

# COCOA PRESS



## ASSEMBLY MANUAL

Break Free from the Mold.

---

VERSION 2023-10-04



Before you begin on your journey, a word of caution.

This machine can burn and electrocute you if you are not careful.

**Please, read the entire manual before you start assembly.**

**COCOA PRESS**

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### PART PRINTING GUIDELINES

The Cocoa Press team has provided the following print guidelines for you to follow in order to have the best chance at success with your parts. There are often questions about substituting materials or changing printing standards, but we recommend you follow these.

<b>3D PRINTING PROCESS</b> Fused Filament Fabrication (FFF)	<b>INFILL TYPE</b> Gyroid, Grid, Honeycomb, Triangle or Cubic
<b>MATERIAL</b> PETG	<b>INFILL PERCENTAGE</b> Recommended: 25%
<b>LAYER HEIGHT</b> Recommended: 0.2mm	<b>WALL COUNT</b> Recommended: 3
<b>NOZZLE SIZE</b> Recommended: 0.4mm	<b>SOLID TOP/BOTTOM LAYERS</b> Recommended: 4 bottom, 5 top layers

### FILE NAMING

By this time you should have already downloaded our STL files. You might have noticed that we have used a unique naming convention for the files. This is how to use them.

#### PRIMARY COLOR

##### **B\_Drive\_Frame\_Lower\_x1.stl**

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

#### ACCENT COLOR

##### **[a]\_Tensioner\_Knob\_x2.stl**

We have added “[a]” to the front of any STL file that is intended to be printed with accent color.

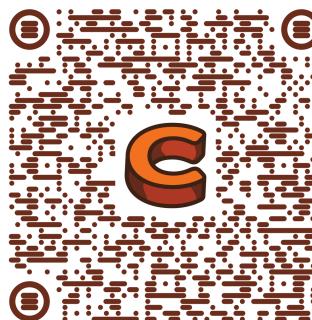
#### QUANTITY REQUIRED

##### **[a]\_Thumb\_Nut\_x3.stl**

Any file that ends with “\_x#” is telling you the quantity of that part required to build the machine.

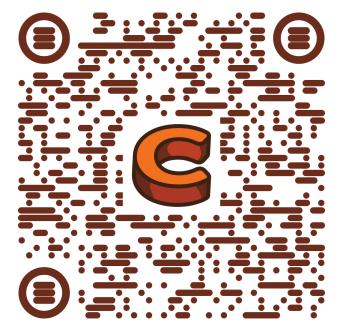
### STL FILE LIST

We have put together a comprehensive list of all the STL files used in this manual you can use this to keep track of parts you have printed, identify the names of printed parts, and/or reference where they are used in the body of this manual. Simply copy the document from the link and you can markup a local copy for yourself.



### FILAMENT

While under no obligation to use our filaments, we've collaborated with PrintedSolid to produce Cocoa Press PETG for use with your FFF plastic printer to make the printed parts for your Cocoa Press. They can be purchased on our website [here](#).



[cocoapress.com/products/cocoa-press-filament](http://cocoapress.com/products/cocoa-press-filament)

**HOW TO GET HELP**

If you need assistance with your build, we're here to help. Head on over to our contact page and submit your questions.

**REPORTING AN ISSUE**

Should you find an issue in the documentation or have a suggestion for an improvement please consider opening an issue on GitHub (  
<https://github.com/CocoaPress/AssemblyManual-Issues>).

When raising an issue please include the relevant page numbers and a short description; annotated screenshots are also very welcome. We periodically update the manual based on the feedback we get.



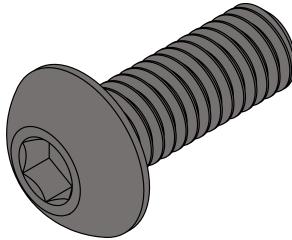
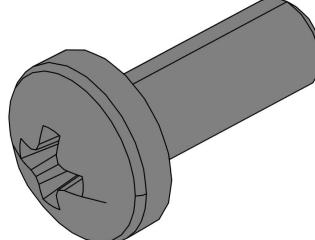
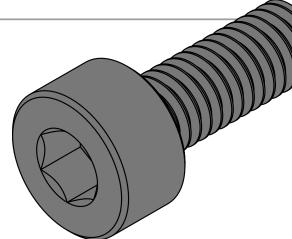
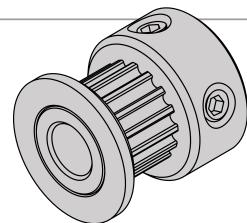
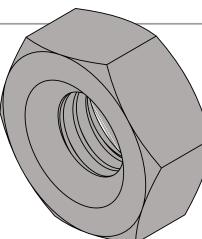
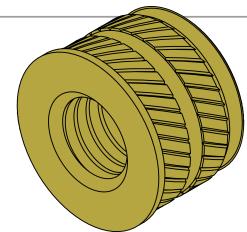
[github.com/CocoaPress/AssemblyManual-Issues](https://github.com/CocoaPress/AssemblyManual-Issues)

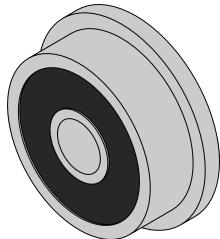


[cocoapress.com/pages/contact](http://cocoapress.com/pages/contact)

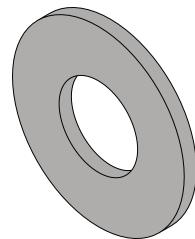
**THIS IS JUST A REFERENCE**

This manual is designed to be a simple reference manual. Building a printer can be a complex endeavour and for that reason we recommend checking out [help.cocoapress.com](http://help.cocoapress.com) for supplemental information or emailing support ([hello@cocoapress.com](mailto:hello@cocoapress.com)).

	<p><b>BUTTON HEAD CAP SCREW (BHCS)</b></p> <p>Metric fastener with a domed shaped head and hex drive. Most commonly found in locations where M3 fasteners are used.</p> <p>ISO 7380-1</p>		<p><b>BUTTON HEAD PHILLIPS SCREW (BHPS)</b></p> <p>Metric phillips fastener with a rounded head.</p> <p>ISO 10642</p>
	<p><b>SOCKET HEAD CAP SCREW (SHCS)</b></p> <p>Metric fastener with a cylindrical head and hex drive. The most common fastener used on the machine.</p> <p>ISO 4762 / DIN 912</p>		<p><b>PULLEY</b></p> <p>GT2 pulley used on the motion system of the machine.</p>
	<p><b>M5 HEX NUT</b></p> <p>Hex nuts couple with bolts to create a tight, secure joint.</p> <p>ISO 4032 / DIN 934</p>		<p><b>HEAT SET INSERT</b></p> <p>Heat the inserts with a soldering iron so that they melt the plastic when installed. As the plastic cools, it solidifies around the knurls and ridges on the insert for excellent resistance to both torque and pull-out.</p>

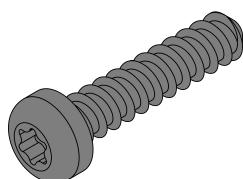
**F695 BEARING**

A ball bearing with a flange used in various gantry locations.

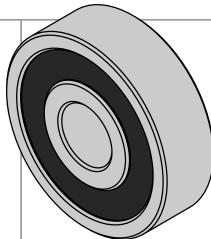
**M5 WASHERS**

These are used in the belt path bearing stacks and other various locations in this manual.

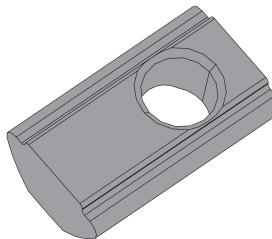
5x10x1 DIN 988

**SELF TAPPING SCREW**

Fastener with a pronounced thread profile that is screwed directly into plastic.

**625 BEARING**

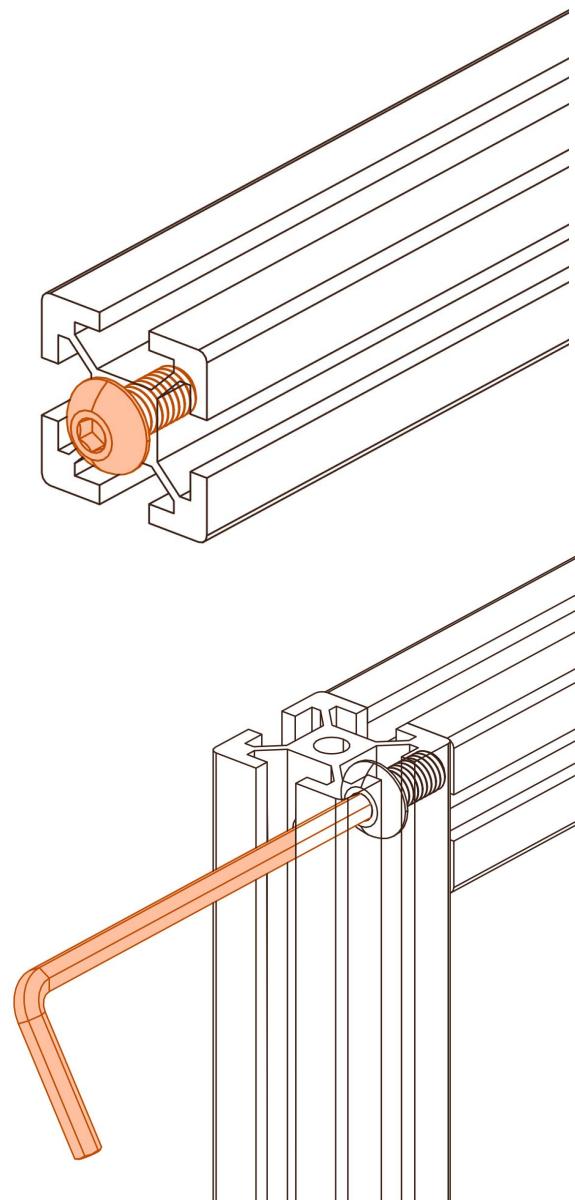
A ball bearing used in various gantry locations.

**POST INSTALL T-NUT**

Nut that can be inserted into the slot of an aluminium profile. Used in both M3 and M5 variants throughout this guide. Often also called "roll-in T-nut".

**ATTENTION BUBBLE**

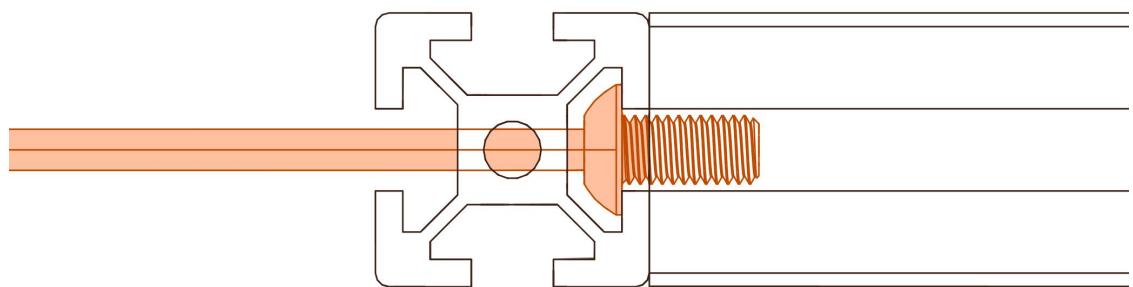
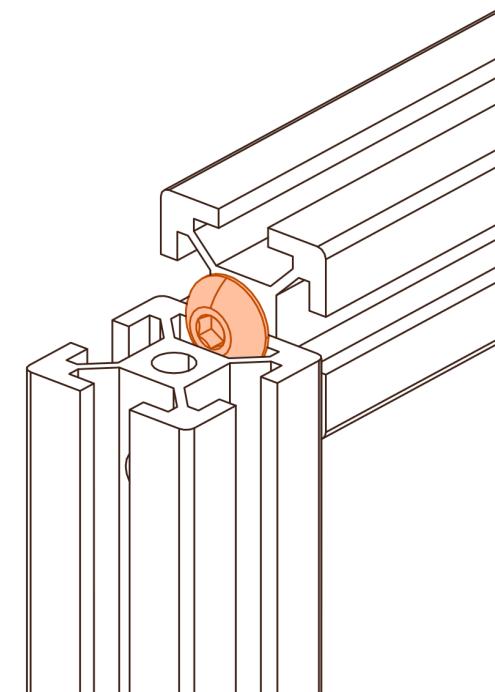
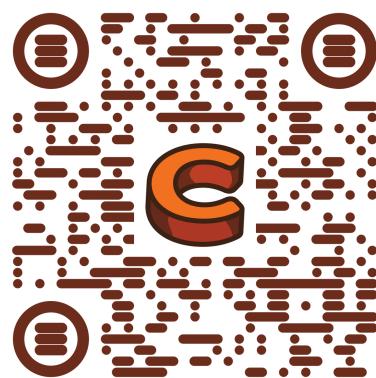
This logo denotes steps that are common areas that mistakes can occur.

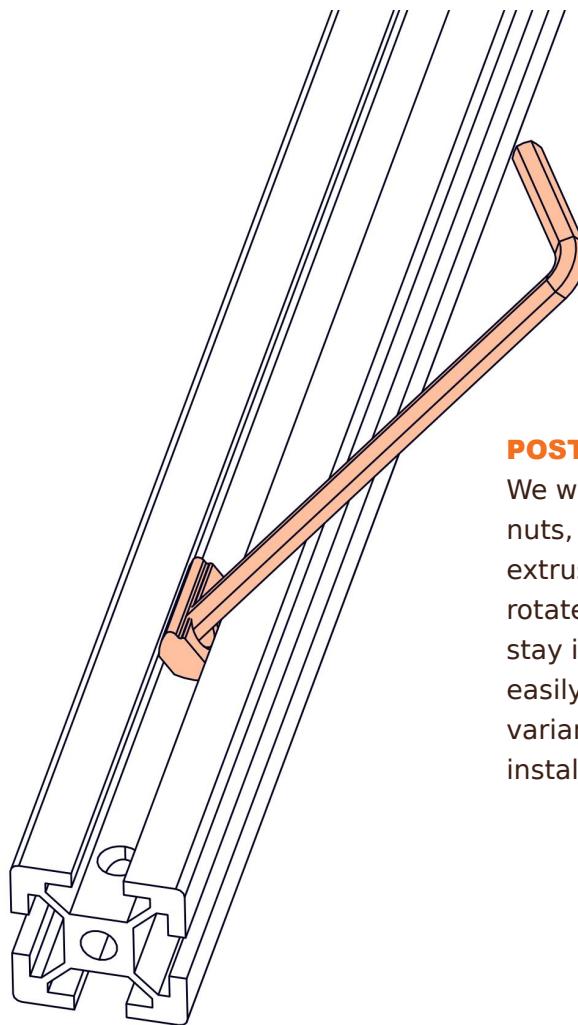
**BLIND JOINT BASICS**

Blind Joints provide a cost-effective and rigid assembly method for joining extrusions. They will be used throughout the frame assembly.

The head of the BHCS is slid into the channel of another extrusion and securely fastened through a small access hole in the extrusion.

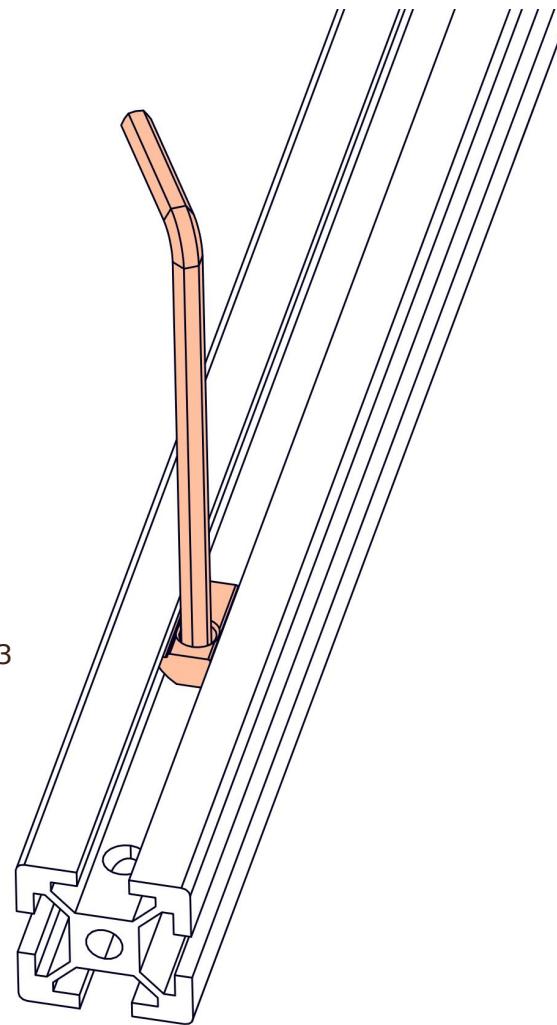
If you've never assembled one before we recommend watching our [assembly guide](#).





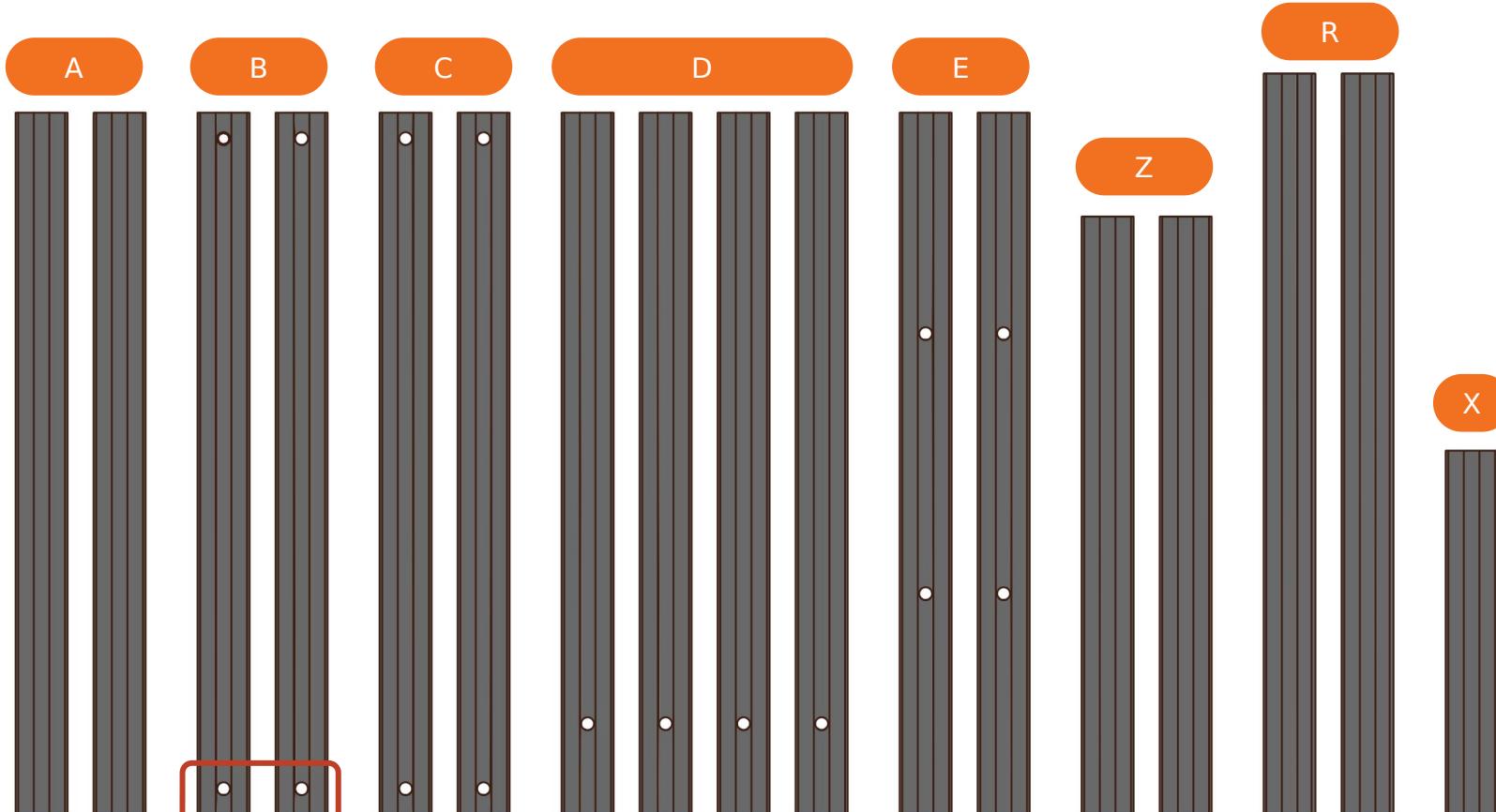
### POST INSTALL T-NUTS

We will be using a lot of post install T-nuts, these can be inserted into the extrusion slots at an angle and then rotated to clip into place, they should stay in position and not slide around easily. We will be using both M5 and M3 variants during the build, so be sure to install the correct ones at each step.



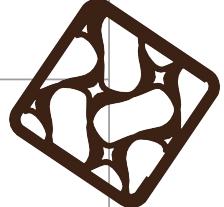
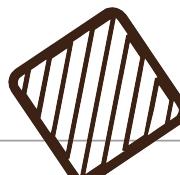
**SORT YOUR EXTRUSIONS**

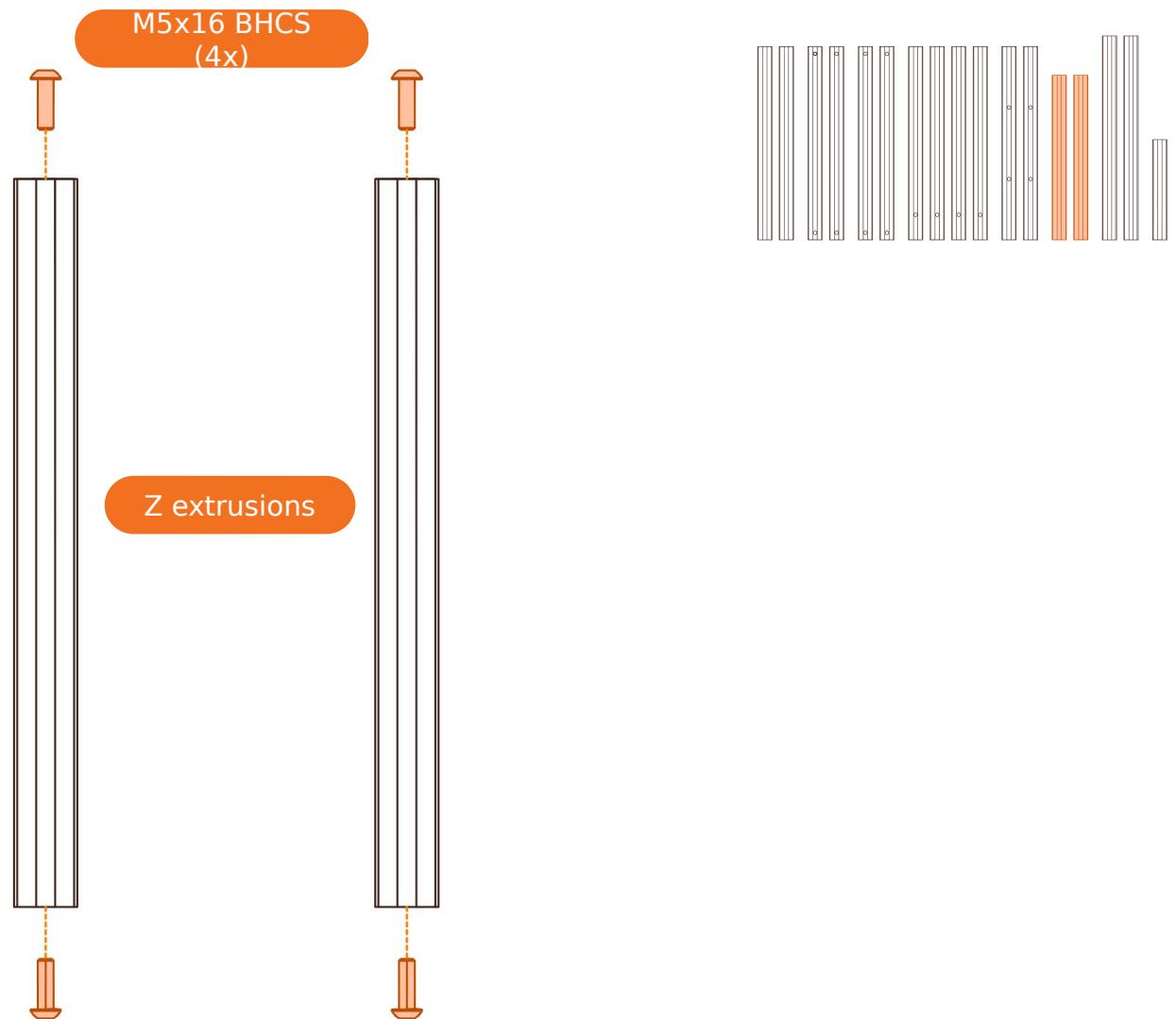
Collect your extrusions and sort them by length. We will highlight the extrusions used in each step and label them as shown on this page.

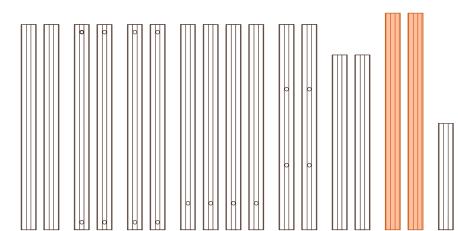
**WHATS THE DIFFERENCE BETWEEN 'B' AND 'C'?**

The "B" extrusions have a third hole cross drilled on the lower end, the C extrusions have only 2 holes each, both in the same direction as shown



	Difficulty	Medium	
	Tools Needed	<p>M3 Driver M5 Driver Small Phillips Screwdriver (Not Included) Scissors (Suggested, To Remove Bags)</p>	
	Hardware Needed	<p>Z Extrusions (2x) E Extrusions (2x) D Extrusions (4x) C Extrusions (2x) B Extrusions (2x) A Extrusion (1x) M5x16 Button Head Cap Screw (16x) M5x10 Button Head Cap Screw (10x) M5 T-Nuts (10x) Rubber Feet (4x)</p>	
	Printed Parts Needed	<p>Front Right / Left Base Rear Right / Left Base</p>	

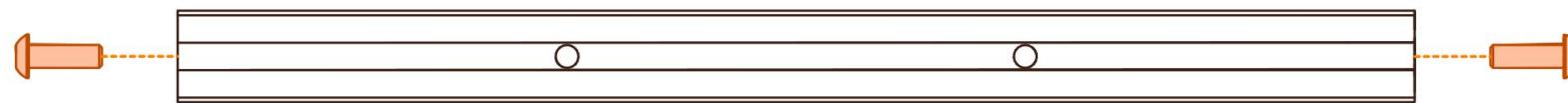


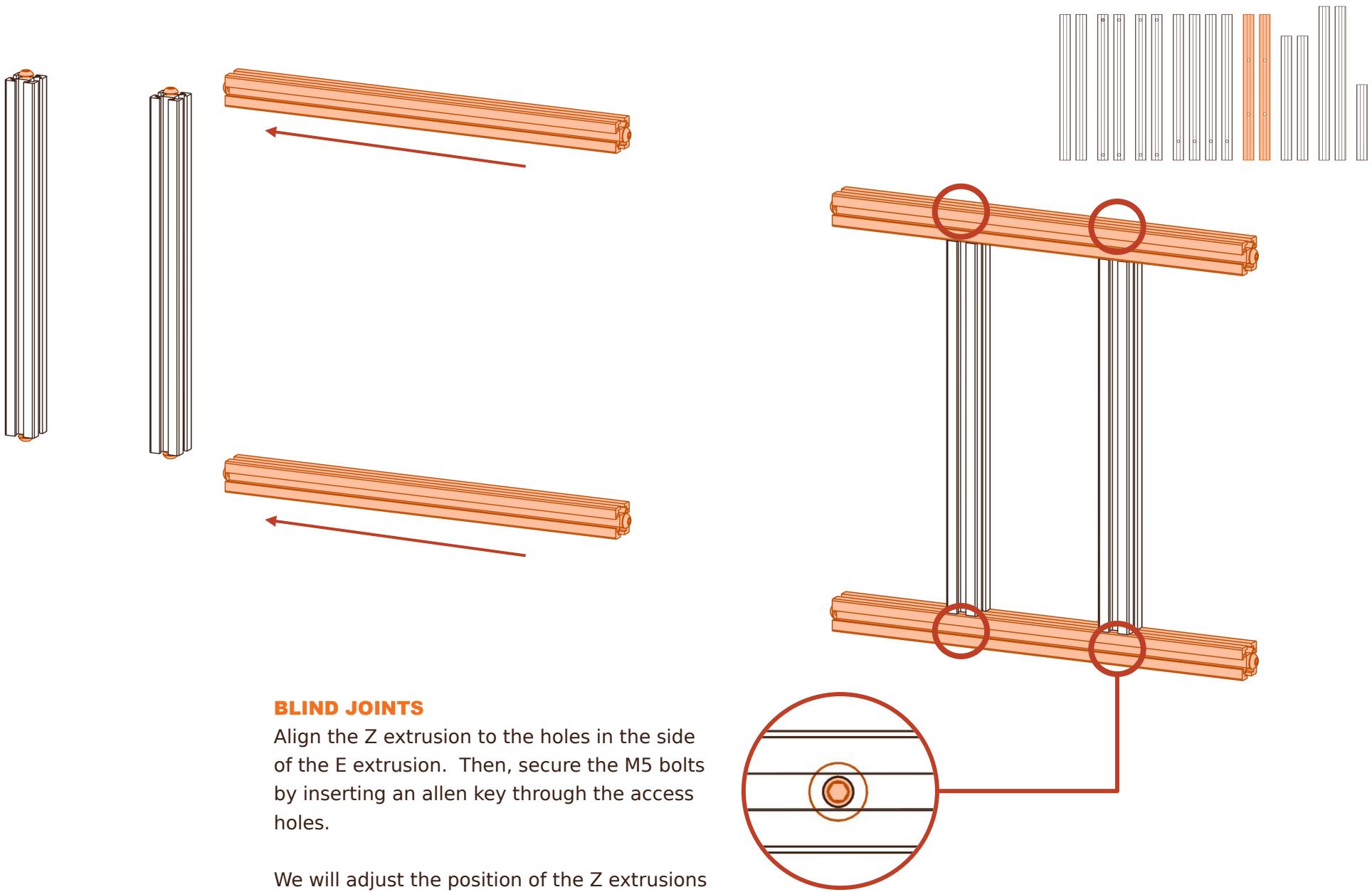


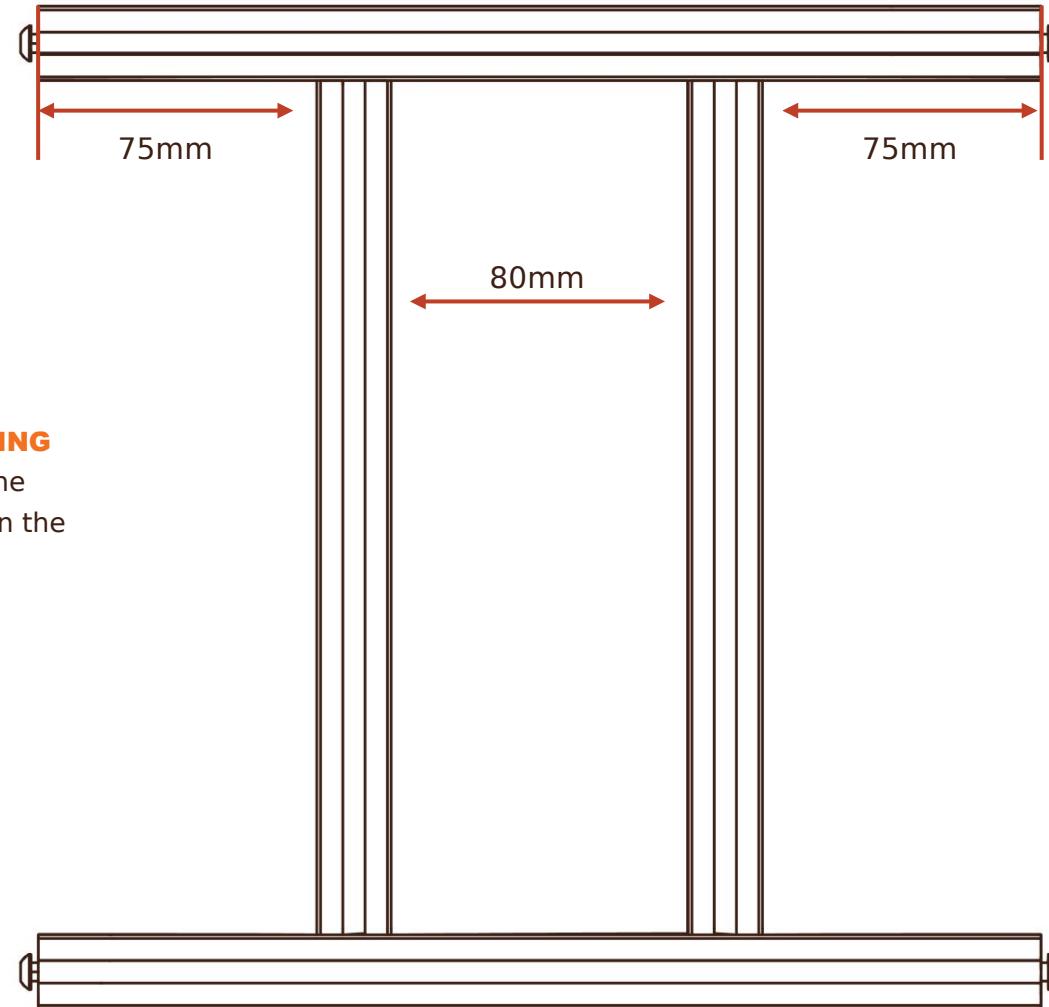
E Extrusions



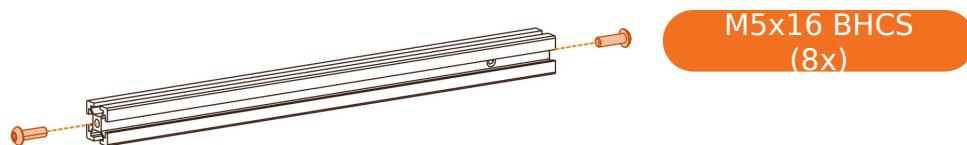
M5x16 BHCS (4x)



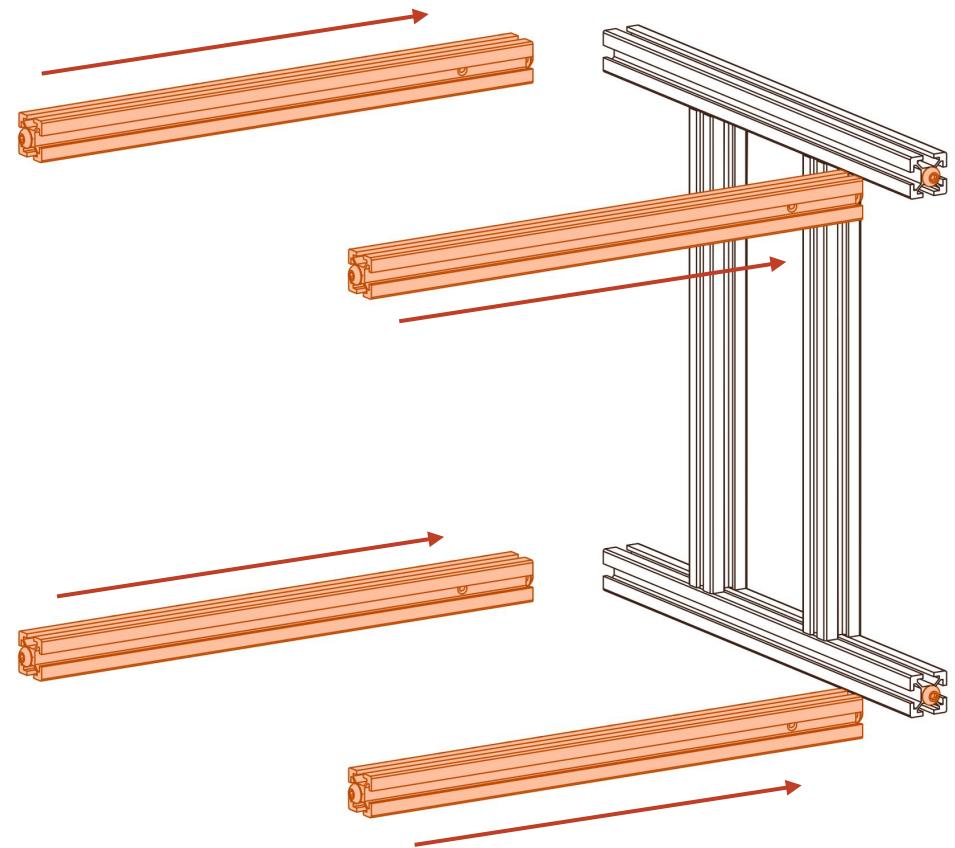
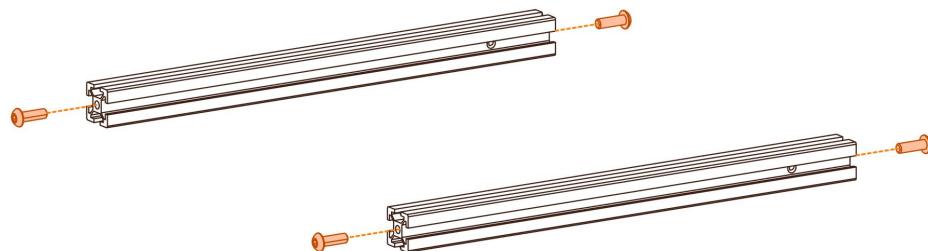


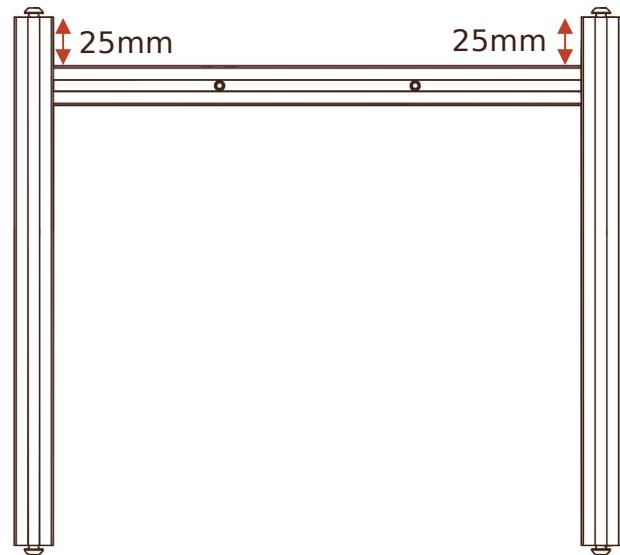
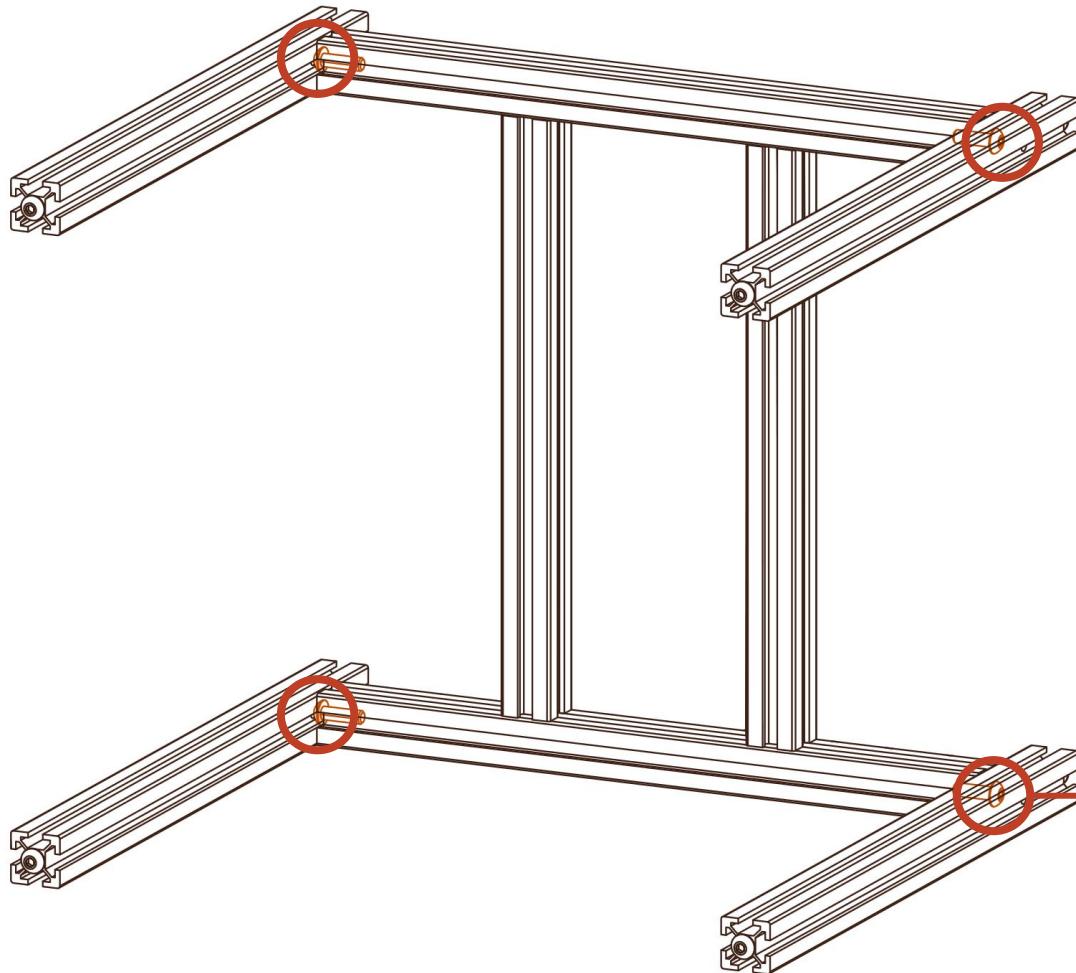
**Z EXTRUSION POSITIONING**

Once you are happy with the positions, be sure to tighten the blind joints fully.



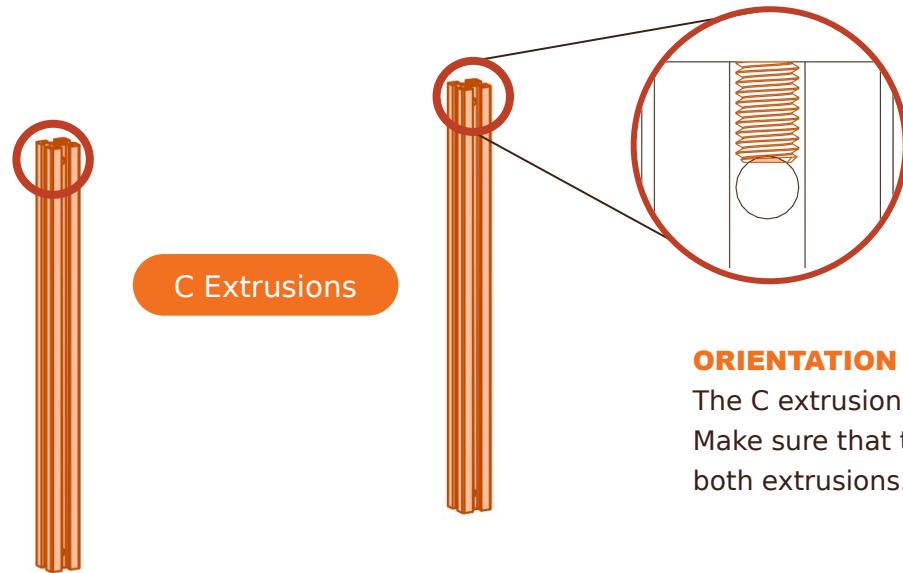
D Extrusions





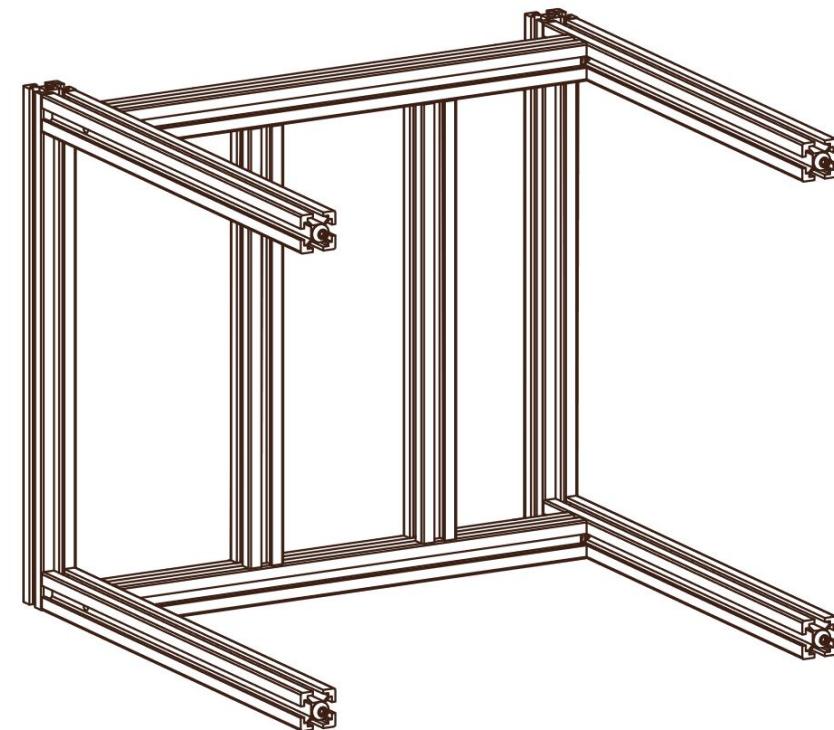
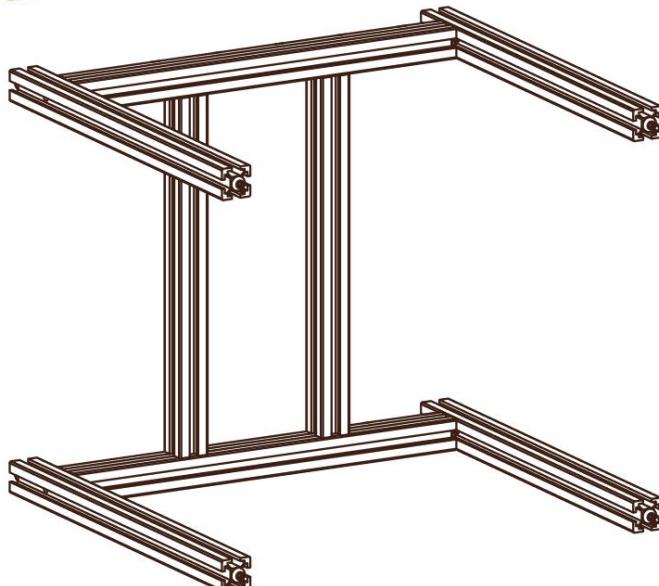
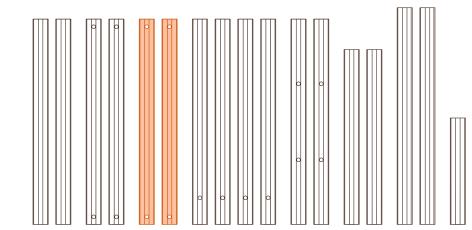
### BLIND JOINTS

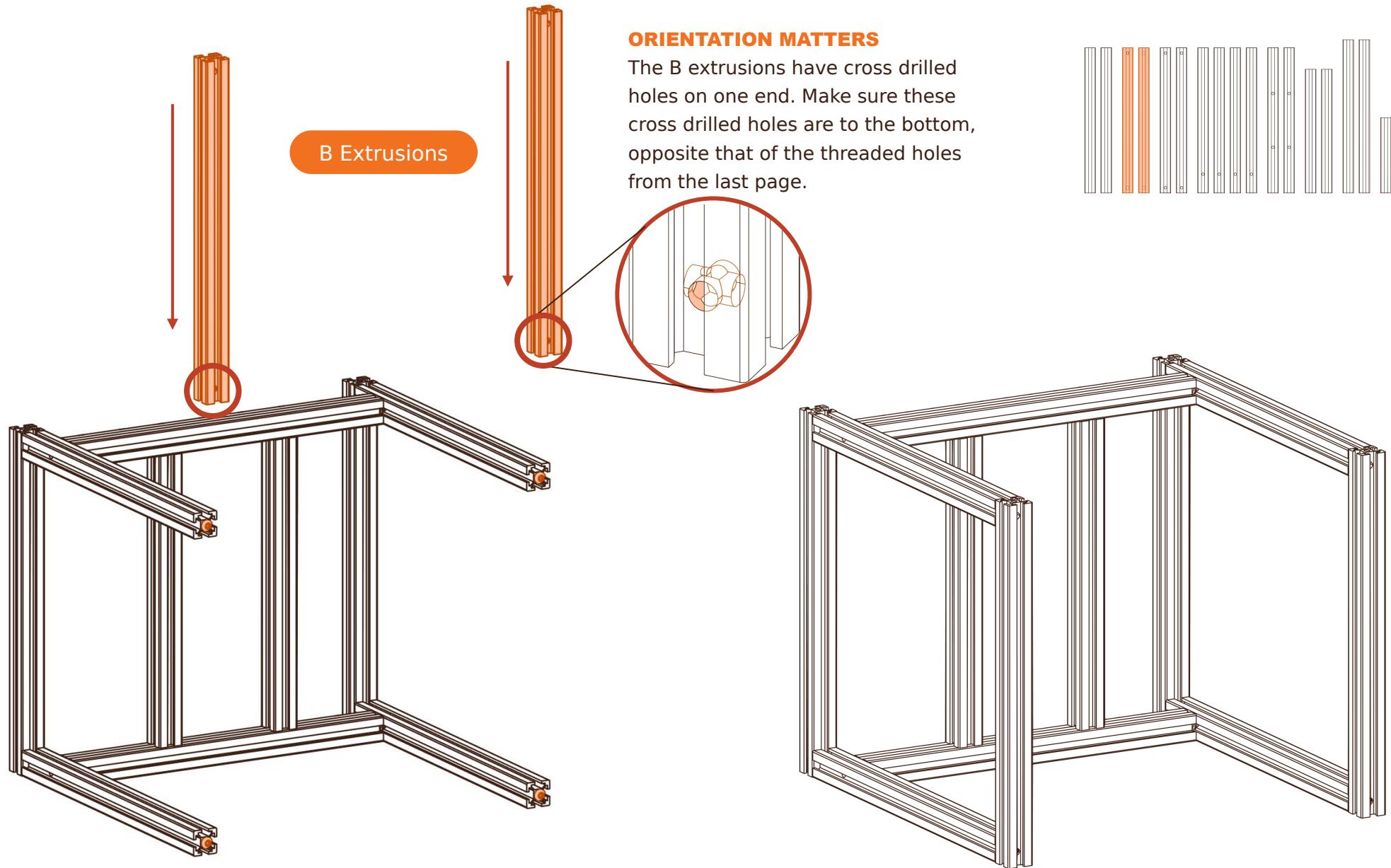
Secure the M5 bolts by inserting an allen key through the access holes. Adjust the position of the D extrusions so that they match the dimensions noted above.

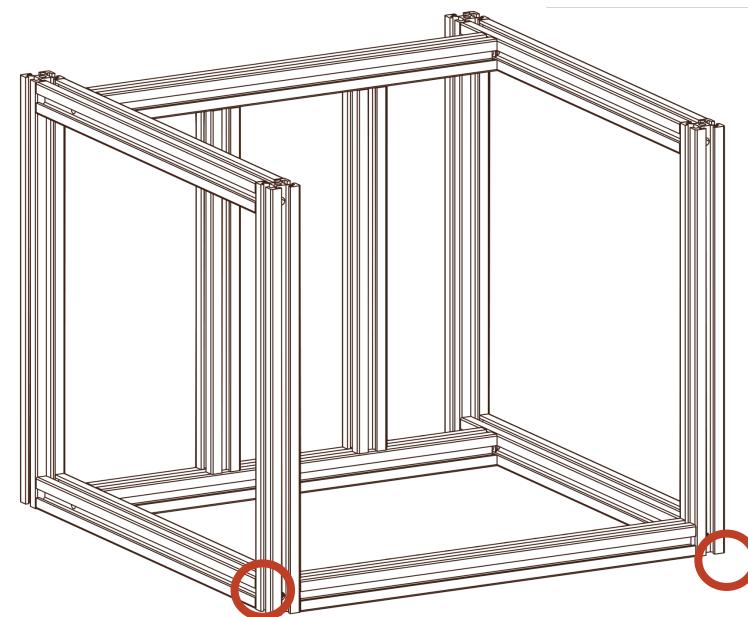
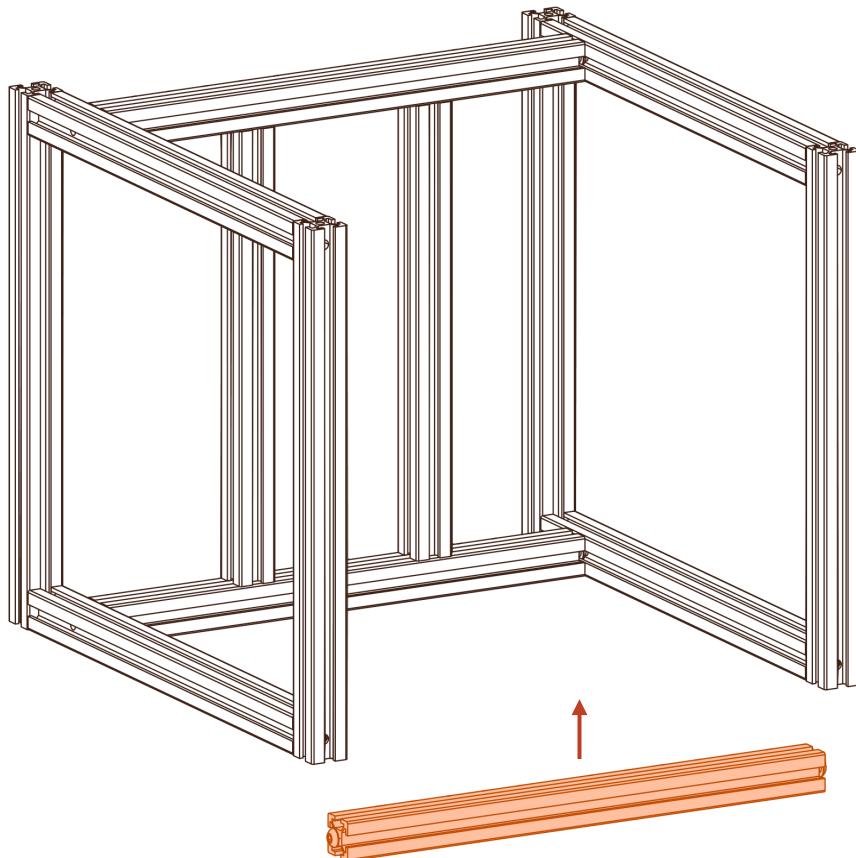


### ORIENTATION MATTERS

The C extrusions are only threaded on one end.  
Make sure that threaded end is facing up on  
both extrusions.

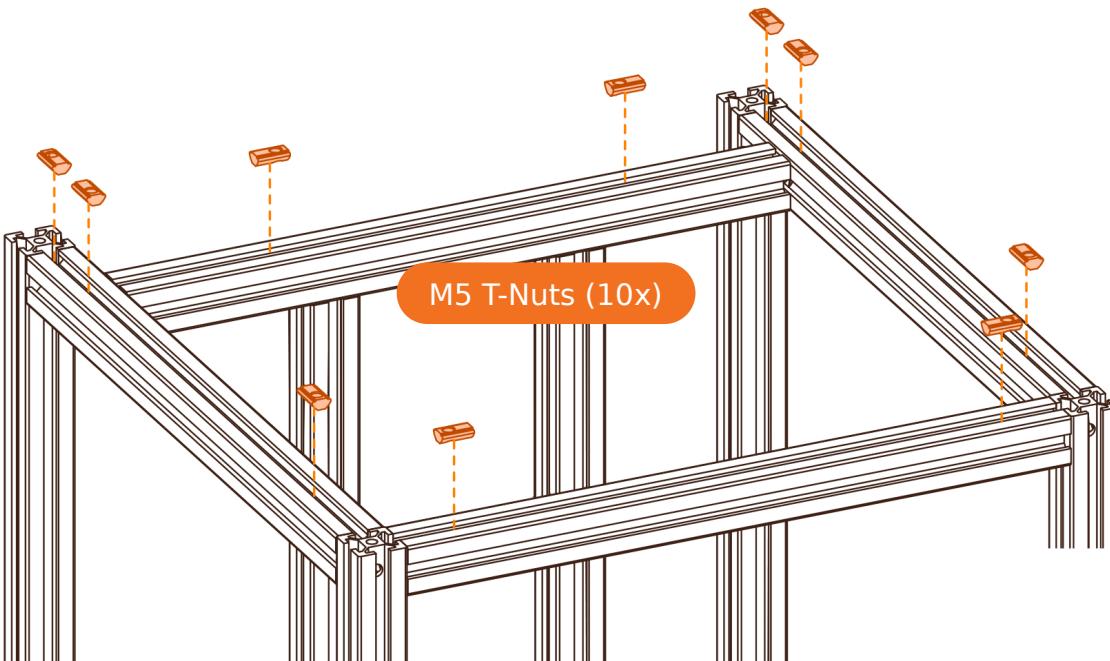






#### TIGHTEN THE BLIND JOINTS

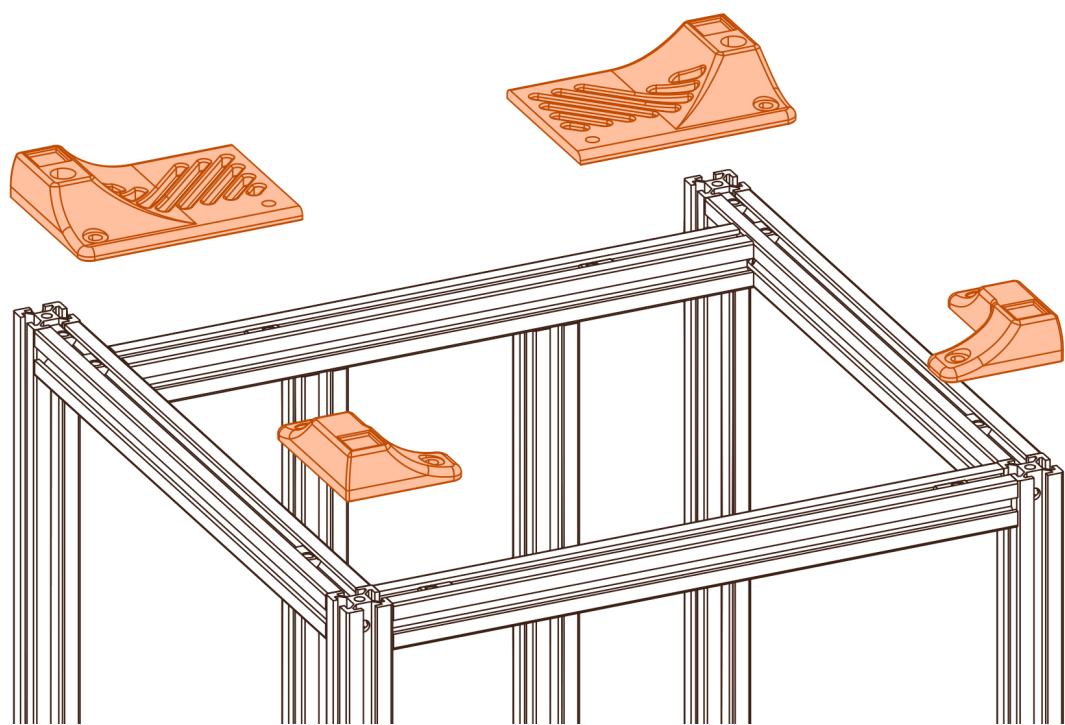
This is the final piece of the frame. Now is a good opportunity to take some extra time to ensure that your connections are tight and everything is square.

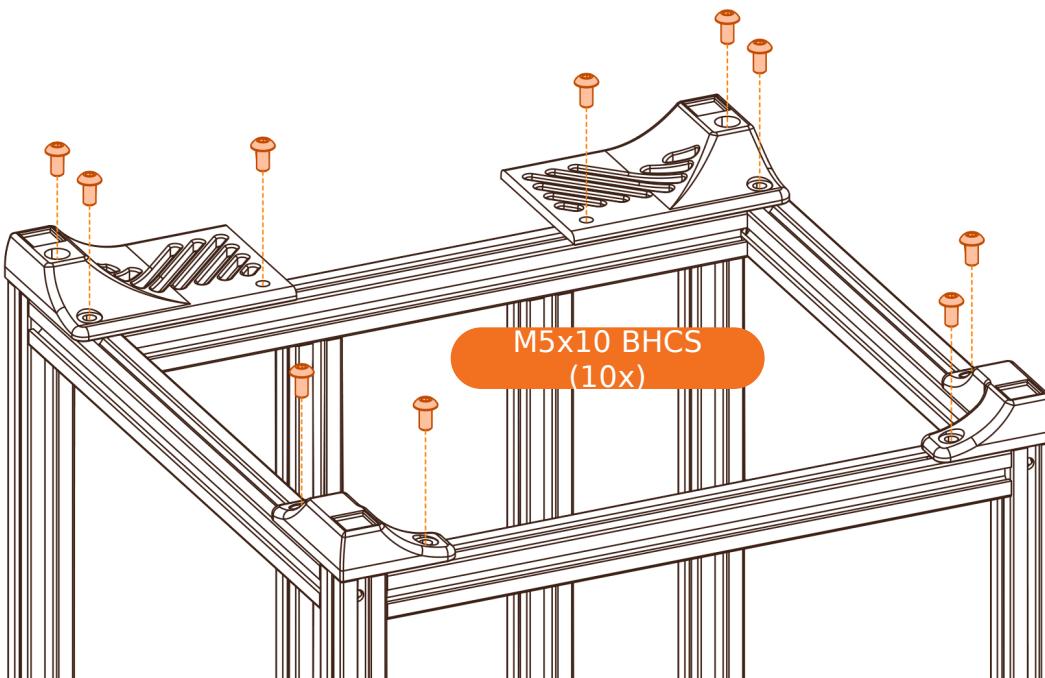
**ORIENTATION MATTERS**

Follow the orientation of the T-nuts as shown above, as installing them backwards results in not being able to tighten your feet prints to the frame as far.

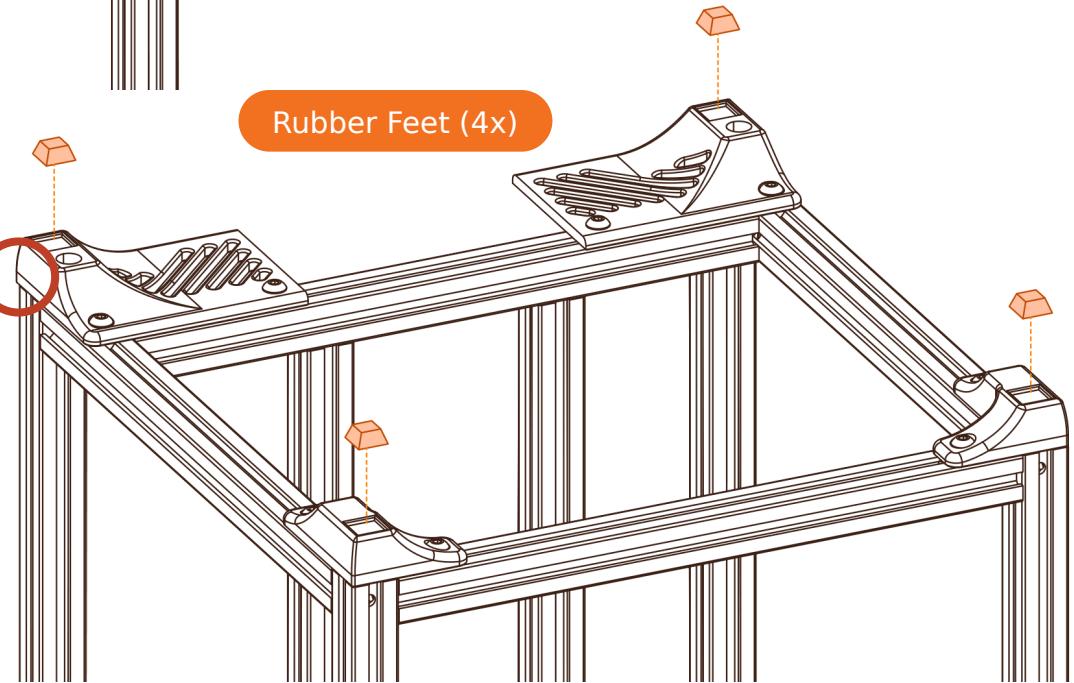
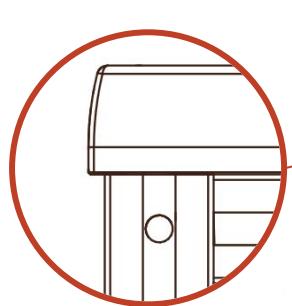
**FLIP THE PRINTER OVER**

These T-nuts and Printed parts are for the feet, then go on the bottom of the frame, make sure you have the assembly oriented correctly so that it matches the pictures.



**MIND THE GAP**

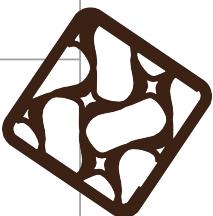
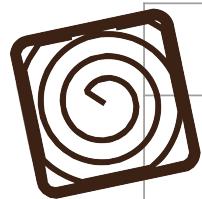
The two rear printed parts will overhang the rear extrusion by about 3mm. This will allow them to be flush with the paneling once it is installed.

**CAN'T FIND MY SHOES!**

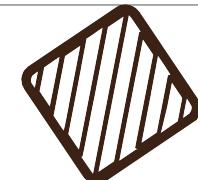
If you can't find the rubber feet in your kit, check the "Wiring Kit" box. Seems wires became laces by accident!

**PRESSURE SENSITIVE ADHESIVE**

The feet have 3M PSA pre-applied, it requires pressure to adhere correctly to the plastic parts.

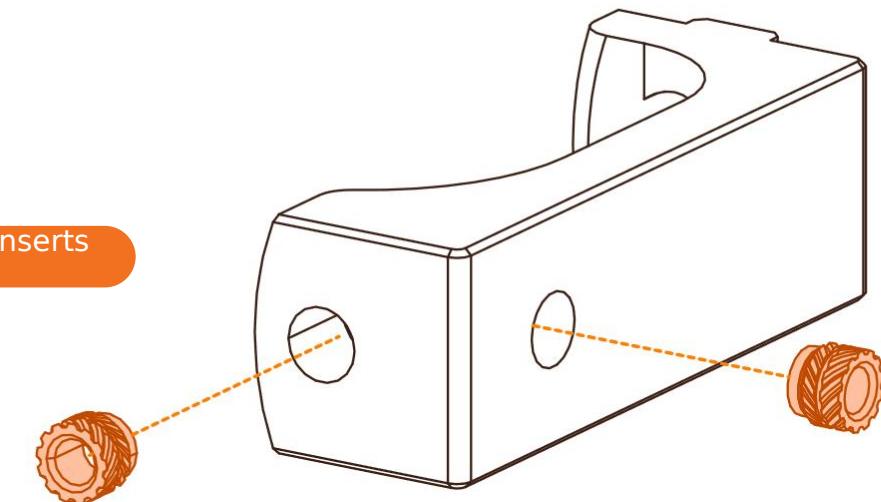
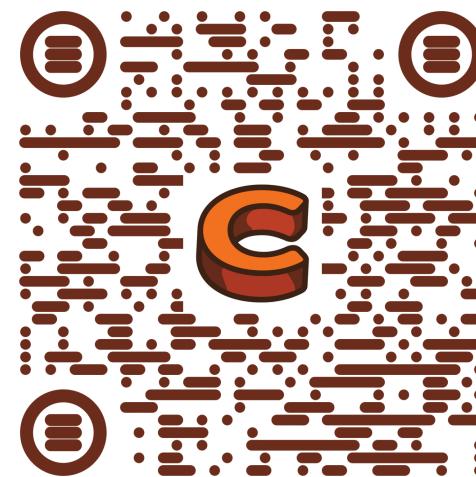
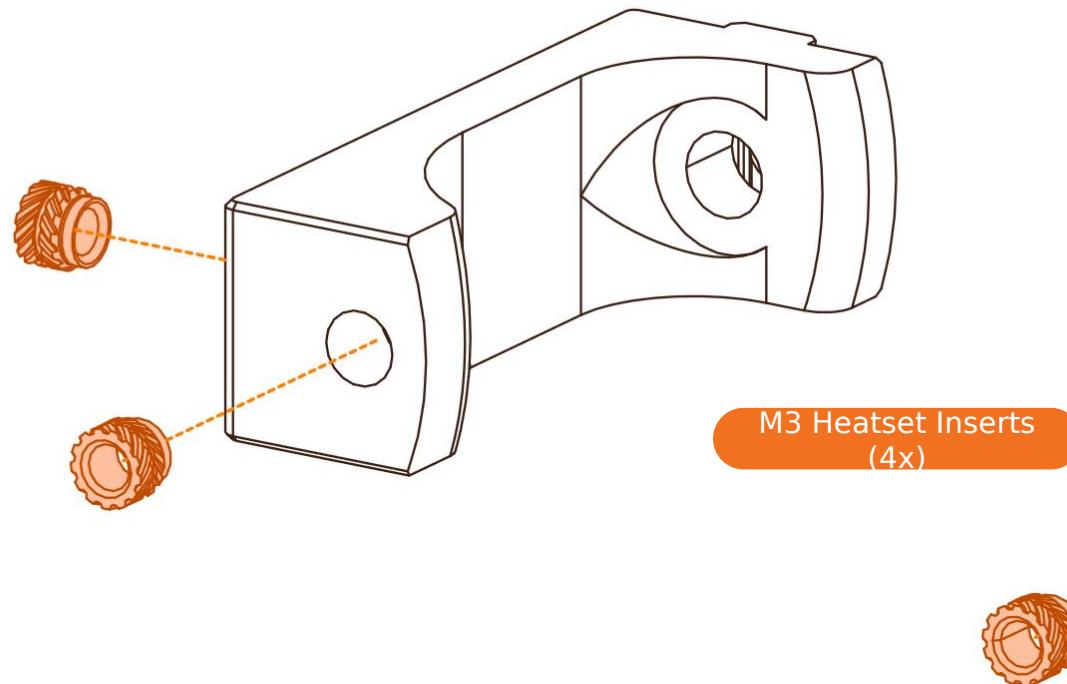


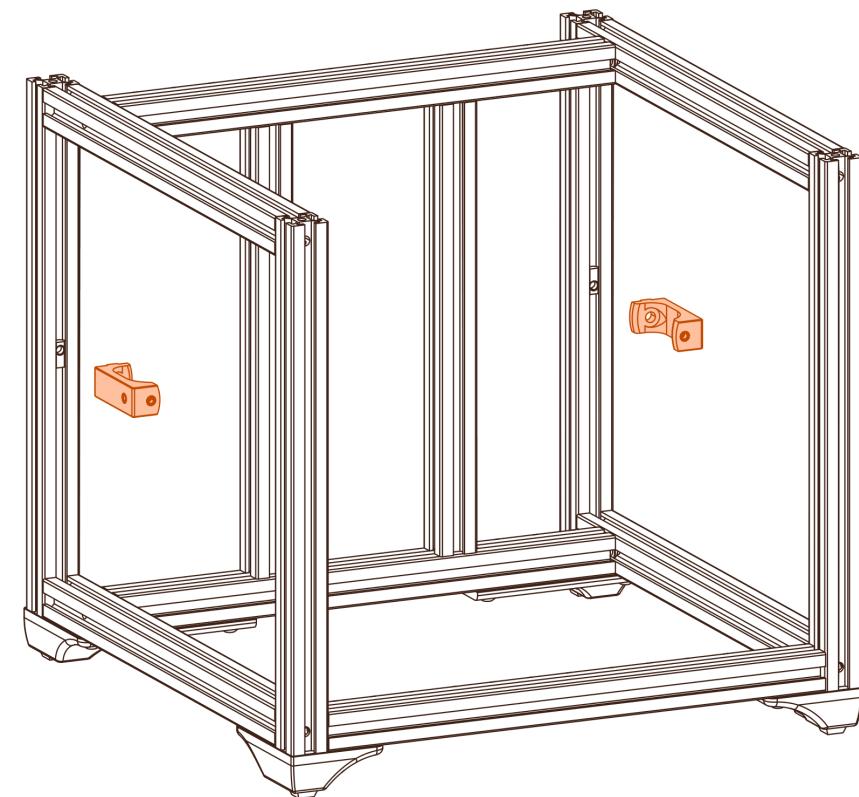
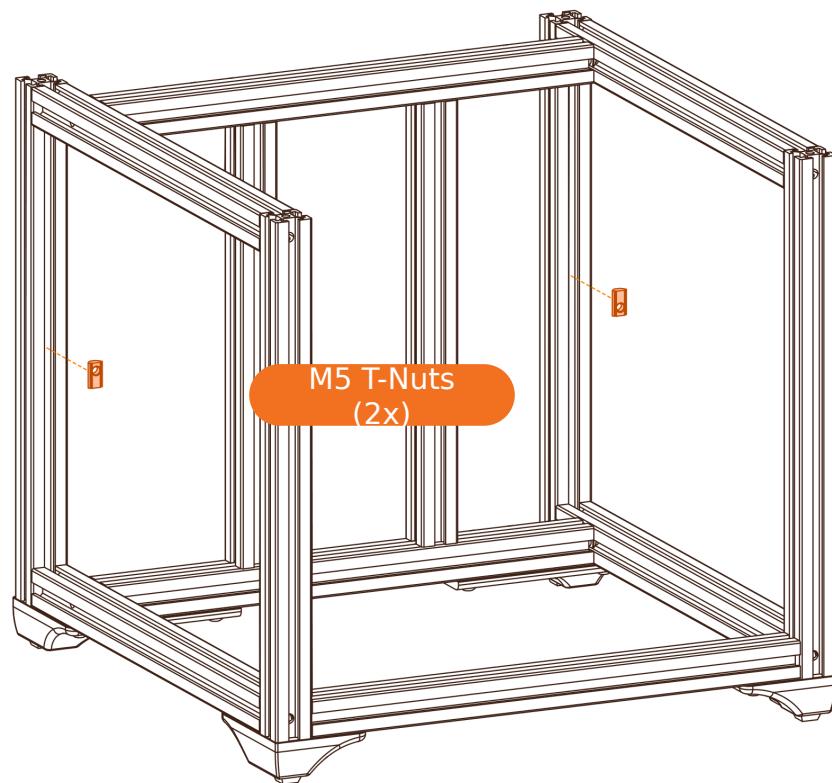
<b>Difficulty</b>	Easy
<b>Tools Needed</b>	M3 Driver M5 Driver Small Phillips Screwdriver Heatset Insert Tool Soldering Iron (Not Included)
<b>Hardware Needed</b>	M3 Heatset Inserts (4x) M5 T-Nuts (2x) M3 T-Nuts (18x) M5x10 Button Head Cap Screw (2x) M3x8 Button Head Phillips Screw (10x) Rear Acrylic Panel (1x)
<b>Printed Parts Needed</b>	Panel Supports (2x)

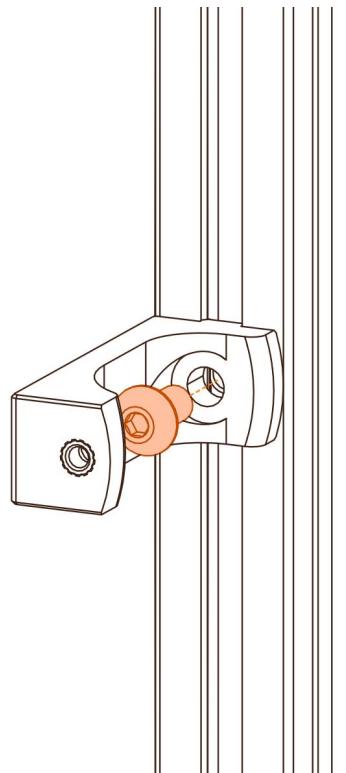


### COMPONENT PREP

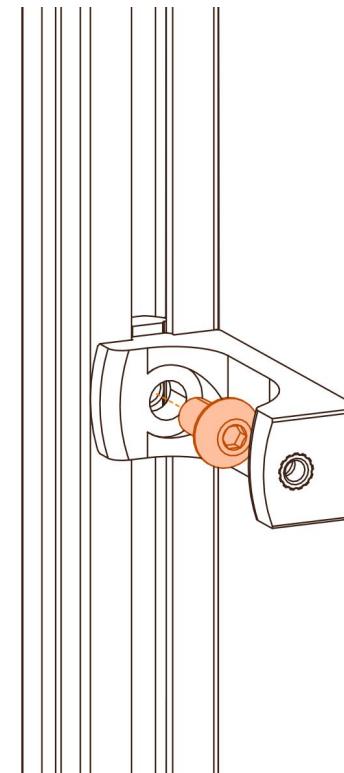
Many of the printed parts will use heatset threaded inserts. If you have never installed these, we recommend you watch the linked video.







M5x10 BHCS  
(2x)

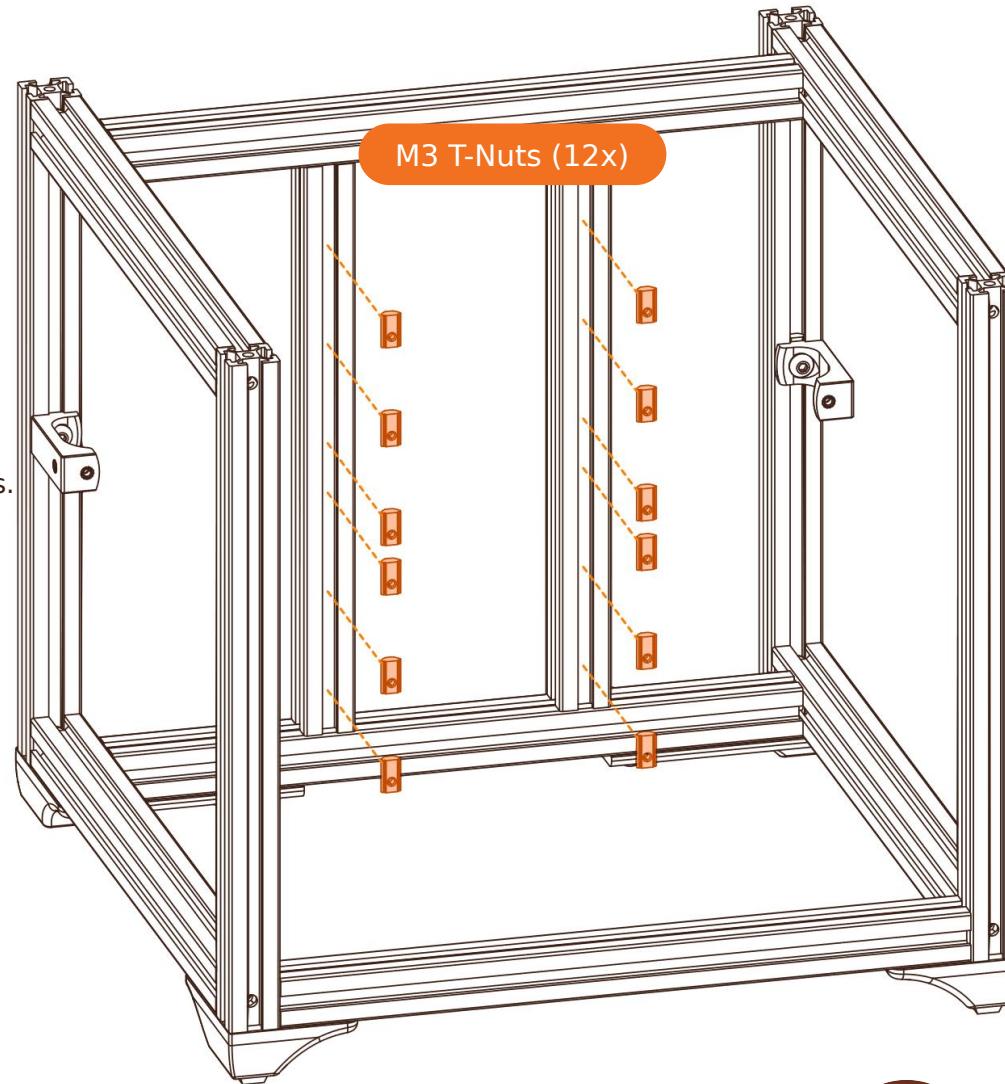


**VERTICAL POSITIONING**

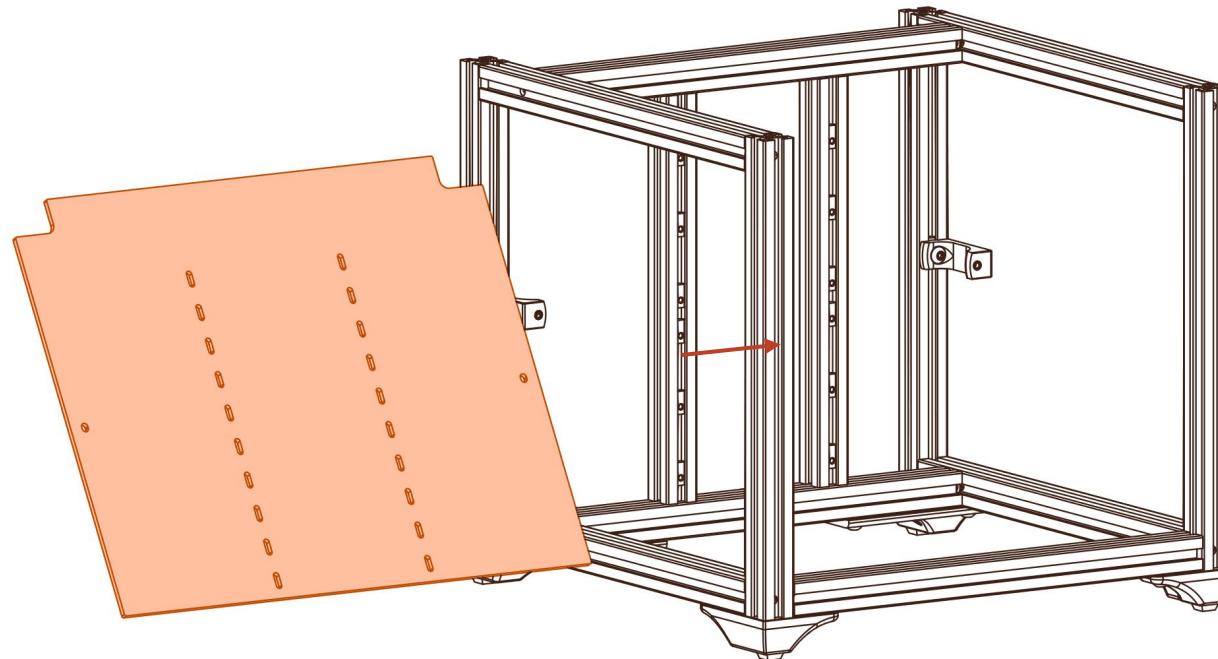
We will align these supports with the mid panel at a later step.  
Their position at this time is not critical

**GRAVITY IS YOUR FRIEND**

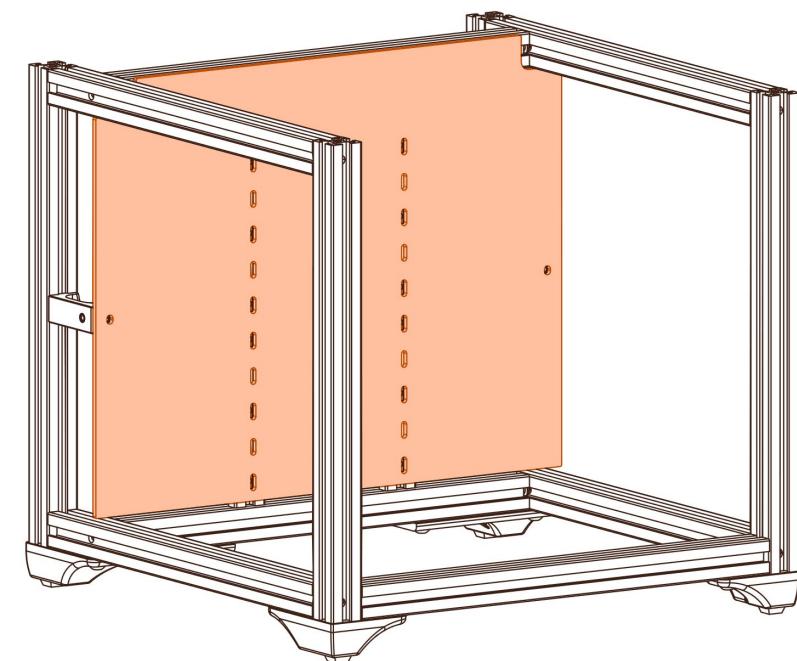
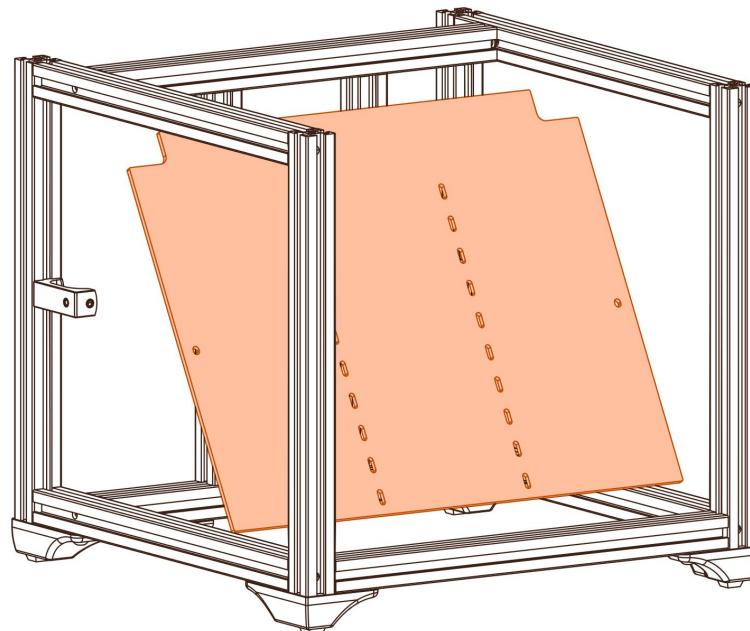
Laying the printer on its back may help with the installation of the T-Nuts.

**M3, WHO IS SHE?**

This is the first time we use M3 T-Nuts. Be sure to select the right type as otherwise there's a significant amount of disassembly to resolve.

**DON'T PAPER OVER THIS**

Remove the protective paper film from the acrylic before installation.



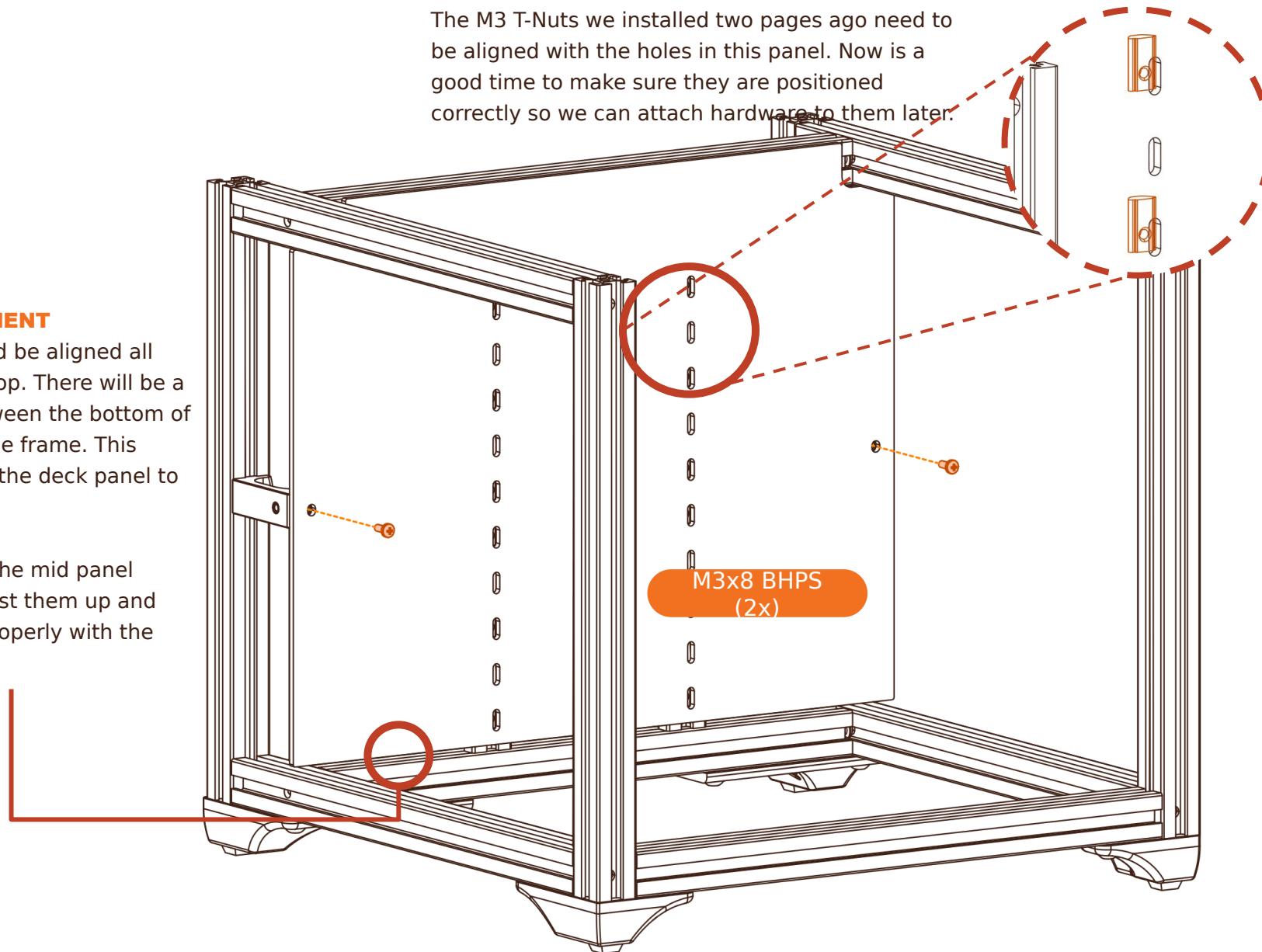
**THINKING AHEAD**

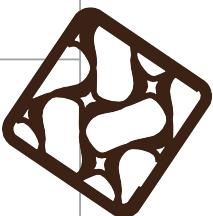
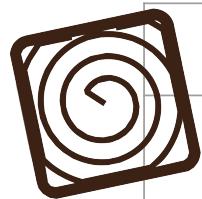
The M3 T-Nuts we installed two pages ago need to be aligned with the holes in this panel. Now is a good time to make sure they are positioned correctly so we can attach hardware to them later.

**PANEL ALIGNMENT**

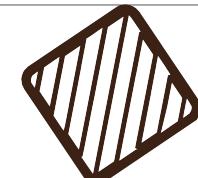
The panel should be aligned all the way to the top. There will be a ~3mm gap between the bottom of the panel and the frame. This leaves room for the deck panel to be installed.

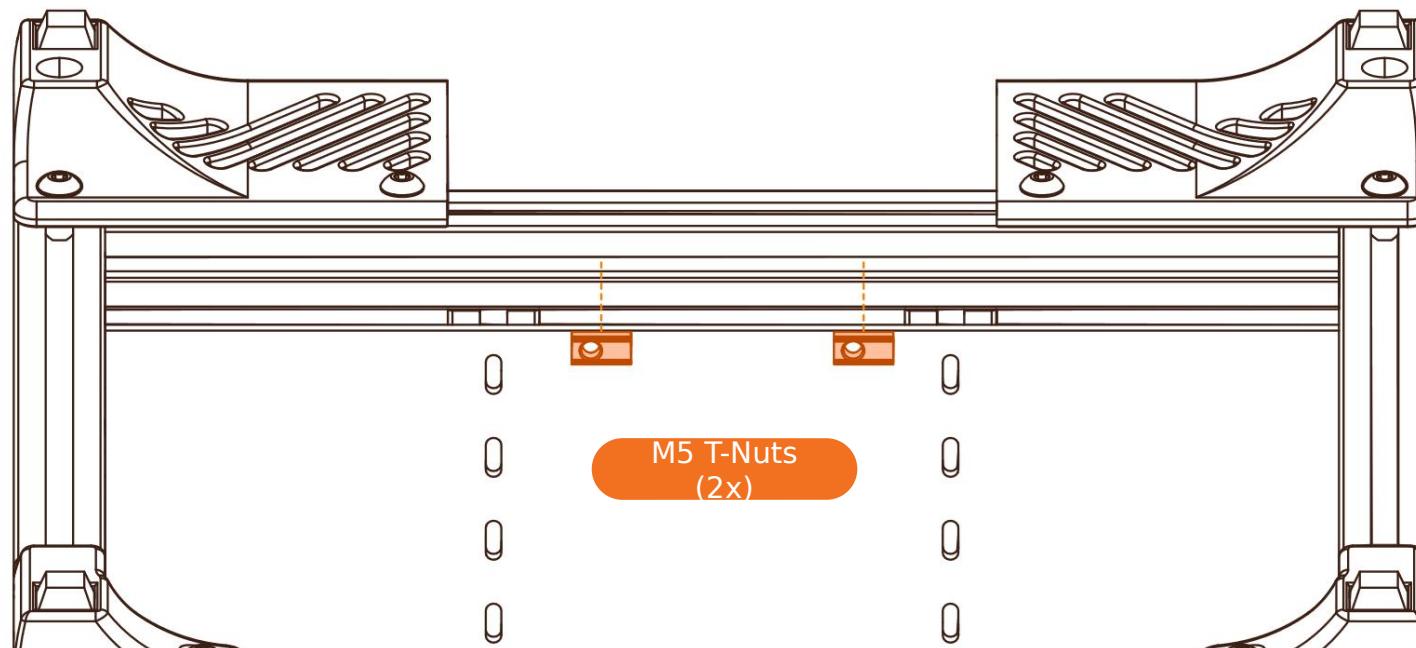
You can loosen the mid panel supports to adjust them up and down to align properly with the screw holes.

