Rat Rig

09. Spoiler Board installation

Written By: Rat Rig
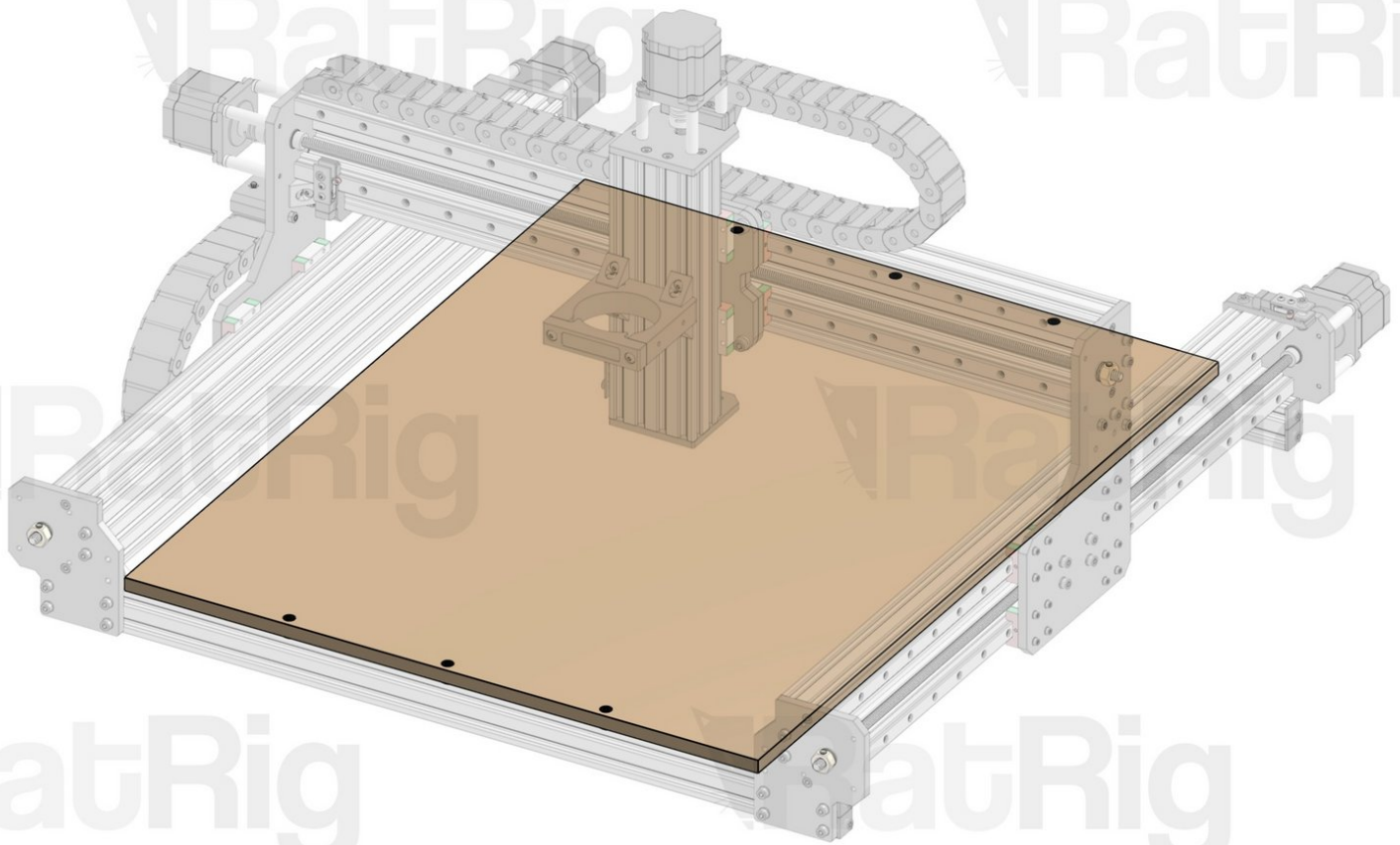