

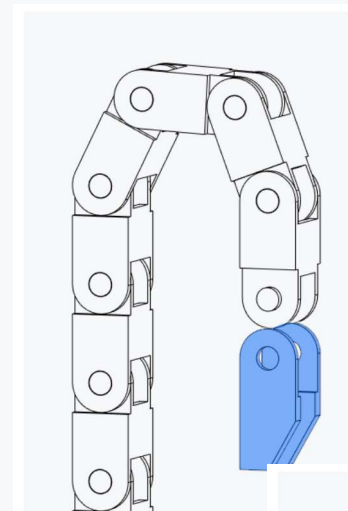
### HEAT SET INSERTS

This design relies heavily on heat set inserts. Make sure you got the proper inserts (check the hardware reference for a close up picture).

If you've never worked with heat set inserts before we recommend you watch a guide.



<https://voron.link/cubk4lh>



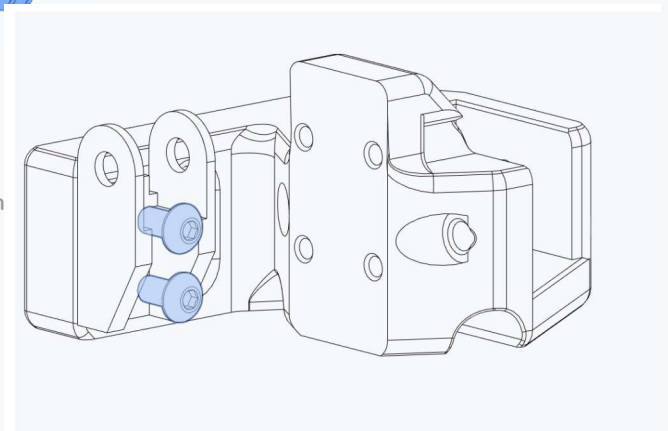
### Cable Chain

#### REMOVE END LINK

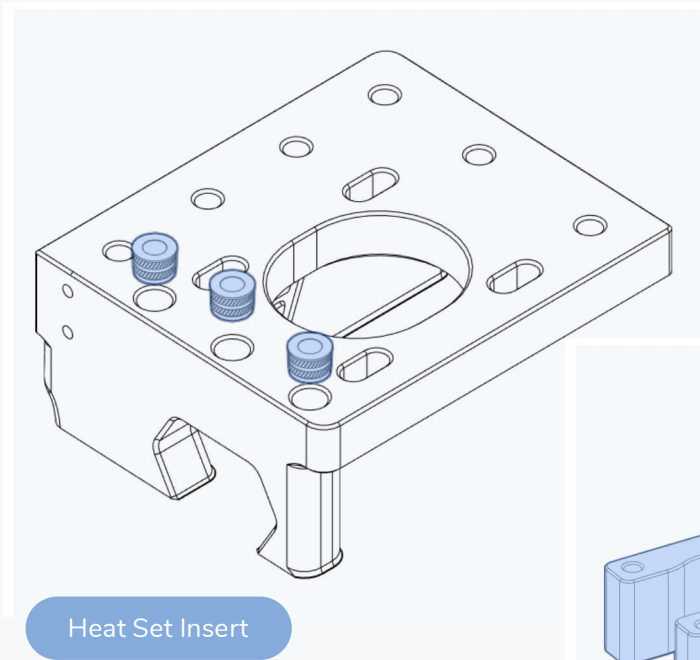
Reattaching the chain later makes the assembly a lot easier.

### CHAIN VISIBILITY

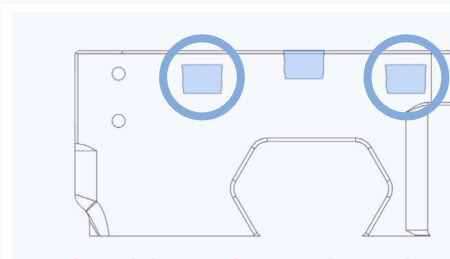
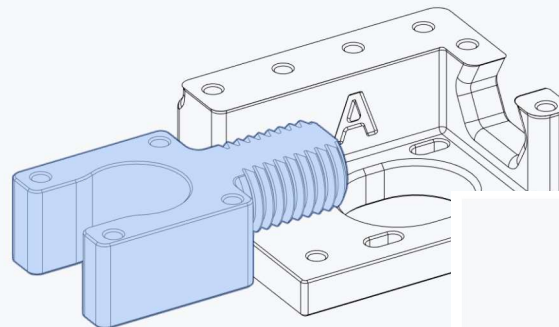
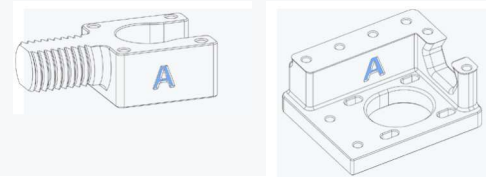
We won't be showing the chain in later pictures.