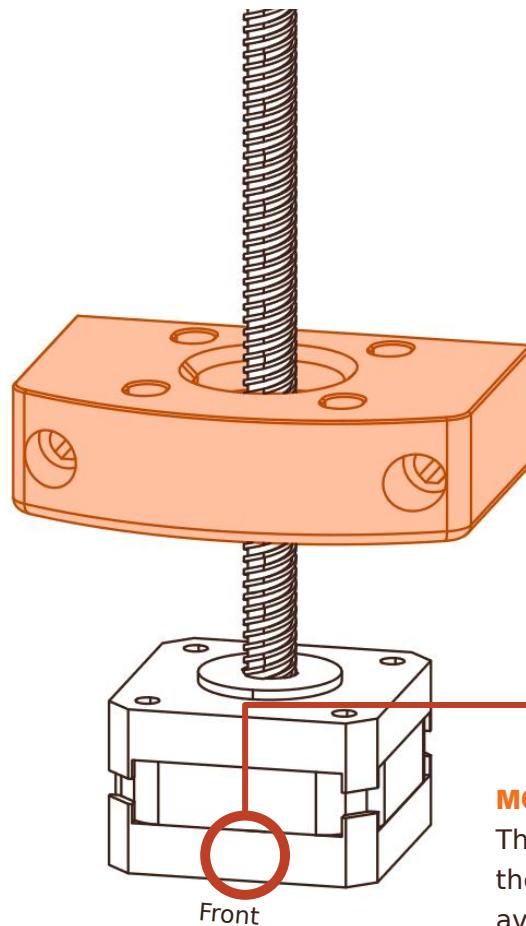




<b>Difficulty</b>	Easy
<b>Tools Needed</b>	M3 Driver M5 Driver
<b>Hardware Needed</b>	M5 T-Nuts (2x) M3x8 Socket Head Cap Screw (4x) M5x40 Socket Head Cap Screw (2x) Bottom Acrylic Panel (1x)
<b>Printed Parts Needed</b>	Z Motor Mount (1x)







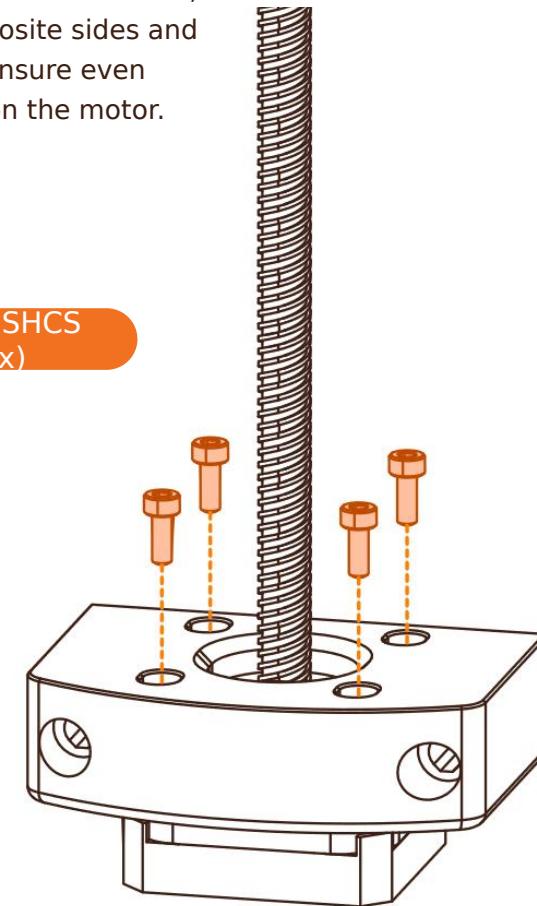
#### MOTOR WIRING

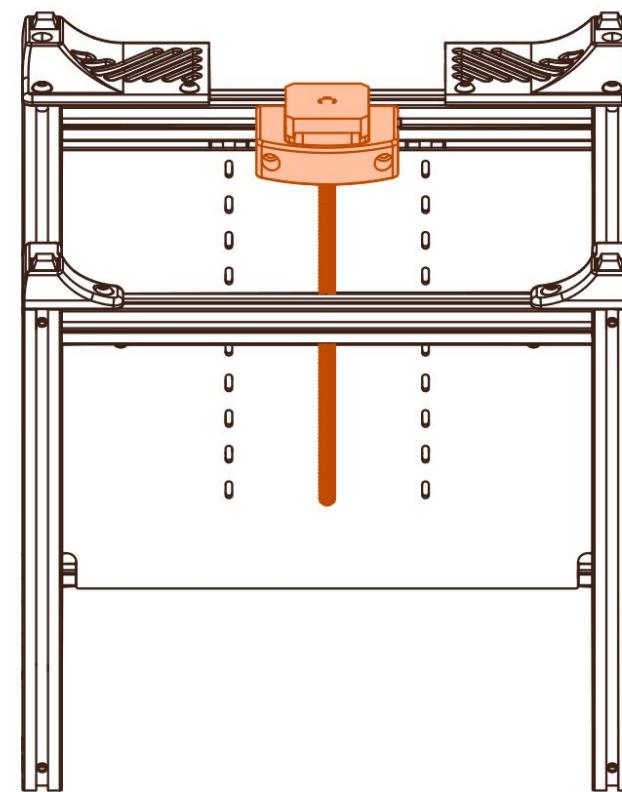
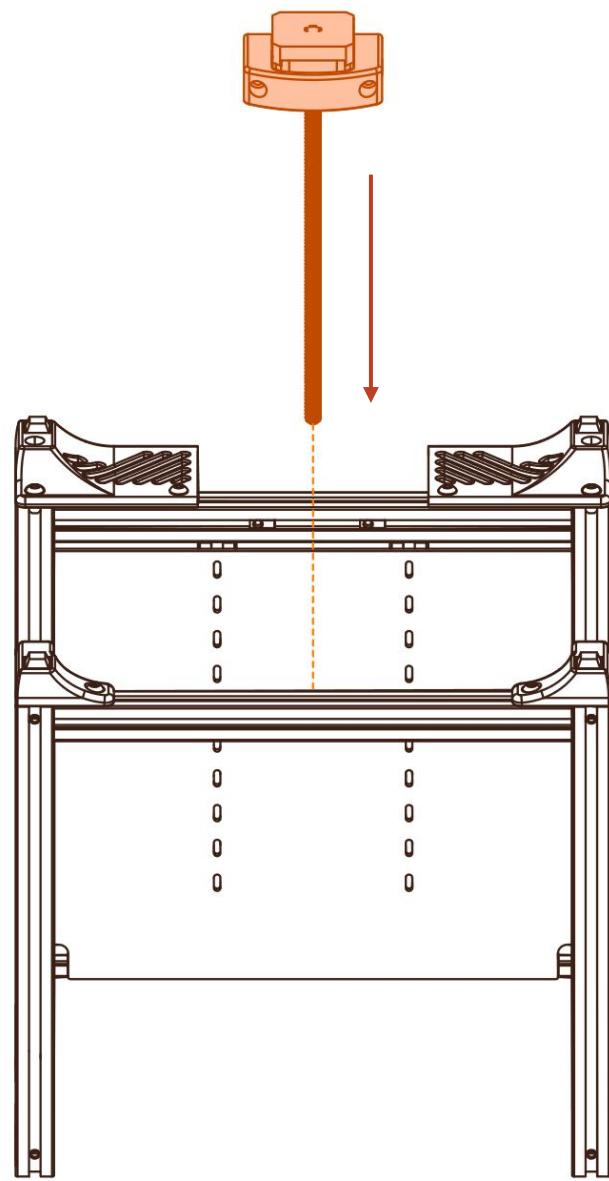
The motor wires should exit through the front of the motor assembly to avoid colliding with the rear wiring cover later.

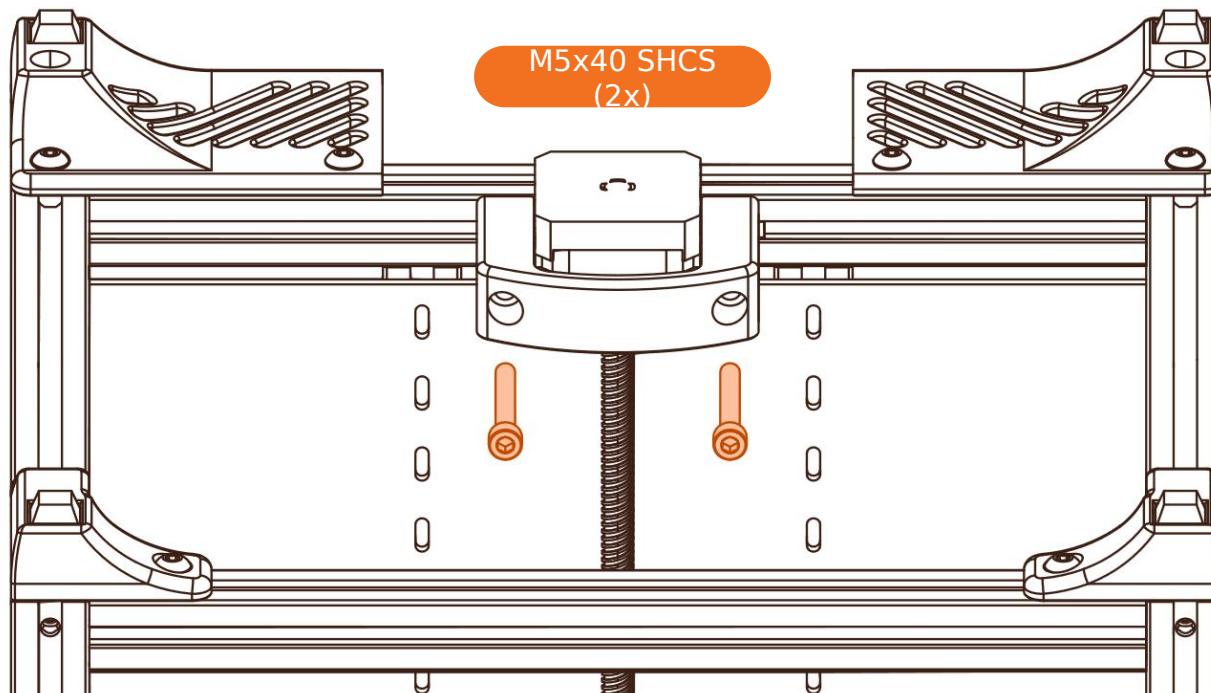
#### OPPOSITES REACT

When tightening the M3x8 fasteners, be sure to tighten opposite sides and then moving over to ensure even distribution of forces on the motor.

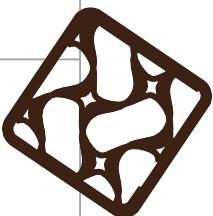
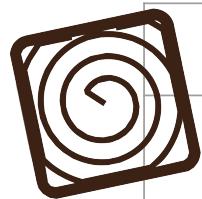
M3x8 SHCS  
(4x)



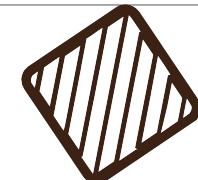


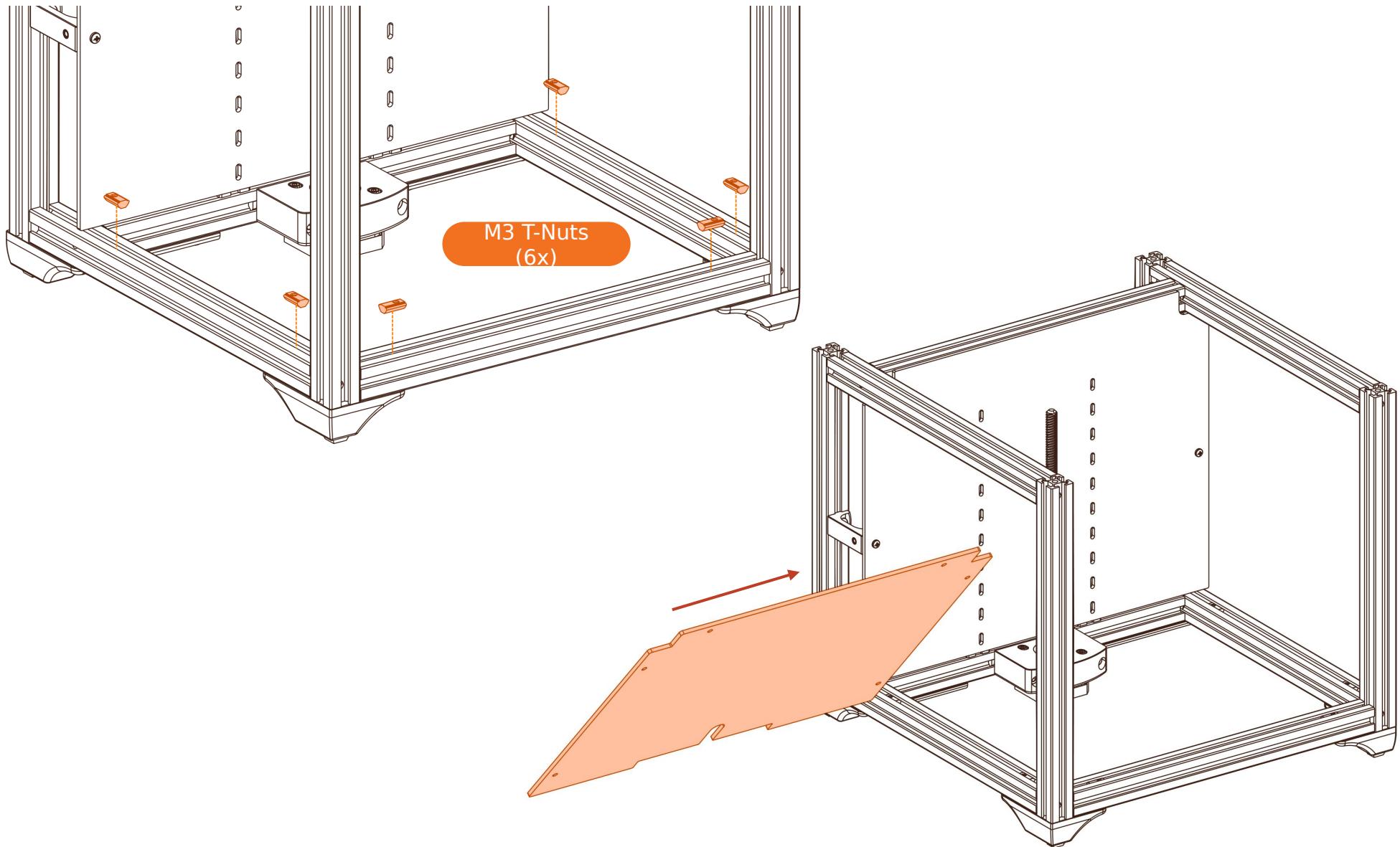
**CENTER THE Z MOTOR**

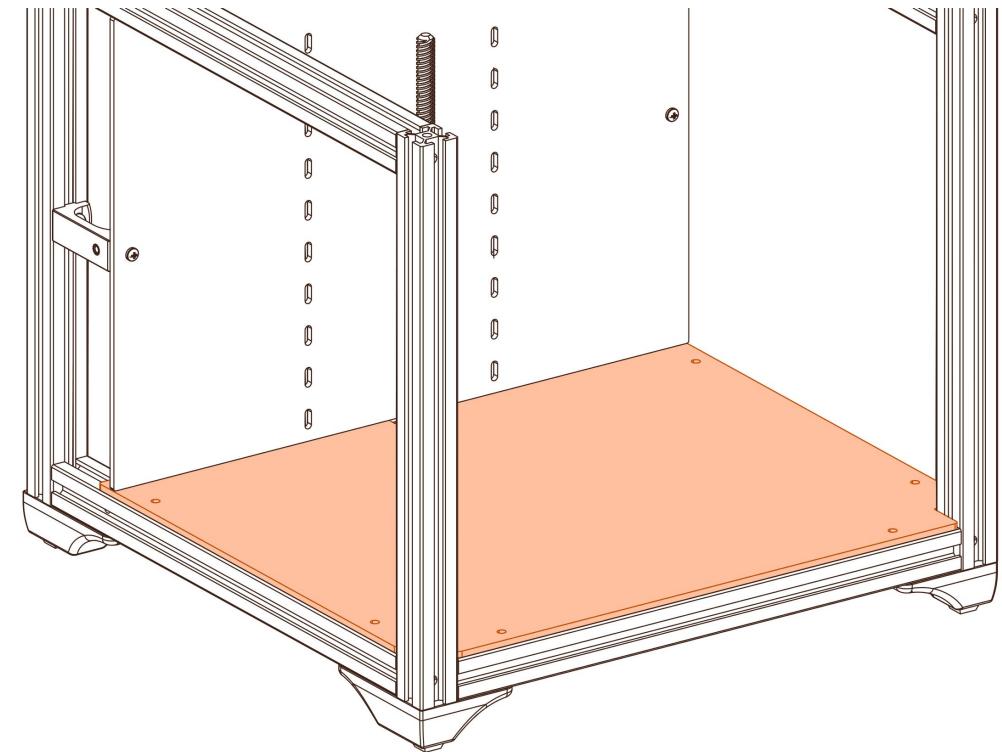
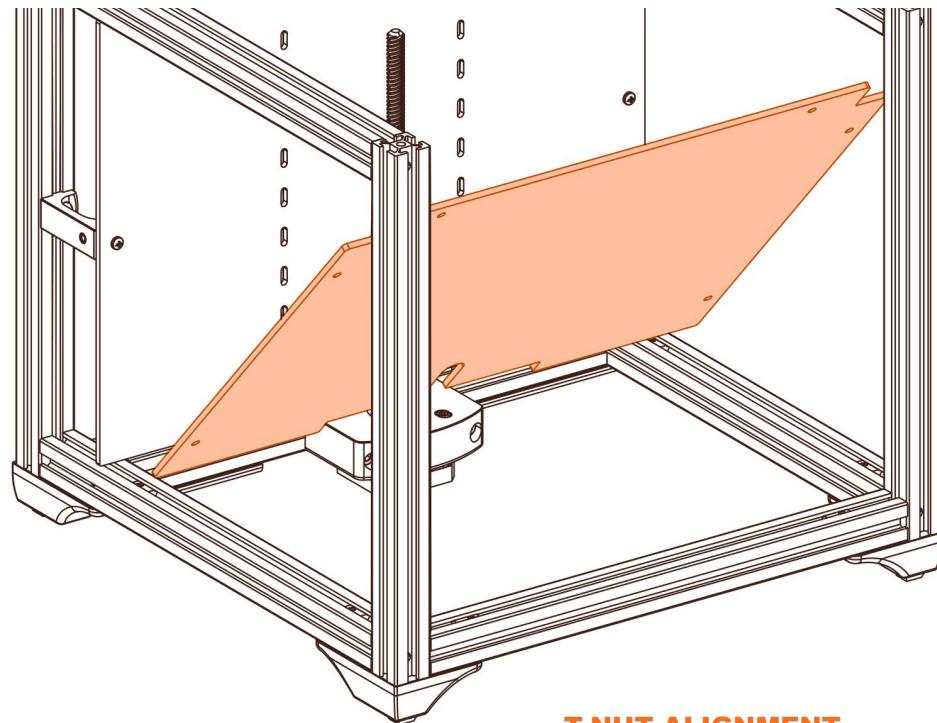
The Z motor should be positioned an equal distance from each side in order for proper bed alignment later on.



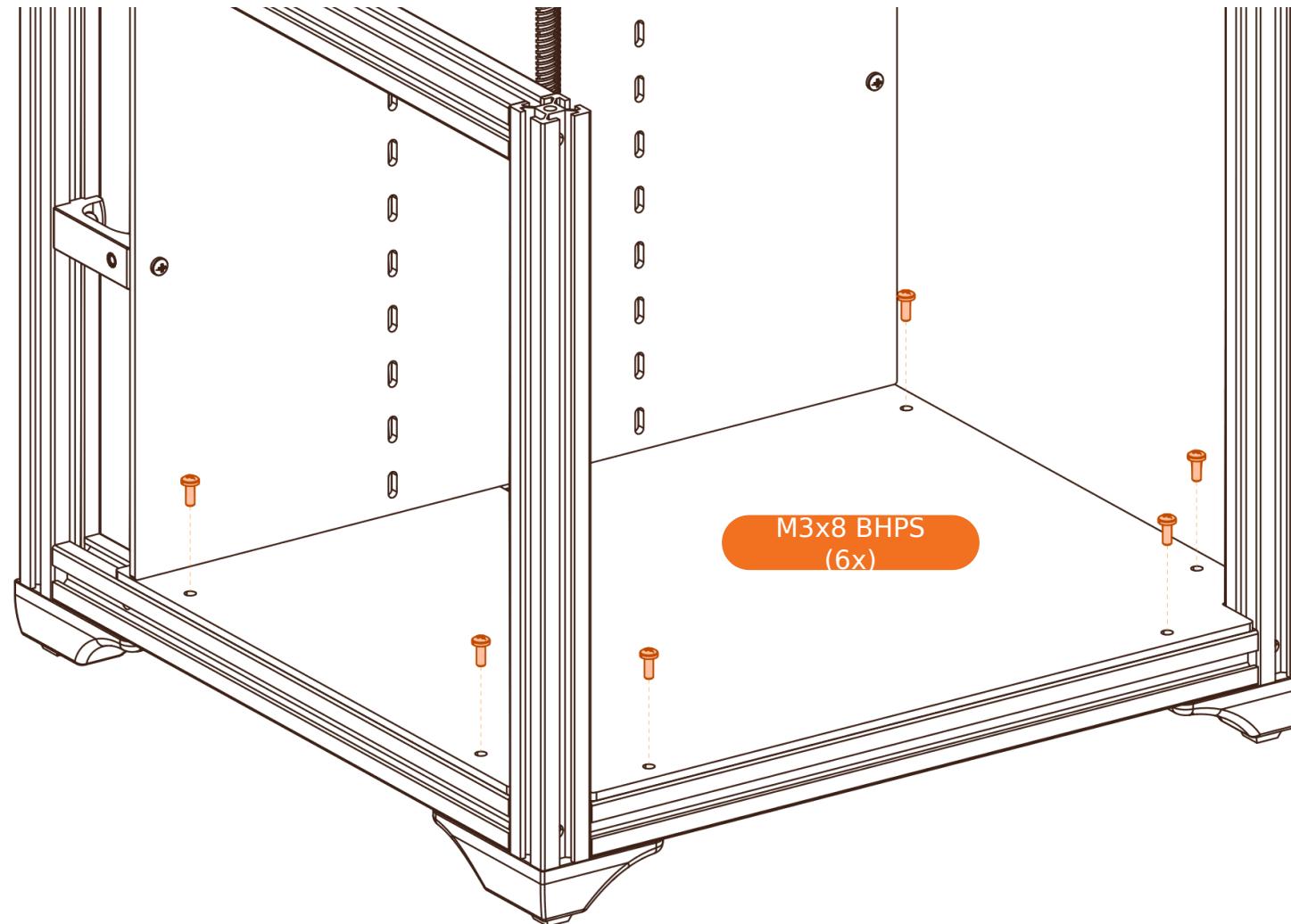
<b>Difficulty</b>	Easy
<b>Tools Needed</b>	M3 Driver Small Phillips Screwdriver
<b>Hardware Needed</b>	M3 Button Head Phillips Screw (6x) M3 T-Nuts (6x)
<b>Printed Parts Needed</b>	None

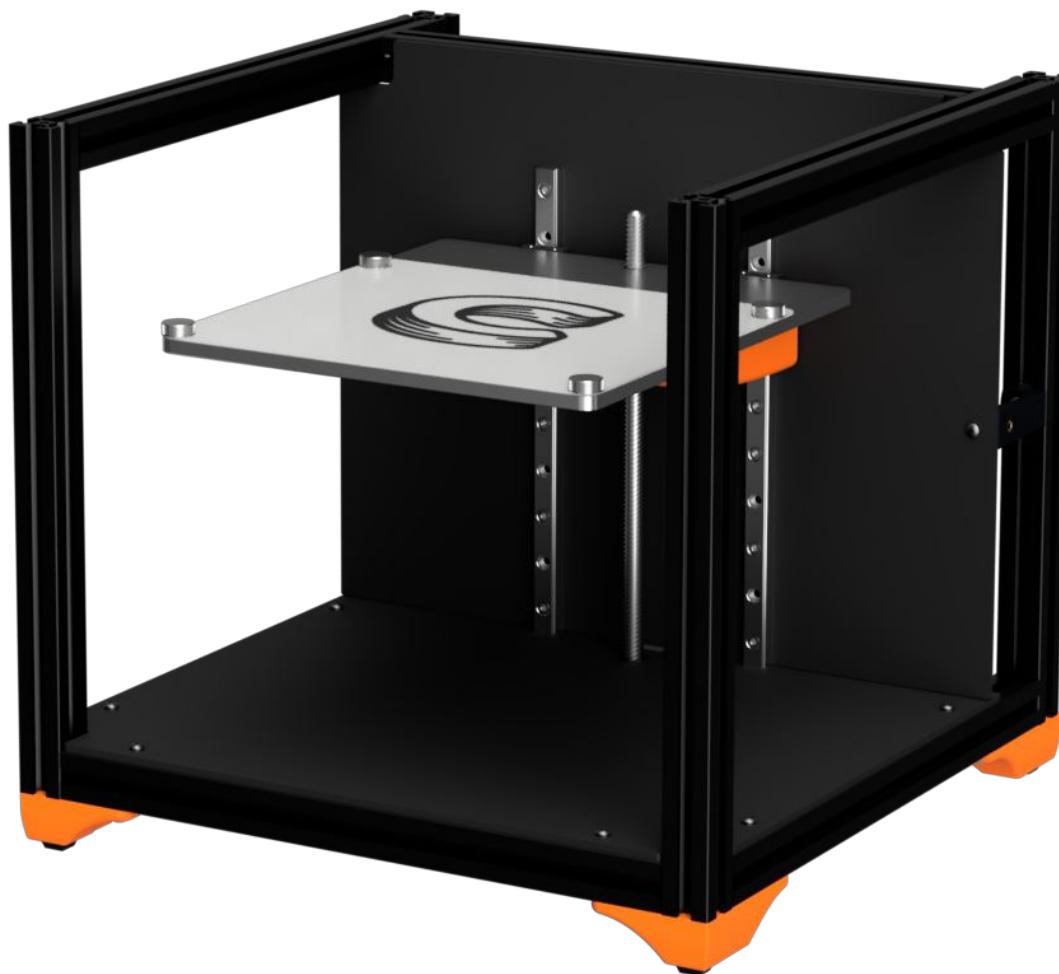


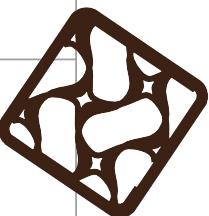
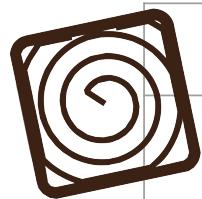


**T-NUT ALIGNMENT**

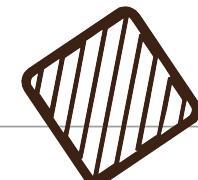
The T-nuts we installed need to be aligned with the holes in this panel. Holding the edge of the panel up to the T slot can make ensuring the correct spacing for the T-nuts easier.



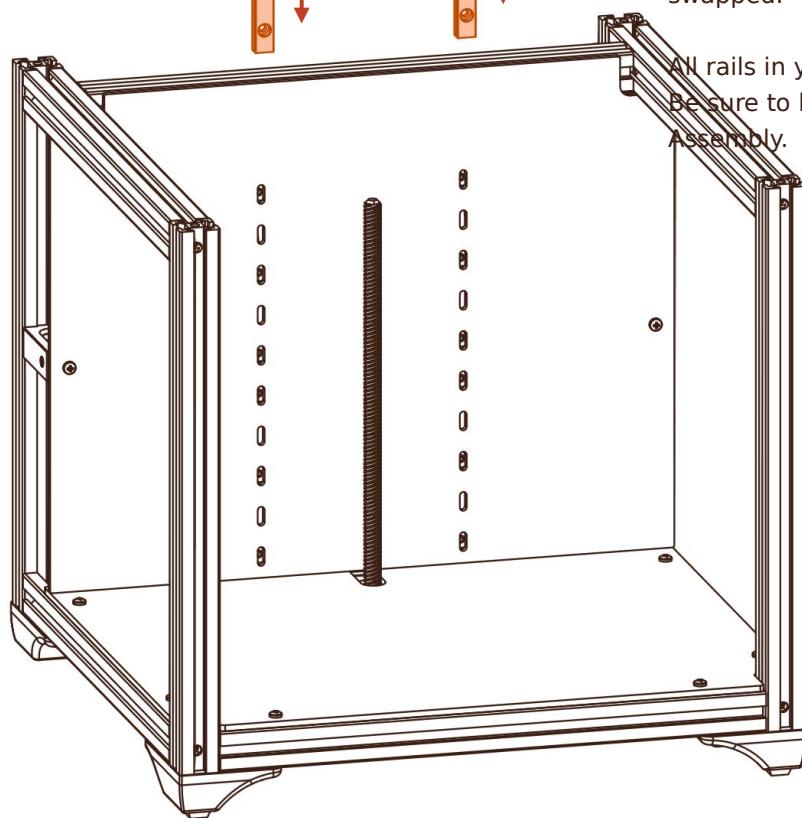




<b>Difficulty</b>	Medium
<b>Tools Needed</b>	M3 Driver M5 Driver
<b>Hardware Needed</b>	M3x10 Socket Head Cap Screw (12x) M3x40 Socket Head Cap Screw (8x) Anti-Backlash Leadscrew Nut (Top+Bottom+Spring, 1x) Aluminum Bed (1x) M5x30 Socket Head Cap Screw (4x) M3x8 Socket Head Cap Screw (2x) M4 Thumbscrews (4x)
<b>Printed Parts Needed</b>	Z Carriage Block Left (1x) Z Carriage Block Right (1x)



MGN9 Rails  
(2x)



#### MIND THE CARRIAGES

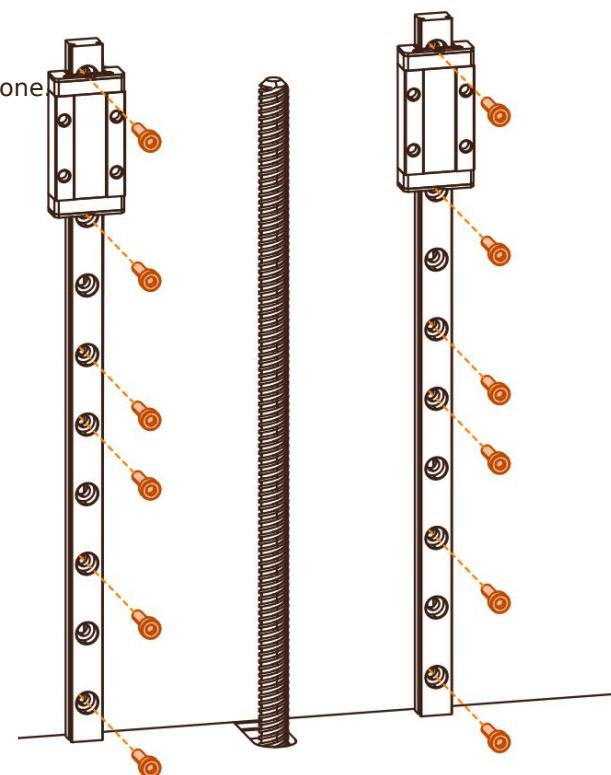
The carriages are designed to slide along the rail easily.

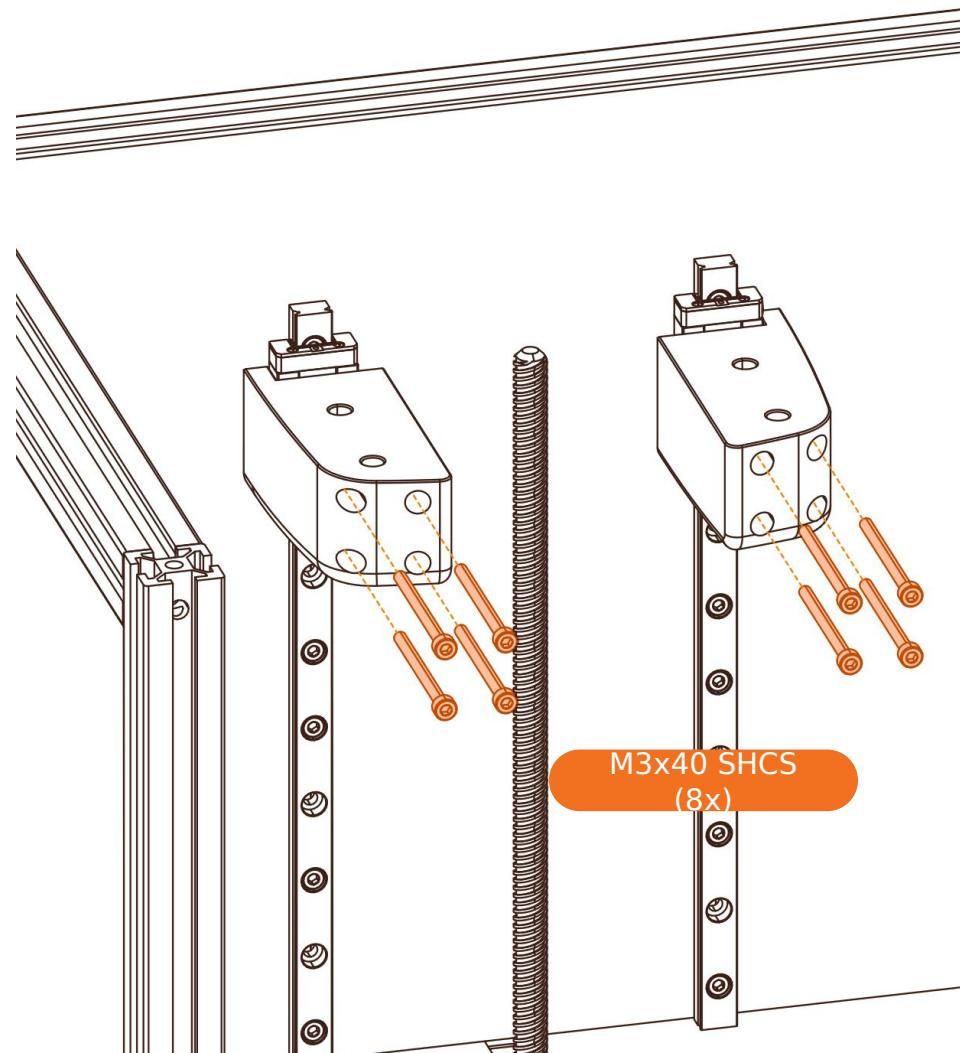
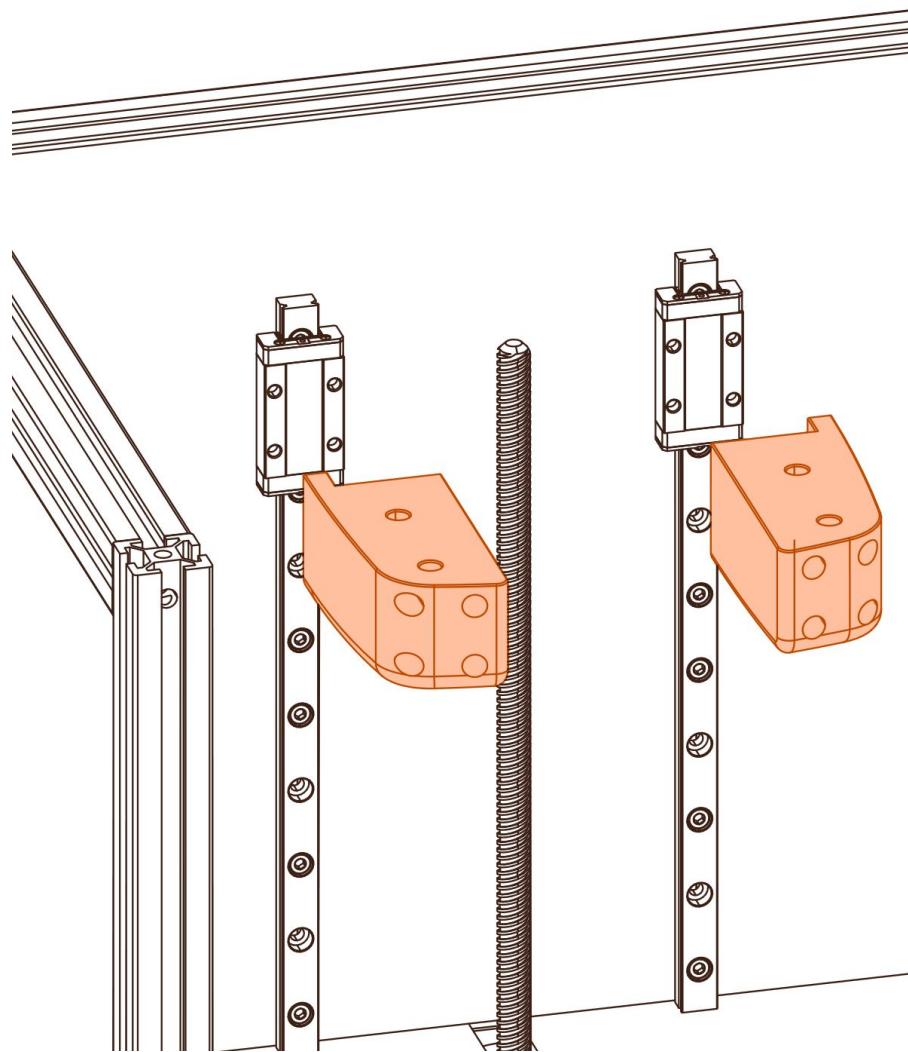
This unfortunately also includes sliding off the rails.

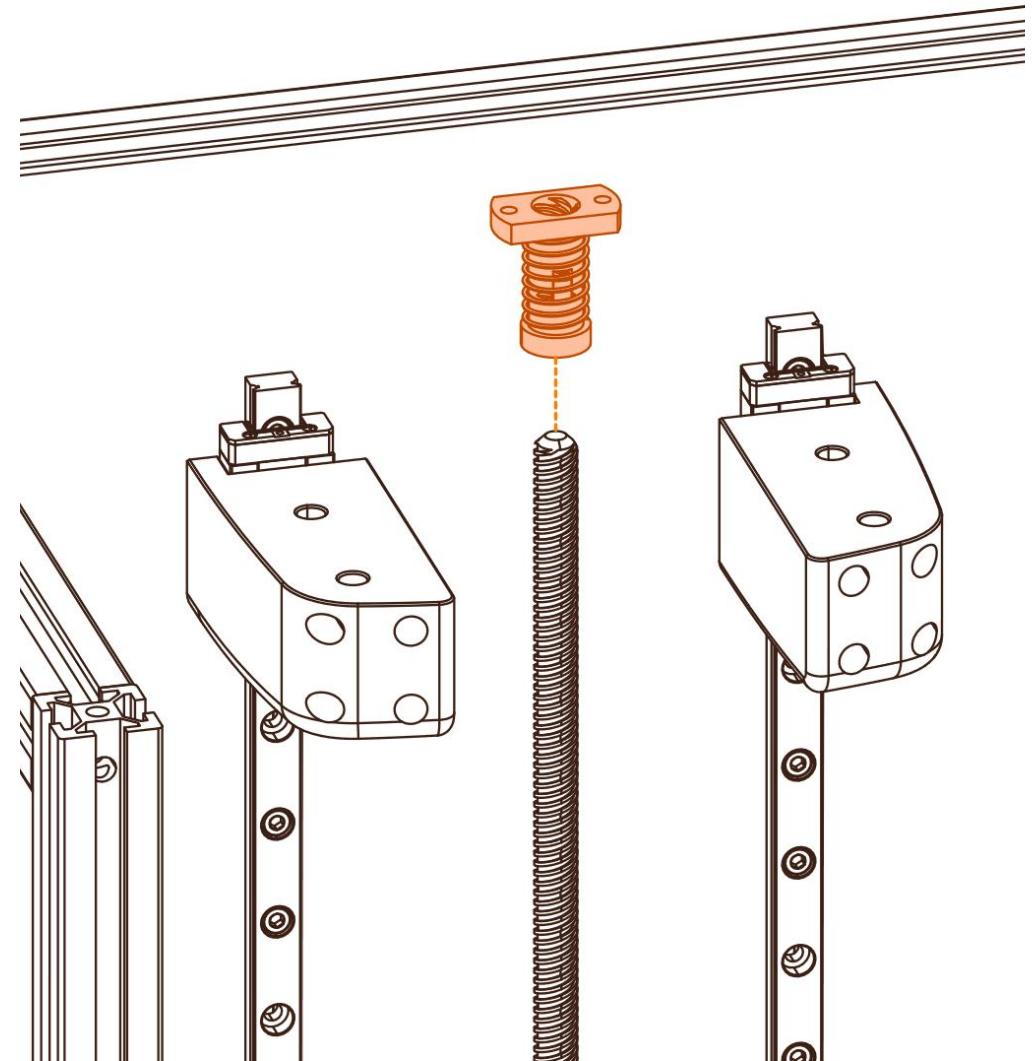
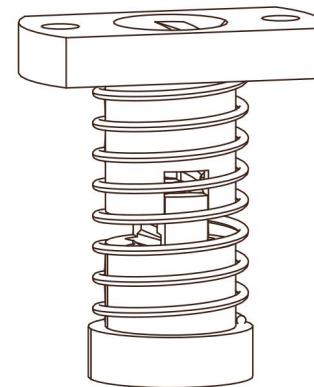
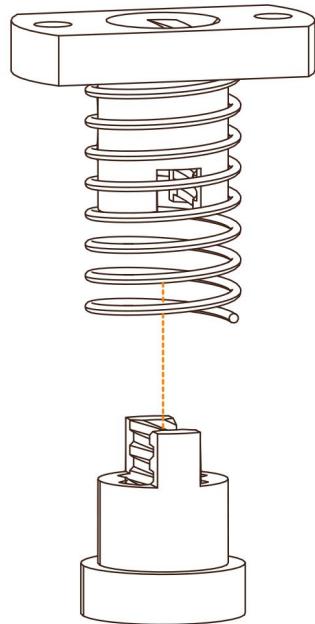
Dropping the carriage will likely result in irreparable damage. Take extra care to ensure that the carriages do not accidentally slide completely off the rails. Keep each carriage with its respective rail, as they are not meant to be swapped.

All rails in your kit are the same except for one. Be sure to leave that one for the Toolhead Assembly.

M3x10 SHCS  
(12x)

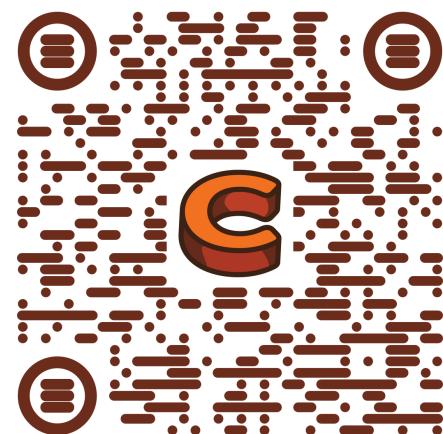




**ANTI-BACKLASH**

The anti-backlash nut works by applying constant pressure on the leadscrew threads. In order for it to function correctly, it must be compressed and then loaded onto the lead crew such that the two pieces cannot spin independently.

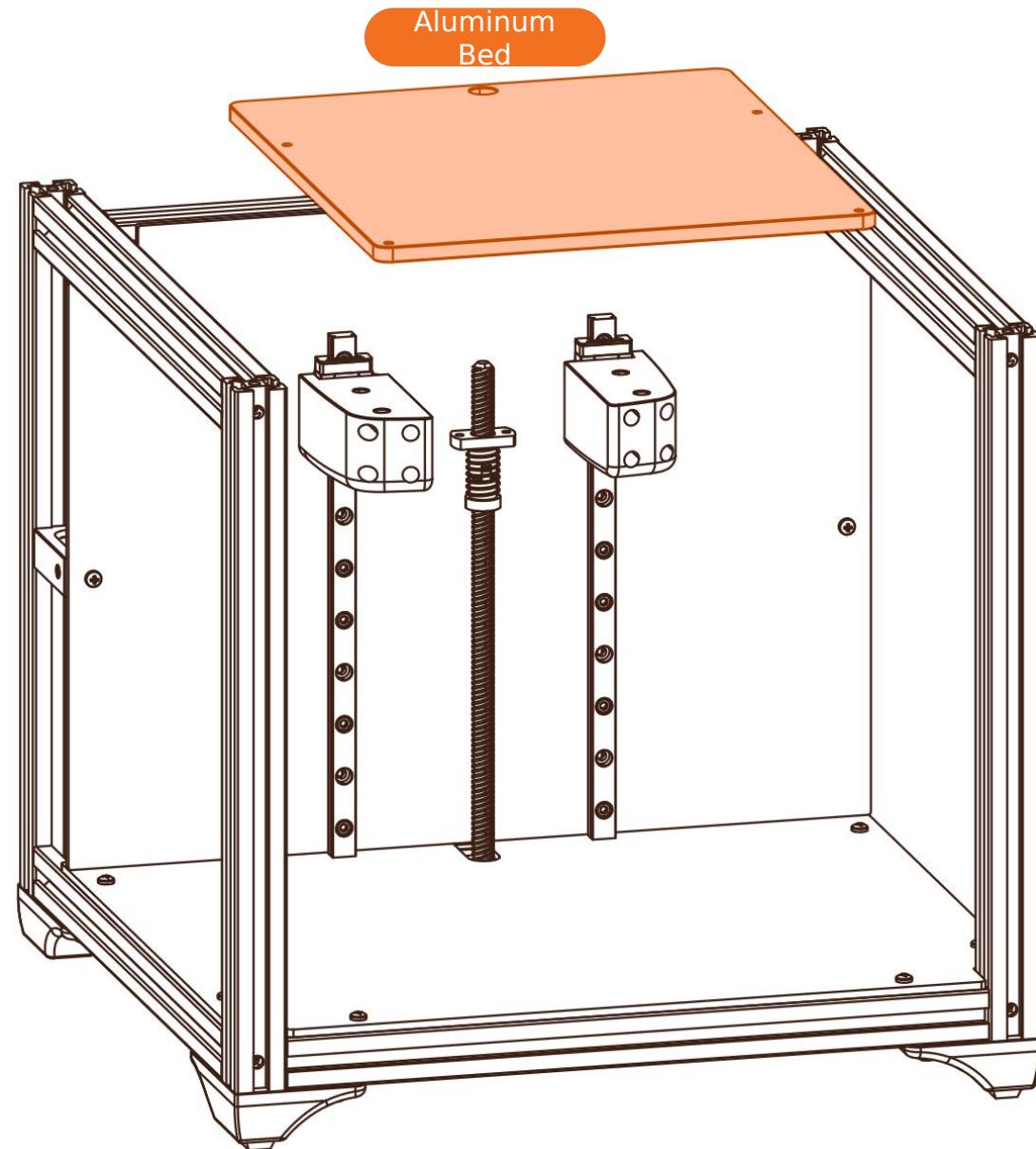
Refer to the linked video for assembly.

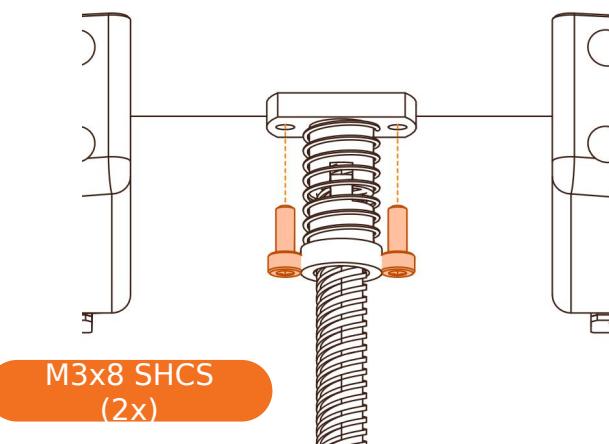
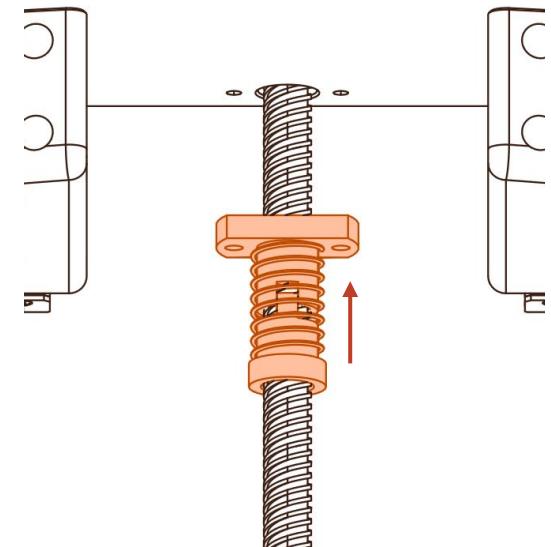
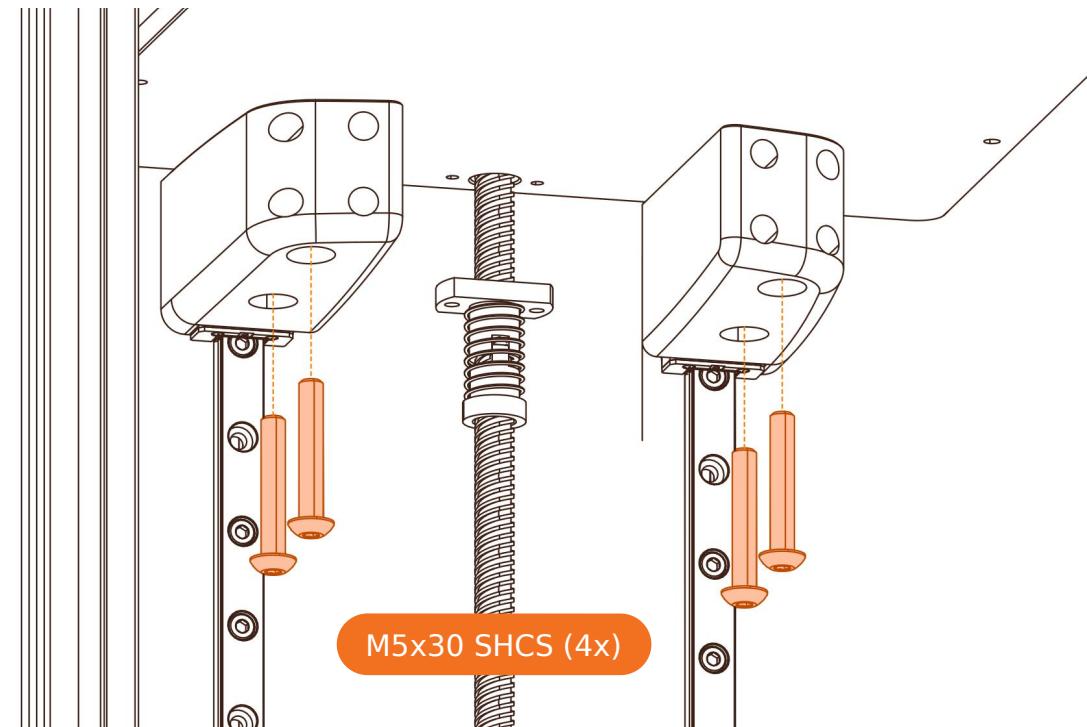


<https://www.youtube.com/shorts/Y4ScC2dLILY>

**BED PREP**

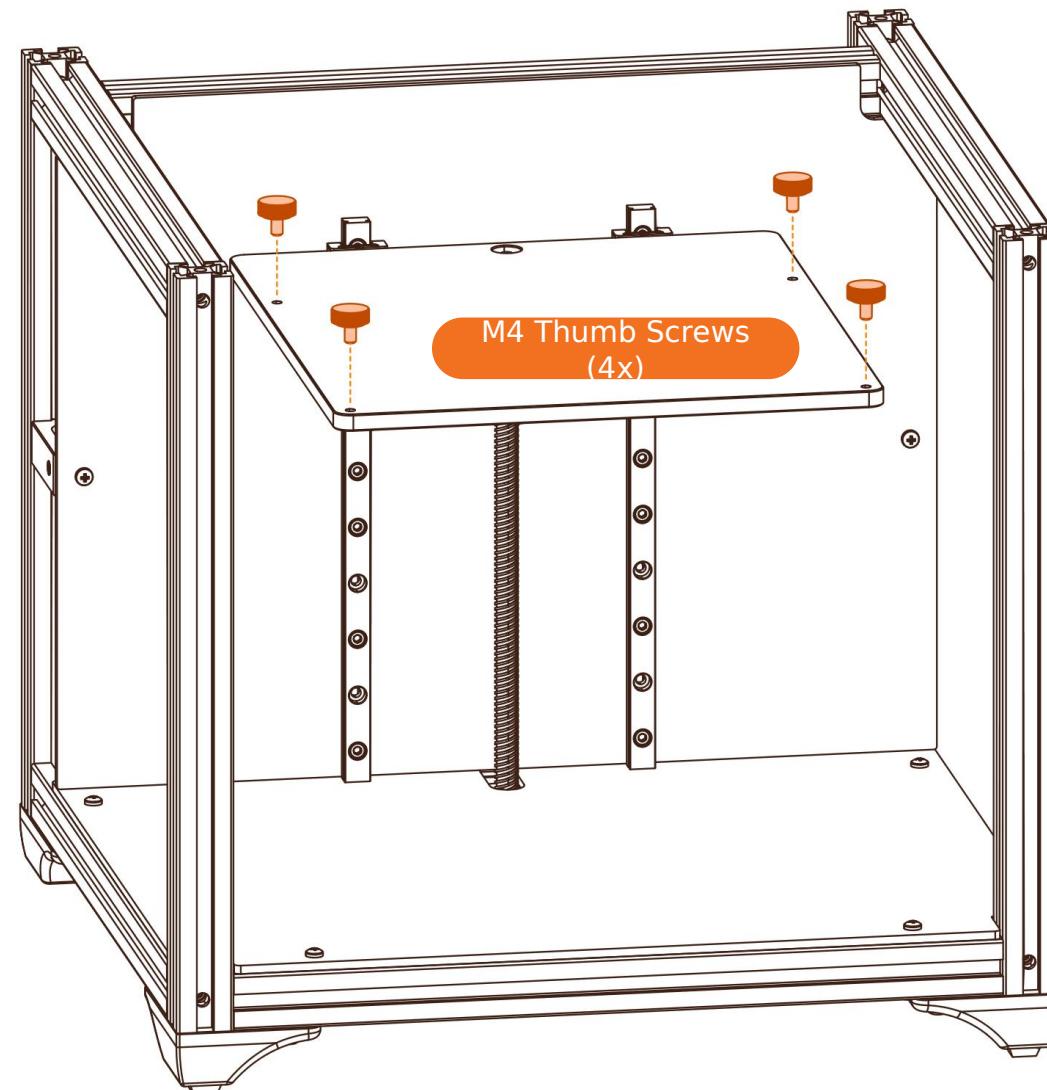
The bed is shipped with a protective film on its surfaces, remove it before you install it into the printer.

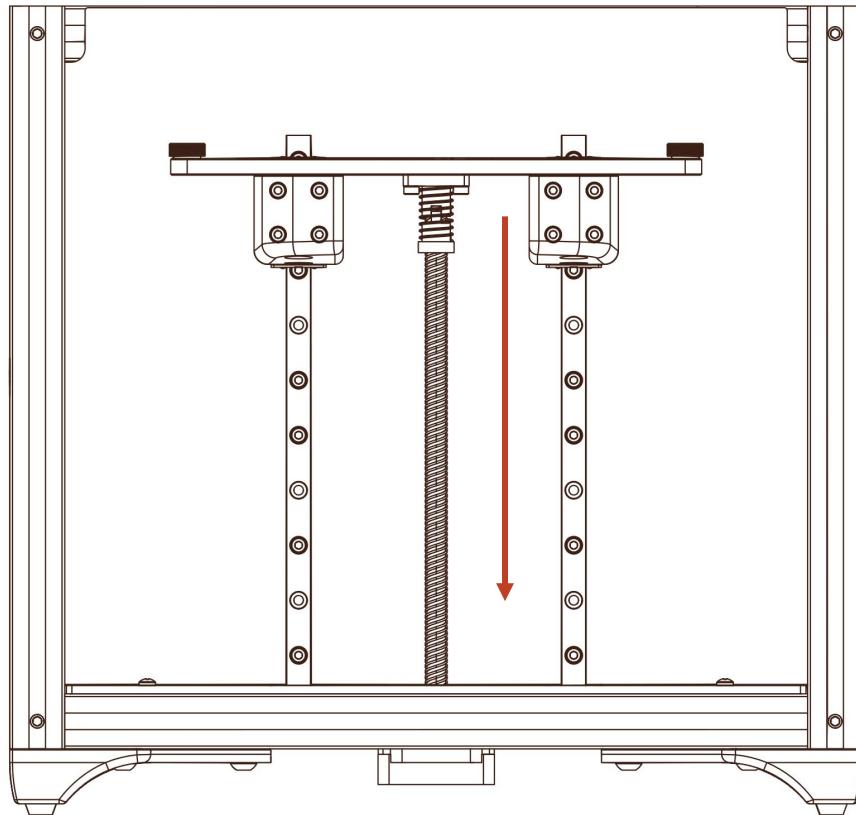




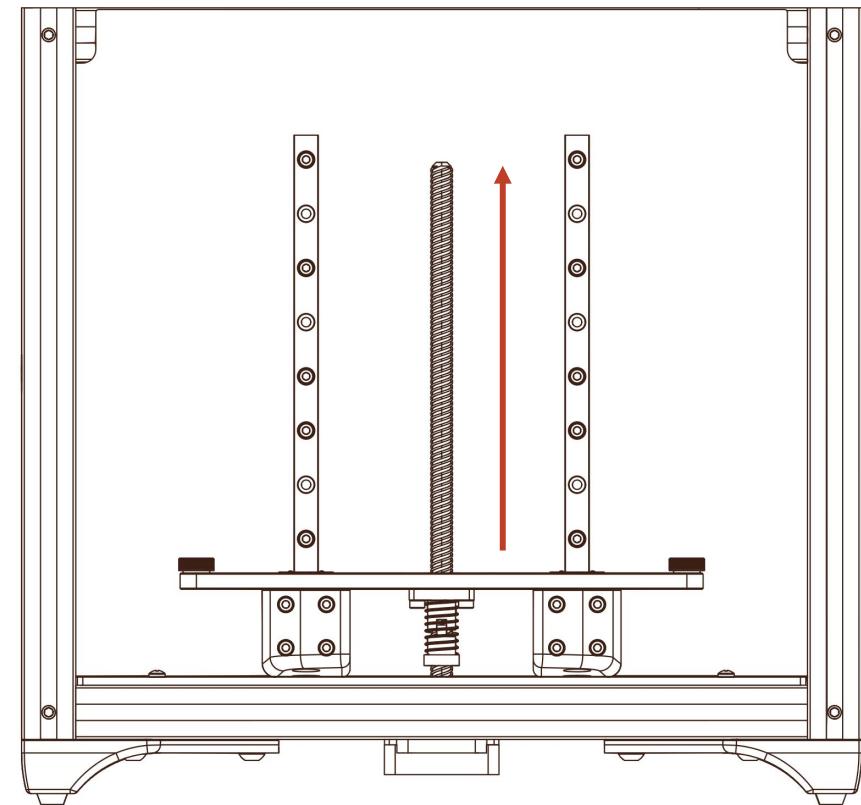
**BUILD SURFACE**

You can install the silicone build mat that came with the printer, the M4 thumb screws should keep it in place.



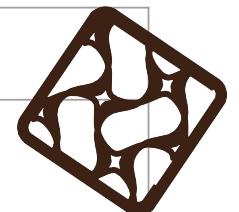
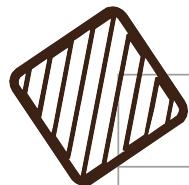
**CHECK BED ALIGNMENT**

Slide the bed assembly up and down to ensure that there are no areas where it is binding. The motion should be smooth and consistent.

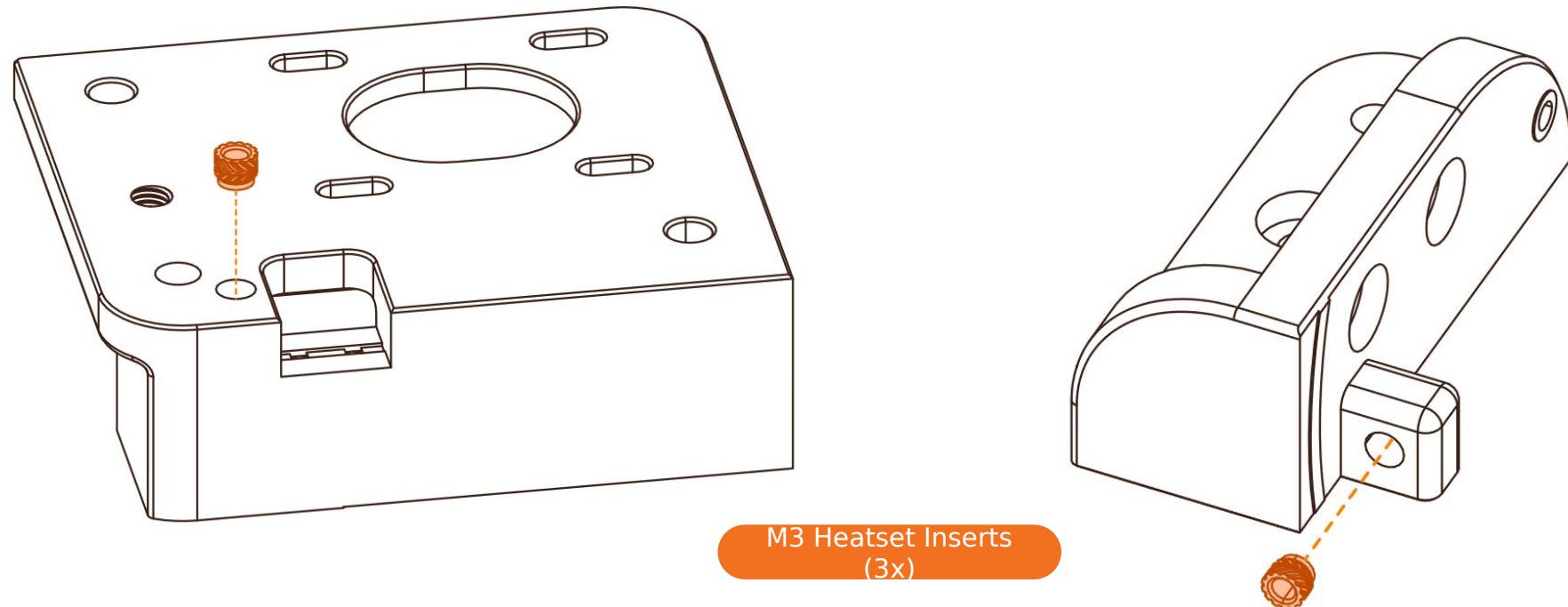
**CHECK RAILS ARE FASTENED**

Wiggle the rails by hand. If you can move them by hand, tighten them down further using an M3 driver.



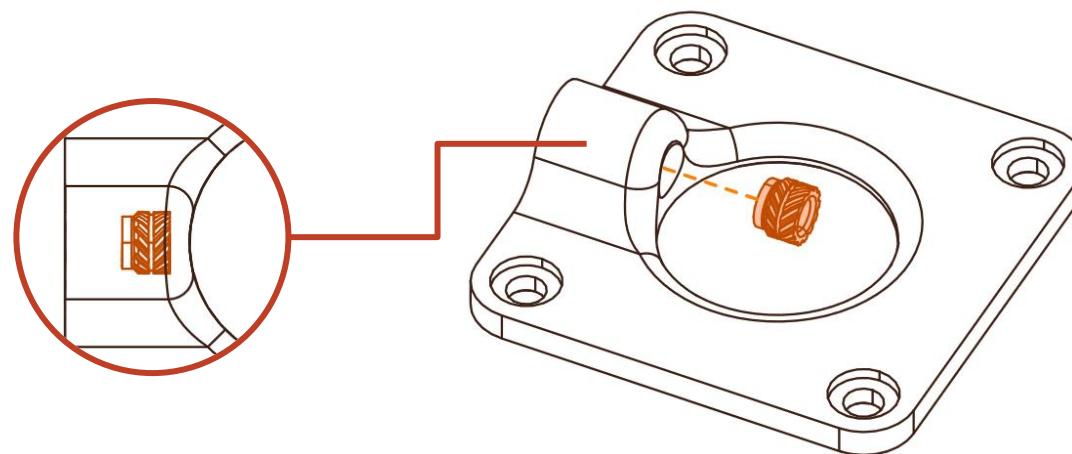


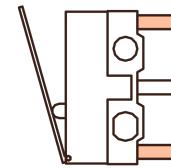
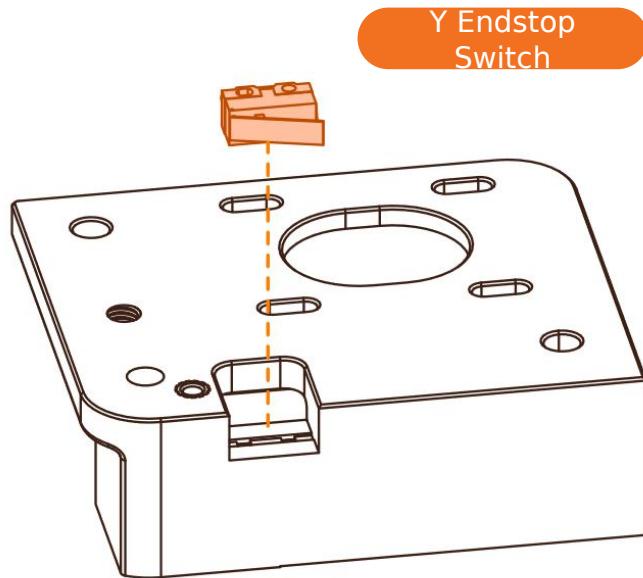
<b>Difficulty</b>	Medium		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M3 Heatset Insert (3x) Y Endstop Switch (1x) M2 Self Tapping Screws (2x) GT2 Pulley (1x) M5 Washer (6x) F695 Bearing (6x)	M3 Thumbscrew (1x) M3x8 Socket Head Cap Screw (4x) M3x30 Socket Head Cap Screw (1x) M3x30 Button Head Cap Screw (1x) M5x40 Socket Head Cap Screw (1x) M5x30 Button Head Cap Screw (2x) M5x10 Button Head Cap Screw (1x)	
<b>Printed Parts Needed</b>	Printed Spacer (1x) Motor Mount Right (1x) Rear Idler Stabilizer Right (1x) Belt Tensioner Sled (1x)		



#### INSERT INSTALLATION

This headset insert sits below the surface of the printed part, be sure that you have installed it to its correct position.

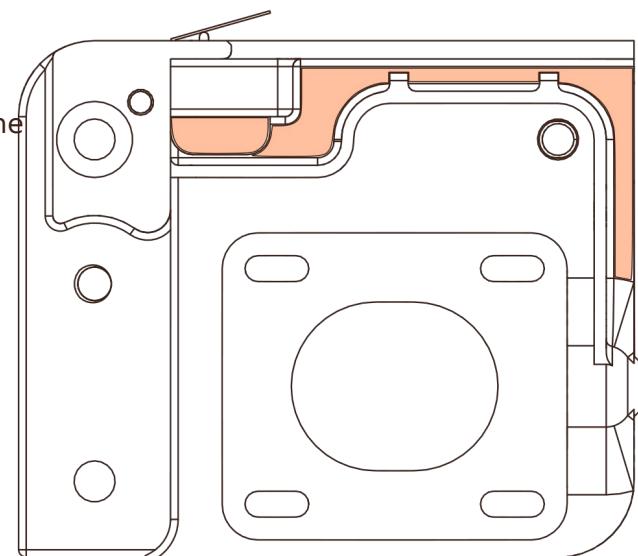


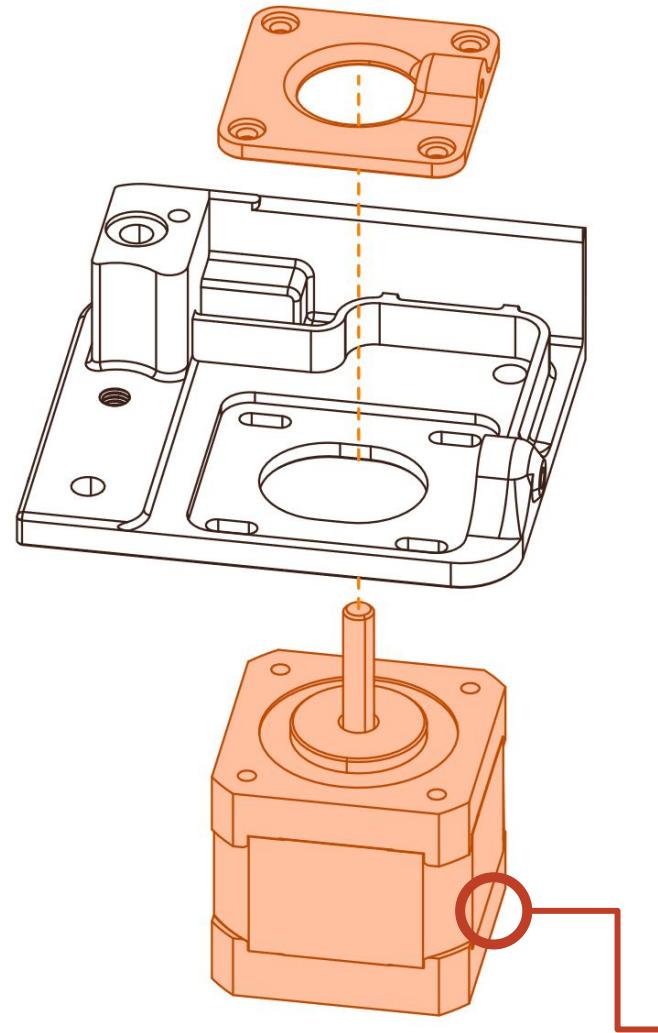
**ENDSTOP WIRING**

The endstop switches come pre-wired to the outer two terminals of the switch.

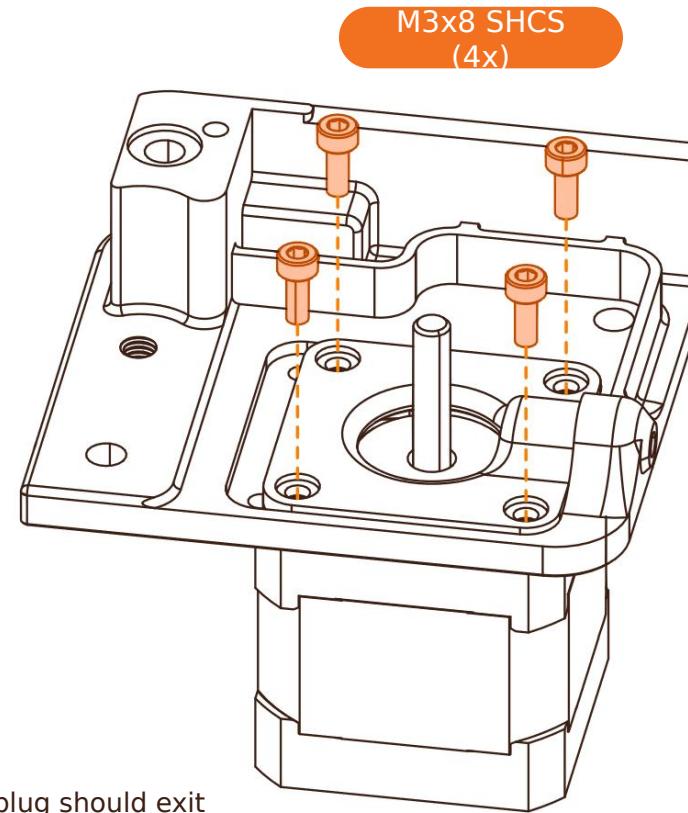
**WIRE PATH**

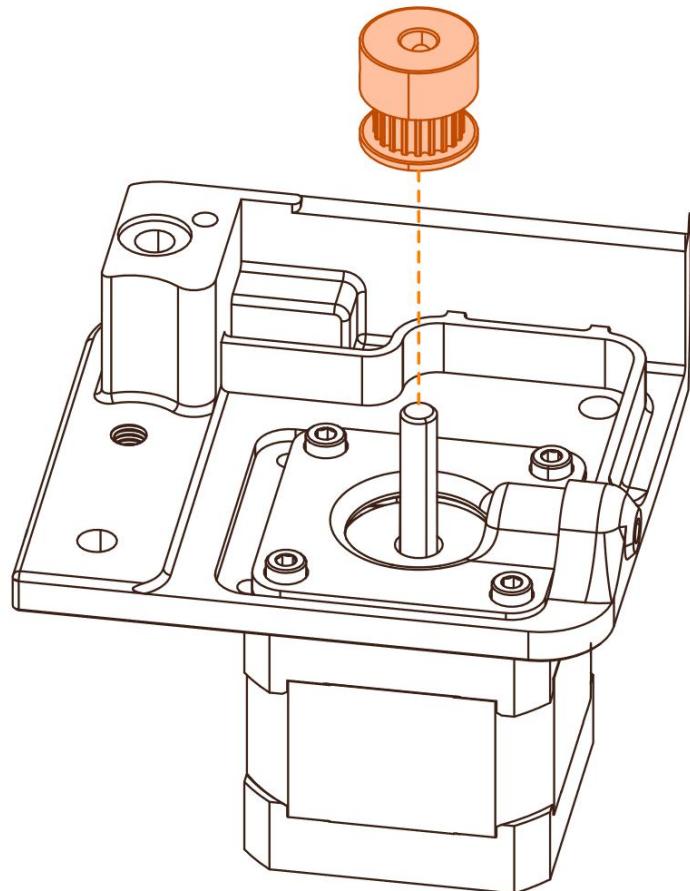
Run the endstop wiring along the highlighted path in the A motor assembly.



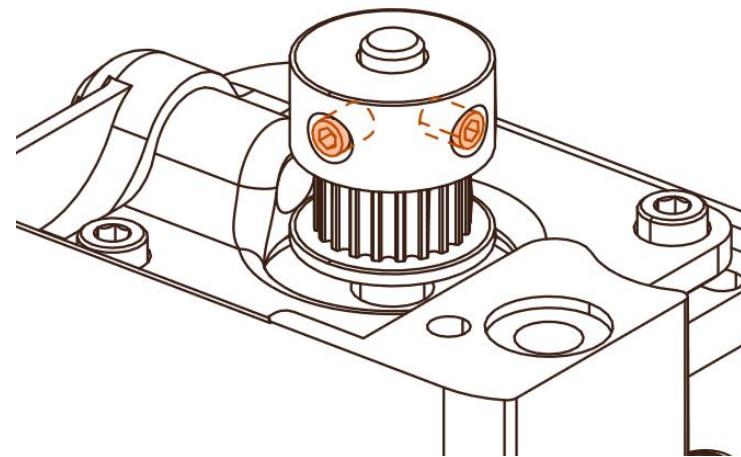
**MOTOR WIRING**

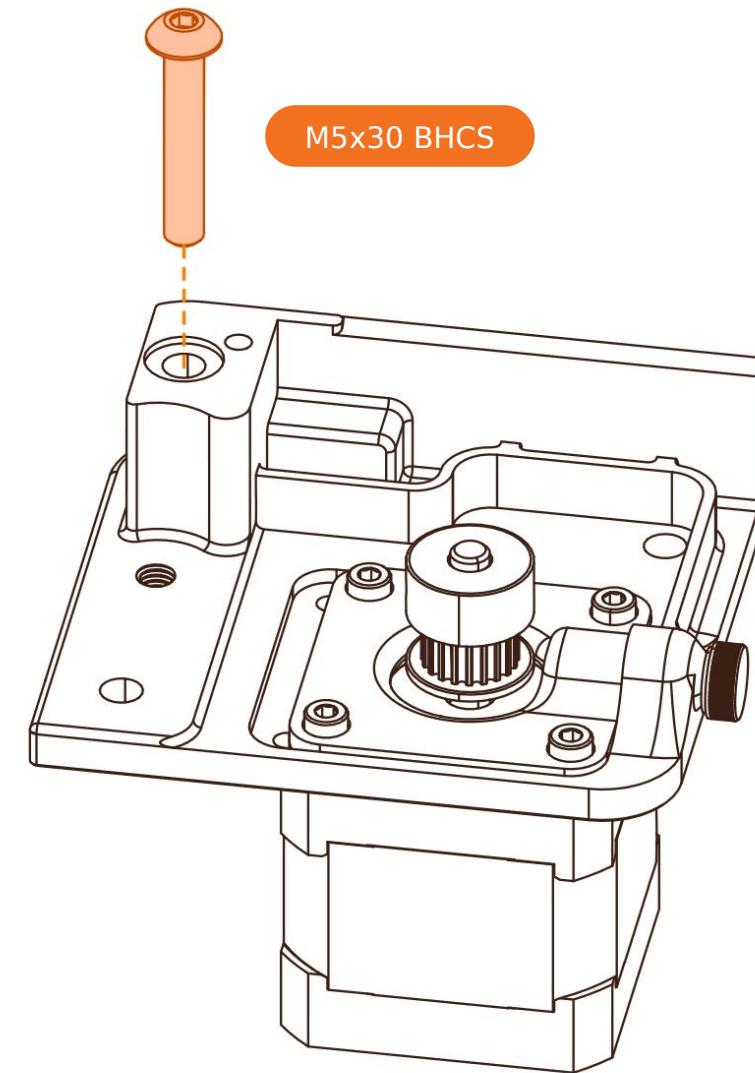
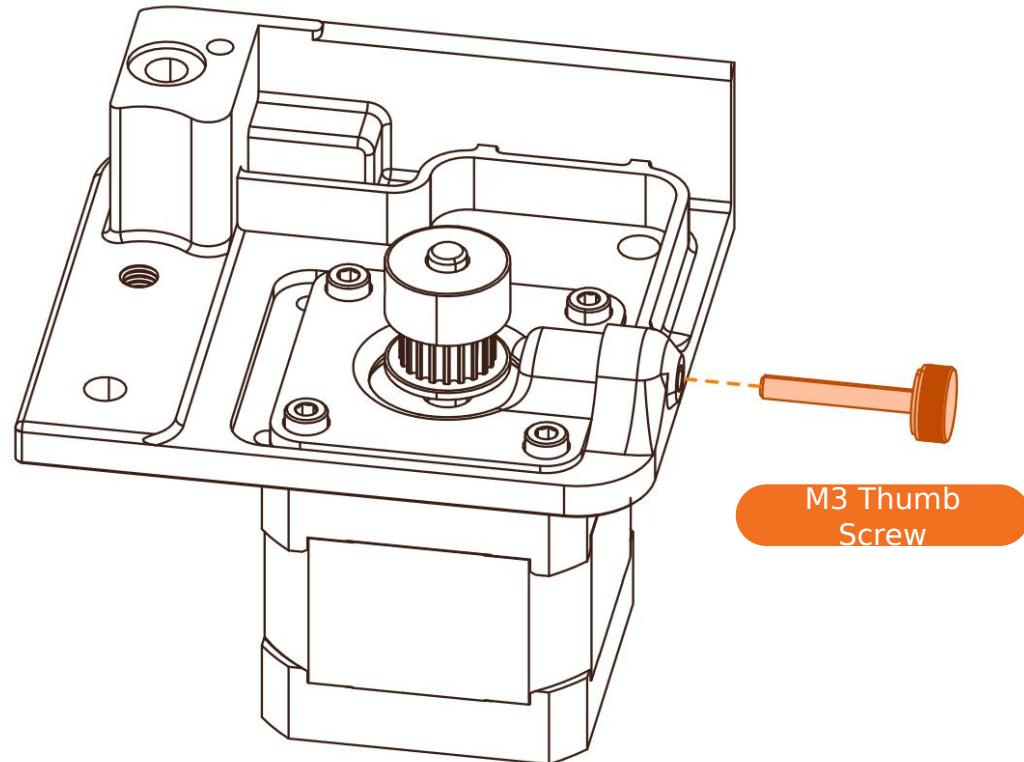
The motor wiring plug should exit from here, towards the center of the machine when the drive unit is installed.

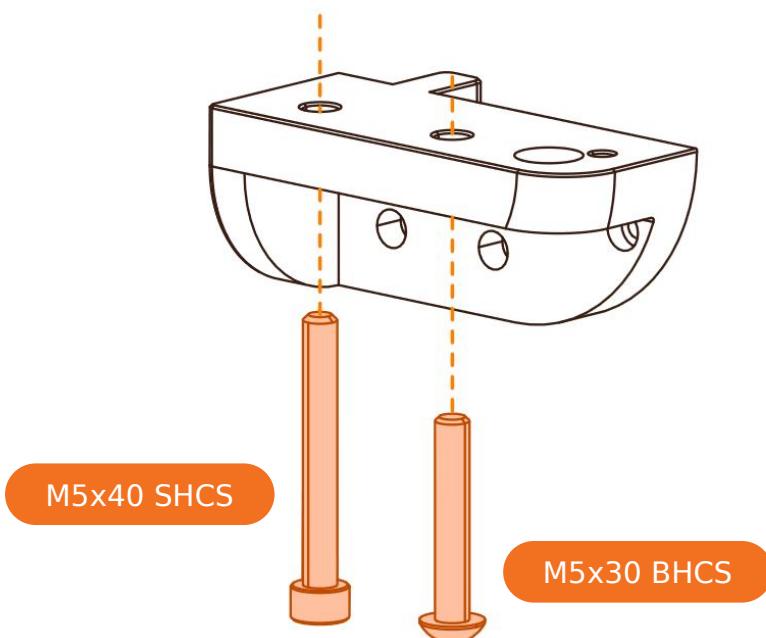


**PULLEY PLACEMENT**

We will set the height of this pulley at a later step. For now, ensure that at least one of the set screws is in contact with the flat portion of the motor shaft.

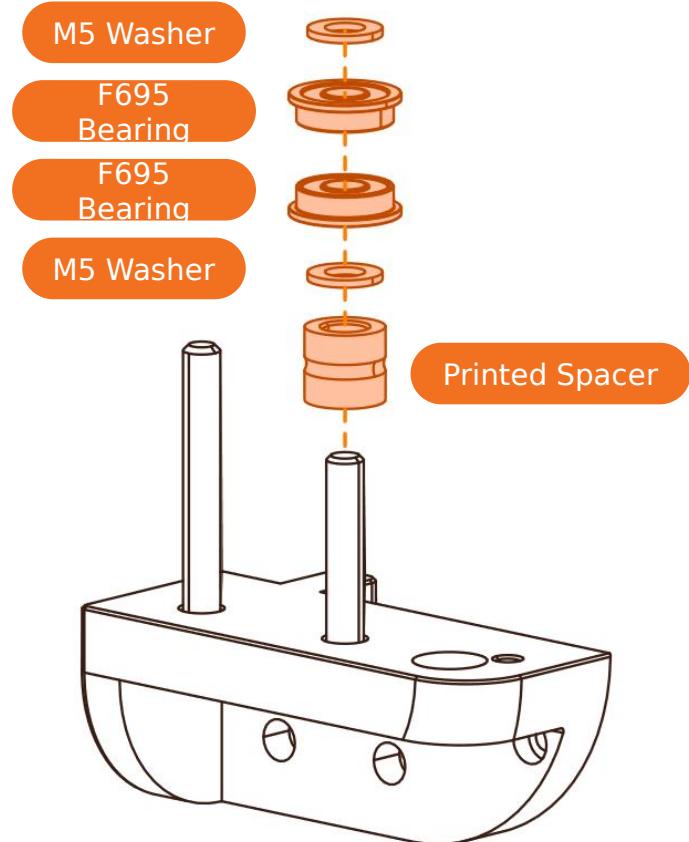






M5x40 SHCS

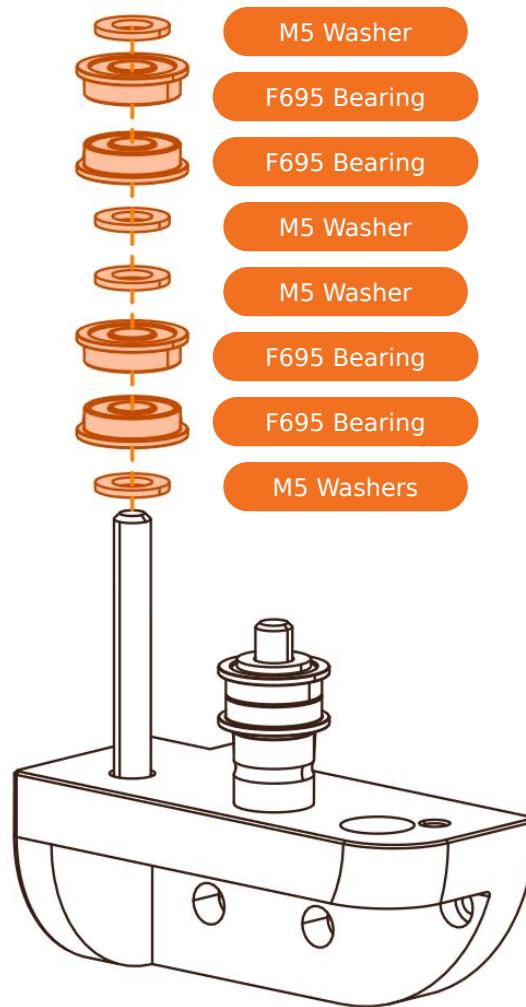
M5x30 BHCS



#### HARDWARE STACKS

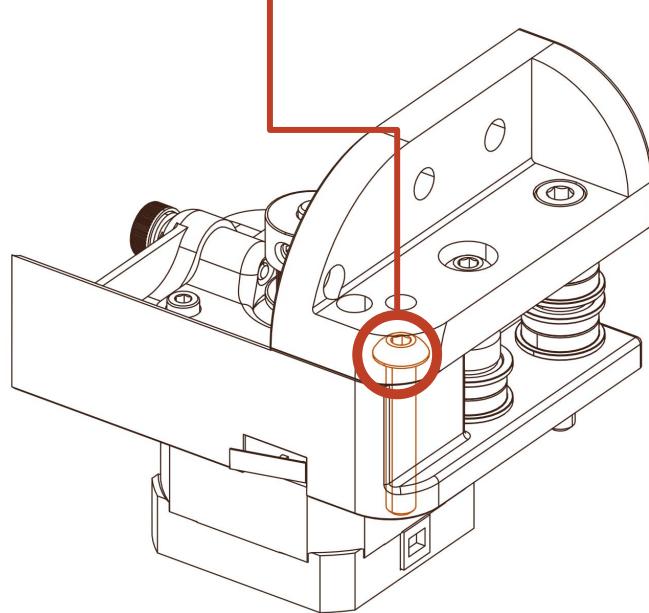
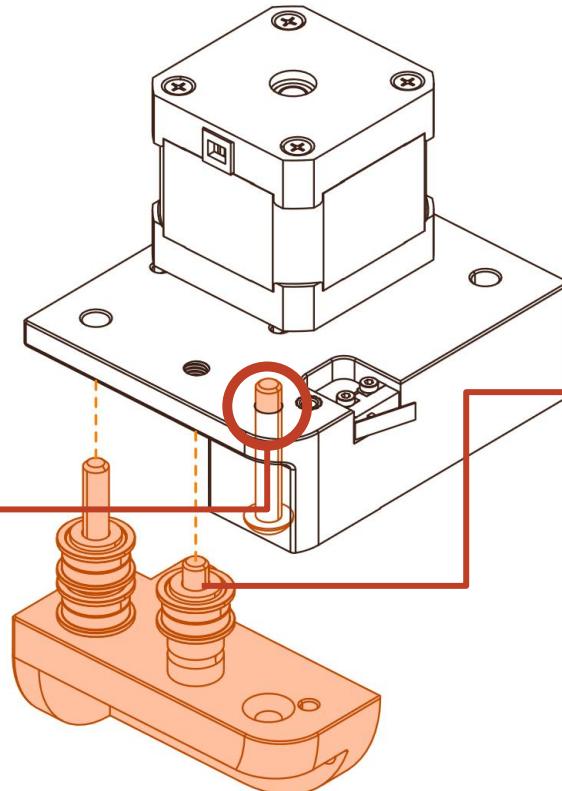
We will be installing a number of similar but NOT identical stacks of hardware like the one shown above.

Pay attention to the printed part orientation and the order of the stacked components as they are not all the same.

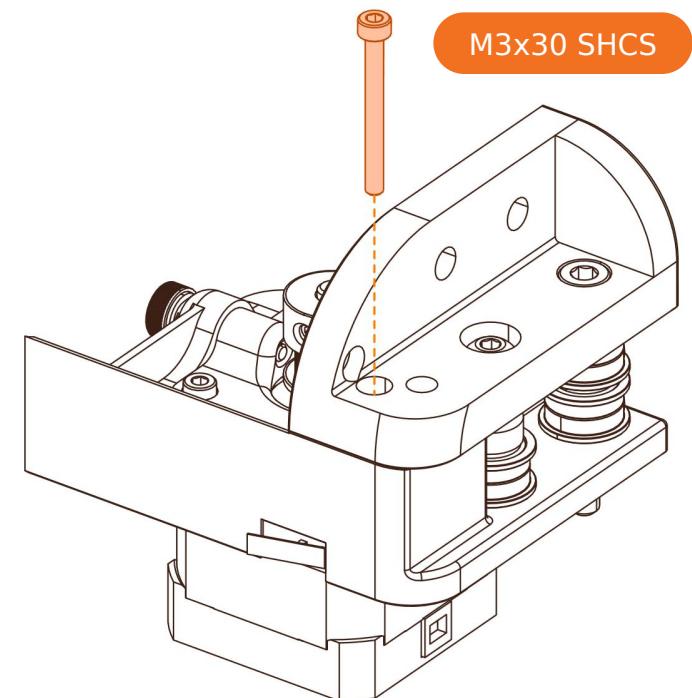


**EXTRA SCREWS**

We installed an M5x30 screw here on page 56 that will be captured by the printed parts. This fastener will help mount the drive unit to the frame at a later step.

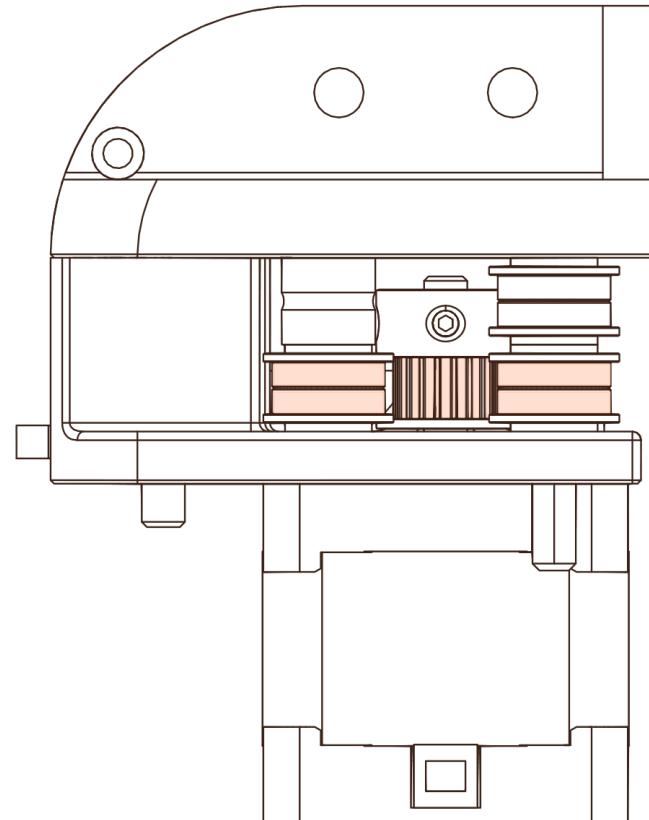
**THREADING INTO PLASTIC**

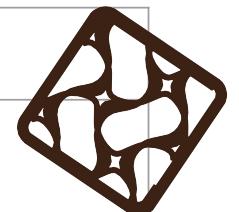
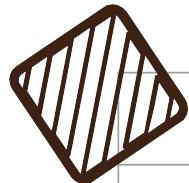
This screw threads into the plastic printed part, take care not to strip it by tightening it too much.



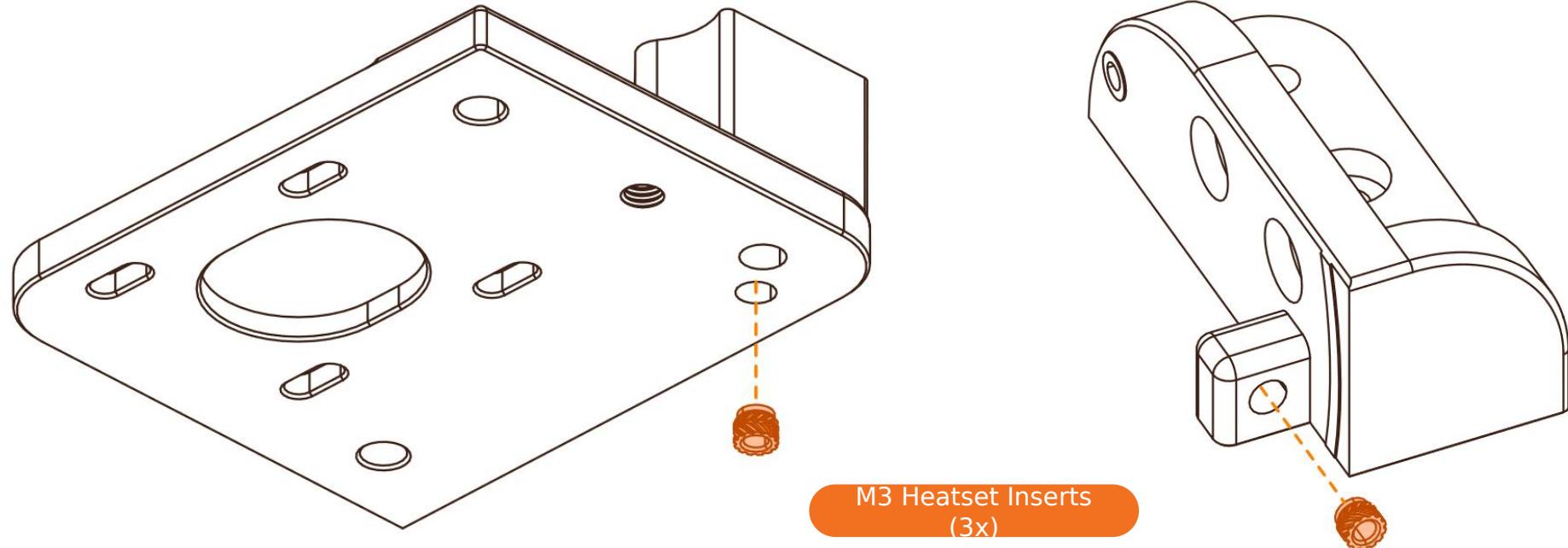
**SETTING DRIVE PULLEY HEIGHT**

At this point we can adjust the height of the drive pulley on the motor shaft. We want the pulley to be centered with the top pair of bearings on the A drive unit.