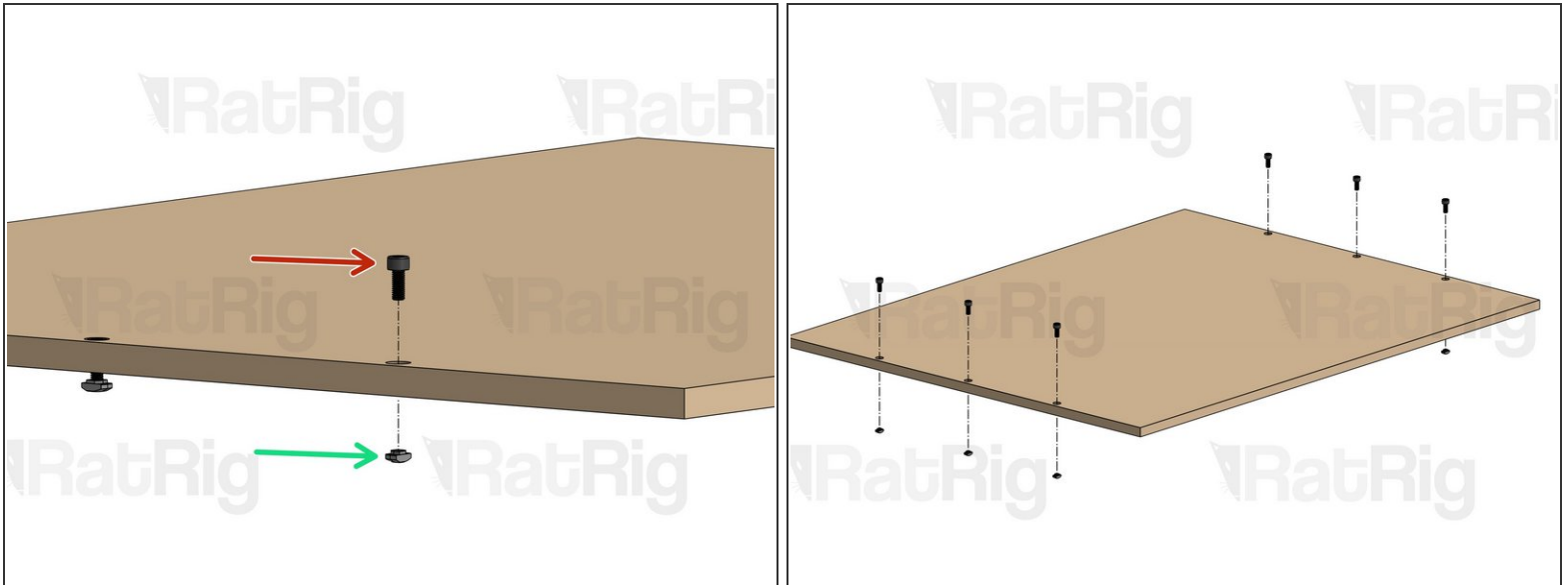
Step 1 — Drill your Spoiler Board

