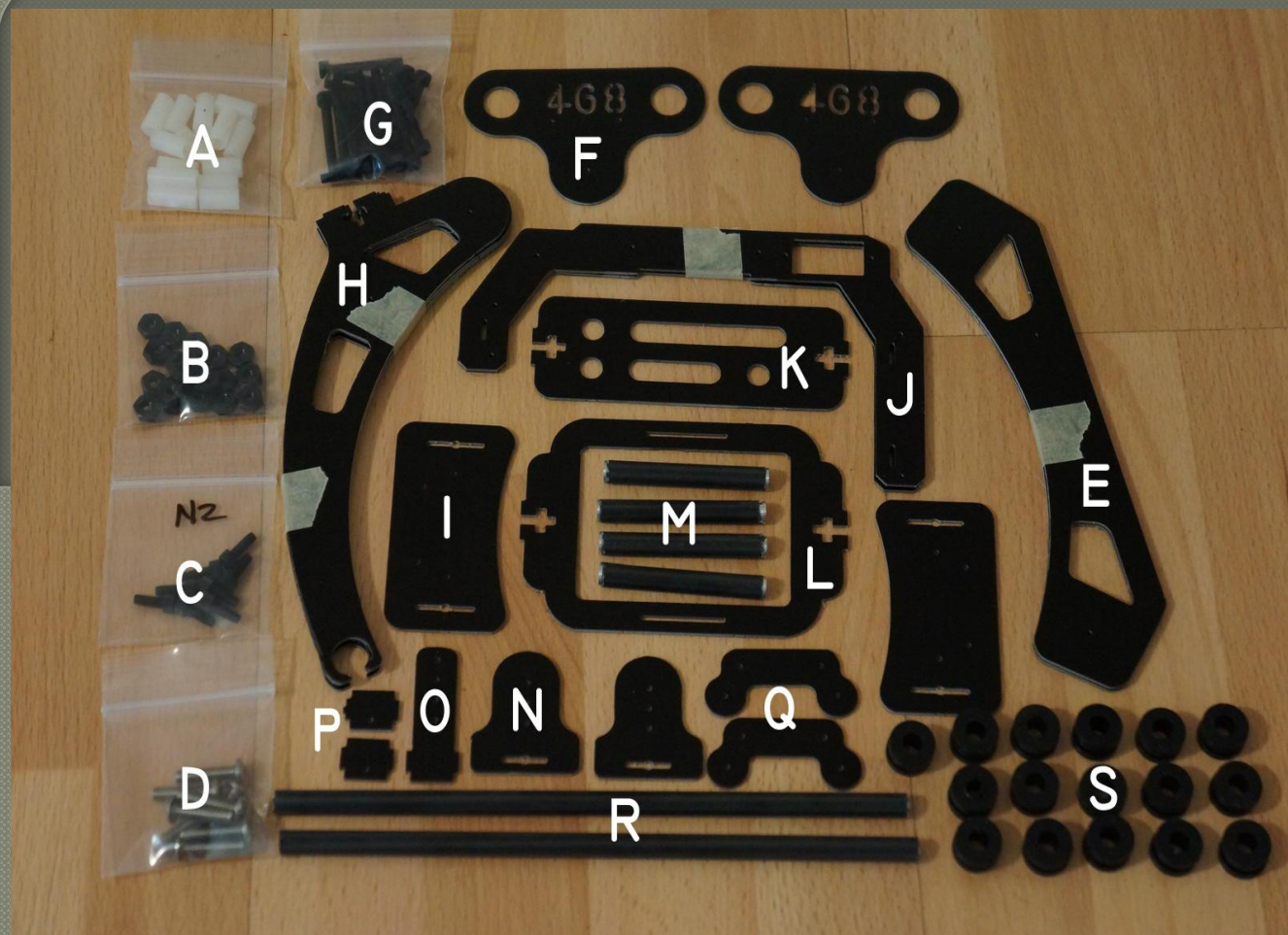


# NAZA Flame Gear

ST



Assembly Guide Rev. 2



- A – Nylon Spacers
- B – Nylon Nuts
- C – 3/8" 6/32 Nylon Bolt
- D – 3/4" 8/32" SS Bolts
- E – Leg Carriers (2)
- F – Camera Mount Tabs (2)
- G – 1" Nylon Bolts
- H – Legs (4)
- I – Frame Mounting Tab (2)
- J – Camera Frame (2)
- K – Camera Mount Plate (1)
- L – GoPro Mount Plate (1)
- M – 2" Fiberglass Shafts w/ Inserts (4)
- N – Camera Plate Mount Tabs (2)
- O – Camera Pivot Point Tab (2)
- P – Servo Mount Tabs (2)
- Q – Frame Mounting Washers (2)
- R – Landing Skids (2)
- S – Rubber Grommets

Not Pictured – Ball linkage and Ball

## Package Contents

\*\*\*\*\*G10 Warning – Please wear a dust mask when filing G10 glass material\*\*\*\*\*

1. All kits usually require a small amount of fit filing some may need a small amount drilling. We recommend using an xacto knife verses filing
2. All kits are Hobby Grade – Meaning that they are not designed to snap together. You will need to modify them slightly to get a perfect fit.
3. All packages subject to change or revisions
4. XT hardware list is slightly different but assembly is the same

### Bagged Hardware List

- 20 - 6-32 black nylon 1"
- 20 - 6-32 black nylon nuts
- 16 - Push in Grommets
- 8 - Aluminum inserts
- 4 - 2" Carbon/Fiberglass Tubes
- 2 - 7" Carbon/Fiberglass Tubes
- 8 - 8-32 Pan Head Screws
- 5 - 6-32 black nylon 1"
- 5 - 6-32 black nylon nuts
- 12 - Nylon Spacers 1/2"
- 2 - Nylon Spacers 5/8"





Step 1:  
Mix epoxy (not included)

Step 2: Add epoxy to shaft insert. Push into Fiberglass shaft with a turning motion to distribute the epoxy around the insert. Do this for each insert

