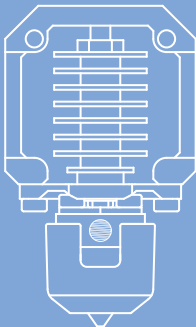


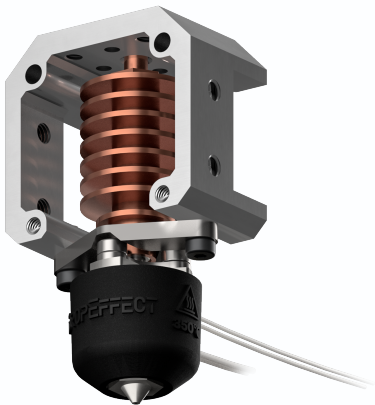
DROPEFFECT™

# XG Hotend Assembly Instruction



Please read and keep this manual carefully  
before using our products properly

## Product Appearance



Dear customer, firstly thank you for purchasing  
XG Hotend from DropEffect.

# XG Hotend Parts



1 Groove Mount



2 CR Mount



3 Copper Plated Nozzle

## Parts & Accessories

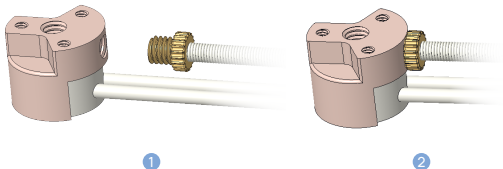
When you open the package,  
you will find the following components.

No.	Name	Quantity
1	H6.0 Open Spanner	1
2	H1.5 Hex Key	1
3	H2.0 Hex Key	1
4	Fans Extension wire -5cm	1
5	Thermistor Extension wire -5cm	1
6	Heating ring Extension wire -5cm	1
7	Fans Extension wire -5cm	1
8	Thermistor Extension wire -5cm	1
9	Hexagon countersunk screw M3*8	4
10	M2.0*6.0 screw	6
11	M2.0*4.0 titanium alloy screw	1
12	Thermal Grease (0.5g)	1

# Assembly Steps

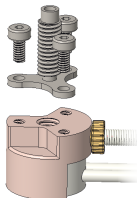
## Step 1

Mount the thermistor to the heatblock through the threaded hole of M4.

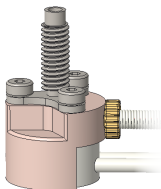


## Step 2

Fix the heatbreak to the heatblock with H1.5 Hex Key through 3 M2\*4 titanium alloy screws. At the same time, coat the external thread of the throat evenly with thermal grease.



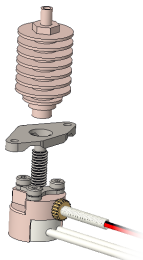
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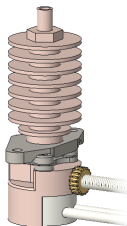
2

### Step 3

Put the heatbreak fixing seat into the threaded end of the heatbreak through the middle hole, the V slot of the heatbreak fixing seat faces the screw, and the side plane of the heatbreak fixing seat faces the thermistor direction. Then screw the heatsink into the thread of the heatbreak M4 and lock it.



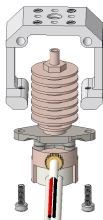
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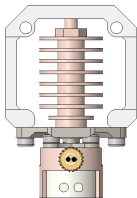
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#### Step 4

Use the H1.5 hex key to connect the heat dissipation frame to the heatbreak fixing seat with two M2\*6 screws.



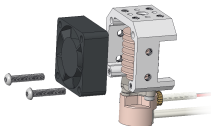
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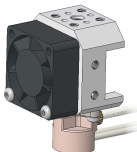
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#### Step 5

Use the H2.0 hex key to connect the 2510 fan to the heat dissipation frame with two M2.5\*14 screws.



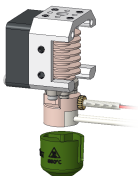
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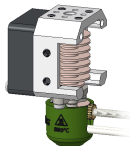
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## Step 6

Put the silicone protective sleeve on the heatblock.



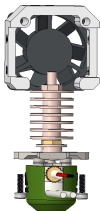
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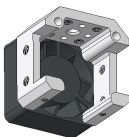
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## Step 7

Connection of the mount: Use the H1.5 hex key to loosen the two M2\*6 screws connecting the heat dissipation frame and the heatbreak fixing seat, and remove the heat dissipation frame, which can be connected with the following two different mounts:



1

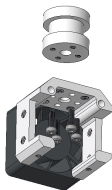


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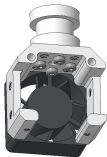


### Step 7-1

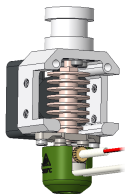
With H1.5 hex key, use 4 M2\*6 screws to connect the heat dissipation frame with the mount - Groove Mount.



1



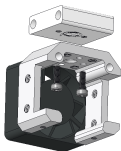
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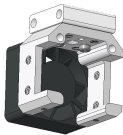
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### Step 7-2

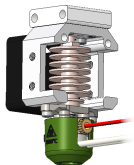
Or with H1.5 hex key, use 2 M2\*6 screws to connect the heat dissipation frame with the mount - CR Mount.



1



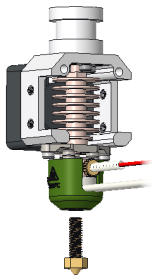
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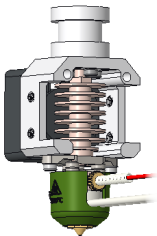
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## Step 8

Install the nozzle: Heat the heating Hotend to 285 °C without filaments, use the H6 open spanner to tighten the nozzle with a torque of about 2.5 NM (see nozzle hot tightening assembly process for more details).



1



2

# Hot - Tightening

## Step 1

Hot - tightening is the last mechanical step before XG Hotend is ready! It is essential for the sealing of the nozzle and heatbreak to ensure that molten filaments do not leak out of the hotend during use.

## Step 2

Using the printer's control software (or LCD screen) to set the hotend's temperature to 285°C. Wait one minute after its temperature reaches 285°C to equalize the temperature of all components.

## Step 3

Gently tighten the nozzle while fixing the heatblock with a wrench, and tighten the nozzle . This will keep the nozzle close to the heatbreak and ensure that the hotend does not leak.

## Step 4

The tightening torque of the hot nozzle is about 2.5NM, which is about the pressure applied by one finger on the small wrench.

# DROPEFFECT™

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