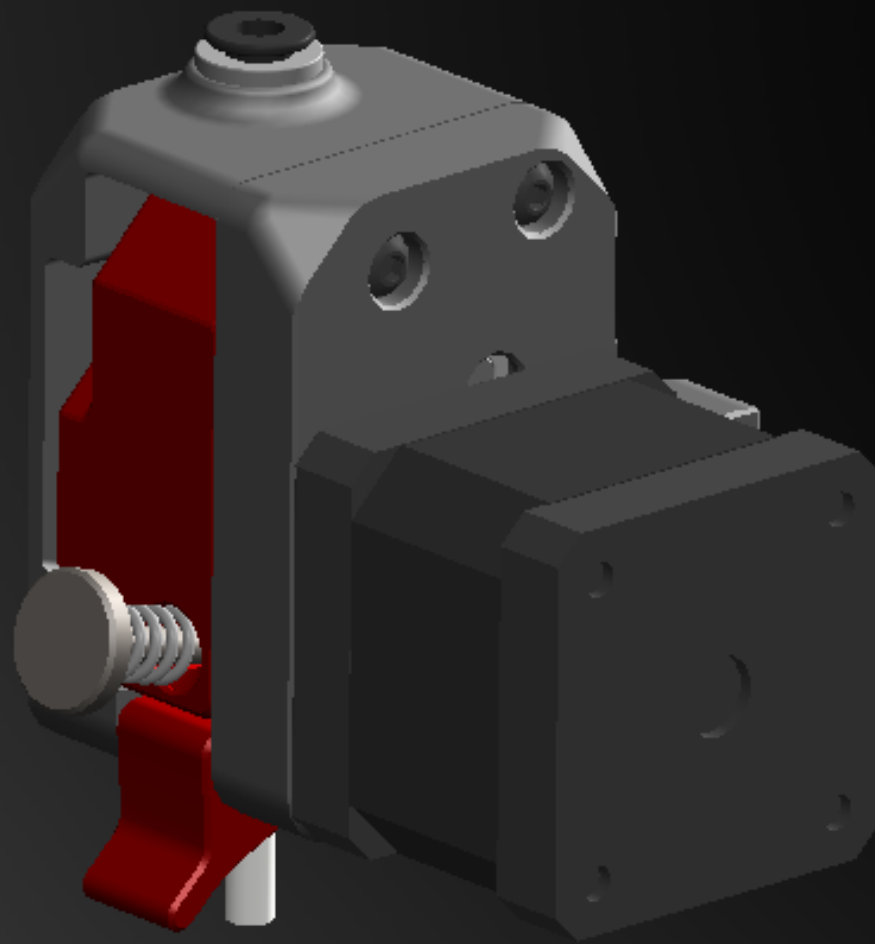


VORON

POCKETWATCH



Assembly Manual

Please, read the **entire manual** before you start assembly. As you begin wrenching, please check our Discord channel ([#voron_v0_questions](#)) for any tips and questions that may halt your progress.

Most of all, good luck!

- The VORON Development Team

File Key	
Primary Color	nothing at start of file name
Accent Color	[a]_ at start of file name
Quantity Required	_x# near end of file name

Part Printing Guidelines and Standards	
Approved FDM Materials	ABS or ABS+ Only
Layer Height	0.2mm
Extrusion Width	Forced 0.4mm
Infill Percentage	40% minimum
Infill Type	Grid, Gyroid, Honeycomb, Triangle or Cubic
Wall Count	4 minimum
Solid Top/Bottom Layers	5 minimum

Very Important Steps

Fastener Size/Type Part

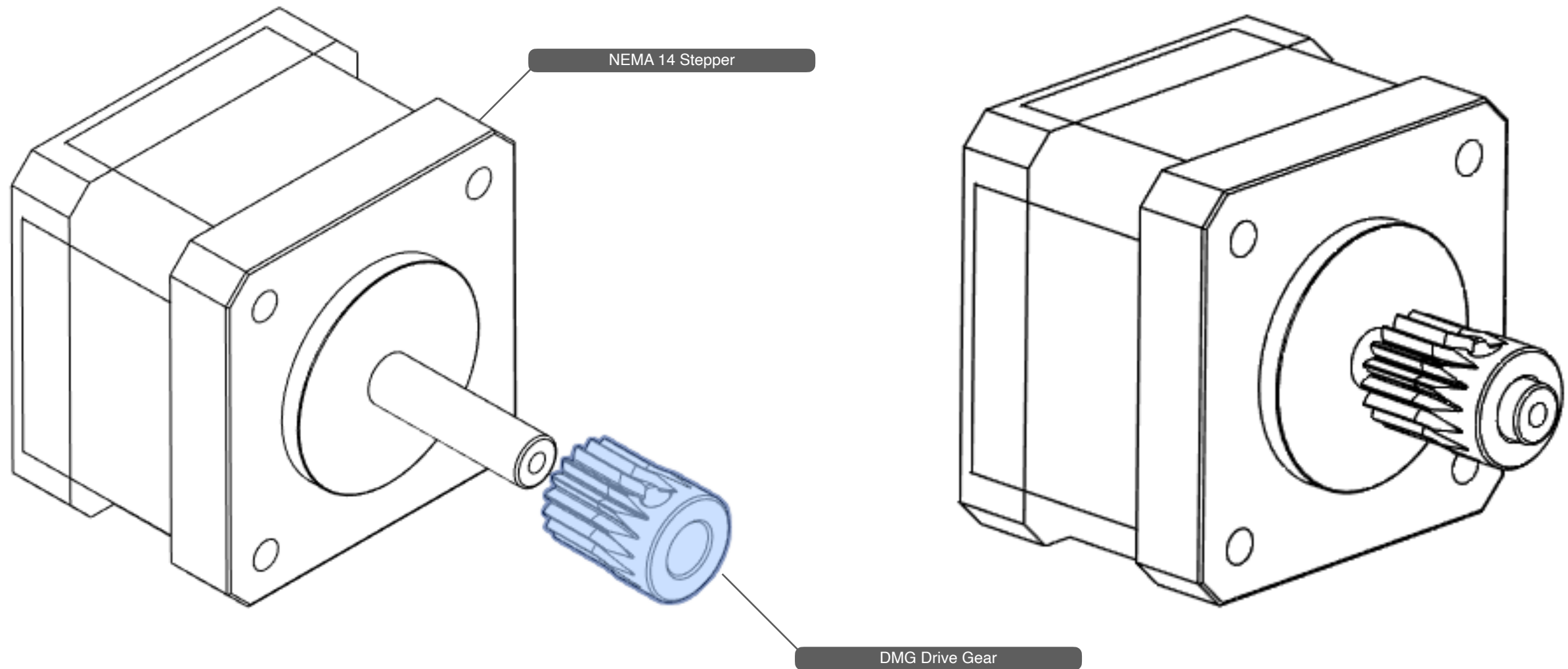
Notes and Tips

Important Definitions and Adhesives List

Callout	Definition
BHCS	Button Head Cap Screw (ISO 7380-1)
SHCS	Socket Head Cap Screw (ISO 4762/DIN 912)
Shim	Shim Ring (DIN 988)
Nut	DIN934 or equivalent
Lock Nut	DIN985 or equivalent
Low Strength Thread Locker	Loctite 222 (aka "Purple")
Shaft Retaining Compound	Loctite 641 ("Yellow") or 609 ("Light Green")

