



# SIBOOR Trident [JUNE] ASSEMBLY

VERSION 2024/12/31

# INTRODUCTION



## Important Note:

This assembly manual is exclusively designed for the SIBOOR Trident JUNE kit. For the official VORON Trident assembly manual, please refer to the following link:

<https://github.com/VoronDesign/Voron-Trident/tree/main/Manual>

## Why the Change?

The SIBOOR Trident JUNE kit includes numerous modifications and significant electrical adjustments. Simply adding supplementary pages to the existing manual is no longer sufficient. You would have to navigate through many pages repeatedly.

To enhance user experience, SIBOOR has opted to create a new assembly guide from scratch, ensuring it closely matches the Trident JUNE kit. The assembly logic and the presentation of most steps in this manual are inspired by the original VORON manual.

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/Lzhikai/SIBOOR-Voron-Trident-June/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 feed-

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## HOW TO GET HELP

If you need assistance with your build, we're here to help. Head on over to our Discord group and post your questions. This is our primary medium to help VORON Users and we have a great community that can help you out if you get stuck.



Voron Discord: <https://discord.gg/voron>

Siboor Discord: <https://discord.gg/BMJD4puJf6>

Here are some portals for your convenience:

- VORON Design: [www.vorondesign.com](http://www.vorondesign.com)
- SIBOOR DOCS: <https://docs.siboор.com>
- SIBOOR Trident [JUNE] Github: <https://github.com/Lzhikai/SIBOOR-Voron-Trident-June>

If you want to learn more about the mods included in this kit:

- CNC AWD Drive: <https://github.com/GKD-Team/Voron-Trident-CNC-Gantry>
- Cartographer Probe: <https://docs.cartographer3d.com>
- Fume pack V2: [https://github.com/Exerqtor/Voron/tree/main/Mods/fume\\_pack](https://github.com/Exerqtor/Voron/tree/main/Mods/fume_pack)
- Clickyclacky door: [https://github.com/tanaes/whopping\\_Voron\\_mods/tree/main/-clickyclacky\\_door](https://github.com/tanaes/whopping_Voron_mods/tree/main/-clickyclacky_door)

Mods already included in the SIBOOR Trident [JUNE] GitHub are not listed separately.

## PART PRINTING GUIDELINES

The Voron 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:

### 3D PRINTING PROCESS

Fused Deposition Modeling (FDM)

### MATERIAL

ABS

### LAYER HEIGHT

Recommended: 0.2mm

### EXTRUSION WIDTH

Recommended: Forced 0.4mm

### INFILL TYPE

Grid, Gyroid, Honeycomb, Triangle or Cubic

### INFILL PERCENTAGE

Recommended: 40%

### WALL COUNT

Recommended: 4

### SOLID TOP/BOTTOM LAYERS

Recommended: 5

## FILE NAMING

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

### PRIMARY COLOR

Example z\_joint\_lower\_x4.stl

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

### ACCENT COLOR

Example [a]\_tensioner\_left.stl

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

### QUANTITY REQUIRED

Example [a]\_z\_belt\_clip\_lower\_x4.stl

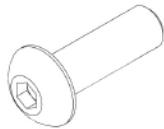
If any file ends with “\_x#”, that is telling you the quantity of that part required to build the machine.

\*The suffix "by\_SIBOOR" on some STL files indicates that these files differ from the original VORON design or the original MOD design and are specifically tailored for the SIBOOR Trident JUNE KIT.

\*The prefix "[Two-color]" indicates that the STL file requires printing with two different colors of ABS filament.



In this manual, parts marked with a red star indicate they are ACCENT COLOR.



## BUTTON HEAD CAP BOLT (BHCS)

Metric fastener with a domed shape head and hex drive. Most commonly found in locations where M5 fasteners are used.



## FLAT HEAD COUNTERSUNK BOLT (FHCS)

Metric fastener with a cone shaped head and a flat top.



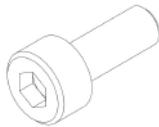
## HEX NUT

Hex nuts couple with bolts to create a tight, secure joint. You'll see these used in both M3 and M5 variants throughout this guide.



## POST INSTALL T-SLOT NUT (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".



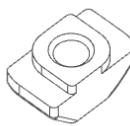
## SOCKET HEAD CAP BOLT (SHCS)

Metric fastener with a cylindrical head and hex drive. The most common fastener used on the Voron.



## HEAT SET INSERT

Heat inserts with a soldering tip 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.



## HAMMERHEAD NUT

Nut that can be inserted into the slot of an aluminium profile. Used exclusively for panel mounting, all other components use T-Slot nuts.



## FLANGE NUT

A flange nut is a nut with a wide edge that increases contact area, distributes pressure, and prevents loosening.



## F695 BEARING

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



## 695 BEARING

Bearings are used to support and reduce friction between rotating parts in mechanical devices.



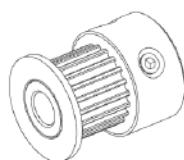
## F623 BEARING

A ball bearing with a flange used . Used for drag chain brackets.



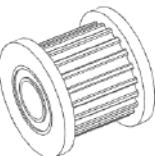
## GE5C BEARING

A spherical bearing is a mechanical component enabling rotational movement and load transfer at various angles, comprising a spherical inner ring and a tilting outer ring.



## PULLEY

GT2 pulley used on the motion system of the Voron.



## IDLER

GT2 idler used in the motion system of the Voron.



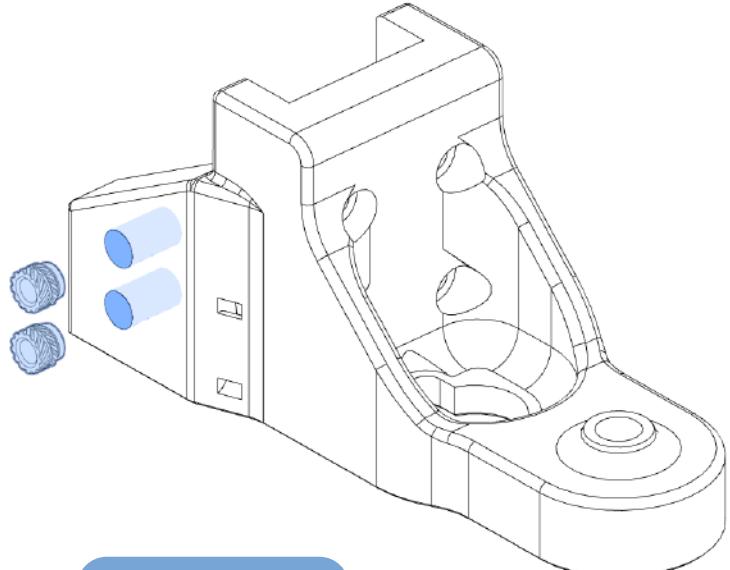
## THUMB NUT

Used in the print bed as a spacer.

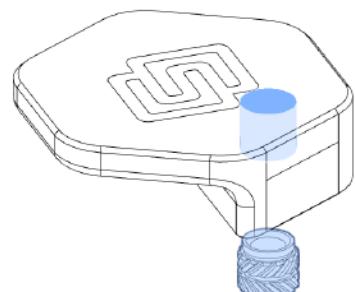


## SET SCREW

Small headless fastner with an internal drive. Used in pulleys and other gears. Also called a grub screw.



Heat Set Insert



## HEAT SET INSERTS

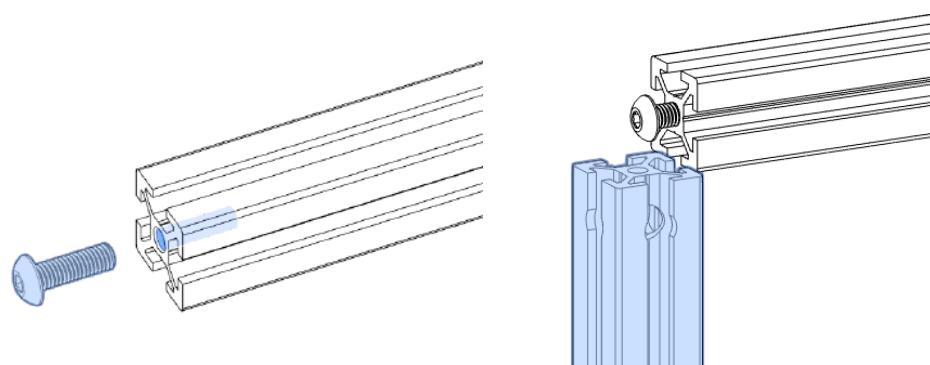
This design relies heavily on heat set inserts. Make sure you have the proper inserts (check the hardware reference for a close-up picture and the Sourcing Guide for dimensions).

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

You can choose to complete all the heat set inserts at once.  
They are located on pages  
76/93/125/126/199/  
203/206/211/212/230



<https://voron.link/m5ybt4d>

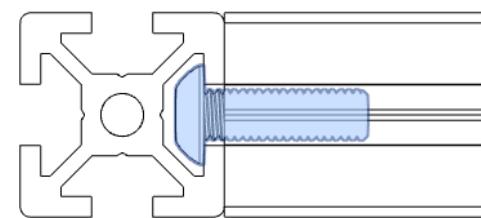
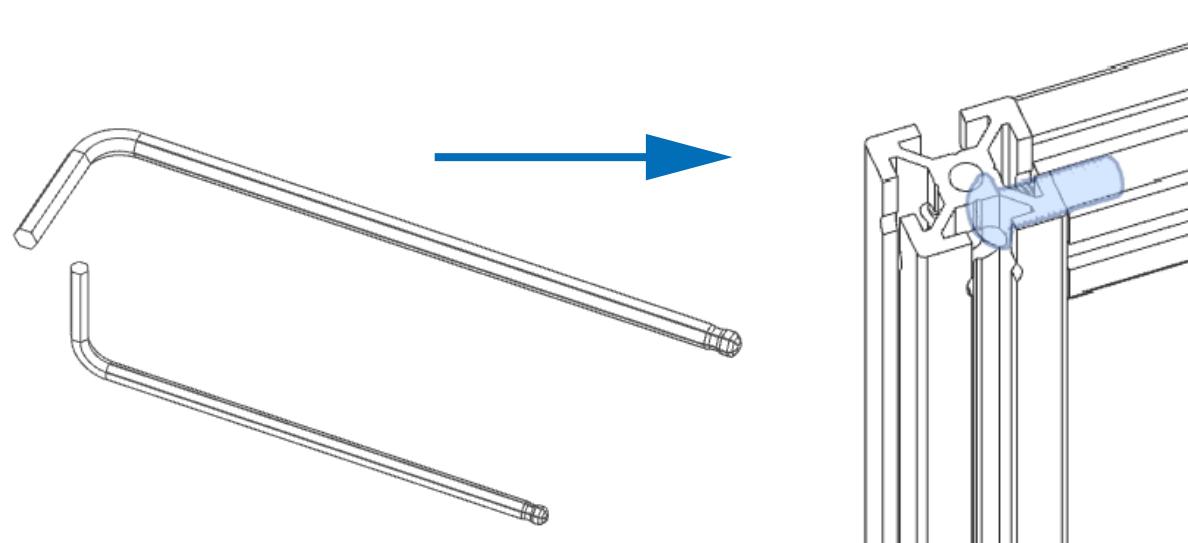


## BLIND JOINT BASICS

Blind Joints provide a cost effective and rigid assembly method

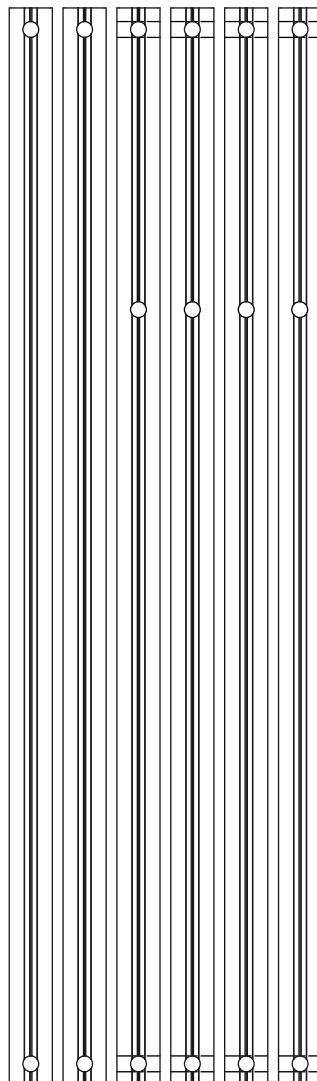
The head of the BHCS is slid into the channel of another extrusion and securely fastened through a small access hole in the extrusion.

If you've never assembled one before we recommend you watch the linked guide.



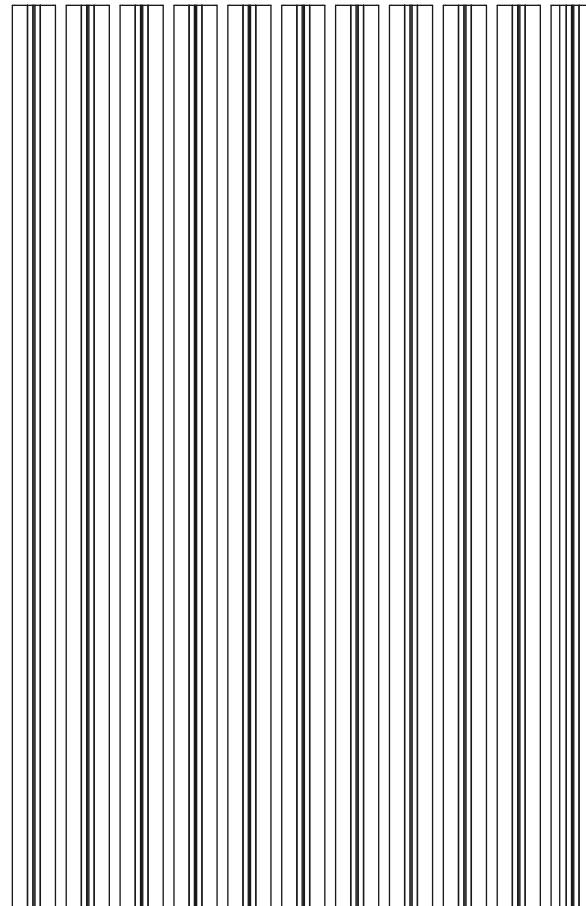
<https://voron.link/onjwmcd>





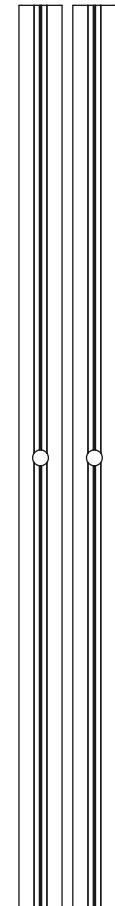
B Extrusion

500mm



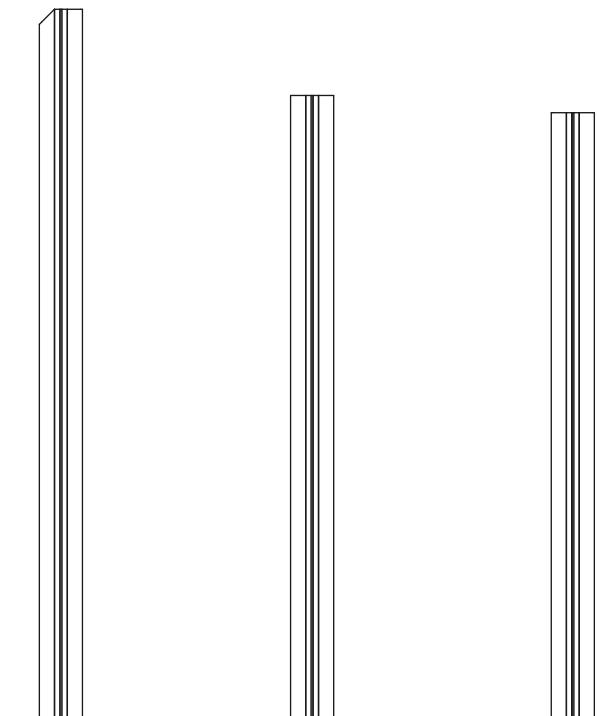
A Extrusion

420mm / 470mm



C Extrusion

420mm / 470mm



H Extrusion

330mm



D Extrusion

290mm / 340mm



G Extrusion

282mm / 332mm

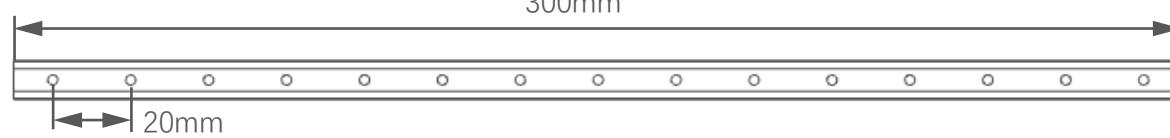
### SORT EXTRUSIONS

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.

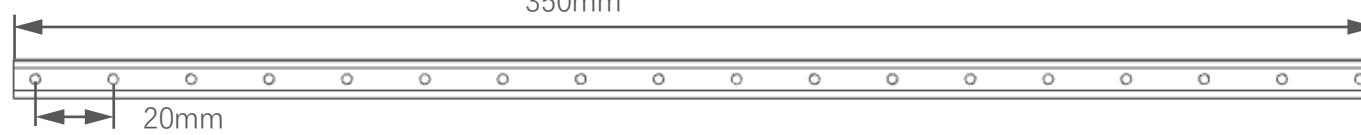
Please find these fixing strips and linear rails, and arrange them together. They will be needed soon.

### 300 Model

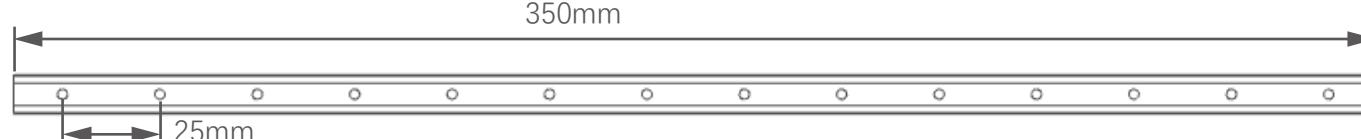
Z-axis  
Fixed strips  
**x3PCS**



Y-axis  
Fixed strips  
**x2PCS**

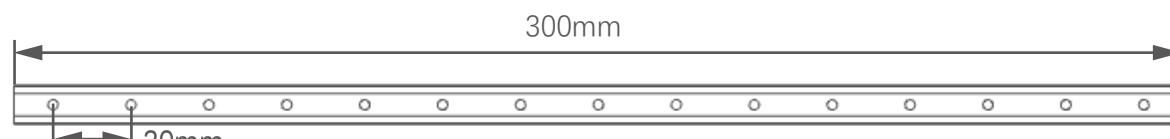


X-axis  
Fixed strips  
**x1PCS**

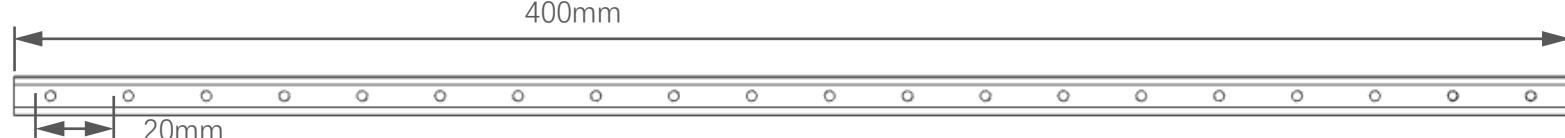


### 350 Model

Z-axis  
Fixed strips  
**x3PCS**



Y-axis  
Fixed strips  
**x2PCS**

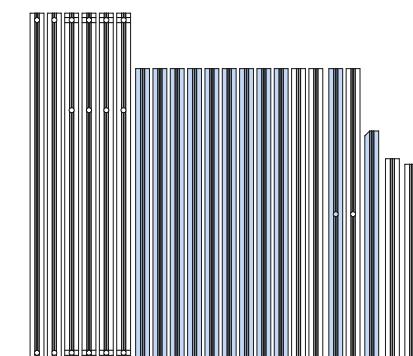
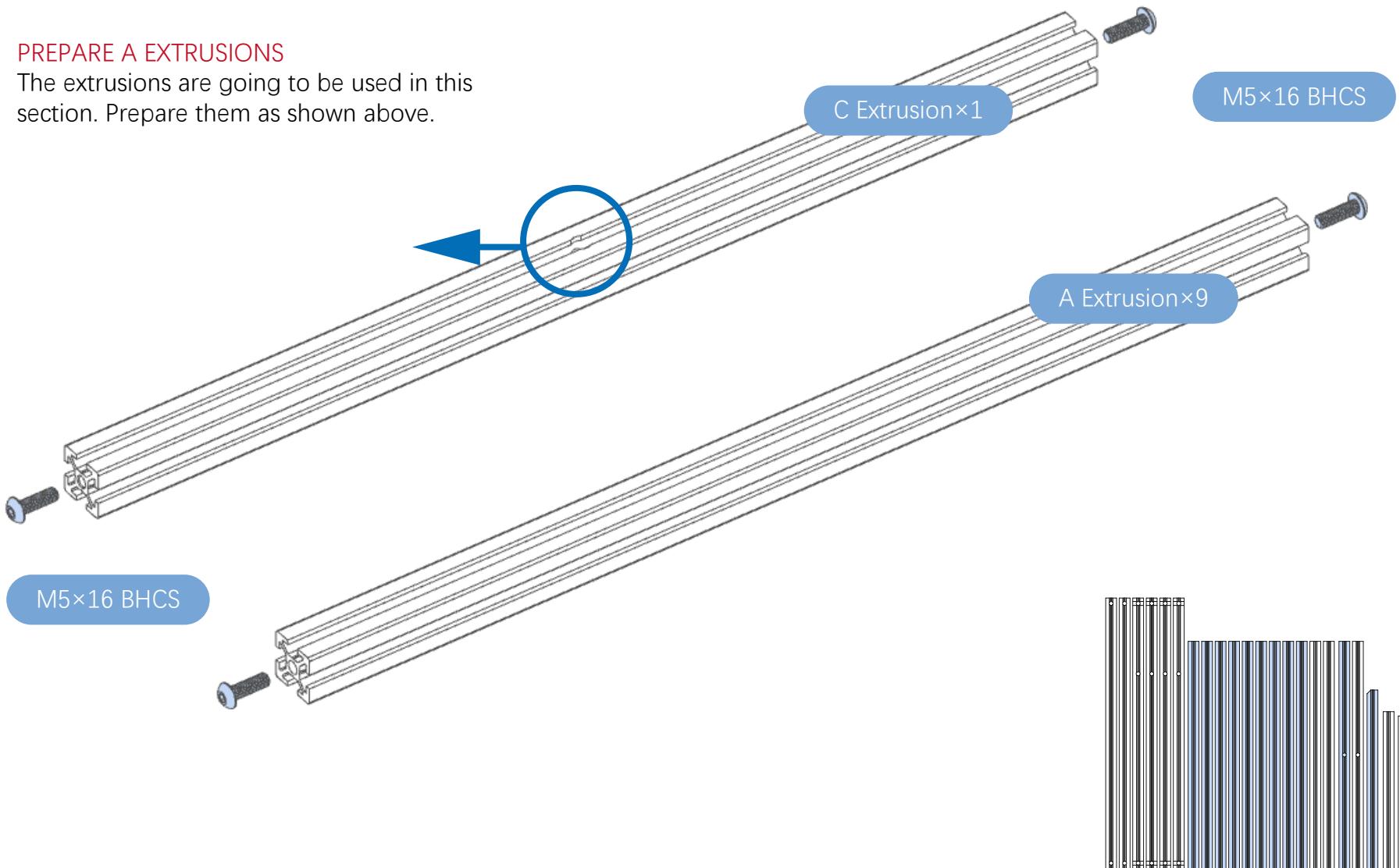


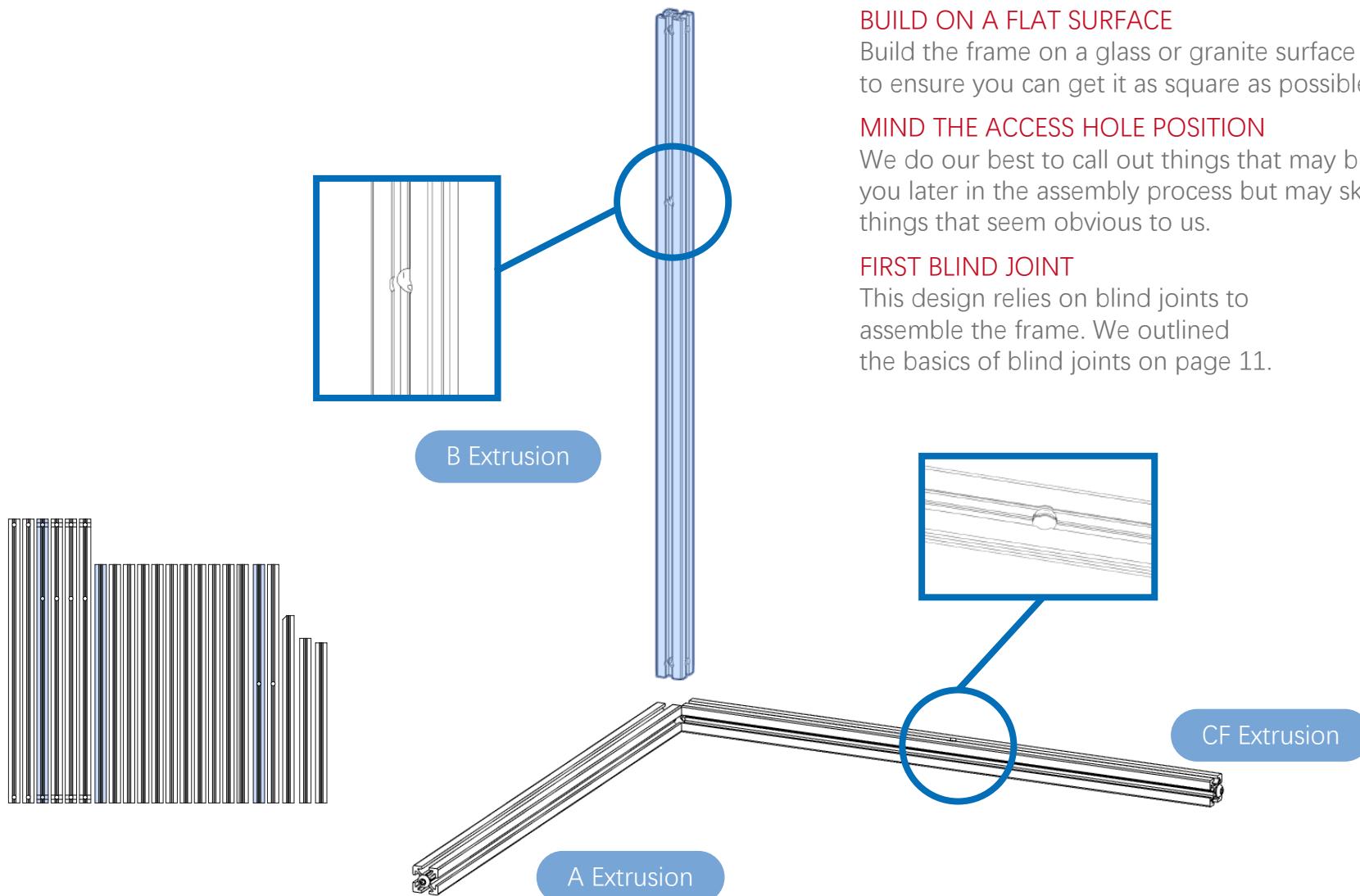
X-axis  
Fixed strips  
**x1PCS**



**PREPARE A EXTRUSIONS**

The extrusions are going to be used in this section. Prepare them as shown above.



**BUILD ON A FLAT SURFACE**

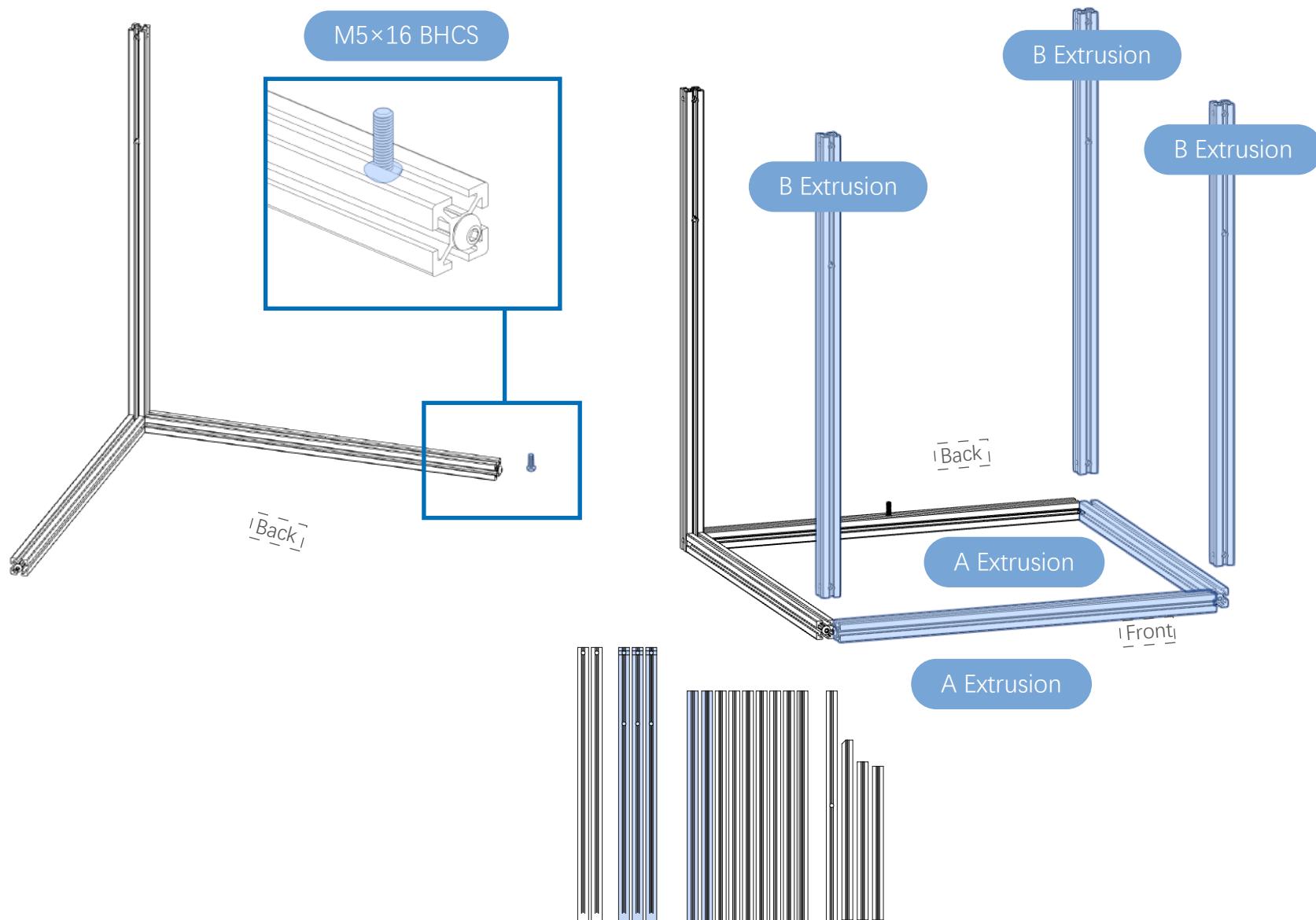
Build the frame on a glass or granite surface to ensure you can get it as square as possible.

**MIND THE ACCESS HOLE POSITION**

We do our best to call out things that may bite you later in the assembly process but may skip things that seem obvious to us.

**FIRST BLIND JOINT**

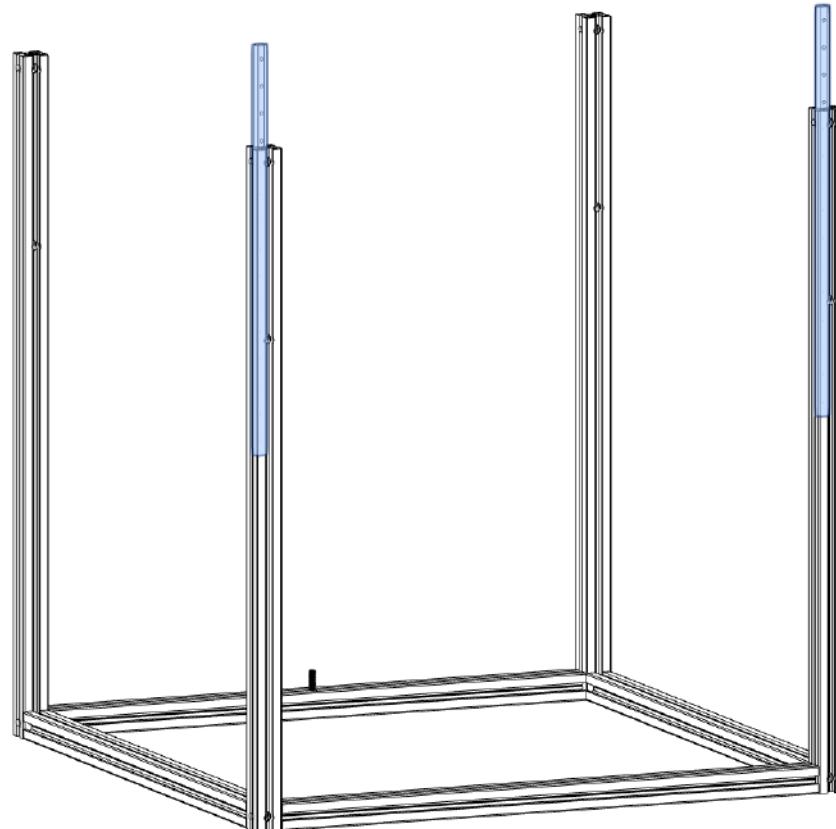
This design relies on blind joints to assemble the frame. We outlined the basics of blind joints on page 11.



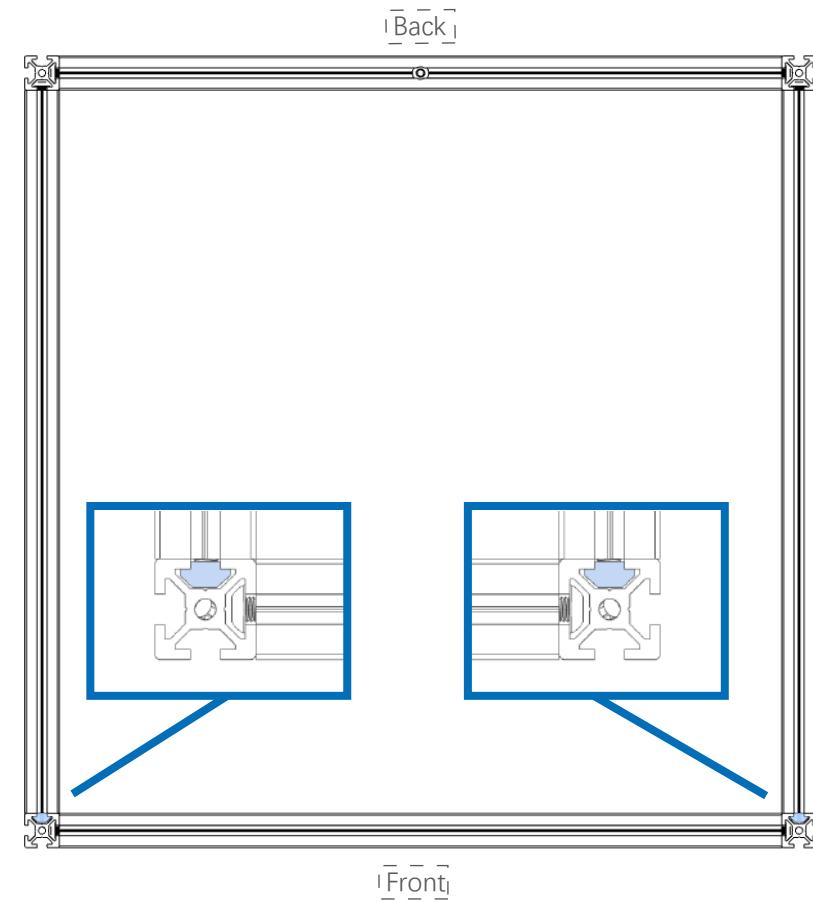
**INSERTION DIRECTION**

Insert the fixing strips into the profile, paying attention to the insertion direction.

Z-axis Fixed strips

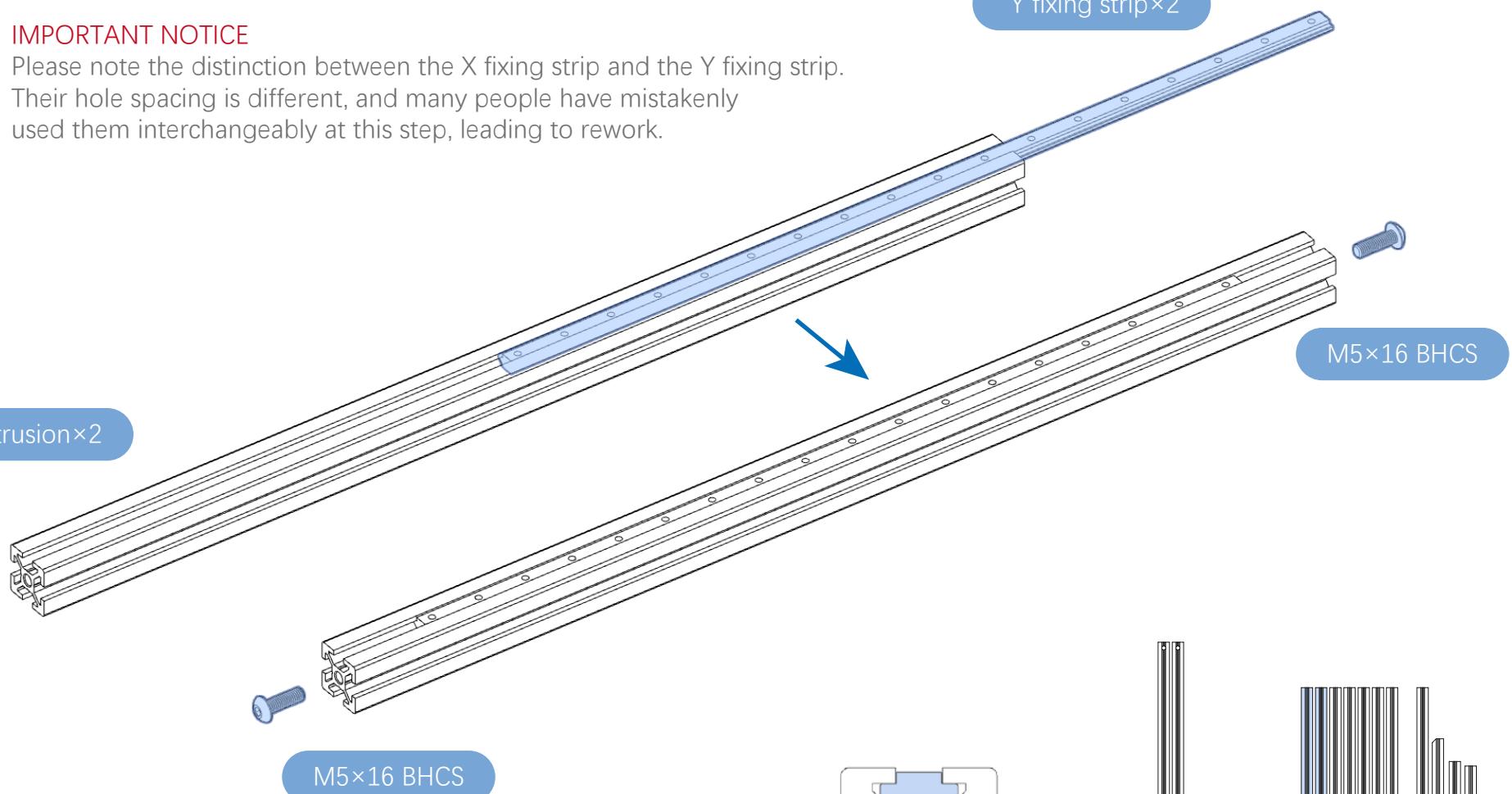
**FIXED STRIPS**

Push the two fixed strips into the deepest position and temporarily secure each with a screw to prevent the fixed strips from colliding with the aluminum extrusions when flipping the machine later.

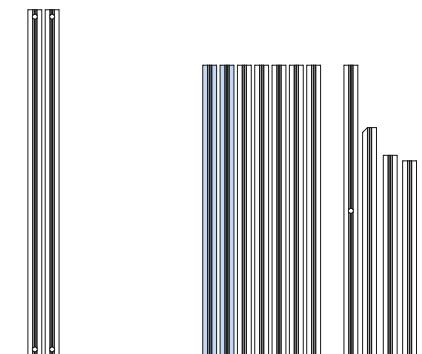
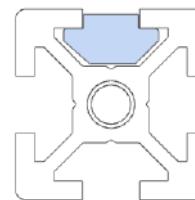


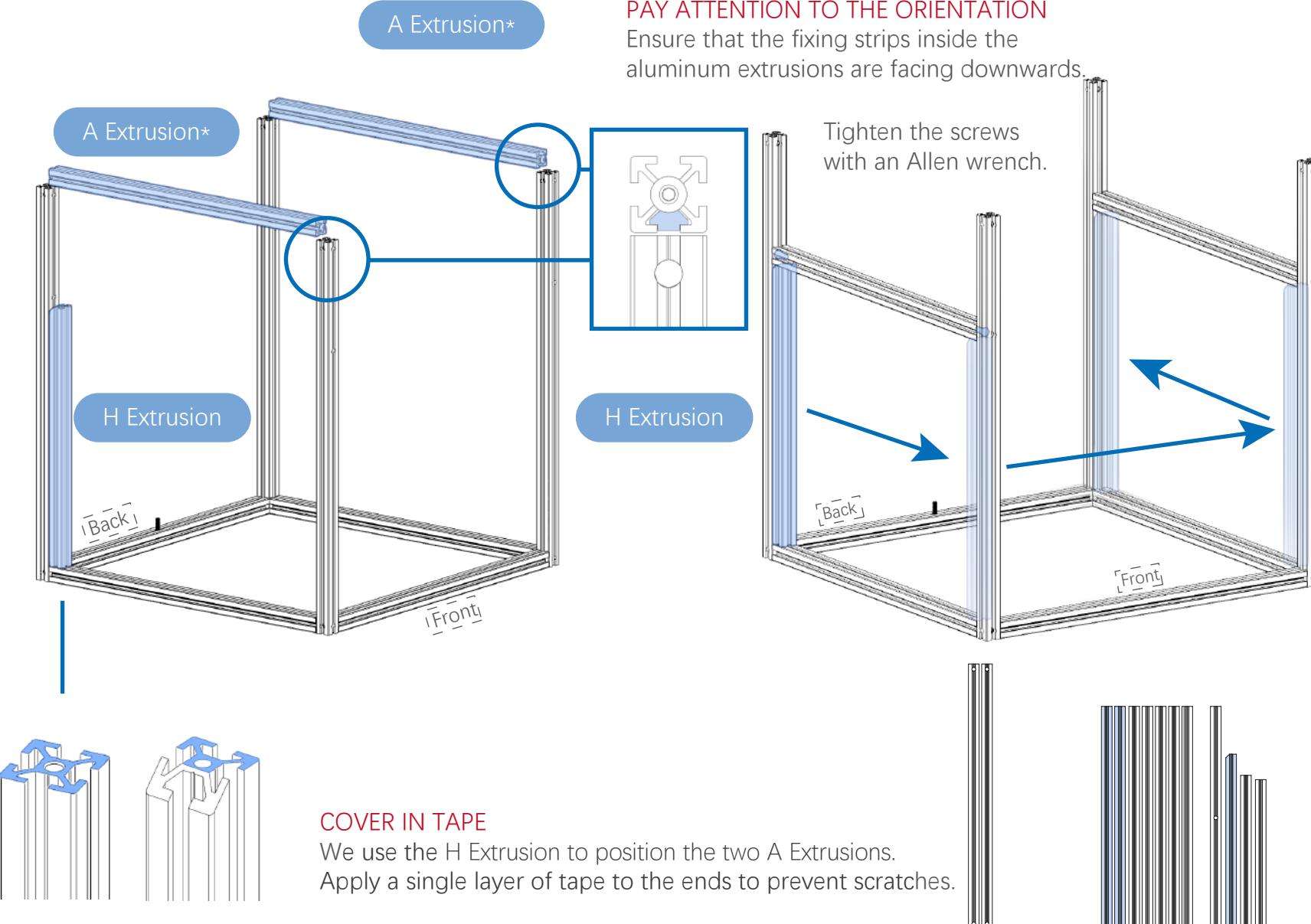
**IMPORTANT NOTICE**

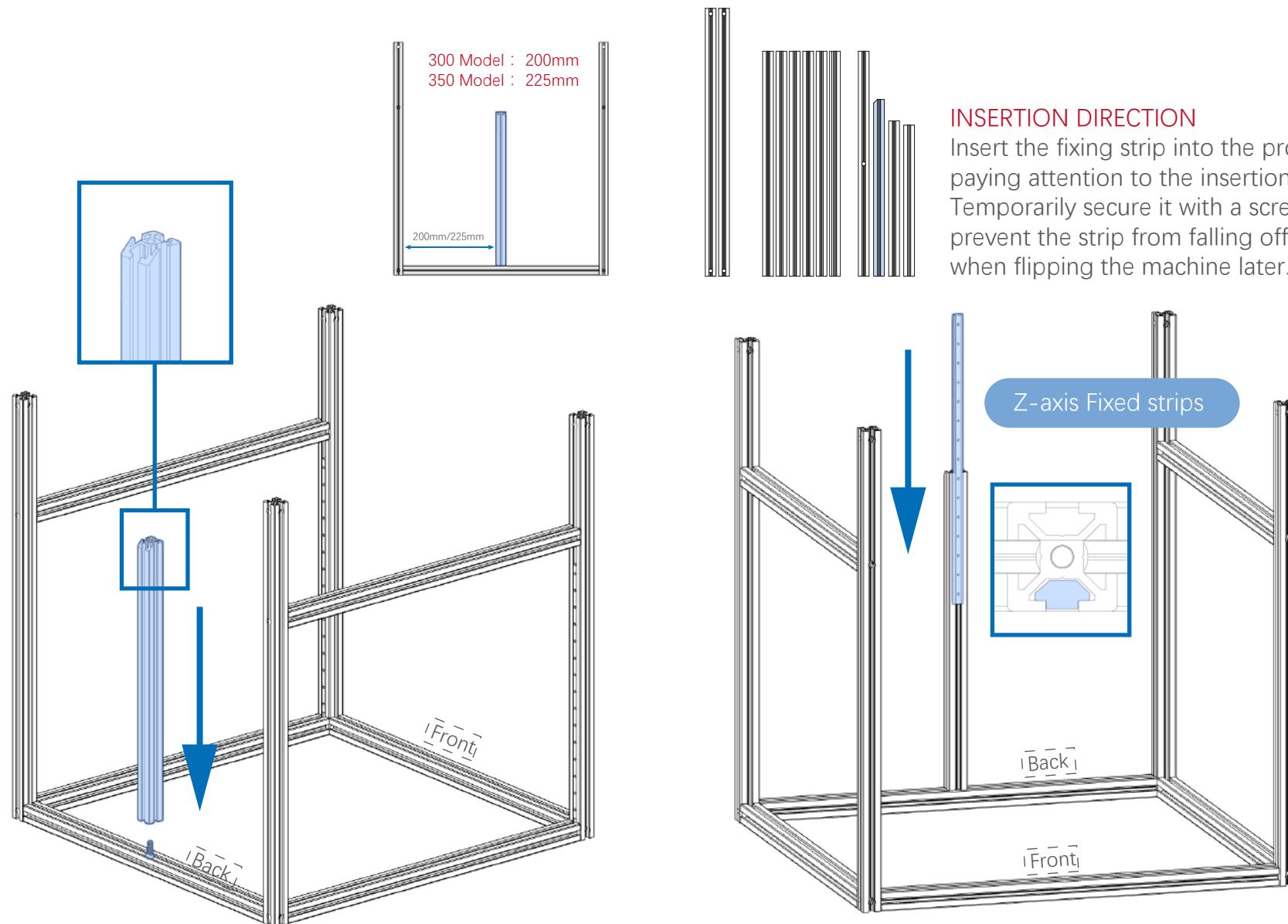
Please note the distinction between the X fixing strip and the Y fixing strip. Their hole spacing is different, and many people have mistakenly used them interchangeably at this step, leading to rework.

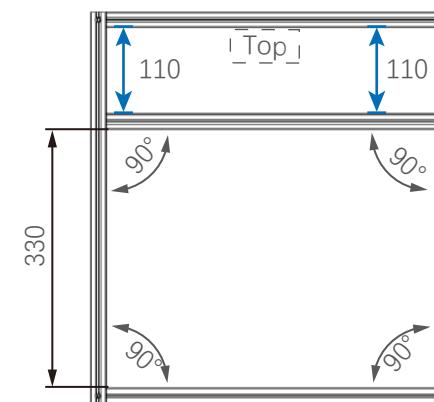
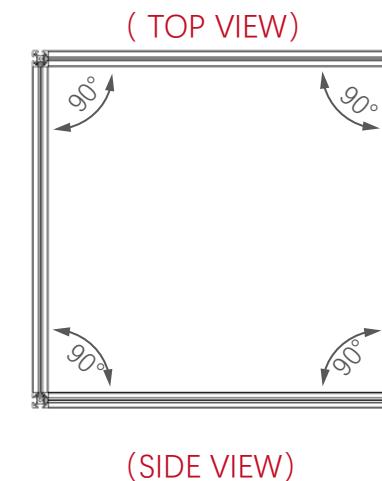
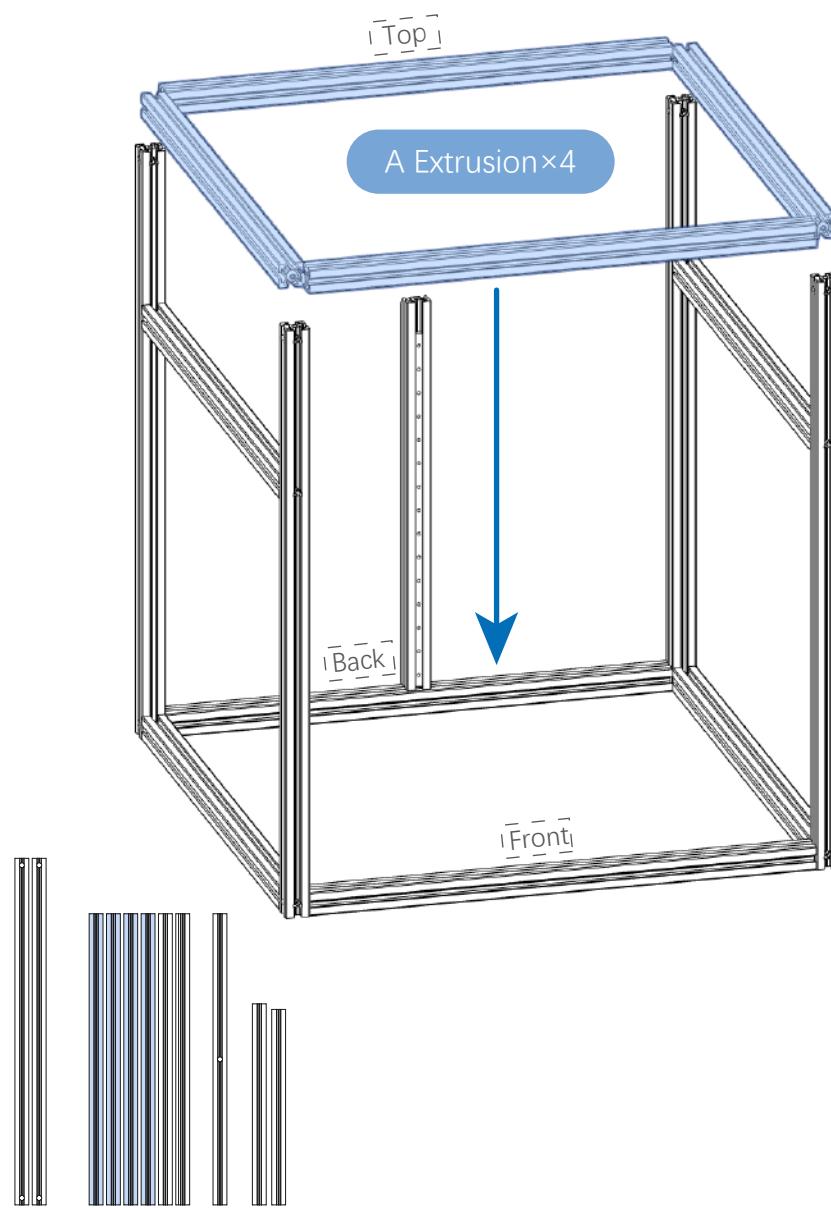
**A EXTRUSION\***

To facilitate differentiation, an asterisk (\*) will be added in front of the two aluminum extrusions with fixed strips. They will be used for the Y-axis on page 20.



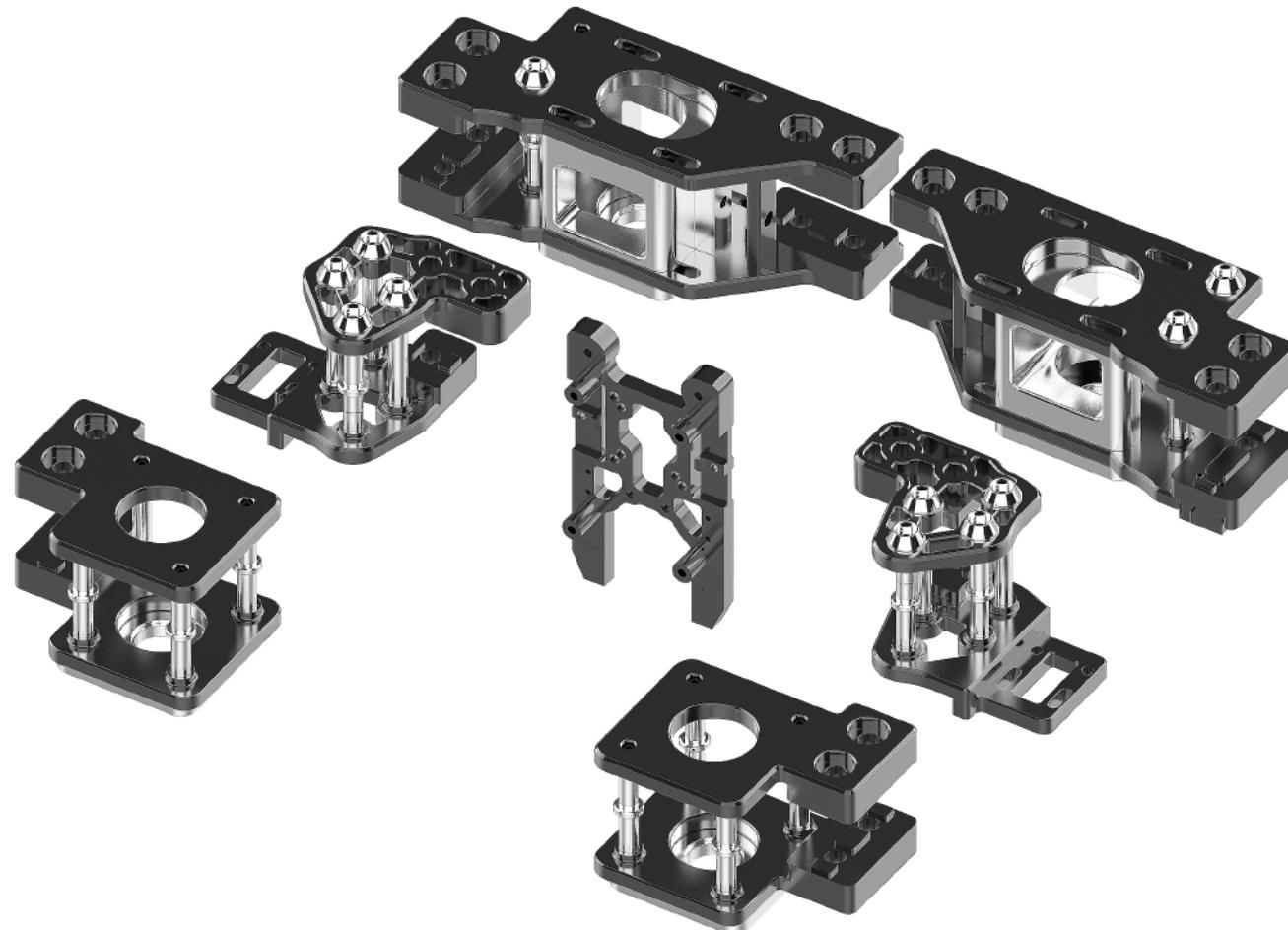


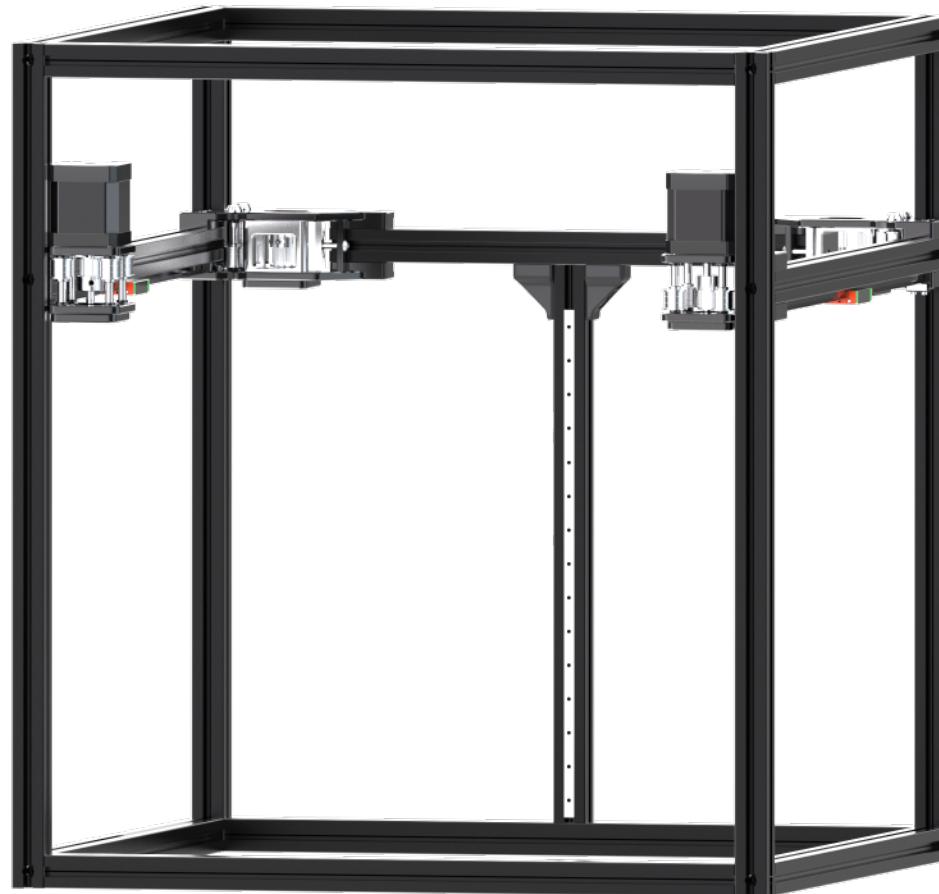


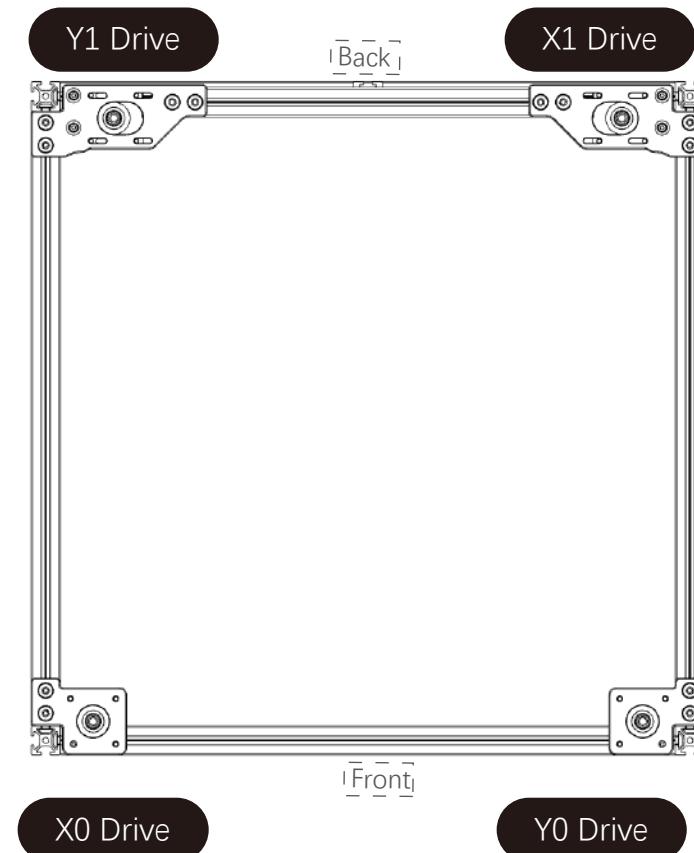
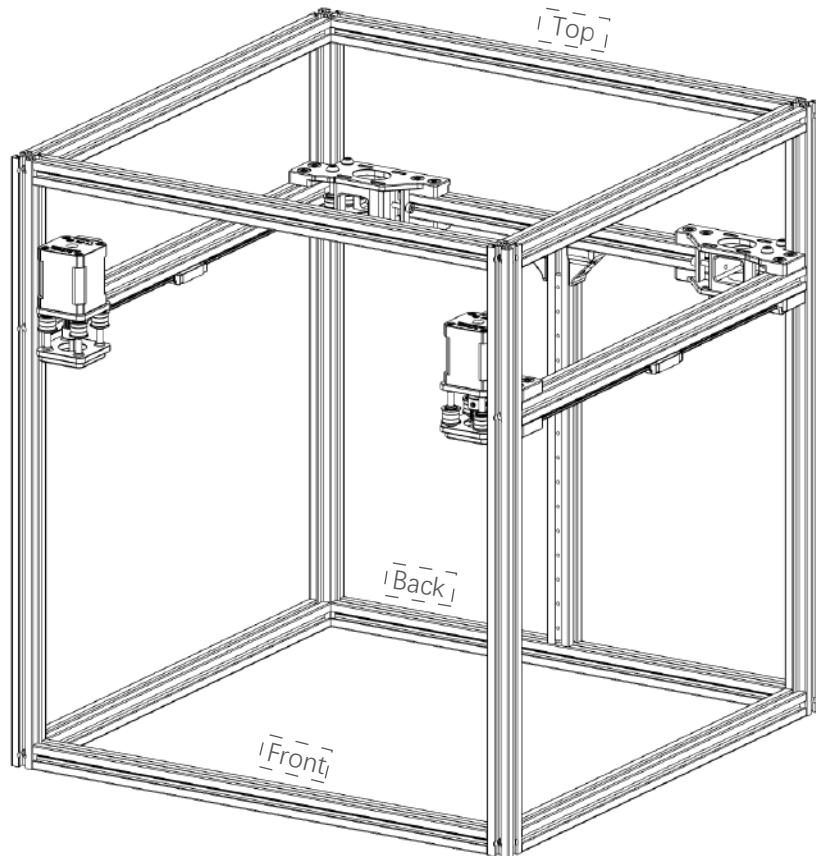


<https://voron.link/kdtpzam>

CHECK FOR SQUARENESS  
Verify the angle of all corners and the overall squareness by measuring the diagonals. Refer to the second half of the linked video for additional information.





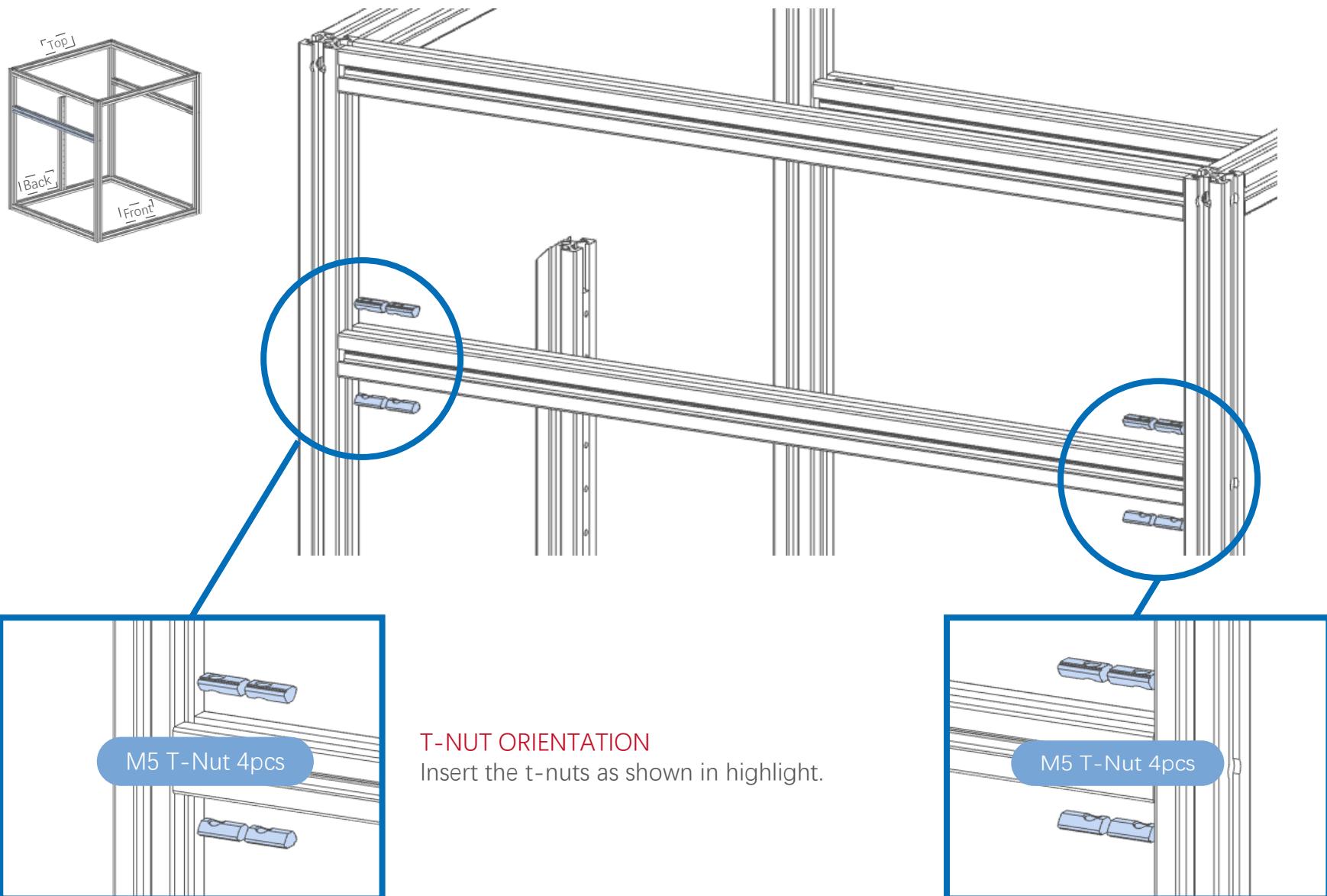


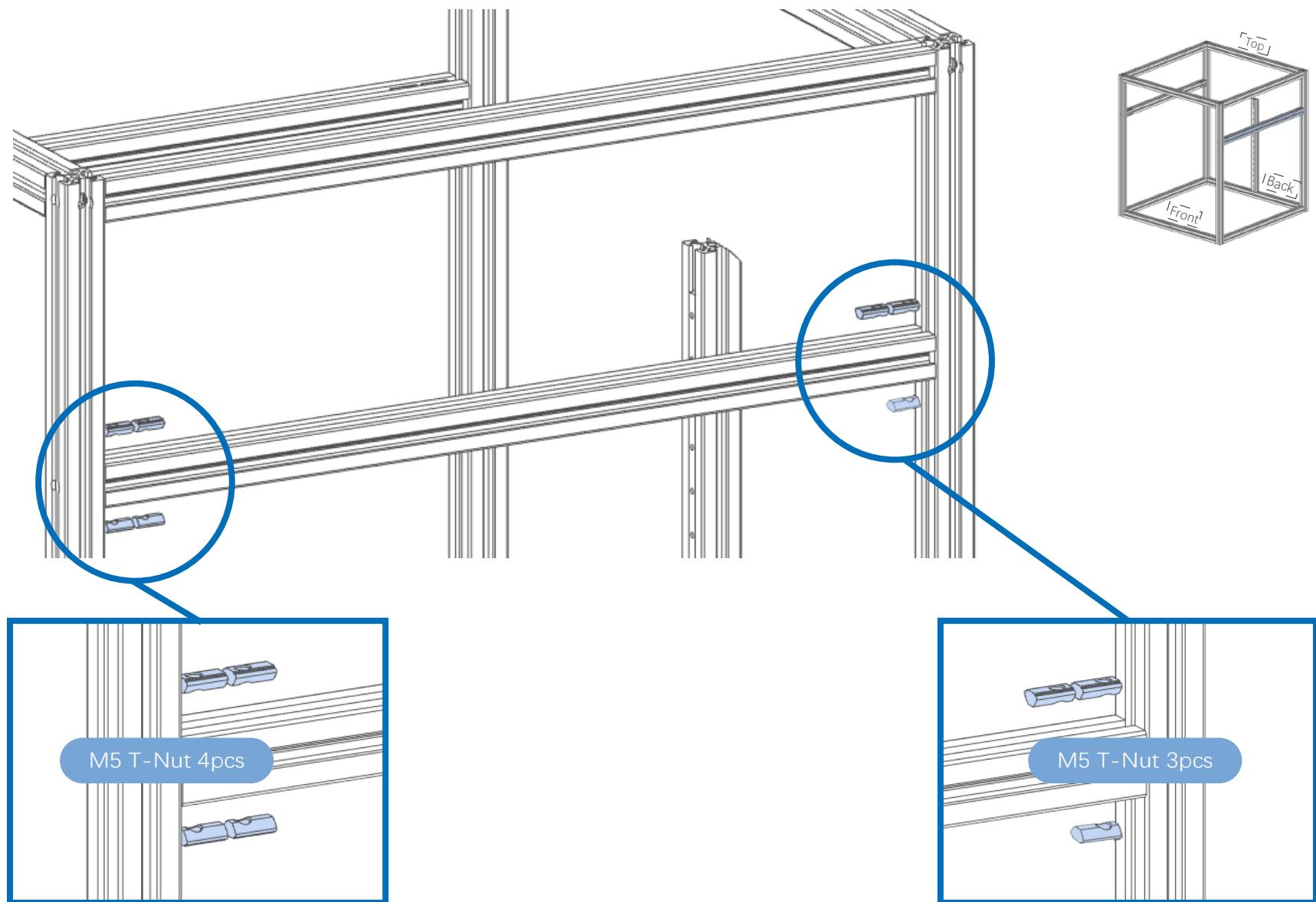
## WHY IS THIS HERE?

As you likely skipped over the advice to flip through the entire manual we added graphics like these to assist you with the orientation of the part before you actually put them on the printer.

## OVERVIEW

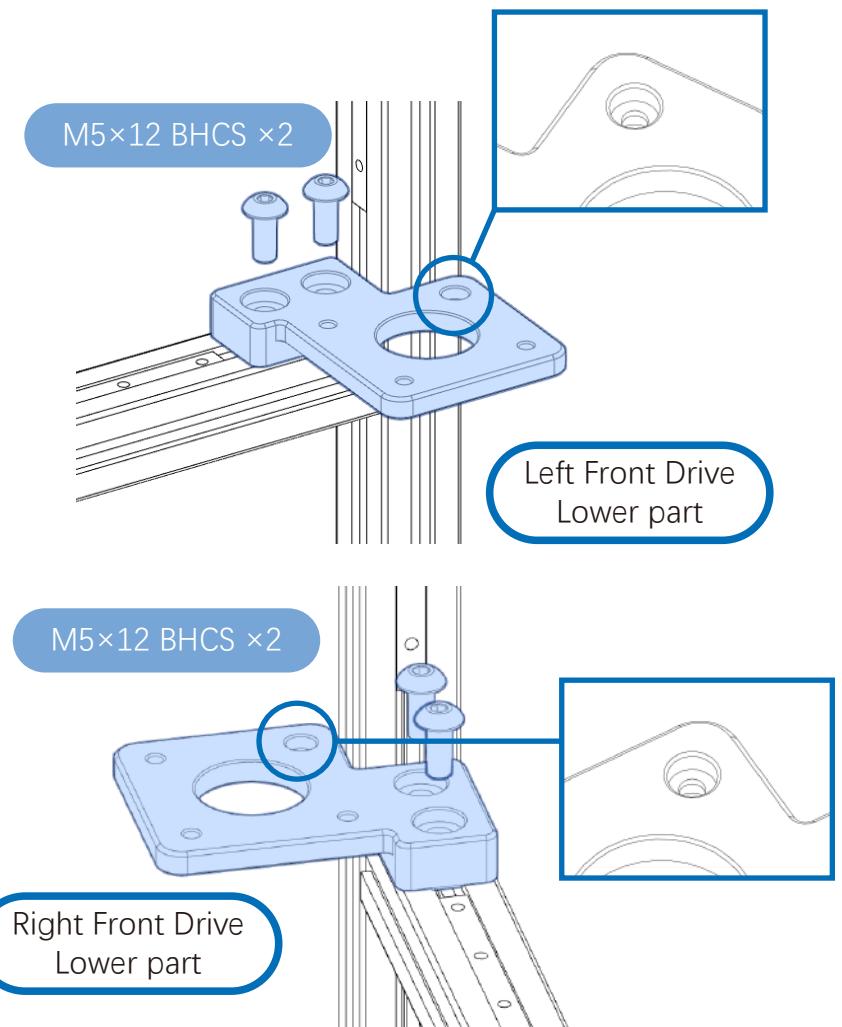
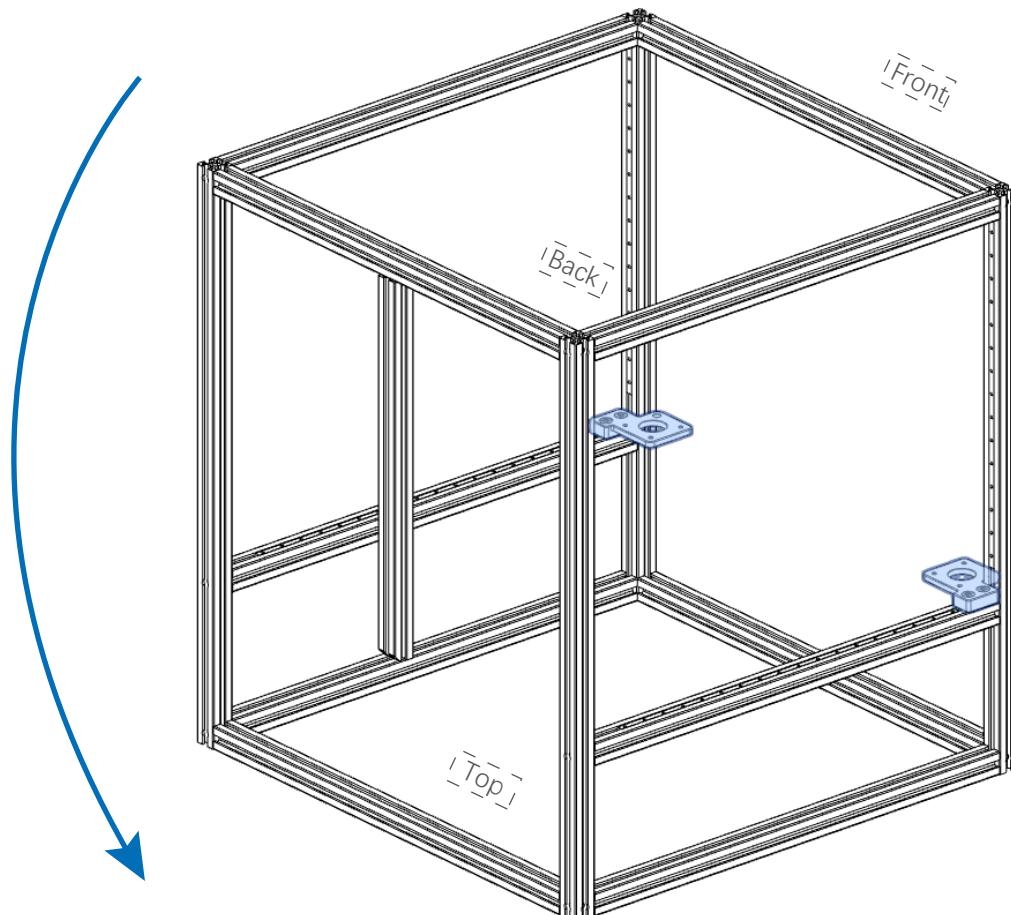
Individual chapters start with an overview of the components that will be built/added to the printer in the chapter.



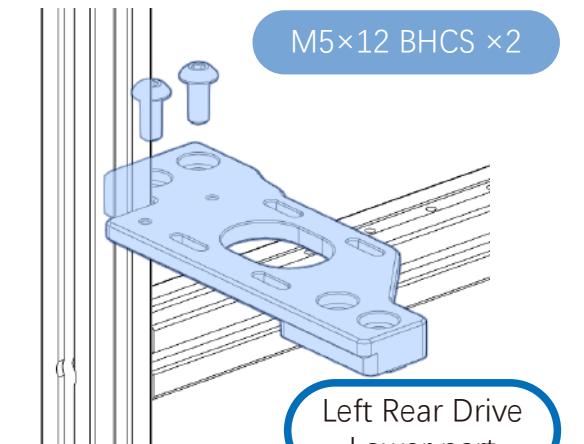
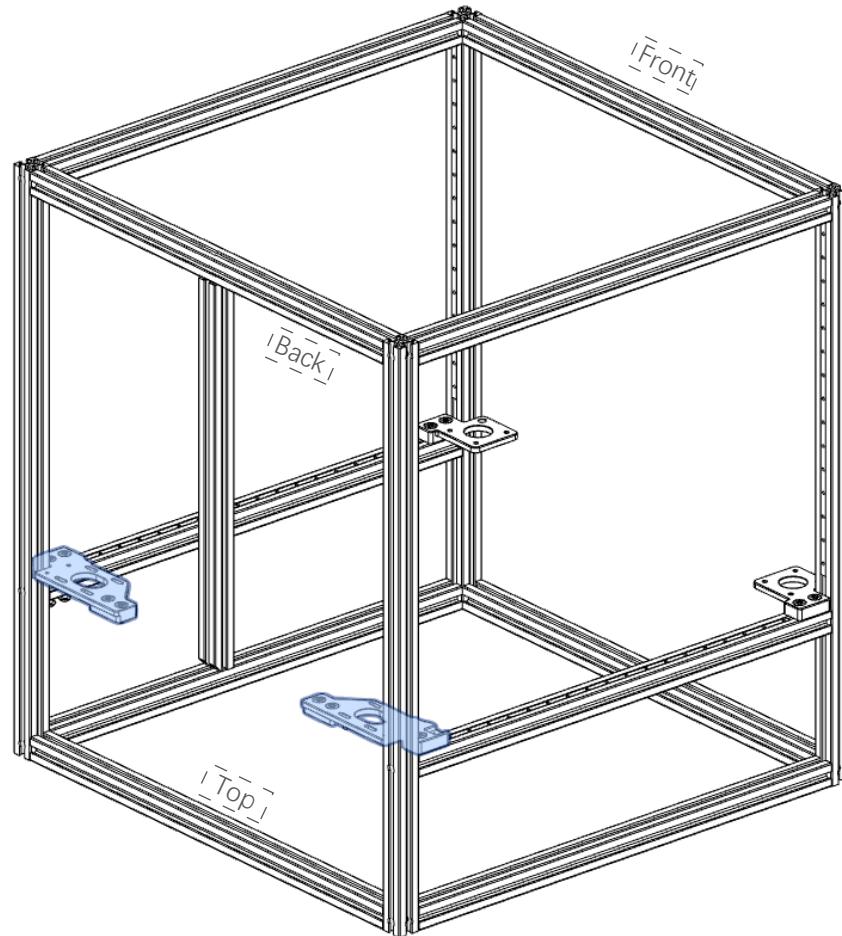


## UPSIDE DOWN ASSEMBLY

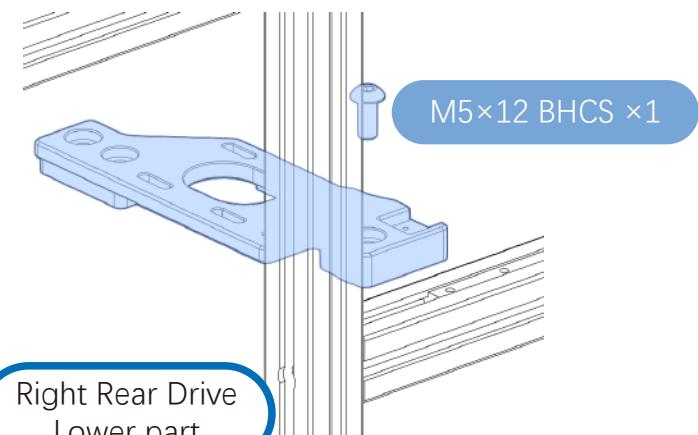
For ease of assembly, it is recommended that the printer be turned upside down for ease of subsequent operation.



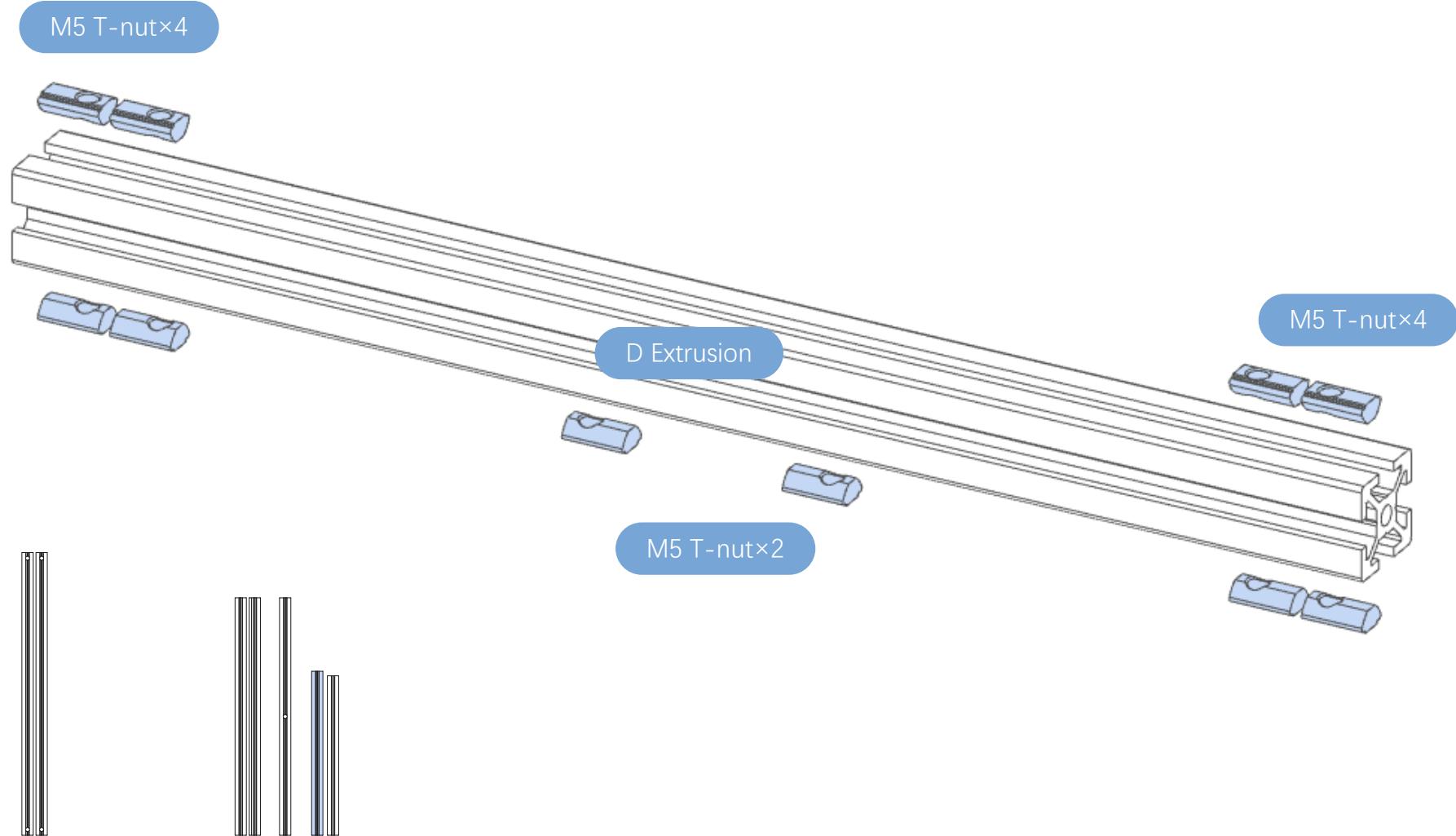
The front drive lower pieces each have a stepped hole, distinguishing them from the upper pieces.

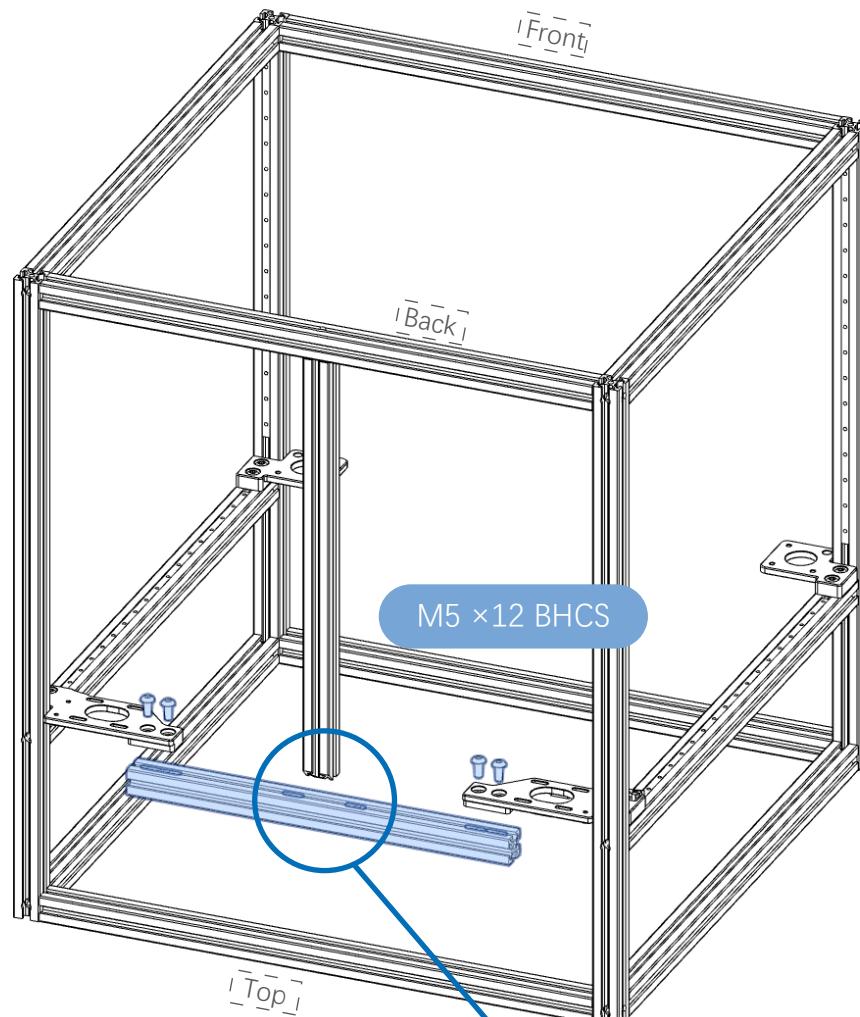


Left Rear Drive  
Lower part

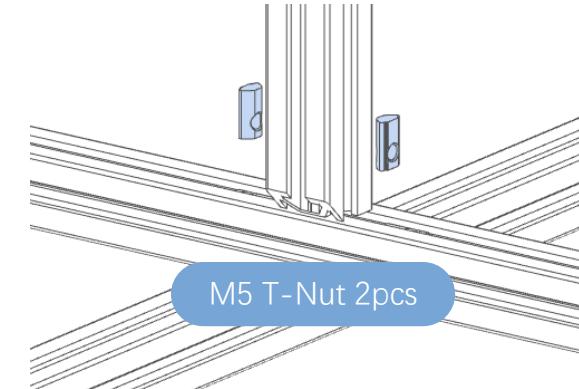


Right Rear Drive  
Lower part

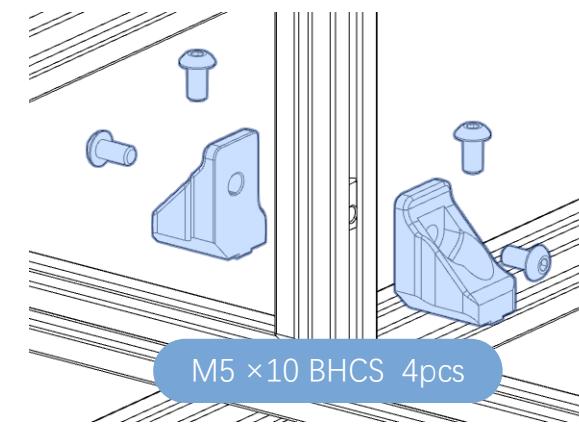




NOTE THE DIRECTION OF ALUMINUM EXTRUSION

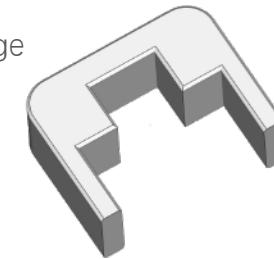


NOTE THAT ABS PRINTS ARE USED HERE



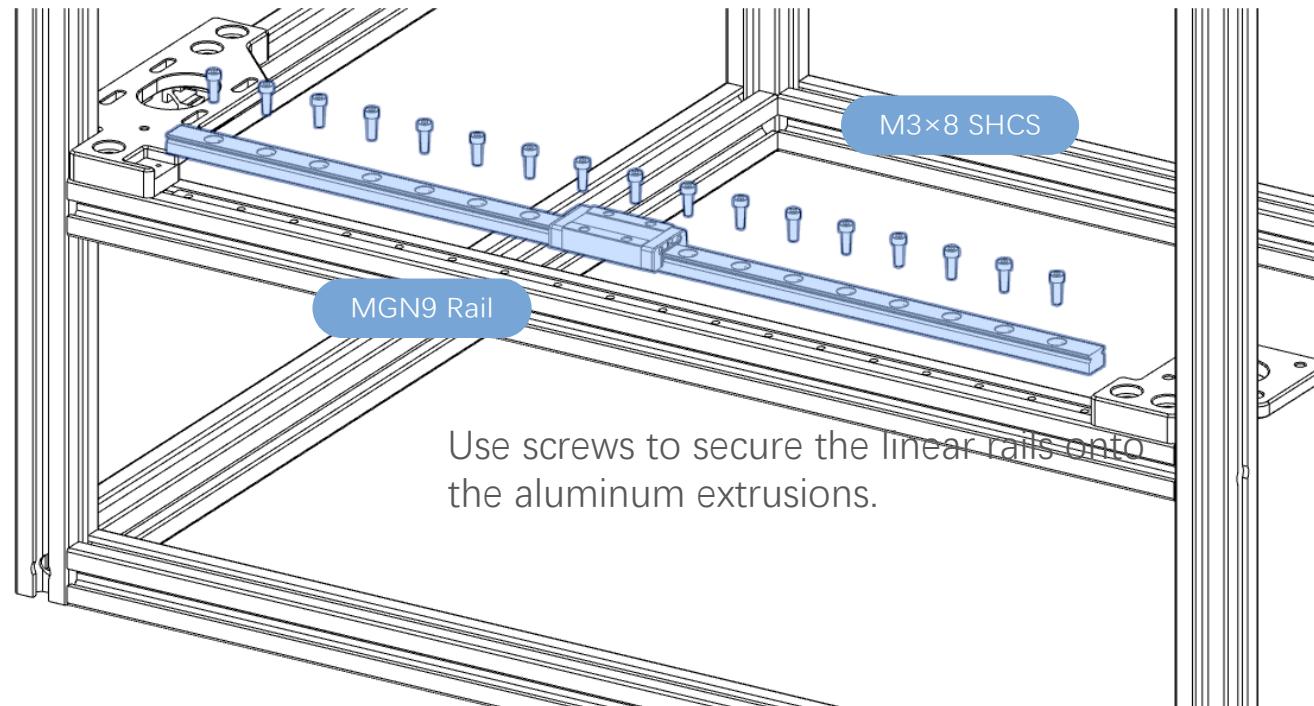
## RUBBER STOPPERS ON LINEAR RAIL

You may notice rubber stoppers on both sides of the carriage. These effectively prevent the carriage from accidentally dislodging, so do not attempt to remove them before installing the screws.

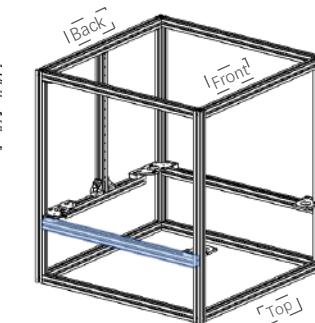


## CENTRED RAIL INSTALLATION GUIDE

Use the MGN9 guides to position the rail in the centre of the extrusion prior to fastening the bolts.



Use screws to secure the linear rails onto the aluminum extrusions.



## LINEAR RAILS - PREPARATION AND MOUNTING

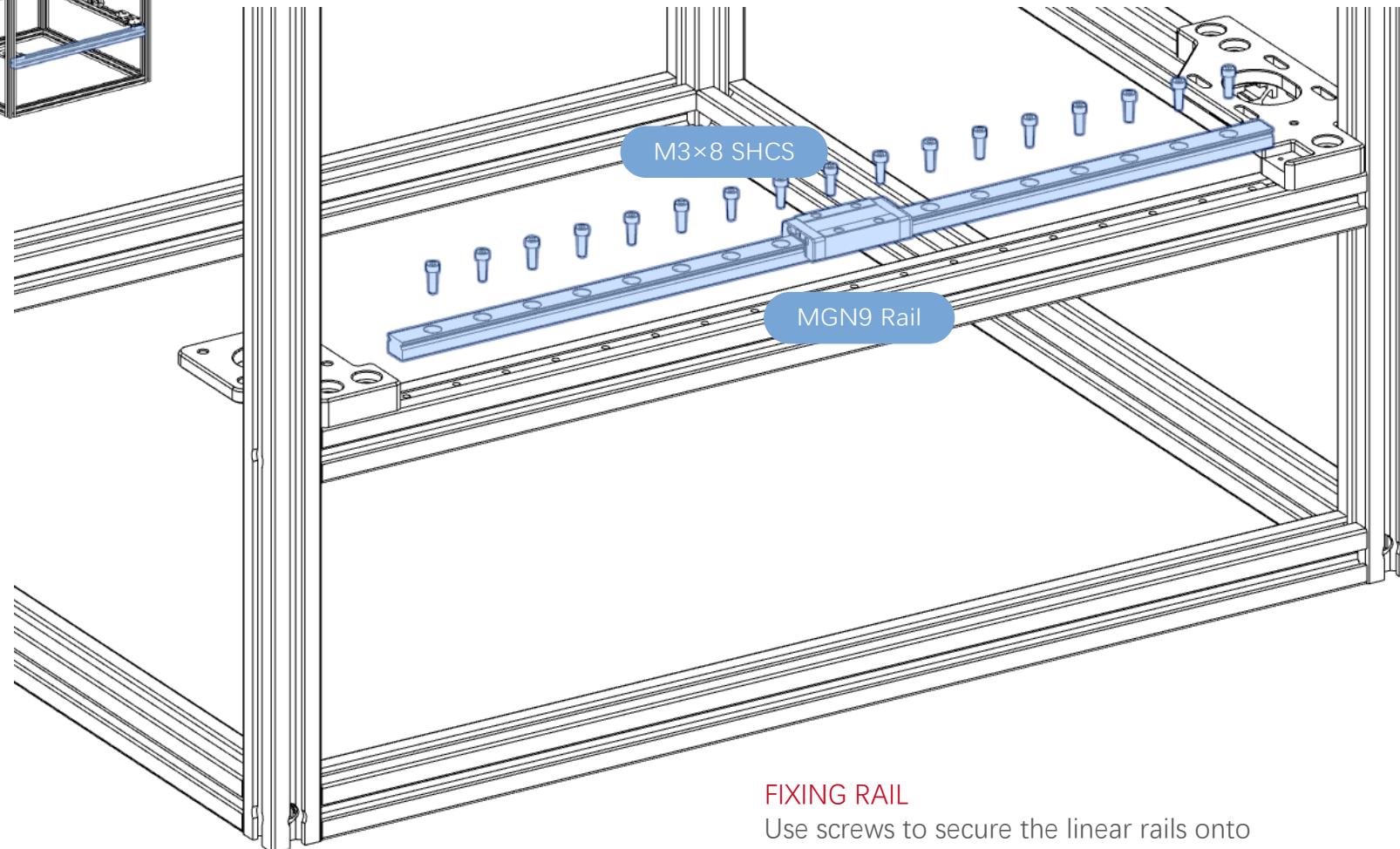
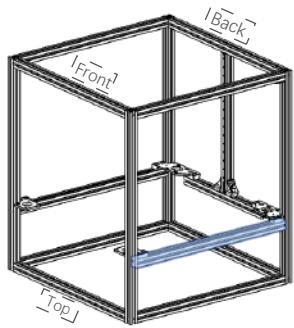
Most linear rails arrive with shipping oil. To ensure a smooth gliding motion and long service life, this oil needs to be removed and its rail carriage greased.

See the Voron sourcing guide for a recommended list of lubricants.

We attached a link to a video guide to get you started.



<https://voron.link/agu0nes>

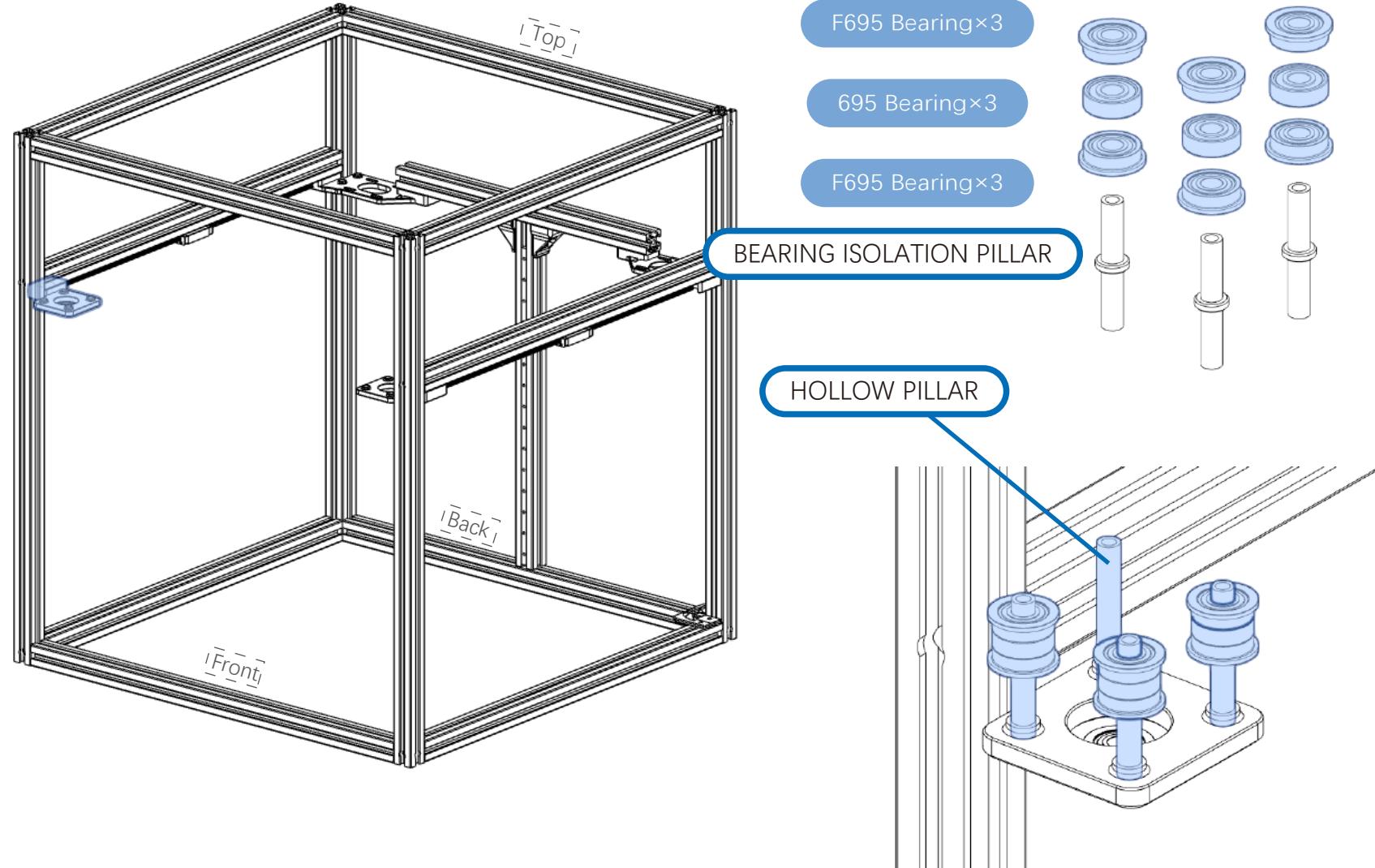


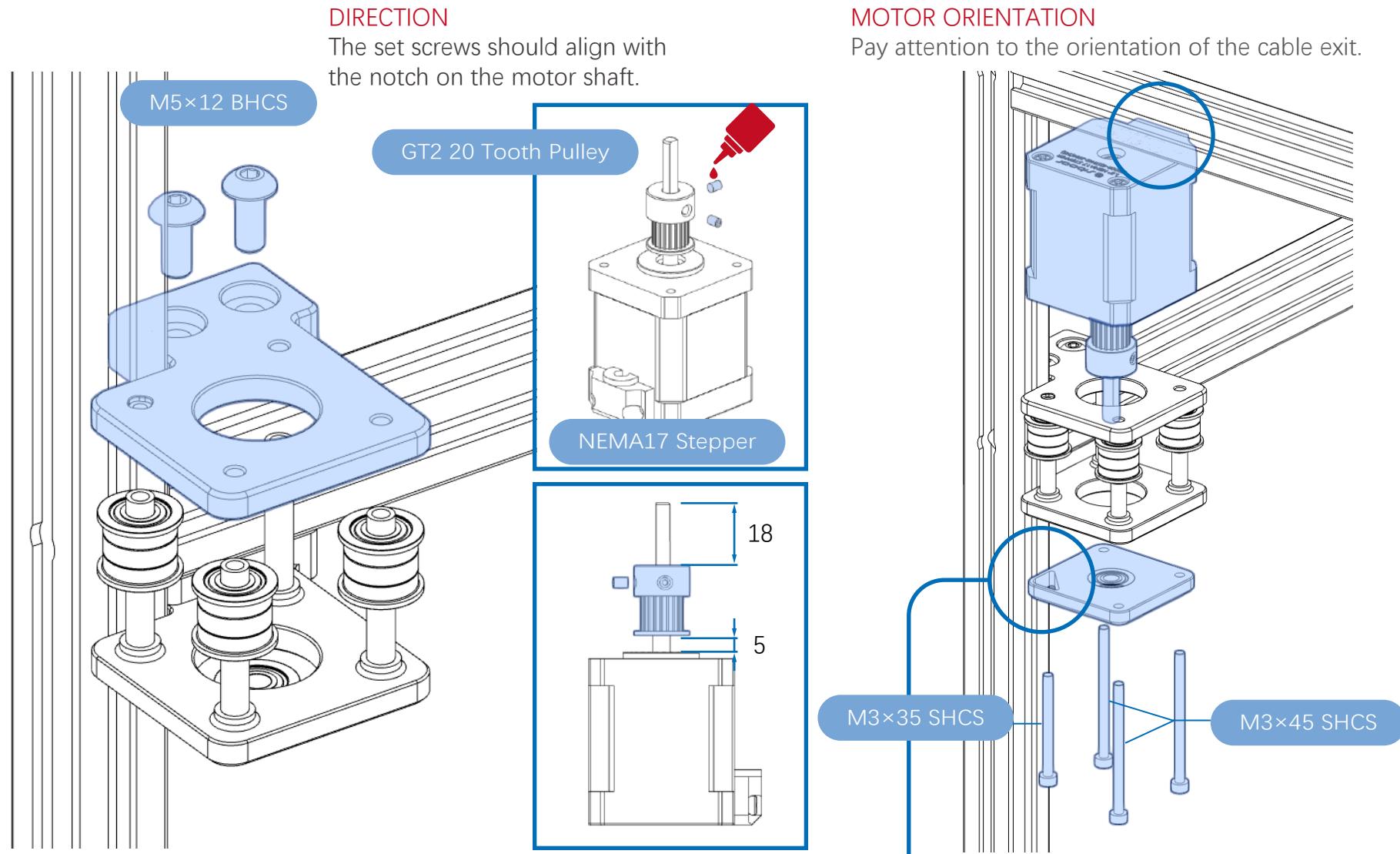
### RUBBER PLUGS ON LINEAR RAIL

You may notice rubber plugs on both sides of the carriage. These effectively prevent the carriage from accidentally dislodging, so do not attempt to remove them before installing the screws.

### FIXING RAIL

Use screws to secure the linear rails onto the aluminum extrusions.

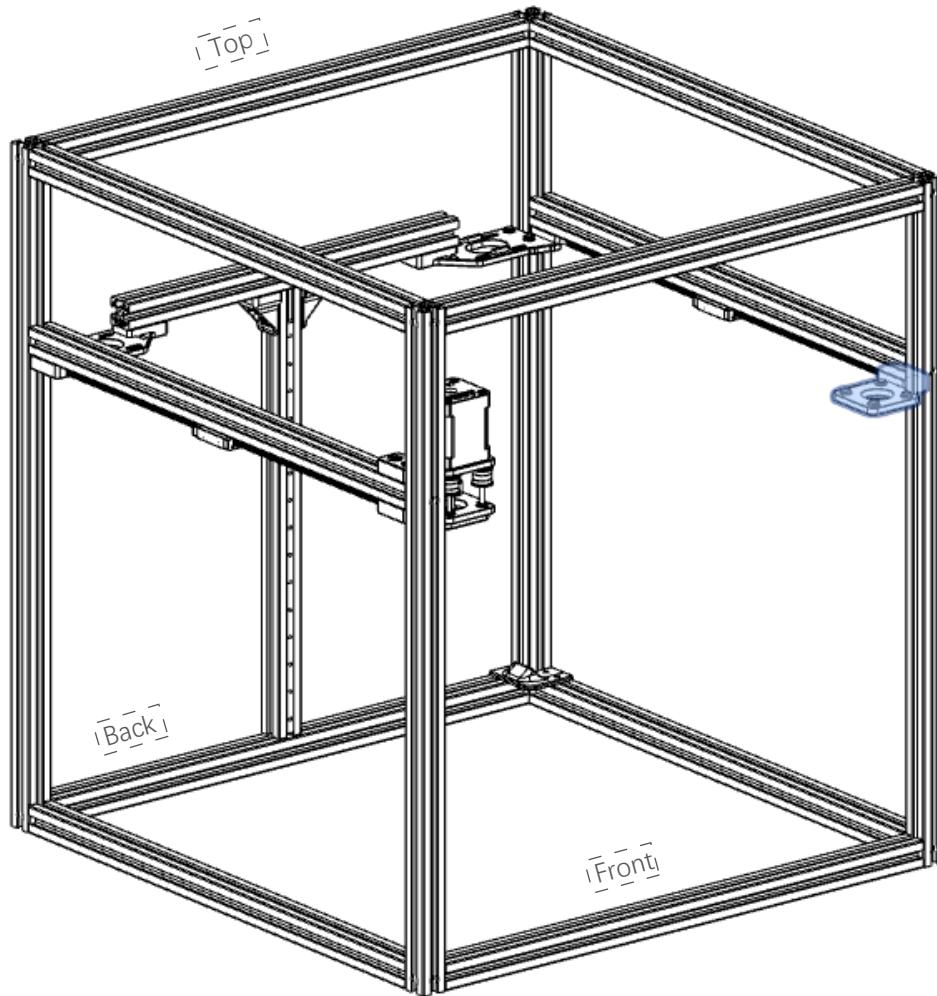


**THREAD LOCKER**

Consider adding threadlocker for the specific screw (e.g., the Voron motor mount screw). This screw often loosens and causes tension issues. Note that some threadlockers might lock too tightly for future adjustments. If threadlocker is unavailable, you can temporarily skip this step.



A bearing cap with a triangular notch is used in this instance.

