



07 - Fitting The Spool Holders.

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**TOOLS:**

- [M3 Thread Tap](#) (1)
- [2mm Allen Key](#) (1)
- [Mallet](#) (1)


**PARTS:**

- [M3 12mm Button Head Screw](#) (16)
- [M3 Washer](#) (16)
- [Printed Spool Carrier](#) (4)
- [Printed Filament Pick-Up](#) (4)
- [Printed Spool Bar](#) (4)
- [8mm x 90mm Metal Bar \(Optional\)](#) (4)
- [Printed PSU Duct](#) (1)
- [Cable Blank](#) (1)

Step 1 — Spool Carrier Parts.

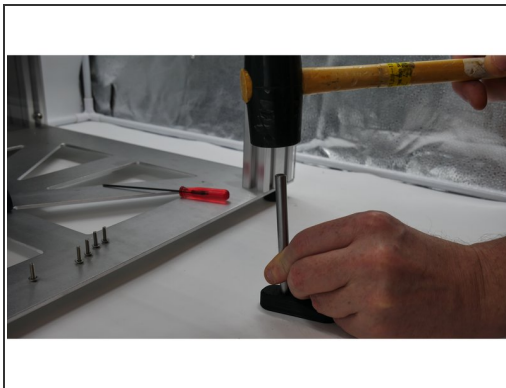



- Gather the parts shown.

 The four 8mm x 90mm bars are **NOT** supplied and the option to print four Spool Bar is provided as an alternative.

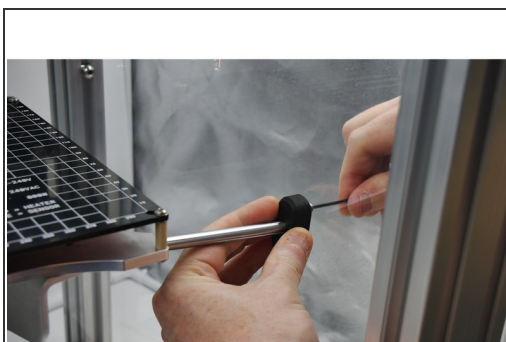
- Download the STLs from [GitHub](#).

Step 2 — Bars.



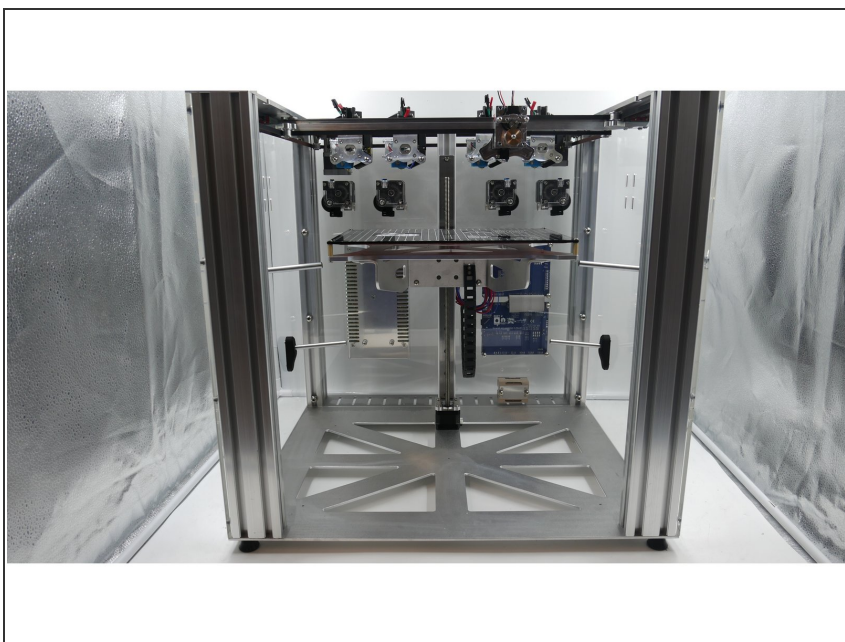
- Tap M3 Threads into the Printed Spool Carriers.
- Carefully hammer the rods into the carriers.
-  They have an upwards tilt, make note of that when hammering them home. You may find it helps to ream the hole with an 8mm drill bit before installing the bars.

