



**Less than \$500
total BOM cost.**

upside-down print orientation

PEI bed (heating not required)

printing without retractions

- high-acceleration CoreXY
- Klipper input shaping
- small frame rigidity
- gravity reduces “oozing”

low-maintenance toolhead

- Ø2.85 mm filament (Orbiter)
- copper plated nozzle
- titanium heatbreak
- 4010 fans (DragonBurner)

modified Voron0 frame

- open for better cooling
- faster assembly
- easy-to-source parts

Estimated assembly time:

1-3 days (first-time)

< 1 day (with prior experience)