Machine Volume			
Version	X (mm)	Y (mm)	Z (mm)
55	644.1	644.1	525.7
75	894.1	894.1	525.7
1075	894.1	1144.1	525.7
1050	644.1	1144.1	525.7
1010	1144.1	1144.1	525.7
1510	1144.1	1644.1	525.7
1515	1644.1	1644.1	525.7

Working volume			
Version	X (mm)	Y (mm)	Z* (mm)
55	281	288	113
75	531	538	113
1075	531	788	113
1050	281	788	113
1010	781	788	113
1510	781	1288	113
1515	1281	1288	113

* With no spoilerboard

Spoiler board dimensions		
Version	X (mm)	Y (mm)
55	346	500
75	596	750
1075	596	1000
1050	346	1000
1010	846	1000
1510	846	1500
1515	1346	1500

(i) The Spoiler Board is not included in your kit, you will have to source it and have it cut locally. Check this table (see image) to identify Spoiler Board dimensions for your specific KillerBee size. We recommend using a 12mm thick MDF board.

(i) A Power Drill with 5mm and 10mm drilling bits for wood will be needed for this step.

- Identify the side of the Spoiler Board that corresponds to the X Axis of the machine and drill 3x 5mm through-holes on each side (6 holes in total, 4 on the corners and 2 in the middle).
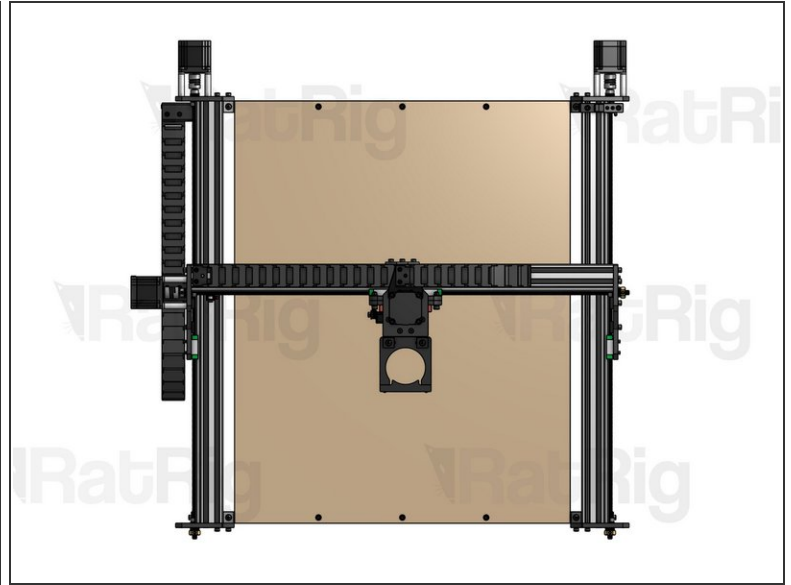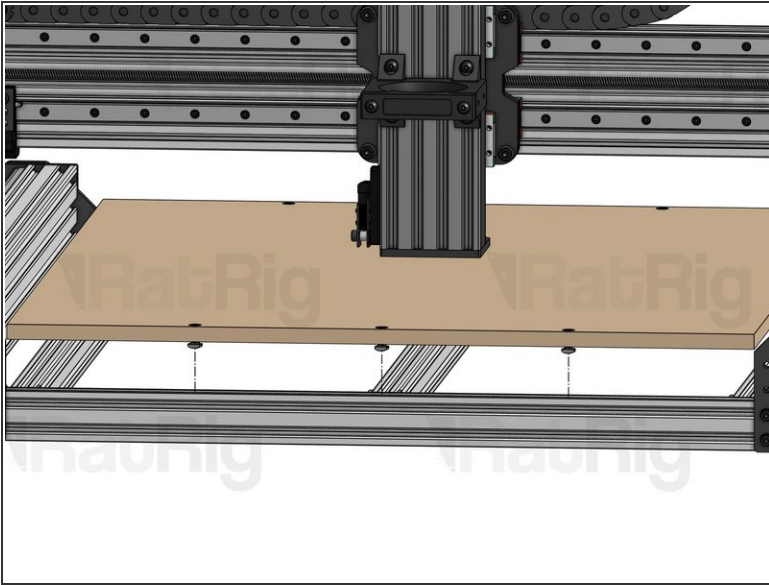
  ⚠ CAUTION: the center of each hole should be placed exactly 10mm away from the edge of the board.

- Widen the top half of every hole to a diameter of 10mm, to accommodate screw heads. For a 12mm thick board, make the wider holes 7mm deep.

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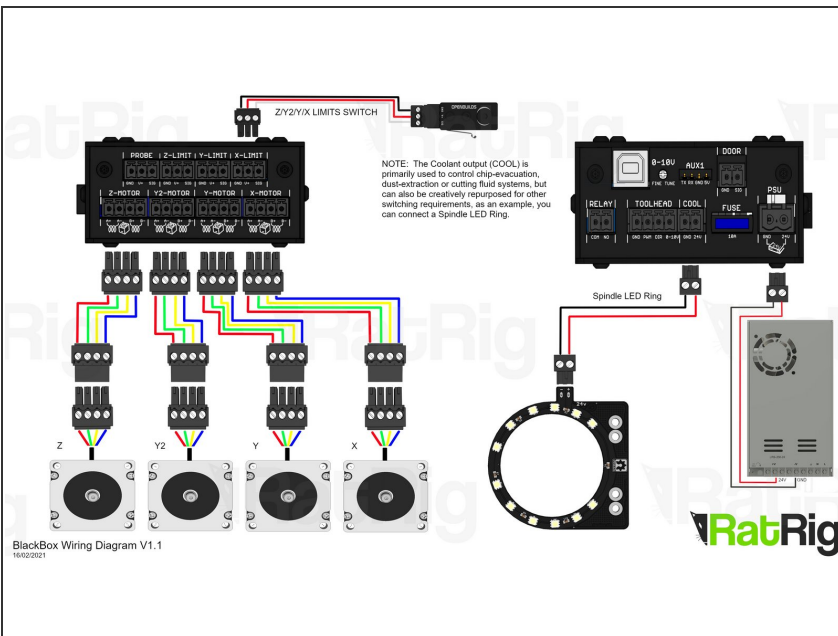## Step 2 — Mount Fasteners on your Spoiler Board

- Cap Head Screw M5x12mm

- Drop-in T-Nut M5. Screw them into position, but don't tighten.

- (i) Repeat this step for each of the 6 holes on your board.

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Step 3 — Attach Spoiler Board to Machine

- Align the T-nuts on the board so they fit inside the X Base 2040 slots and tighten the screws.

- ⓘ We recommend Surfacing your Spoilerboard once you have your clamping method set as it will make sure your work area is perfectly parallel with your machine.

Step 4 — Next guide

- Move on to the [Wiring Diagrams](#).

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