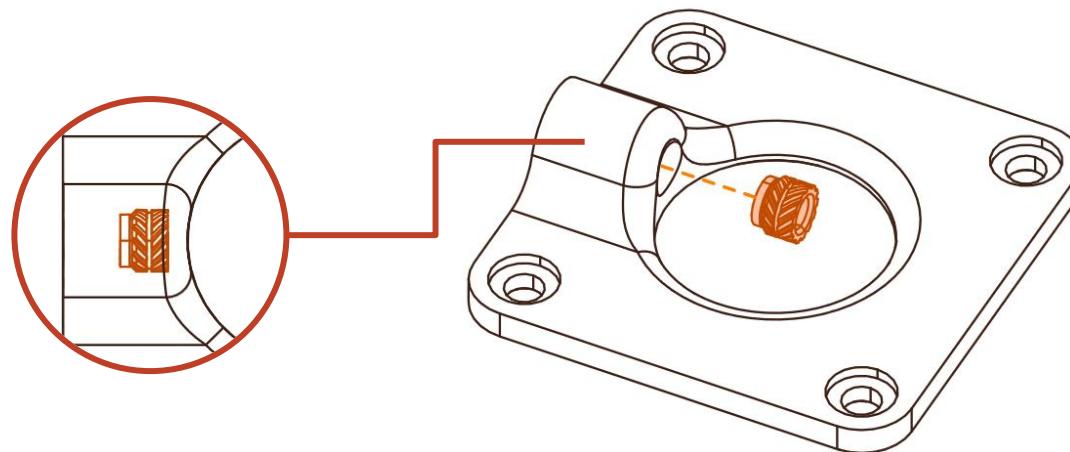


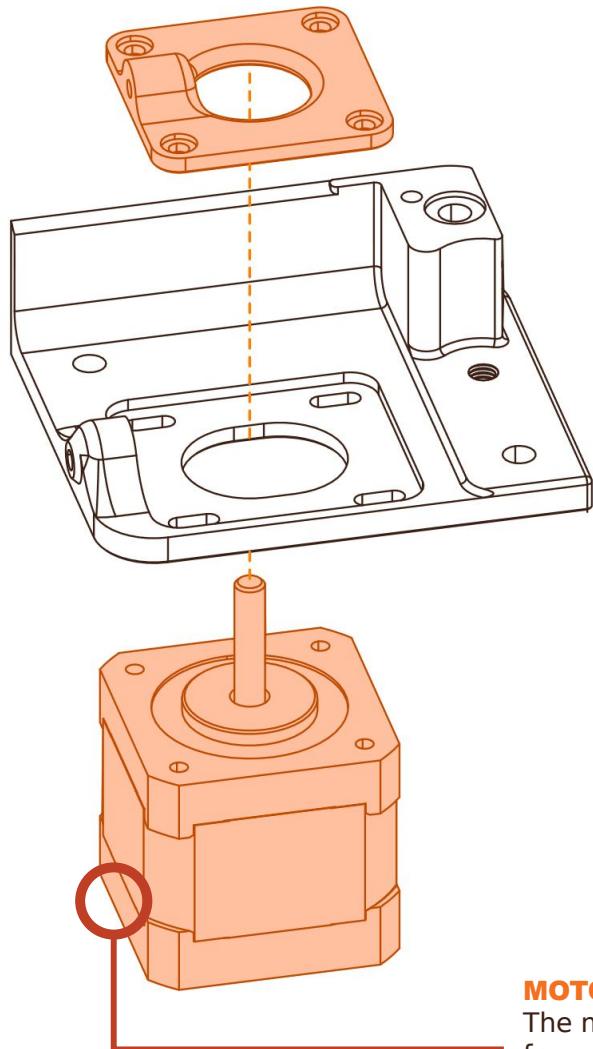
<b>Difficulty</b>	Medium		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M3 Heatset Insert (3x) M5 T-Nuts (3x) Y Endstop Switch (1x) M2 Self Tapping Screws (2x) GT2 Pulley (1x) M5 Washer (6x) F695 Bearing (6x)	M3 Thumbscrew (1x) M3x8 Socket Head Cap Screw (4x) M3x30 Socket Head Cap Screw (1x) M3x30 Button Head Cap Screw (1x) M5x40 Socket Head Cap Screw (1x) M5x30 Button Head Cap Screw (2x) M5x10 Button Head Cap Screw (1x)	
<b>Printed Parts Needed</b>	Printed Spacer (1x) Motor Mount Left (1x) Rear Idler Stabilizer Left (1x) Belt Tensioner Sled (1x)		



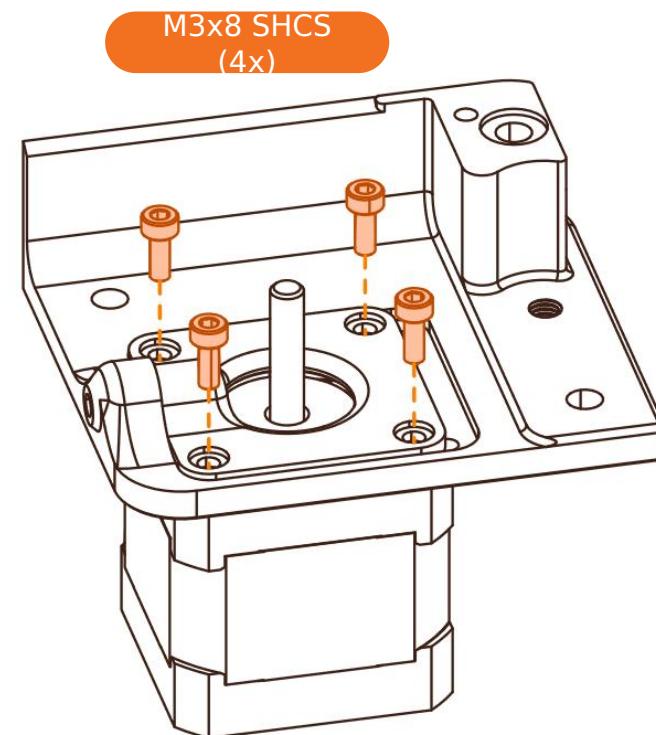
**INSERT INSTALLATION**

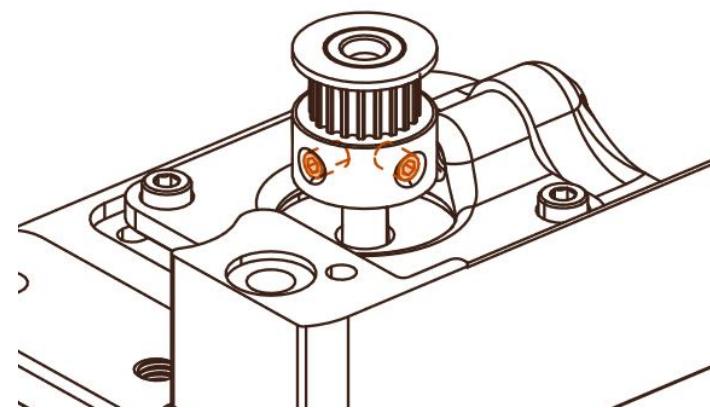
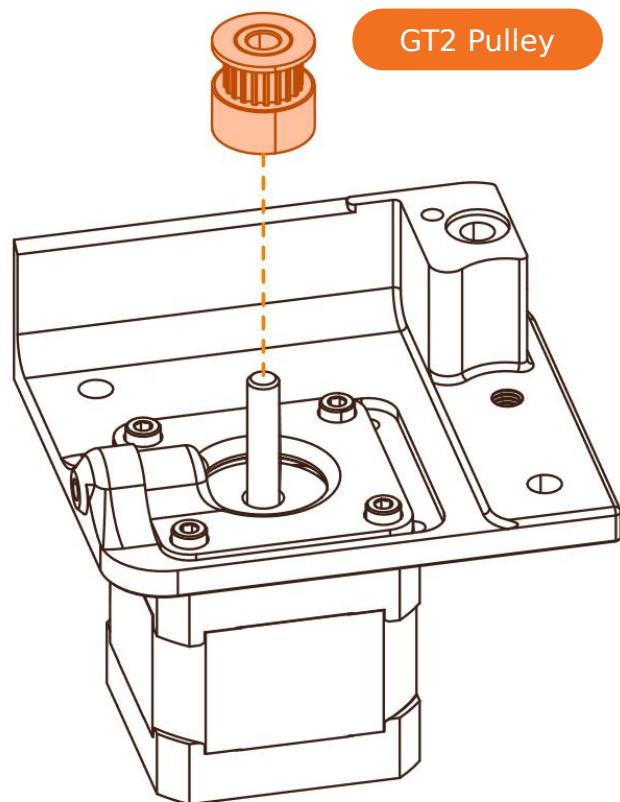
This headset insert sits below the surface of the printed part, so be sure that you have installed it to its correct position.

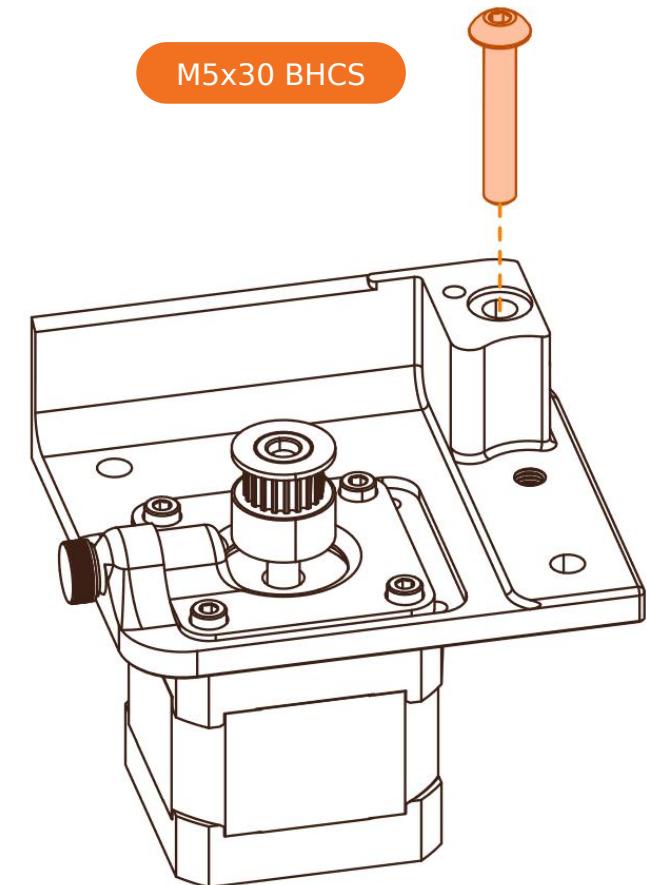
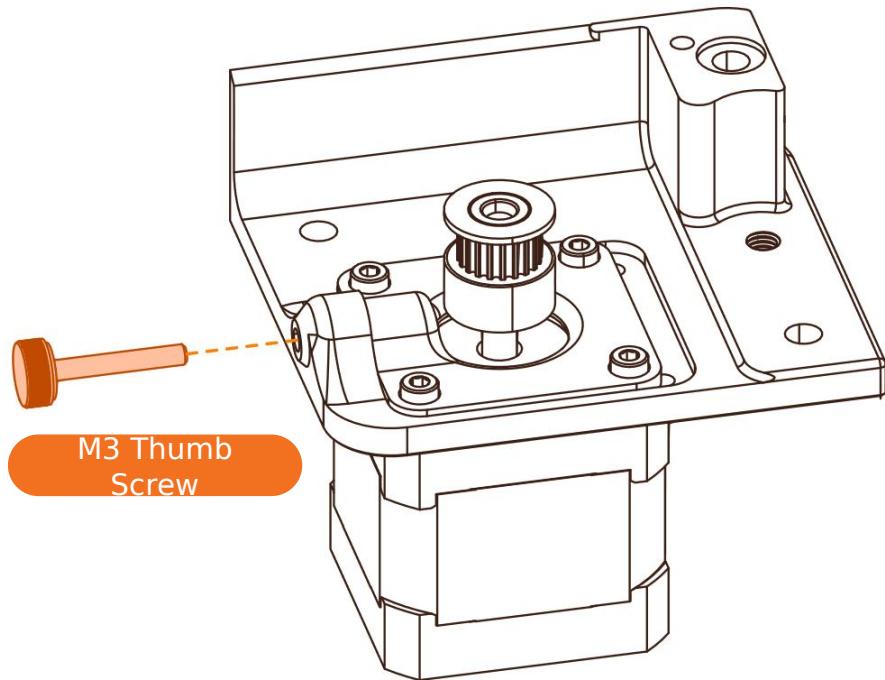


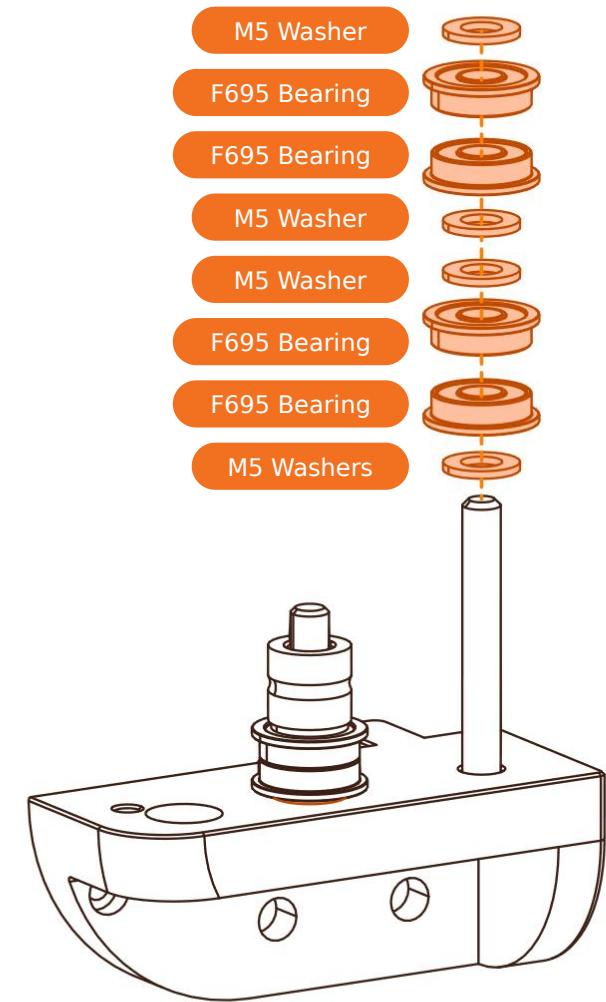
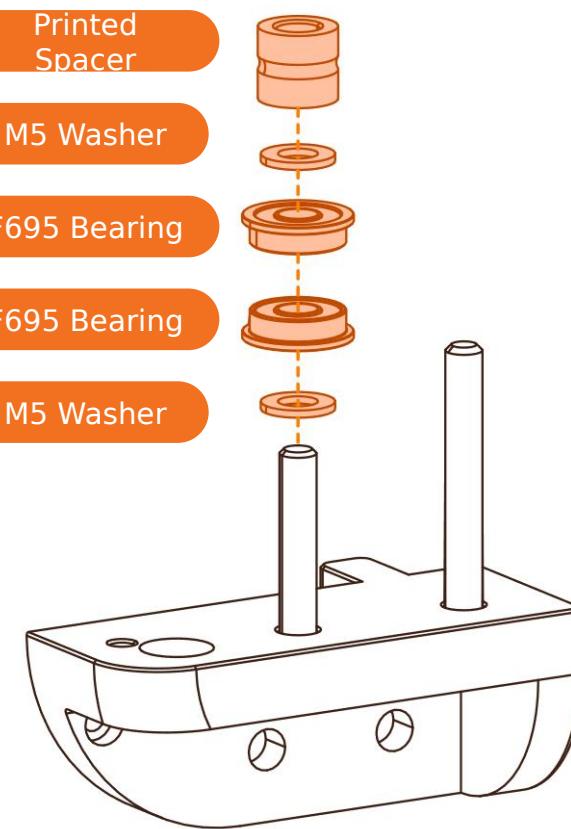
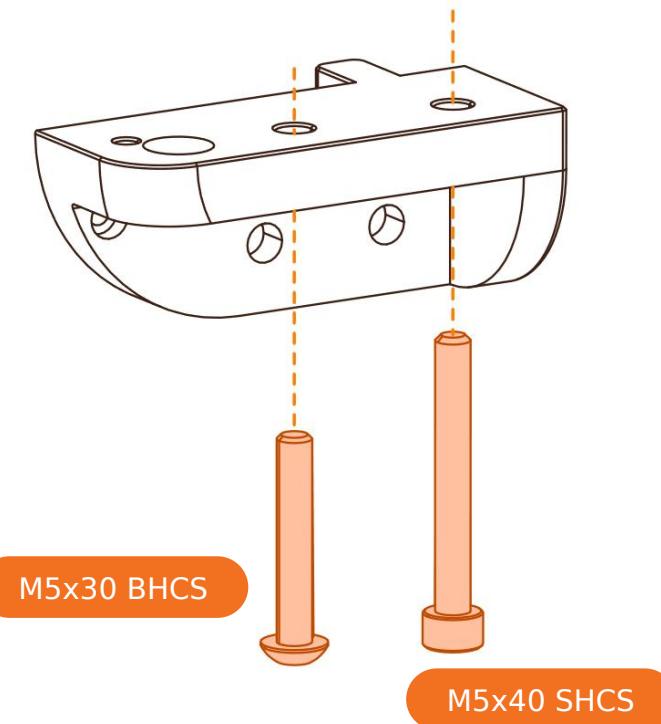
**MOTOR WIRING**

The motor wiring plug should exit from here, and direct towards the center of the machine when the drive unit is installed.



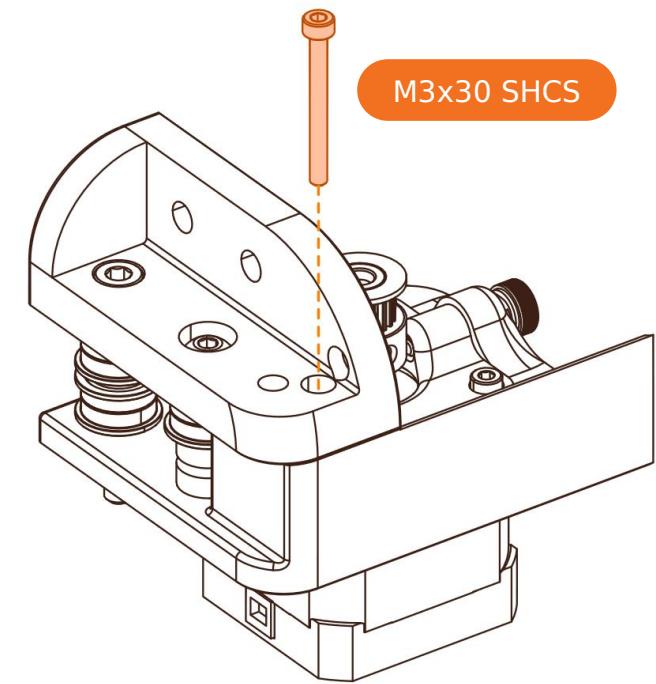
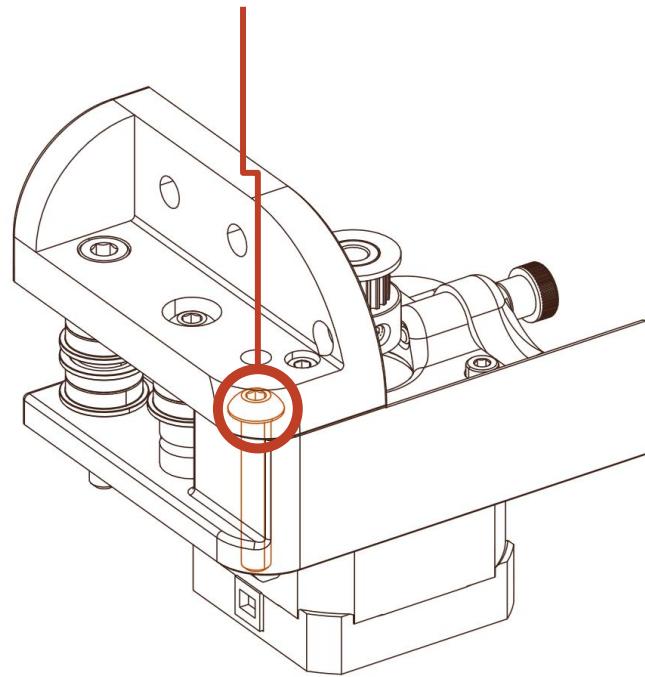
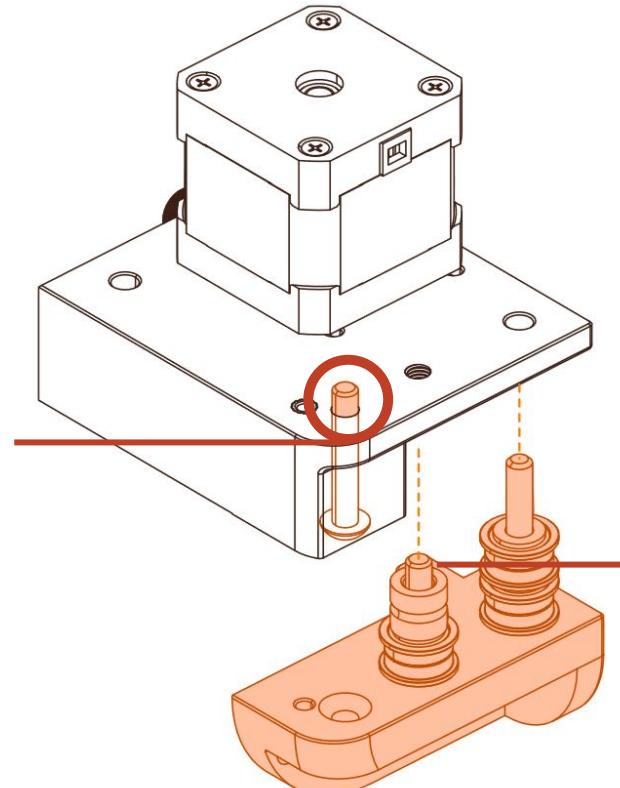






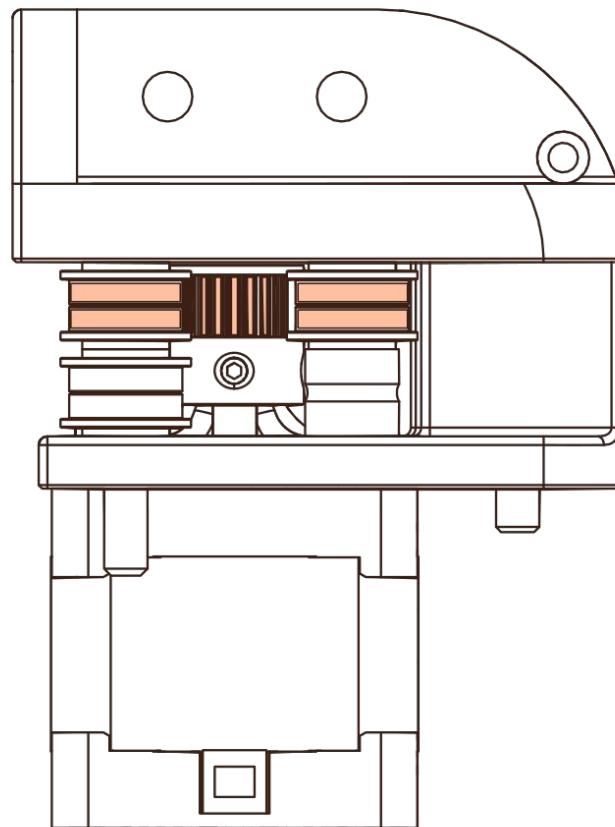
**EXTRA SCREWS**

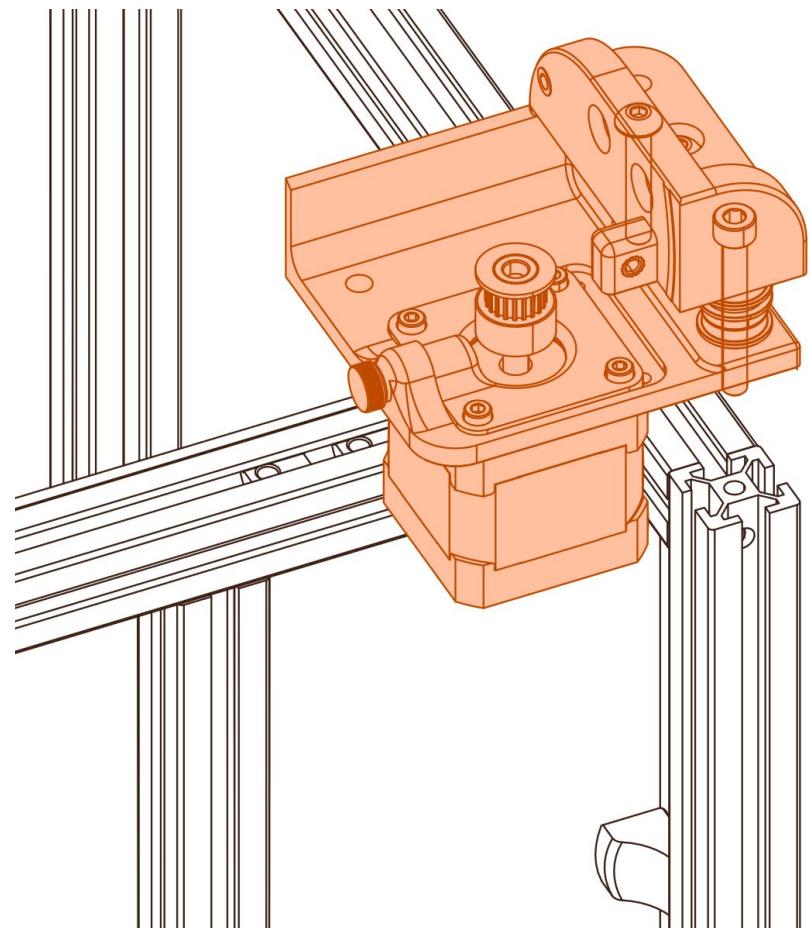
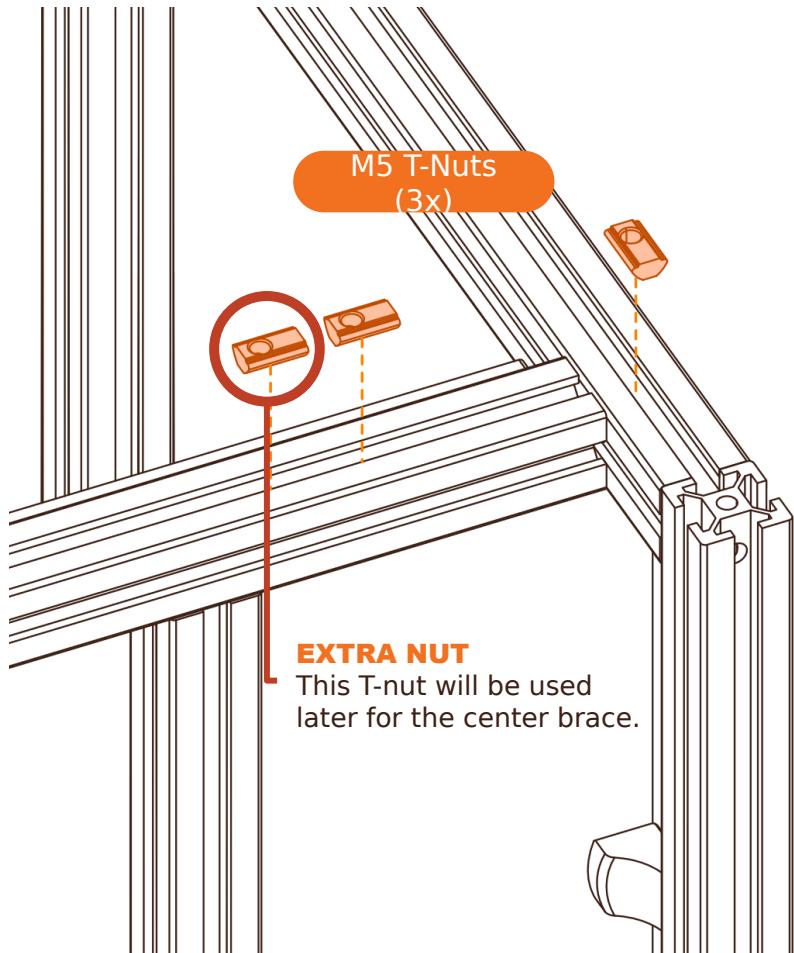
We installed an M5x30 screw here back on page 65 that will be captured by the printed parts. This fastener will help mount the drive unit to the frame at a later step.



**SETTING DRIVE PULLEY HEIGHT**

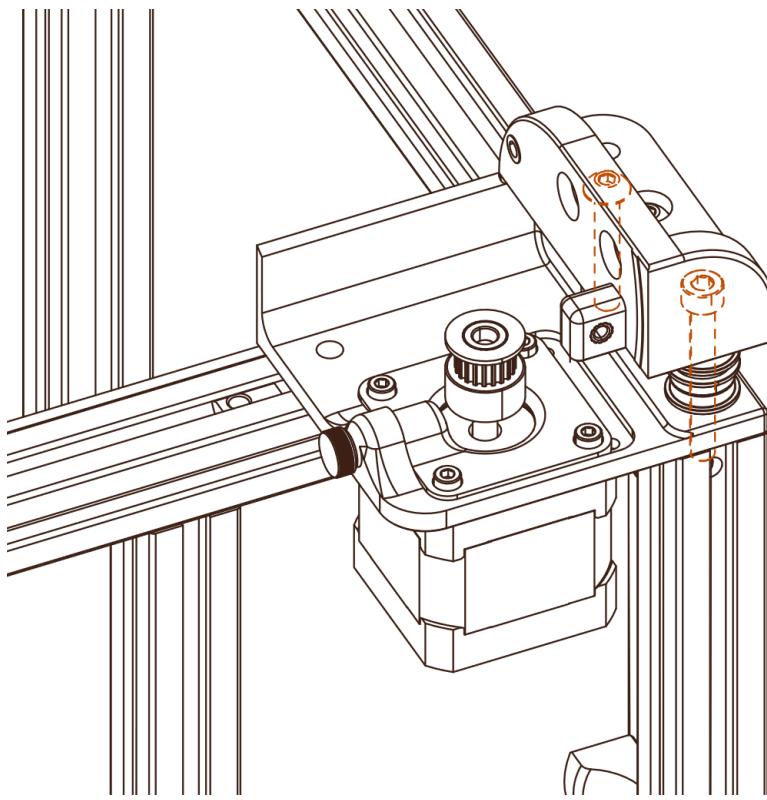
At this point we can adjust the height of the drive pulley on the motor shaft. We want the pulley to be centered with the top pair of bearings on the B drive unit.



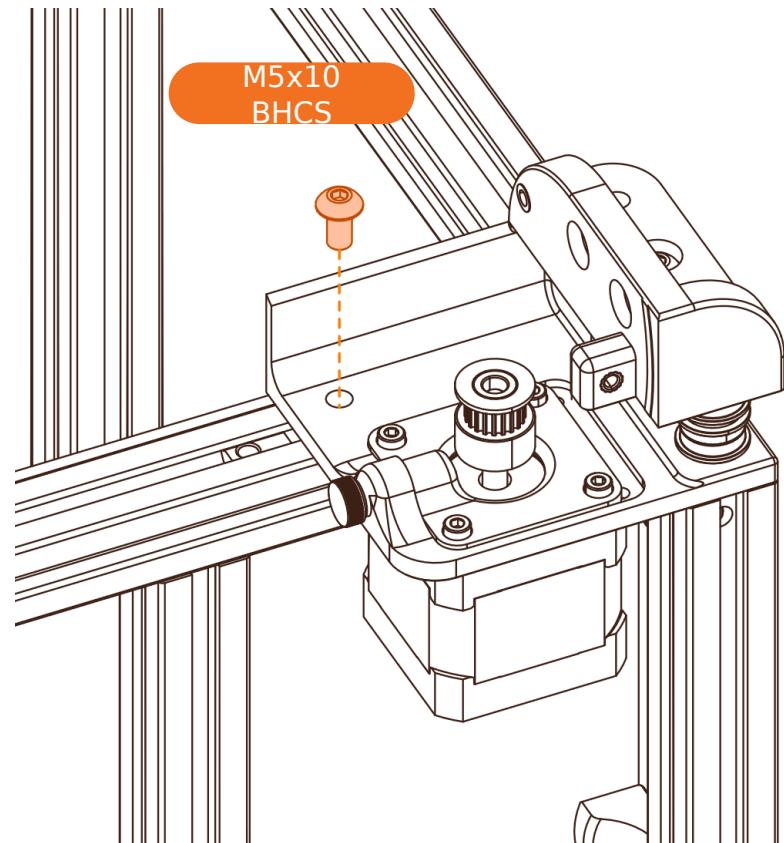


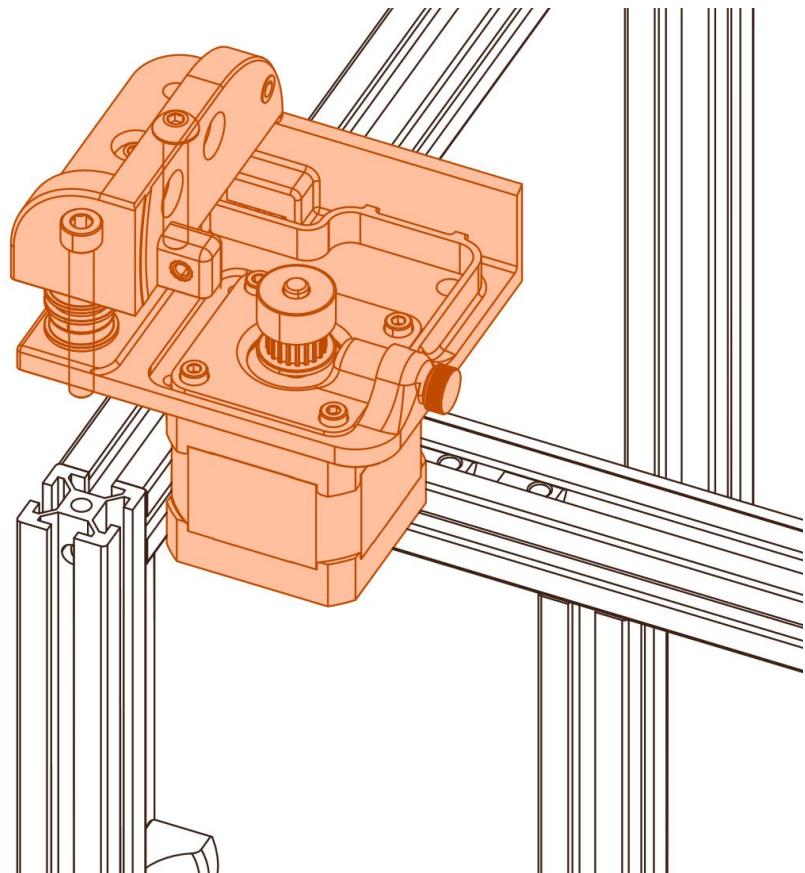
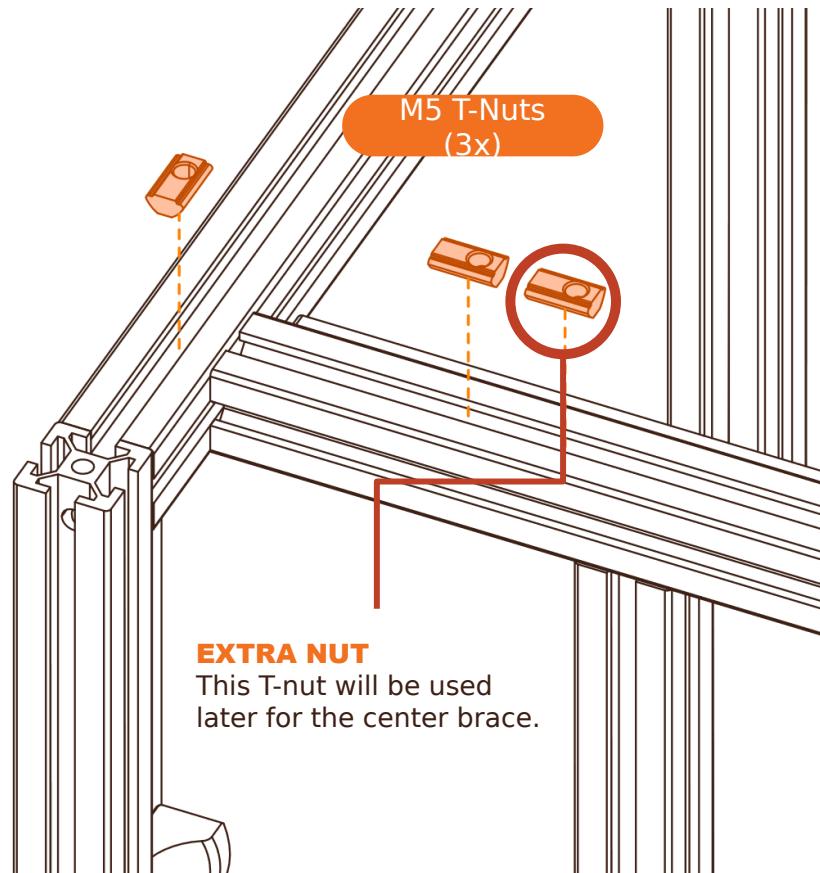
**ATTACHING THE DRIVE UNIT**

The two highlighted screws help secure the drive unit to the frame, the button head screw threads into a T-nut you installed on the previous page, and the socket head screw threads into the end of the vertical extrusion.

**SQUISH (PLEASE DON'T)**

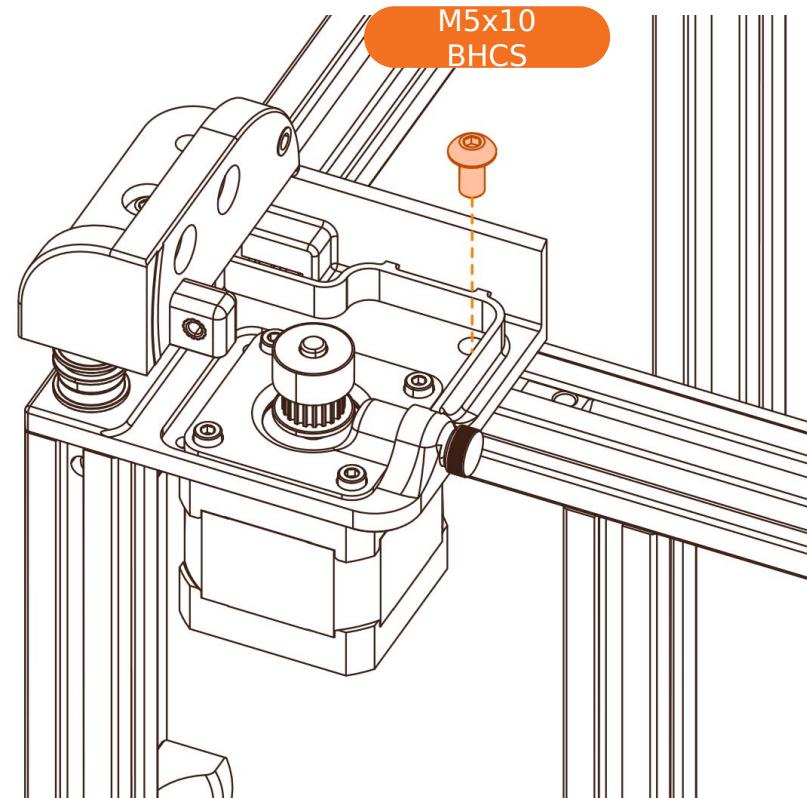
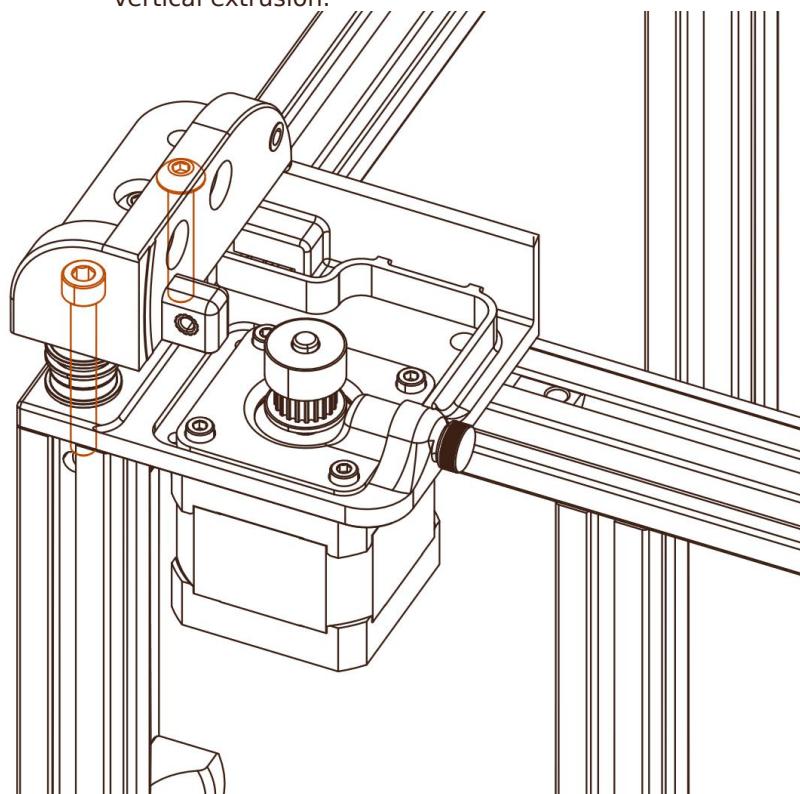
This screw threads through printed parts and can compress the part accidentally. Do not overtighten.

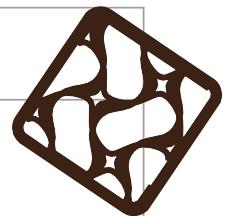
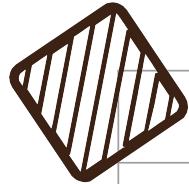




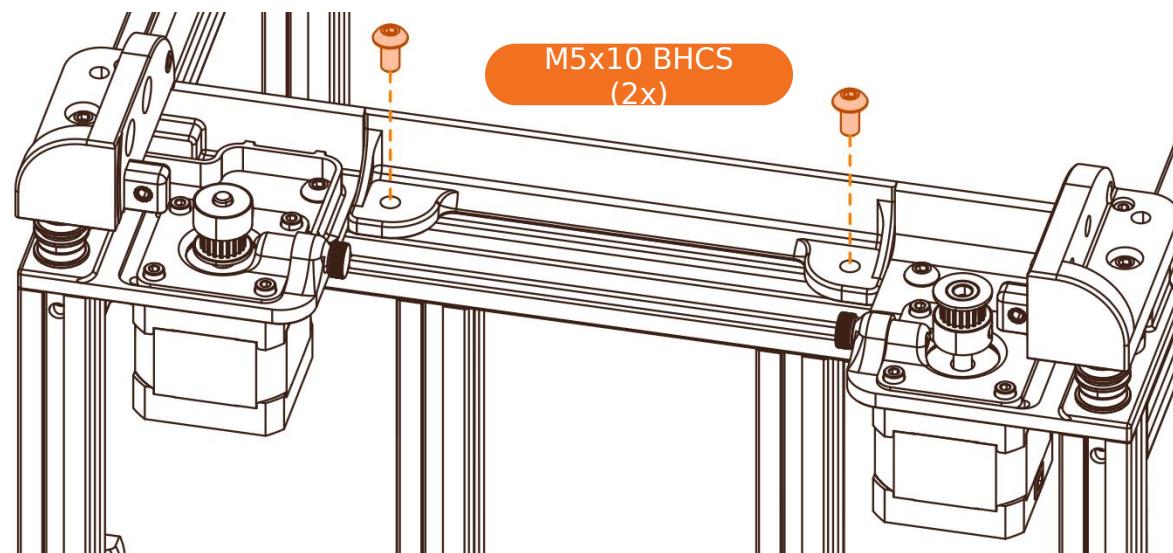
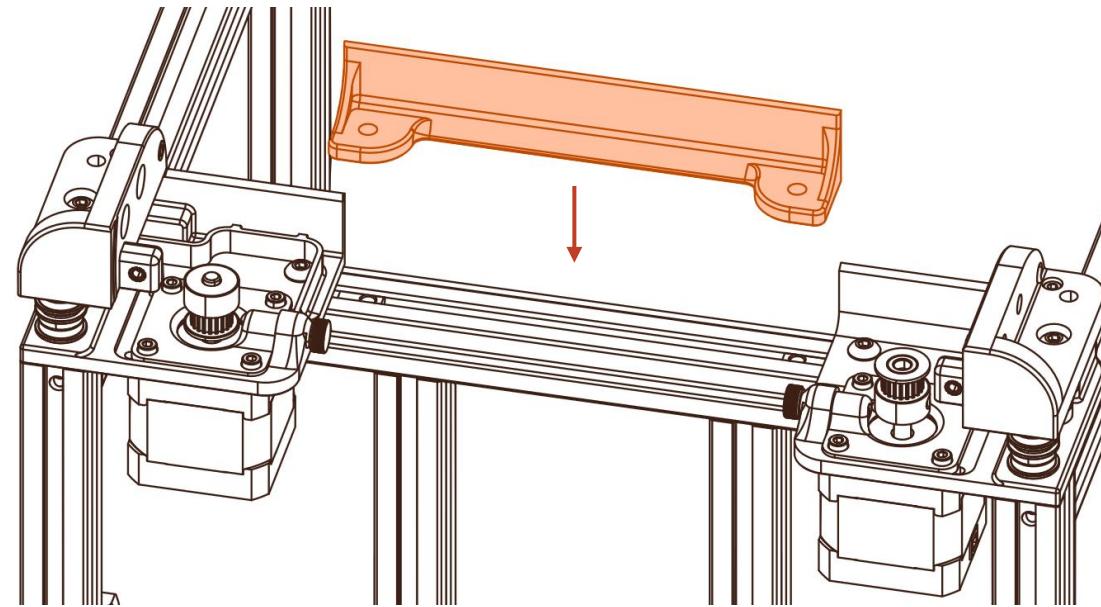
**ATTACHING THE DRIVE UNIT**

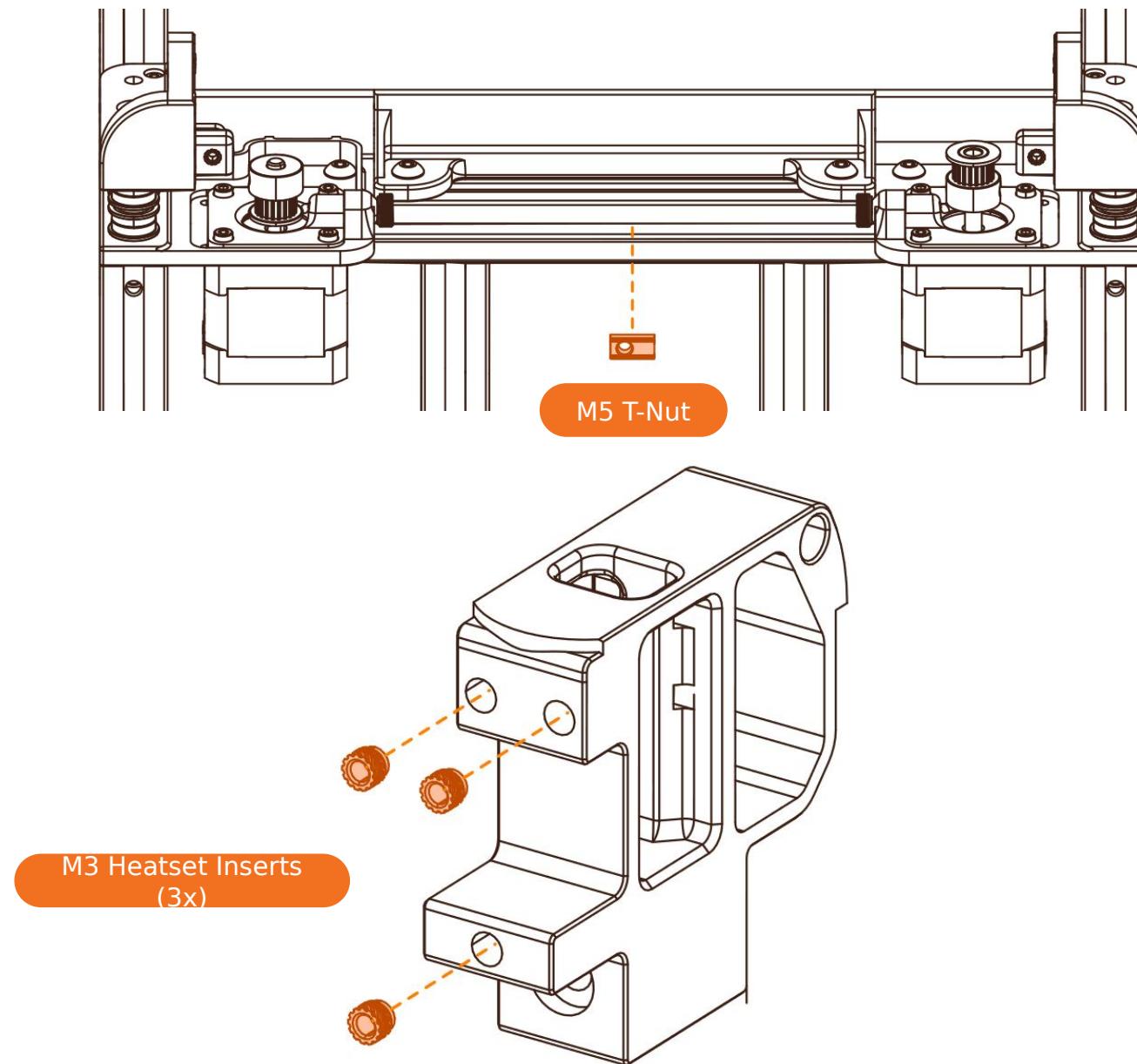
The two highlighted screws help secure the drive unit to the frame, the button head screws threads into a T-nut you installed on the previous page, and the socket head screw threads into the end of the vertical extrusion.

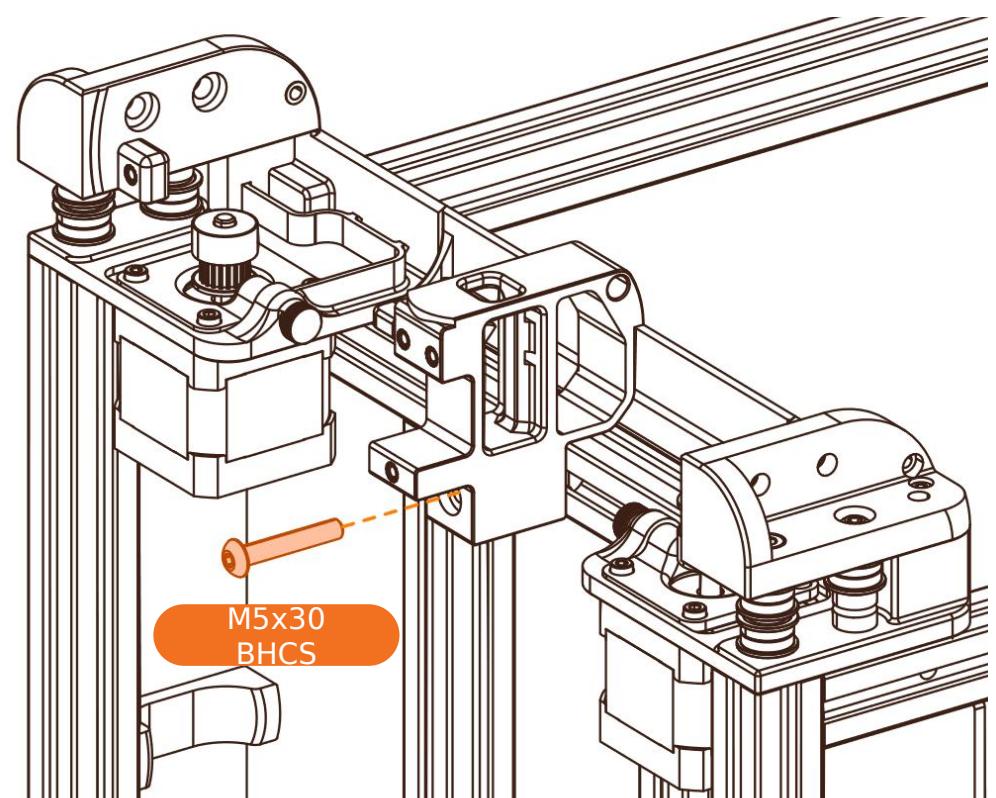
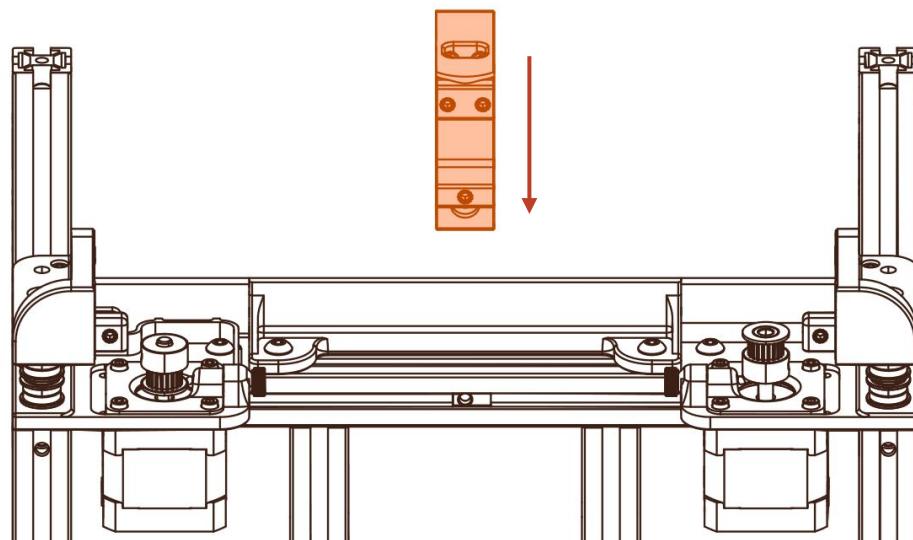


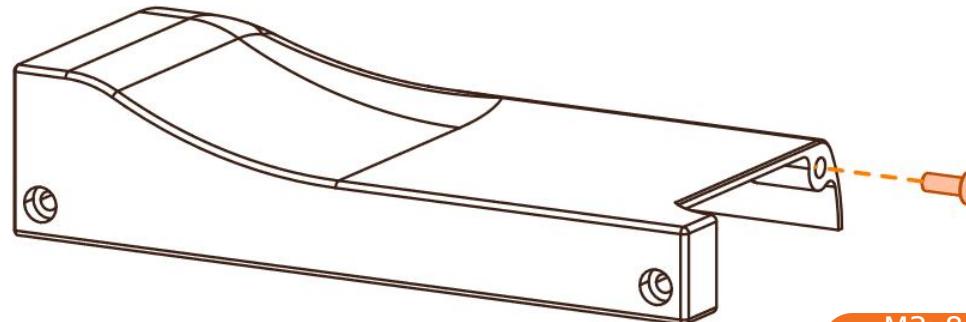


<b>Difficulty</b>	Medium		
<b>Tools Needed</b>	M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M5x10 Button Head Cap Screw (2x) M5 T-Nut (1x) M3 Heatset Inserts (3x) M5x30 Button Head Cap Screw (1x) M3x8 SHCS (2x) M3x16 SHCS (2x) M3x12 SHCS (4x)		
<b>Printed Parts Needed</b>	Rear Cover Panel (1x) Rear Center Support (1x) Motor Bay Cover Left (1x) Motor Bay Cover Right (1x)		A black icon of a square with concentric circles inside it, representing a circular part like a cover or plate.







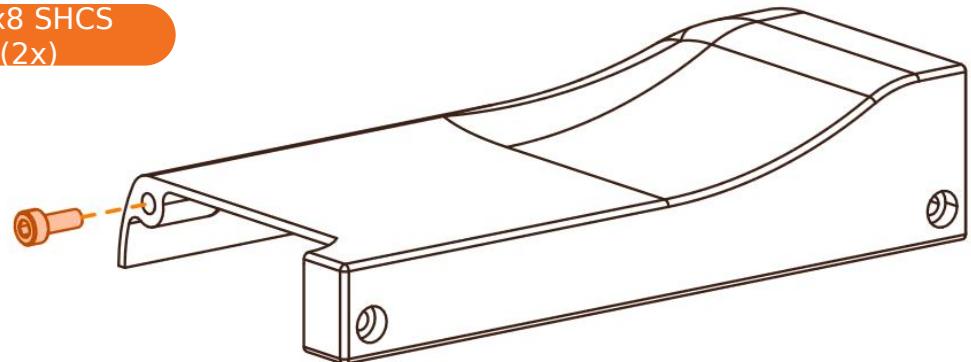


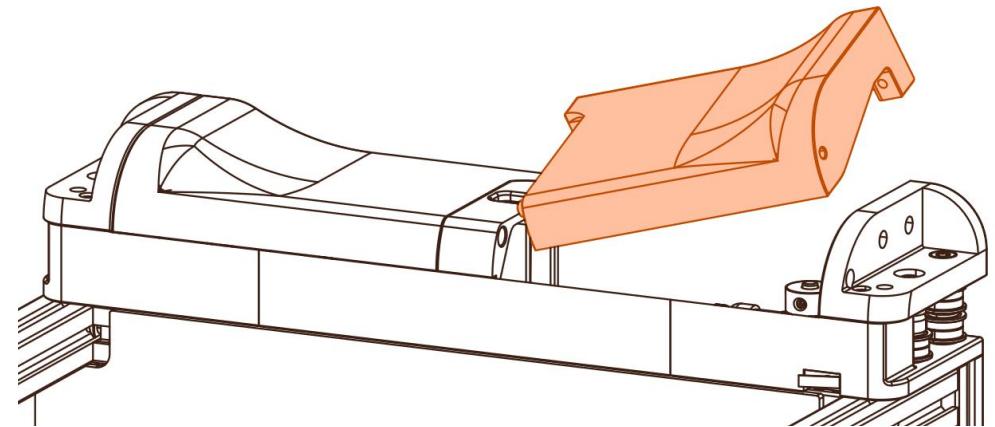
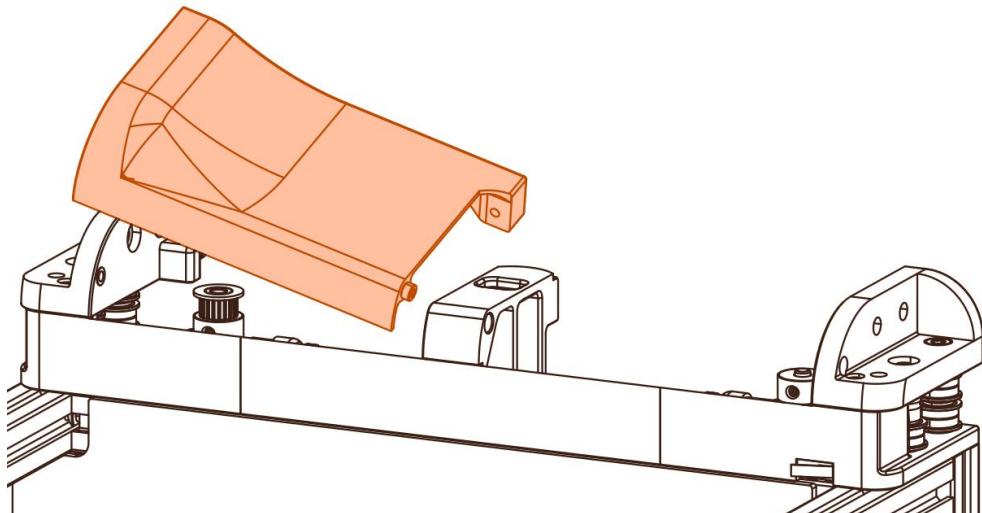
M3x8 SHCS  
(2x)

#### PREPPING THE DRIVE UNIT COVERS

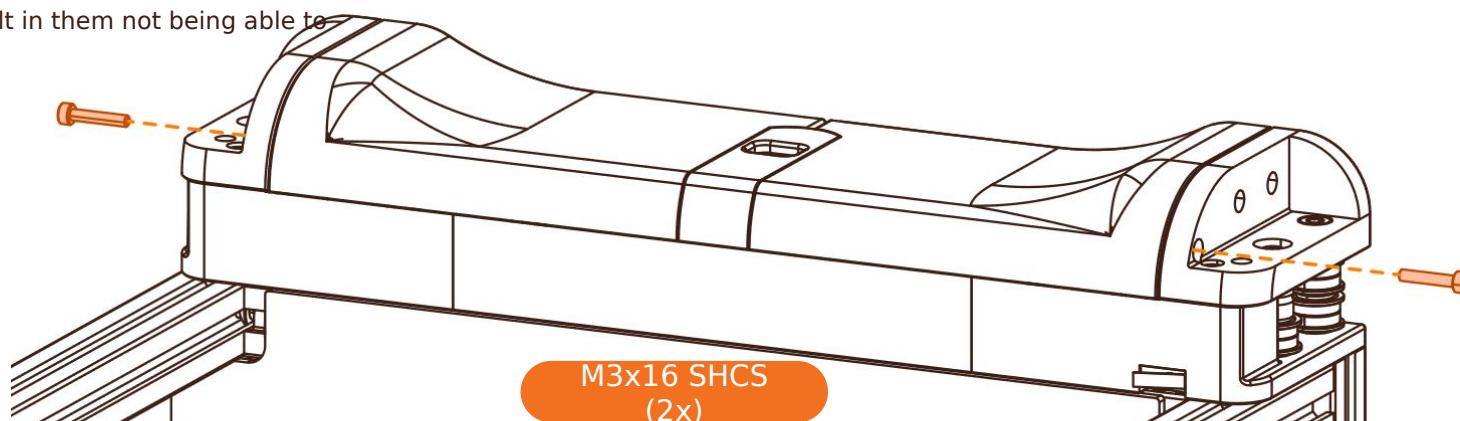
These two M3 screws will act as hinge points for the drive covers. The screws thread directly into the cover.

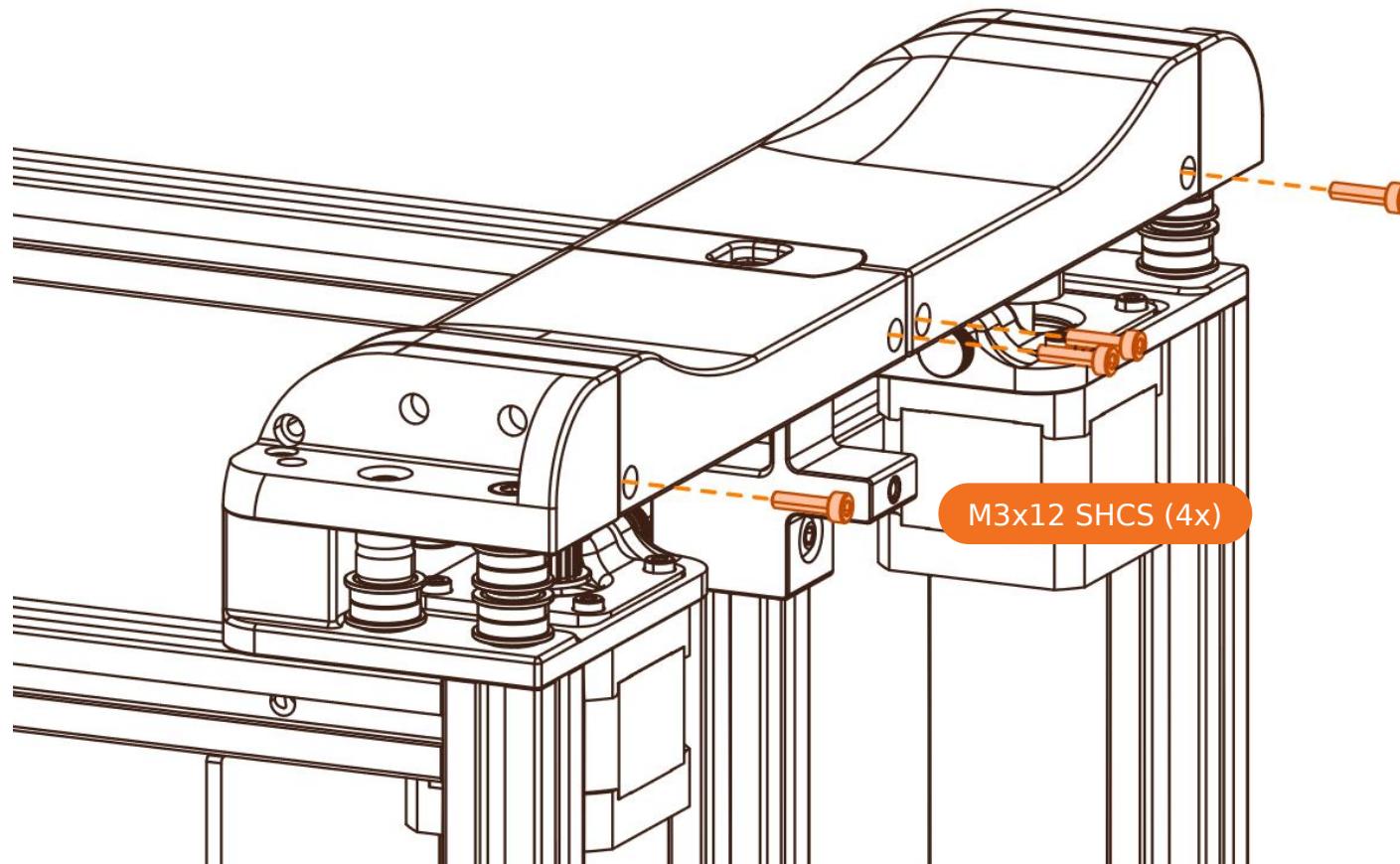
Tighten fully; they're likely to make noise while being tightened. Continue until the screw head is flush with the print surface.



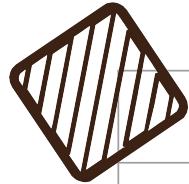
**HANG LOOSE**

Leave the M3x16 screws loose enough that the hinge of the Drive cover can still pivot. Tightening them too well will result in them not being able to hinge.

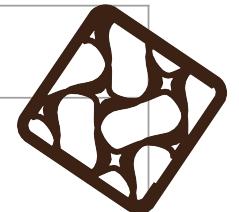


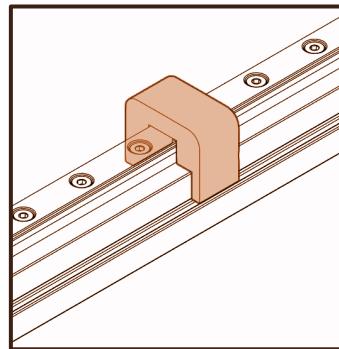
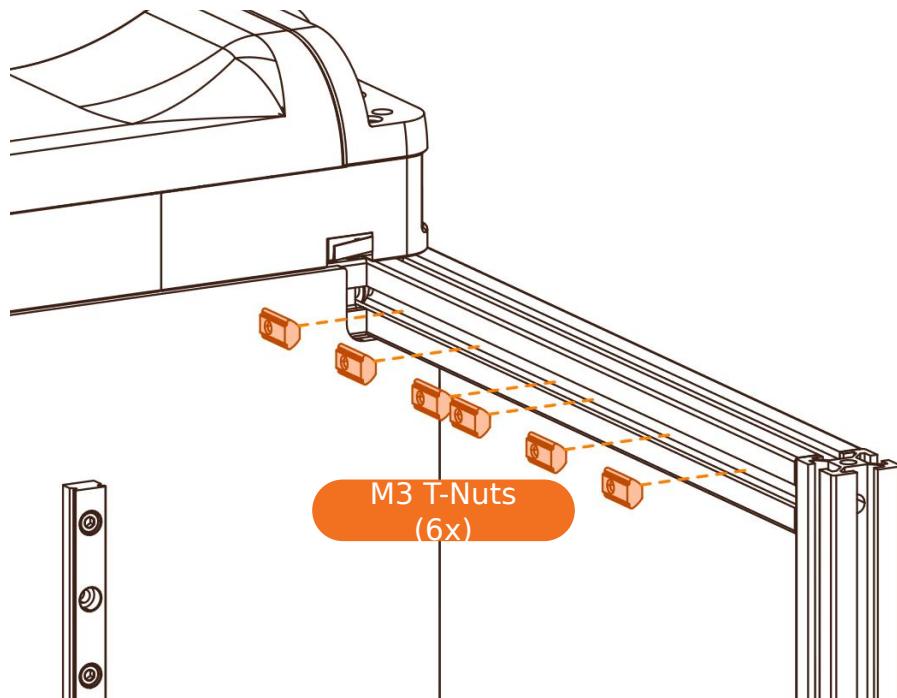






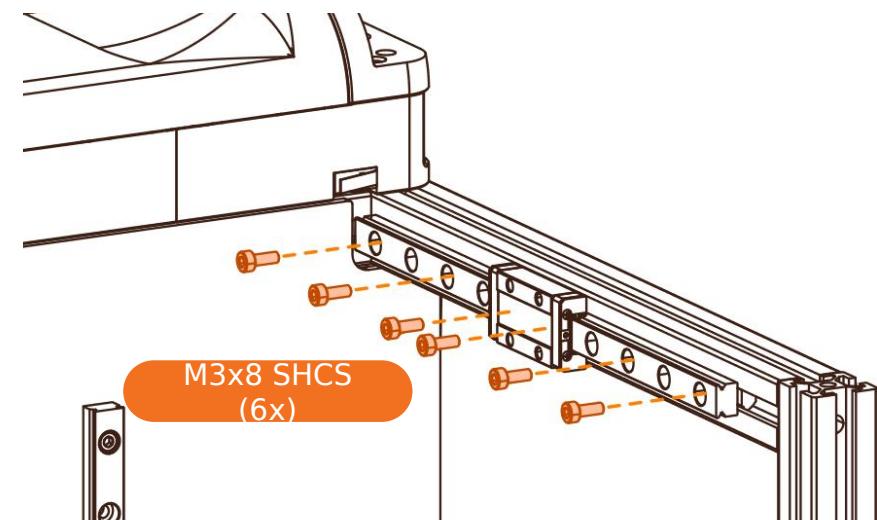
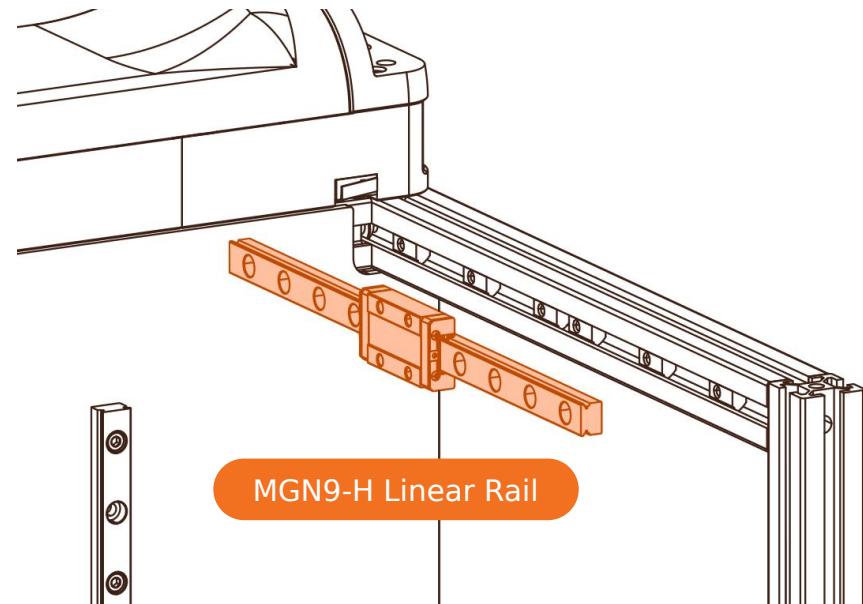
<b>Difficulty</b>	Medium			
<b>Tools Needed</b>	M3 Driver			
<b>Hardware Needed</b>	M3 T-Nuts (12x) M3x8 SHCS (12x) MGN-H Linear Rail (2x)			
<b>Printed Parts Needed</b>	MGN9 Rail Guide (2x)			

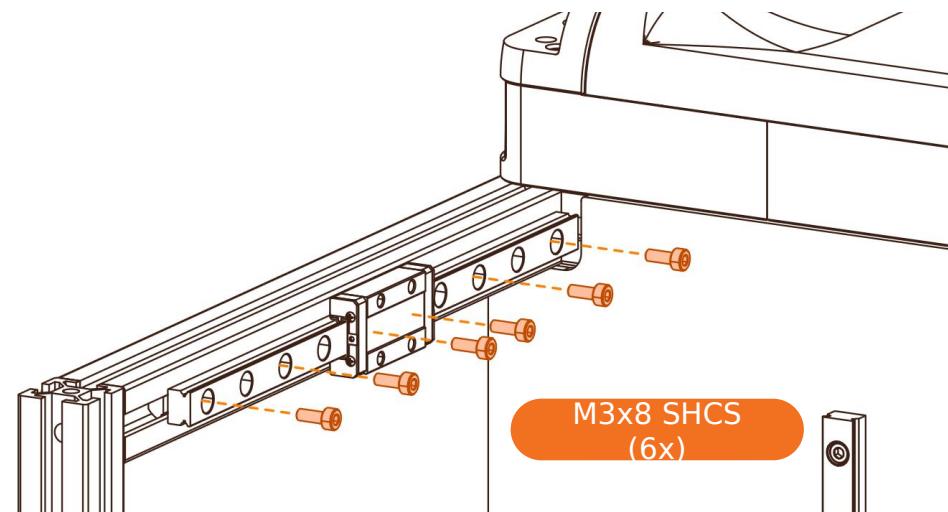
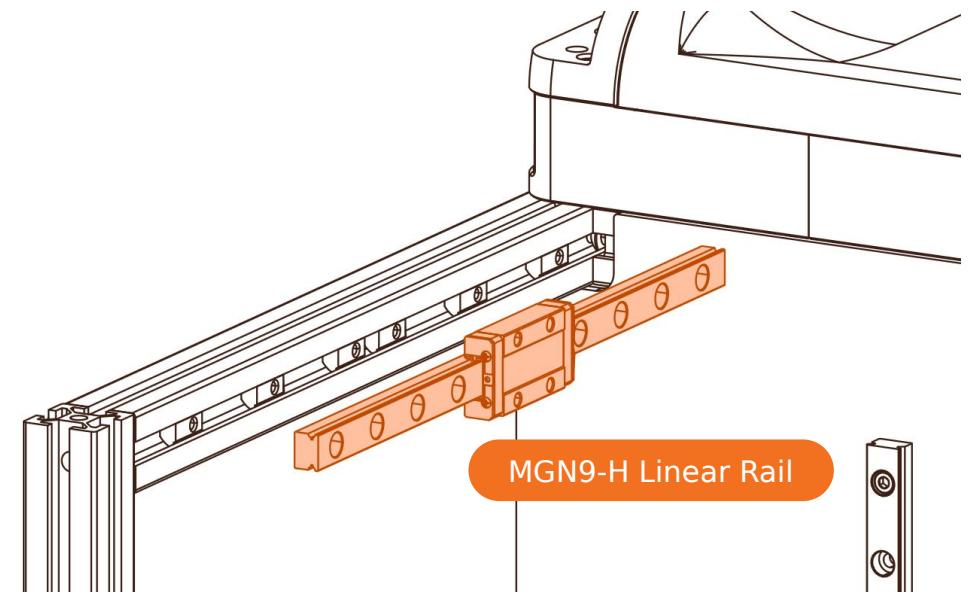
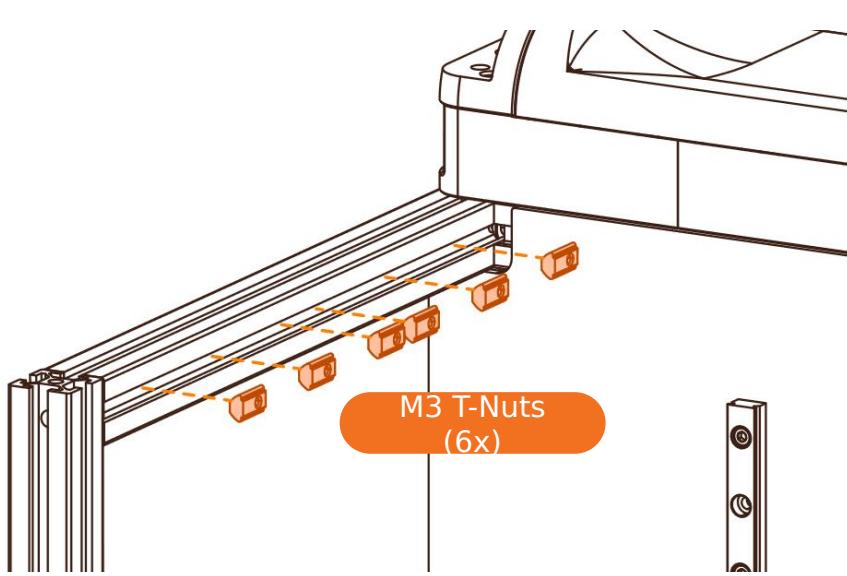


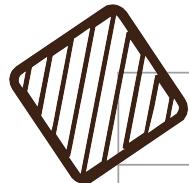


#### RAIL INSTALLATION GUIDES

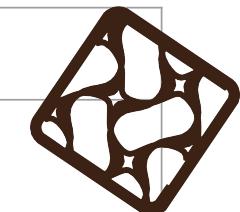
Use the guides to position the rail in the center of the extrusion prior to fastening the screws.

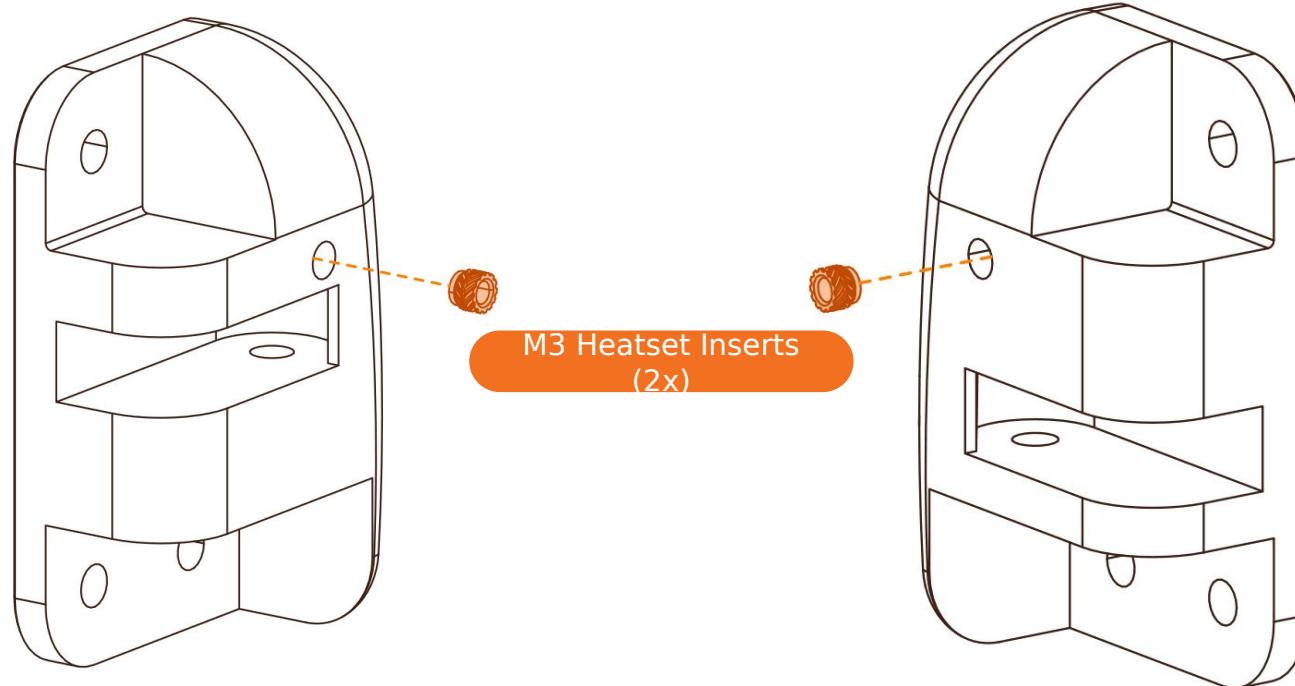


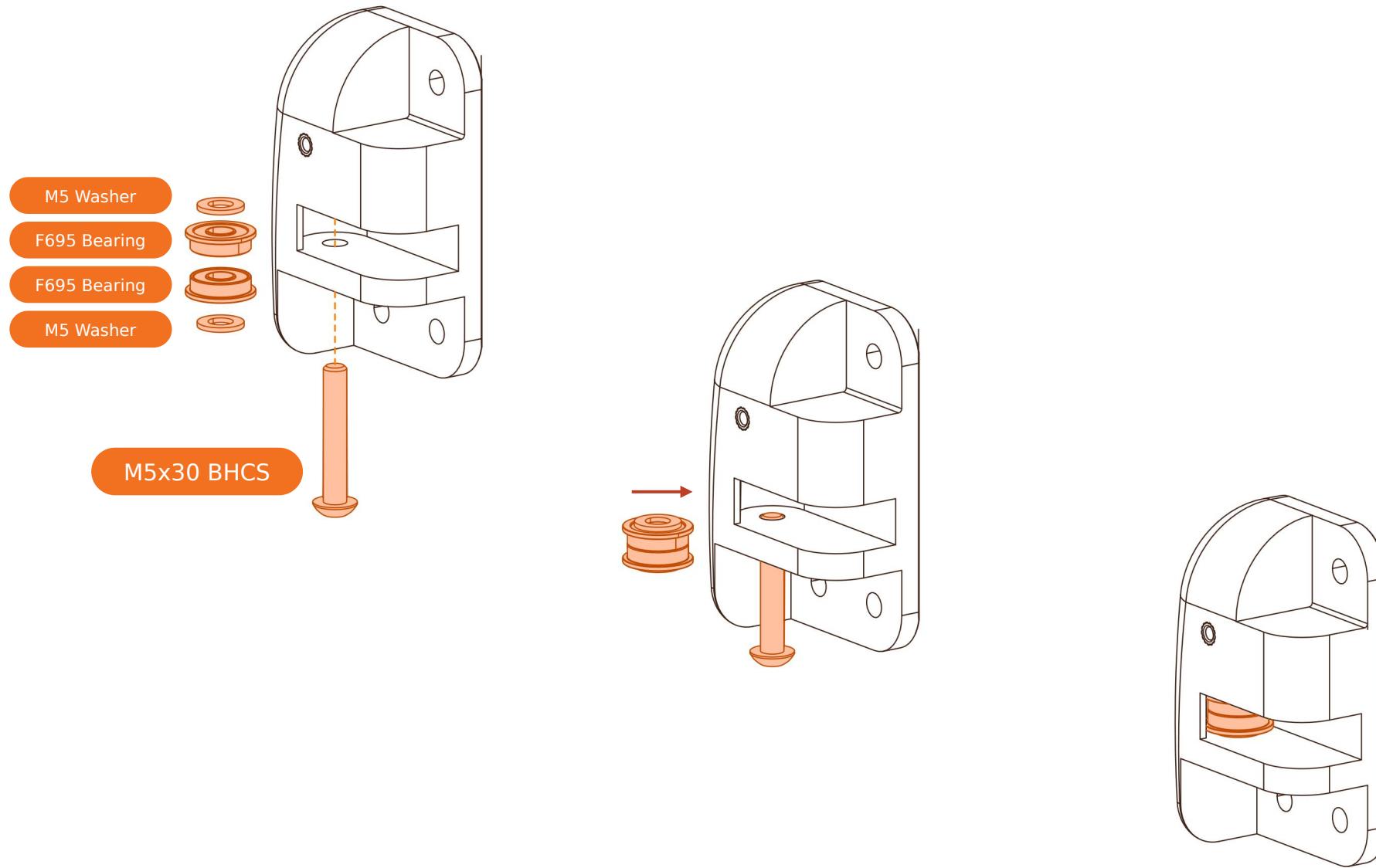


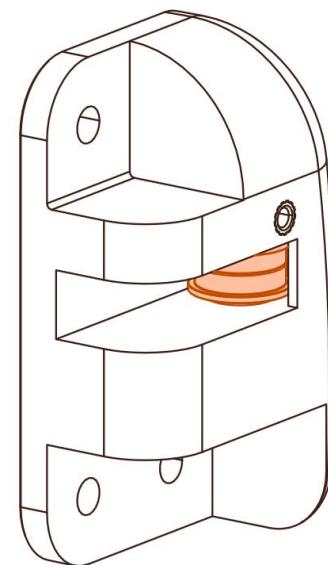
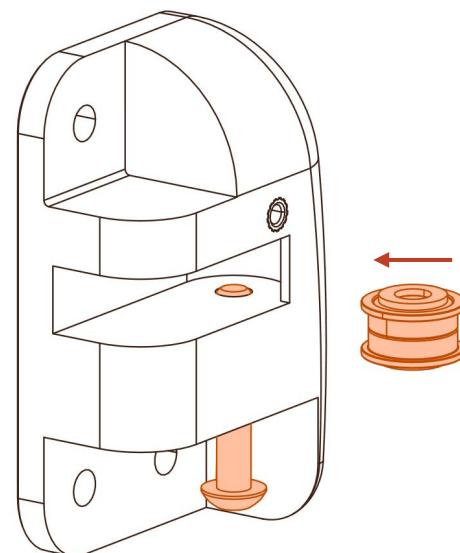
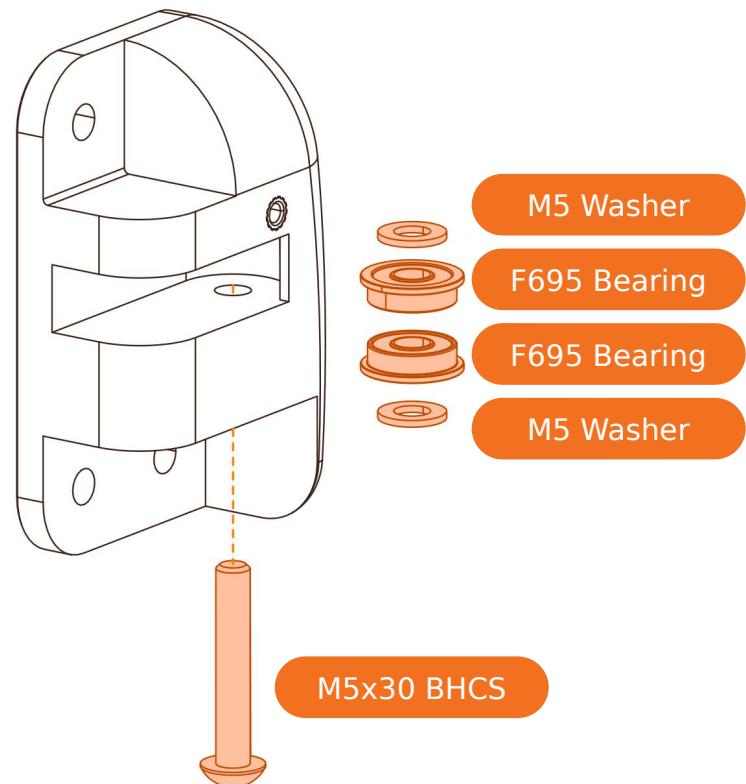


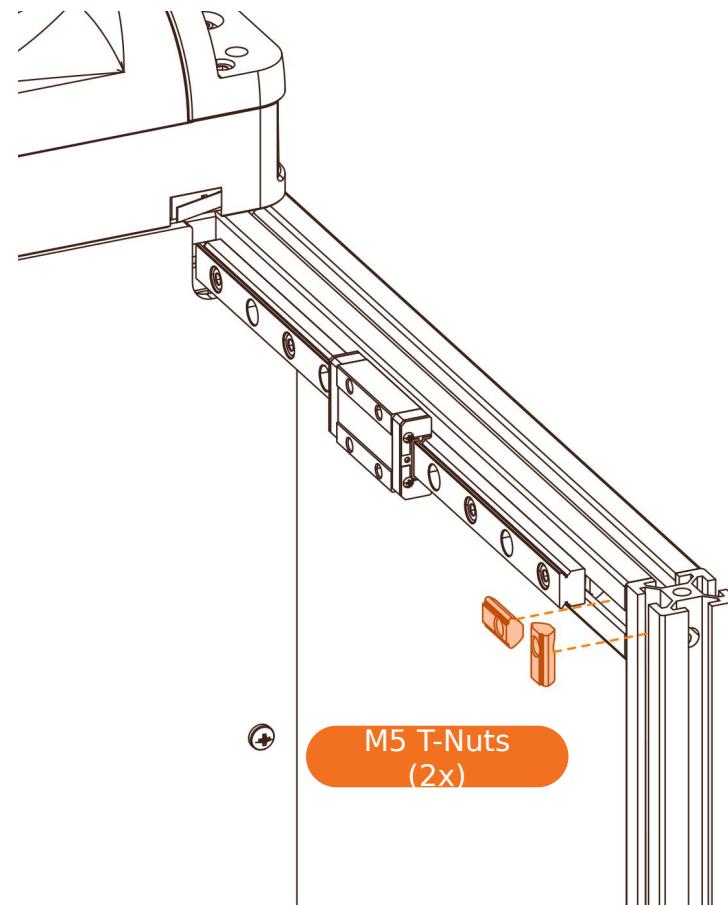
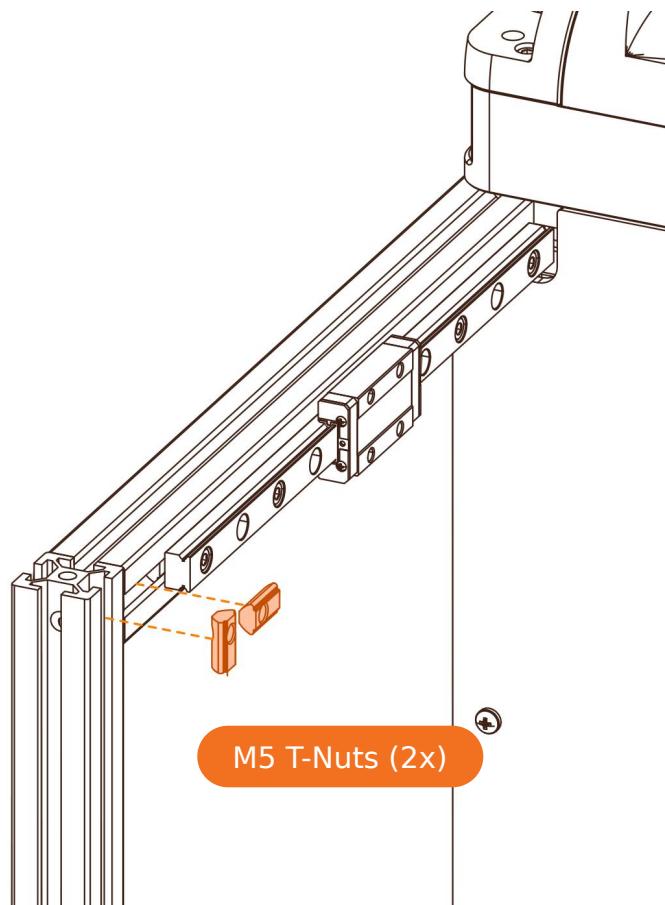
<b>Difficulty</b>	Medium		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M3 Heatset Inserts (4x) M5 Washer (4x) F695 Bearing (4x) M5x30 Button Head Cap Screw (2x)		M5 T-Nuts (4x) M5x10 Button Head Cap Screw (4x)
<b>Printed Parts Needed</b>	Front Idler Left (1x) Front Idler Right (1x)		