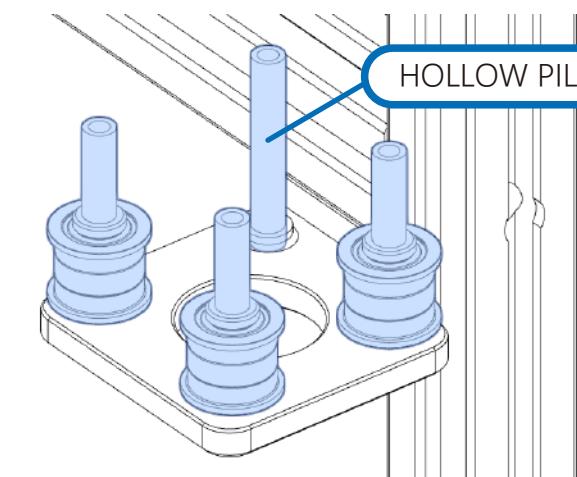
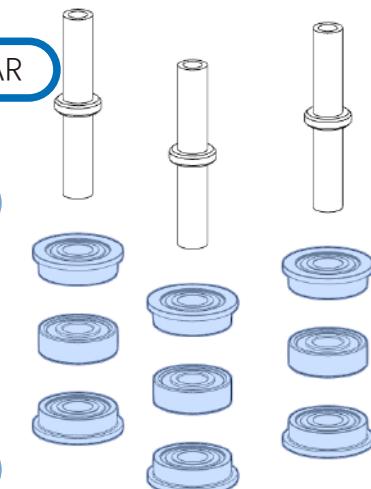


BEARING ISOLATION PILLAR

F695 Bearing×3

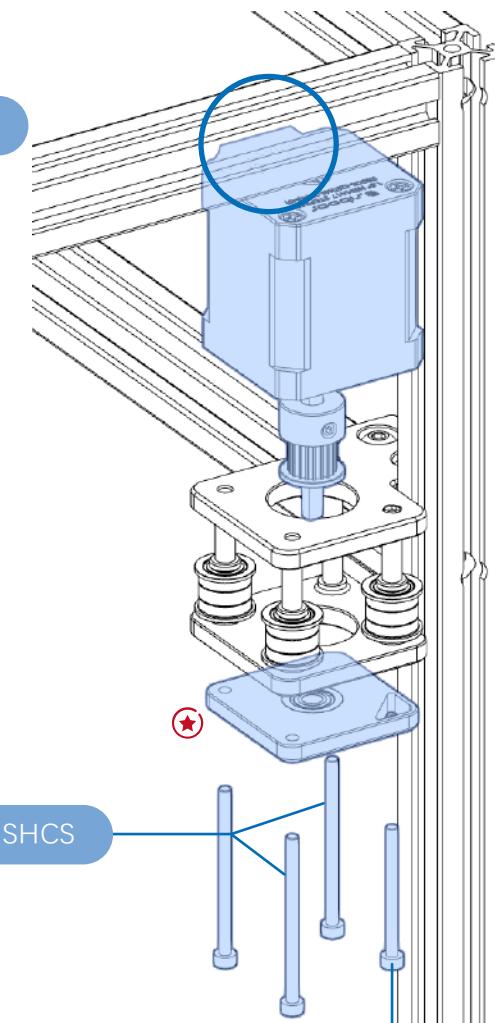
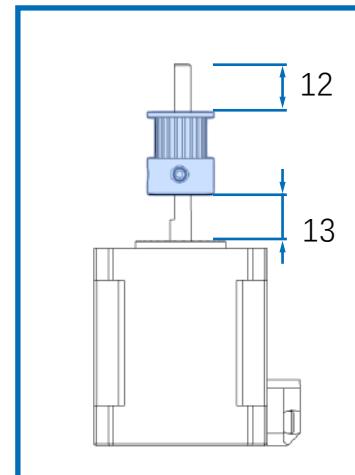
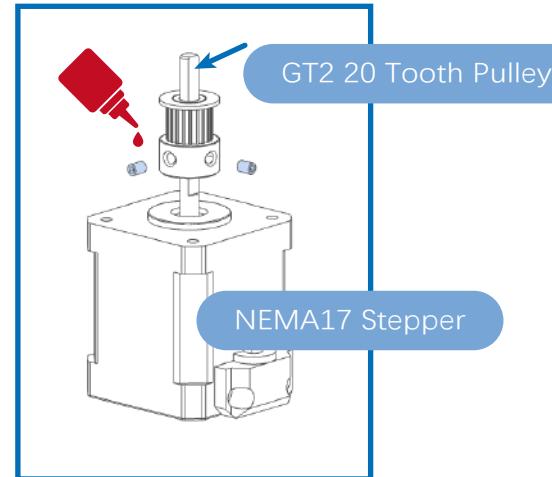
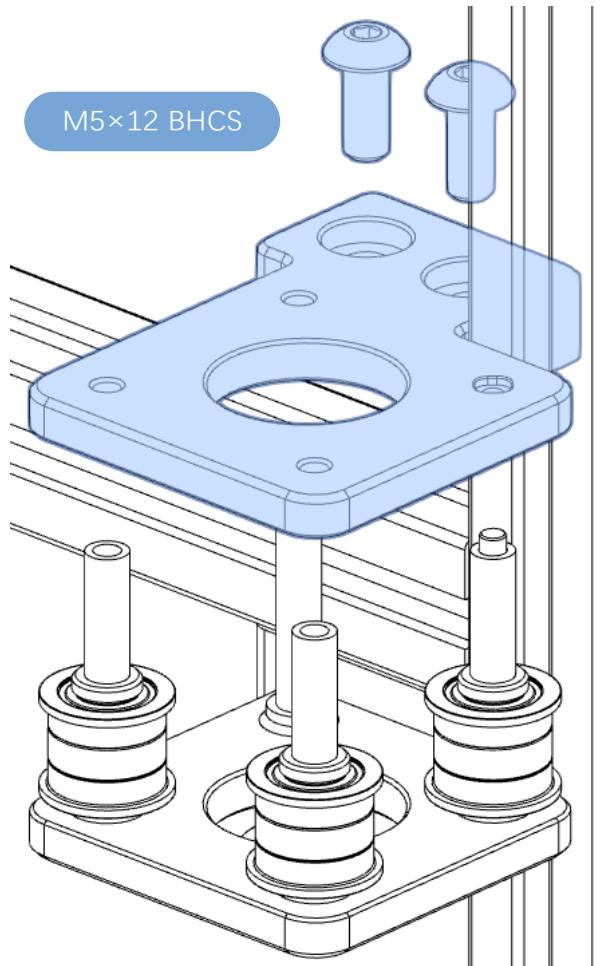
695 Bearing×3

F695 Bearing×3

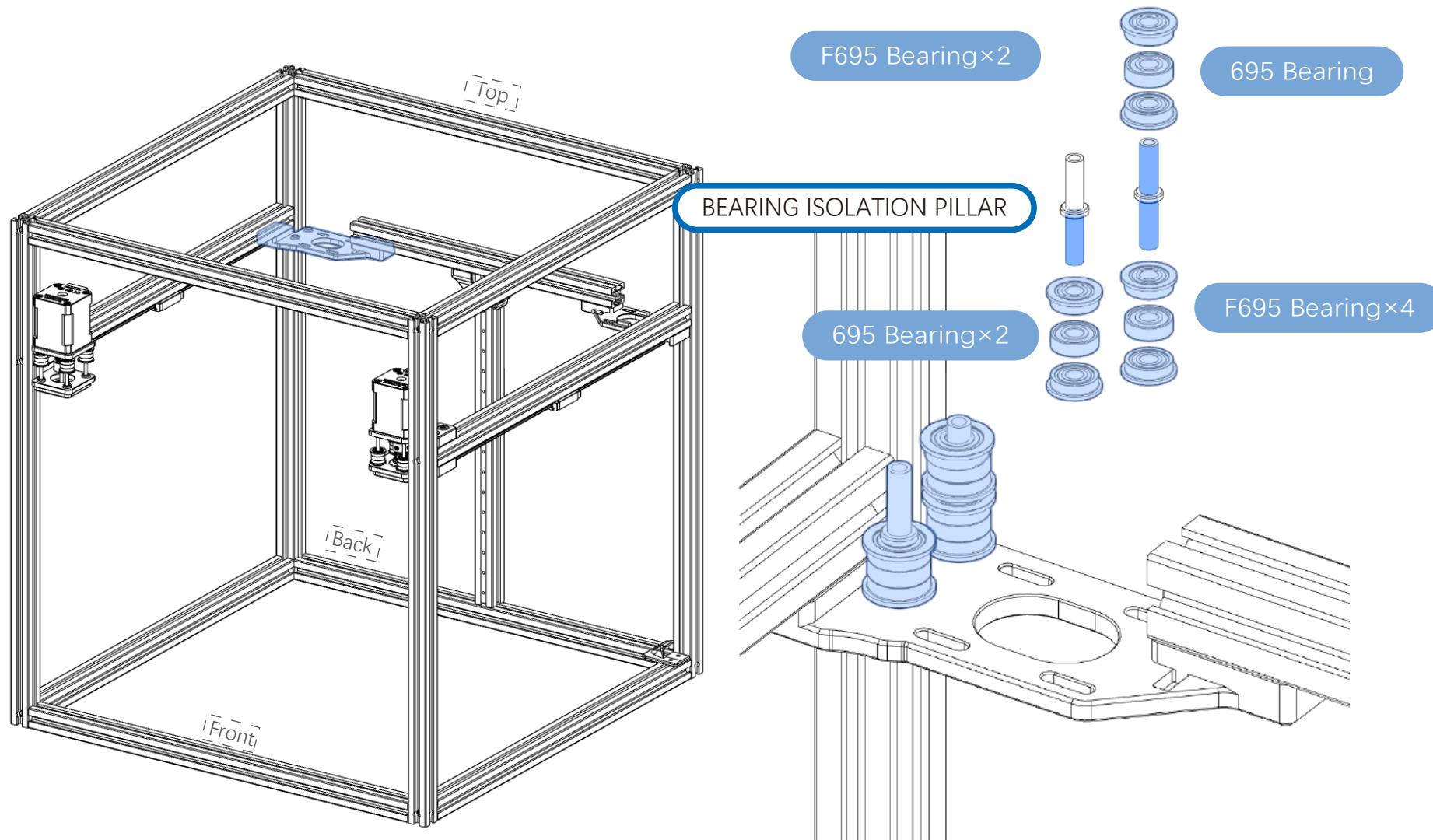


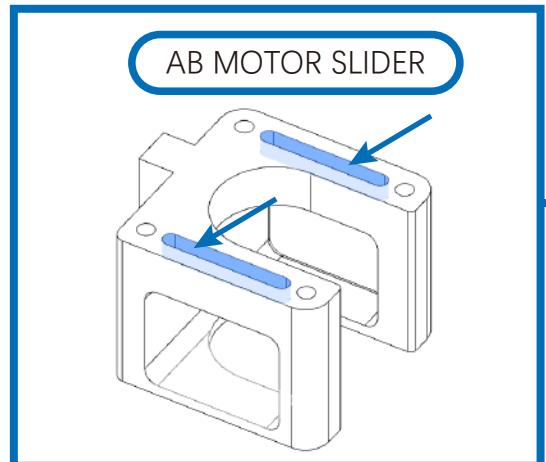
**DIRECTION**

The set screws should align with the notch on the motor shaft.

**THREAD LOCKER**

Consider adding threadlocker for the specific screw (e.g., the Voron motor mount screw). This screw often loosens and causes tension issues. Note that some threadlockers might lock too tightly for future adjustments. If threadlocker is unavailable, you can temporarily skip this step.

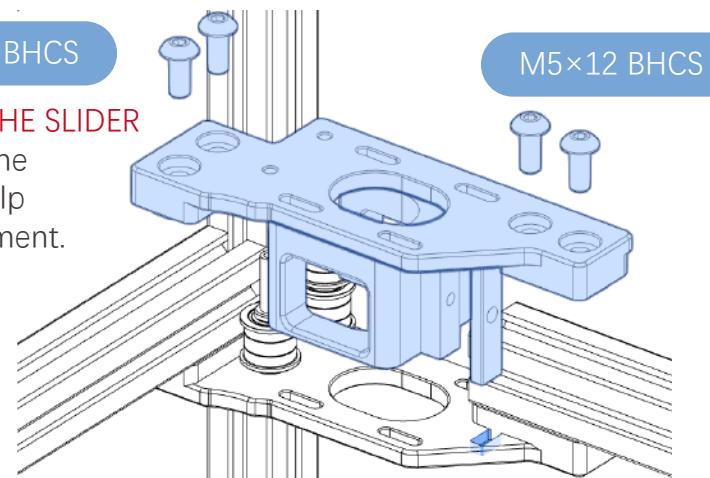




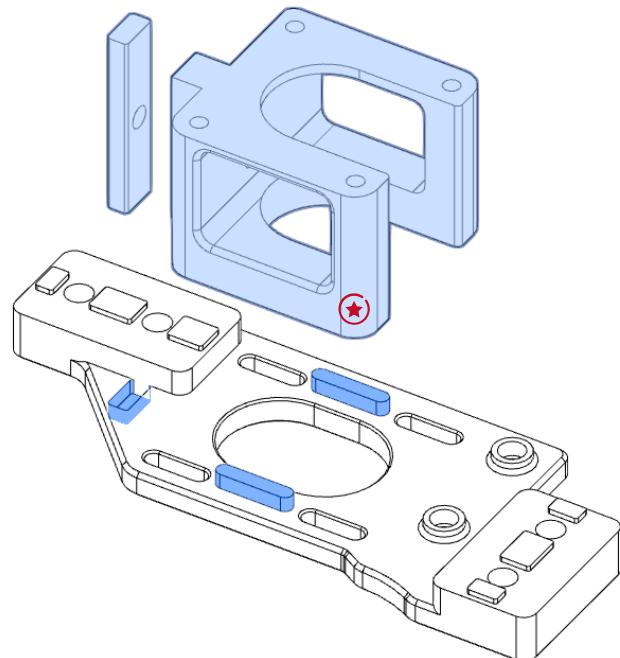
AB MOTOR SLIDER

## M5×12 BHCS

**ADDING LUBRICANT TO THE SLIDER**  
Applying some grease in the groove of the slider will help facilitate its smooth movement.



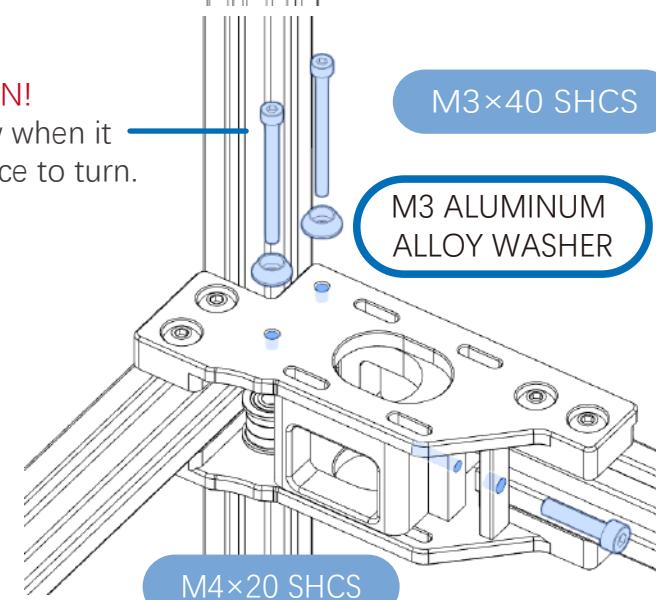
M5×12 BHCS



TENSIONING ALUMINUM BAR

## DO NOT OVERTIGHTEN!

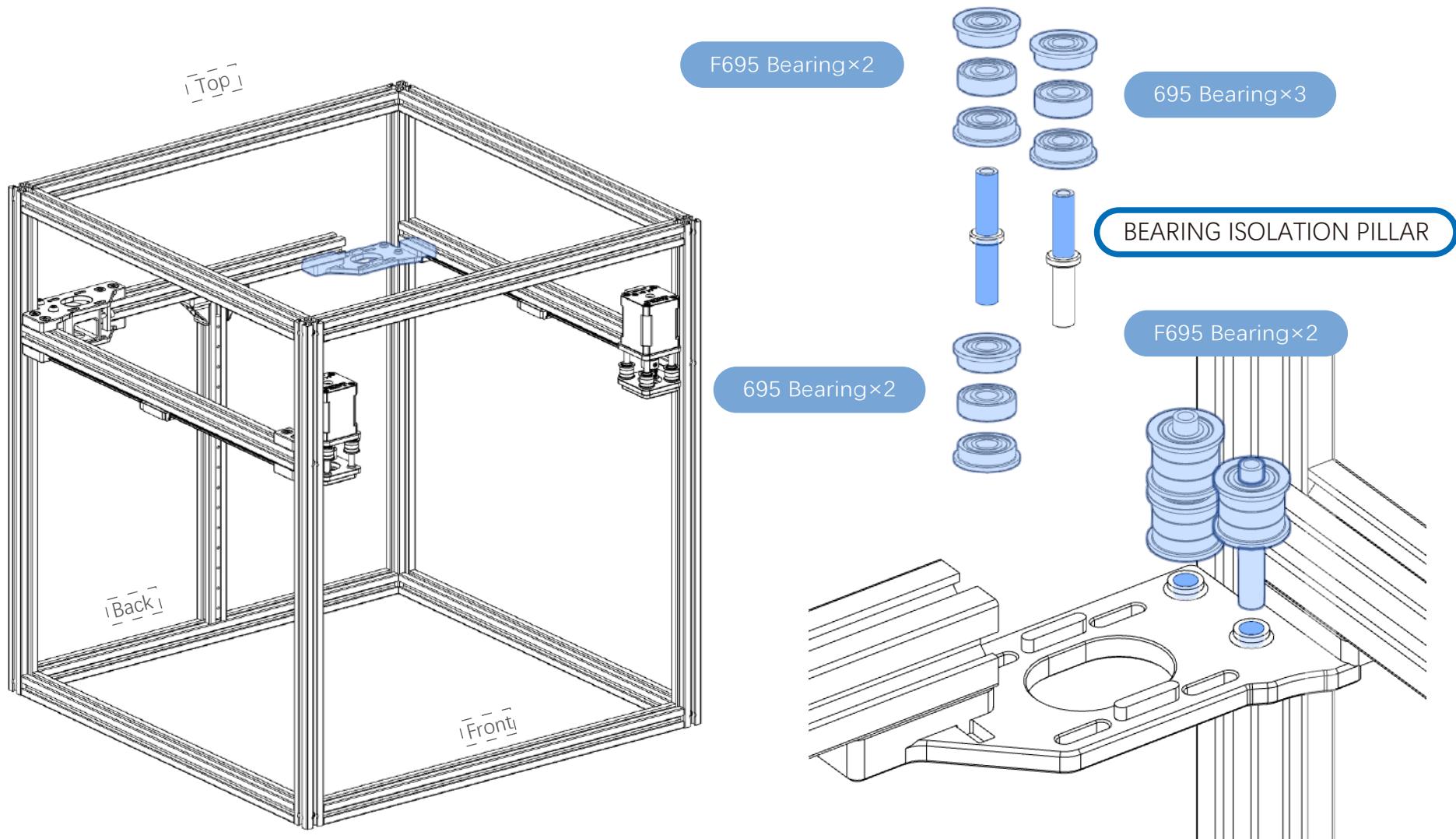
Stop turning the screw when it requires significant force to turn.

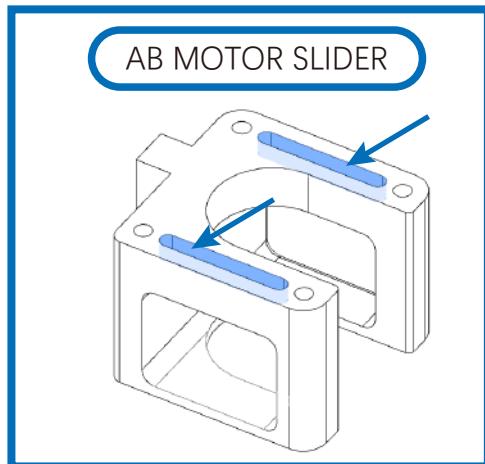


M3×40 SHCS

M3 ALUMINUM ALLOY WASHER

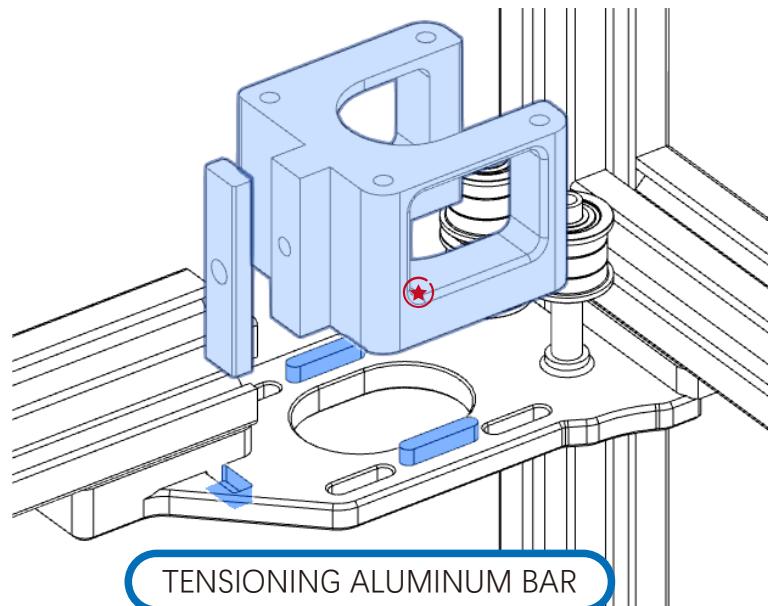
M4×20 SHCS



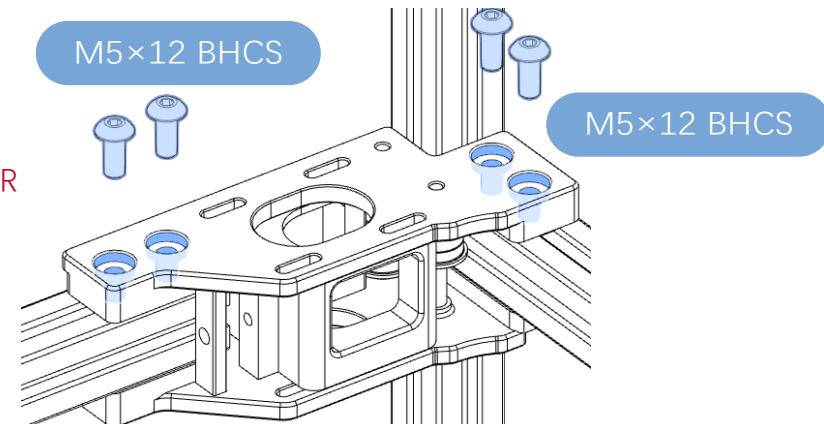


AB MOTOR SLIDER

**ADDING LUBRICANT TO THE SLIDER**  
Applying some grease in the groove of the slider will help facilitate its smooth movement.



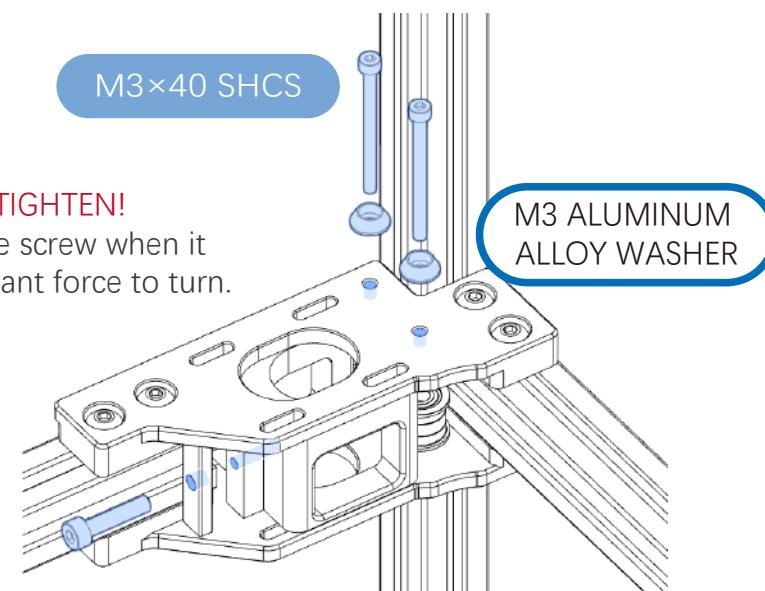
TENSIONING ALUMINUM BAR



M5×12 BHCS

M5×12 BHCS

**DO NOT OVERTIGHTEN!**  
Stop turning the screw when it requires significant force to turn.

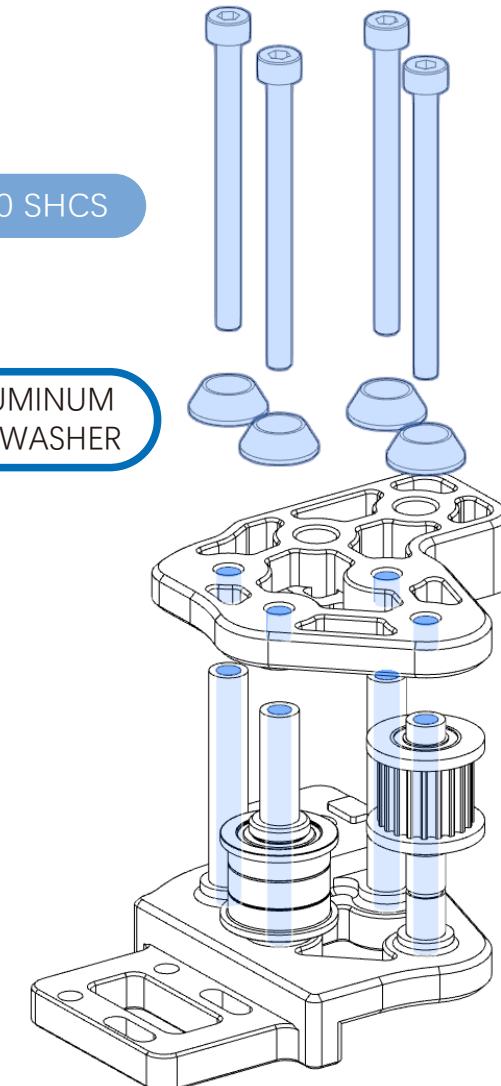
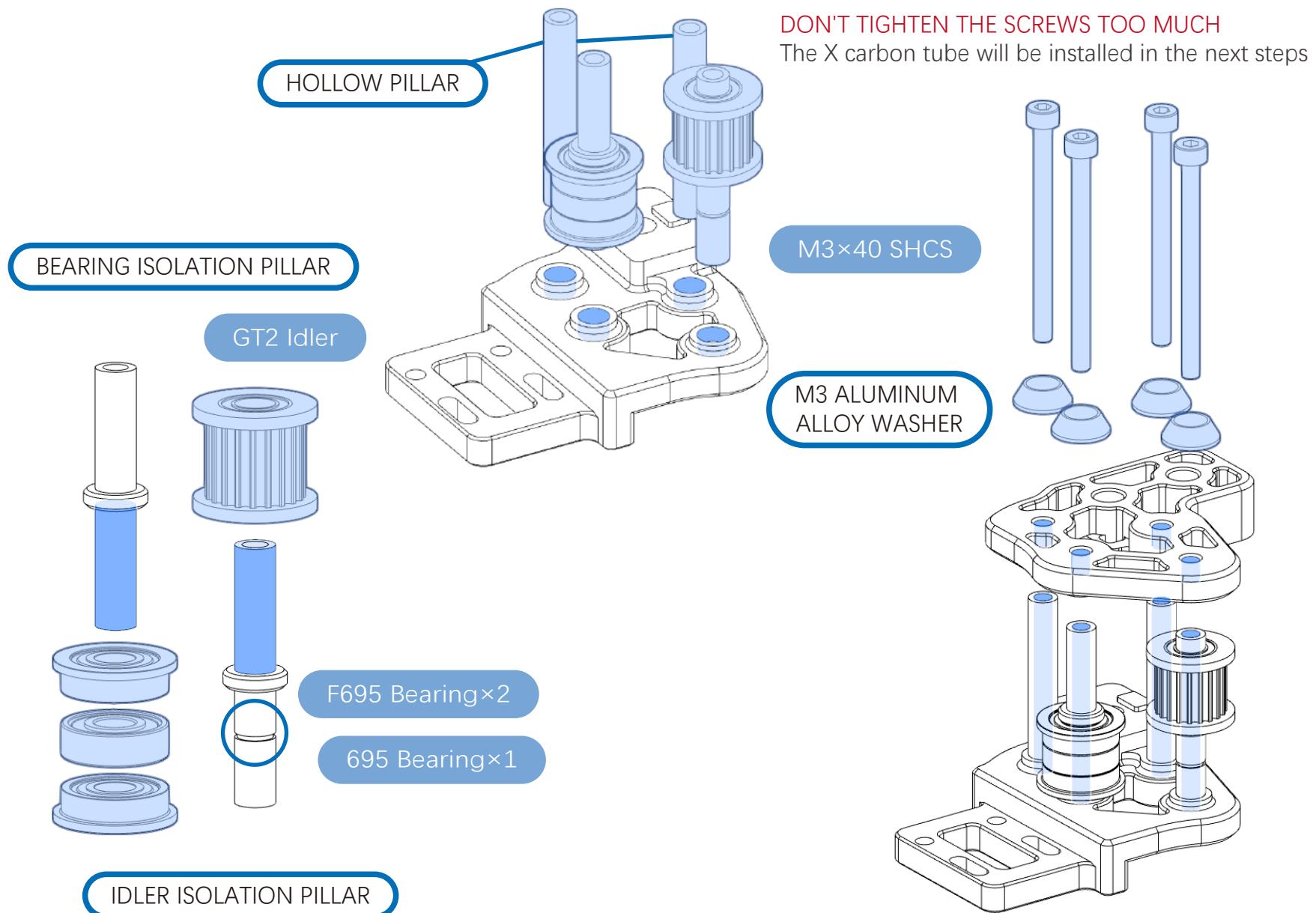


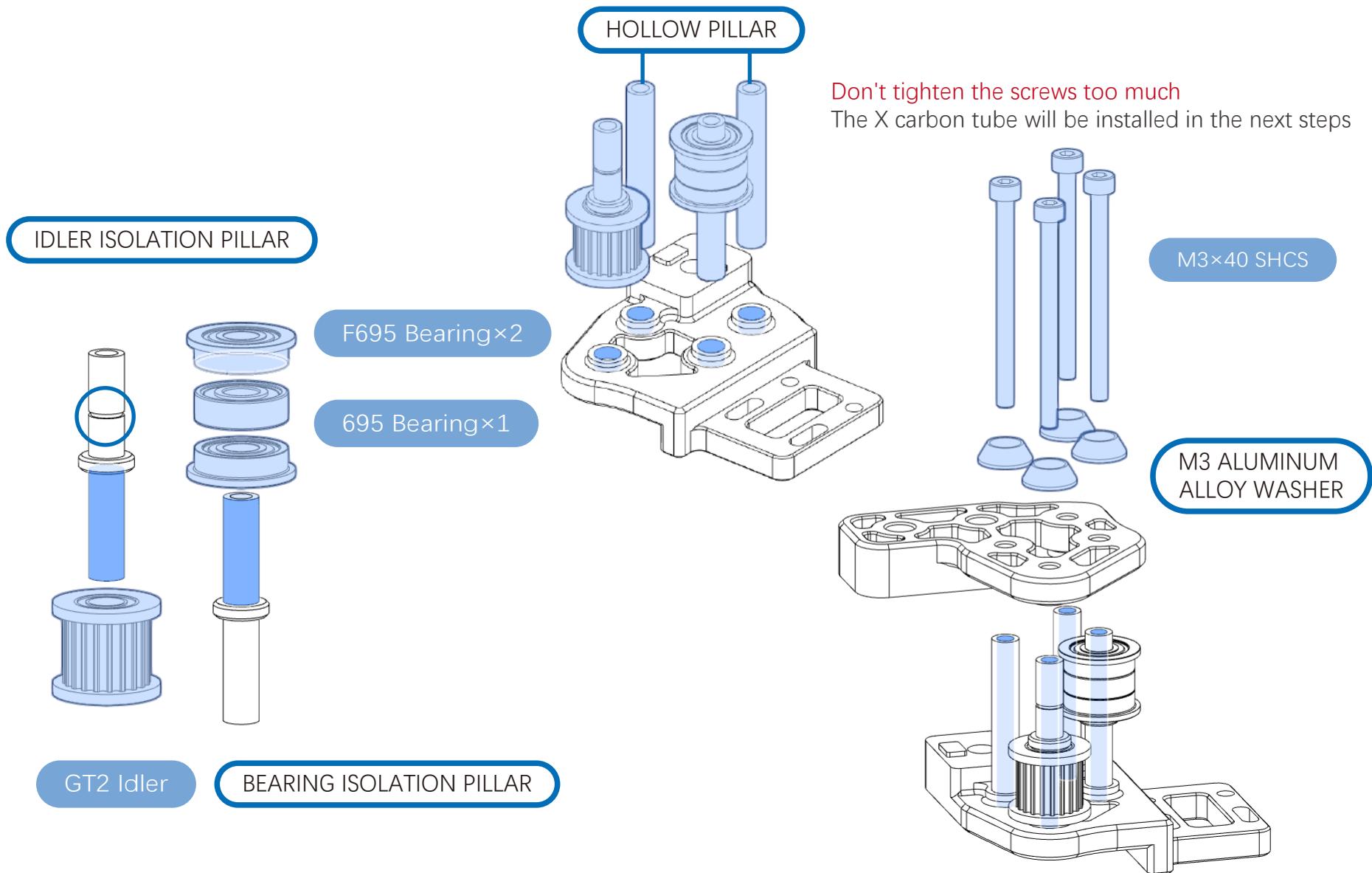
M4×20 SHCS

M4×20 SHCS only need to be threaded in 2-3 turns to facilitate subsequent belt tensioning.

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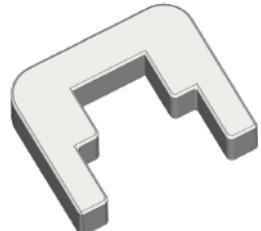
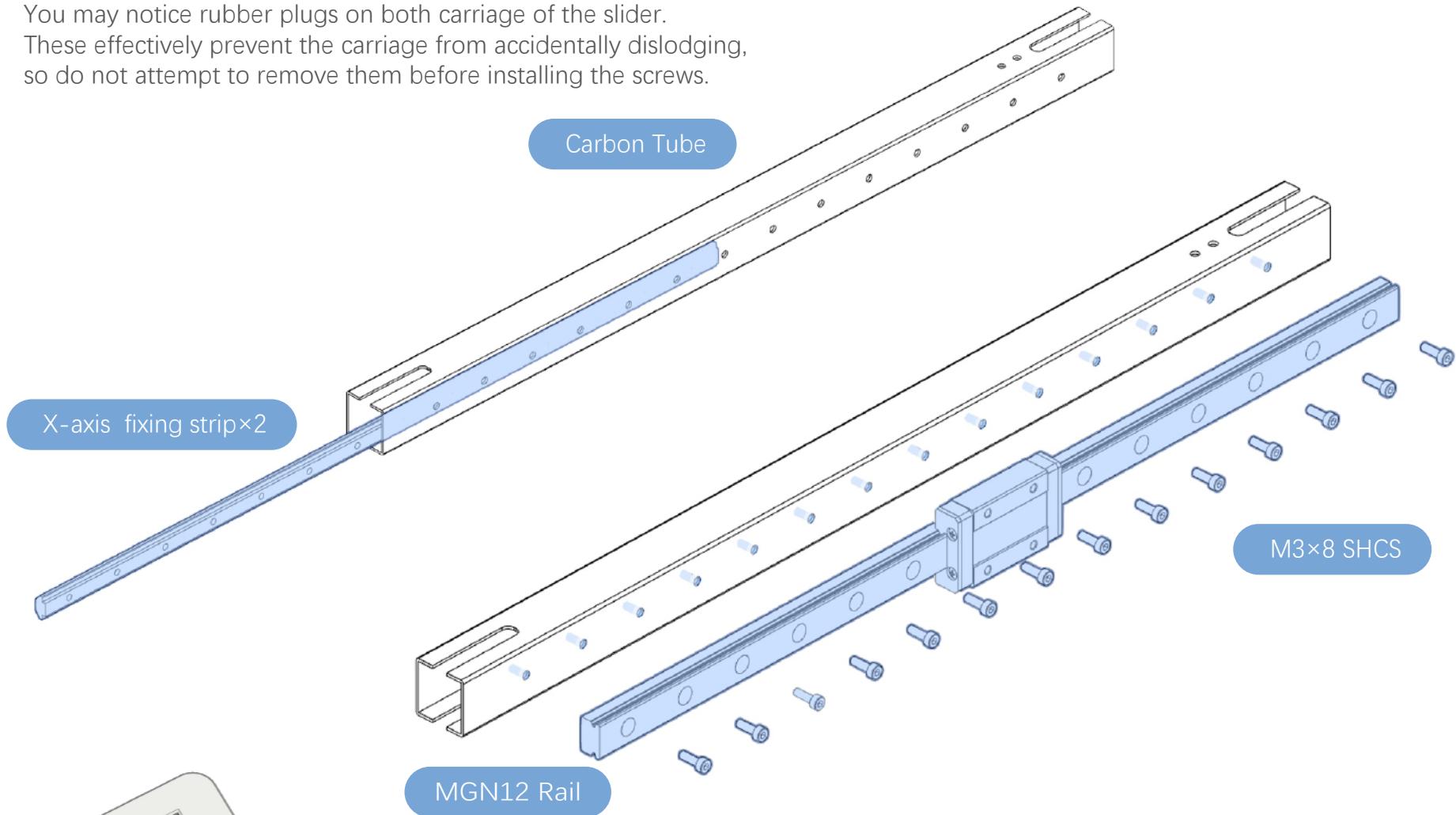






## RUBBER PLUGS ON LINEAR RAIL

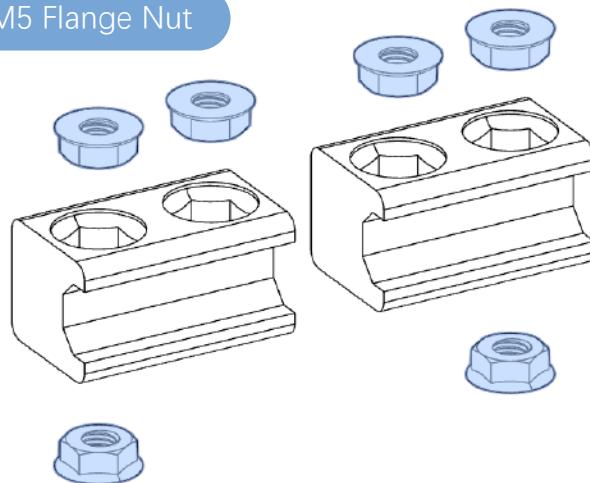
You may notice rubber plugs on both carriage of the slider. These effectively prevent the carriage from accidentally dislodging, so do not attempt to remove them before installing the screws.



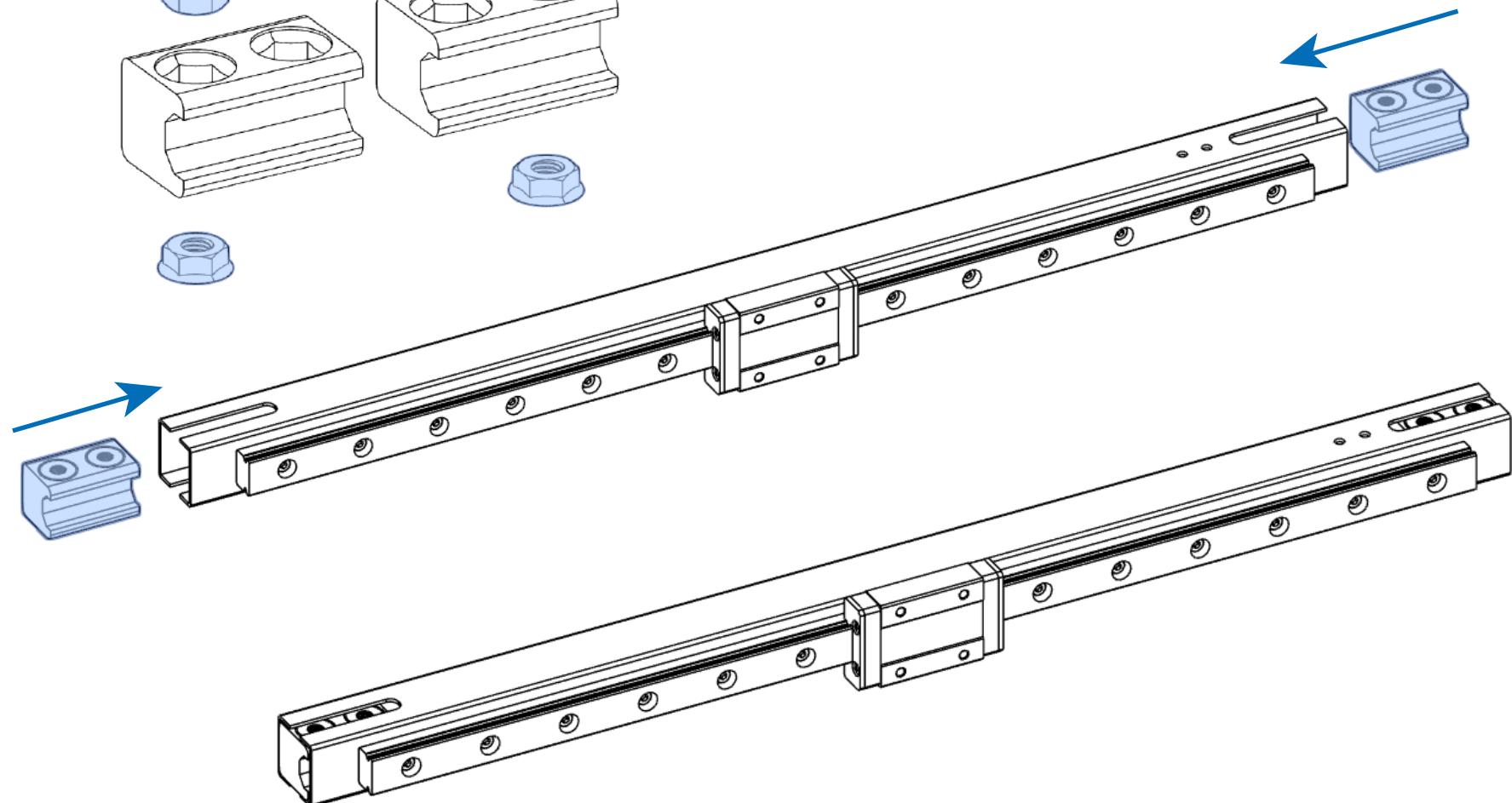
## CENTRED RAIL INSTALLATION GUIDE

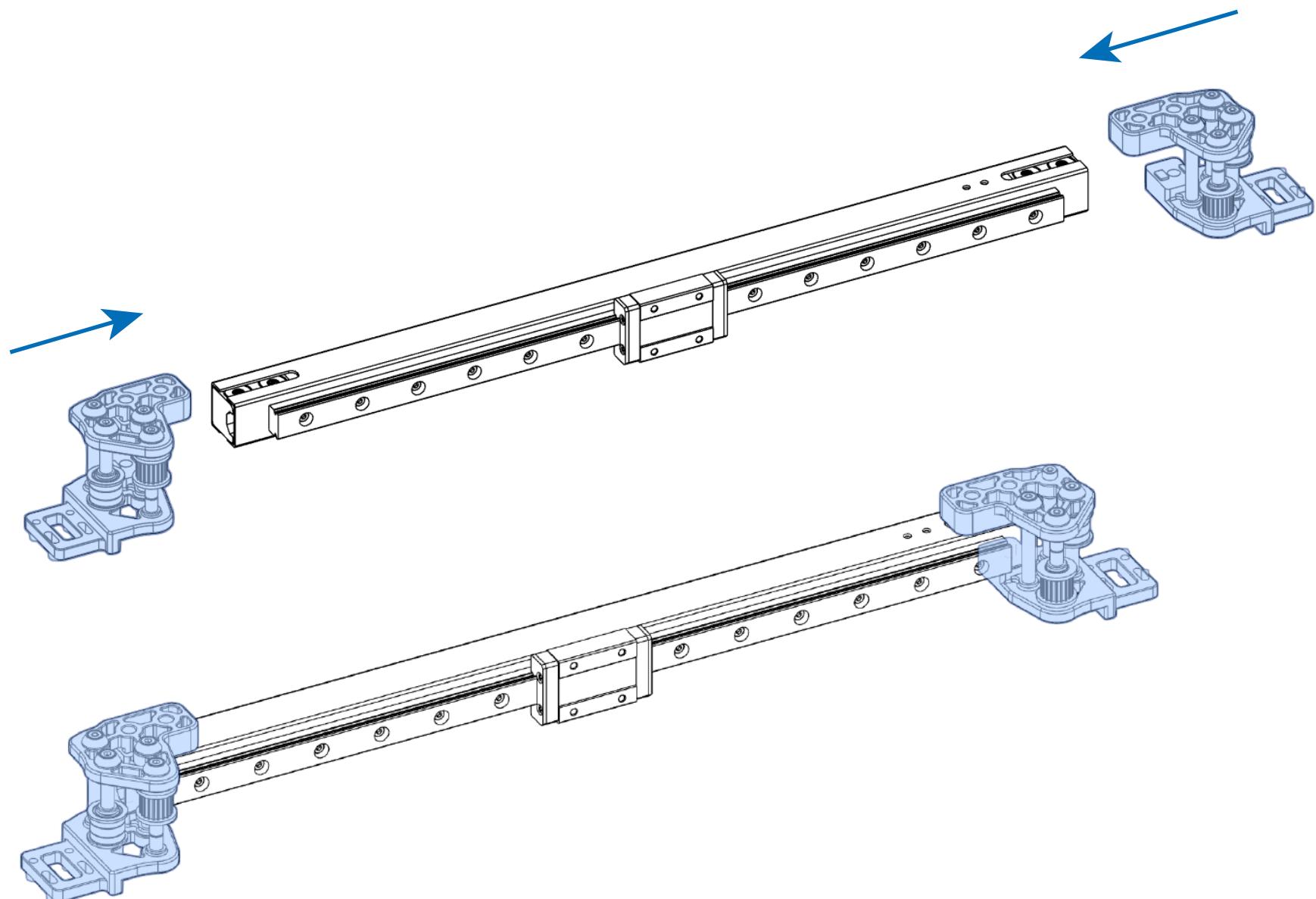
Use the MGN12 guides to position the rail in the centre of the extrusion prior to fastening the bolts.

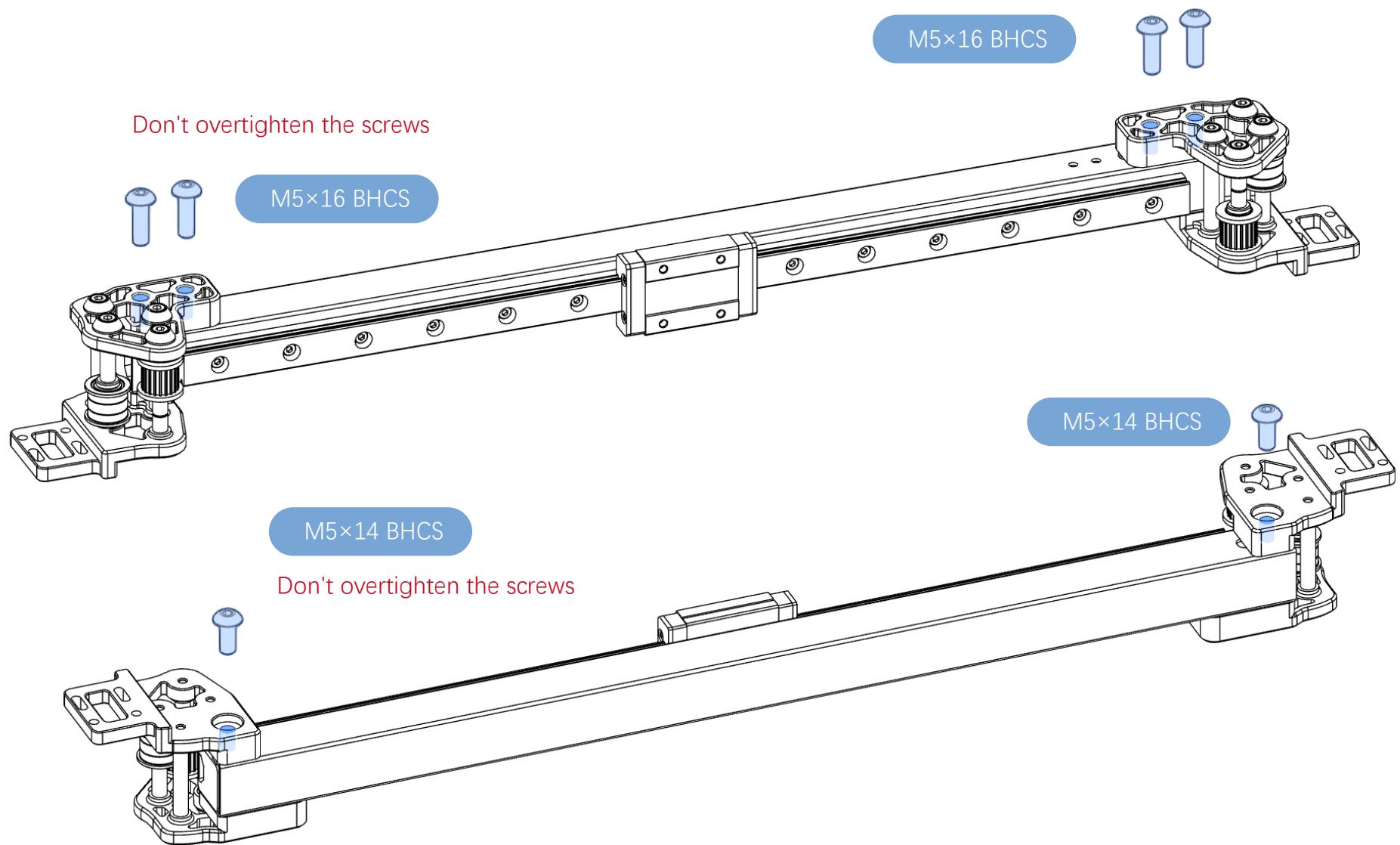
M5 Flange Nut

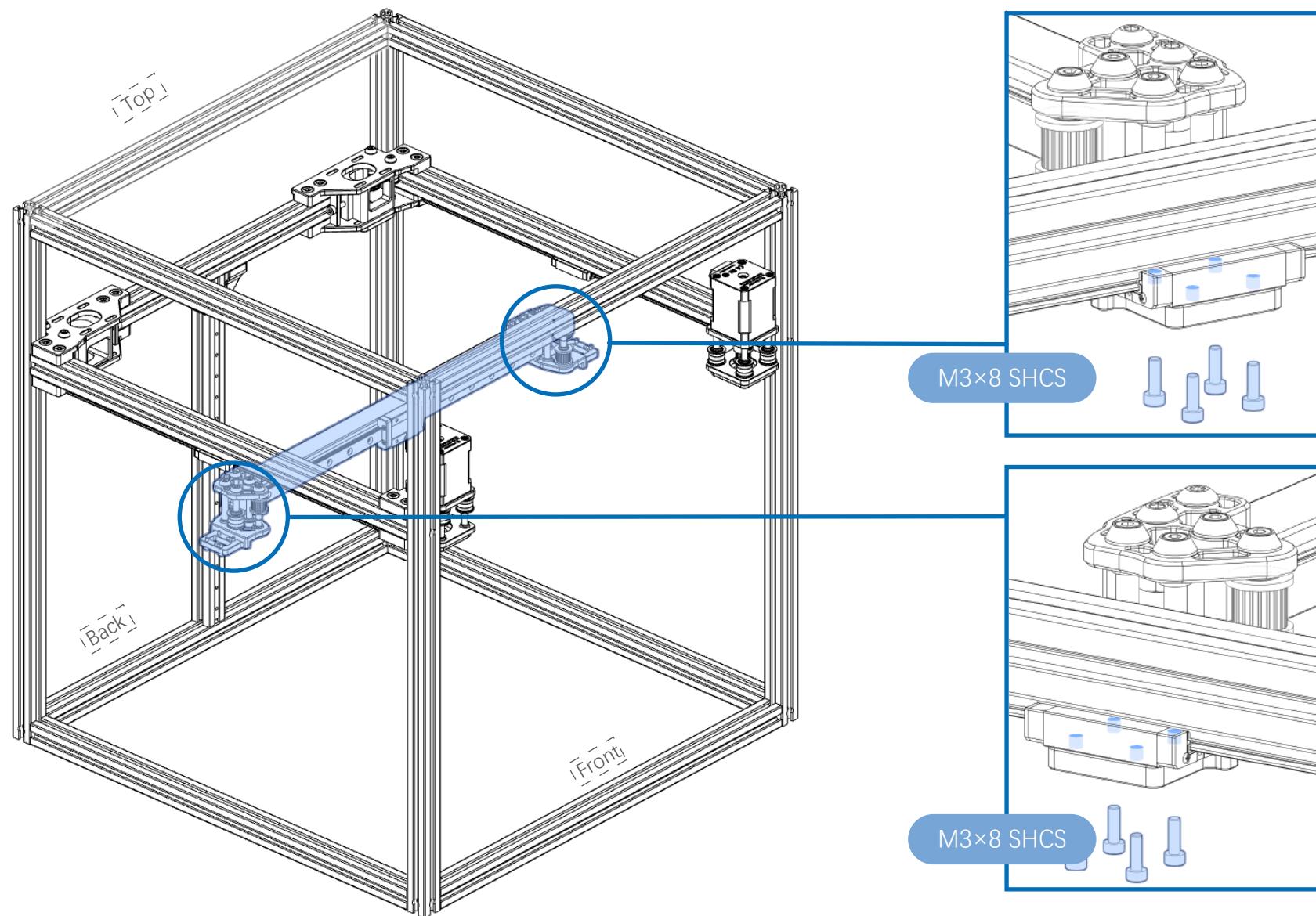
**X CARBON TUBE FIXINGS**

The X Carbon Tube Fixings made from ABS material help reduce vibrations on the X-axis and prevent the flange nut from loosening.







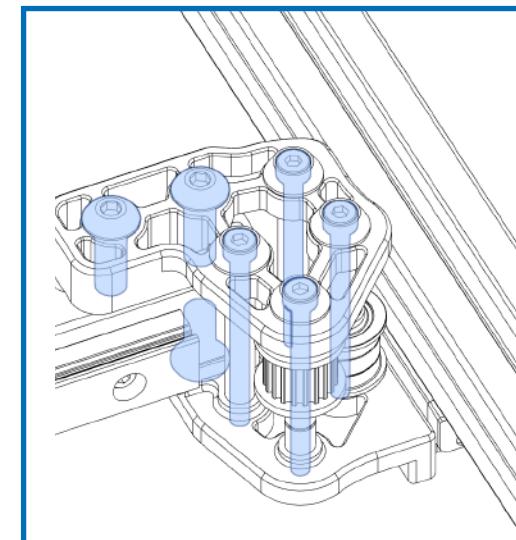
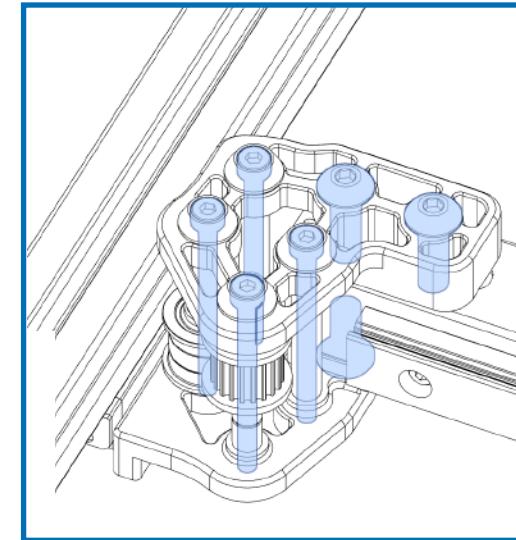
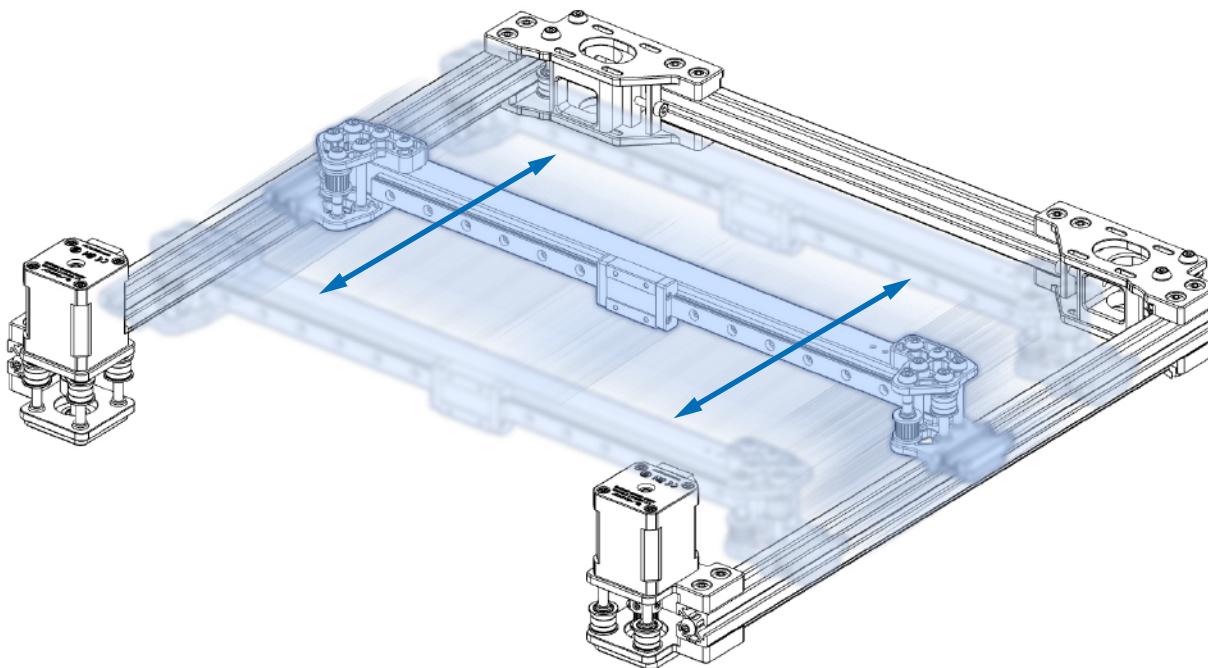


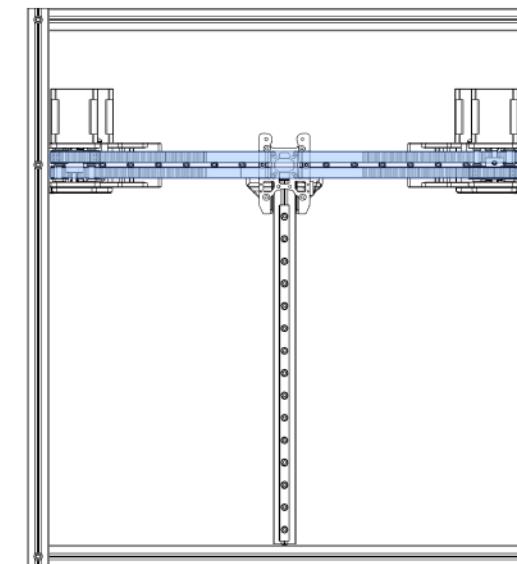
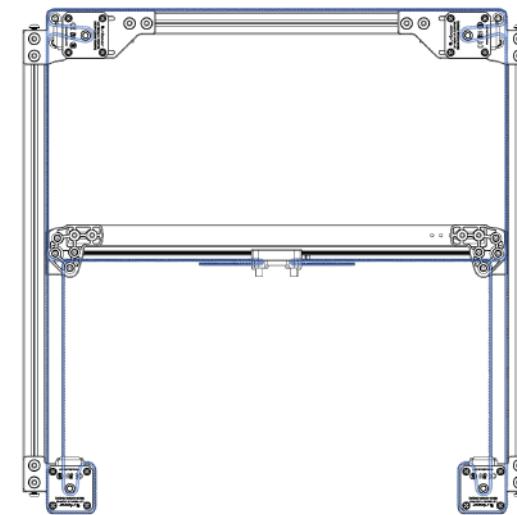
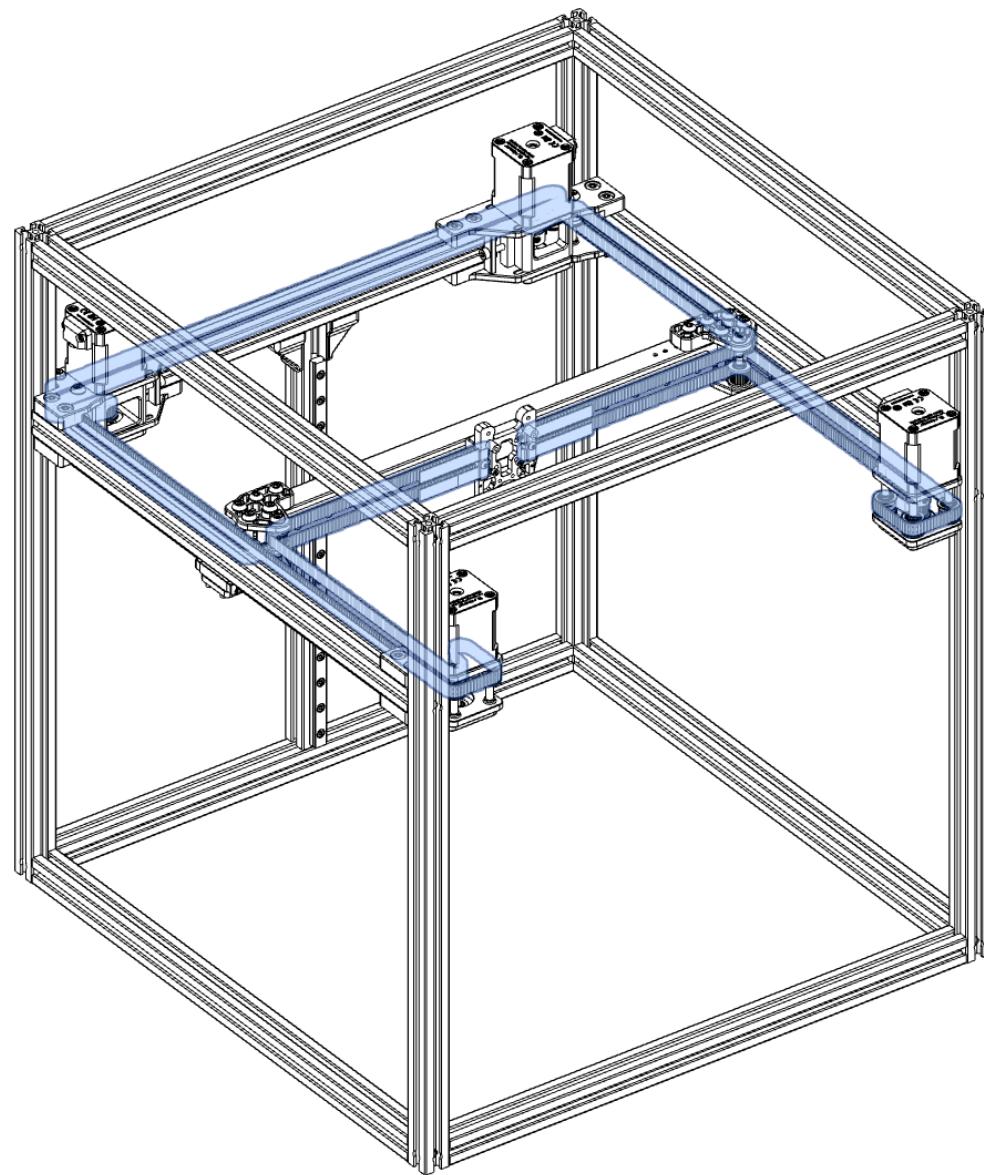
## ADJUSTING THE X-AXIS JOINTS

Slide the X-axis part quickly along the Y-axis. Since the screws on both sides of the X-axis joints are not fully tightened, the joints will automatically adjust their positions on the carbon tubes during the sliding process.

Once you feel the movement is very smooth and without any resistance, you can fully tighten the screws on both sides of the X-axis joints.

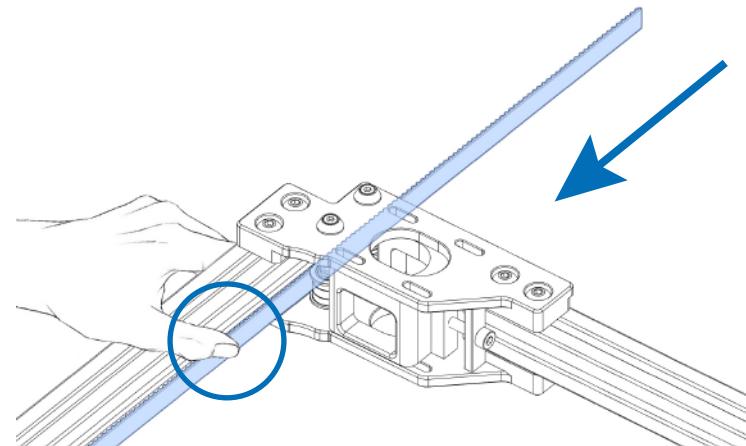
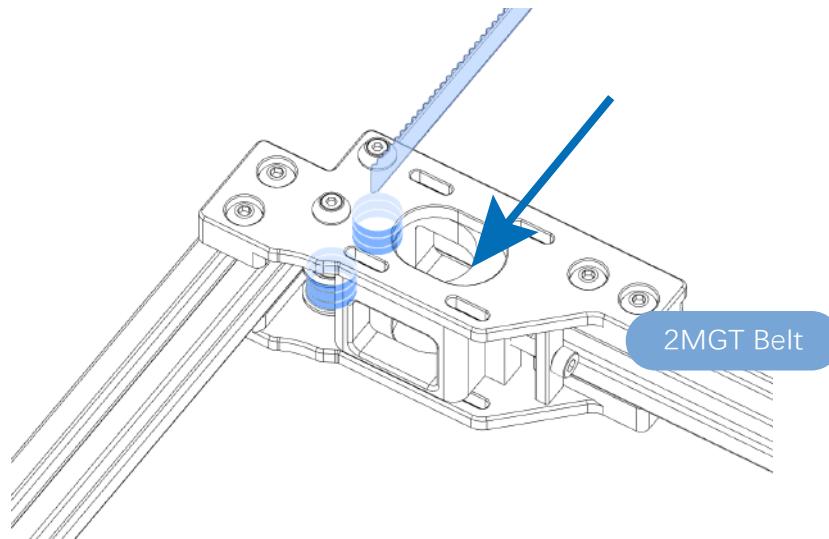
Don't forget to tighten the M5×12 BHCS screws at the bottom; otherwise, they may become loose and fall off during high-speed machine operation.





**INSTRUCTION**

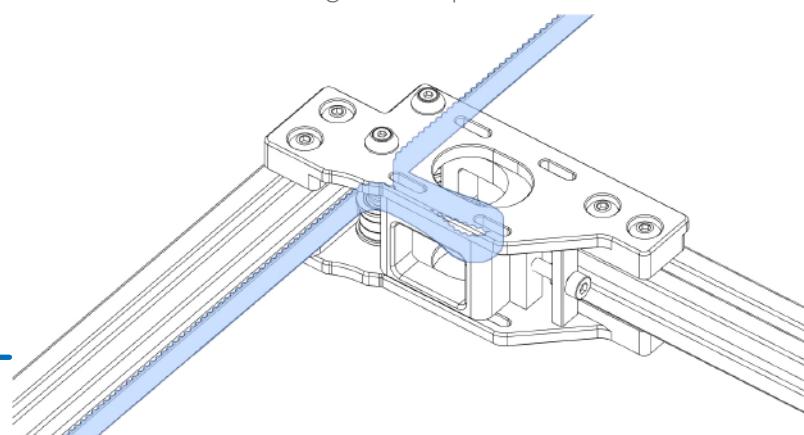
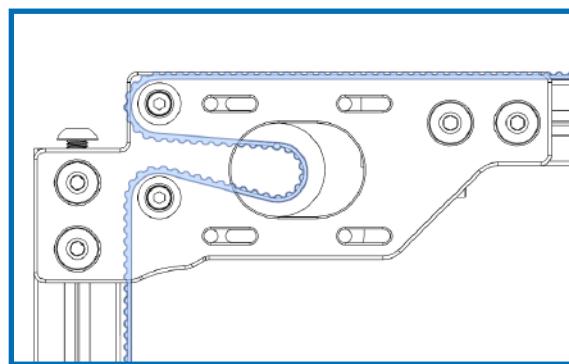
Cut the timing belt in the kit into two equal parts.

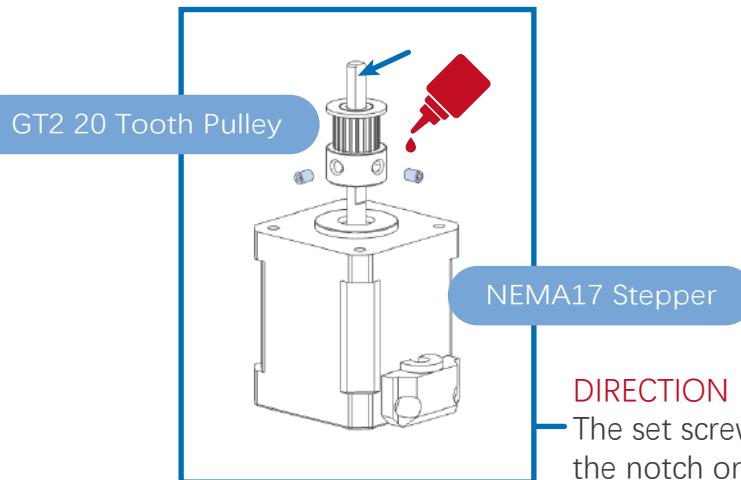
**FEEDING THE TIMING BELT**

Hold the timing belt at the exit point and continue feeding it until the belt is forced into place between the two sets of bearings under pressure.

**TEMPORARILY HIDING THE FRAME EXTRUSION**

To provide a clear demonstration of the timing belt installation steps, we will temporarily hide the frame extrusion in the subsequent sections.

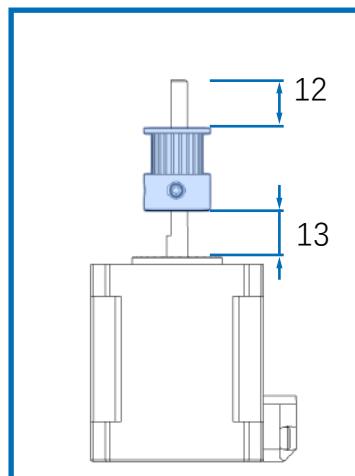


**MOTOR ORIENTATION**

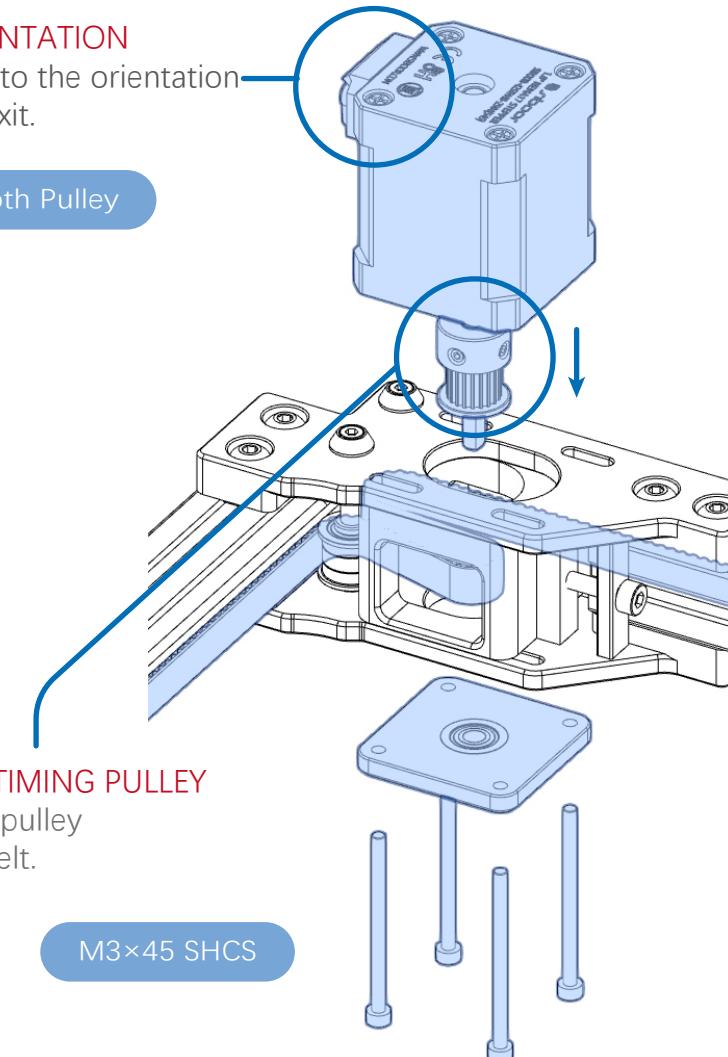
Pay attention to the orientation of the cable exit.

**GT2 20 Tooth Pulley****DIRECTION**

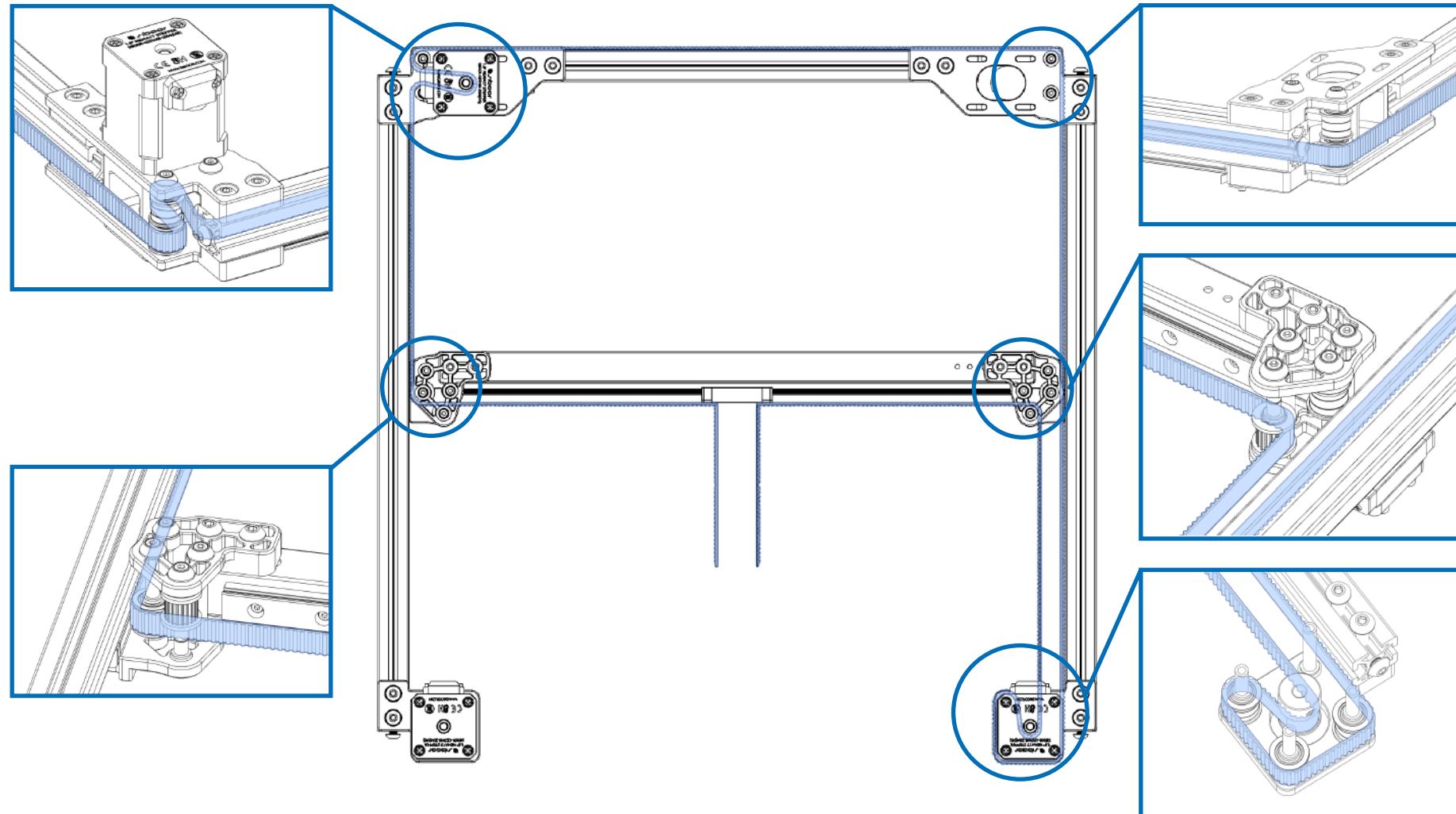
The set screws should align with the notch on the motor shaft.

**INSERTING THE TIMING PULLEY**

Insert the timing pulley into the timing belt.

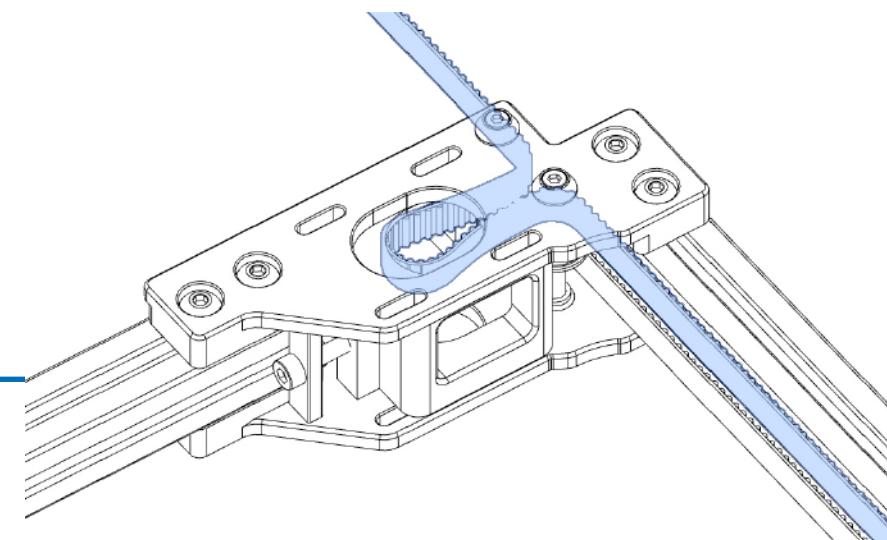
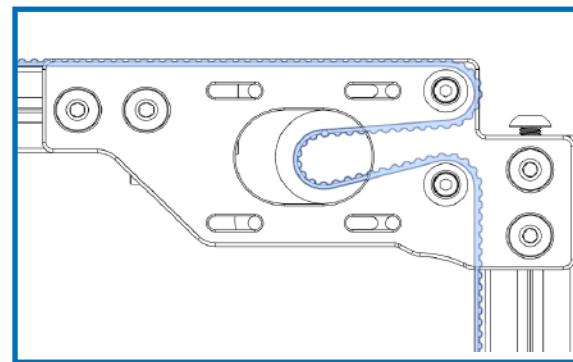
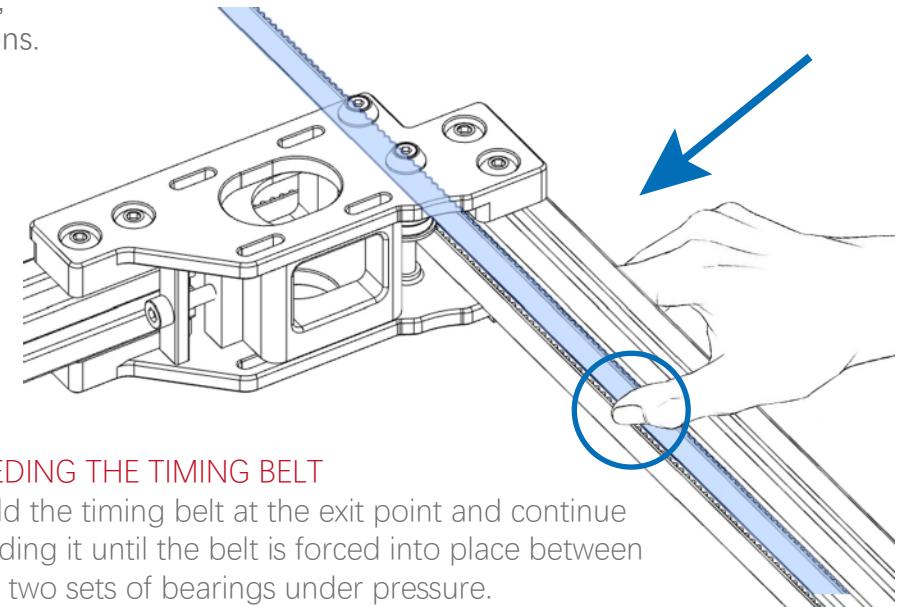
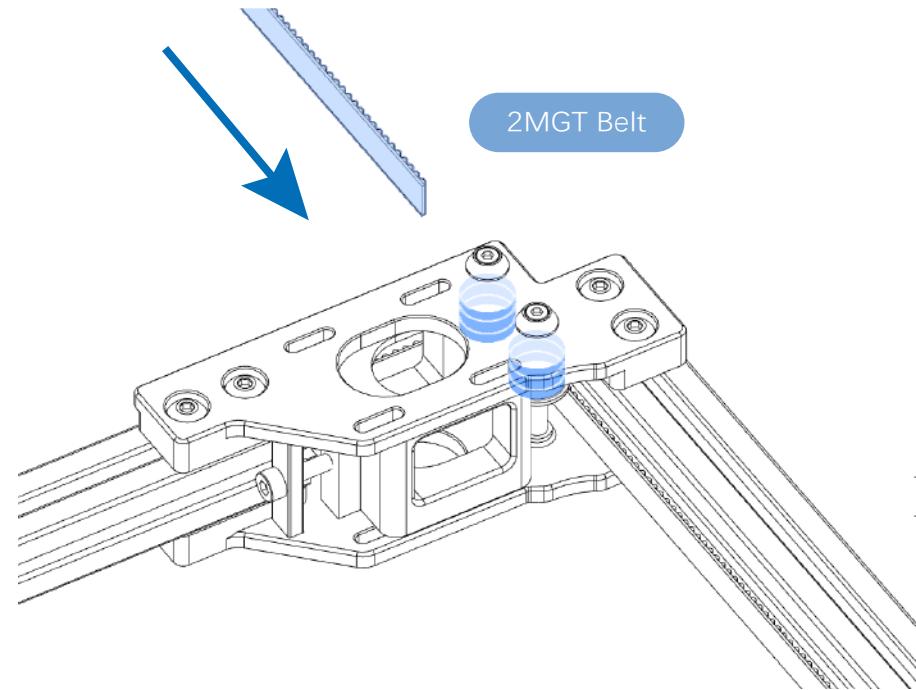
**M3×45 SHCS****THREAD LOCKER**

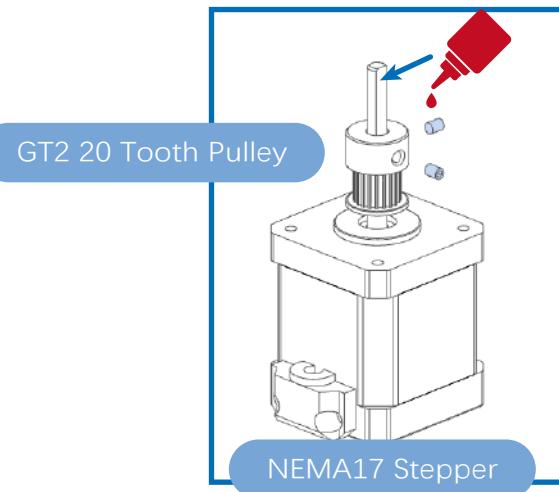
Consider adding threadlocker for the specific screw (e.g., the Voron motor mount screw). This screw often loosens and causes tension issues. Note that some threadlockers might lock too tightly for future adjustments. If threadlocker is unavailable, you can temporarily skip this step.



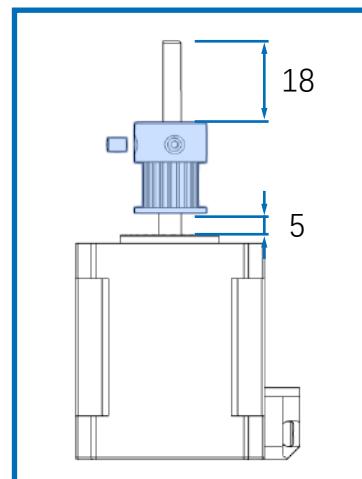
**TEMPORARILY HIDING THE FRAME EXTRUSION**

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**DIRECTION**

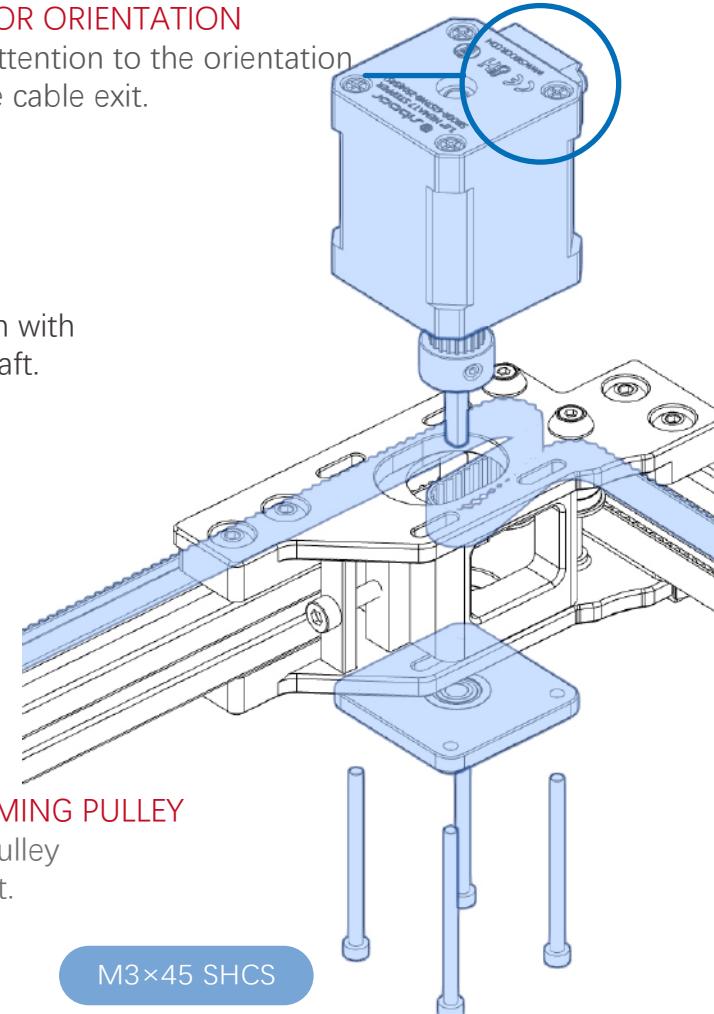
The set screws should align with the notch on the motor shaft.

**THREAD LOCKER**

Consider adding threadlocker for the specific screw (e.g., the Voron motor mount screw). This screw often loosens and causes tension issues. Note that some threadlockers might lock too tightly for future adjustments. If threadlocker is unavailable, you can temporarily skip this step.

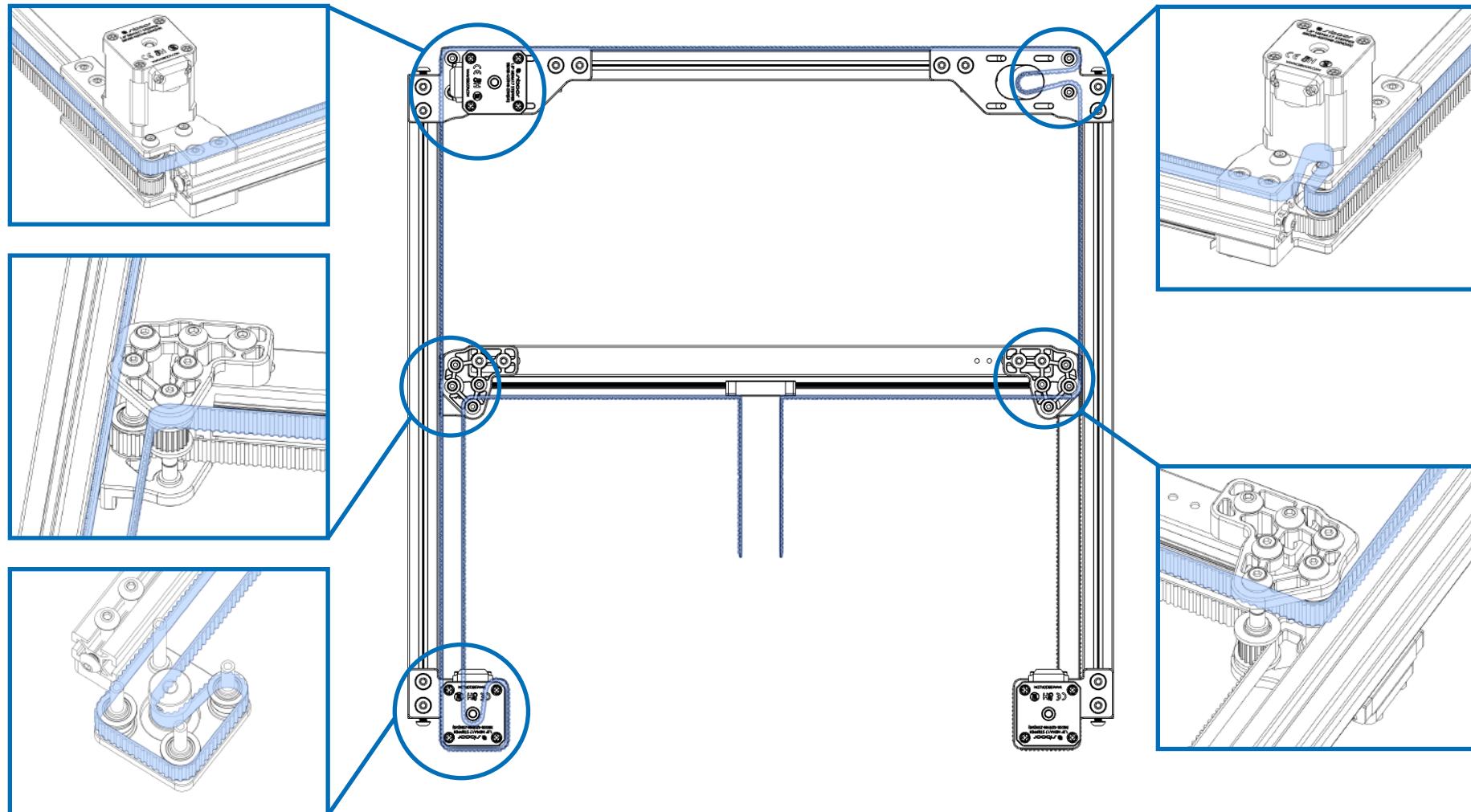
**MOTOR ORIENTATION**

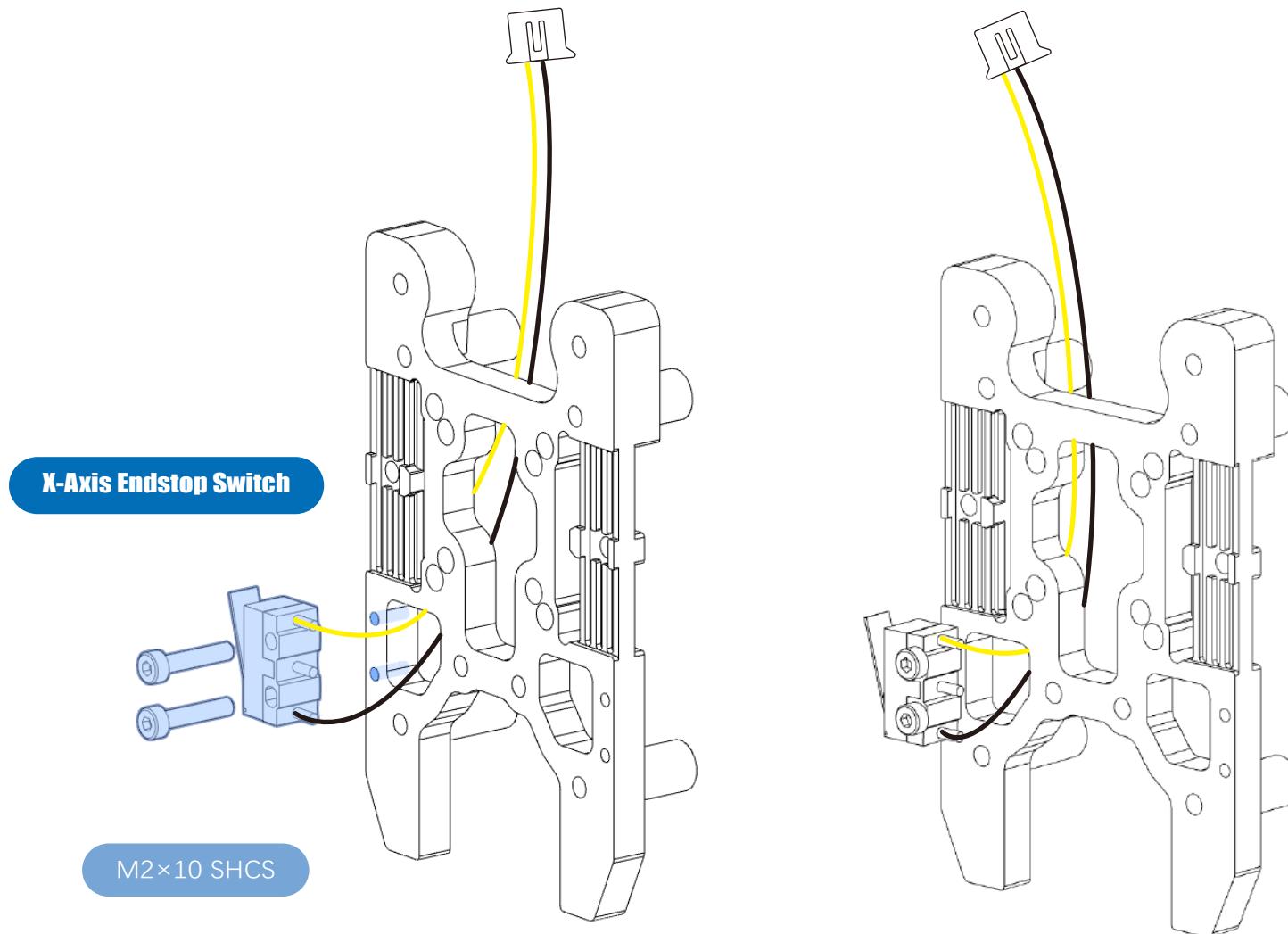
Pay attention to the orientation of the cable exit.

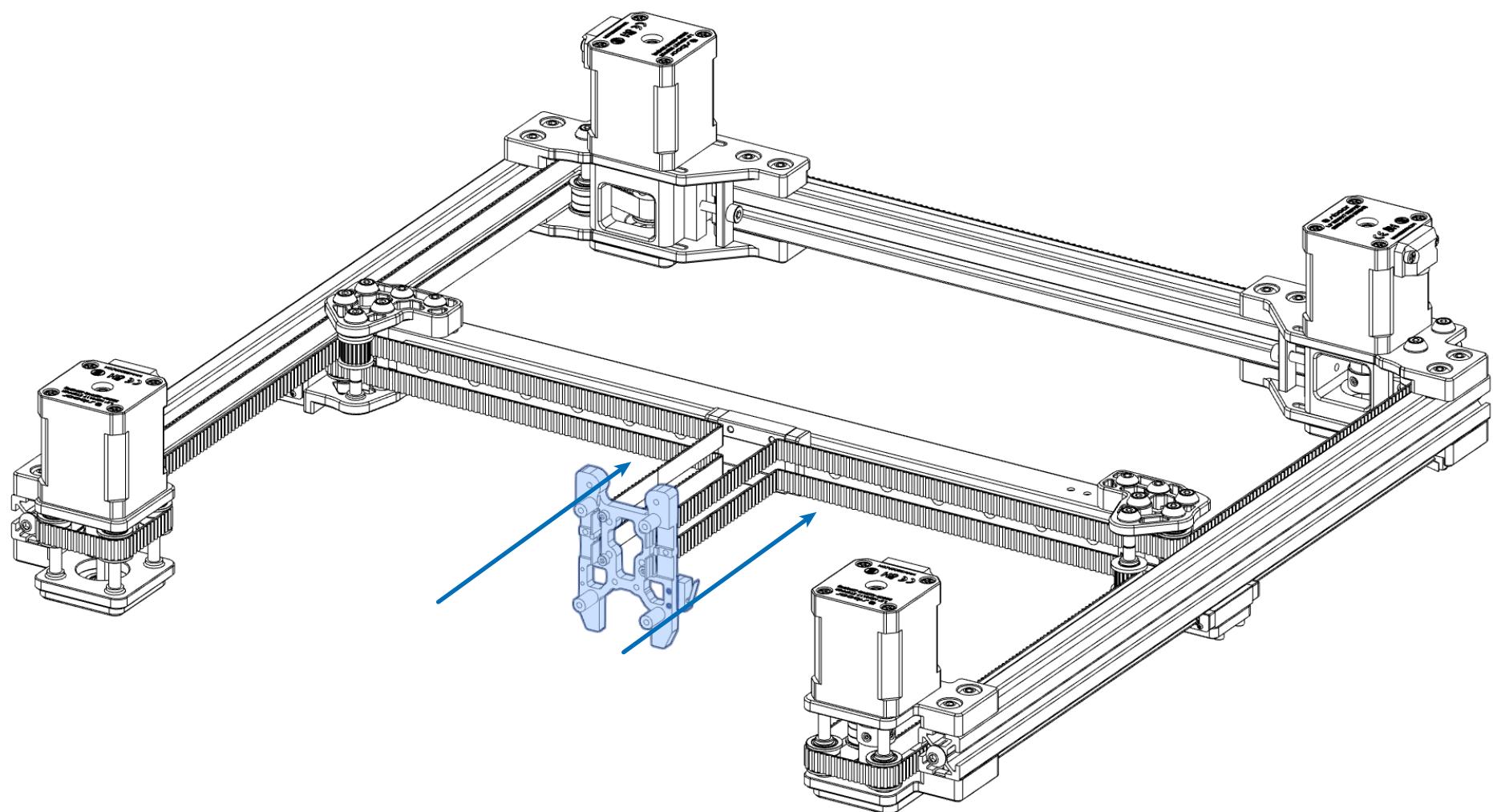
**INSERTING THE TIMING PULLEY**

Insert the timing pulley into the timing belt.

M3×45 SHCS

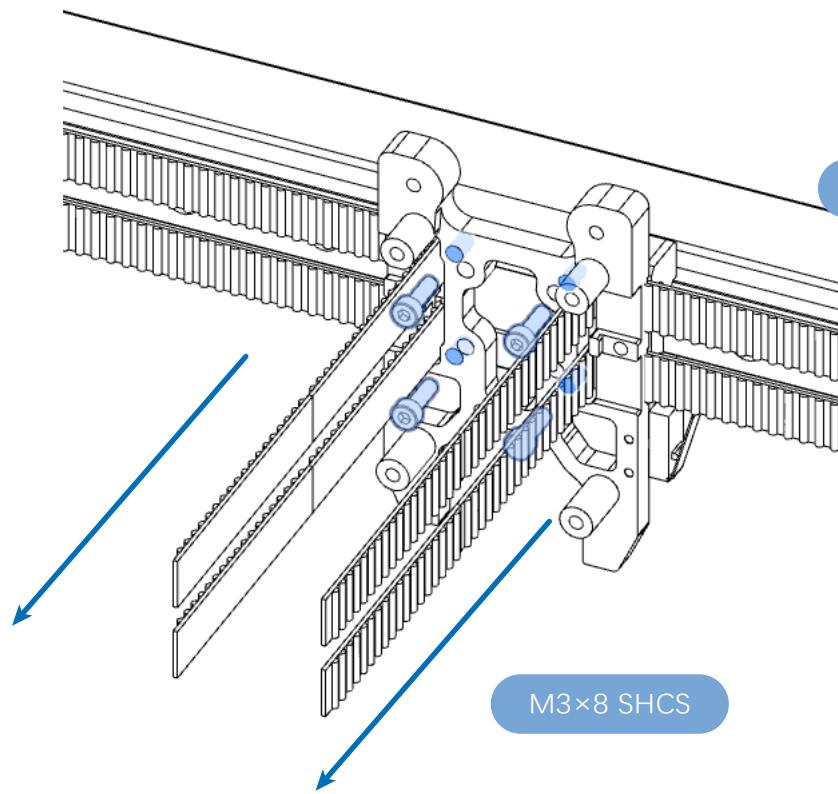






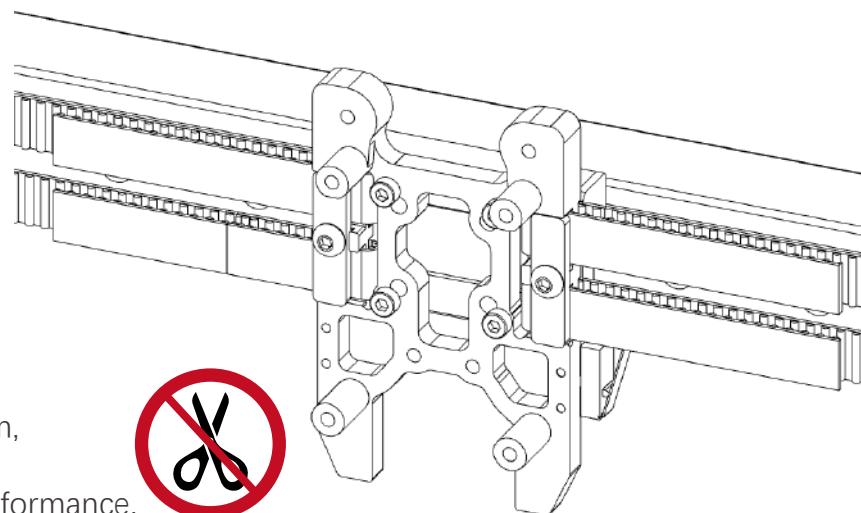
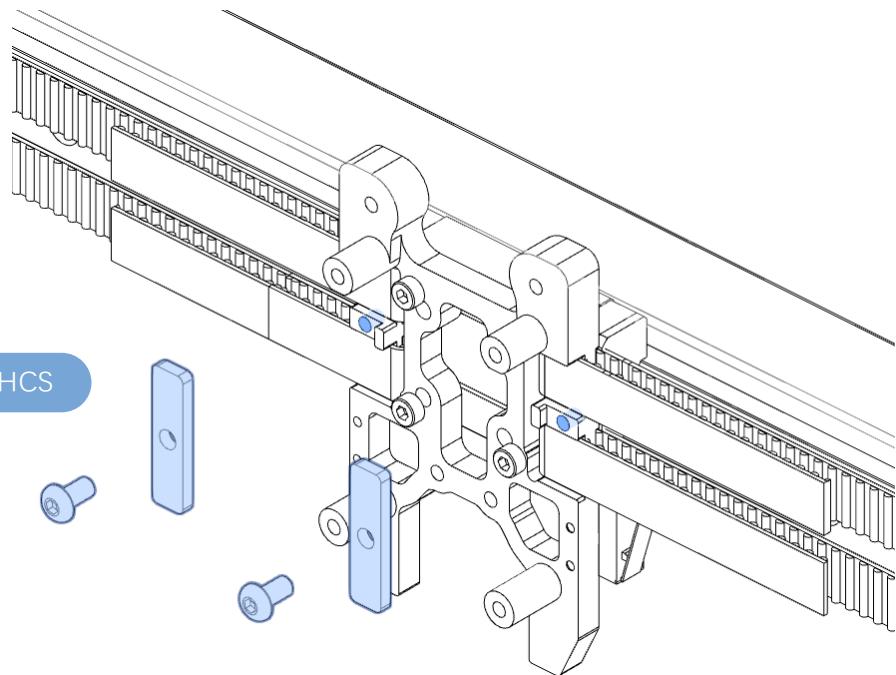
**INSTRUCTION**

After tightening the timing belt, secure the M3×8 SHCS screws.



M3×6 BHCS

M3×8 SHCS

**DO NOT CUT THE TIMING BELT AT THIS TIME**

Wait for 24 hours, retighten the belt, then cut it to approximately 5 cm, ensuring both ends have the same number of teeth.

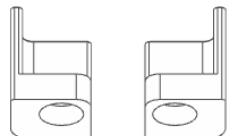
Matching teeth count is crucial for consistent tension and optimal performance.

Before sitting down for a cup of coffee,  
check what's left in the CNC KIT to prevent it from disappearing as scrap.



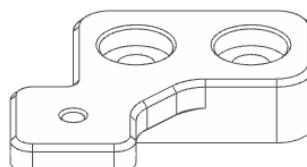
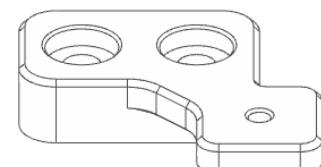
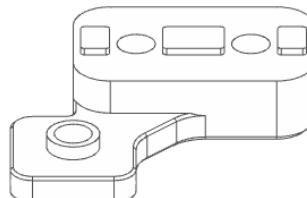
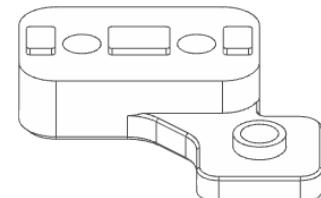
#### UHF EXTENSION BLOCK

This is the X-carriage extension block,  
an essential component required when using the Rapido V2.0 hotend.



#### PEI PRINT BED LOCATOR

This is installed on the heated bed's aluminum  
plate and is used to position the PEI print bed.