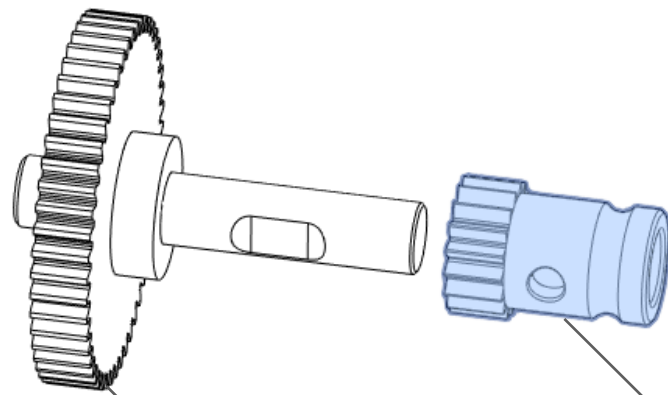
BMG Drive Gears

Part	Qty
NEMA 14	1
BMG Drive Gear	1



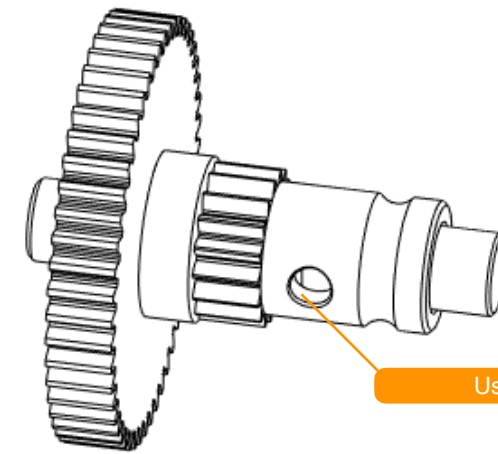
BMG Drive Gears

Part	Qty
BMG Filament Drive Gear	1
BMG White Gear	1
MR85 Bearing	2

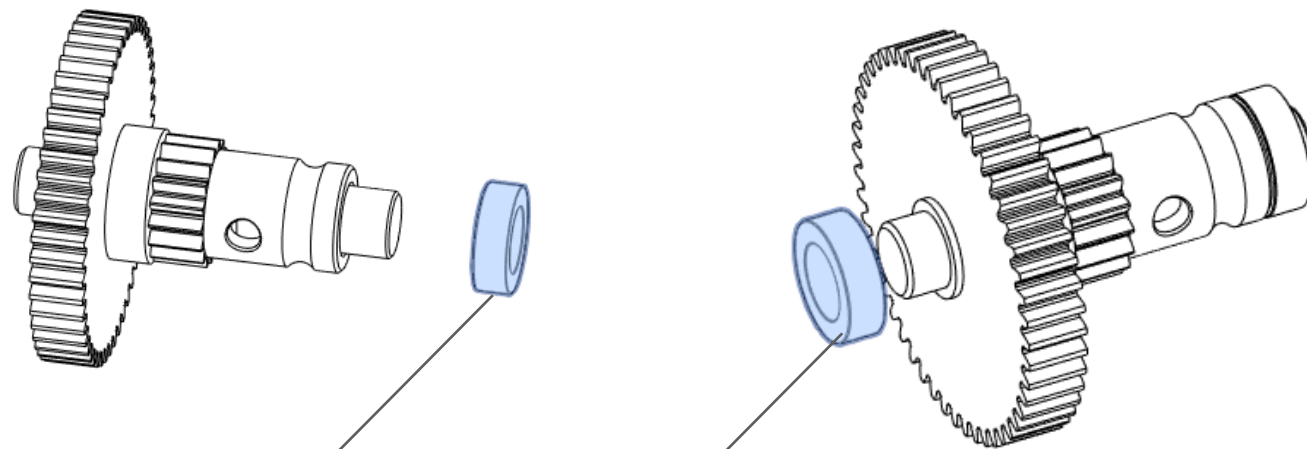


BMG White Gear

BMG Filament Drive Gear

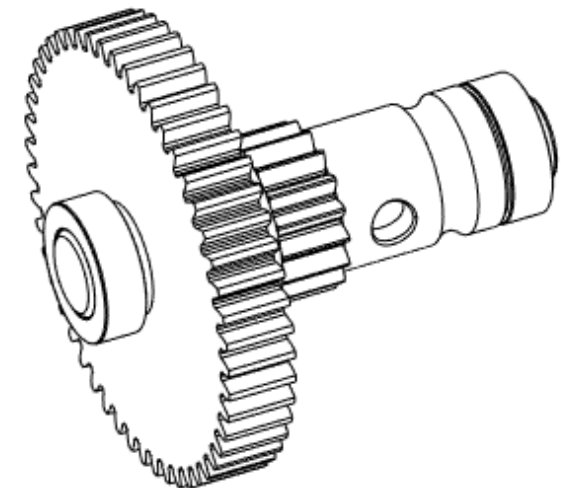


Use Thread Locker On Set Screw



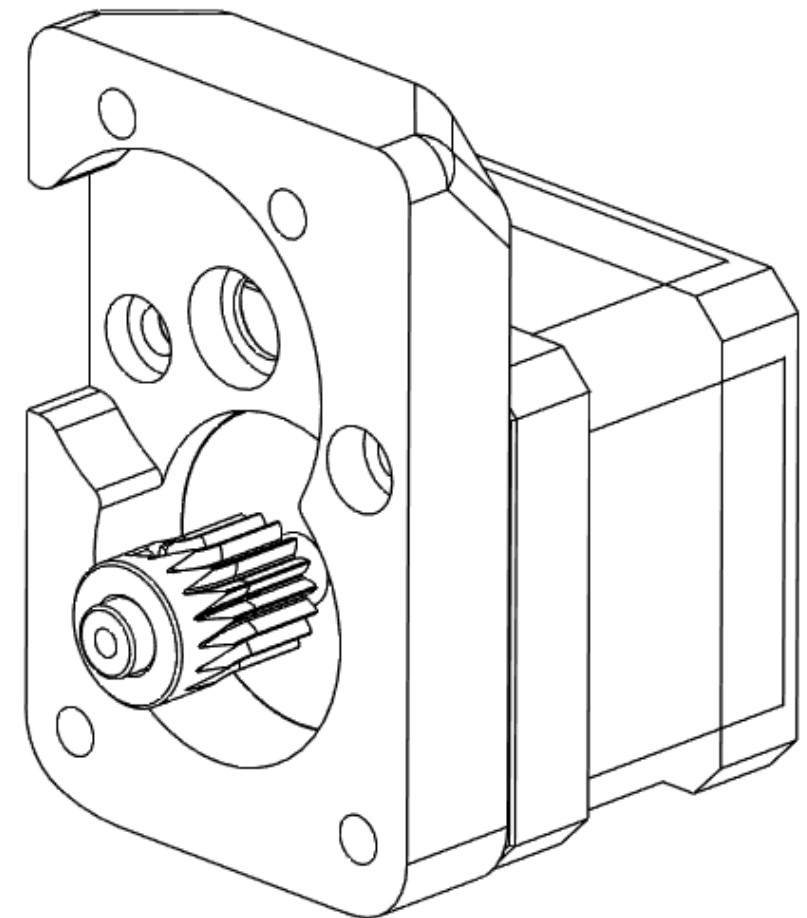
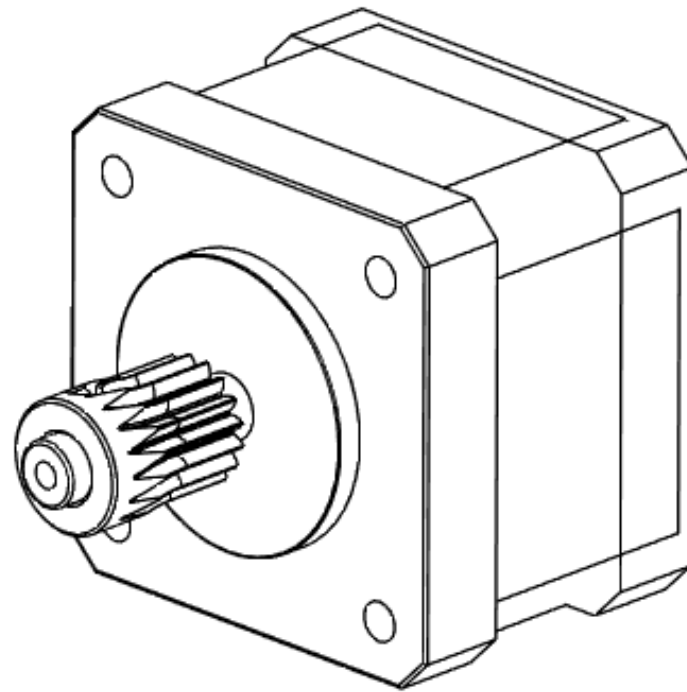
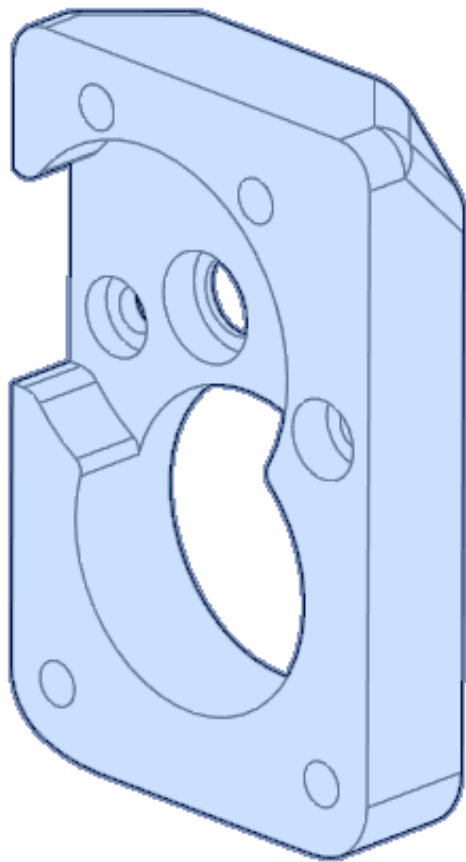
MR85 Bearing