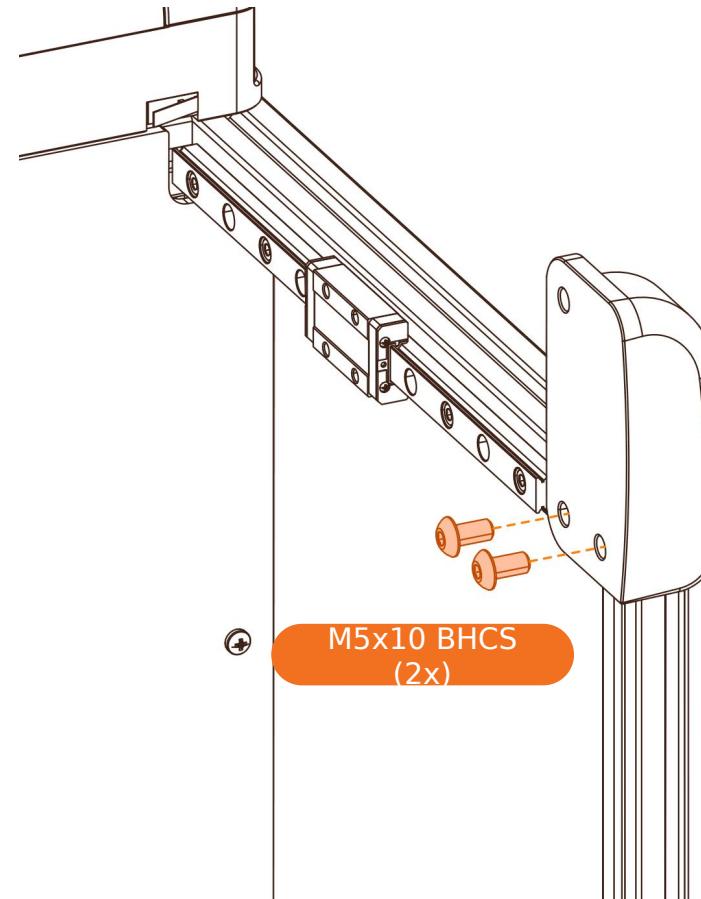
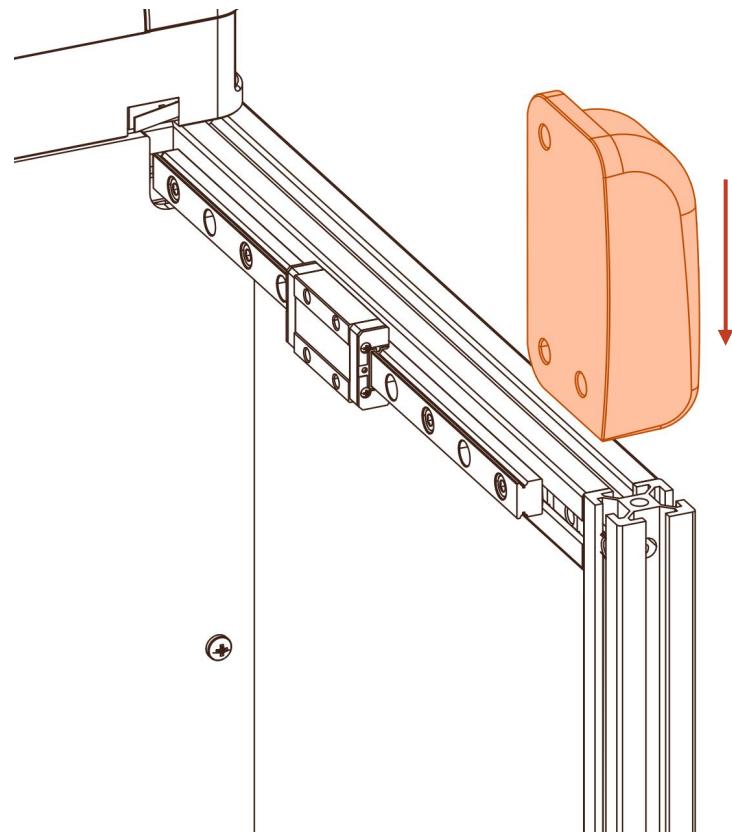


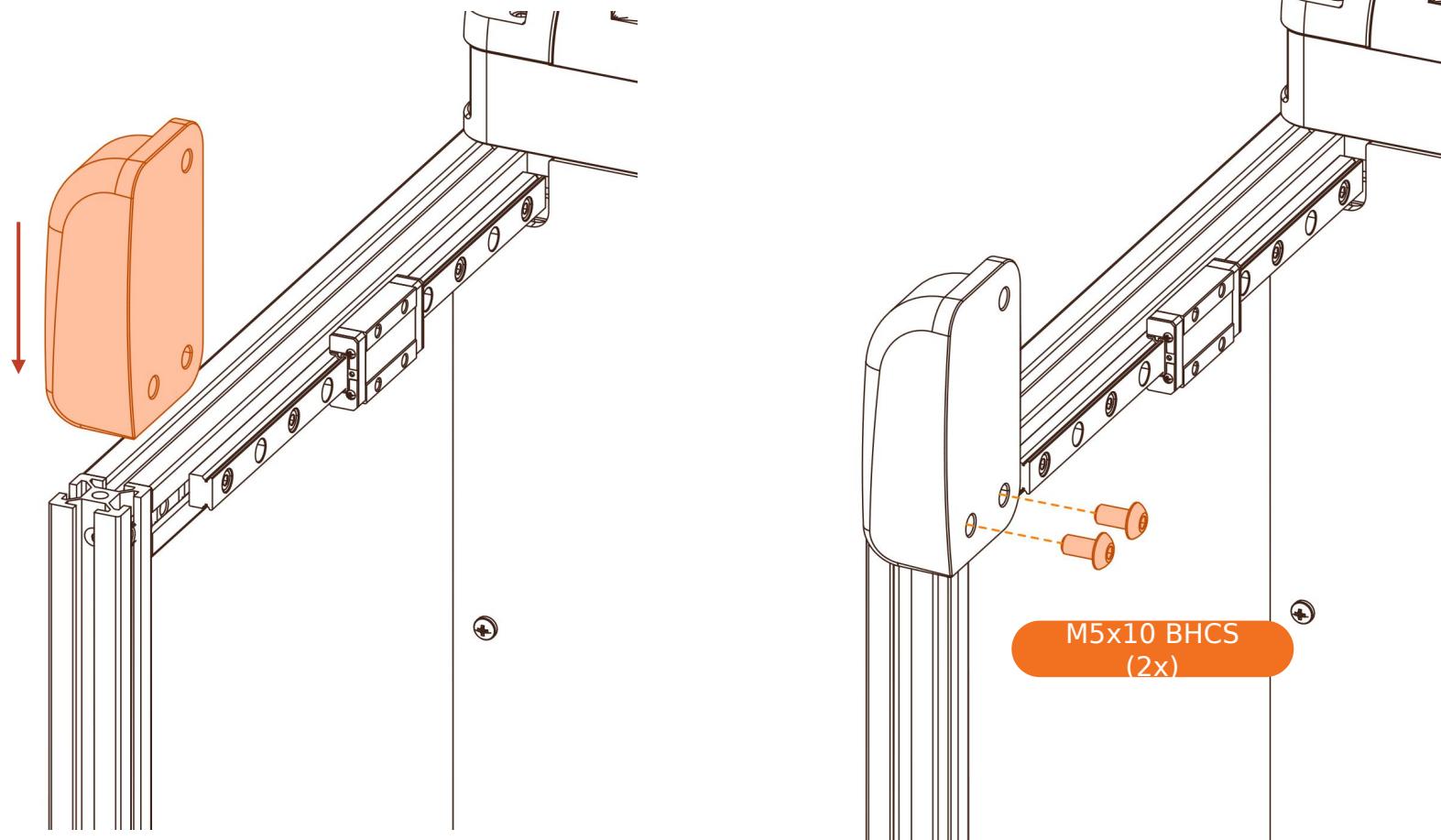


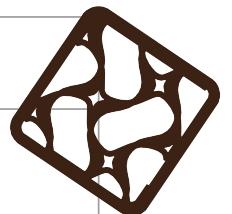
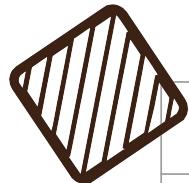




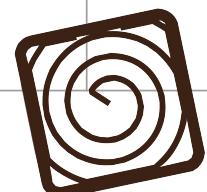


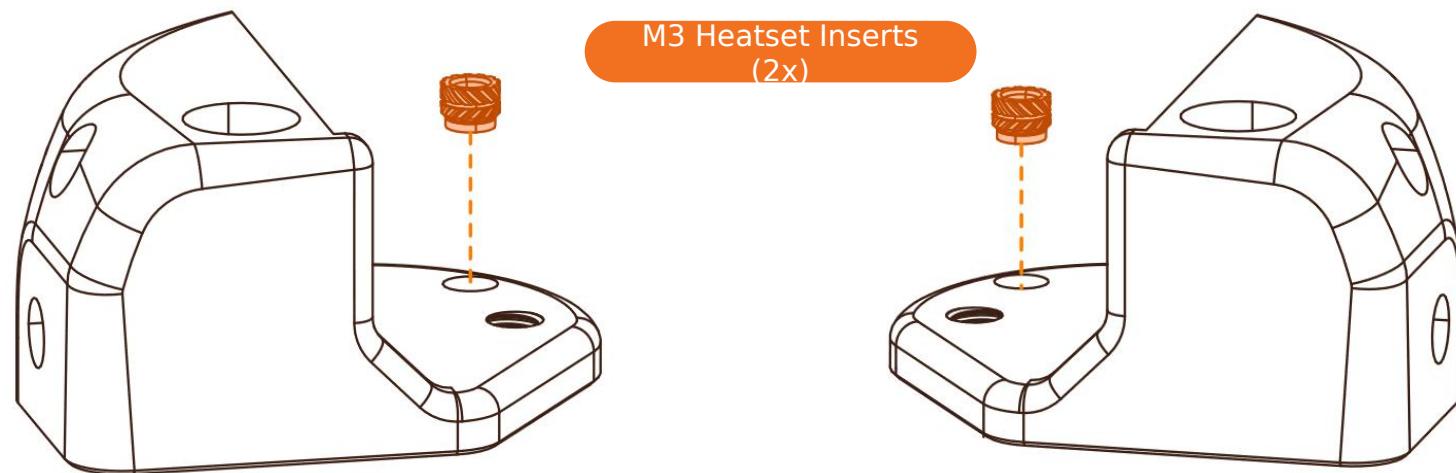






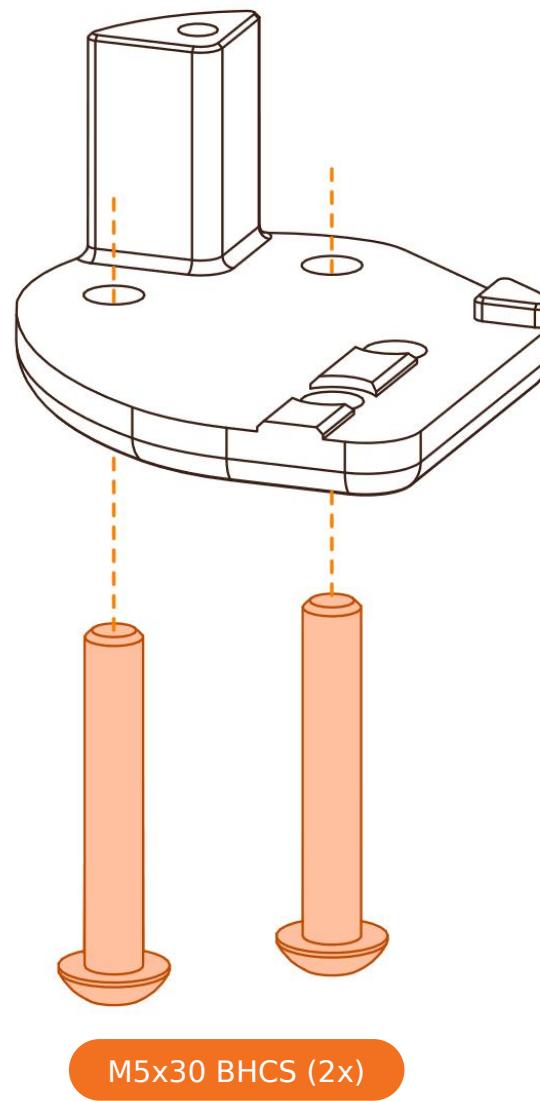
<b>Difficulty</b>	Medium
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)
<b>Hardware Needed</b>	M3 Heatset Inserts (2x) M5x30 Button Head Cap Screw (2x) F695 Bearings (4x) M5 Washers (4x) M3x30 Socket Head Cap Screw (1x)
<b>Printed Parts Needed</b>	XY Lower Left (1x) XY Upper Left (1x) Printed Spacer (2x)



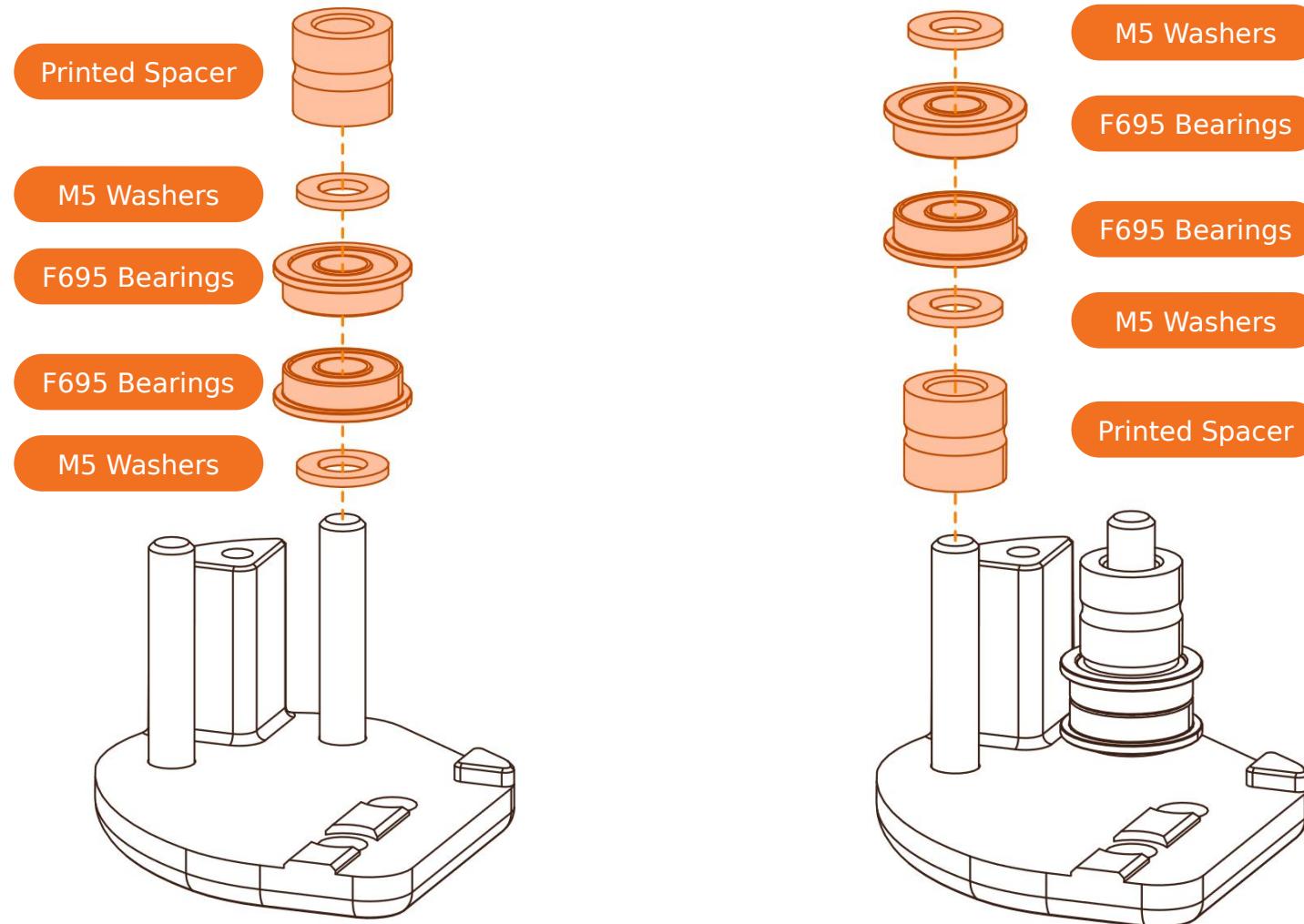


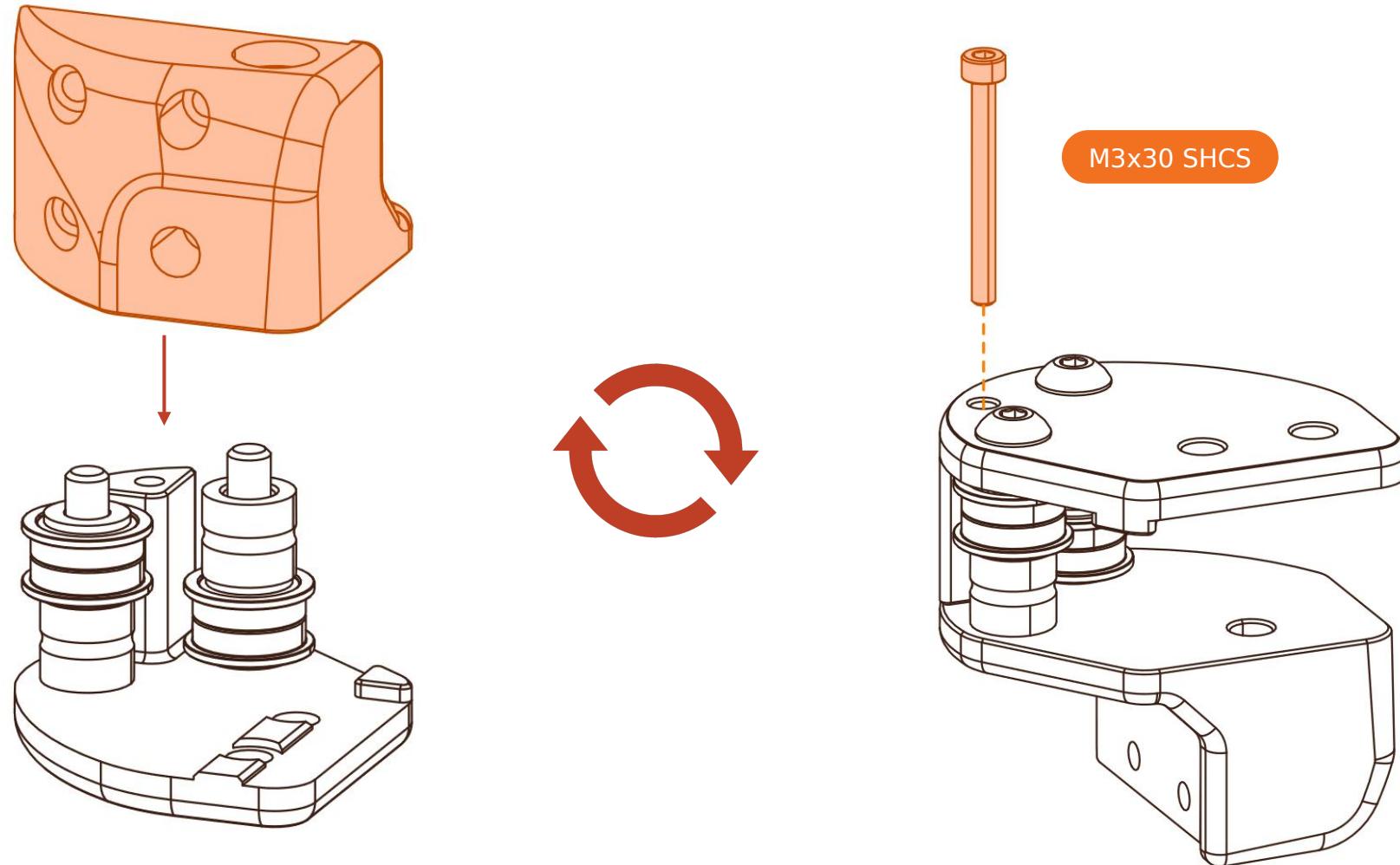
**MIRROR MIRROR ON THE WALL...**

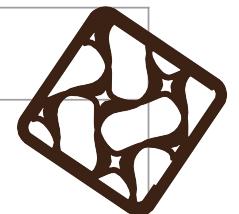
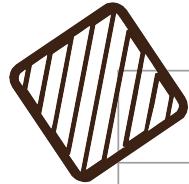
The X/Y joints use similar, *but not identical*, mirrored parts. Be sure to closely match the printed part you are using to the picture to ensure you are assembling the correct joint.



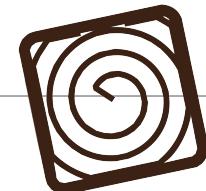
M5x30 BHCS (2x)





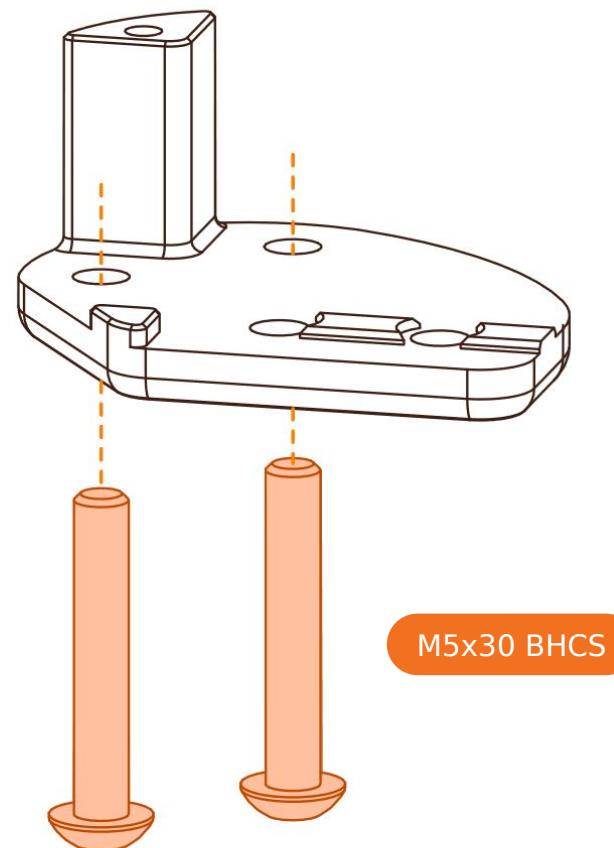


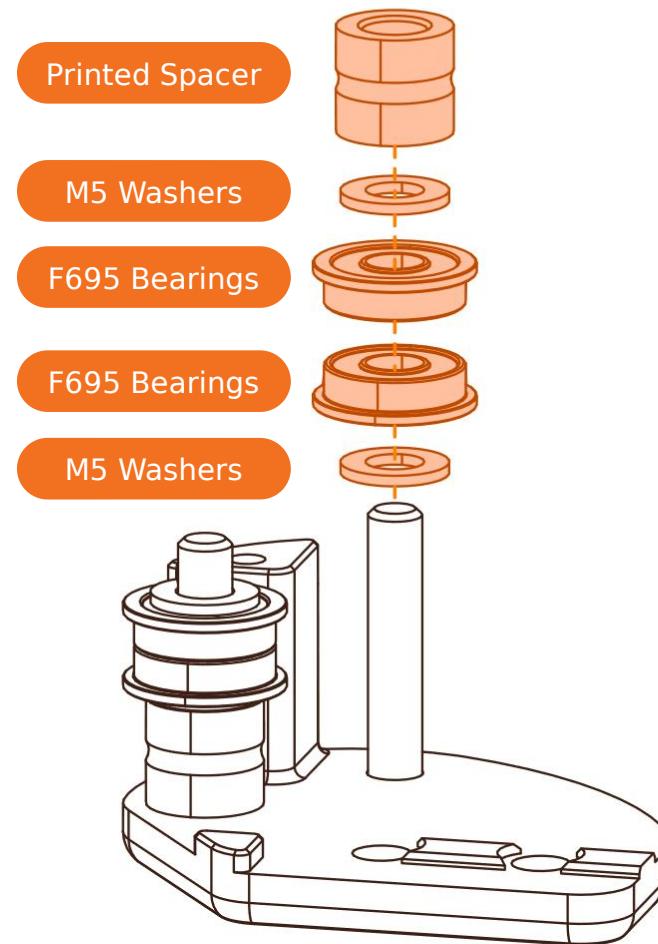
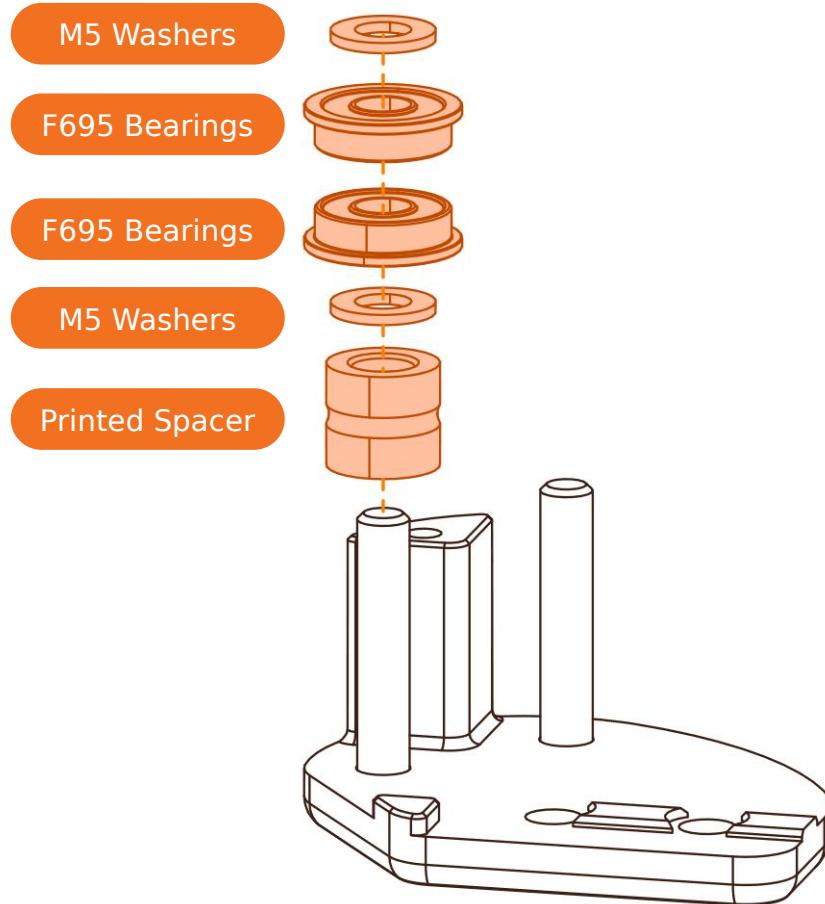
<b>Difficulty</b>	Medium		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M5x30 Button Head Cap Screw (2x) F695 Bearings (4x) M5 Washers (4x) M3x30 Socket Head Cap Screw (1x)		
<b>Printed Parts Needed</b>	XY Lower Left (1x) XY Upper Left (1x) Printed Spacer (2x)		

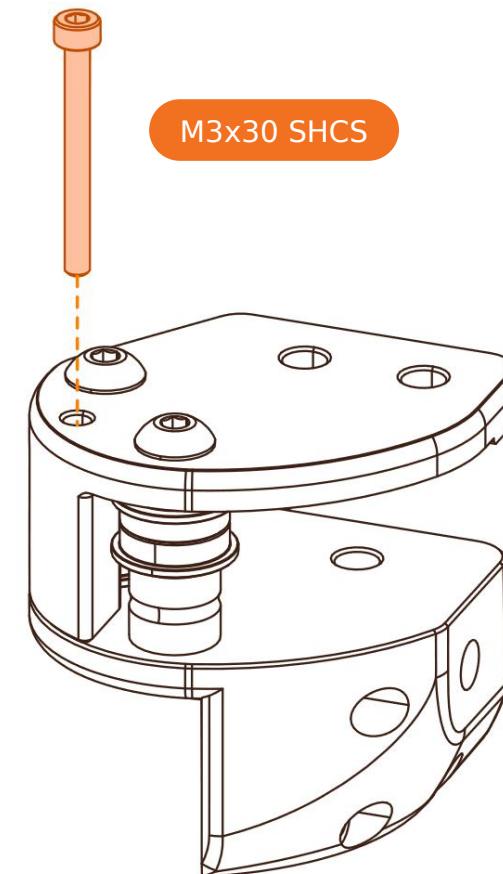
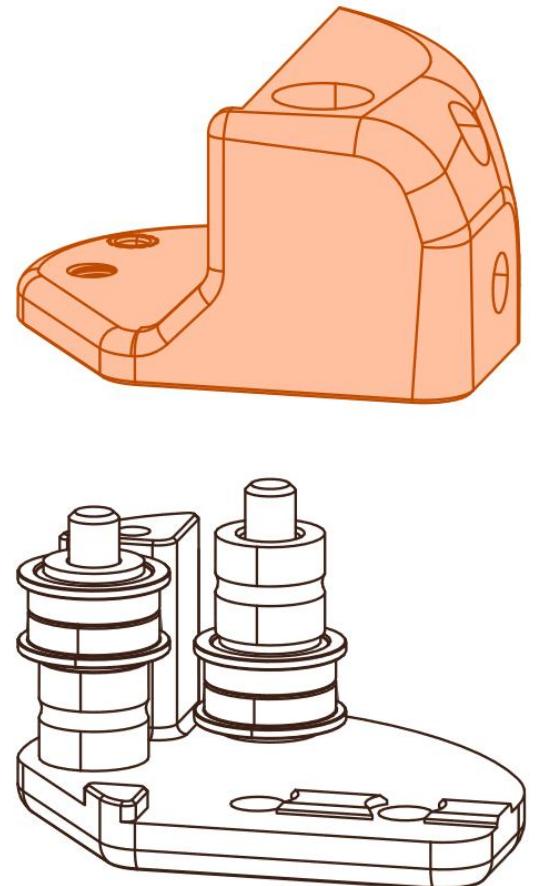


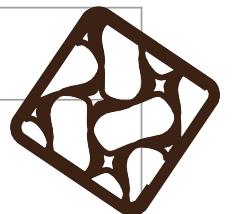
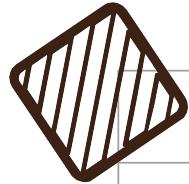
**...WHO IS THE FAIREST OF THEM ALL**

The X/Y joints use similar, but not the same, parts. Closely match the printed part you are using to the picture to ensure you are assembling the correct joint.

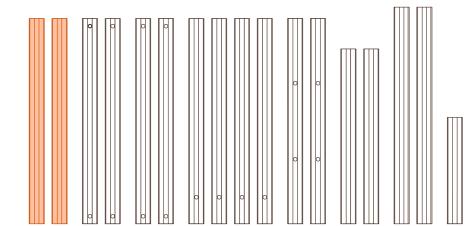
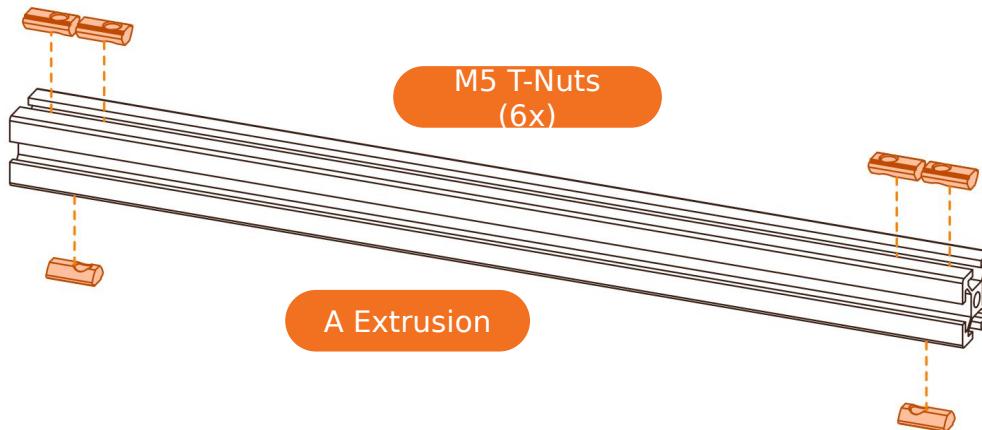
**M5x30 BHCS**





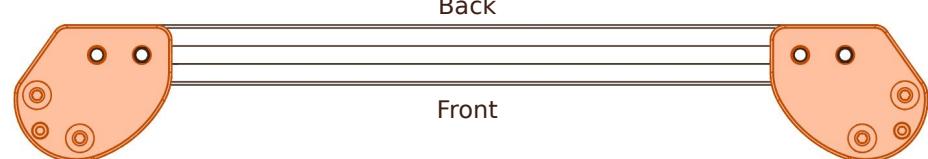
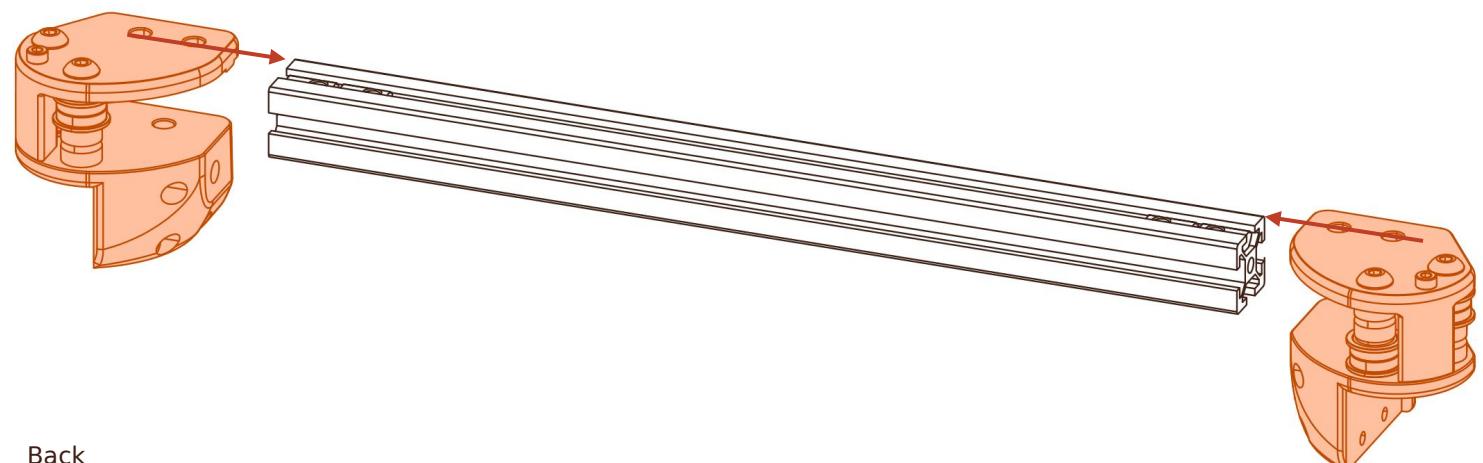


<b>Difficulty</b>	Easy		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver Heatset Insert Tool Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M5x10 Button Head Cap Screw (4x) M5x30 Button Head Cap Screw (2x) M3x8 Socket Head Cap Screw (10x) M3x16 Socket Head Cap Screw (8x)		M5 T-Nuts (6x) M3 T-Nuts (10x)
<b>Printed Parts Needed</b>	Rail Installation Guides (2x)		



#### WHEN WILL MY REFLECTION SHOW...

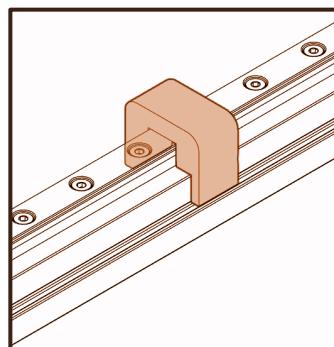
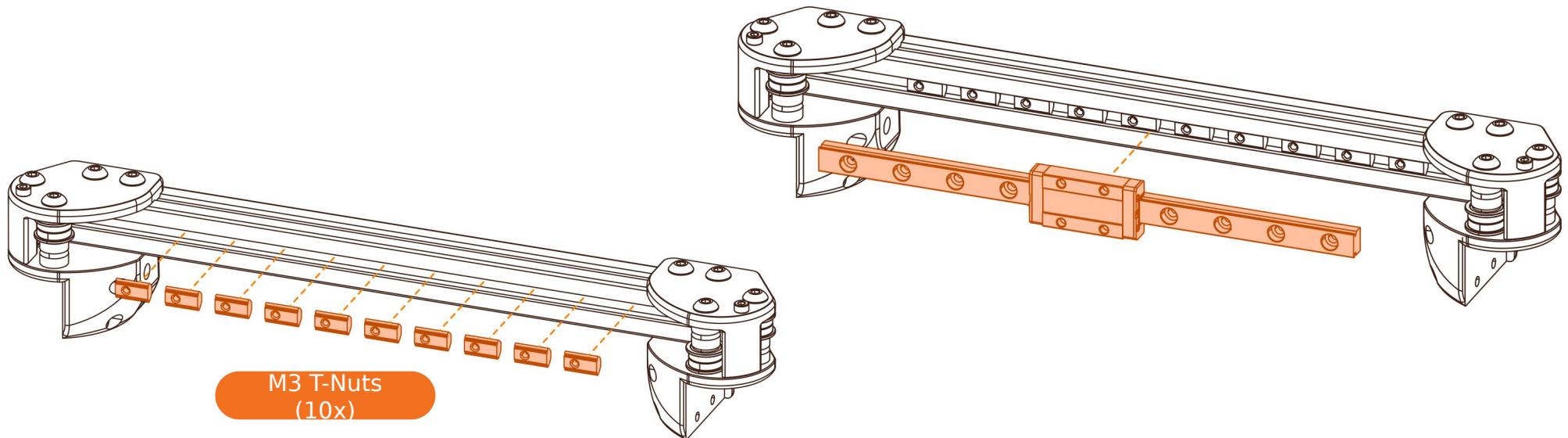
Double-check that your X/Y gantry joints follow the diagrams on this page accurately. Otherwise, a partial or full disassembly of the X/Y gantry may be required to resolve issues.



**NOT SO FAST**

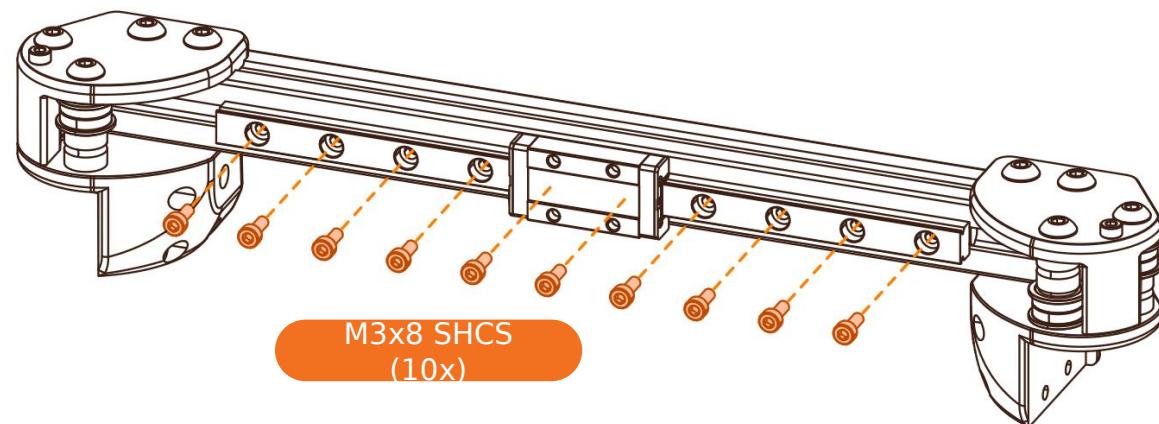
Leave these 6 screws loose for now. We will tighten them at a later step, when the gantry is installed in the machine.

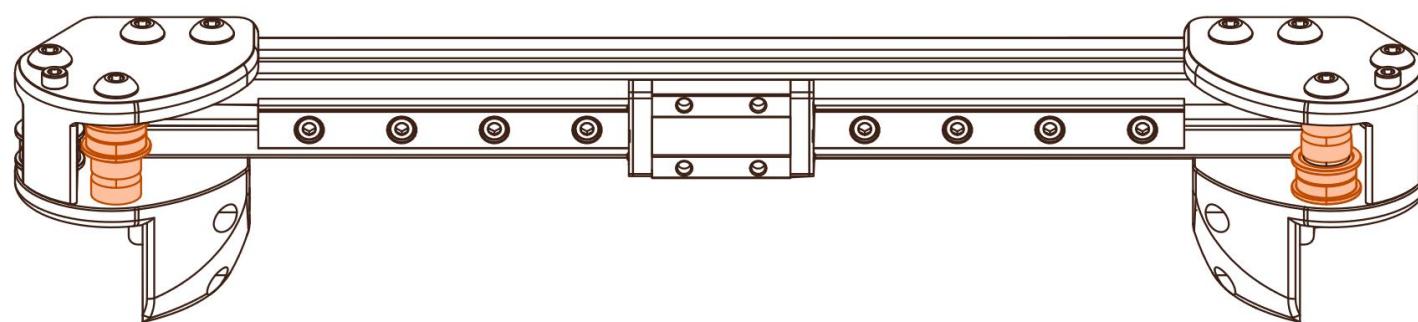




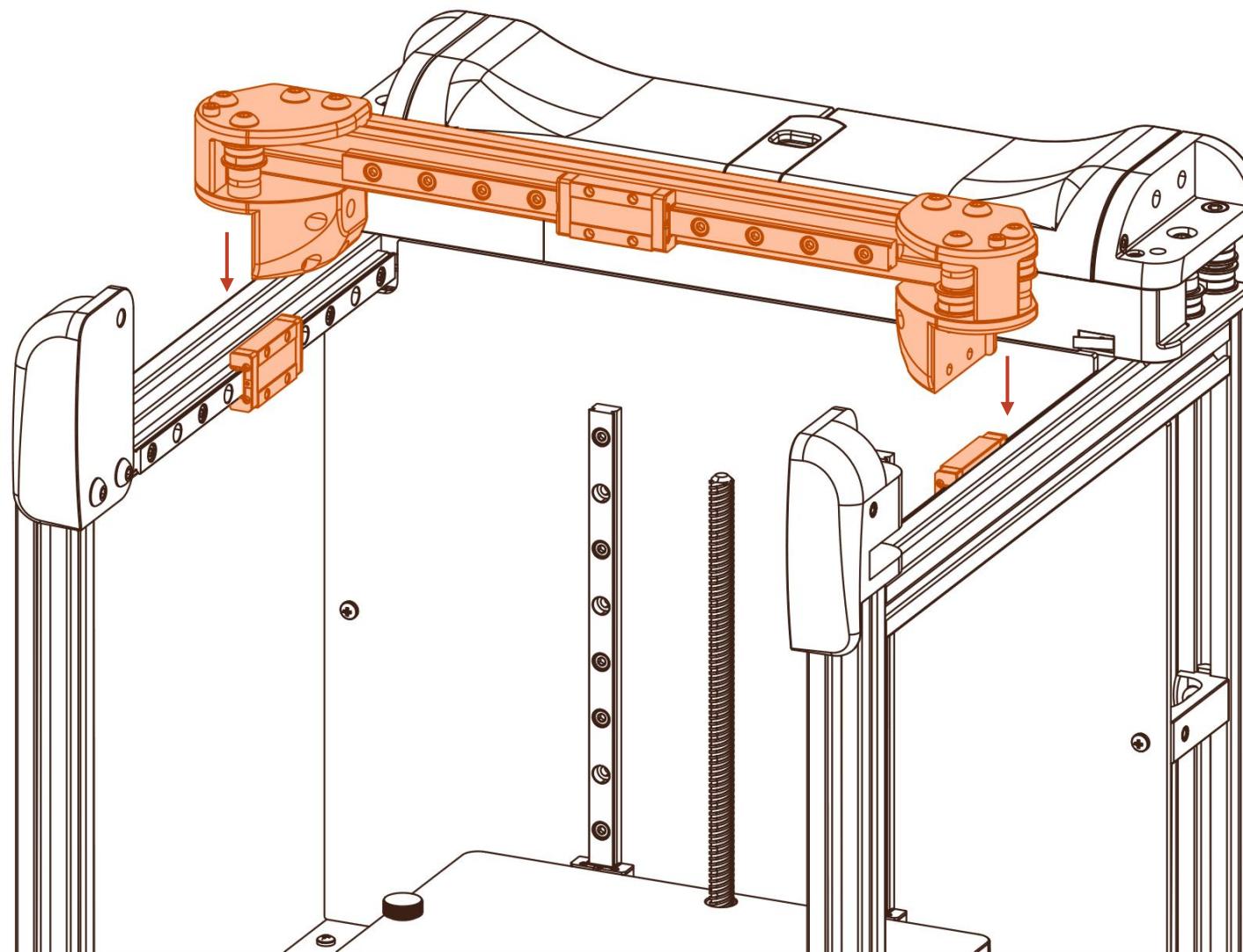
#### RAIL INSTALLATION GUIDES

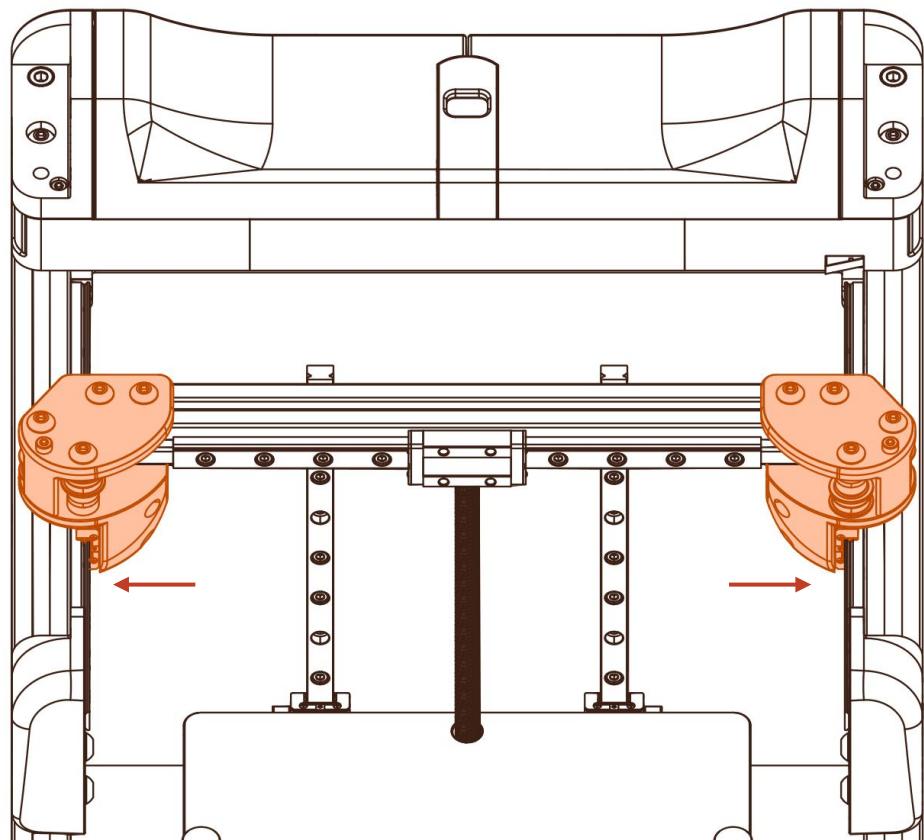
Use the guides to position the rail in the center of the extrusion prior to fastening the screws.



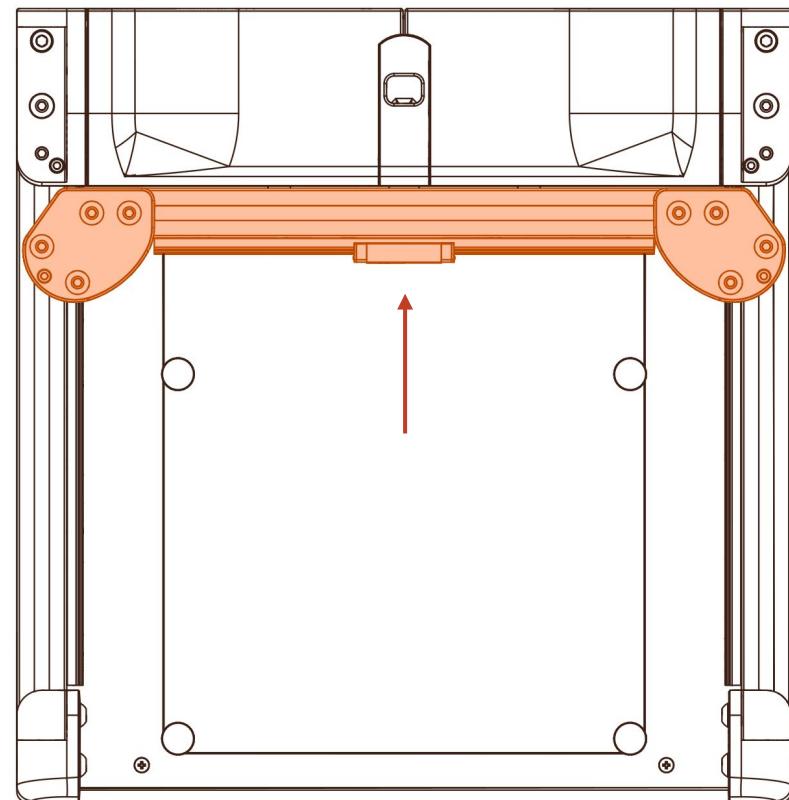
**TRUST BUT VERIFY**

Double check your work. The bearing positions should match the image above.

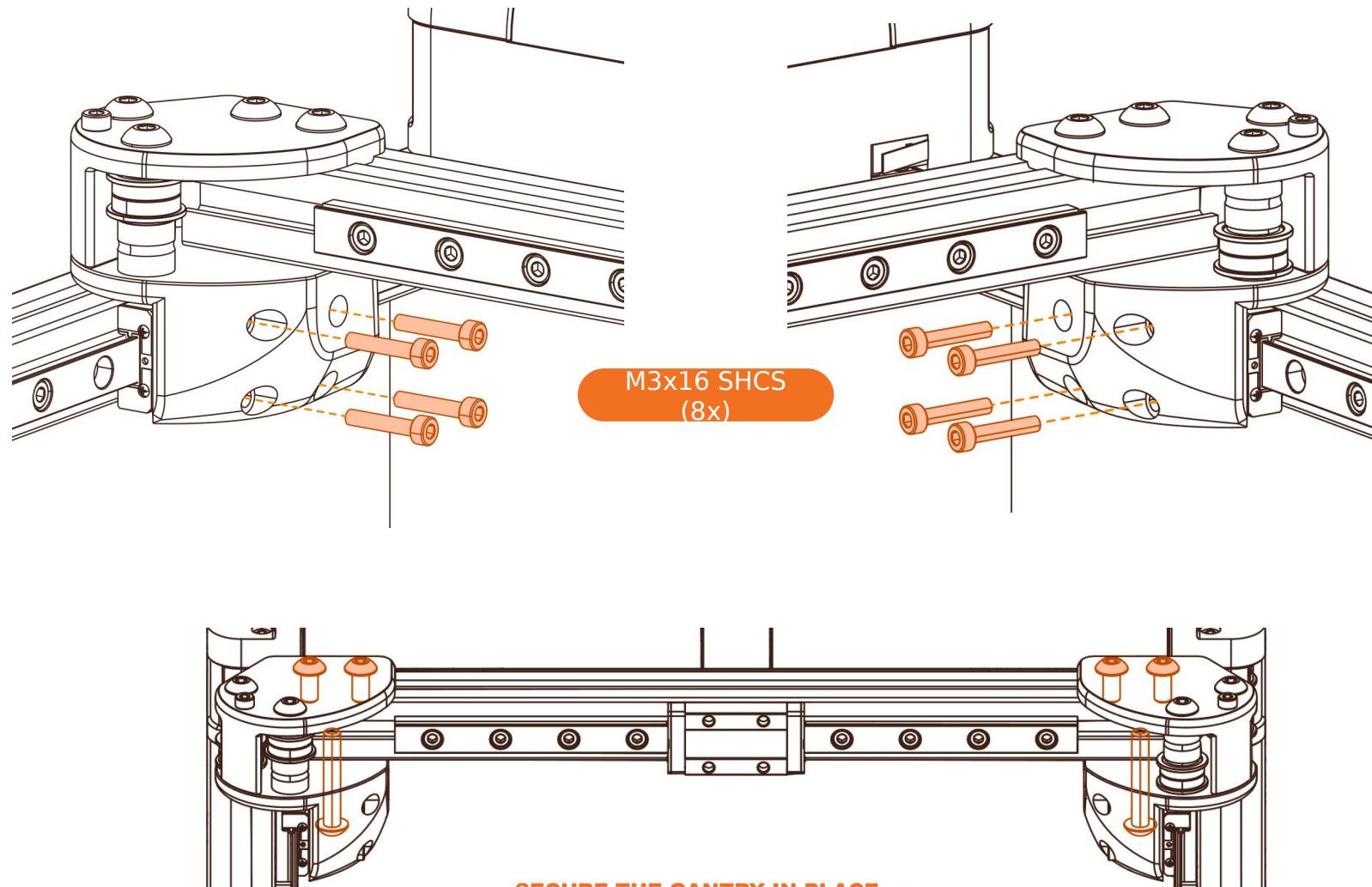


**GANTRY INSTALLATION**

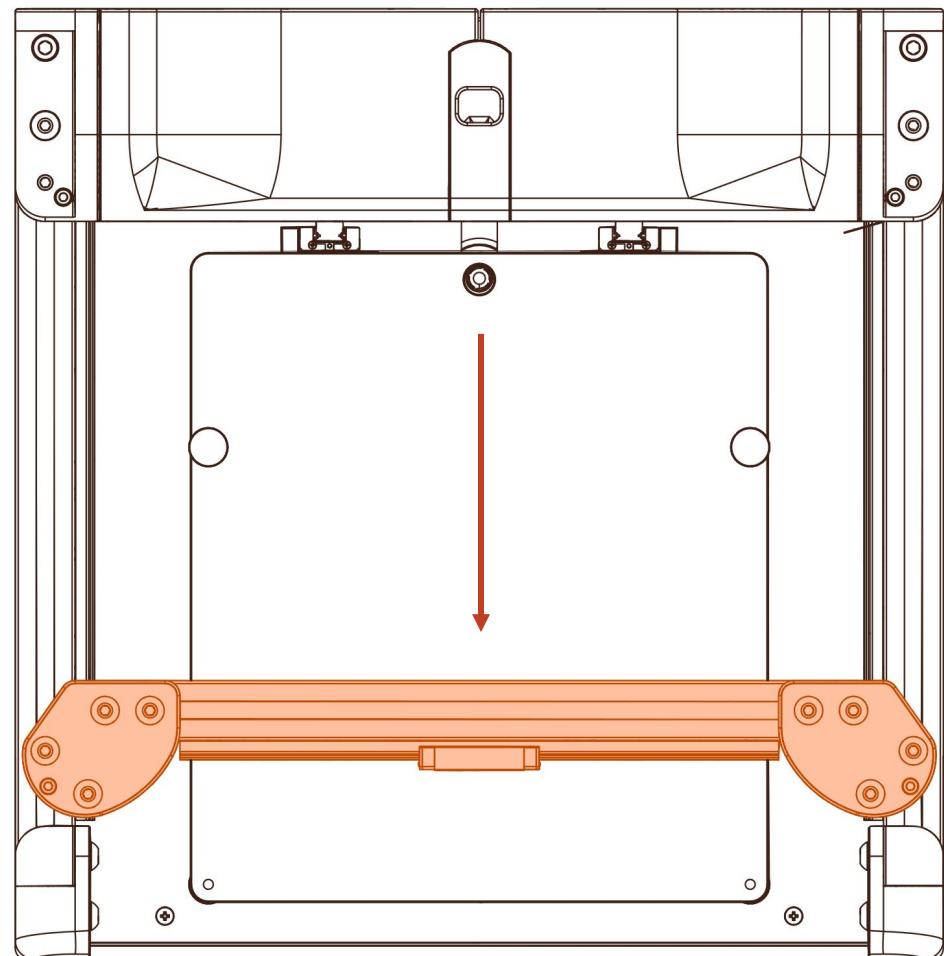
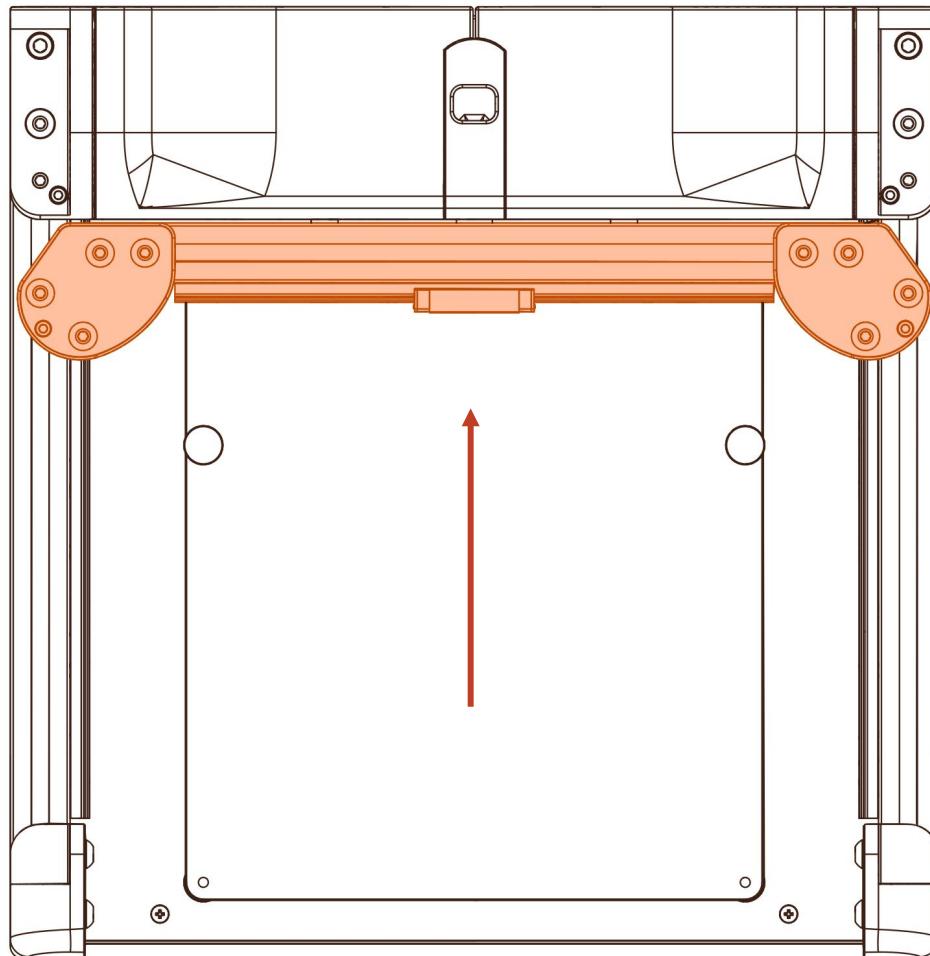
Press the X/Y joints outward so that they are flush with the Y carriages, then move the gantry all the way to the rear of the machine.

**CLICK CLICK!**

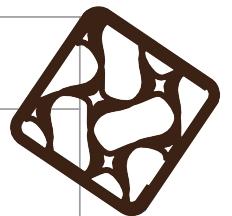
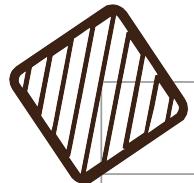
Make sure that when the gantry collides with the rear of the machine. The Y limit switch makes a quiet “click” noise.

**SECURE THE GANTRY IN PLACE**

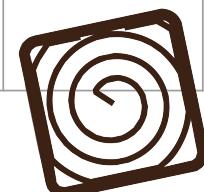
Now we can tighten the 6 screws we left loose earlier. This will complete the installation of the gantry.

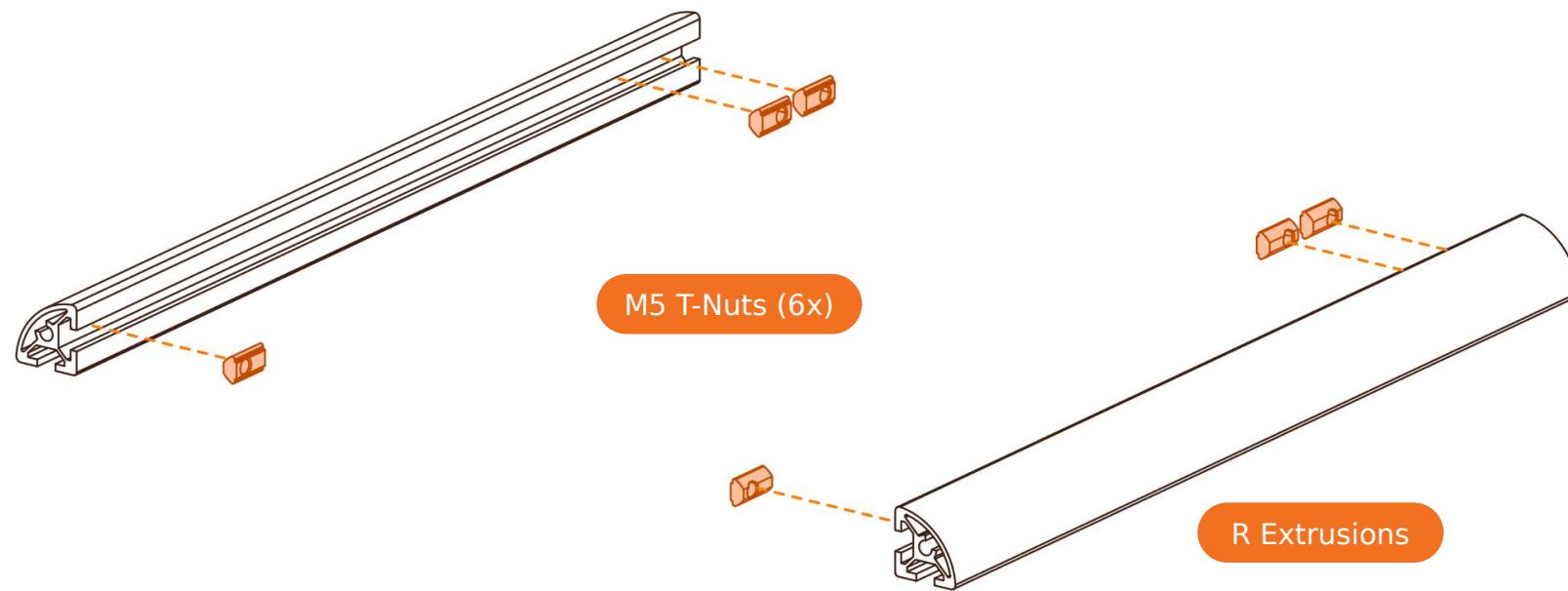
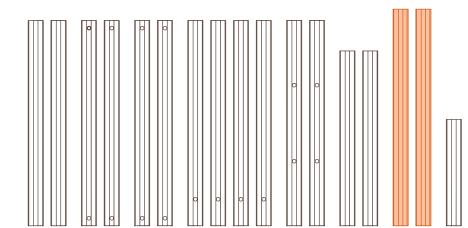
**TEST THE GANTRY MOTION**

Slide the gantry back and forth to ensure that it has smooth consistent motion along its entire travel distance. Listen to verify the Y limit switch makes a quiet “click” noise when the gantry is at the back of the machine.



<b>Difficulty</b>	Easy
<b>Tools Needed</b>	M3 Driver M5 Driver
<b>Hardware Needed</b>	R Extrusions (2x) M5 T-Nuts (6x) M5x10 Button Head Cap Screw (6x)
<b>Printed Parts Needed</b>	None

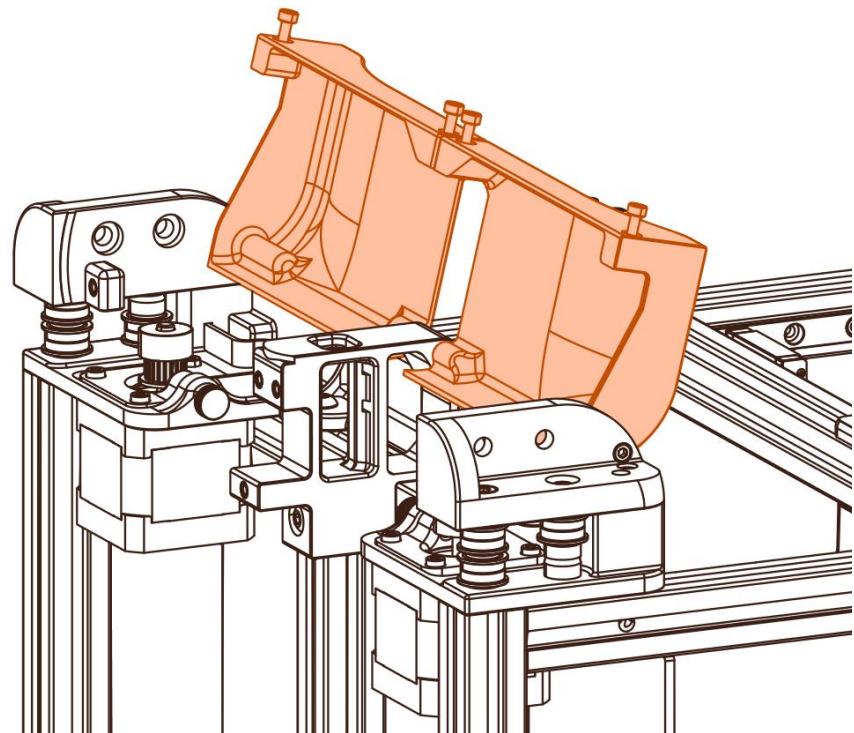
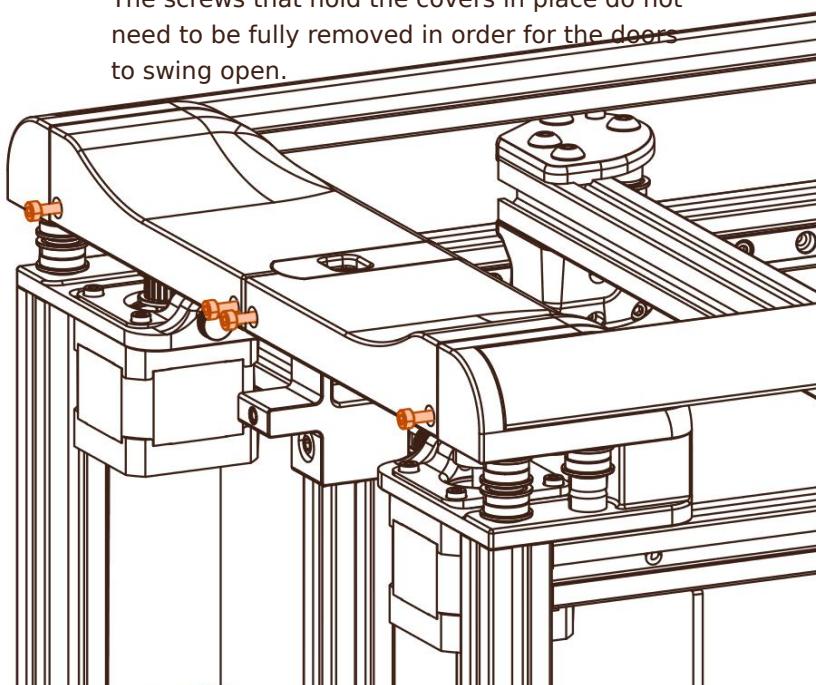


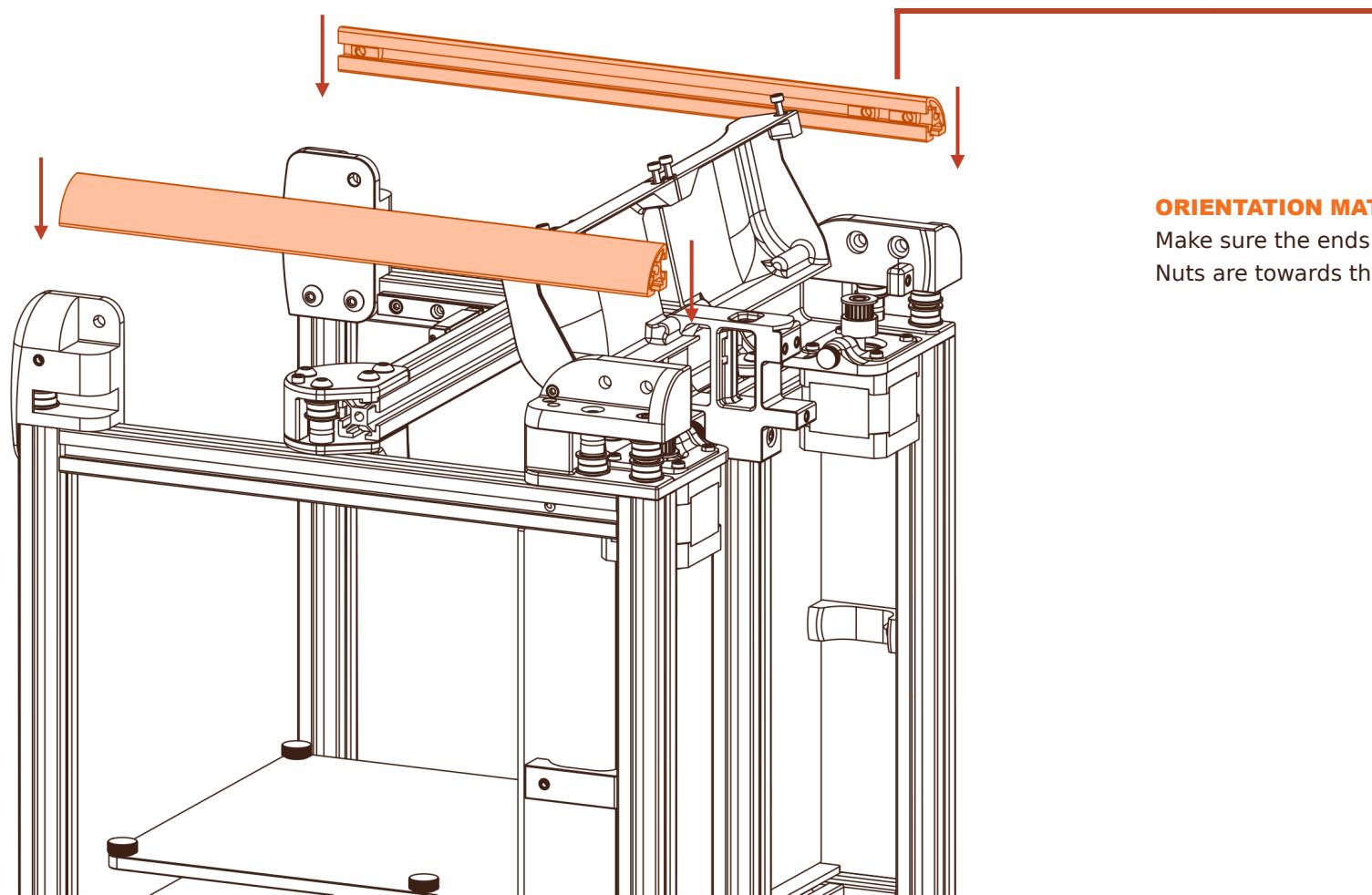


**ACCESS TO THE GOODS**

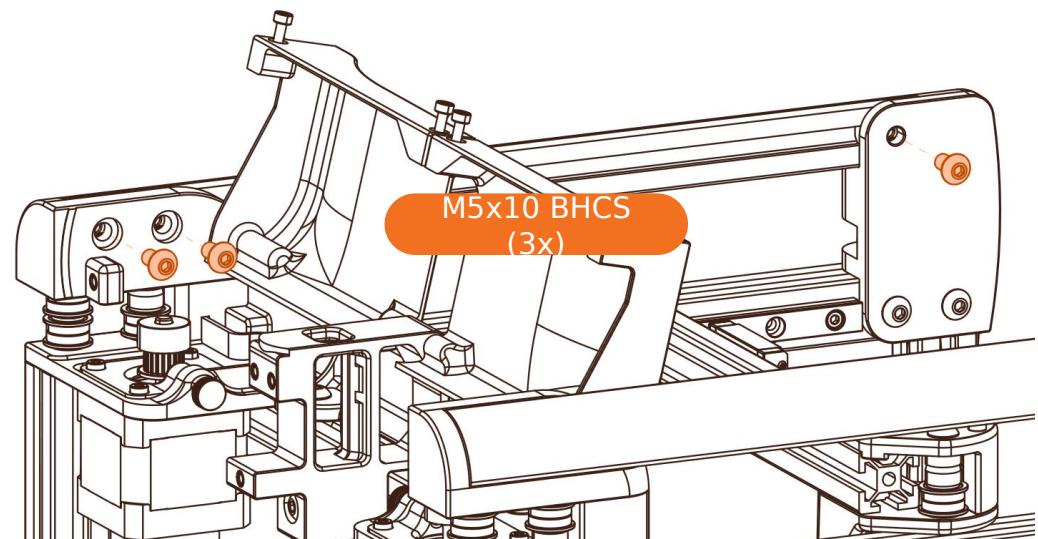
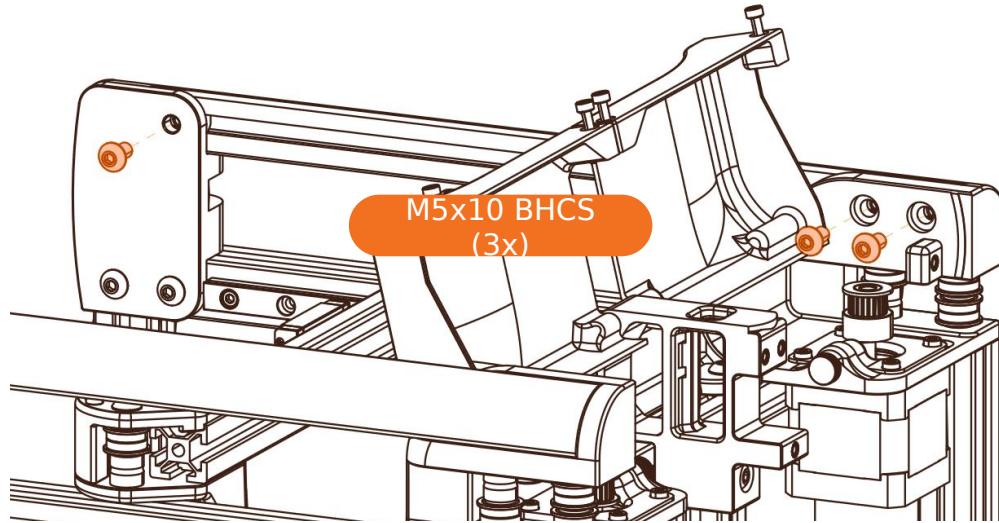
Open the Drive covers, as we will need access to some of the holes in the drive units for the next steps.

The screws that hold the covers in place do not need to be fully removed in order for the doors to swing open.

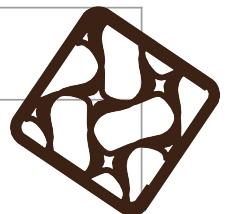
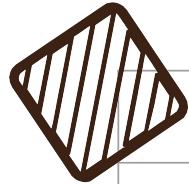


**ORIENTATION MATTERS**

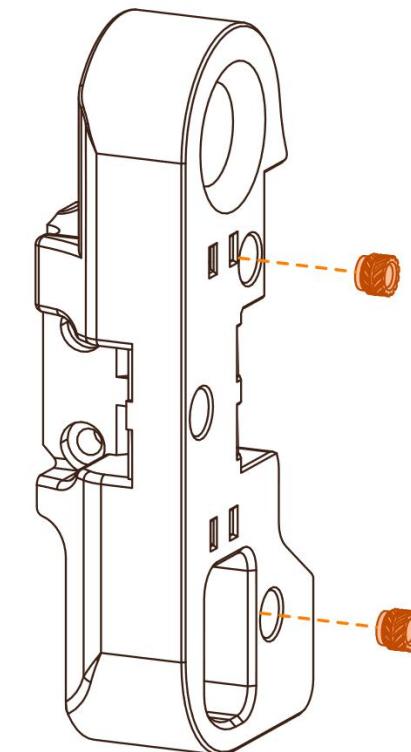
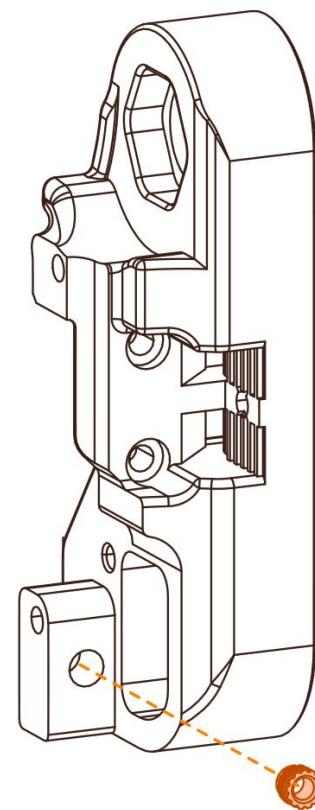
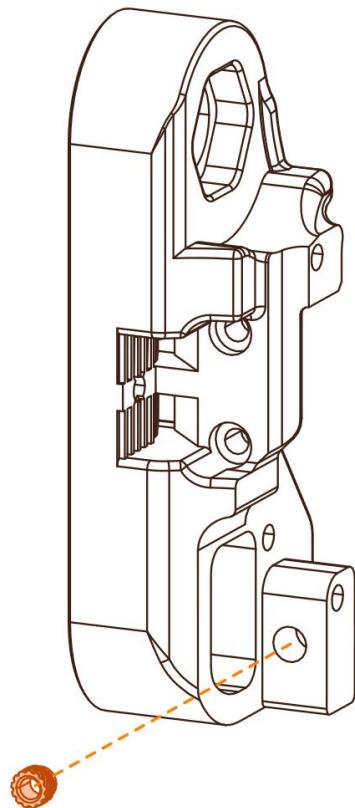
Make sure the ends with two preloaded T-Nuts are towards the rear of the machine.



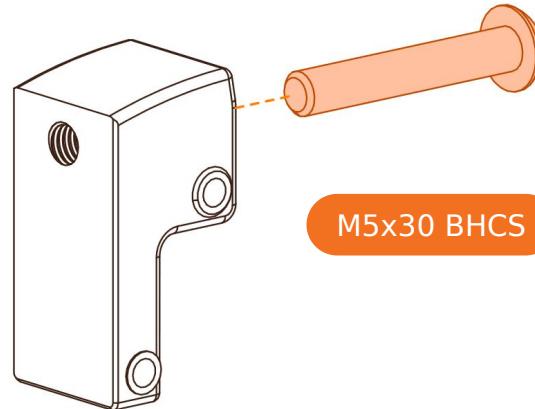
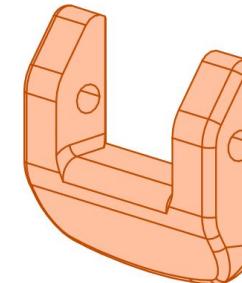
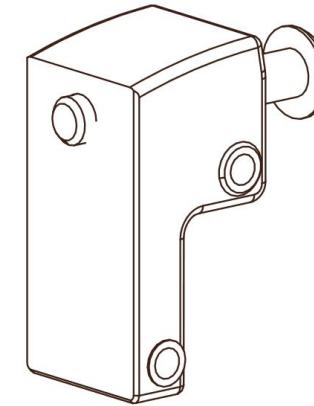




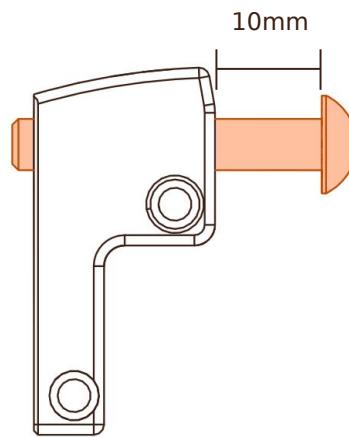
<b>Difficulty</b>	Hard		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver	Heatset Insert Tool Soldering Iron (Not Included)	
<b>Hardware Needed</b>	M3 Heatset Inserts (4x) M3x10 Socket Head Cap Screw (4x) M3x10 Self-Tapping Screw (4x) M3x16 Socket Head Cap Screw (2x) M3x30 Socket Head Cap Screw (1x) M5x30 Button Head Cap Screw (1x) M5x10 Button Head Cap Screw (2x) M3x40 Socket Head Cap Screw (3x)	X Endstop Switch (1x) Inductive Probe (1x) Zip Ties (2x) E Extrusion (1x) 625 Bearings (2x) M5 Washer (2x) M5x40 Socket Head Cap Screw (1x) M5 Hex Nut (1x) M5 T-Nuts (2x)	
	X Carriage Frame Left (1x) X Carriage Frame Right (1x)		

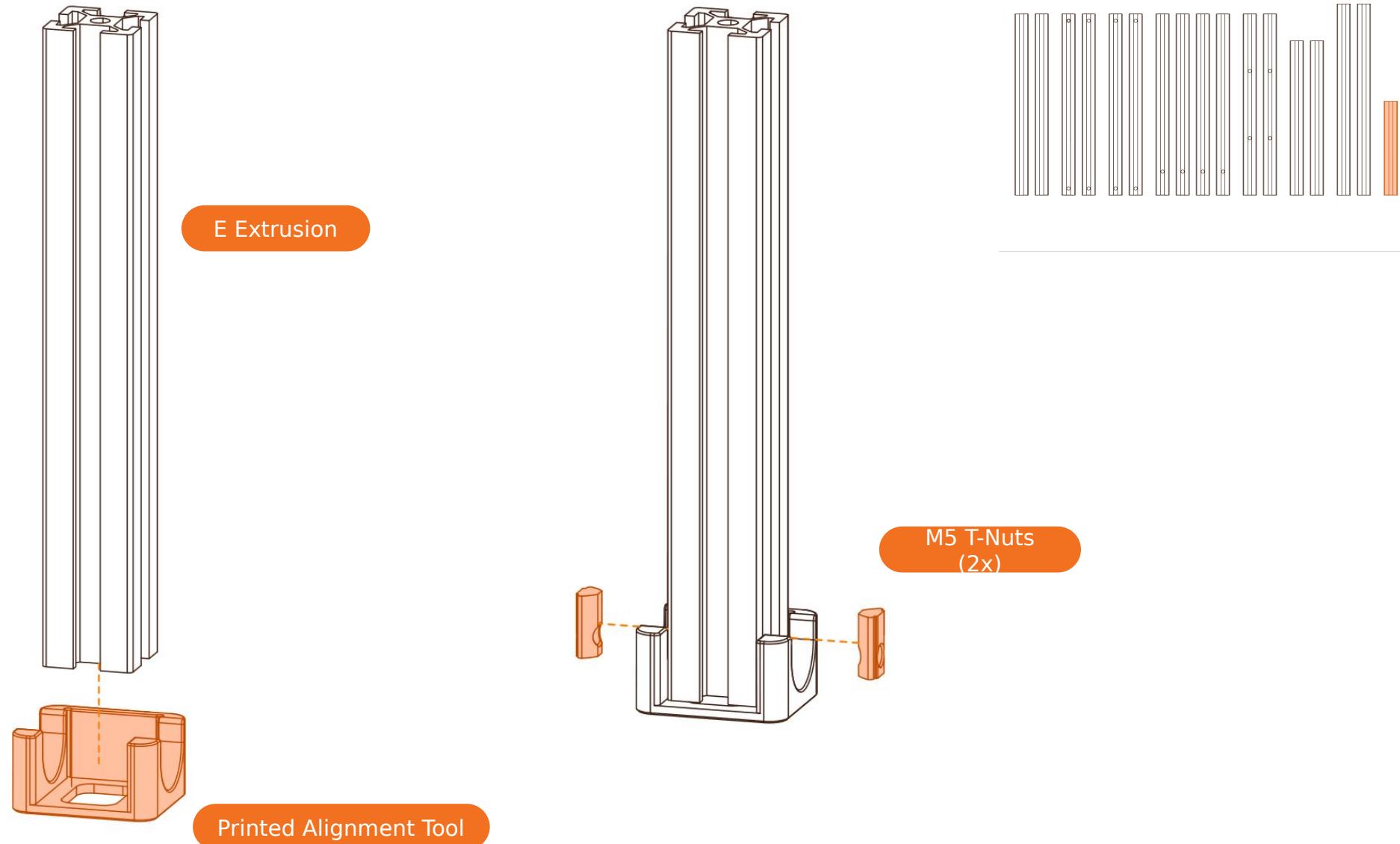


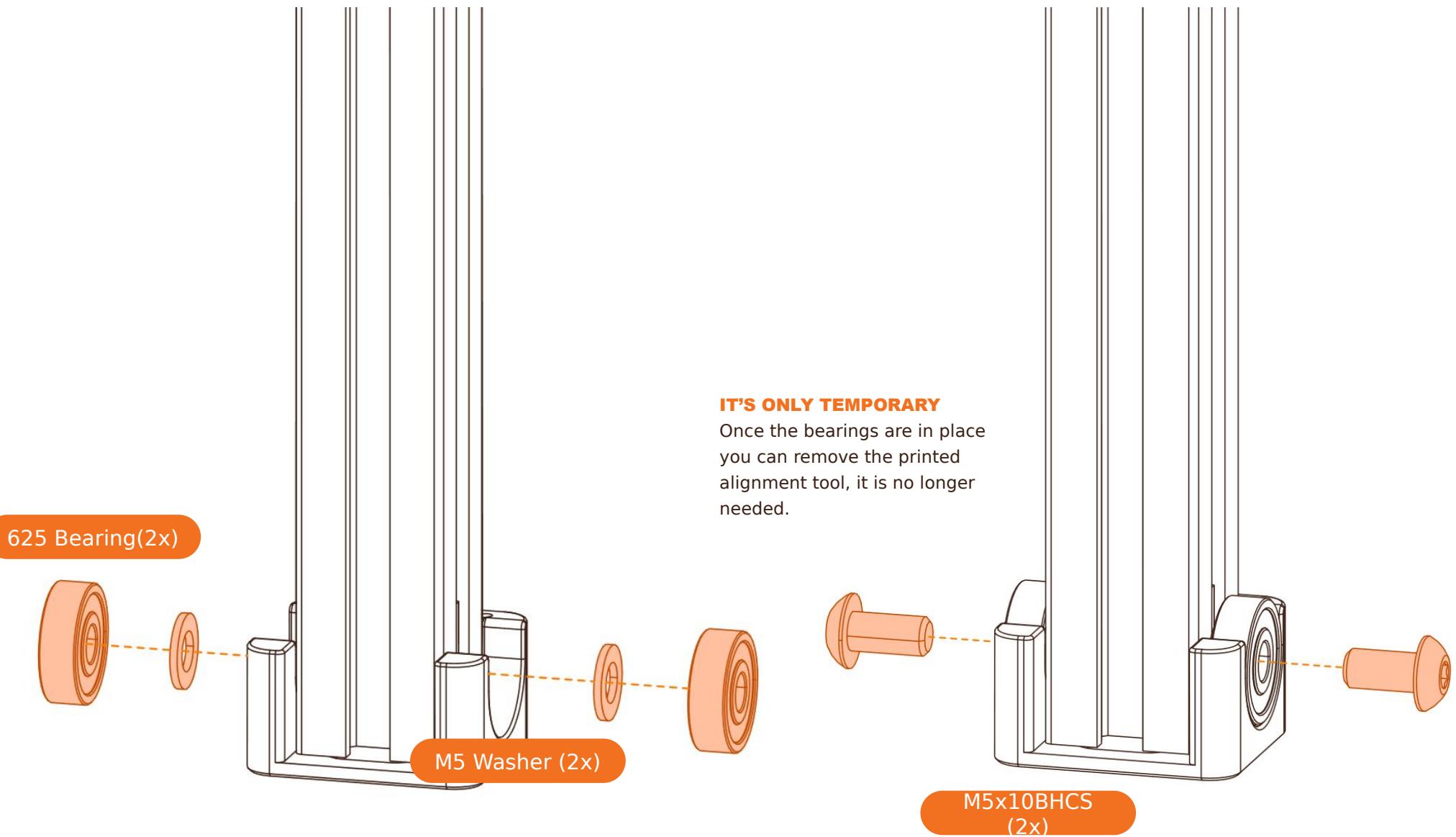
M3 Heatset Inserts  
(4x)

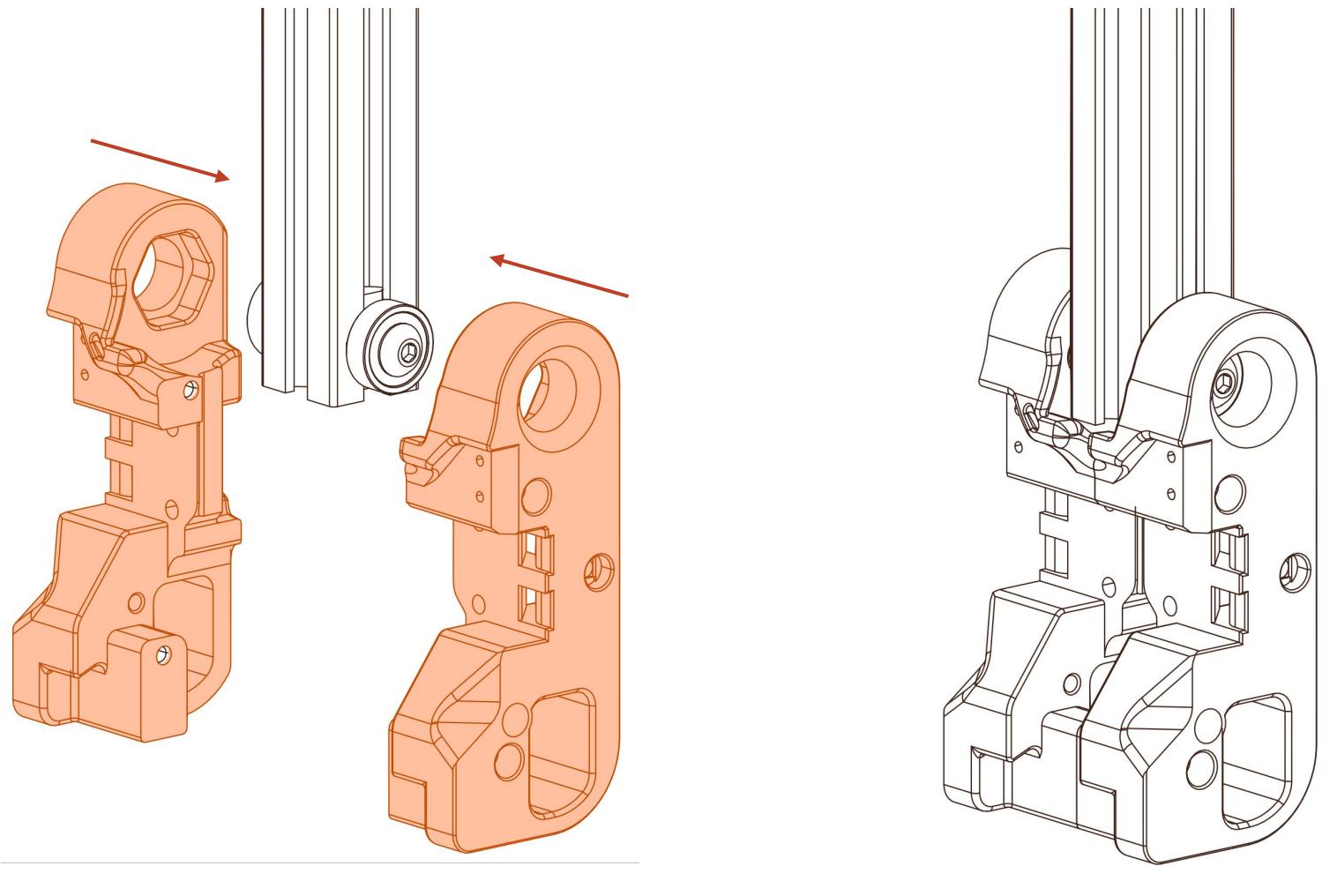
**M5x30 BHCS****ORIENTATION MATTERS**

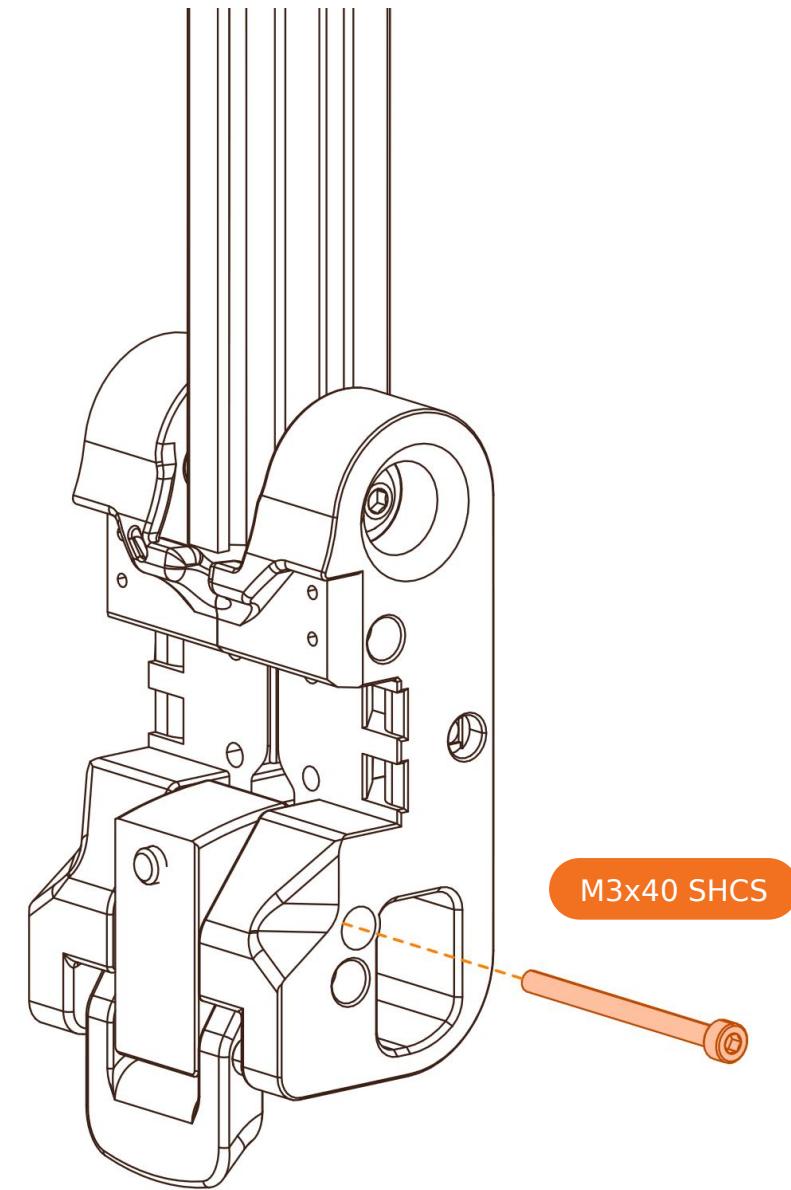
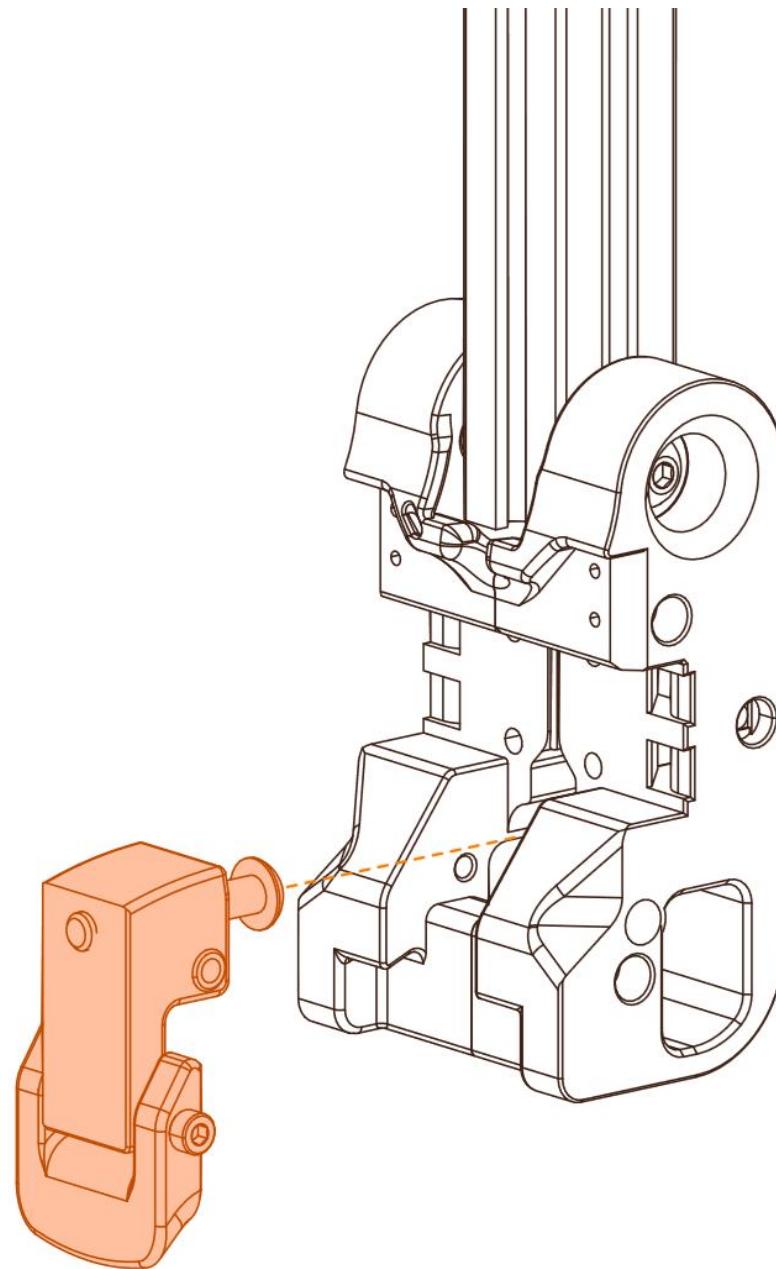
The over-center action of this latch, and its ability to hold the extruder in place, is dependent on the orientation of this piece, so ensure that it matches the diagram.