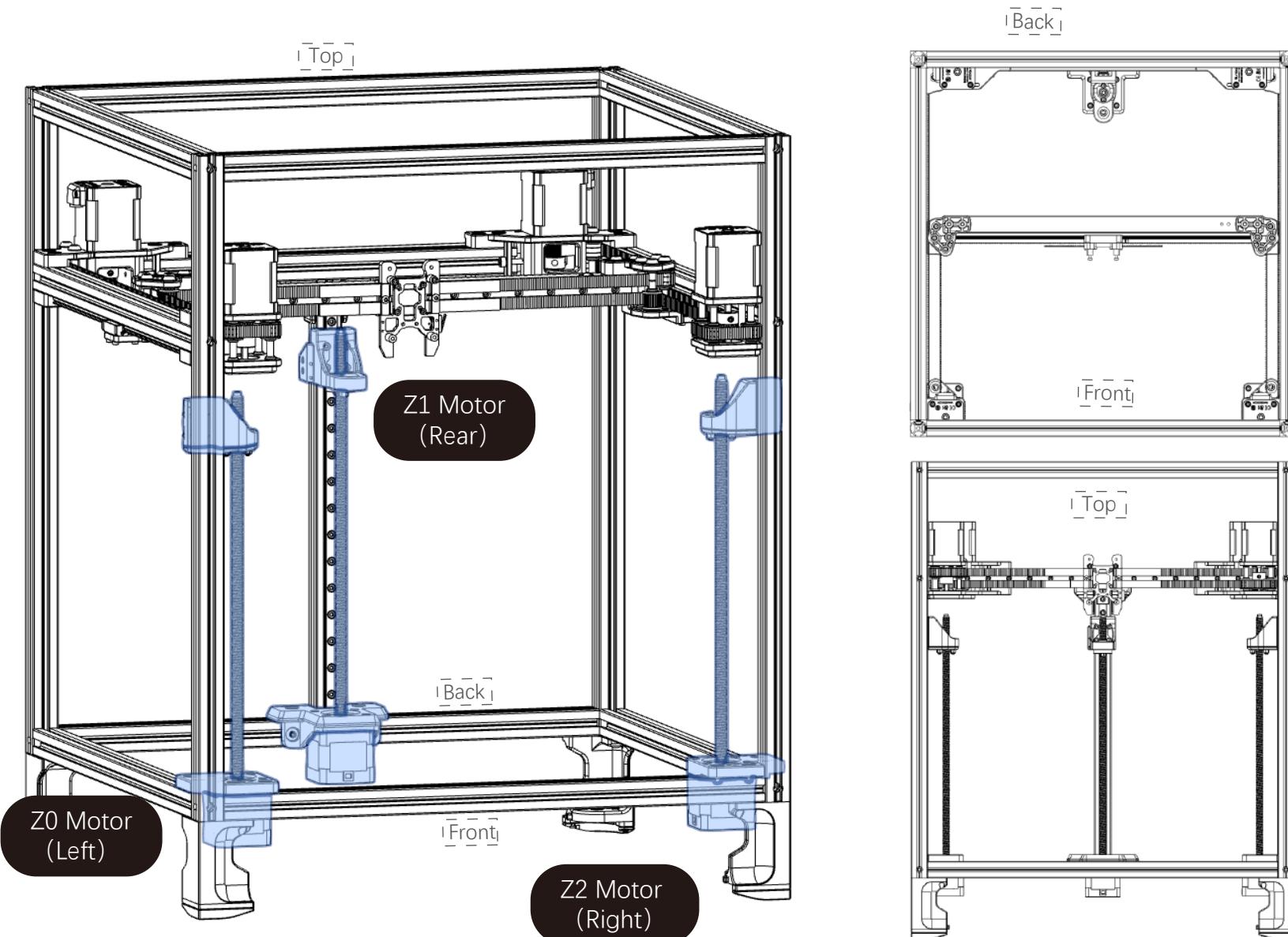
#### FRONT IDLER BRACKET FOR 2WD

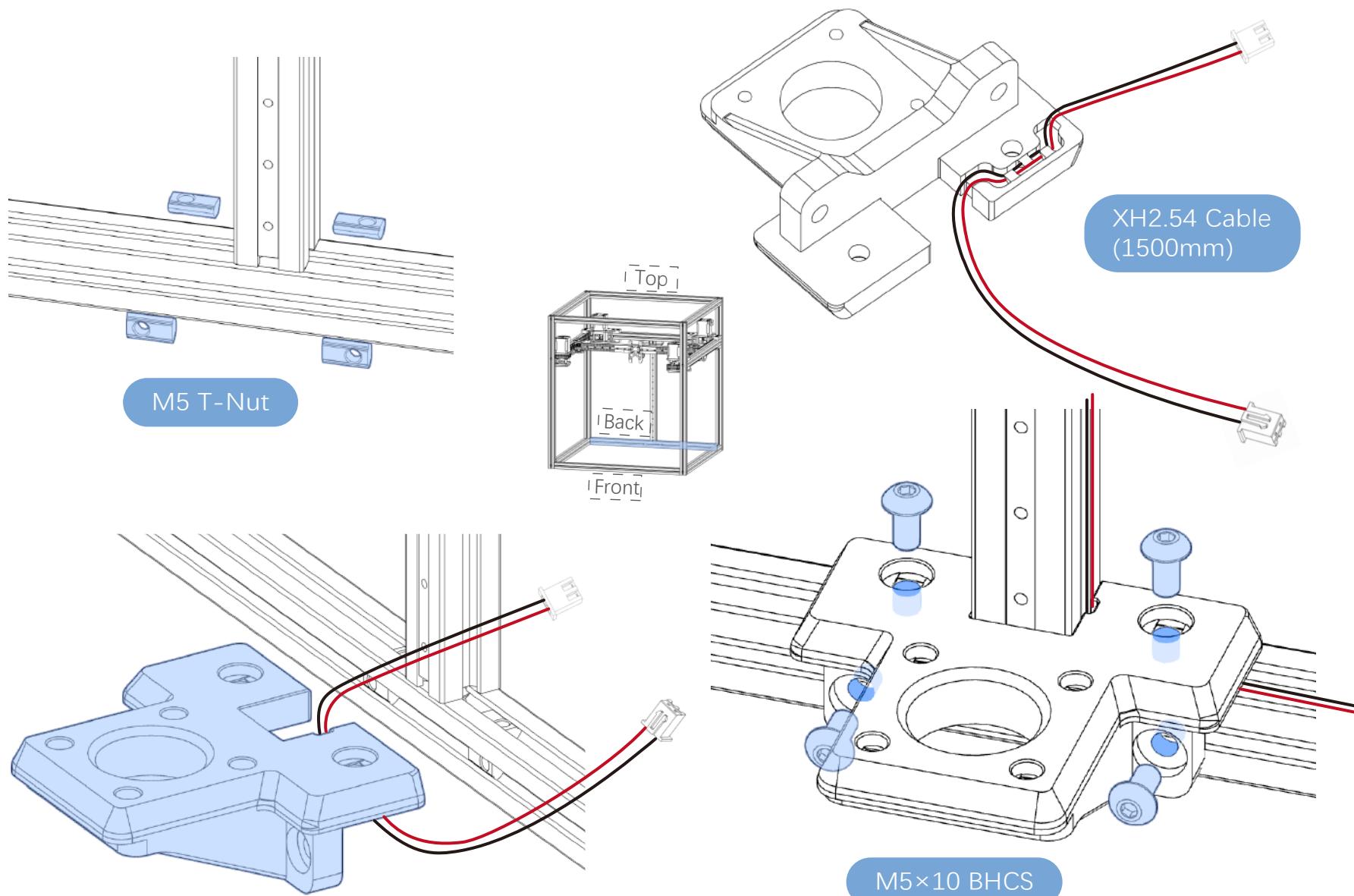
This is the front idler bracket for the 2WD system.  
These parts aren't used when building AWD motion system

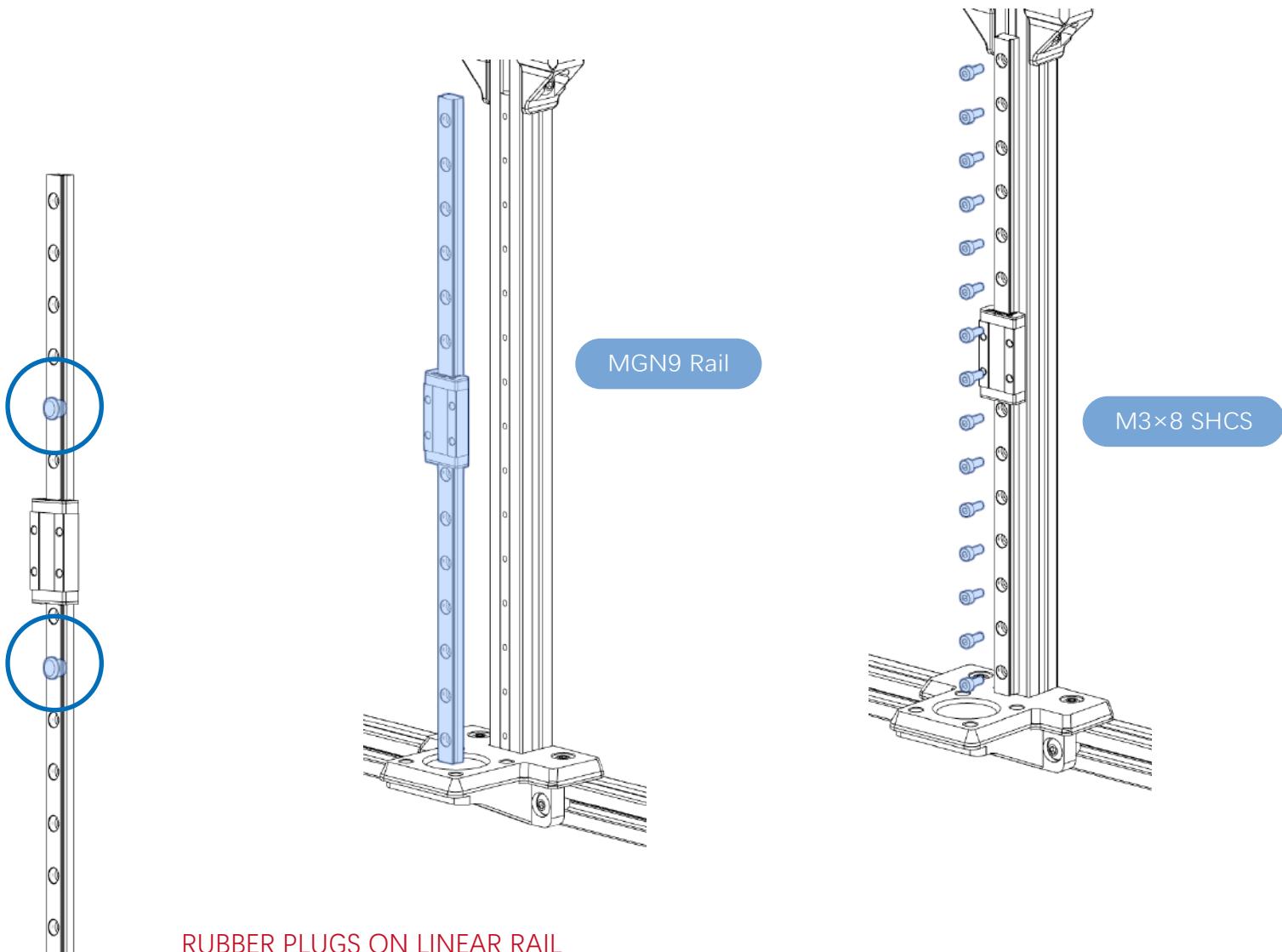
#### TAKE A BREAK

Stop and listen to a song, have a cup of coffee.  
Alternatively, organize the remaining parts and  
tidy up your workspace. Then start fresh.



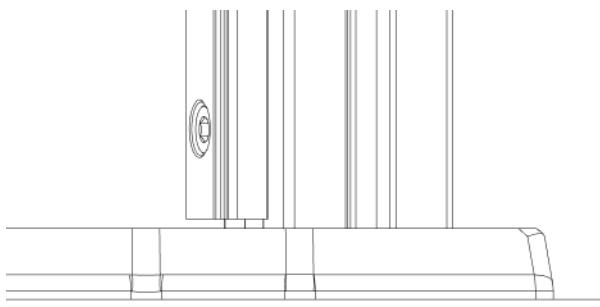
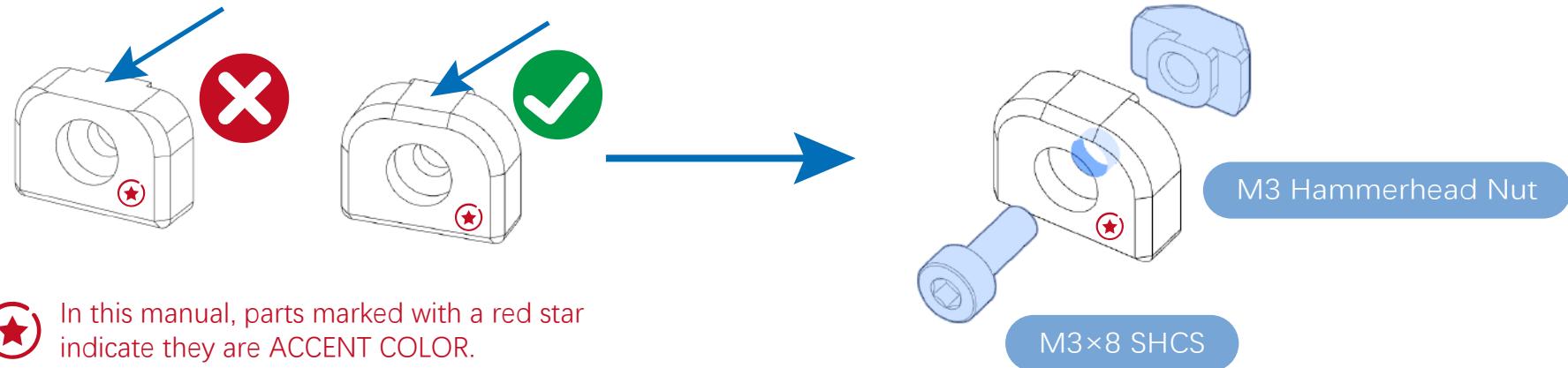






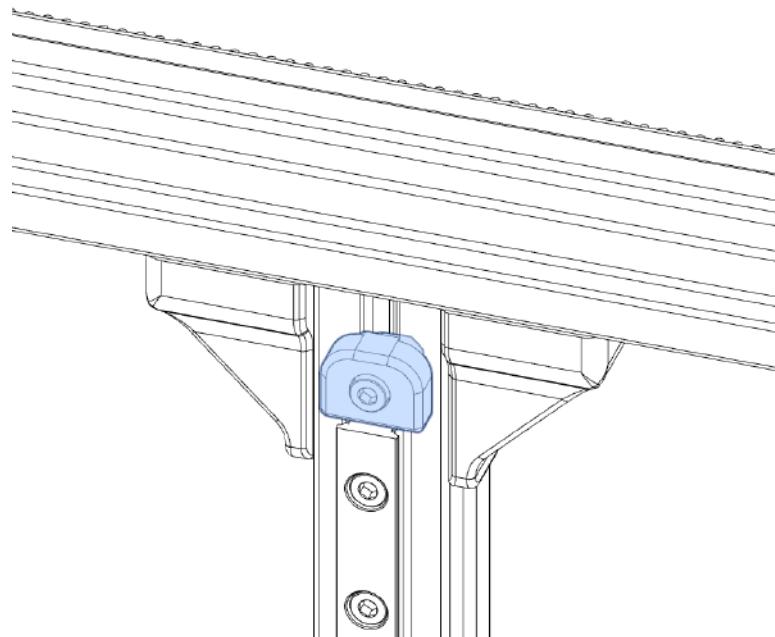
#### RUBBER PLUGS ON LINEAR RAIL

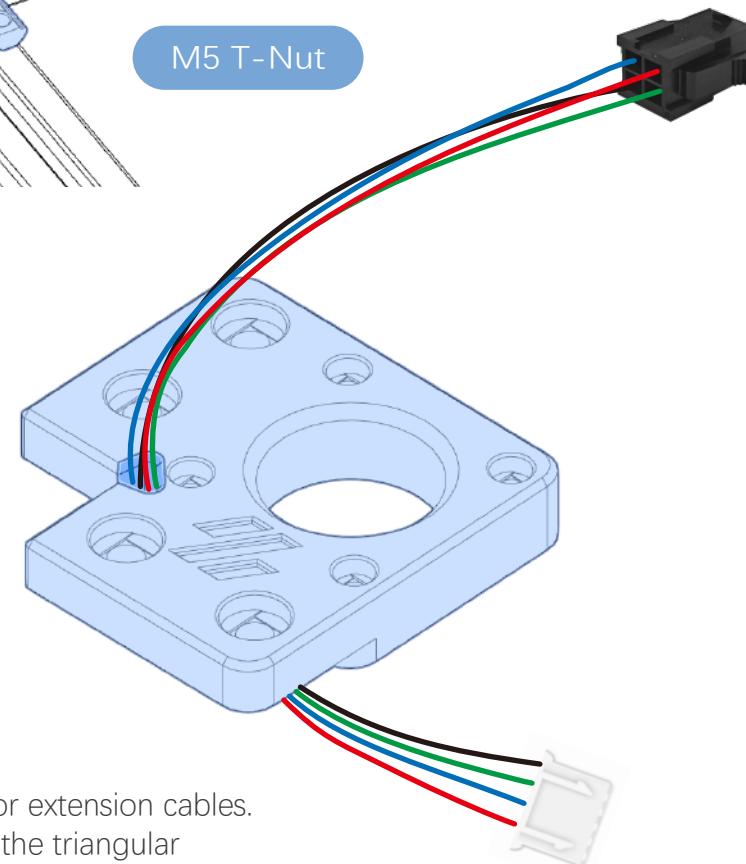
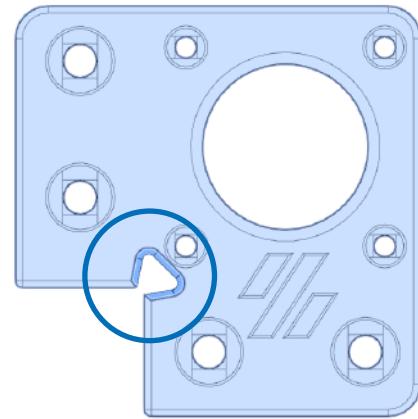
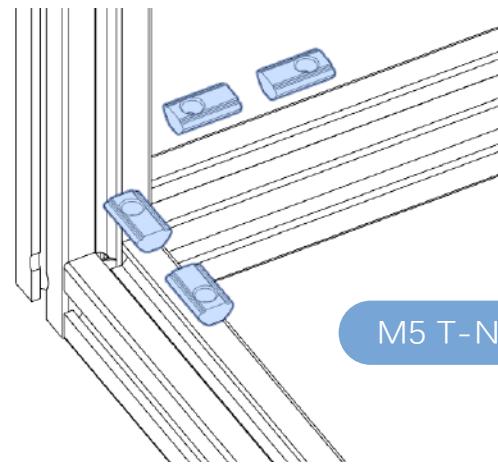
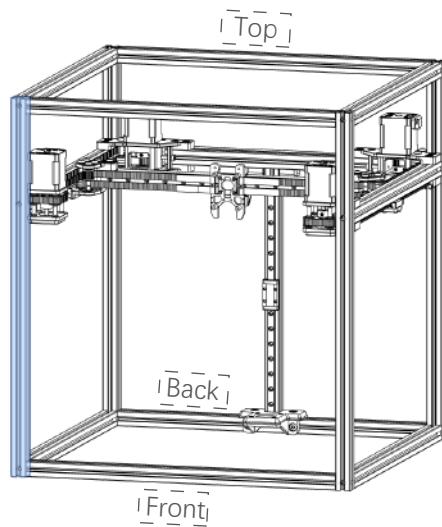
You may notice rubber plugs on both carriage of the slider.  
These effectively prevent the carriage from accidentally dislodging,  
so do not attempt to remove them before installing the screws.



#### BOTTOM GAP

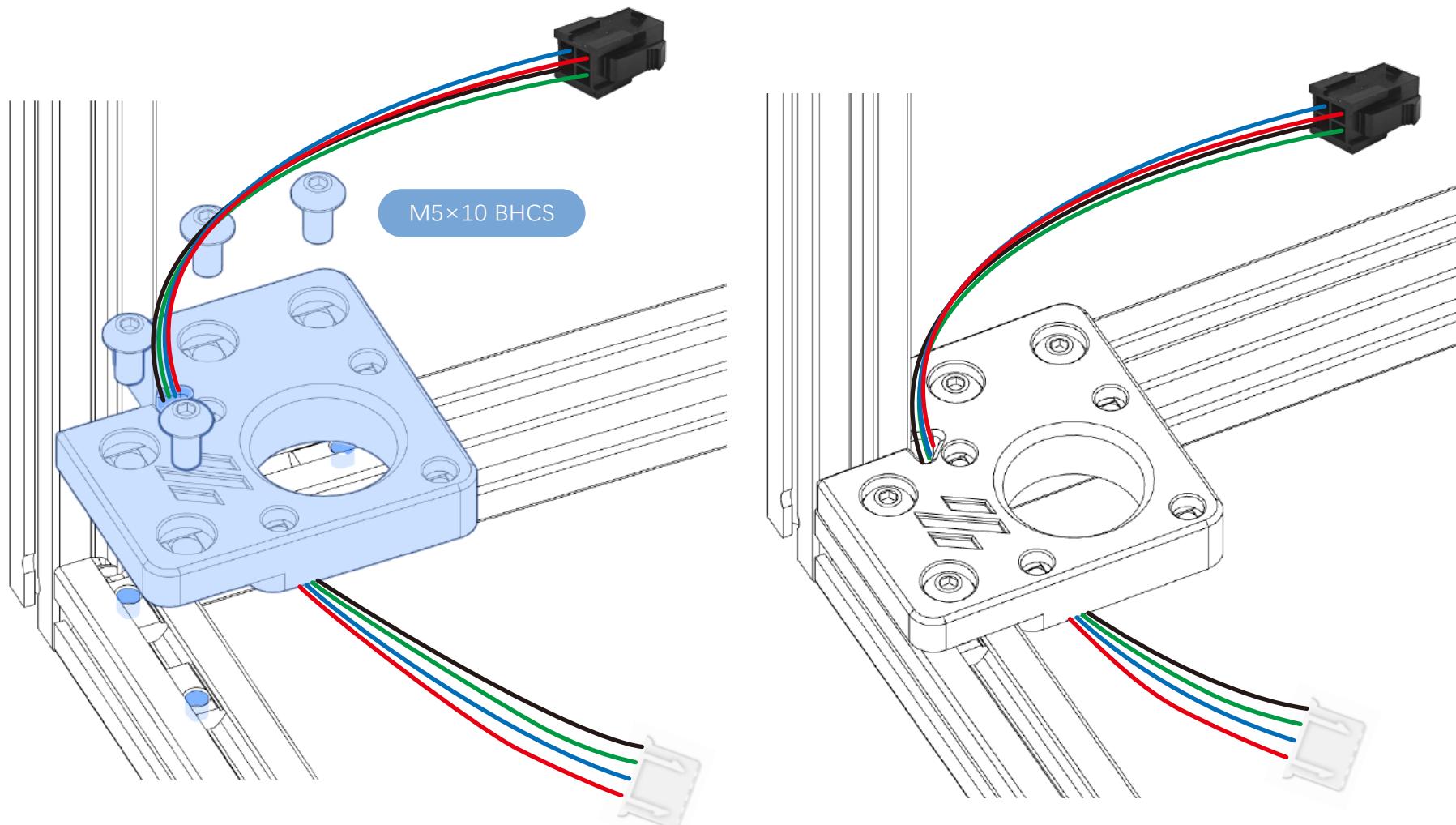
Leave a small gap between the printed part and the rail. 1-2mm is fine.

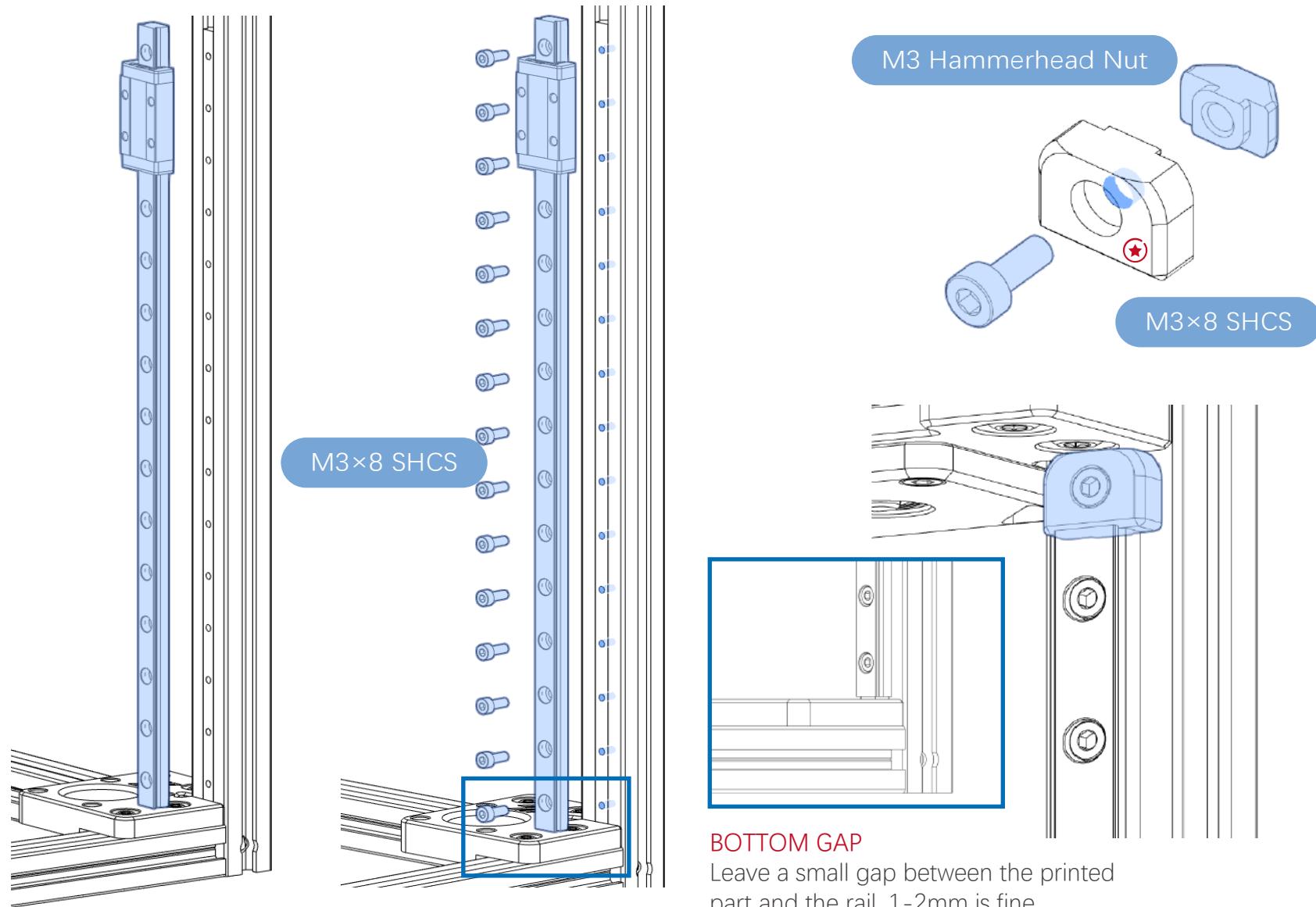


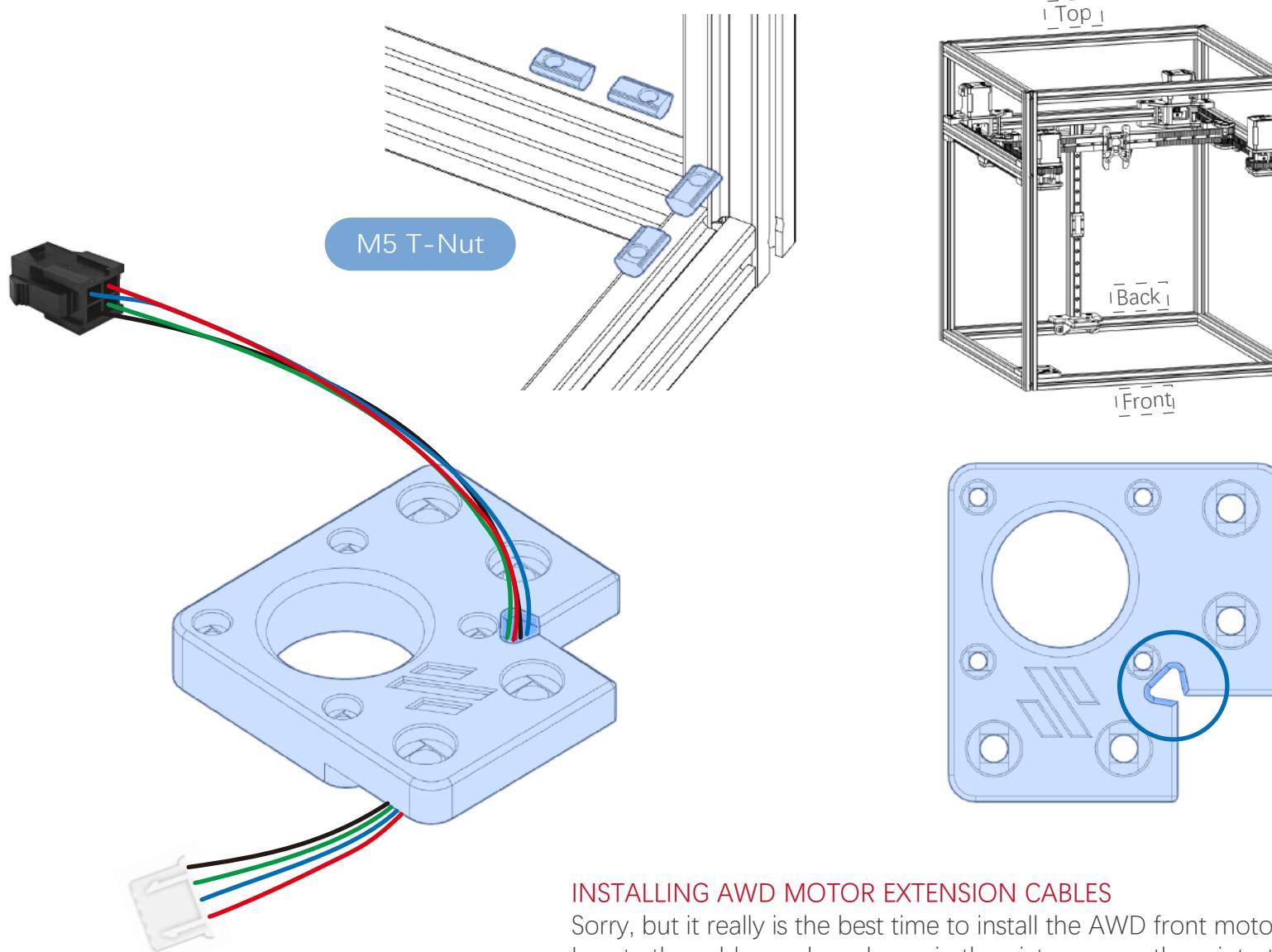


#### INSTALLING AWD MOTOR EXTENSION CABLES

Sorry, but it really is the best time to install the AWD front motor extension cables. Locate the cables and, as shown in the picture, snap them into the triangular notch in the motor mount.

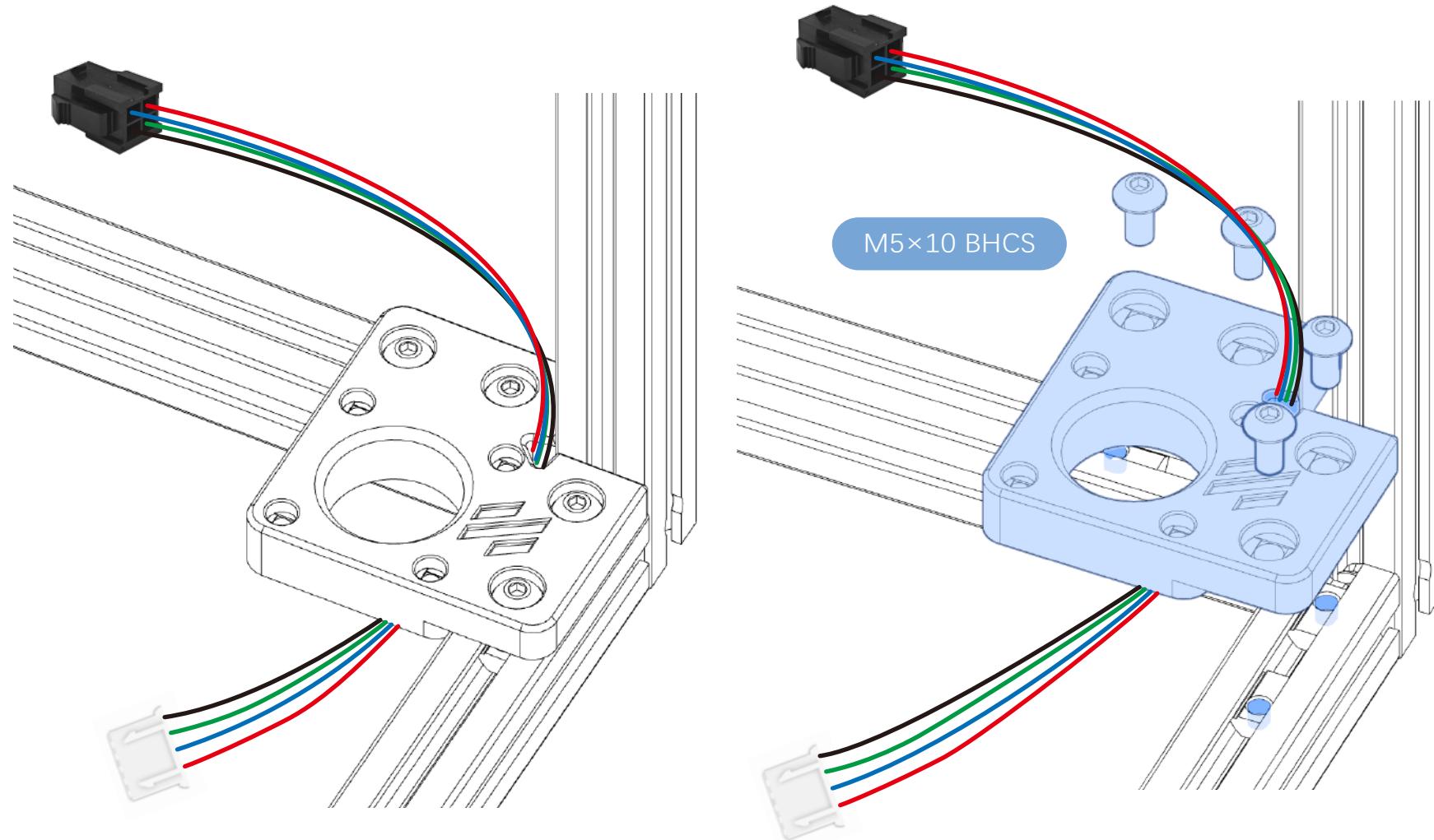


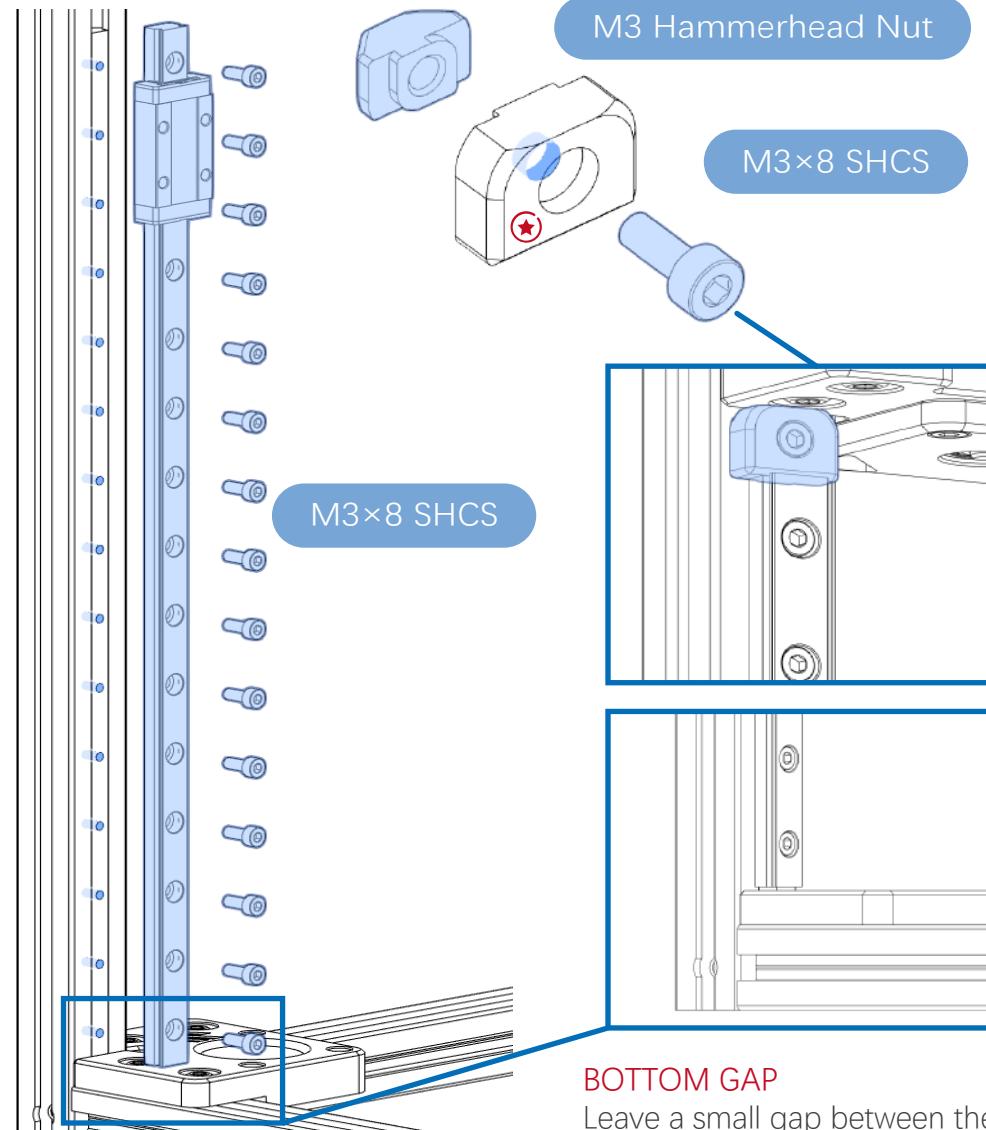
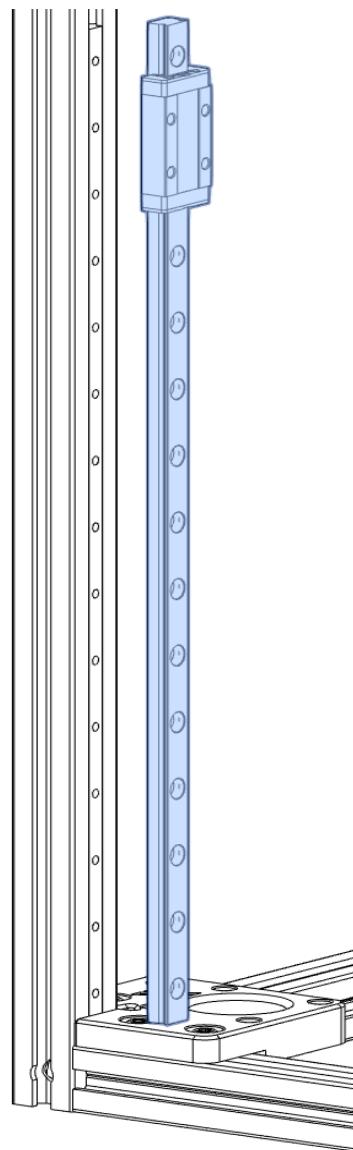




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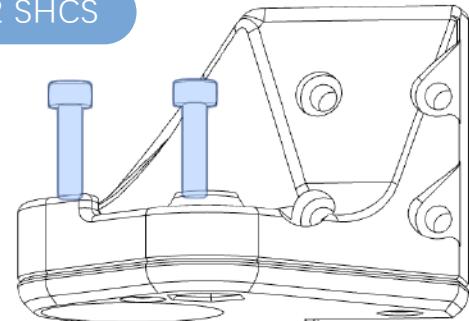
**BOTTOM GAP**

Leave a small gap between the printed part and the rail. 1-2mm is fine.

DON'T FULLY TIGHTEN

For best results do not tighten fully.

M3×12 SHCS



lead screw Nut

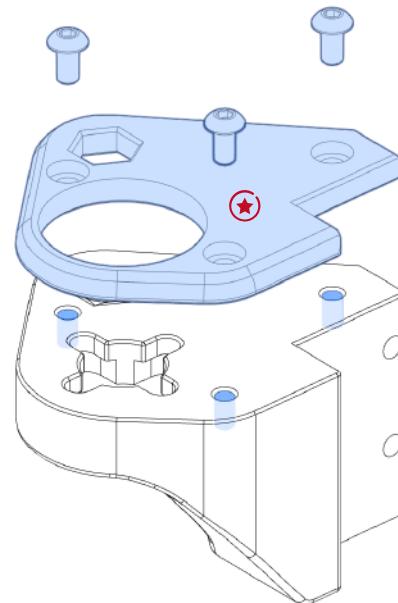


M3 Lock Nut

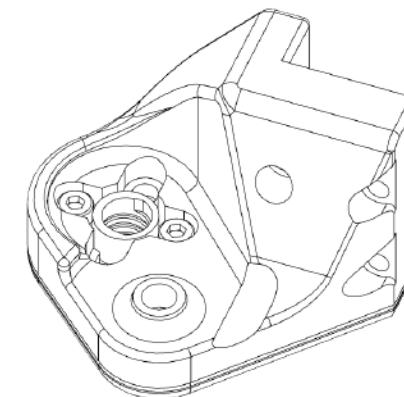
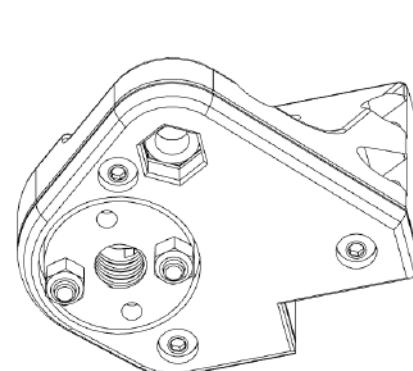


LEAD SCREW NUT?

Where is the lead screw nut? It is installed on the lead screw motor and can be removed by unscrewing it from the lead screw.

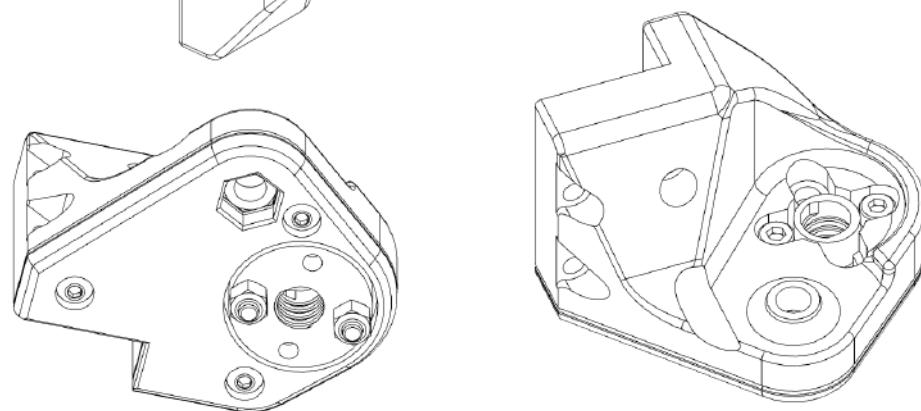
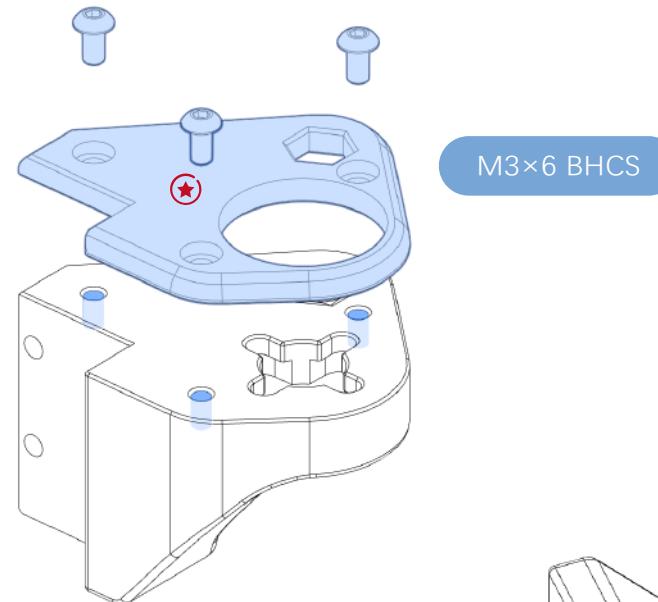
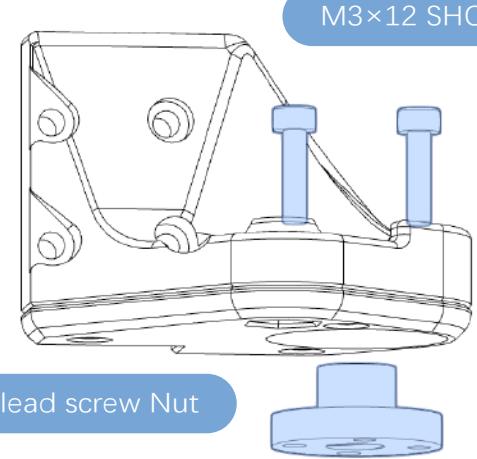


M3×6 BHCS



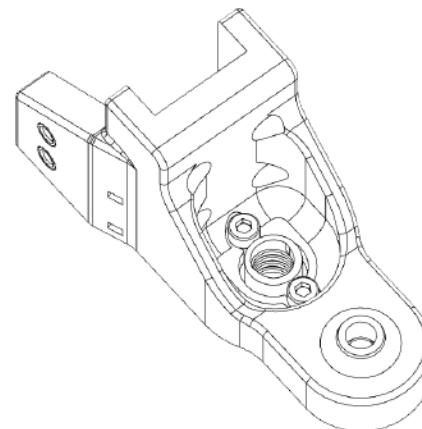
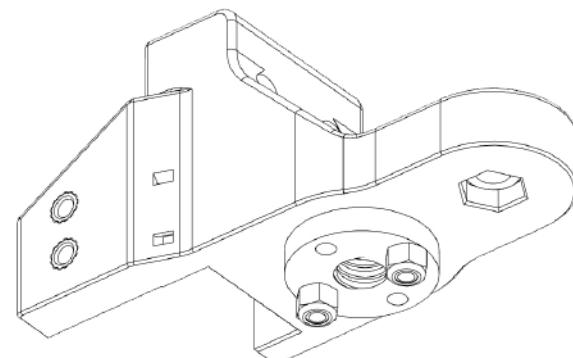
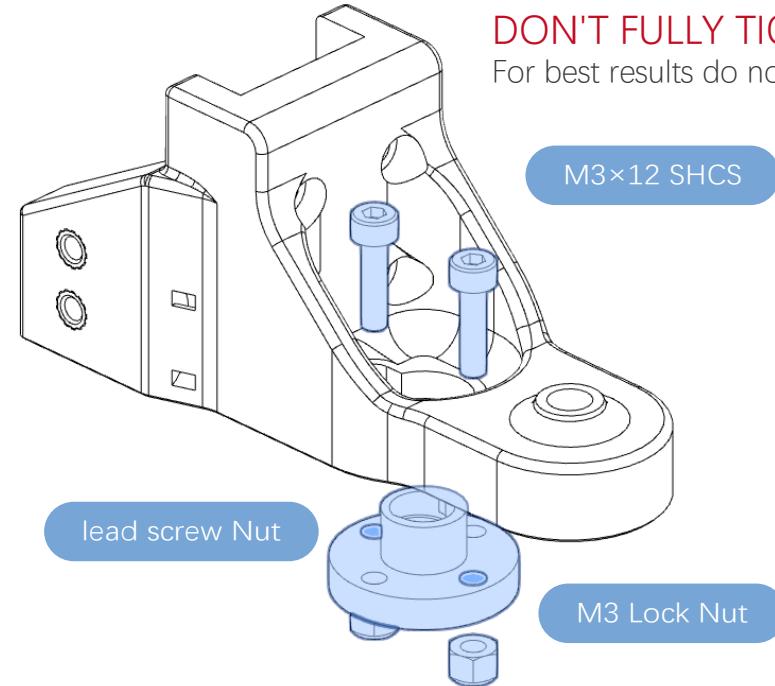
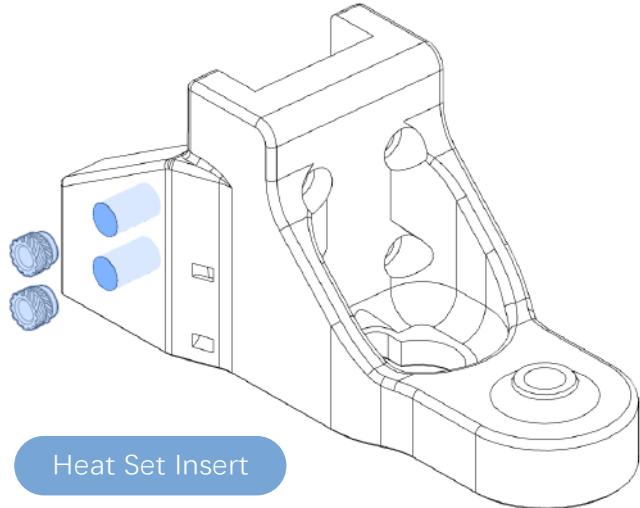
## DON'T FULLY TIGHTEN

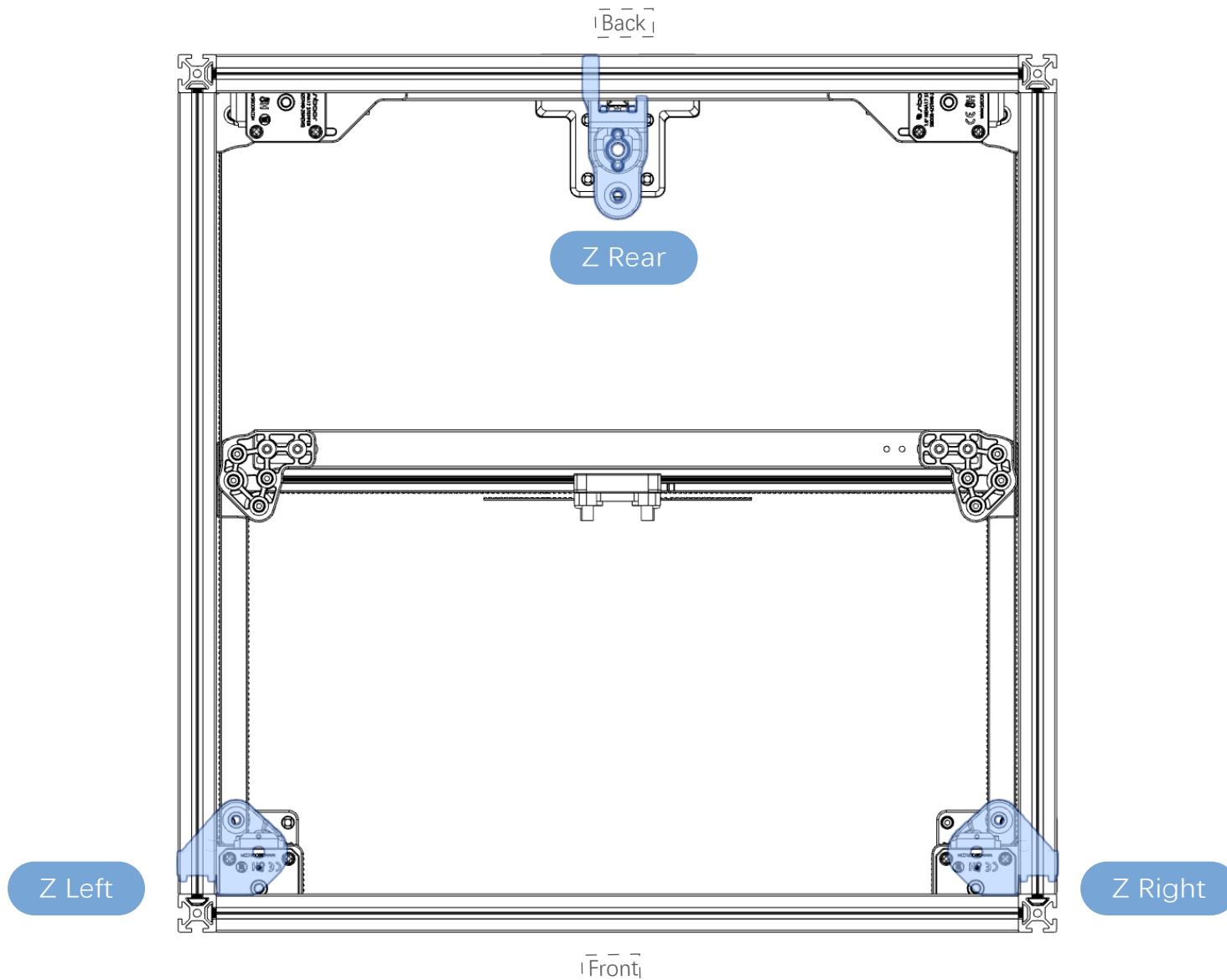
For best results do not tighten fully.

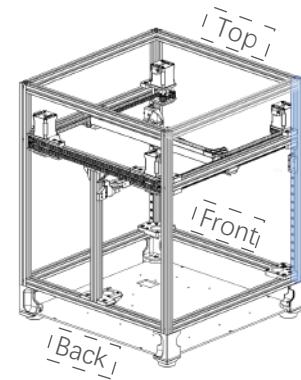
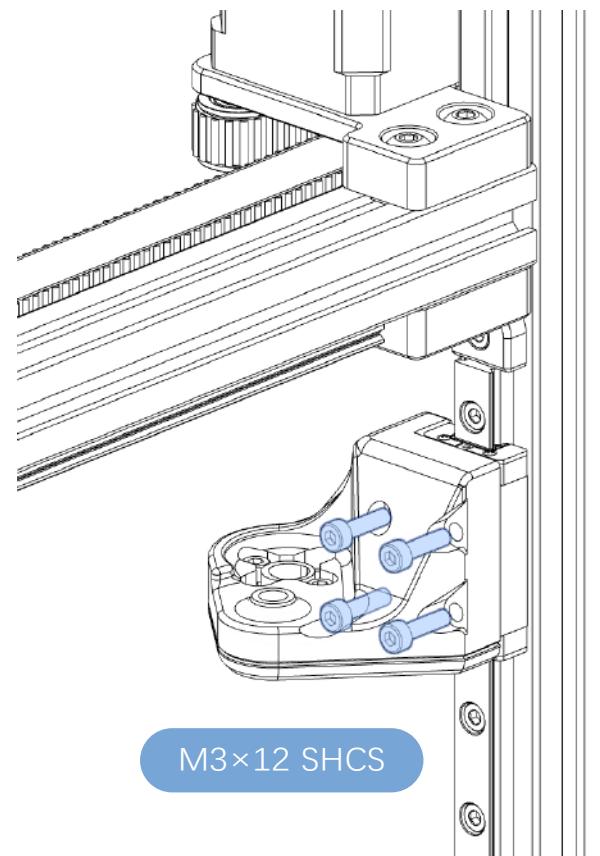
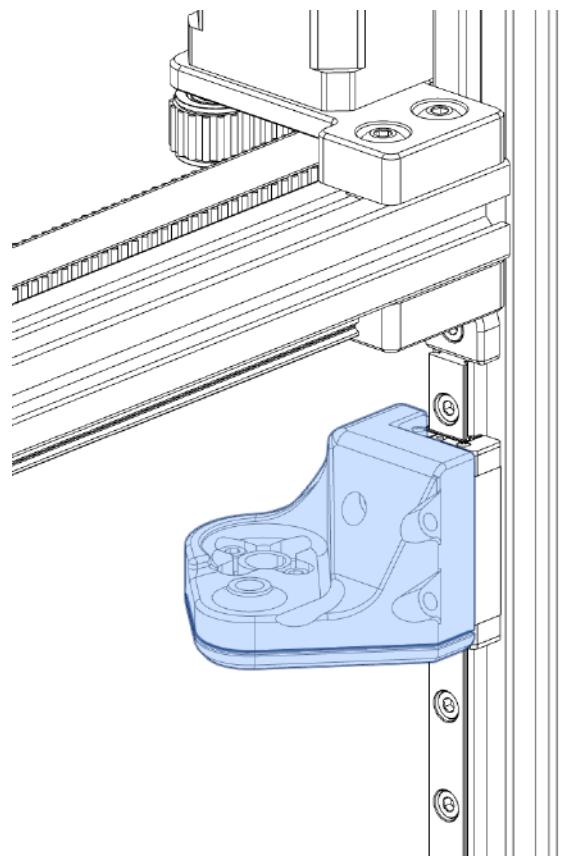


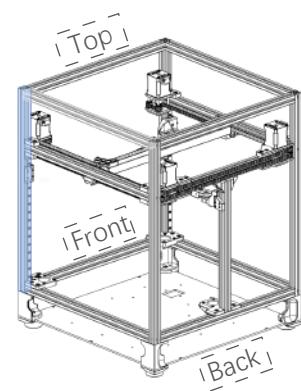
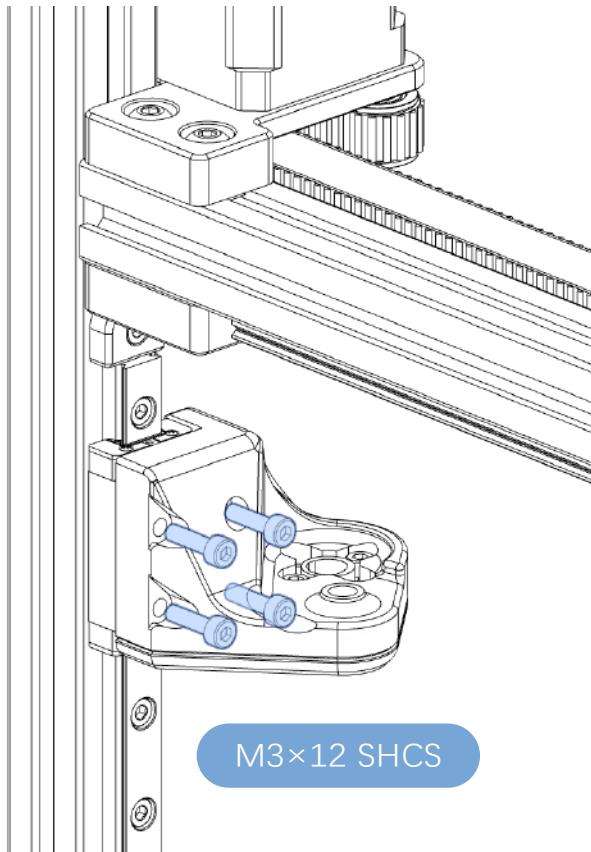
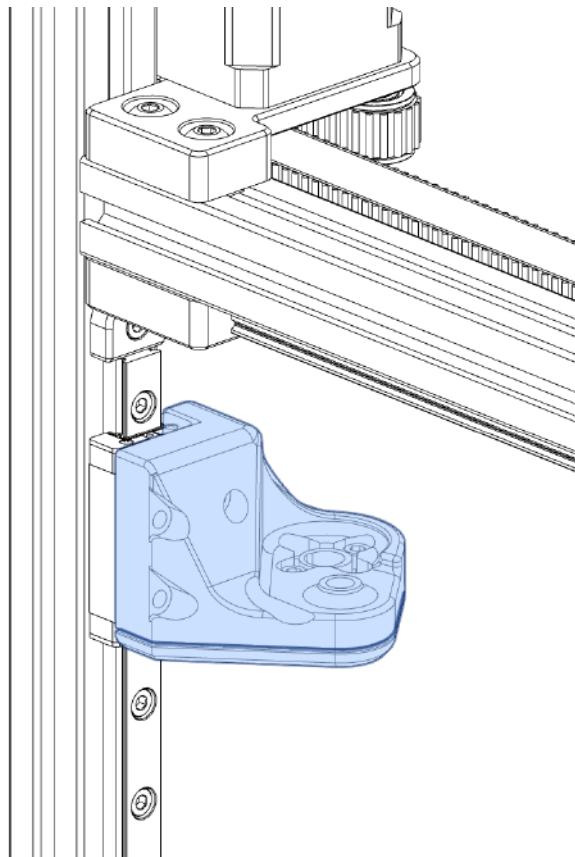
## LEAD SCREW NUT?

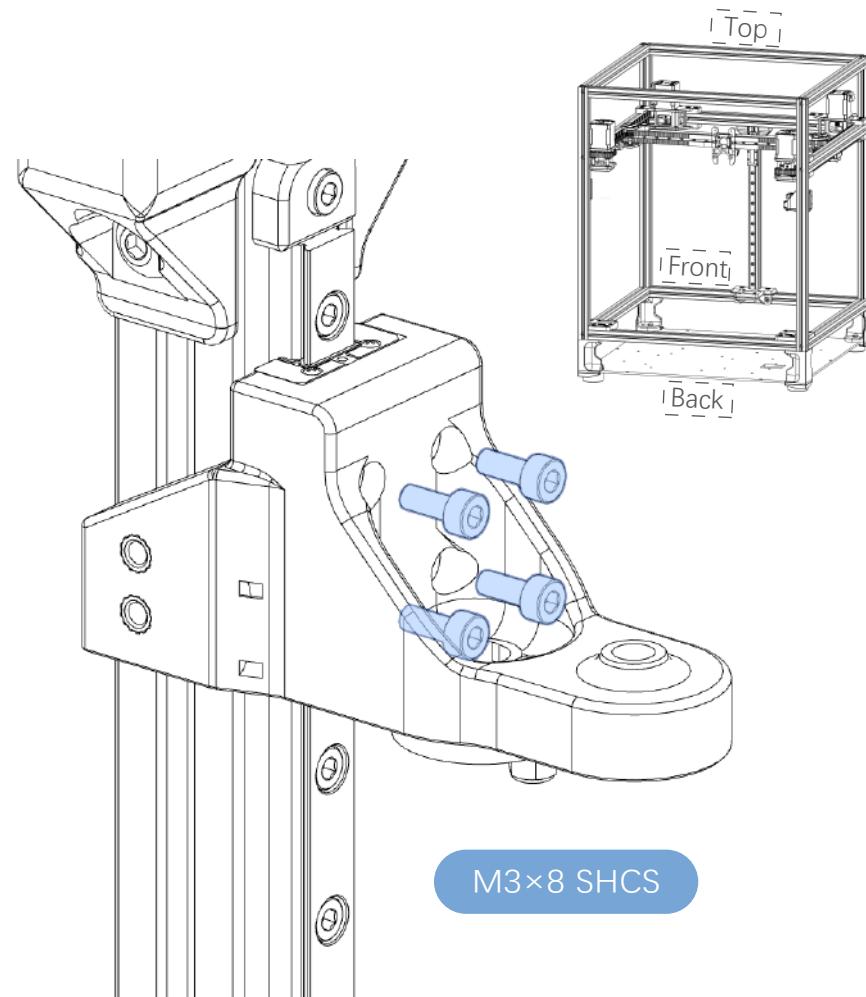
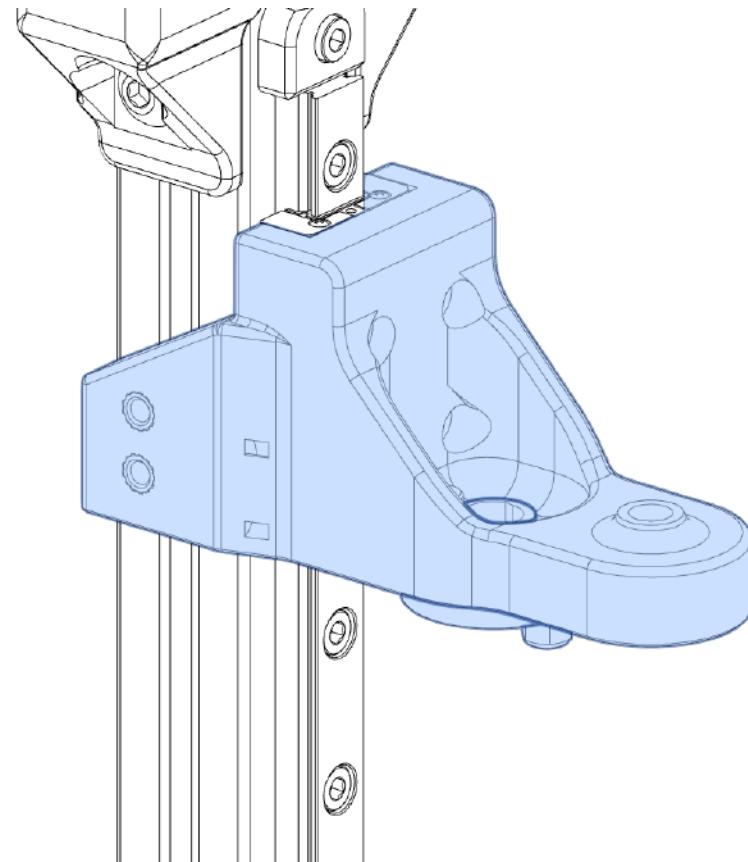
Where is the lead screw nut? It is installed on the lead screw motor and can be removed by unscrewing it from the lead screw.

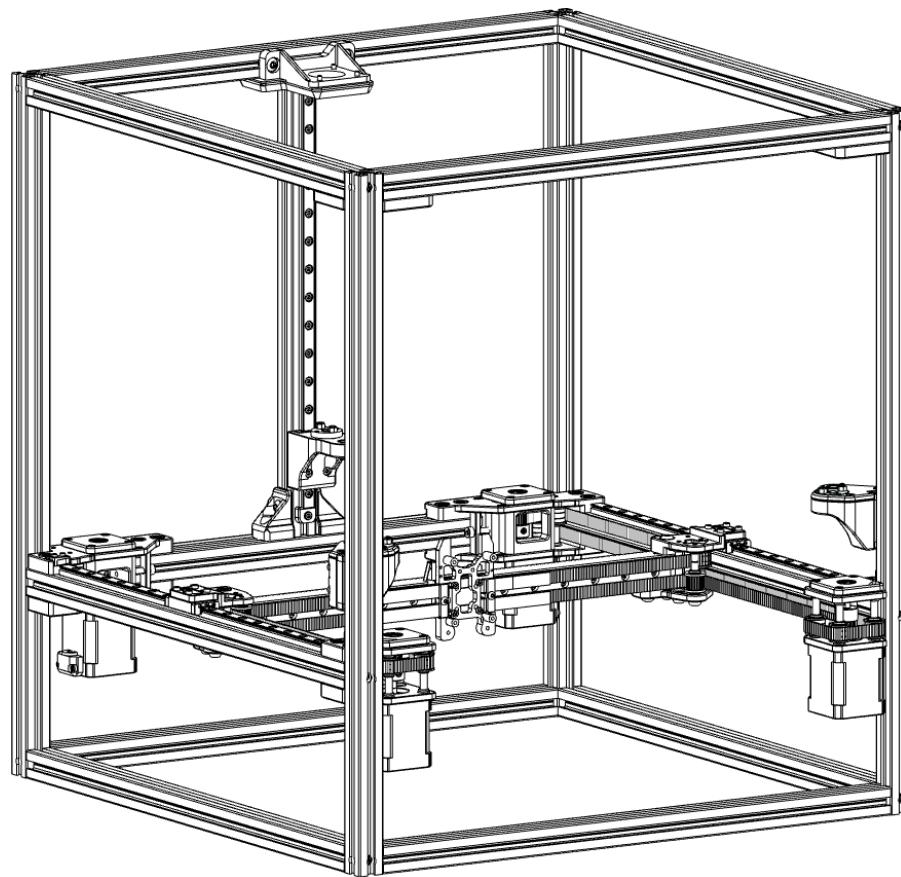




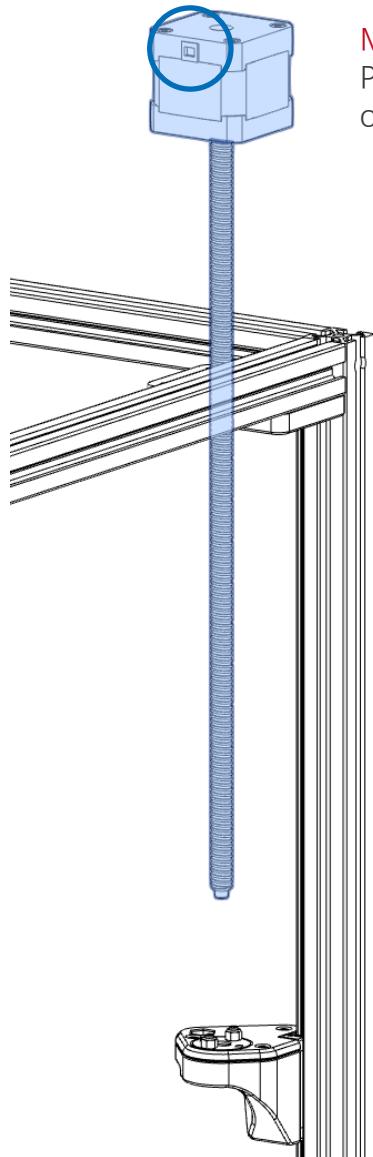






**FLIP UPSIDE DOWN**

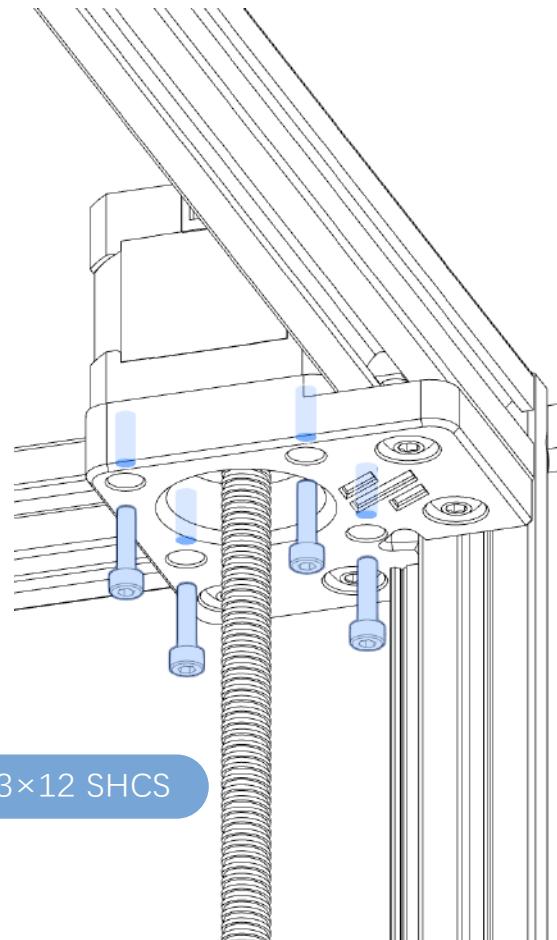
Turn the printer upside down for the next assembly steps.

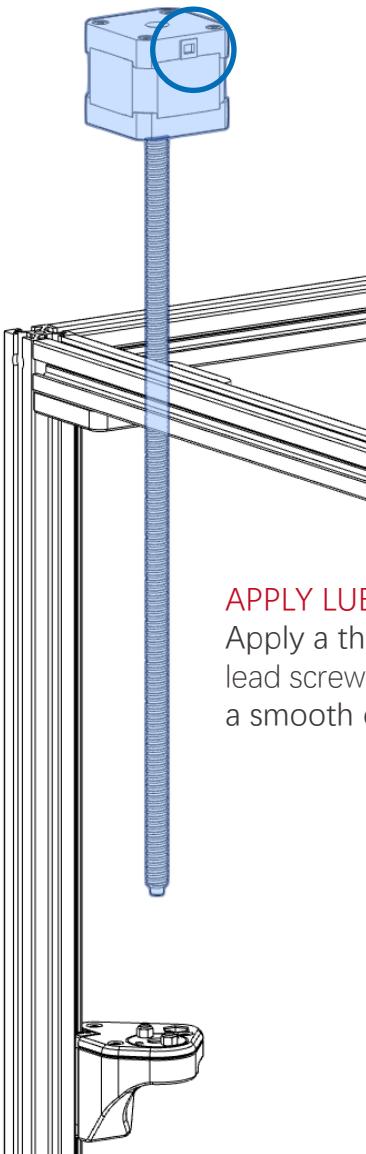
**MOTOR ORIENTATION**

Pay attention to the orientation of the cable exit.

**APPLY LUBRICATION**

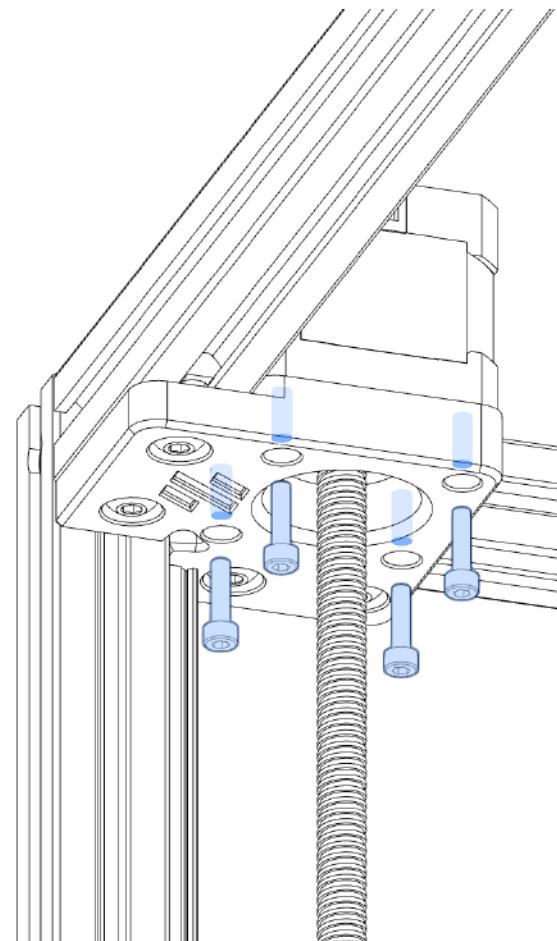
Apply a thin layer of grease to the lead screw to prevent rust and ensure a smooth operation.





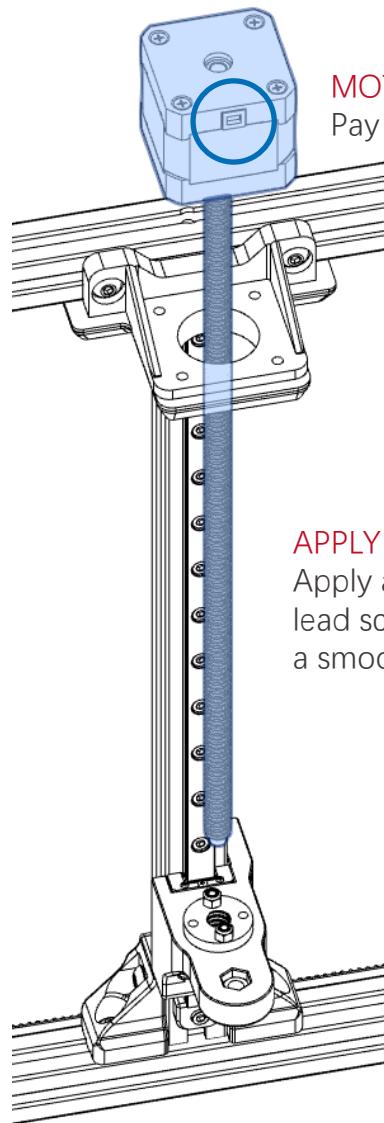
#### MOTOR ORIENTATION

Pay attention to the orientation of the cable exit.



#### APPLY LUBRICATION

Apply a thin layer of grease to the lead screw to prevent rust and ensure a smooth operation.

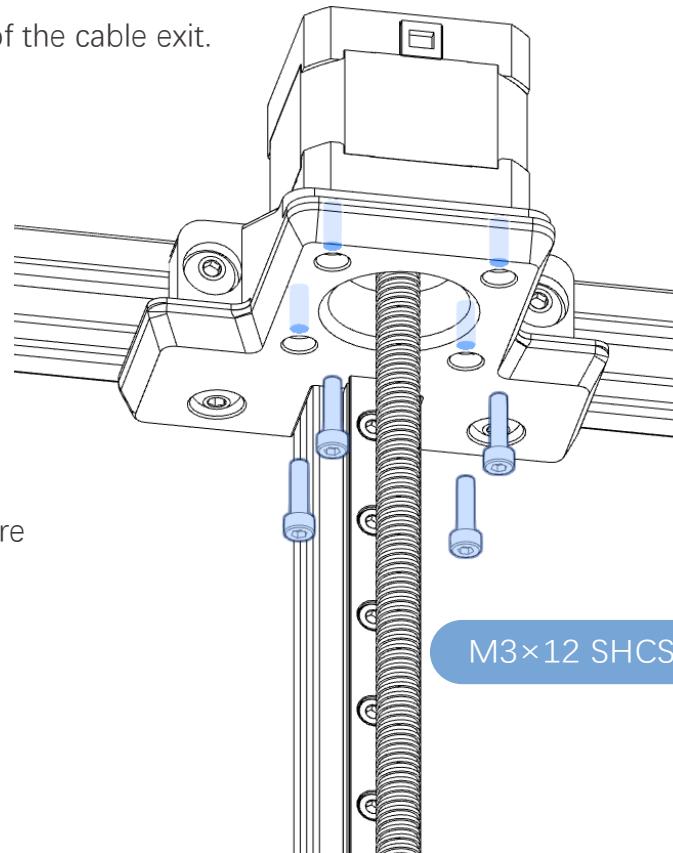


#### MOTOR ORIENTATION

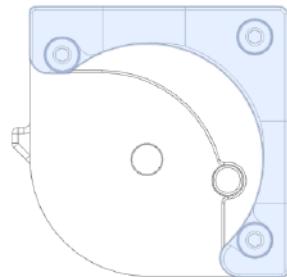
Pay attention to the orientation of the cable exit.

#### APPLY LUBRICATION

Apply a thin layer of grease to the lead screw to prevent rust and ensure a smooth operation.

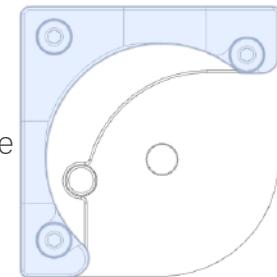
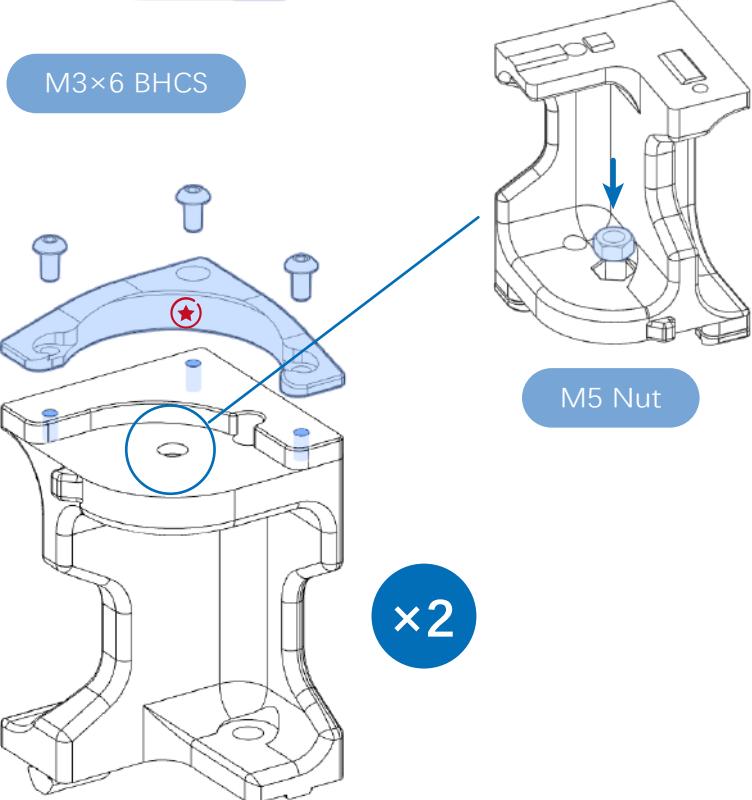


M3×12 SHCS

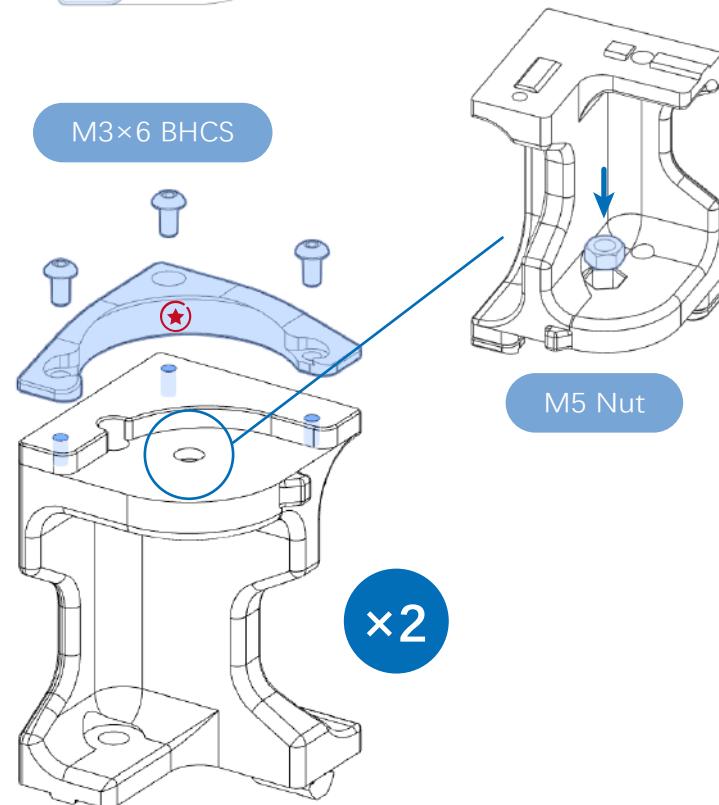


## USE ADHESIVE

Before installing the M5 nut, apply some adhesive (e.g., 502 glue) to the inner walls of the hole to prevent the nut from loosening.

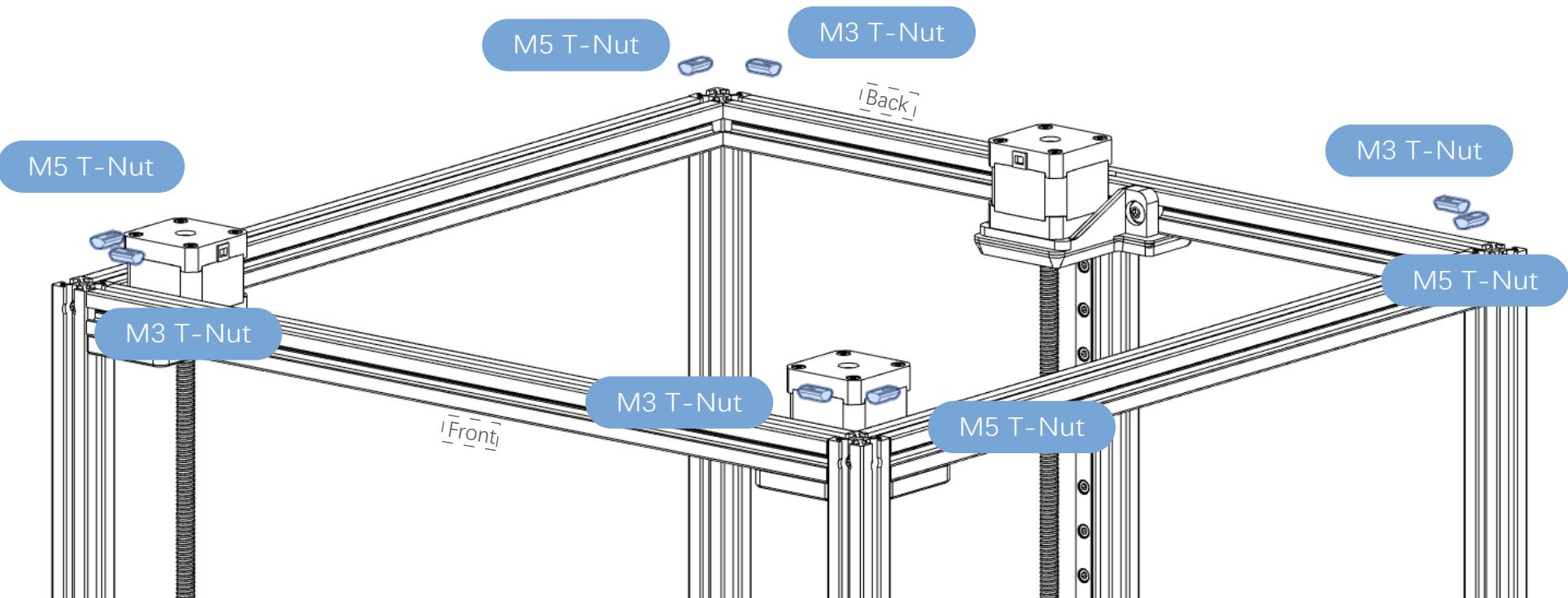


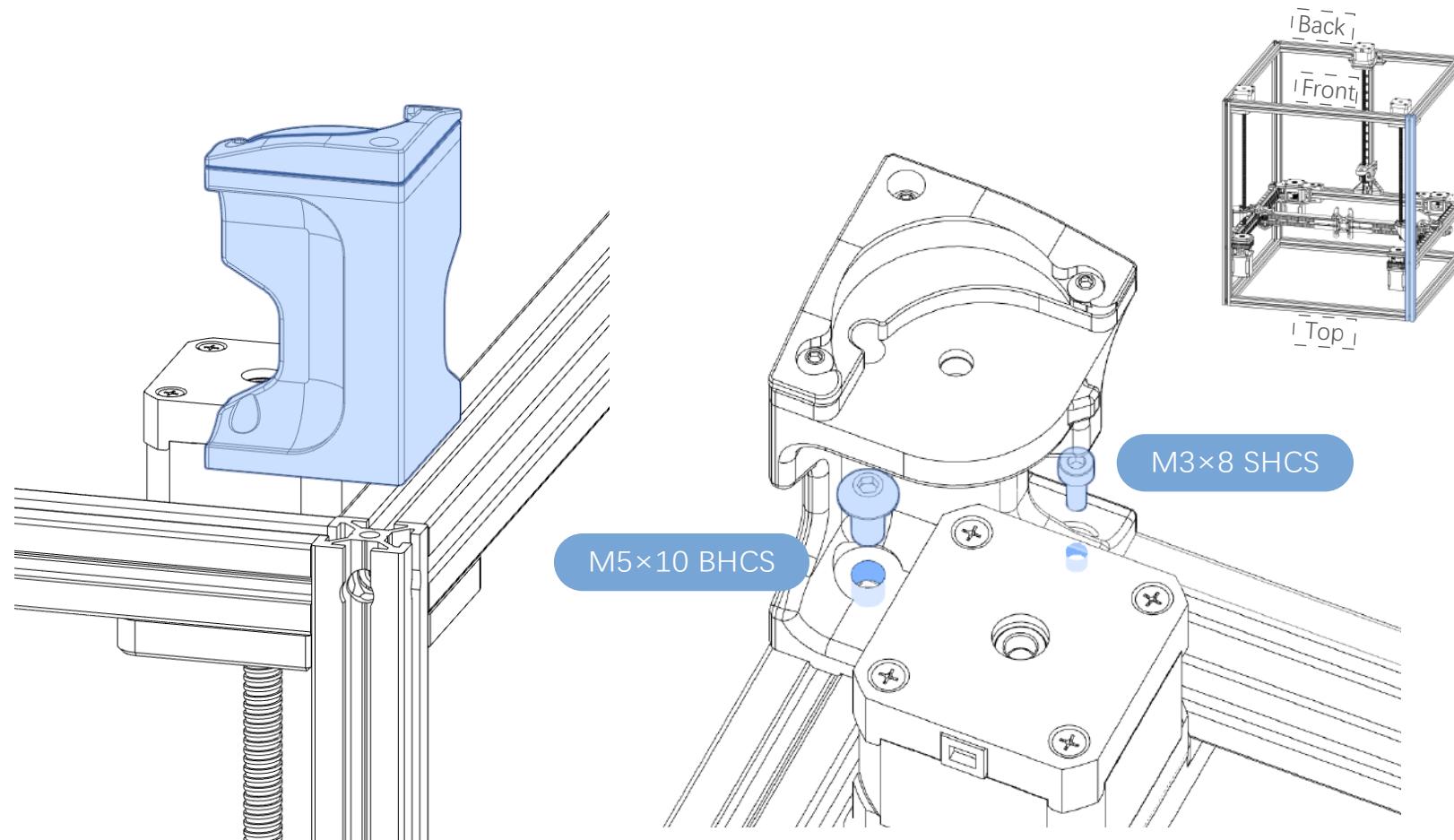
## M3×6 BHCS

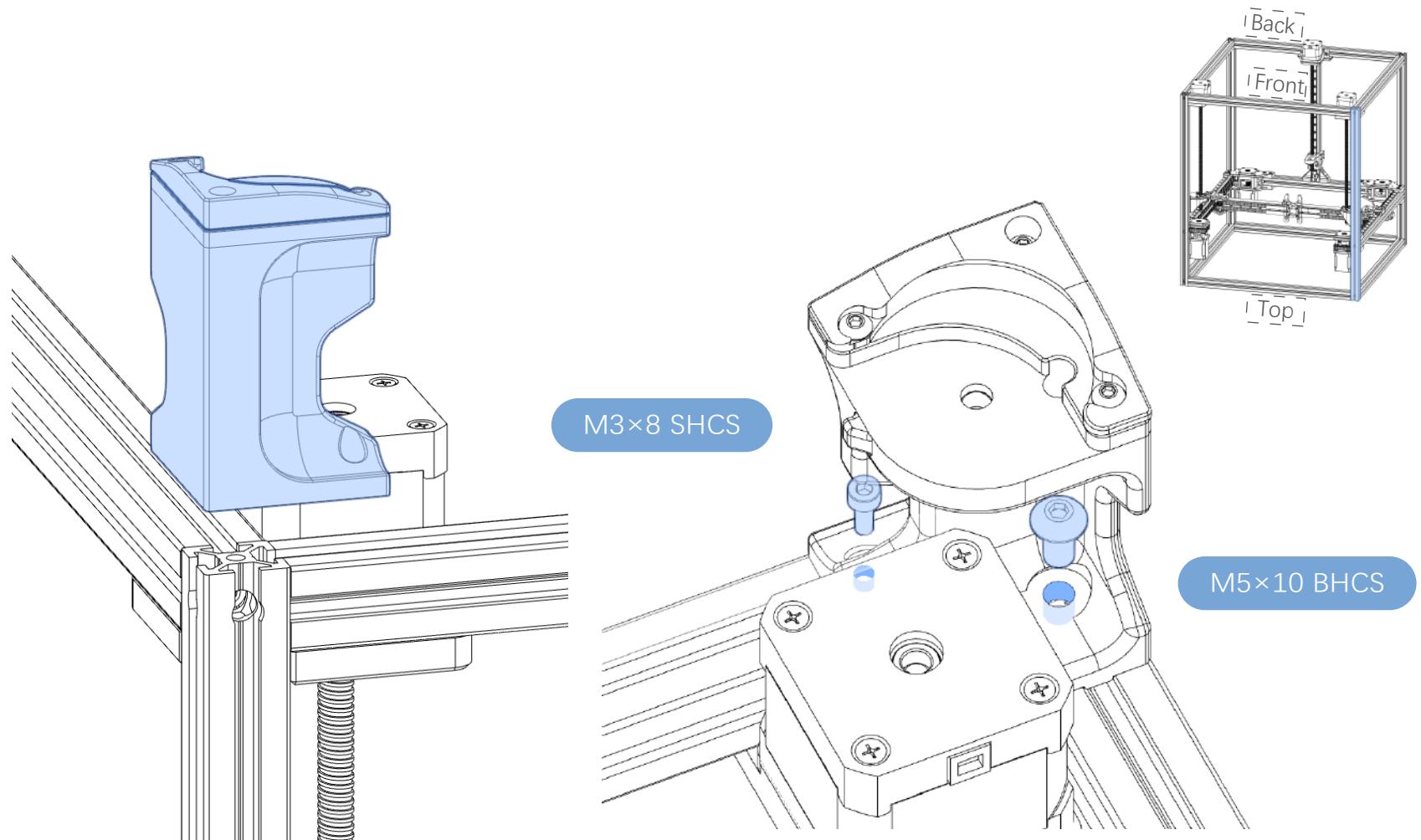


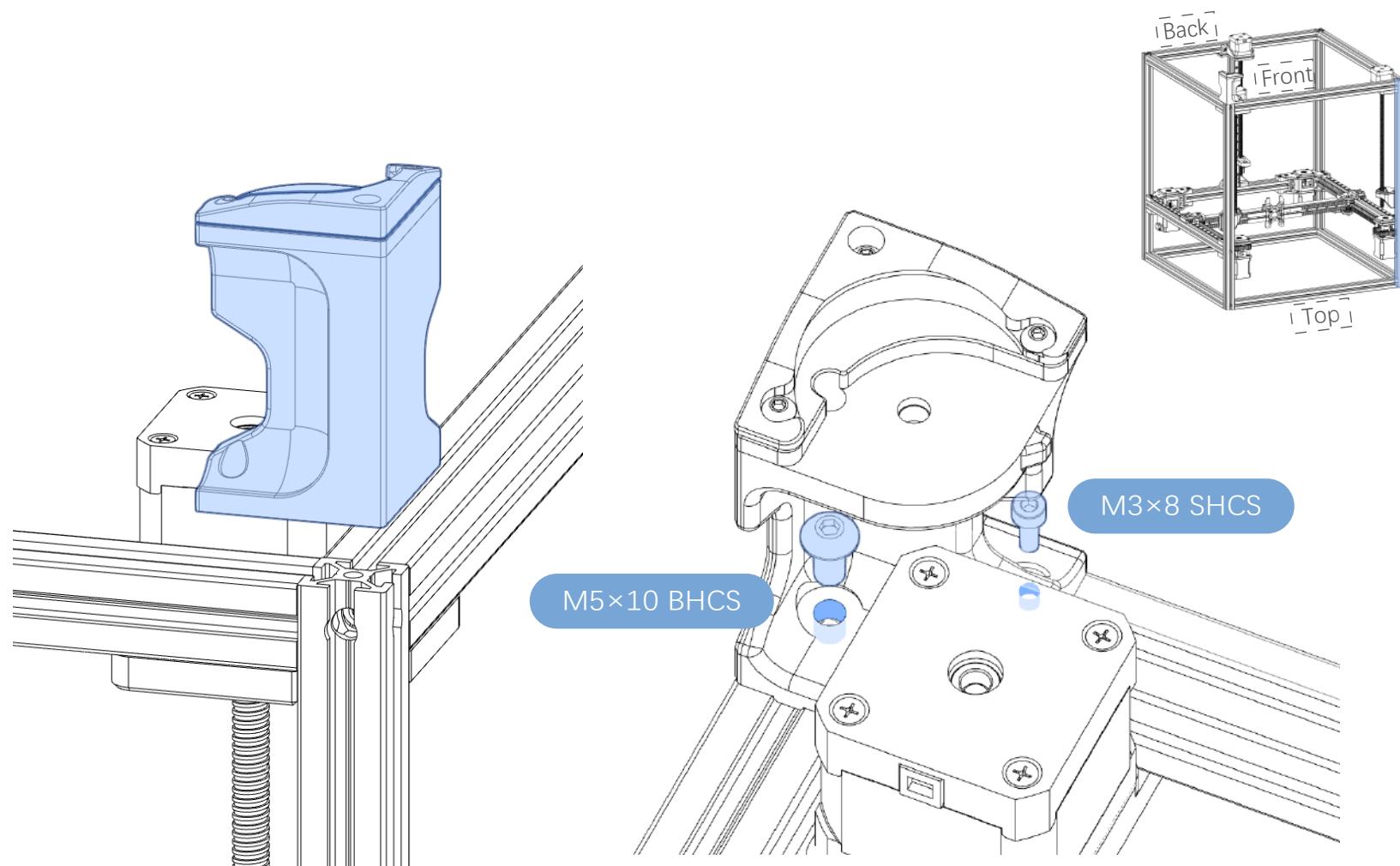
## ASSEMBLE FOUR FEET

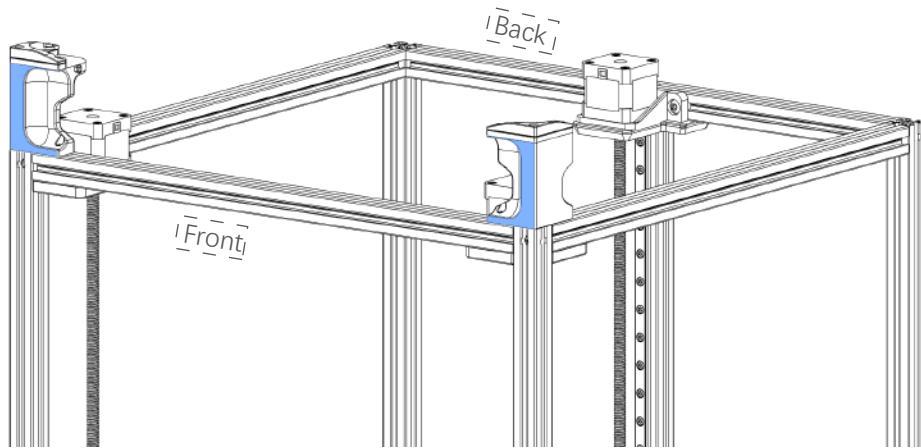
Repeat the instructions and assemble all four feet.





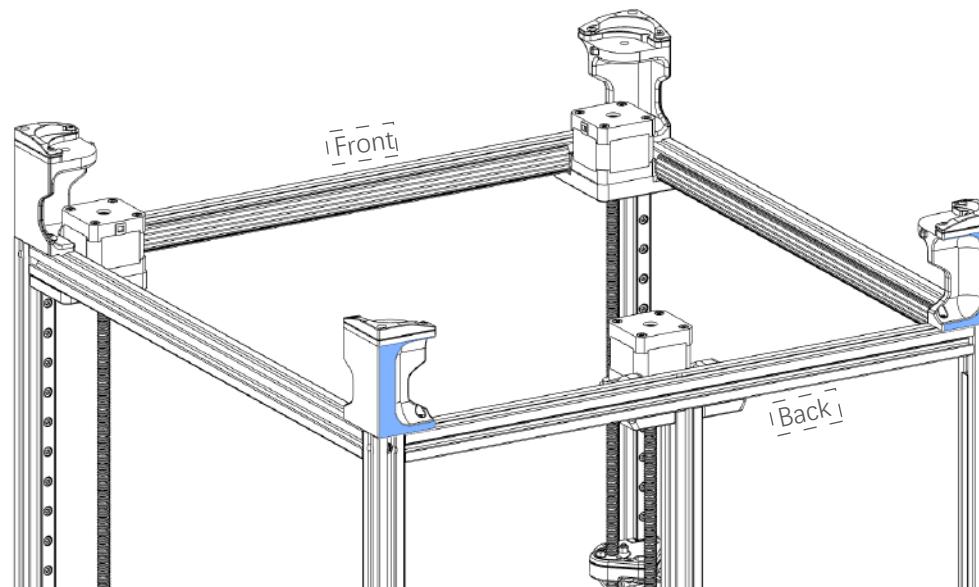






#### MIND THE PART ORIENTATION

The faces highlighted above are towards the front and rear of the printer

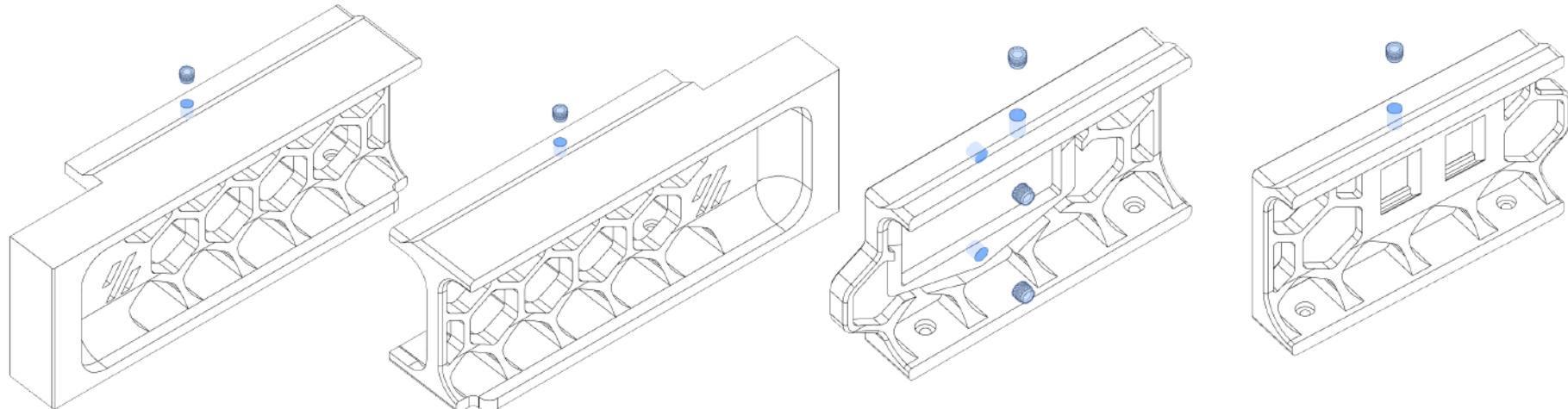


#### MIND THE PART ORIENTATION

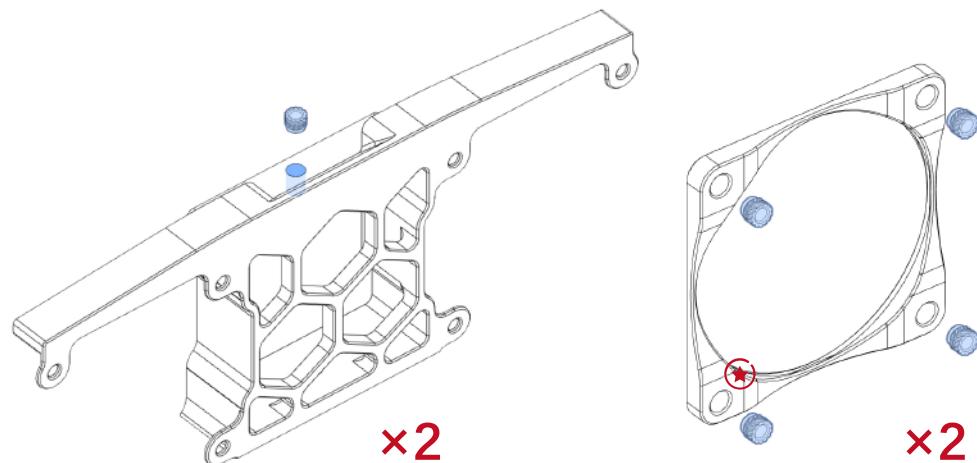
The faces highlighted above are towards the front and rear of the printer



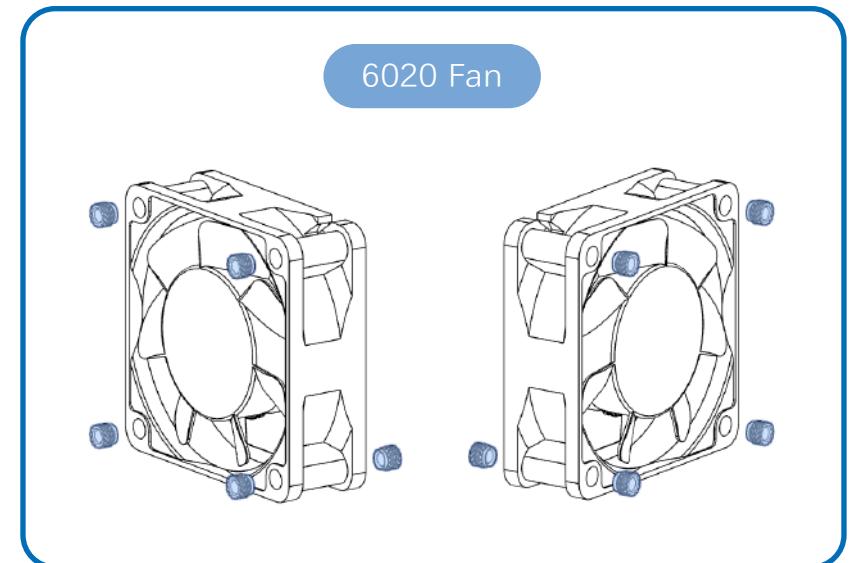
Report, Commander,  
we have discovered a batch of ABS printed parts that require heat set inserts...

