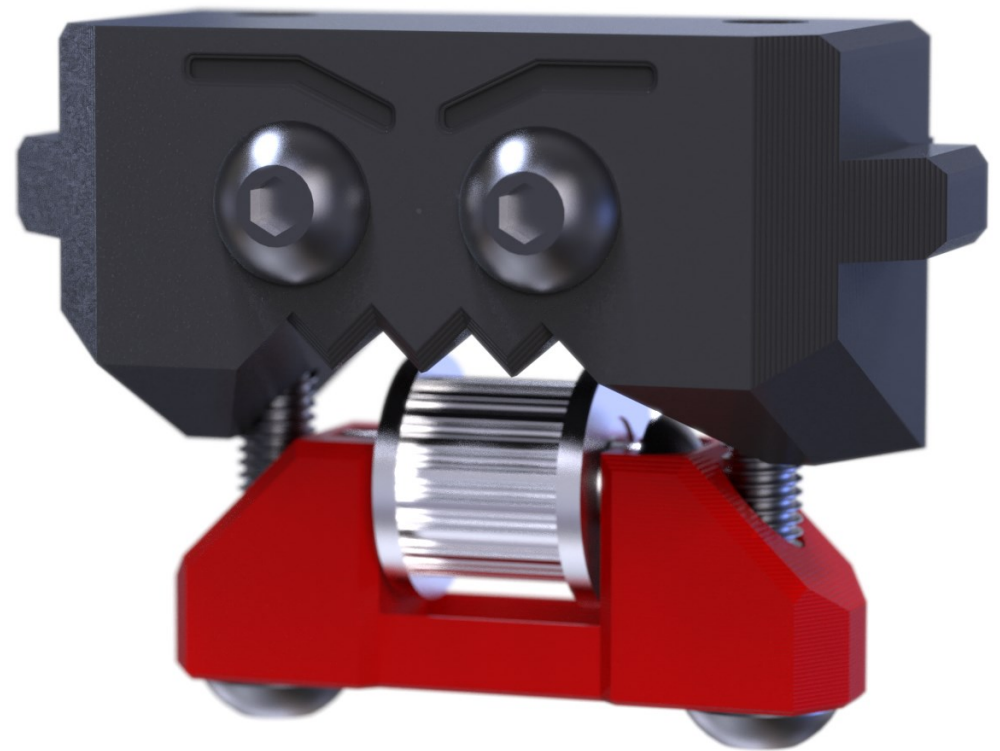


# BZI

ASSEMBLY MANUAL



Everyone could use a little extra Beef

VERSION 10/31/2024

## STL FILE KEY

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The STL naming convention used for BFI/BZI is the same as that used for VORON printers:

### PRIMARY COLOR

#### Example

**BZI\_V2.4\_idler\_body\_x4.stl**

These files will have nothing at the start of the filename.

### ACCENT COLOR

#### Example

**[a]\_BZI\_V2.4\_carrier\_x4.stl**

These files will have "[a]" to the front to mention that they are intended to be printed with an accent color.

### QUANTITY REQUIRED

#### Example

**[a]\_BZI\_V2.4\_carrier\_x4.stl**

If a file ends with "\_x#", that is telling you the quantity of that part required to build this system..

## PRINT GUIDELINES

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The recommended print settings are also those used for VORON printers:

### FDM MATERIAL

Micron was designed for ABS.  
Use other plastics at your own discretion.

### LAYER HEIGHT

Recommended : 0.2mm

### EXTRUSION WIDTH

Recommended : Forced 0.4mm

### INFILL PERCENTAGE

Recommended : 40%

### INFILL TYPE

Grid, Gyroid, Honeycomb, Triangle, Cubic, Adaptive Cubic.

### WALL COUNT

Recommended : 4

### SOLID TOP/BOTTOM LAYERS

Recommended : 5

### SUPPORTS REQUIRED

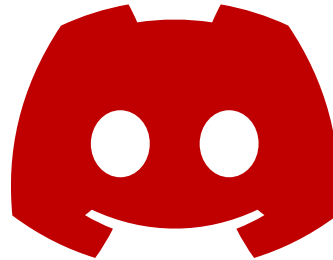
If the part needs supports, they are built into the model.