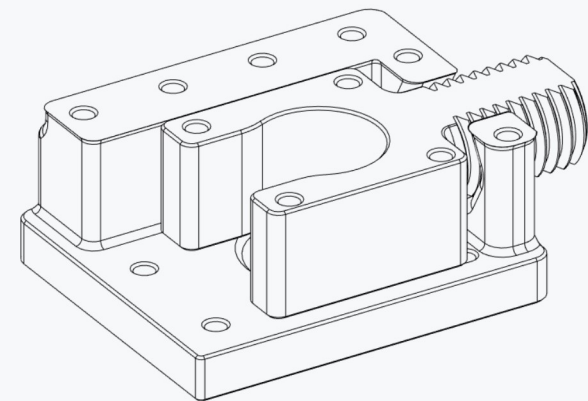
### M3x8 BHCS

**IDENTIFYING THE RIGHT PART**

The parts have their sides embossed.

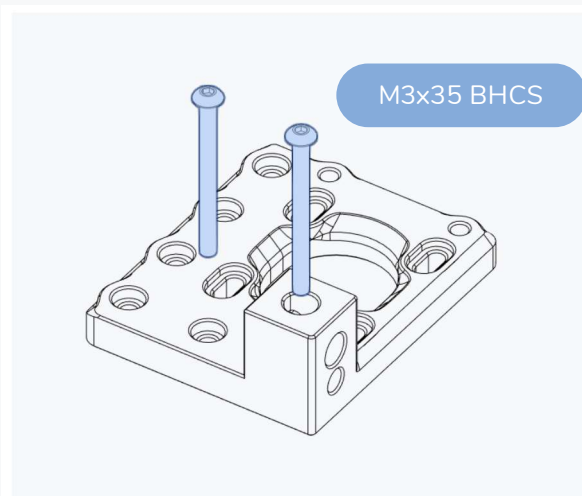
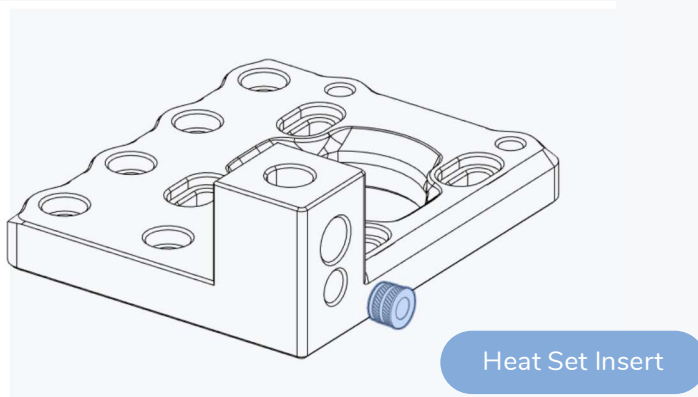
**INSERTS SIT BELOW THE SURFACE**

The outer heat set inserts sit below the surface of the part. When installing make sure the heat set inserts bottom out in their hole.