MR85 Bearing



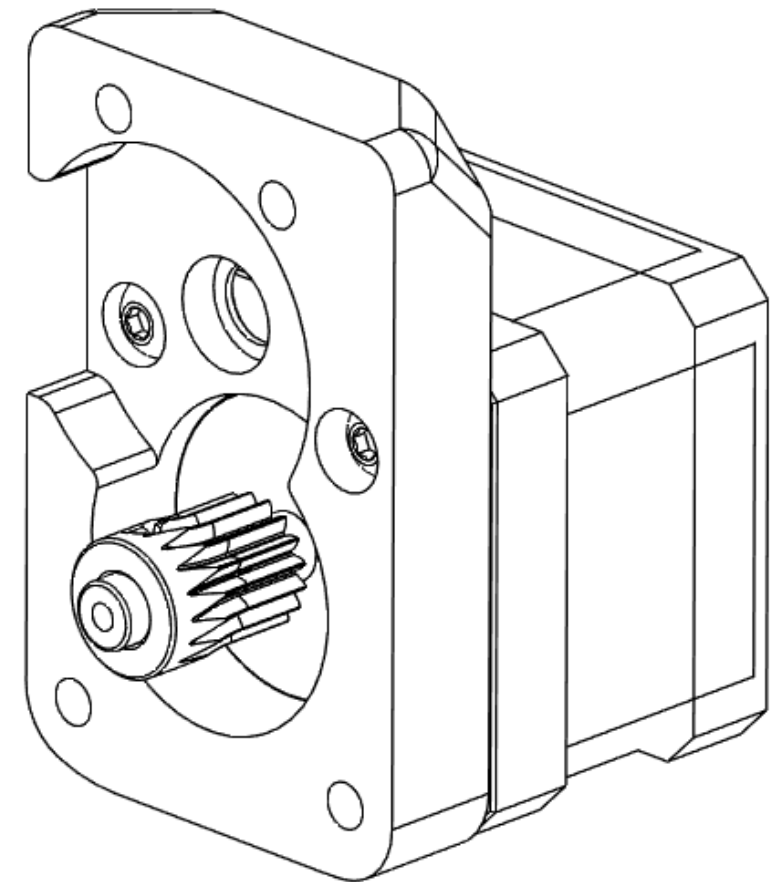
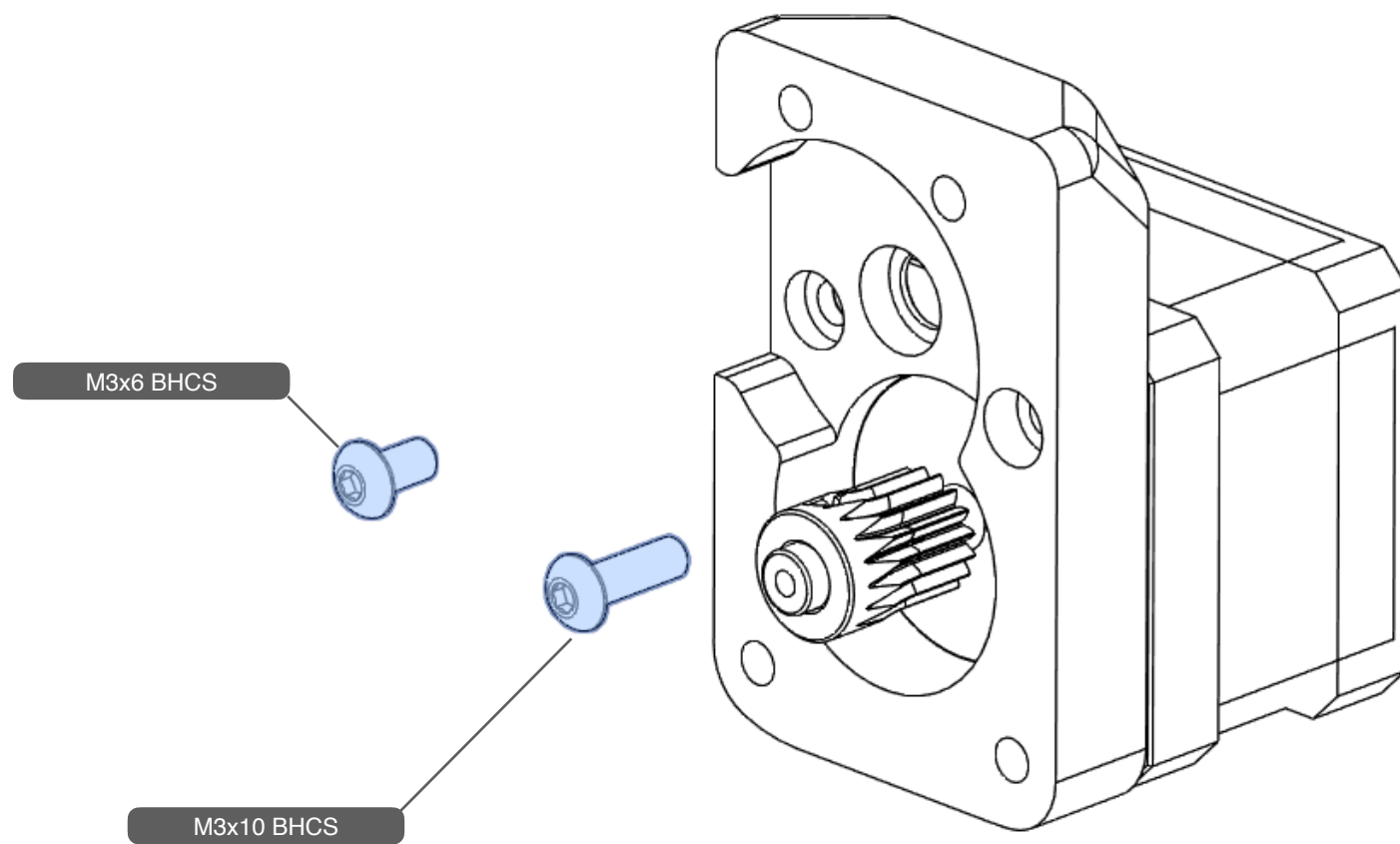
Motor Frame