Let dry (See Epoxy Instructions)

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue



Step 3:  
Insert Rubber Grommet into leg assembly – Do this for  
each of the 4 legs



Leg and Leg carrier holes should be drilled out to  
.165" Please use 11/64" drill bit for the leg carriers –  
All other holes should be drilled to 5/32" (New sets  
are predrilled)



All Nylon Bolts should be clipped close to the nut  
and secured with a dab of hot glue

Completed Leg Set with grommets attached







Step 4:  
Insert Rubber Grommets into Camera Mount Tabs

Step 5:  
Slide 2 completely dry 2" shafts into rubber grommets  
of one camera tab.

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue



Step 6:

Slide the second camera mount tab onto the 2 shafts.

Step 7:

Insert 8 – 8/32" X3/4" bolts into the leg carrier. The leg carrier should be on the outside of the legs when mounted. Note the picture below



Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue







#### Step 8:

Thread the other two 2" fiberglass shafts into the aluminum insert. Be careful not to cross the threads. No Locktight is needed in this area. Snug the bolt but do not over tighten. Do this for both sides as seen below. If the insert starts to turn your epoxy is not dry (See epoxy instructions)

#### Step 9:

Attach other set of legs and leg carrier. Make sure leg carrier is on the outside of the legs

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue





Step 10:  
Install 1" 6-32 Nylon Bolt with 5/8" spacer between camera mount tabs.