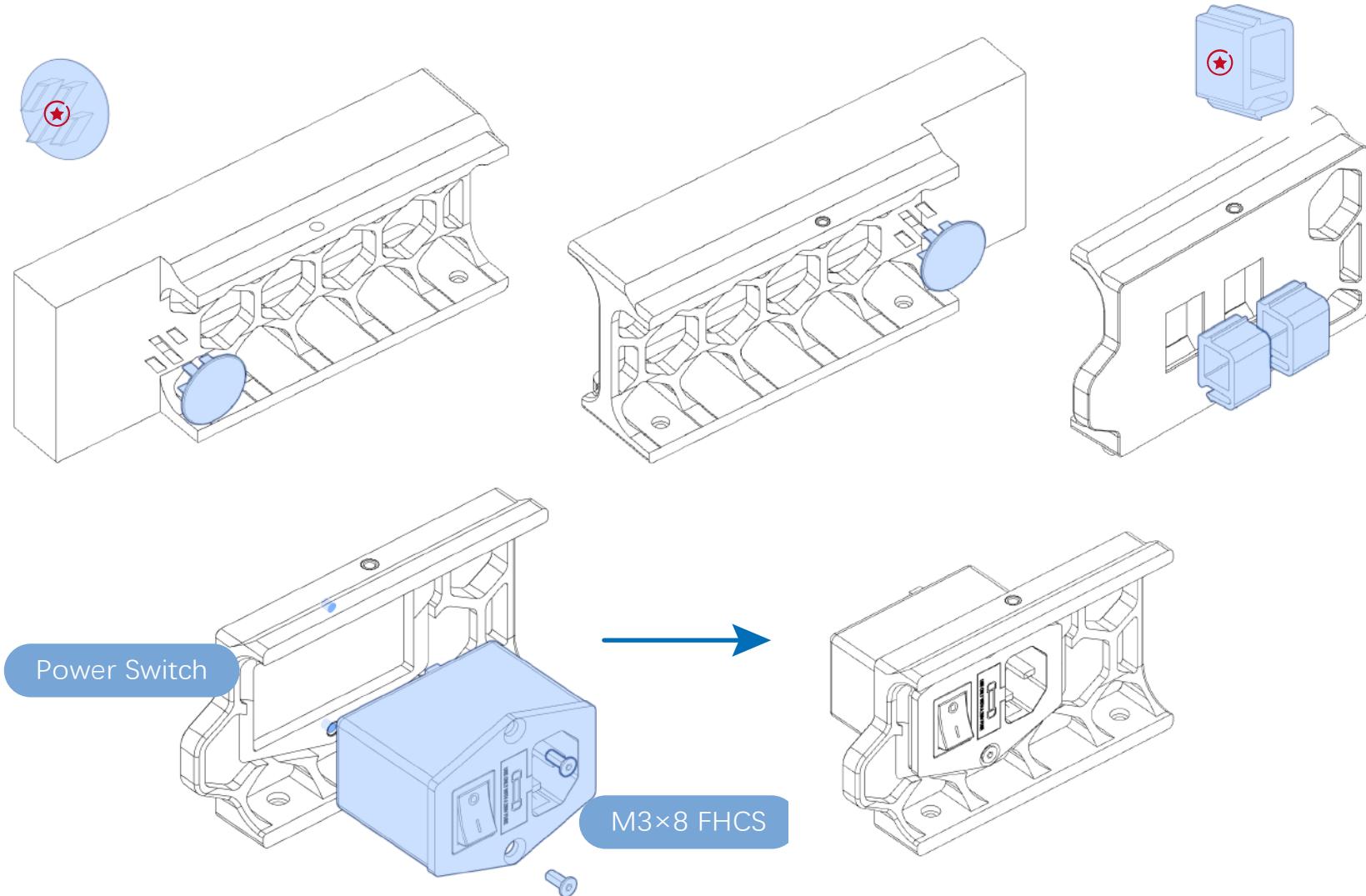


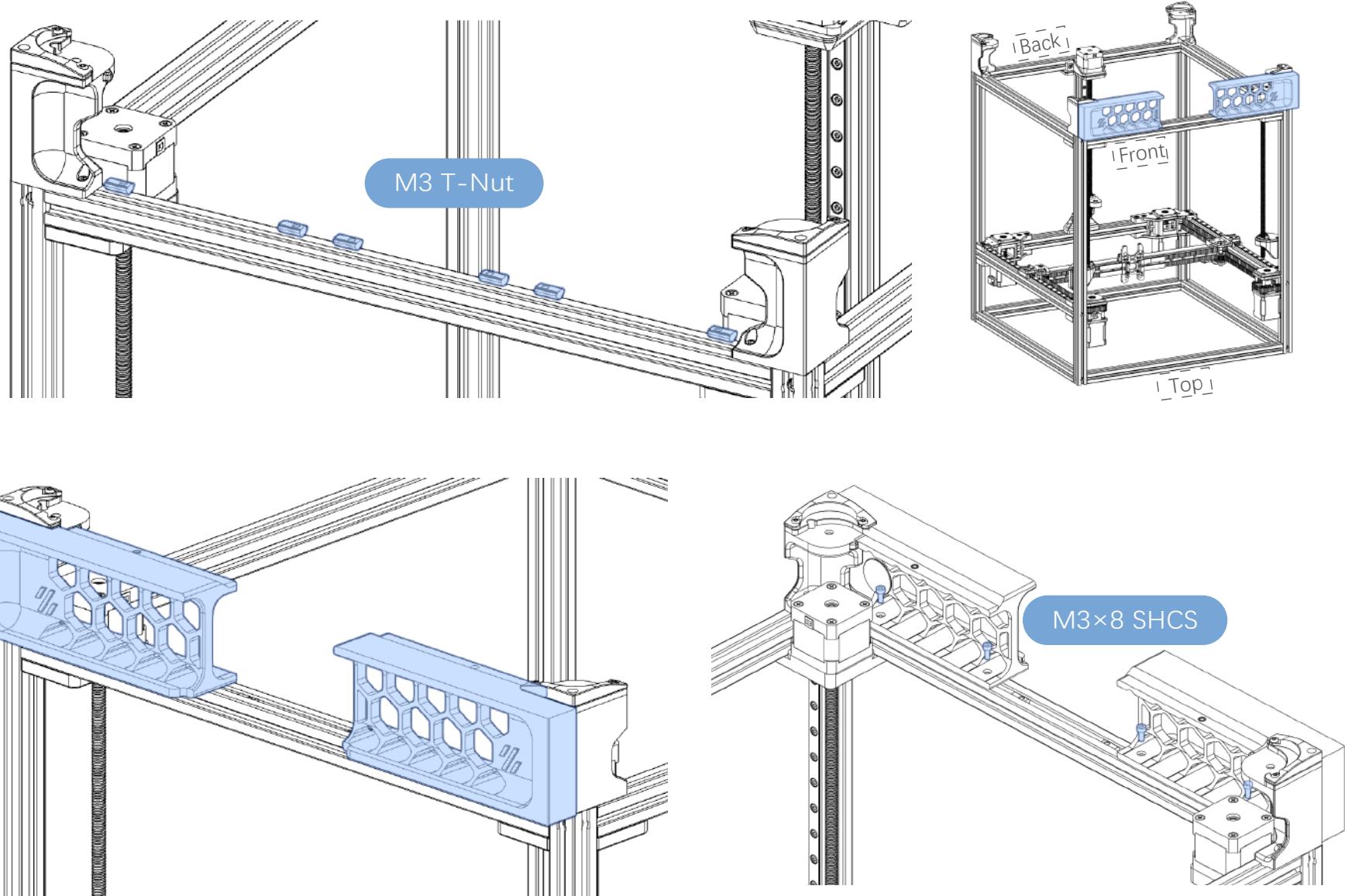
Heat Set Insert



6020 Fan



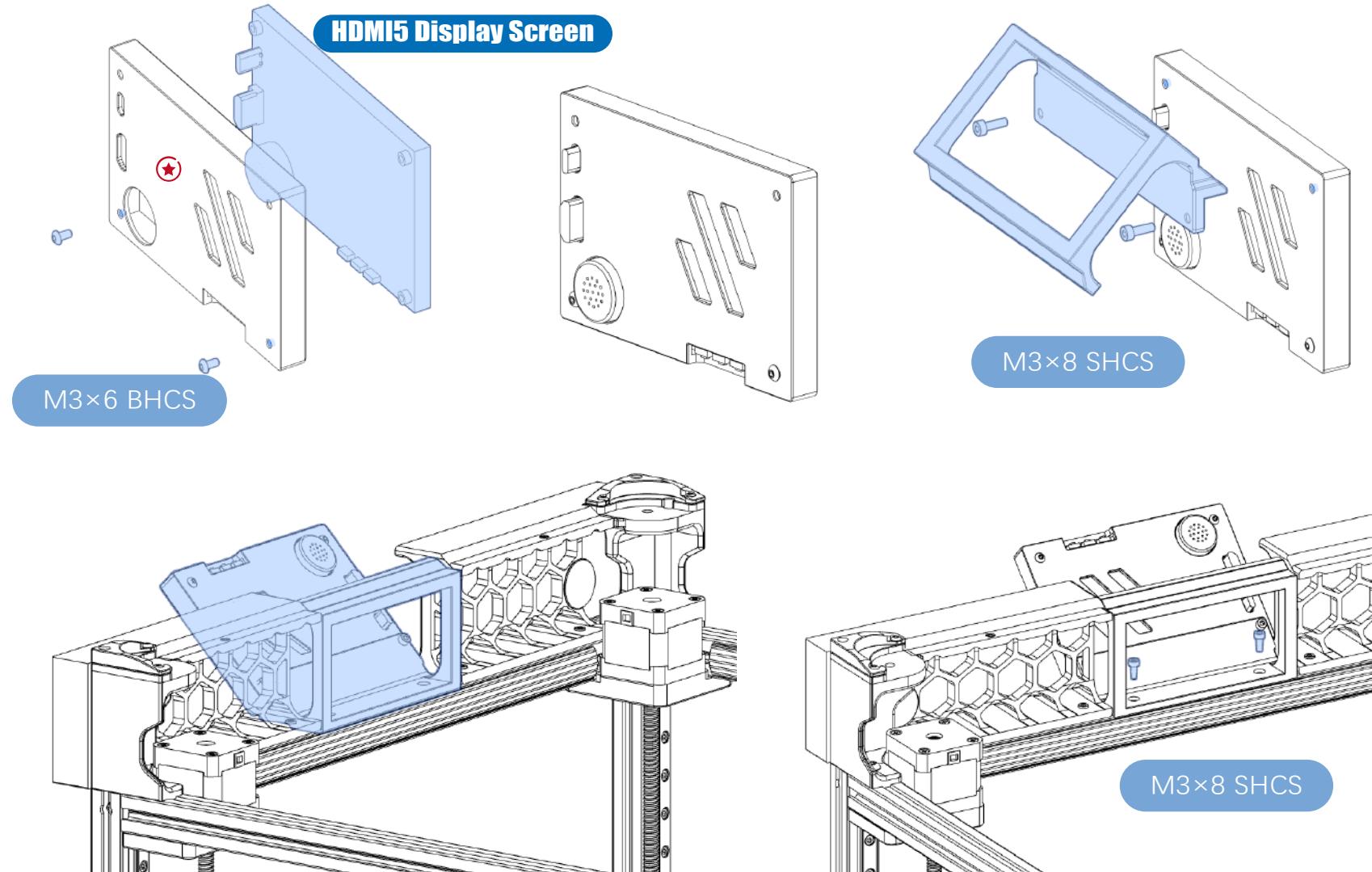


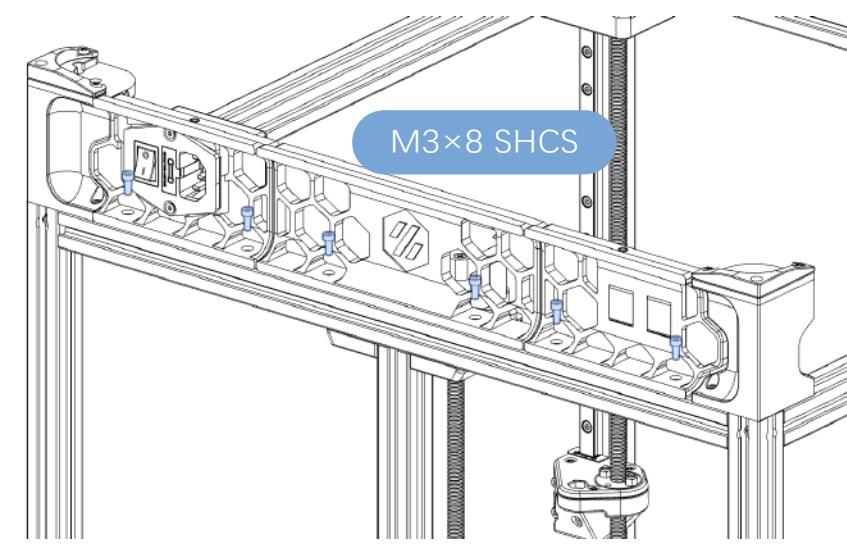
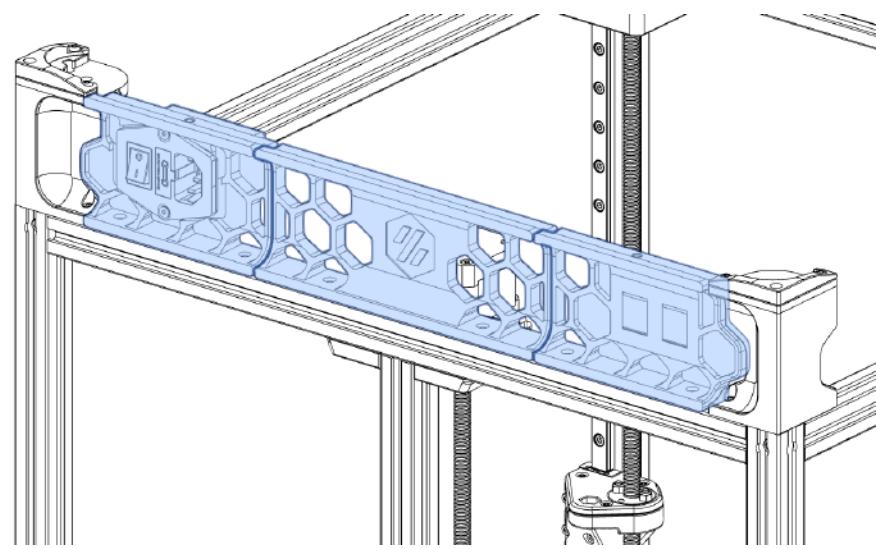
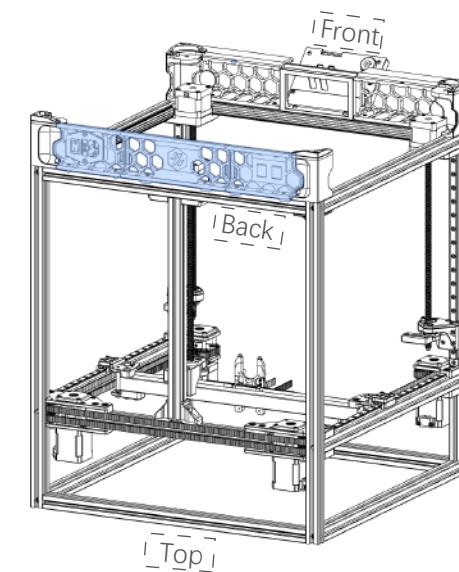
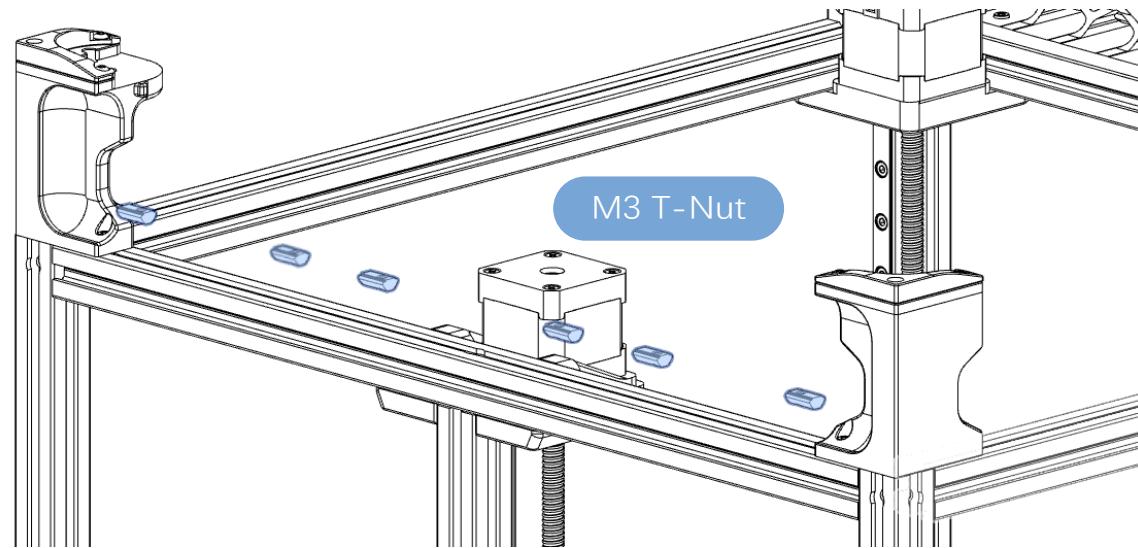


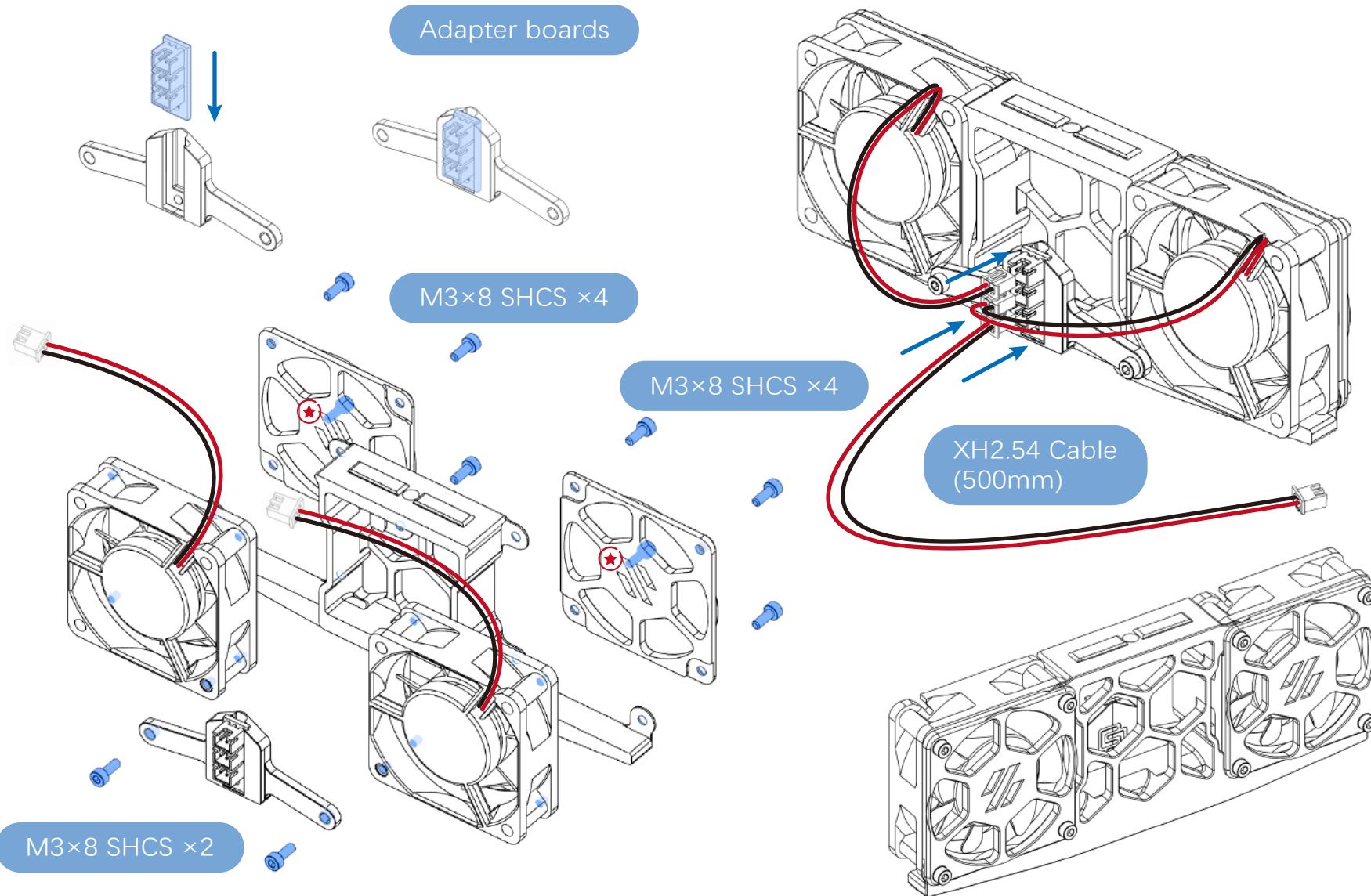
**Important Installation Note**

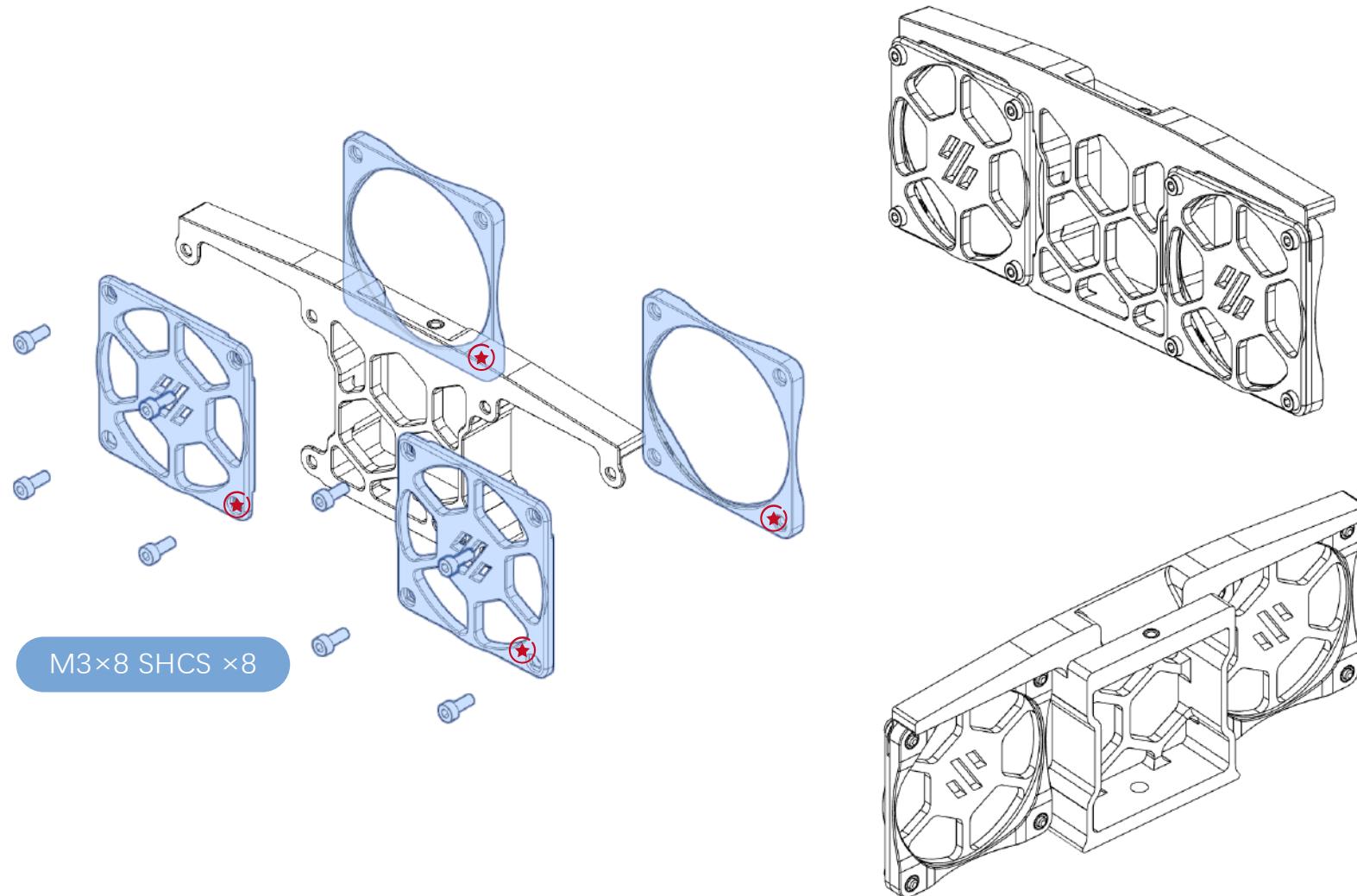
After installing the touch screen bracket, avoid turning the printer with its front facing down towards the desk, as this may damage both the touch screen and the bracket.

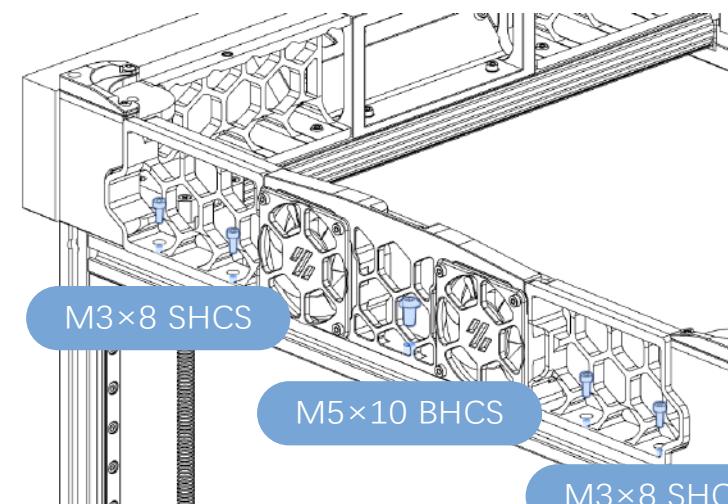
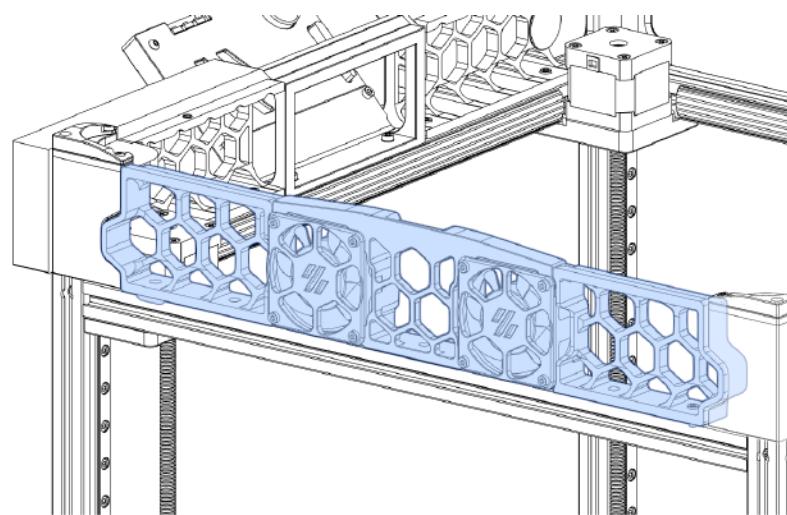
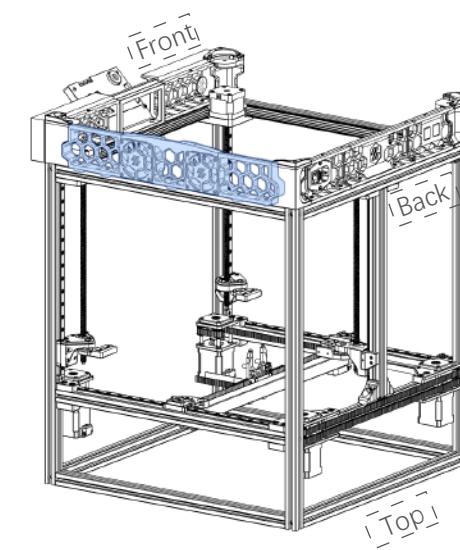
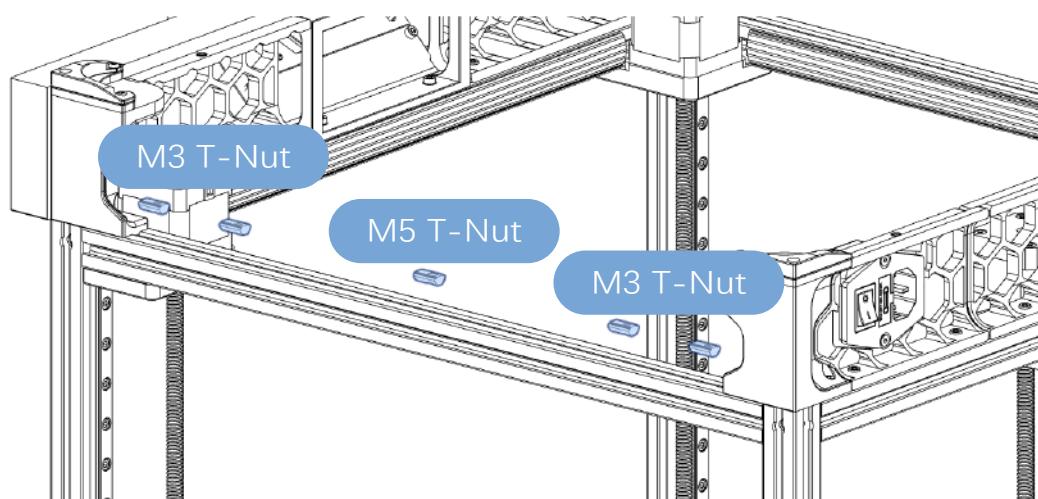
Alternatively, you can install the touch screen on the bracket without securing the bracket to the printer.

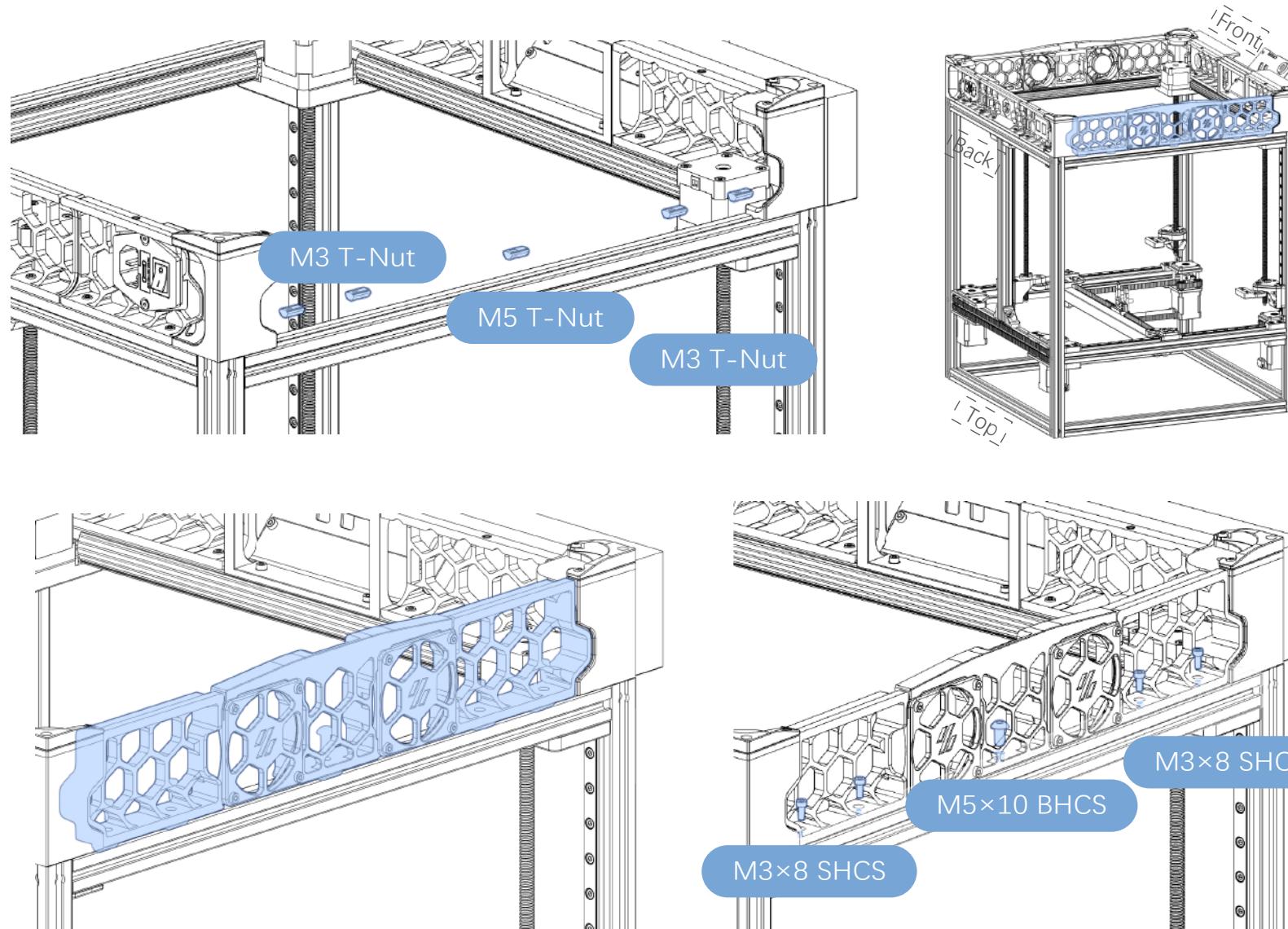


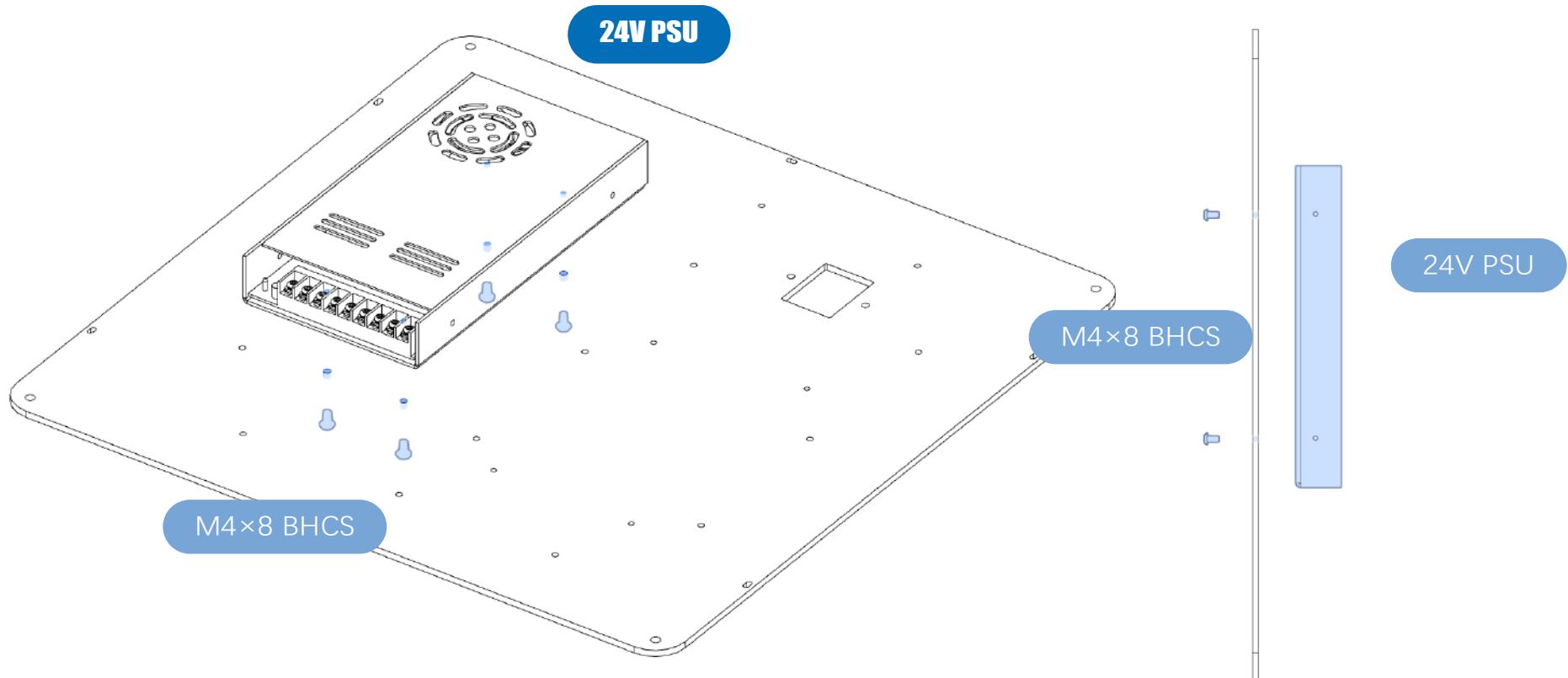






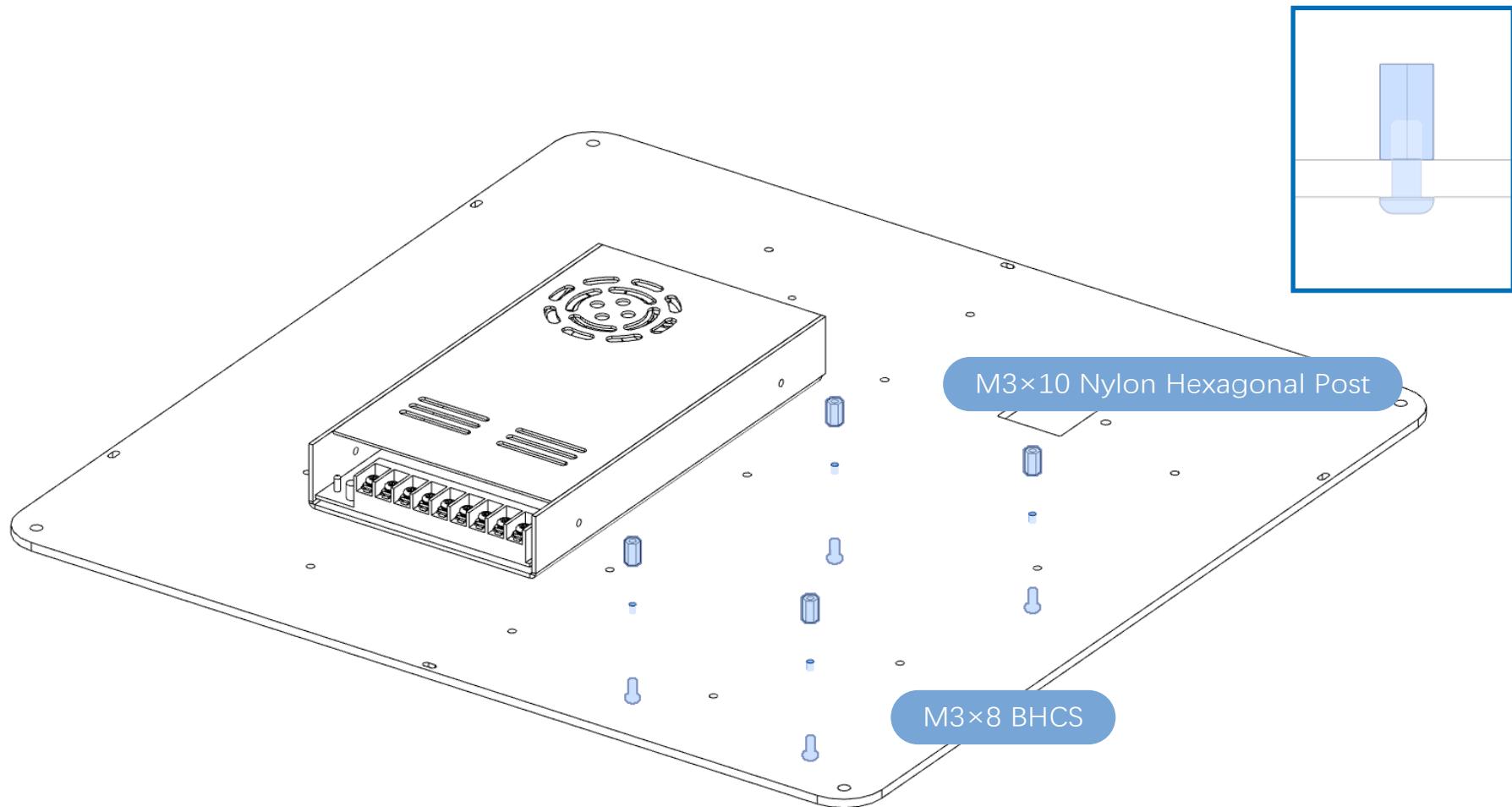


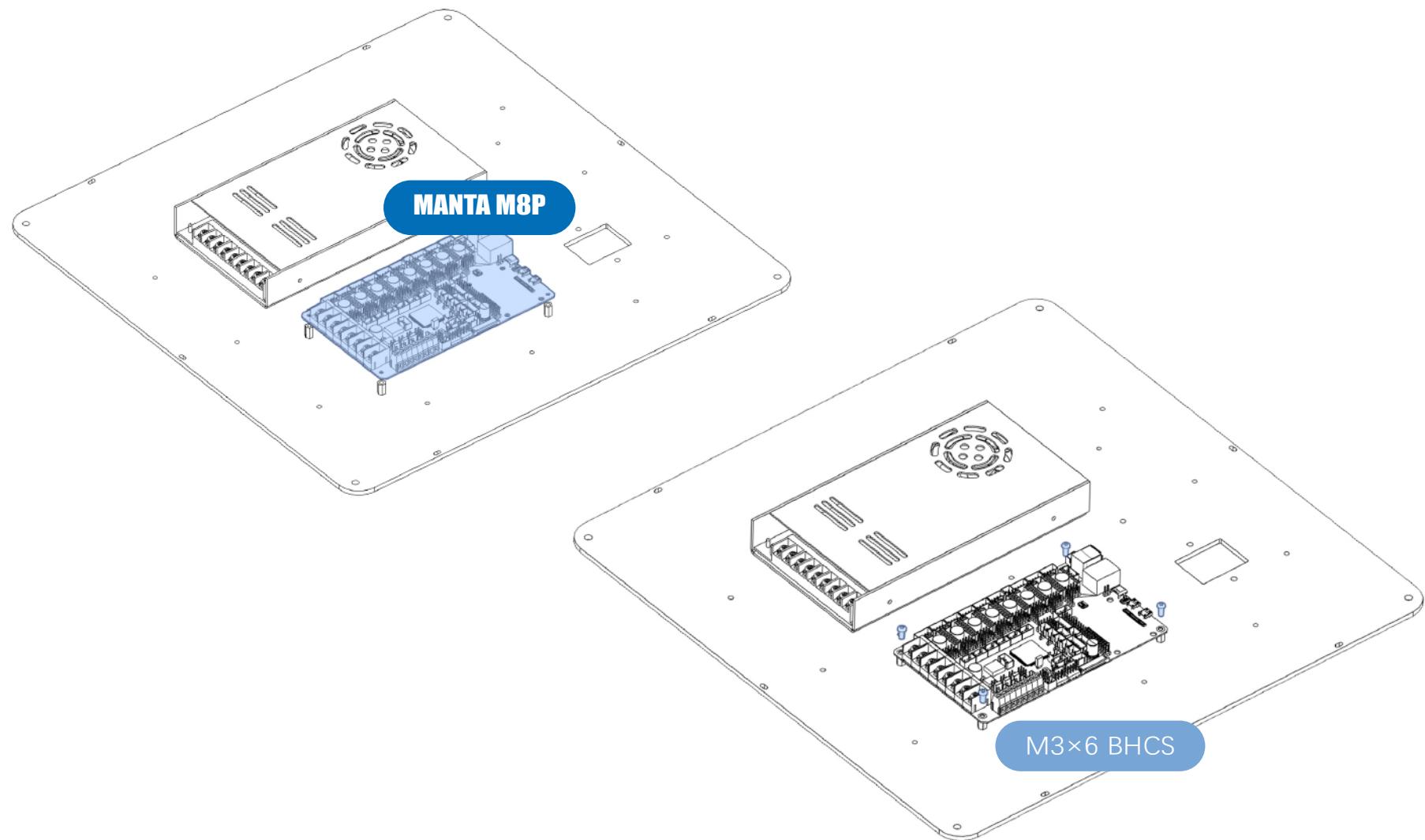


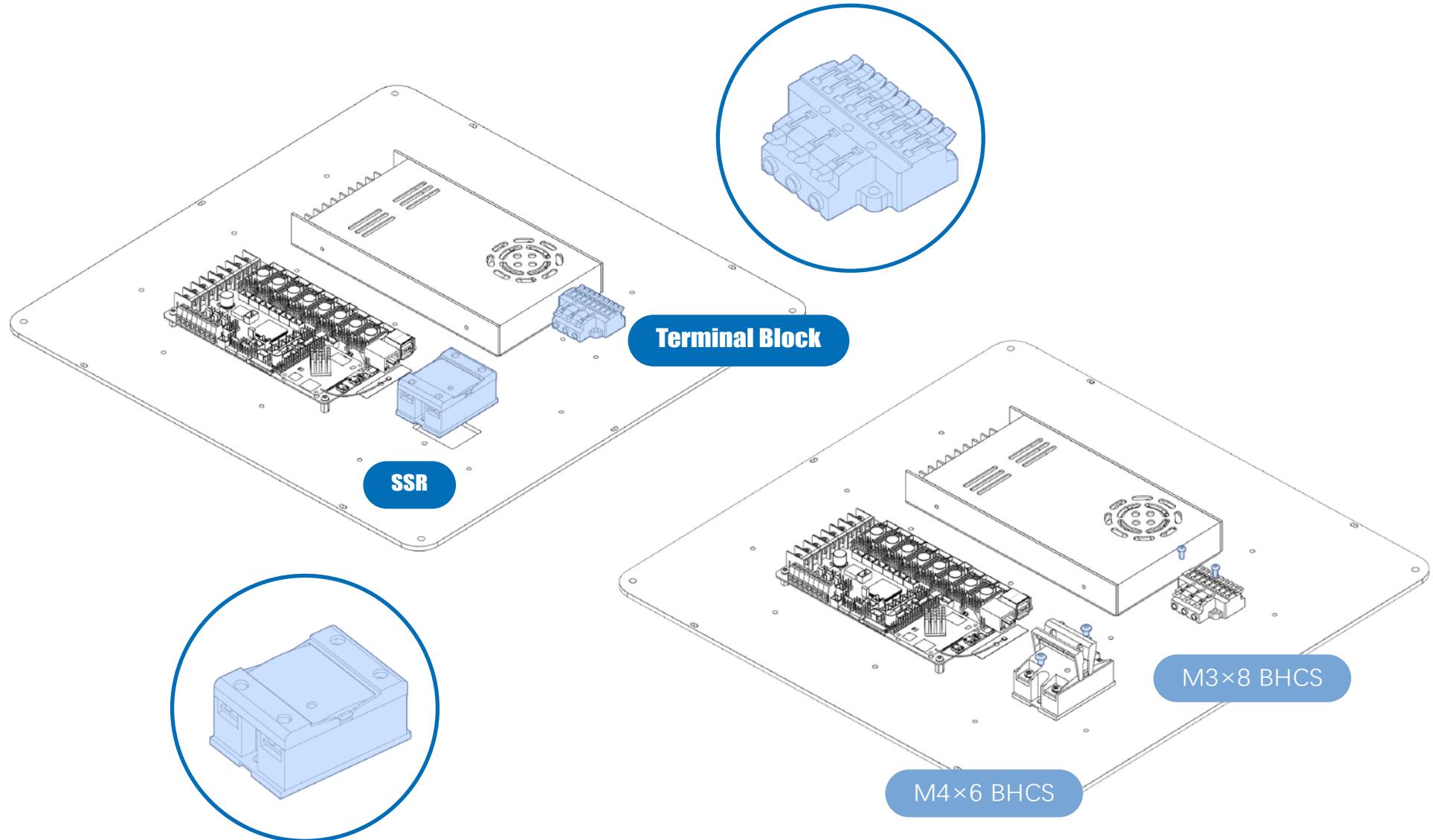


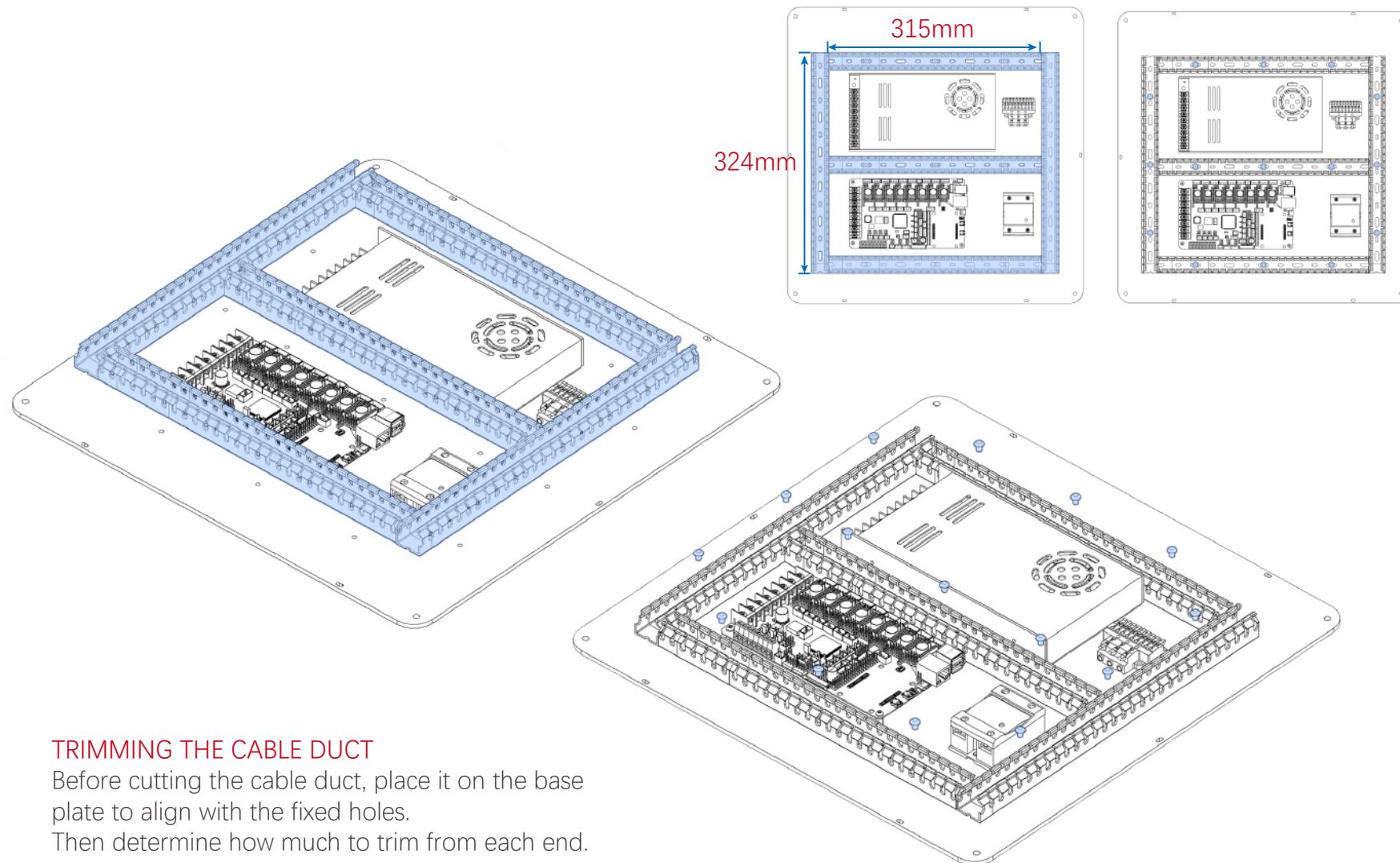
## Securing the 24V PSU

Use M4×8 BHCS screws to secure the 24V PSU to the black base plate.









#### TRIMMING THE CABLE DUCT

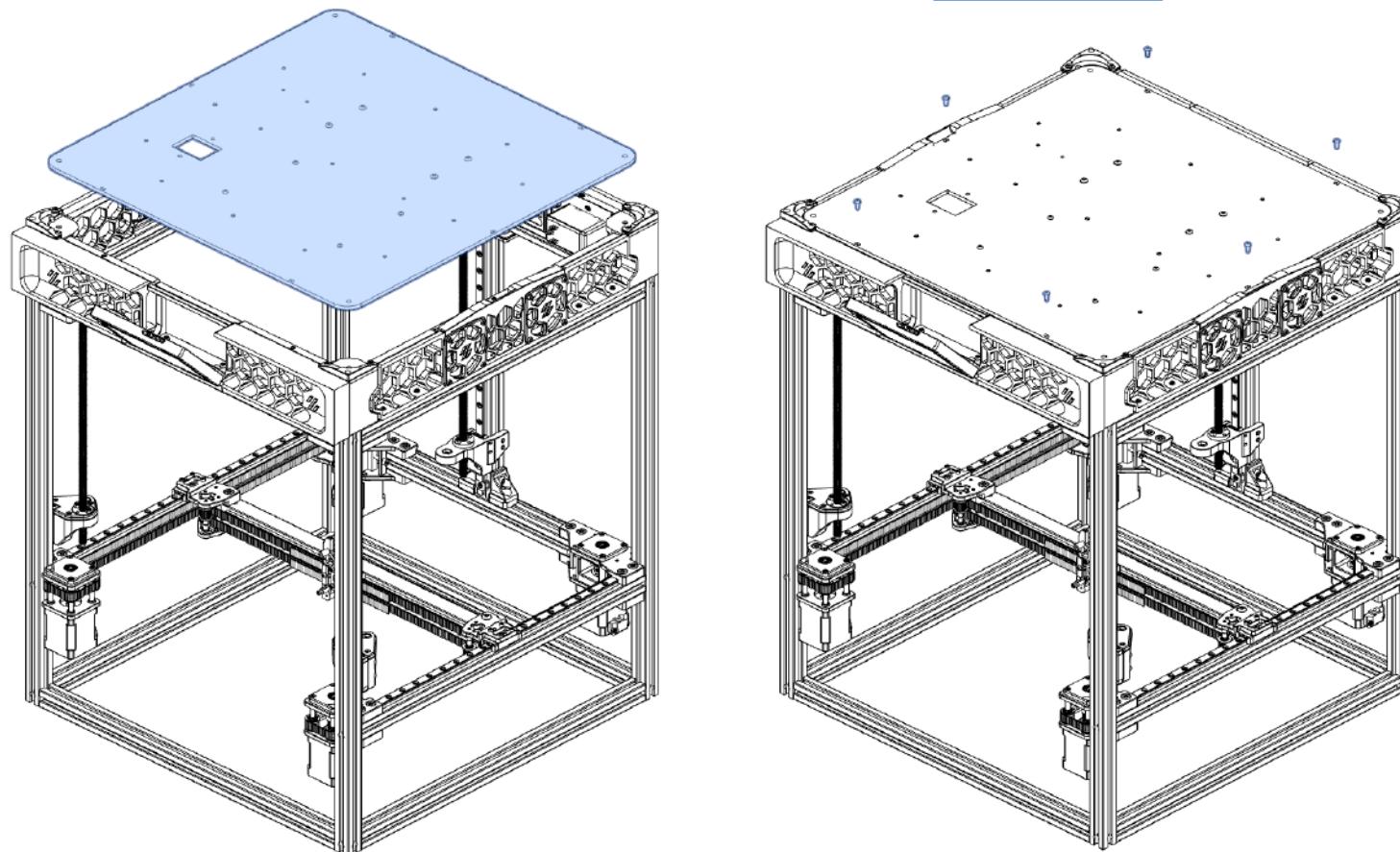
Before cutting the cable duct, place it on the base plate to align with the fixed holes.  
Then determine how much to trim from each end.

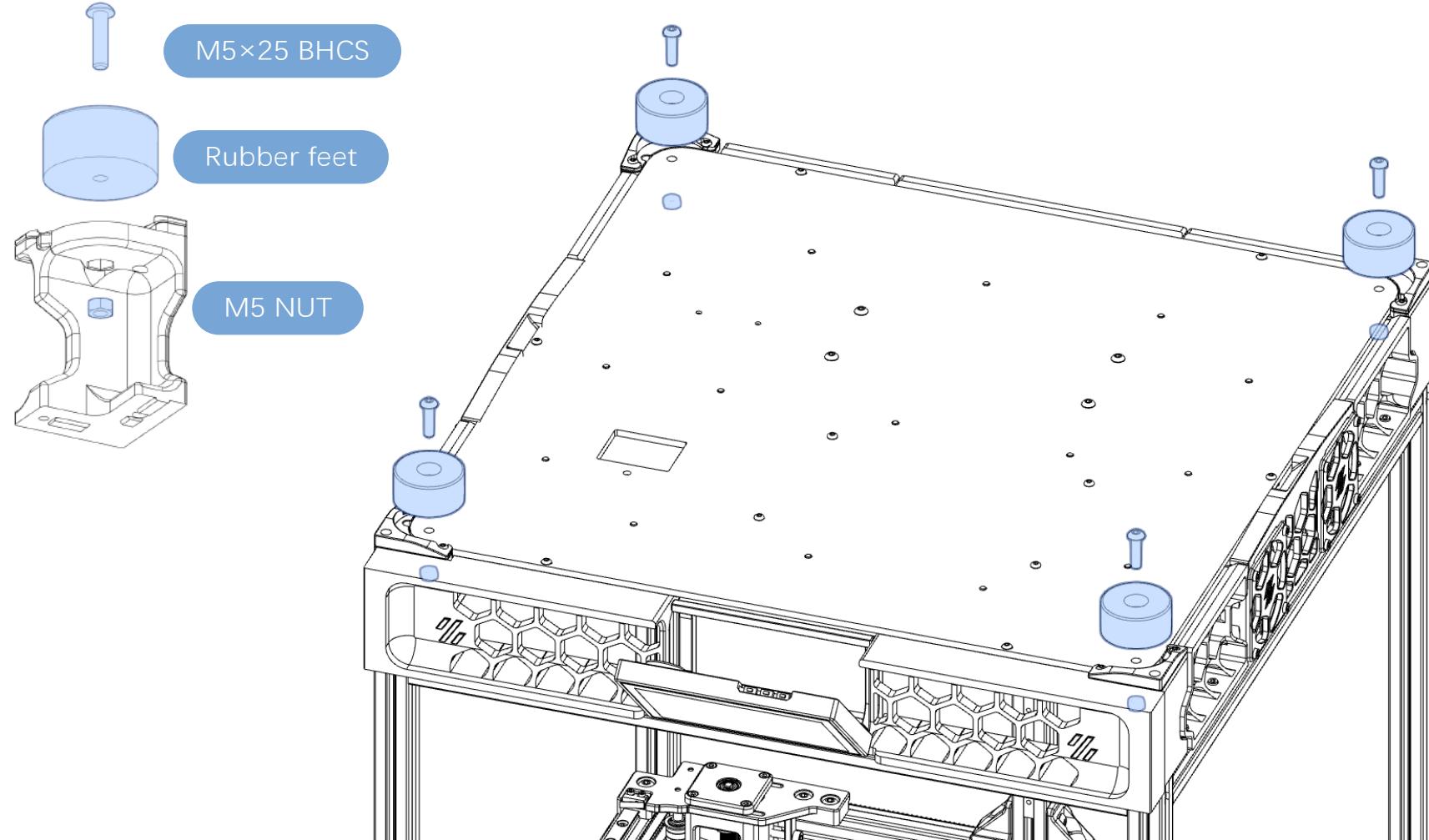
M4×6 BHCS

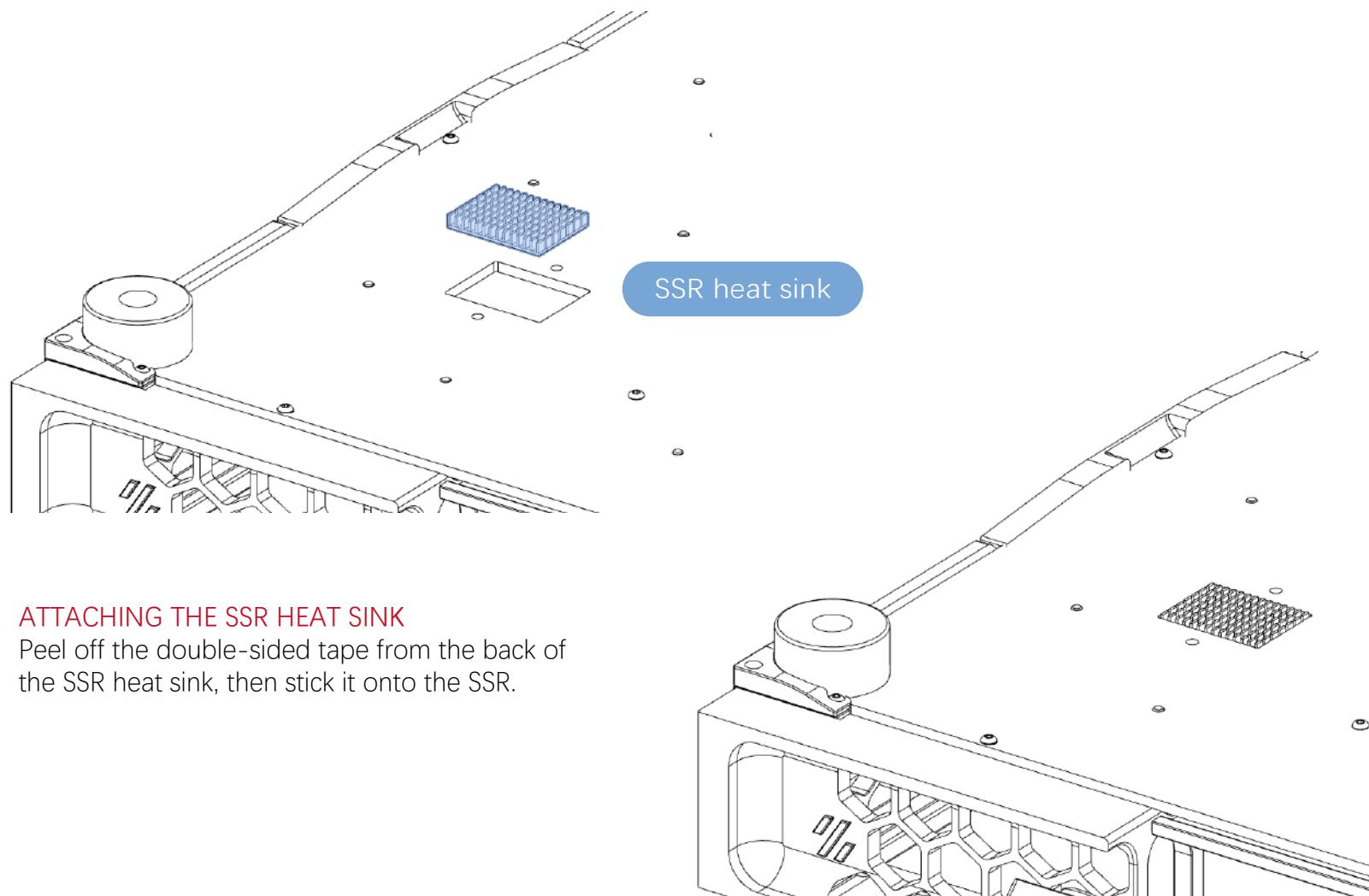
## PARTIAL WIRING BEFORE INSTALLING THE BASE PLATE

Before installing the base plate, you can start some of the wiring first.

The benefit is that you won't be confined to working within the space of the printer, allowing you to work easily on a desk and save a lot of time. If needed, please refer to pages 187-192.



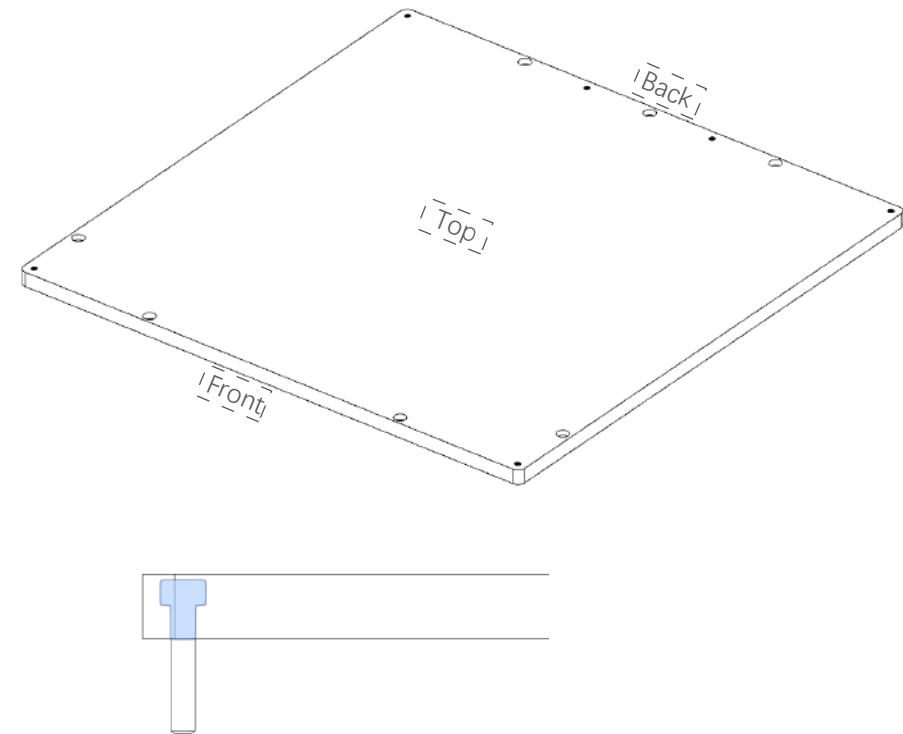
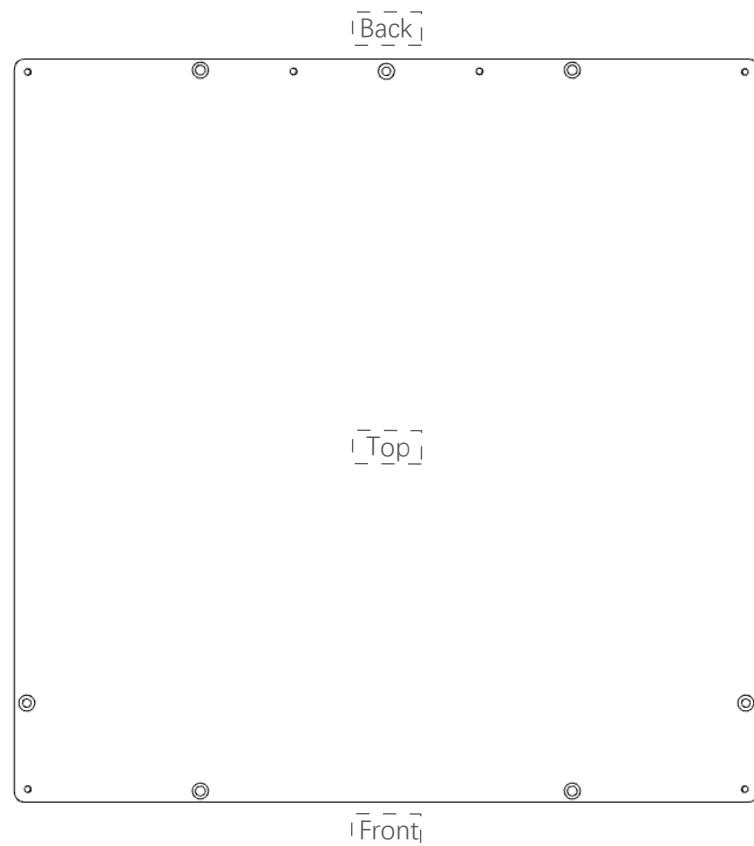




#### ATTACHING THE SSR HEAT SINK

Peel off the double-sided tape from the back of the SSR heat sink, then stick it onto the SSR.

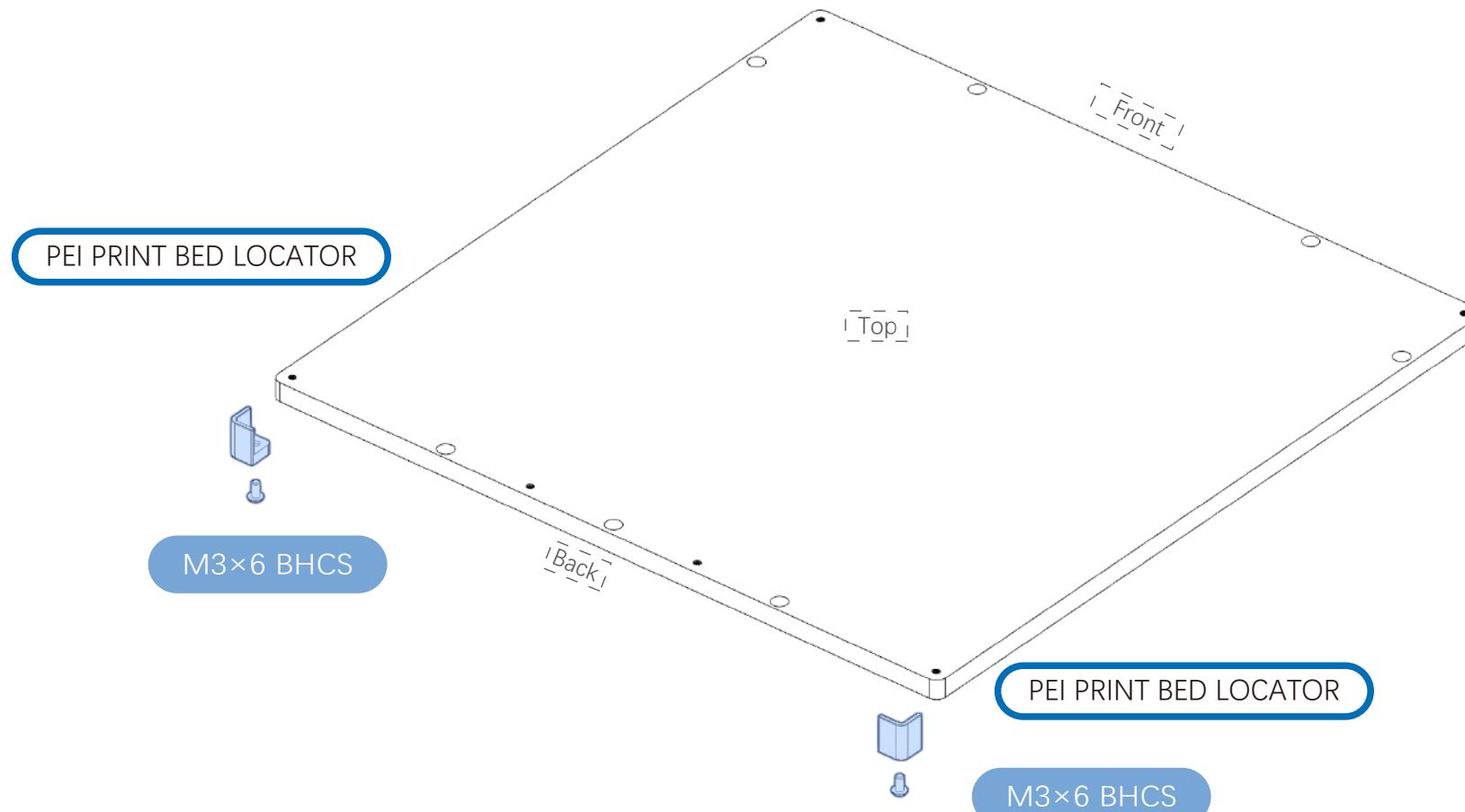




### WHICH SIDE IS WHICH?

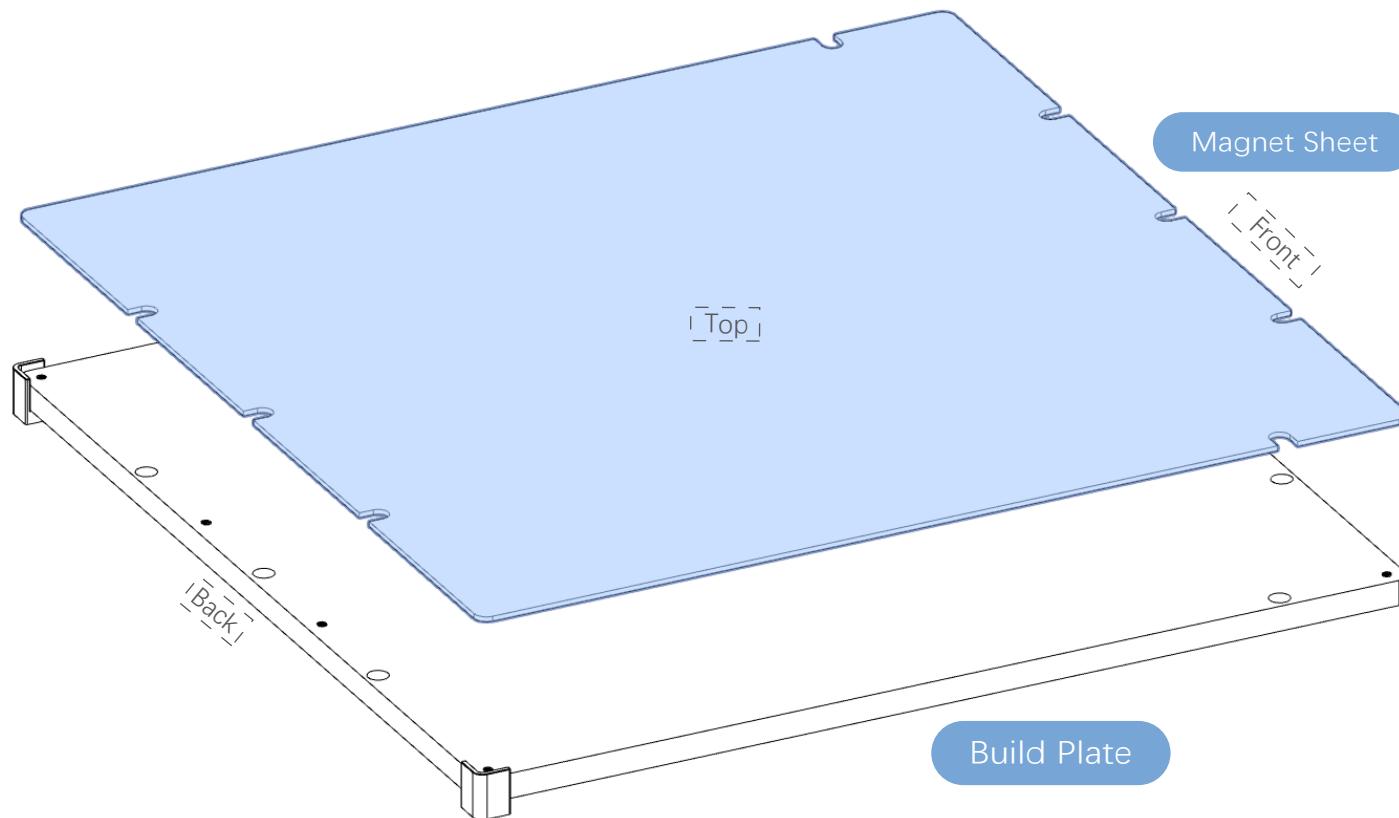
The top of the plate has mounting holes with bores that allow boltheads to sit flush/below the surface.

The plate has additional tapped holes to secure the PE connection and a thermal fuse, those are on the back side of the plate.



### LOCATING THE PEI PRINT BED LOCATORS

The PEI Print Bed Locators are in the CNC AWD box, as mentioned on page 72.



<https://voron.link/rm6tpld>

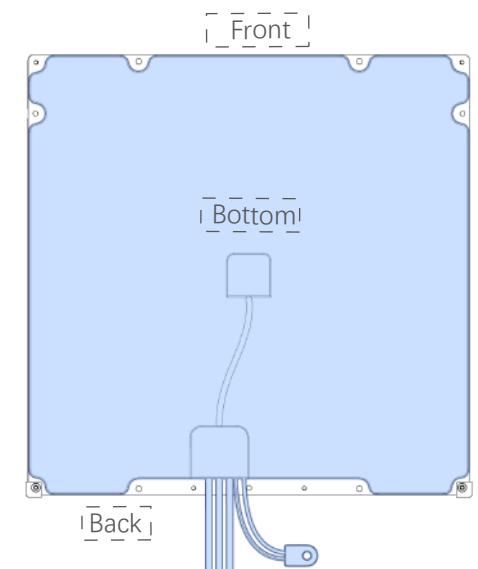
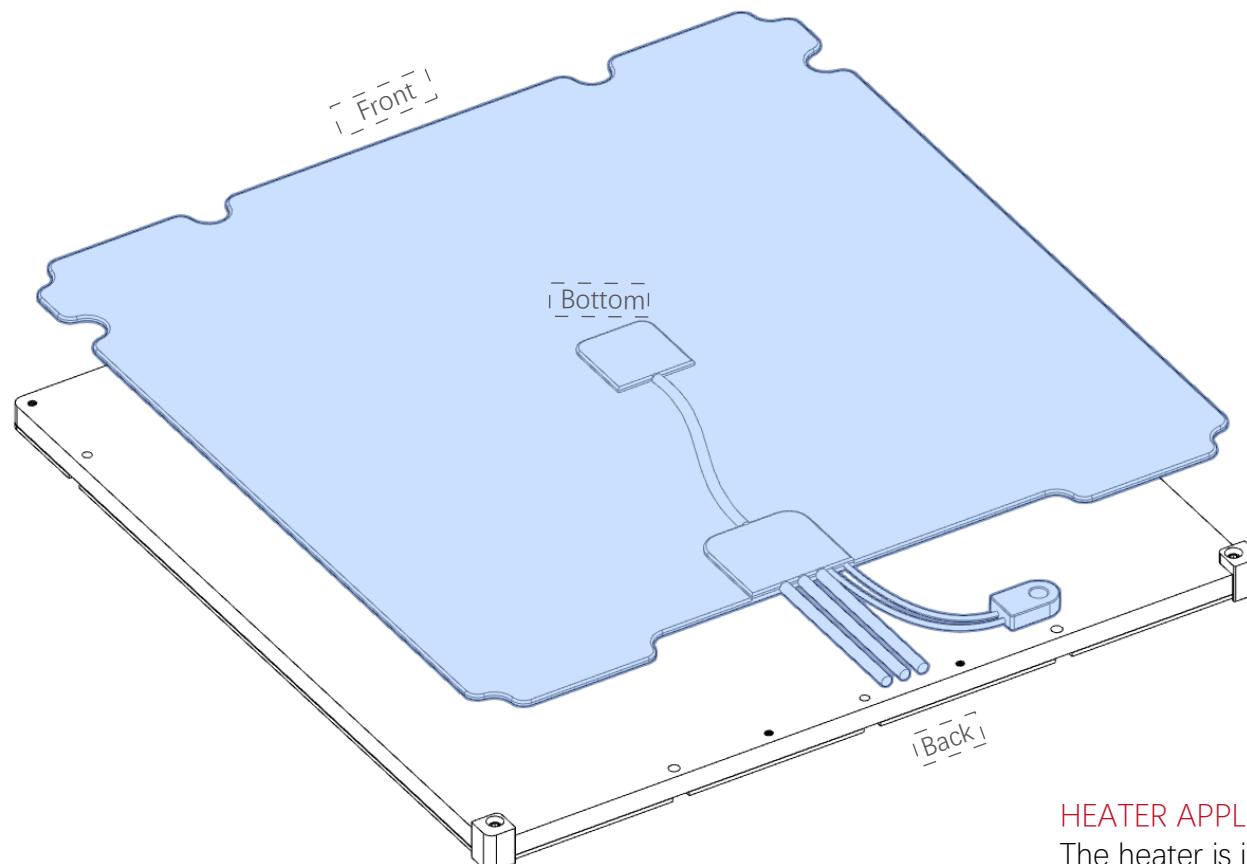
### MAGNET APPLICATION

Clean the plate with isopropyl alcohol or similar cleaner prior to applying the magnet.  
Use the edge of a plastic object or a small roller to firmly press the magnet on the plate to get a good bond.  
If you have never done this before we recommend you watch the linked guide.



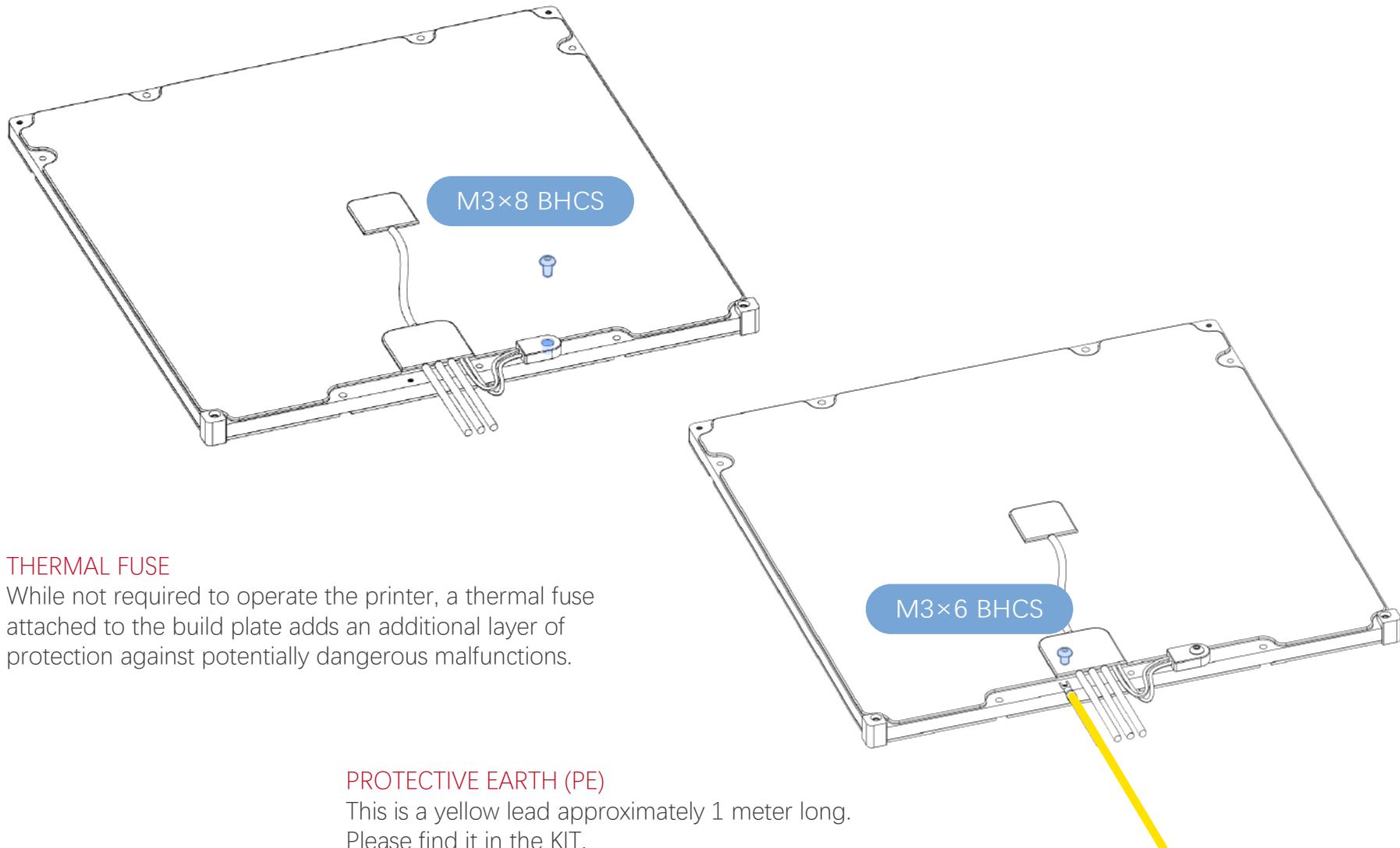
### CHECKING SPECIFICATIONS BEFORE INSTALLING THE BED HEATER

Before installing the Bed Heater, be sure to check the specification information on the surface silkscreen to ensure the voltage matches the power supply voltage in your area!



### HEATER APPLICATION

The heater is installed in the same fashion as the magnet. Centre it on the underside of the build plate and make sure to firmly press it on the build plate.

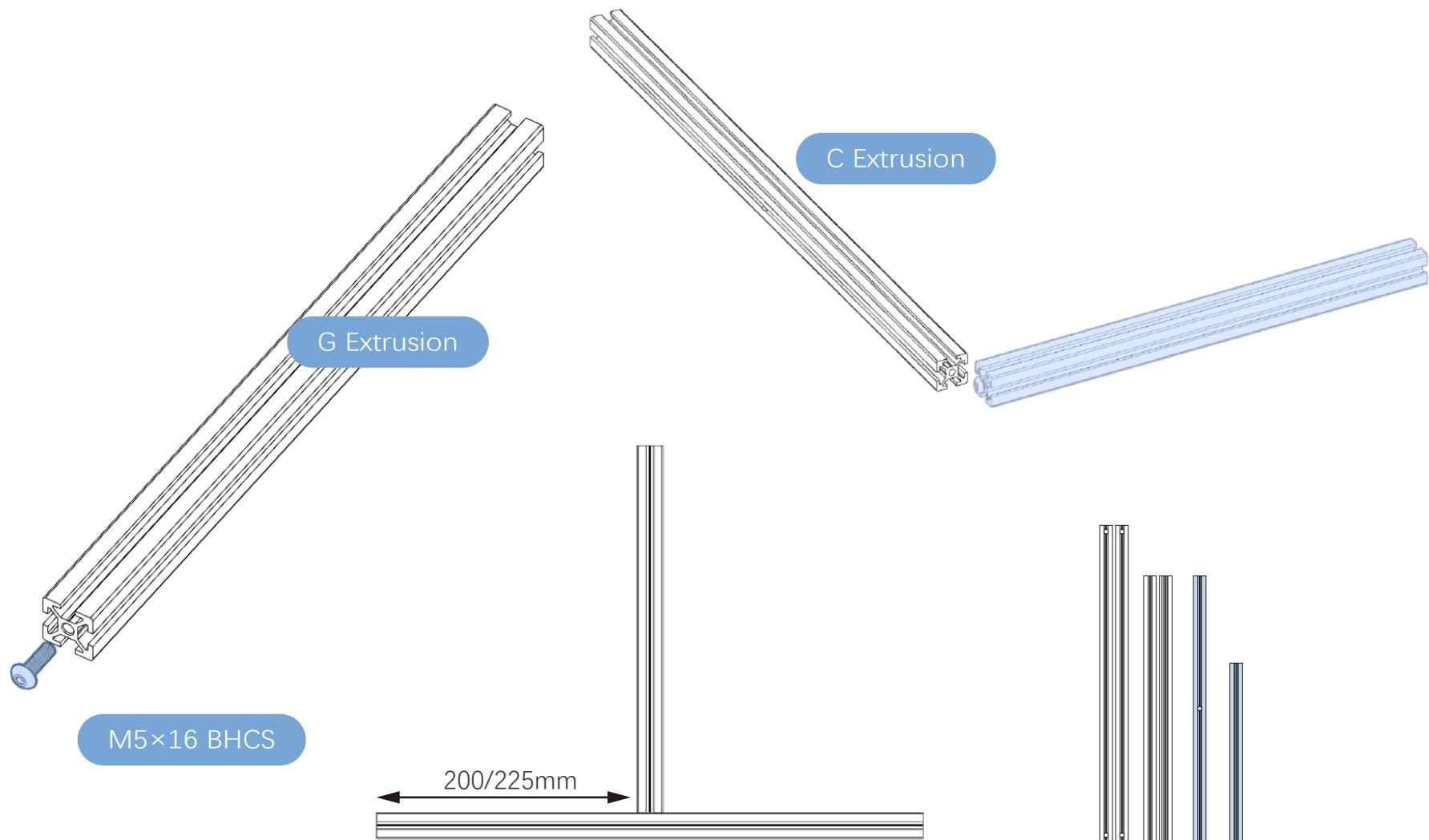


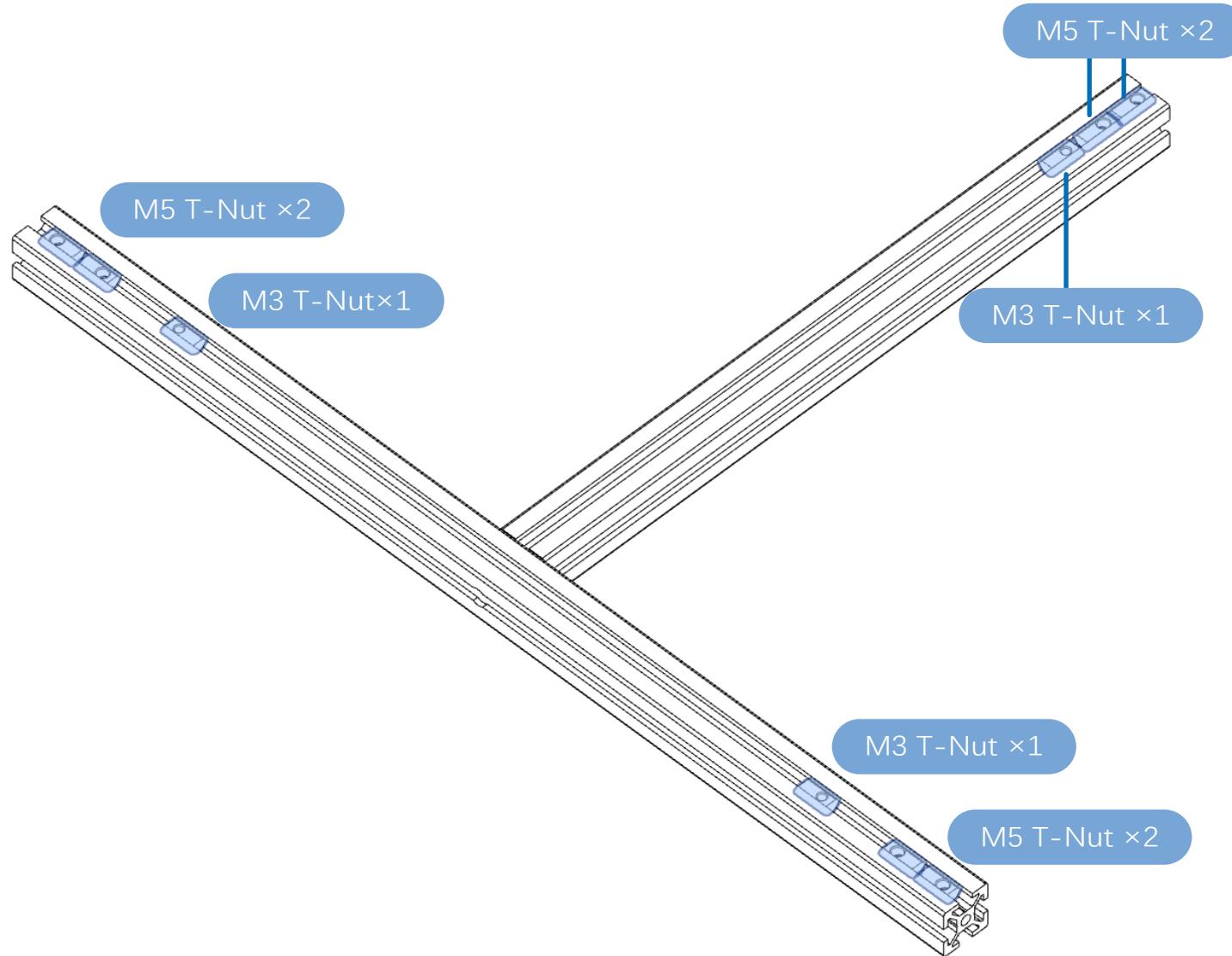
#### THERMAL FUSE

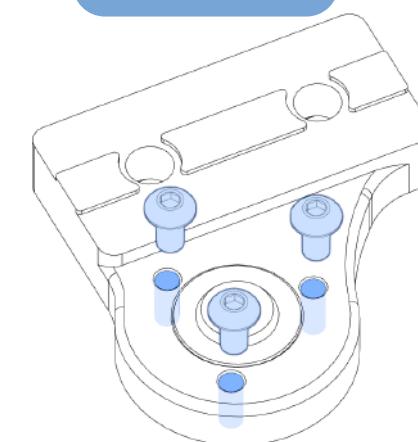
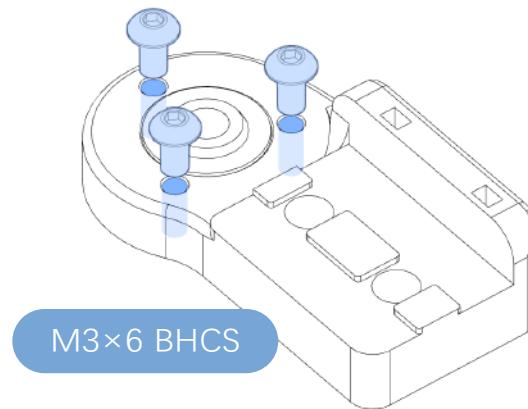
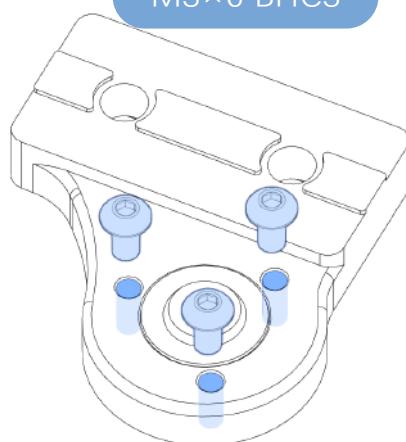
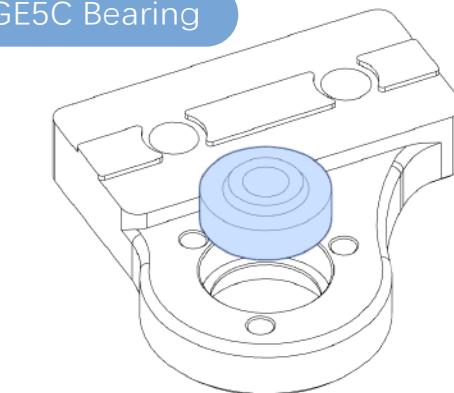
While not required to operate the printer, a thermal fuse attached to the build plate adds an additional layer of protection against potentially dangerous malfunctions.

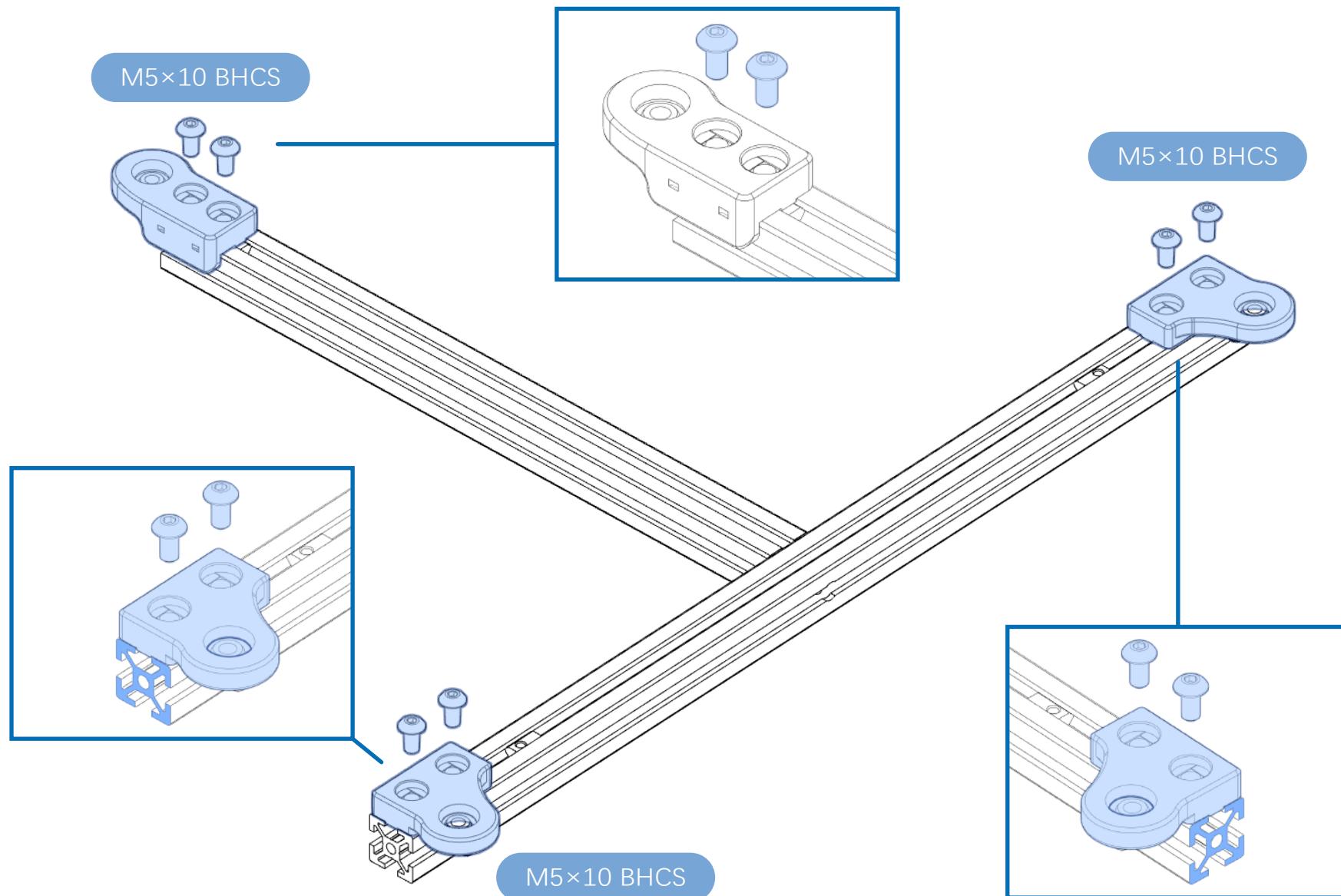
#### PROTECTIVE EARTH (PE)

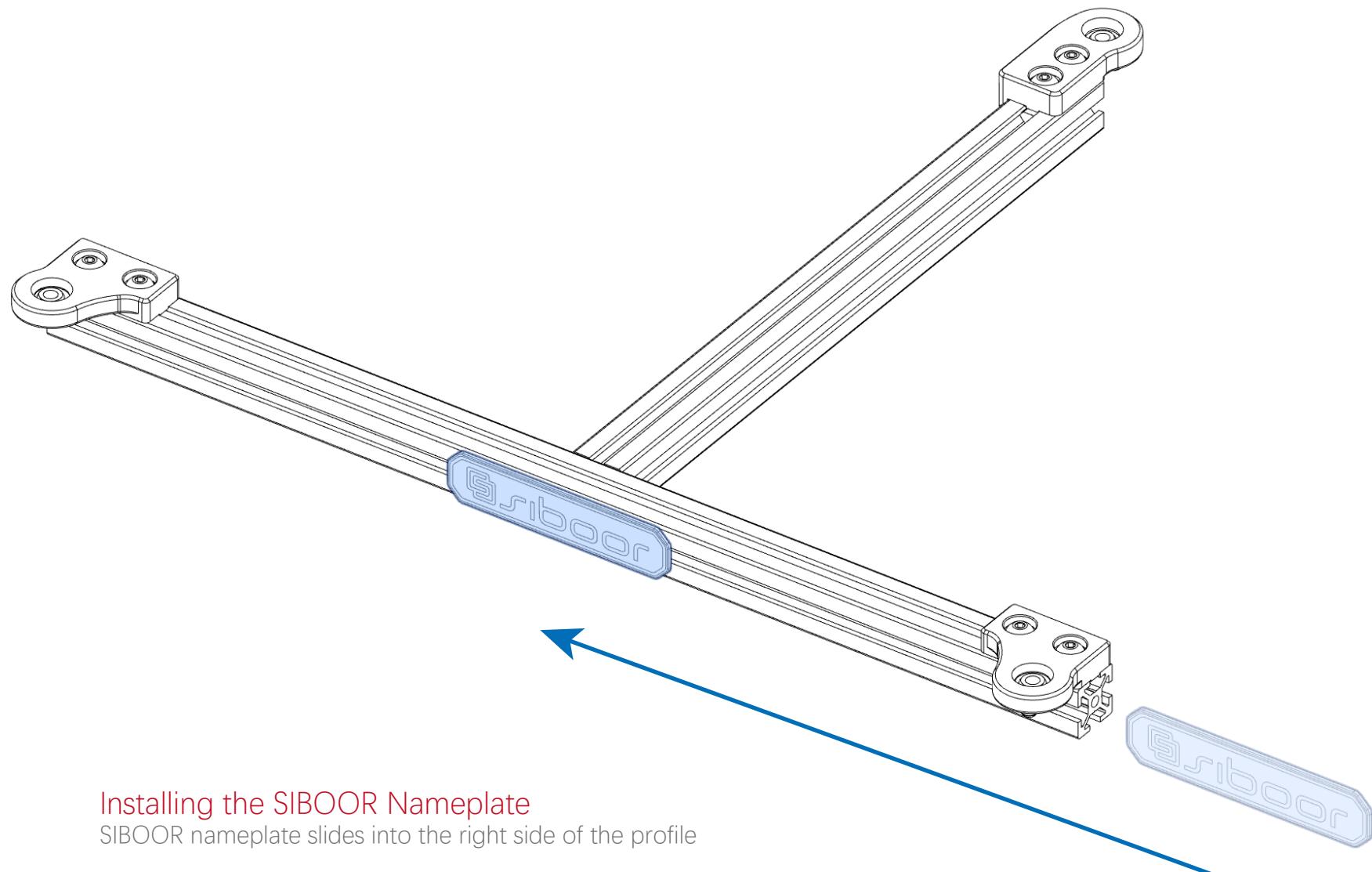
This is a yellow lead approximately 1 meter long.  
Please find it in the KIT.





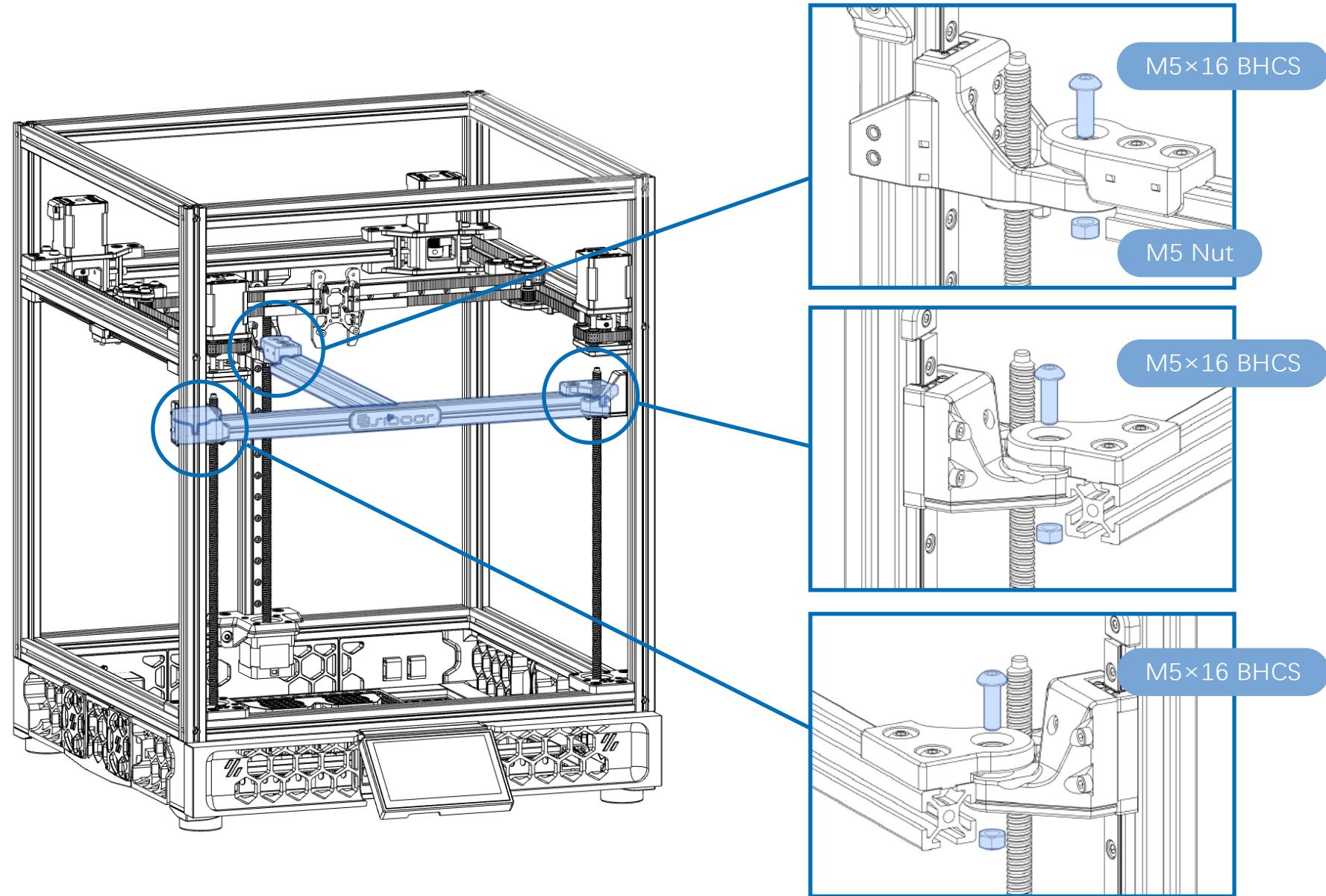


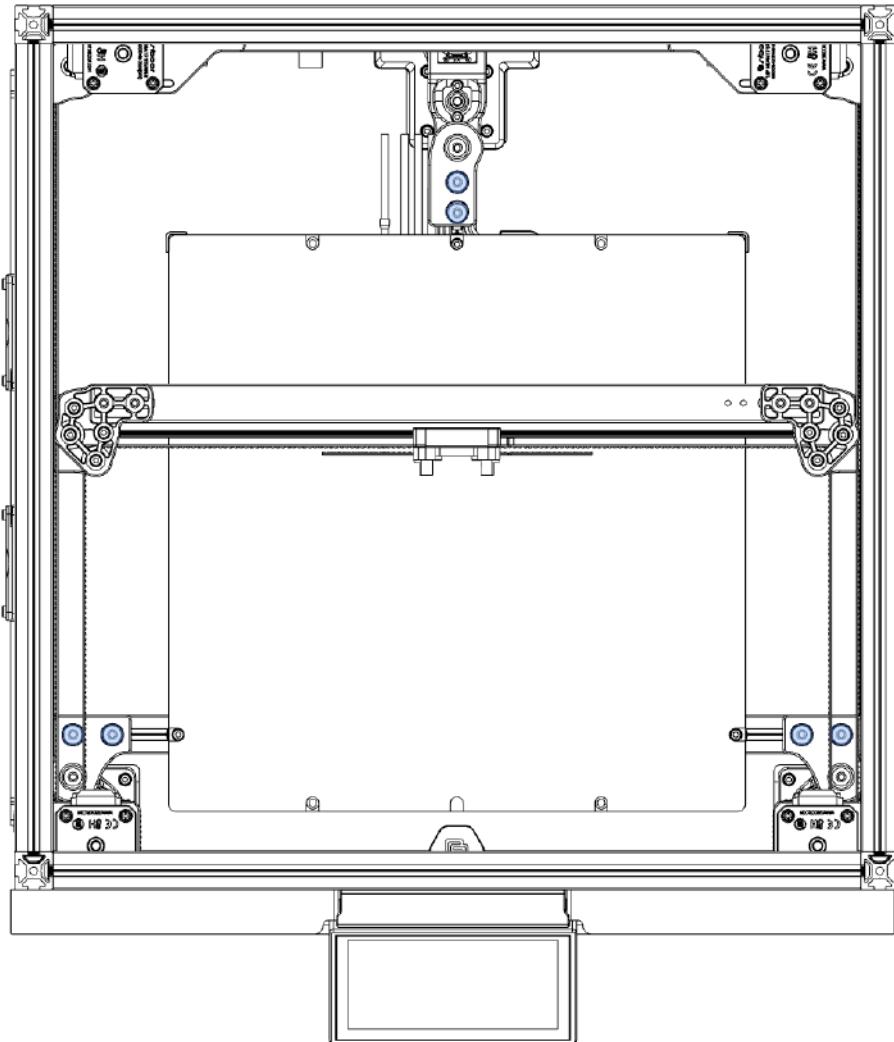




## Installing the SIBOOR Nameplate

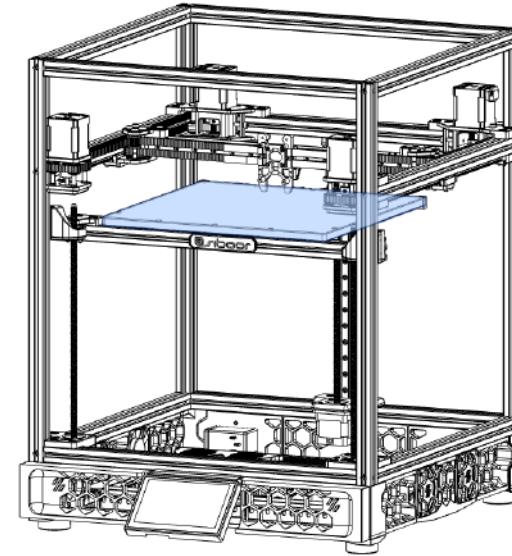
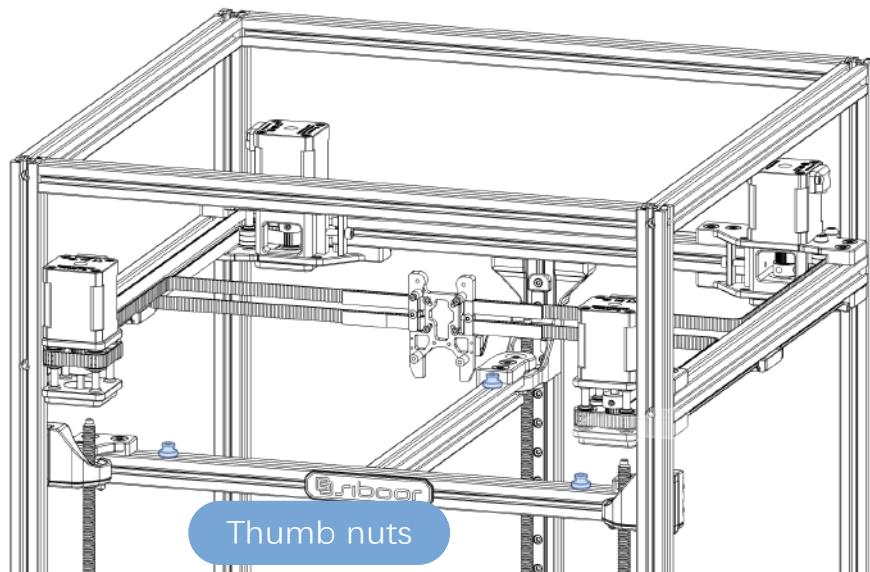
SIBOOR nameplate slides into the right side of the profile





### LOOSEN AND RETIGHTEN

Slightly loosen the bolts that hold the bed frame to the printed parts and gently shake the bed frame before retightening them.

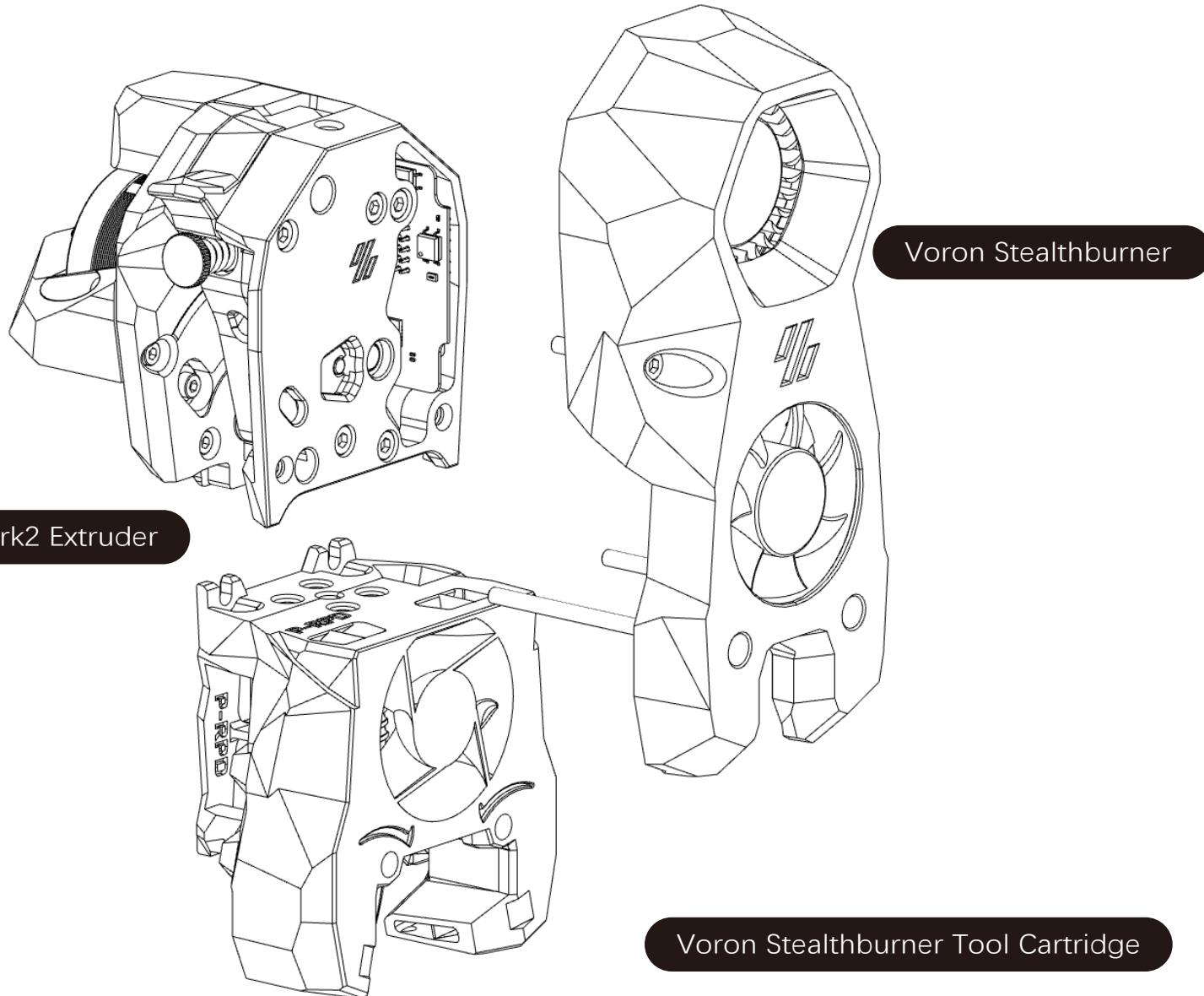


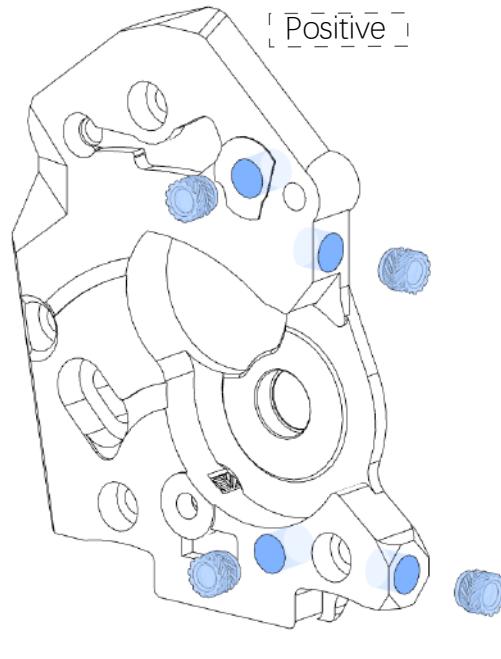
### ALTERNATIVE EXPERIMENTAL SOLUTION

The KIT also provides an alternative approach for mounting the bed. Using insulation columns and PEEK M3×16 SHCS screws, temperature transfer from the bed to extrusions is reduced. This helps prevent thermal expansion from deforming the frame.

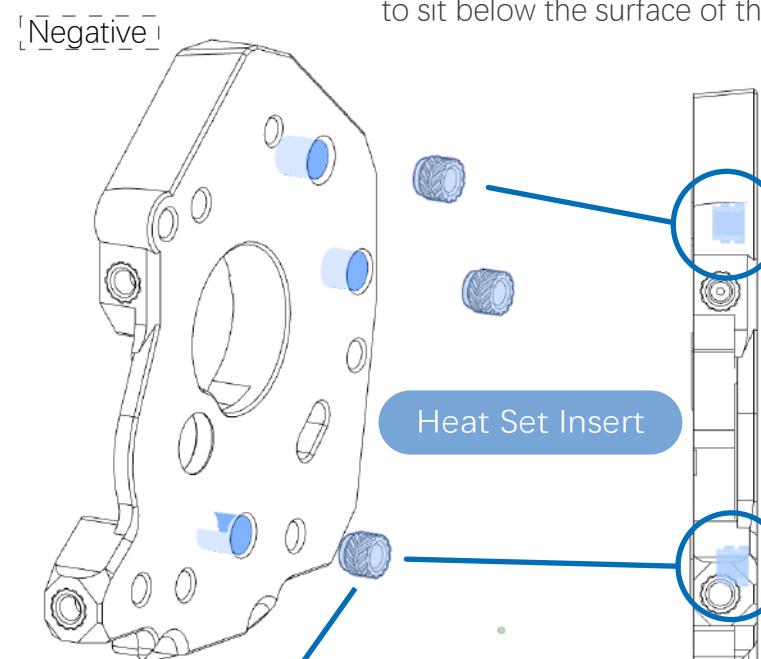
The way the bed is attached remains the same, but it's crucial to remember that PEEK screws can break. When installing, avoid using excessive force to prevent breaking the PEEK screws.





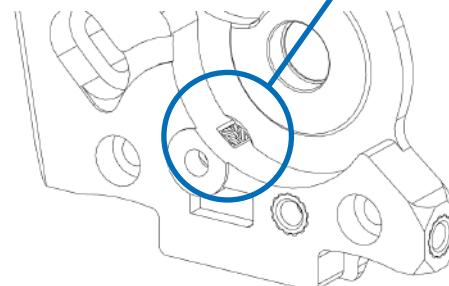


Heat Set Insert



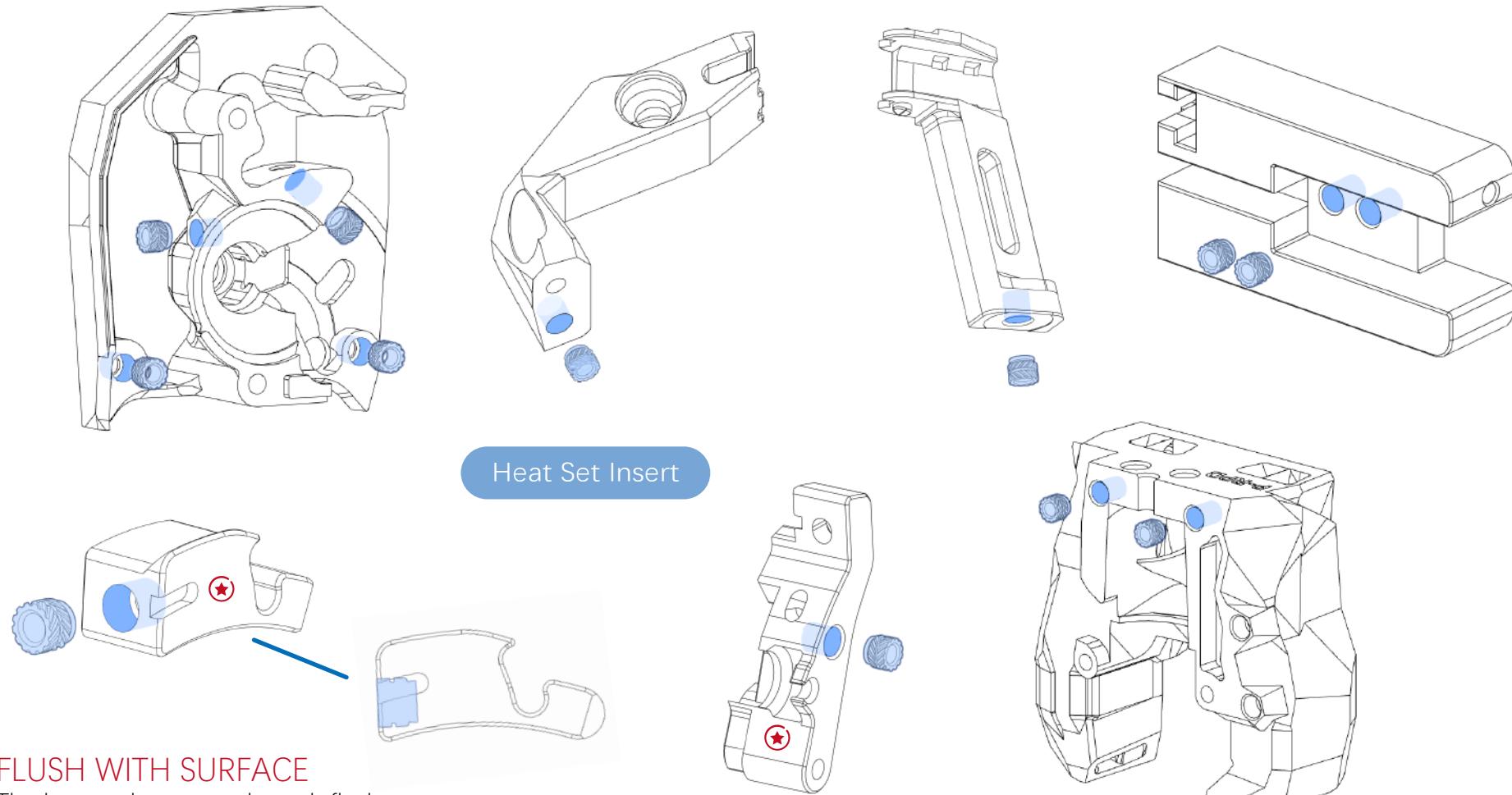
## BELOW SURFACE

The top heatset insert needs to sit below the surface of the printed part.



