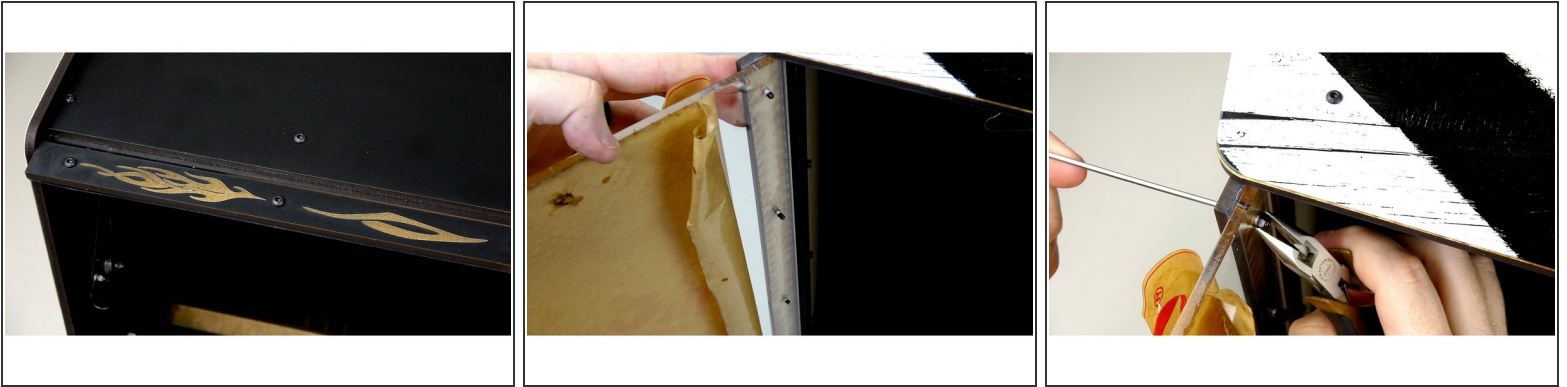
- Acrylic Panel
- Acrylic Lid Clamp Panel
- 14mm bolts, 10mm bolts, Nylock Nuts
- Laser Cut Wood Spacer (1 for Seal Kit, 2 for Standard Kit)
- 3D Printed Handle
- SEAL KIT: 3D Printed Handle, Lock and Key kit


Step 10 — Acrylic Panel Prep



- Carefully peel back the protective film to expose the top of the acrylic. Repeat for the back as pictured.
 - The amount exposed should be just a little more than the width of the Acrylic Lid Clamp on both sides.
-  Leave the rest of the film on for now to protect the acrylic during install.

Step 11 — Attaching the Acrylic Lid



 This next step is easier if the box is on its side.

- Take the Acrylic Clamp panel and line it up with the vinyl on top of the box.
- Start threading through **14mm** bolts from the top of the Clamp panel, through the vinyl.
- Line up the Acrylic panel and thread the bolts through the holes on the panel.
- Secure in place with Nylock nuts. (A pair of needle nose pliers may work better than the hex key for this step)

 Be Careful not to over tighten the nylock nuts! It could break the acrylic!