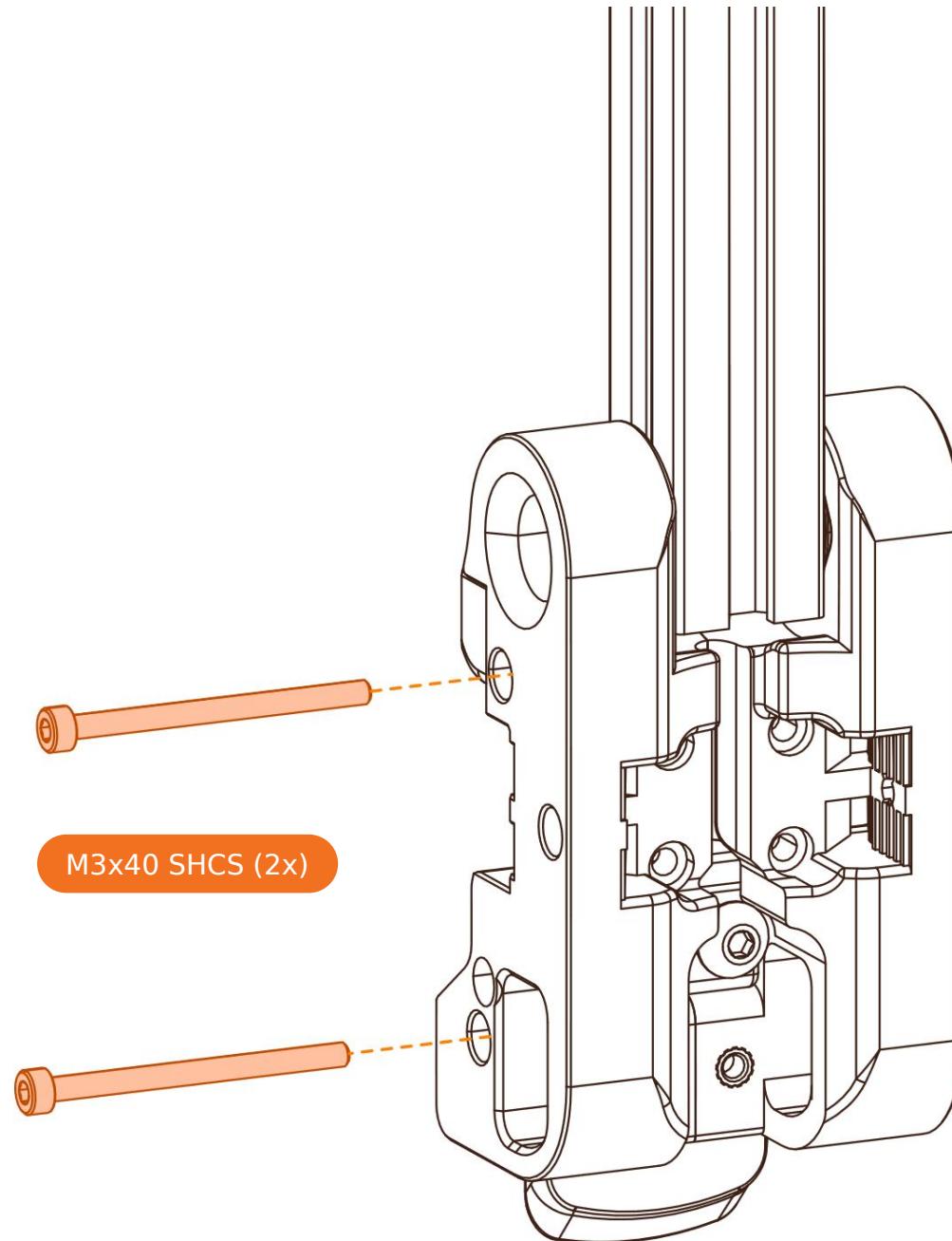
**M3x30 SHCS**

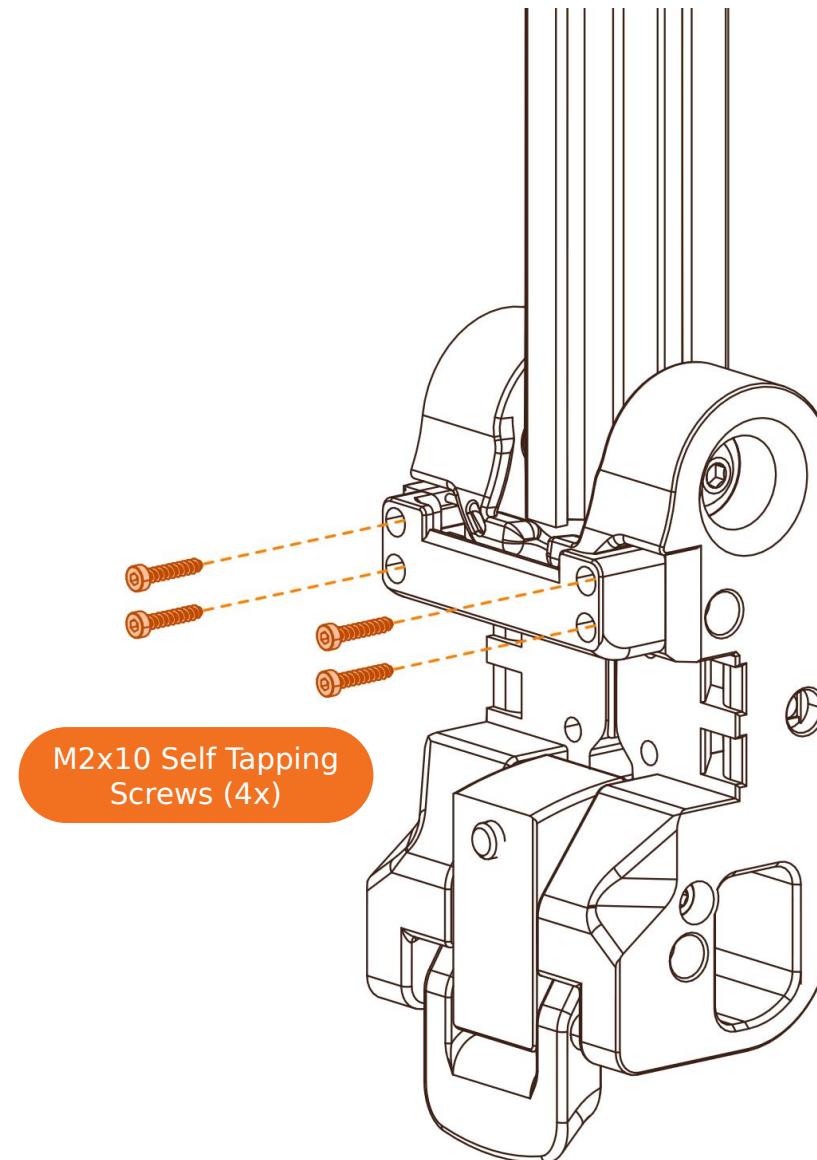
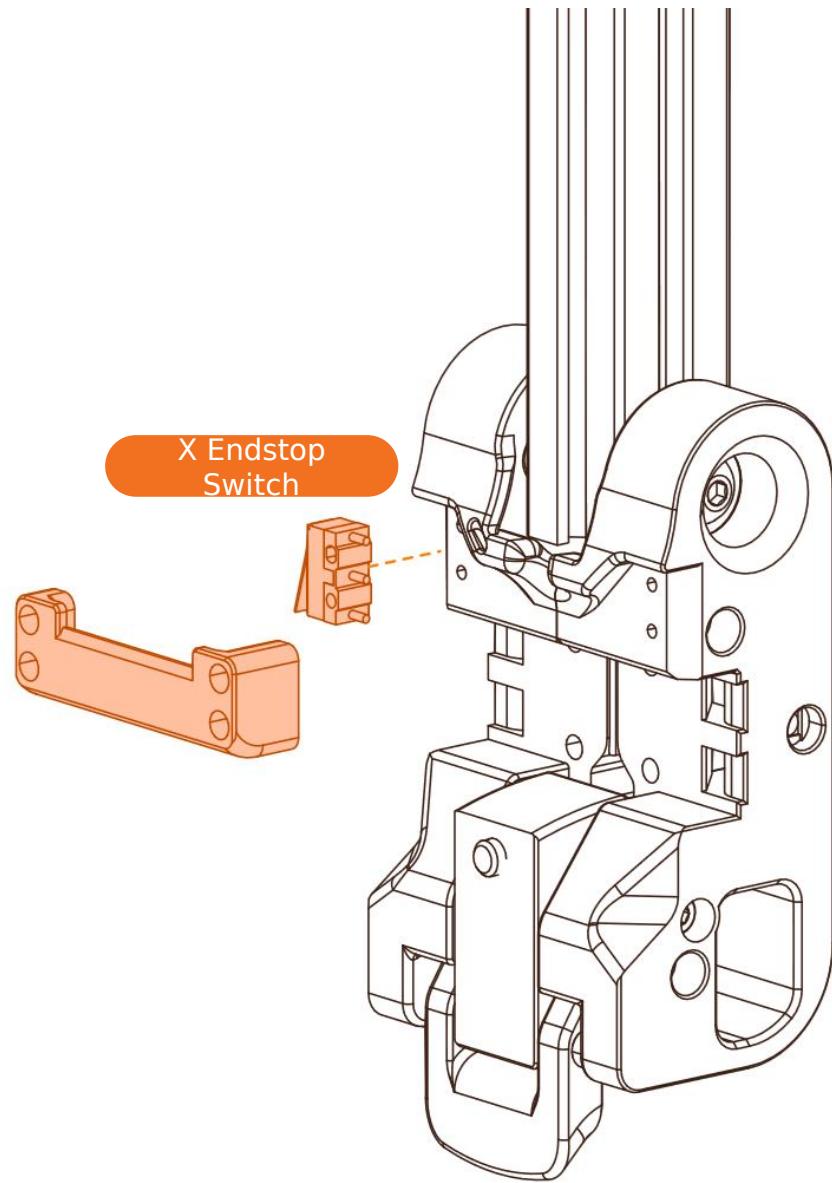


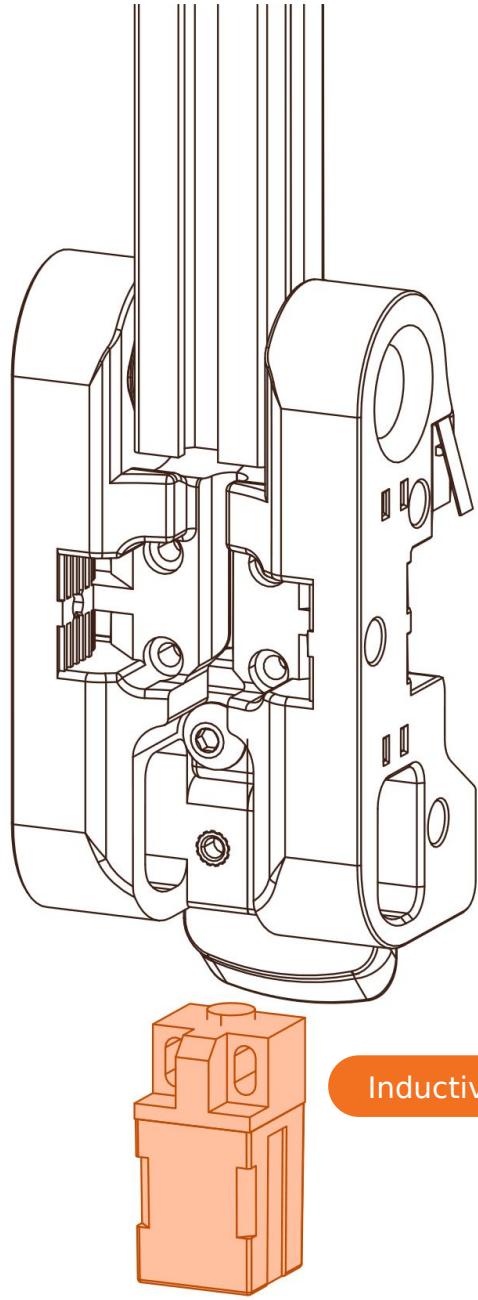






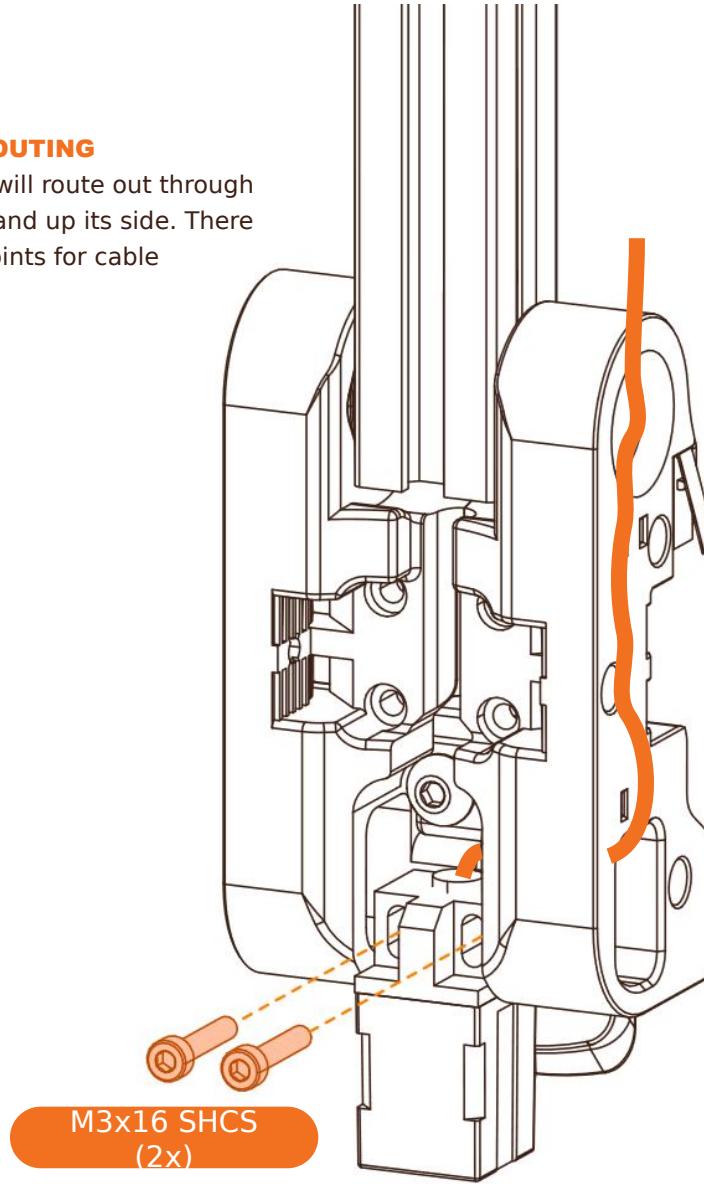


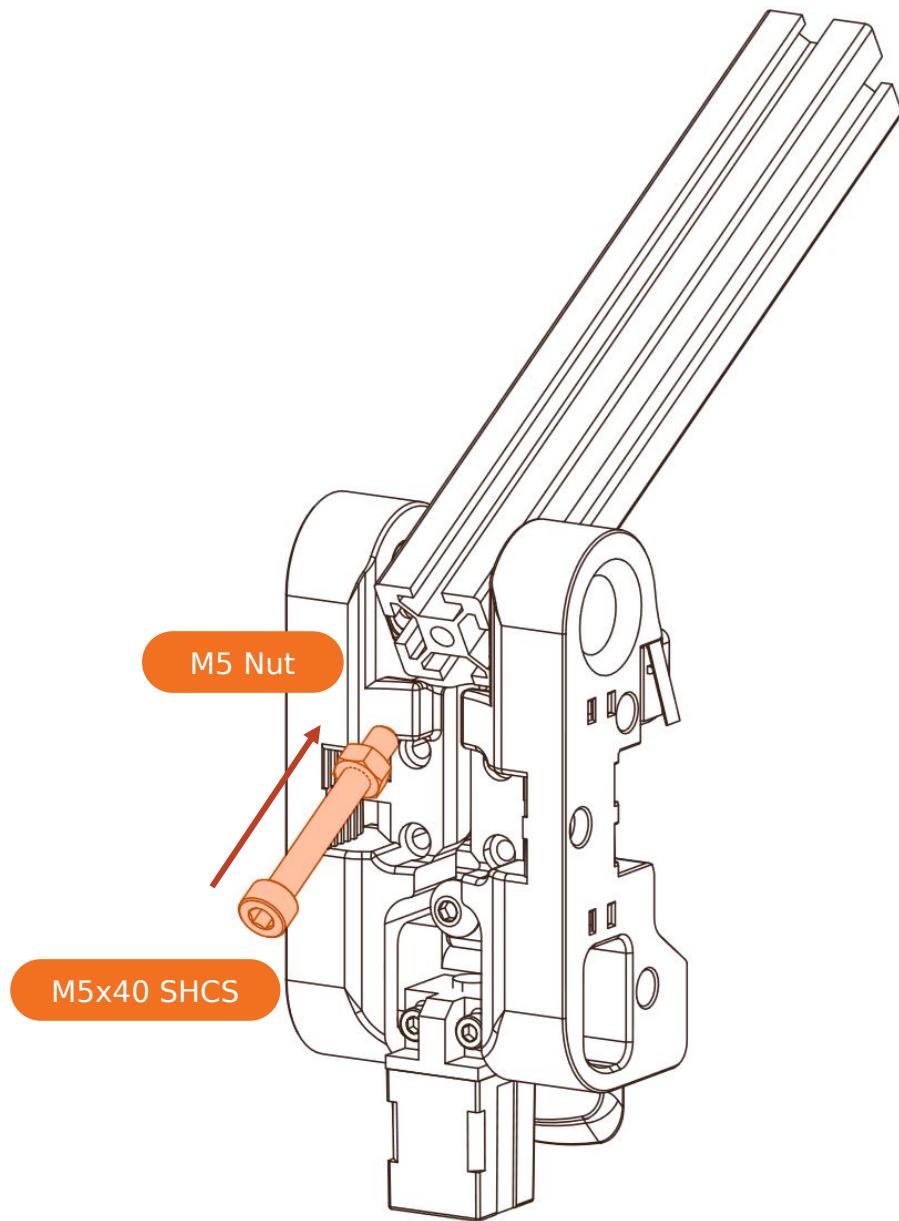




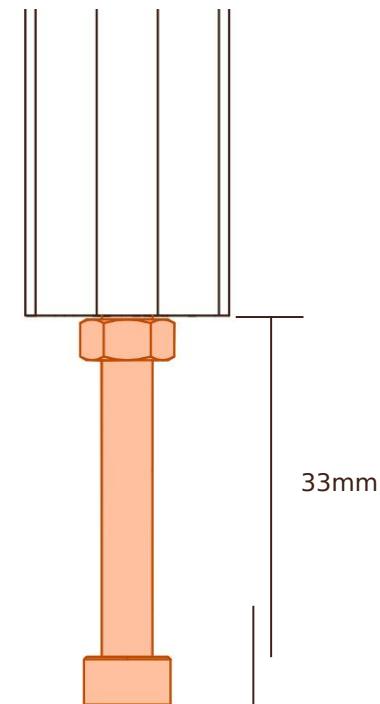
#### PROBE WIRE ROUTING

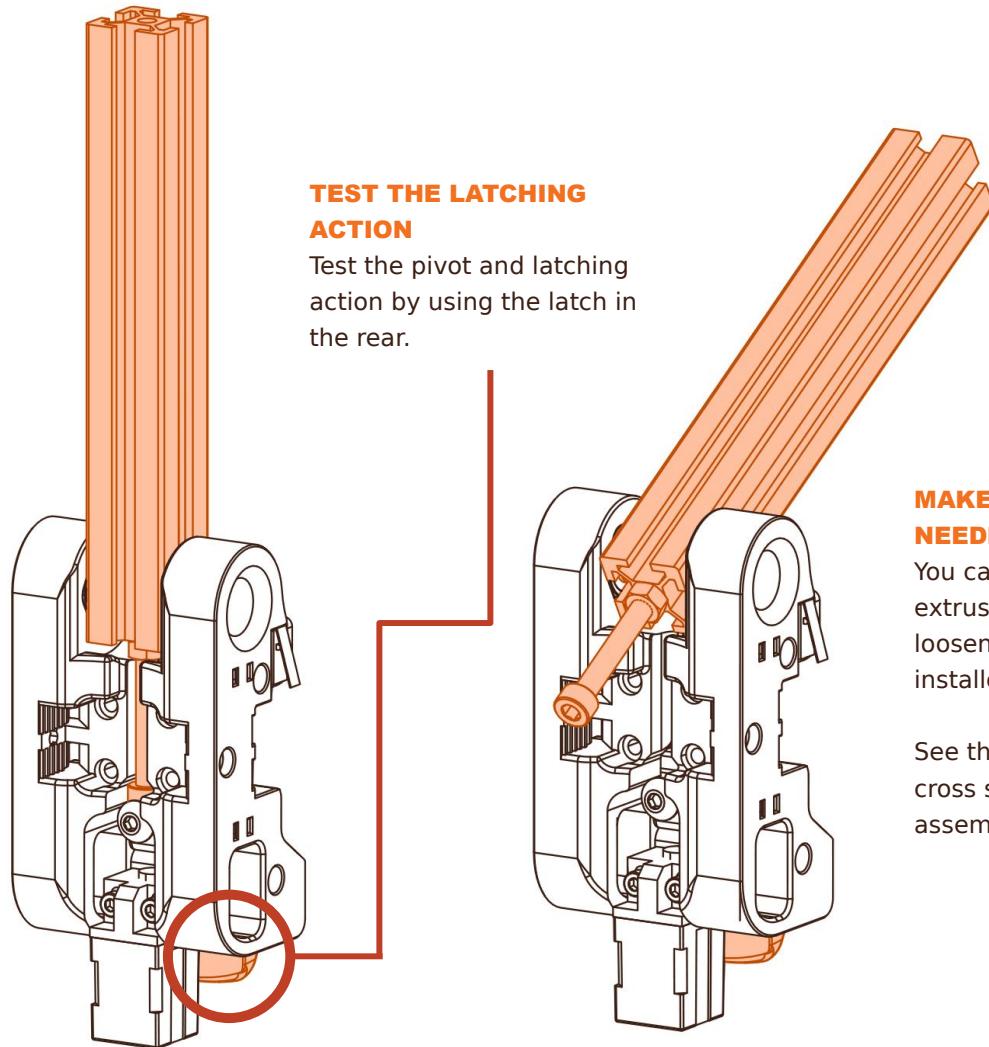
The probe wires will route out through the printed part and up its side. There are two zip tie points for cable management.



**LOCKING MECHANISM**

Use an M5 nut as a locking nut to position this SHCS exactly 33mm from the end of the extrusion. This will be used as the latching mechanism for the tilt action of the toolhead.



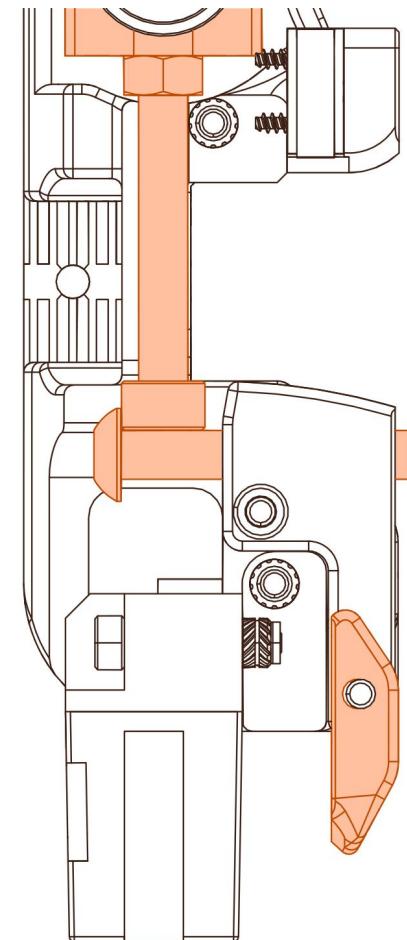
**TEST THE LATCHING ACTION**

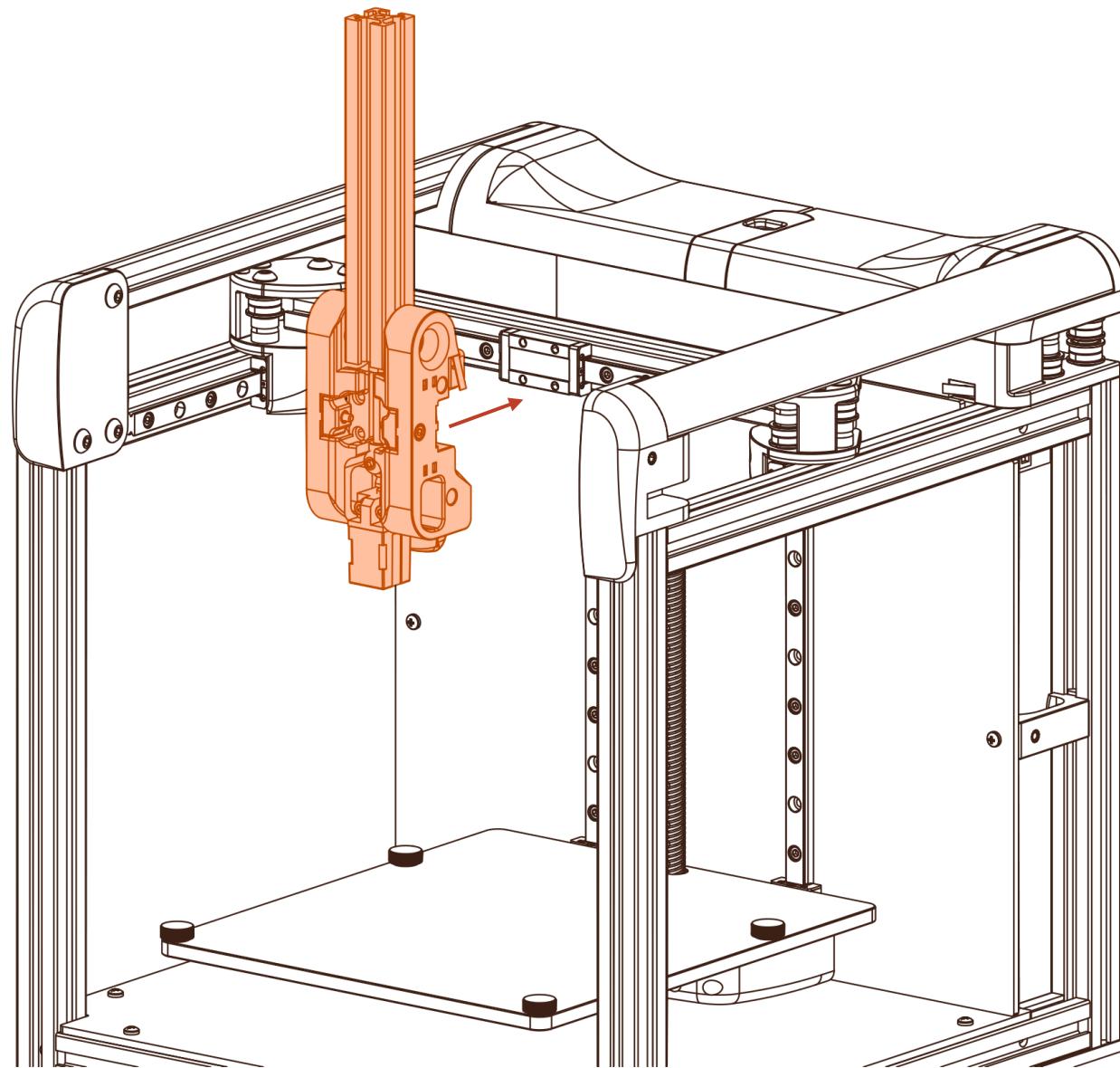
Test the pivot and latching action by using the latch in the rear.

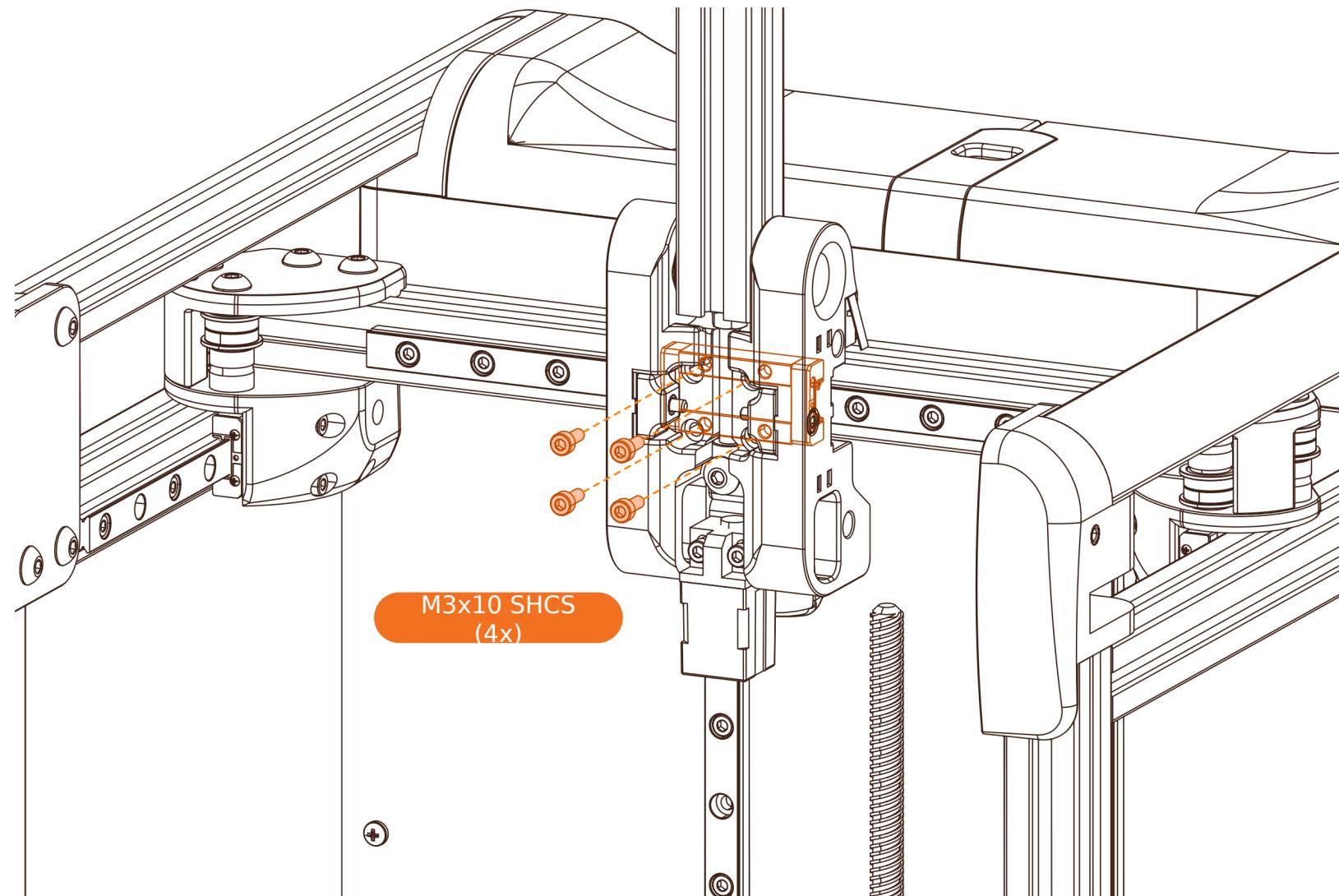
**MAKE ADJUSTMENTS AS NEEDED**

You can adjust the position of the extrusion up and down by loosening the M5x10 BHCS you installed on the last page.

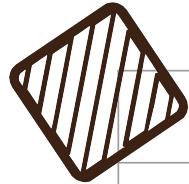
See the figure on the right for the cross section view on the correct assembly.



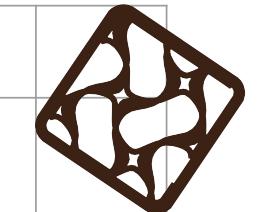


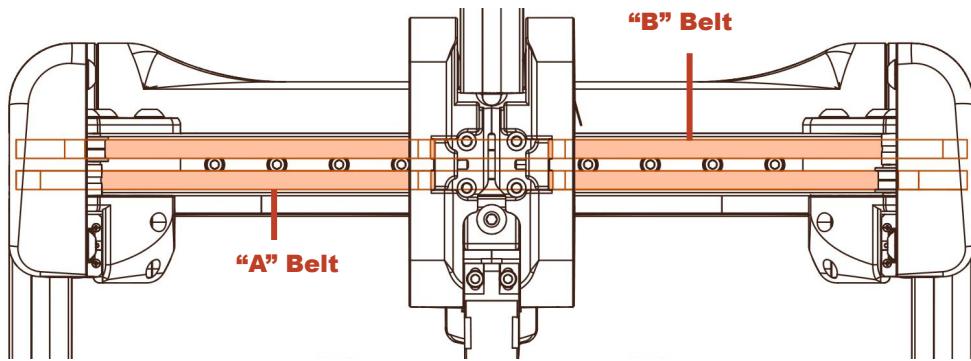






<b>Difficulty</b>	Medium	
<b>Tools Needed</b>	M3 Driver Heatset Insert Tool Soldering Iron (Not Included) Scissors (Not Included)	
<b>Hardware Needed</b>	M3 Heatset Inserts (2x) M3x16 Socket Head Cap Screw (2x) X & Y Belts (2x)	
<b>Printed Parts Needed</b>	Belt Clip (2x)	



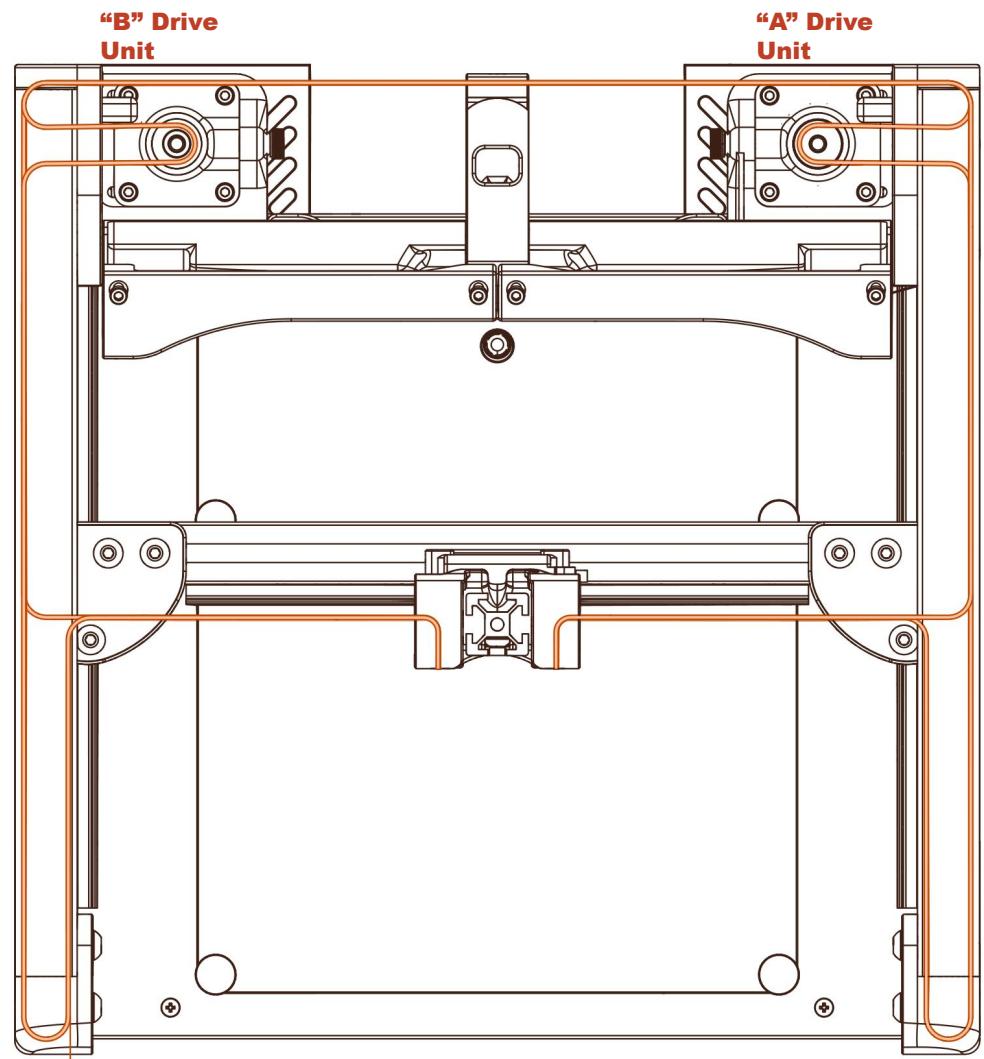


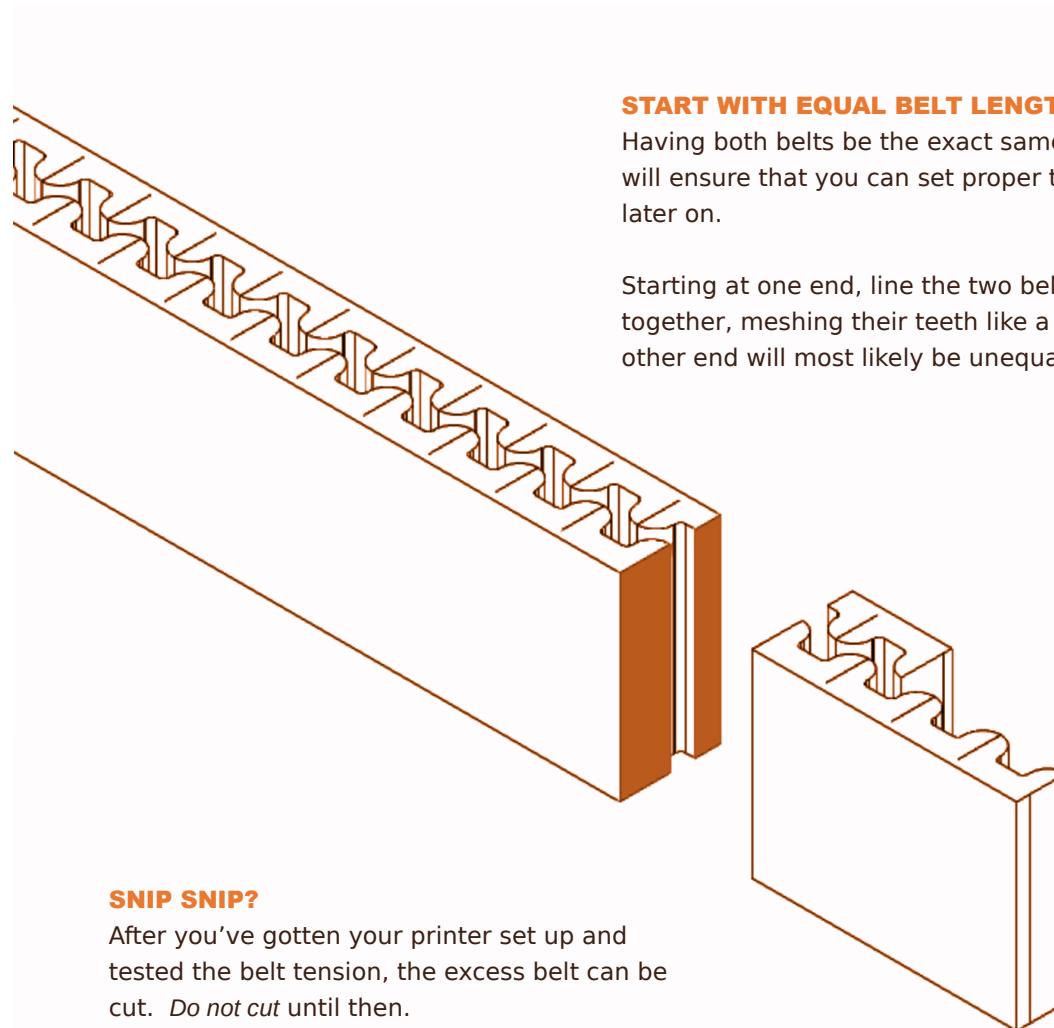
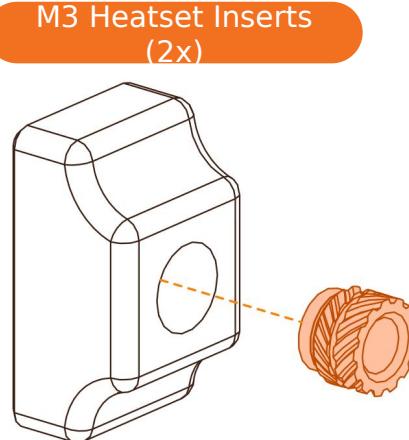
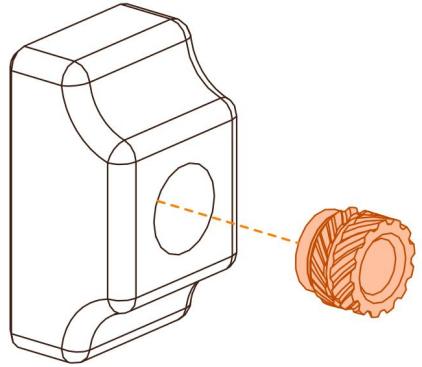
#### THE BELT PATH

The Cocoa Press printer uses a belt path based on the popular CoreXY pattern.

The individual belt paths are stacked on top of each other, and the crossing often found in CoreXY designs is omitted. Compared to many other implementations, the motors are moved to a less intrusive position.

**Equal belt tension is important to the proper function of a CoreXY motion system.**





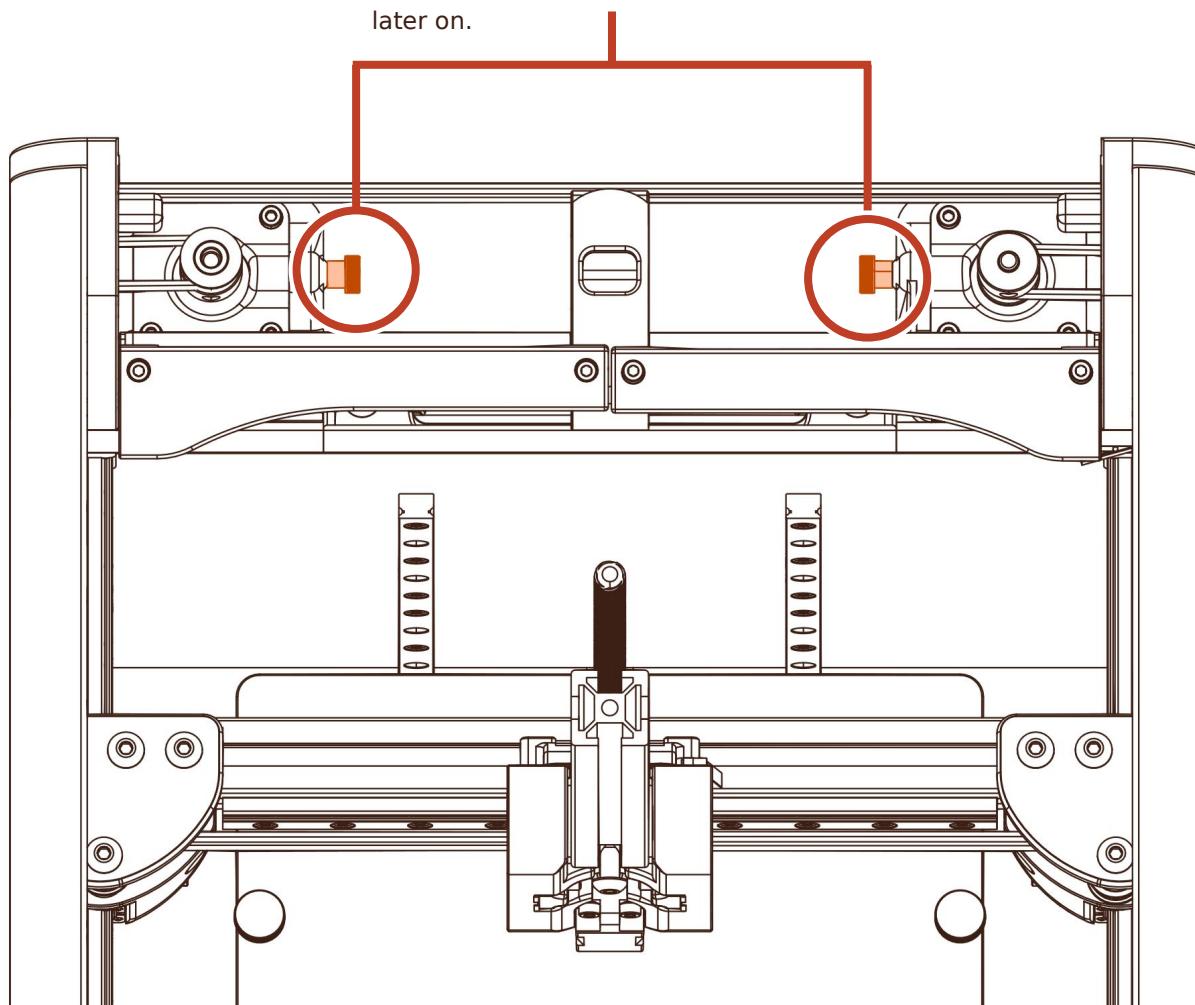
#### START WITH EQUAL BELT LENGTHS

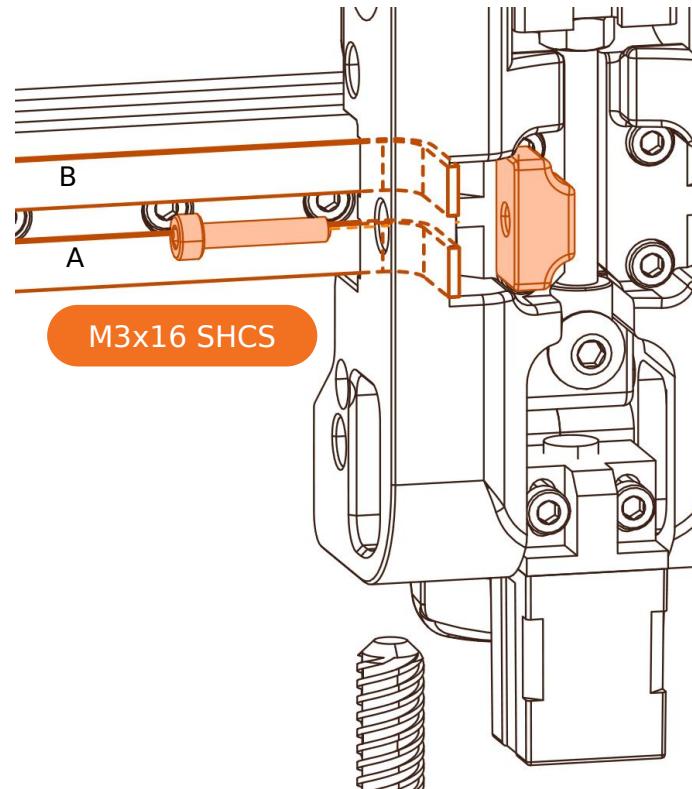
Having both belts be the exact same length will ensure that you can set proper tension later on.

Starting at one end, line the two belt runs together, meshing their teeth like a zipper. The other end will most likely be unequal.

**LOOSEN THE BELT TENSION KNOBS**

Before we begin belting the printer, we need to loosen the tension knobs so that we have adequate travel to properly tension the belts later on.



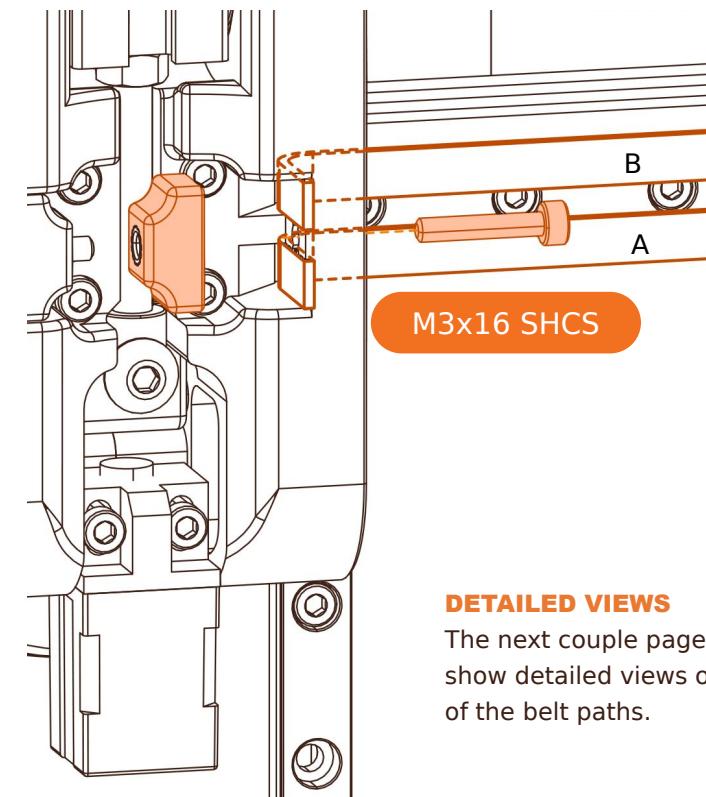


#### SECURING THE BELTS

Run the belts through their respective paths, and attach them to the opposite side of the X carriage. Before fully tightening the belt clamps, you can pull the ends of the belts to tighten them as best you can by hand.

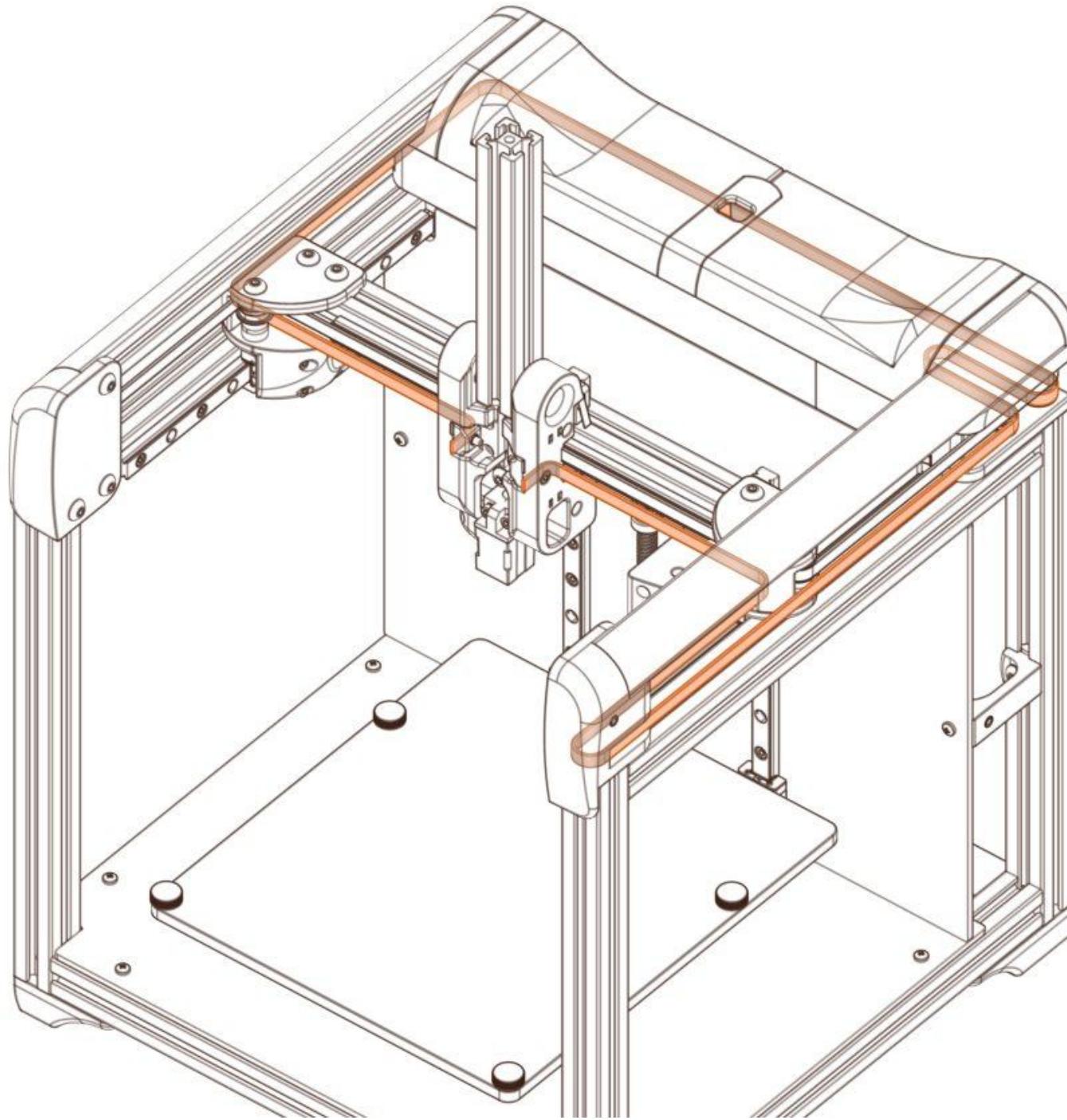
#### BELTING THE PRINTER

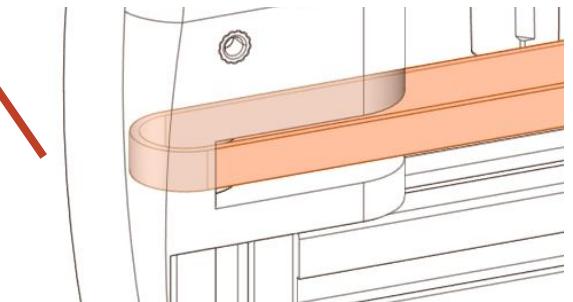
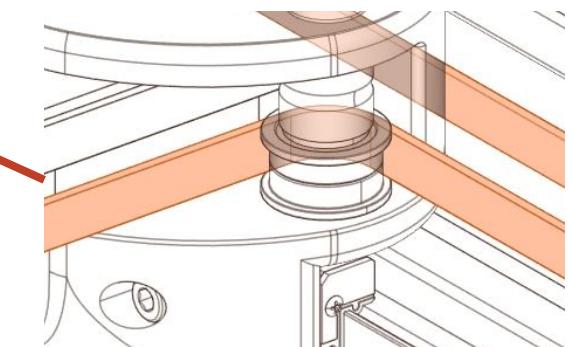
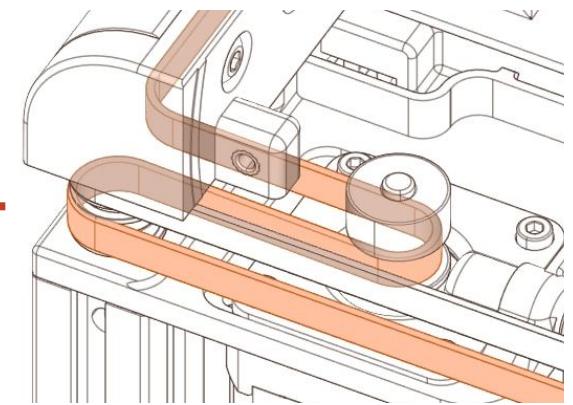
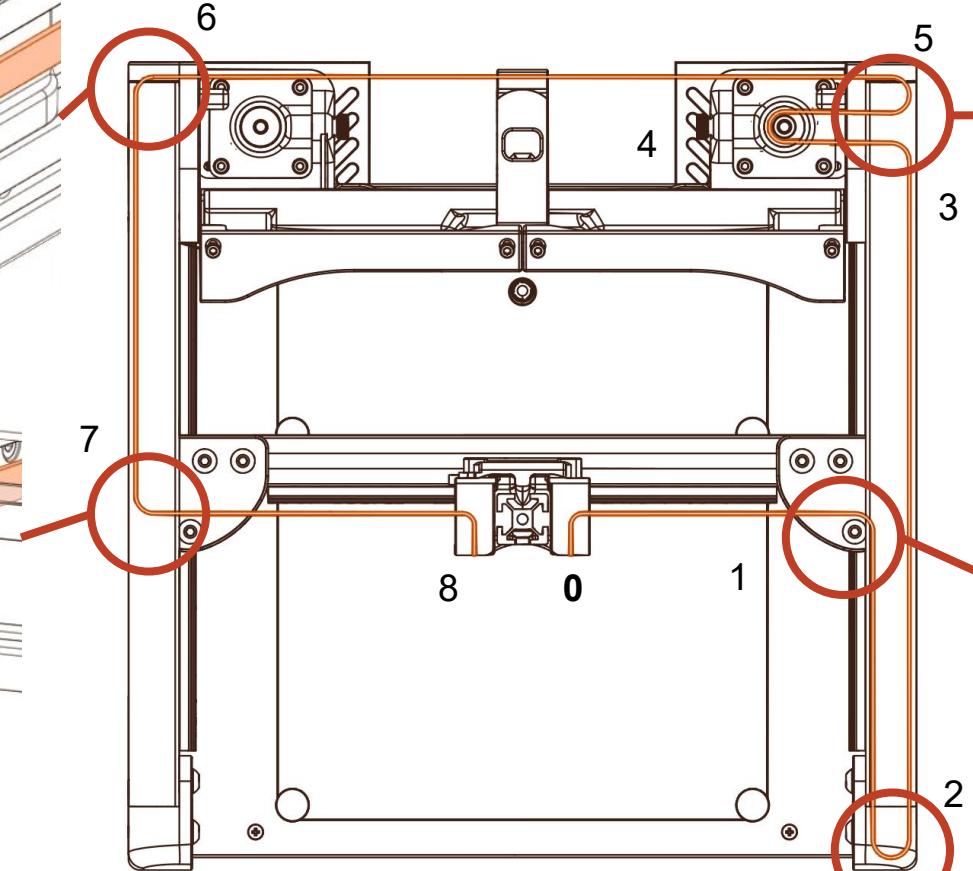
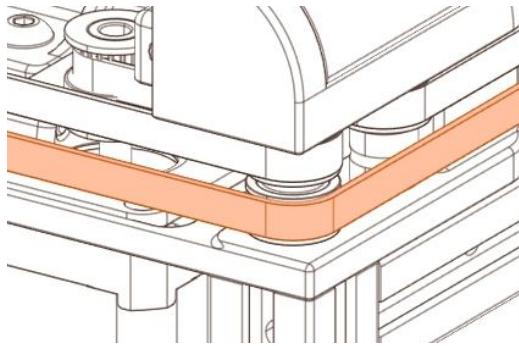
Start on one side of the toolhead and secure the A and B belts to the X carriage.



#### DETAILED VIEWS

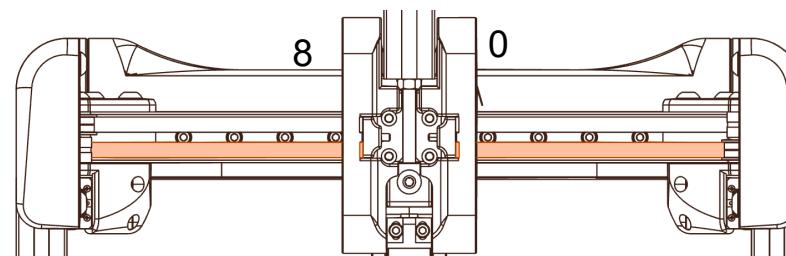
The next couple pages will show detailed views of each of the belt paths.

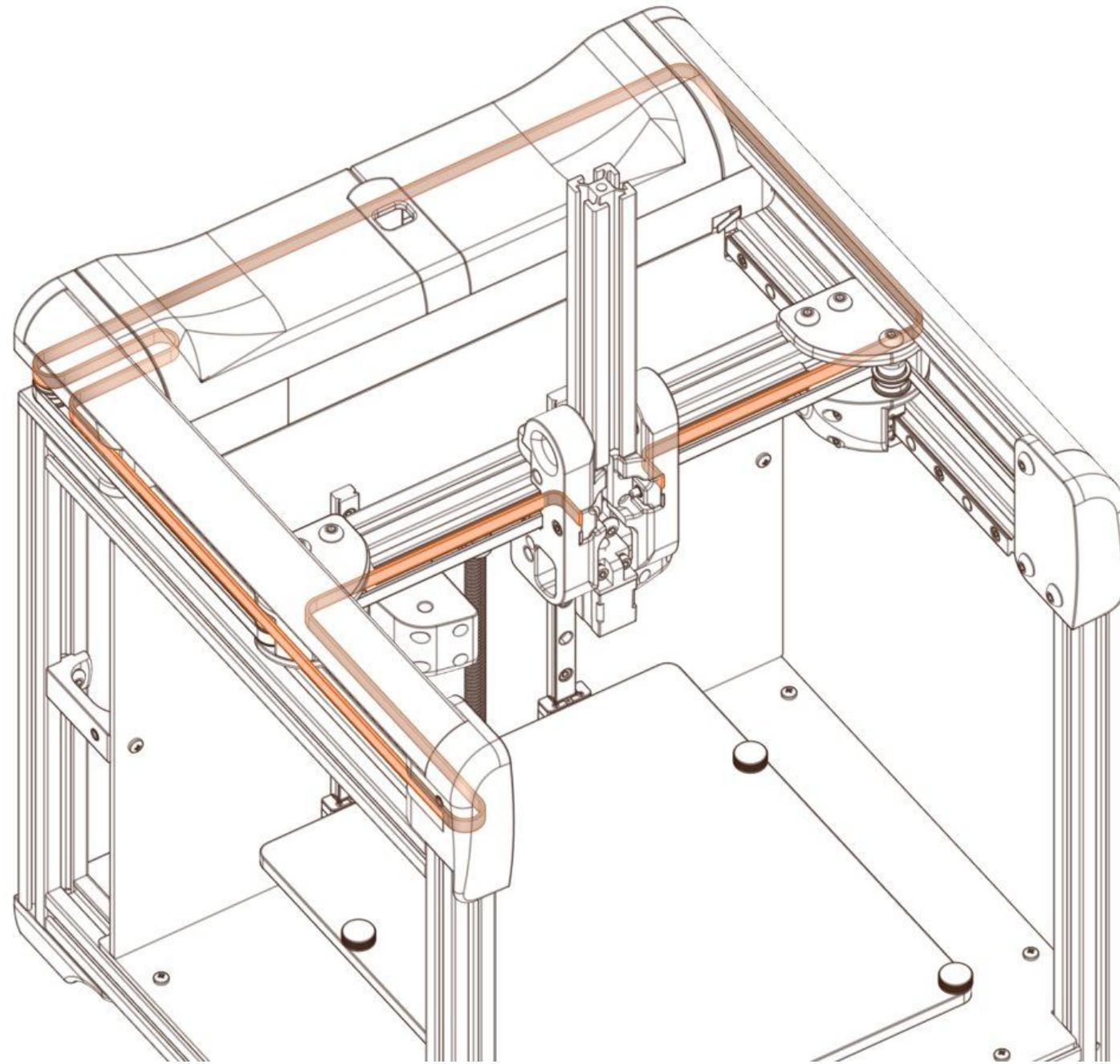


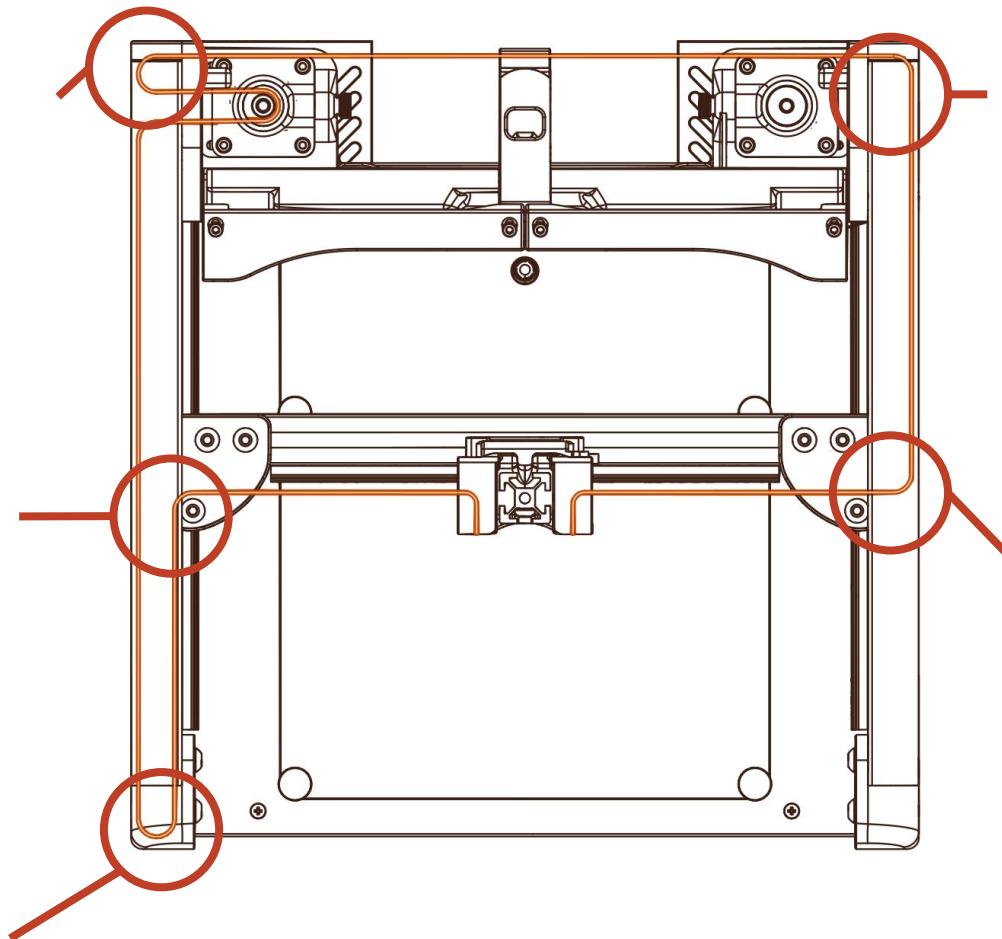


**LIKE TYING YOUR SHOES BUT  
WORSE**

Thread belt A through the printer. The A belt sits below the B belt. The flat side of the belt should only contact smooth bearing surfaces. No part of the belt should be touching plastic.



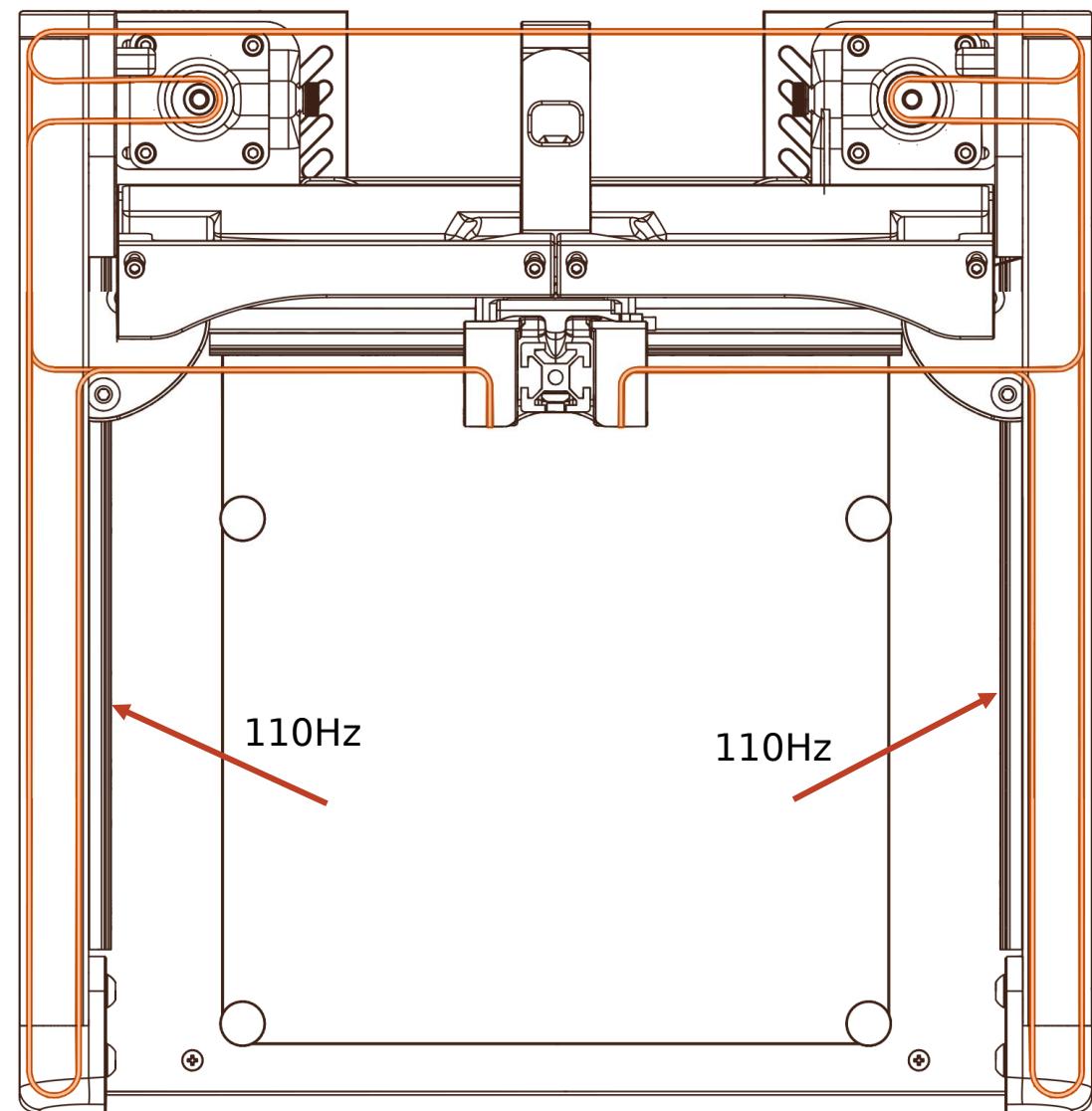


**LIKE TYING YOUR SHOES BUT  
WORSE**

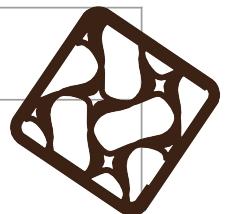
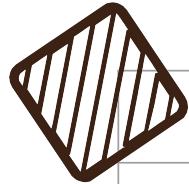
Thread belt B through the printer. The B belt sits above the A belt. The flat side of the belt should only contact smooth bearing surfaces. No part of the belt should be touching plastic.

**110Hz AT MAX Y TRAVEL**

You can use a tuning app on your smartphone [or in browser](#) to measure the frequency of the belts when the gantry is in a fixed location. Move the gantry all the way to the rear of the printer and pluck the indicated belts. We are looking for 110Hz in these locations.





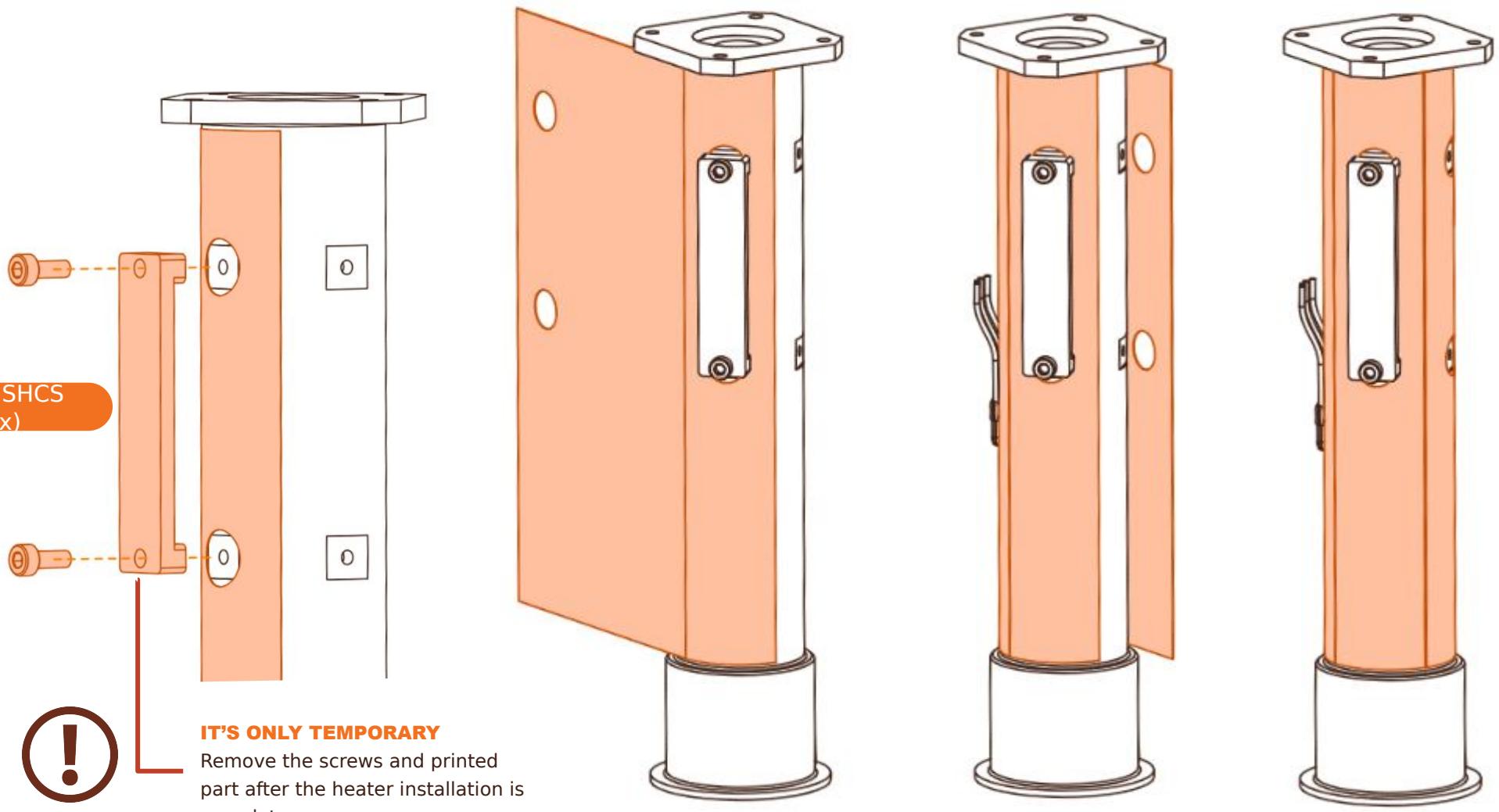


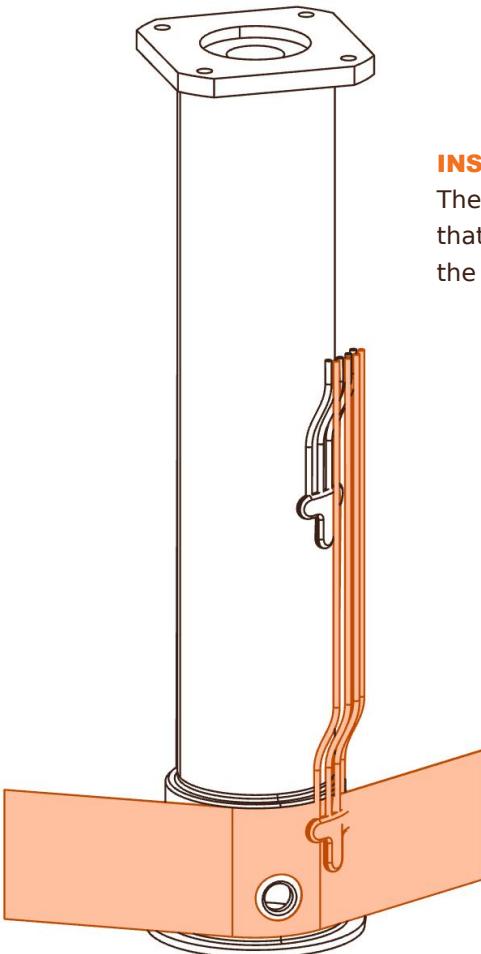
<b>Difficulty</b>	Hard		
<b>Tools Needed</b>	M2 Driver M3 Driver M5 Driver	Heatset Insert Tool Soldering Iron (Not Included)	
<b>Hardware Needed</b>	M3 Heatset Inserts (8x) M2 Heatset Inserts (2x) M2x10 Socket Head Cap Screw (6x) M3x8 Socket Head Cap Screw (7x) M3x12 Socket Head Cap Screw (5x) M3x16 Socket Head Cap Screw (2x) M3x20 Socket Head Cap Screw (8x) M5x10 Button Head Cap Screw (1x) M6 Thumb Screw (1x)	Nozzle Heater (1x) Body Heater (1x) E Motor (1x) Z Leadscrew (1x) Heater Body (1x) Zip Ties (3x) Cartridge (1x) MGN7-H Rail (1x)	
<b>Printed Parts Needed</b>	Heater Jig (1x) Cocoa Press Medallion (1x) MJF Plunger Adapter (1x) Extruder Motor Case (1x)	Extruder Motor Cover (1x) Extruder Shell Front (1x) Extruder Shell Rear (1x) Extruder Cable Cover (1x)	



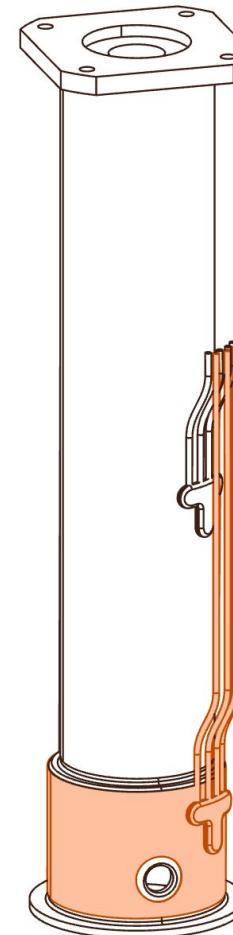
**INSTALLING HEATERS**

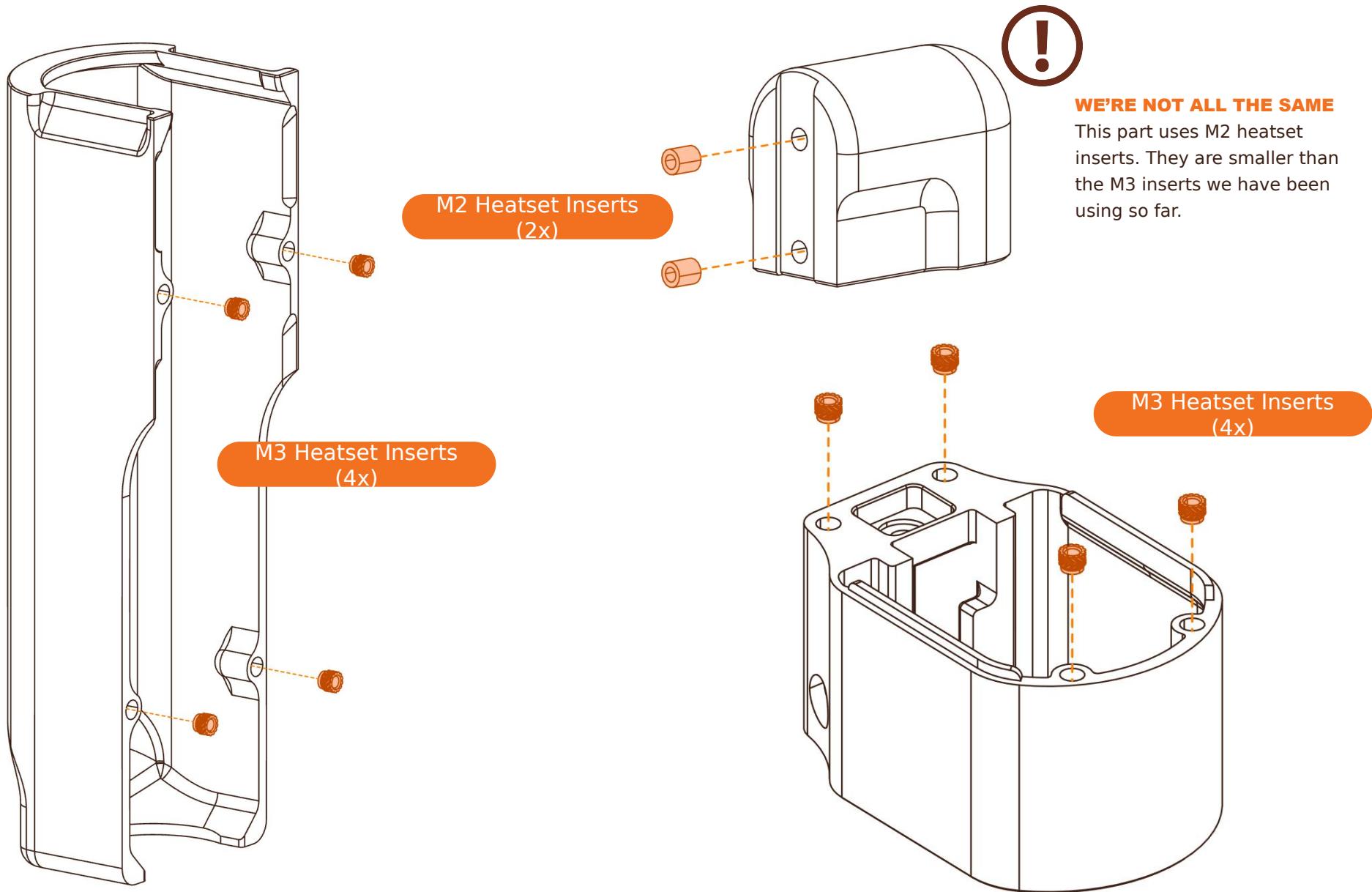
The large heater mat gets wrapped around the machined metal component. The 4 holes in the mat align with the 4 screw holes in the component. Use the printed guide to help attach the heater to the barrel. Wrap the heater around and be sure to prevent any air bubbles from forming.

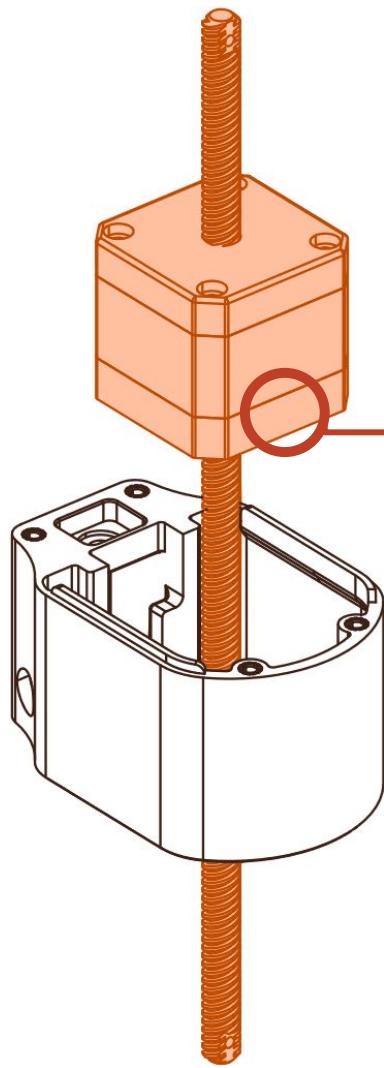


**INSTALLING HEATERS**

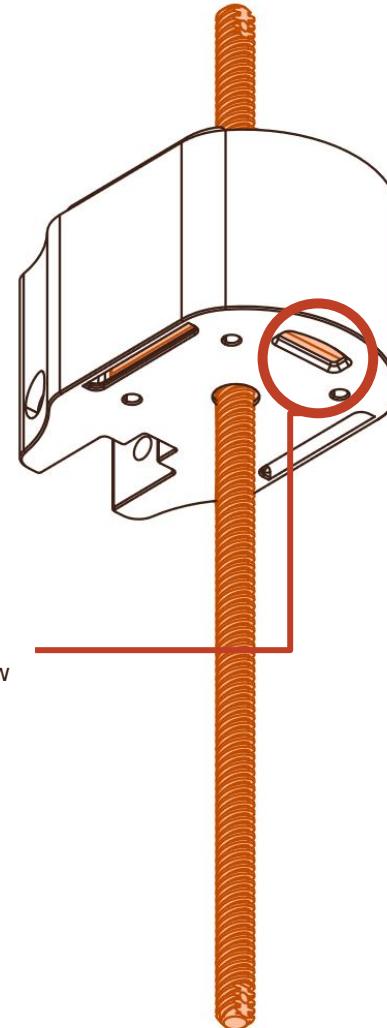
The smaller heater has a single hole that aligns with the hole in the front of the machined component

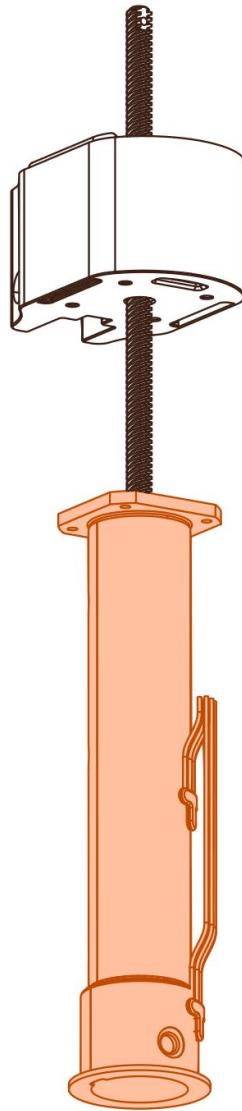




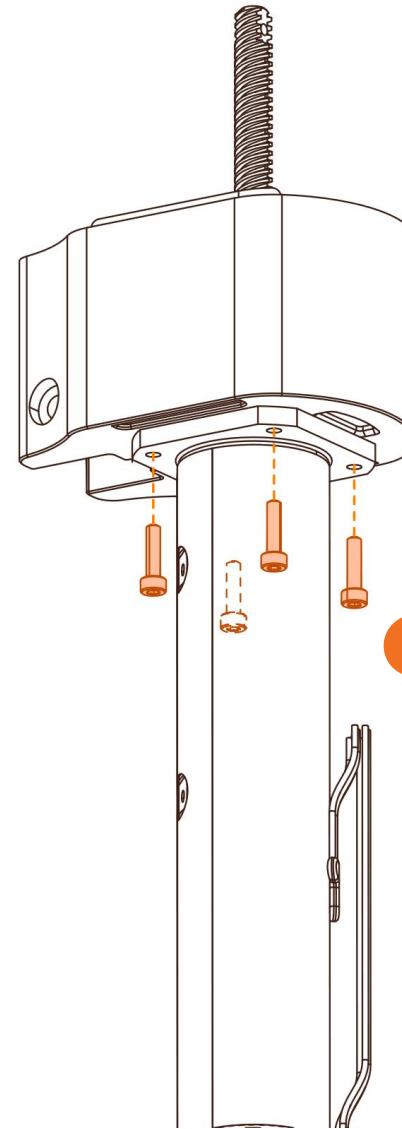
**MOTOR WIRE ROUTING**

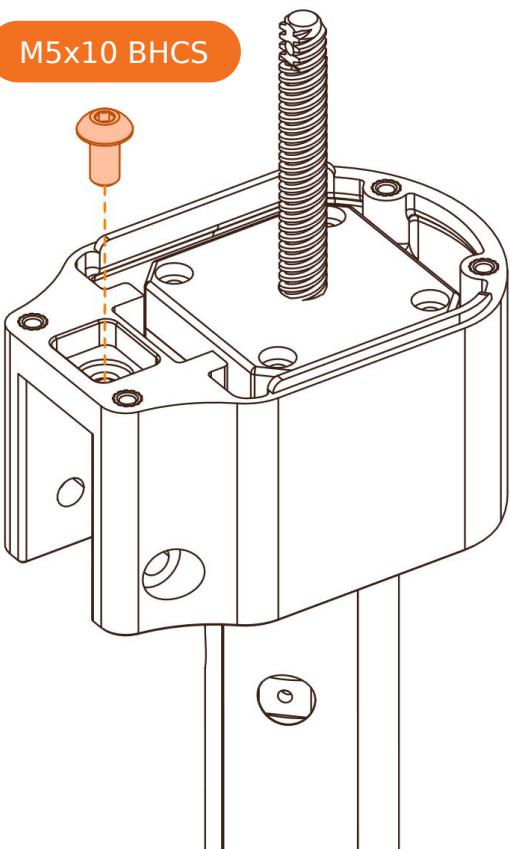
The motor wires should exit out the front of the motor. The white plug can be routed up through the open window in the printed part and connected to the motor.