## HOW TO GET HELP

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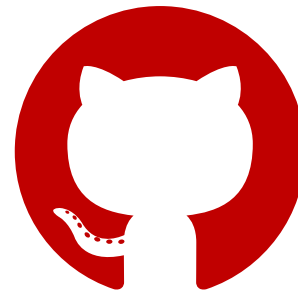
### DISCO? OH ...DISCORD

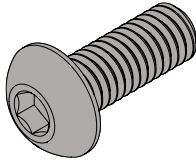
If you need assistance with your BFI/BZI assembly, you can head over the Voron Discord server and post your questions ( typically in the `#voronuser_mods` channel ).



### GIT GUD

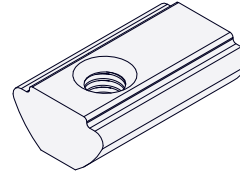
If you want to stay up to date on the latest files for BFI/BZI. The github page is the only source for the latest files.



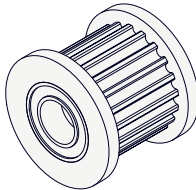
**BUTTON HEAD CAP SCREW  
(BHCS)**

Metric fastener with a domed shaped head and hex drive.

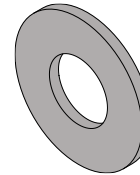
**ISO 7380-1**

**DROP-IN 2020 T-NUT**

Nut that can be inserted into the slot of an aluminum profile.

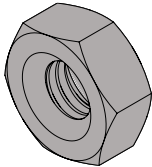
**GT2 20T TOOTHED IDLER**

GT2 idler used in BZI

**M5 SHIMS**

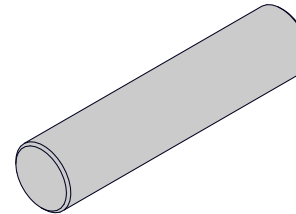
Not to be confused with stamped washers. These are used in all M5 call-out locations in this manual.

**3x6x0.5 DIN 988**

**HEX NUT**

Hex nuts couple with bolts to create a tight, secure joint.