Part	Qty
Motor_Frame_x1	1



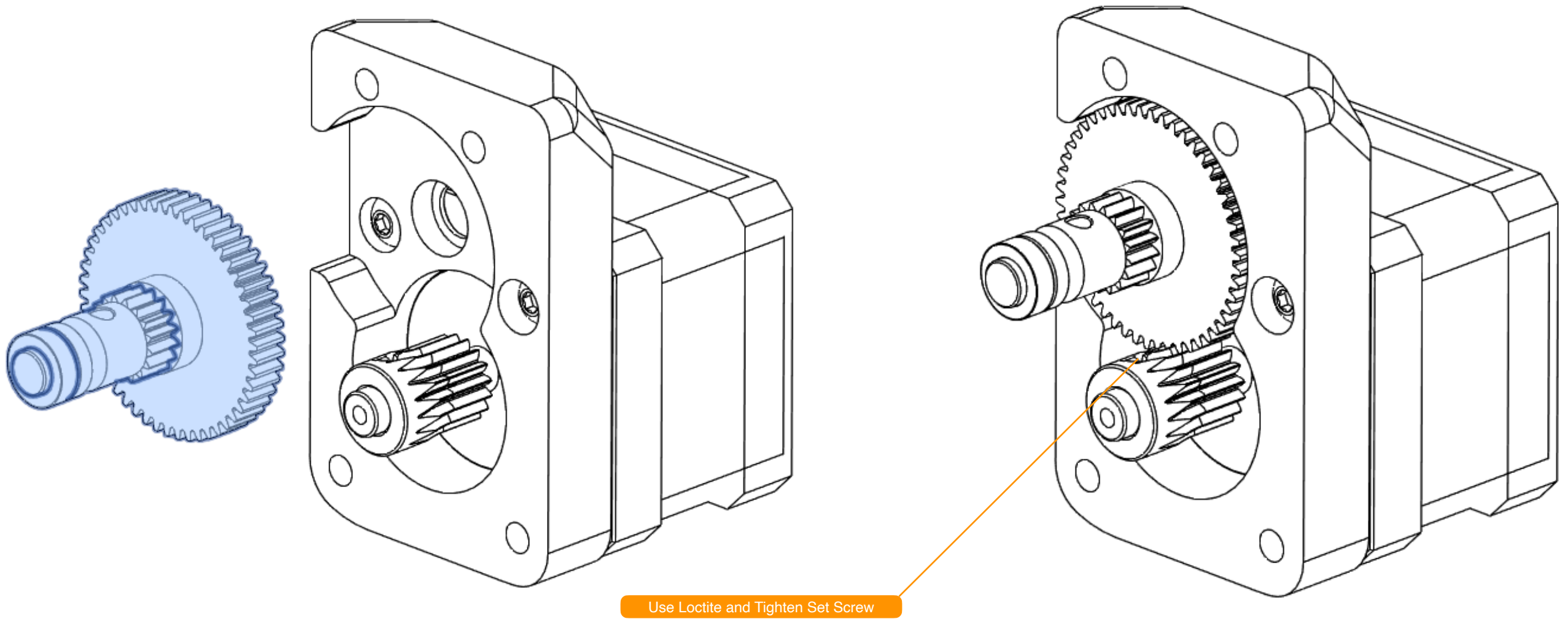
Motor Frame

Part	Qty
M3x6 BHCS	1
M3x10 BHCS	1



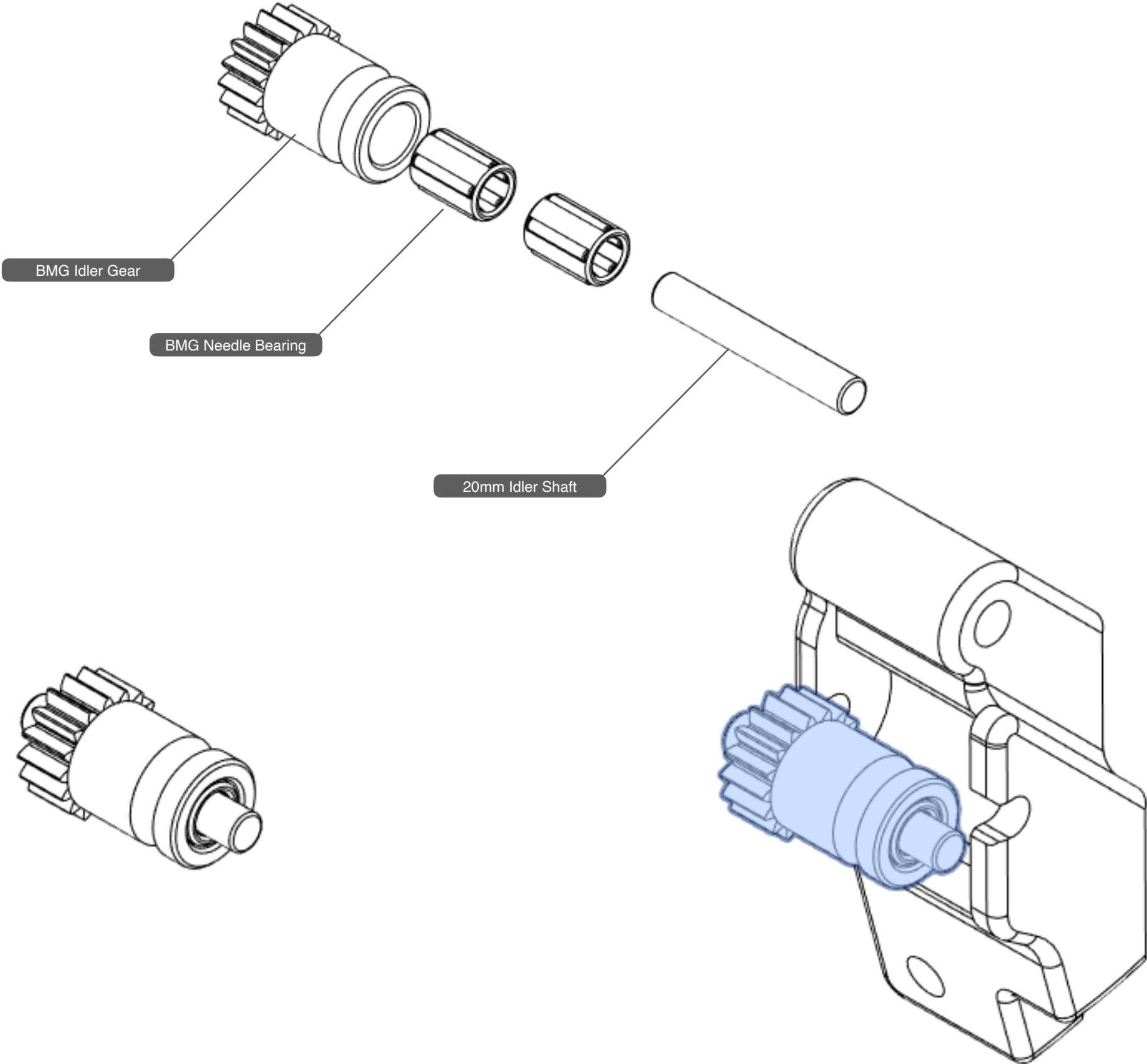
BMG Drive Gears

Part	Qty
BMG Drive Mechanism	1



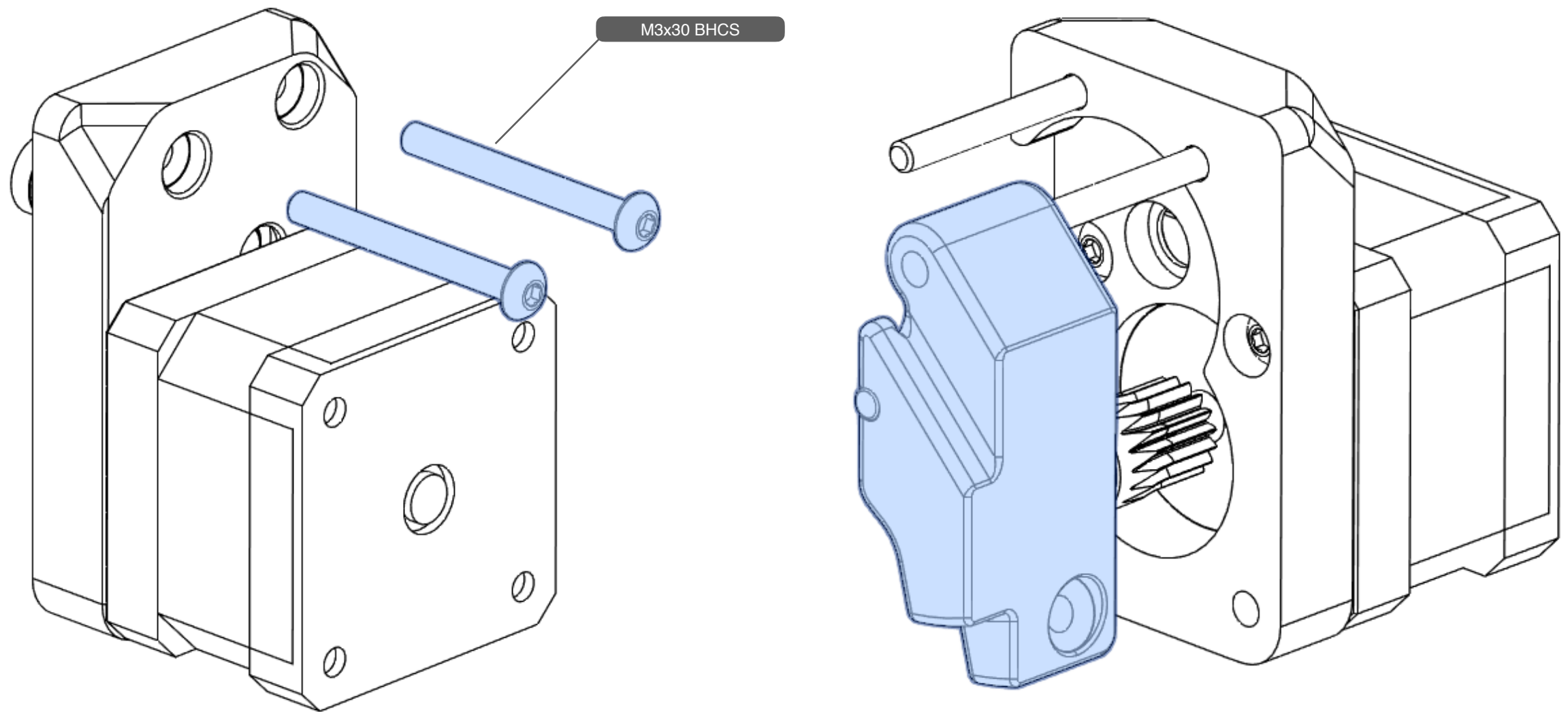
Guidler Door Assembly

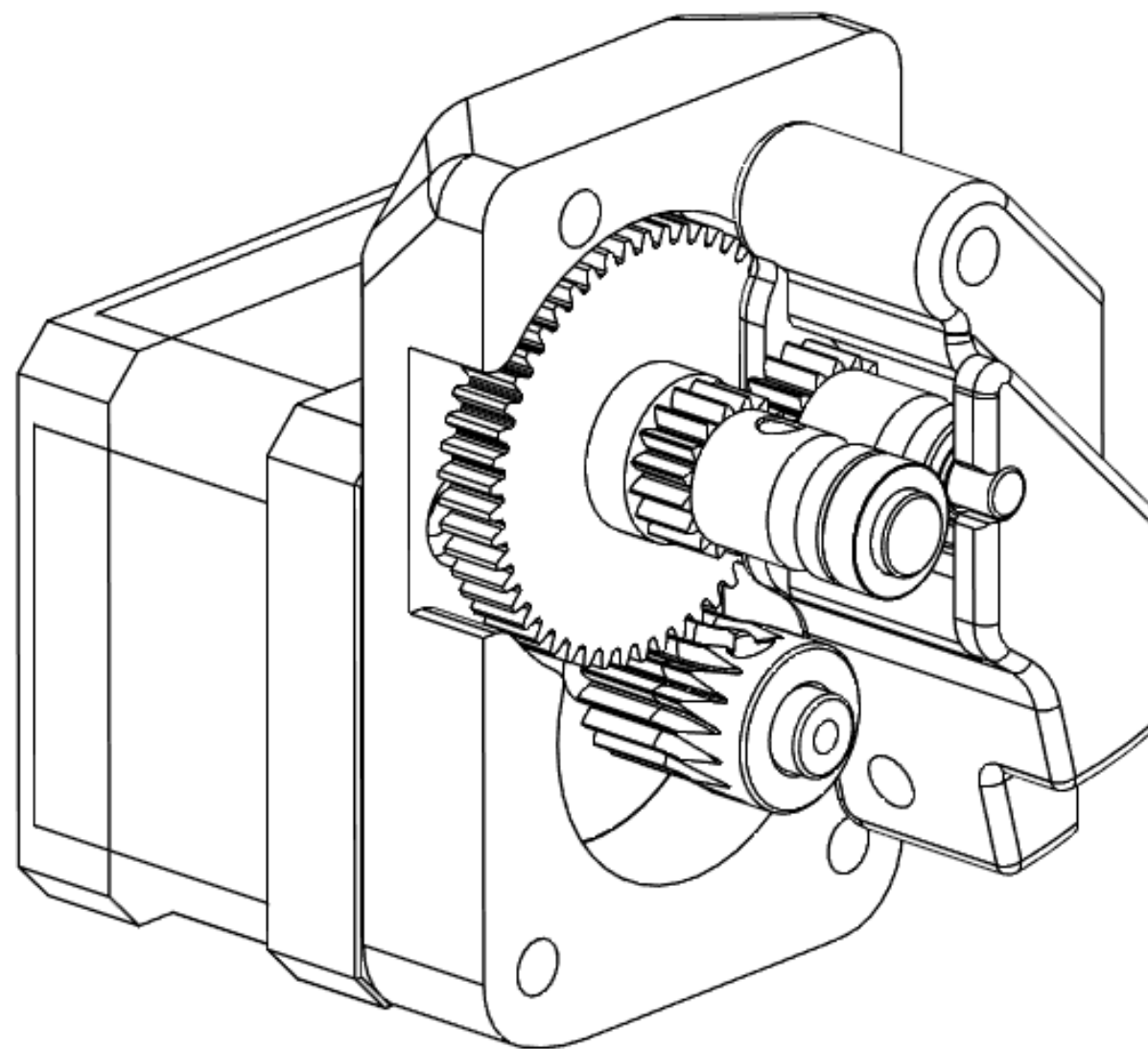
Part	Qty
BMG Idler Gear	1
BMG Needle Bearing	2
20mm Idler Shaft	1
[a]_Guidler_Door_x1	1