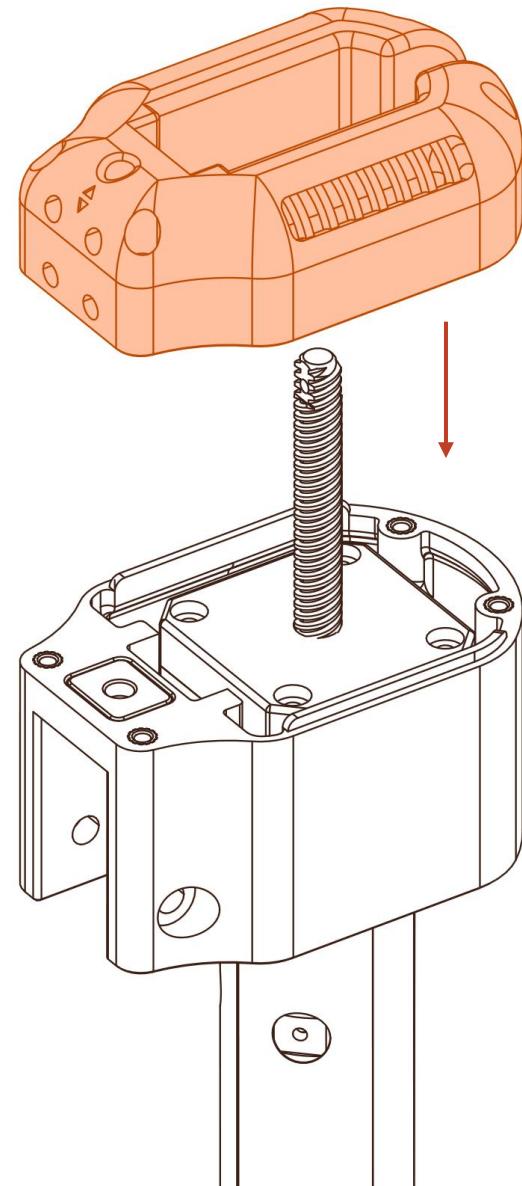
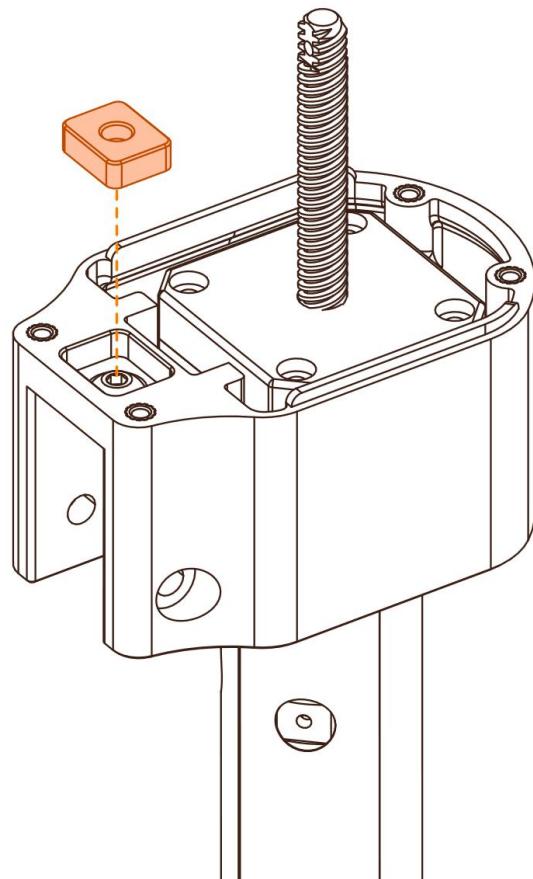
**FRONT TO FRONT**

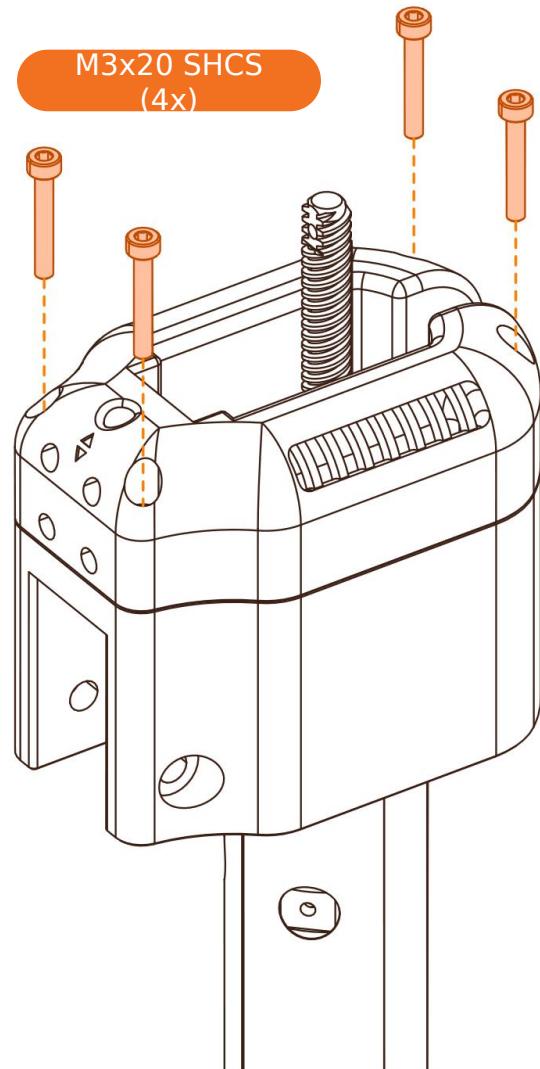
Make sure the through hole in the cartridge housing assembly is facing the front rounded portion of the printed part.



**CAREFUL, CAREFUL**

This insert allows you to more precisely adjust the spacing between your inductive probe and the nozzle of the printer, be sure to include it.

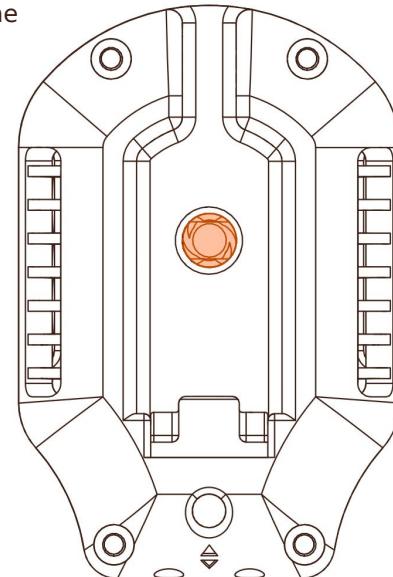
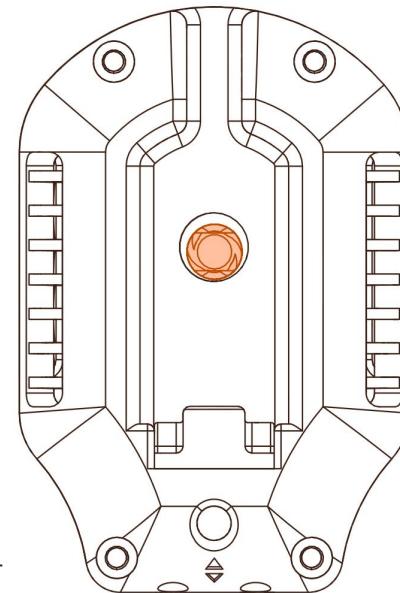


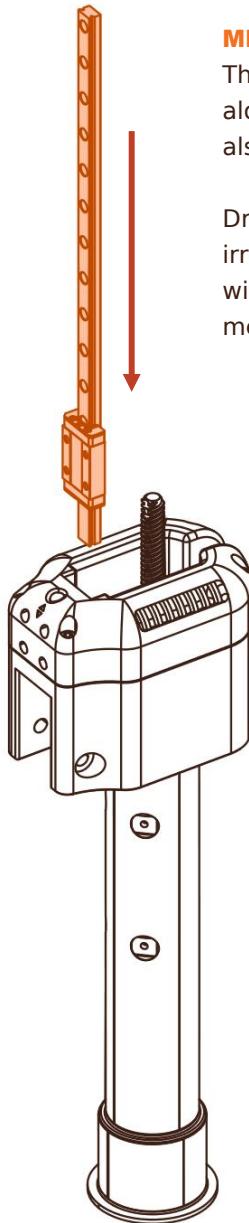


M3x20 SHCS  
(4x)

#### LEAD SCREW ALIGNMENT

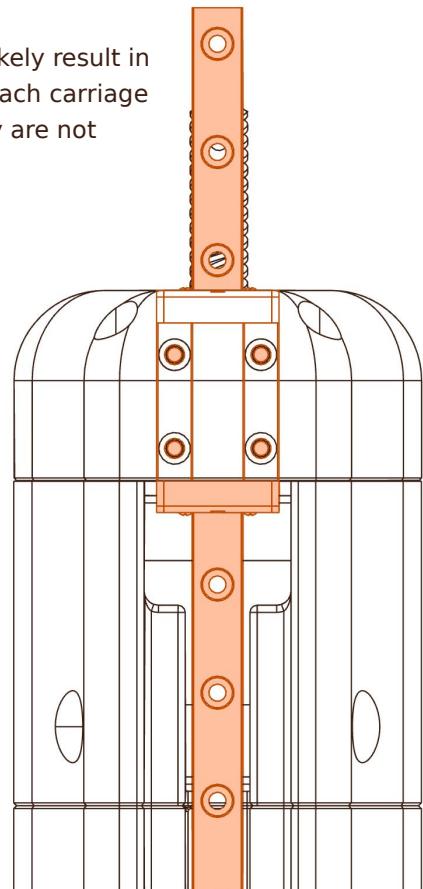
Make sure the leadscrew from the extruder motor is aligned in the center of the printed parts. If it is not, you may need to loosen the 4 M3x12 screws holding the motor on and adjust its position.



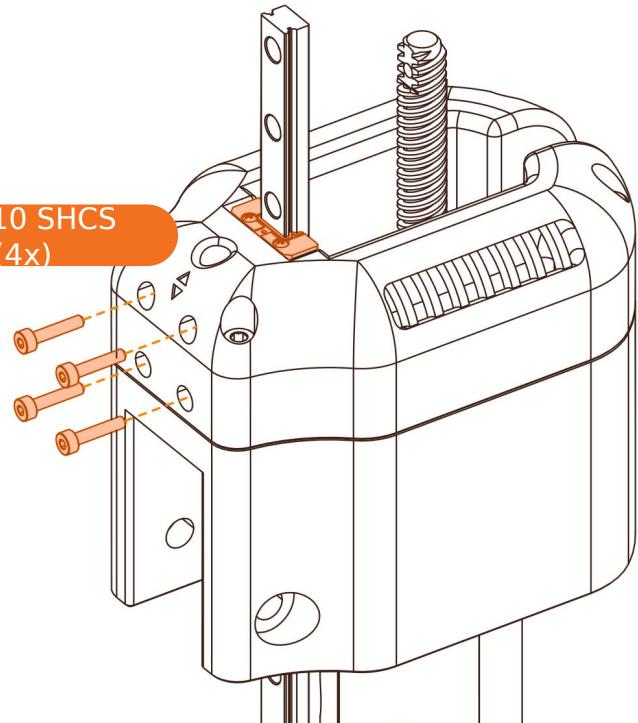
**MIND THE CARRIAGES**

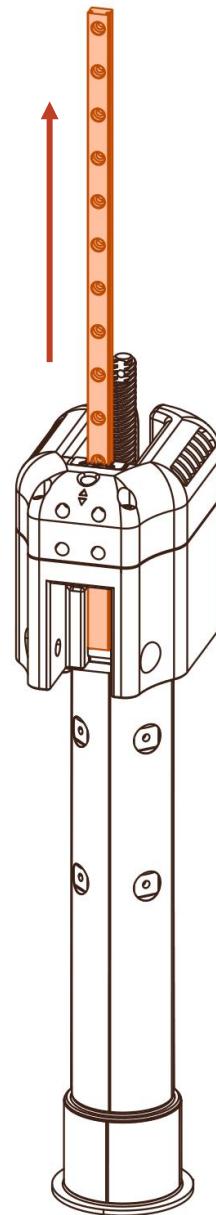
The carriages are designed to slide along the rail easily. This unfortunately also includes sliding off the rails.

Dropping the carriage will likely result in irreparable damage. Keep each carriage with its respective rail. They are not meant to be swapped.

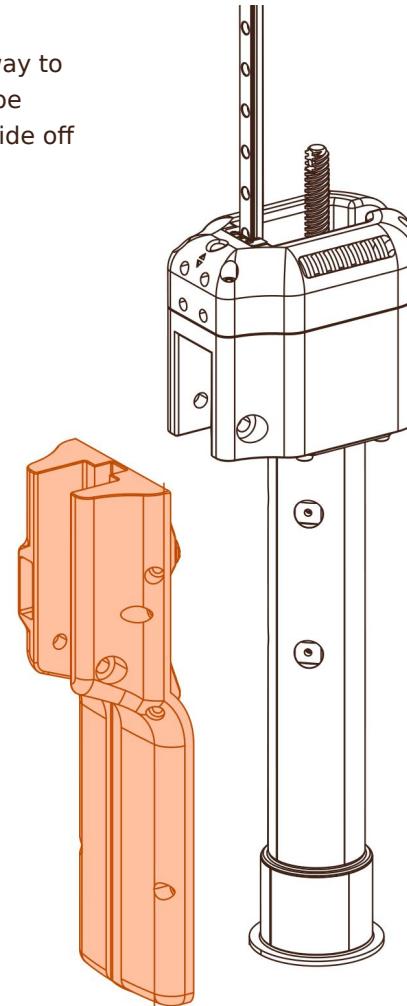


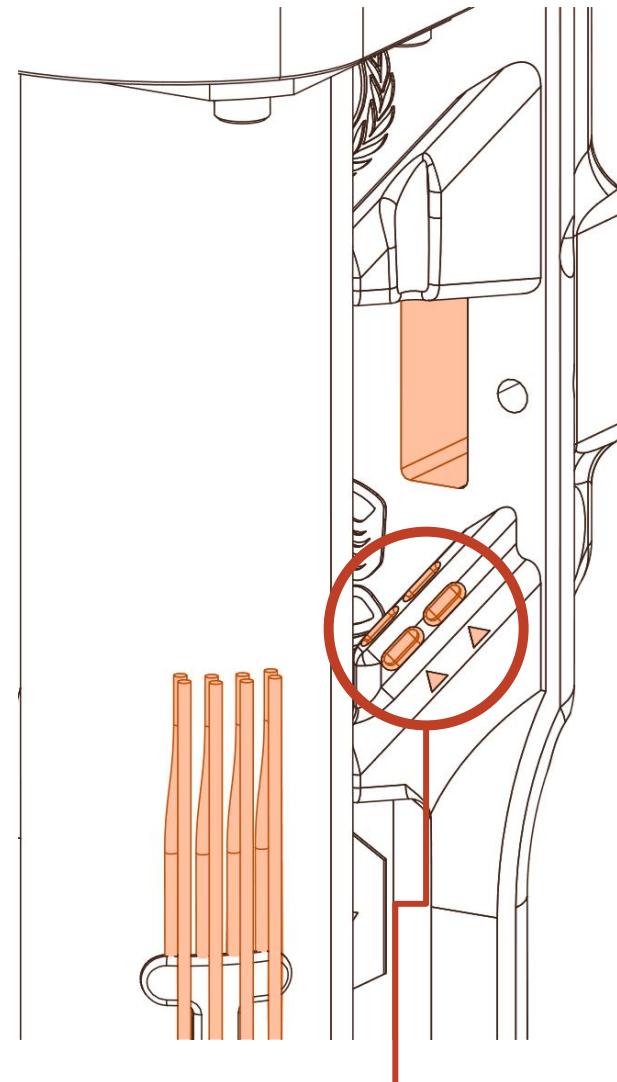
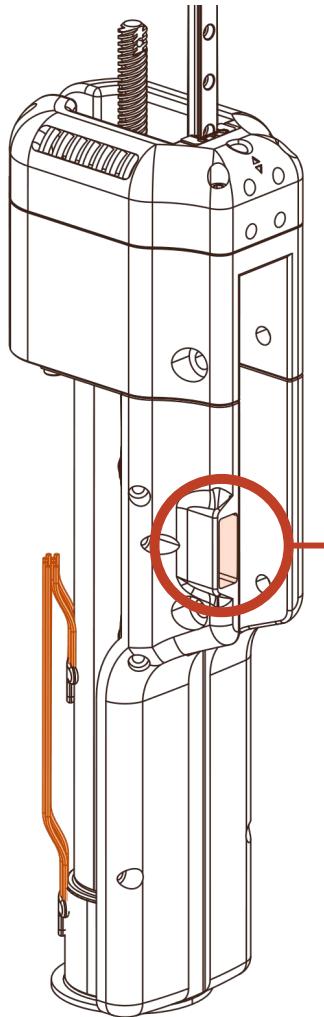
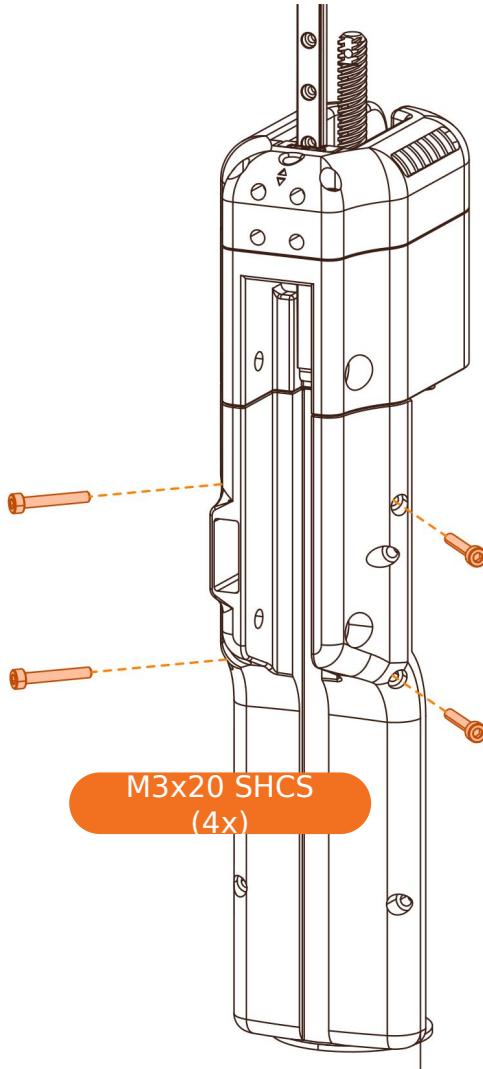
M2x10 SHCS  
(4x)



**MAKE ROOM**

Slide the linear rail up and out of the way to make room for the printed housing to be installed. Take care not to let the rail slide off of the carriage.

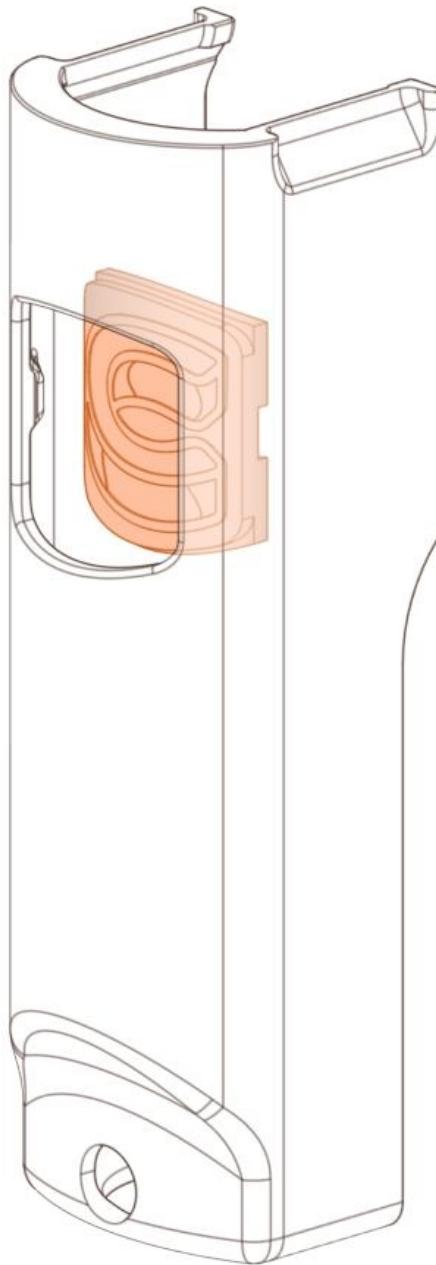




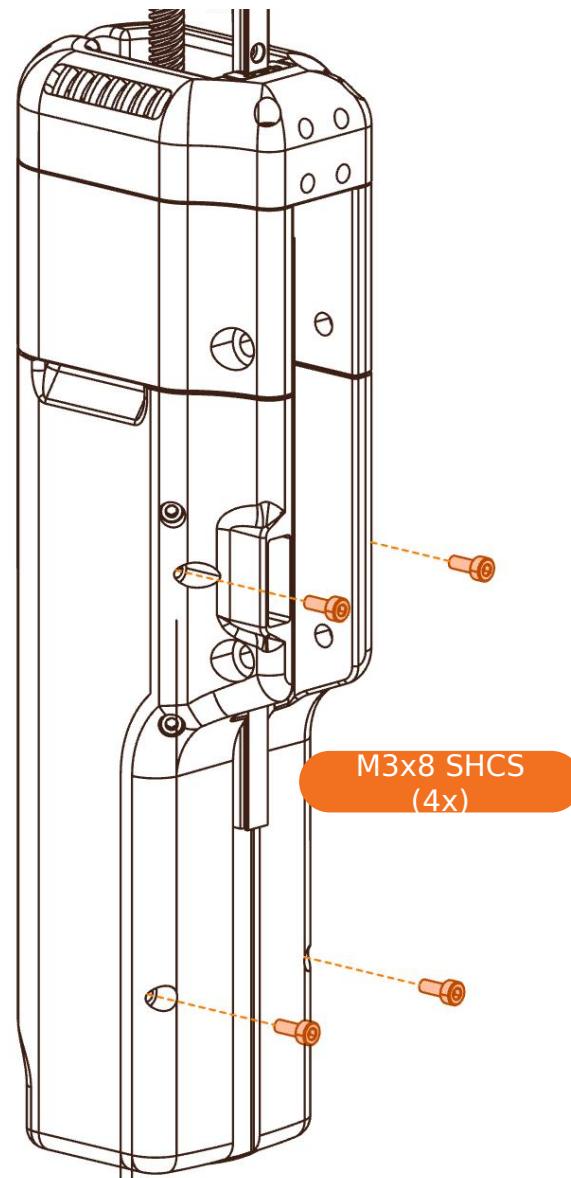
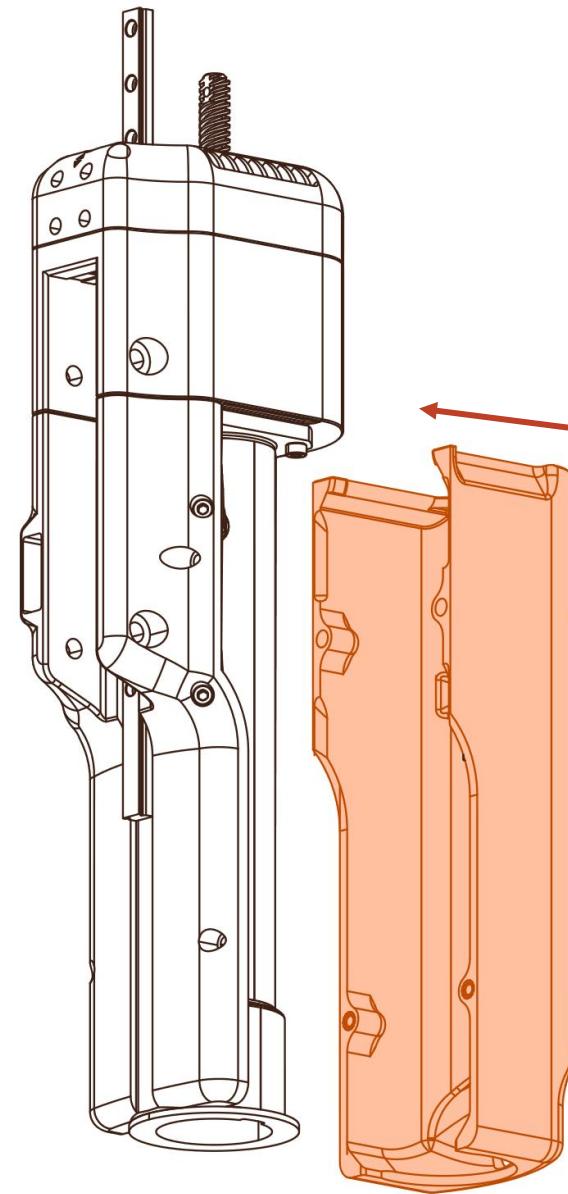
#### WIRE ROUTING

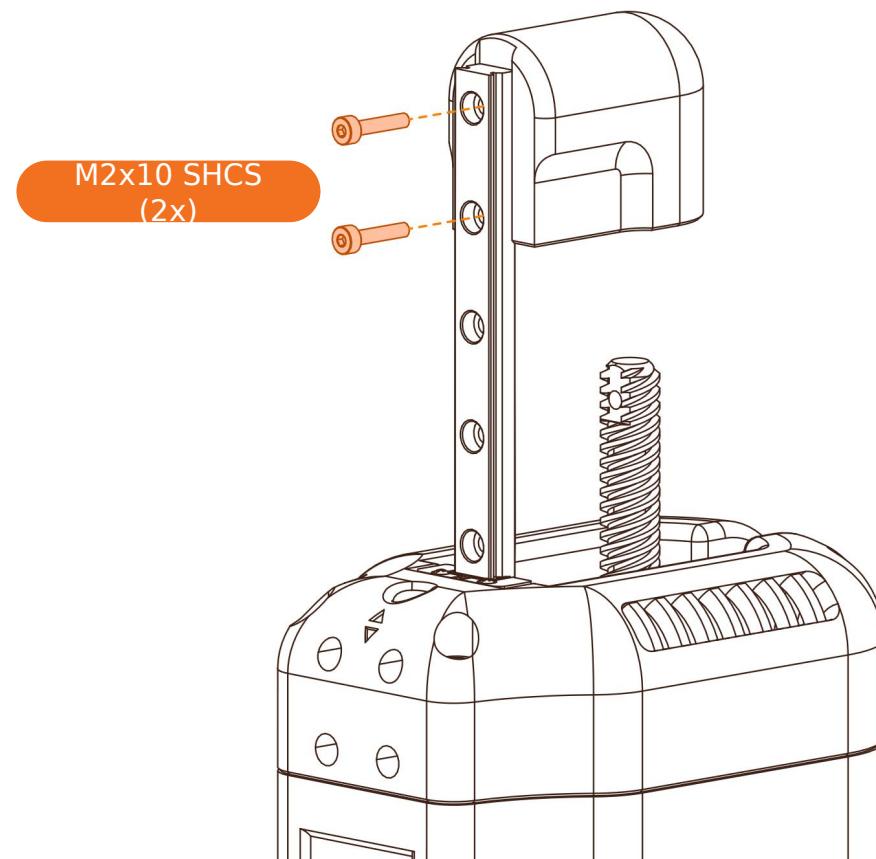
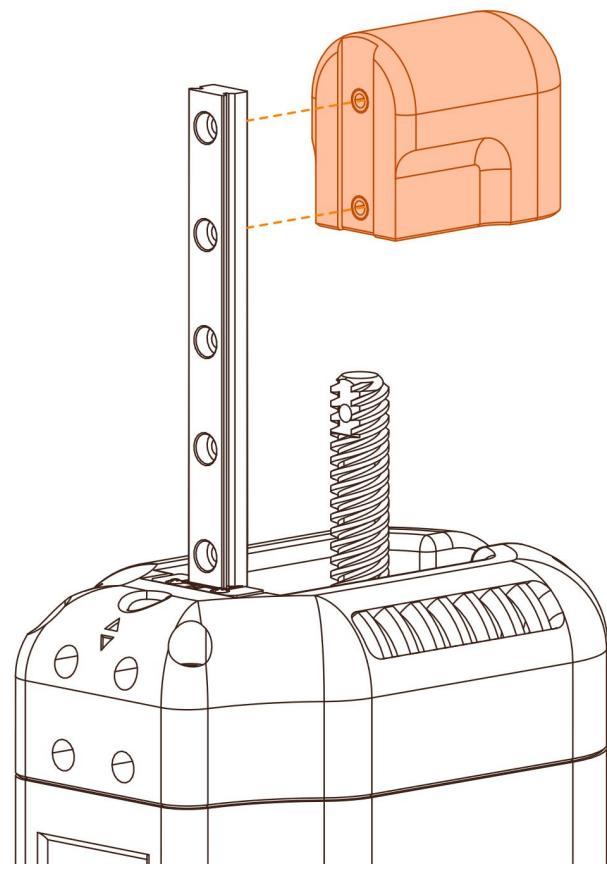
The wires for both heaters and the extruder motor will feed through the hole in the printed part highlighted here.

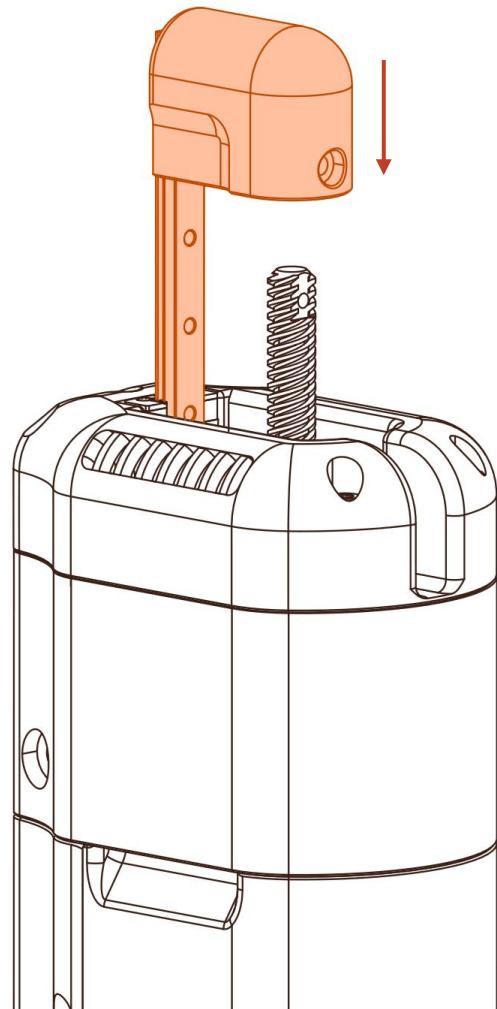
Use the zip tie mounts on the opposite side to hold the heater wires in place to avoid strain.

**DO IT FOR THE BRAND**

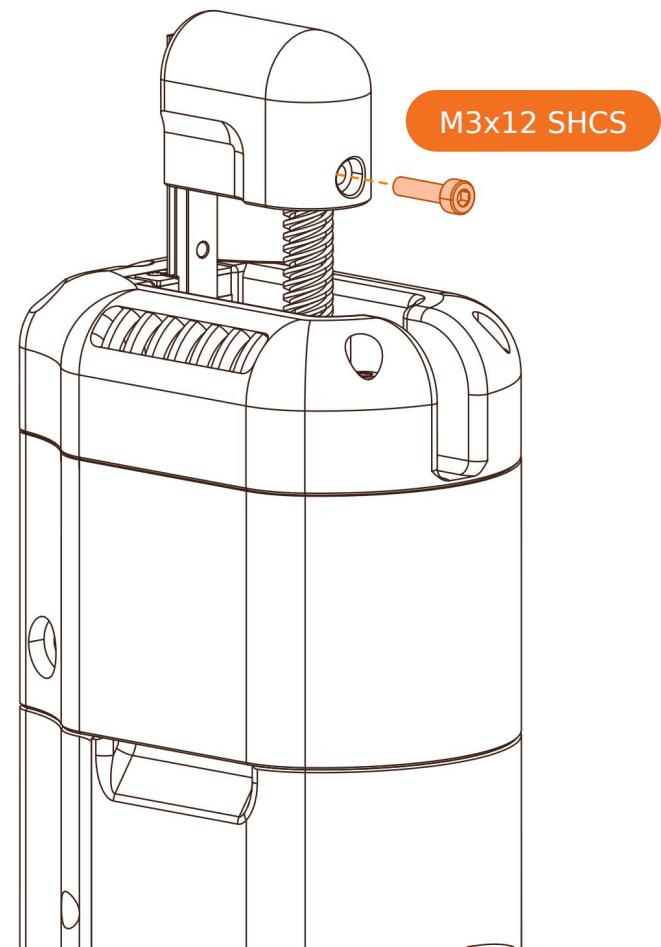
The logo insert clips into place from the inside of the shroud.

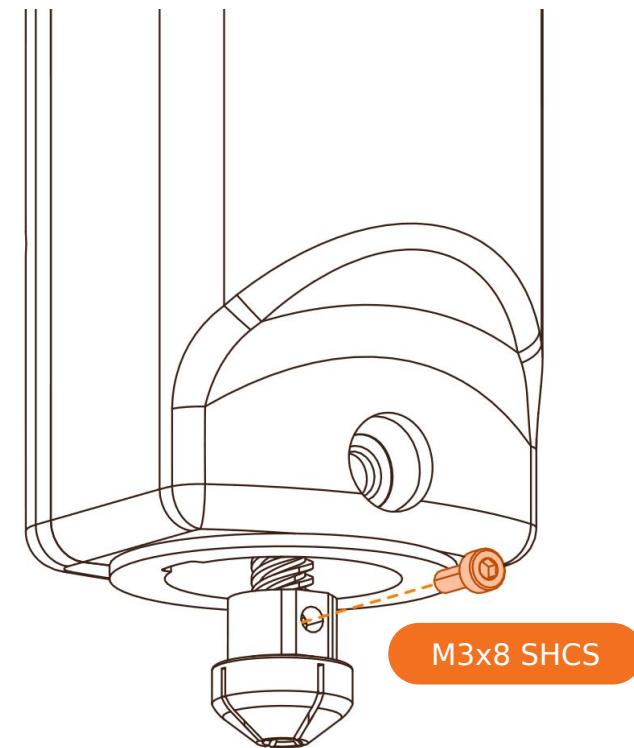
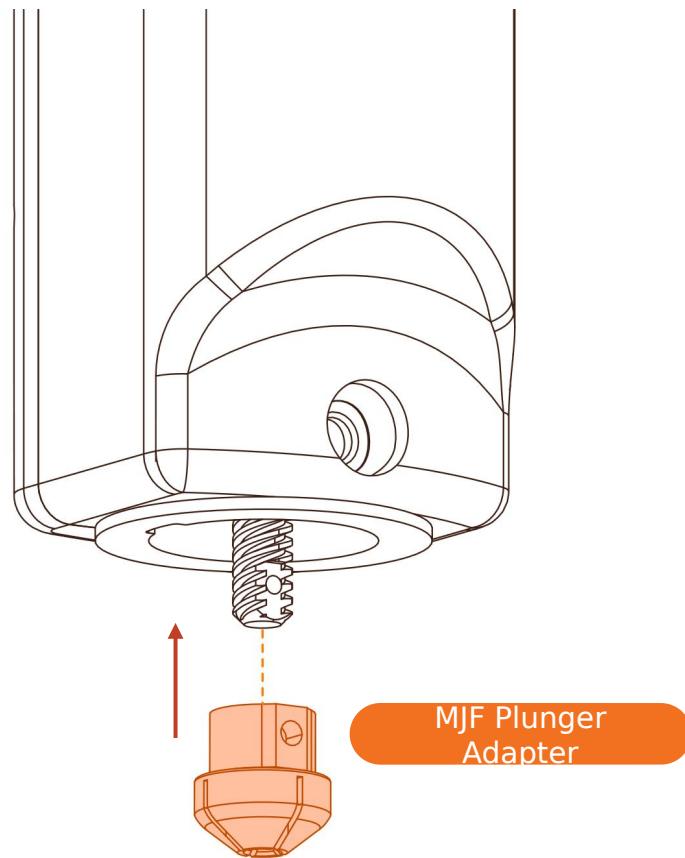


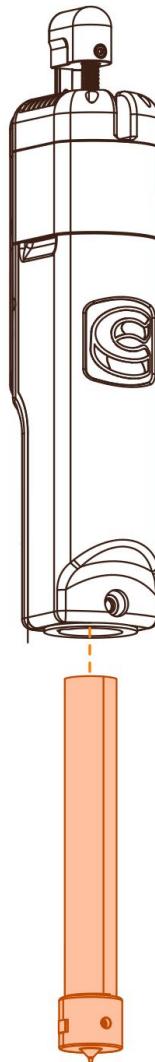


**LEADSCREW FLATS**

The leadscrew has two flats machined into it, make sure they are positioned front to back to that the leadscrew fits into the printed part.

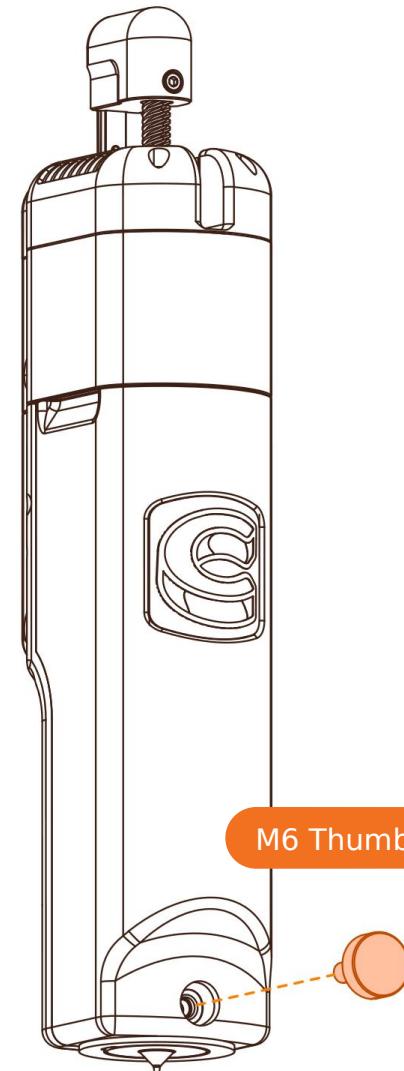


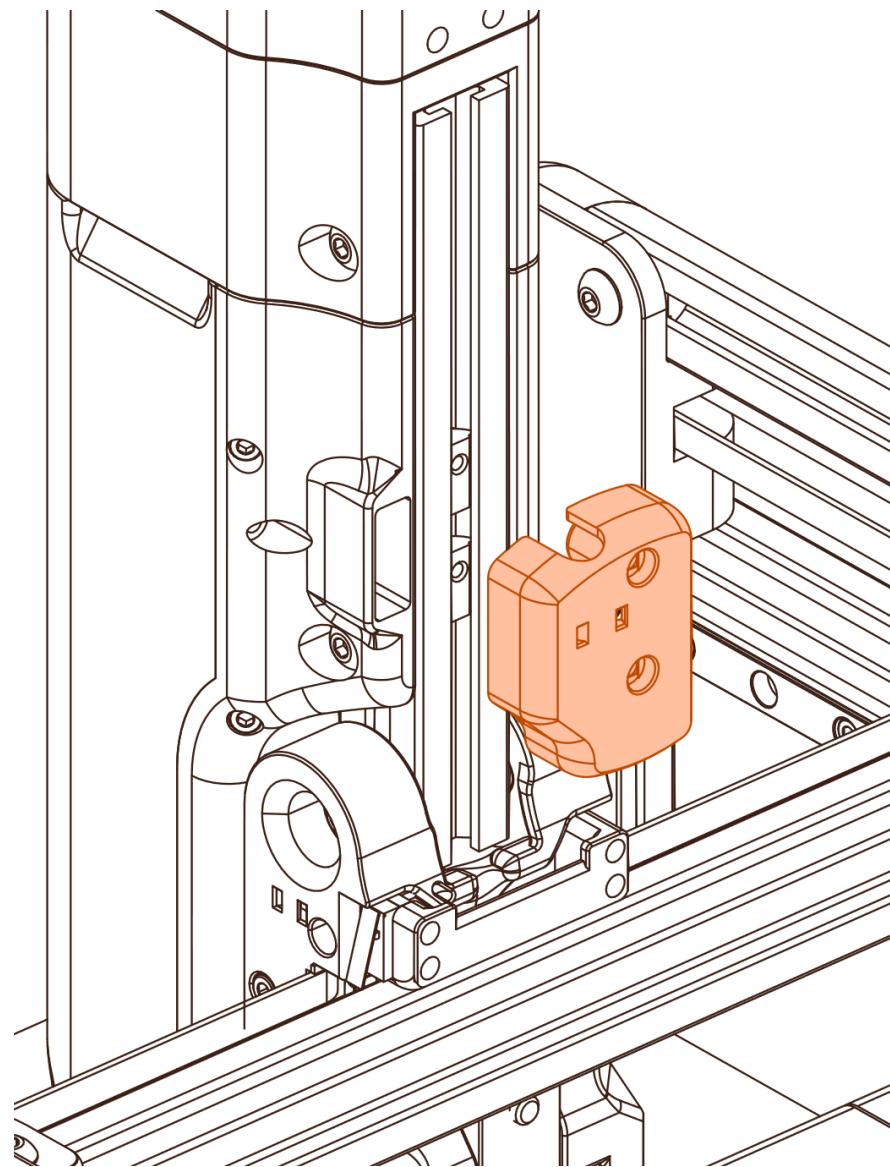
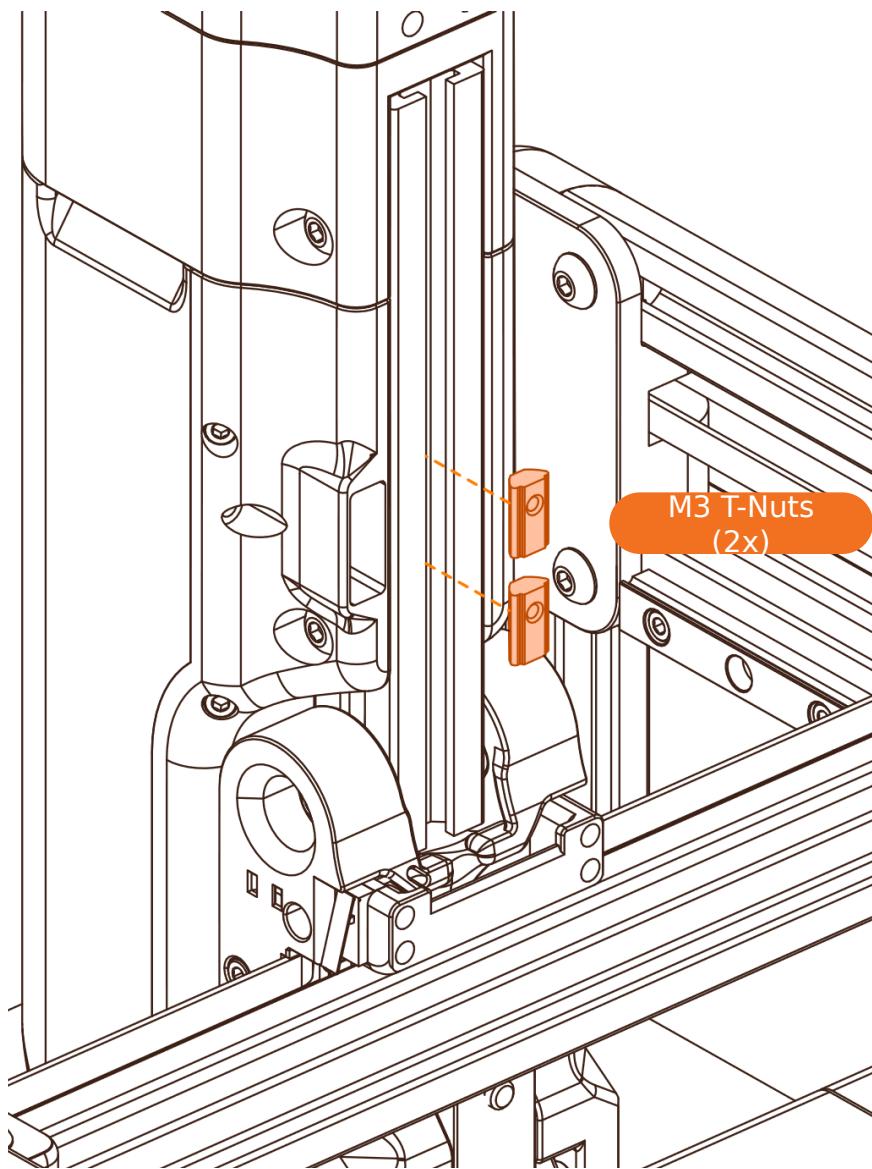


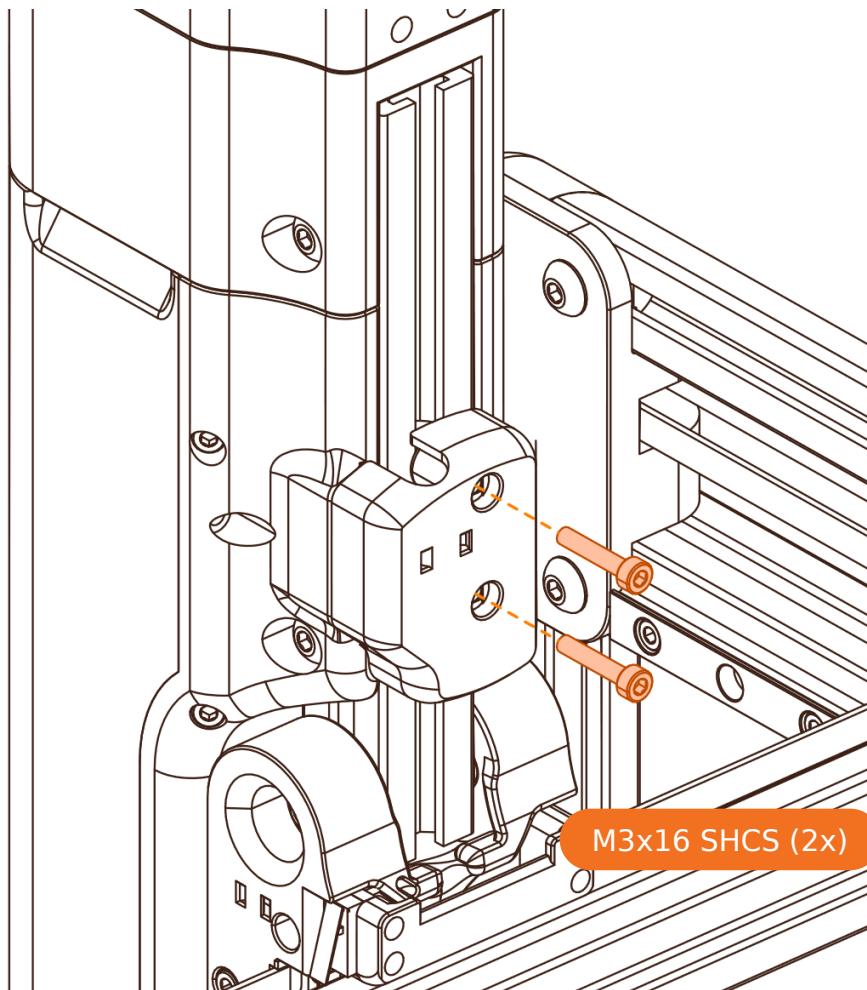
**NOZZLE CARTRIDGE**

It is a good idea to thoroughly wash the nozzle and cartridge parts as they may have contaminates from the bead blasting process.

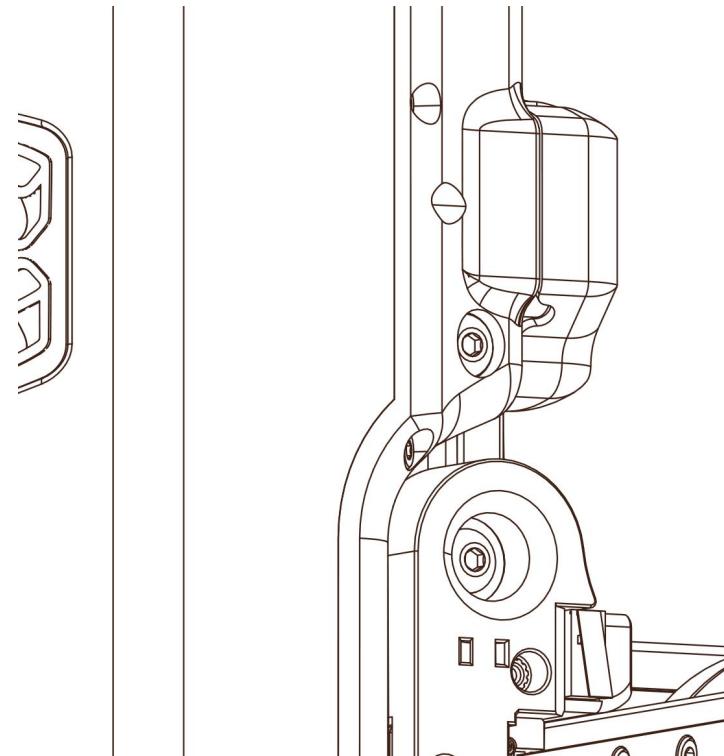
These components directly contact the chocolate and should be cared for like any other food contact items in your kitchen.



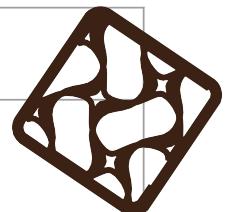
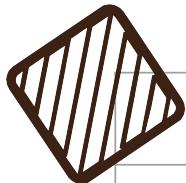


**PINCH WARNING**

Take care to not crush any cables when securing the toolhead cables through the Extruder Cable Cover. Damaging the Inductive Probe or X Limit Switch will render your printer non-functional.

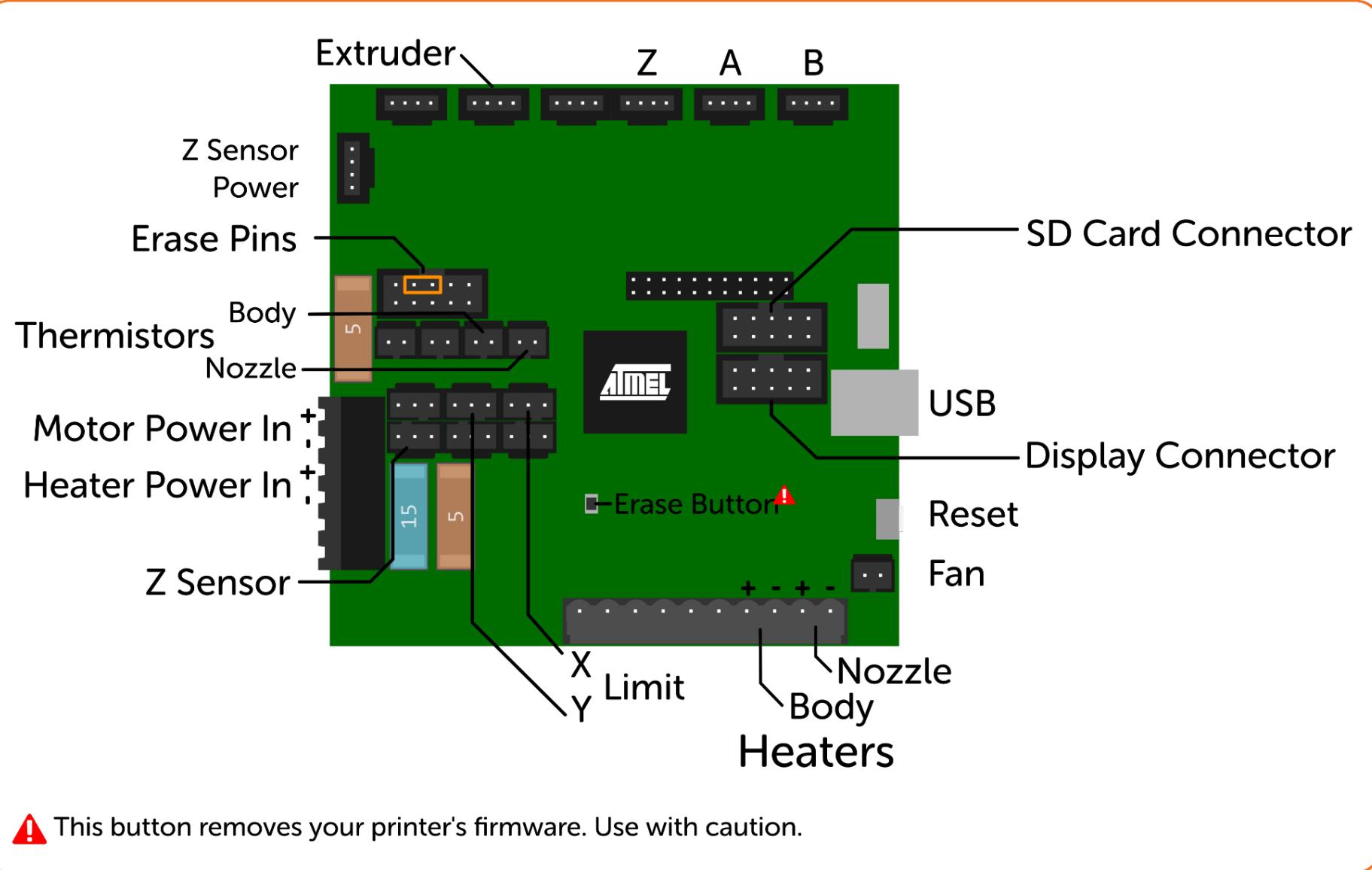






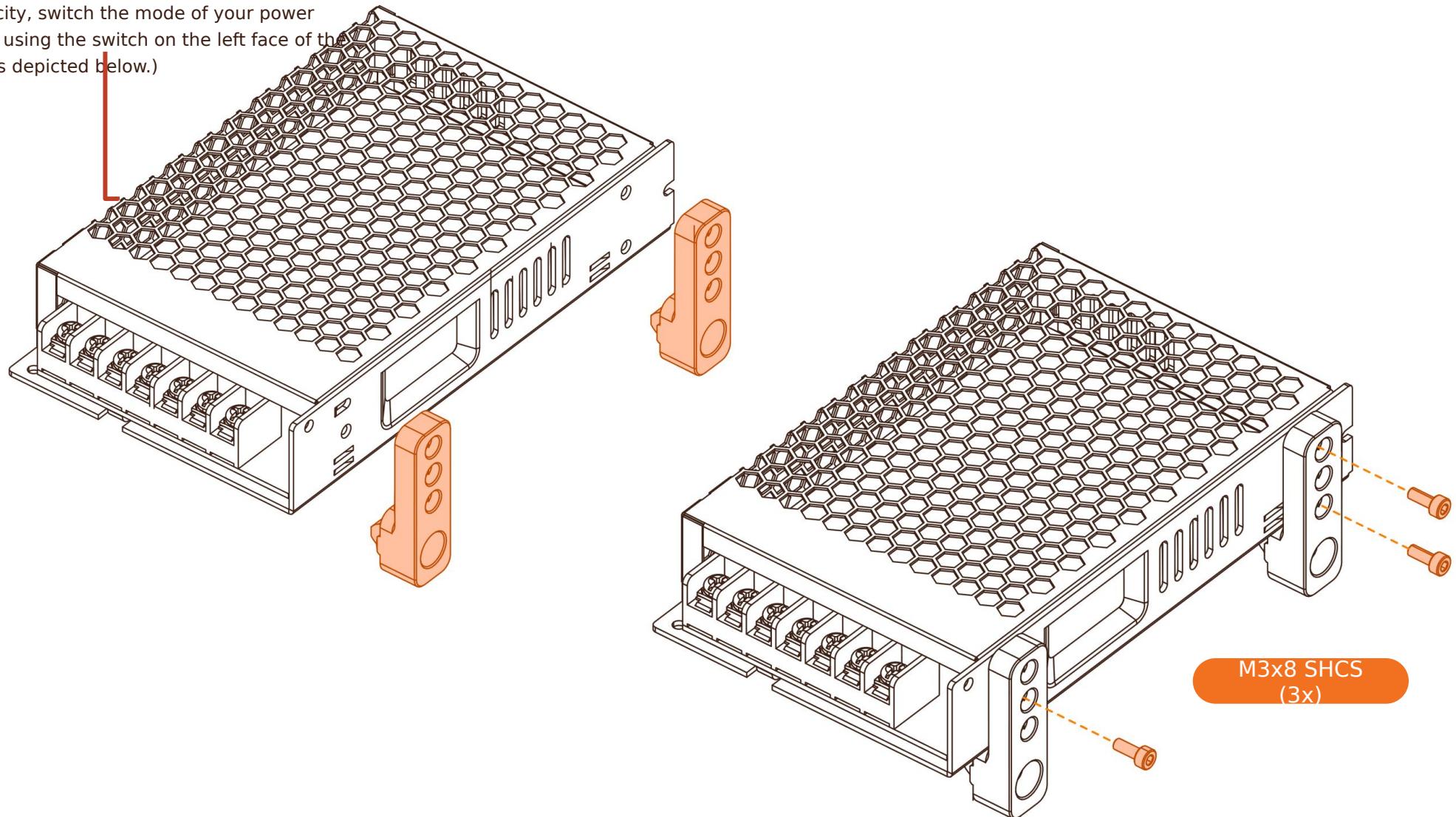
<b>Difficulty</b>	Medium		
<b>Tools Needed</b>	M3 Driver M5 Driver Phillips Driver Soldering Iron (Not Included)		
<b>Hardware Needed</b>	M3x8 Socket Head Cap Screw (12x) M5 T-Nuts (2x) M3 T-Nuts (7x) M5x10 Button Head Cap Screw (2x) M3x8 Button Head Phillips Screw (2x)		Power Supply Cable (1x) Archim2 Power Cable (1x) Erase Button (1x)
<b>Printed Parts Needed</b>	PSU Bracket (2x) Inlet Bracket (1x) Plug Panel (1x) Archim2 Top Bracket (1x) Archim2 Bottom Bracket (2x)		Wire Anchor (4x) PSU Cover (1x) Erase Button Jig (1x)

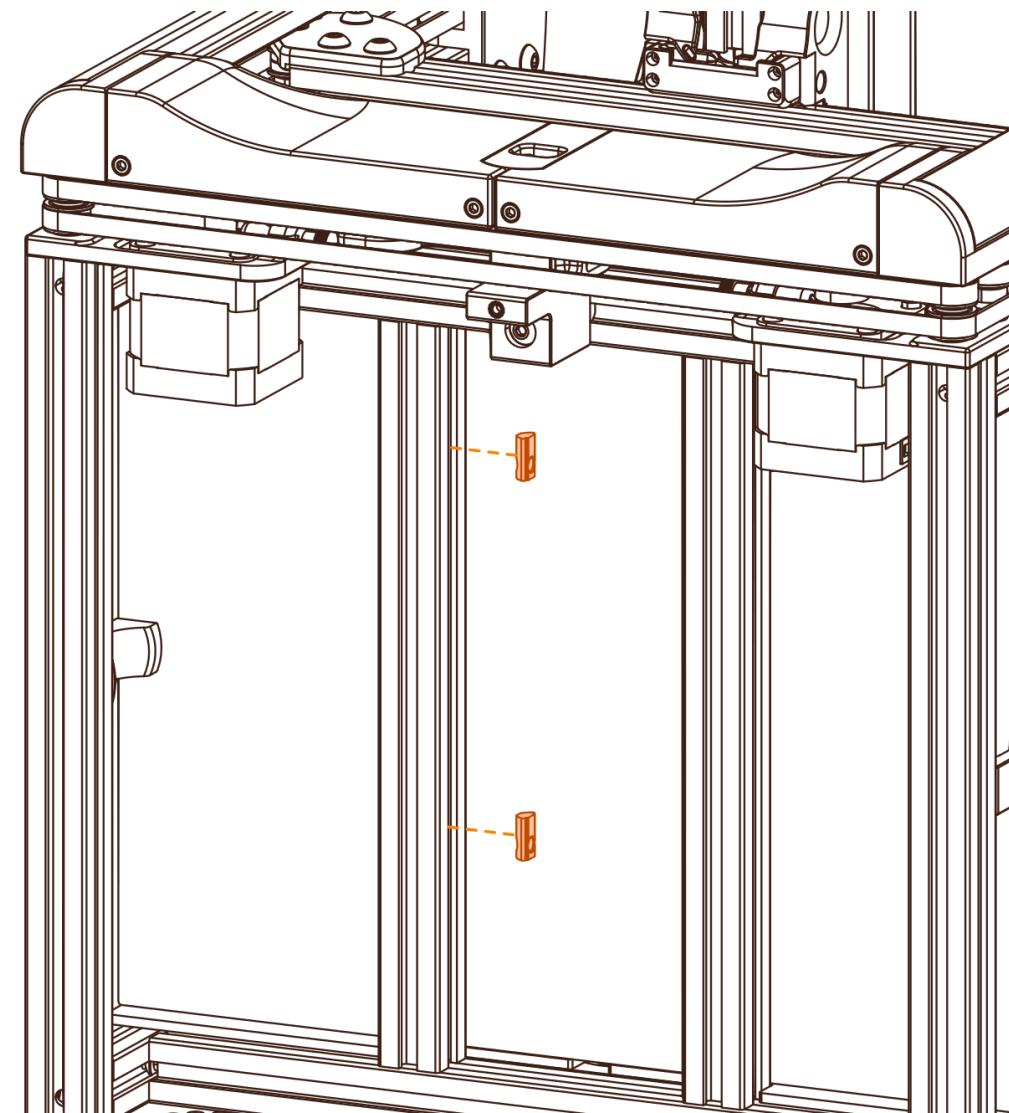




**TURN IT OFF/ON, FLIP FLIP**

If in a region that does not use 110VAC mains electricity, switch the mode of your power supply using the switch on the left face of the unit (as depicted below.)

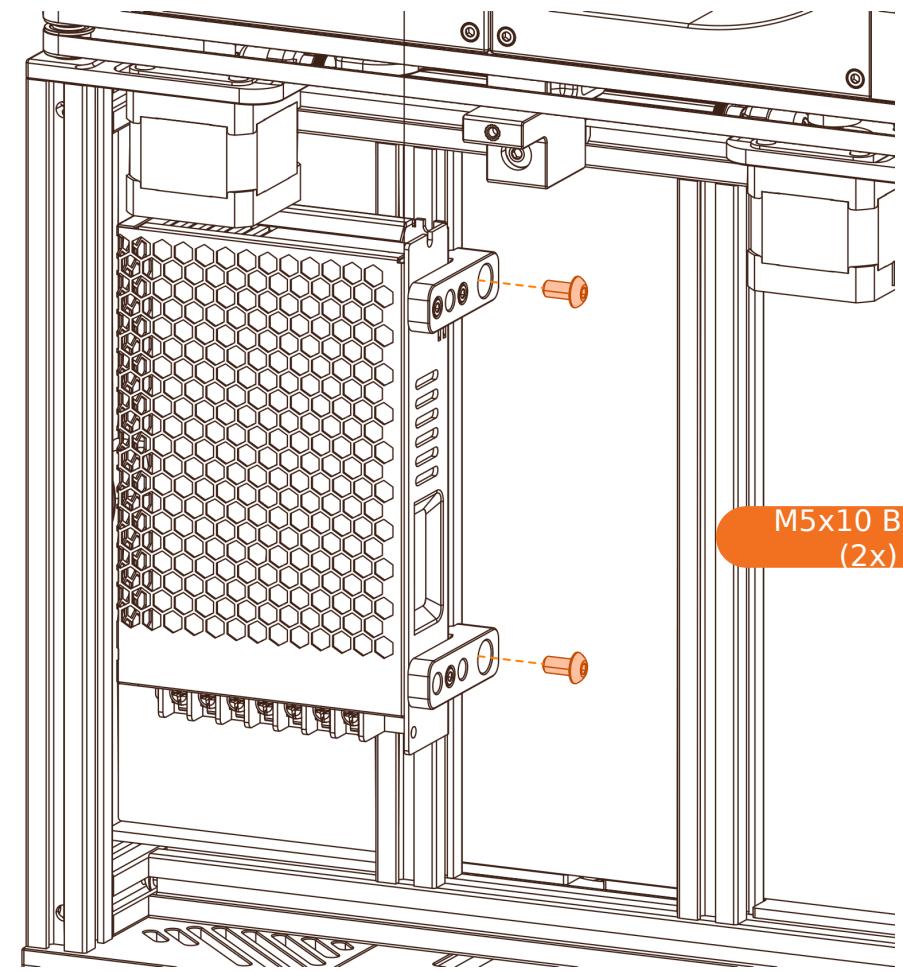
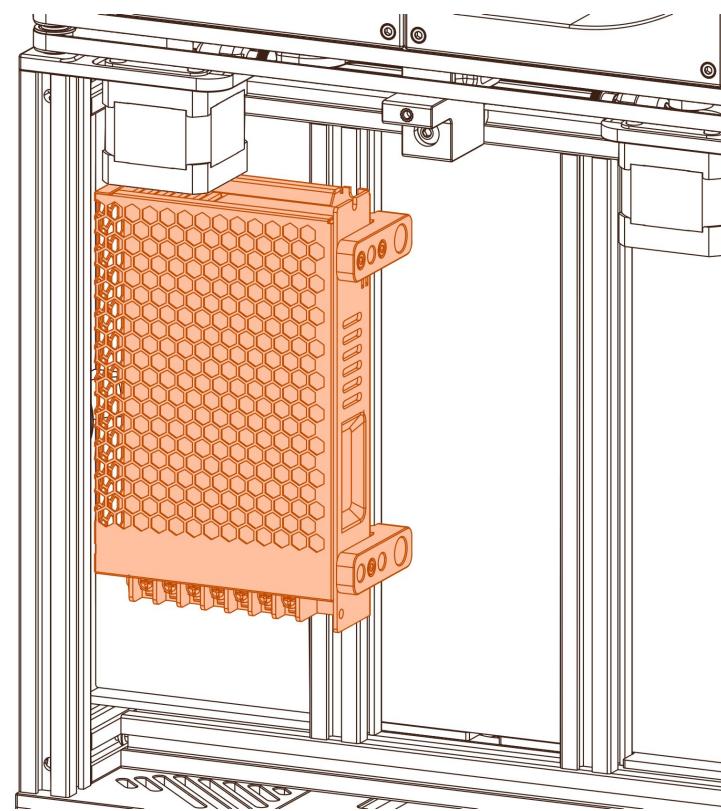




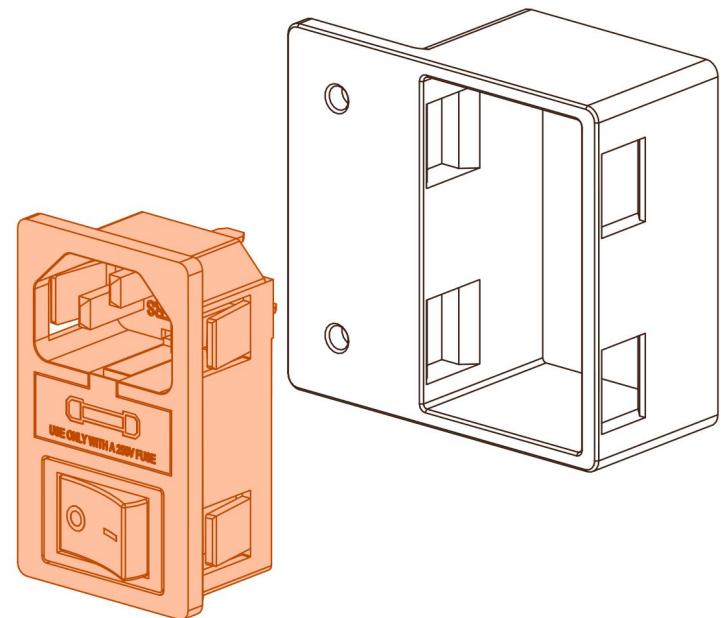
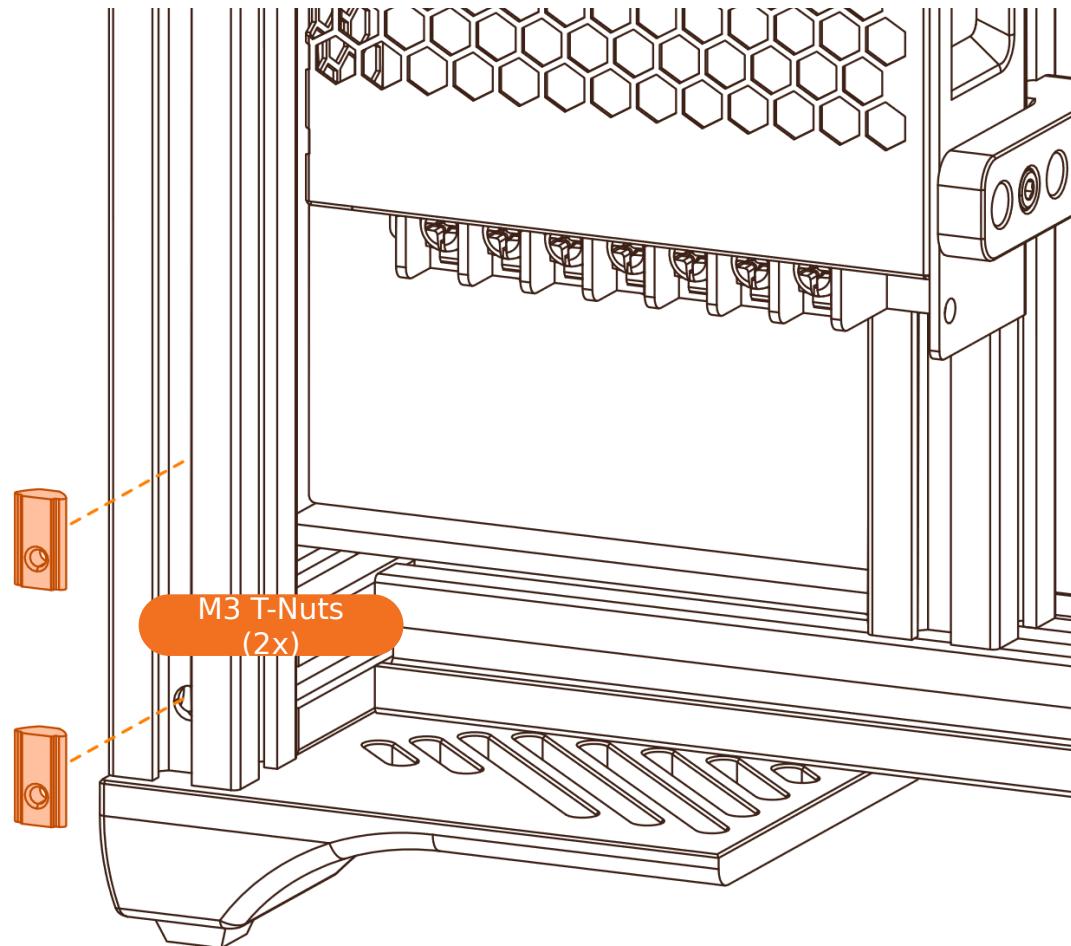
M5 T-Nuts  
(2x)

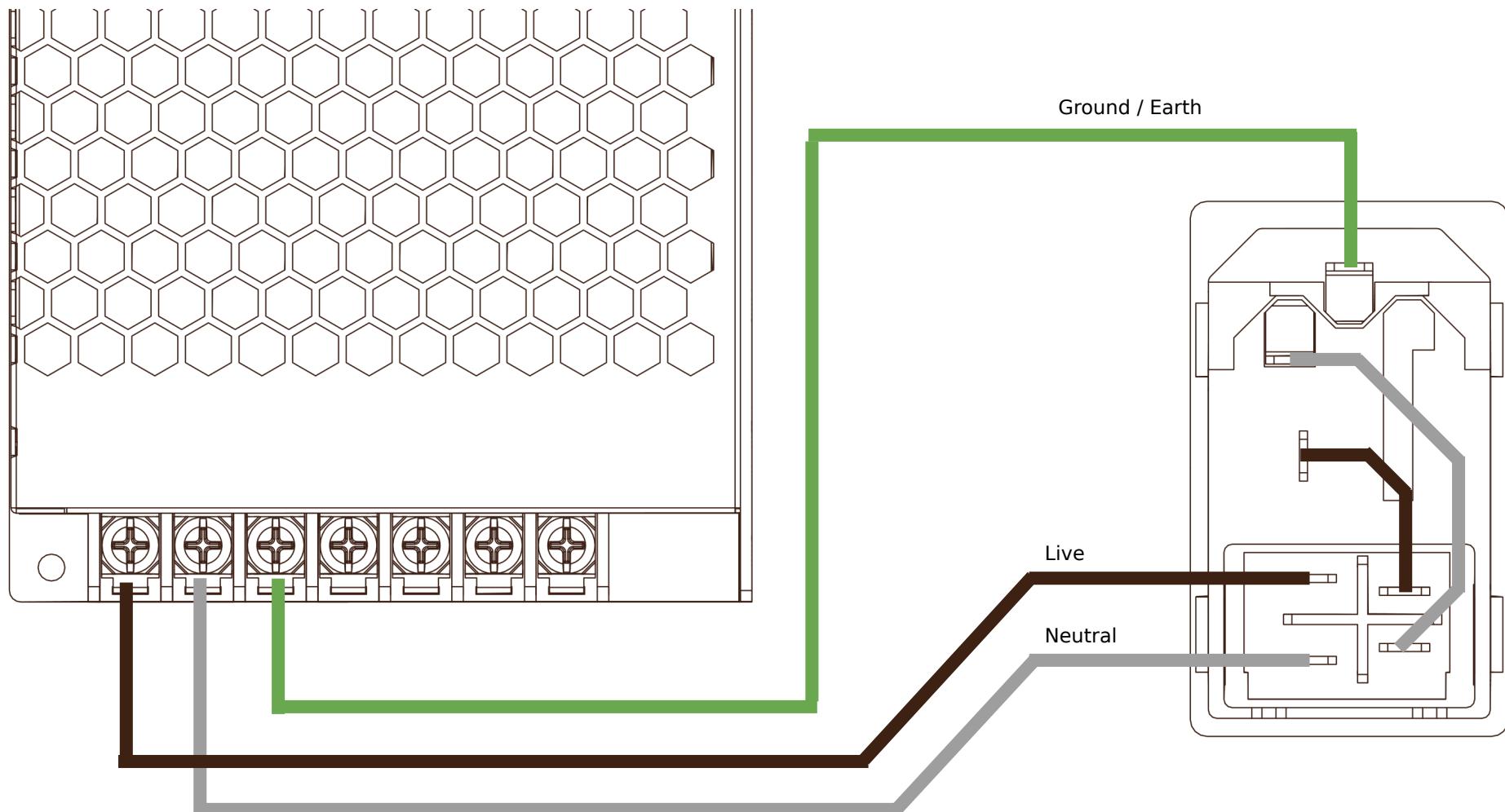
**"I'M NOT TOUCHING YOU"**

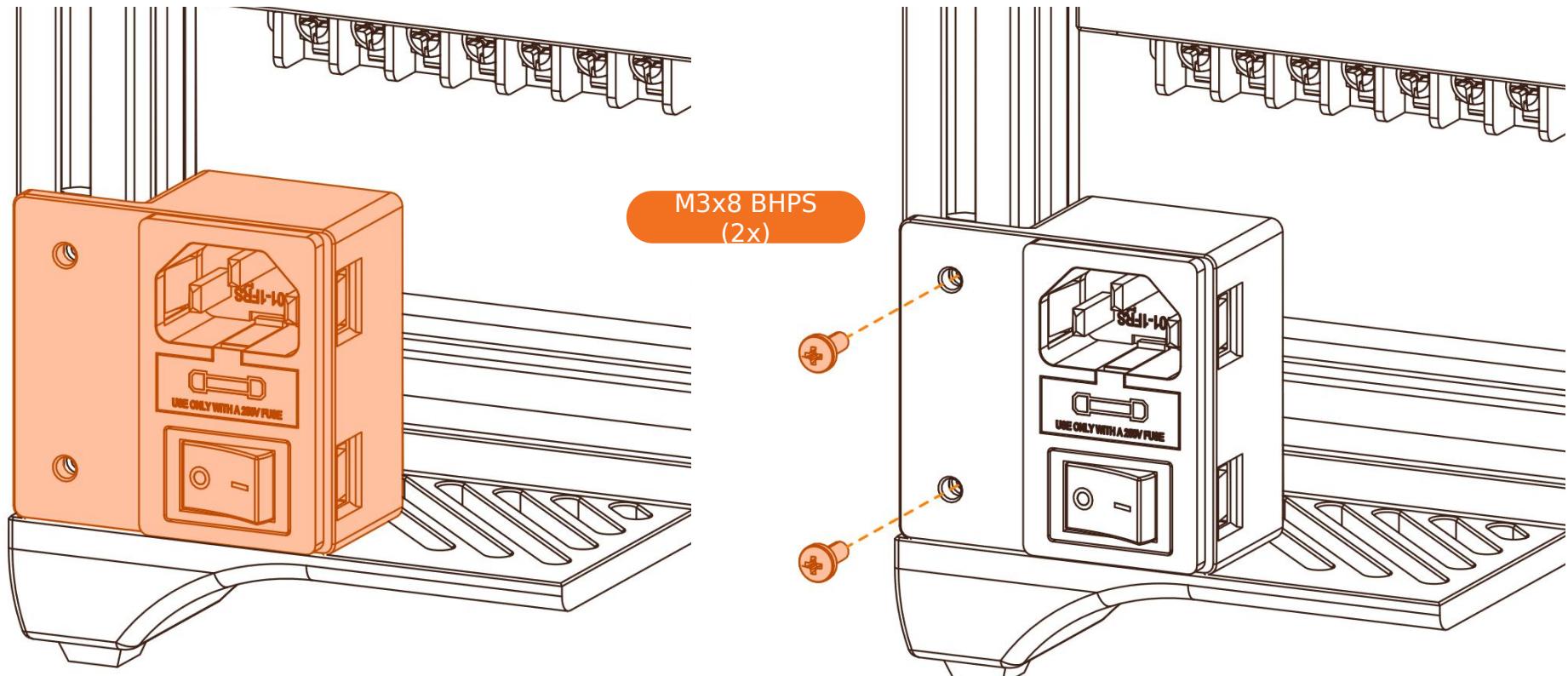
The power supply should be slid along the rail to touch the stepper motor above it, and then slid back off, by approximately 20mm. This makes wire routing easier later, as well as ensures airflow around both units.



M5x10 BHCS  
(2x)

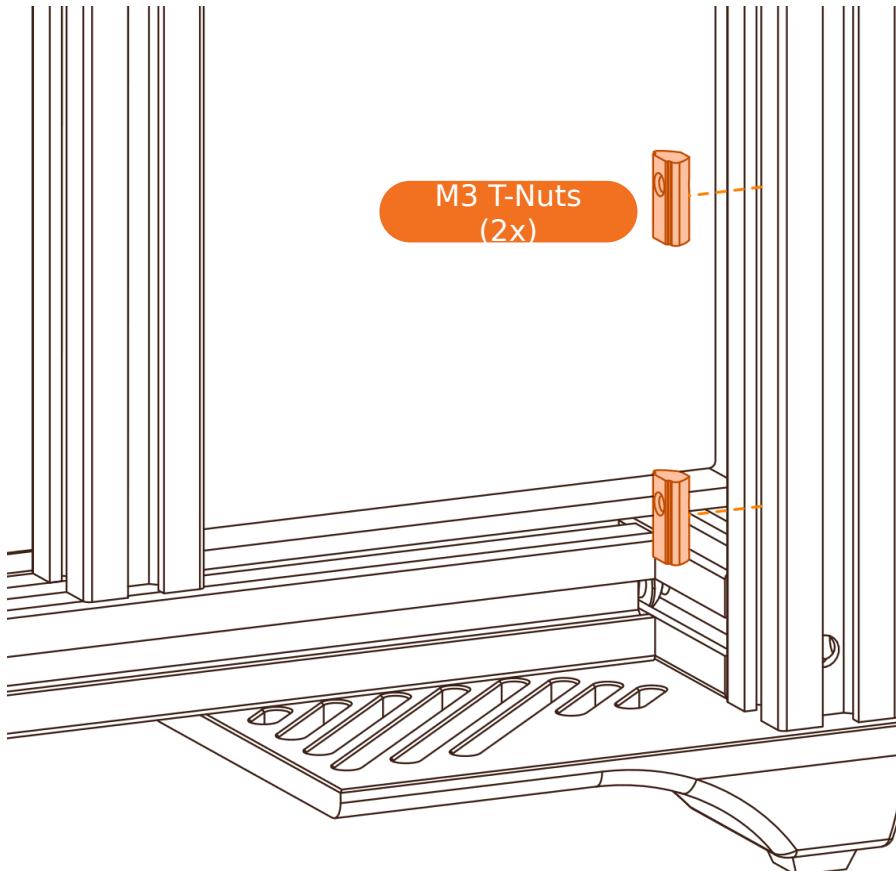






#### POWER CONNECTOR

Install wires to carry mains voltage from the IEC14 socket to the power supply now, *before* mounting it to the frame.

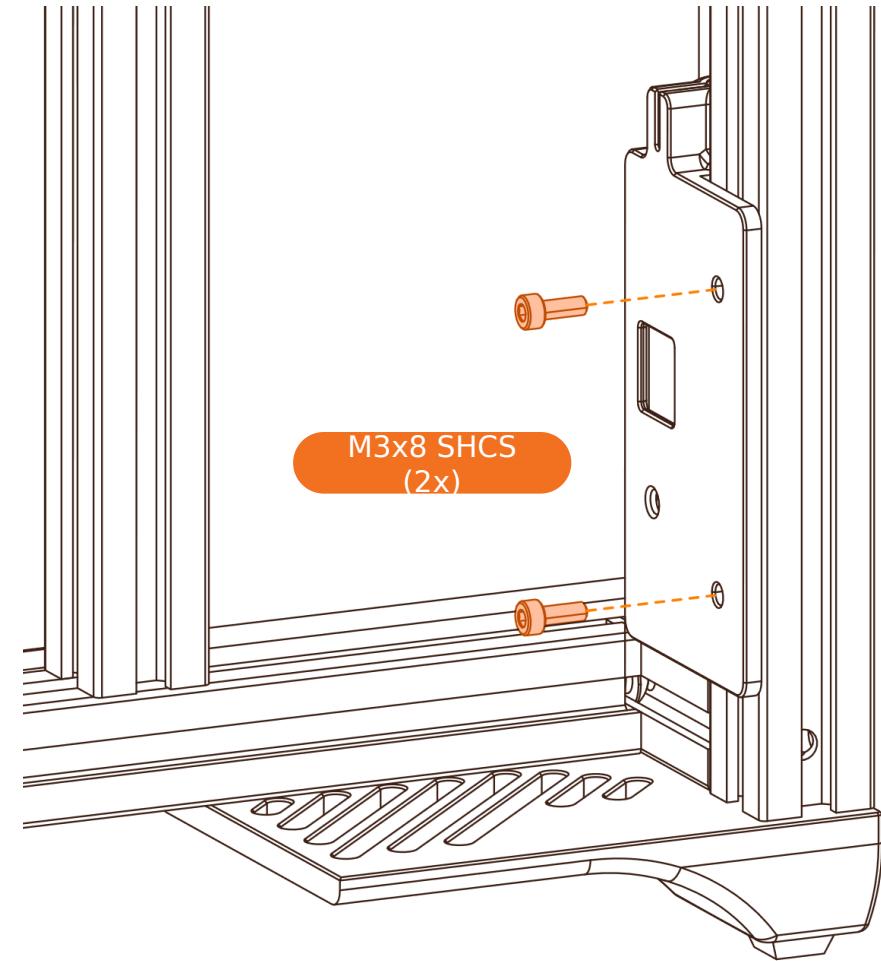
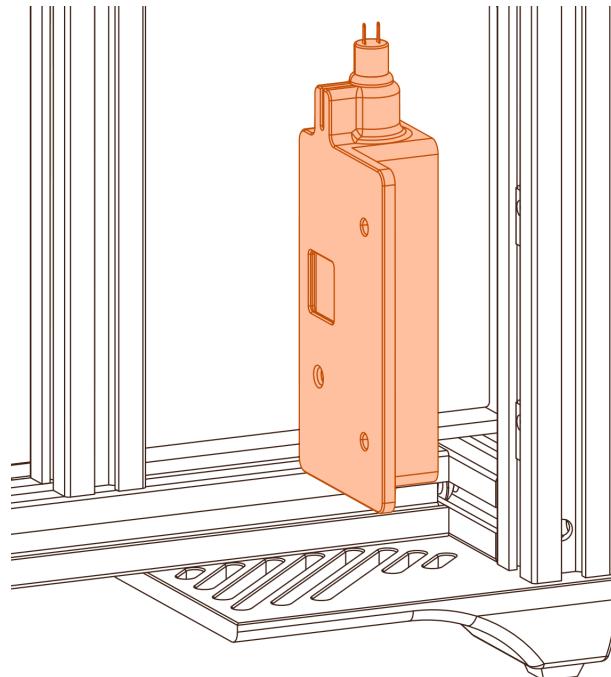


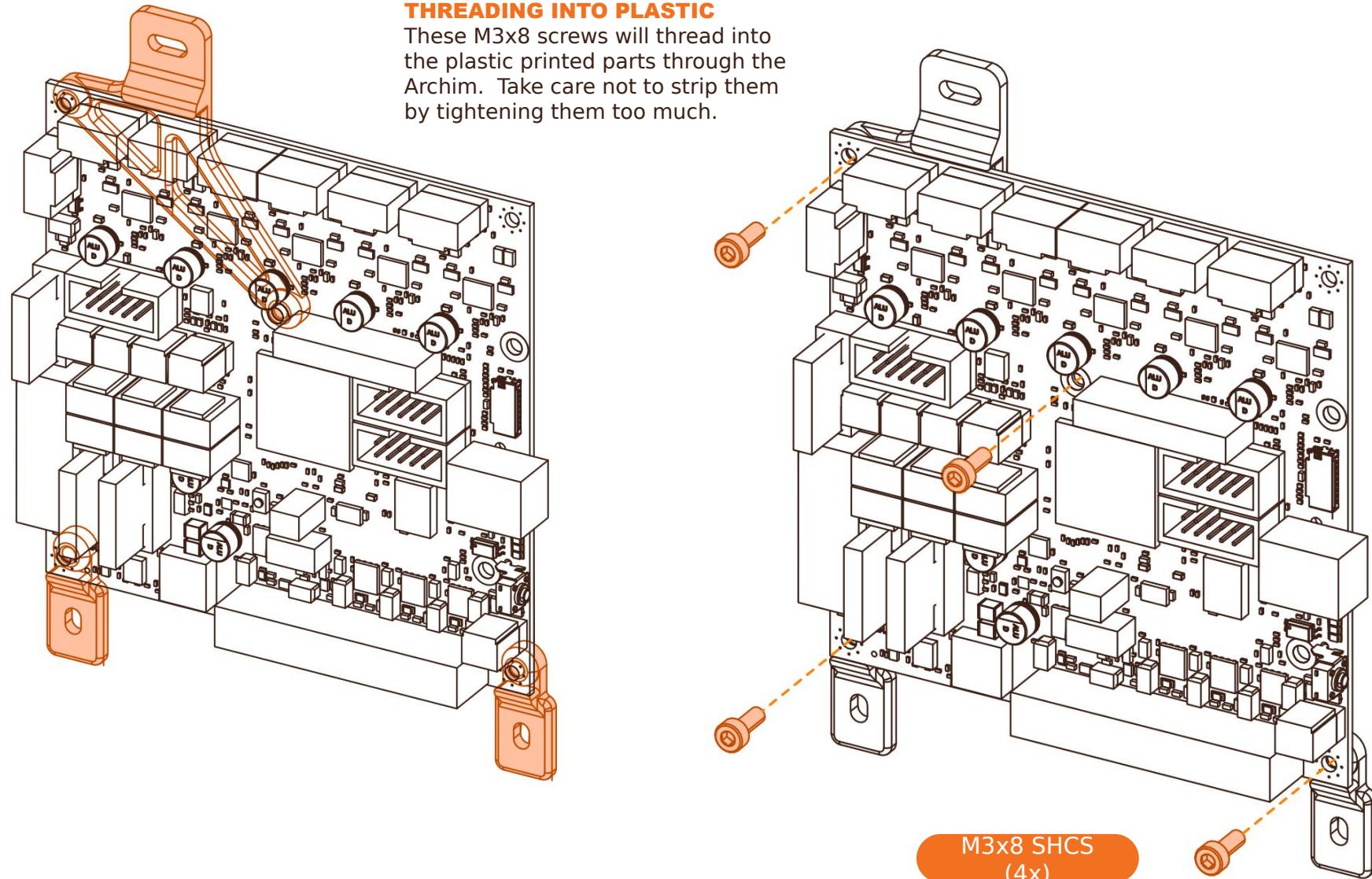
**NUT-THING REALLY MATTERS...**

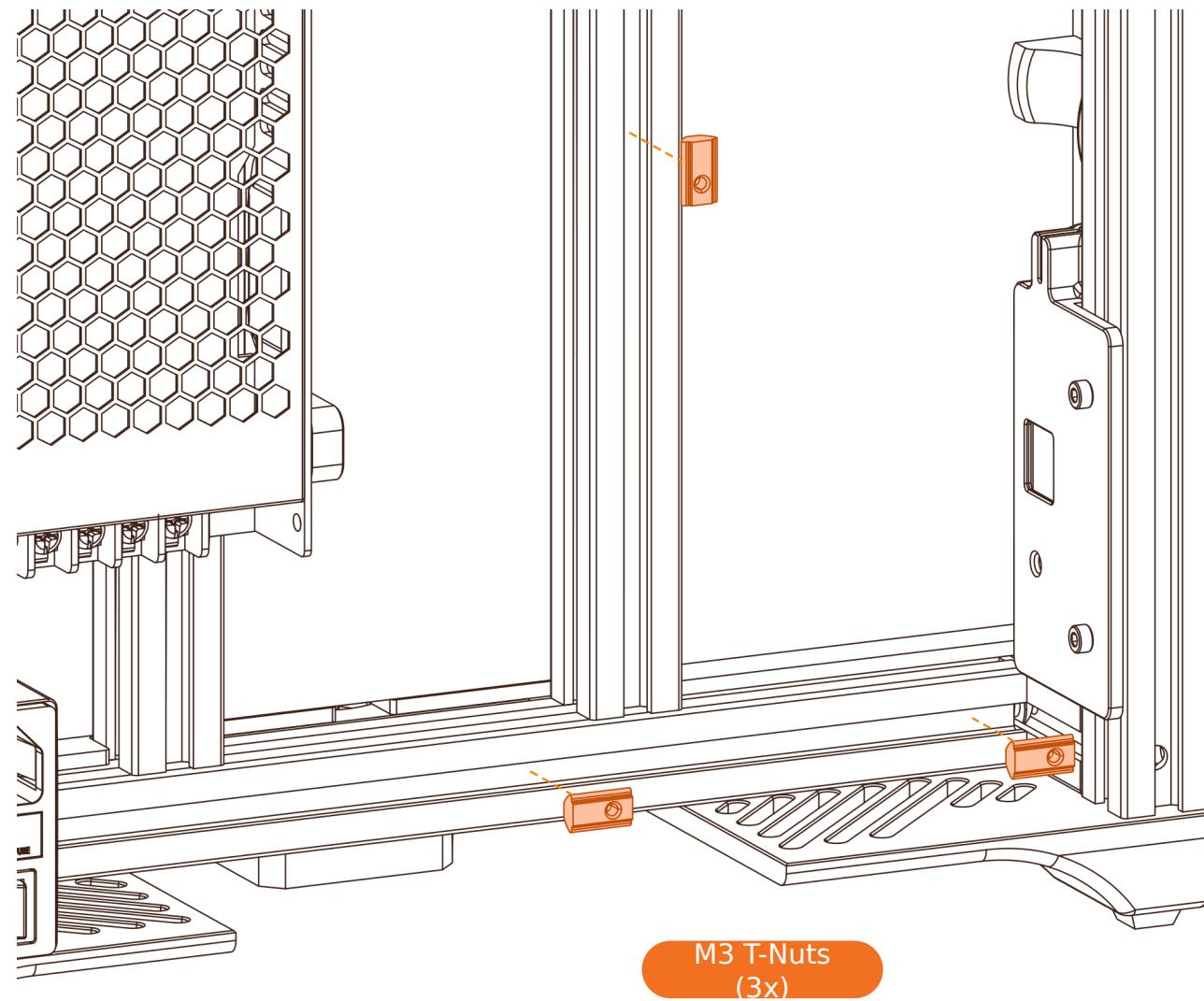
Be sure to remove the locking nut from the Erase Button before installation, as you otherwise may not be able to use the button if necessary.