**ISO 4032 / DIN 934**

**5MM PIN**

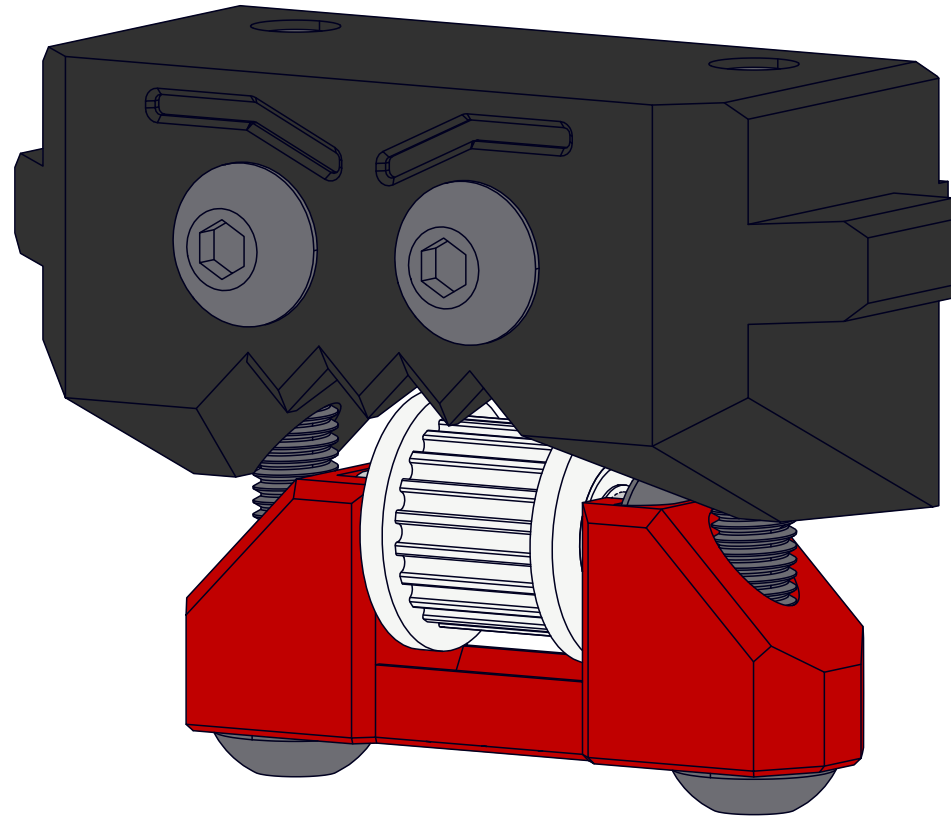
Steel shaft, 5mm in diameter

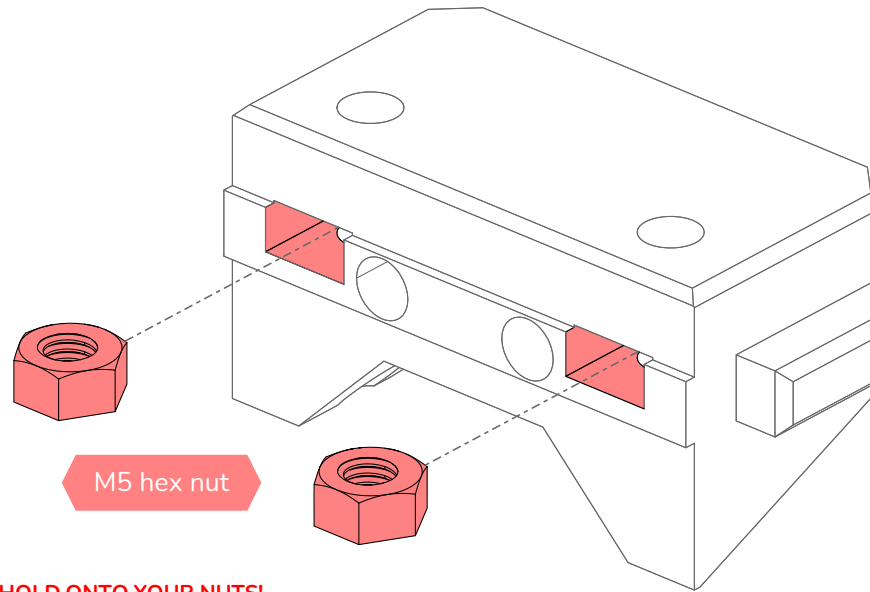
**ATTENTION BUBBLE**

This logo denotes steps that are common areas that mistakes can occur.

**Hardware Used**

Look for the **RED** call outs to mention the various hardware used

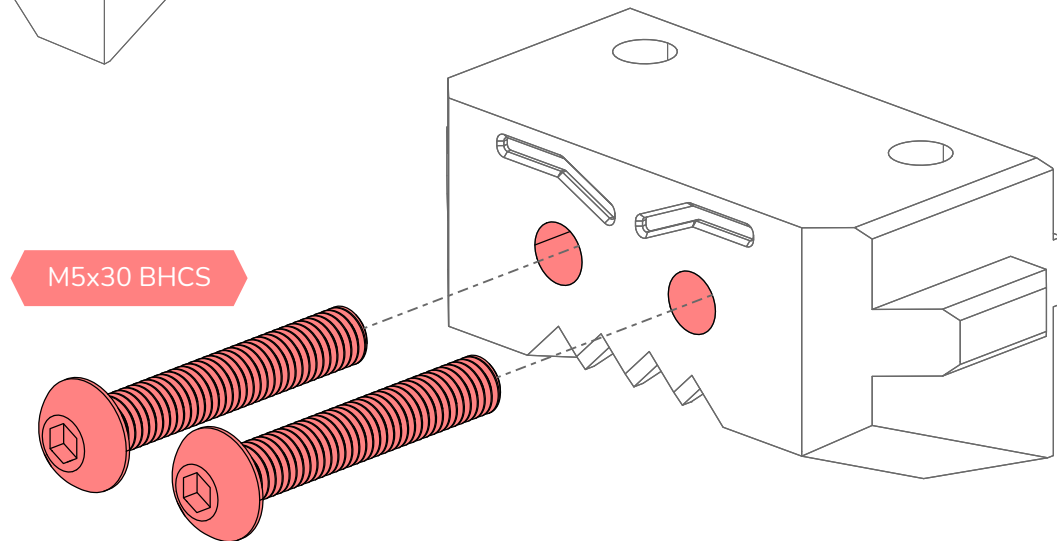


**HOLD ONTO YOUR NUTS!**

M5 hex nuts get pressed into these recesses in the back of the main body, once installed the 2020 extrusions keep them from falling out. The holes above the hex nuts are slightly undersized, this is on purpose to act as a built-in lock nut.