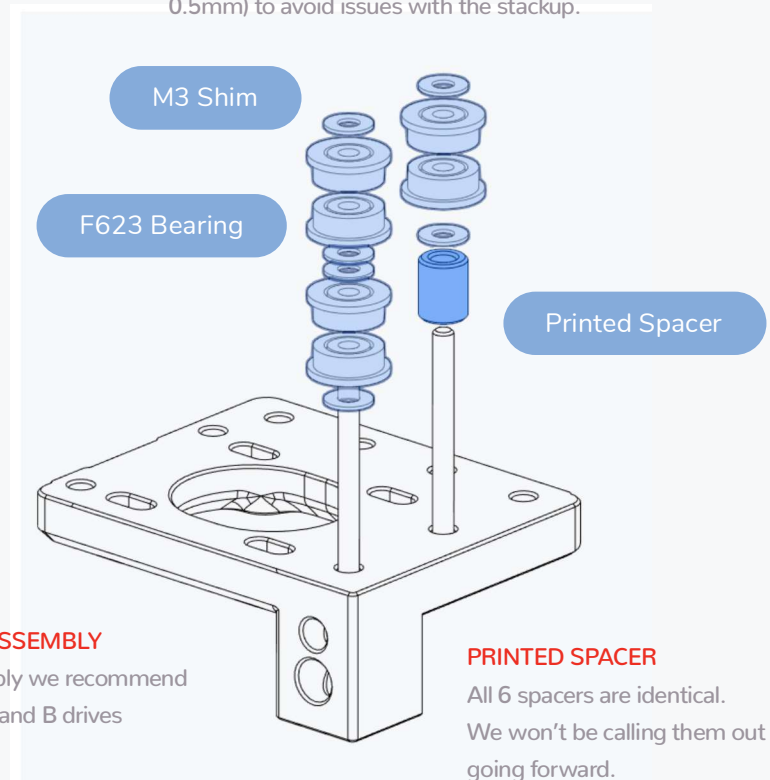
## A DRIVE

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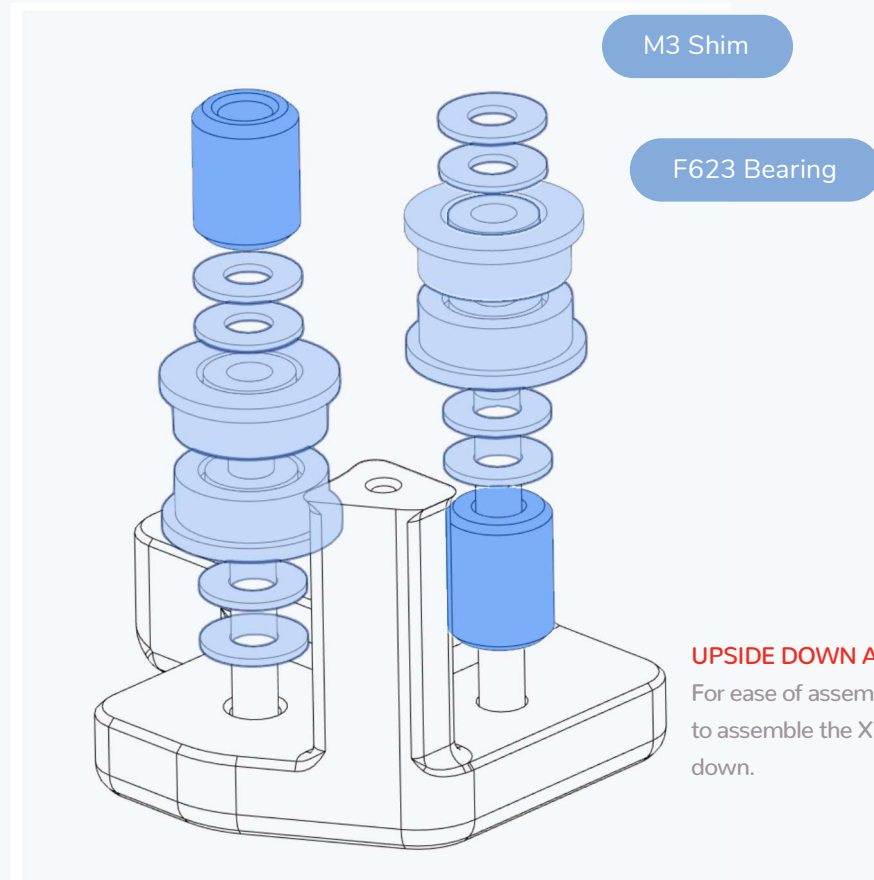
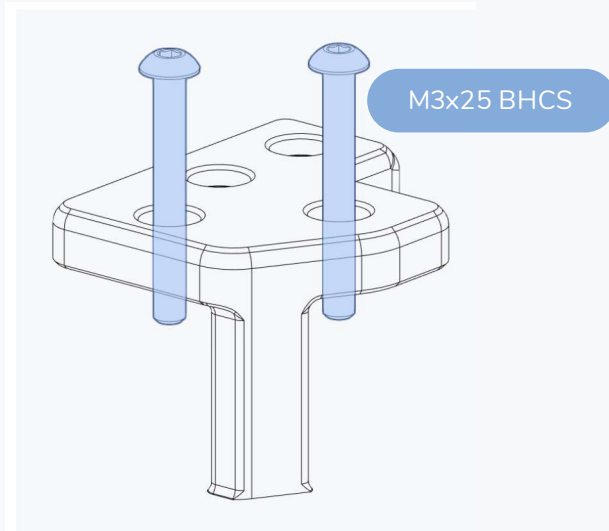
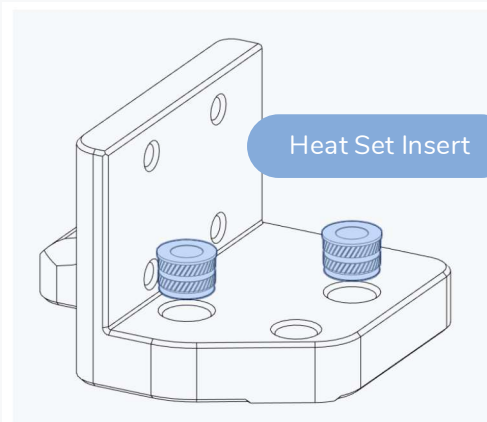
### A NOTE ON SHIMS