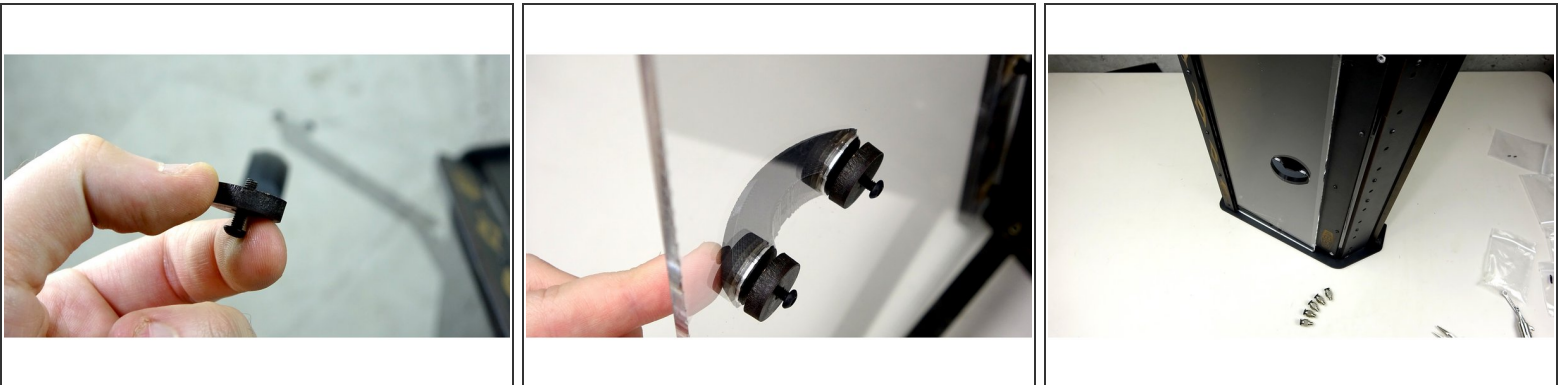
Step 12 — Attaching the Hinge Arms



- Remove the rest of the protective film from the acrylic.
- Using **10mm** bolts and Nylock nuts, secure the Hinge arms to the Acrylic as shown.

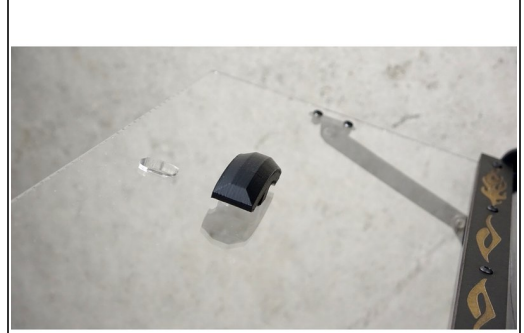
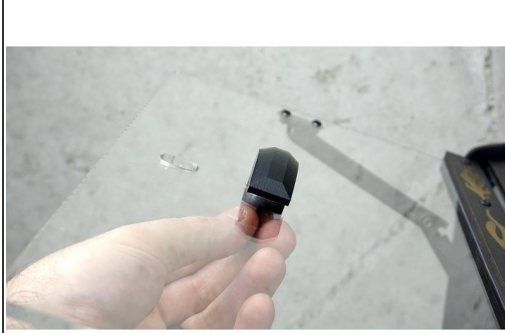
⚠ Be Careful not to over tighten the nylock nuts! It could break the acrylic!

Step 13 — Attaching the handle (Standard Kit)



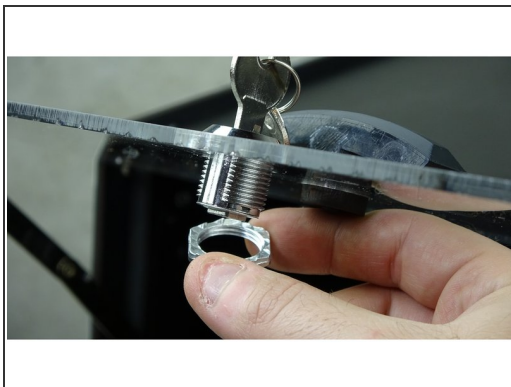
- Take two of the laser cut stand offs and two **10mm** bolts. Put the bolts through the standoffs as pictured
- Place the handle into the holes of the Acrylic lid.
- Secure into place using the bolts and standoffs.

Step 14 — Attaching the Handle and Lock (Sealed Kit)



- Put the handle that comes with the seal kit into the top large hole in the acrylic.
- Attach with a 10mm bolt and a laser cut circular stand off.

Step 15 — Attaching the Handle and Lock (Sealed Kit)



- Disassemble the lock assembly.
- Insert the main assembly into the bottom hole. It helps to have the key in to check orientation. The key should be up and down.
- Thread the nut over the lock assembly and secure it to the acrylic.
- Attach the latching arm using the Phillips bolt that came in the same bag.
- Check orientation.
- **i** The last pic shows how the rotation should work. The latch should rotate from horizontal to vertical with a COUNTER CLOCKWISE turn and lock. Pay close attention to the notch orientation.
- [If everything looks good, Click here to head to Stage 7!](#)