



## SurRon Light Bee Shroud for X-9000

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## 1 Files Included

File Name	Description
Shroud_Left_V6.1.stl	Left hand side shroud.
Shroud_Right_V6.1.stl	Right hand side shroud.
Shroud_Top_V6.1.stl	Upper shroud. Mounted to upper portion of X-9000, requires the removal of the horn.
Shroud_ControllerSpacer_1mm.stl	Spacer used to space top of X-9000 from frame (only use if required).
Shroud_ControllerSpacer_2mm.stl	Spacer used to space top of X-9000 from frame (only use if required).
Shroud_ControllerSpacer_3mm.stl	Spacer used to space top of X-9000 from frame (only use if required).

## 2 Recommended Hardware

Item	Description	QTY
Self-tapping screw 8G x 1/4"	Phillips head-drive	2
M6x10 socket head cap screw	Low profile DIN7984 recommended	2
M6x20 socket head cap screw	Low profile DIN7984 recommended	2
M6x16 socket head cap screw	Low profile DIN7984 recommended	1
M6 plain washer	Recommended	5
M6 lock nut	Flanged lock nut recommended. It is possible to reuse the existing nut mounting the horn	1



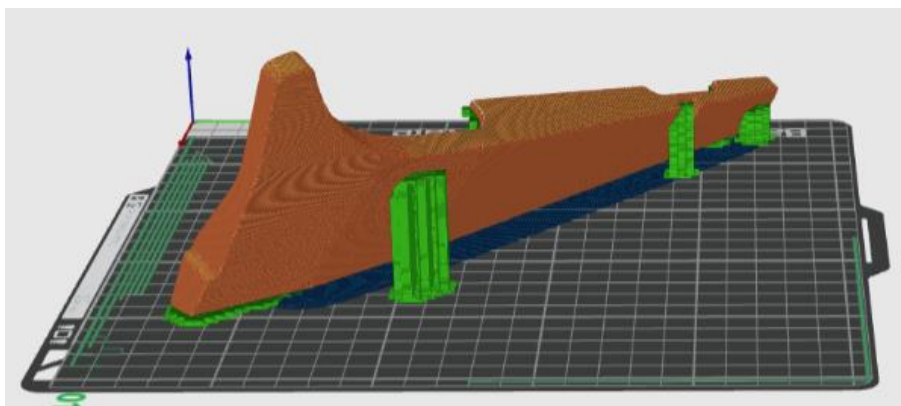
**Figure 1: Fastener locations**

### 3 Printing Notes

Through testing we have discovered that most SurRon Light Bee frames, in particular the OEM controller mounts, vary slightly depending on level of use and manufacturing tolerances of the frame. Because of this, sometimes there may be slight gaps between the shroud and the frame on your bike. To account for this, we included slots in the shroud to give some adjustment, we have also provided shims (1mm, 2mm and 3mm) to space the upper mount face of the controller from the frame.

The recommended hardware to be used with the controller kit is shown below. Please note that during assembly of the shroud, do not overtighten the screws as it may damage the plastic. We also recommend installing the socket head cap screws with Loctite to prevent loosening.

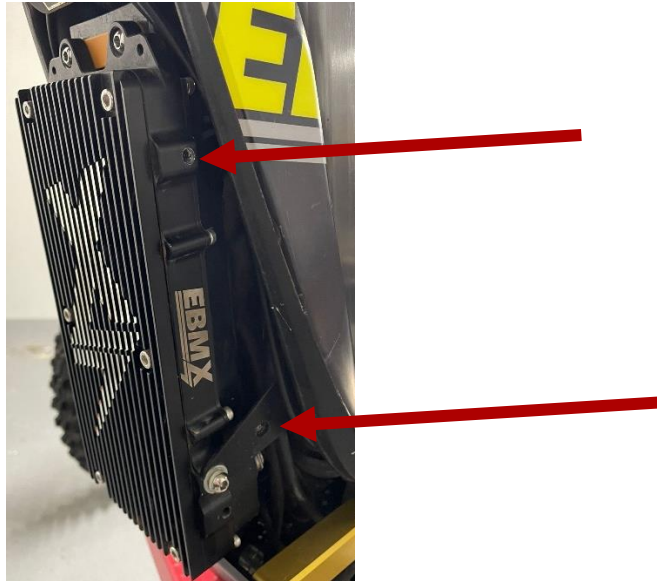
We have tested and printed on our printer (Bambu Lab X1C) with the following filaments: PLA, PLA-CF and PETG. We recommend printing with supports at a 0.2mm layer height. Minimum required bed space: 220mm x 220mm. For best finish and minimal support, align the plate with the edge parallel to the X-9000.



**Figure 2: Recommended orientation of the shroud side piece.**



## 4 Installation Notes



**Figure 3: Shroud side piece mounting holes are shown above**

To install the upper shroud piece, first remove the horn and mounting bracket. Bolt the shroud piece to the frame using the same hole, finally attach the upper piece to the side pieces using a self-tapping screw.



**Figure 4: Attached side piece and upper piece shown. Printed from PLA-Basic on the Bambu Lab X1C**