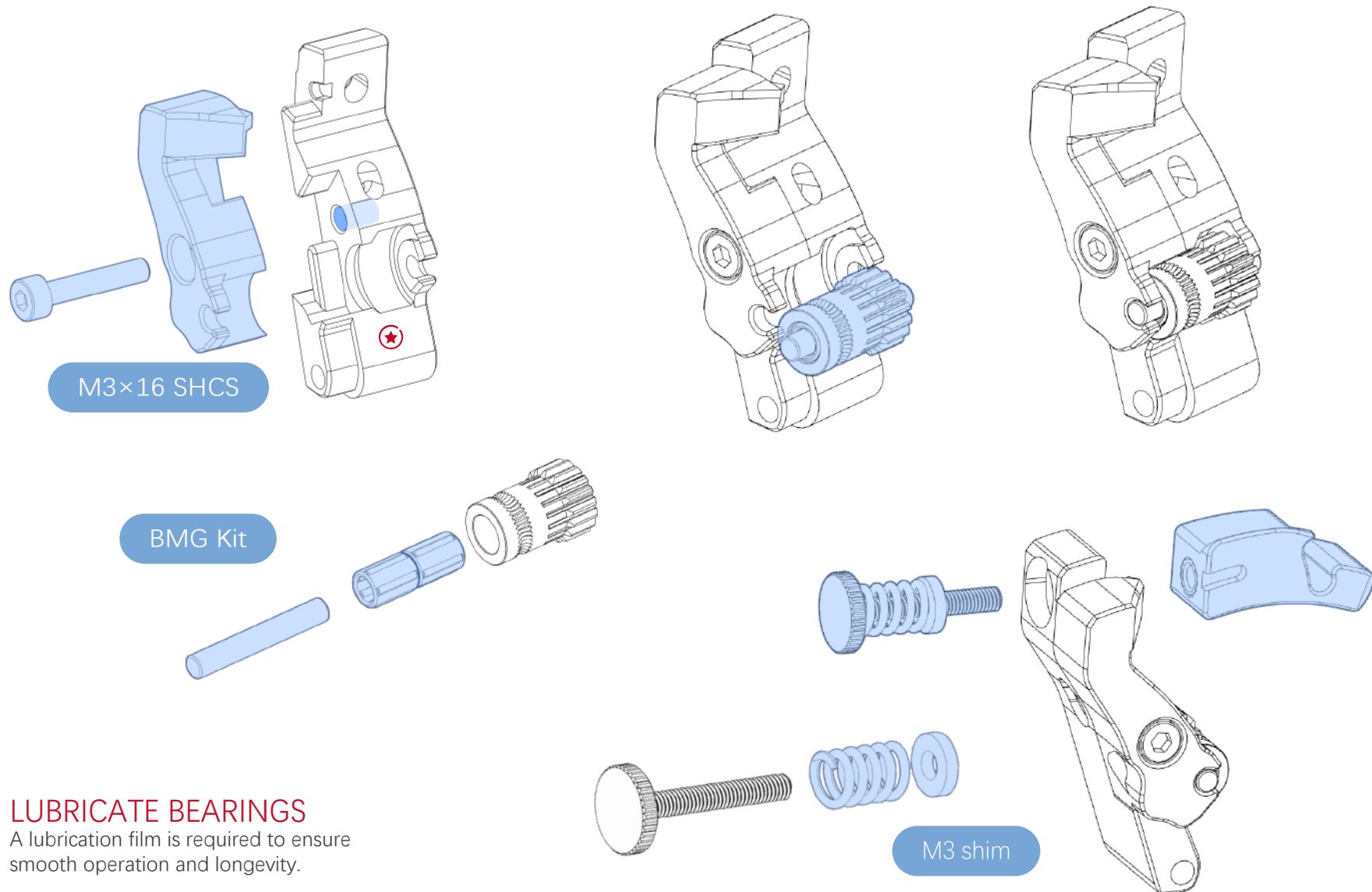
## BELOW SURFACE

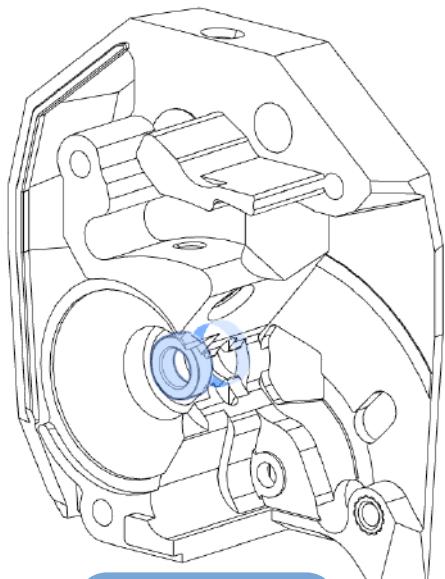
The bottom heatset insert needs to sit below the surface of the printed part. Mind the cutout in the part and make sure to install it straight.



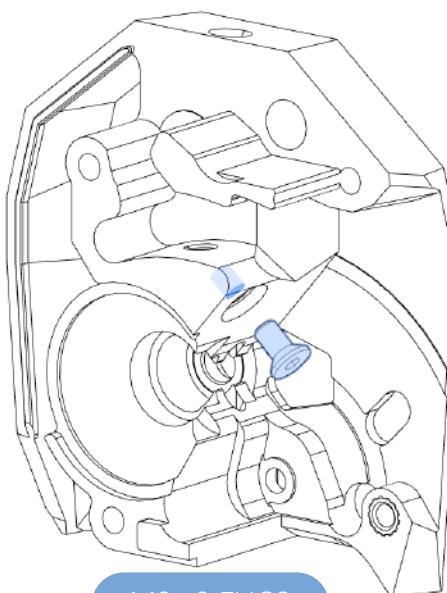
### FLUSH WITH SURFACE

The heatset insert needs to sit flush or slightly below the surface of the printed part.

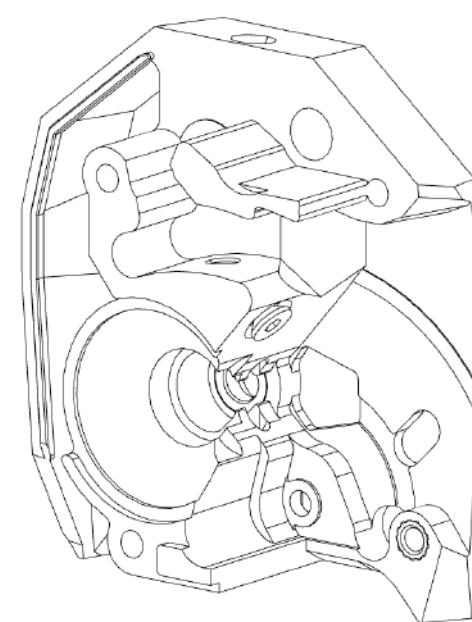




MR85 Bearing



M3×6 FHCS

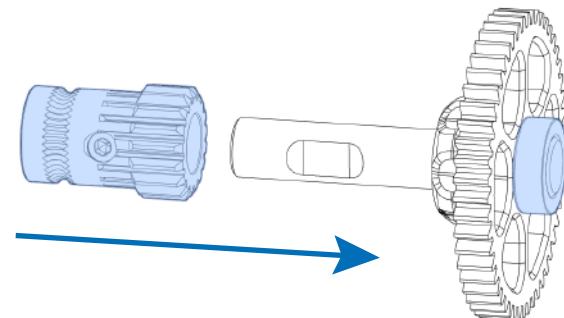


### BEARING FIT

Fully seat the bearing into the plastic pocket.  
Apply even pressure to insert them. Avoid  
pressing on the inner ring of the bearing.

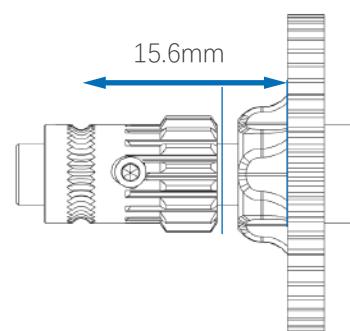
### IMPORTANT NOTICE ON MR85 BEARINGS

An MR85 bearing is pre-installed and precisely positioned next to the 50T reduction gear. Under normal circumstances, do not attempt to forcibly remove it, as this may cause damage.



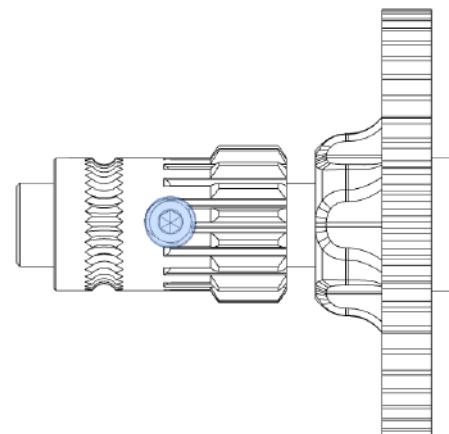
### INITIAL POSITION

The final position is set later.



### DRIVE GEAR

Make sure the set screw in the filament drive gear is seated against the notch in the shaft. Carefully tighten the set screw, the head is easy to strip

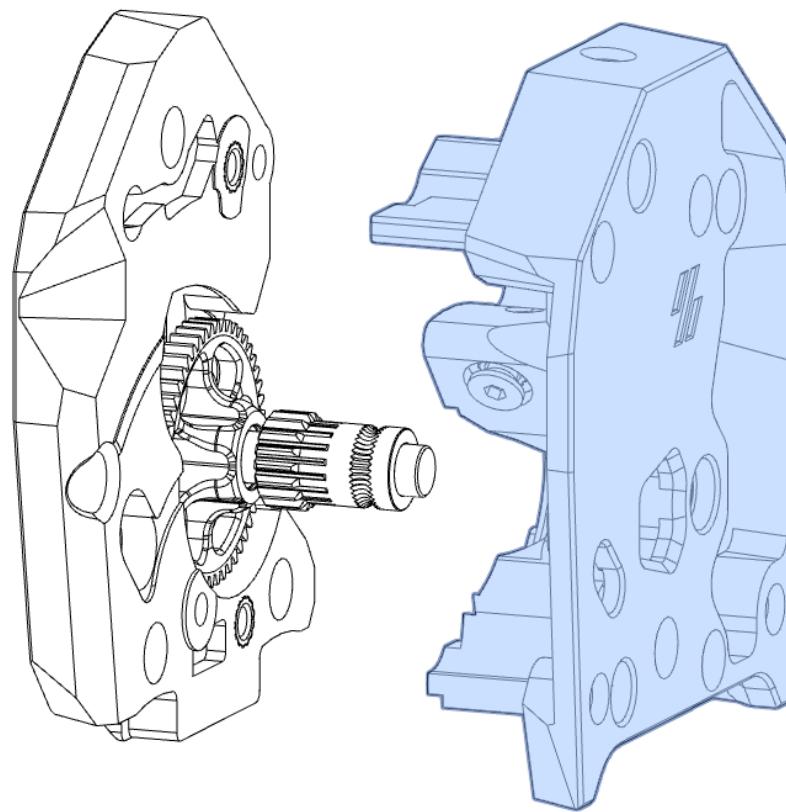
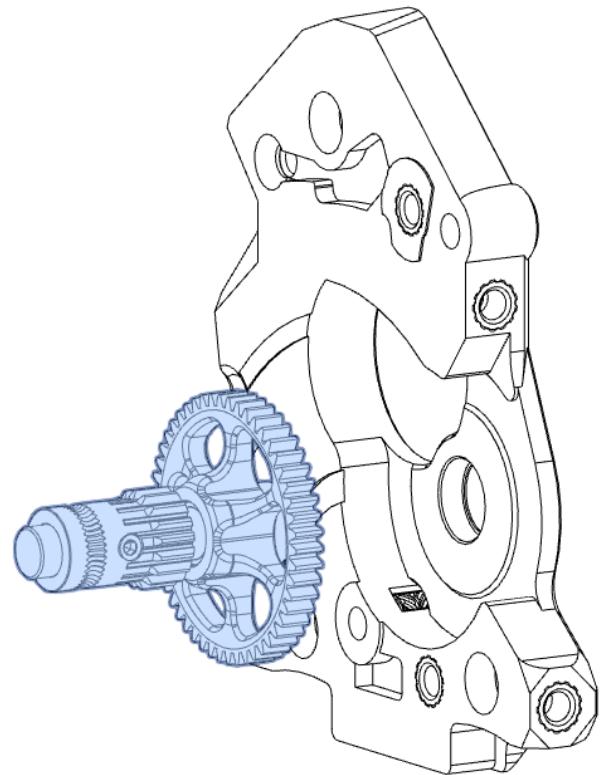


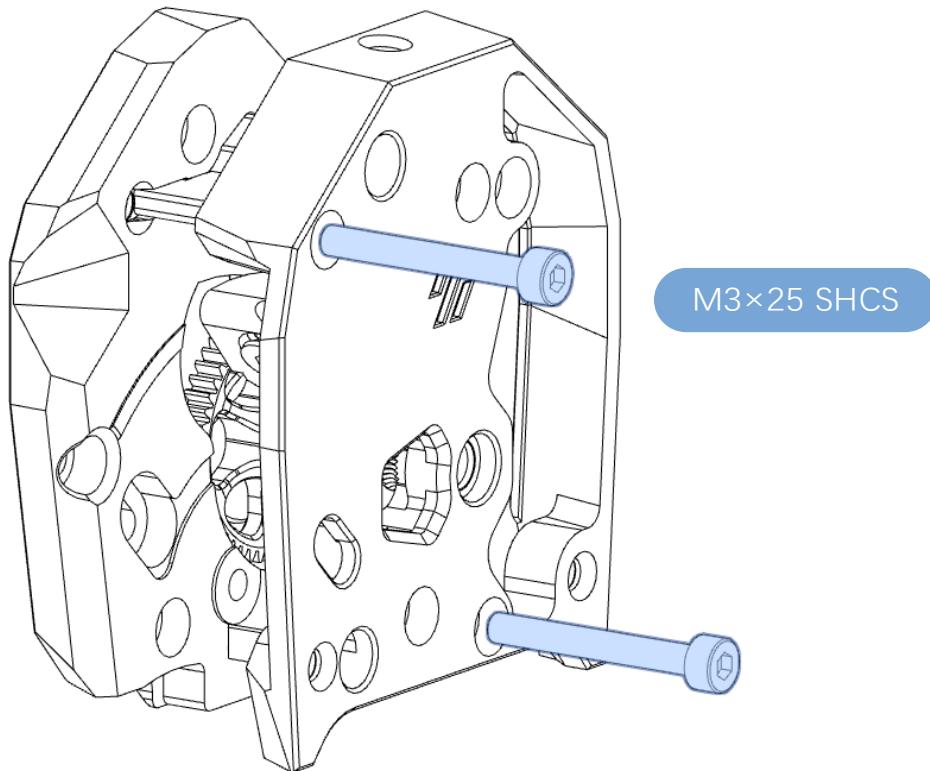
### THREAD LOCKER

The final position of the drive gear is set in a later step. Common thread lockers have a long enough working time to complete the steps without issues.

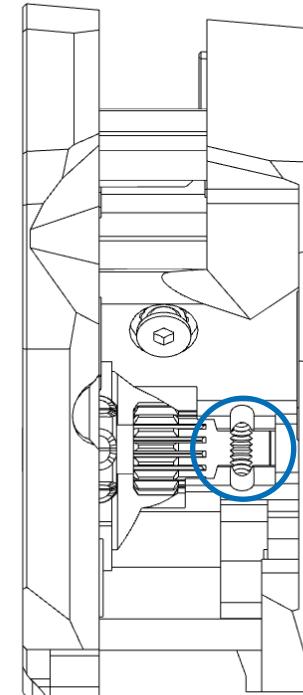
Familiarize yourself with the steps on the next 3 pages before you apply thread locker.

Complete the steps on the next 3 pages after applying the thread locker.

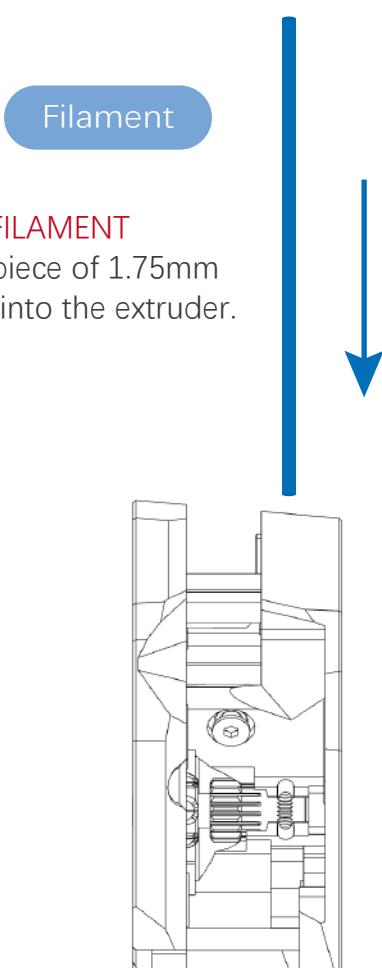


**DON'T OVERTIGHTEN**

Tighten until the plastic bends and cracks.  
Back up 2 turns, discard parts, reprint and try again.

**INITIAL ALIGNMENT CHECK**

Check if the filament path aligns with the toothed section of the drive gear.



Filament

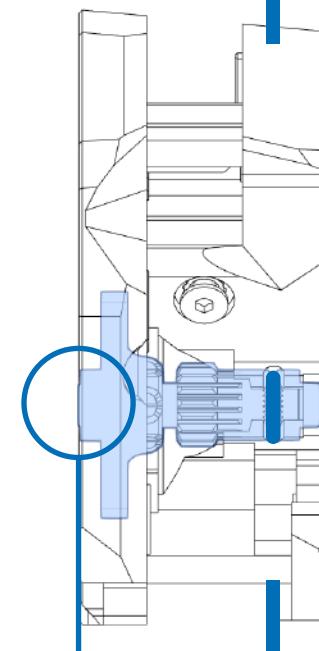
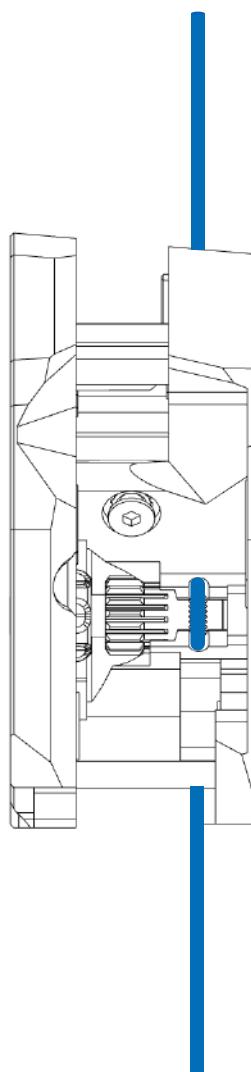
**INSERT FILAMENT**

Insert a piece of 1.75mm filament into the extruder.

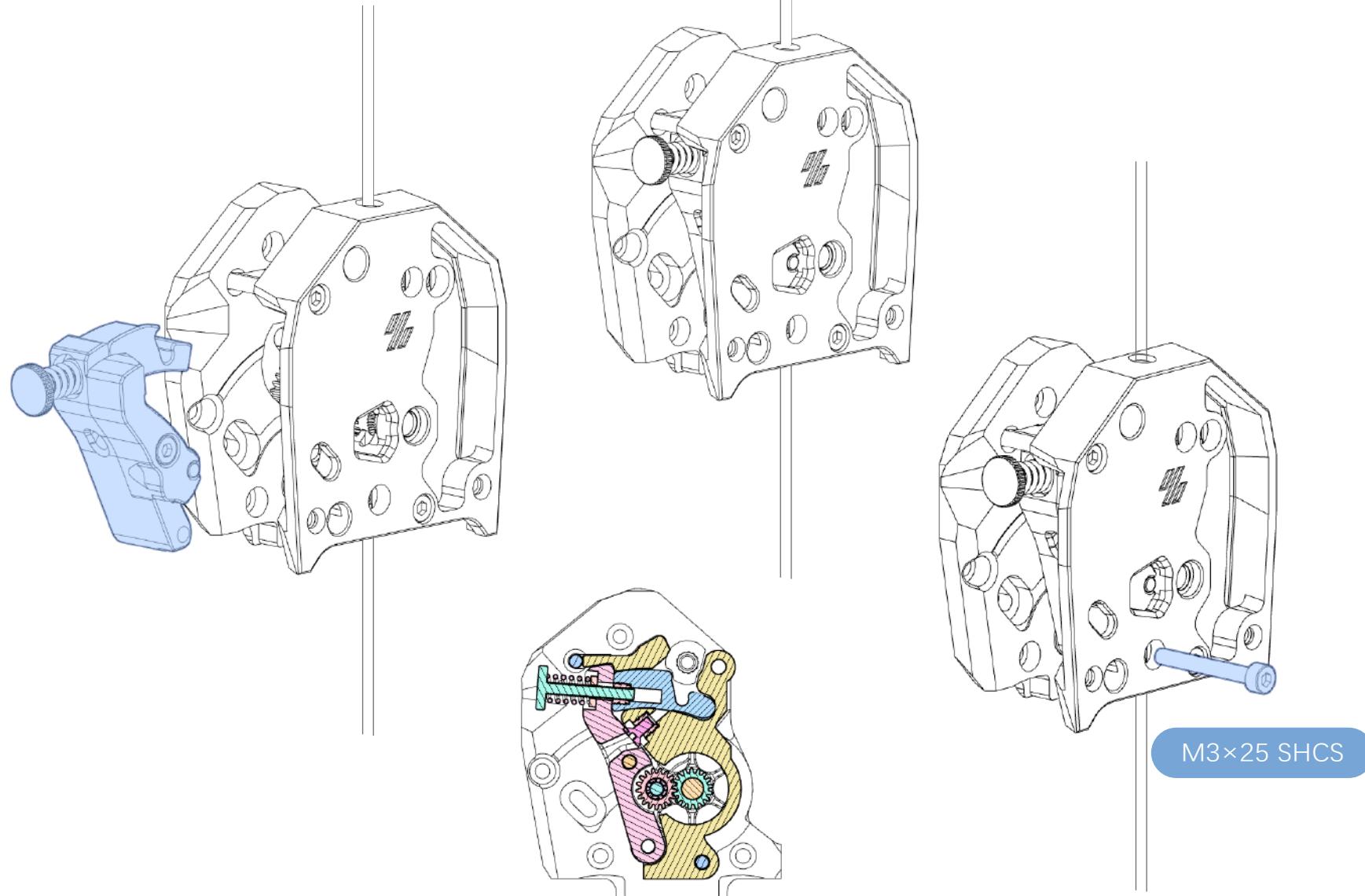
**CHECK ALIGNMENT**

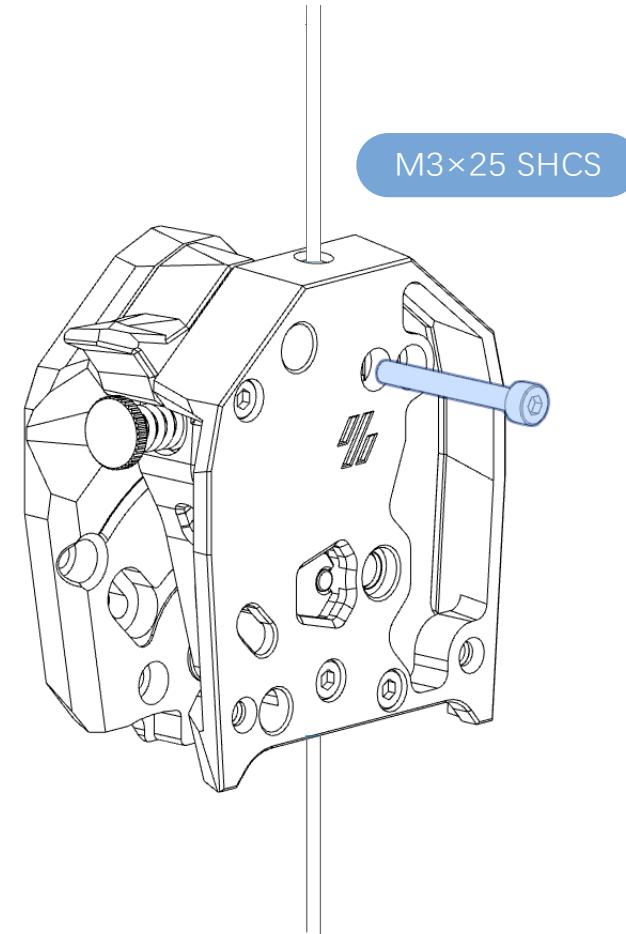
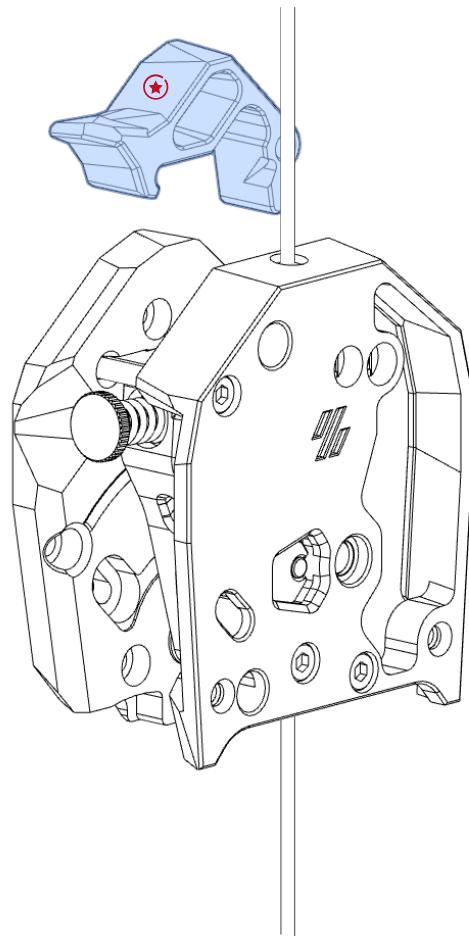
With the filament inserted, verify if the filament path and drive gear are aligned.

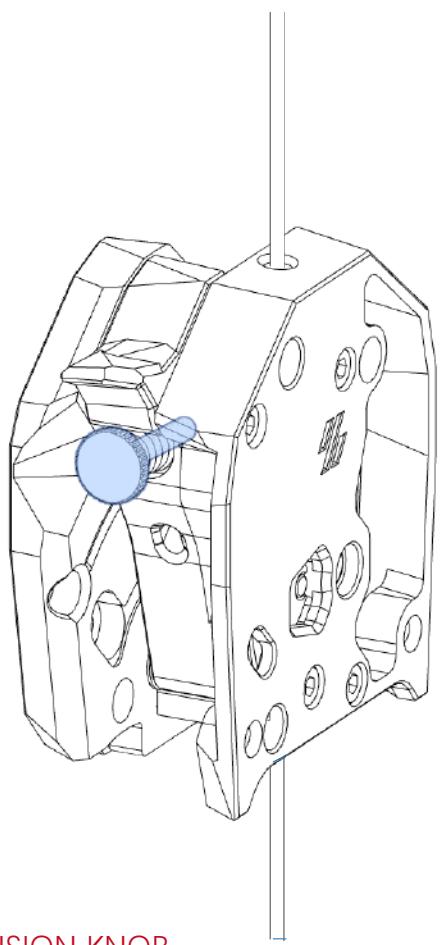
Loosen the set screw and adjust the position of the drive gear if required.

**CHECK FOR CLEARANCE**

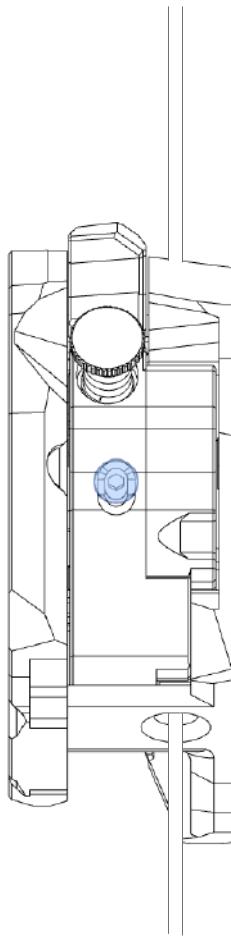
The drive shaft must not touch the motor housing. Make sure it does not sit above the surface of the printed part. Check if the shaft has sufficient clearance when fully seated. Depending on the shafts tolerances you may need to adjust the position of the drive gear or sand the face of shaft.



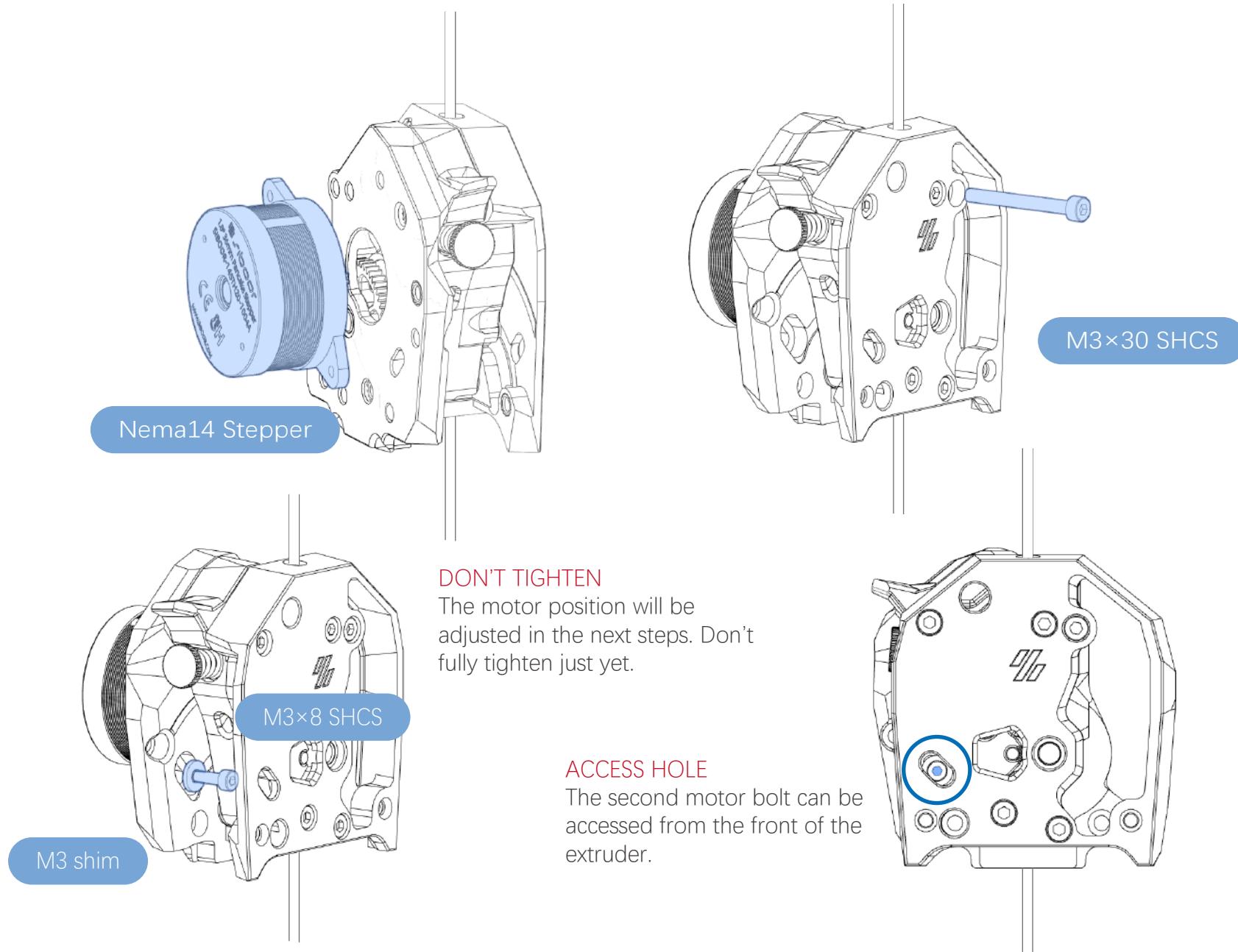


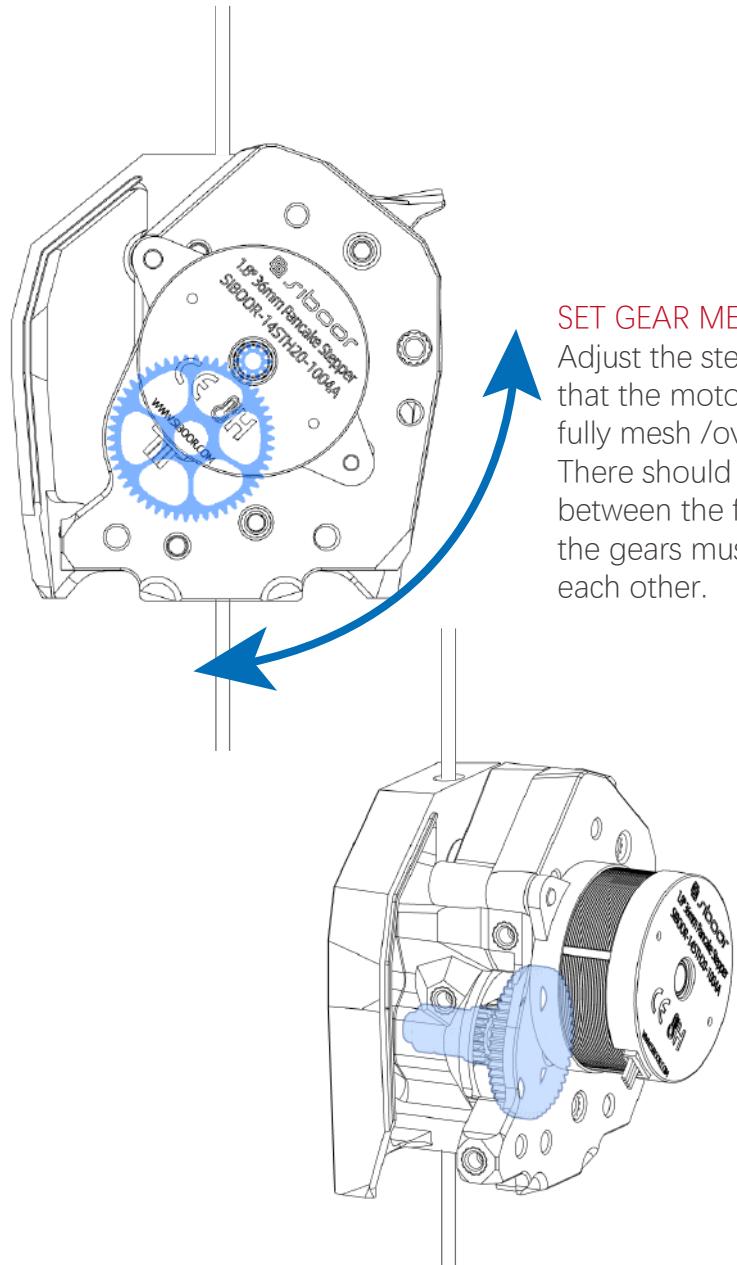
**TENSION KNOB**

Turning the thumb screw clockwise will increase the tension and grip on the filament. Too much tension will result in print issues.

**ANTI SQUISH THINGYMAJIG**

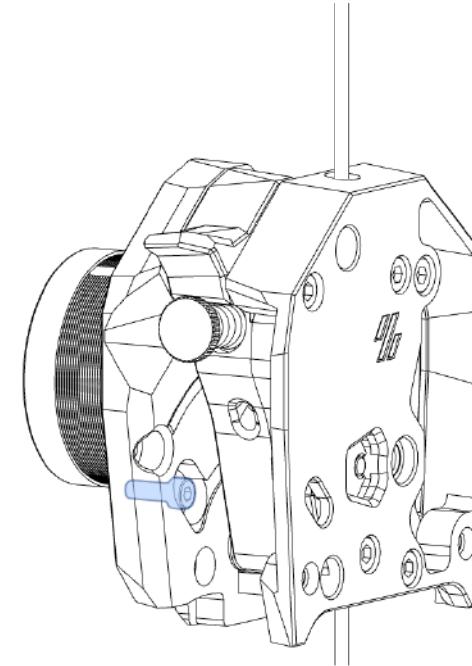
Softer and flexible materials will deform and extrude poorly under too much tension. ClockWork2 adds an adjustment feature to set the minimum distance between the drive gear and the idler, limiting the squish on the filament, and to prevent the gears from meshing too tightly or binding up the extruder.





#### SET GEAR MESHING

Adjust the stepper motor position so that the motor and extruder gear teeth fully mesh /overlap with each other. There should be a very small gap between the faces of the gear teeth; the gears must not press tightly against each other.

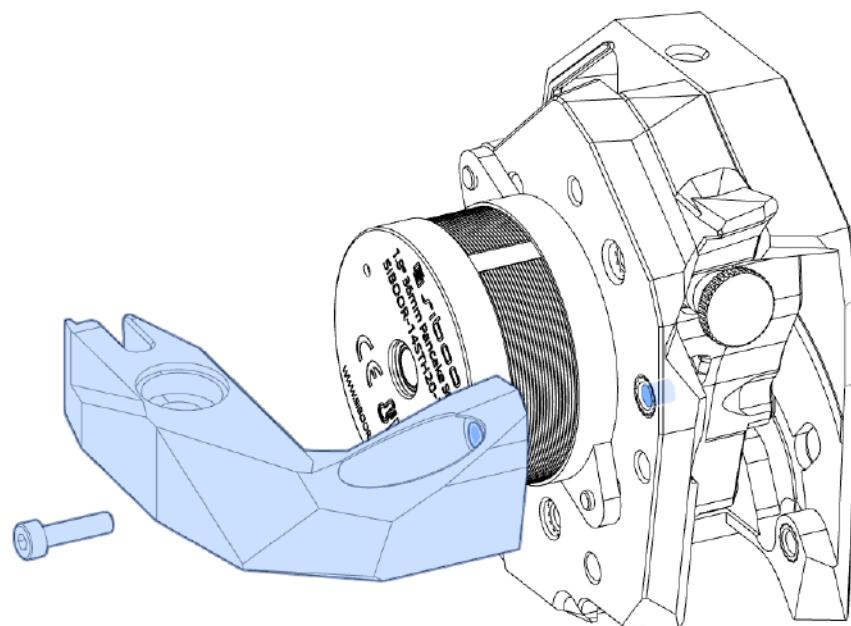


#### TIGHTEN WHEN DONE

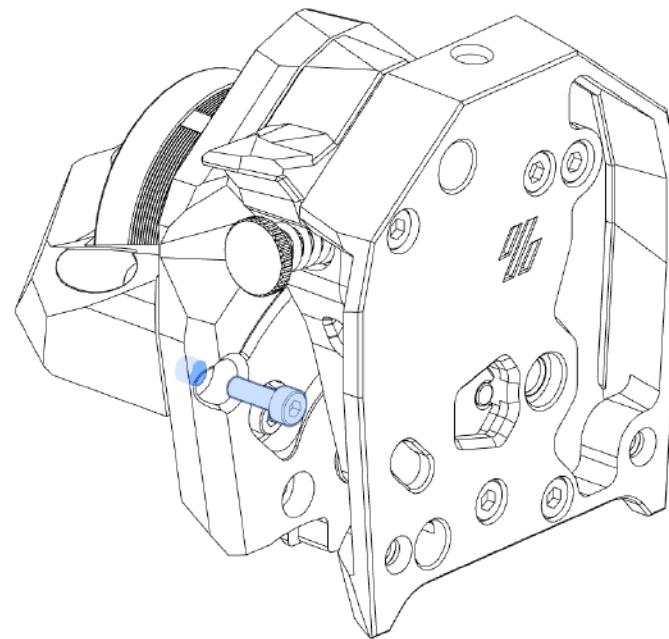
Don't forget to tighten the second motor bolt after adjusting

#### CHECK GEAR PLAY

The gear should have a slight play and should not be fully tight against the pinion. Adjust the position of the motor until you have a faint play



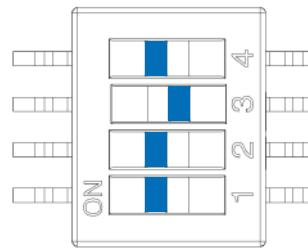
M3×10 SHCS



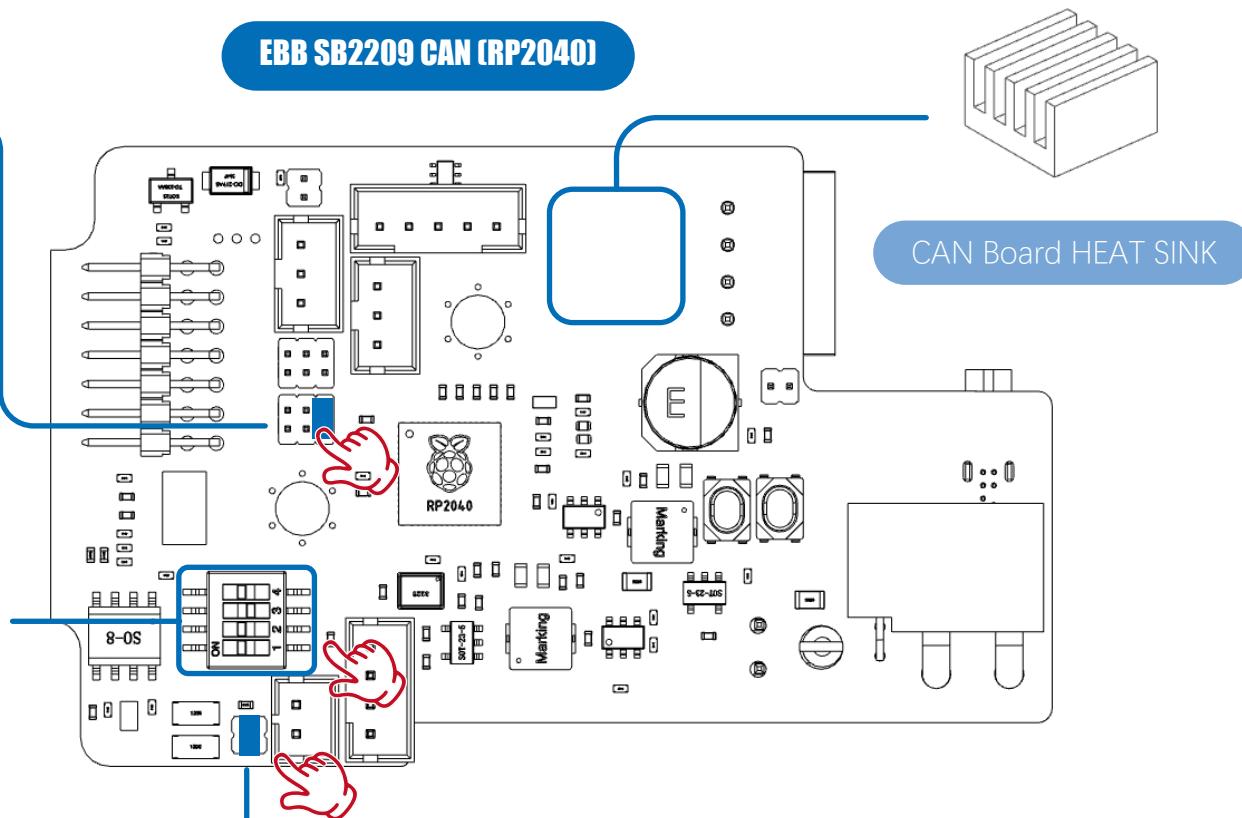
M3×8 SHCS

**SETTING FAN OUTPUT VOLTAGE**

Insert the jumper here to set the fan output voltage to 24V.

**CHECKING THE DIP SWITCHES**

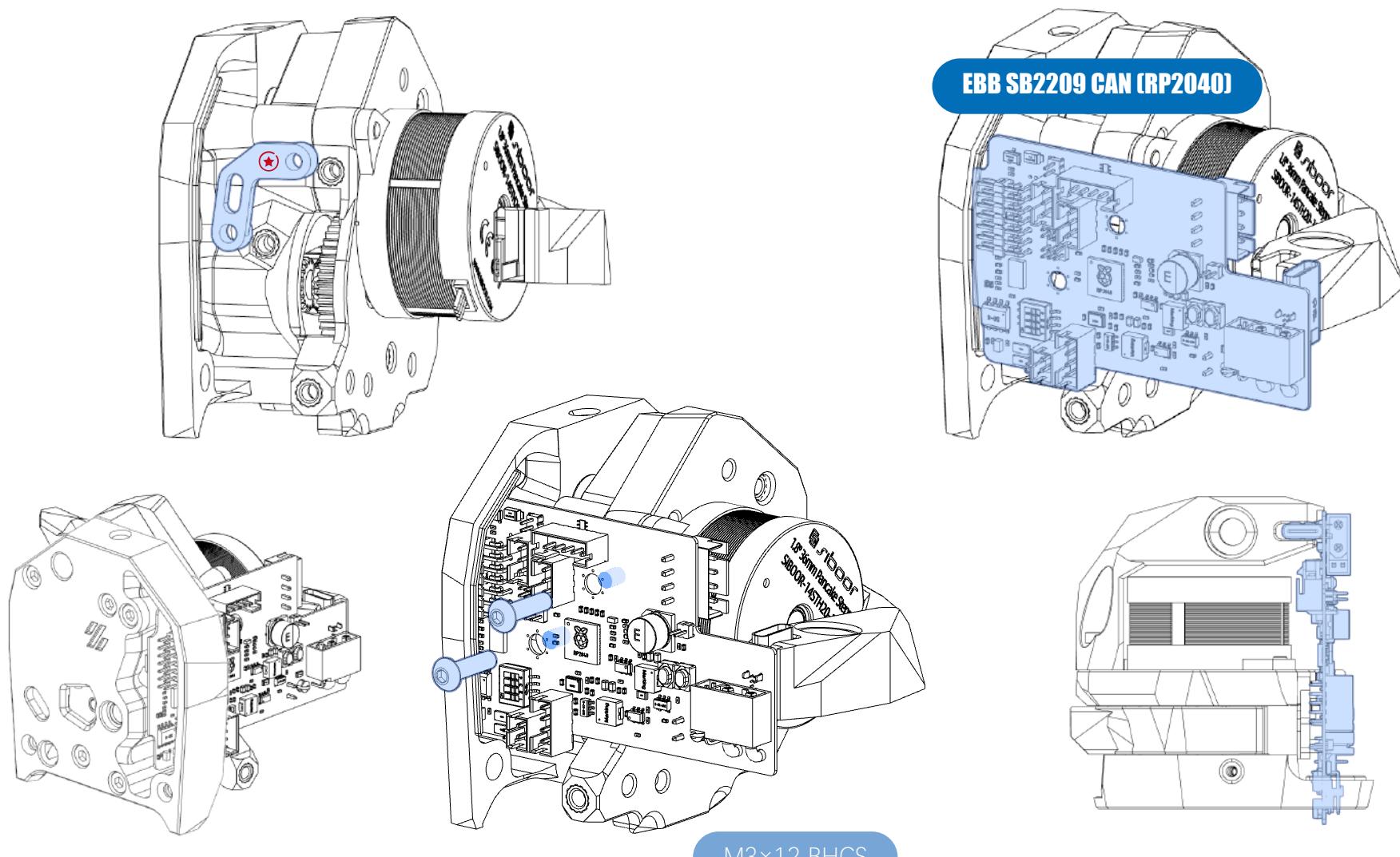
Verify that the dip switches are set as shown in the image. This is the configuration for the 2-wire PT1000.

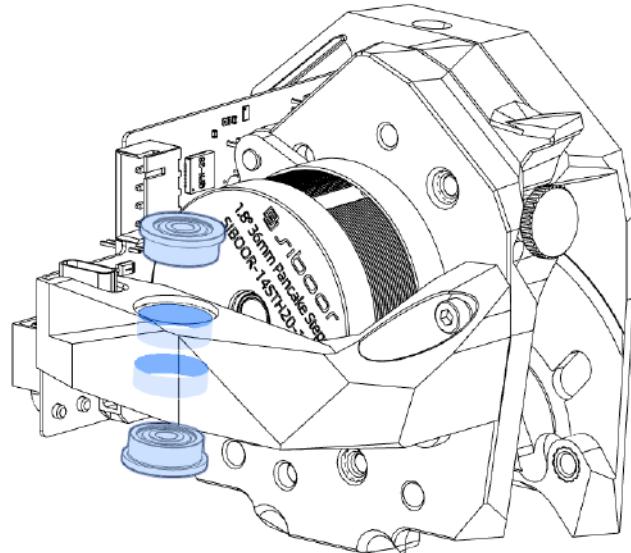
**EBB SB2209 CAN (RP2040)****CAN-120R JUMPER**

Insert the jumper here for the CAN-120R to enable proper CAN communication.

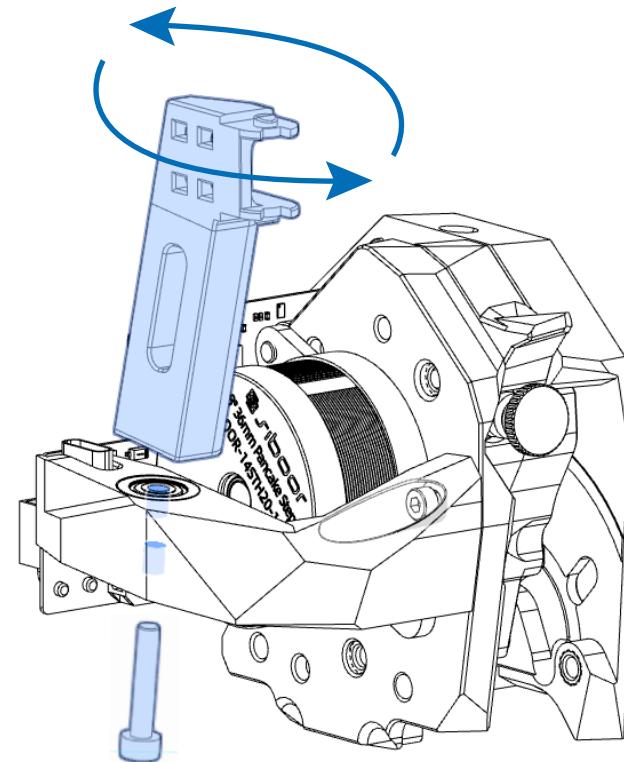
**WHERE DO I FIND THE JUMPERS**

The jumpers aren't packaged with the can board, but are in the same compartment where the can board was shipped in.





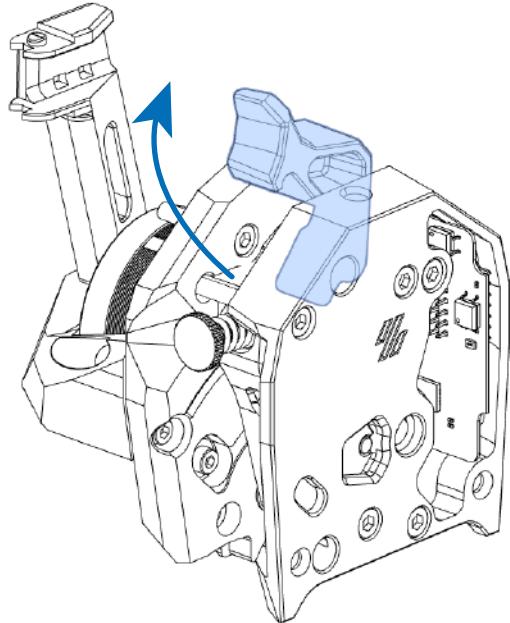
F623 Bearing



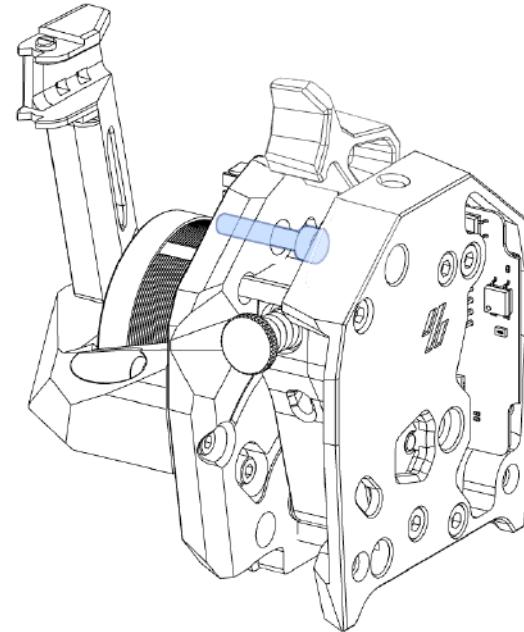
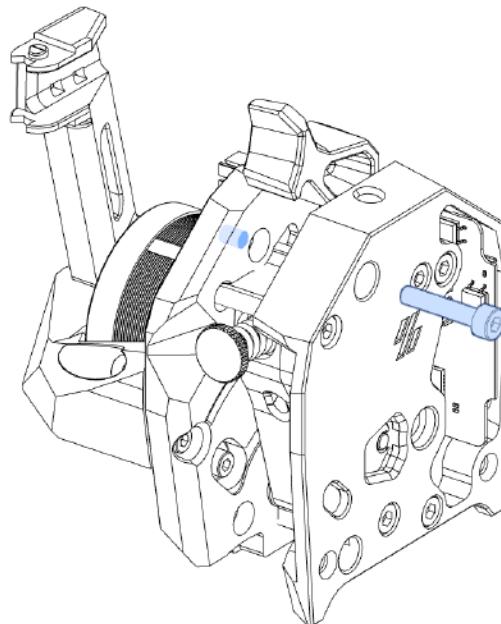
M3×20 SHCS

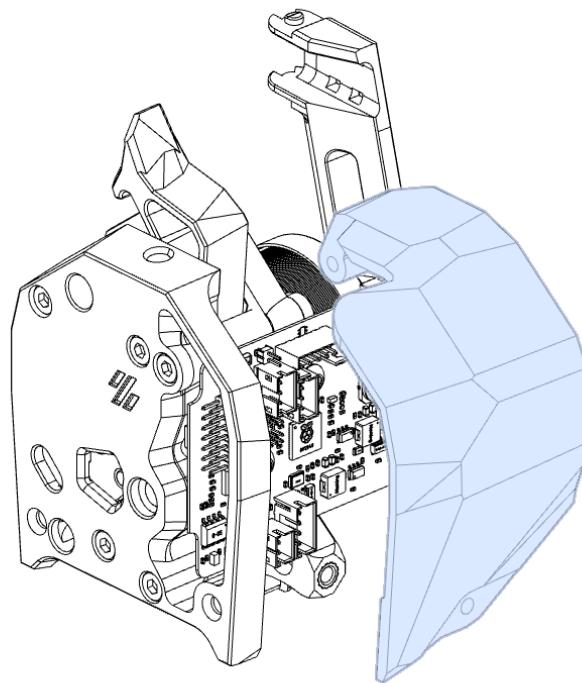
**DON'T OVERTIGHTEN**

The drag chain bracket should rotate smoothly 360°.

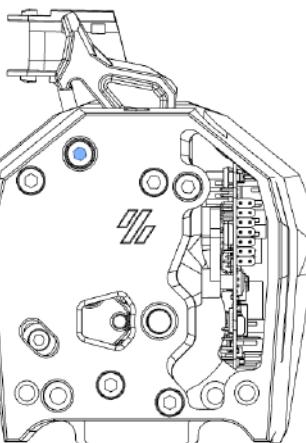
**OPEN LATCH**

Undo the filament latch to expose the bolt pocket for the cable cover.

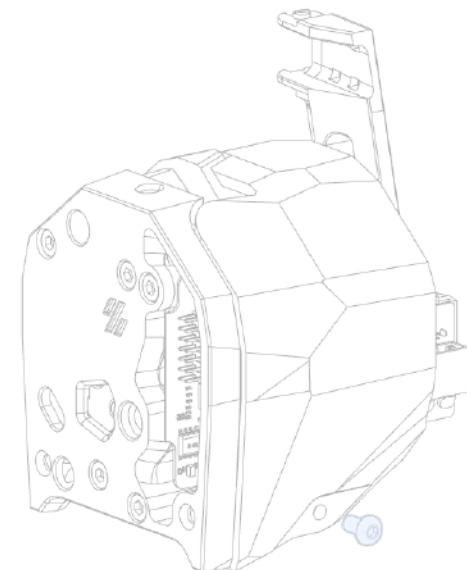
**M3×16 SHCS**

**ACCESS HOLE**

The bolt drive can be accessed from the front of the extruder.

**DON'T OVER-TIGHTEN**

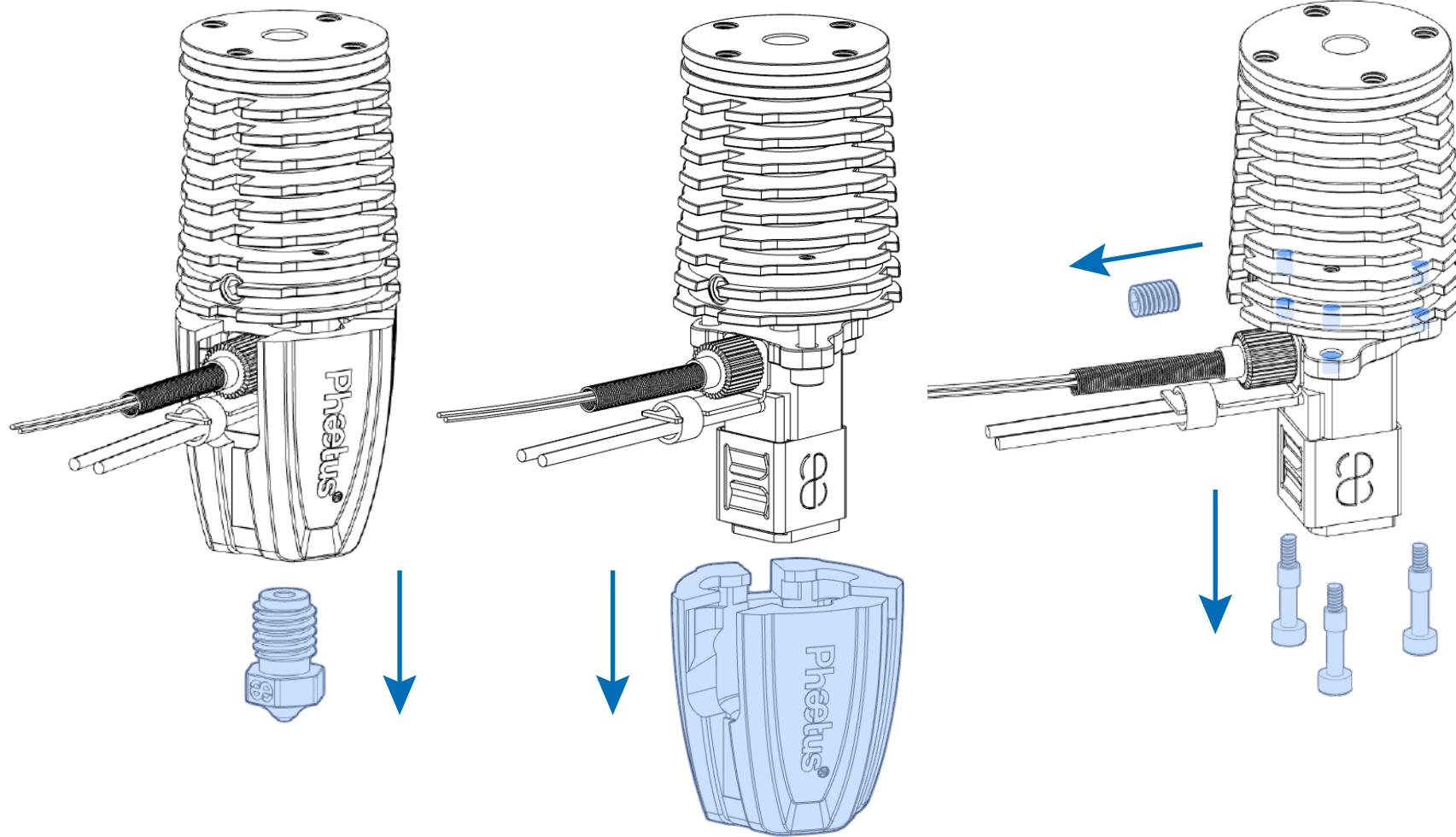
The bolt is threaded directly into plastic.

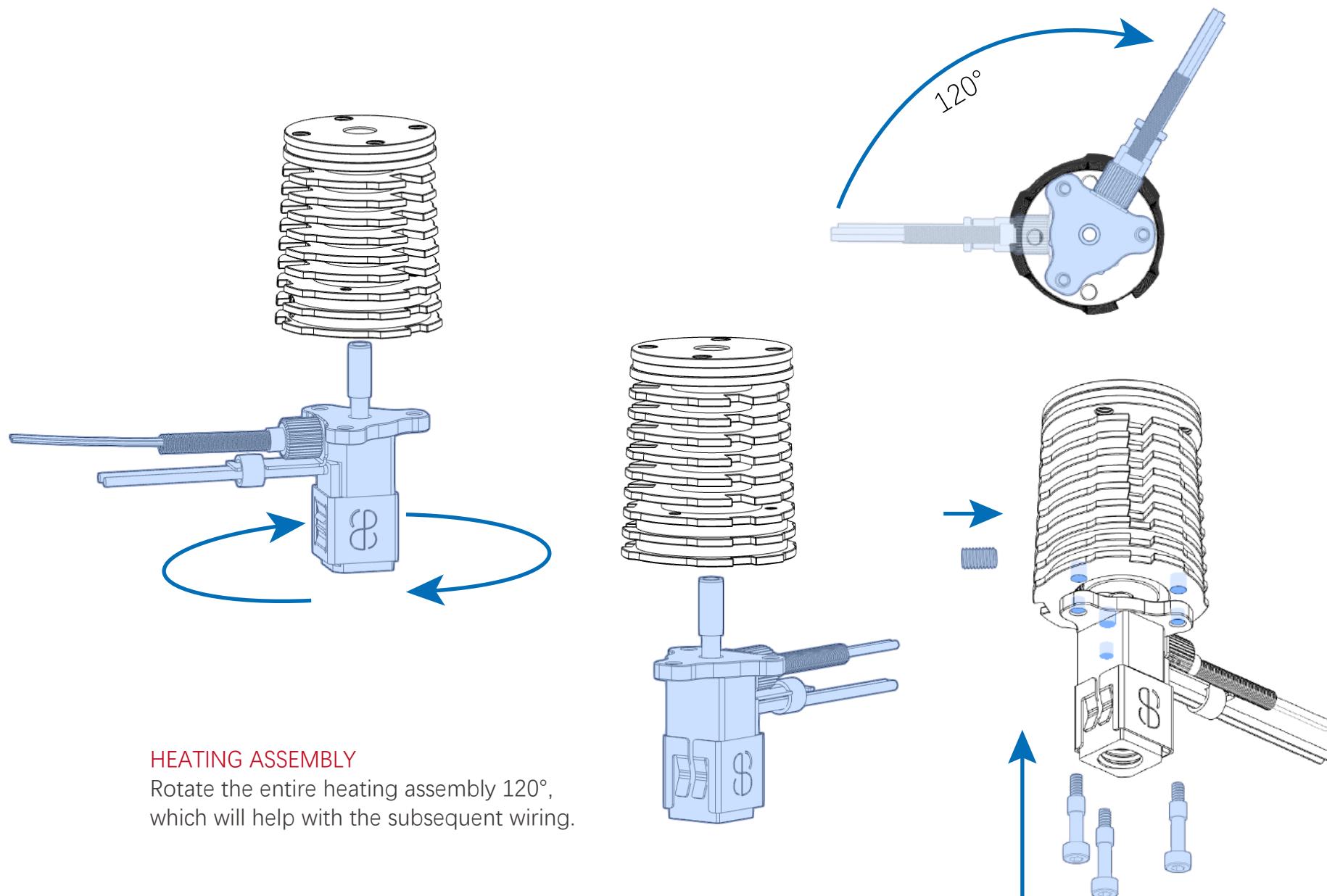


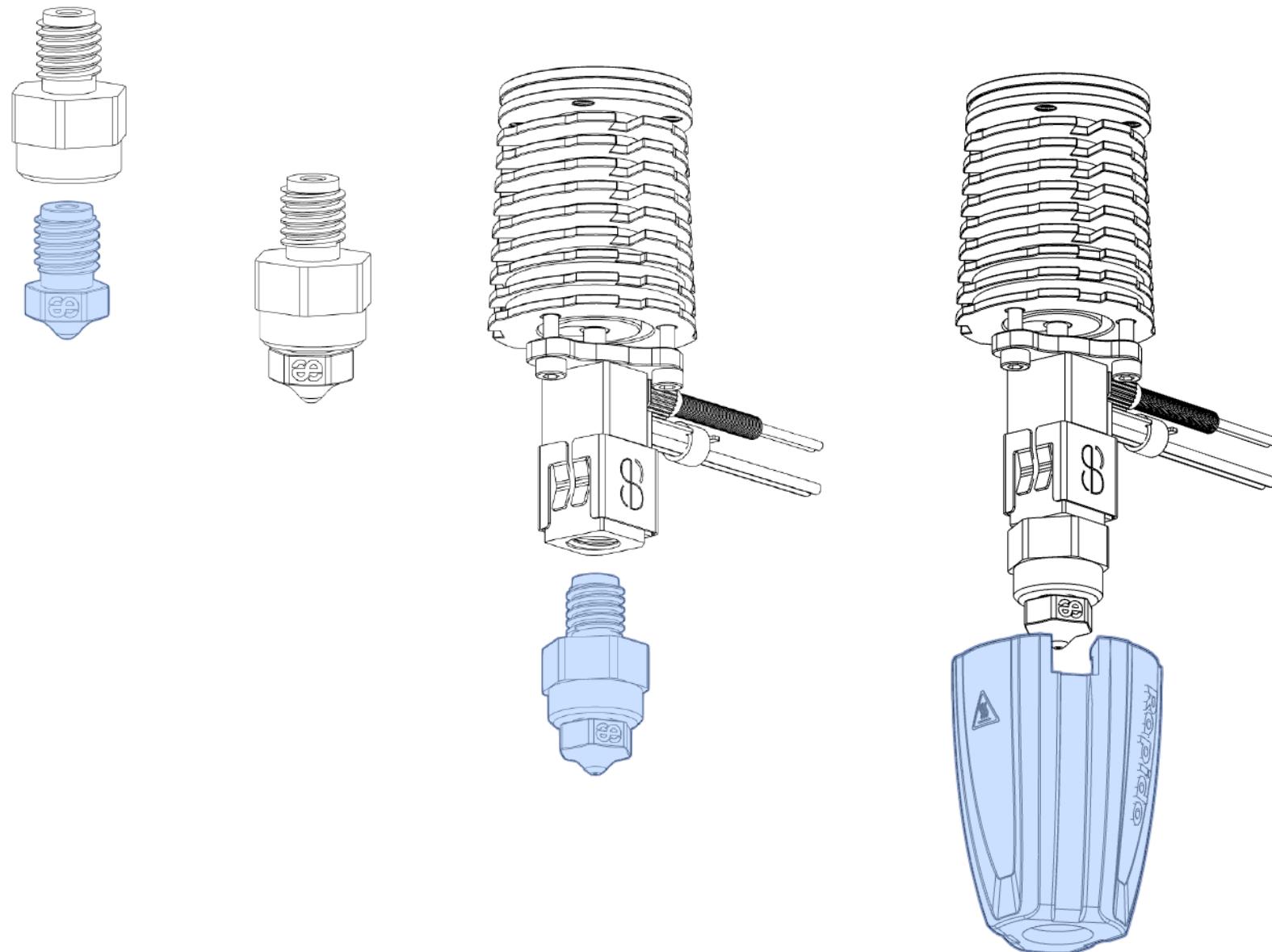
M3×6 BHCS

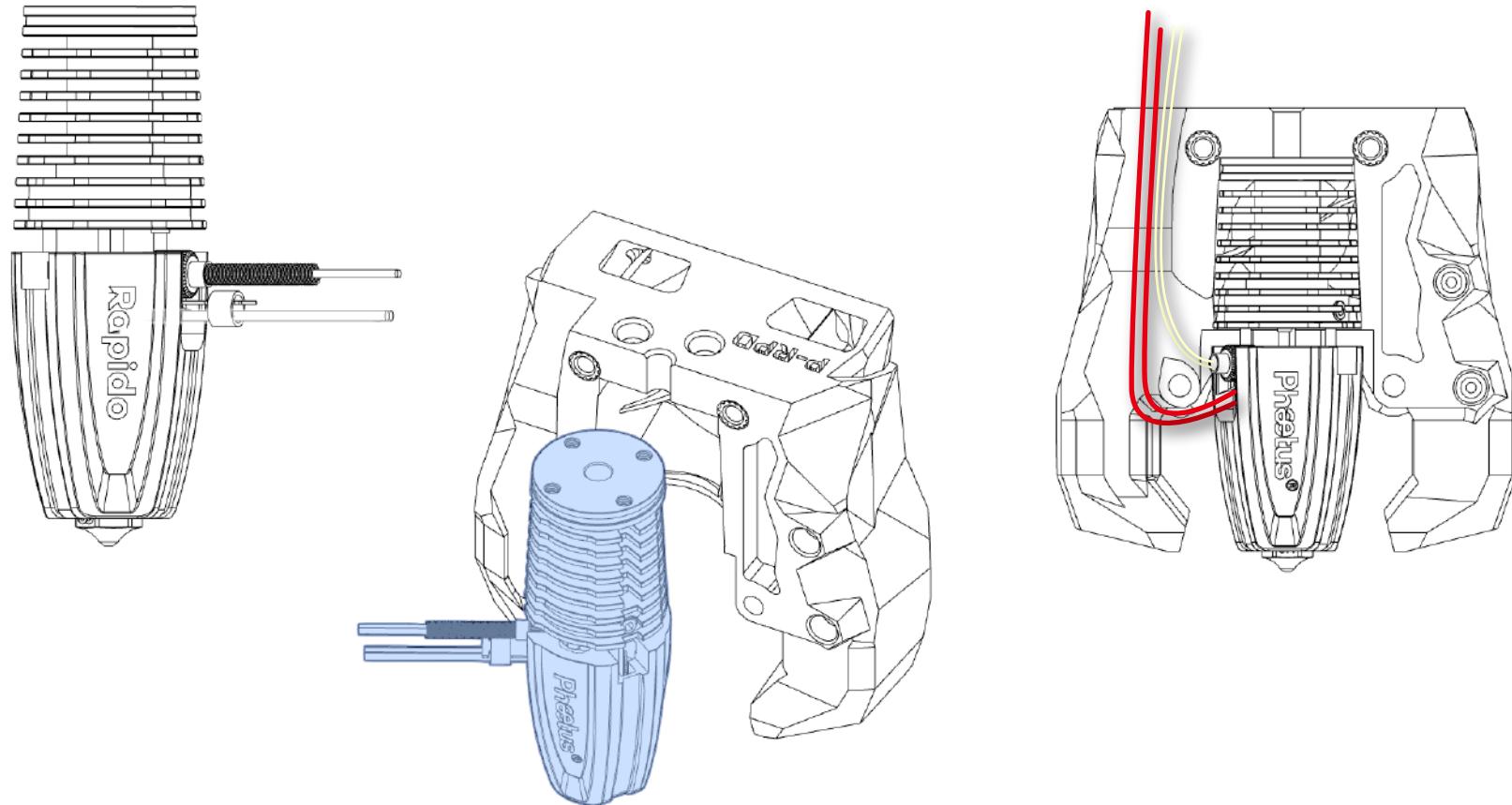
**CABLE COVER**

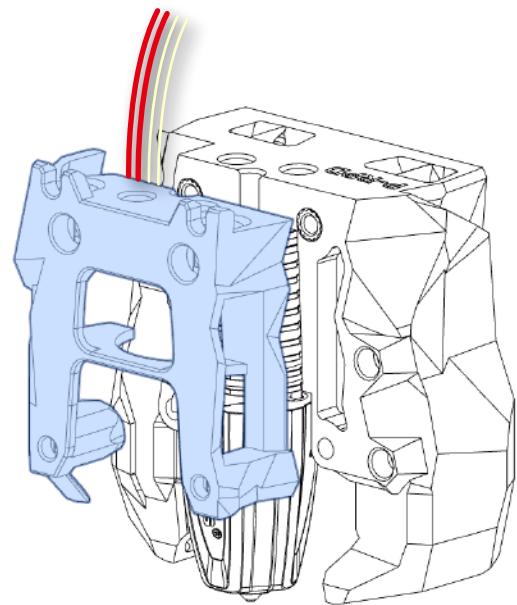
The cable cover can be secured using M3×6 BHCS screws, but not now, as we still need to do the wiring.



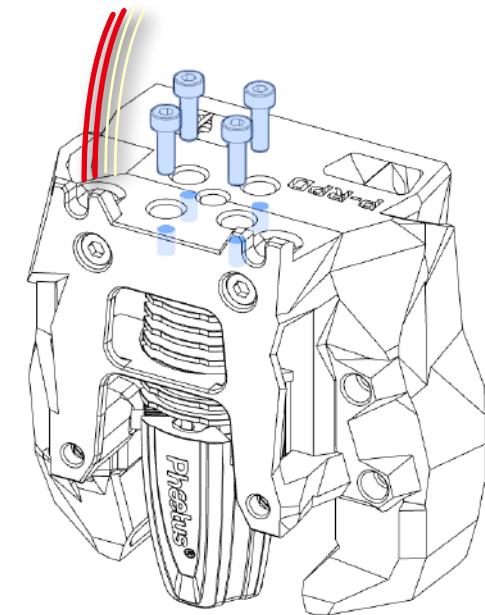
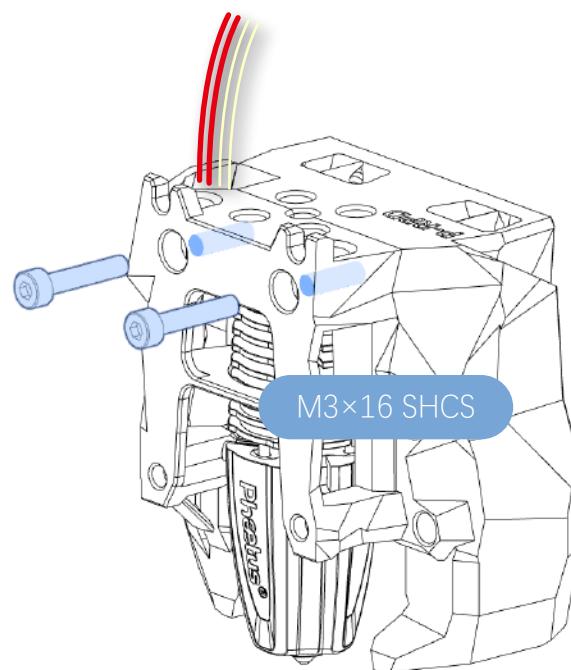






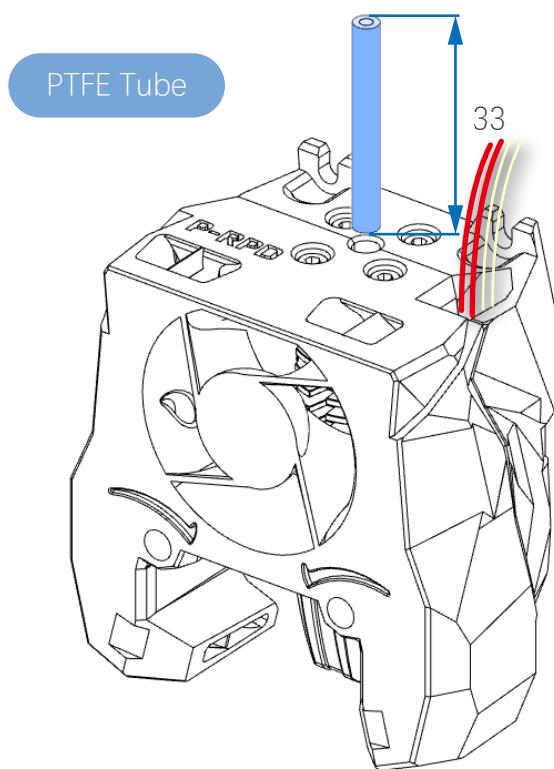


M2.5×8 SHCS

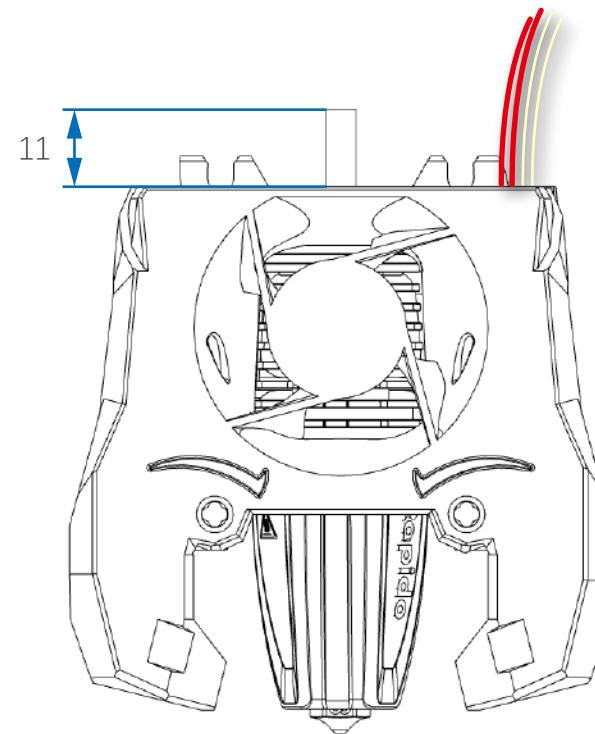


**PTFE TUBE**

Where is the PTFE tube? It is usually a 2-meter white tube that needs to be cut to size.

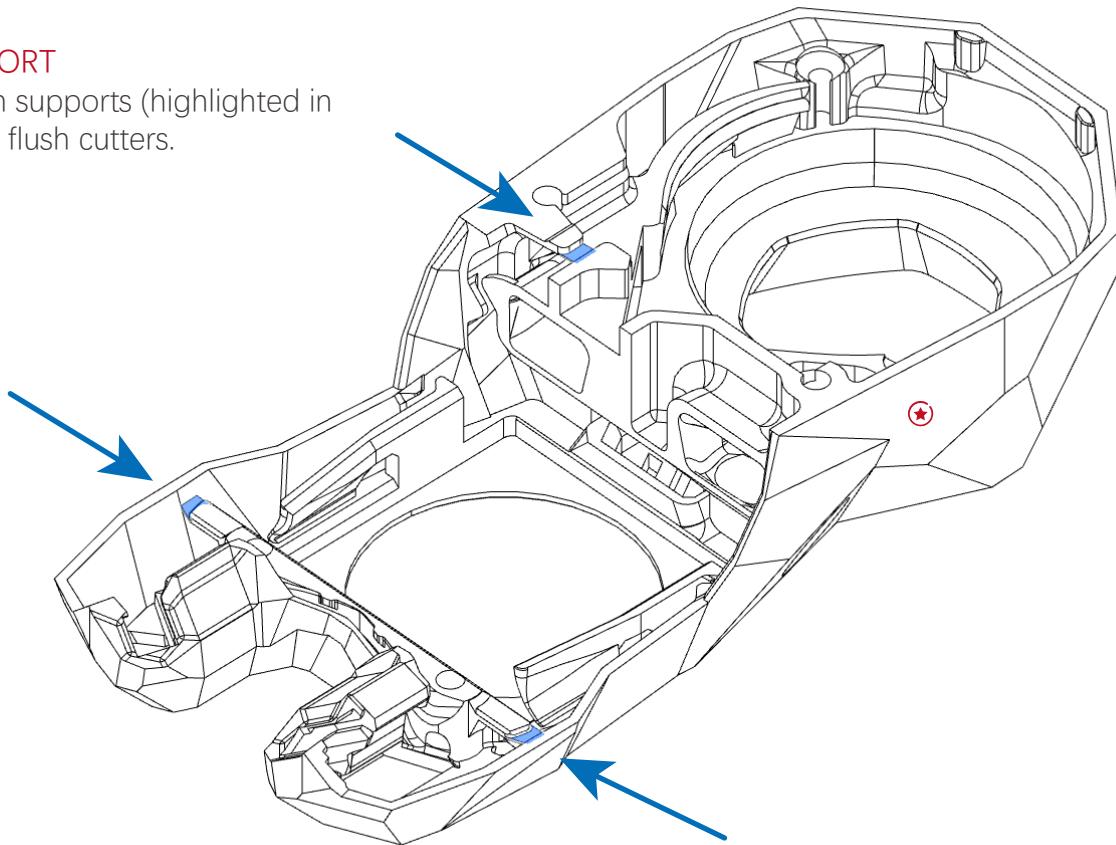
**PTFE STICKOUT**

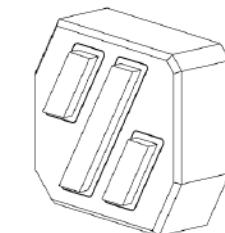
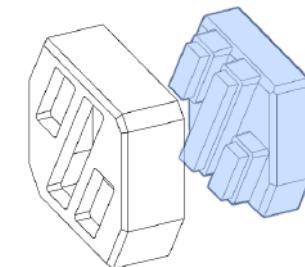
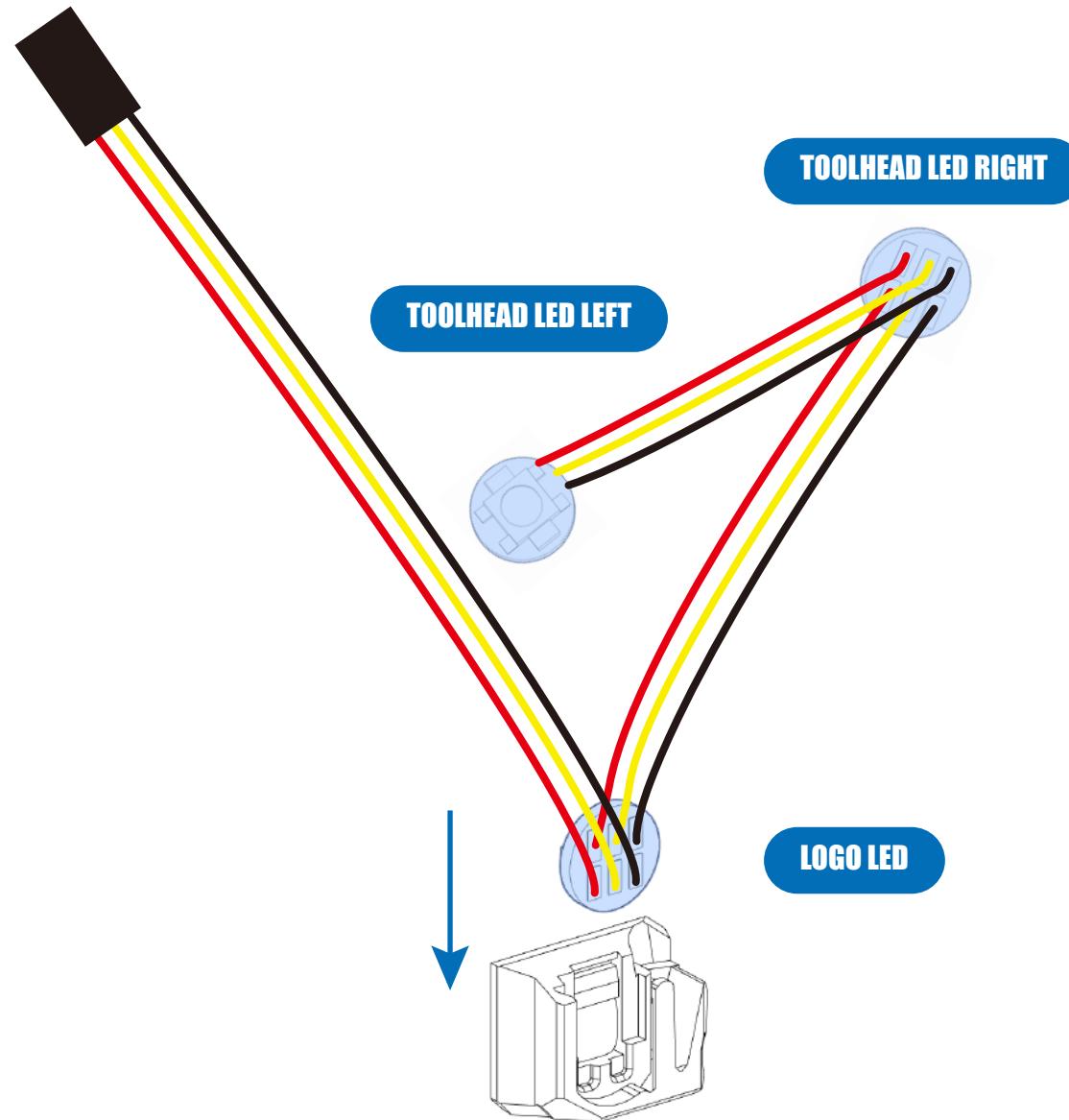
The PTFE tube should stick out 11mm above the surface of the printed part.

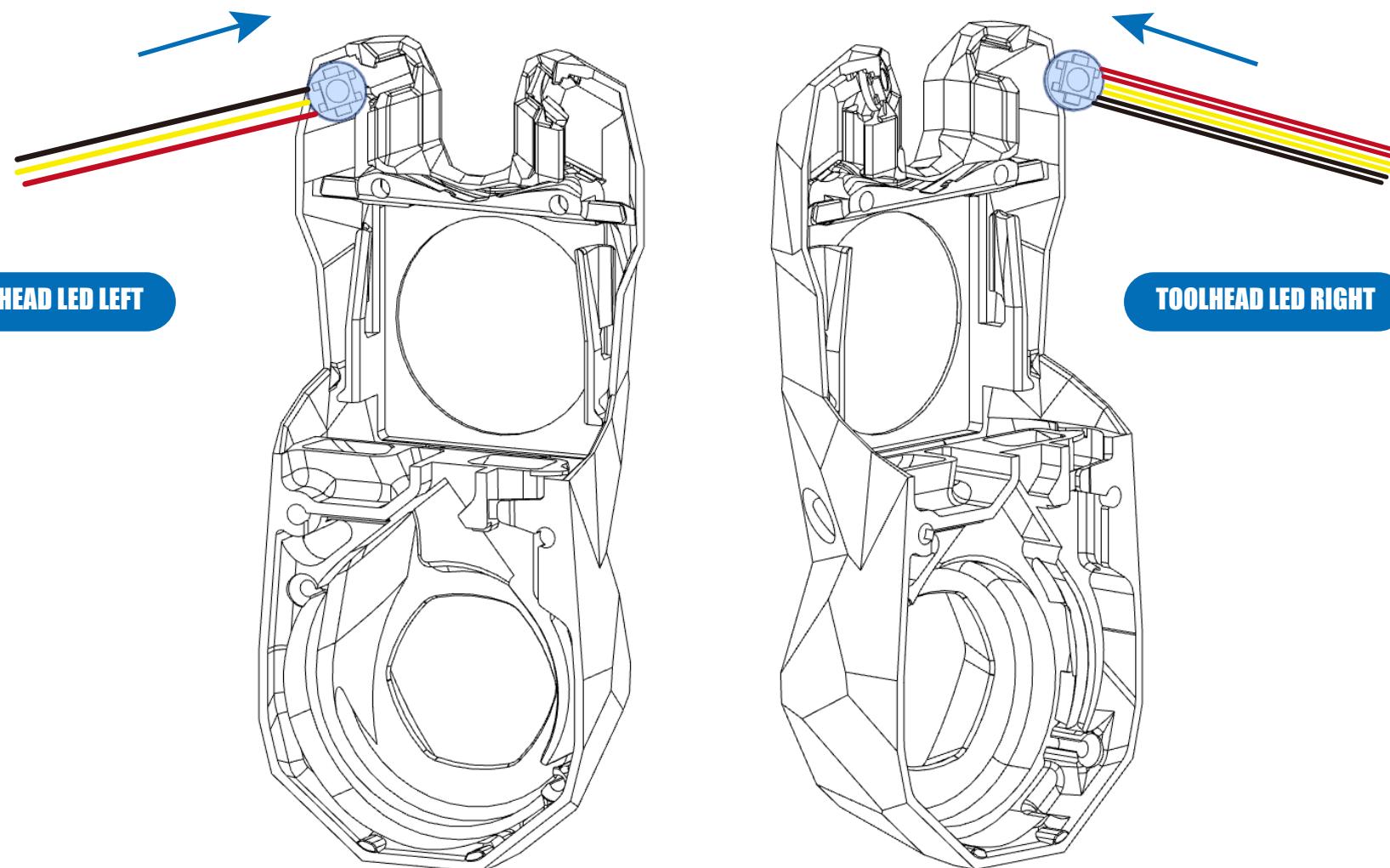


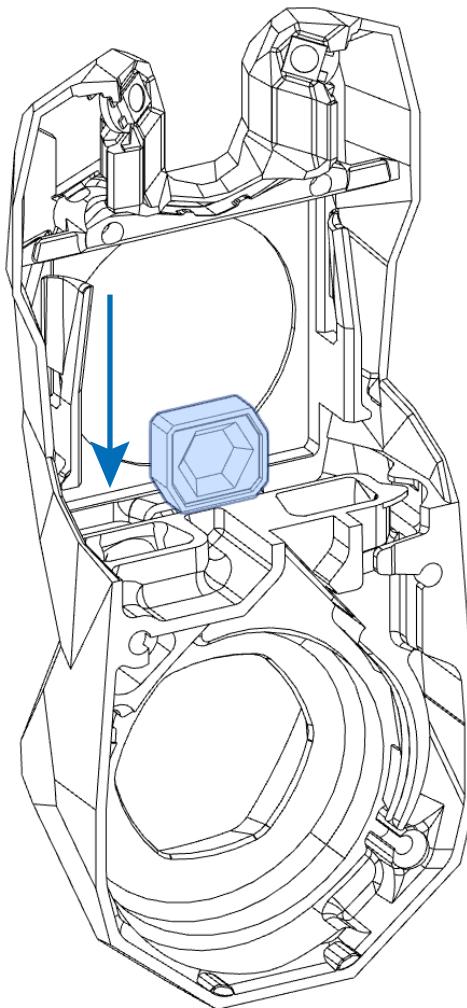
**REMOVE SUPPORT**

Remove built-in supports (highlighted in the image) with flush cutters.

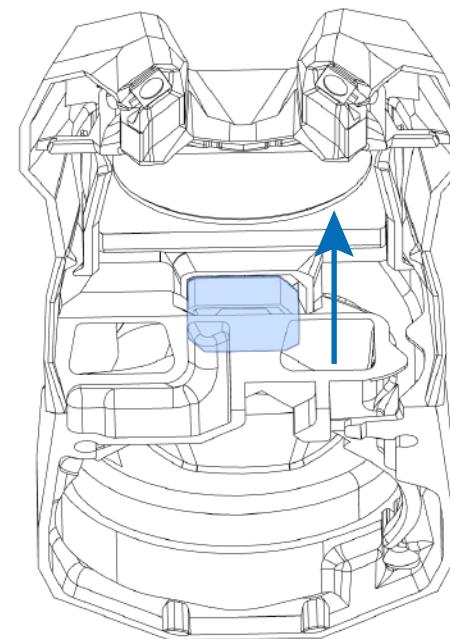


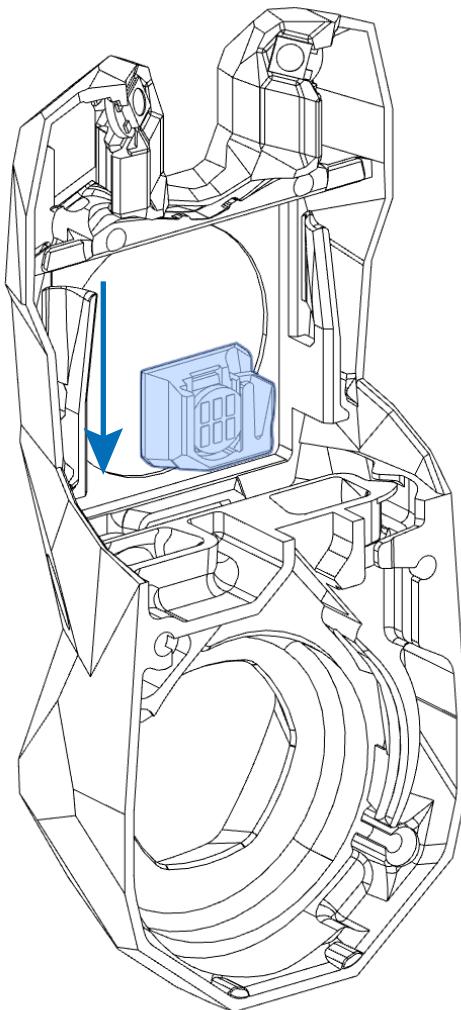




**DIFFUSER INSERTION**

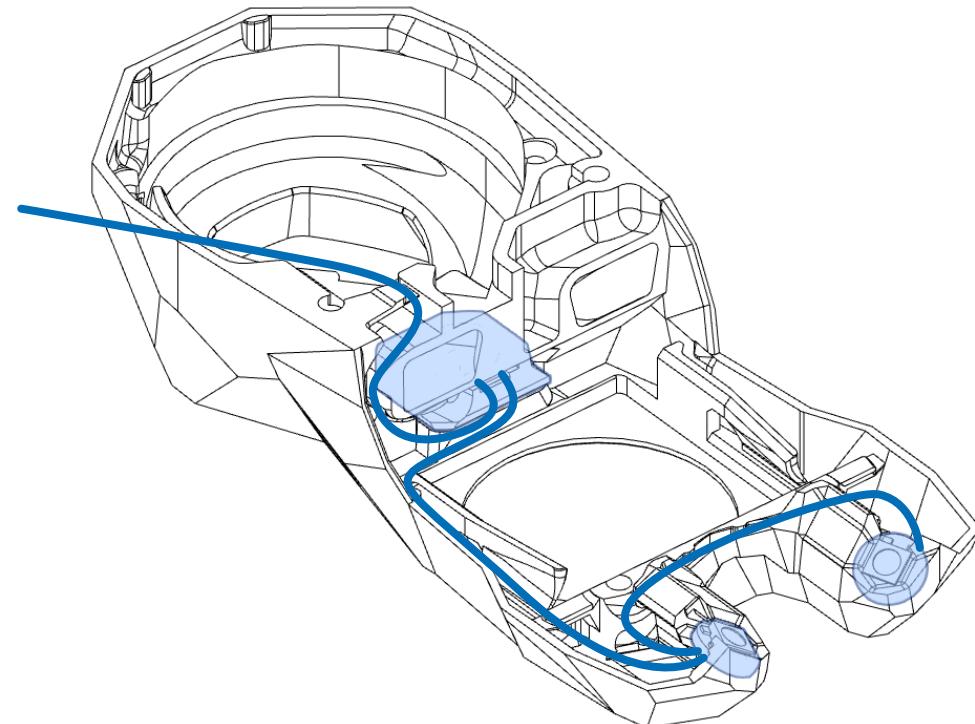
Insert the printed parts and push them towards the front.

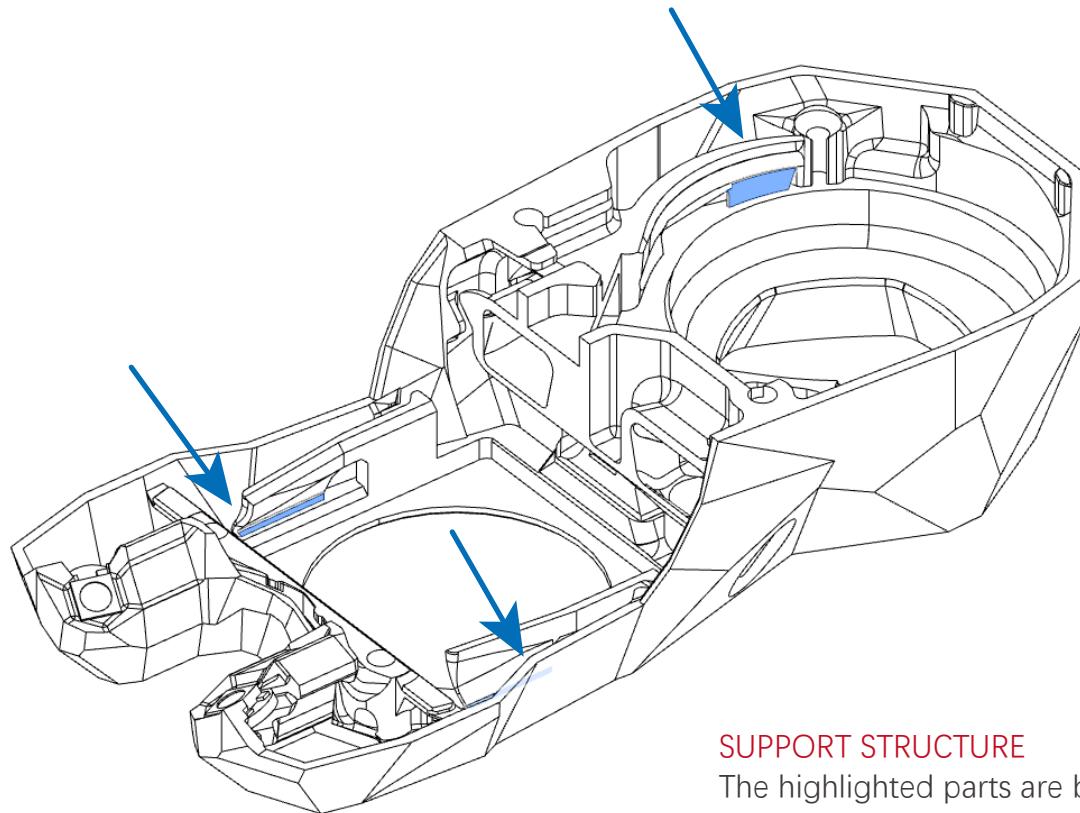




#### LED WIRE ROUTING

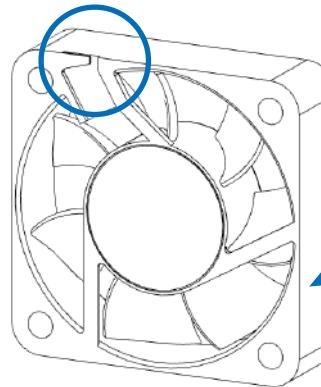
Route the LED wires as shown; wires exit on the right side.





#### SUPPORT STRUCTURE

The highlighted parts are built-in support structures. They are designed to break during the fan installation.



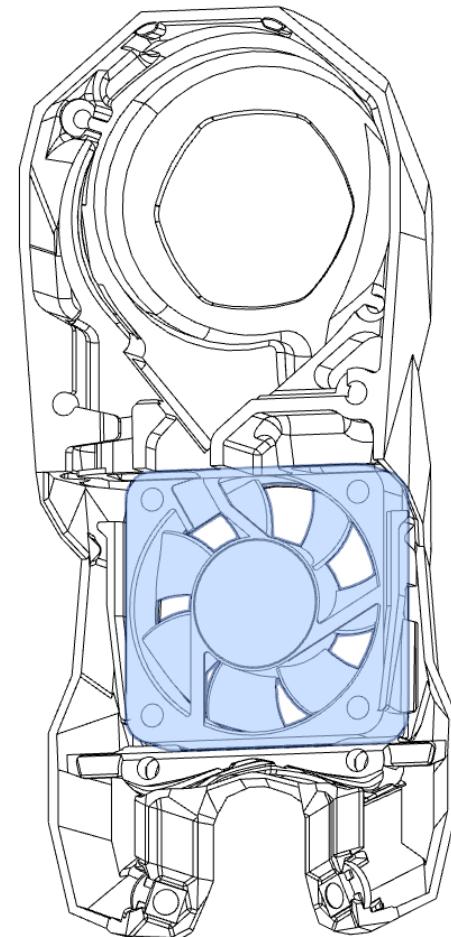
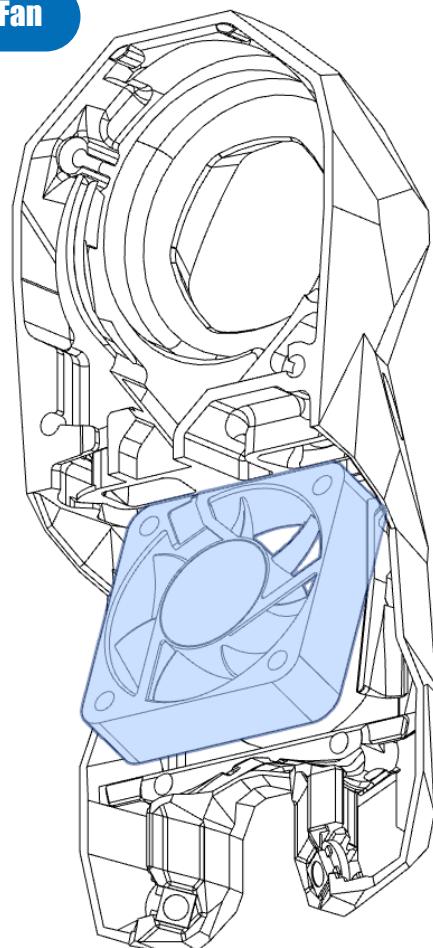
4010 Fan

**FAN ORIENTATION**

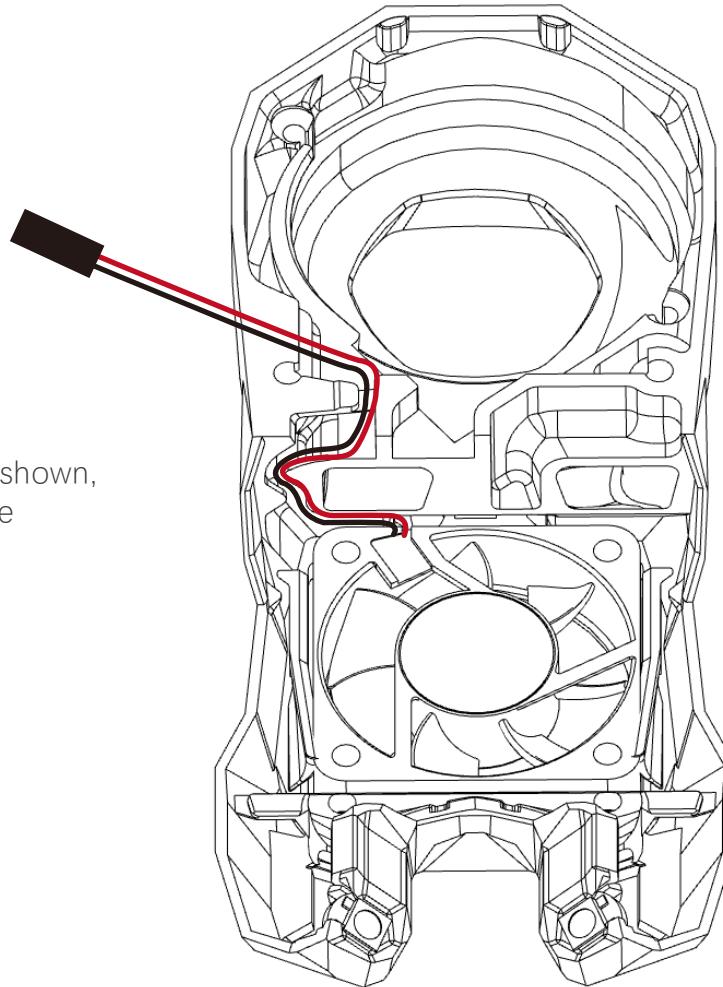
Rotate the fan so that the wires exit on the top and the air is pushed "inwards".

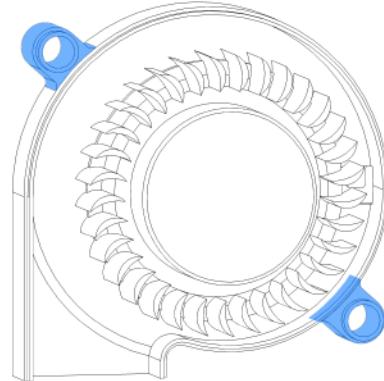
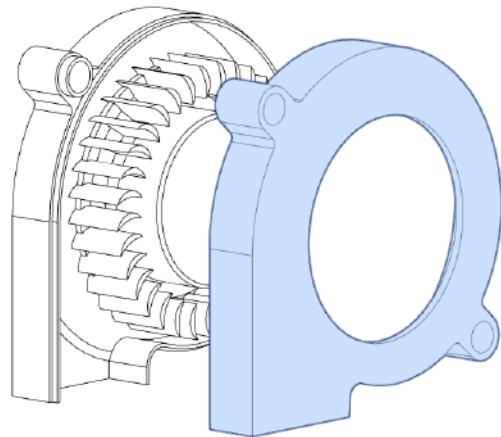
**FAN INSERTION**

Insert the fan at a slight angle and clip it into place.  
Mind the fan orientation.



**FAN WIRE ROUTING**  
Route the fan wires as shown,  
exiting on the right side





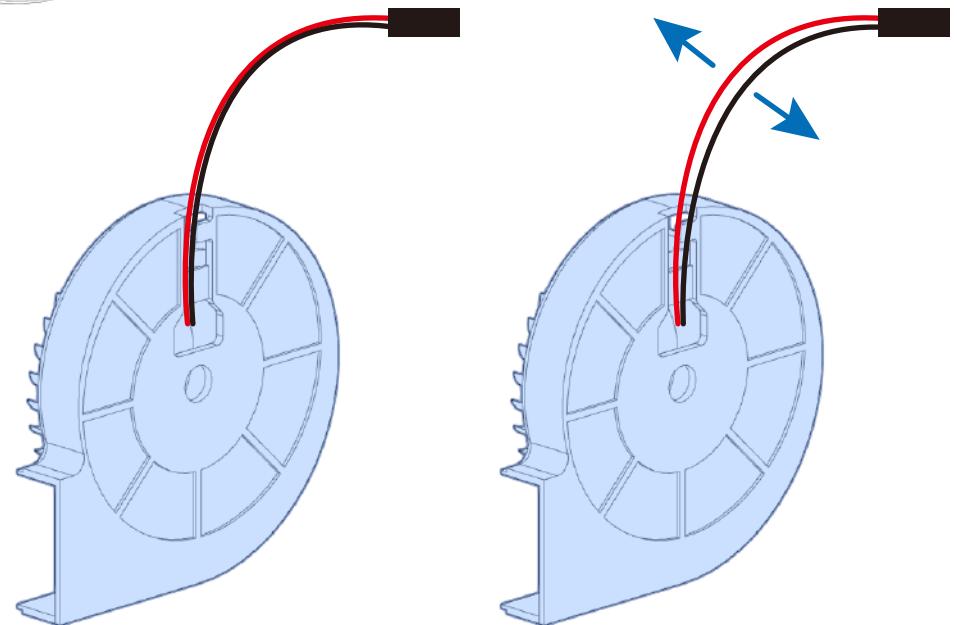
5015 Blower

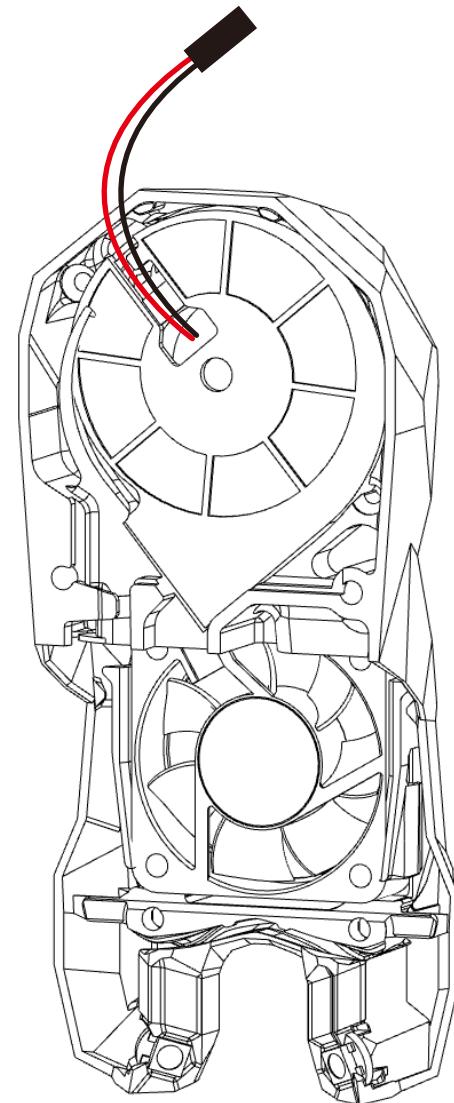
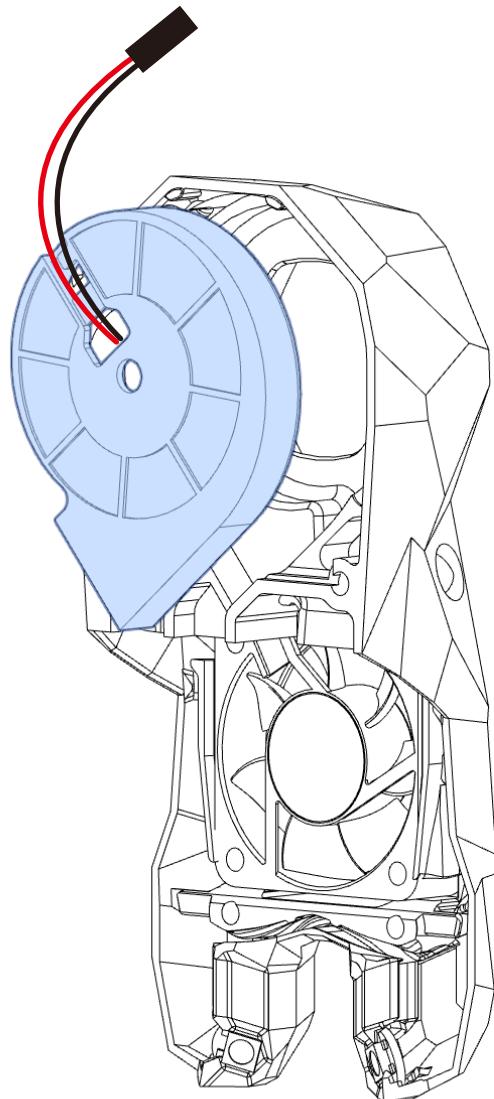
**FAN PREPARATION**

Remove the front of the 5015 fan. Clip off and file down the stock mounting ears.