Door Assembly

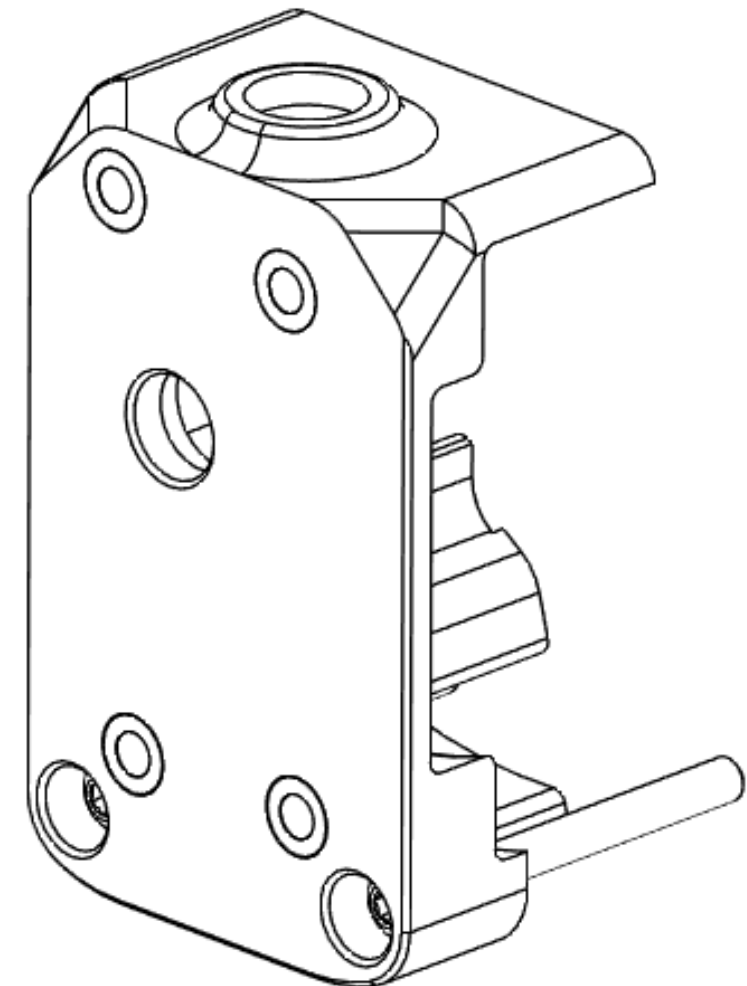
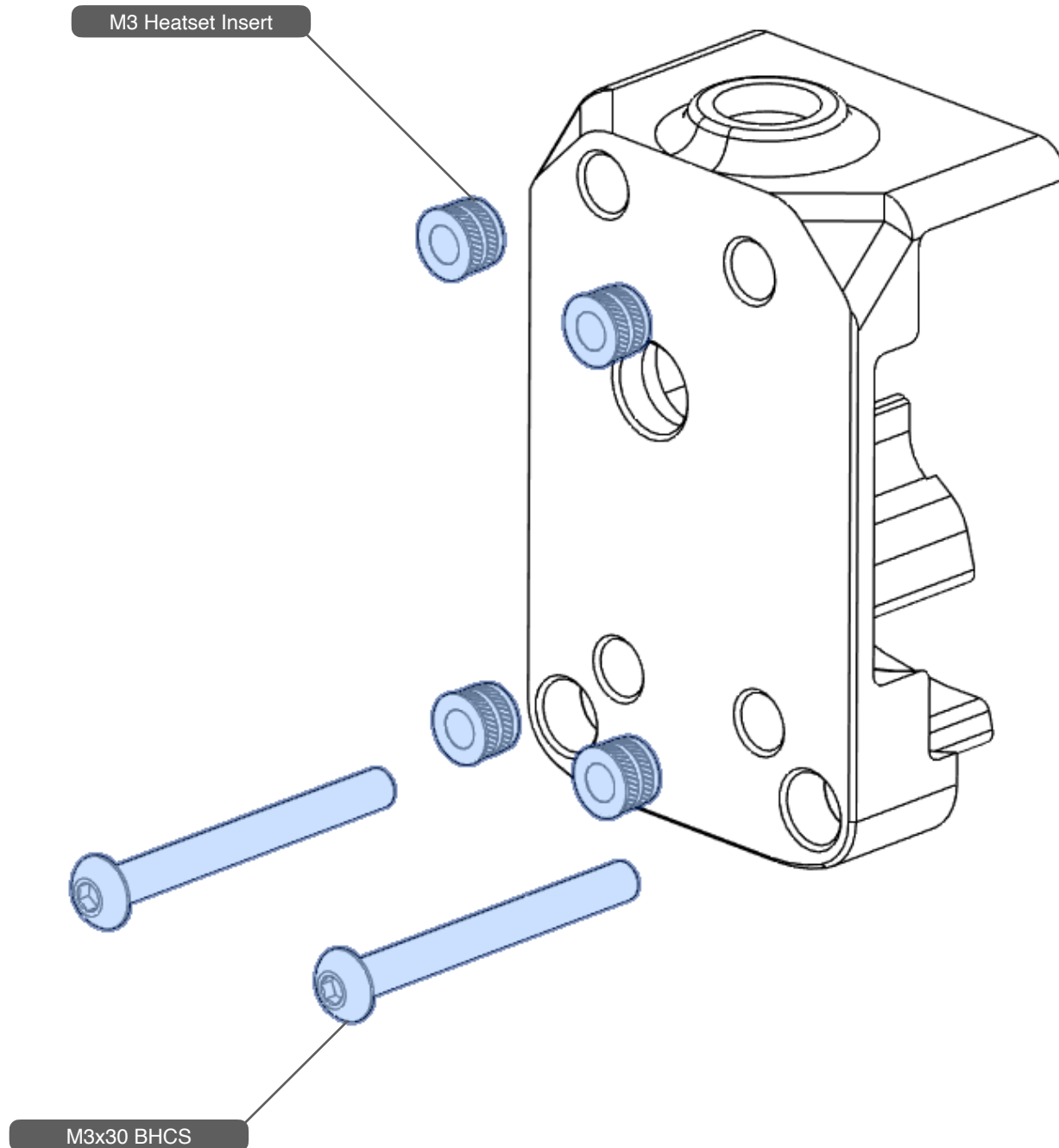
Part	Qty
M3x30 BHCS	2
Guidler Door Assembly	1