Step 11: Install ball link ball into camera mount tab ear

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue







#### Step 12:

Slide Landing skids into leg grommets. Attach one grommet to each end of the skid to balance the legs front and back

Step 13: Attach camera mounting tabs/fiberglass shafts to center of frame. (Snug bolts but not over tight)

We recommend not using lock tight on these parts – Visually inspect before each flight

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue





#### Step 14: (ST)

Insert the GoPro camera tab onto the frame. Slide one nylon bolt into the slot and add a 3/8" nylon 6/32" bolt. Tighten but do not over tighten. We recommend a battery strap to hold you gopro into the mount (Not included)

#### Step 15 (ST)

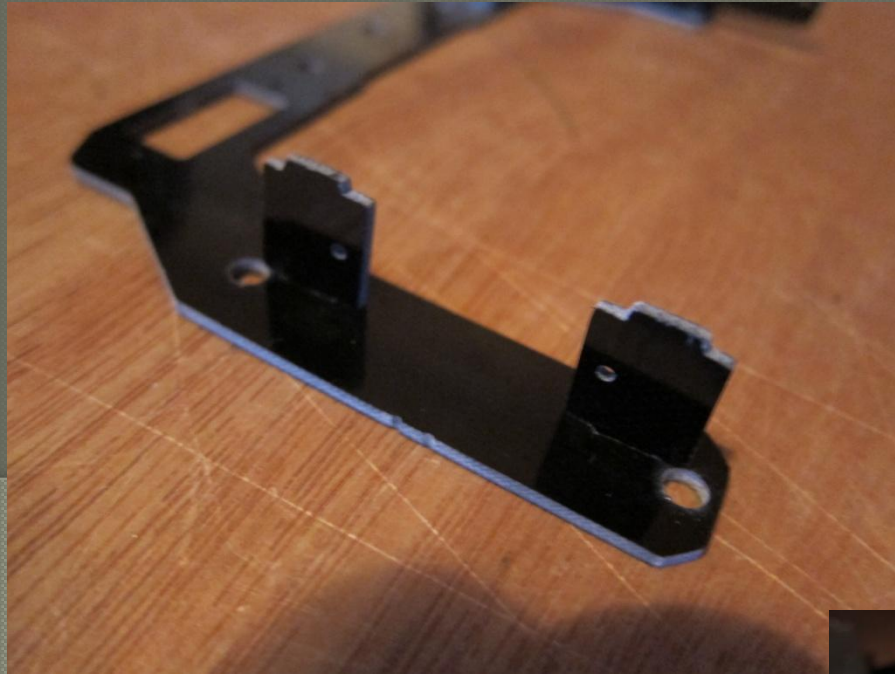
Repeat for other side. (No CA required in this area)

## NAZA Standard

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)







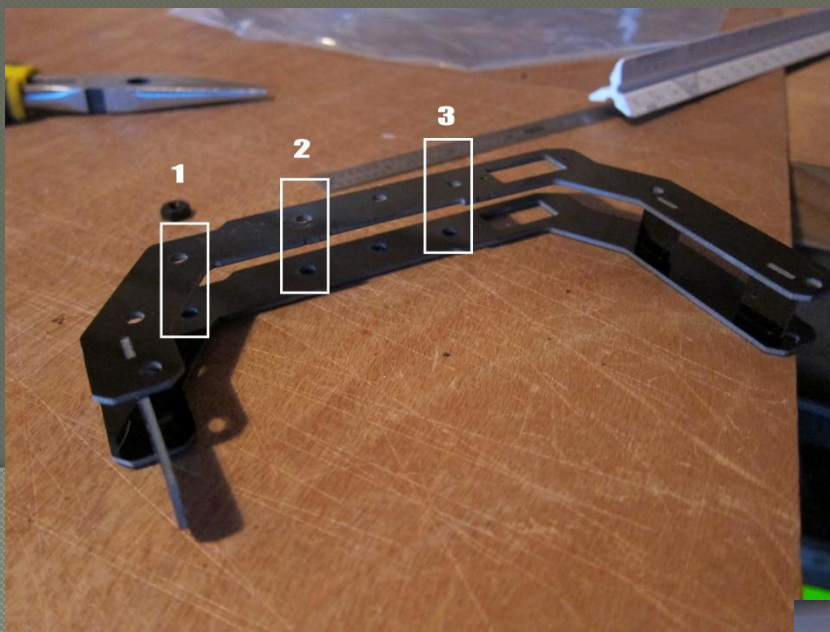
Step 16: Insert Servo Mount tabs into camera frame.  
(trim as needed for a perfect fit)