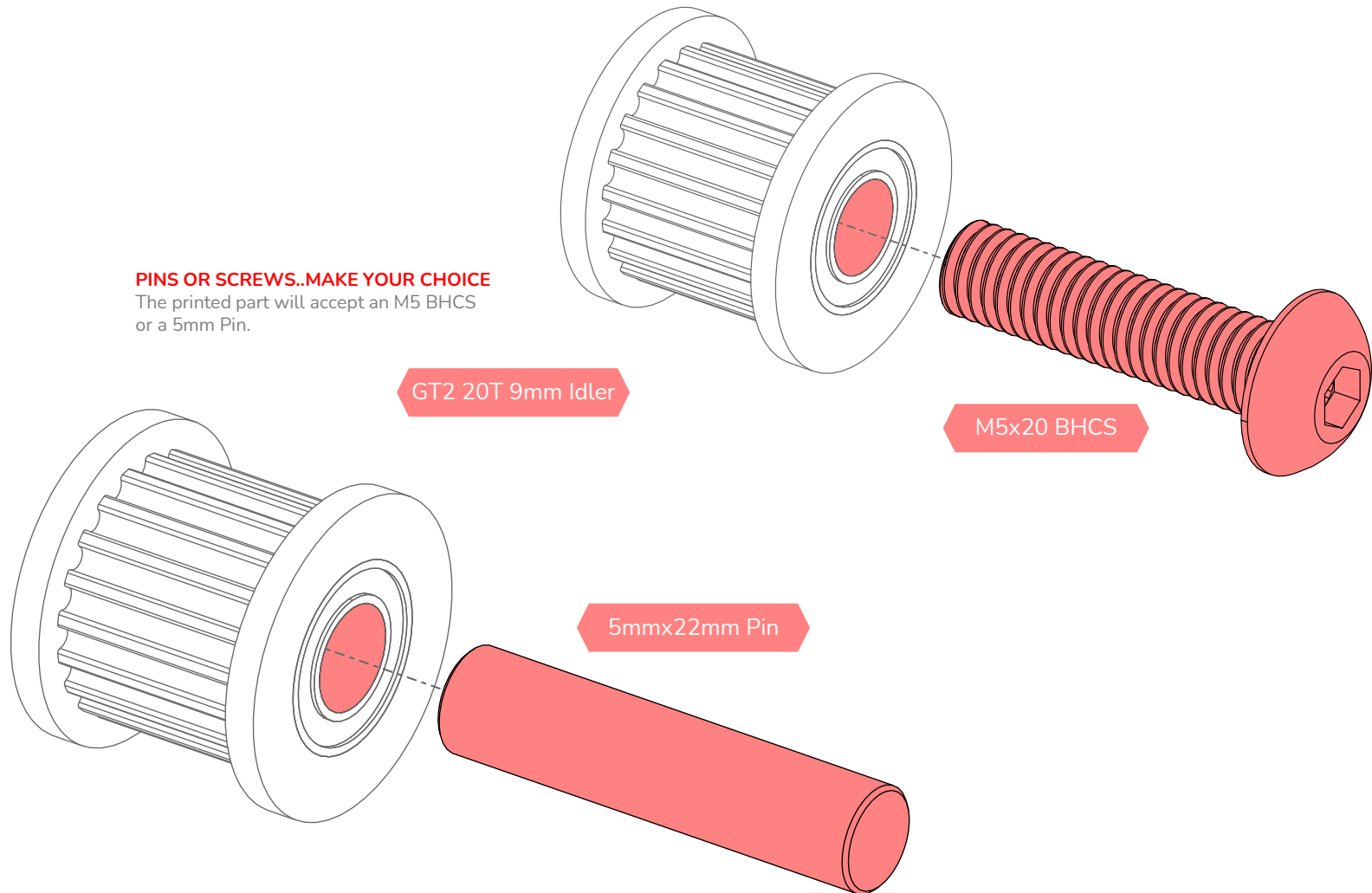
**YOU HAVE BEEN FRAMED!**

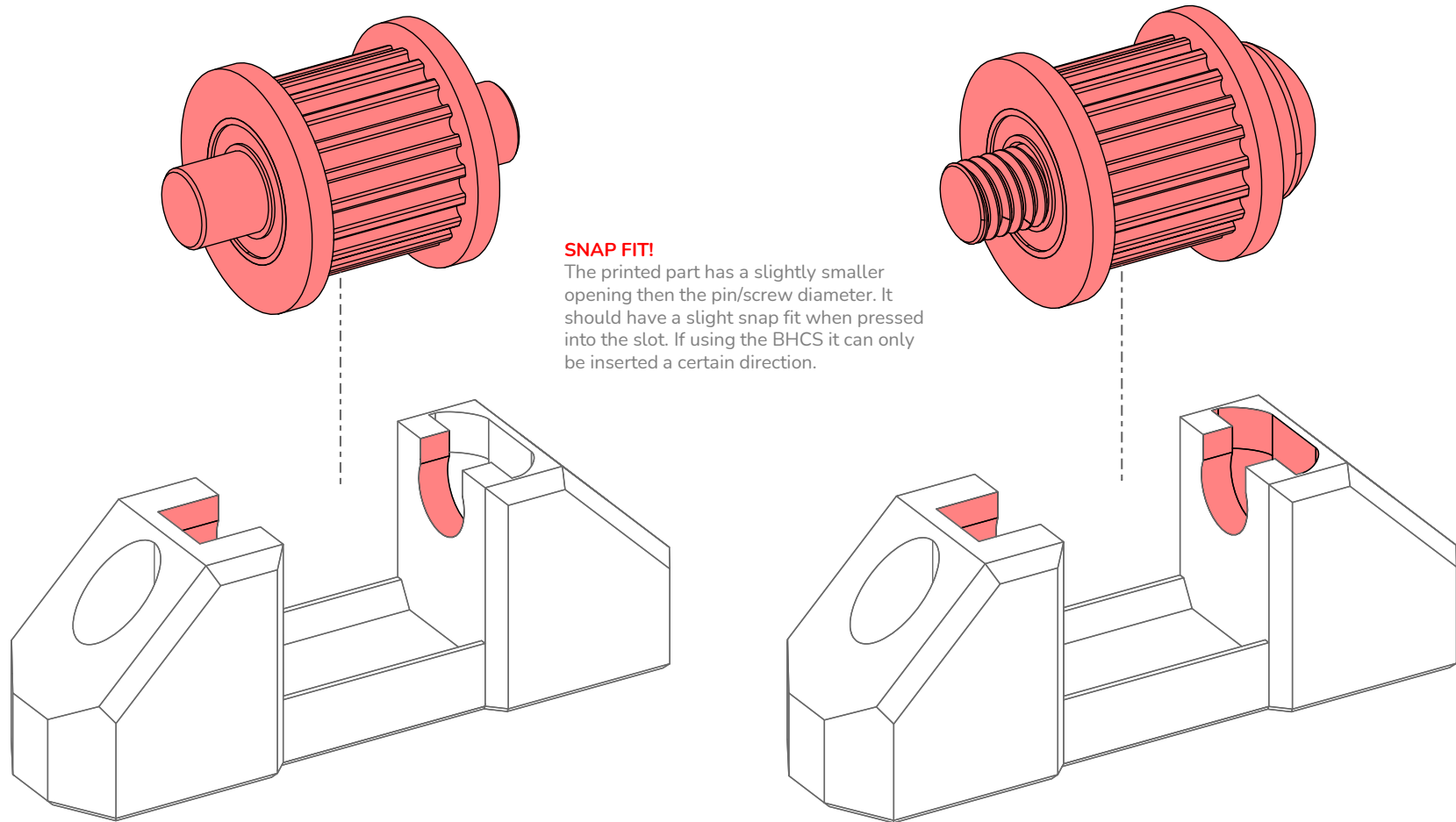
Mount the main body to your frame in the same location as the stock Z idlers. There is only a single STL for the main body instead of 2 as it fits both sides of the frame.