We specify shims as they have a consistent thickness compared to regular washers. If you sourced washers instead make sure to measure their thickness (target = 0.5mm) to avoid issues with the stackup.



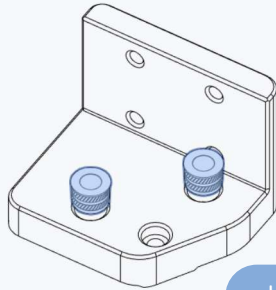
## XY JOINTS

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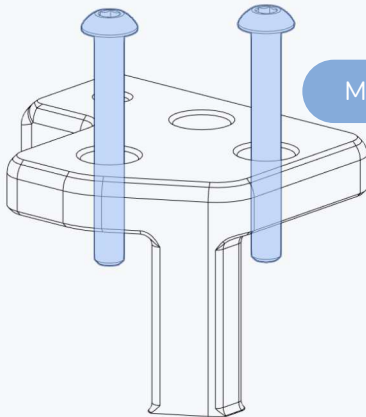


## XY JOINTS

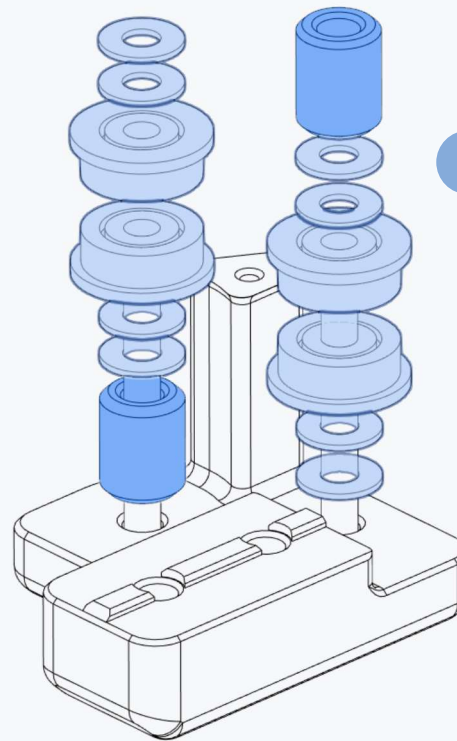
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Heat Set Insert



M3x25 BHCS



M3 Shim

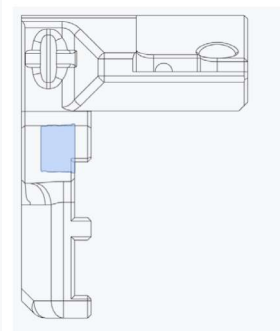
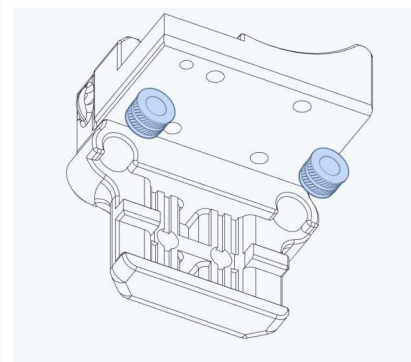
F623 Bearing