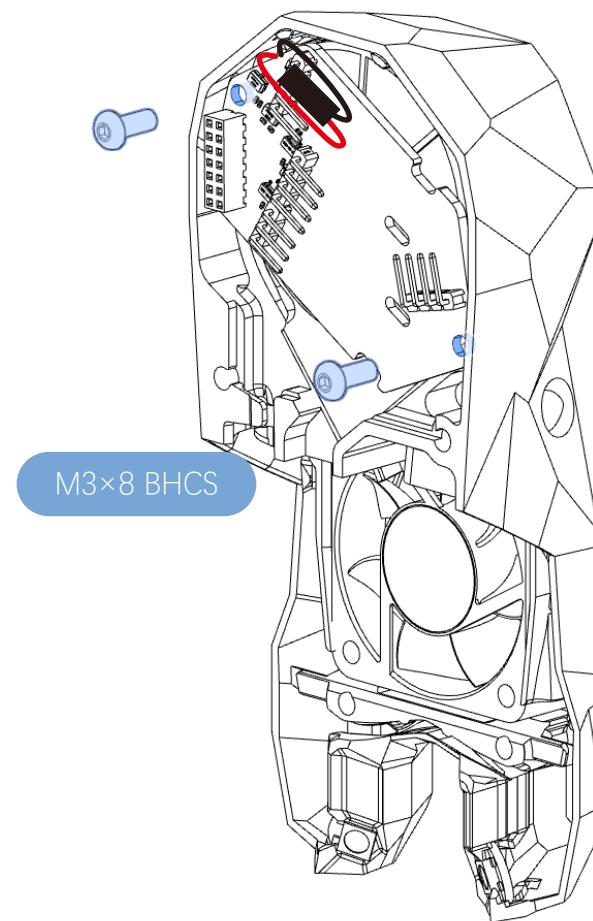
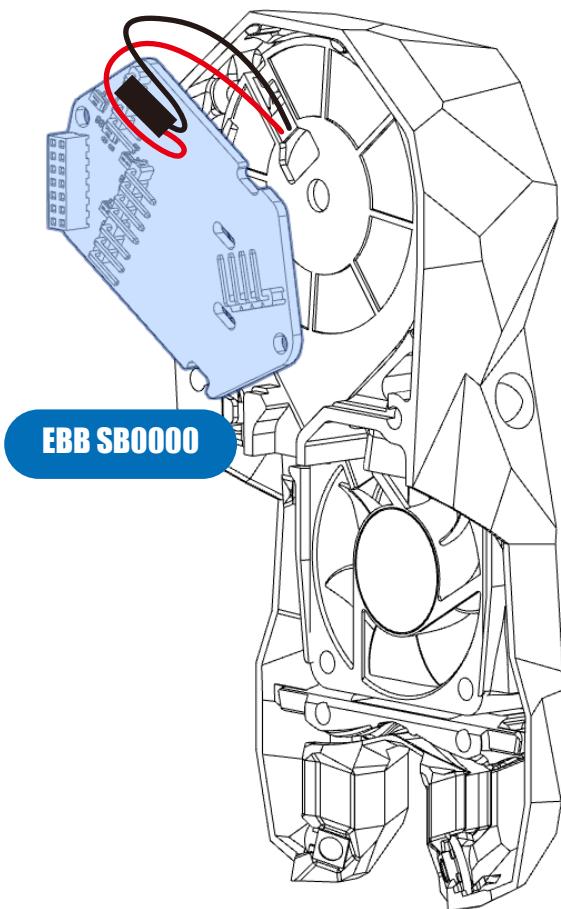
**5015 Blower Wiring Instructions**

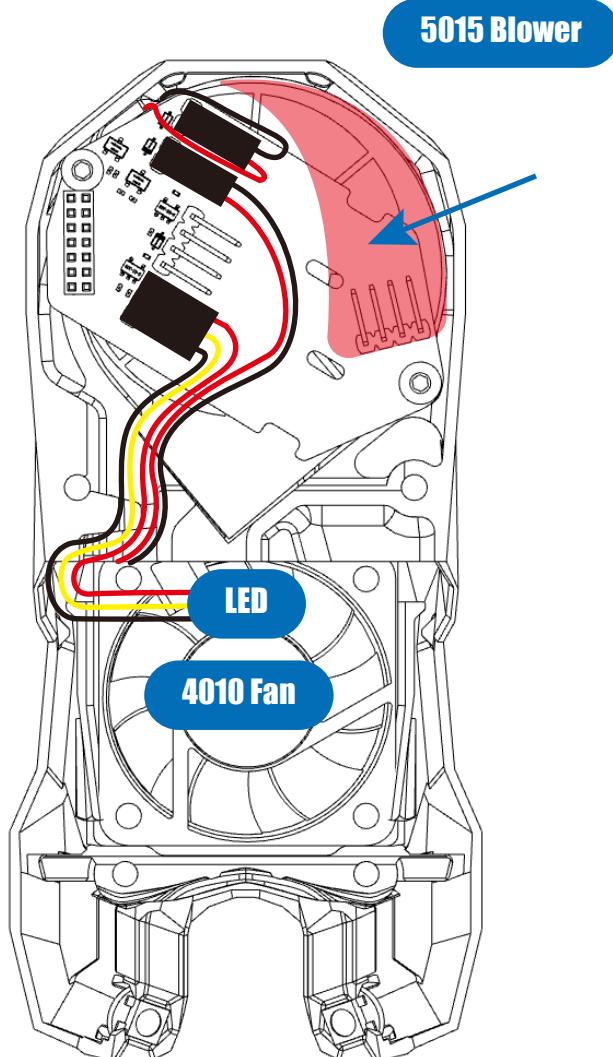
The 5015 blower has short wires by design.  
Separate the 2 wires from each other to make  
wire routing easier





The 5015 cable is a very tight fit.  
Plug it in before mounting the EBB SB0000



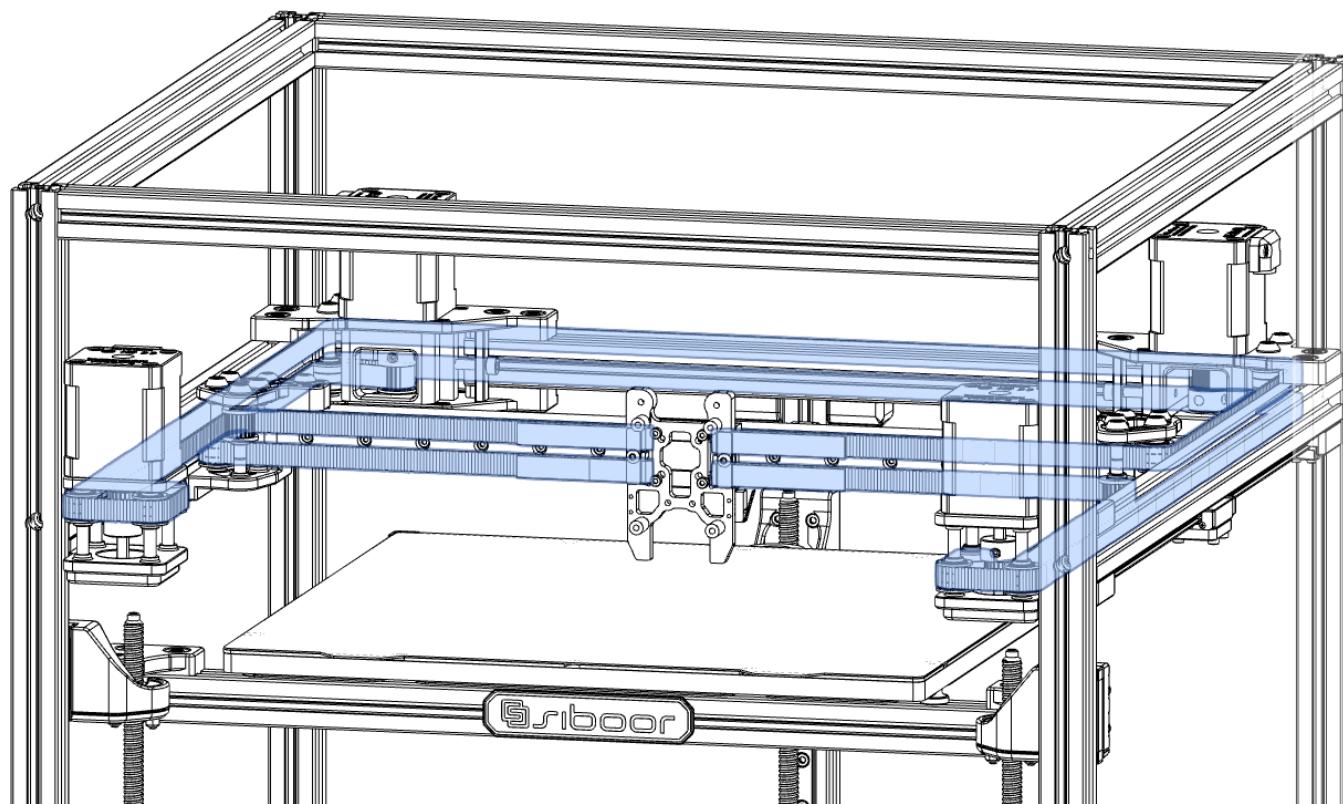


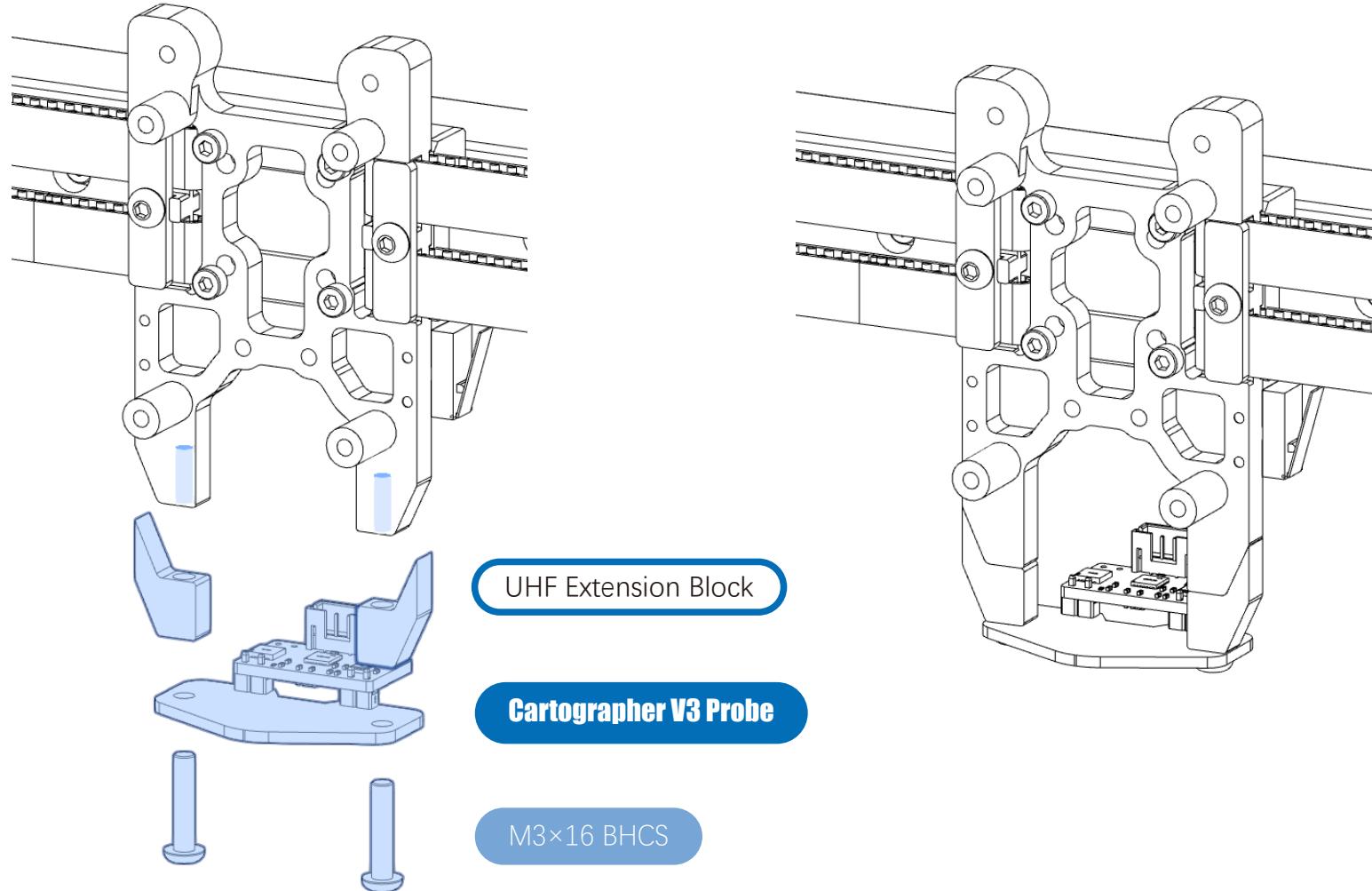
#### REASON FOR TIGHTLY DESIGNED CABLES

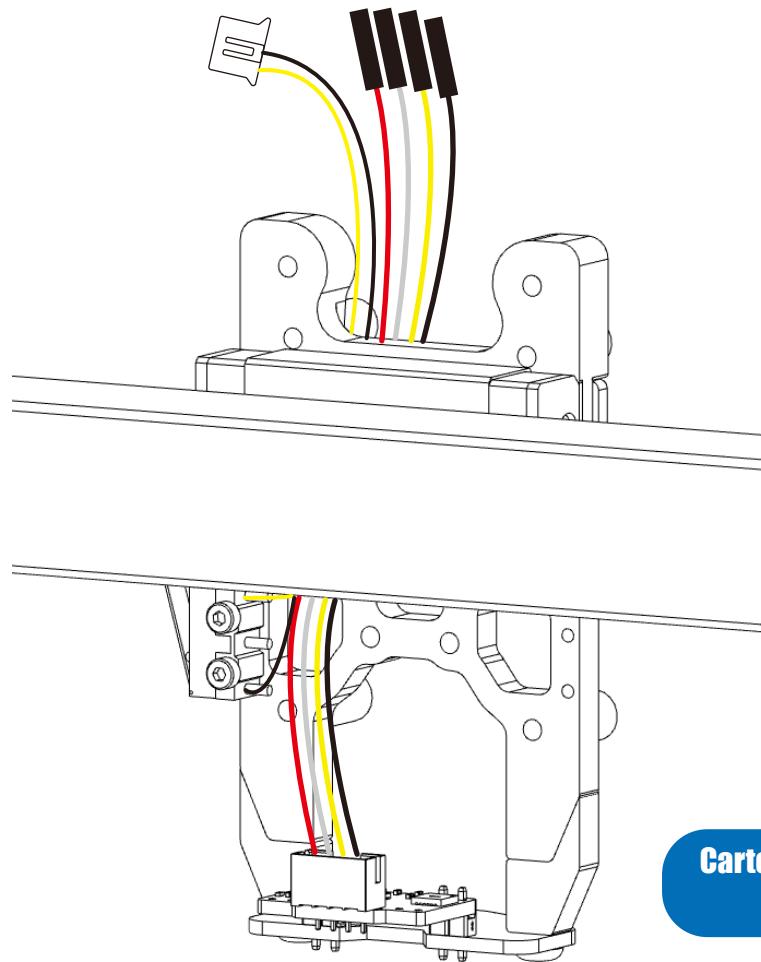
The cables are designed to be so compact to prevent the Cartographer's four cables and the 5015 blower cables from overlapping. This ensures that the faceplate and the CW2 extruder can be properly aligned.

**TENSIONING THE BELTS. AGAIN.**

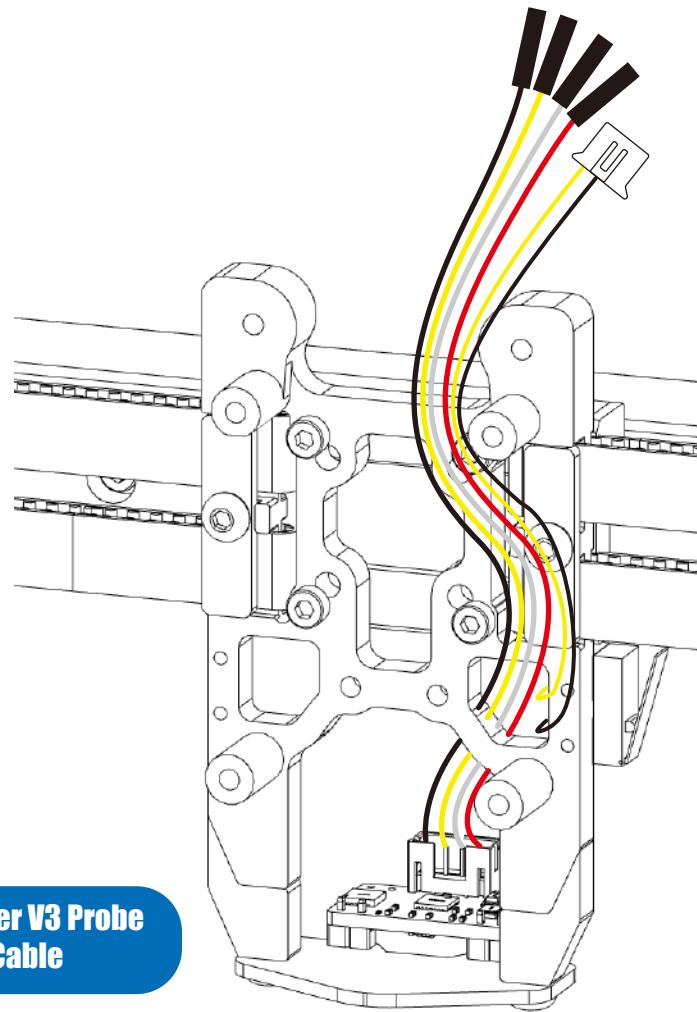
The belts were tensioned before, but you may notice that the belts have now become loose. This is because the tension has now been distributed more evenly. Re-tighten the belts before continuing with the next steps.

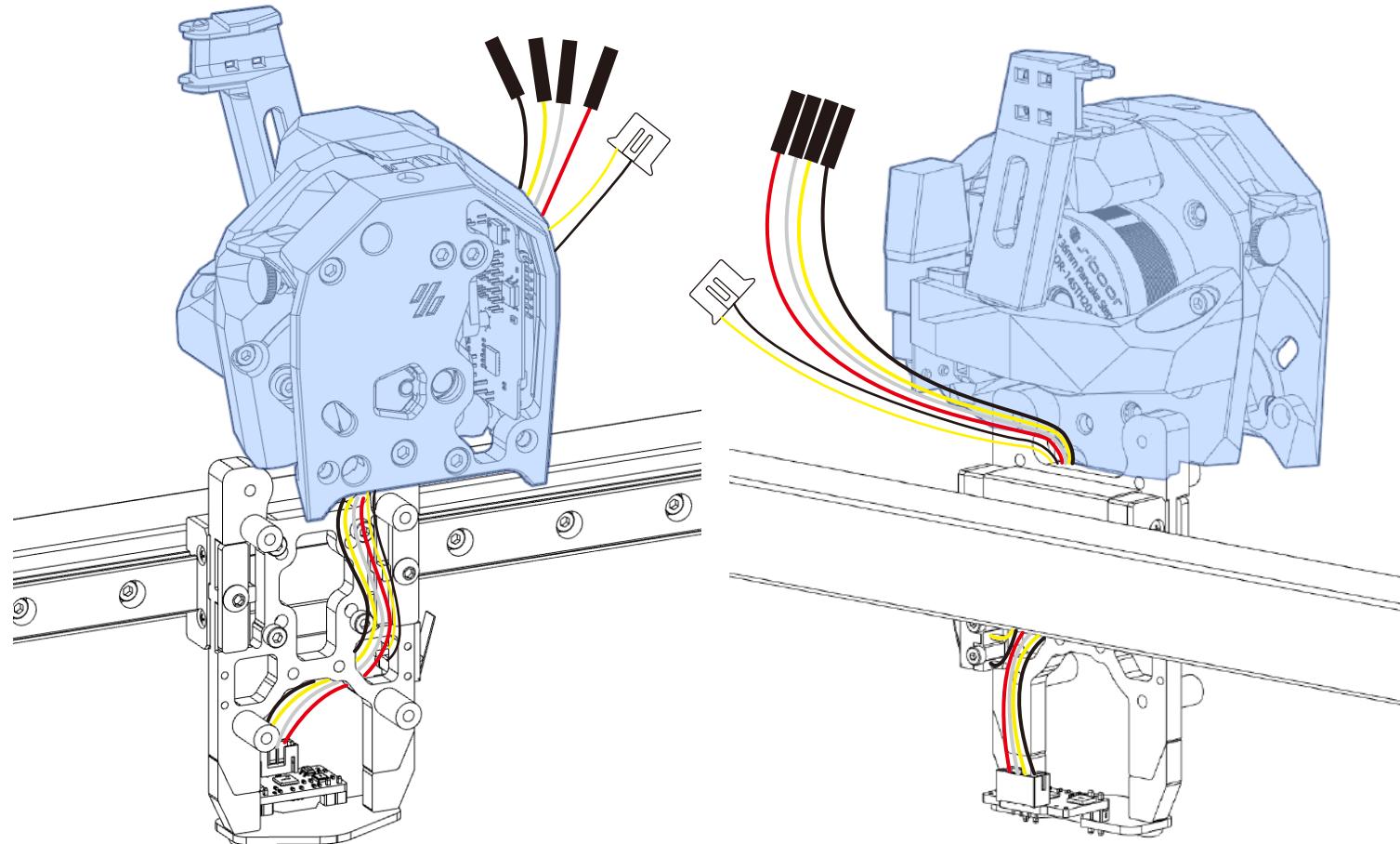


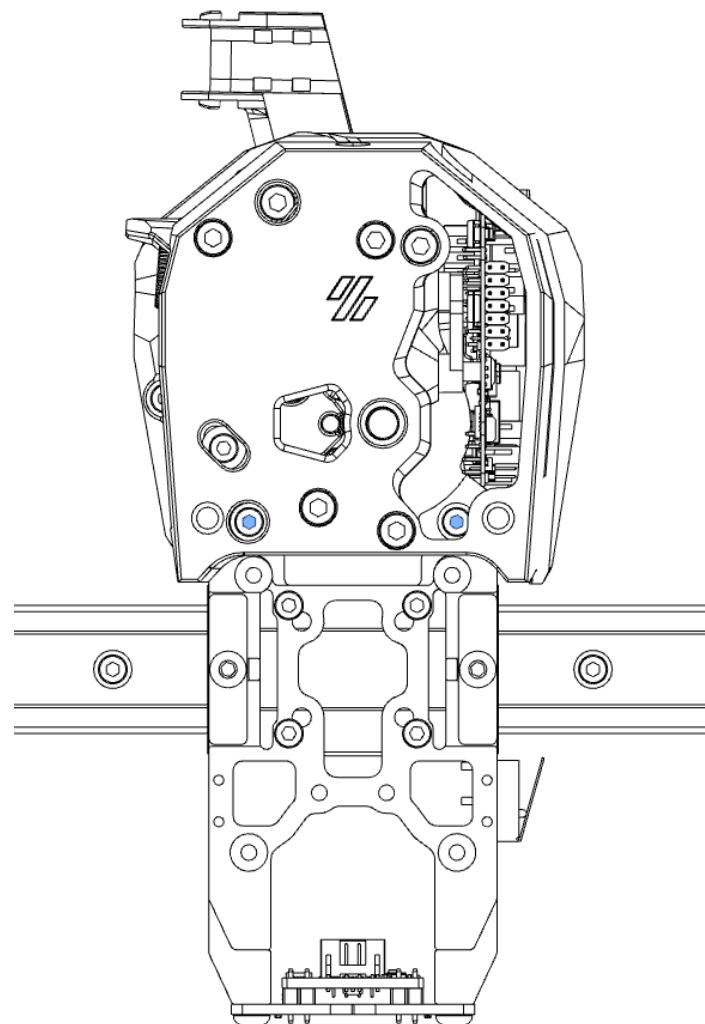
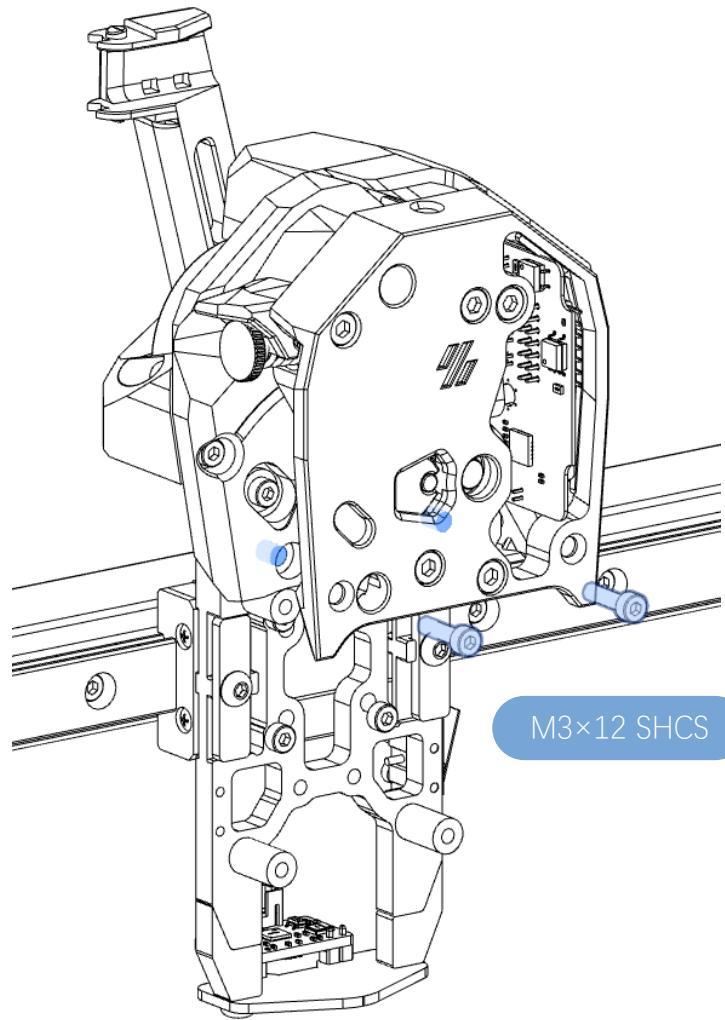


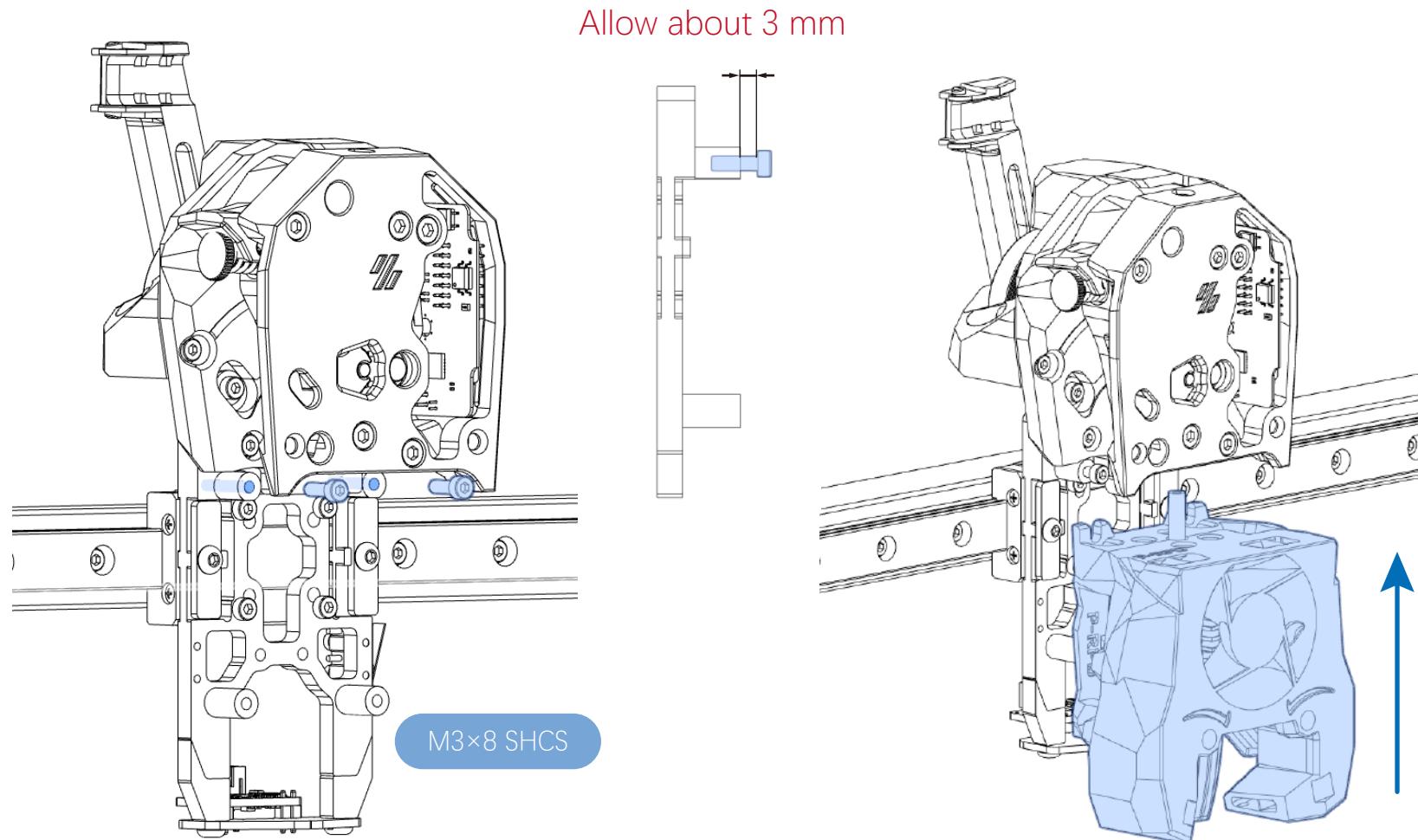


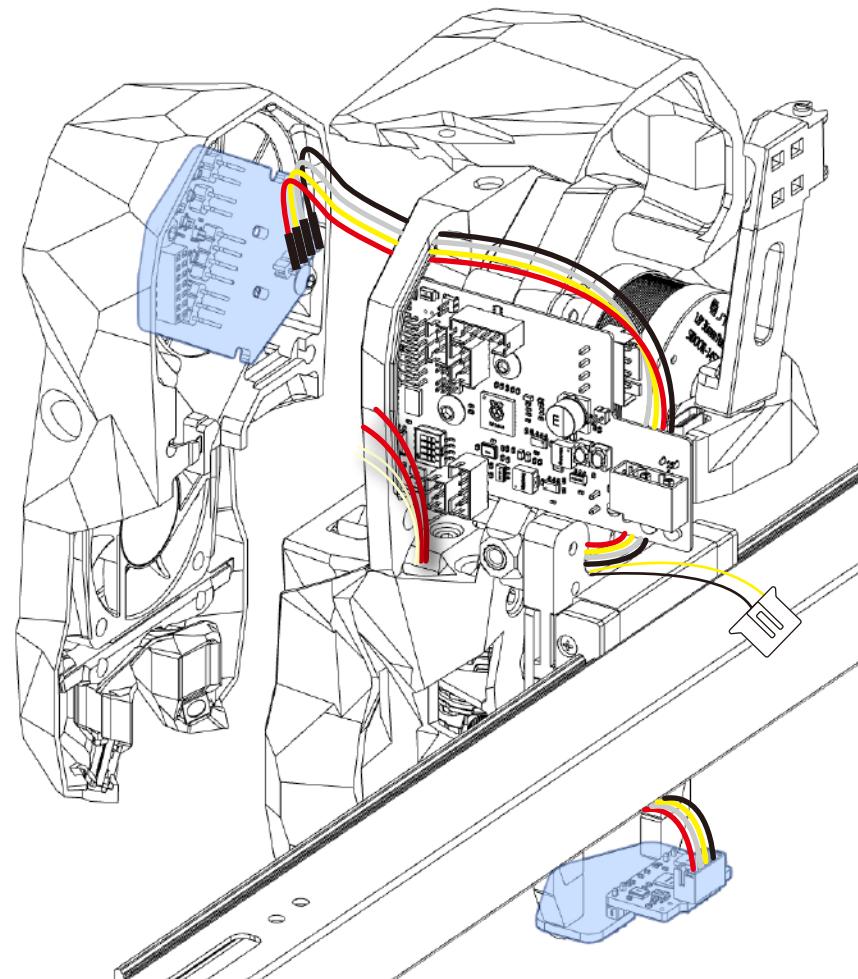
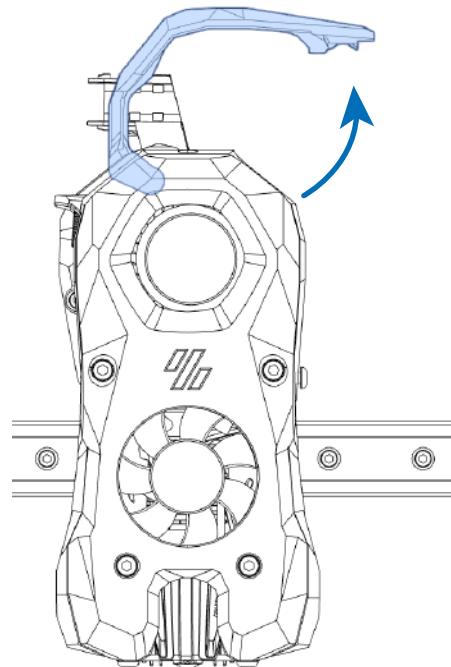
Cartographer V3 Probe  
CAN Cable

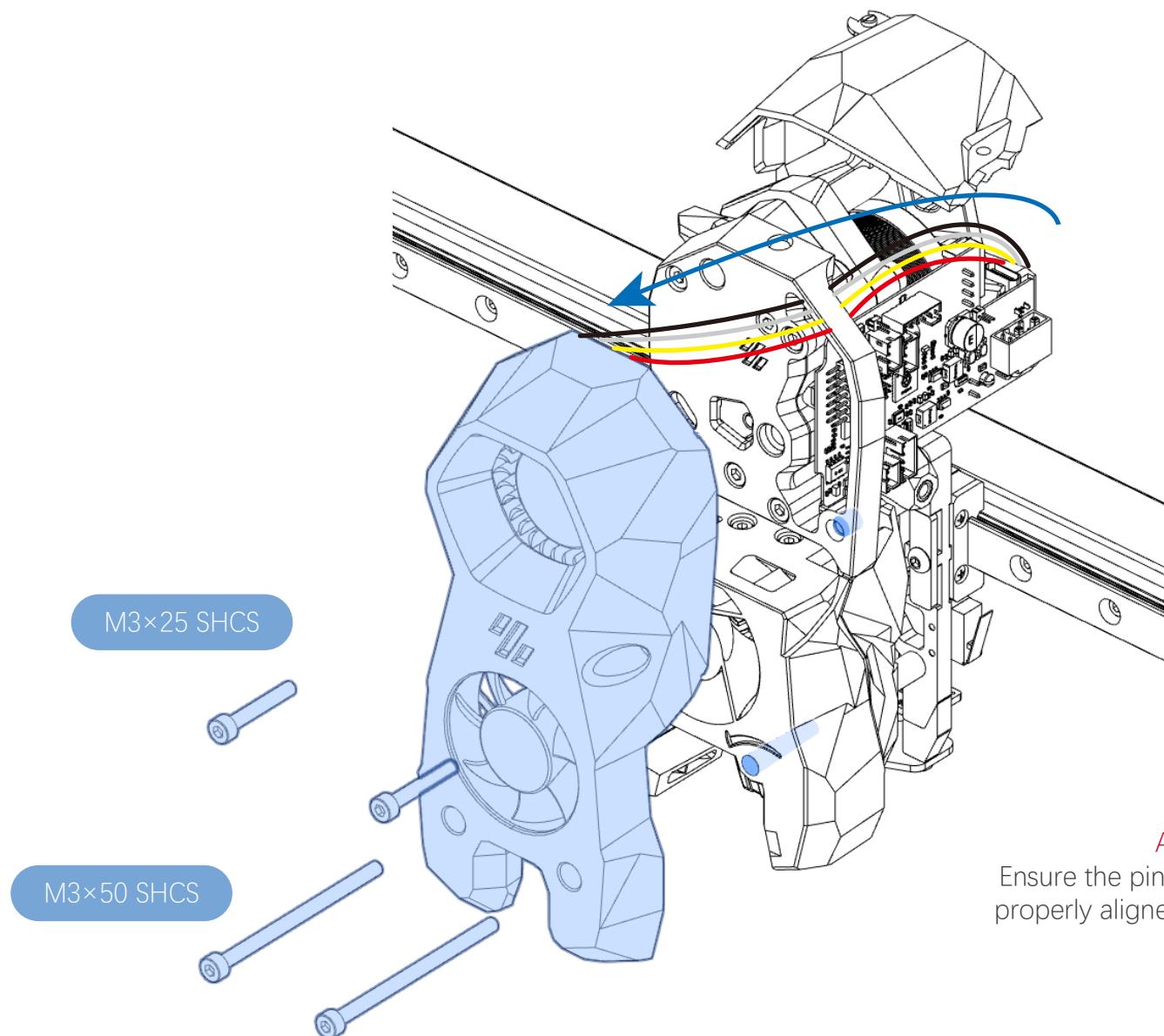






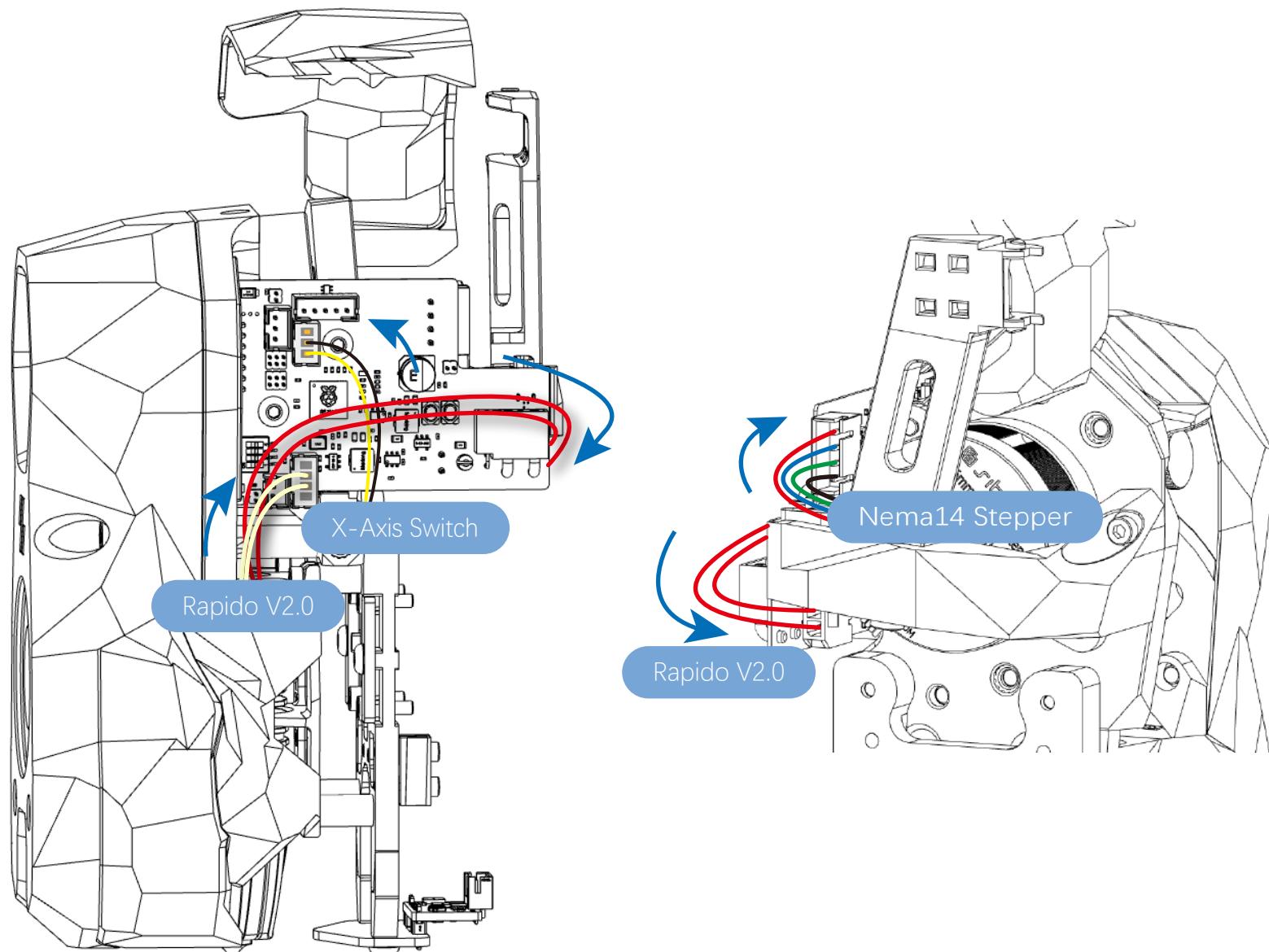




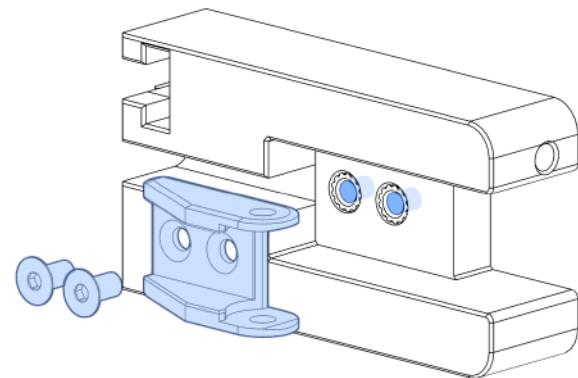


#### Aligning EBB CAN Board Pins

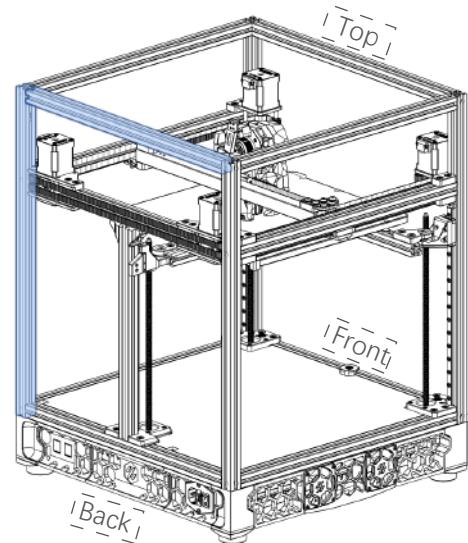
Ensure the pins of the EBB CAN board are properly aligned to avoid any short circuits.



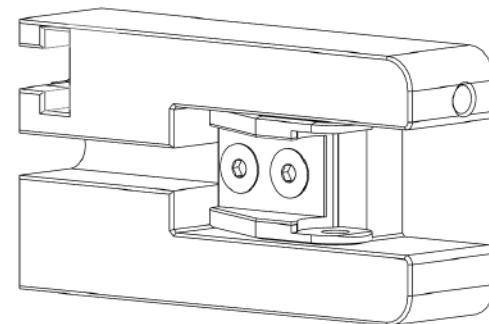




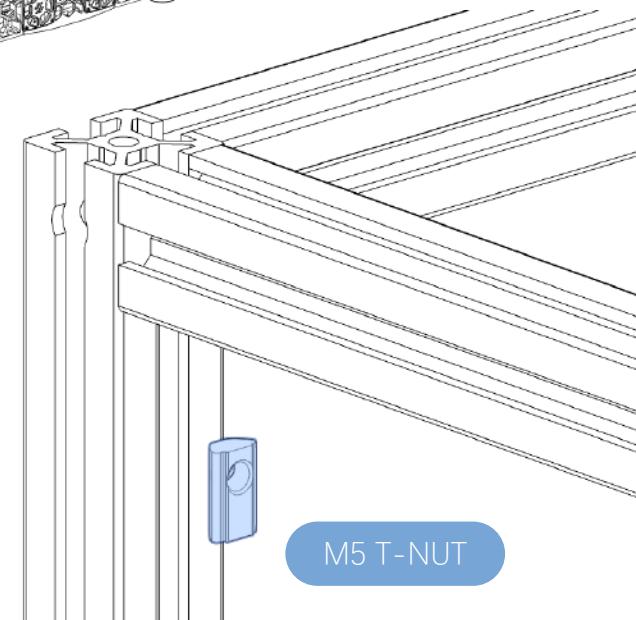
6×10 Drag chain head

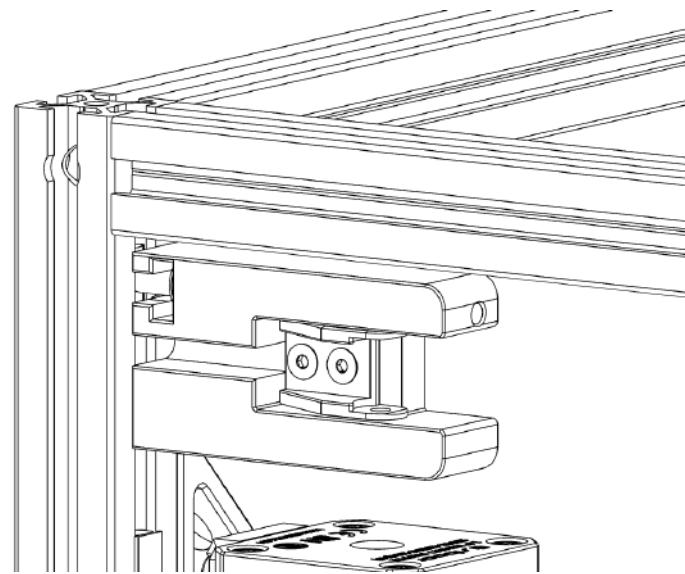
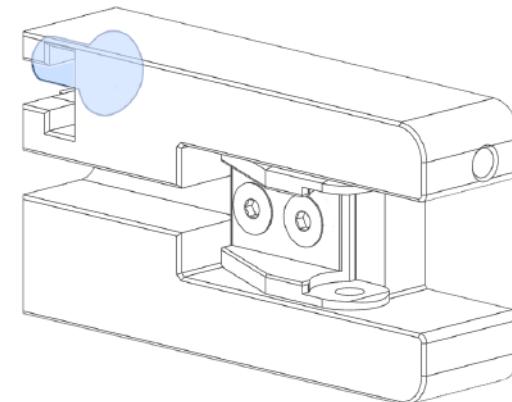
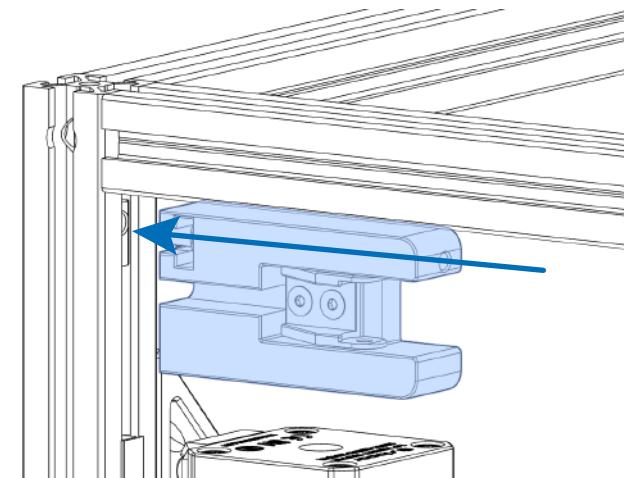
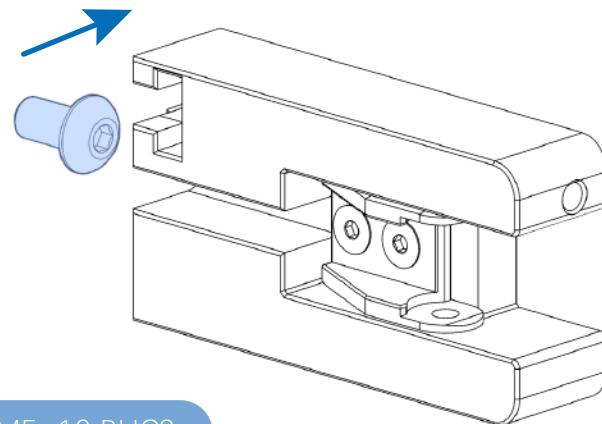


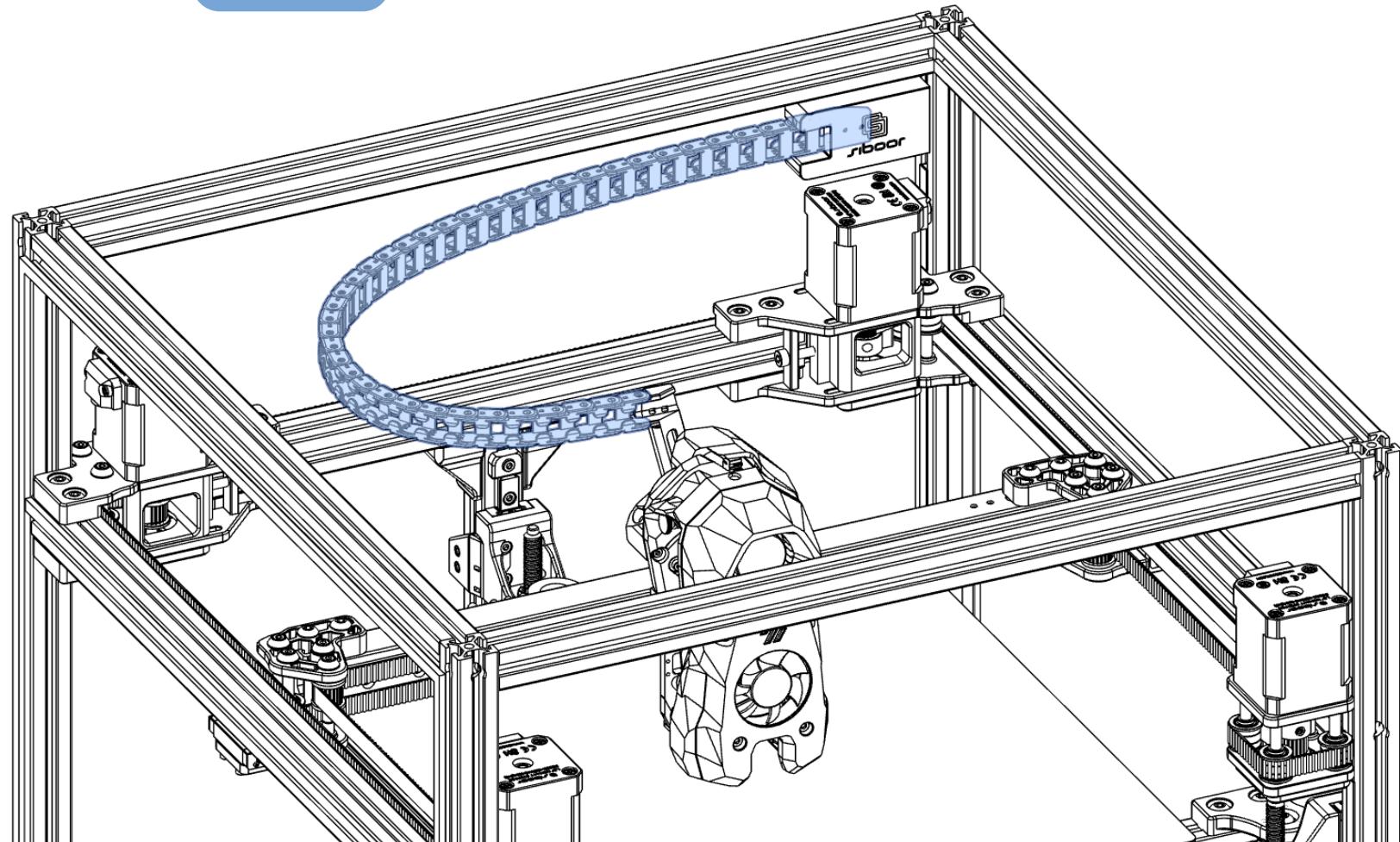
M3×6 FHCS

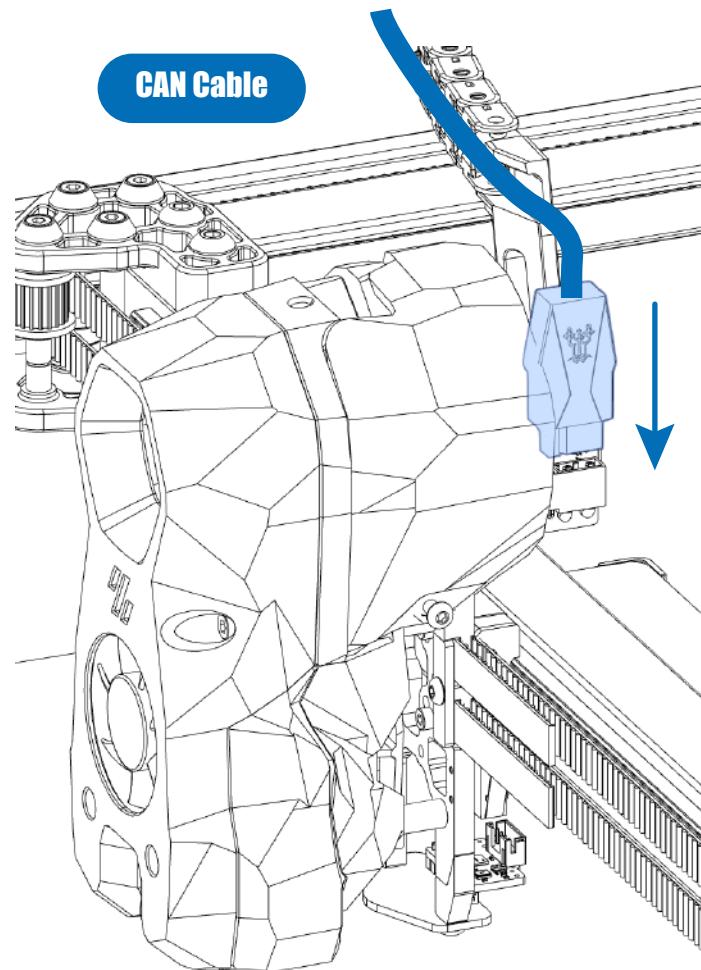


M5 T-NUT

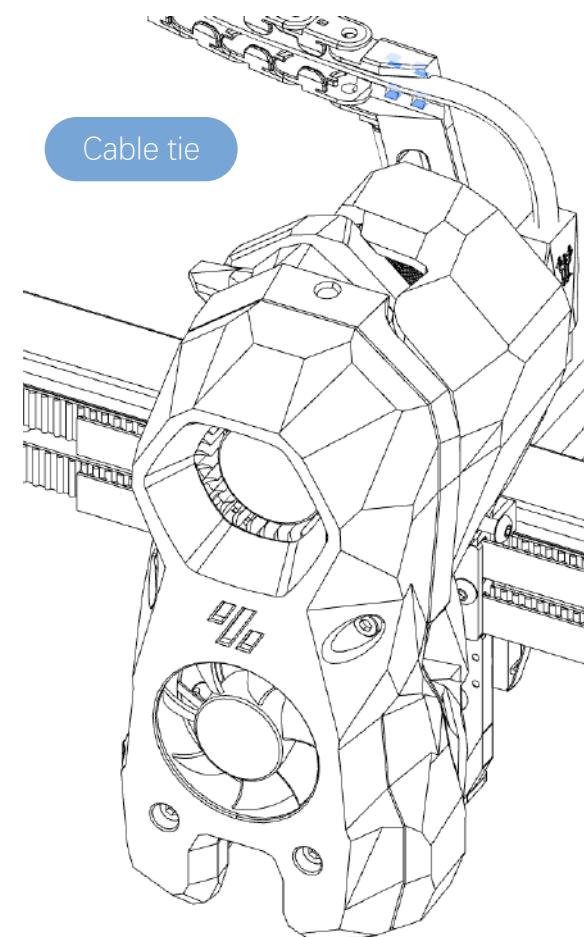


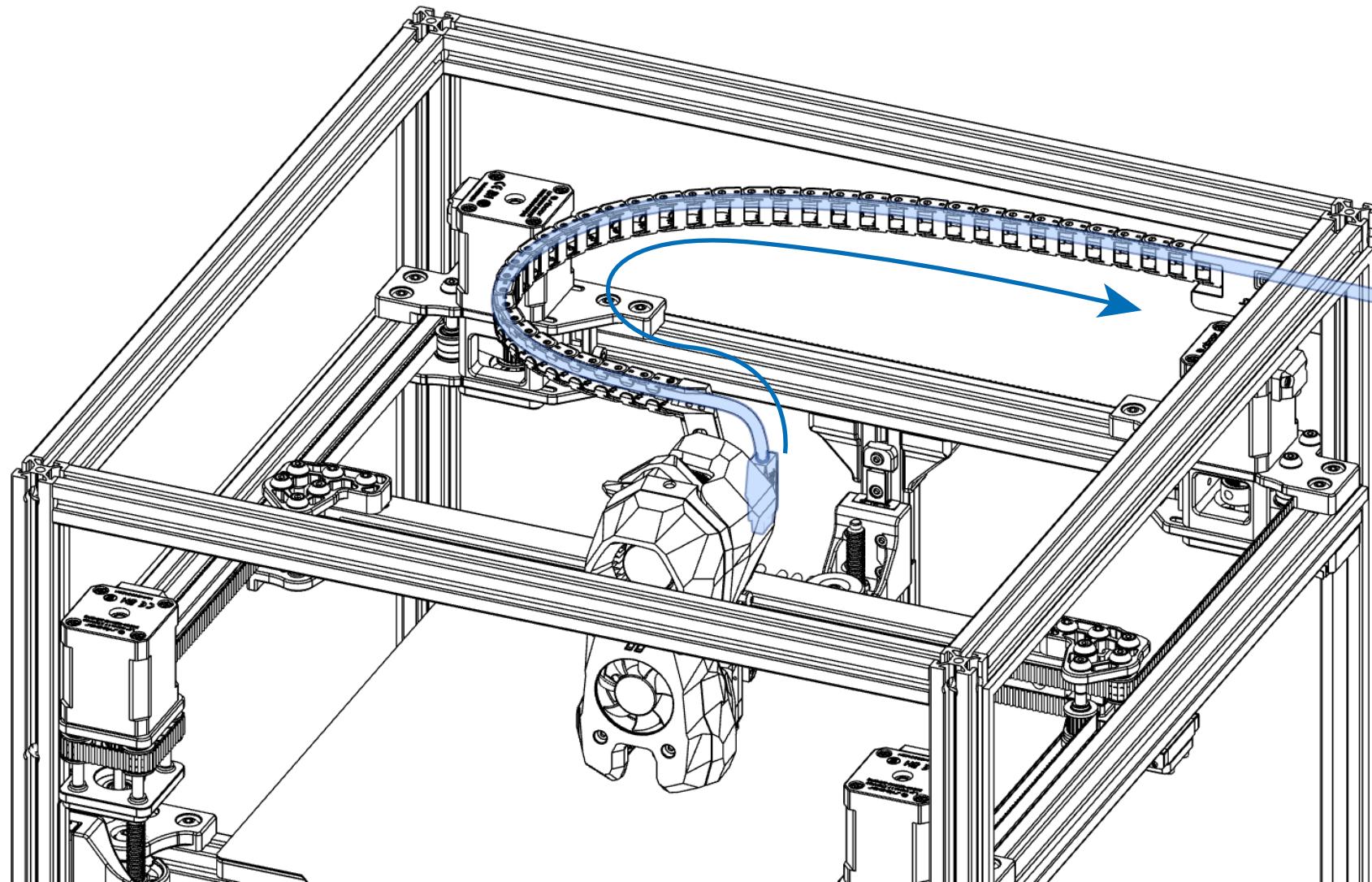






## SECURING CABLES WITH ZIP TIES

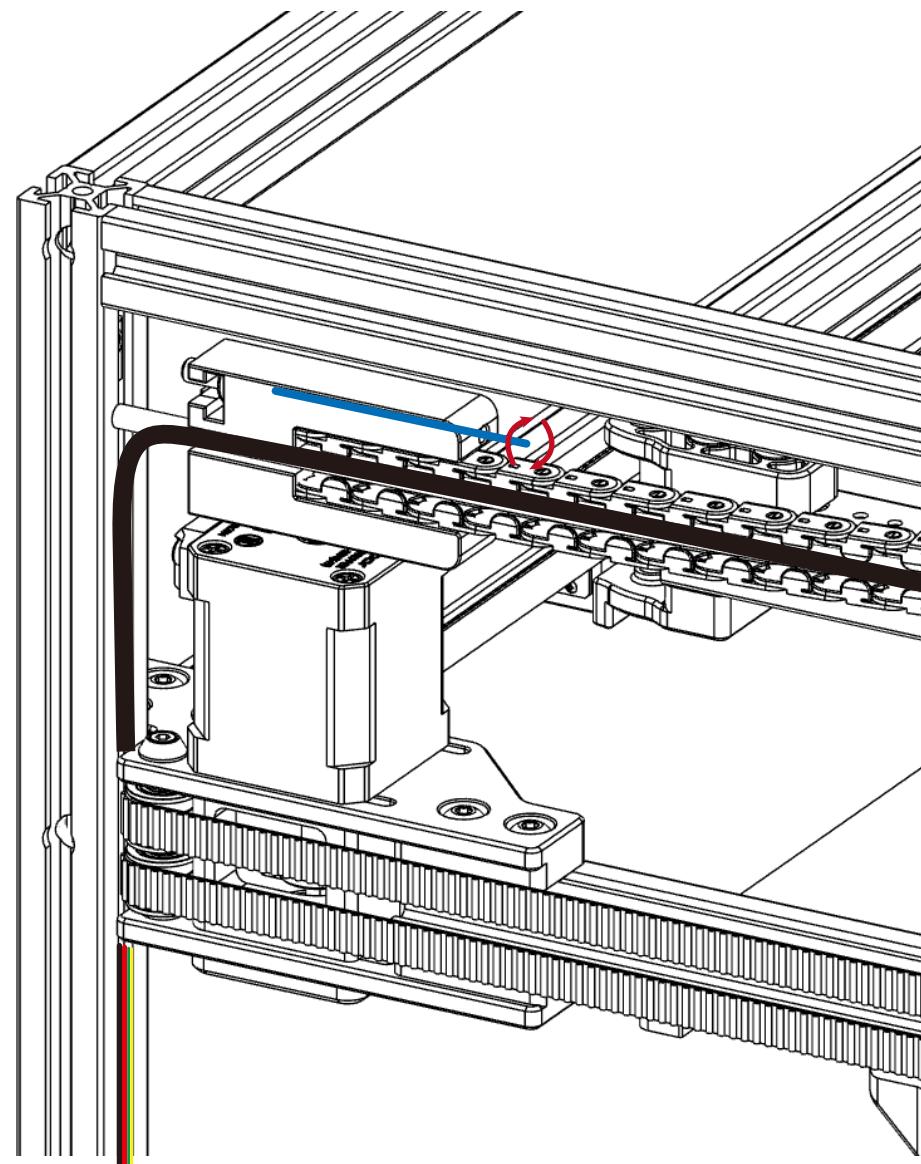


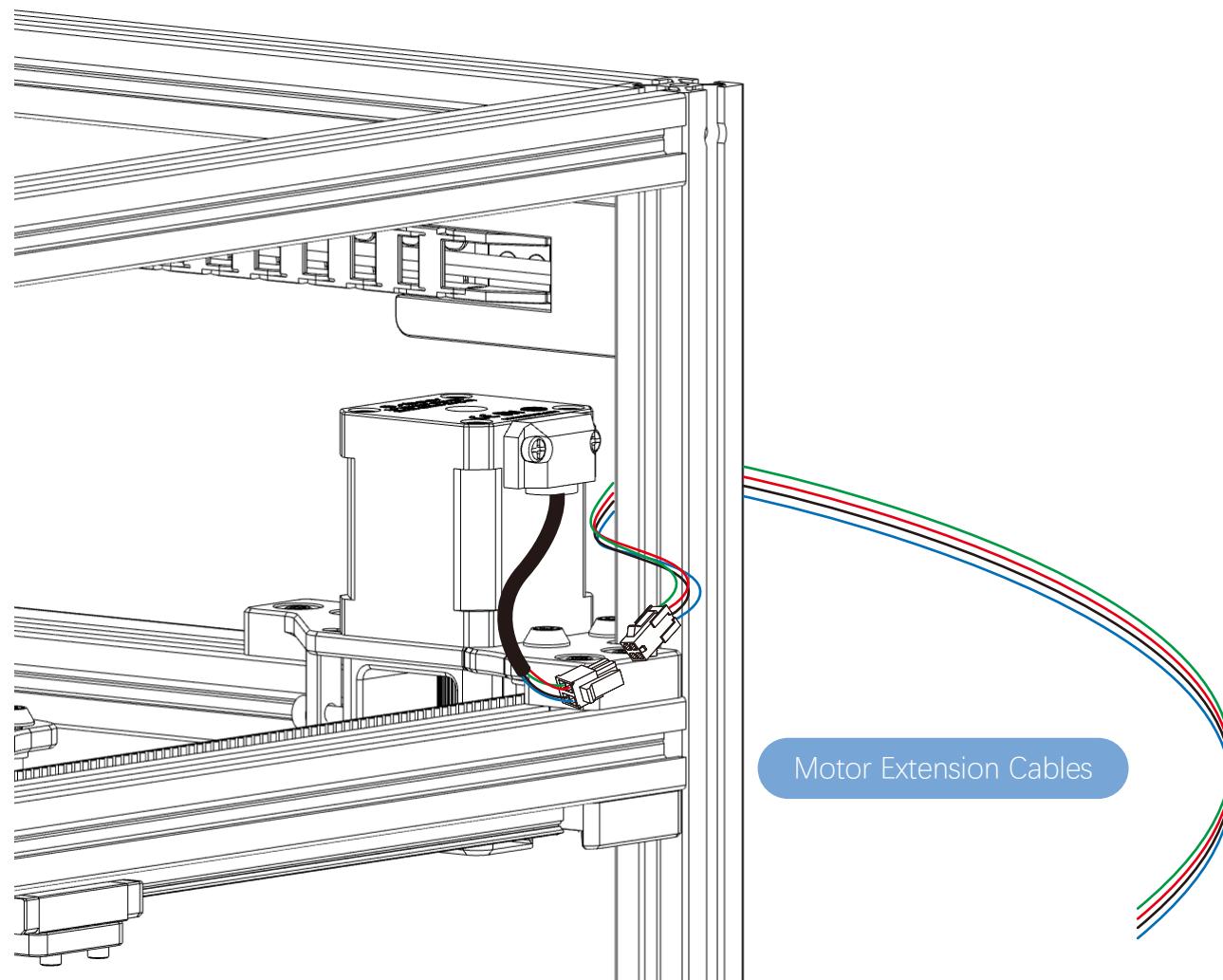


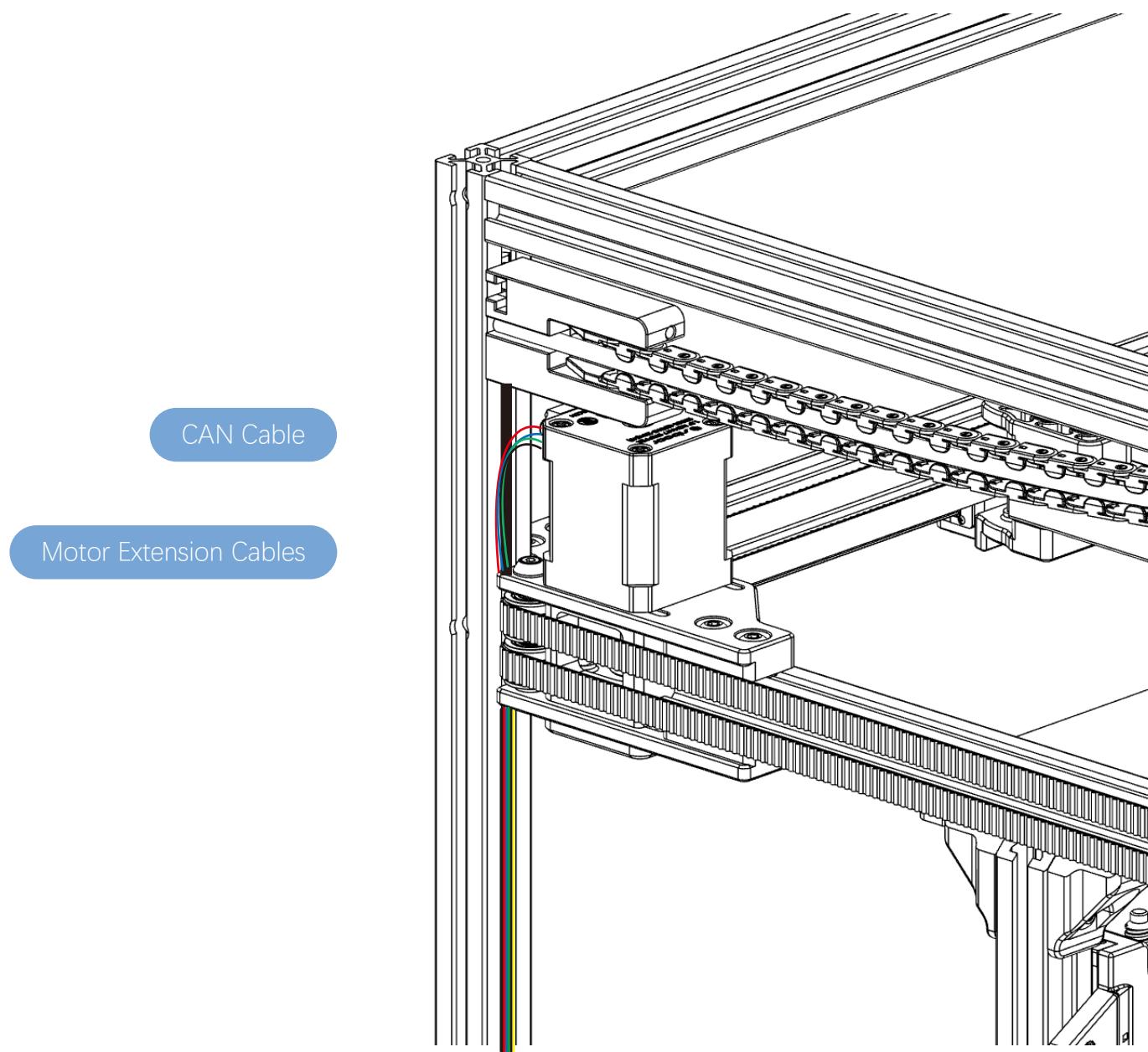
**CAN CABLE**

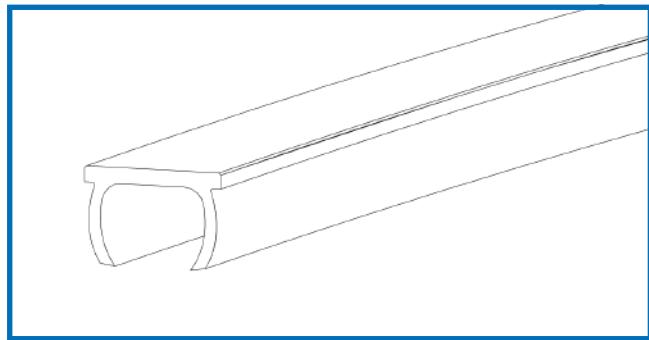
Carefully peel off the black rubber sheath of the CAN cable to ensure the internal wires are not damaged, allowing them to be hidden within the groove of the extrusion.

While removing the connector and peeling off the protective sheet, make sure to keep the green and yellow twisted pair cables intact and do not untwist them. Untwisting these cables can lead to significant communication issues.

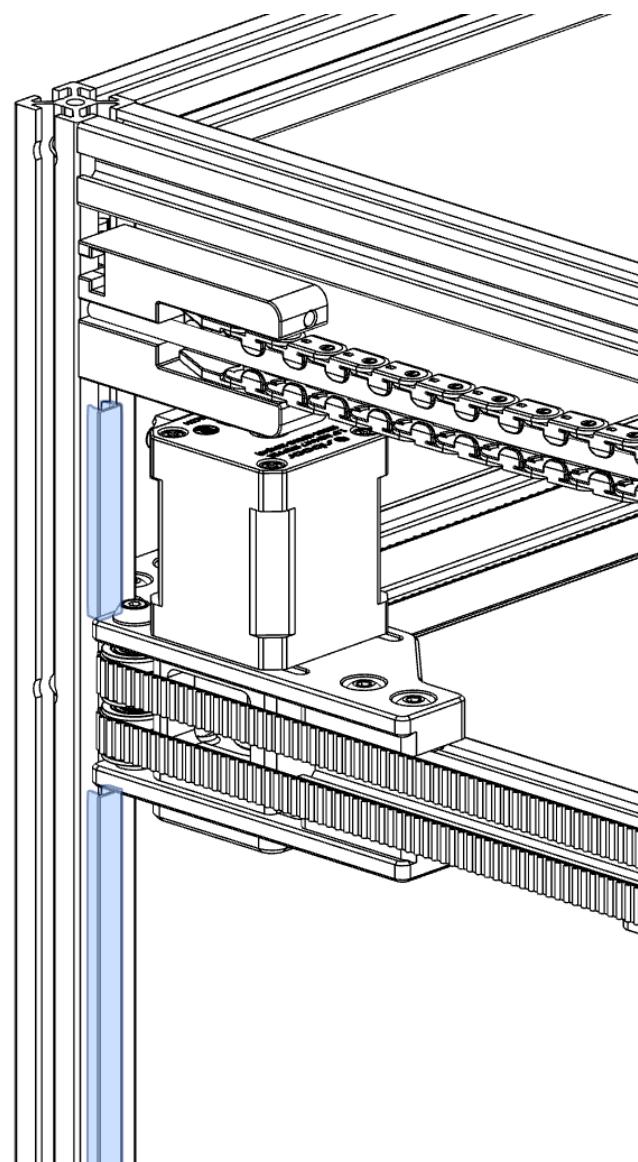
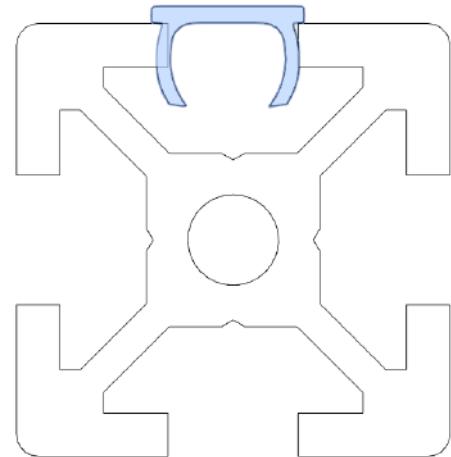


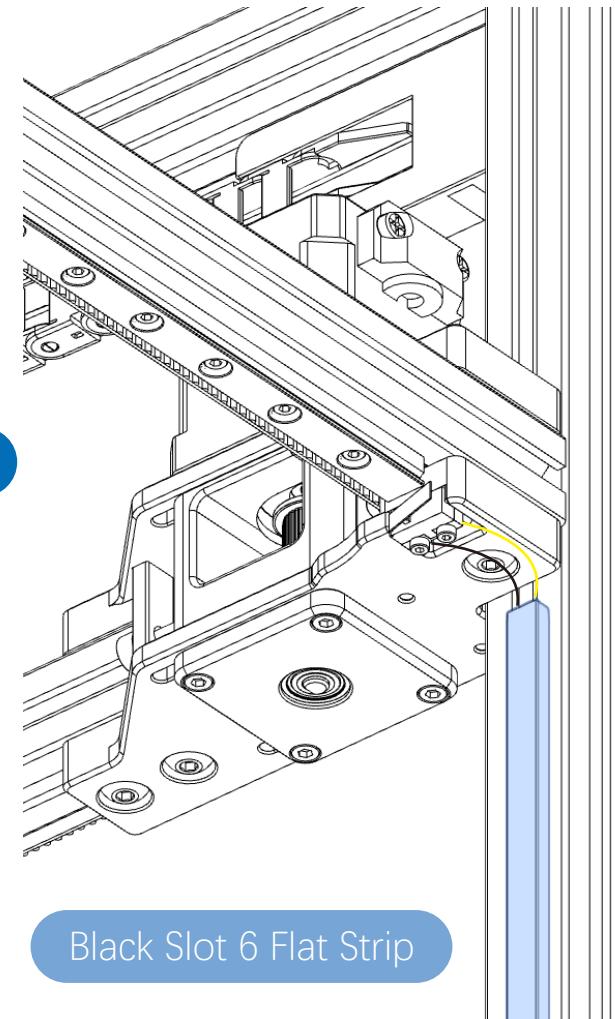
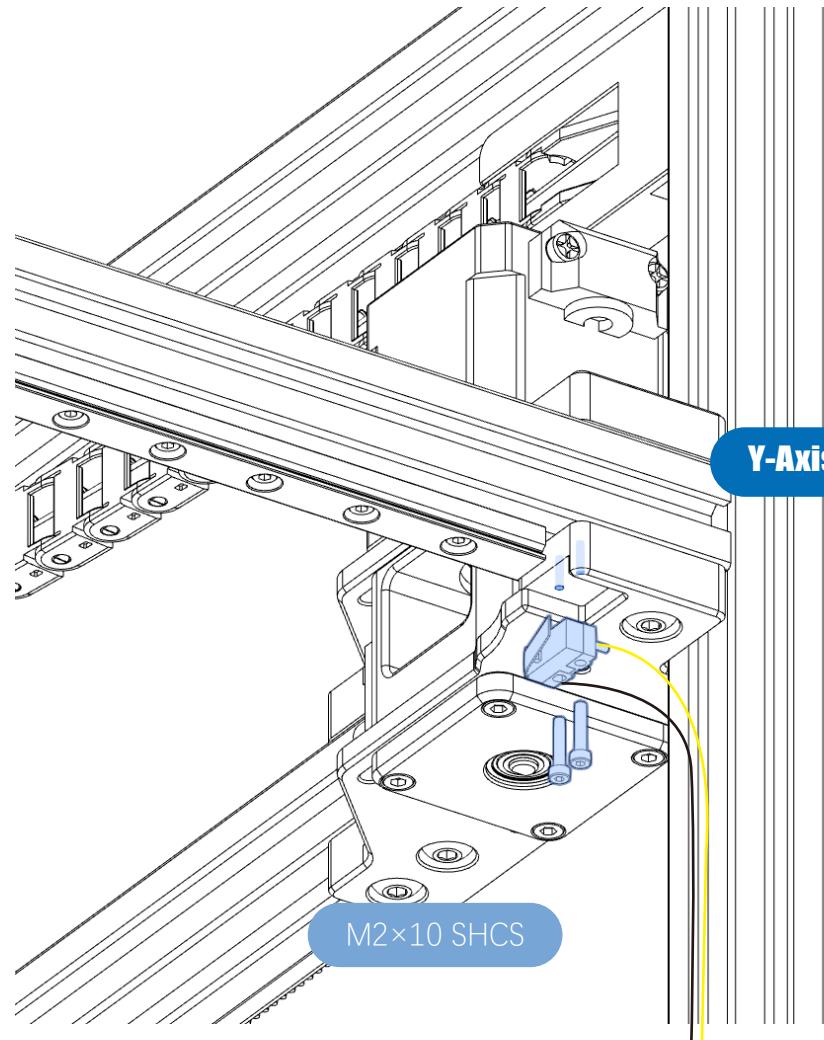


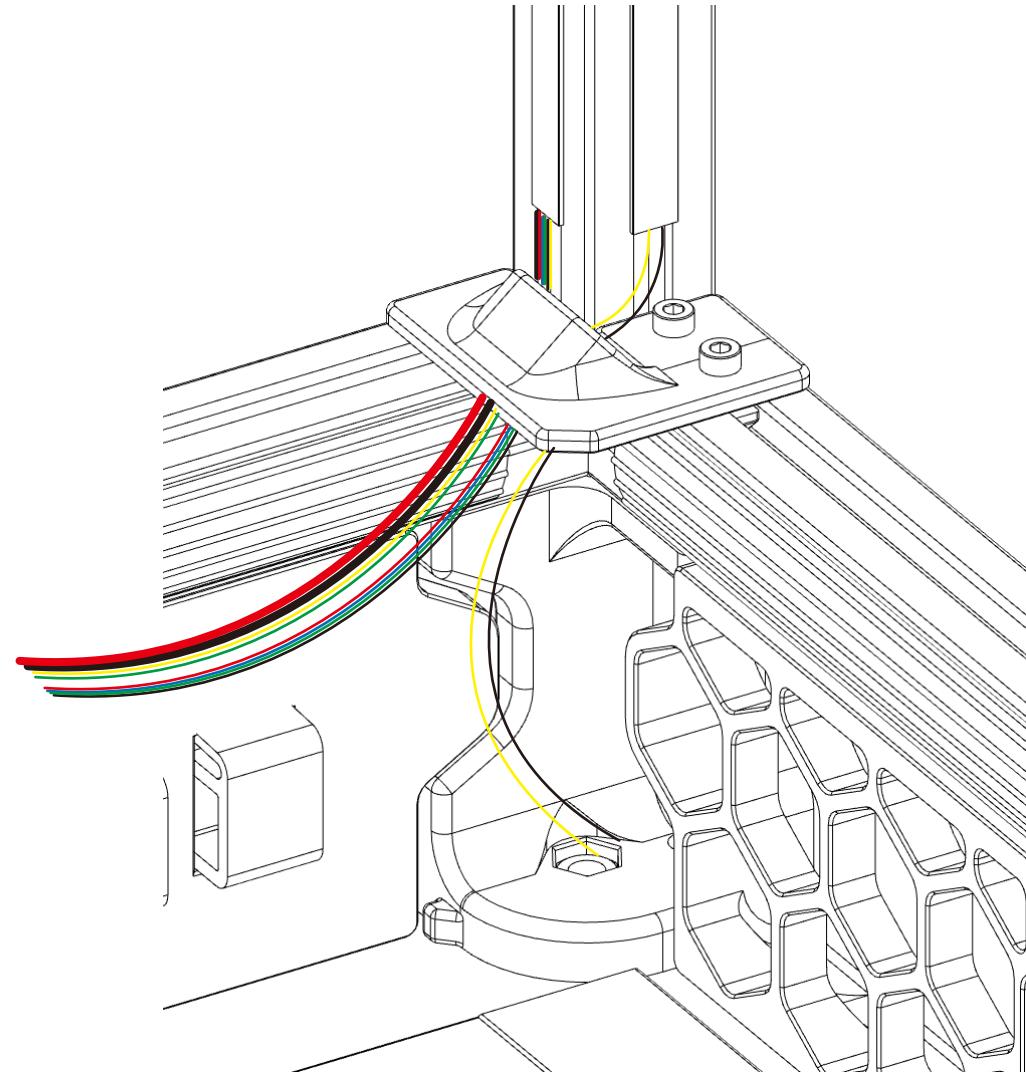
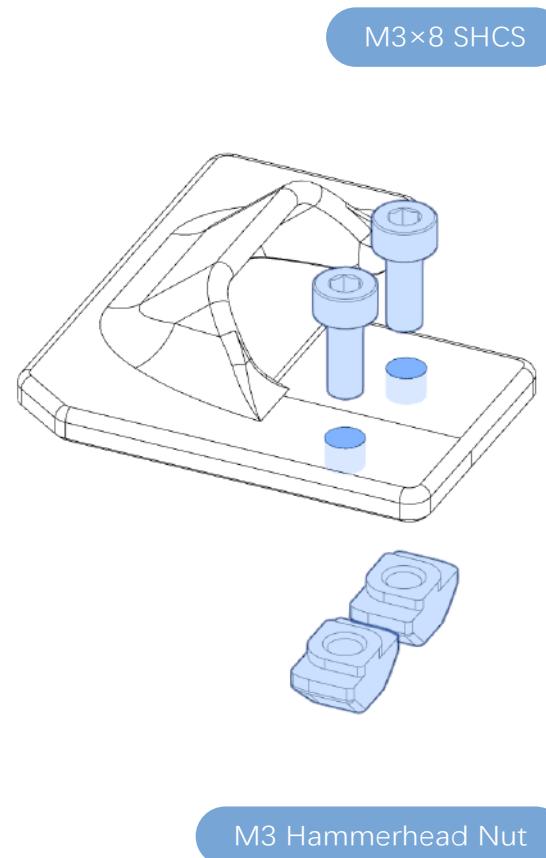


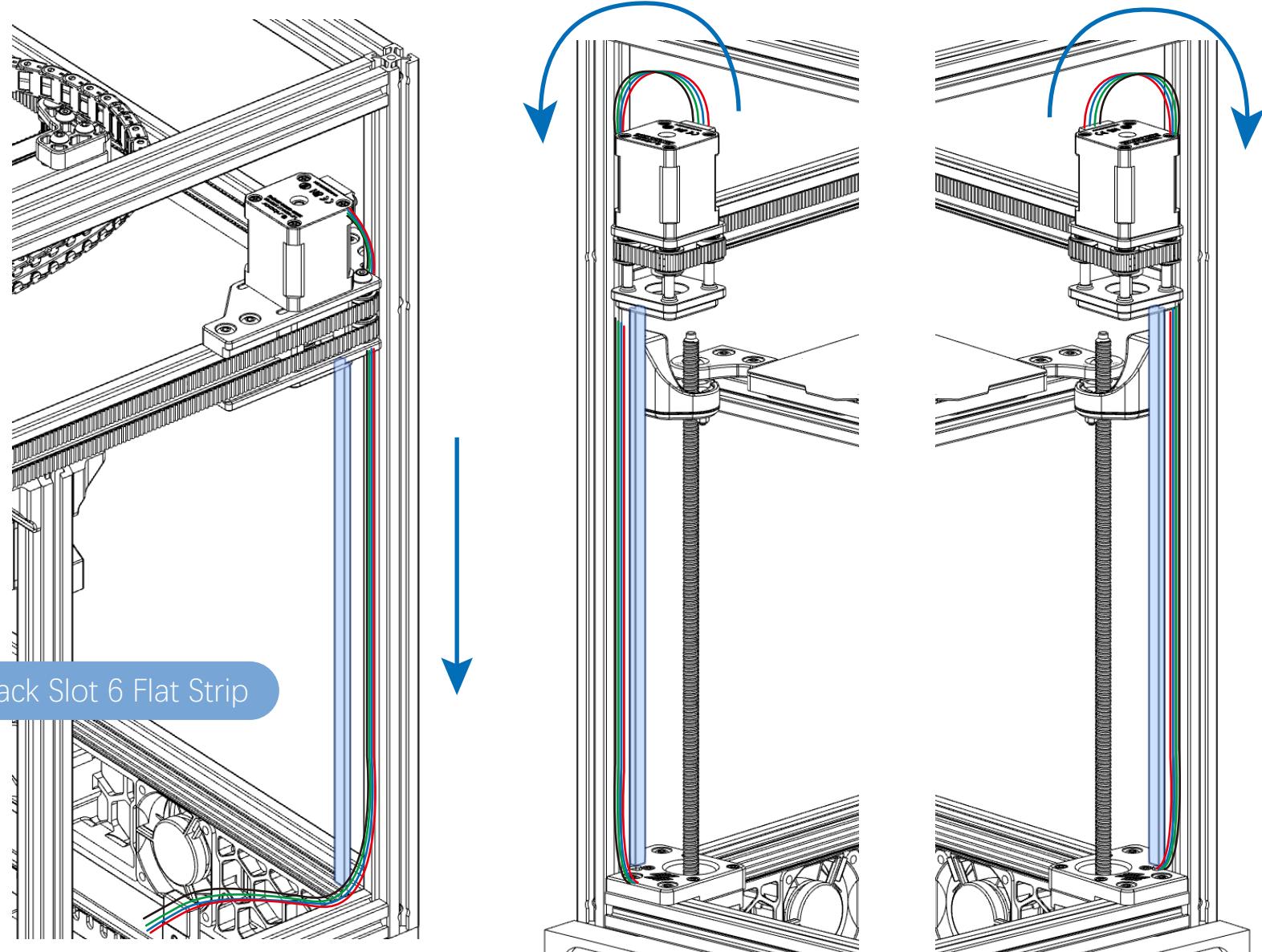


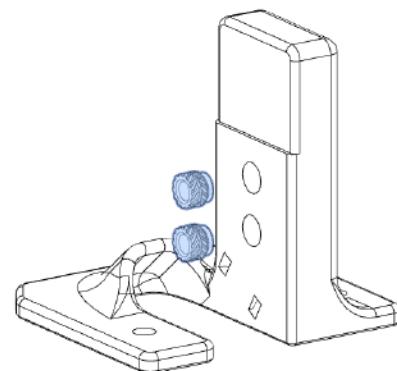
Black Slot 6mm Flat Strip



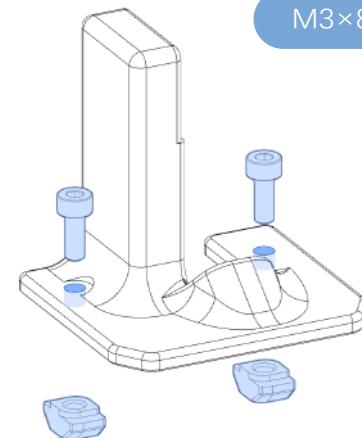




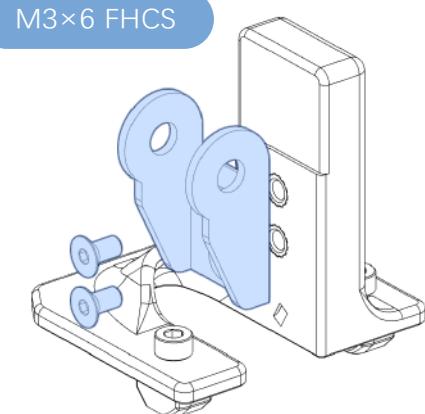




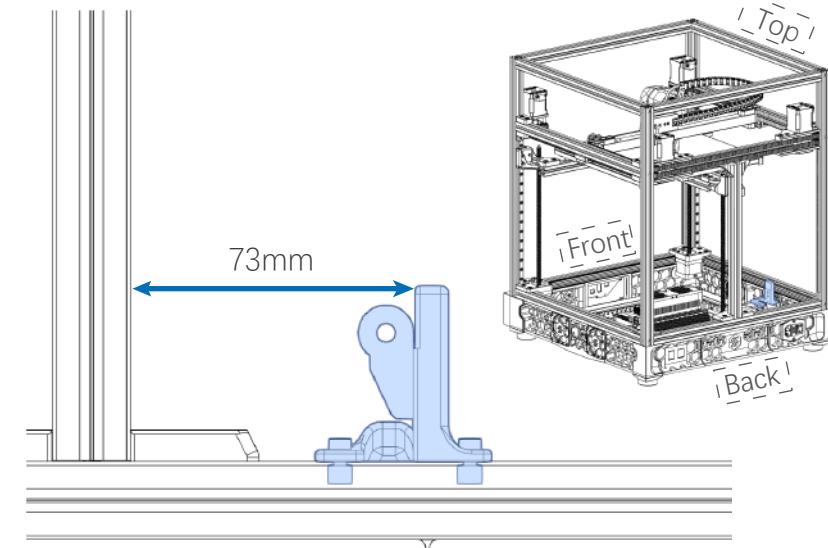
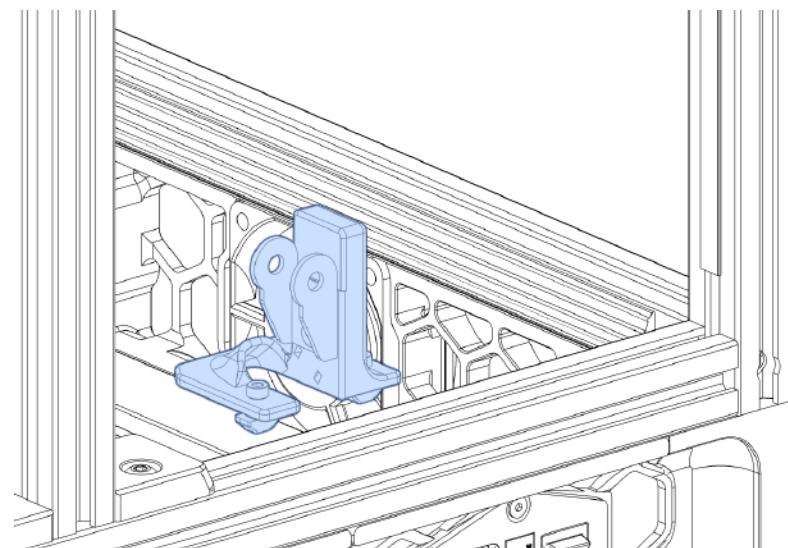
Heat Set Insert

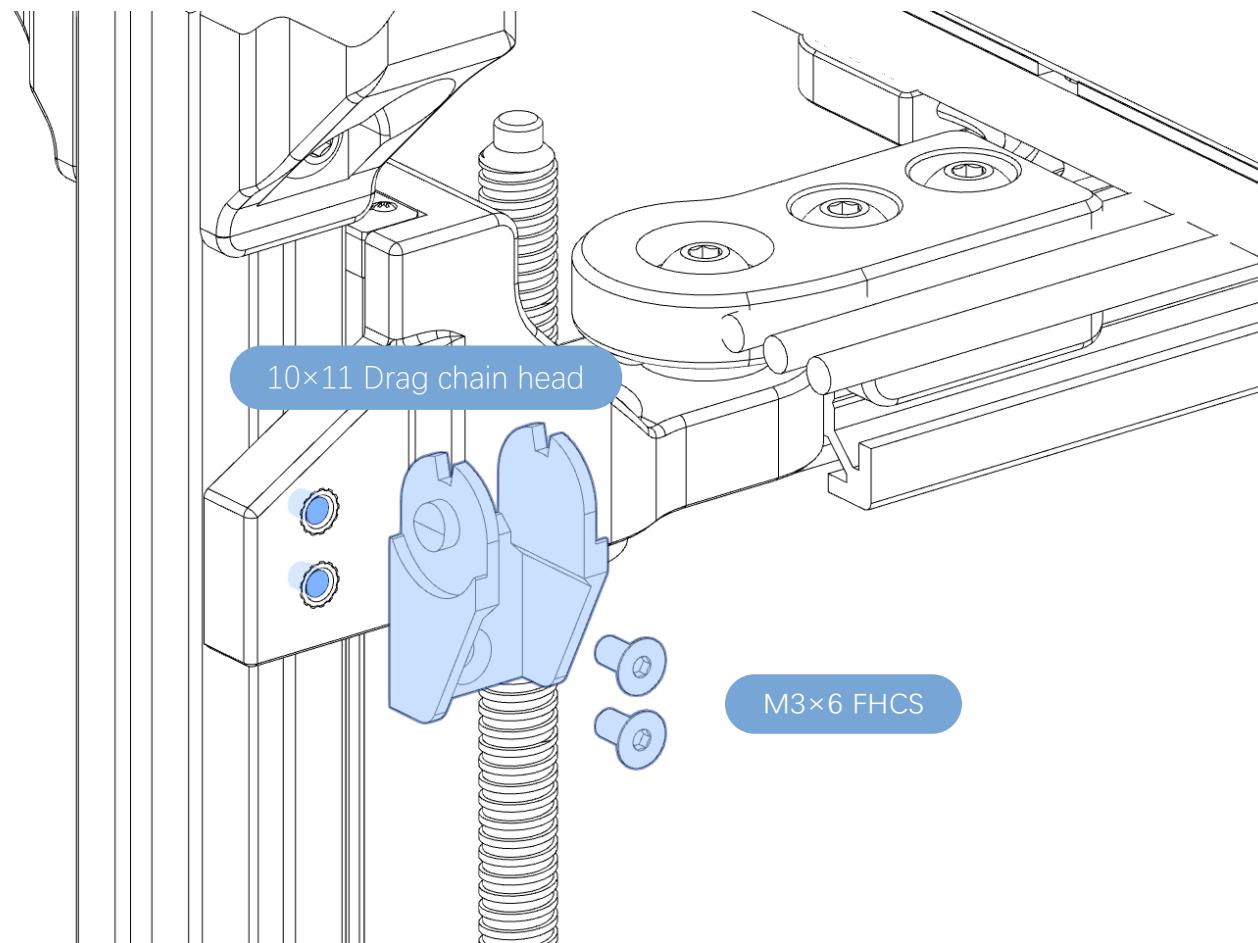


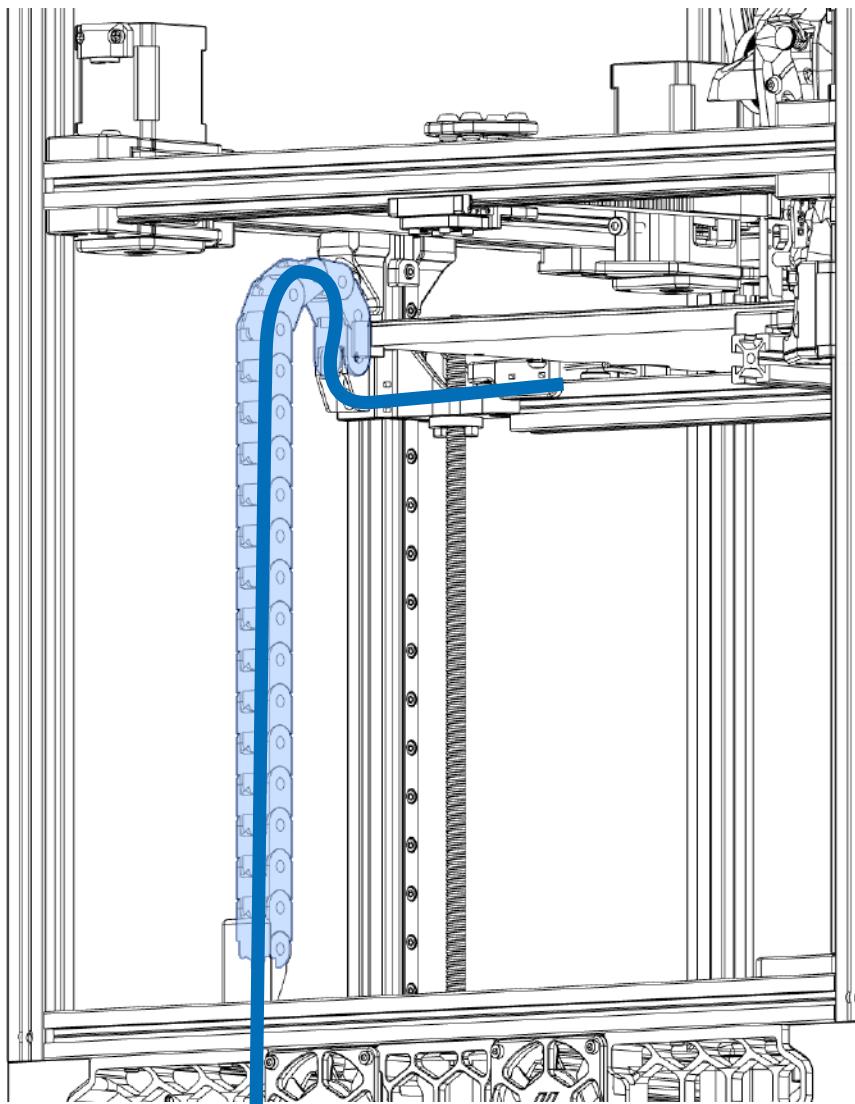
M3 Hammerhead Nut



10×11 Drag chain head

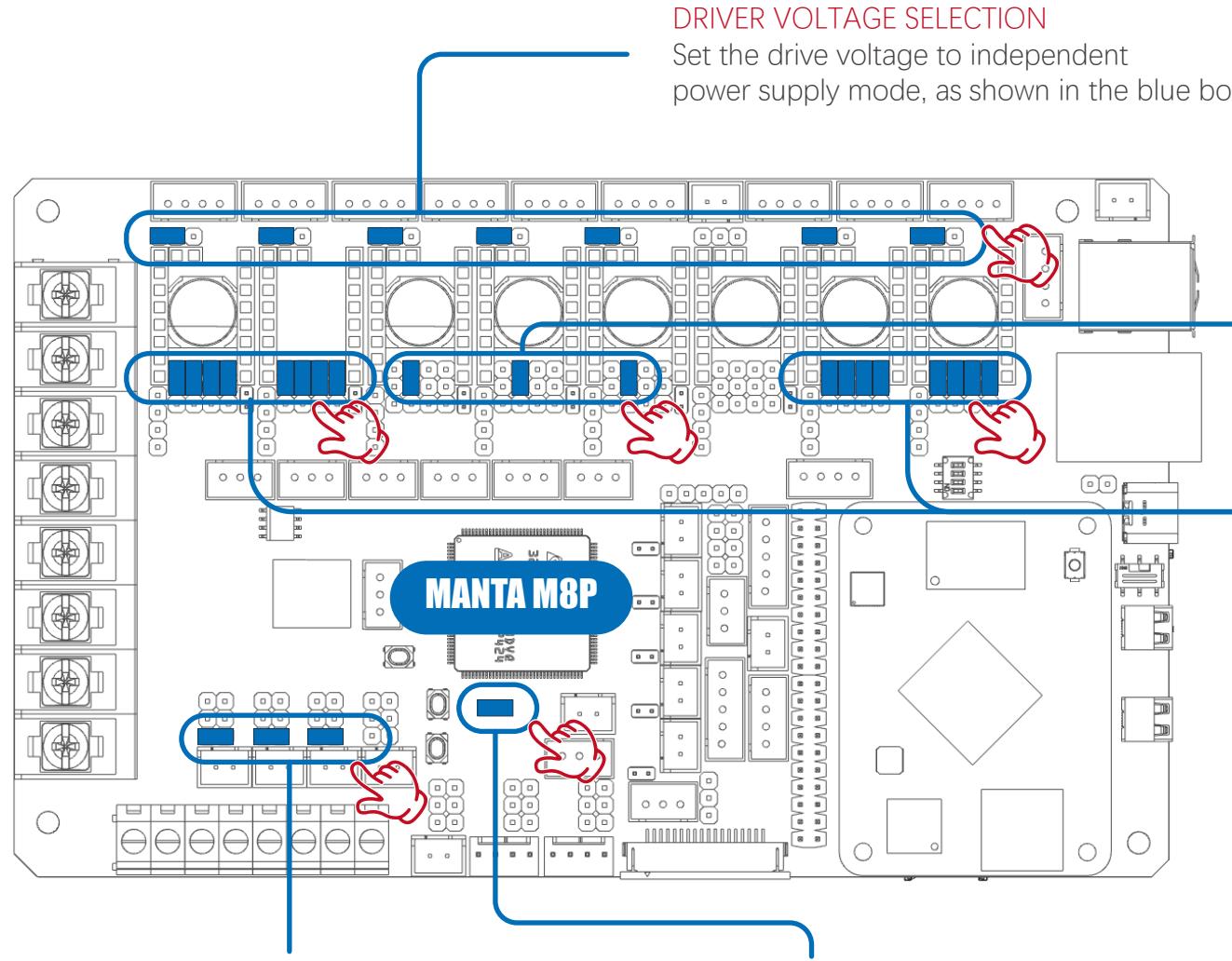






#### INSTALLING CABLES IN THE DRAG CHAIN

Please note that the drag chain can be opened. Use a small screwdriver or tweezers to open the drag chain, then install the cables. The hotbed cable path is shown in the diagram.

**DRIVER VOLTAGE SELECTION**

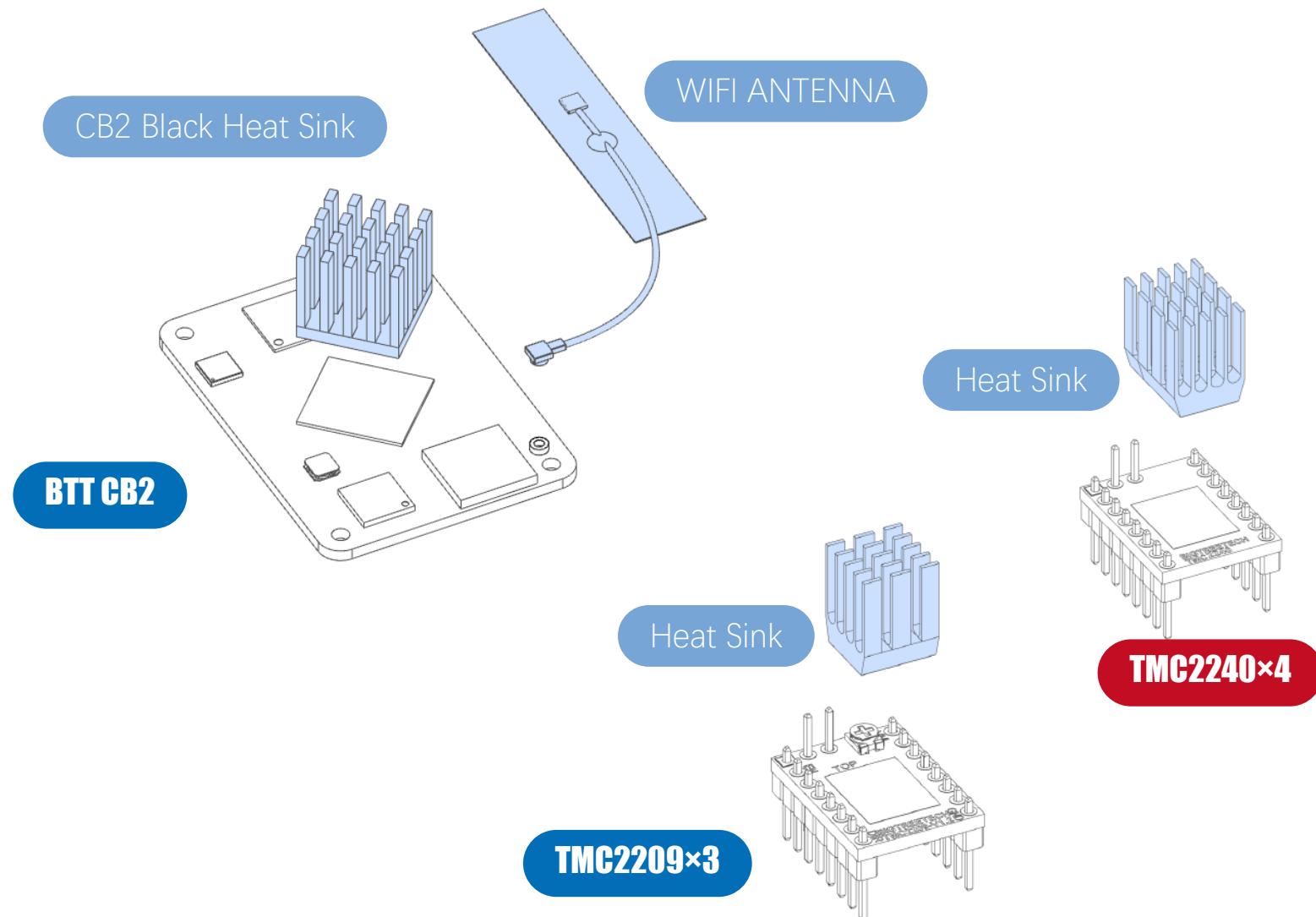
Set the drive voltage to independent power supply mode, as shown in the blue box.