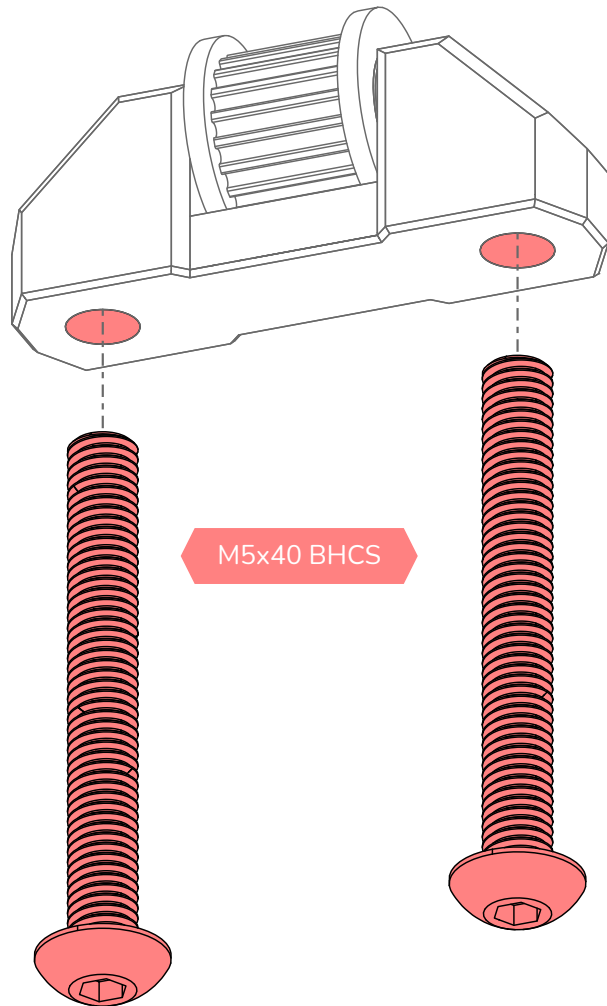
**PINS OR SCREWS..MAKE YOUR CHOICE**

The printed part will accept an M5 BHCS or a 5mm Pin.



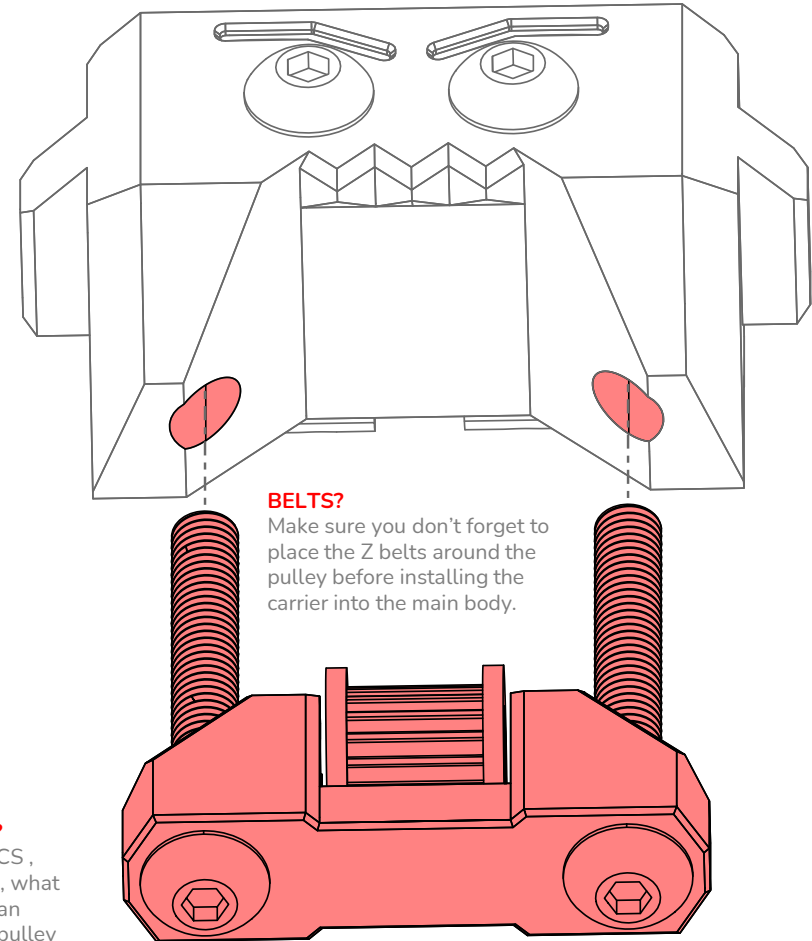






### IS THAT TOO TIGHT??

Using the 2 m5x40 BHCS , you tension the Z belts , what makes BZI nice is you can adjust the angle of the pulley to ensure proper tracking of the belt.



# BZI