Step 3 — Affix.



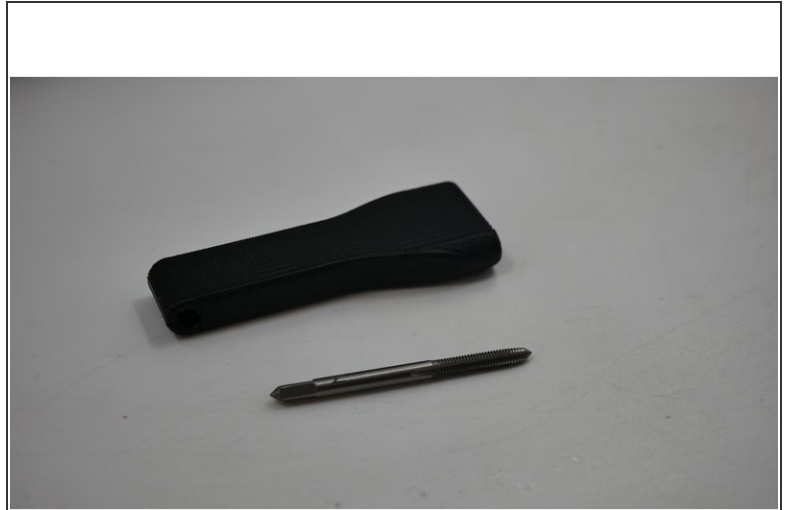
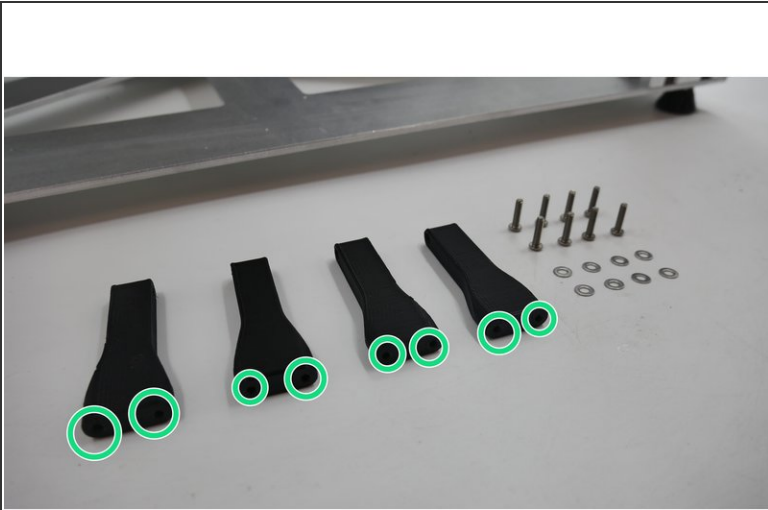
- Place washer over four of the screws.
- Attach two carriers to one side of the machine.

Step 4 — Side.



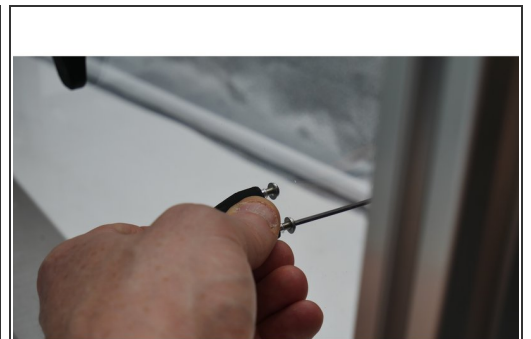
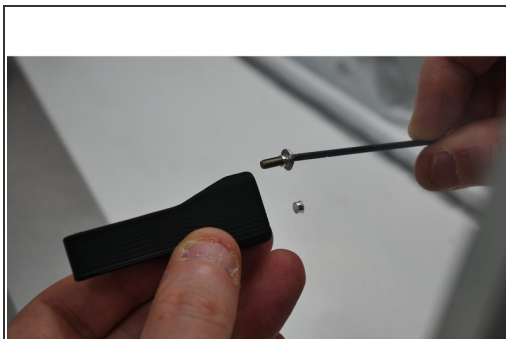
- Repeat the process for the other side.