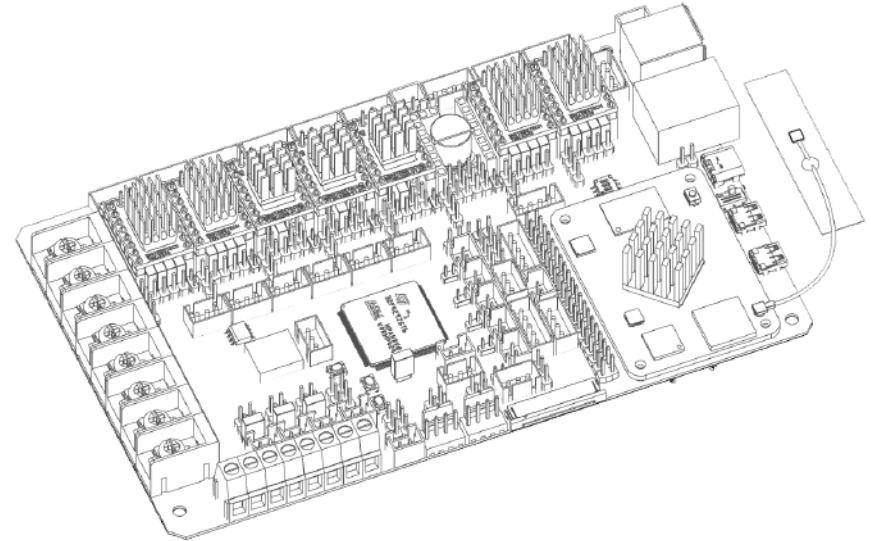
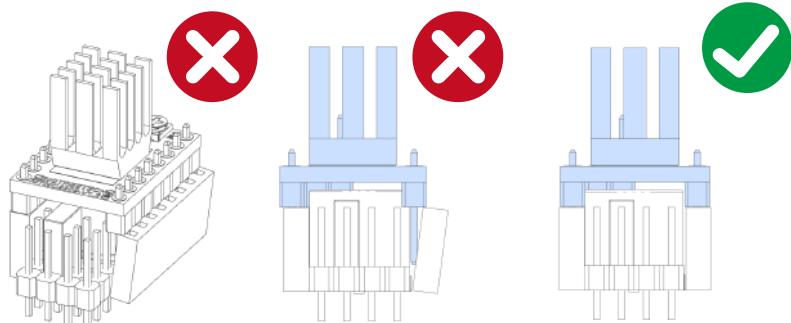
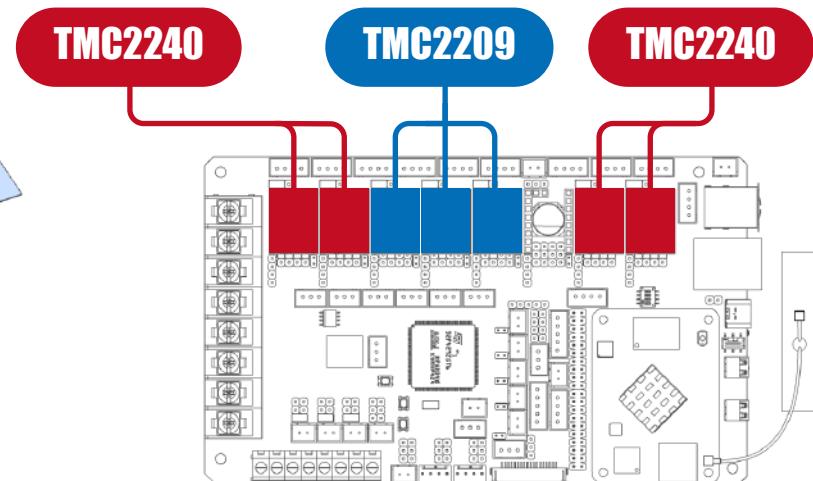
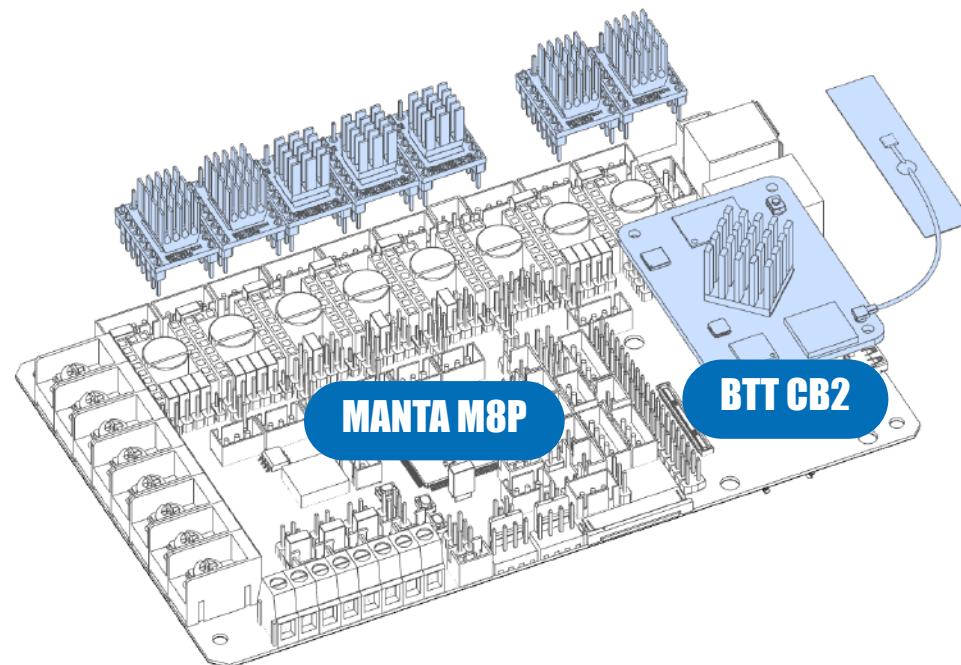
**TMC DRIVERS - UART MODE**

For TMC2209,  
Insert jumpers as shown in the blue box.

**TMC DRIVERS - UART MODE**

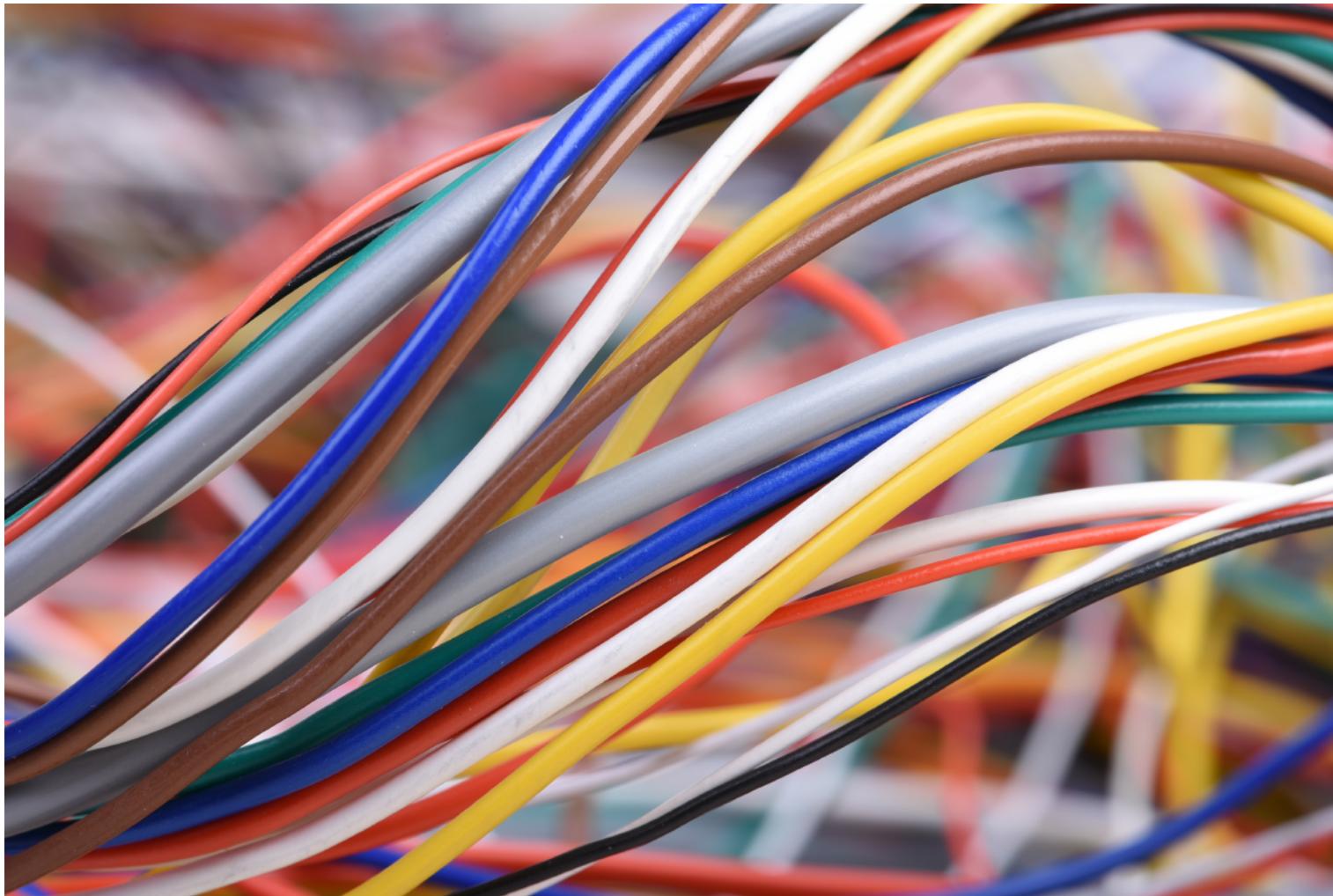
For TMC2240,TMC5160T,TMC5160T Pro  
Insert jumpers as shown in the blue box.

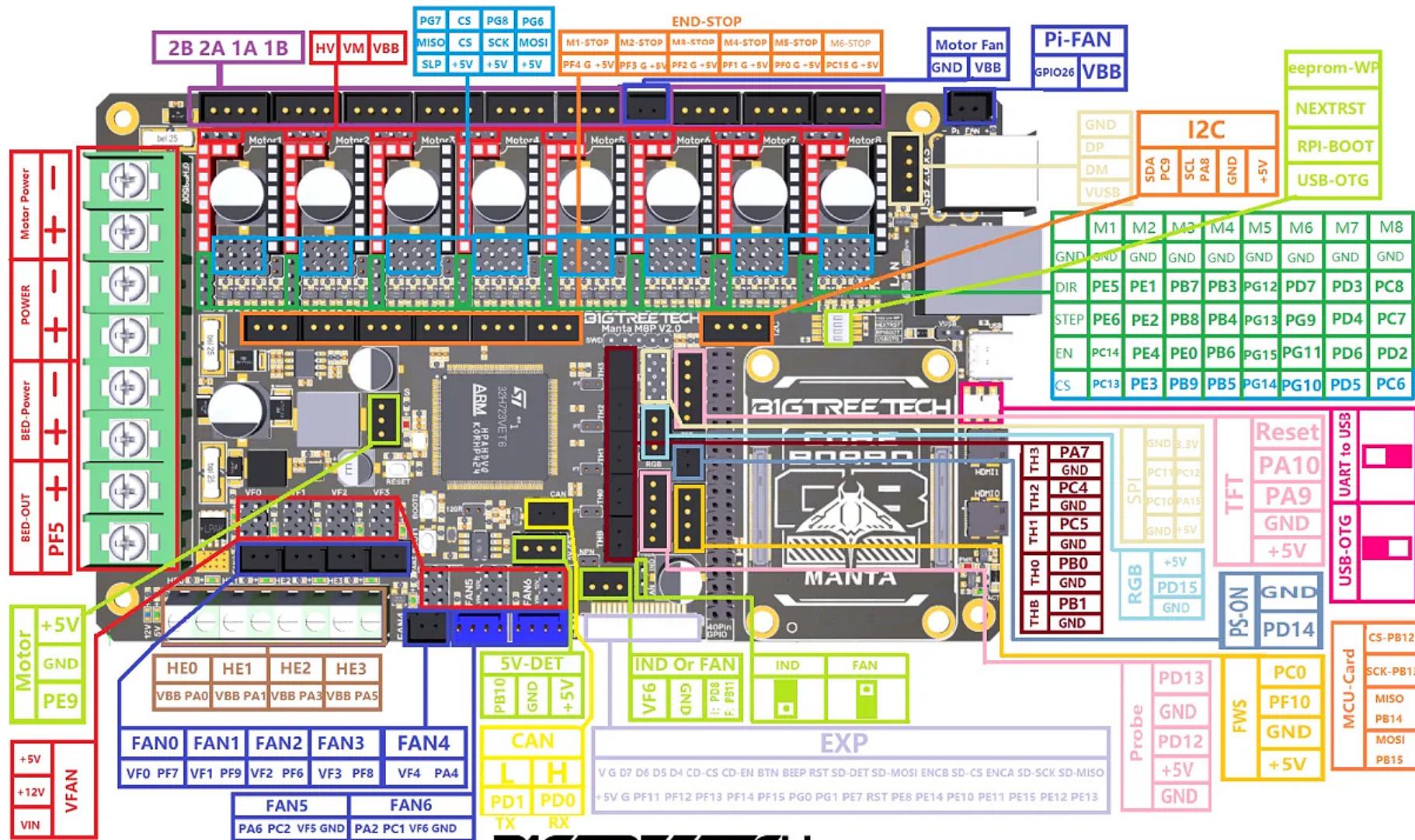




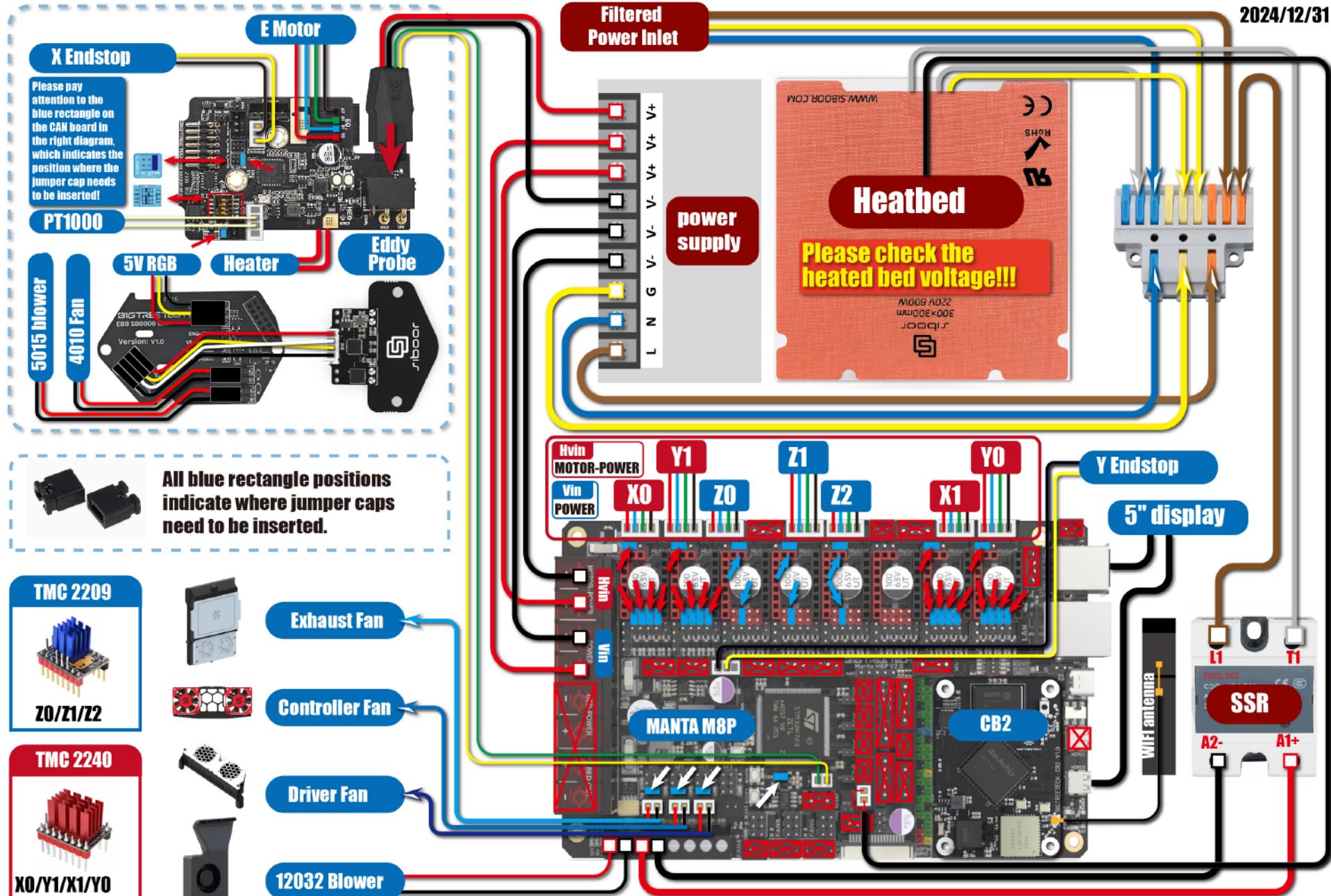
#### CHECKING DRIVER POSITION

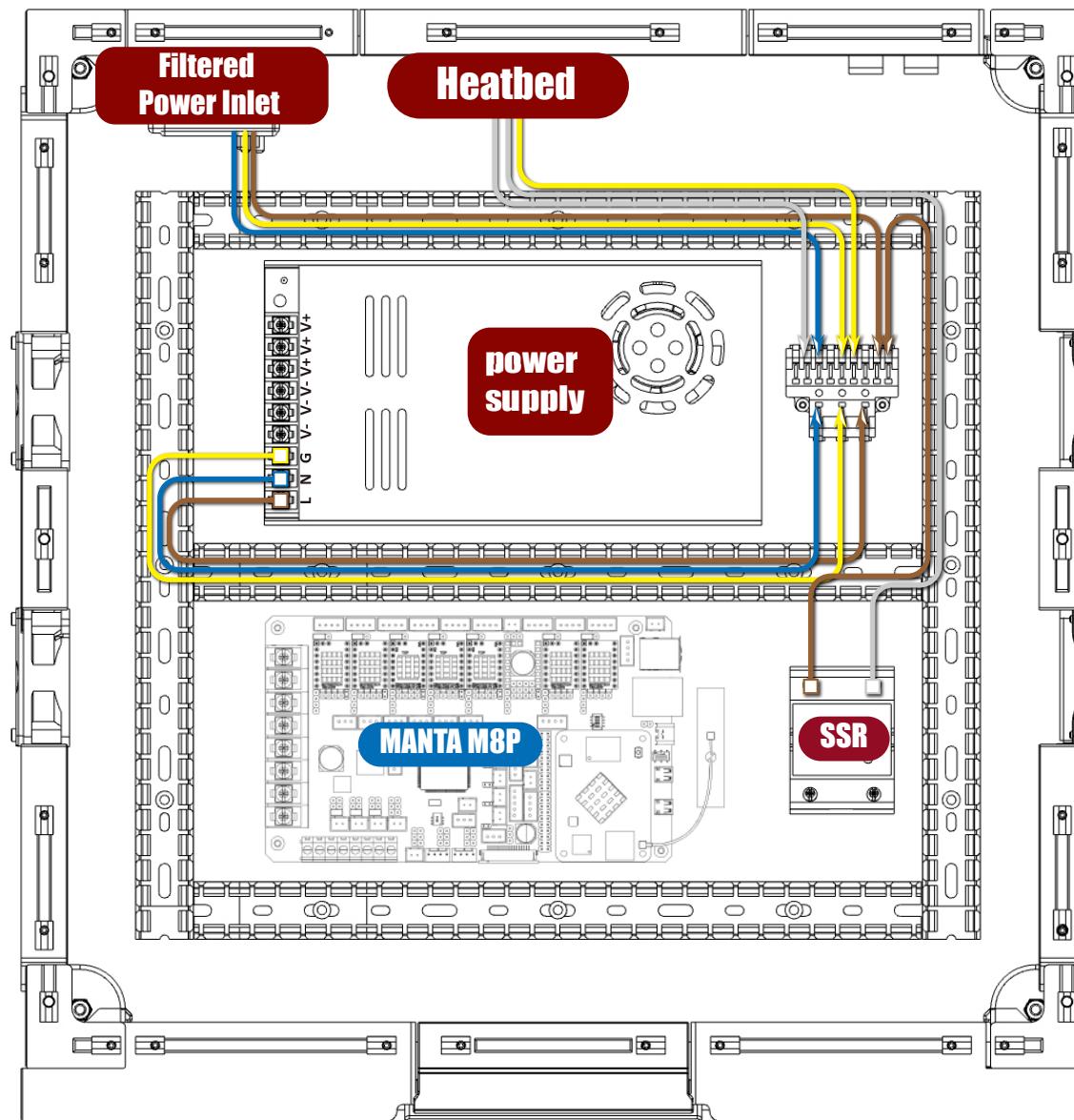
Check that the driver is inserted in the correct position to avoid short-circuiting the motherboard

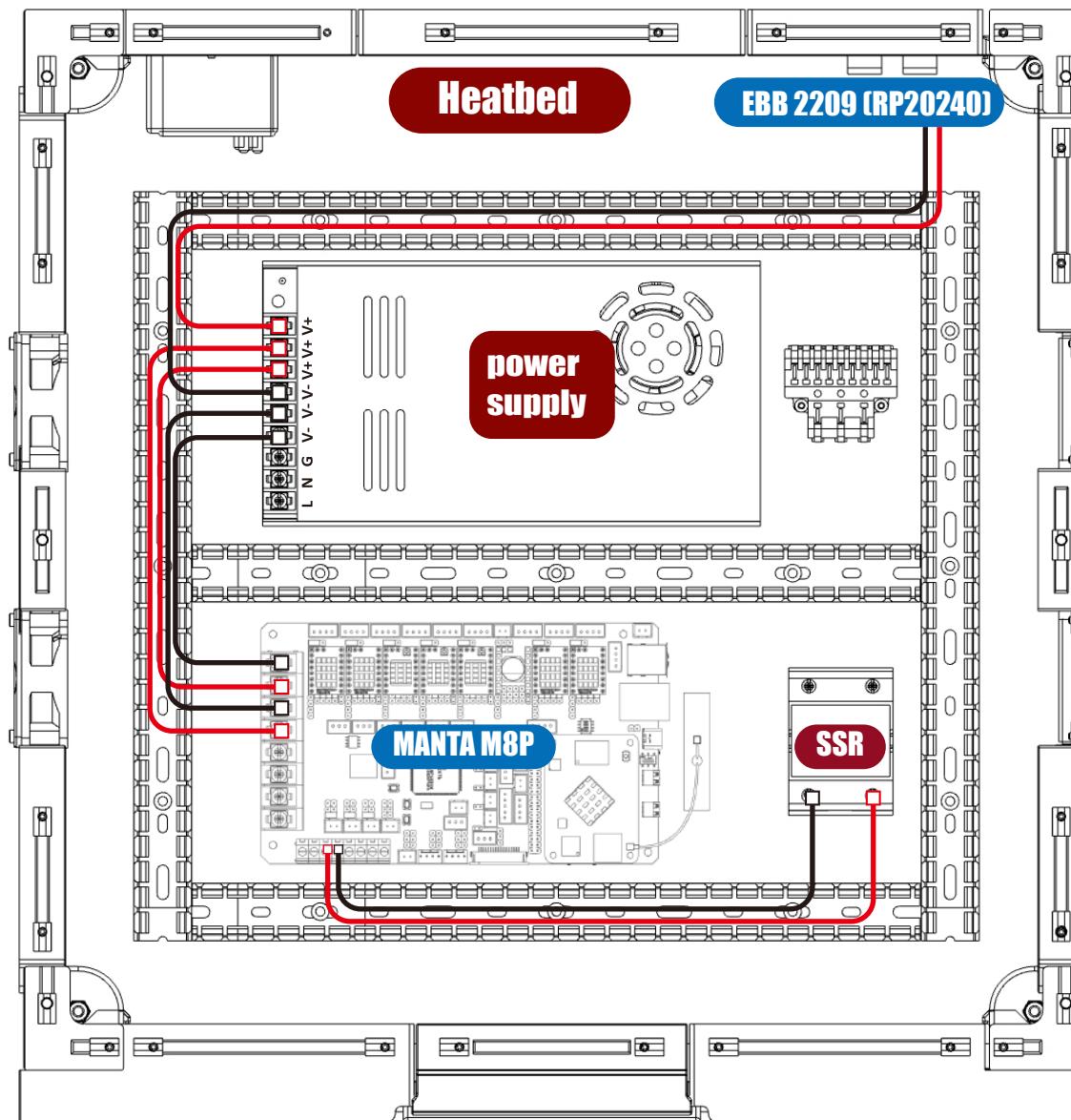


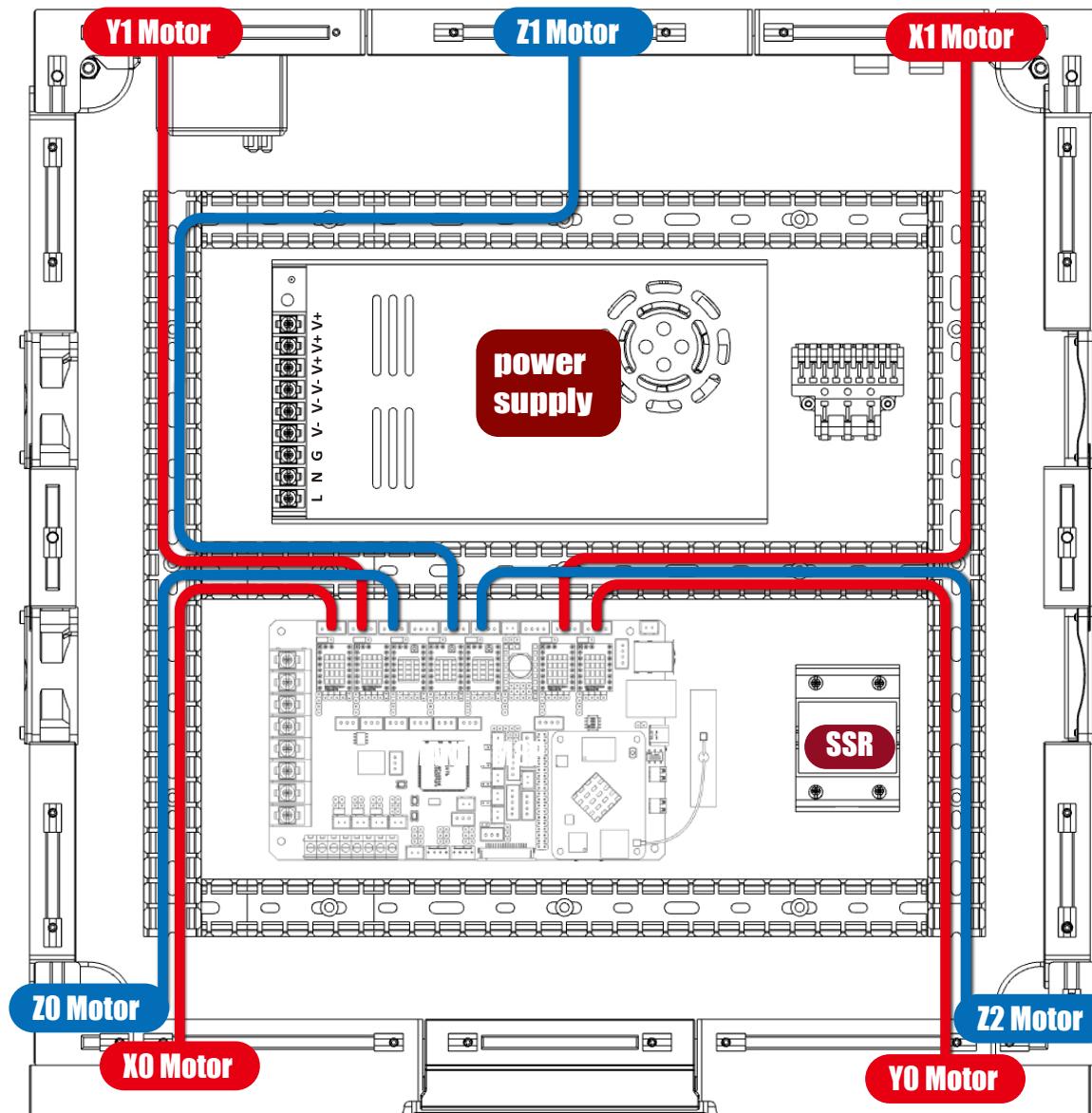


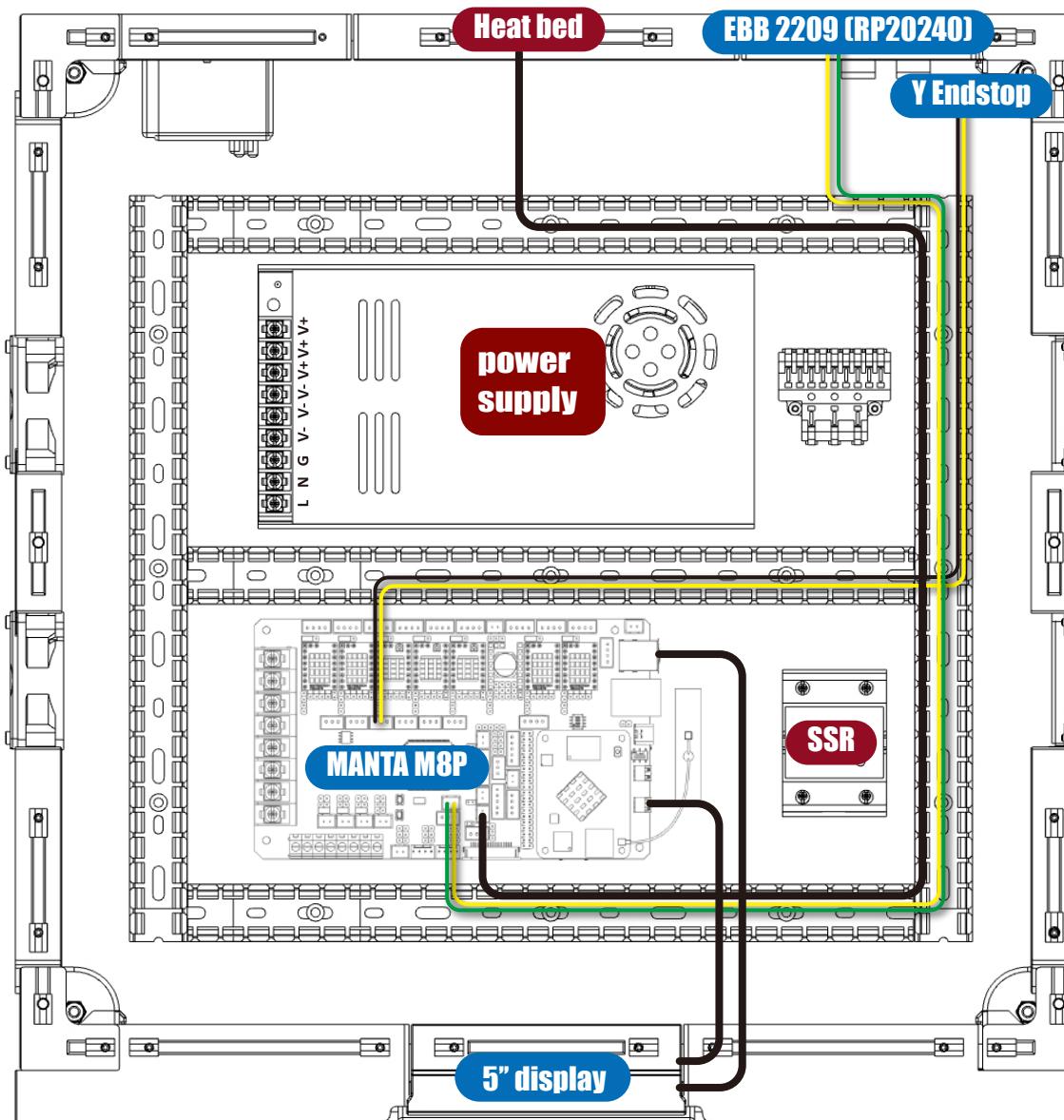
BIGTREE TECH MANTA M8P V2.0 Pin-Out

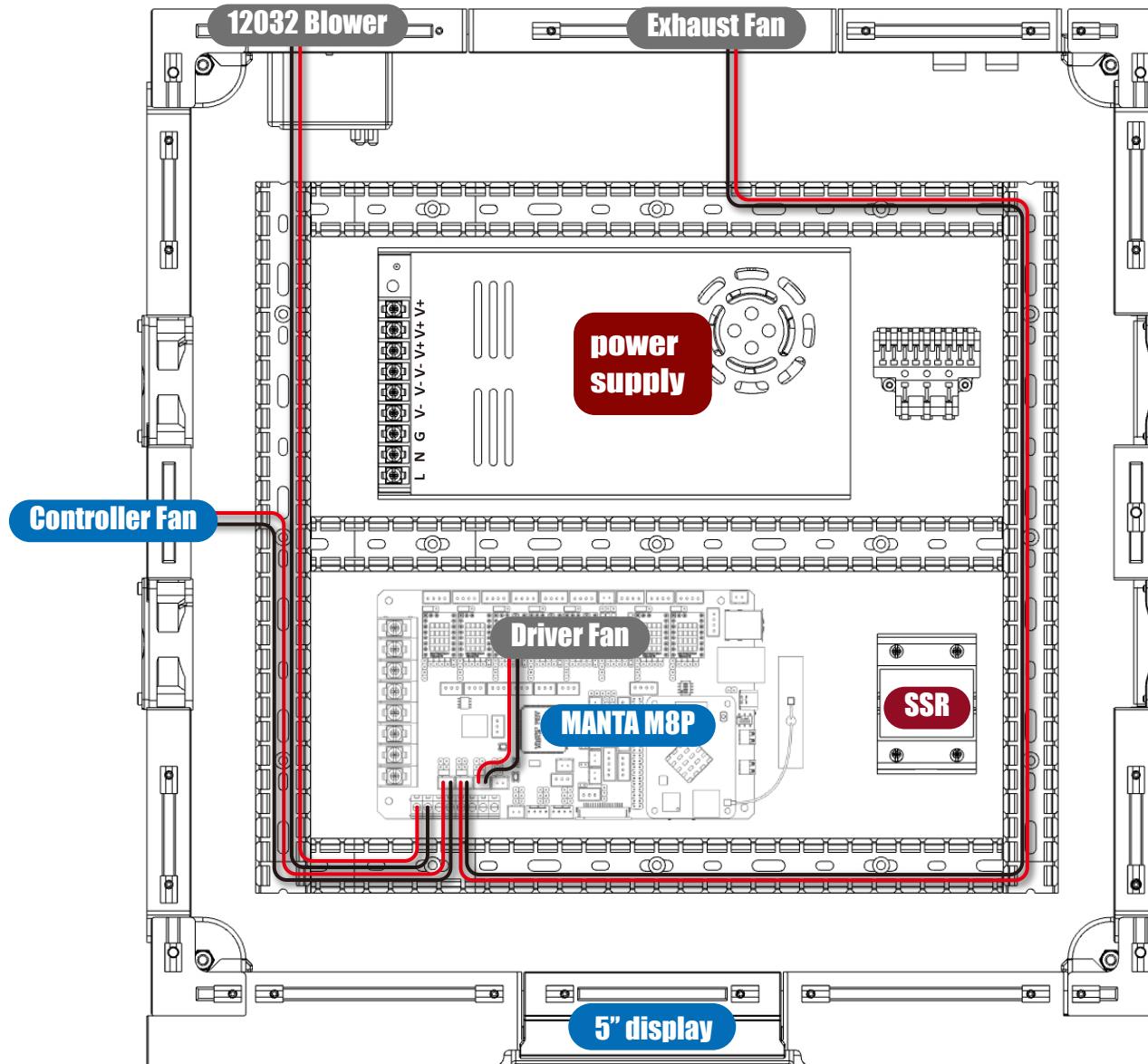










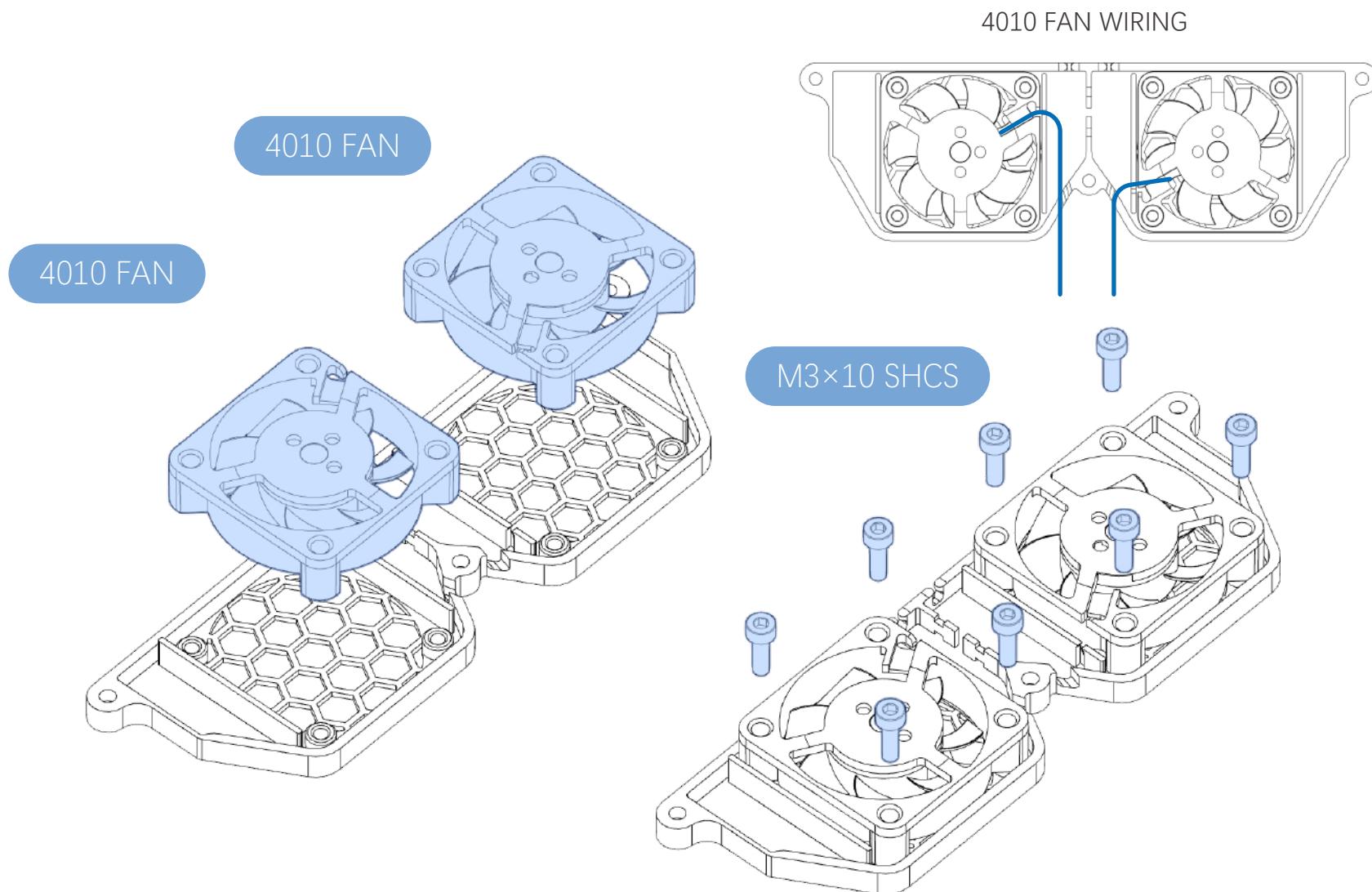


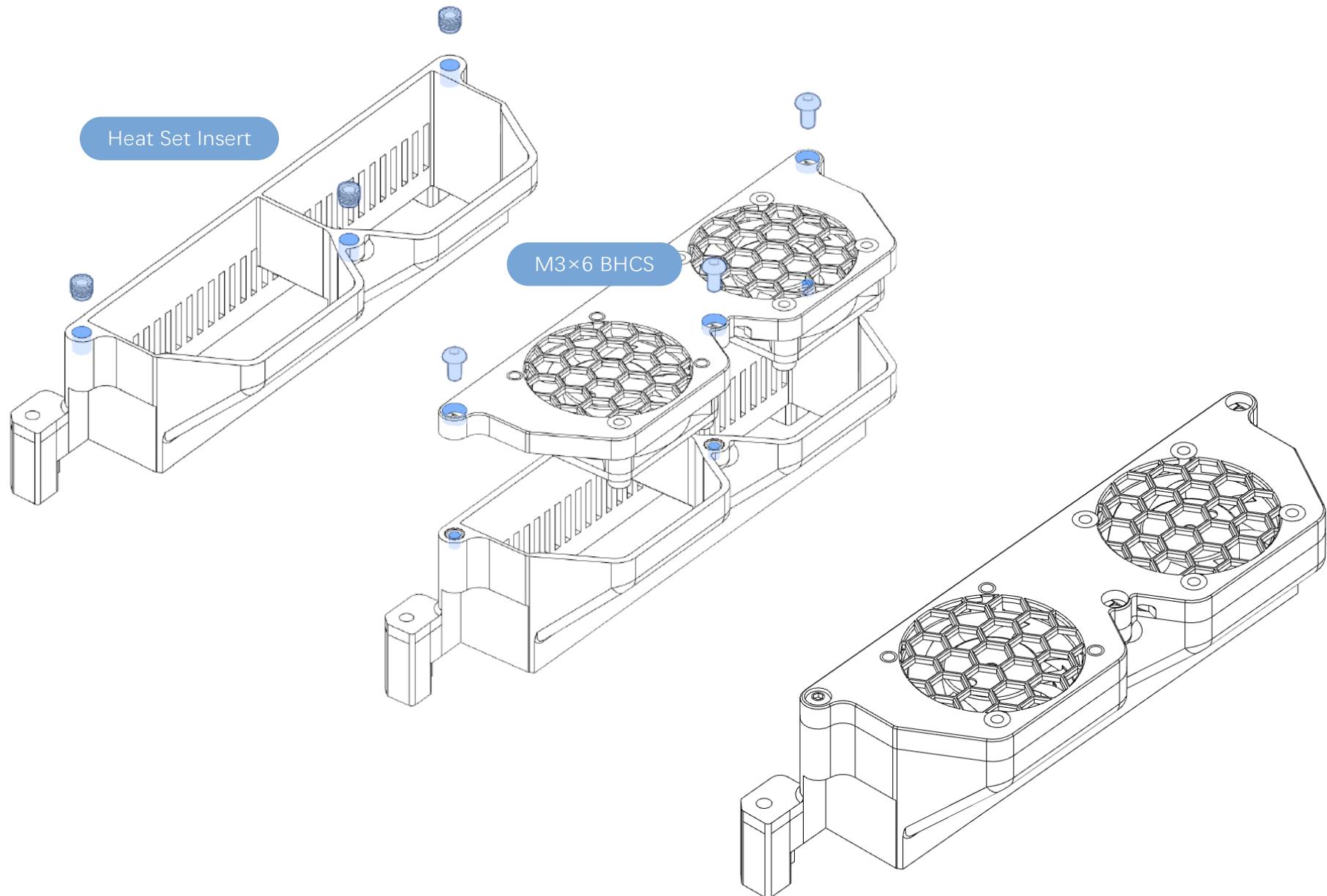
### WHAT DO THE GRAY BOXES MEAN?

The gray boxes symbolize parts that have not yet been assembled in the current progress, but are shown in advance for wiring demonstration purposes.

### CLOSE THE CABLE MANAGEMENT DUCT?

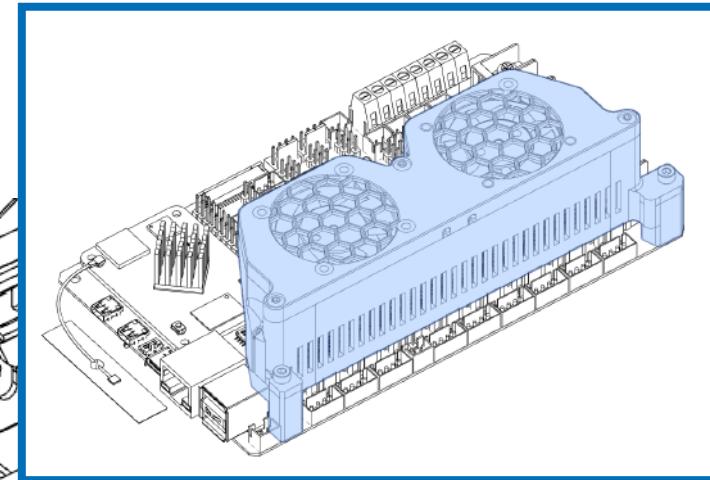
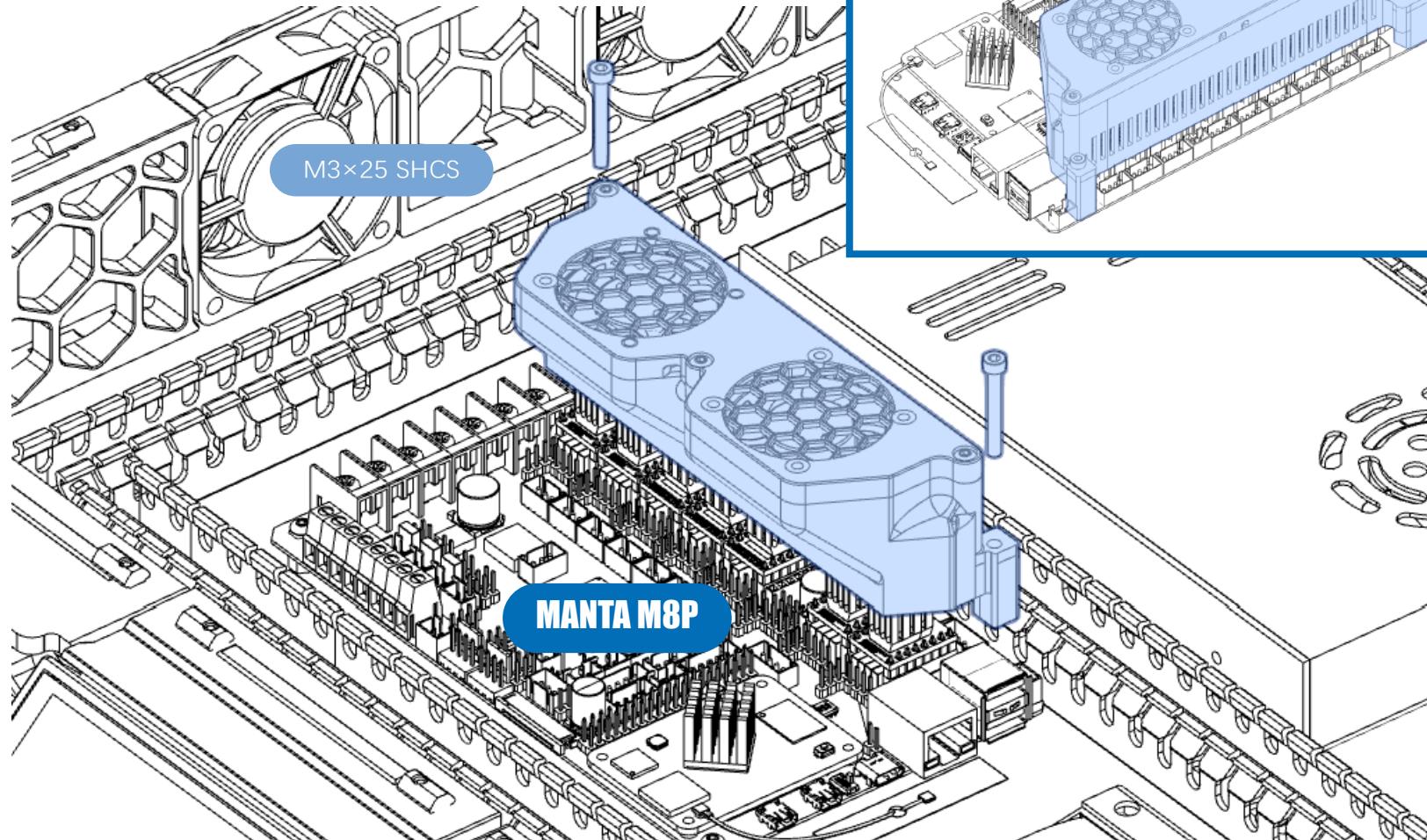
It is not the best time to close the cable management duct now.  
I will remind you on page 221.

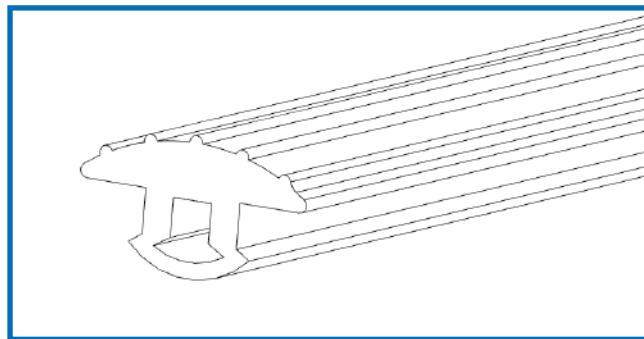




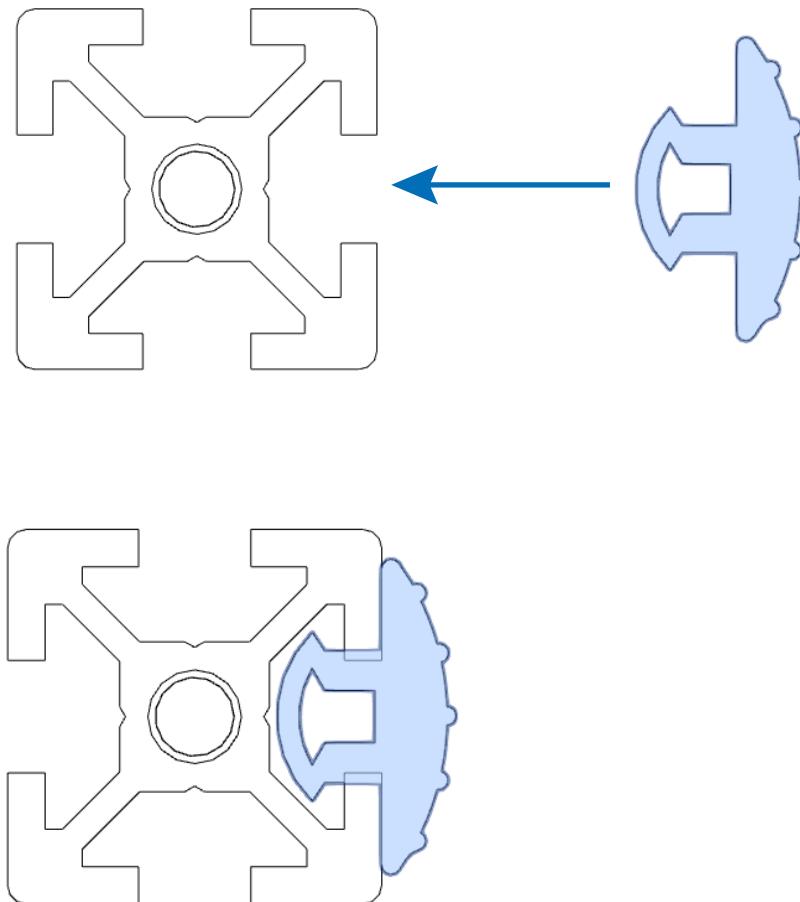
## MOUNTING THE DRIVE HEATSINK MODULE

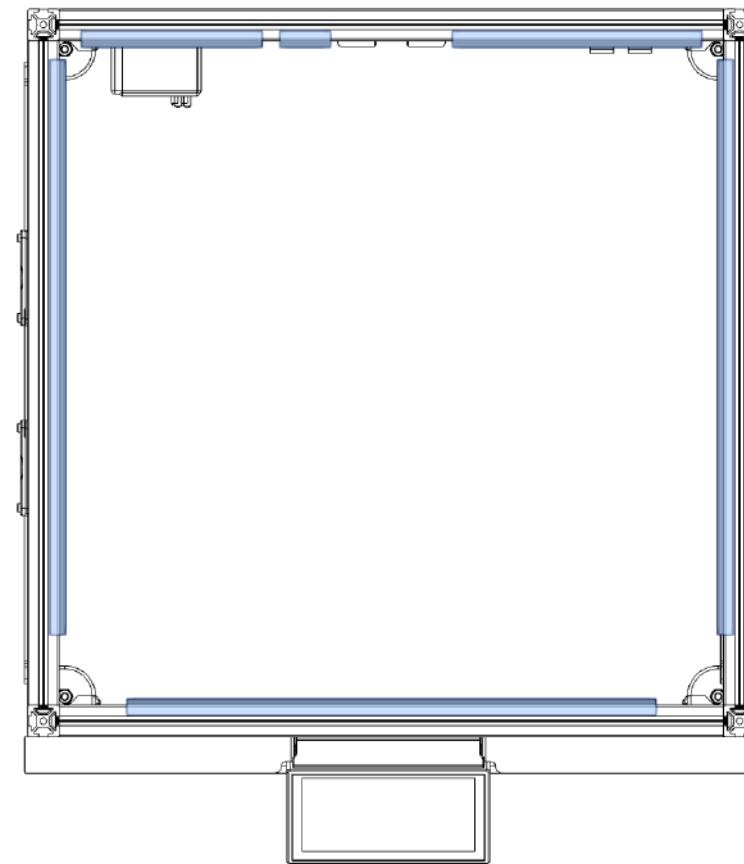
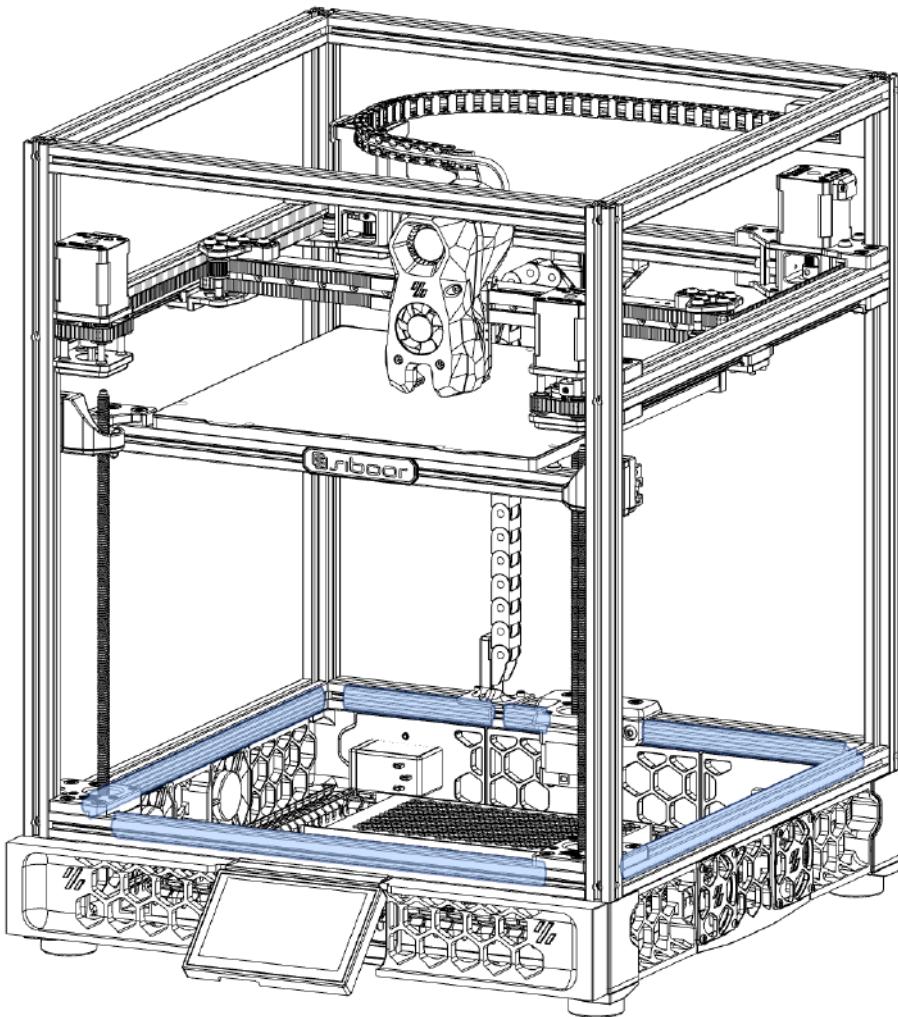
Remove the two M3×6 BHCS screws used to secure the mainboard, then use M3×25 SHCS screws to mount the drive heatsink module onto the Manta M8P board.





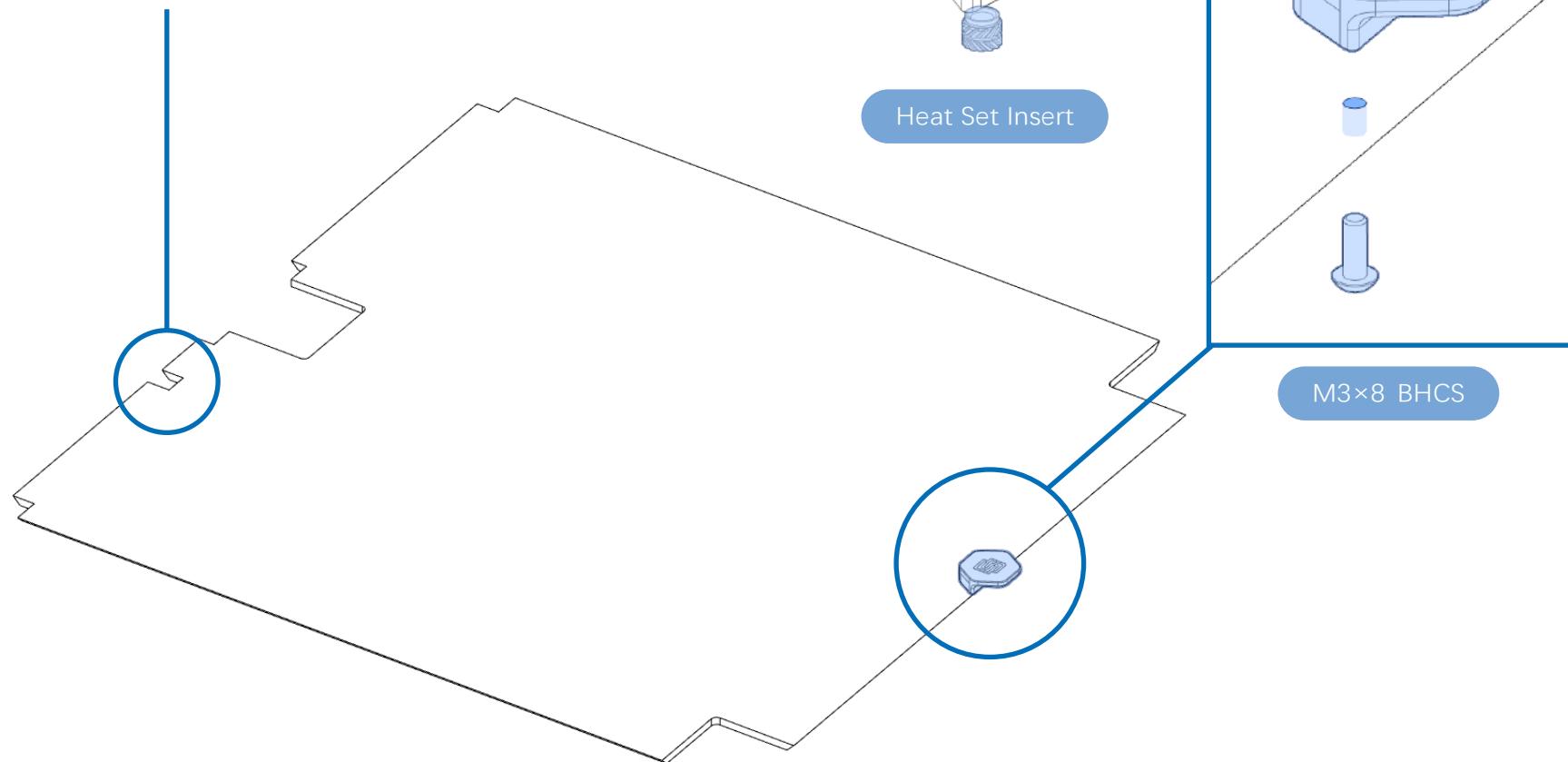
Flat Anti-Slip Strip





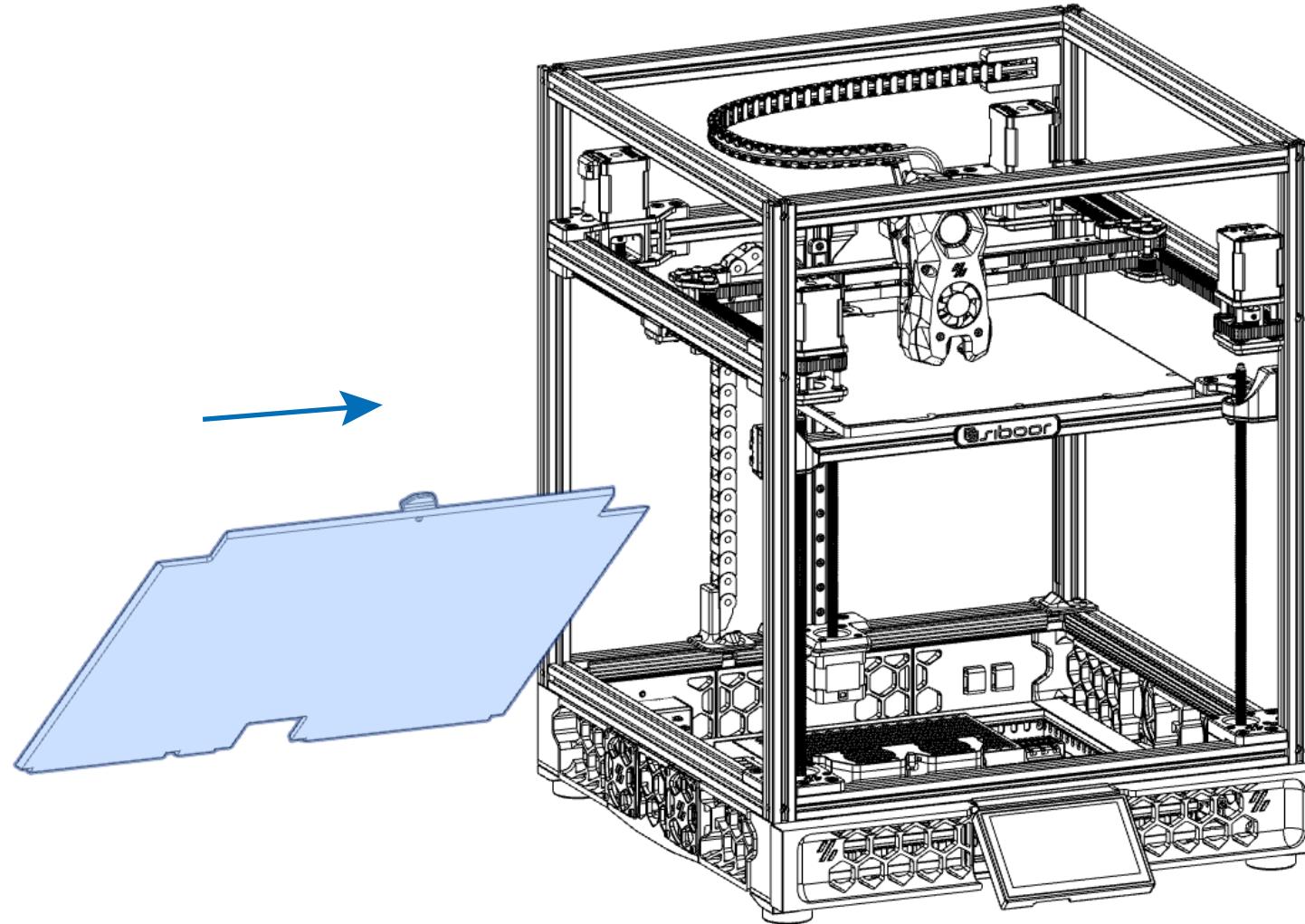
**Notch Position Awareness**

Pay attention to the notch position to distinguish between the top and bottom surfaces.





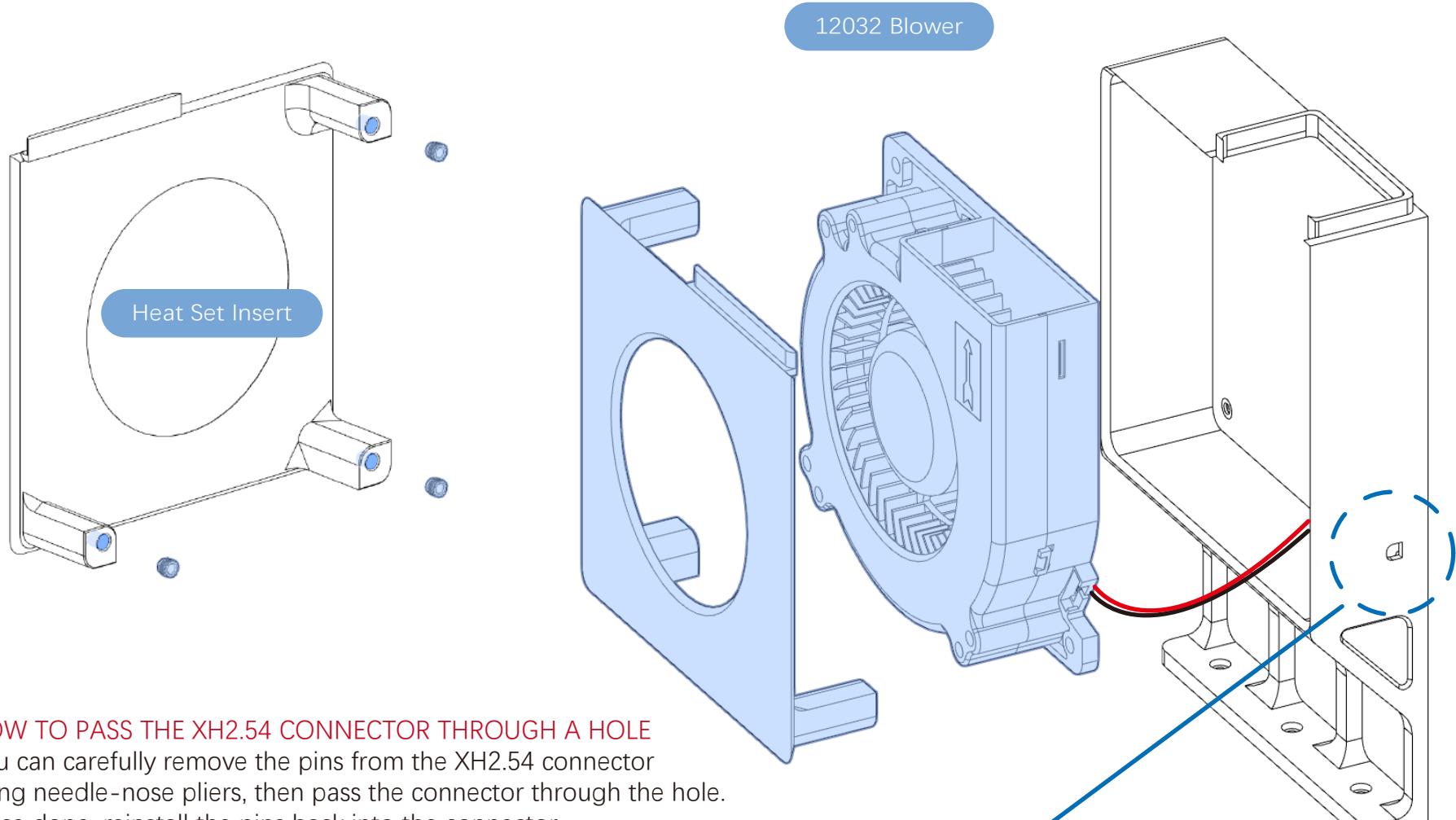
It's pretty cool, right? We can open the electrical compartment without flipping the printer, and the rubber Flat Anti-Slip Strip also provides a good sealing effect.



12032 PART FANS

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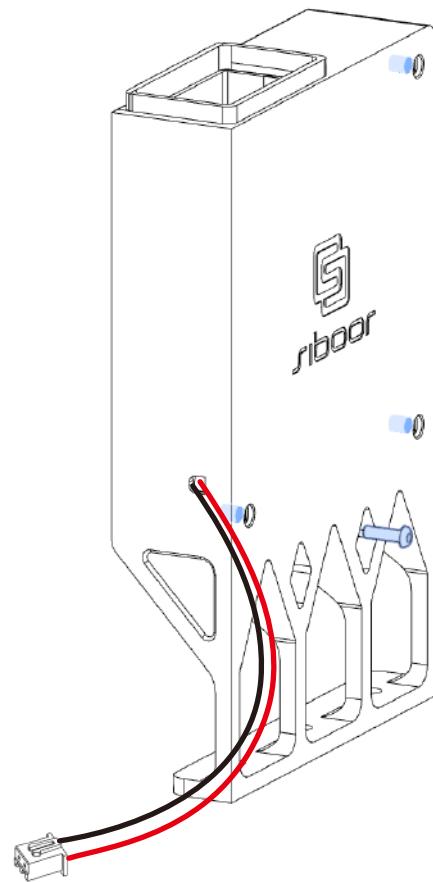


#### HOW TO PASS THE XH2.54 CONNECTOR THROUGH A HOLE

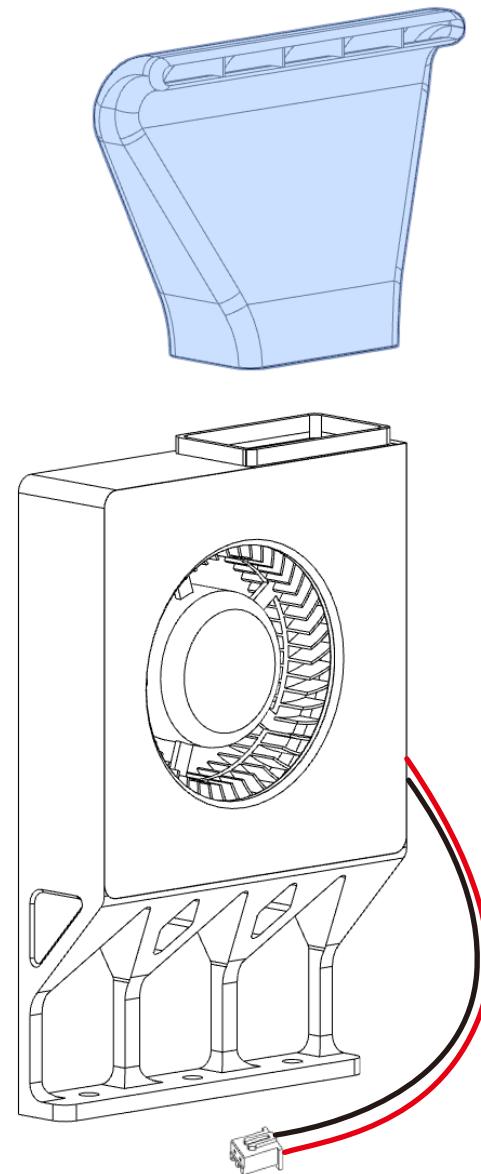
You can carefully remove the pins from the XH2.54 connector using needle-nose pliers, then pass the connector through the hole. Once done, reinstall the pins back into the connector.

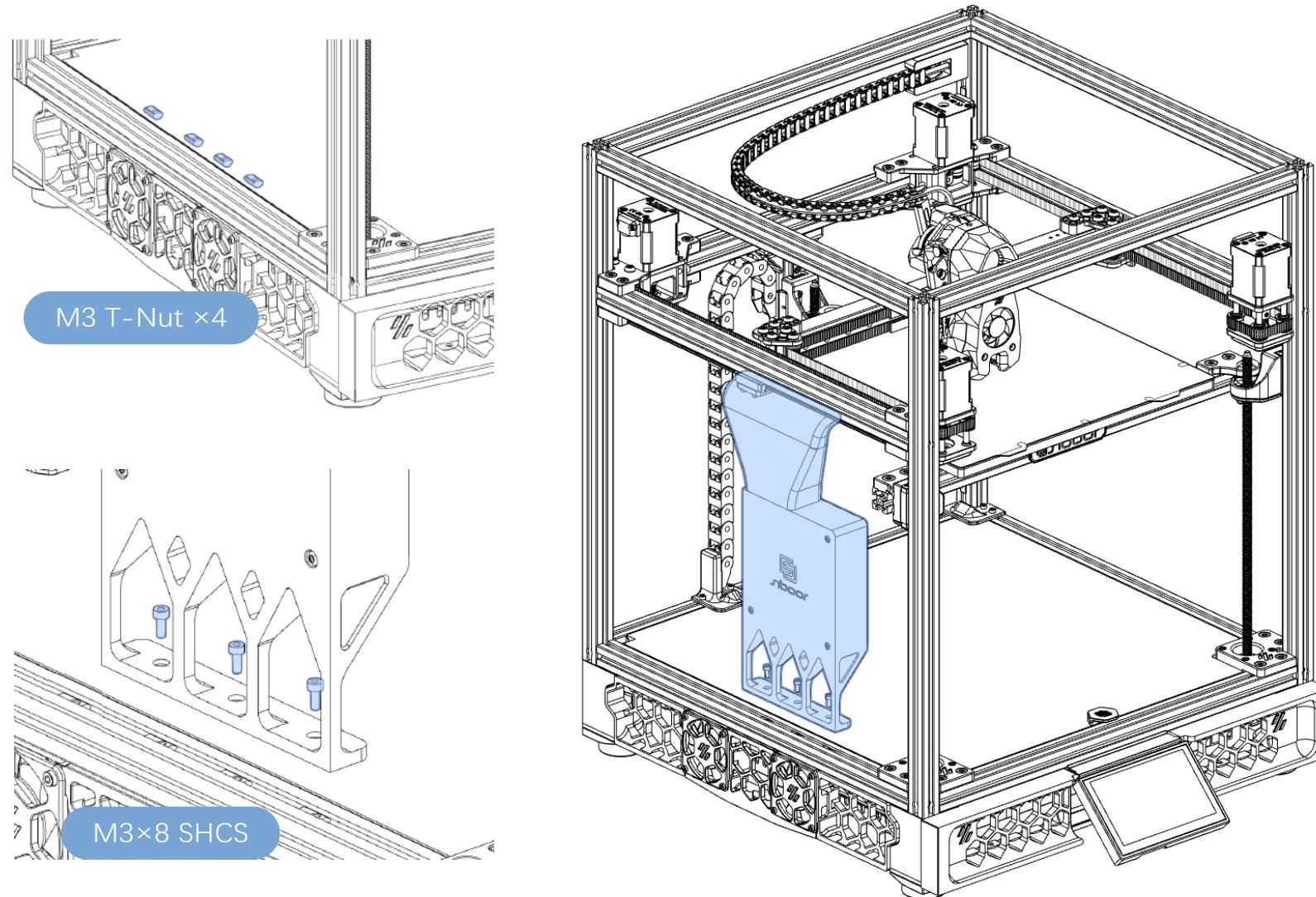
You can refer to this video tutorial:

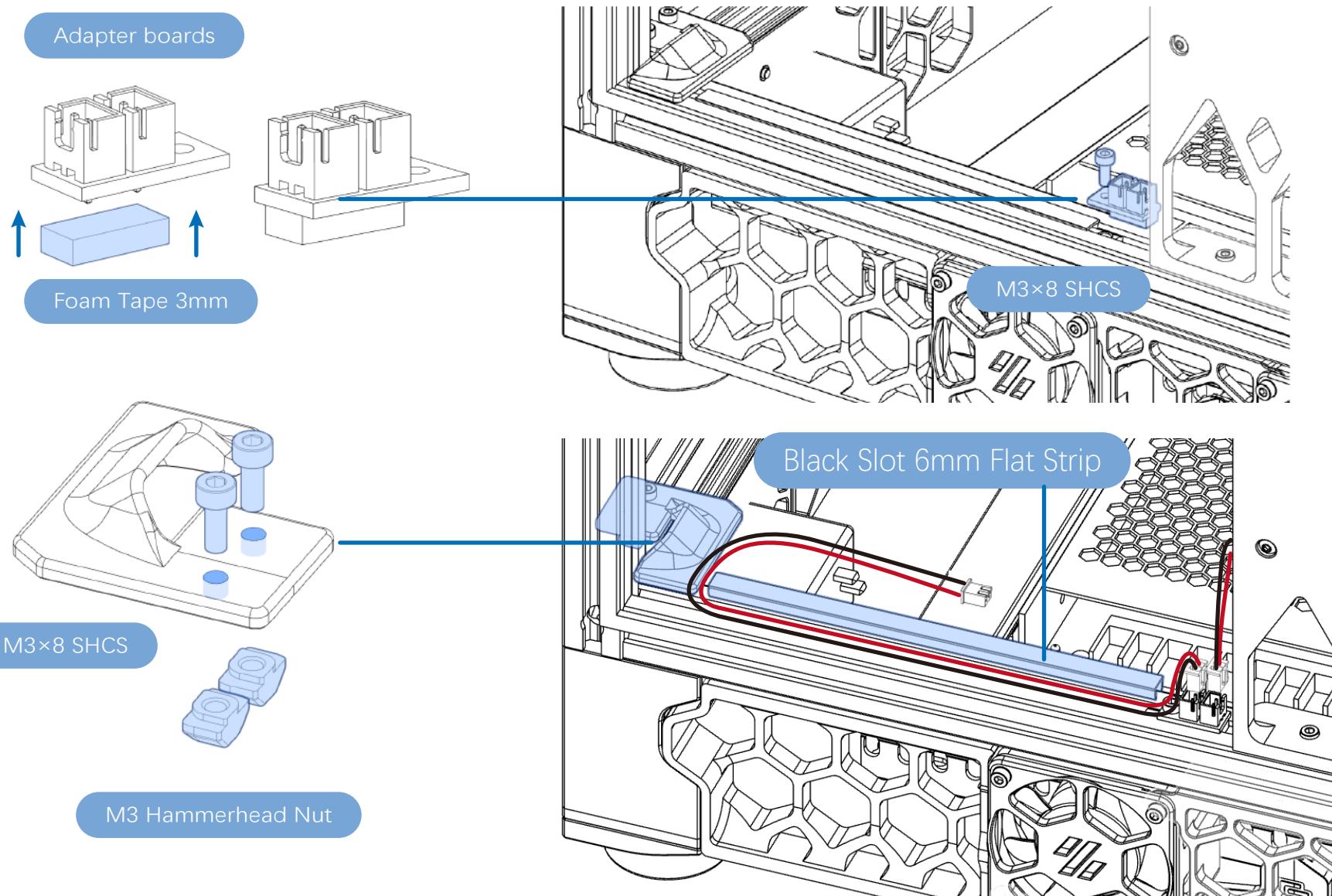
[https://www.youtube.com/watch?v=q8tU\\_NEZK9g](https://www.youtube.com/watch?v=q8tU_NEZK9g)



M3×12 BHCS



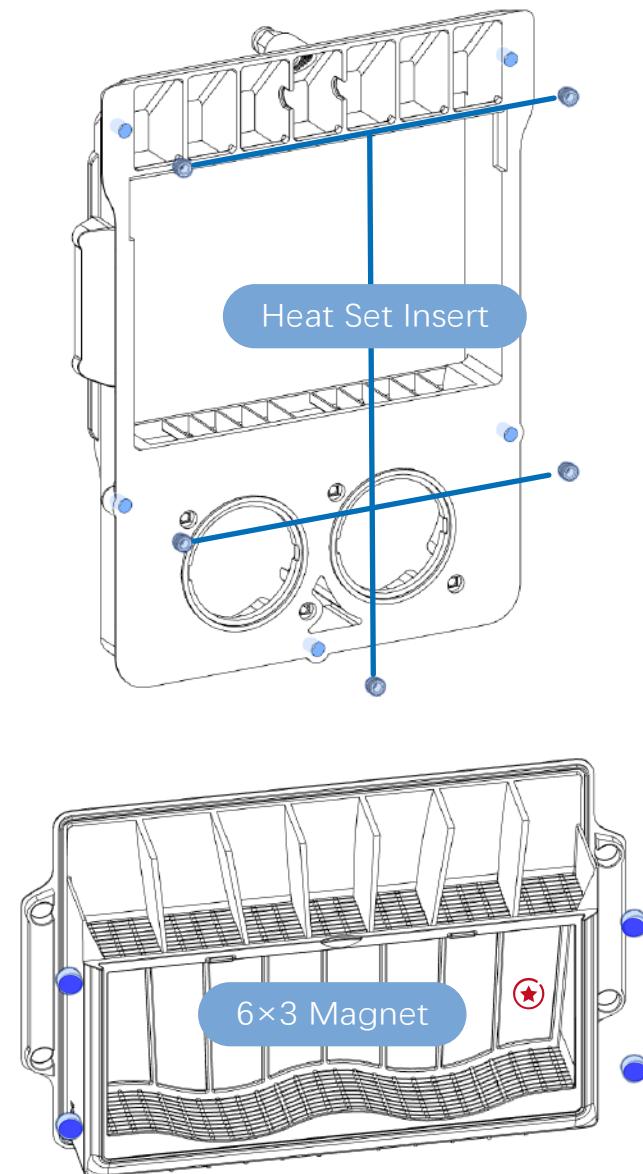
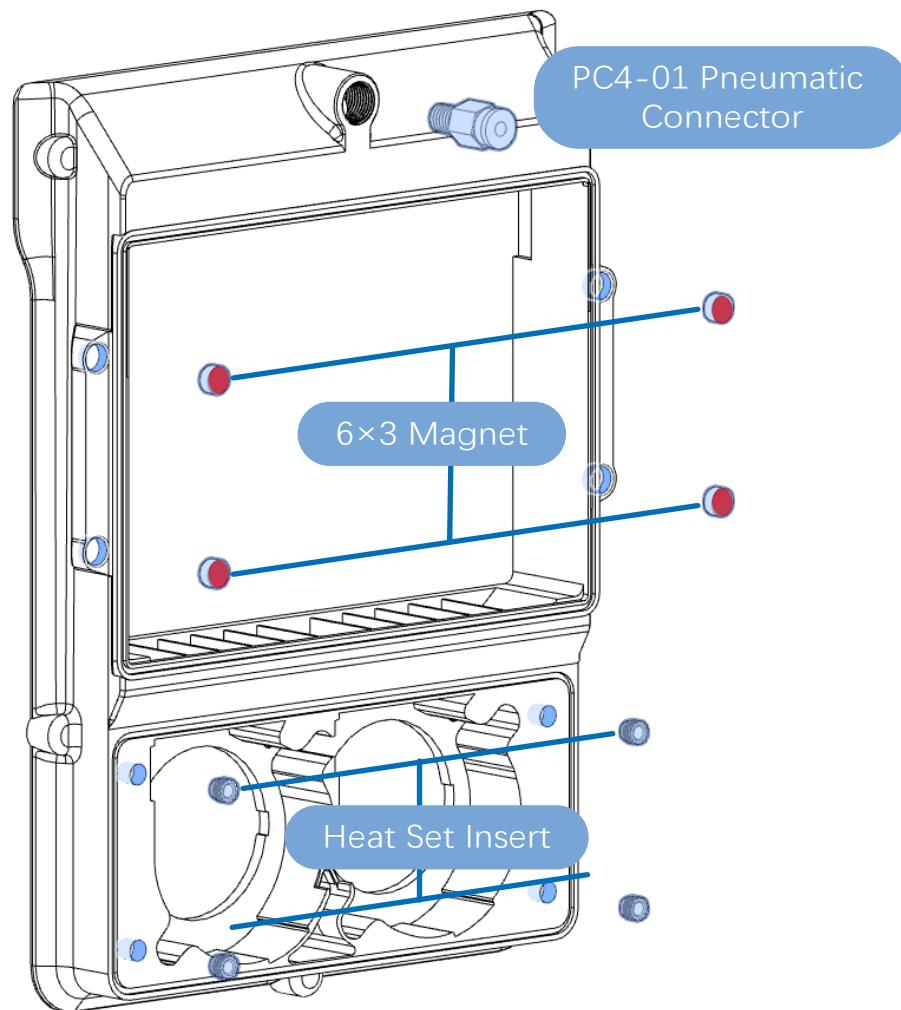


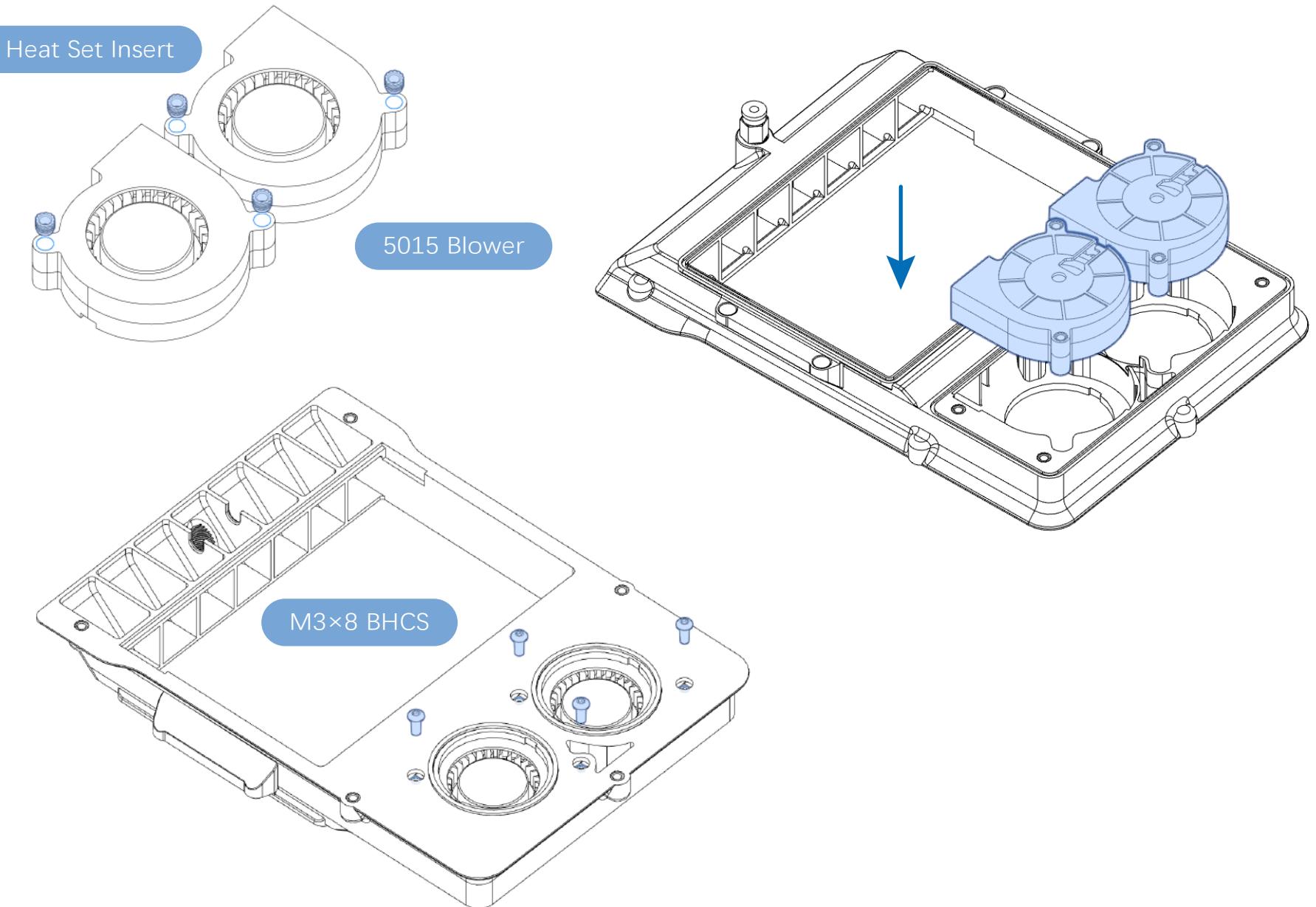


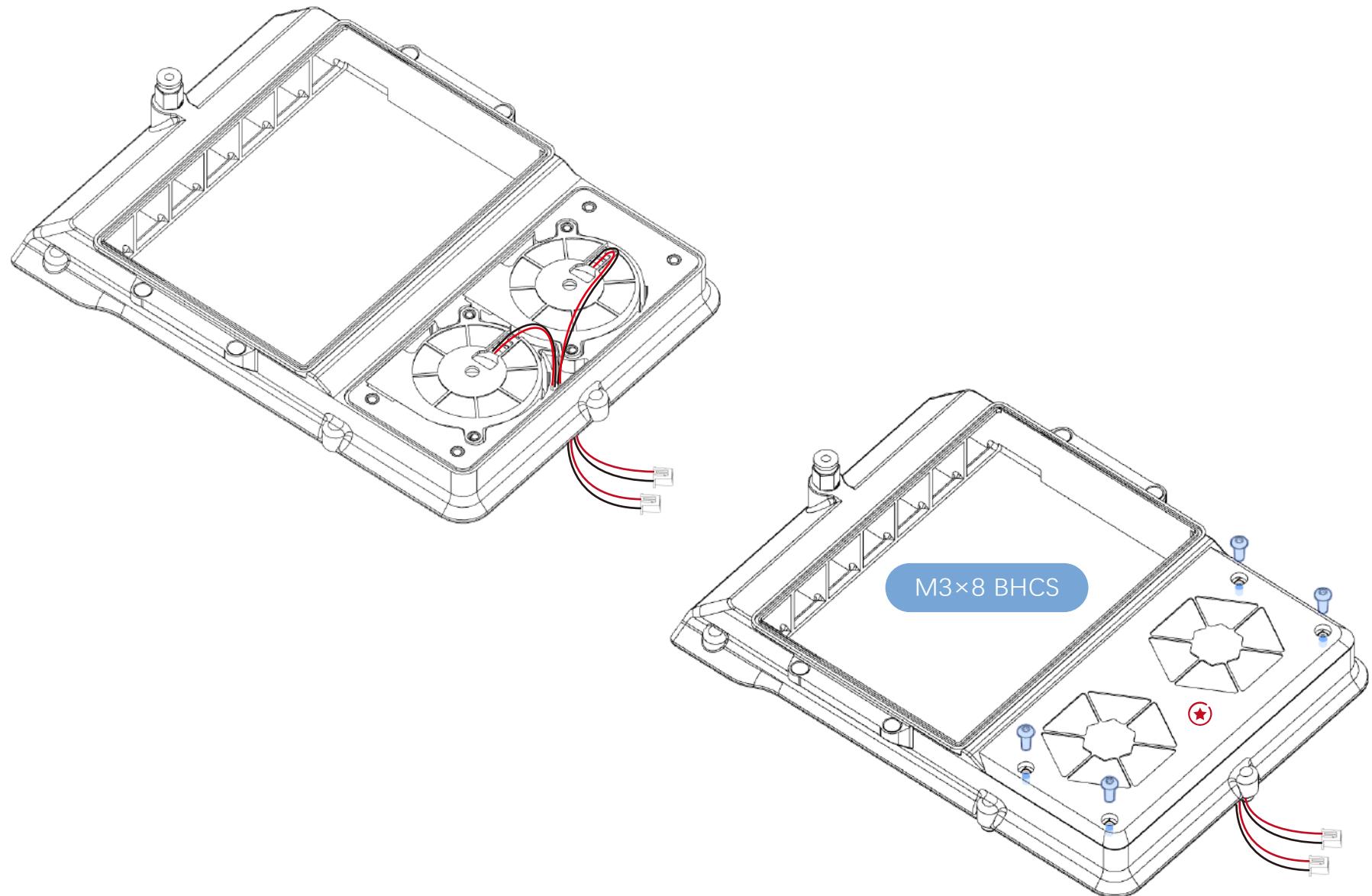


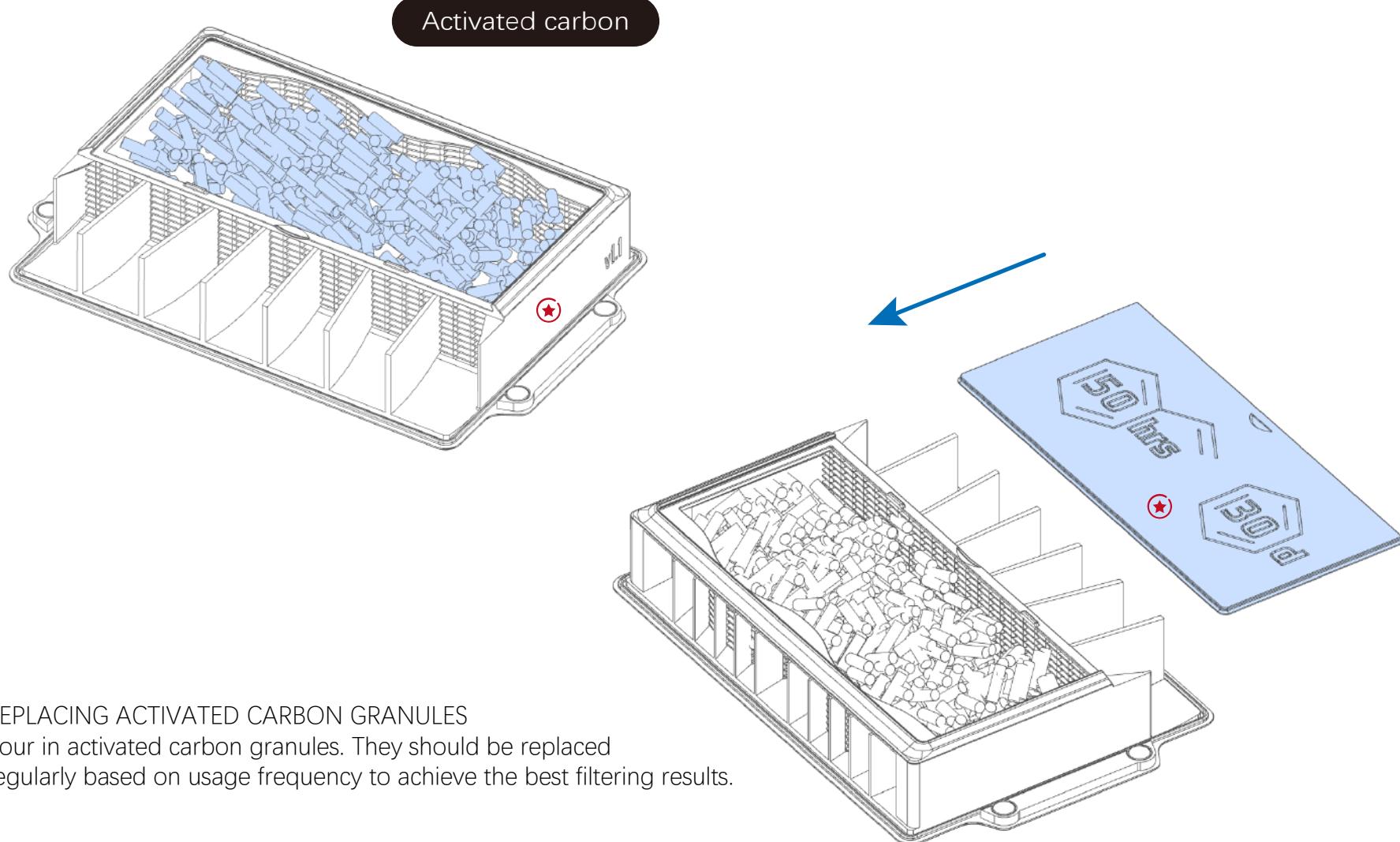
**IMPORTANT NOTICE**

Ensure to distinguish the poles of the round magnets; otherwise, the filter bag will not attach to the main body of the filter module.



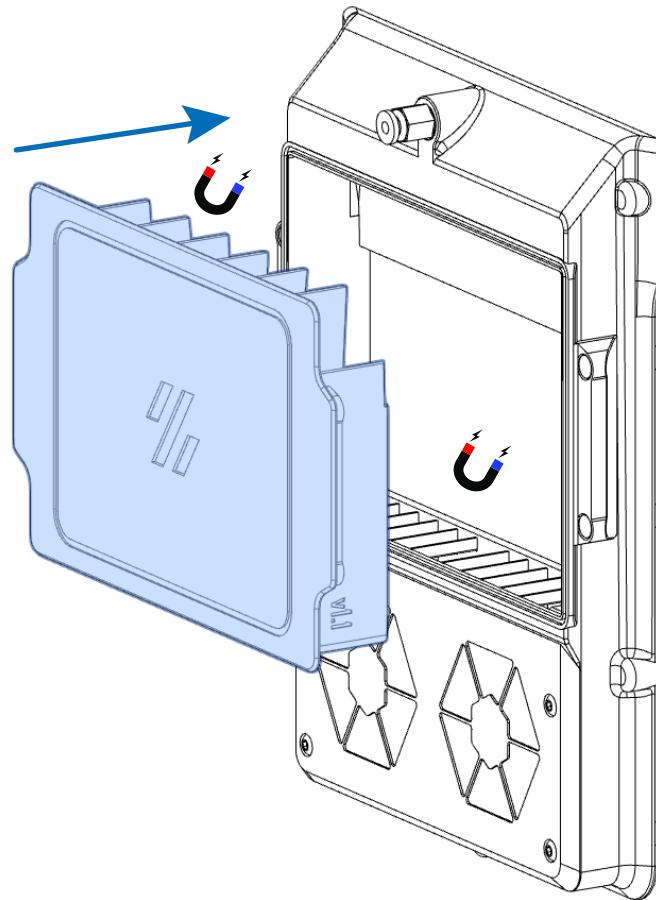
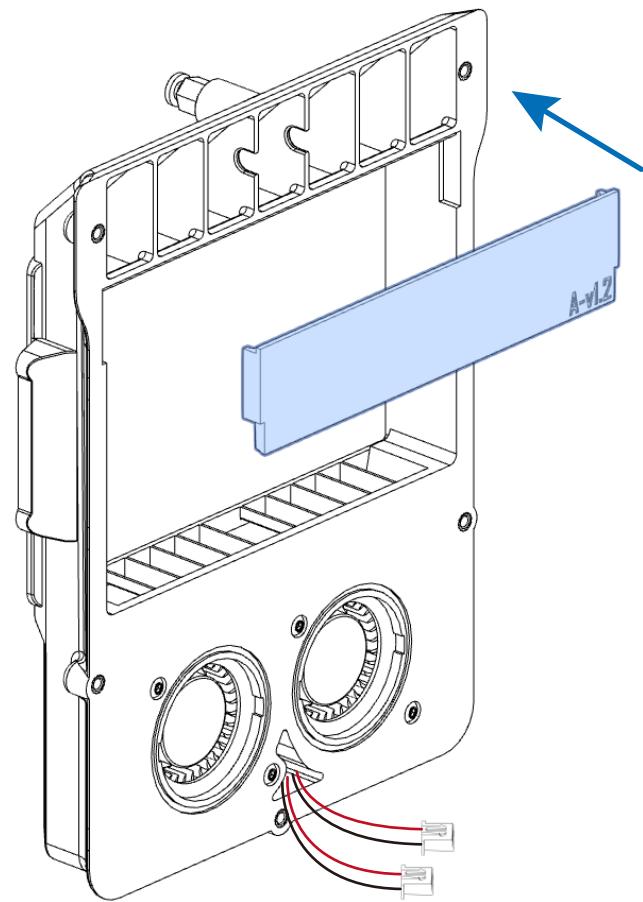


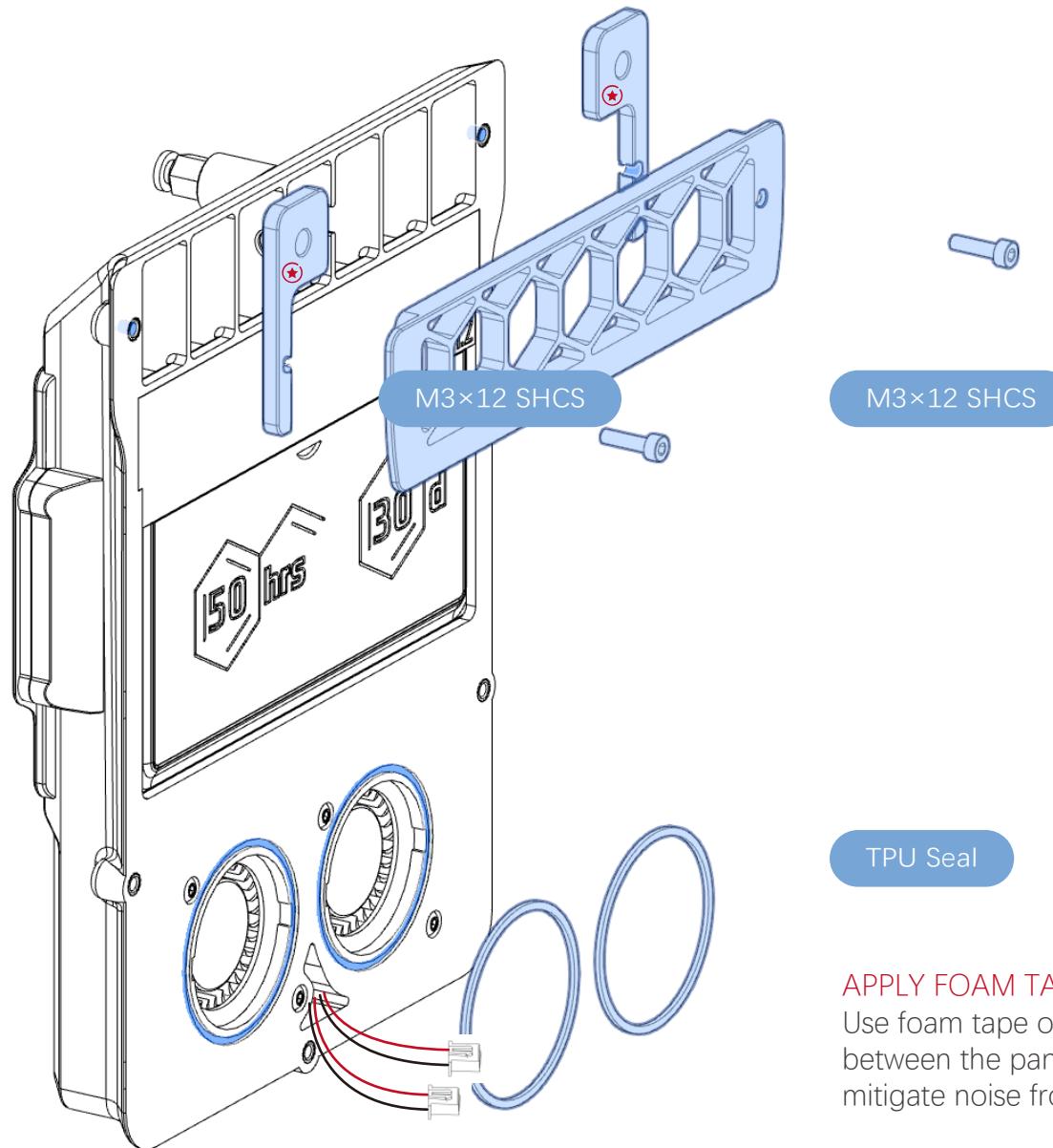




#### REPLACING ACTIVATED CARBON GRANULES

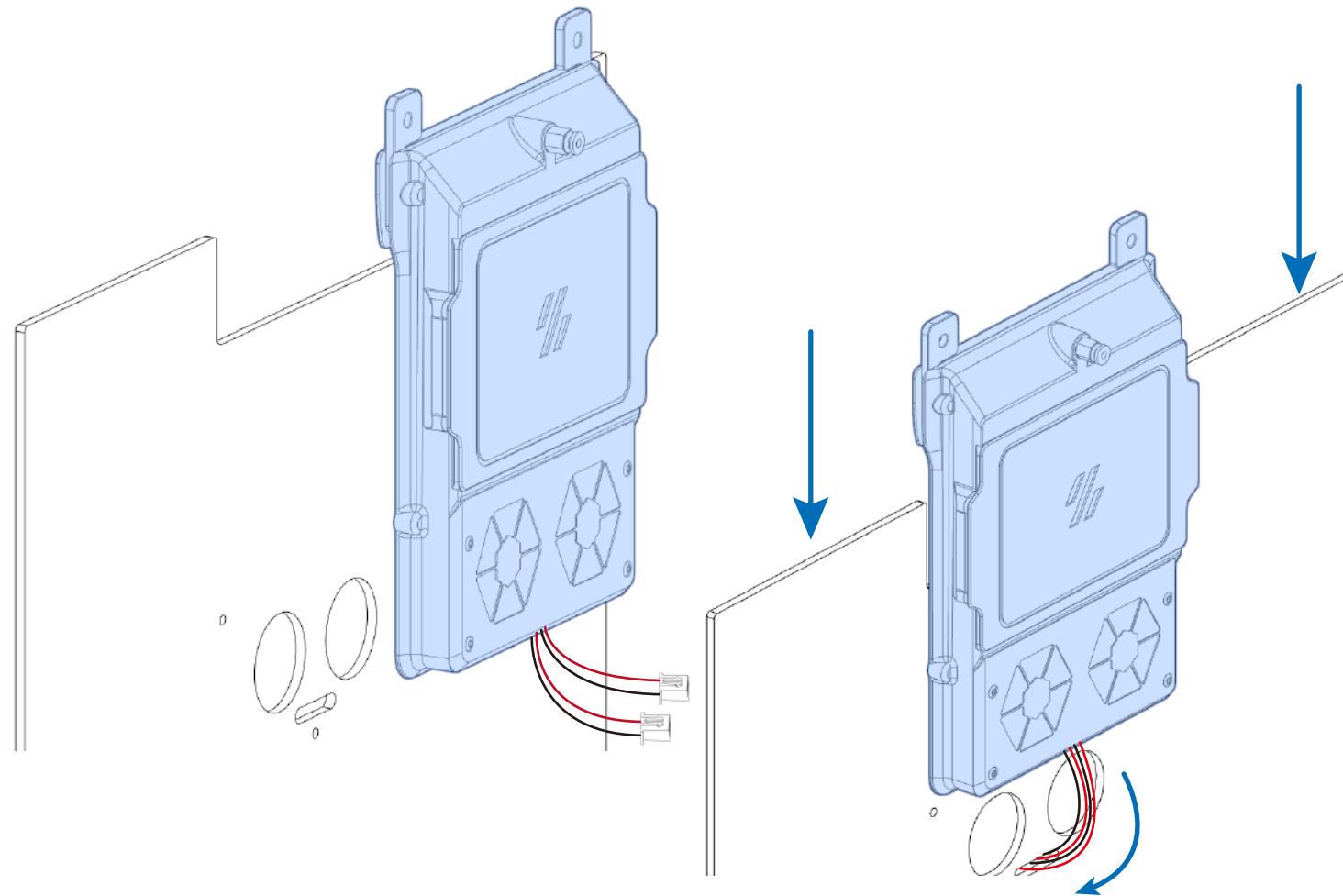
Pour in activated carbon granules. They should be replaced regularly based on usage frequency to achieve the best filtering results.