### UPSIDE DOWN ASSEMBLY

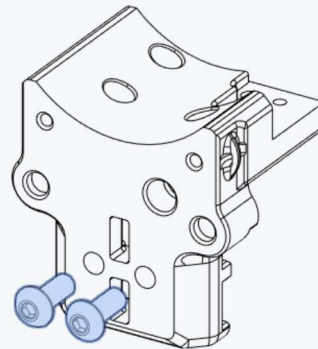
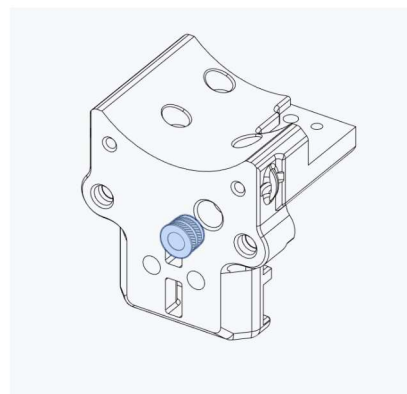
For ease of assembly we recommend to assemble the XY joints upside down.

## X CARRIAGE

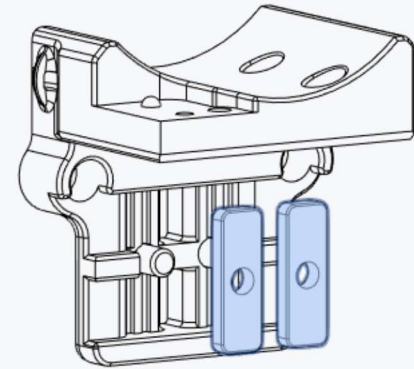
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Heat Set Insert



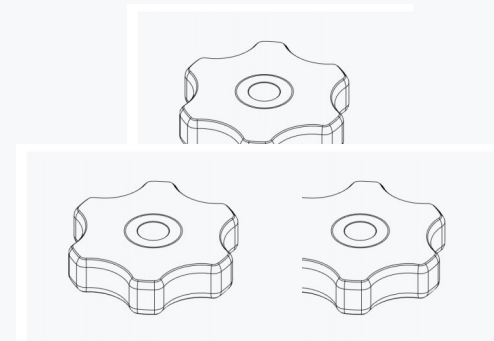
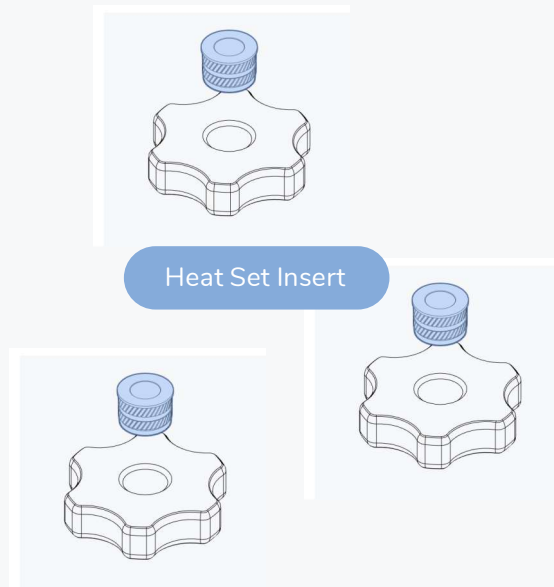
M3x8 BHCS

