Sample Changer 9-cog drive wheel, Lip Assembly Detail
(Lip assembly is the same for both types of nonacogs)

The lip edge should be 0.07"

(Use the same technique for both the drive and idling nonacogs)

To make the lip, mill down on the plastic exactly 0.5", then move radially out from the center 0.07", and finish drilling. Rotate 40 degrees, and do again for each of the 9 holes.