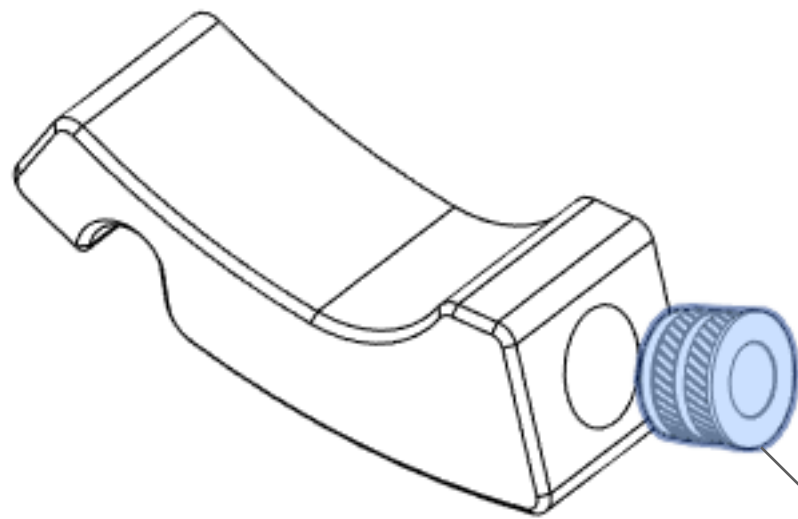
Guts Assembly

Part	Qty
M3x30 BHCS	2
M# Heatset Instart	2

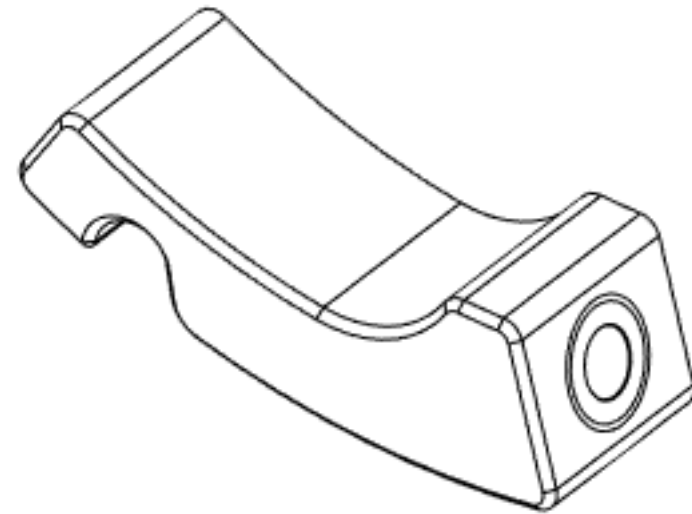


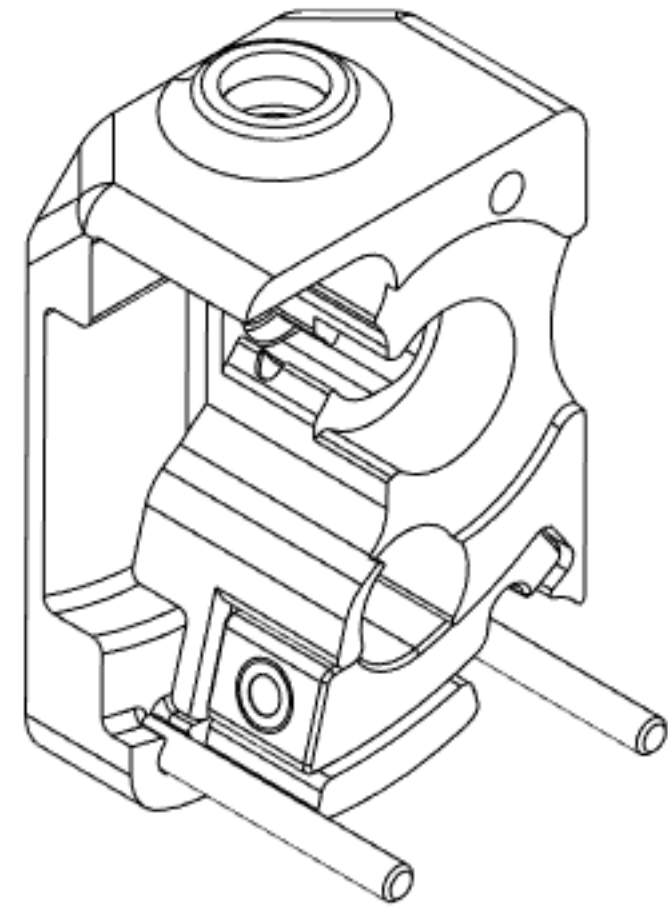
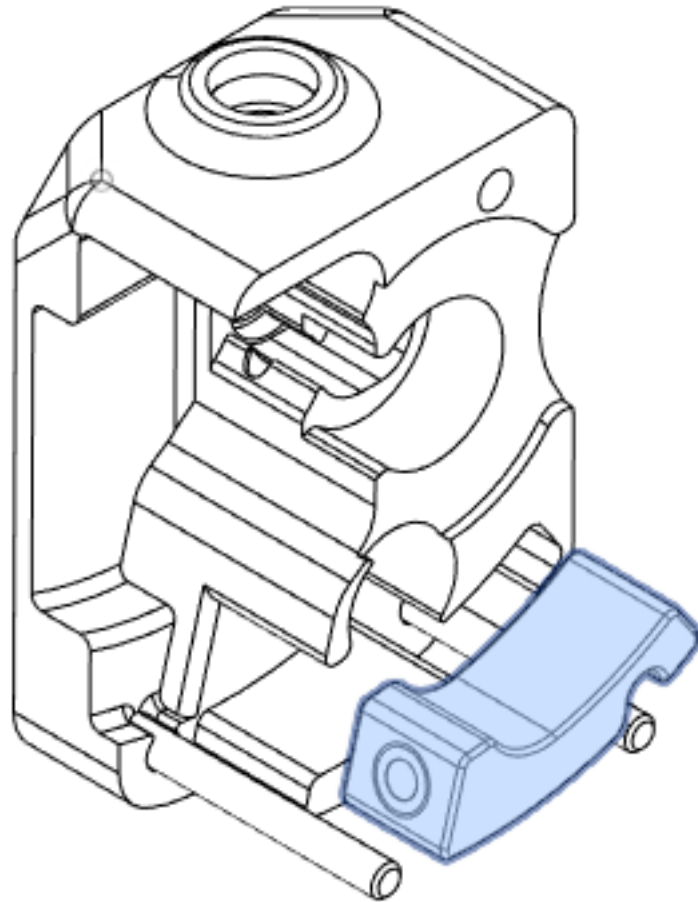
Heatset Insert

Part	Qty
[a]_Latch_Shuttle_x1	1
M3 Heatset Insert	1



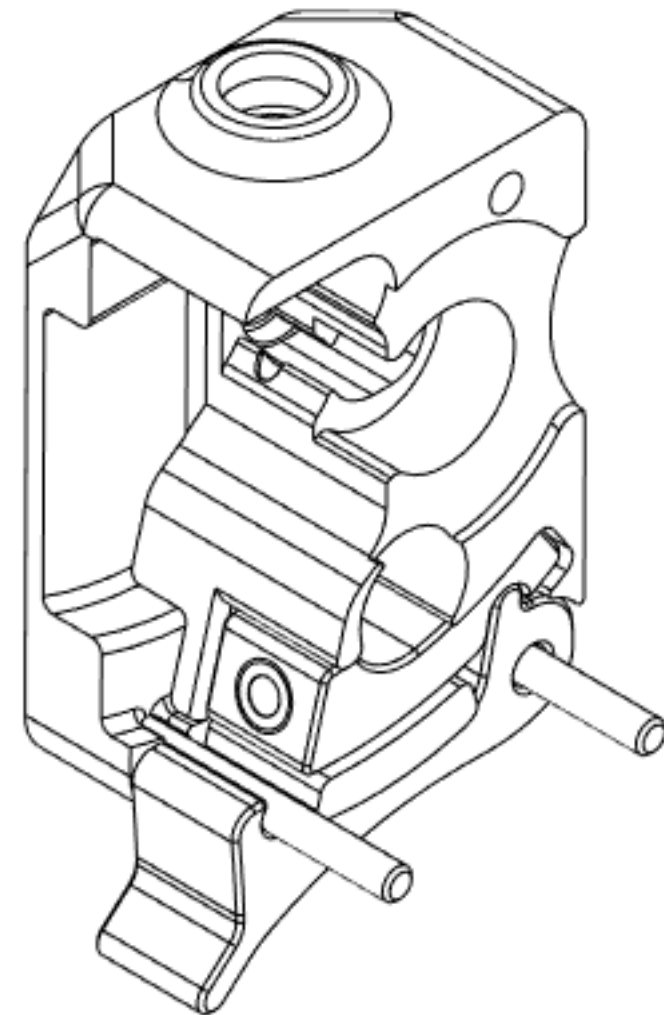
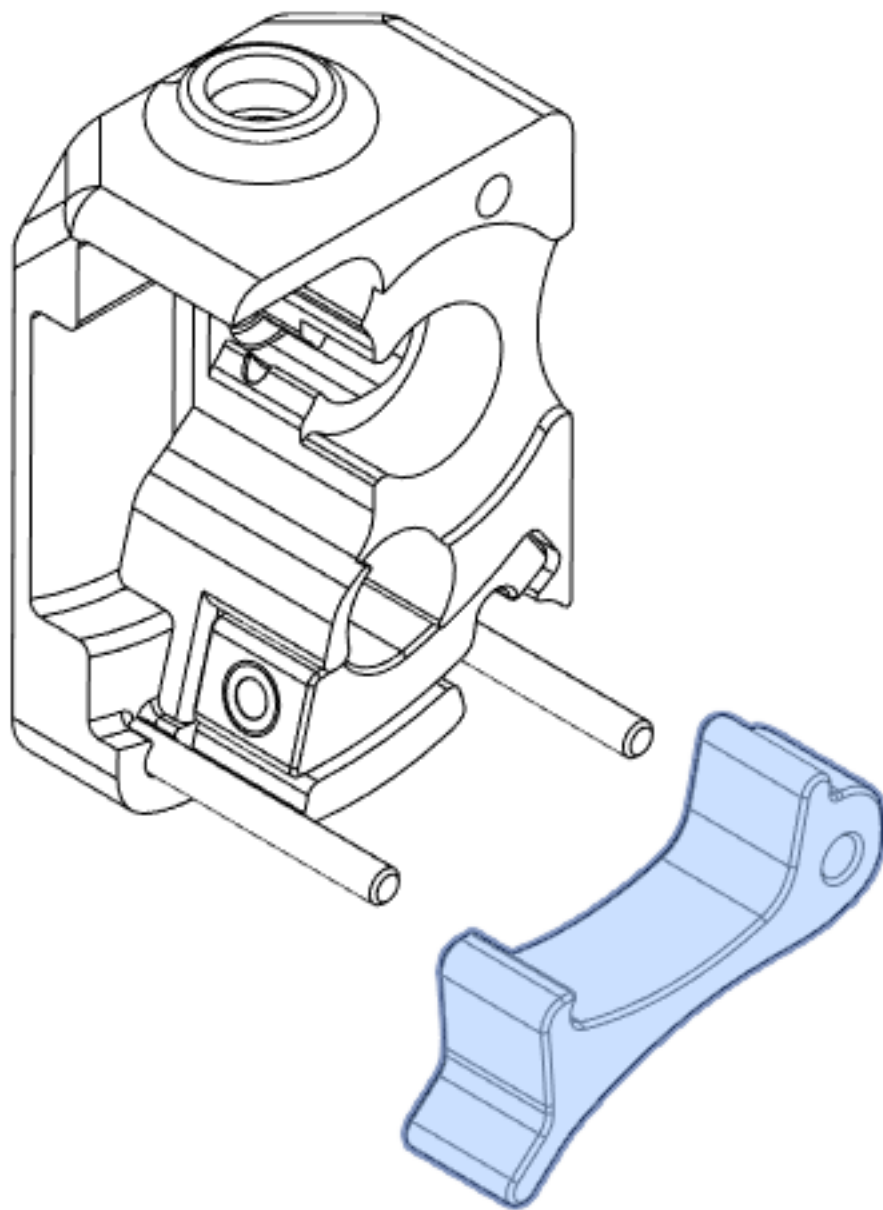
M3 Heatset Insert