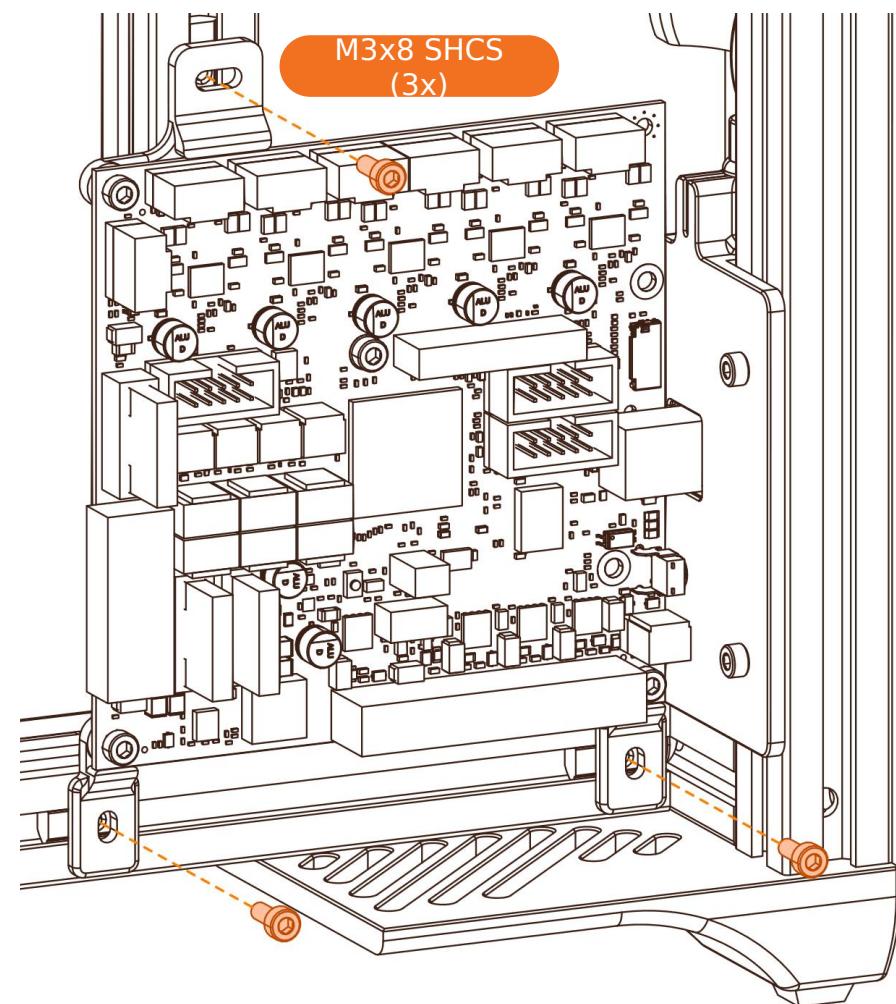
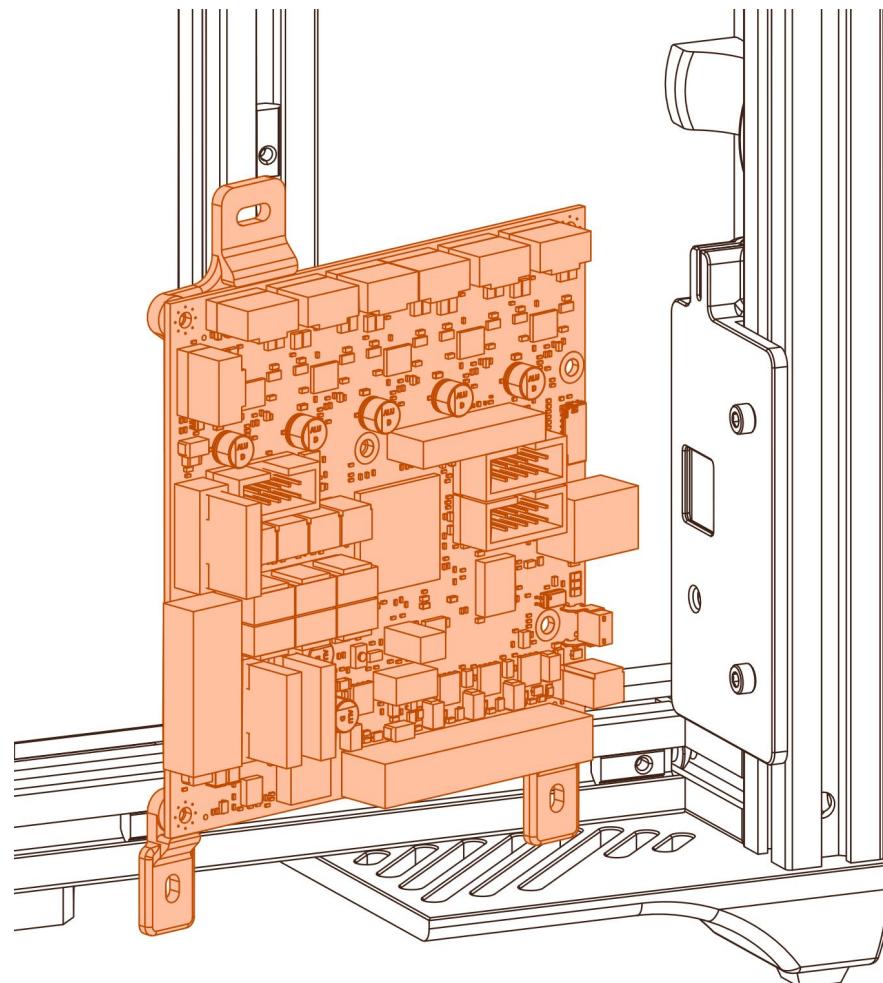
**ANYTHING NOT SAVED...**

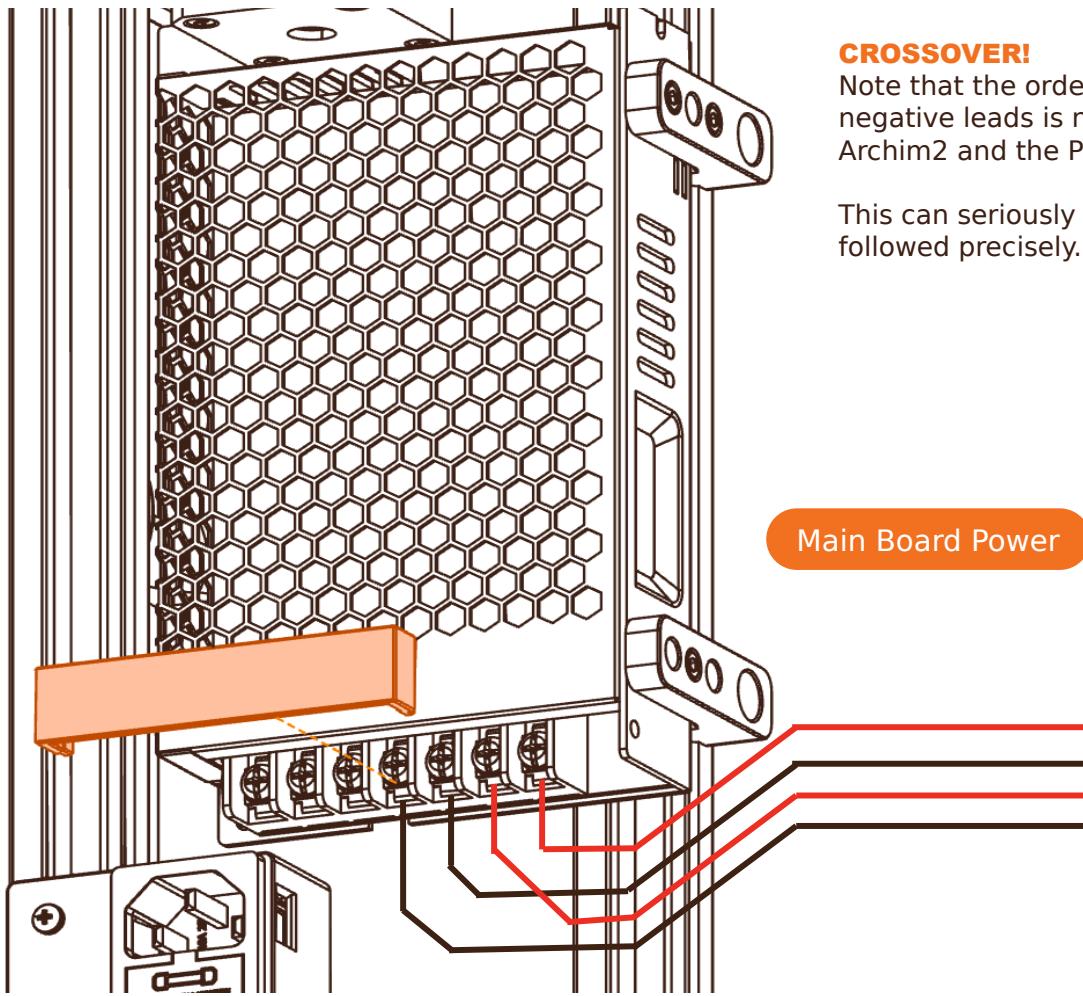
Be sure to add your Erase button into this part before installing it. This allows you to update your Cocoa Press' firmware down the line without taking the back cover off.







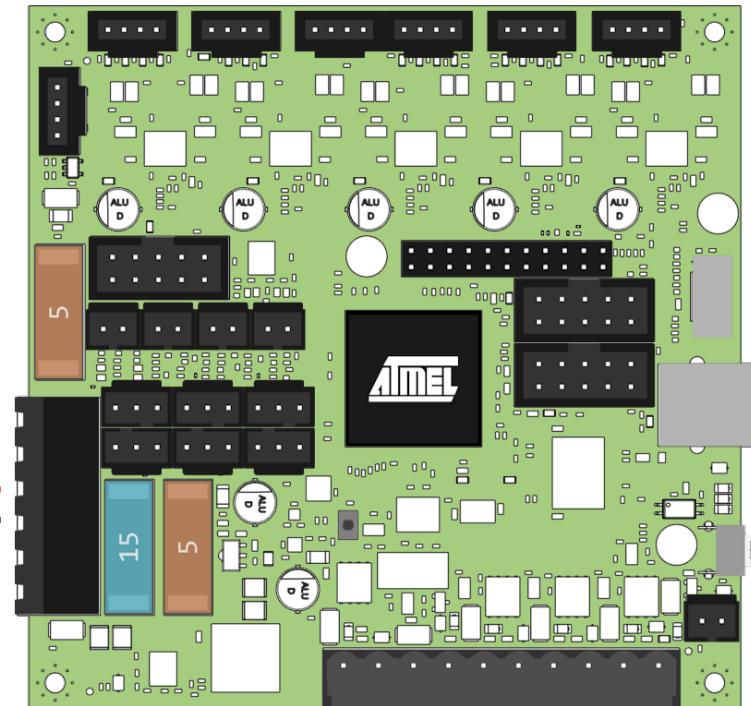


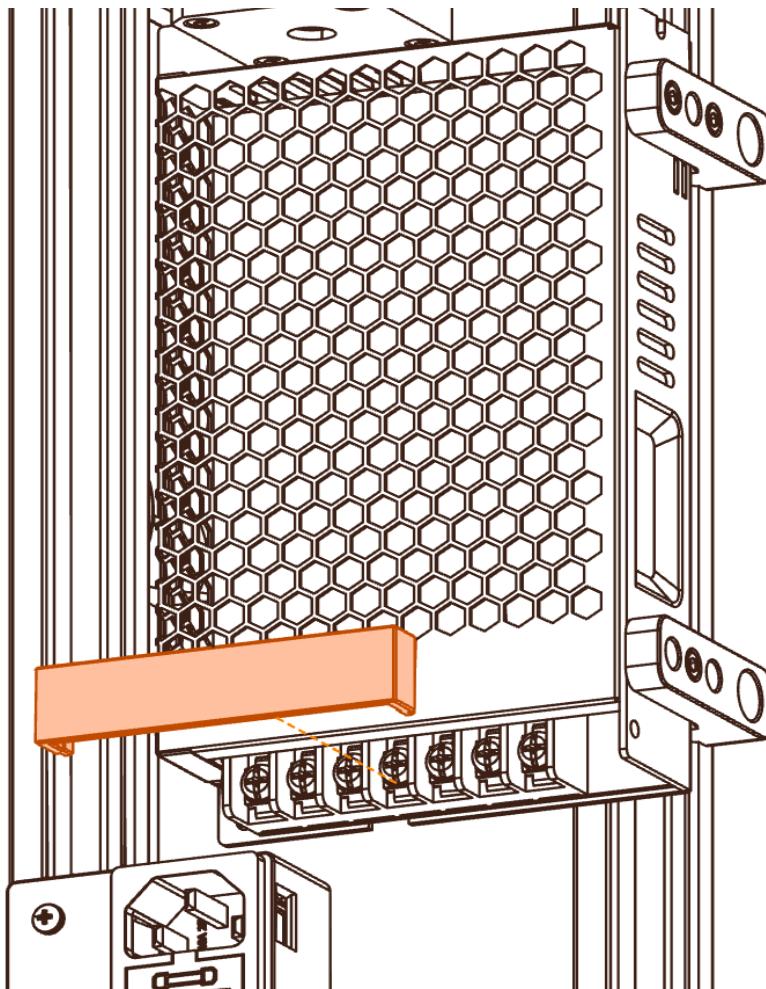


**CROSSOVER!**

Note that the order of the positive and negative leads is not the same for the Archim2 and the Power Supply.

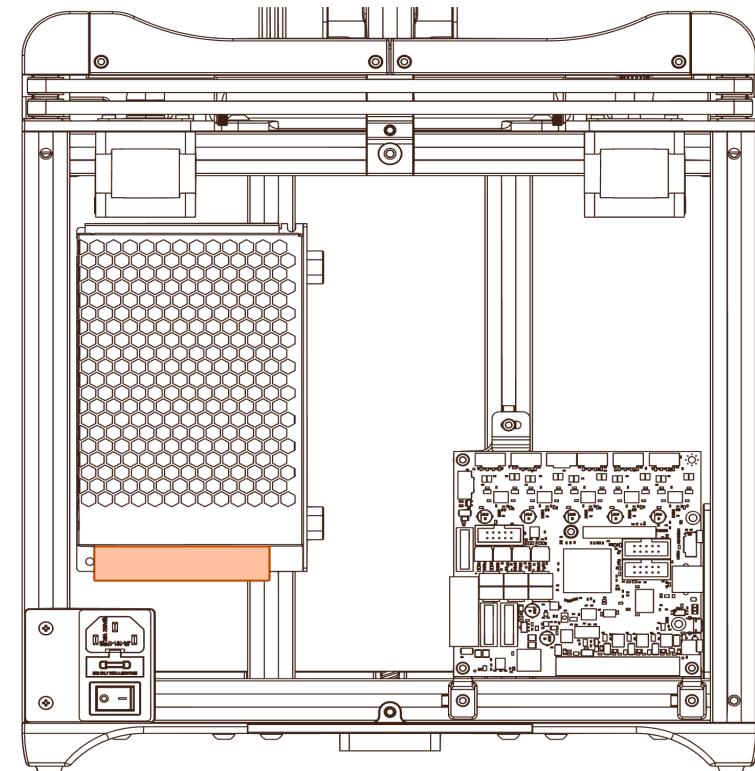
This can seriously damage your printer if not followed precisely.

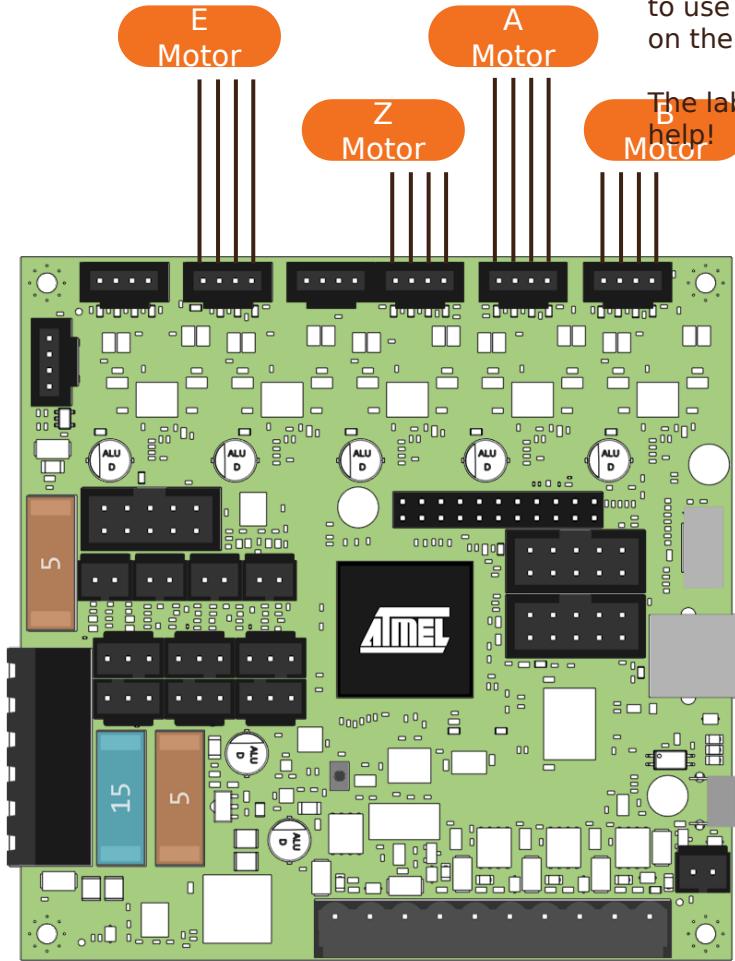




**SO THE MAIN THING IS... DON'T TOUCH  
MAINS**

This cover makes it significantly more difficult to touch the mains voltage terminals wired in from the IEC14 socket right below it. Be sure to install it.

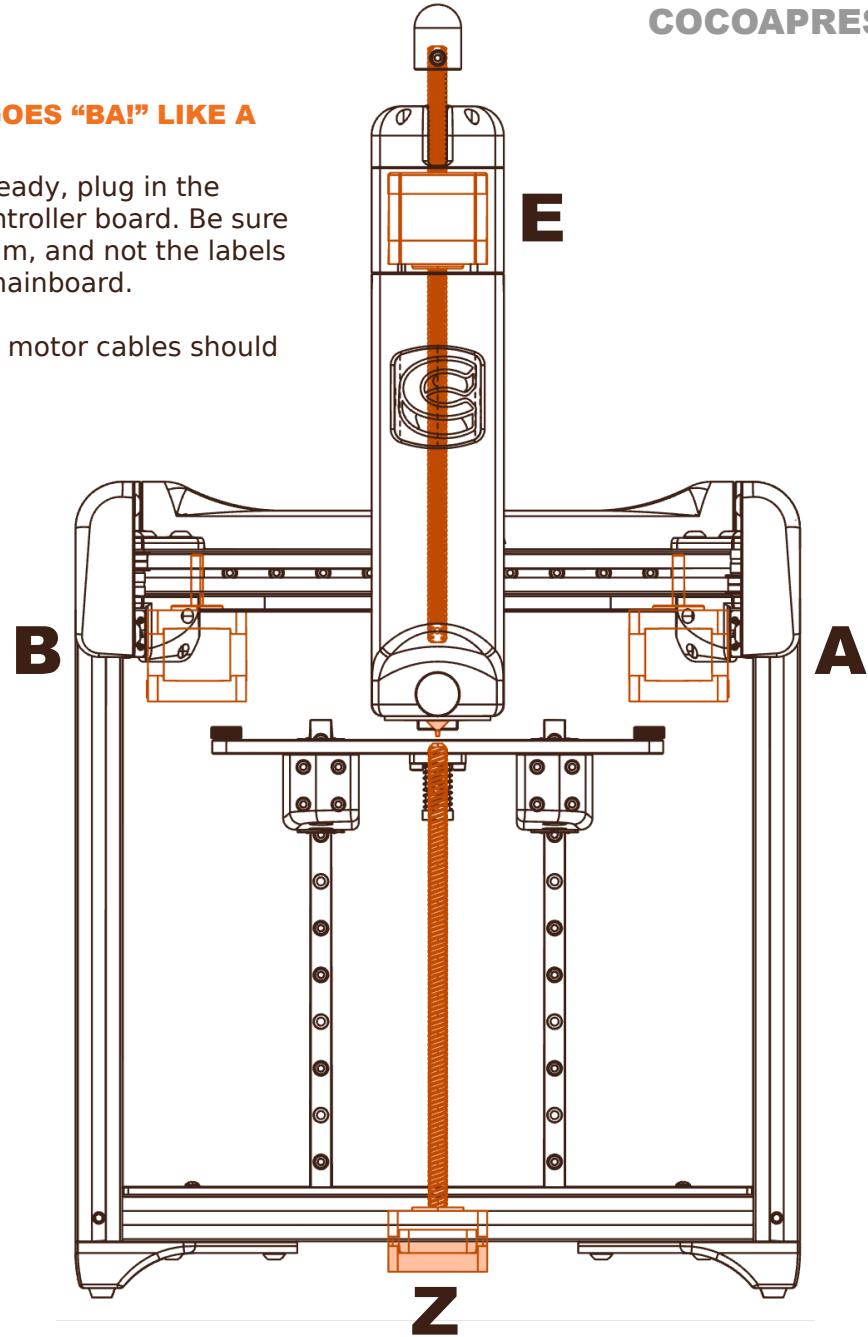




### THE PRINTER GOES “BAI” LIKE A SHEEP

If you haven't already, plug in the motors to the controller board. Be sure to use this diagram, and not the labels on the physical mainboard.

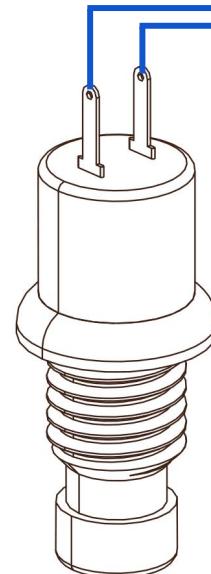
The labels on the motor cables should



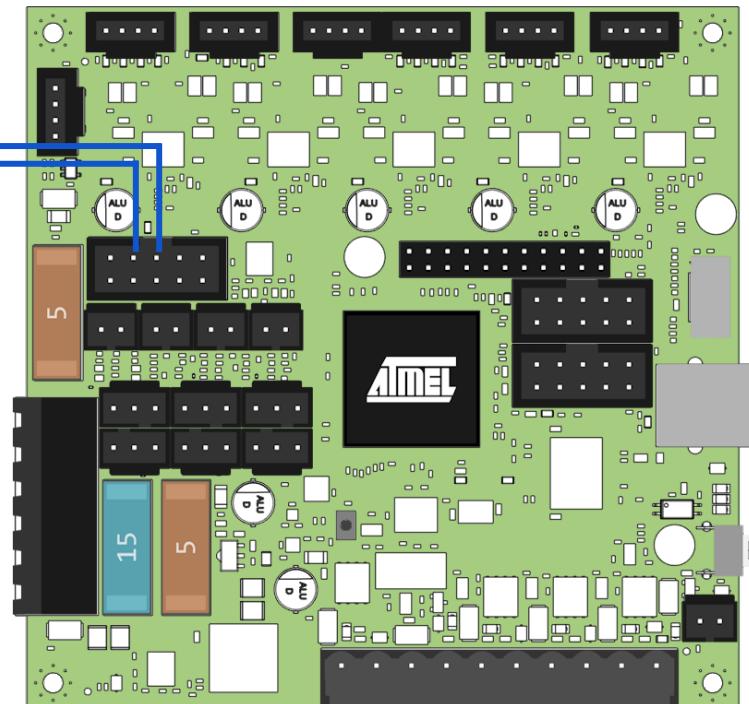
**SENSITIVE ELECTRONICS**

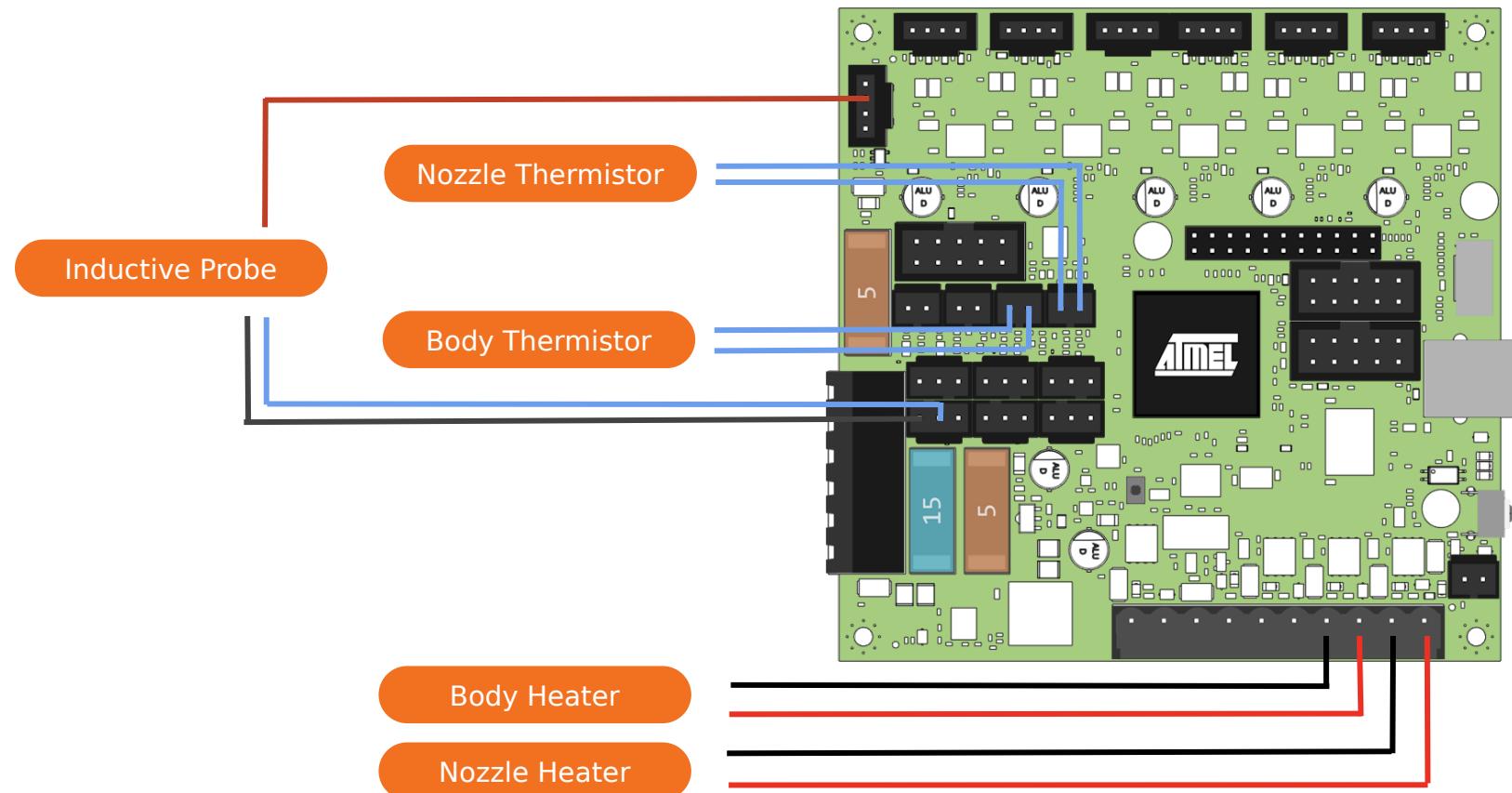
Use the jig shown below to protect the Mainboard from having the wrong pins connected and damaging your mainboard.

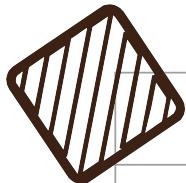
Then, install the Erase Button wiring as depicted.



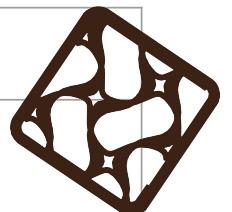
Erase Button





**Difficulty**

Medium

**Tools Needed**

M2 Driver  
M3 Driver  
M5 Driver  
Heatset Insert Tool  
Soldering Iron (Not Included)

**Hardware Needed**

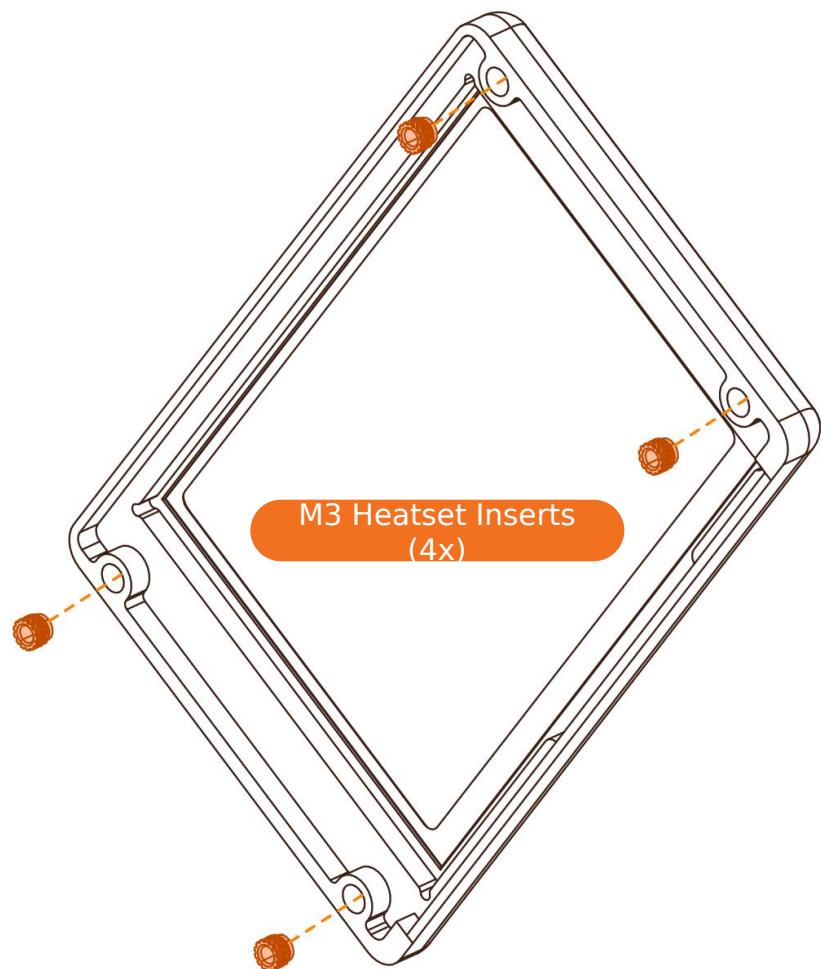
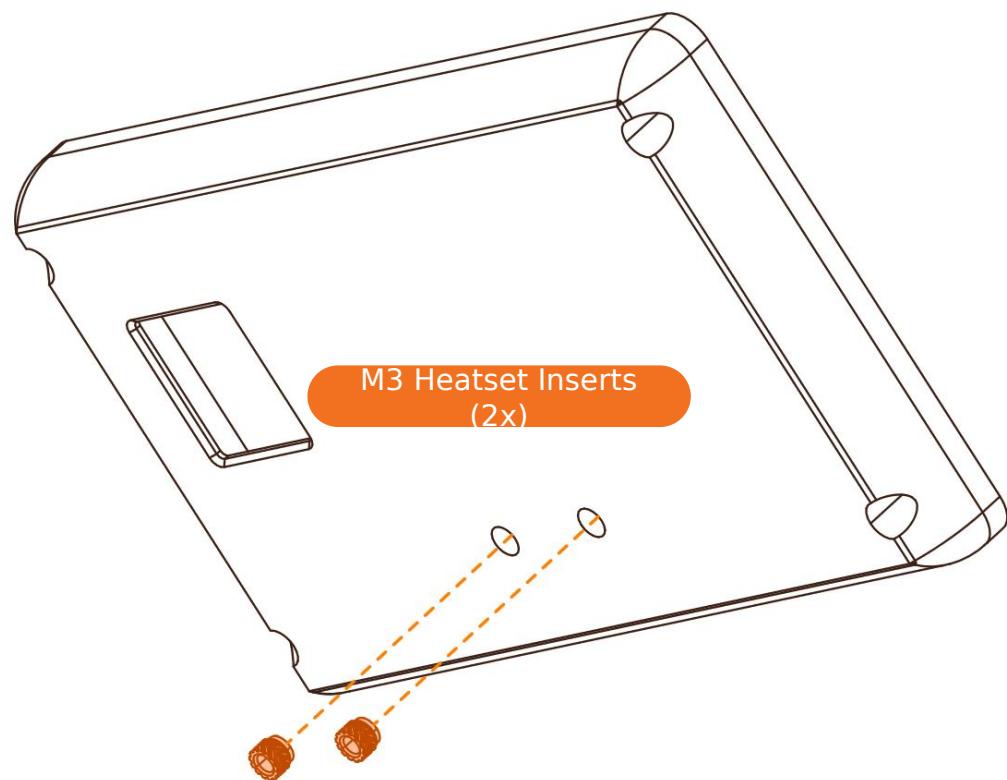
M3 Heatset Insert (6x)  
M3x8 Socket Head Cap Screw (7x)  
M3x16 Socket Head Cap Screw (2x)  
M5 T-Nuts (2x)  
M5x10 Button Head Cap Screw (2x)

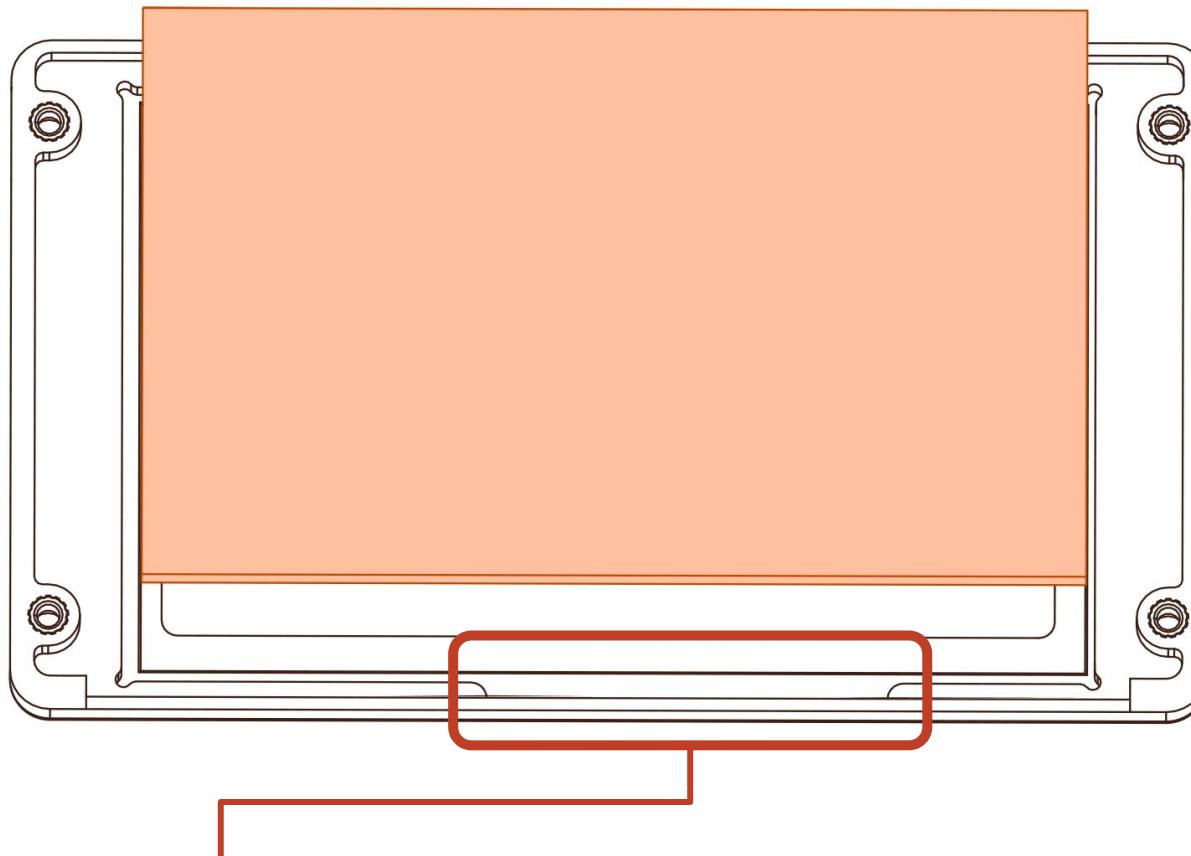
Display Panel  
SD Reader  
LCD Controller  
LCD Ribbon Cable  
SD Ribbon Cable

**Printed Parts  
Needed**

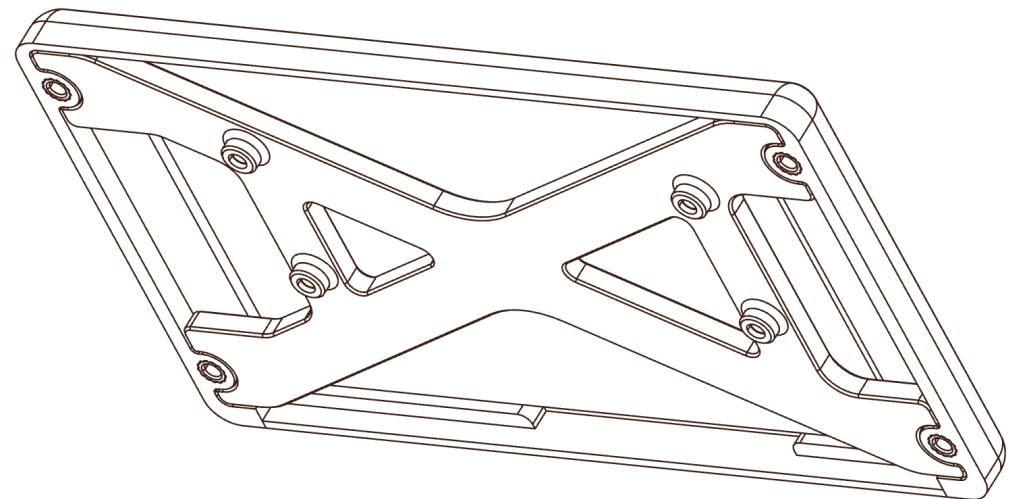
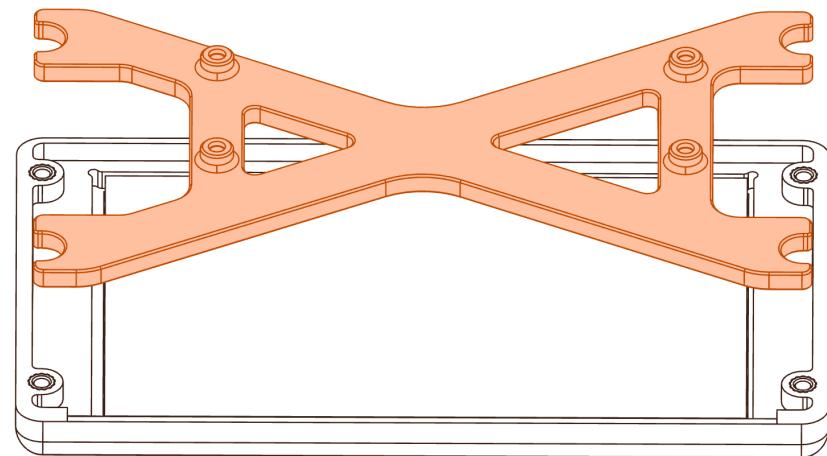
LCD Front Cover (1x)  
LCD Rear Cover (1x)  
LCD Bottom Cover (1x)  
LCD Mount (1x)  
Display Spacer (1x)  
Ribbon Cable Clip (1x)

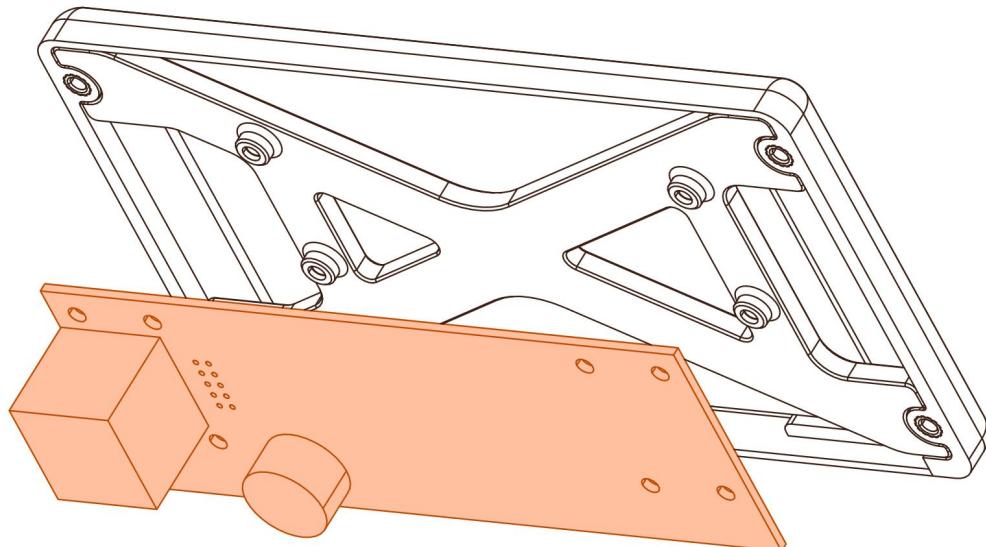




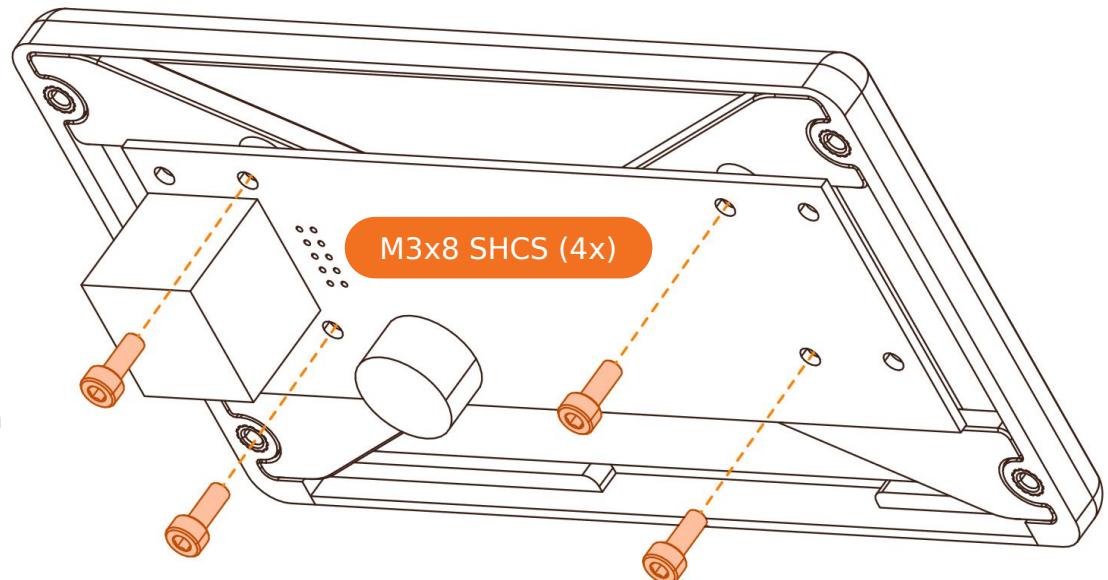
**DELICATE CABLES**

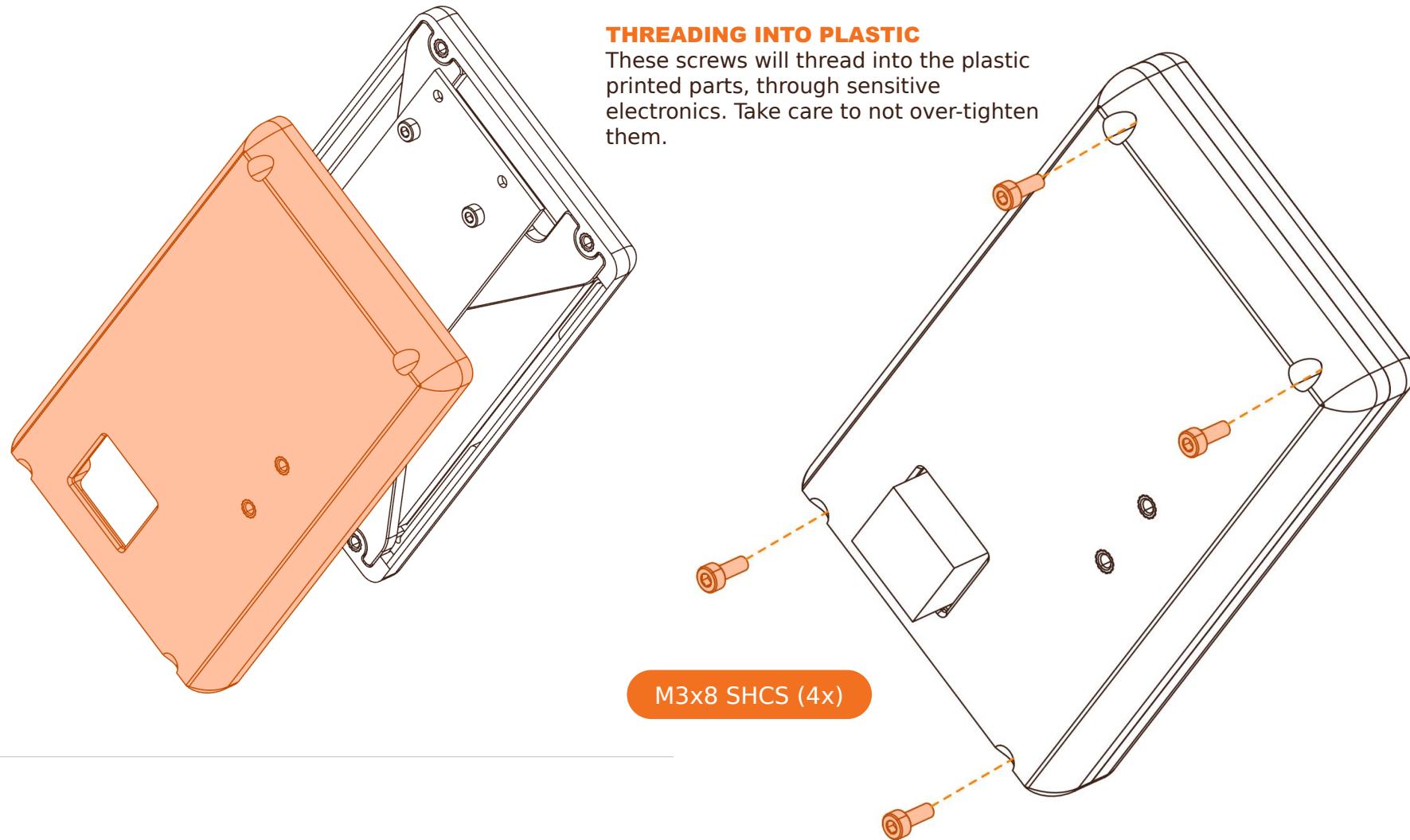
The ribbon cable from the display will sit in the opening here. Take care to not bend excessively or fold, as this may damage the display.



**THREADING INTO PLASTIC**

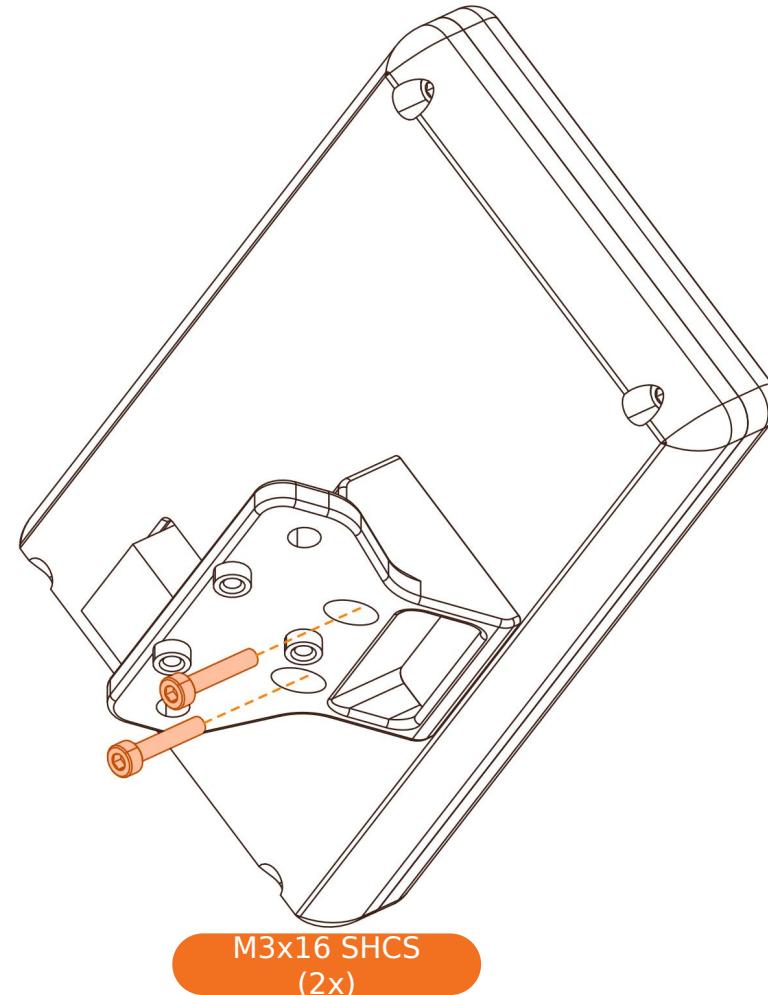
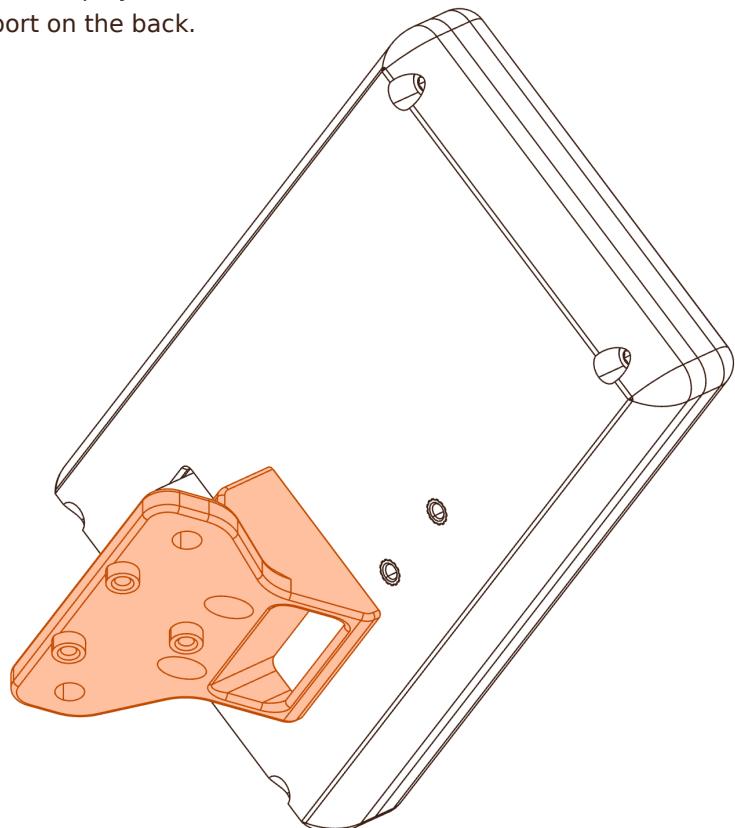
These screws will thread into the plastic printed parts, through sensitive electronics. Take care to not over-tighten them.

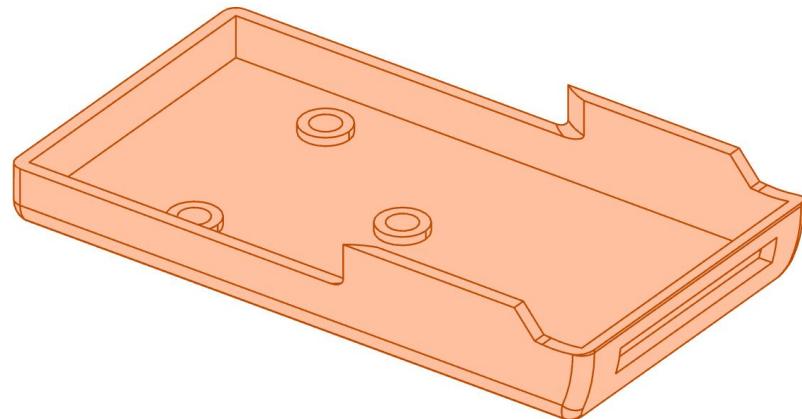




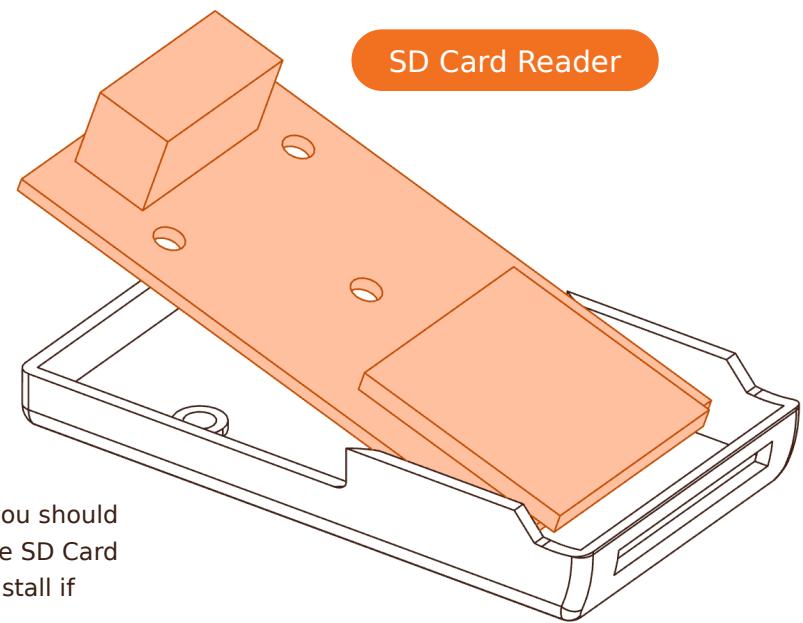
**CONNECTION - GO!**

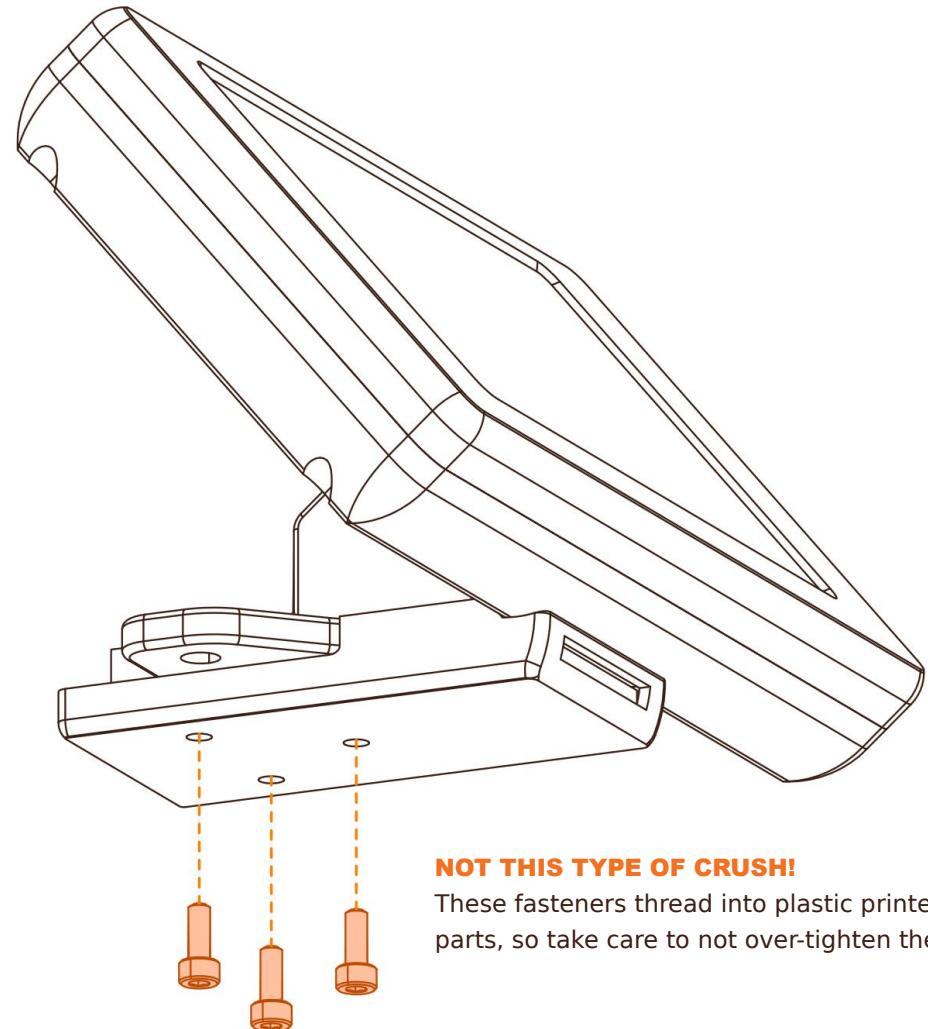
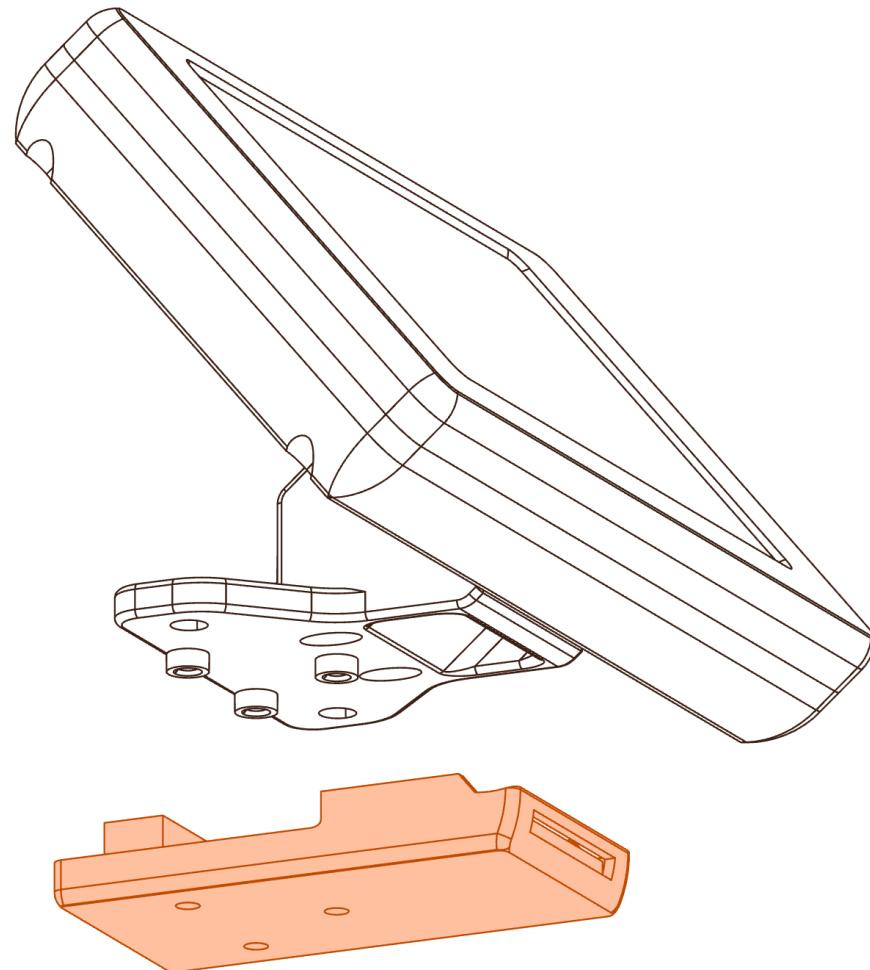
Once you've gotten to this point, you should connect the Display Ribbon Cable to the outside port on the back.



**CONNECTION - GO!**

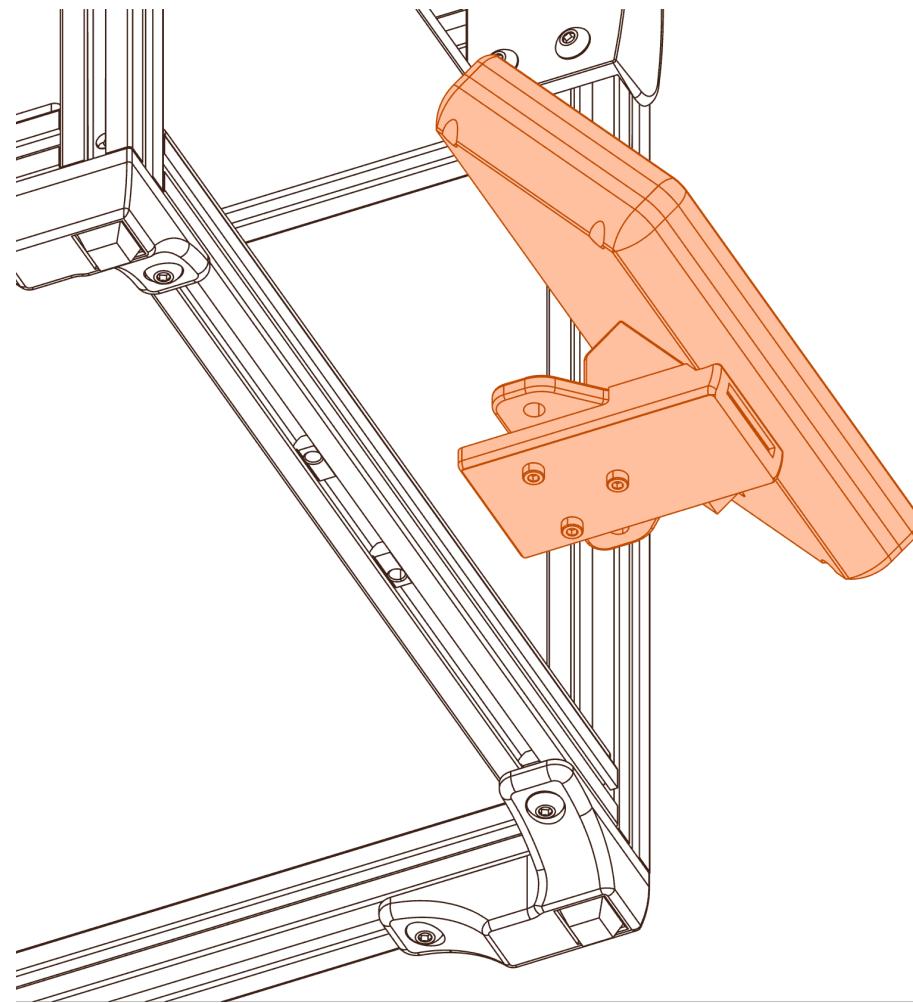
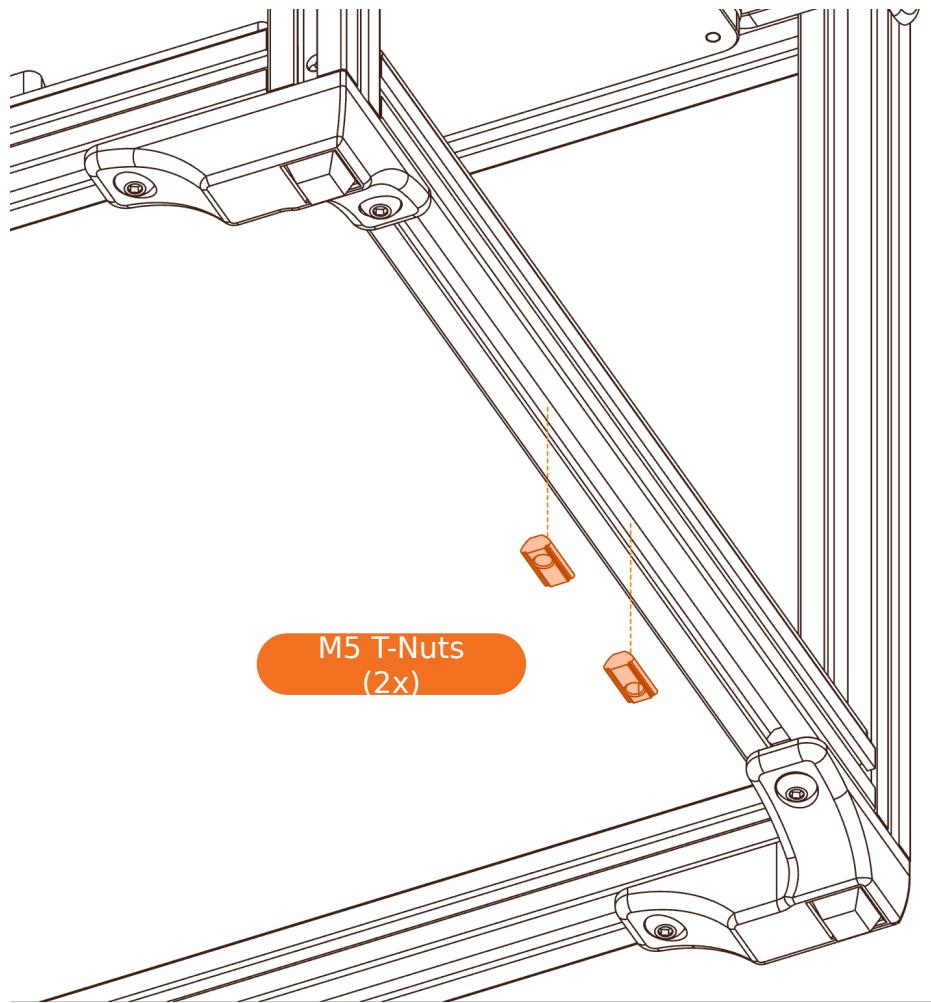
Once you've gotten to this point, you should connect the SD Ribbon Cable to the SD Card Reader board. It'll be difficult to install if done any later.

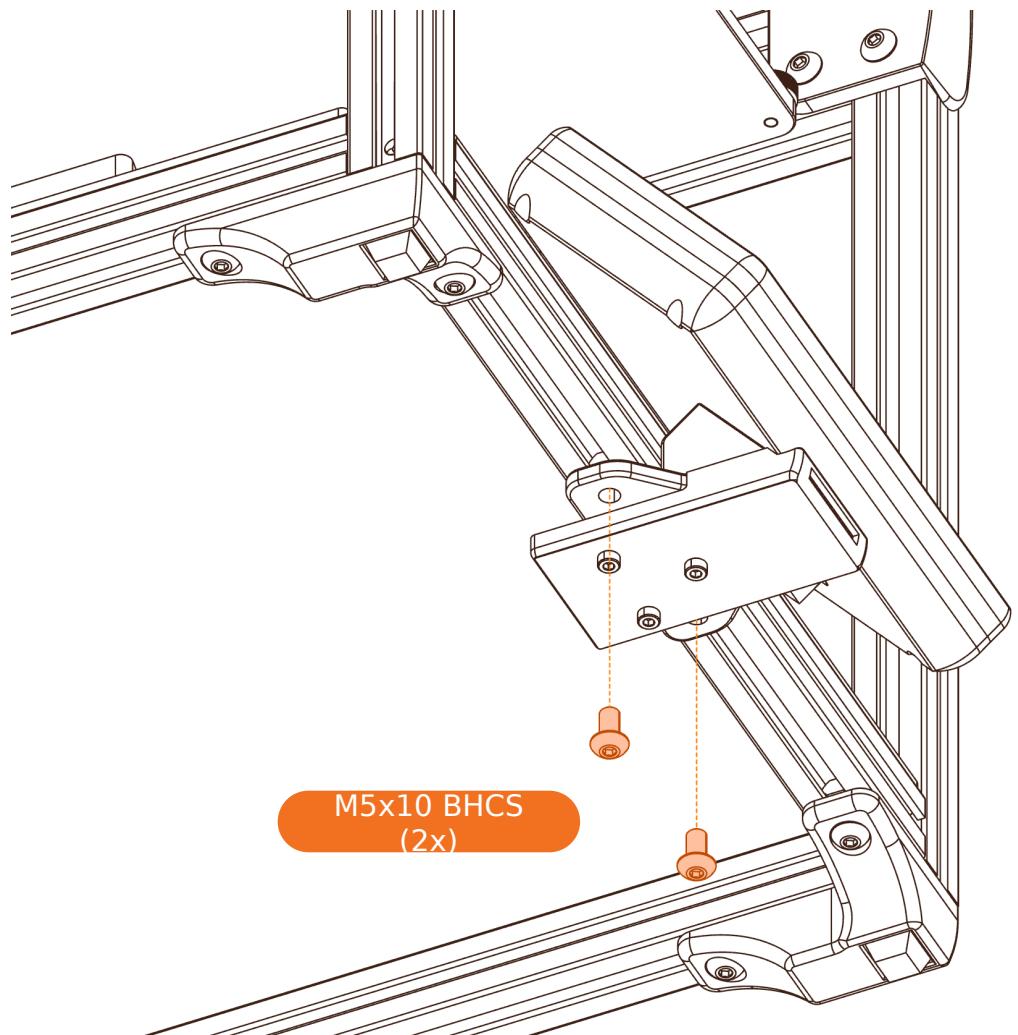


**NOT THIS TYPE OF CRUSH!**

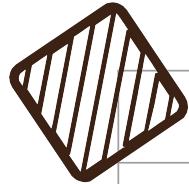
These fasteners thread into plastic printed parts, so take care to not over-tighten them.

**M3x8 SHCS (3x)**

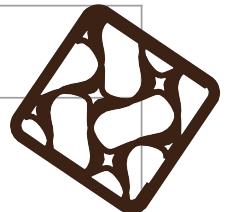




When installing the display, ensure that no connections wiggle loose or are under strain. Be sure to not pinch the cables under the frame until you install the cable management piece.

**Difficulty**

Easy

**Tools Needed**

M3 Driver  
M5 Driver  
Heatset Insert Tool  
Soldering Iron (Not Included)

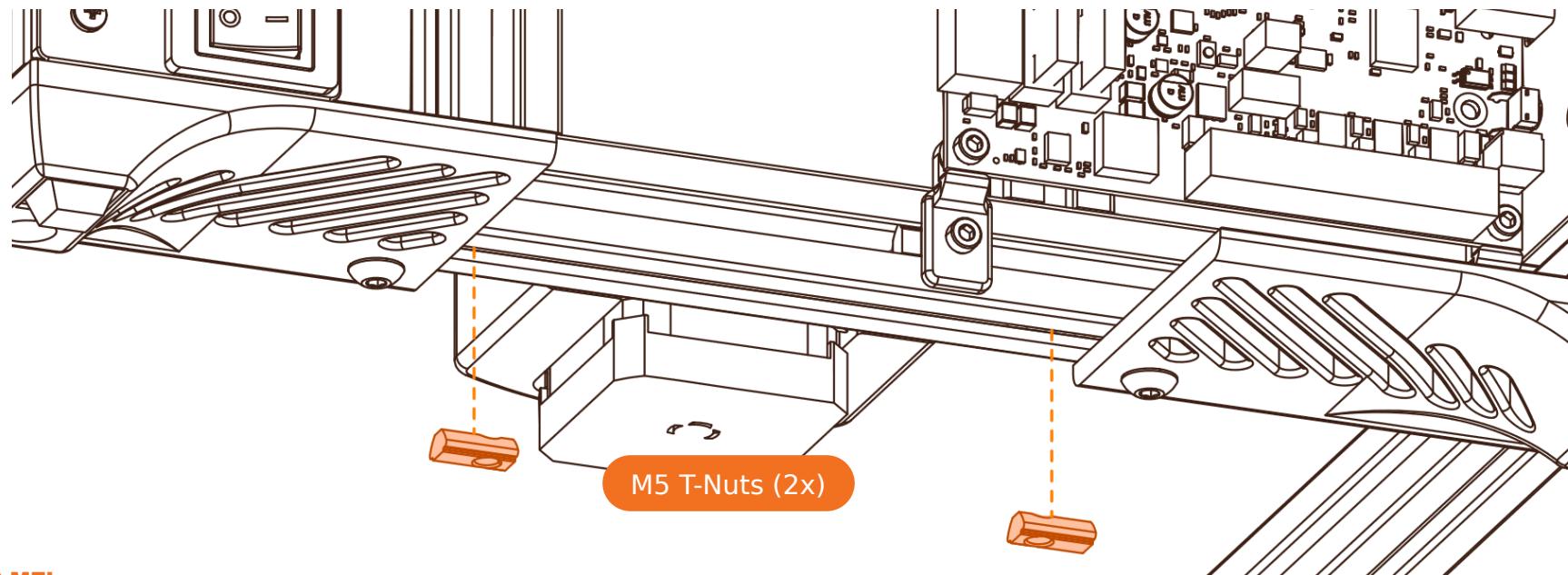
**Hardware Needed**

M5 T-Nuts (2x)  
M3 Heatset Insert  
M5x10 Button Head Cap Screw (2x)

**Printed Parts  
Needed**

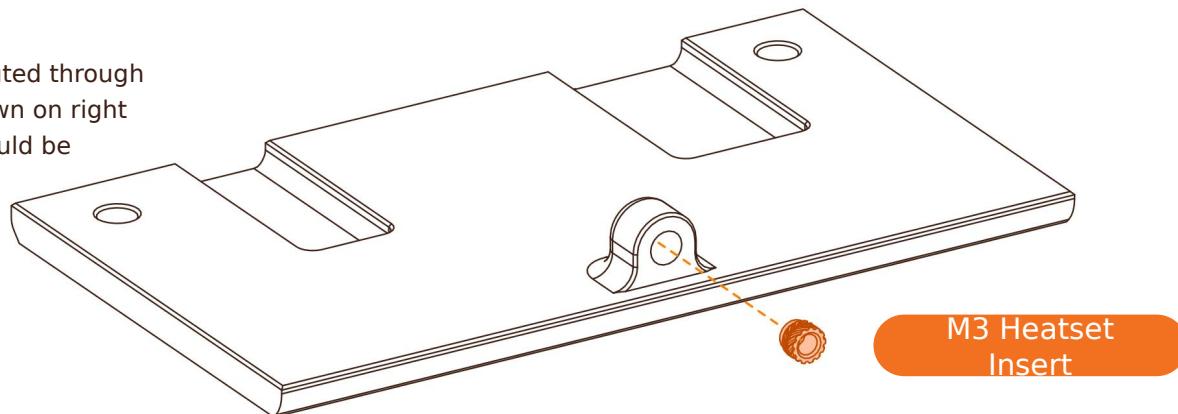
Center Cover (1x)

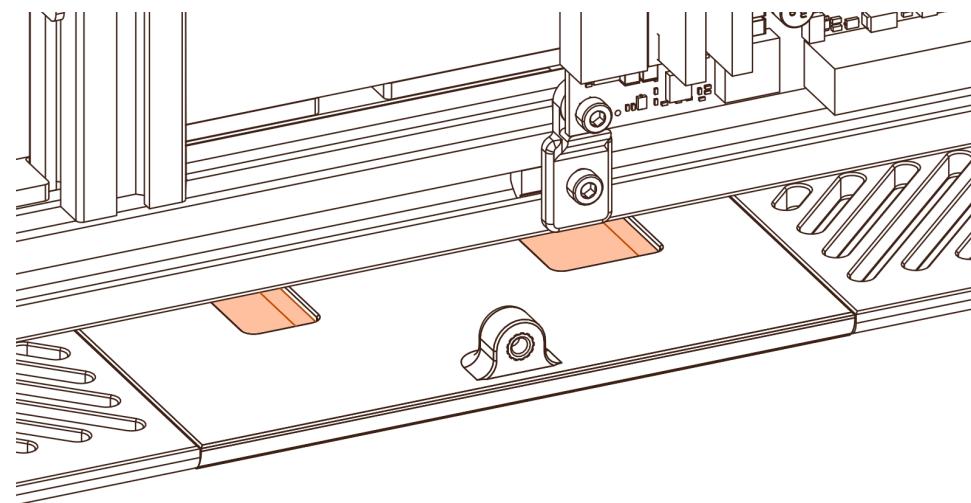
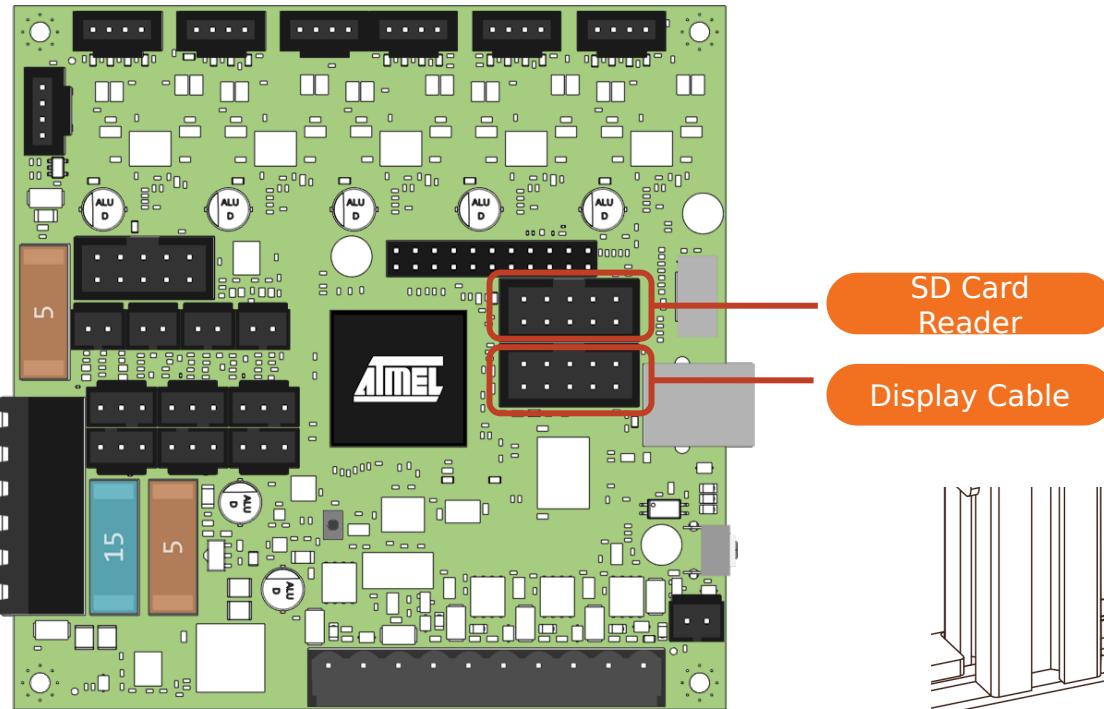


**COVER ME!**

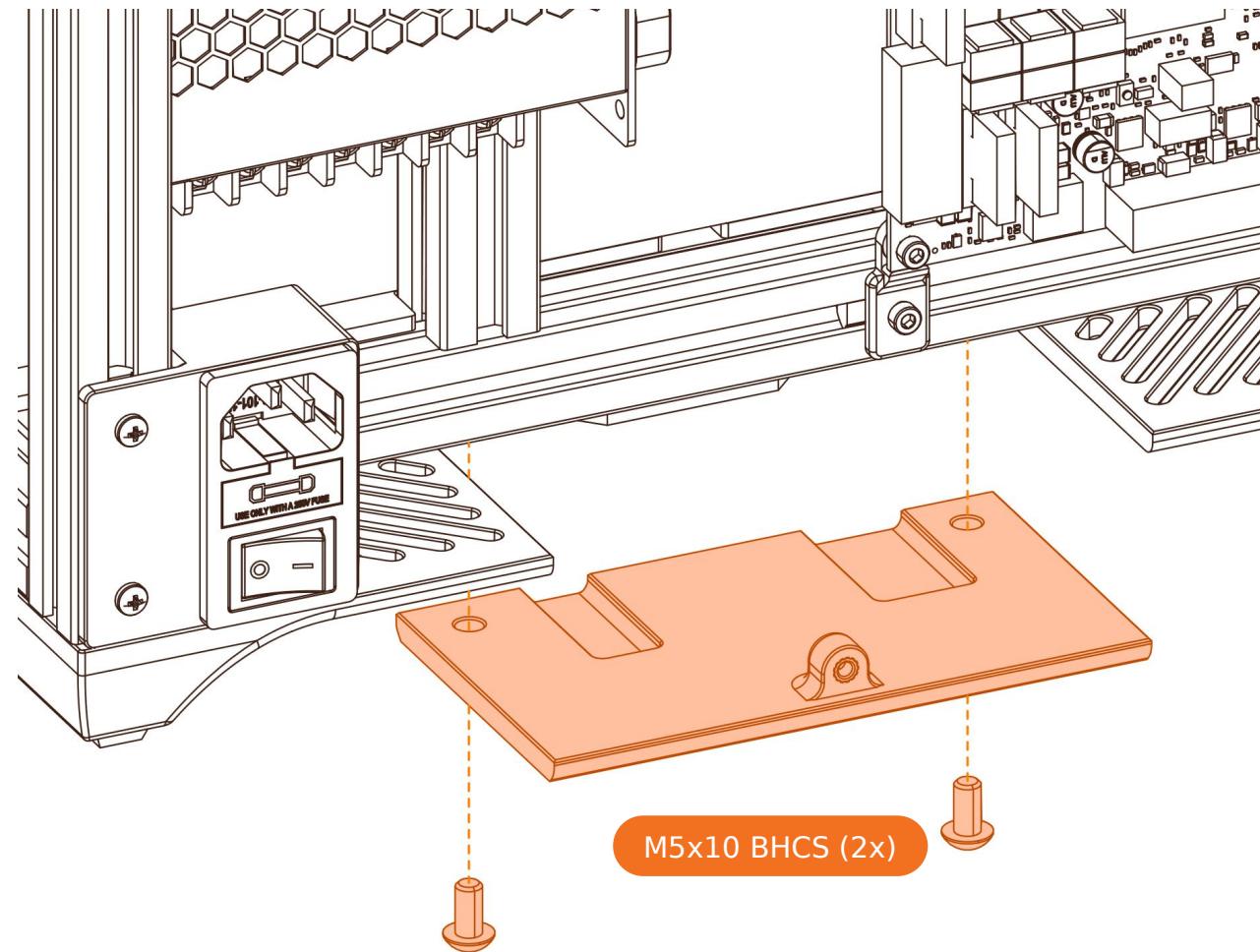
This cover both retains the SD and Display Ribbon Cables, as well as the Z motor. Additionally, it provides routing for the set to avoid cables being pinched.

The Z Motor cable should be routed through the larger of the two holes (shown on right here), and one ribbon cable should be routed through each side.

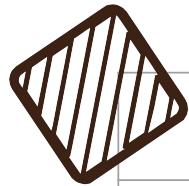


**(DON'T) PINCH ME, I'M DREAMING**

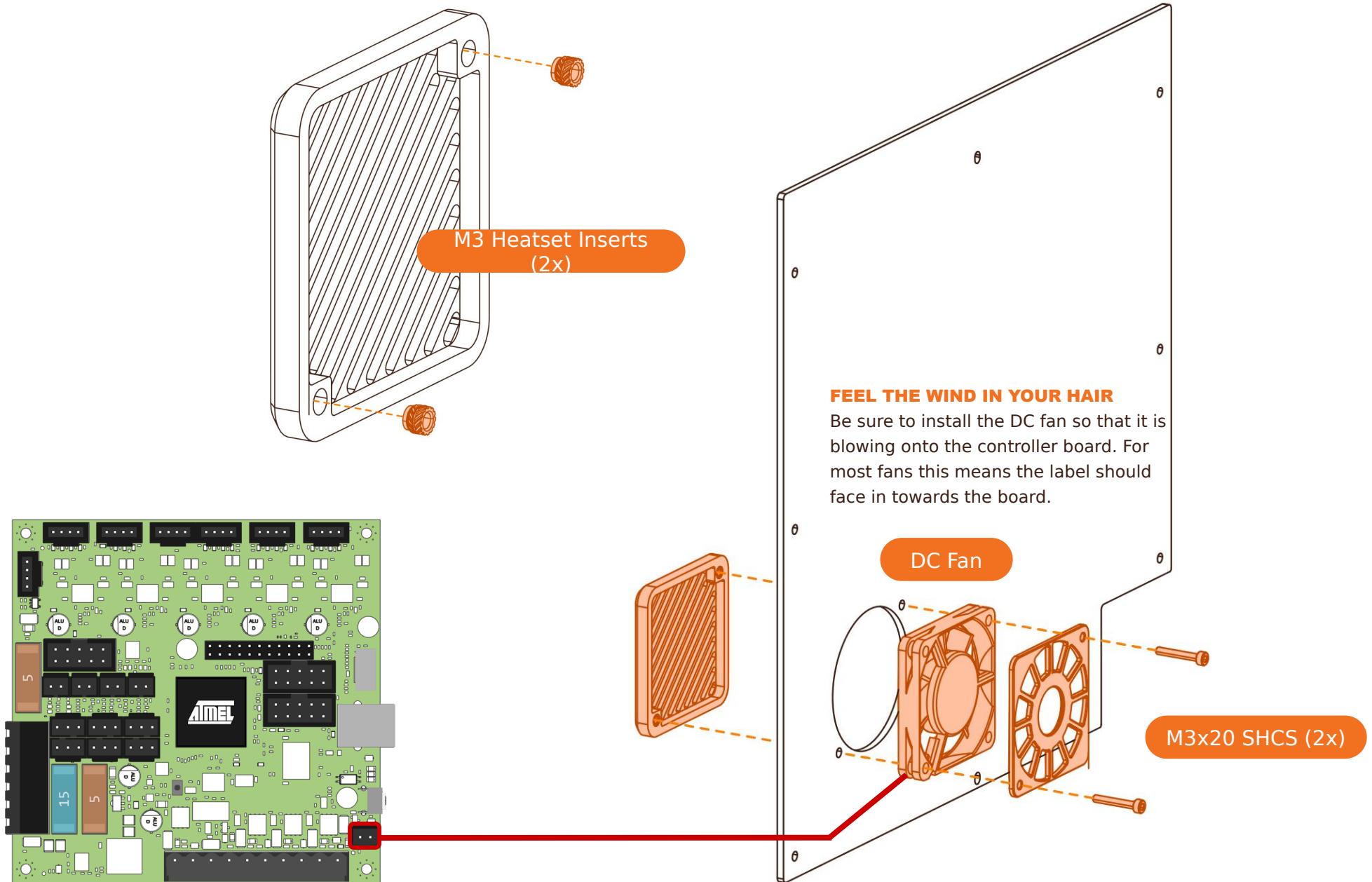
When installing the bottom cover, be sure to route the Display and SD Card ribbon cables, as well as the Z stepper motor wires through the provided grooves. Make sure the cables are loose and can slide to ensure they are not being pinched.





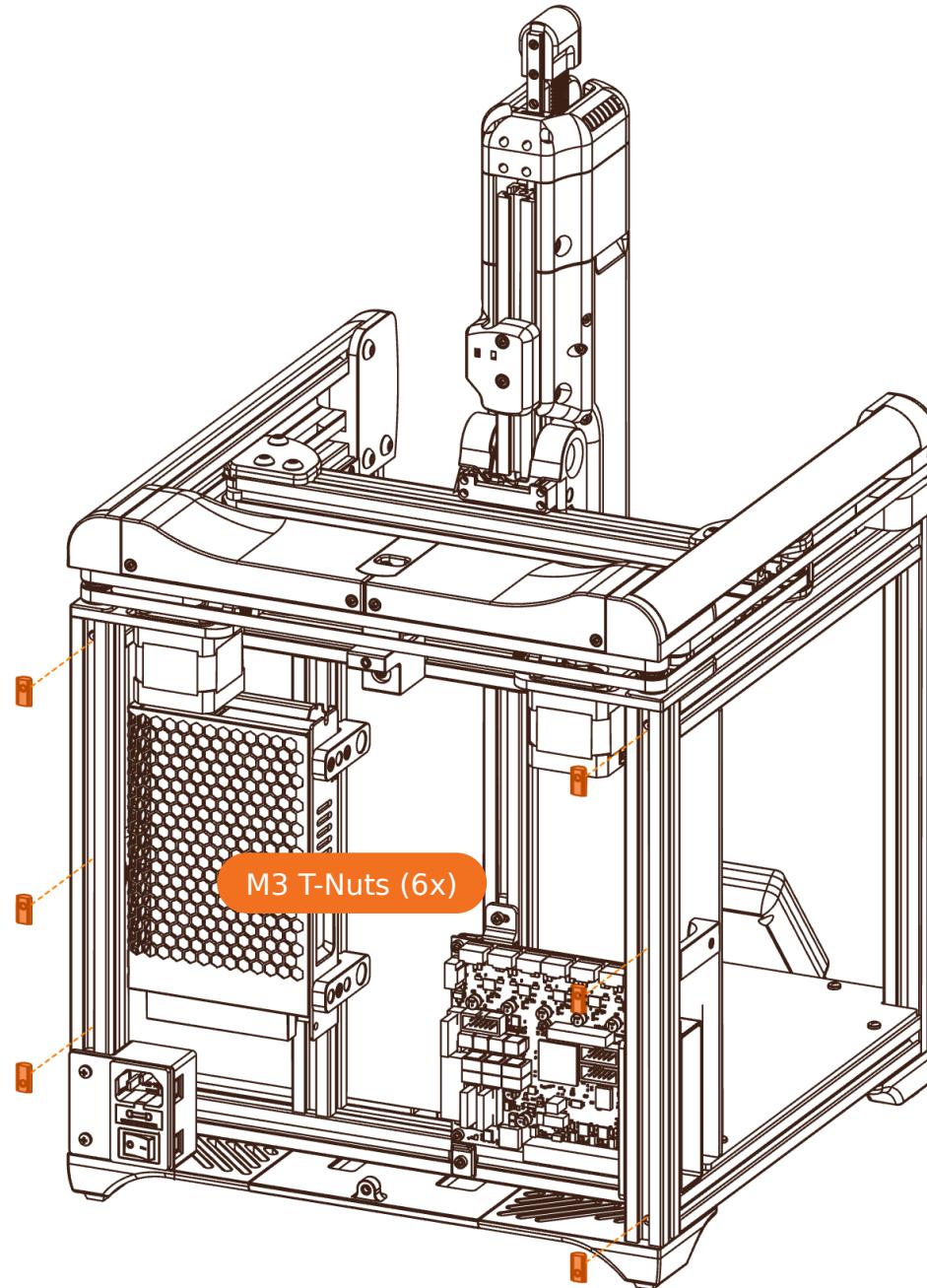


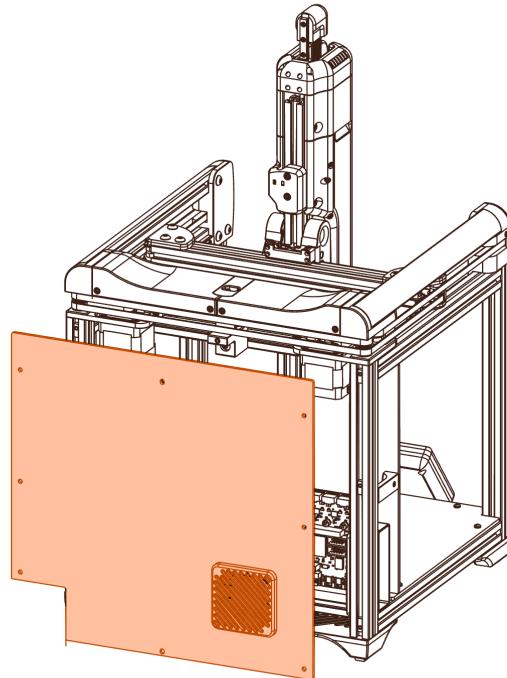
<b>Difficulty</b>	Easy			
<b>Tools Needed</b>	M3 Driver Phillips Screwdriver Heatset Insert Tool Soldering Iron (Not Included)			
<b>Hardware Needed</b>	M3 Heatset Inserts (2x) M3 T-Nuts (20x) M3x8 Button Head Phillips Screw (26x) M3x20 Socket Head Cap Screw (2x)		Rear Panel (1x) Left Panel (1x) Right Panel (1x) 12V Fan (1x)	
<b>Printed Parts Needed</b>	Rear Fan Grill (1x) Rear Fan Inner Guard (1x)			



**ORIENTATION MATTERS**

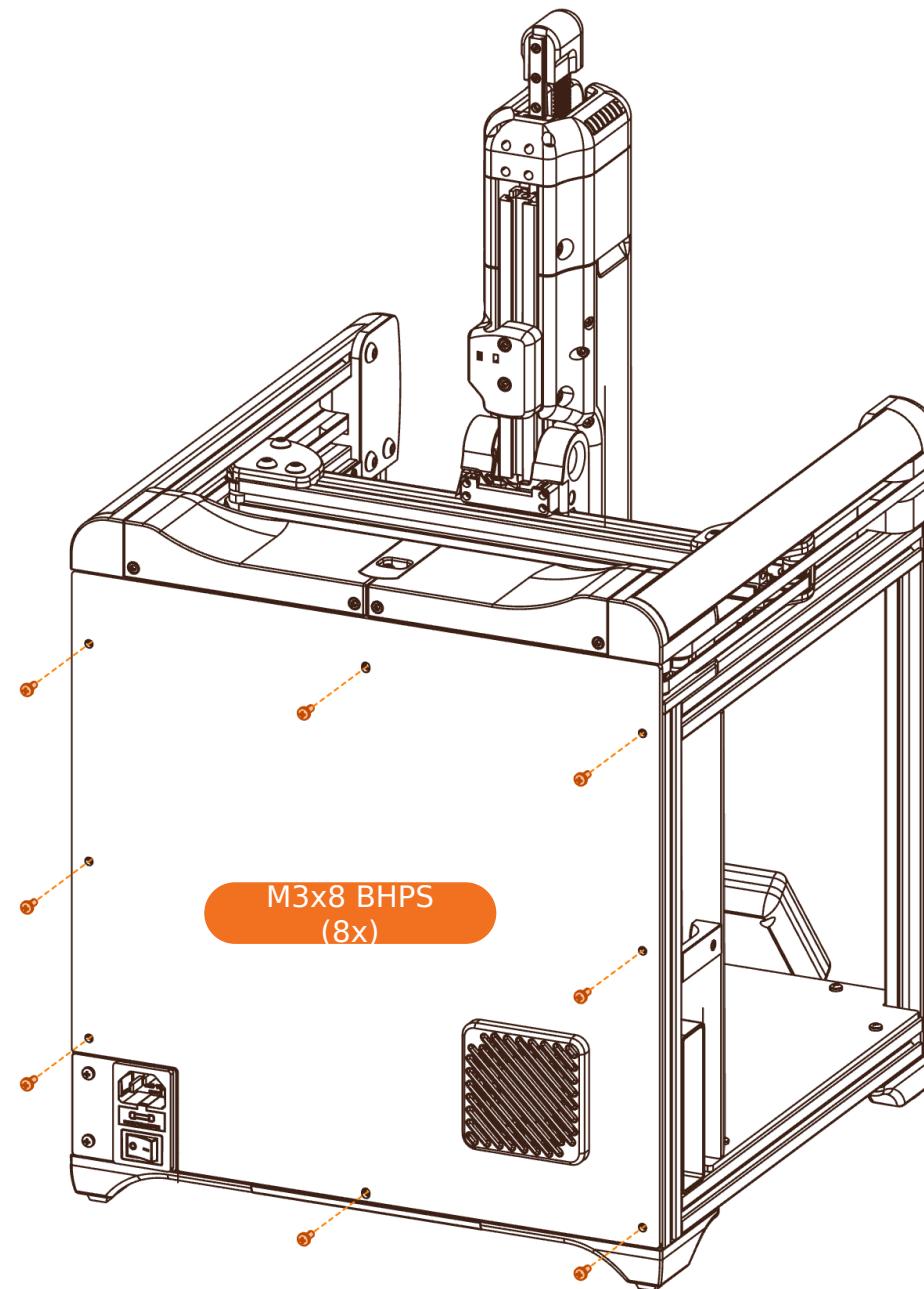
The T-nuts should be aligned such that the threads are often over the access holes in the extrusion. This ensures you can secure every fastener of the panels.