Step 5 — Next.



- Gather the parts show.
- Tap two M3 threads into each of the four printed parts.

Step 6 — Affix.



- With the smaller hole in the Printed Filament Pick-Ups affix them to the frame, two each side, using a washer and screw.

Step 7 — Rear Panel.



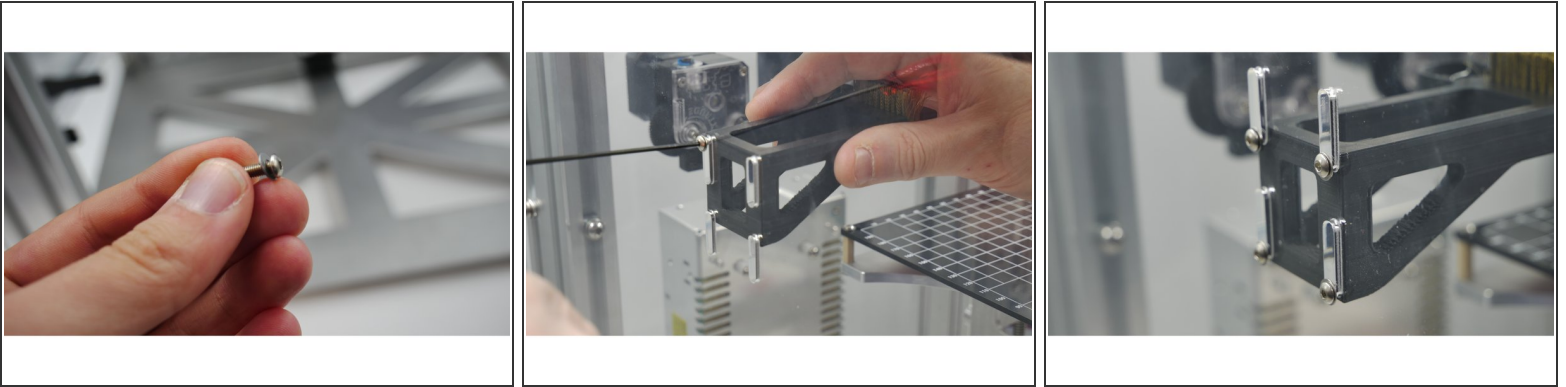
- Fit the Cable Blank into the Rear Panel.
- ❗ The Cable Blank has been provided as a point to which external panel mount cables can be attached. Simply edit the file to match you panel mount cable, and reprint and fit.
- Remove the large circle from the Rear Panel.
- Fit the PSU Fan Duct into the Rear Panel.

Step 8 — Wiper Brush.



- ❗ Using a wiper brush is optional.
- Tap the five holes in the printed part.
- ⚠ I have used a white handled brass brush bought online. The handle was then cut off to leave only the brush component behind. You may need to alter the design of the printed part to fit your brush.
- Slide the brush into the Wiper.

Step 9 — Brush On.



- Attach the Wiper to the Left Side using four M3 12mm Button Head screws and four M3 washers.
- The G-Code to use the brushed wiper is disabled by default in the scripts. If you want to use the brush you will need to re-enable the prime.g and purge.g scripts.
- Using brass nozzles with the brass brush will wear out the nozzles quite quickly. It is recommended that you use [Hardened Steel Nozzles](#) with the brush.