Step 17: Insert Camera Pivot into tab slot (Due to material thickness variation some slots may need a small amount of xacto work)

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32"



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue



Step 18: (ST) Add opposite side of camera arm. Insert  $\frac{1}{2}$ " nylon spacers in the 3 holes noted below. Add 6/32" Nylon bolts and nuts all locations except roll pivot point. Install servo onto mounting tabs and tighten nylon nuts

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue







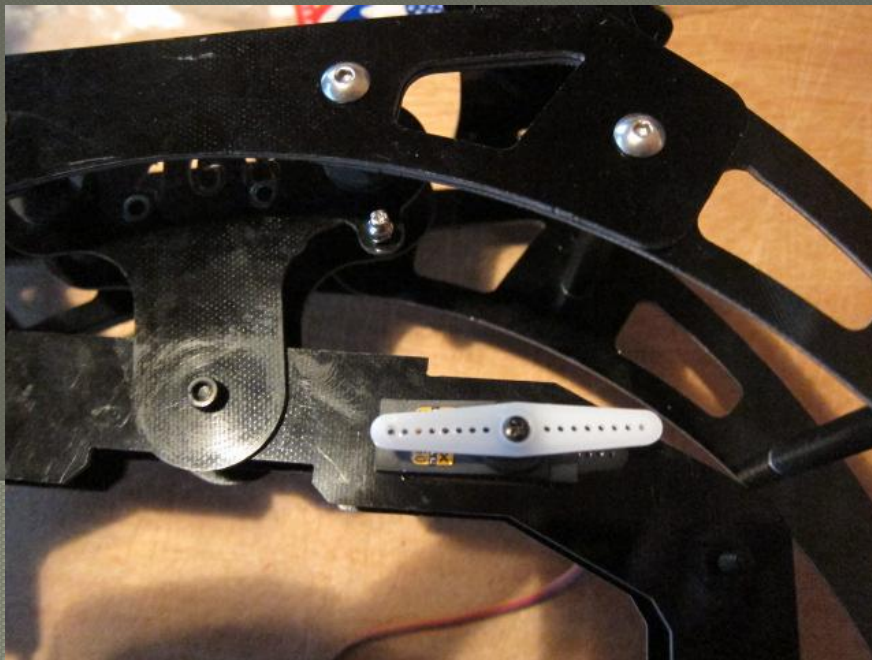
Step 19: Tilt Servo Linkage. I prefer to mount my servo horn on the inside of the camera mount tab. This way only one screw is needed to hold it in place.

Step 20: Camera Pivot hole should be the same as the servo center hole (this is where you add the screw to hold the horn to the servo.) I have found if you drill this hole tight enough there is no play in the mounting hole and no need for a nut on the back side.

We recommend Analog servos to avoid servo twitch on direct drive. Digital servos can twitch slightly during operation. We have tested several servos and find the Hitec HS 65MG to be one of our favorite

Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)





Step 21: Install Roll servo and attach linkage  
Roll servo linkage (provided in newer kits)  
You may need to try different servo horns to find the right one that gives you the most roll. (Make sure linkages are tight and have no movement. Most servo problems comes from unsecure and loose connections.)