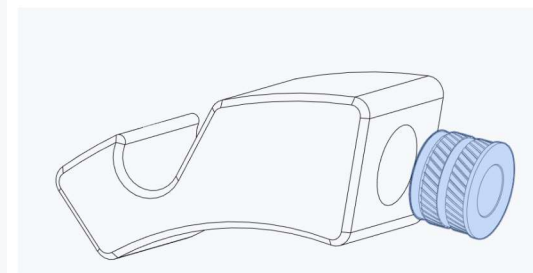
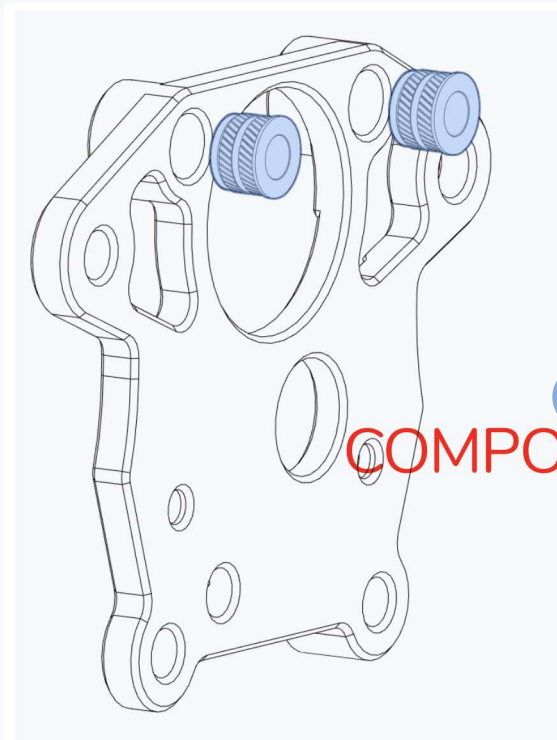


M3 "MakerBeam XL" Nuts

### **DON'T TIGHTEN**

Leave the nuts loose. The belt is threaded into this part in the next step.



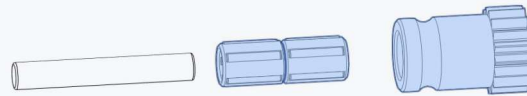


Heat Set Insert

COMPO

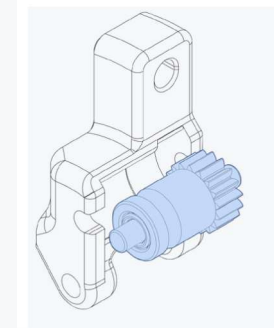


### BMG Idler Assembly

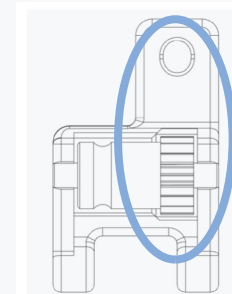
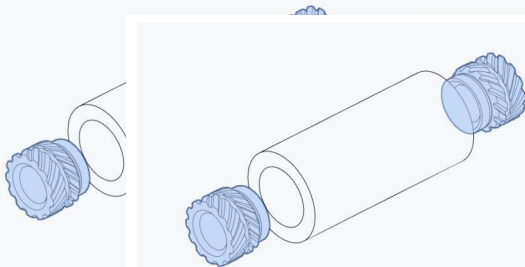


#### LUBRICATE BEARINGS

A lubrication film is required to ensure smooth operation and longevity. Refer to the BOM for lubricant options.