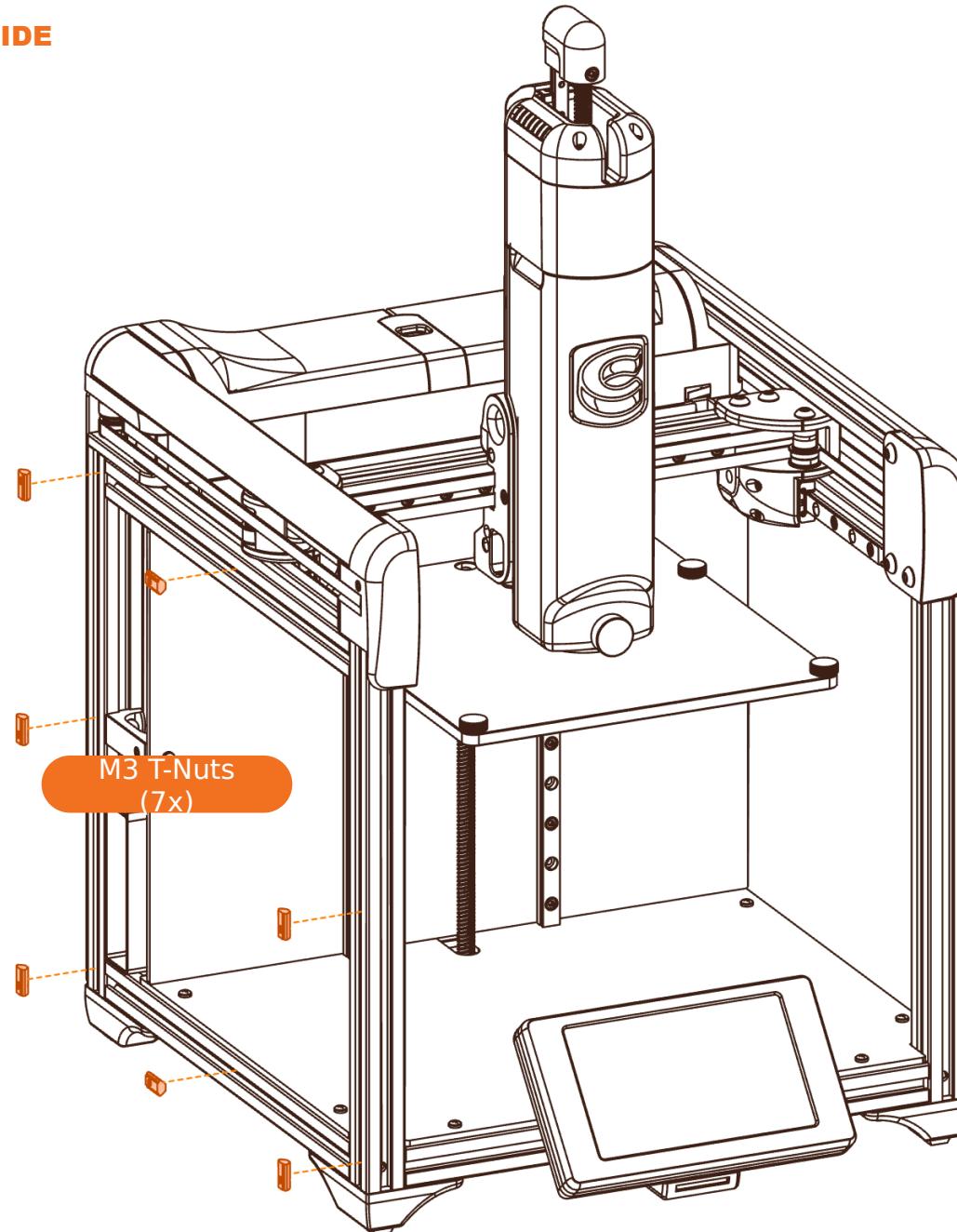




**NOT A FAN OF THAT?**

Be sure to connect your fan header onto the Archim before closing the rear panel. This keeps your stepper drivers nice and cool.



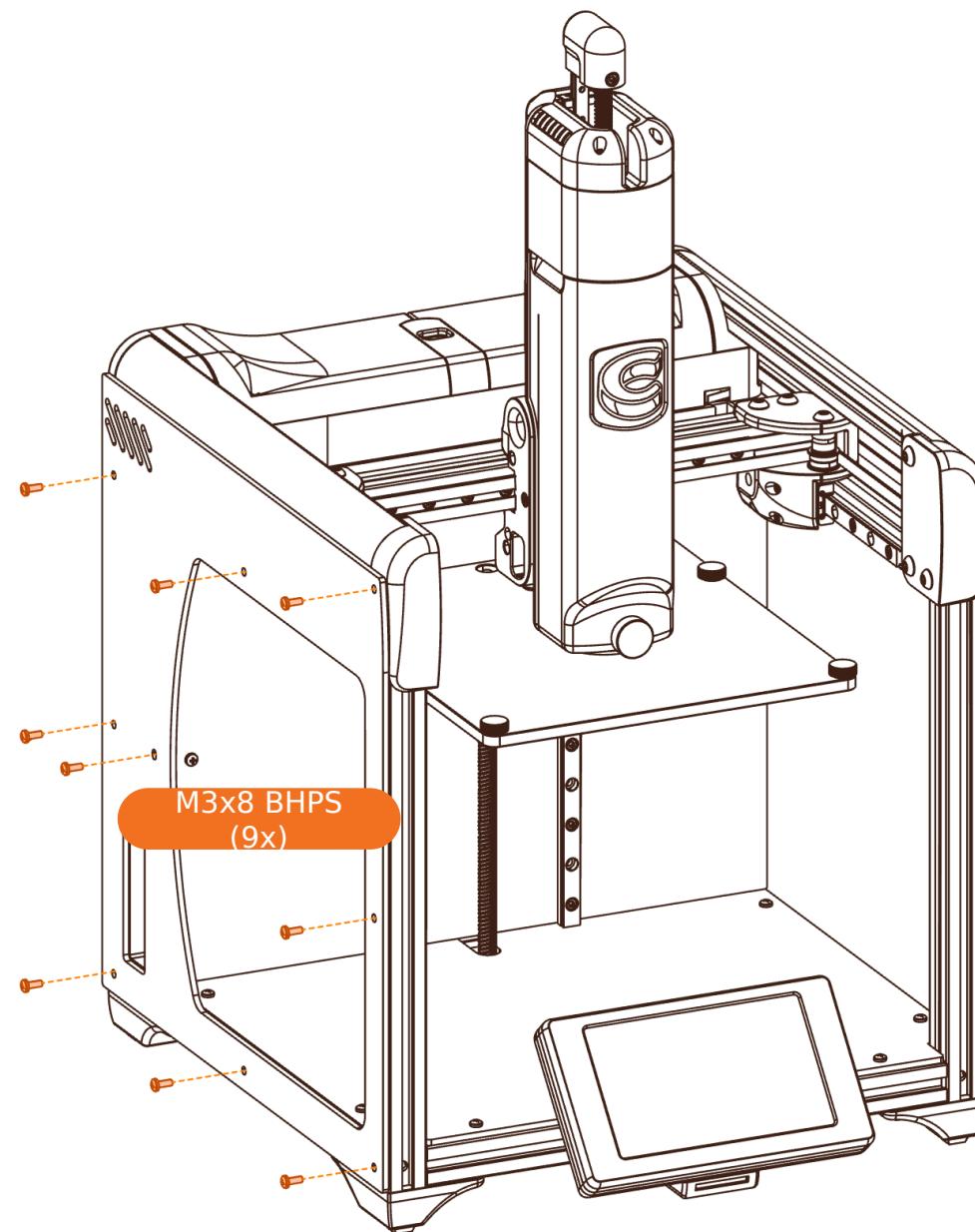
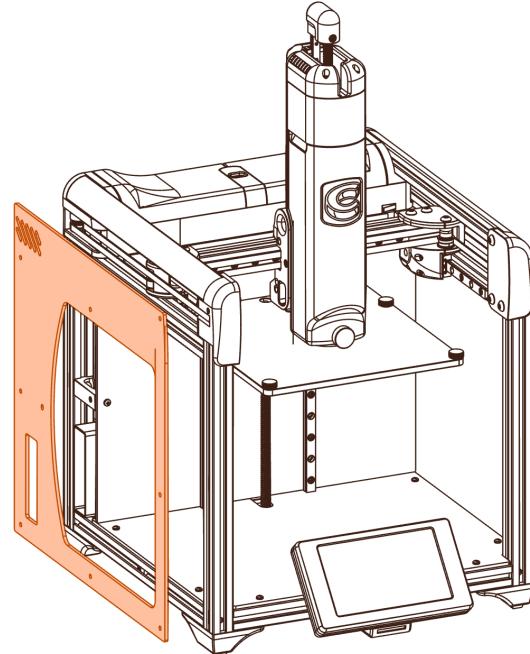


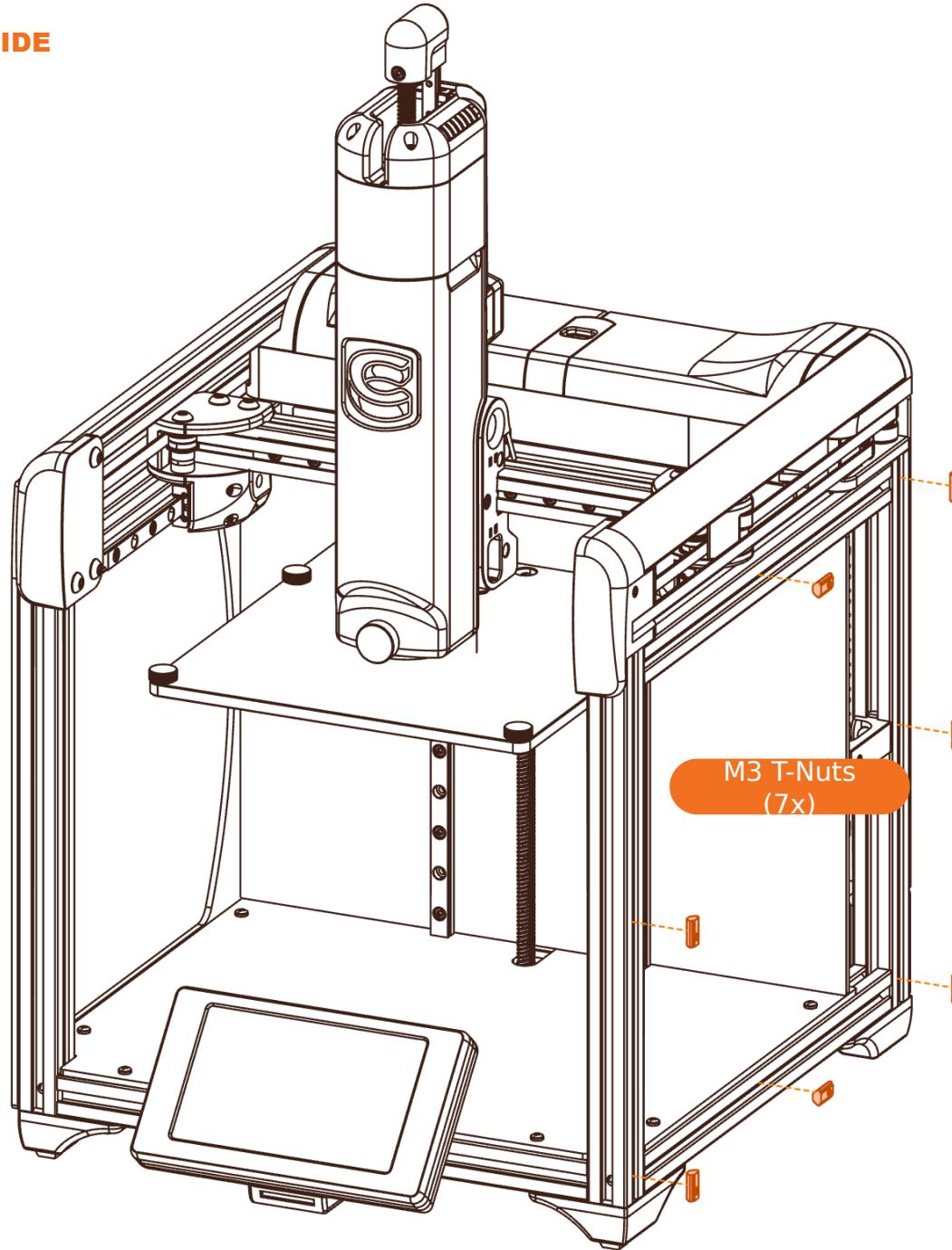
**ORIENTATION MATTERS**

The T-nuts should be aligned such that the threads are often over the access holes in the extrusion. This ensures you can secure every fastener of the panels.

**EXTERIOR PANELS - SIDE  
PANELS**

COCOAPRESS.COM



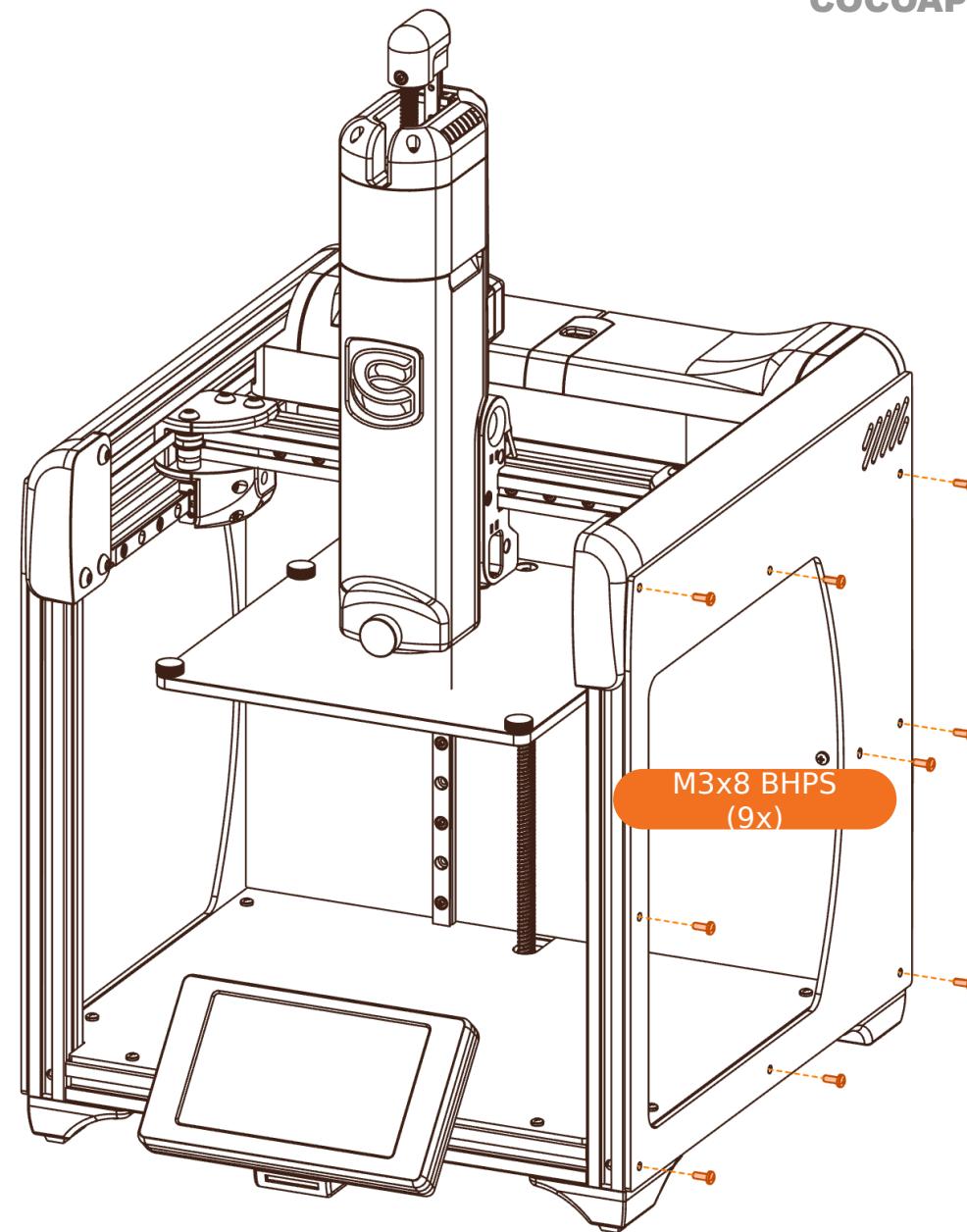
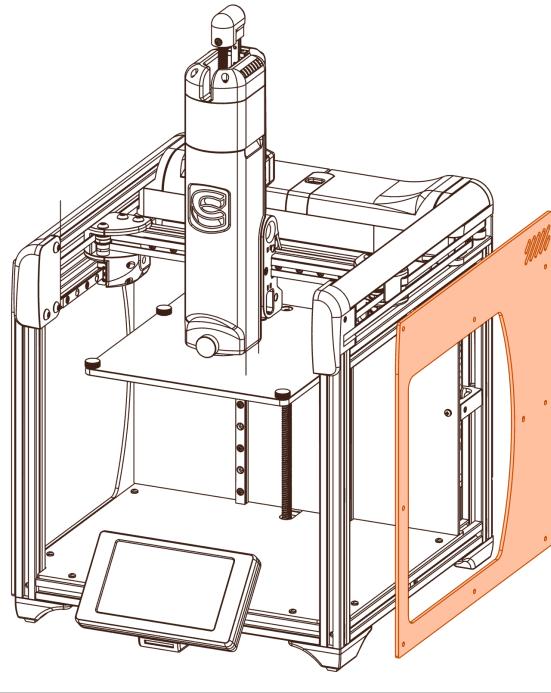


**ORIENTATION MATTERS**

The T-nuts should be aligned such that the threads are often over the access holes in the extrusion. This ensures you can secure every fastener of the panels.

**EXTERIOR PANELS - SIDE  
PANELS**

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DONE

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# COCOA PRESS

## NEXT STEPS

Congratulations! You made it through the assembly manual.

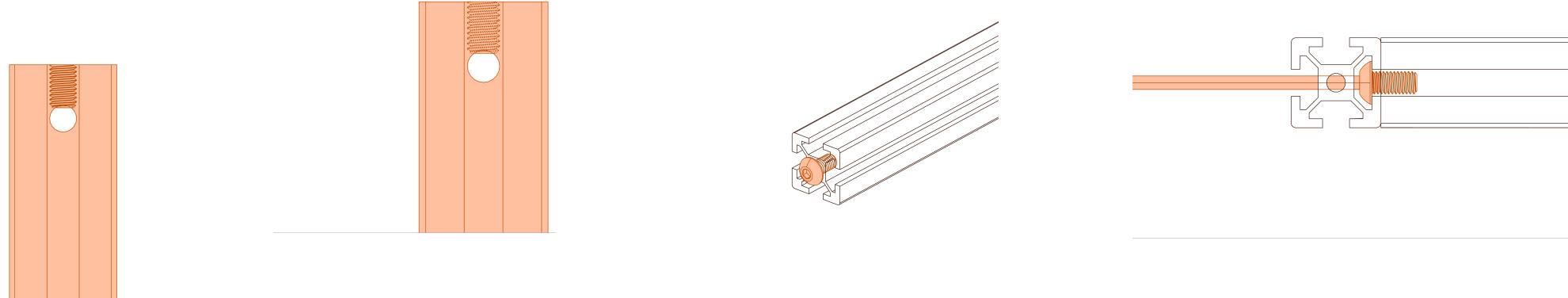
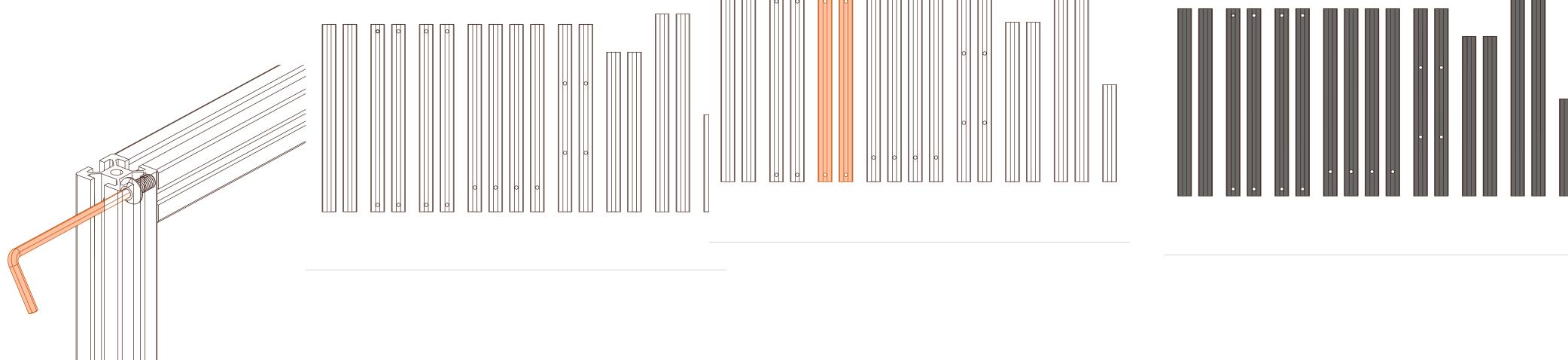
At this point the next steps you likely need to take are software related.

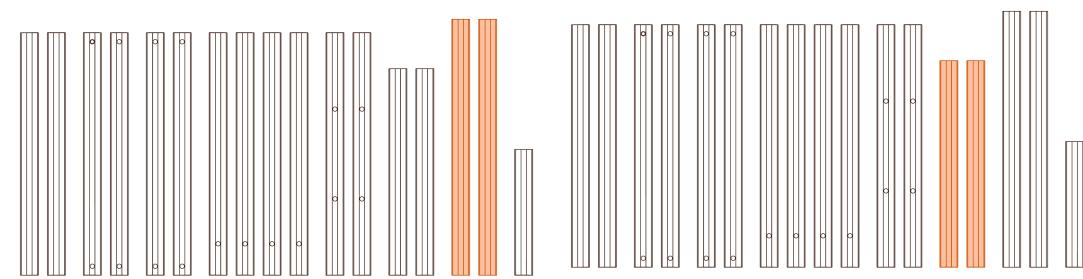
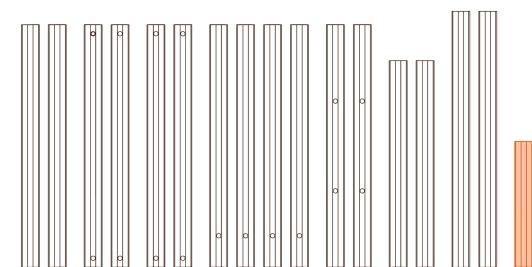
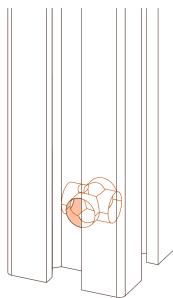
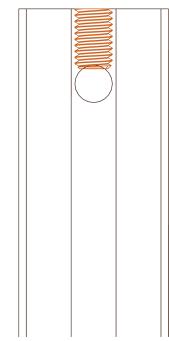
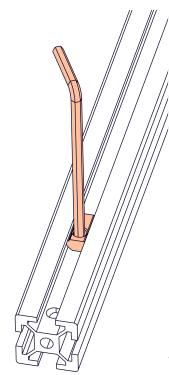
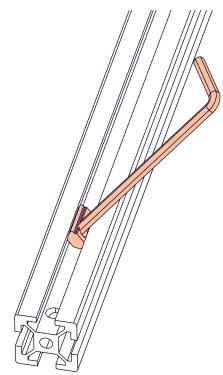
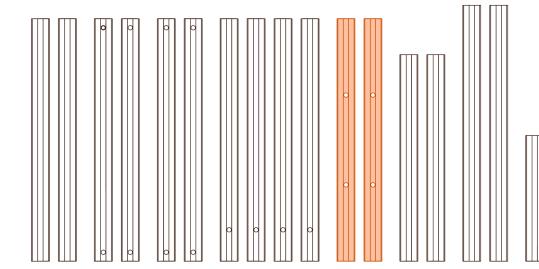
Head on over to [help.cocoapress.com](http://help.cocoapress.com) to find detailed instructions for how to proceed!

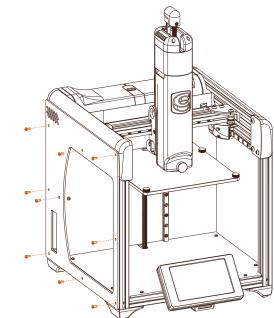
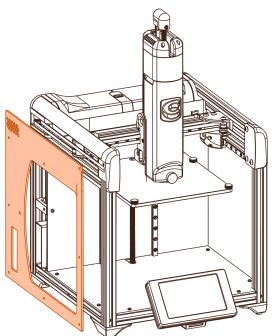
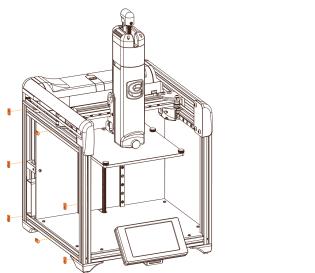
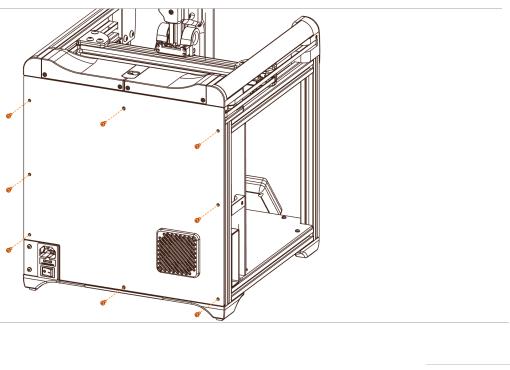
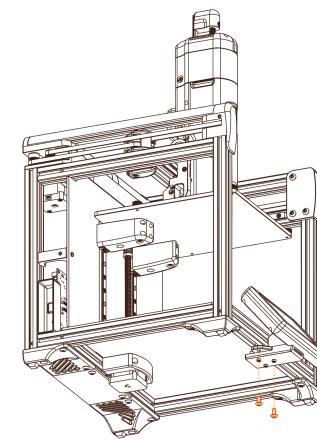
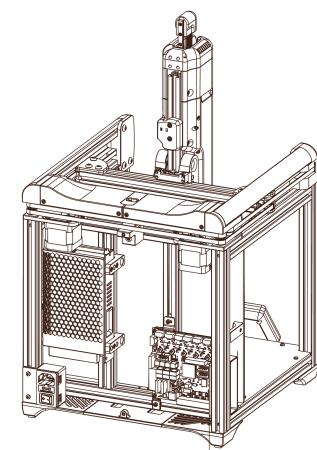
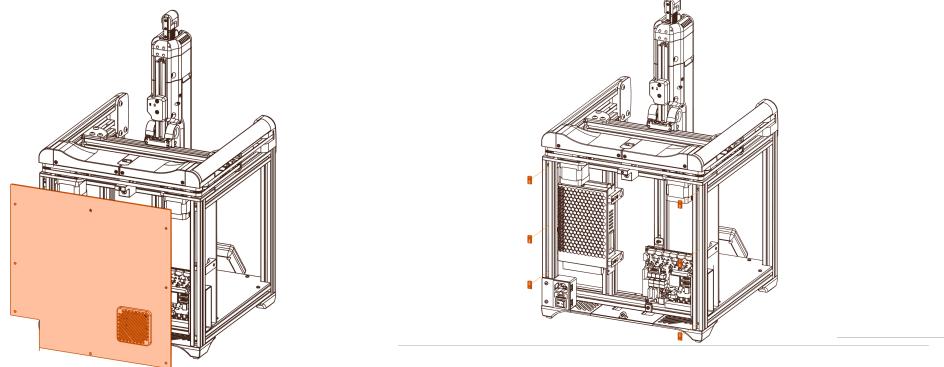
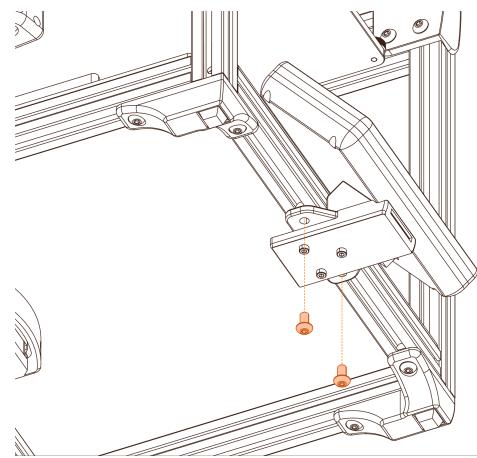
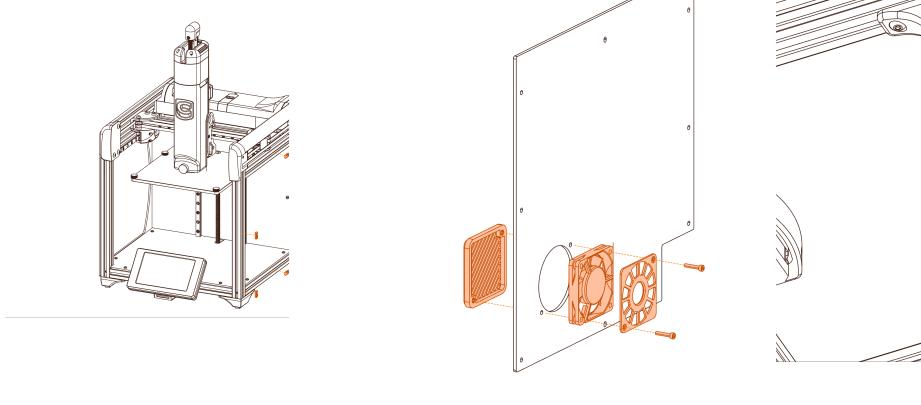
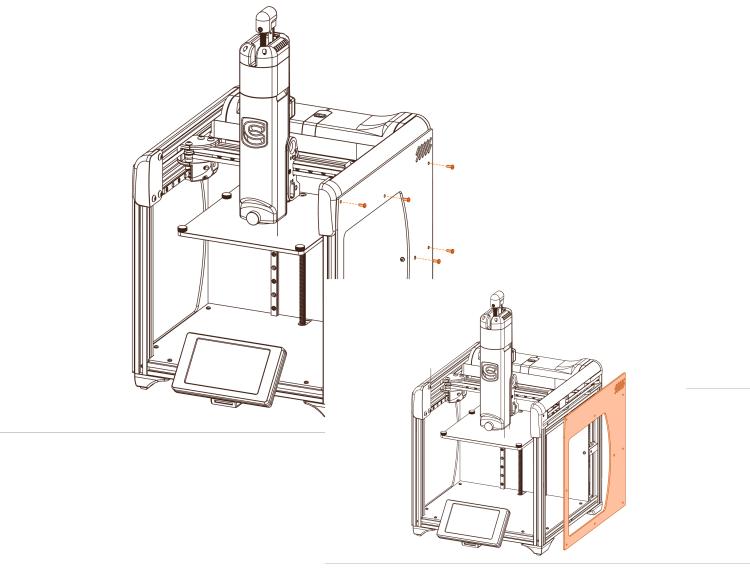
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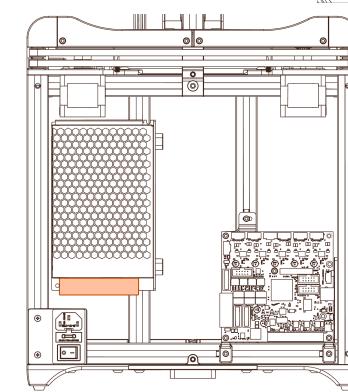
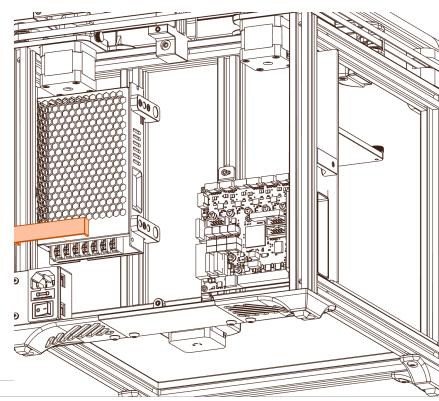
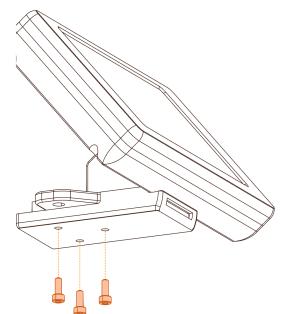
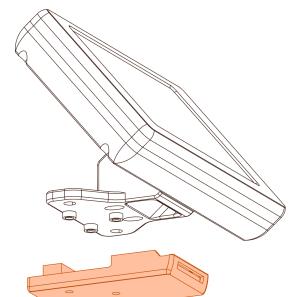
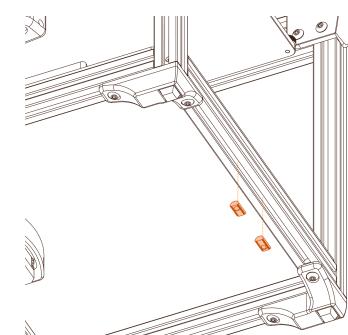
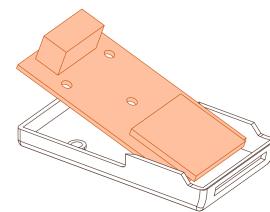
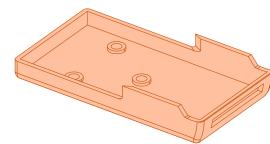
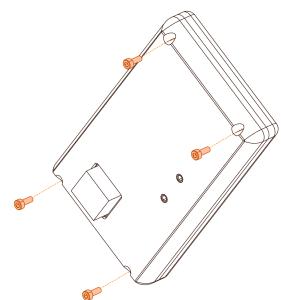
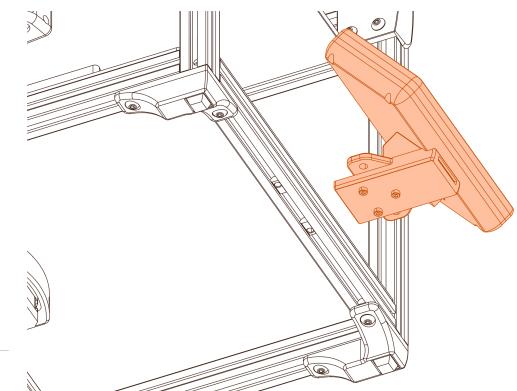
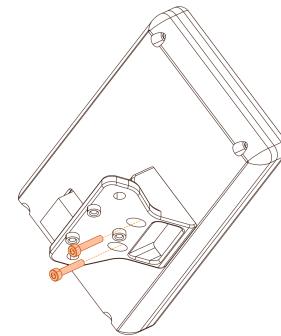
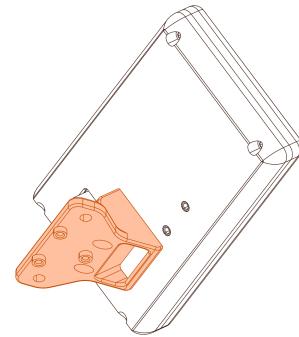
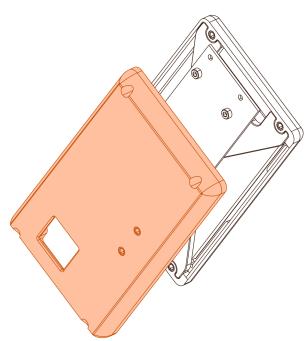
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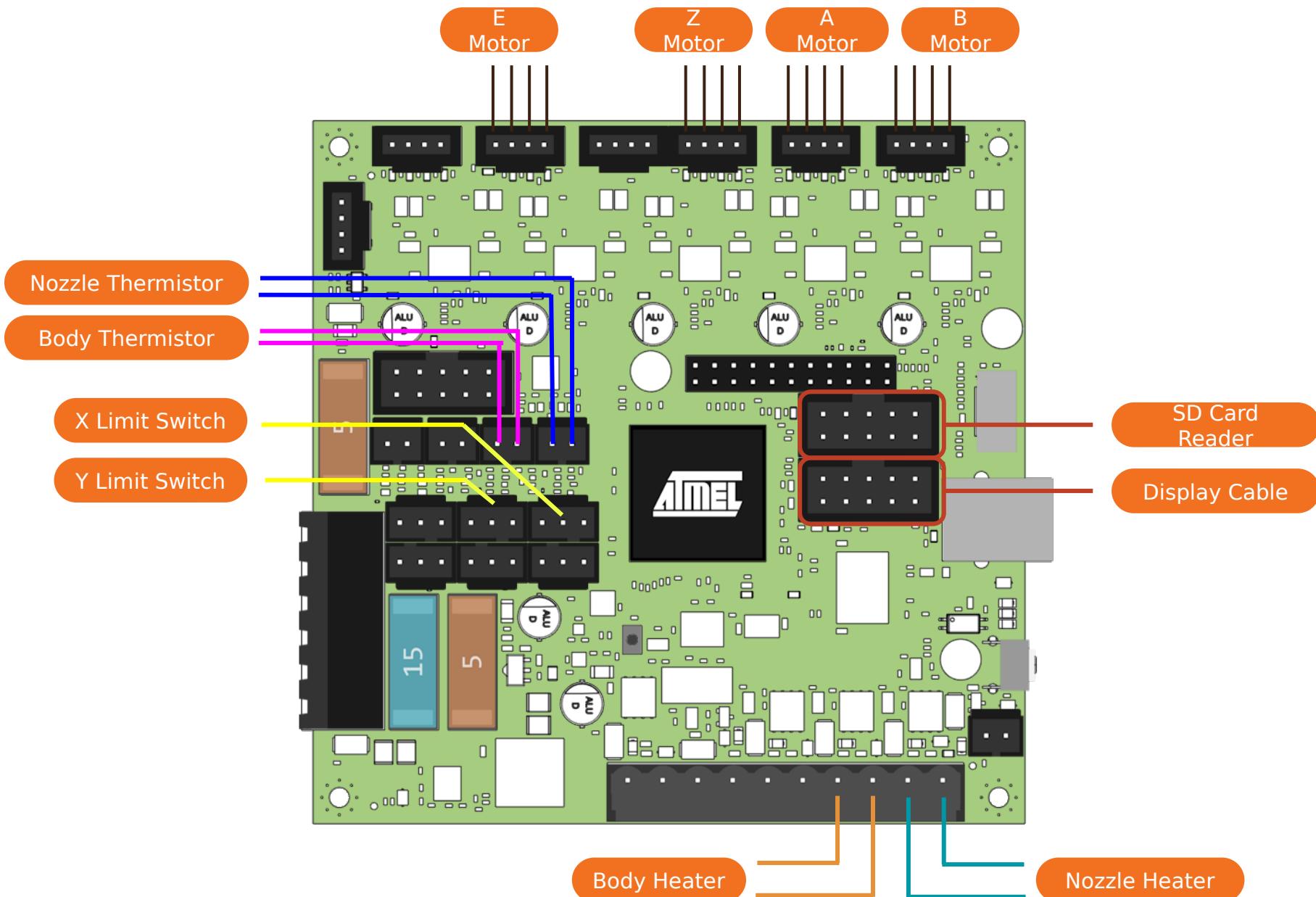


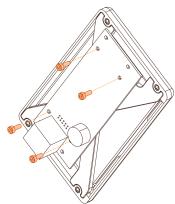
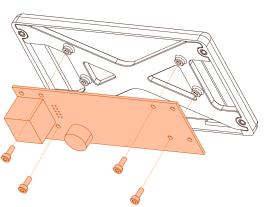
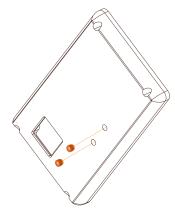
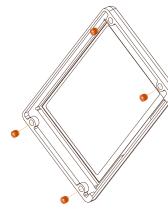
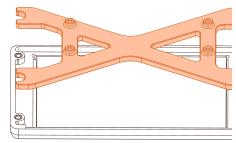
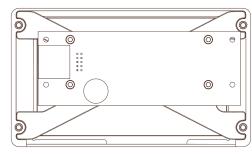
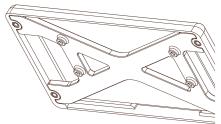
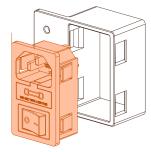
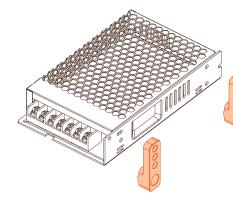
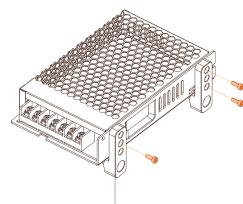
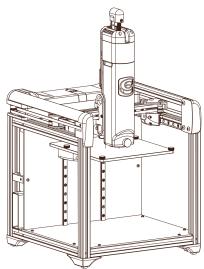


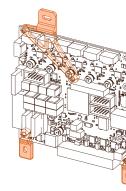
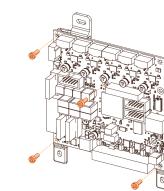
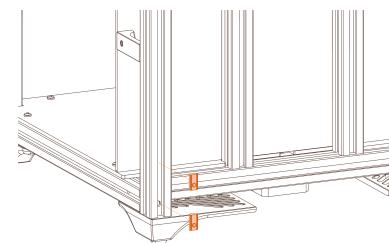
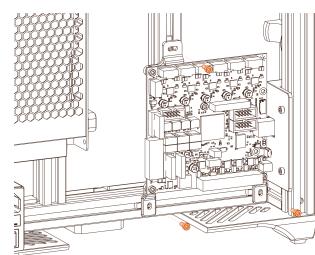
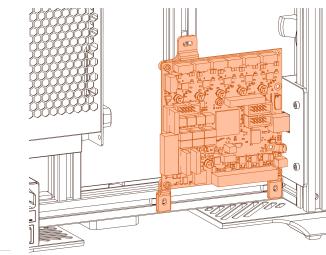
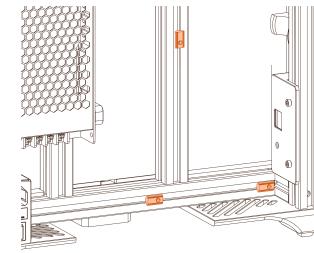
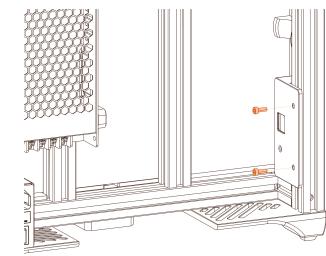
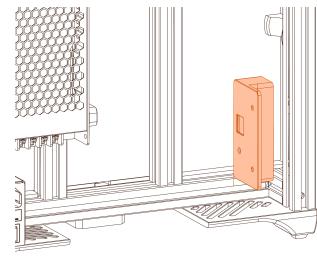
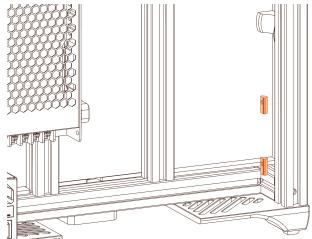
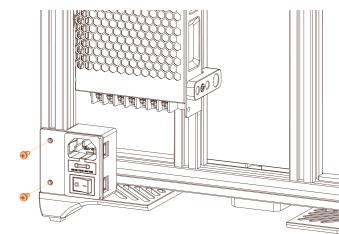
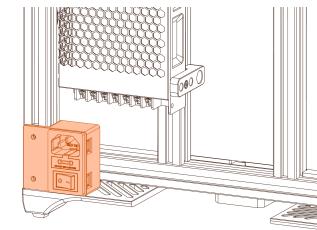
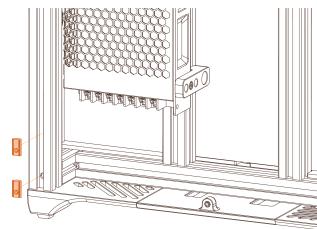
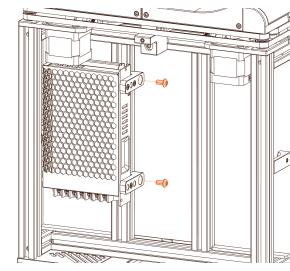
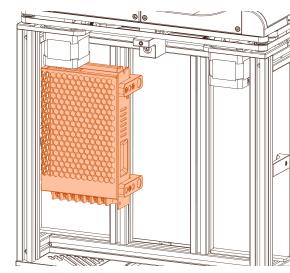
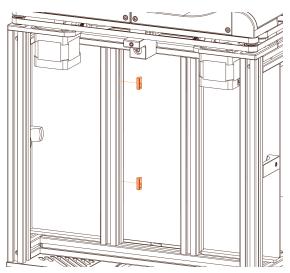
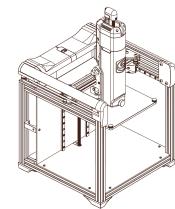
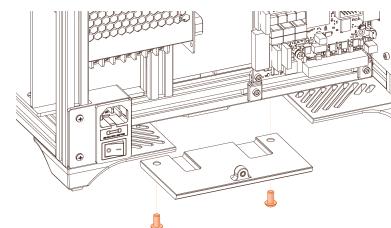
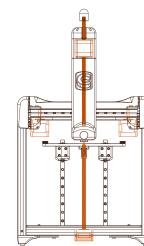
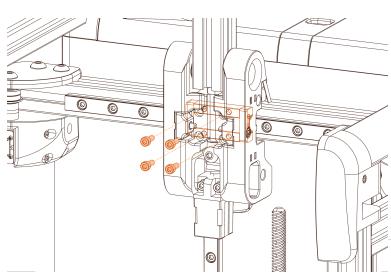


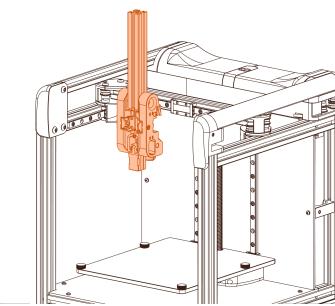
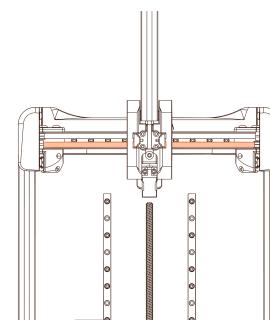
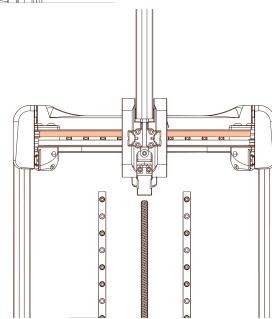
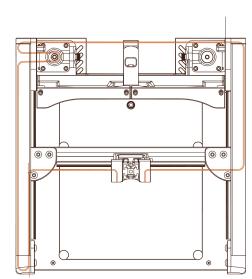
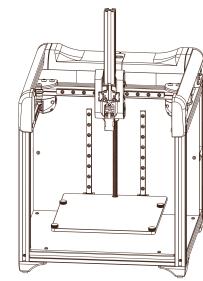
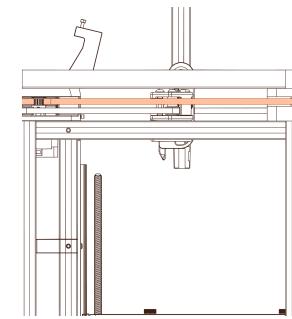
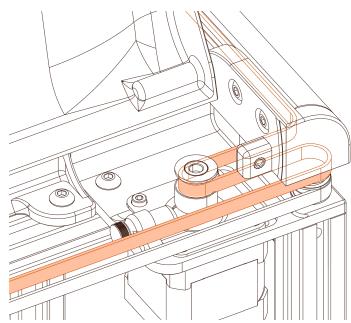
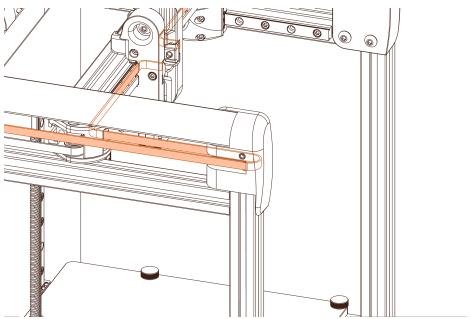
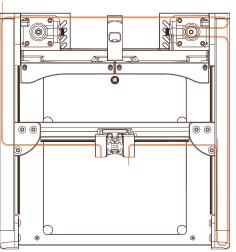


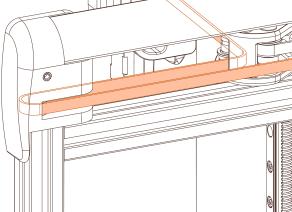
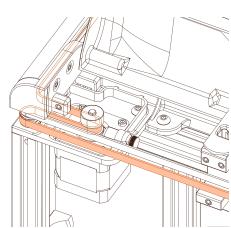
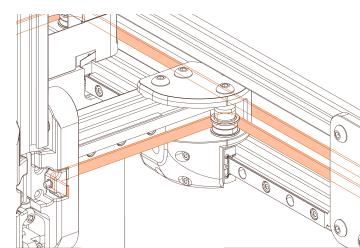
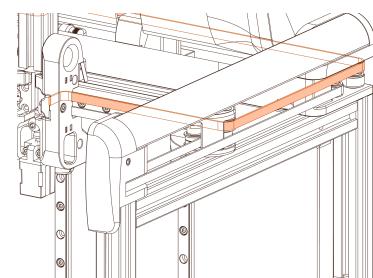
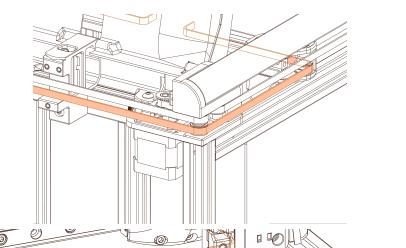
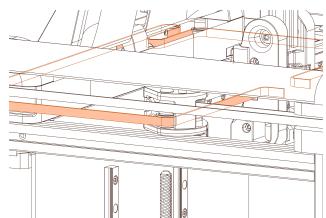
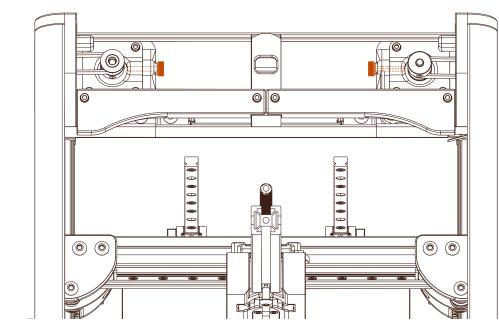
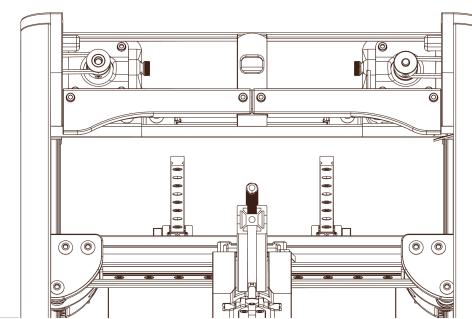
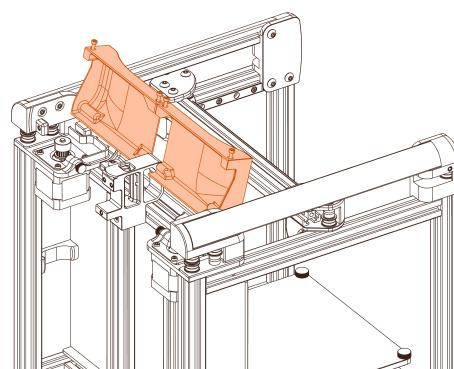
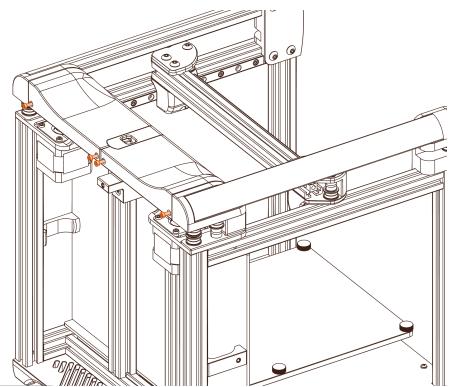
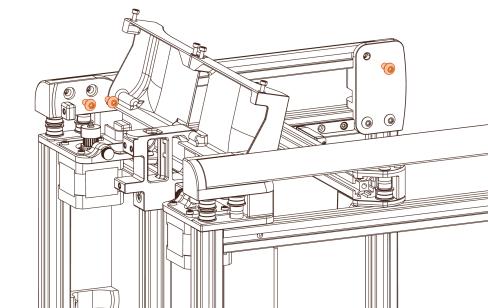
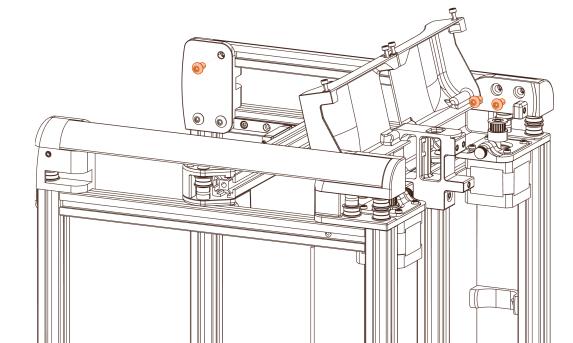
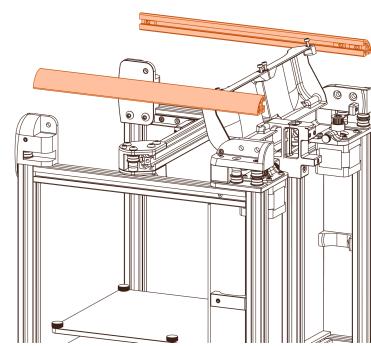
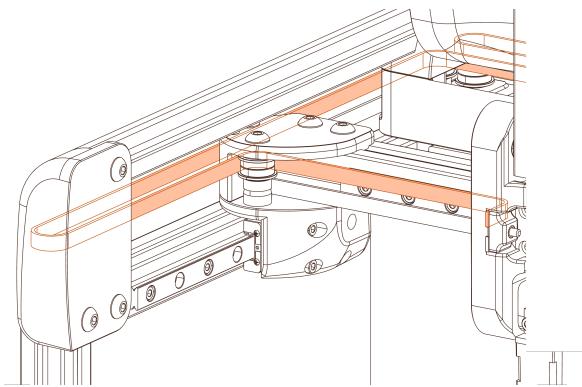


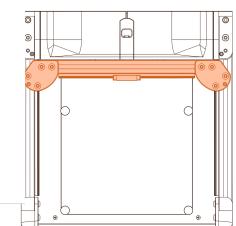
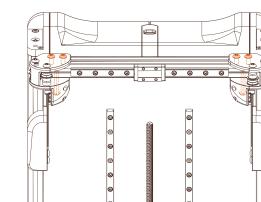
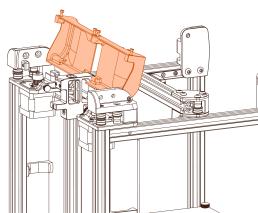
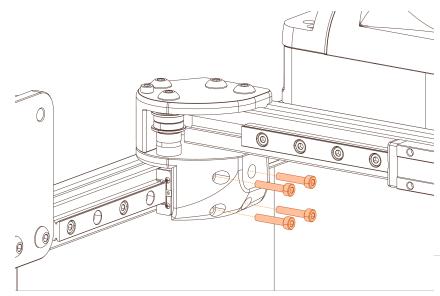
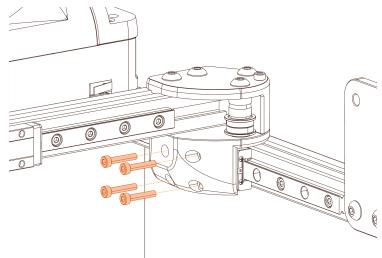
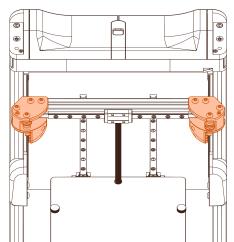
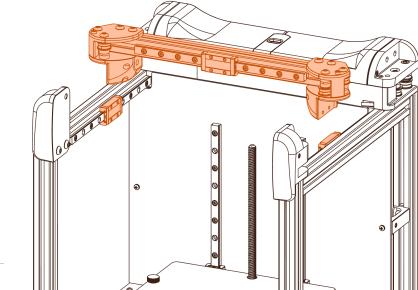
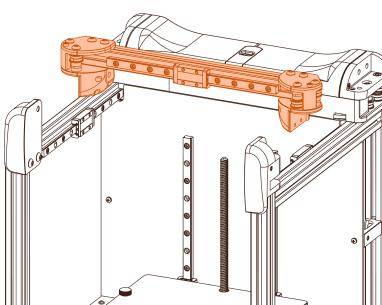
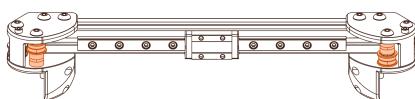
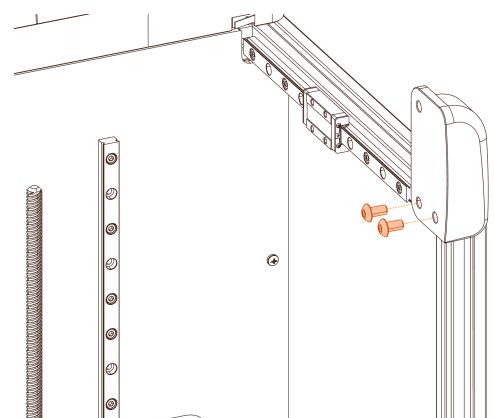
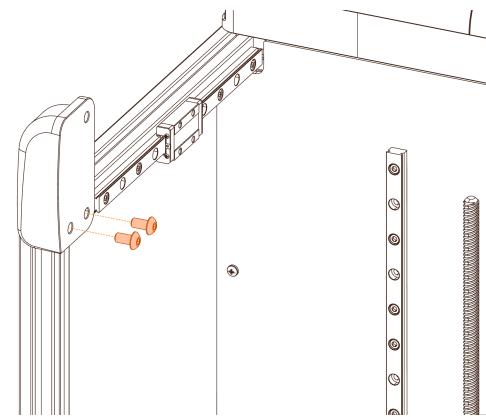
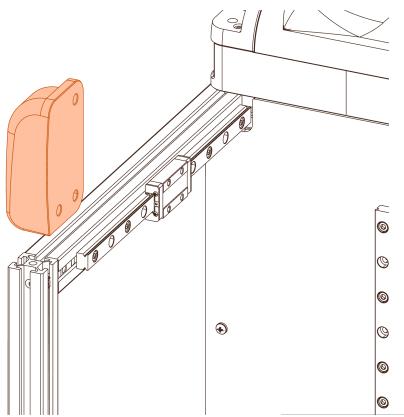
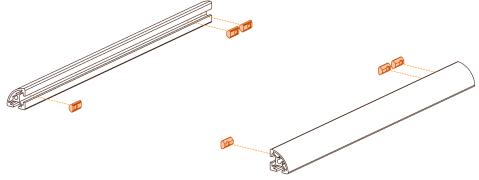


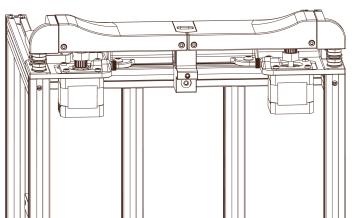
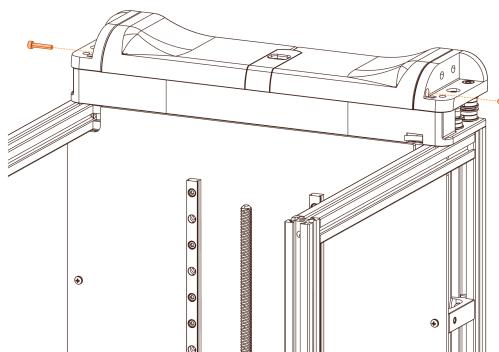
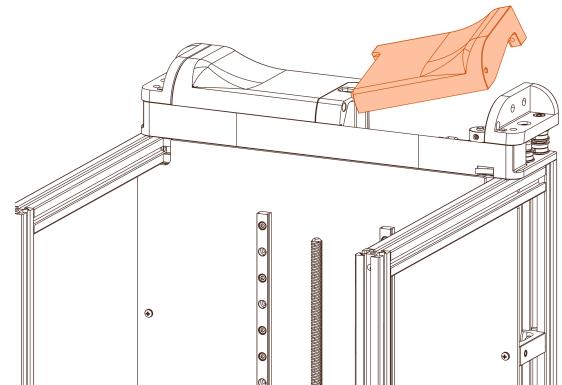
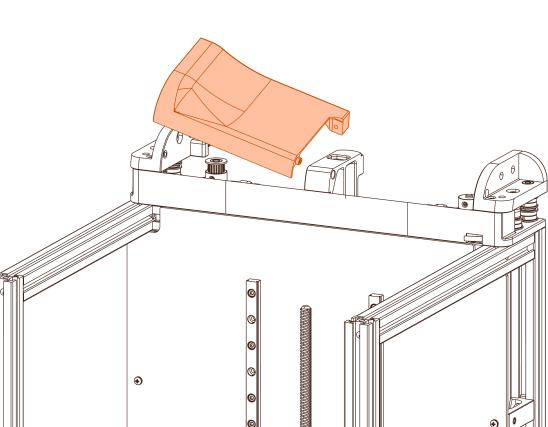
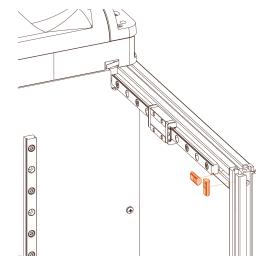
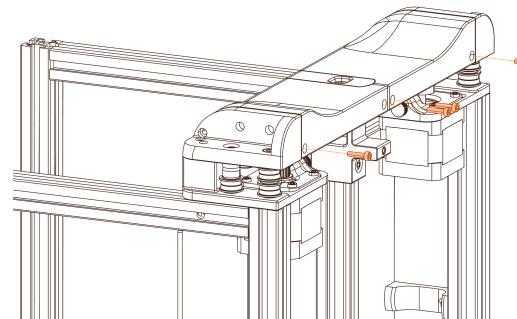
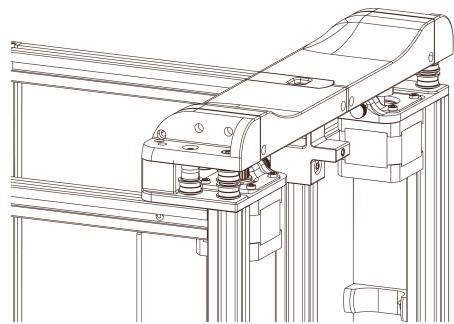
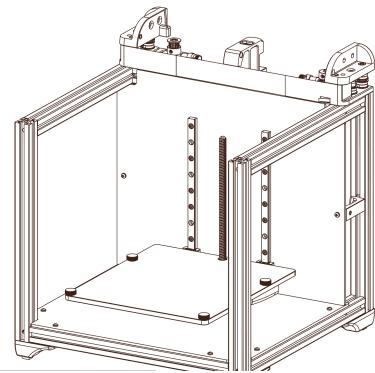
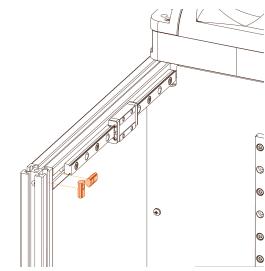
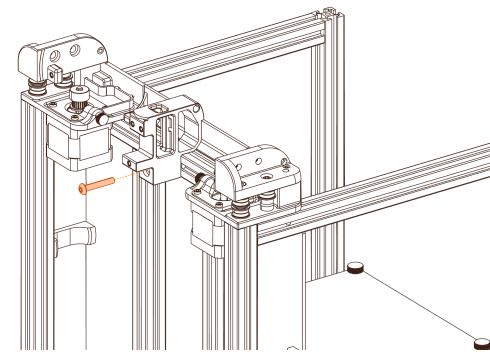
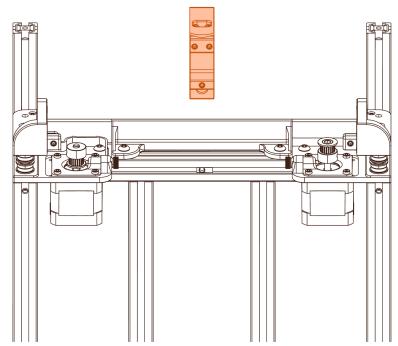
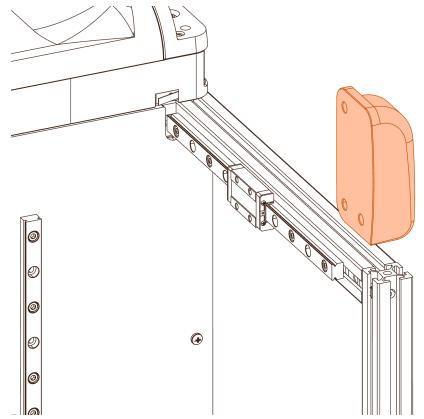




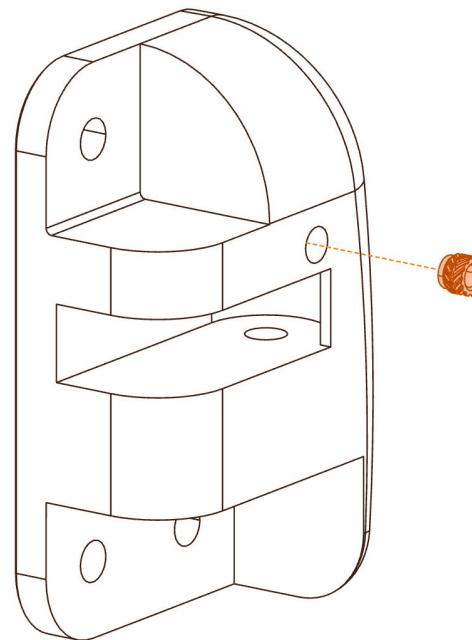
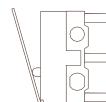
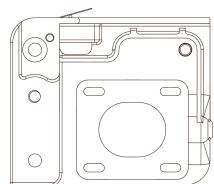
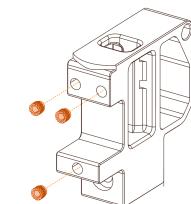
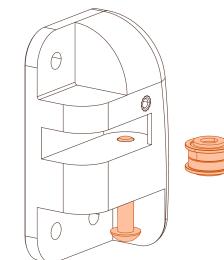
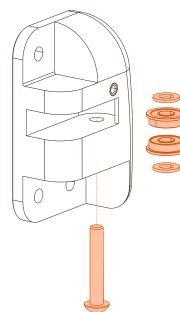
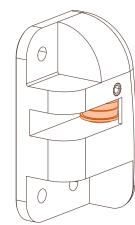
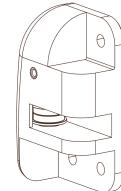
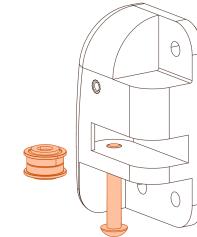
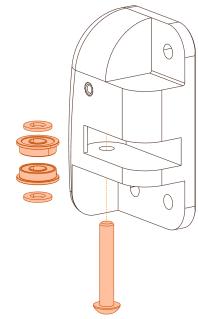
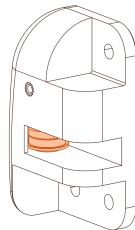


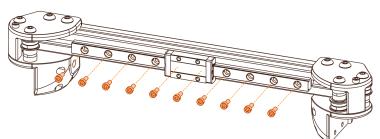
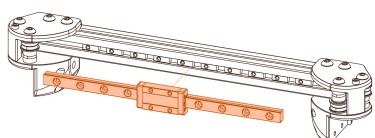
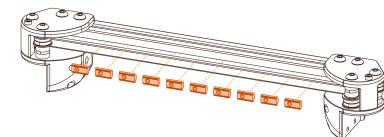
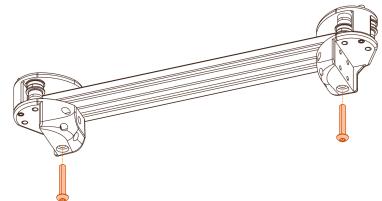
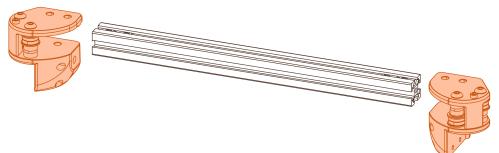
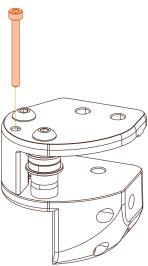
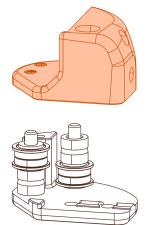
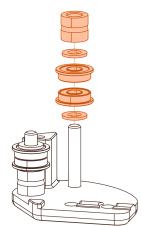
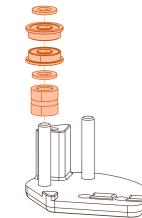
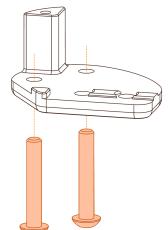
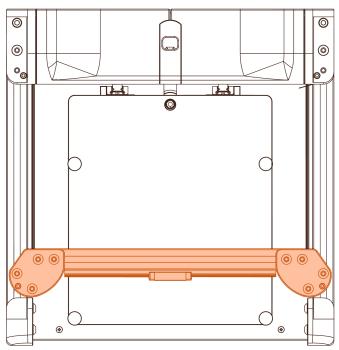
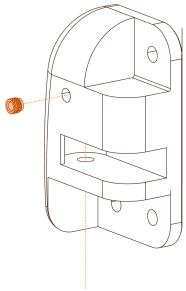


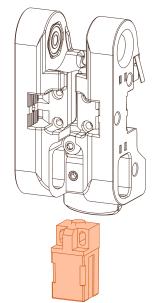
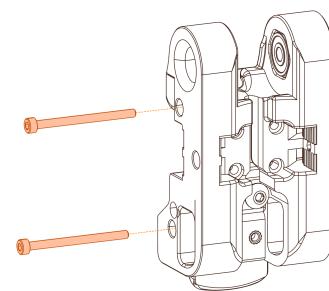
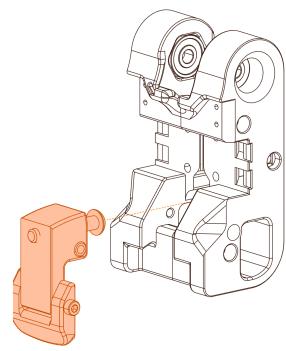
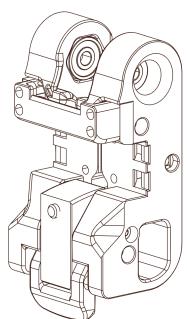
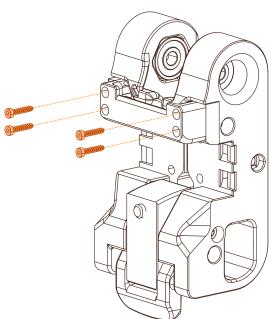
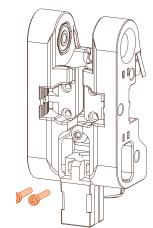
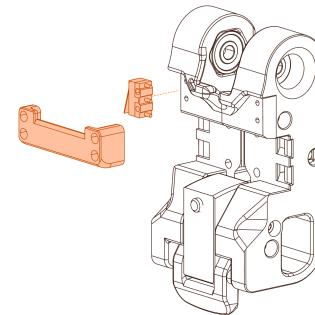
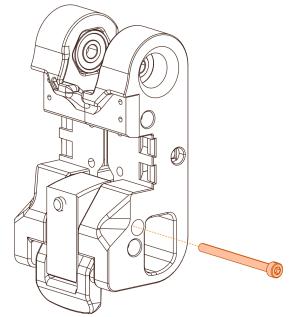
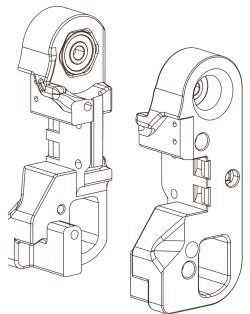
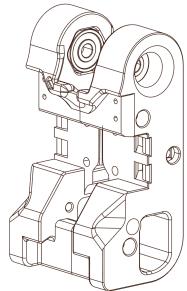
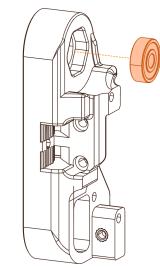
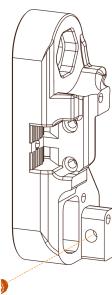
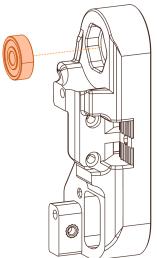
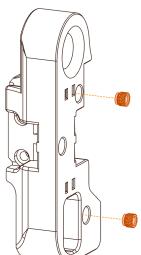
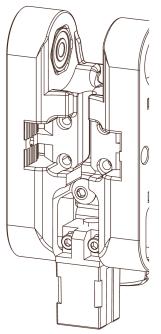


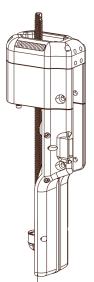
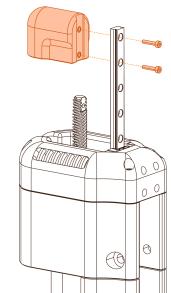
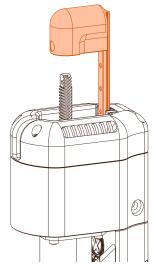
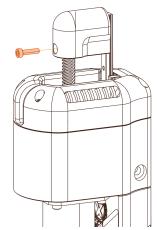
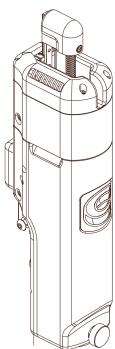
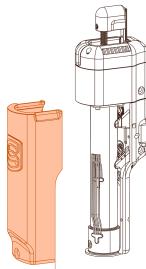
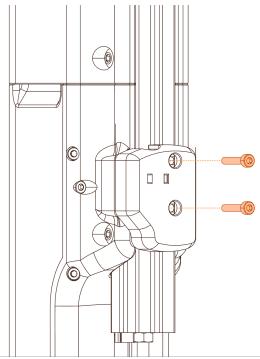
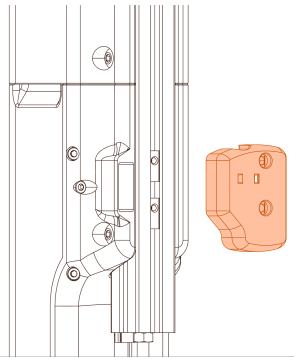
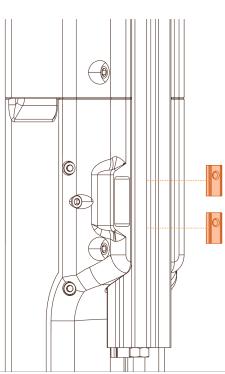
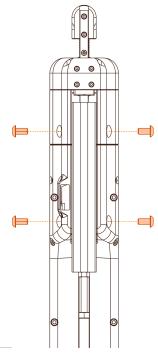
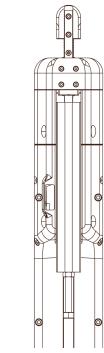
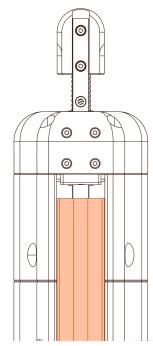
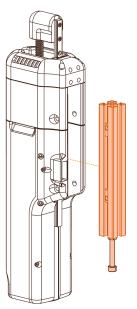
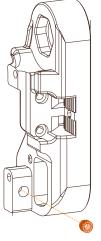




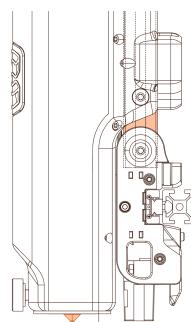
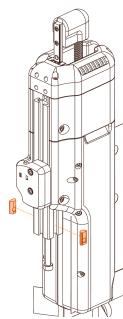
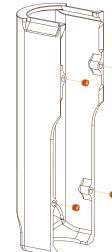
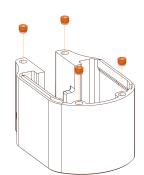
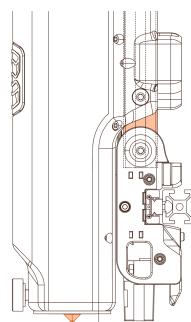
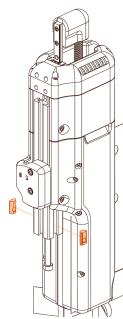
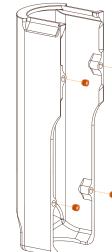
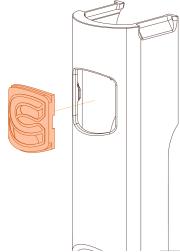
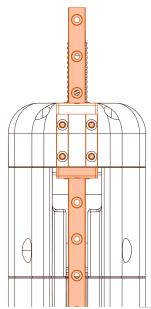
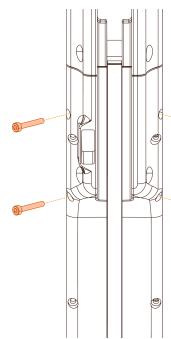
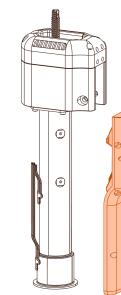
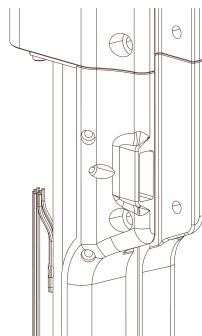
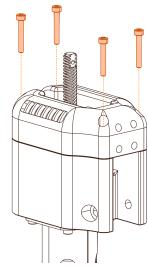
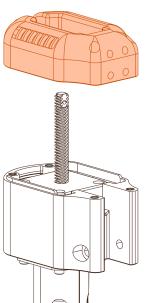
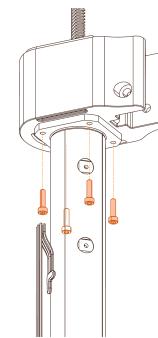
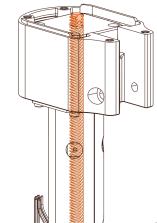
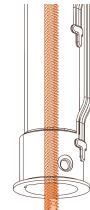
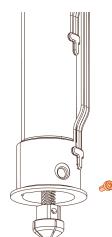
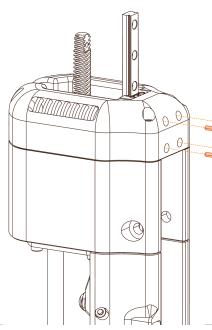


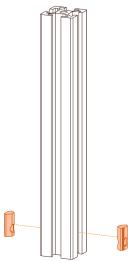
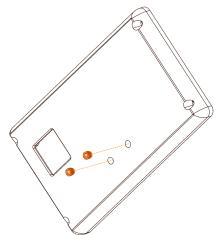
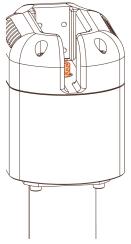
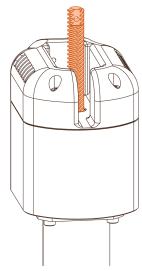
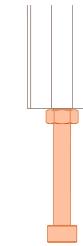
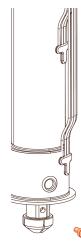
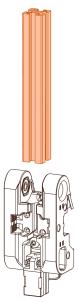
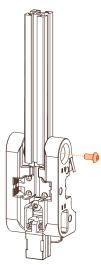
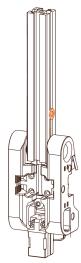
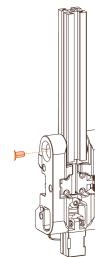
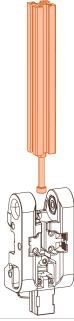
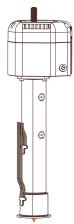


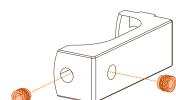
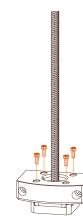
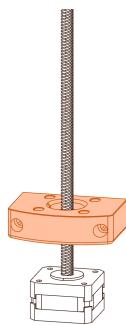
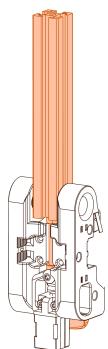
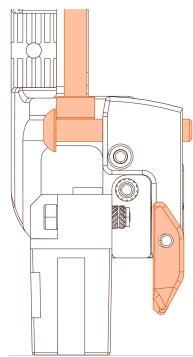
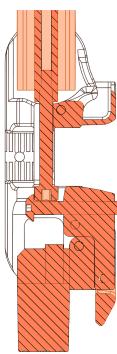
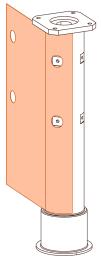
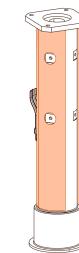
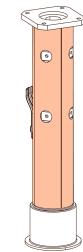
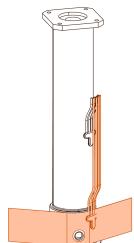
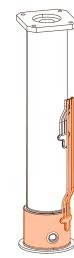
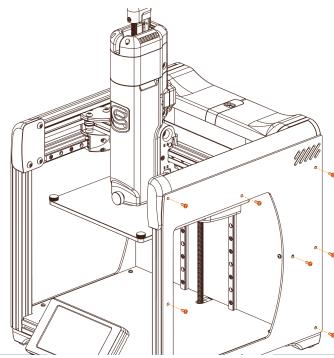
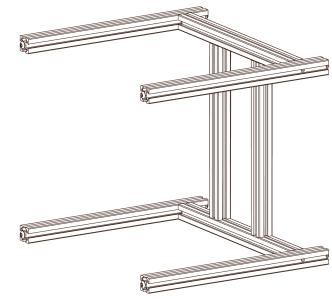
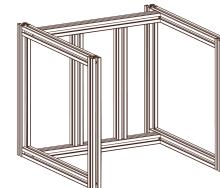
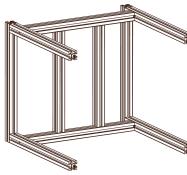
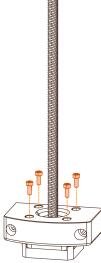
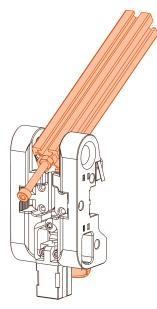


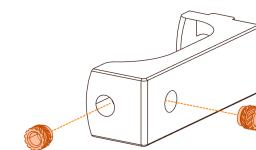
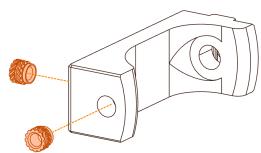
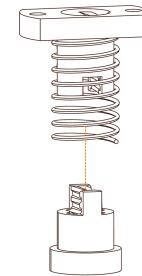
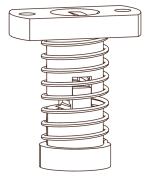


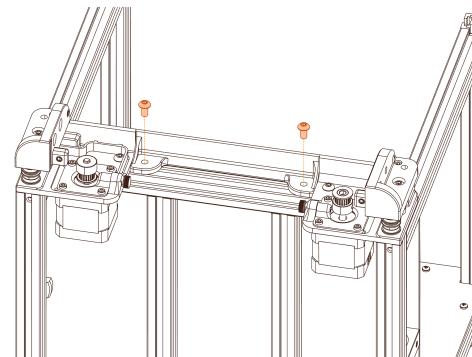
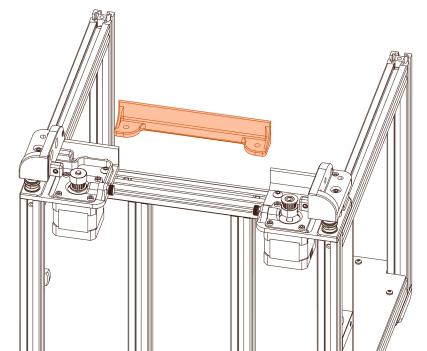
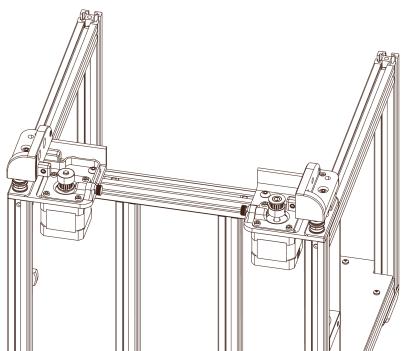
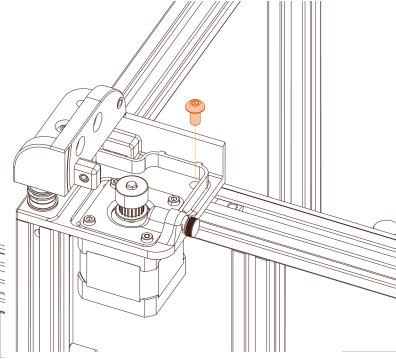
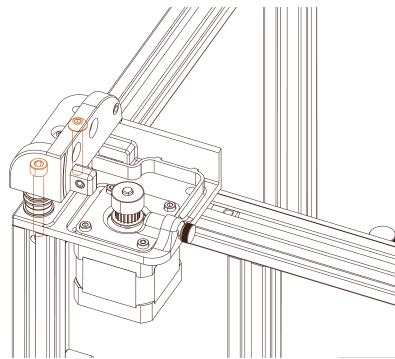
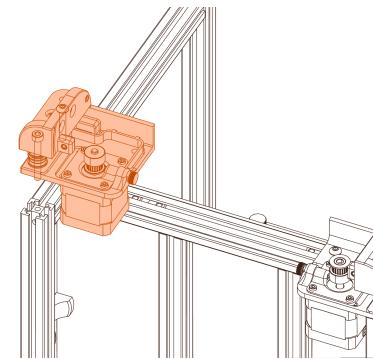
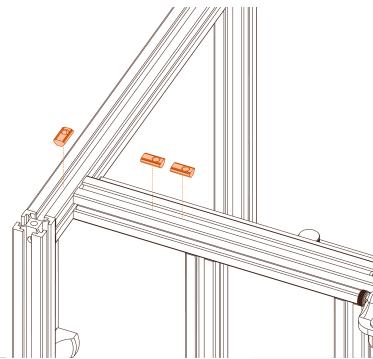
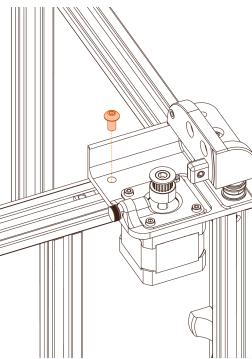
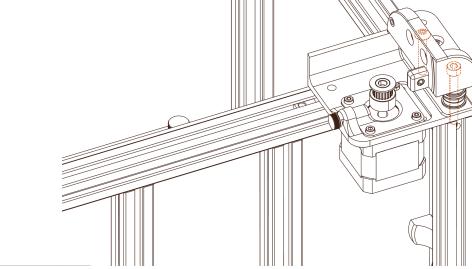
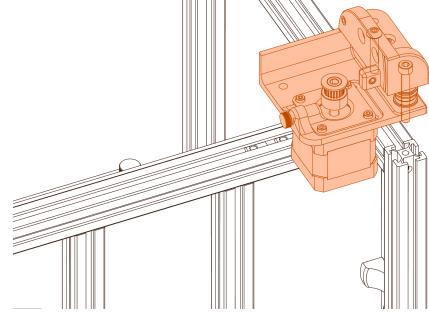
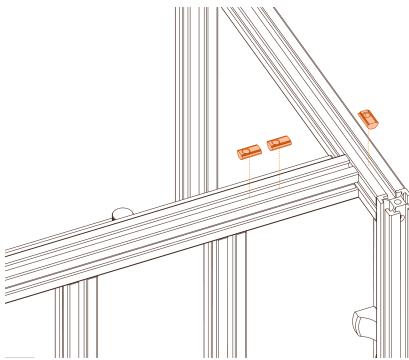
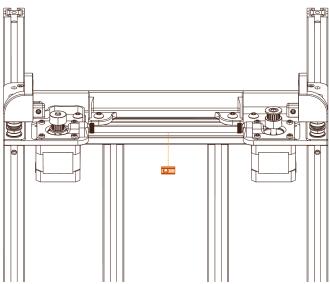
Might need a new image for  
these for the updated stl

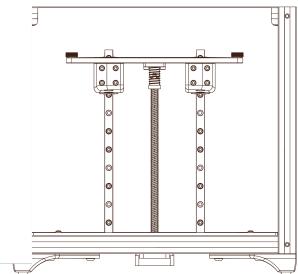
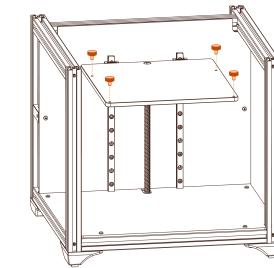
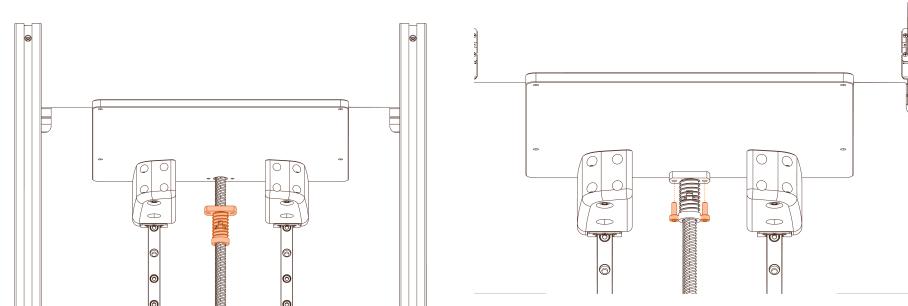
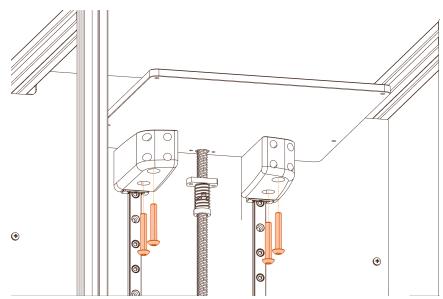
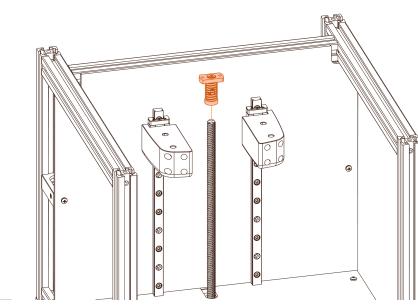
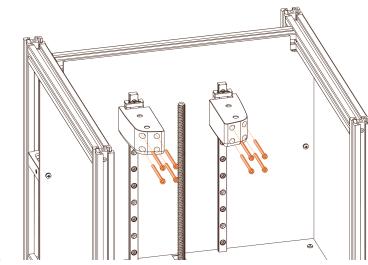
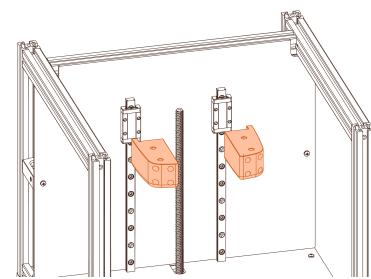
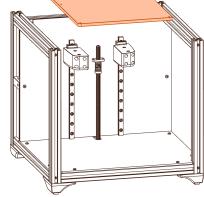
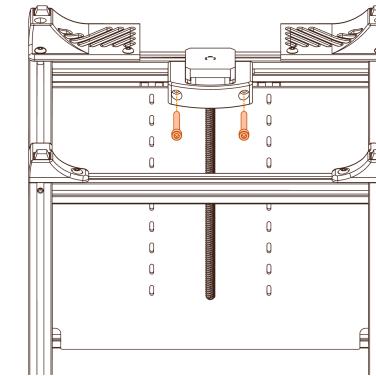
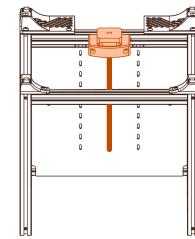
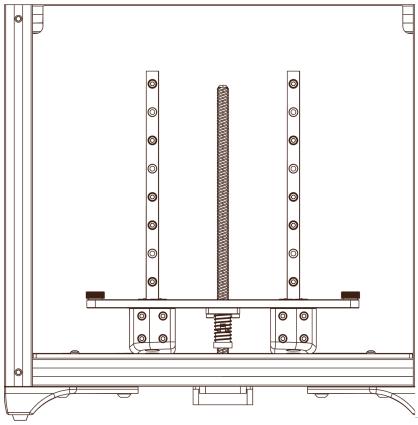


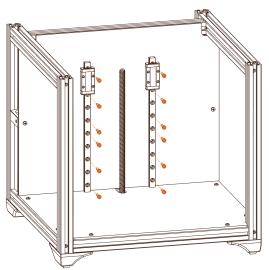
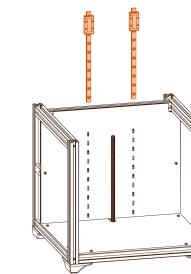
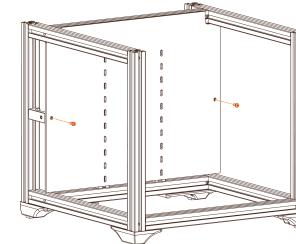
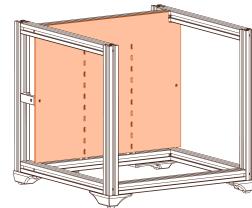
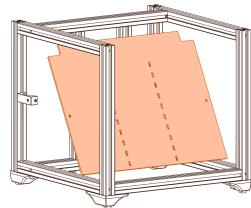
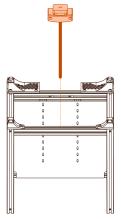




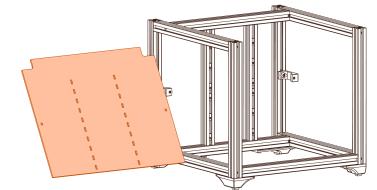
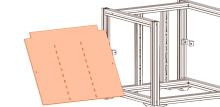
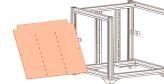
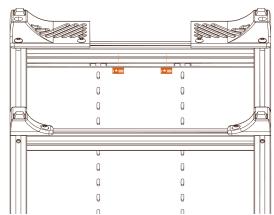
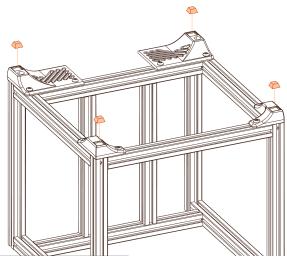
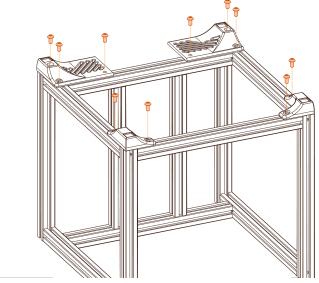
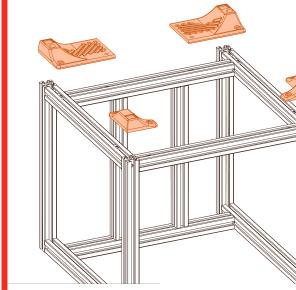
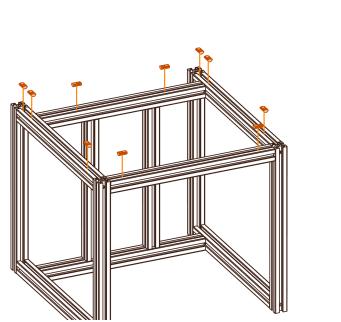








I'm fixing some of this inconsistent line width



Ok! Just let me know if you  
want me to re-add things.  
It's tedious but not too bad  
haha