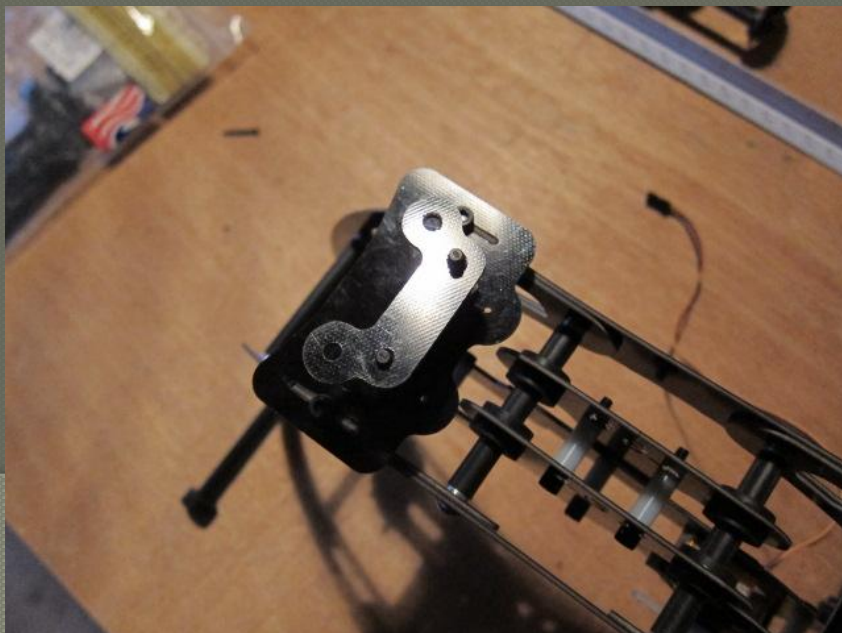
Leg and Leg carrier holes should be drilled out to .165" Please use 11/64" drill bit for the leg carriers – All other holes should be drilled to 5/32" (New sets are predrilled)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue







#### Step 22:

Mounting plates can be mounted either direction for the F450 (center set of holes) – The picture to the left shows a typical 450/550 setup with the retainer clip on the top of the mount.

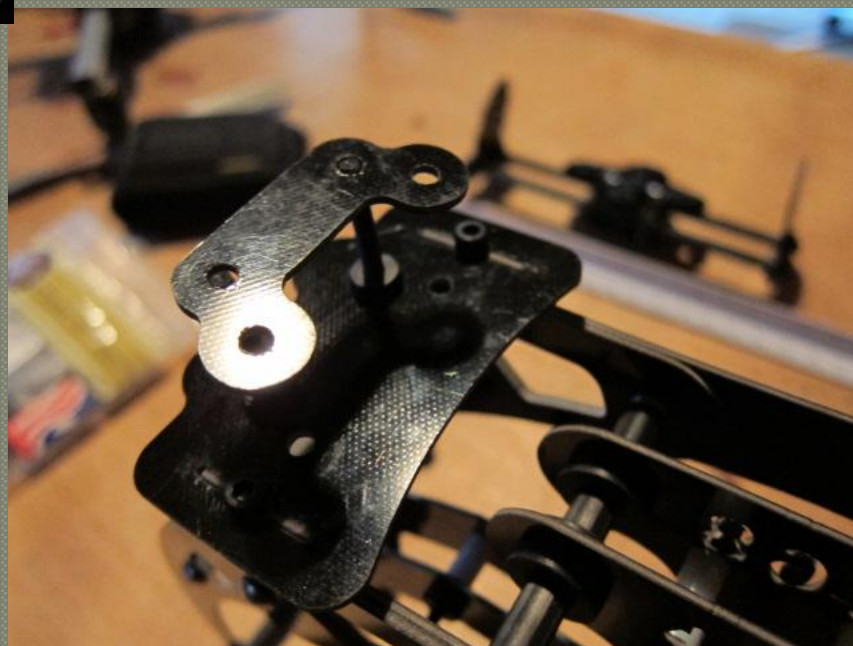
#### Step 23

Attach to the Quad of your choice (Flamewheel 450 – Flamewheel 550 – VC450 or VC550 frames)

Note – Nuts shown on the image to the right are for picture purpose – Mount directly to the power distro plate with “C” washer on the topside of the plate.



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue





Final NAZA Flame Gear Standard Mount installed on F450 (GoPro and 450 not included)



All Nylon Bolts should be clipped close to the nut and secured with a dab of hot glue