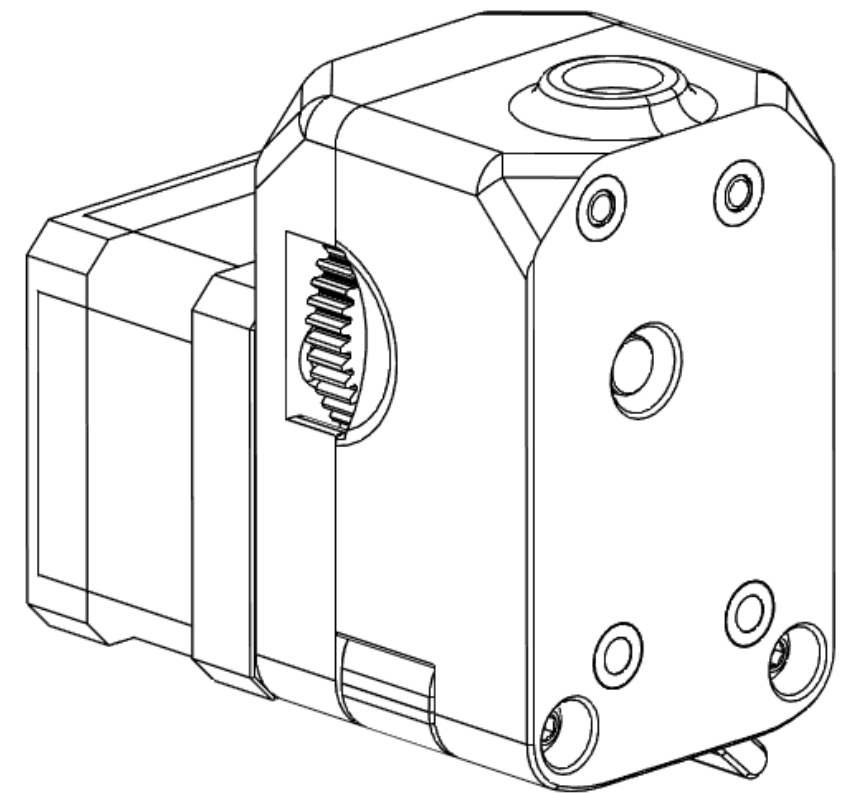
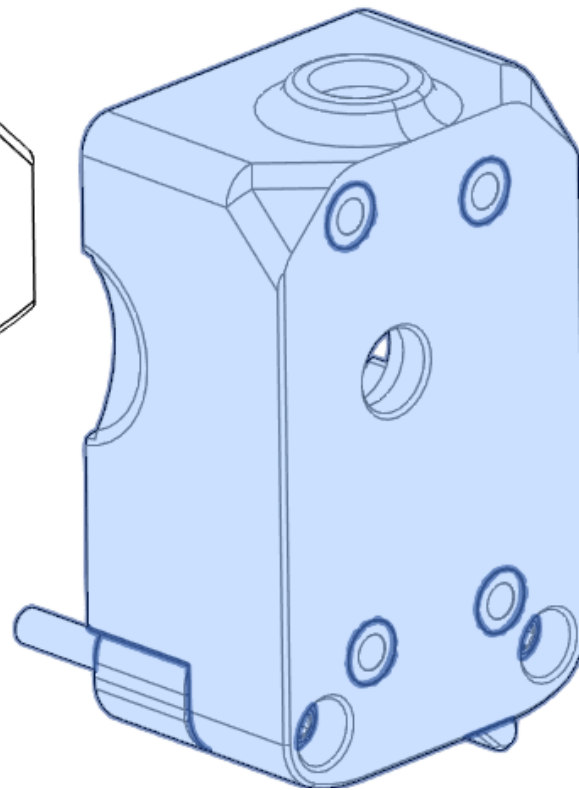
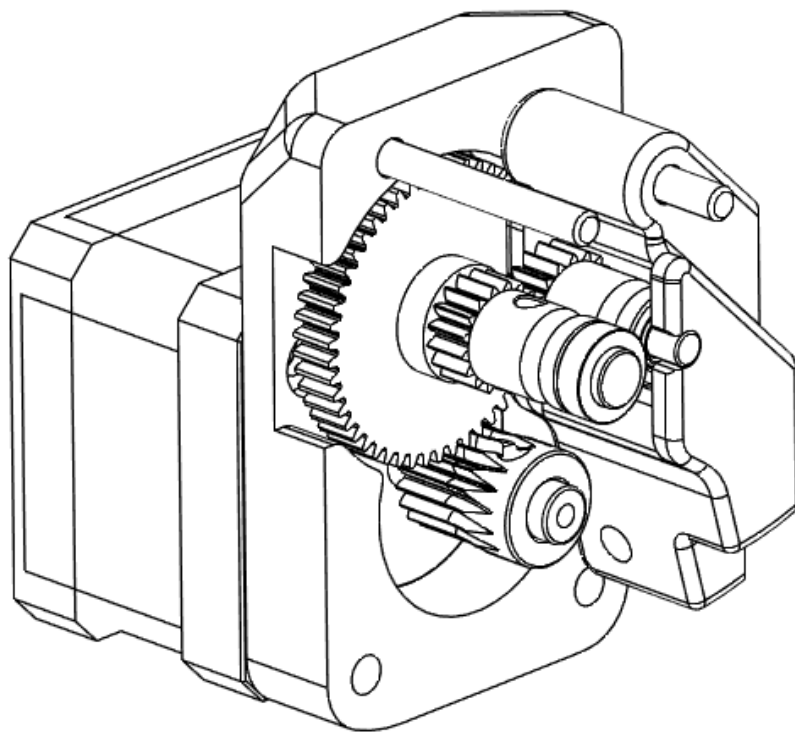