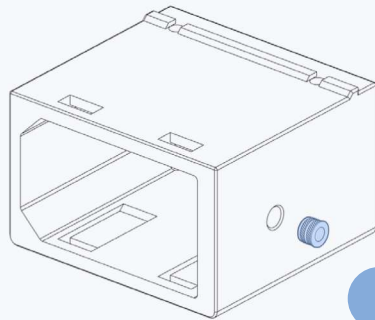


### Heat Set Inserts

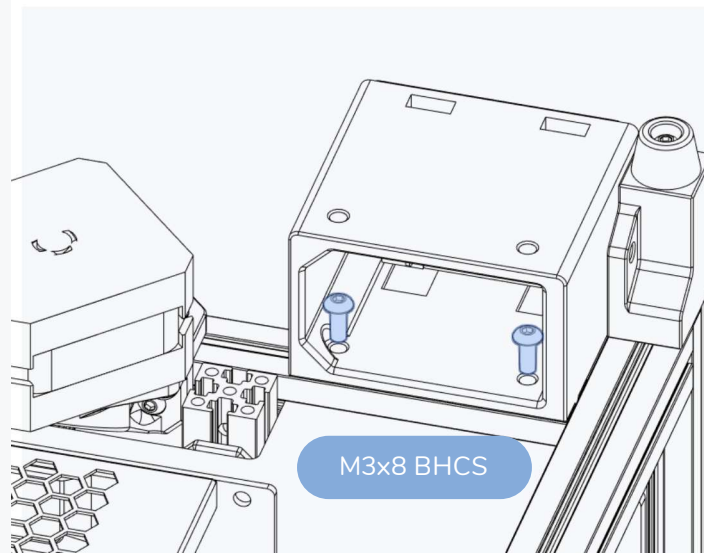


#### CHECK ORIENTATION

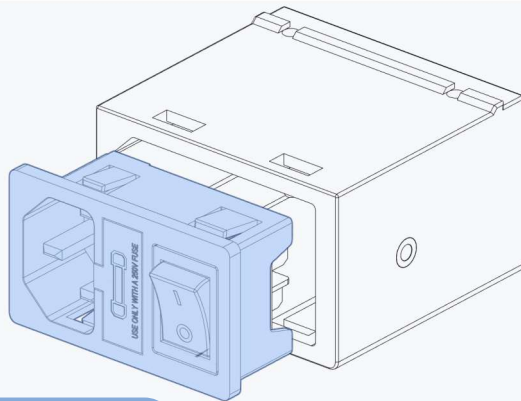
The larger gear section must be on the right hand side. Check for any rubbing or binding.



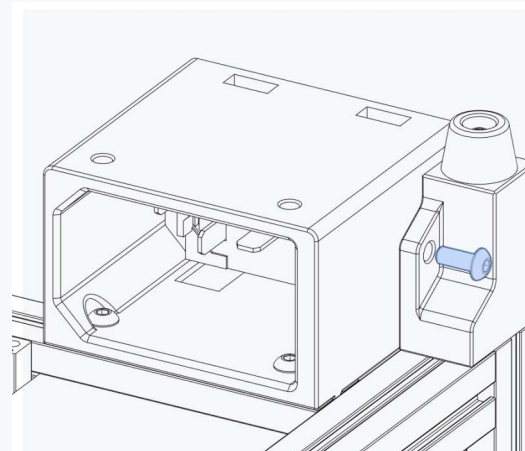
Heat Set Insert



M3x8 BHCS



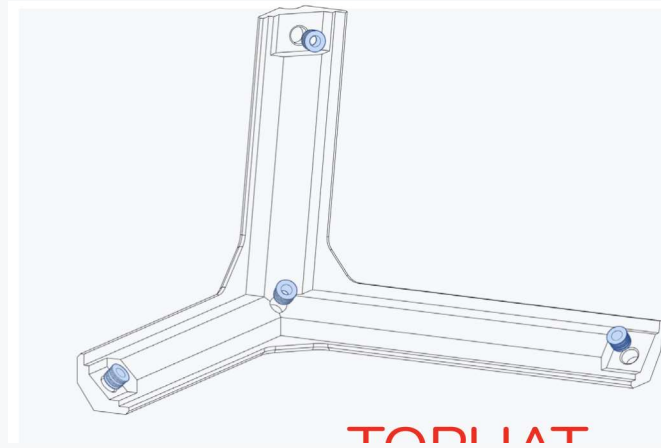
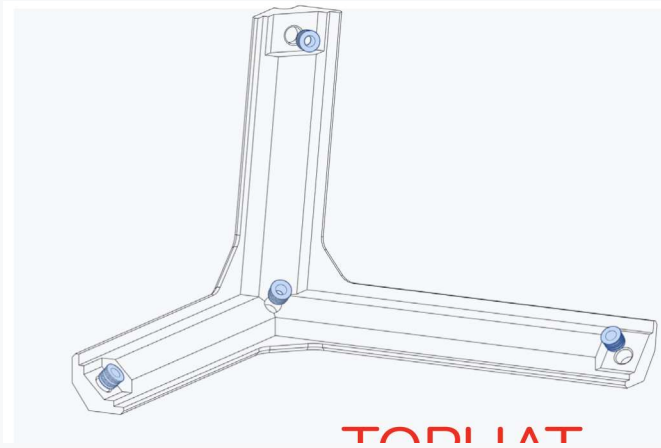
Prepared Mains Inlet



M3x8 BHCS

TOPHAT

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Heat Set Insert