Install Latch

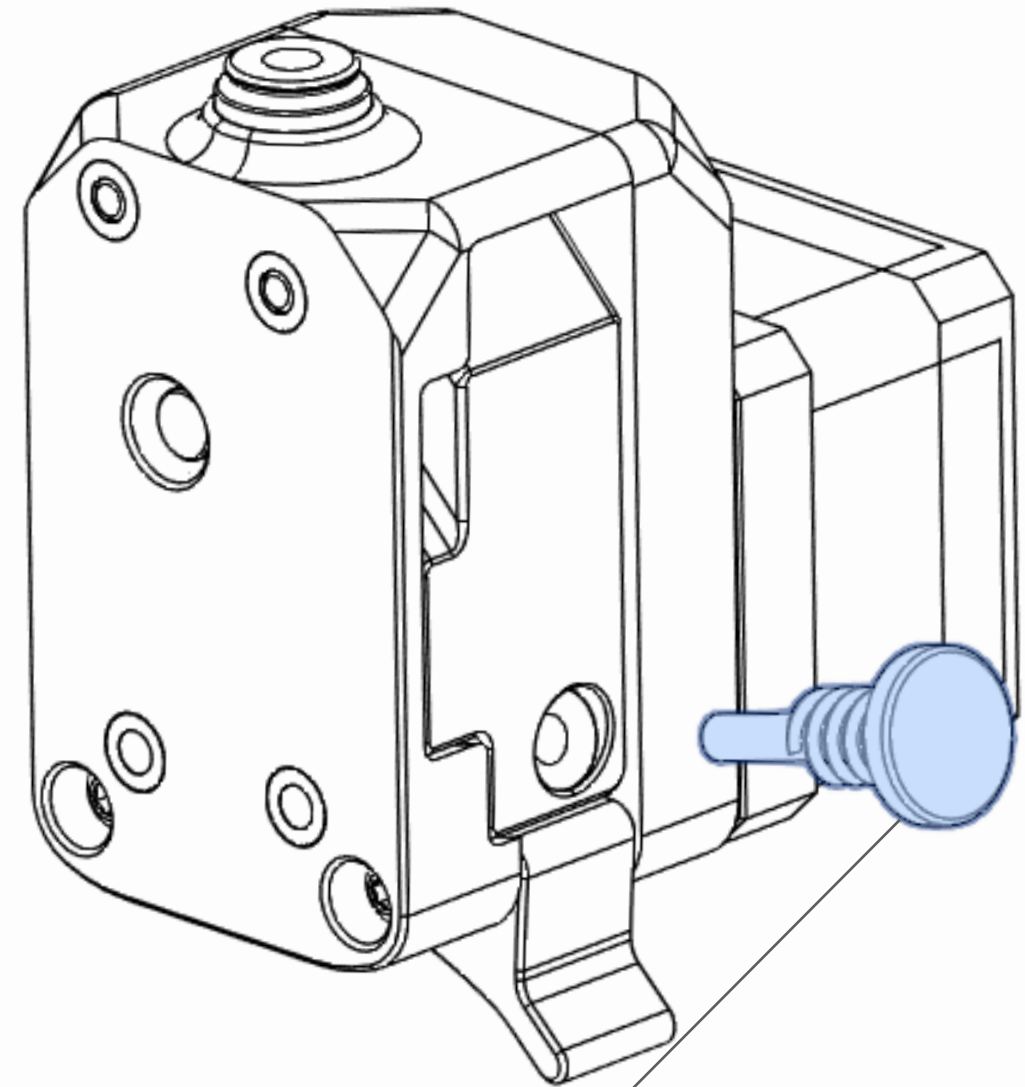
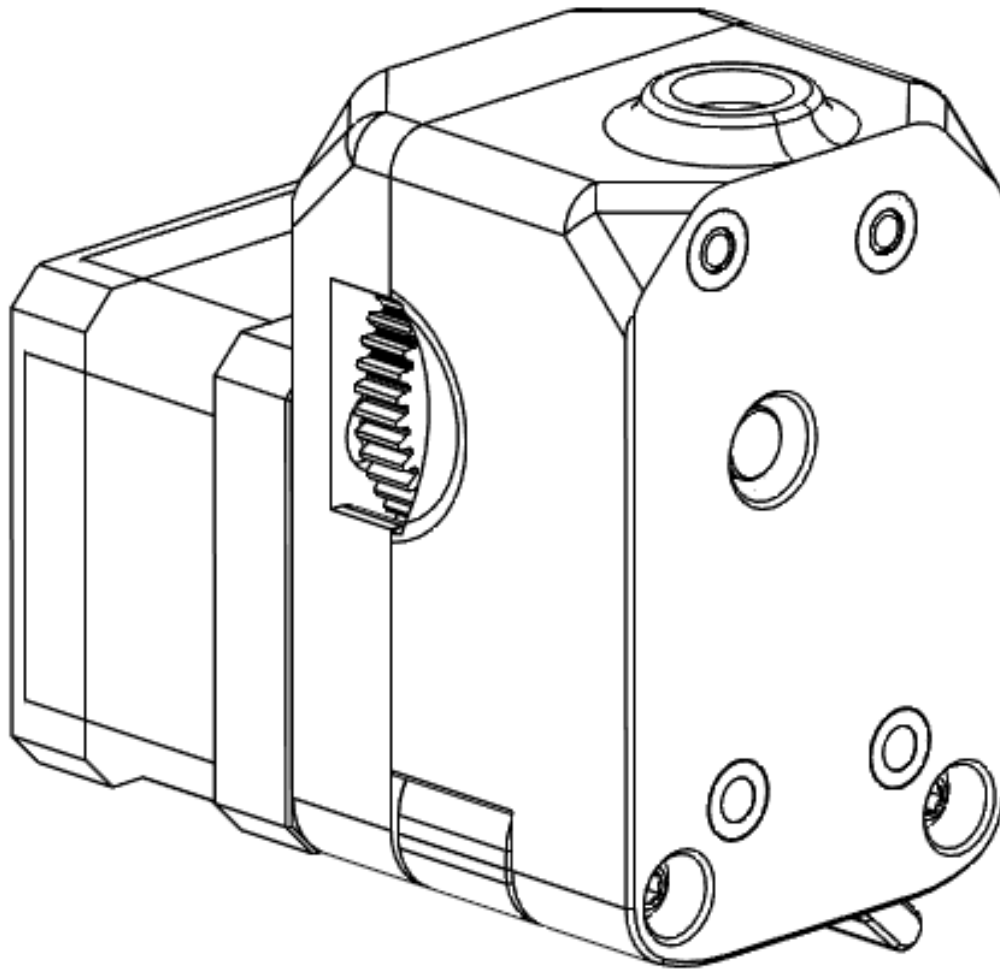
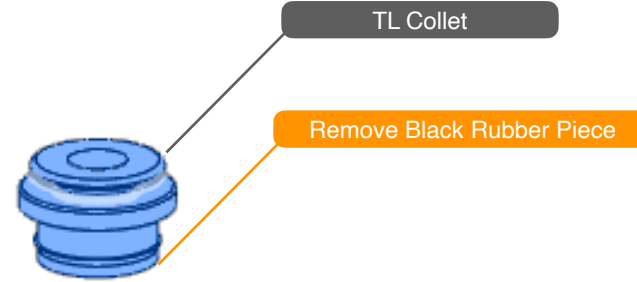
Part	Qty
[a]_Latch_x1	1





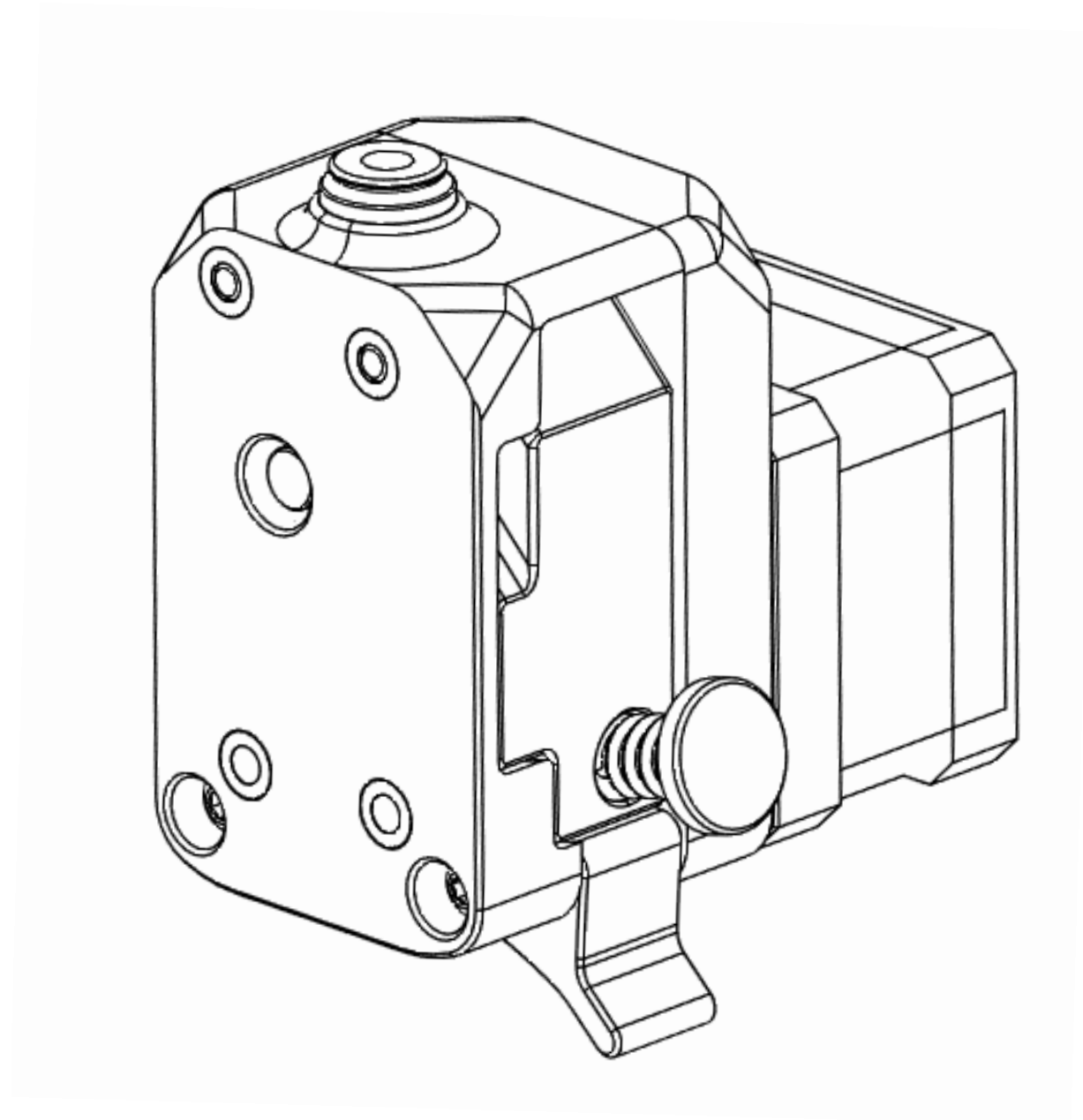
Final Touches

Part	Qty
TL Collet	1
BMG Knob	1
BMG Spring	1



BMG Tensioner Knob

YAY!



Thanks!

Brought To You By; In No Particular Order					
russiancatfood	Chron	etherwalker	Lolmodule	Strubinator	brick_sandwich
8Bit Poro	codeXmas	xanin	louielc	synlor	carnufex
aMpeX	daveidmx	fermion	Maglin	tameike	E.Lariviere
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andylsun	dgcaste	fujimonster	Minasokoni	Timmit99	insurgus
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ArmyAg08	doowrednu	Hackdoggo	pnewb	Trunkmonky	resam
bahahah	Drbpgh	lakabos	pnokel	Ubernero	Stephan
Boff	dunar	Immutef	railgunner13f	_unregistered	wile.e.coyote
<i>our husbands/wives/children/pets/significant others: for putting up with our shit, and dealing with our aliexpress packages</i>					