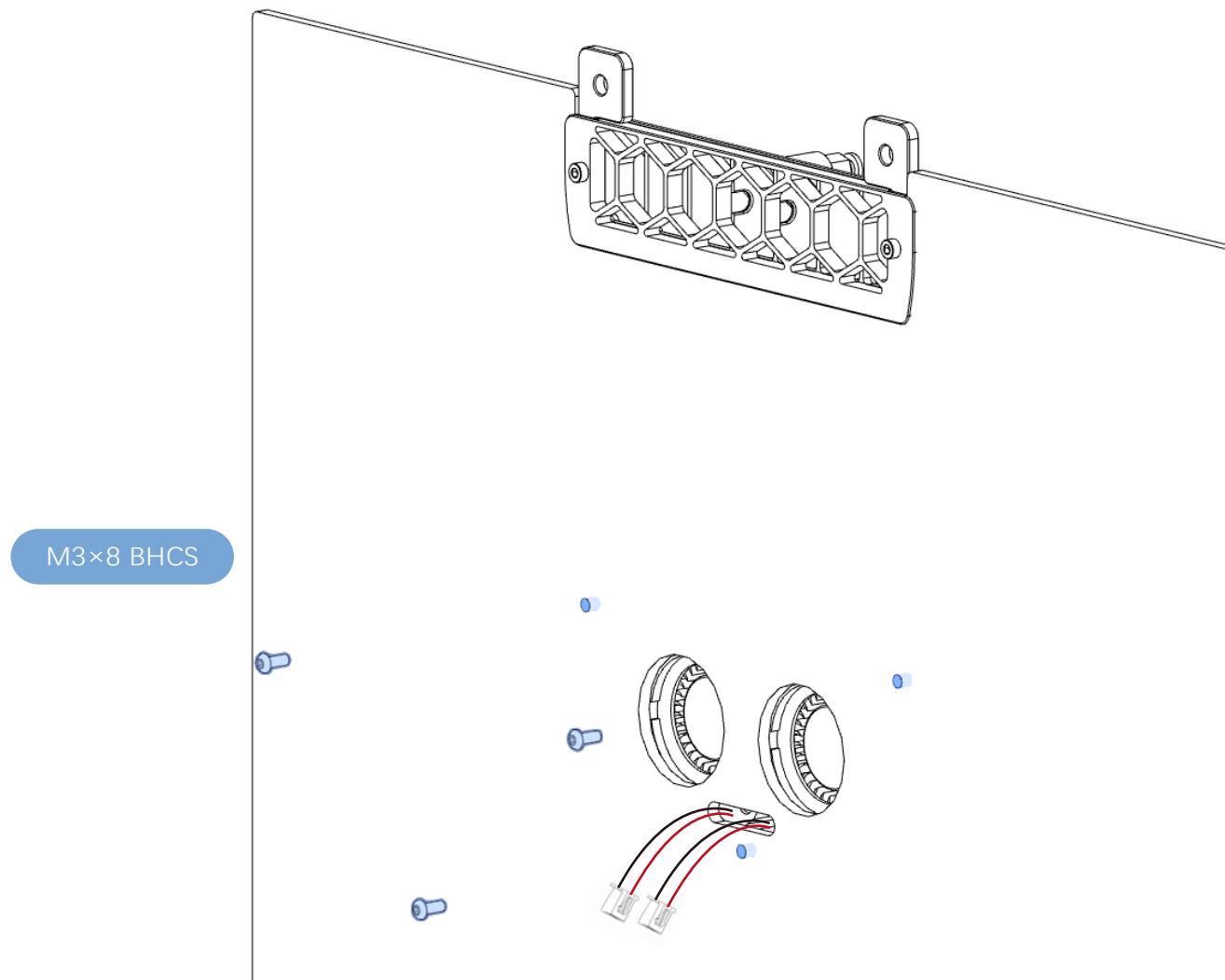


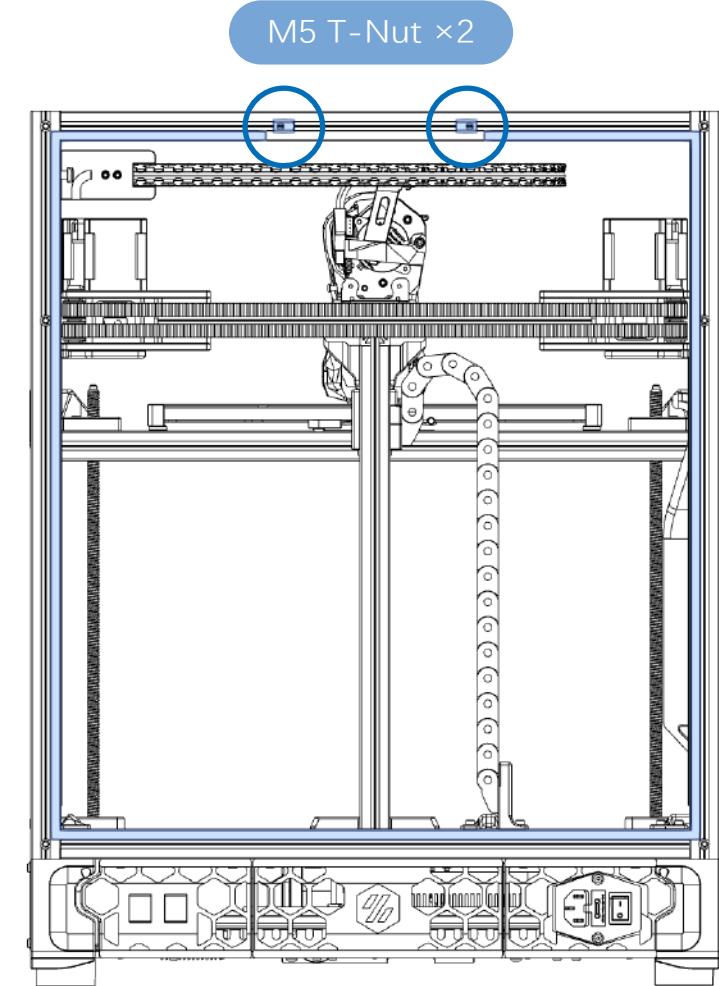
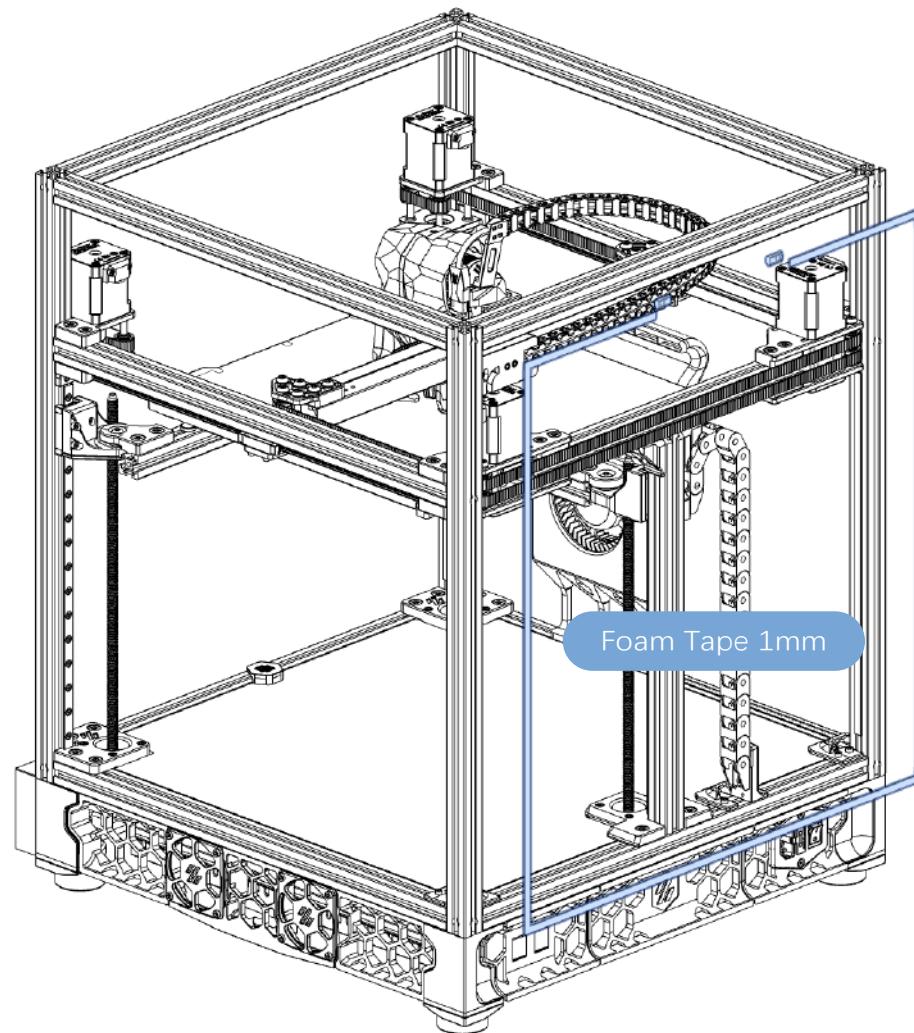


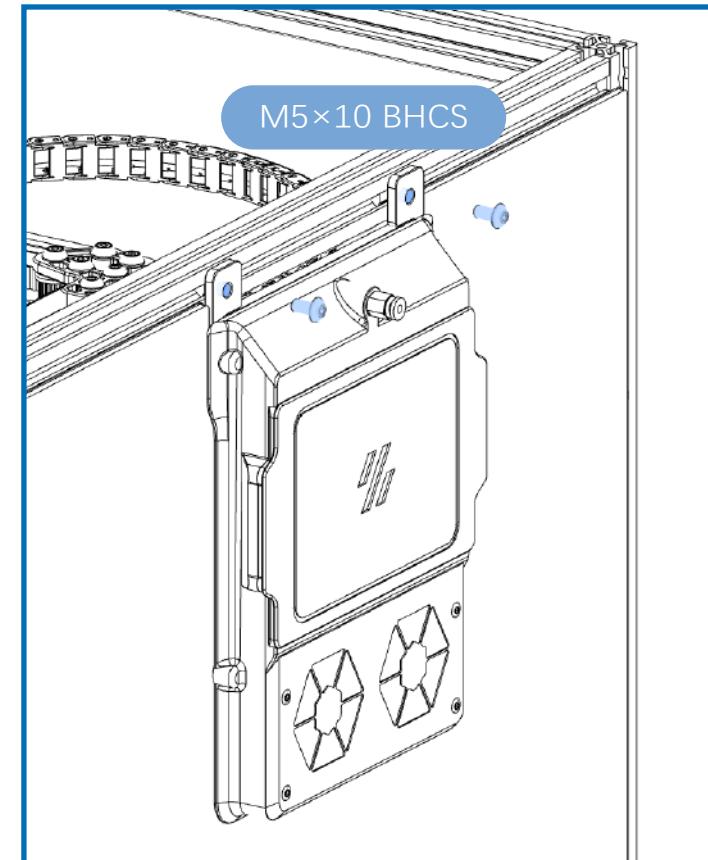
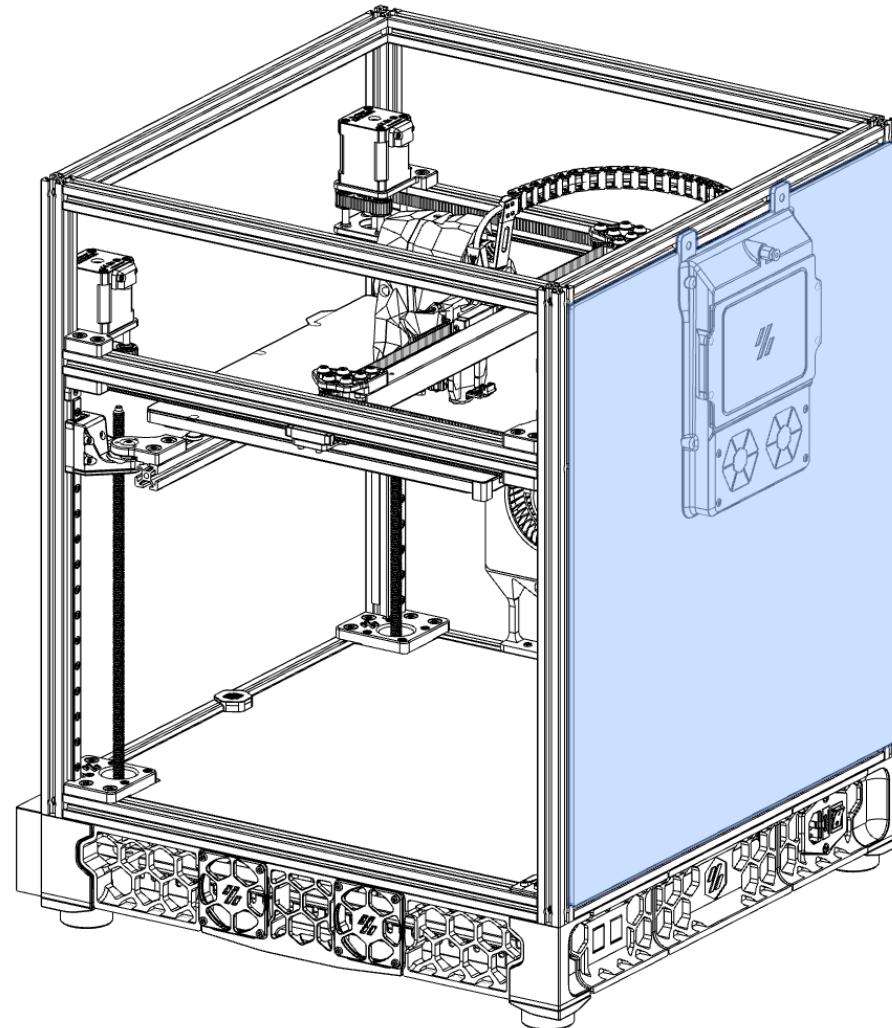
#### APPLY FOAM TAPE

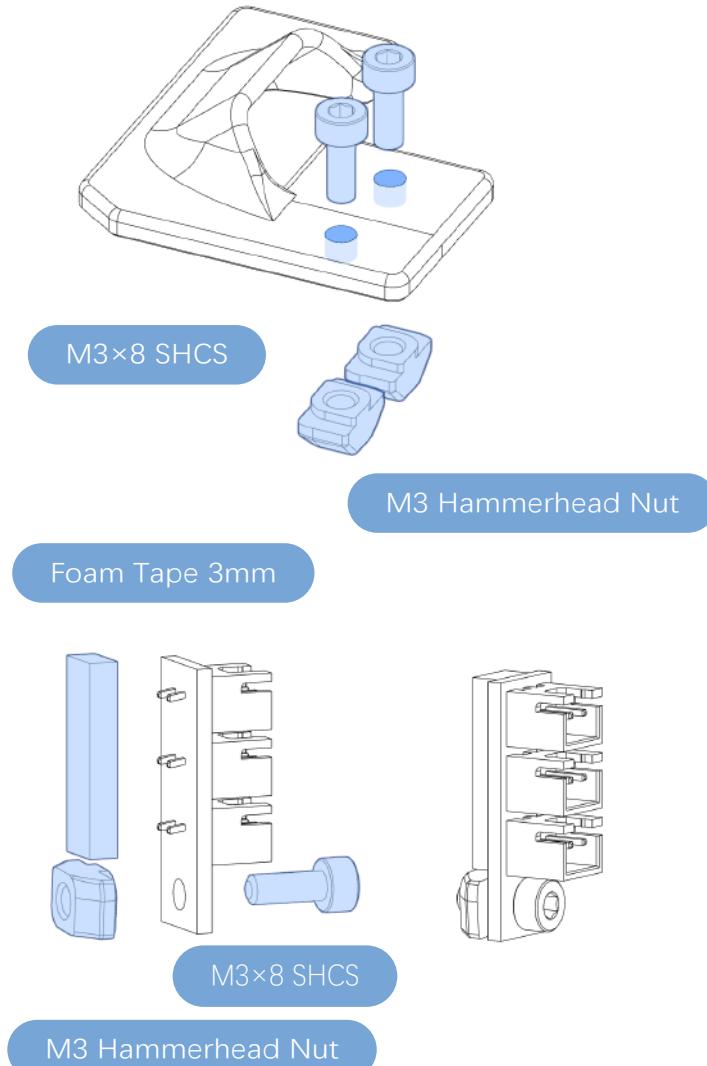
Use foam tape on the contact areas between the panels and the frame to mitigate noise from vibrations.





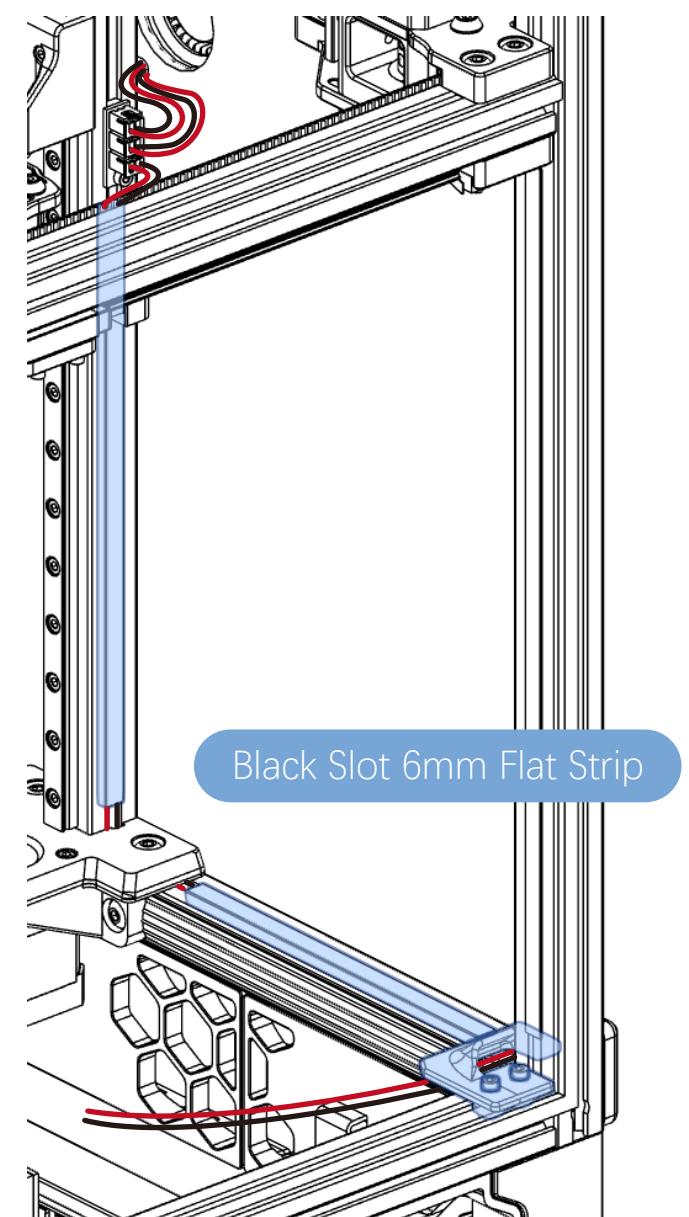
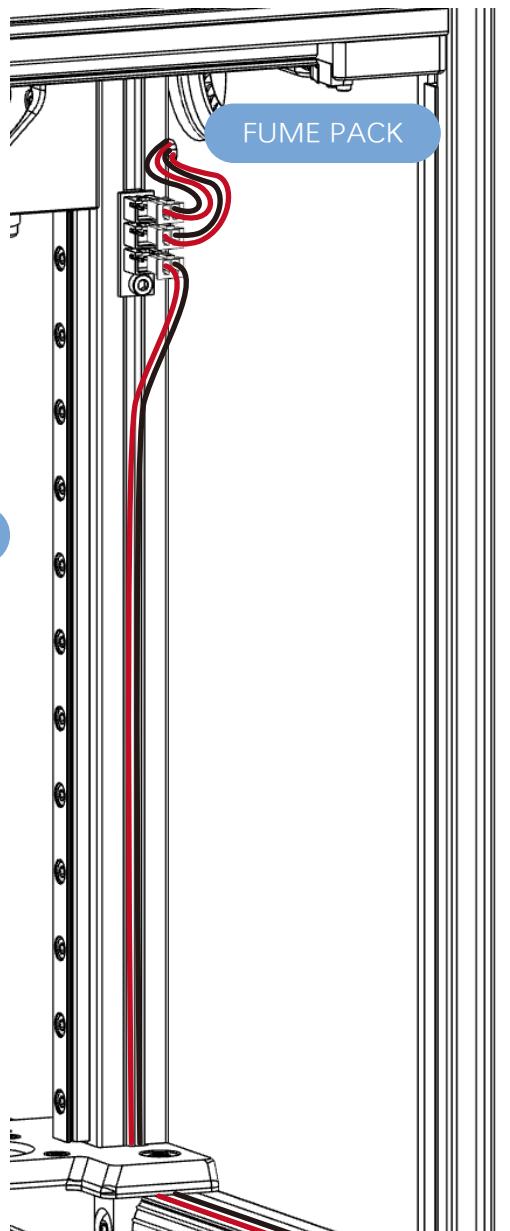


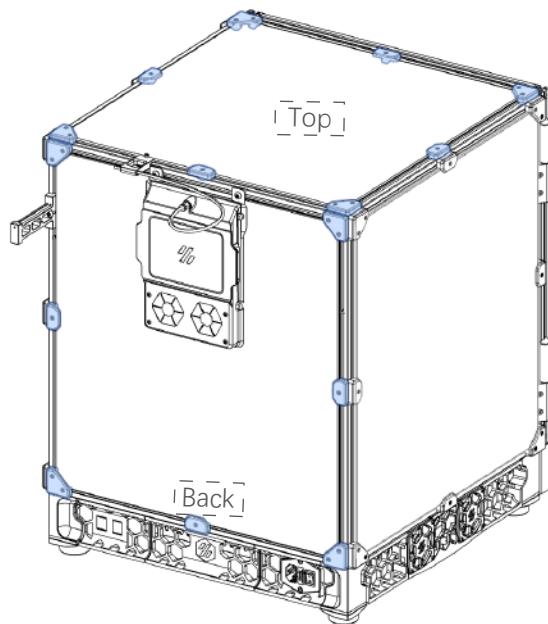




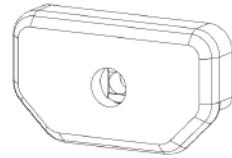
## WHERE IS THE CABLE?

Do you remember the XH2.54 extension cable reserved on page 65? Now it's time to use it.



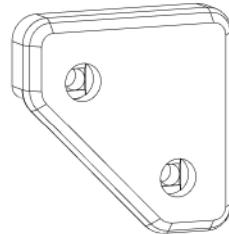


midspan\_panel\_clip\_4mm\_x7

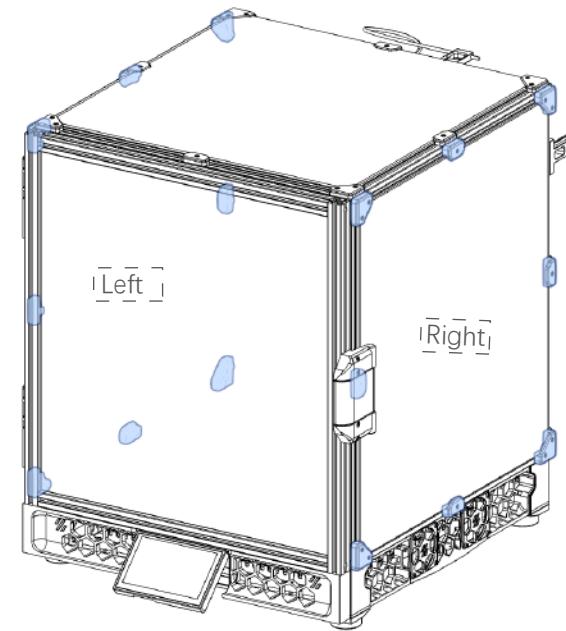


7mm

corner\_panel\_clip\_4mm\_x8



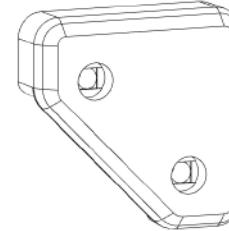
7mm



midspan\_panel\_clip\_6mm\_x7



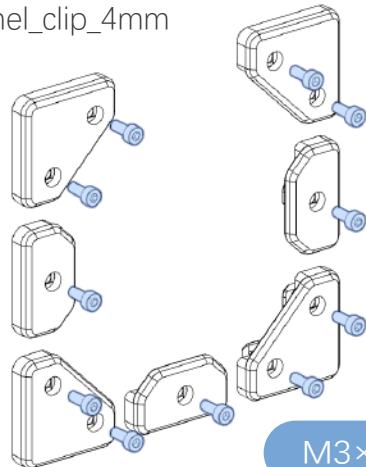
10mm



10mm

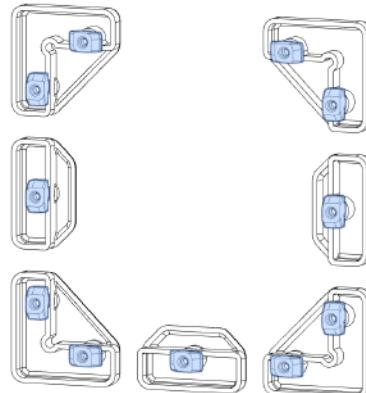
midspan\_panel\_clip\_4mm

corner\_panel\_clip\_4mm



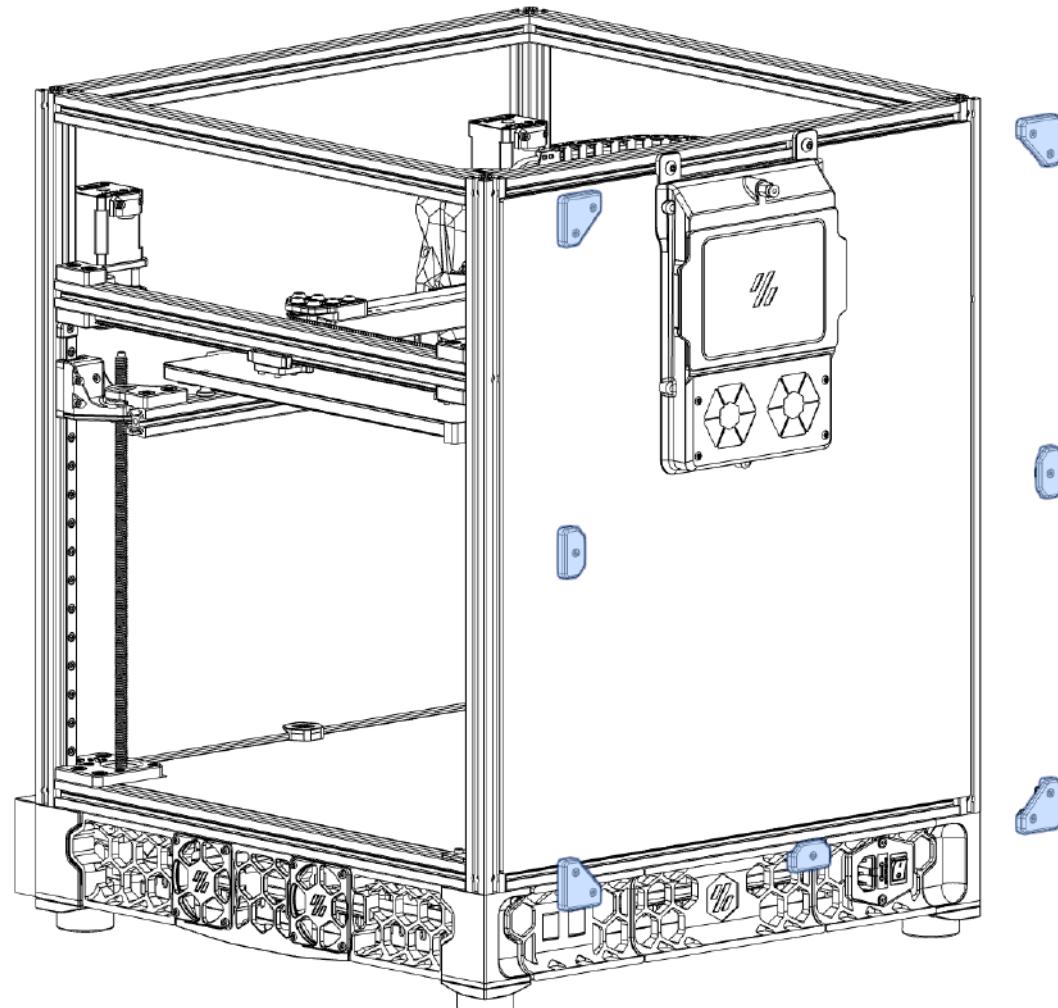
M3×8 SHCS

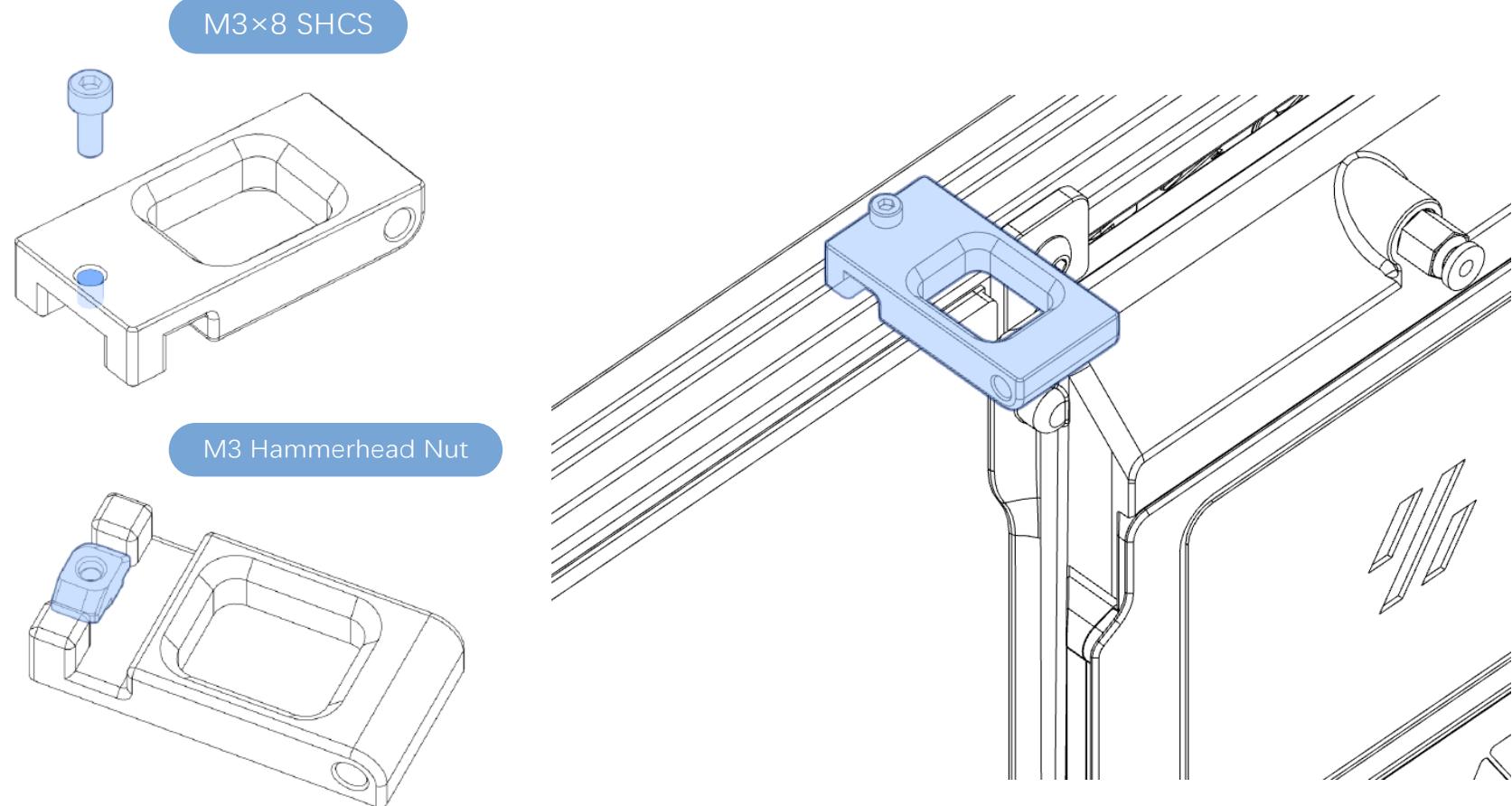
M3 Hammerhead Nut

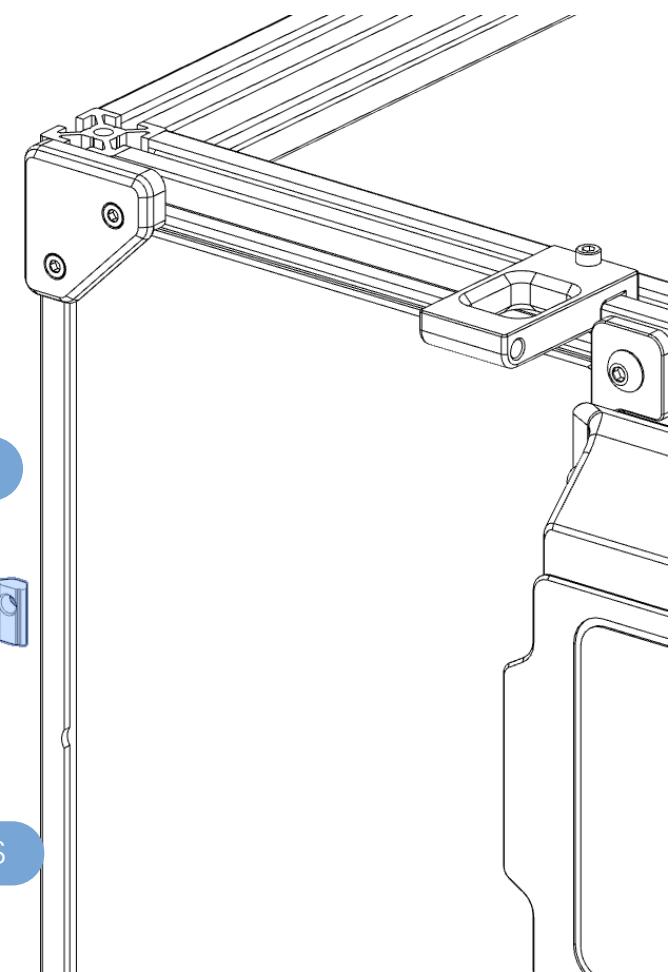
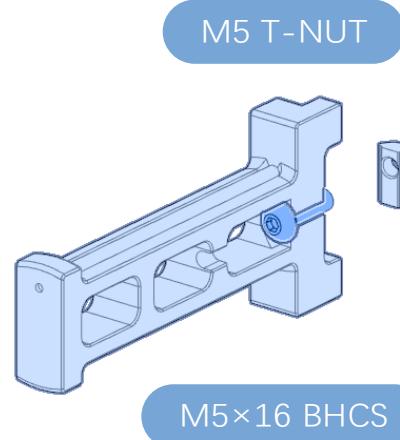
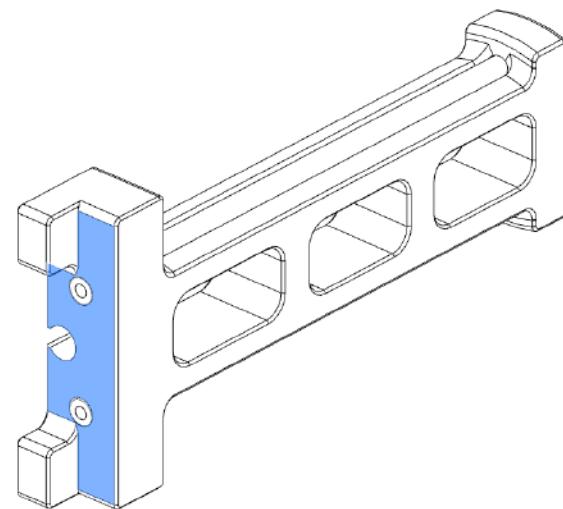
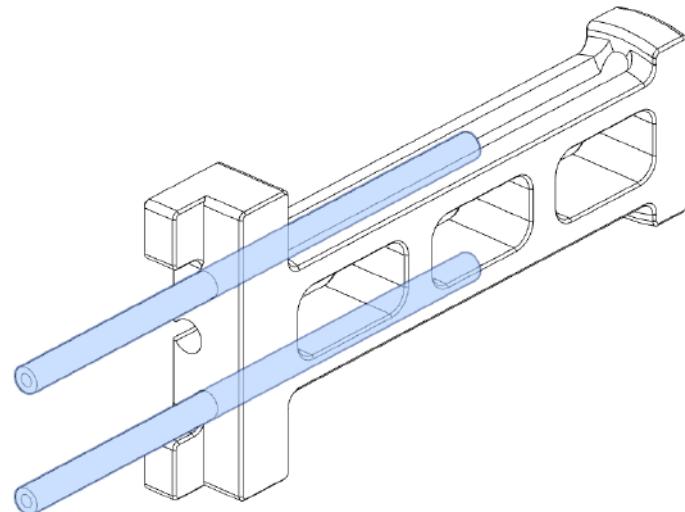


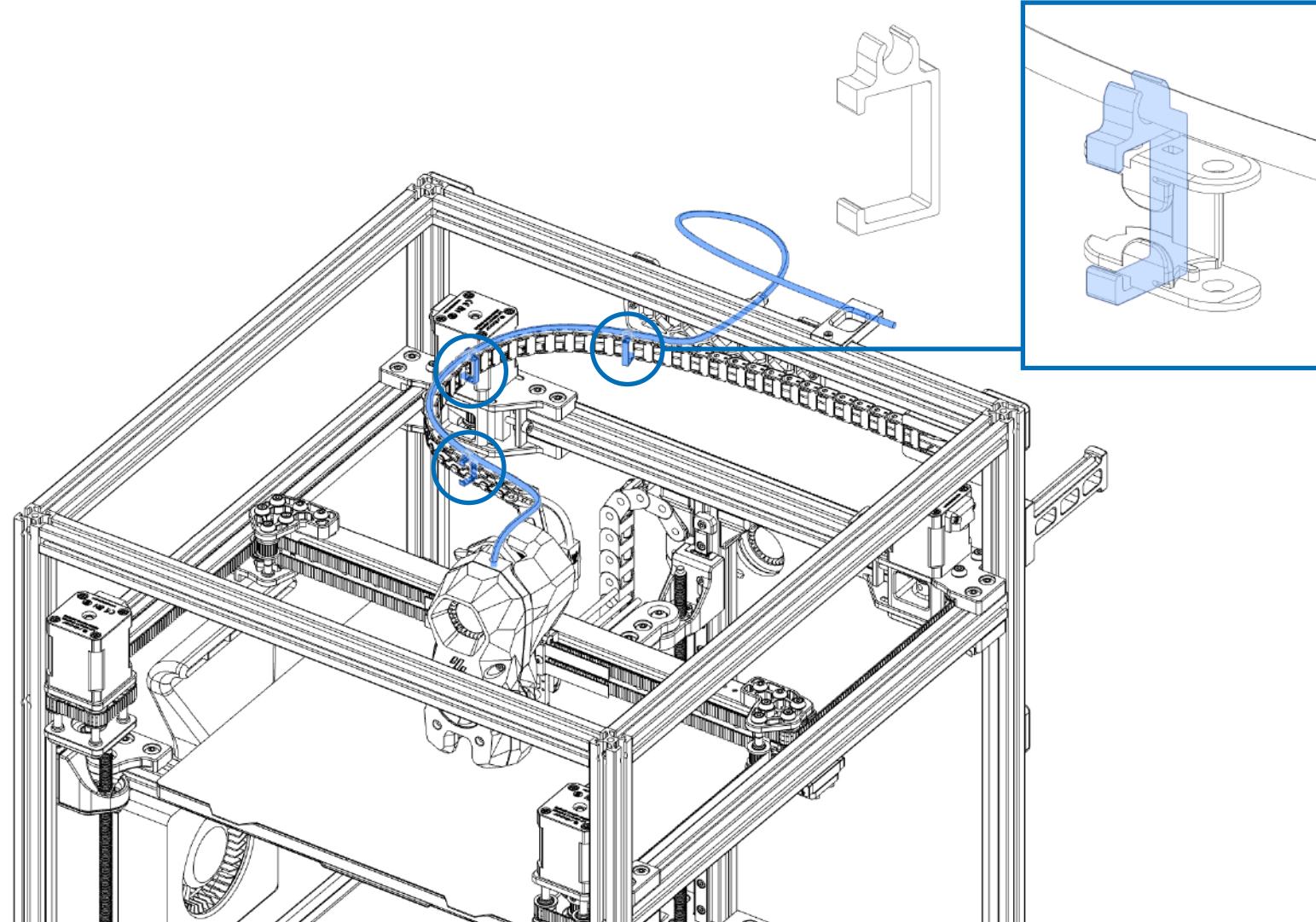
## HAMMERHEAD NUTS?

A drop of thread locker will turn the hammerhead nuts into a 1/4 turn quick release for the panels. Best done once the assembly is finished.



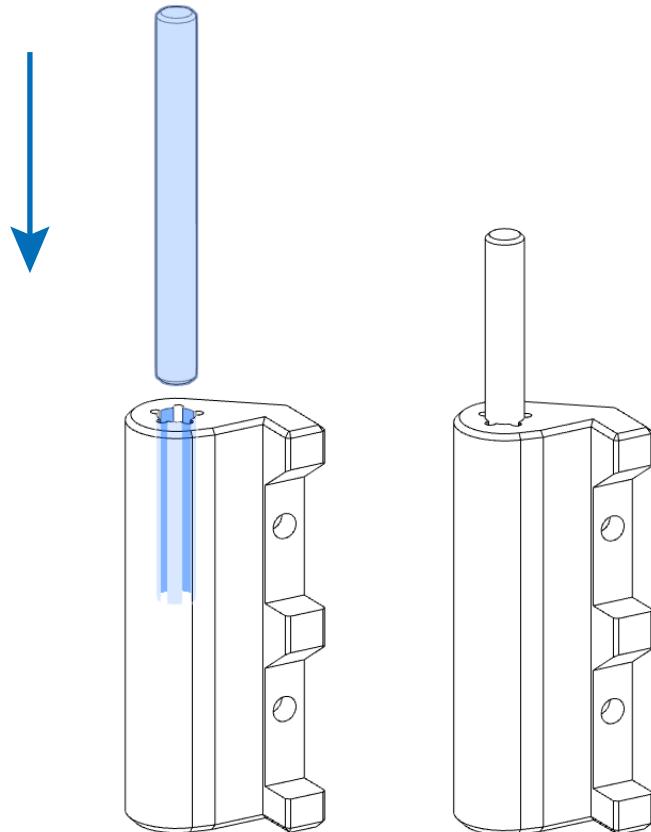








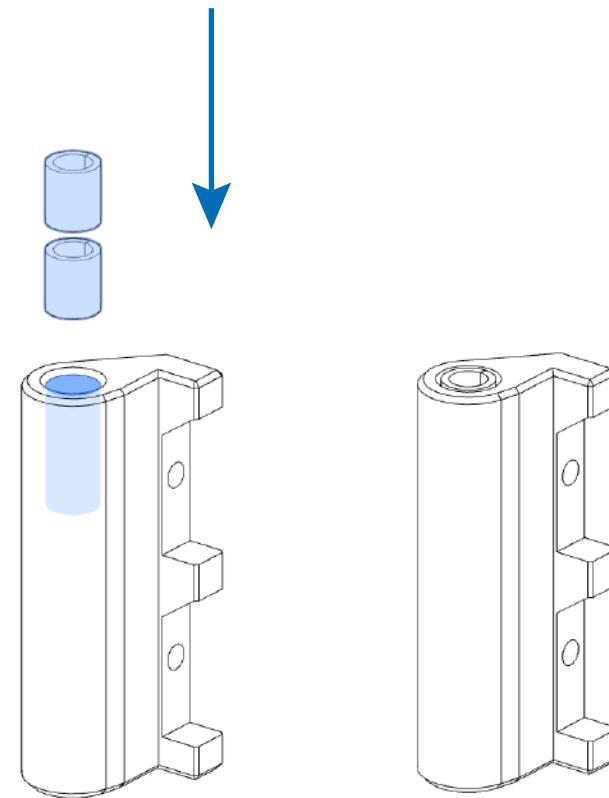
M5×45 Long pin



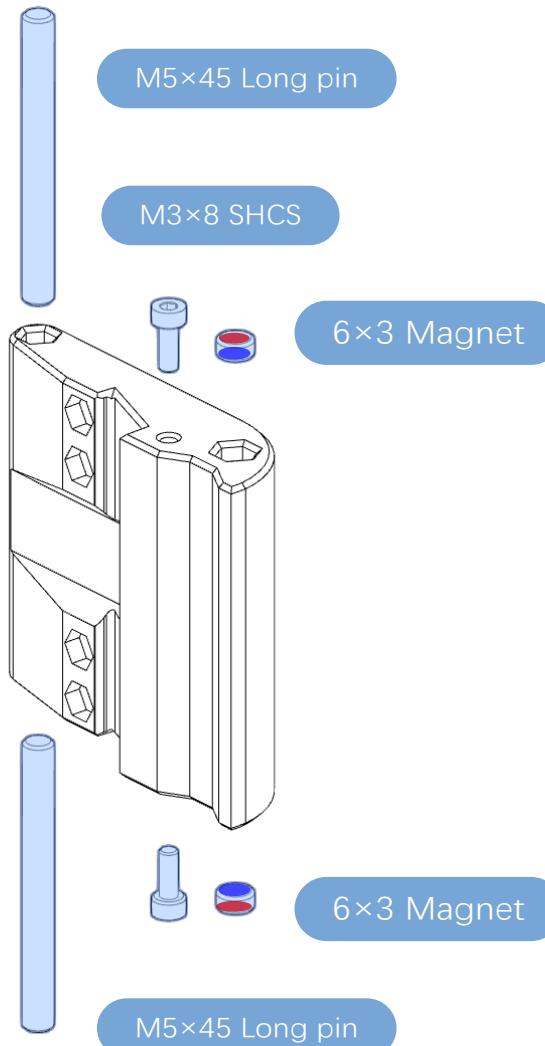
M3×8 SHCS

×2

M5×7×8 Bushing

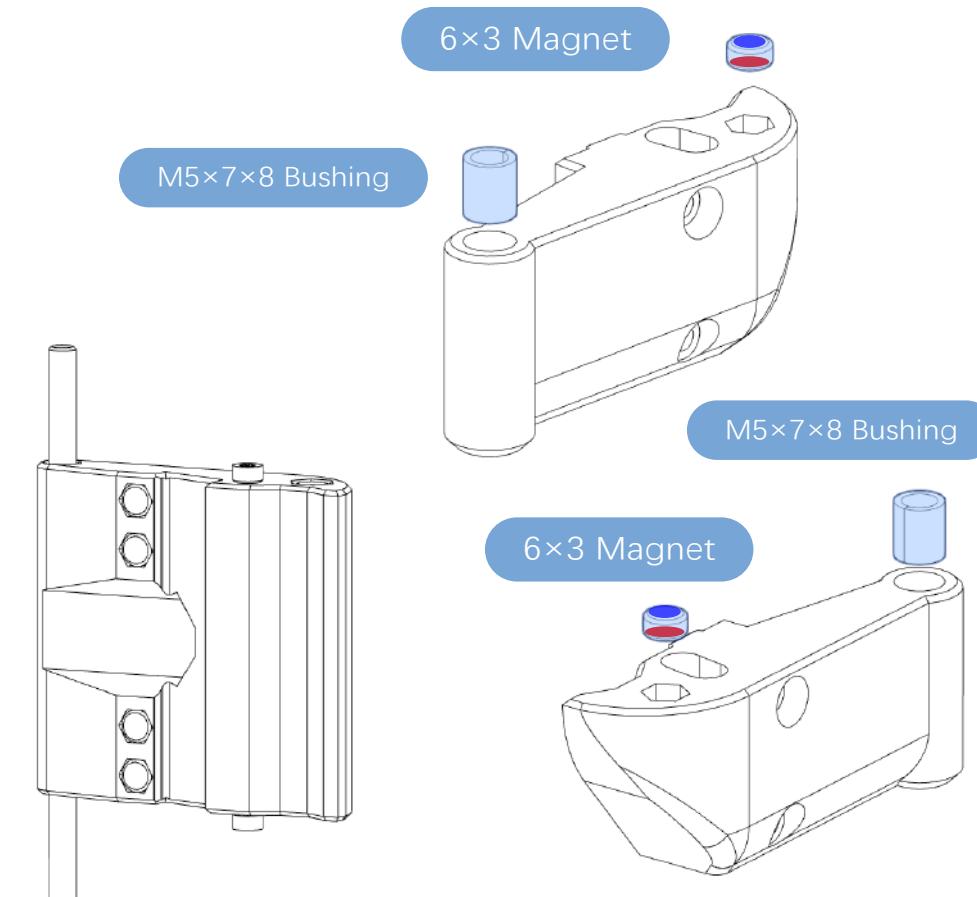


×2

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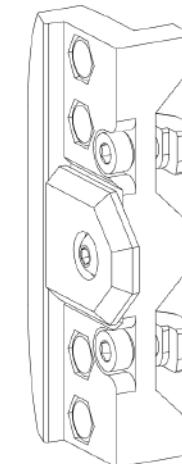
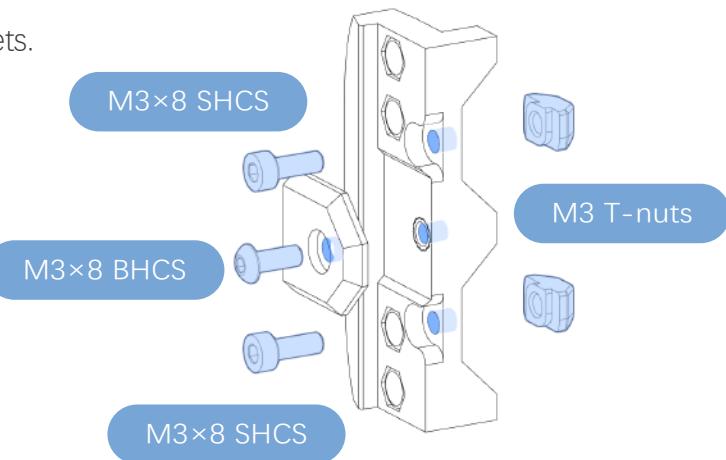
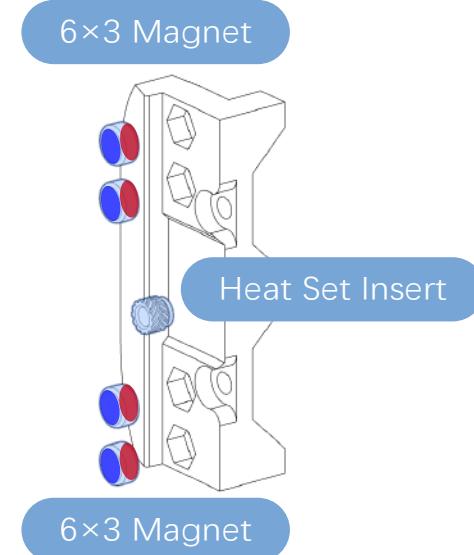
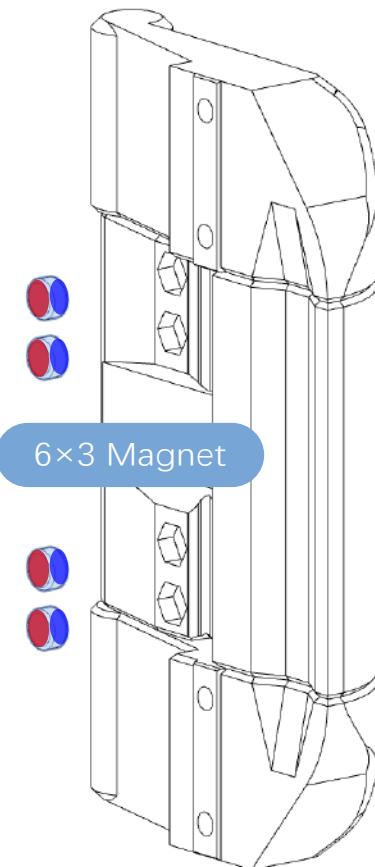
Ensure to distinguish the poles of the round magnets.

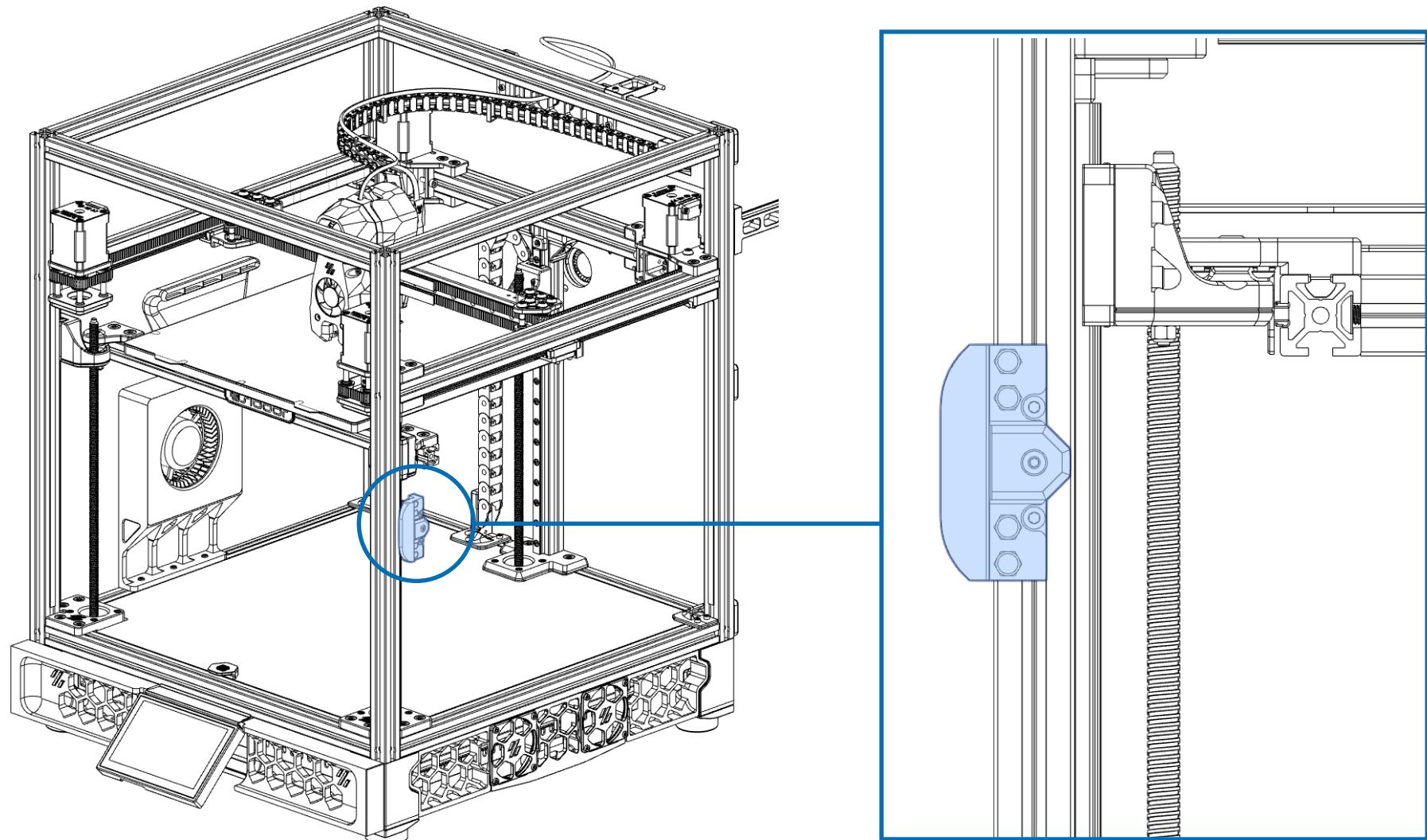
M3 Hammerhead Nut

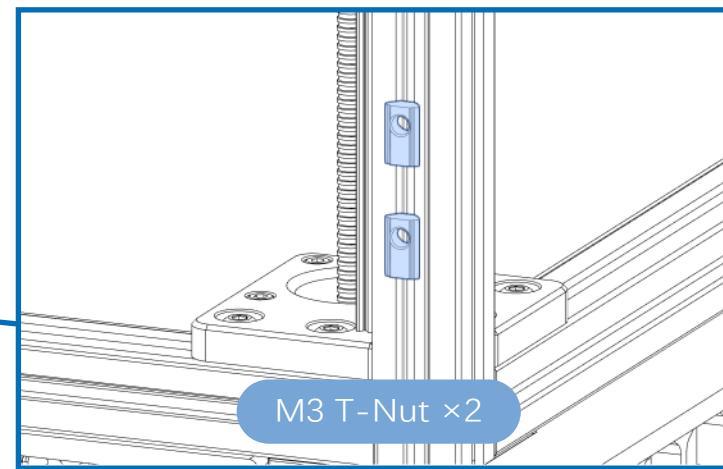
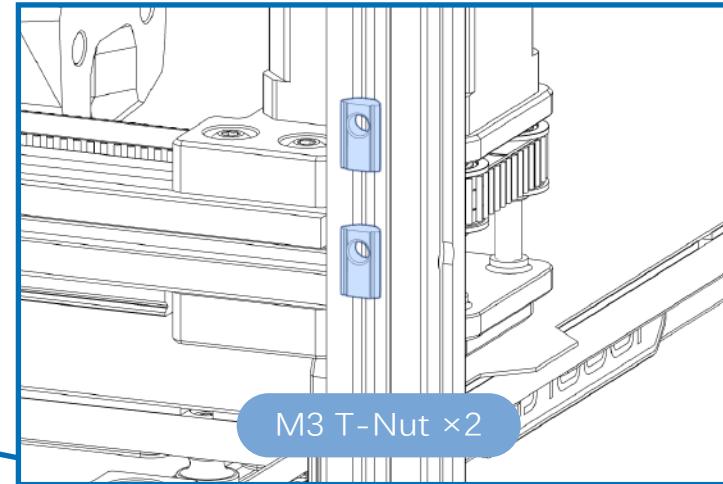
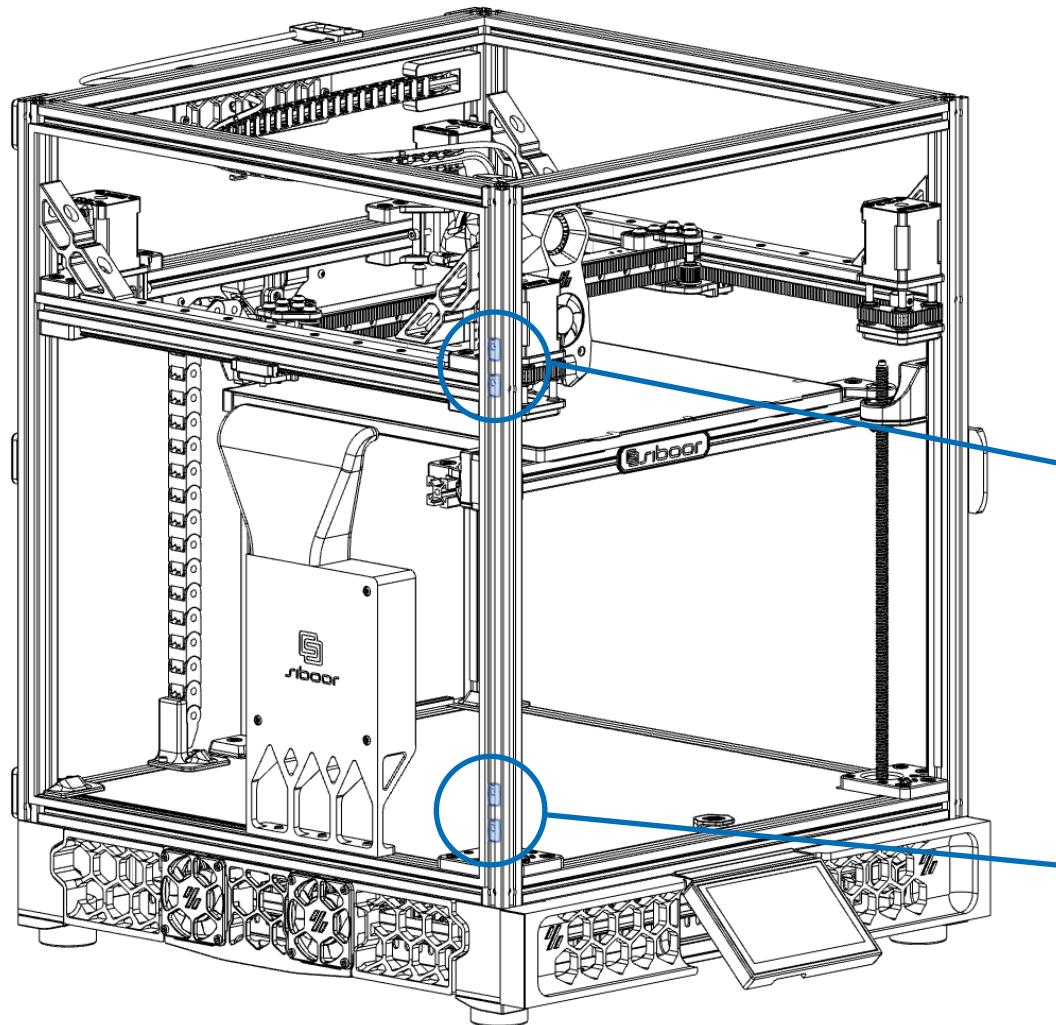


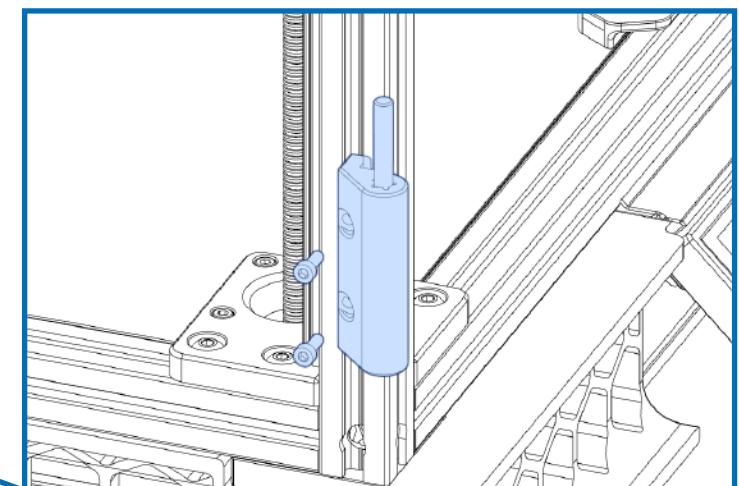
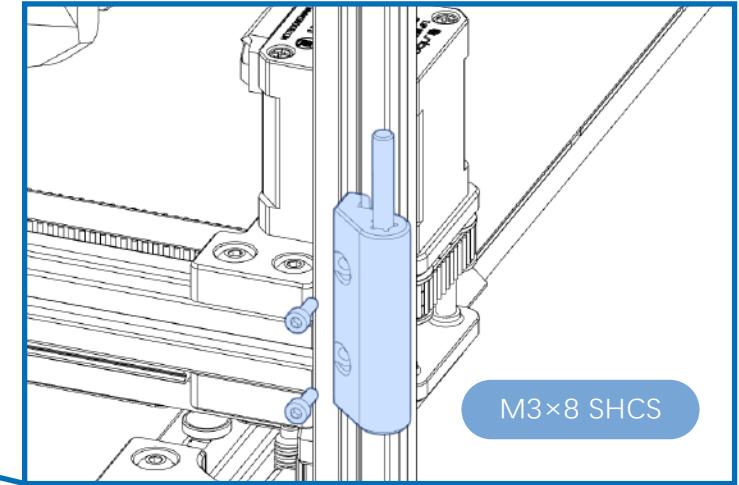
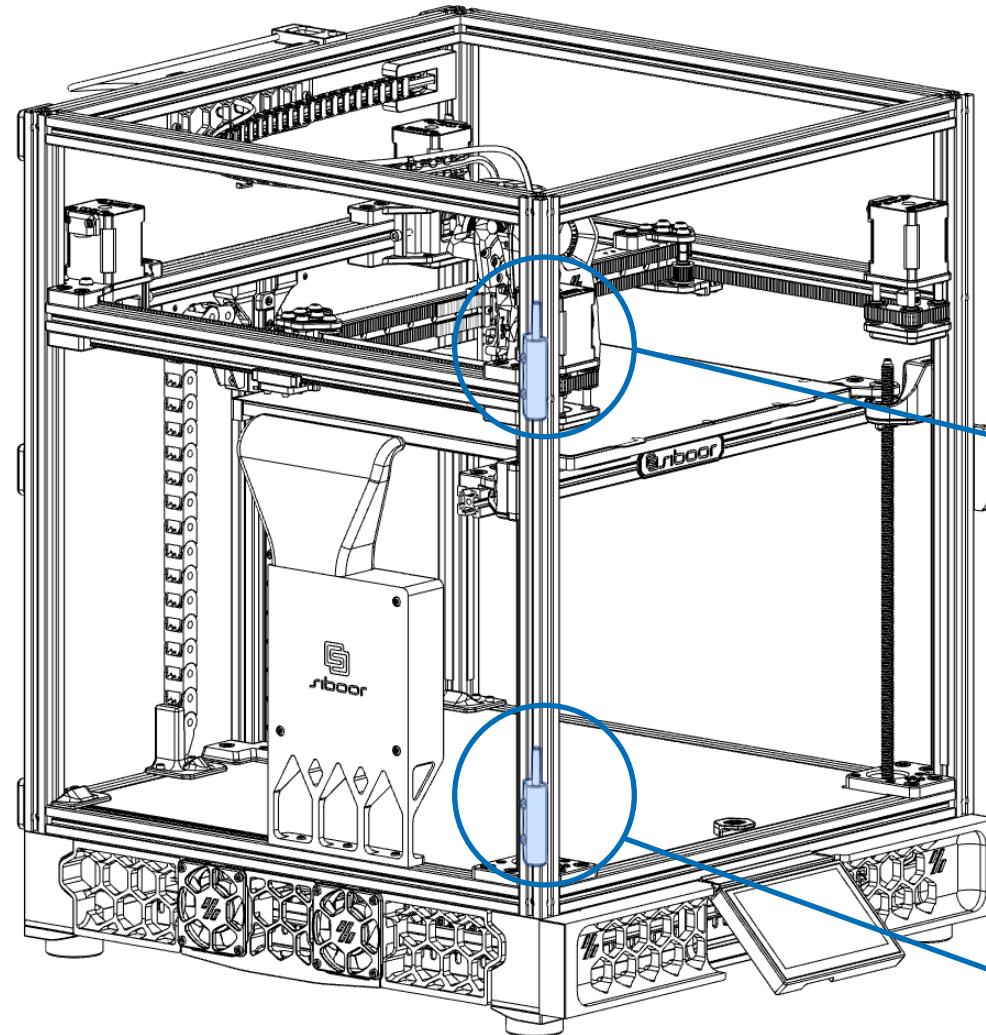
**IMPORTANT NOTICE**

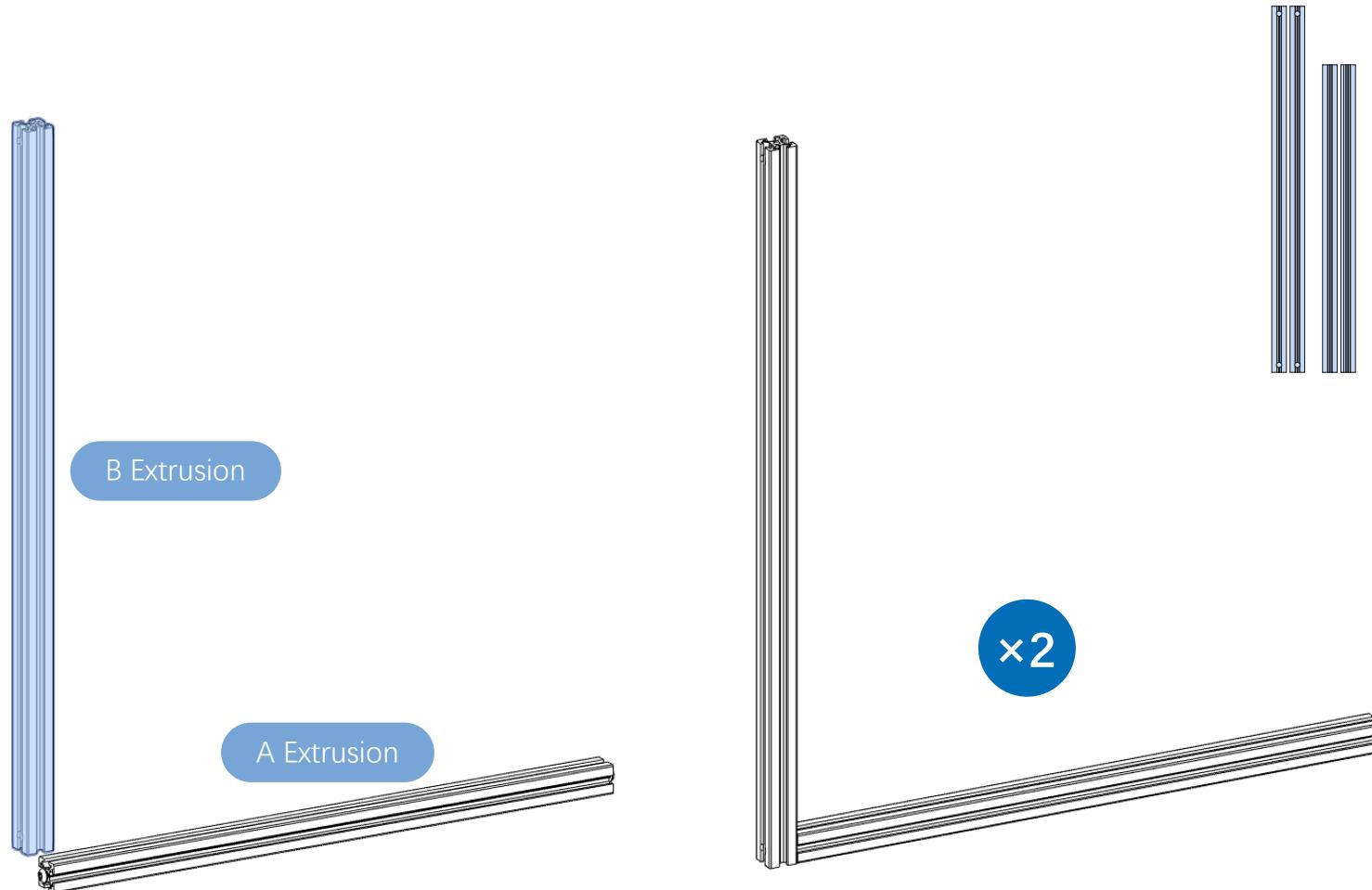
Ensure to distinguish the poles of the round magnets.

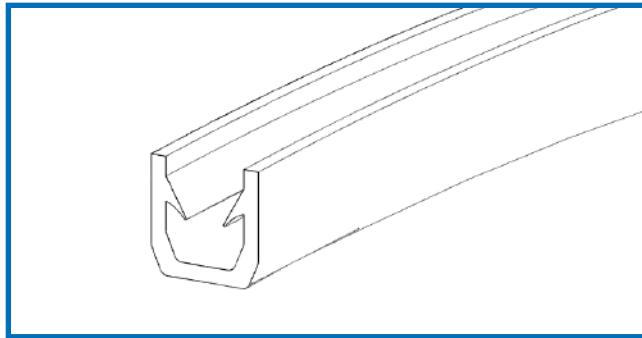




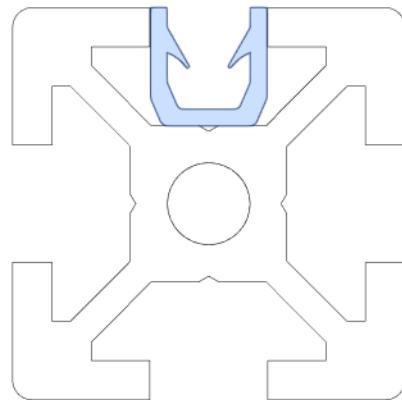






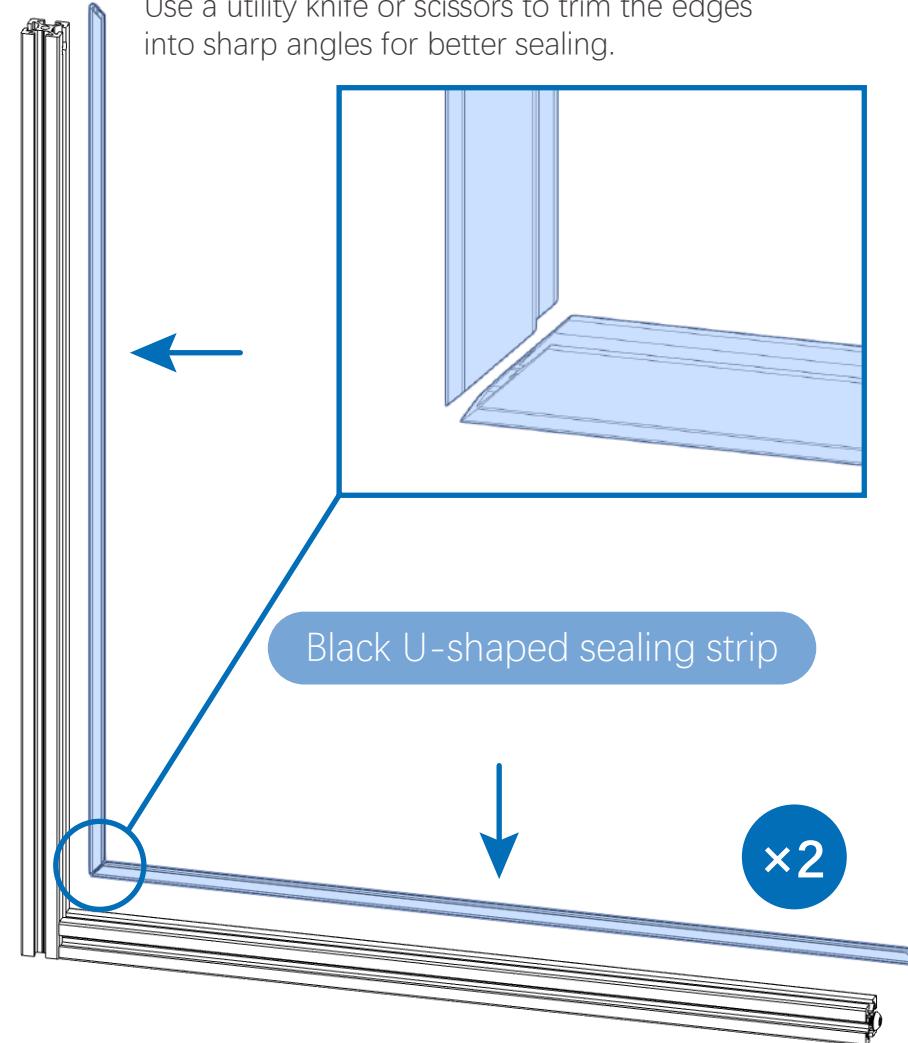


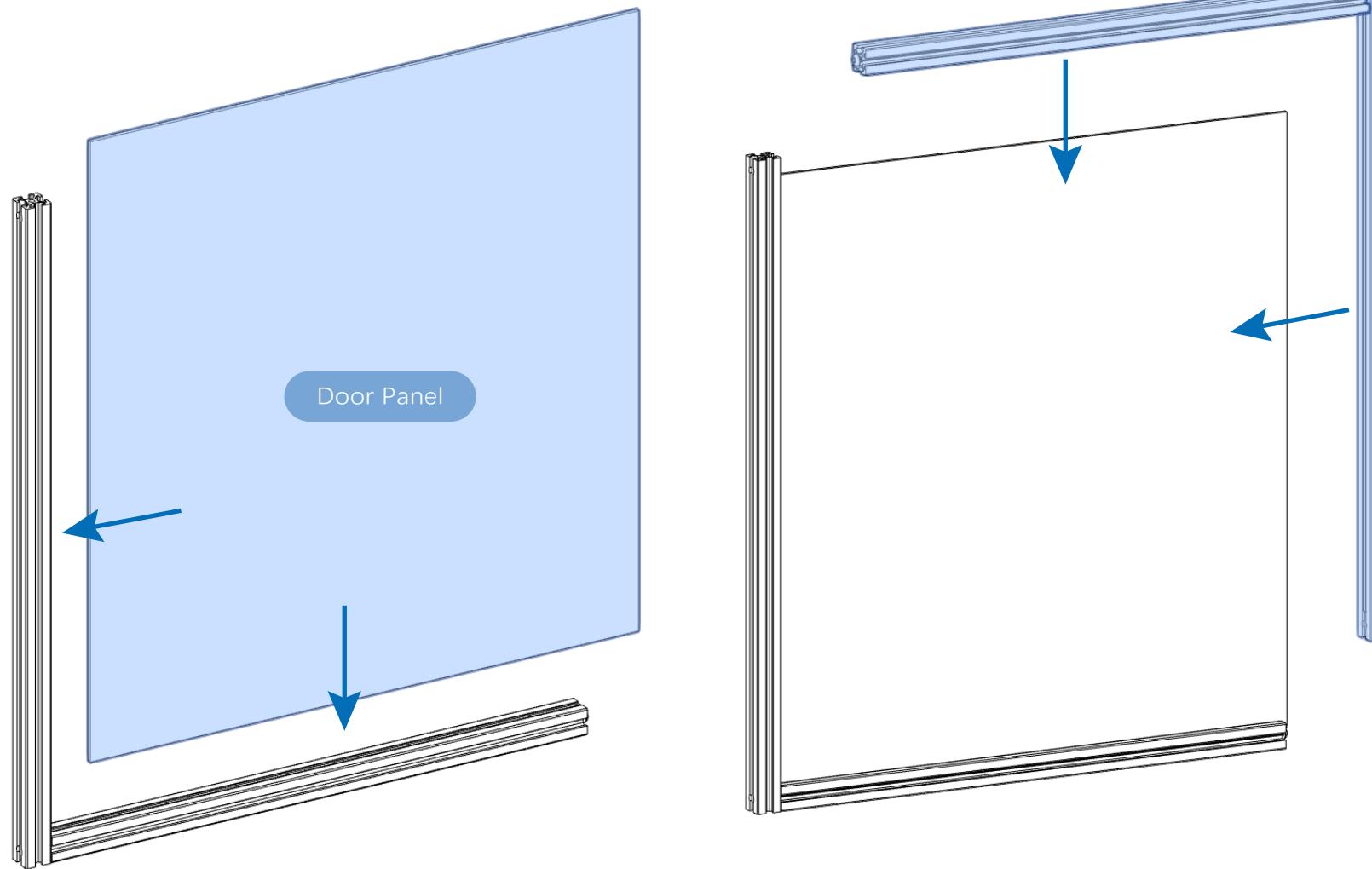
Black U-shaped sealing strip

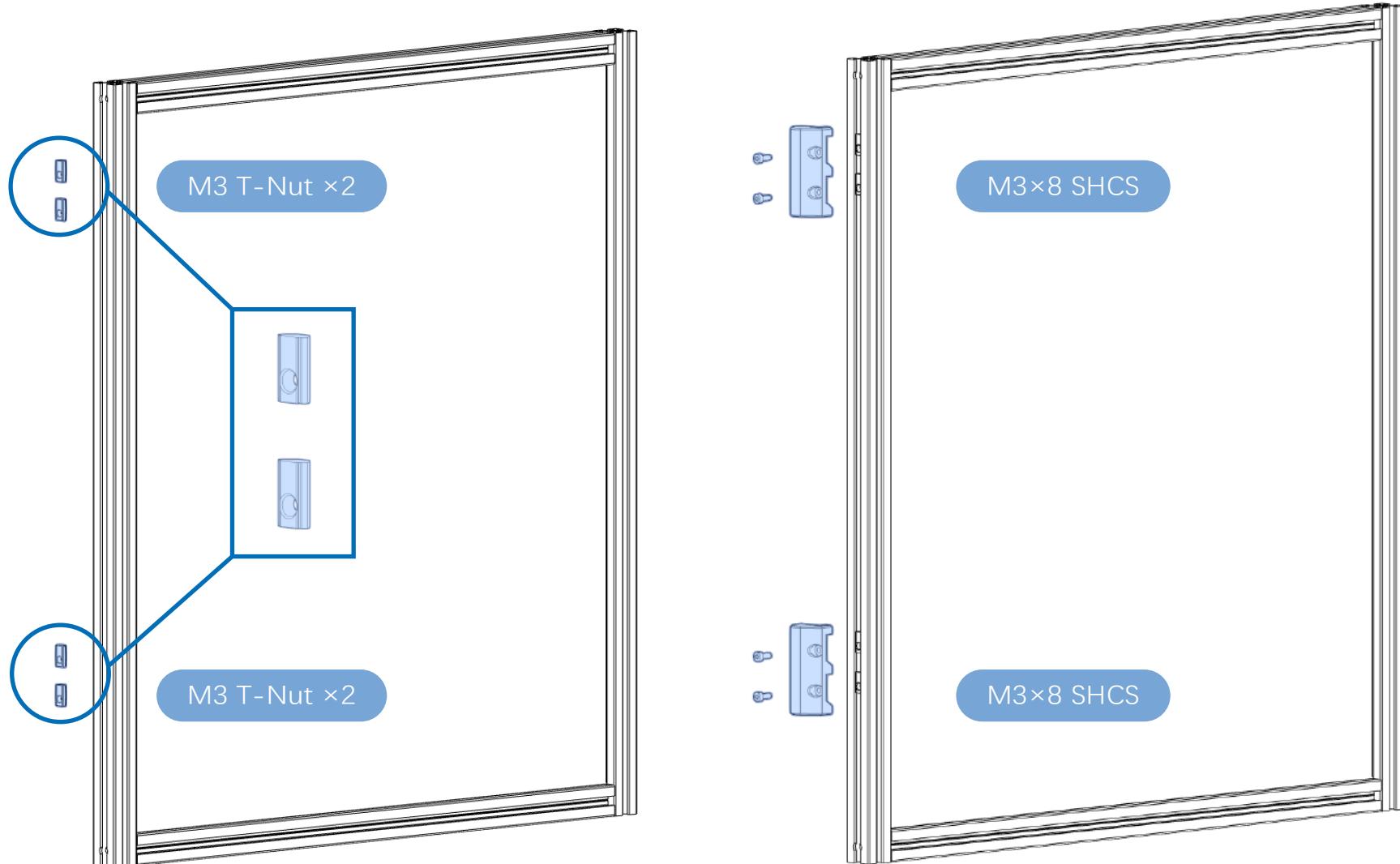


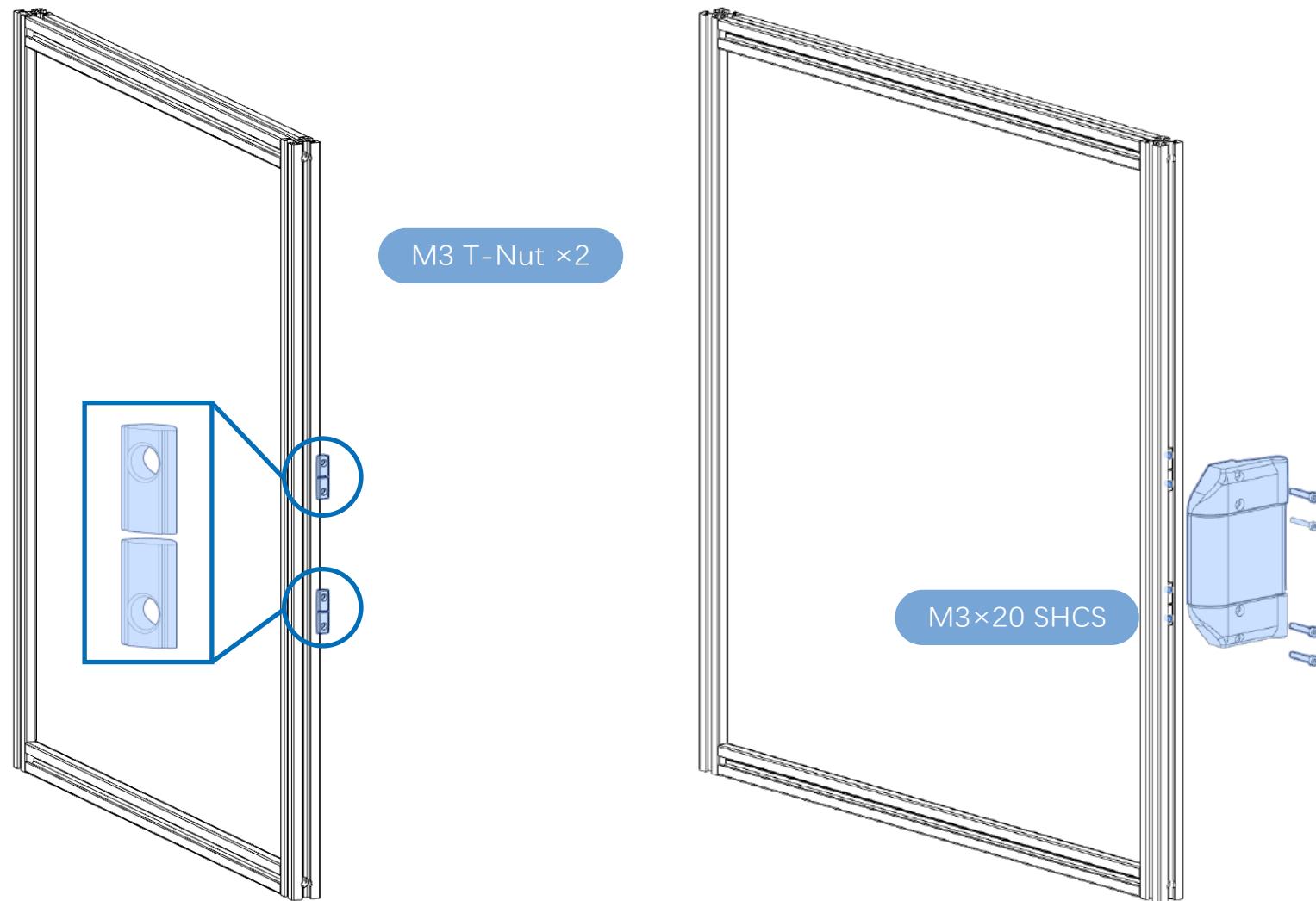
## TRIMMING METHOD FOR IMPROVED SEALING

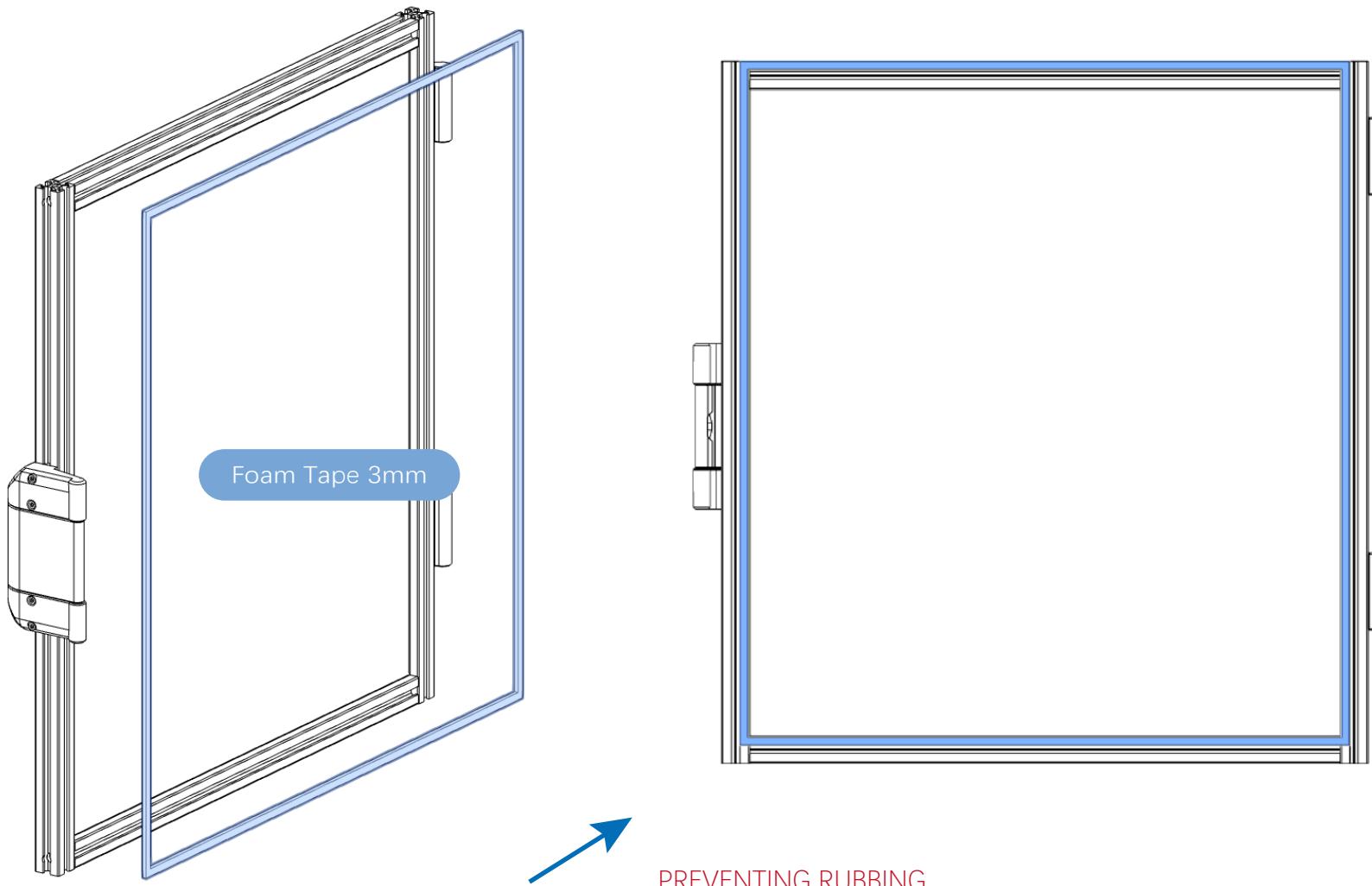
Use a utility knife or scissors to trim the edges into sharp angles for better sealing.





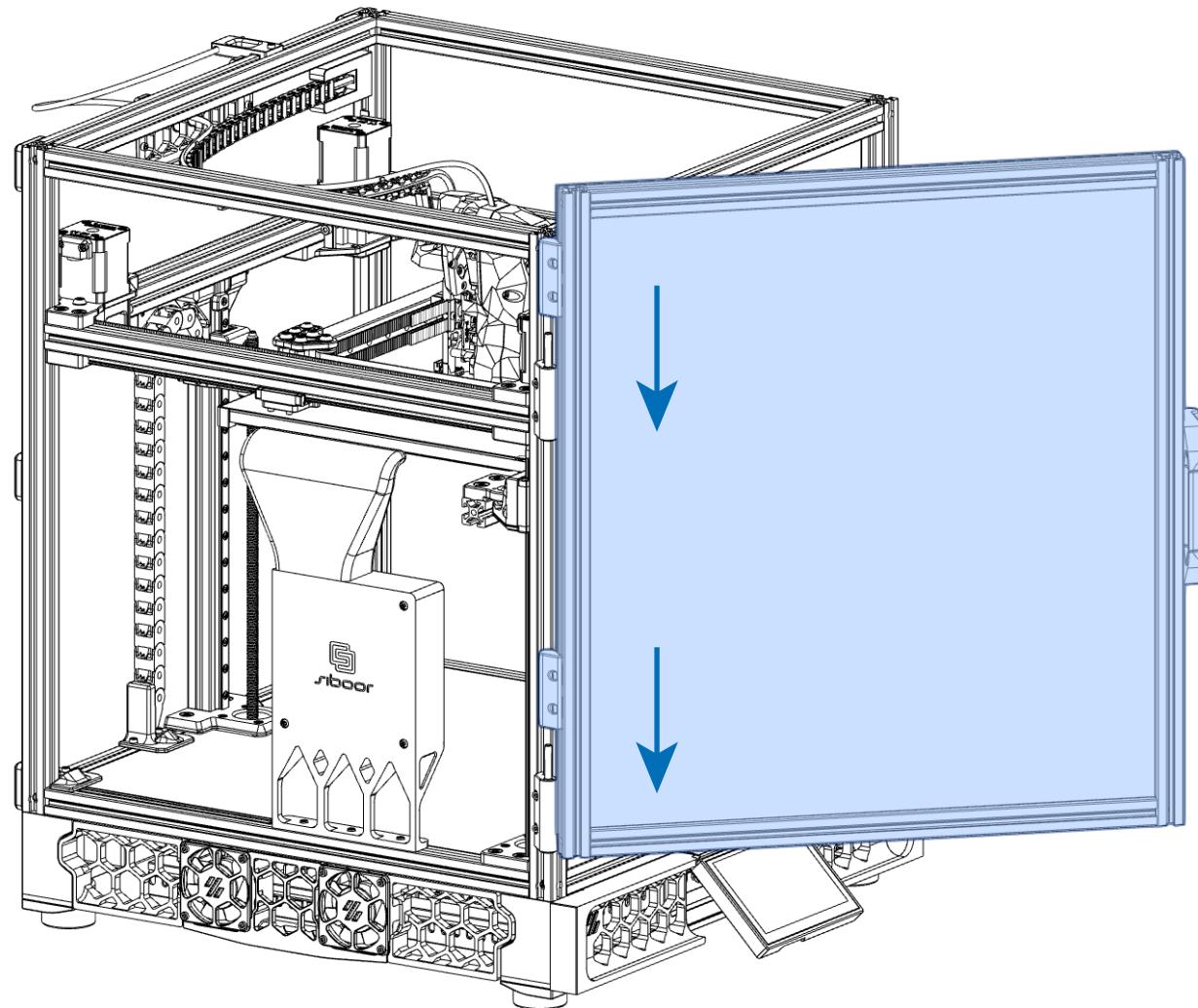


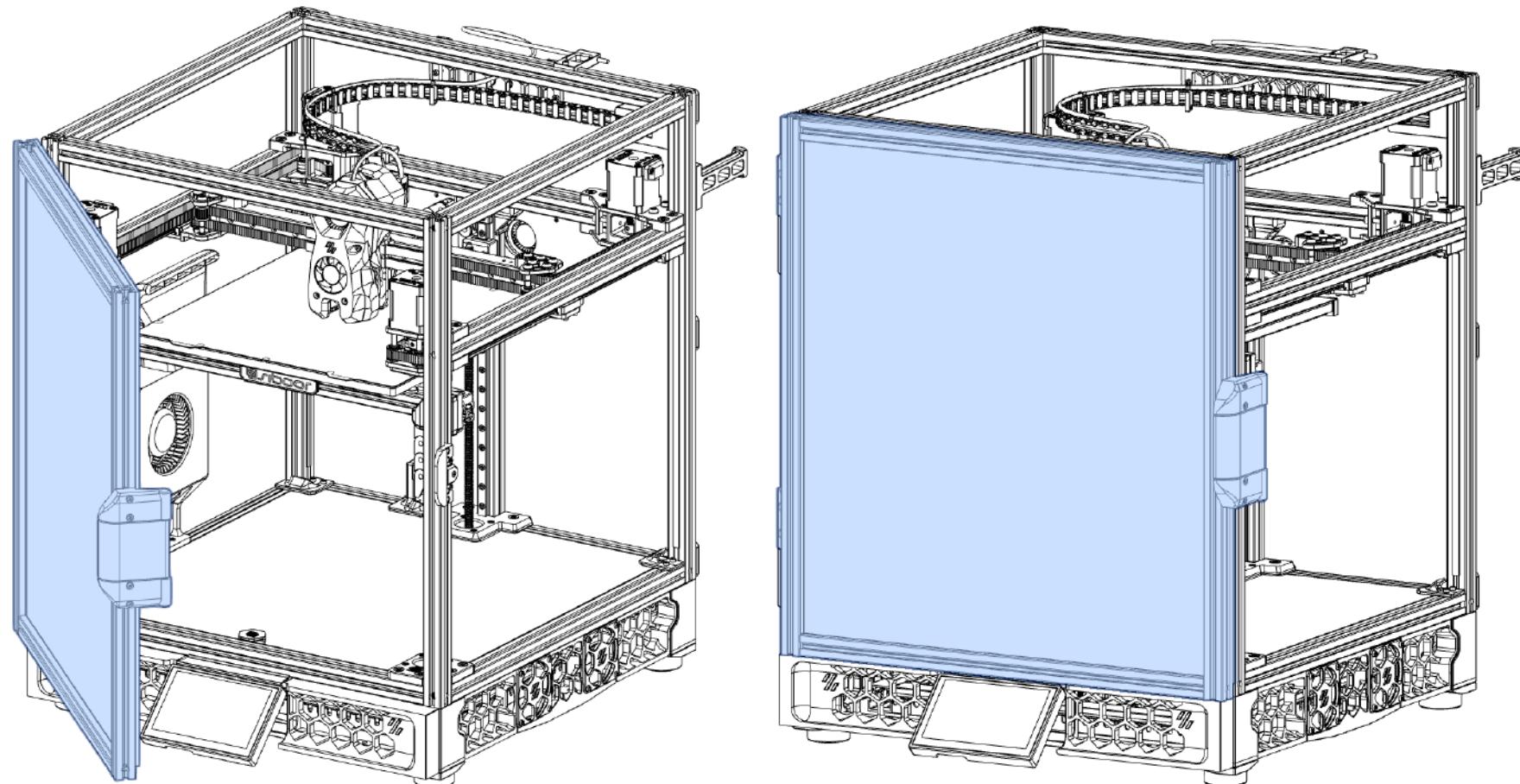




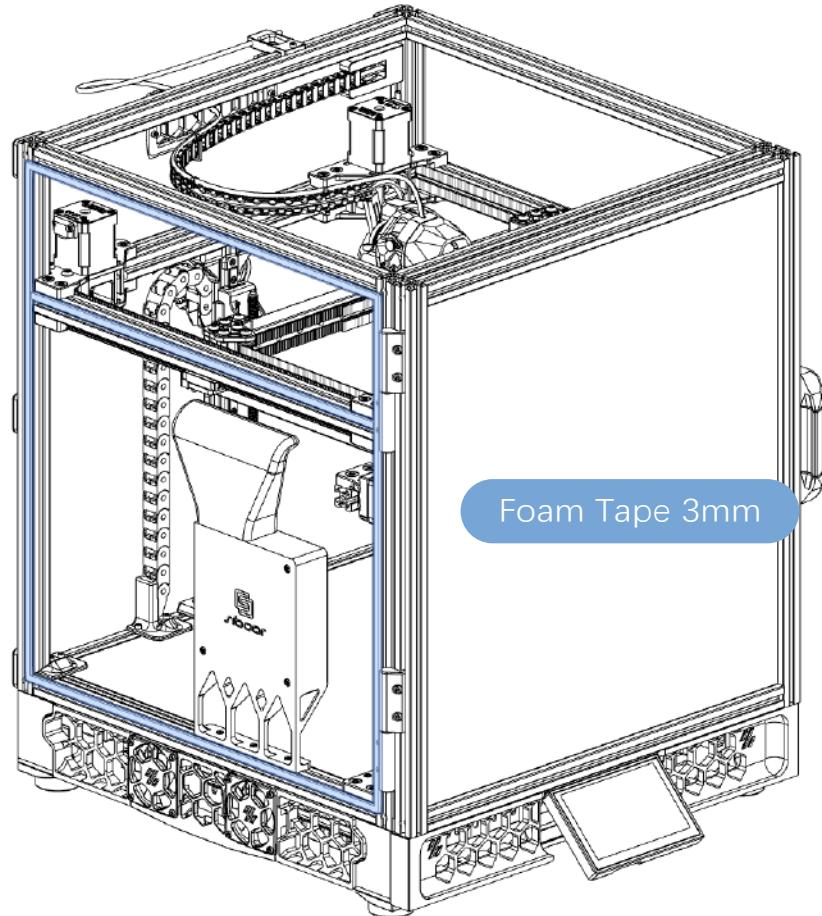
## PREVENTING RUBBING

The Foam Tape is placed at a higher position on the extrusion to prevent it from rubbing against the skirt net.





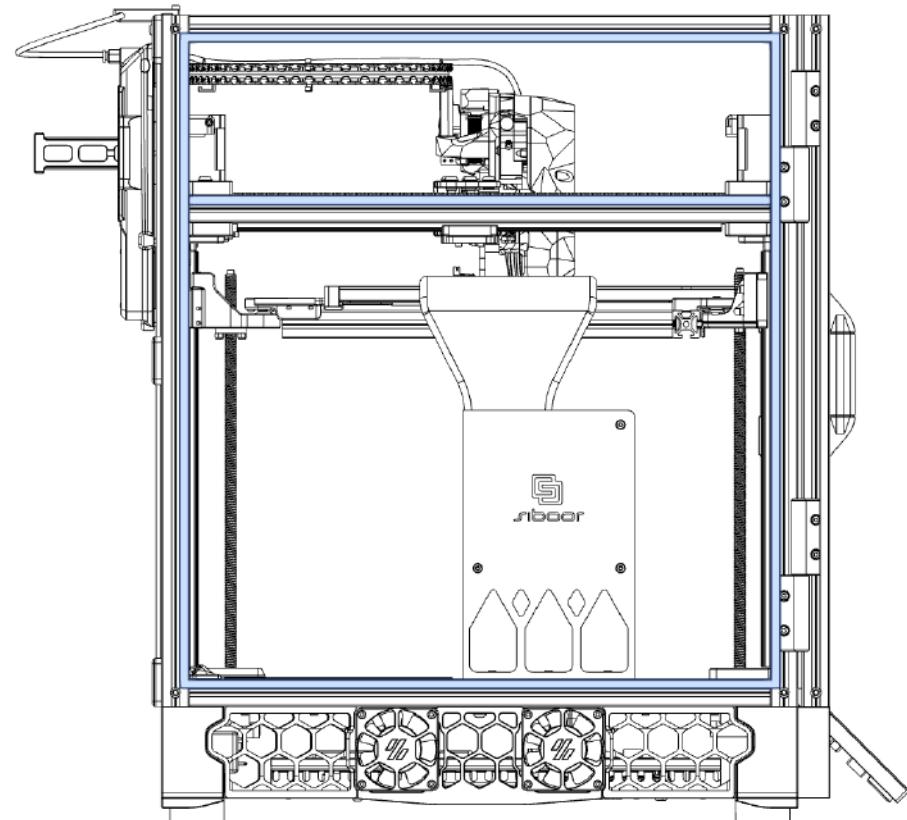




Foam Tape 3mm

#### APPLY FOAM TAPE

Use 3mm foam tape on the contact areas between the panels and the frame to mitigate noise from vibrations.

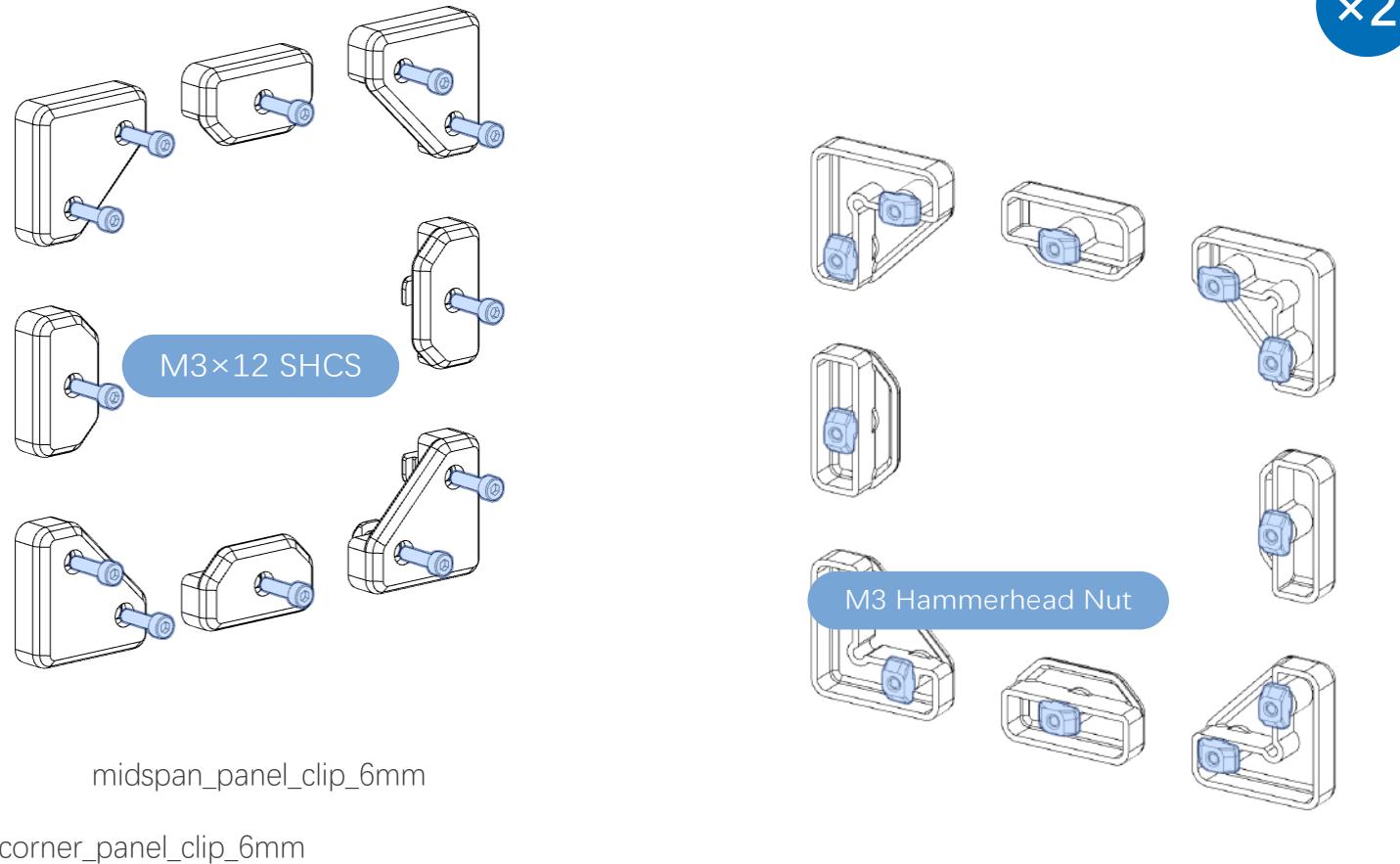


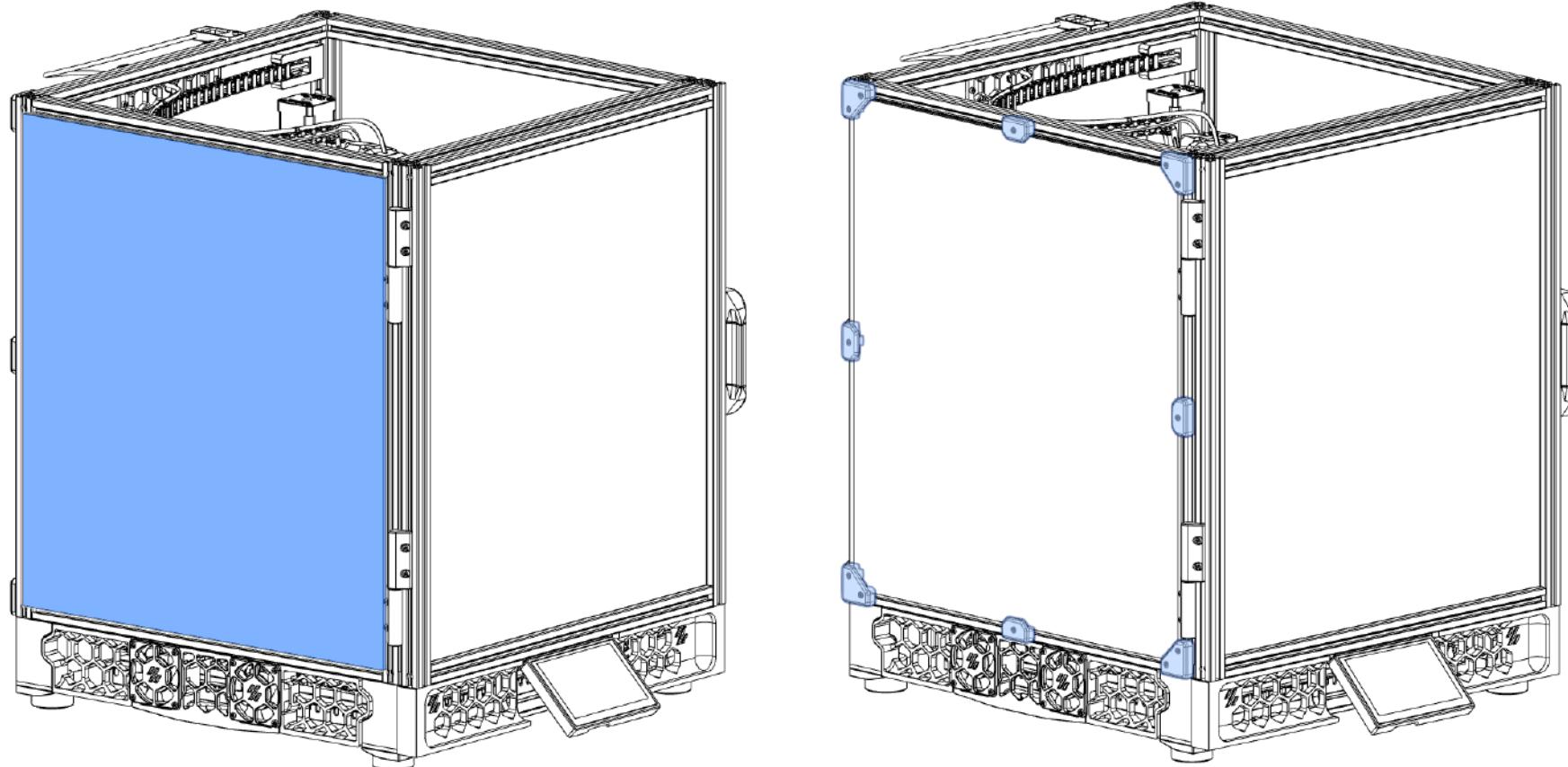
#### APPLYING FOAM TAPE TO THE RIGHT SIDE

Apply Foam Tape (3mm) to the right side of the printer in the same manner. This step is not repeated here.

**IMPORTANT NOTICE**

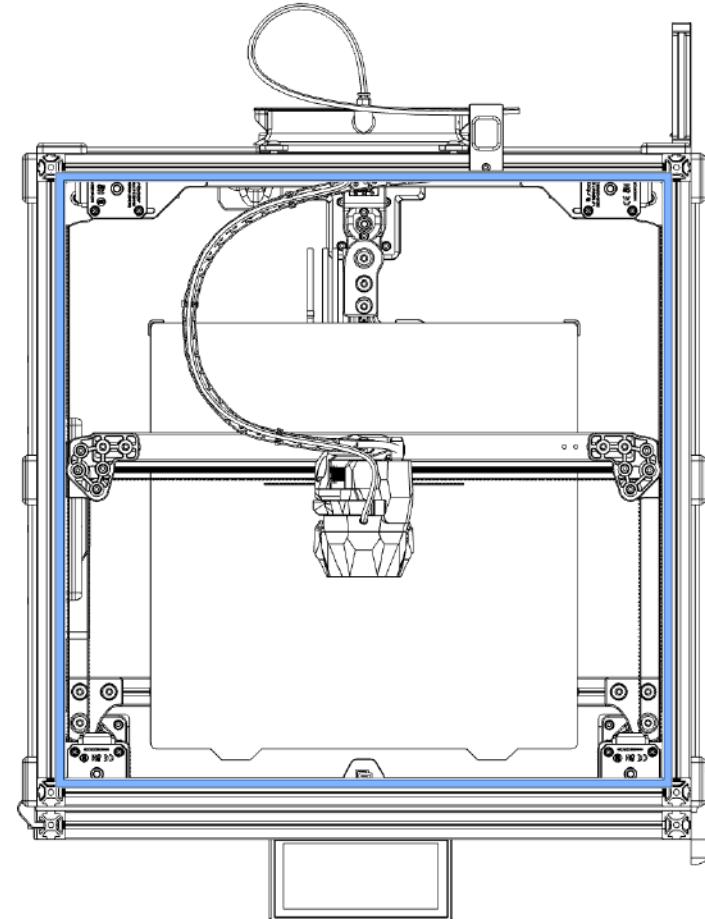
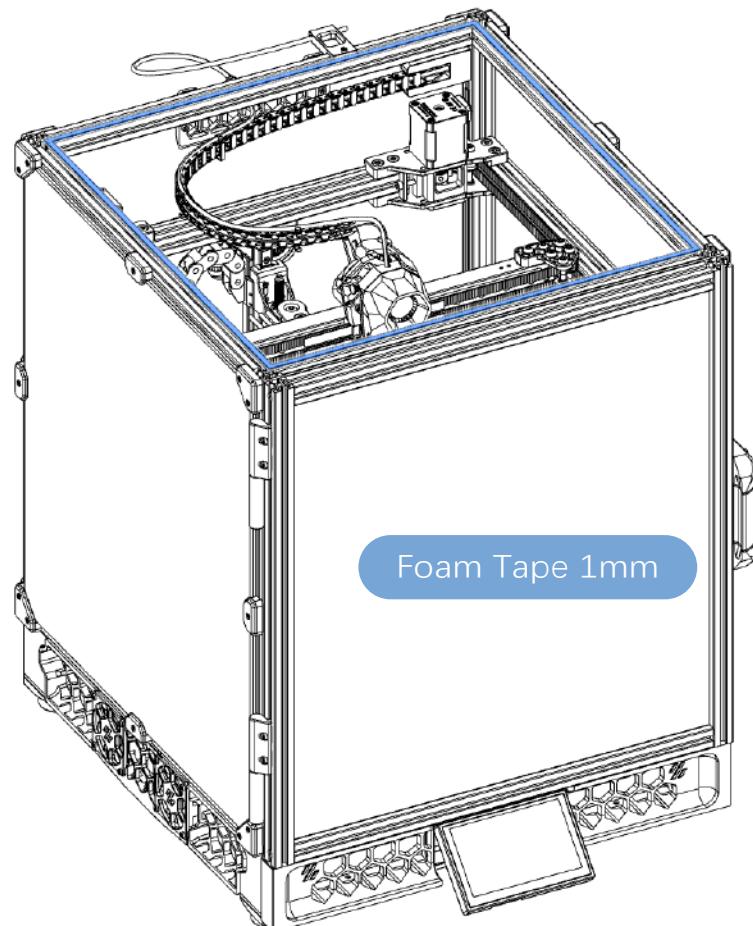
If you have purchased the REINFORCEMENT and CNC Metal Diagonal Rod, now is the time to install them. Please refer to pages 243-245.





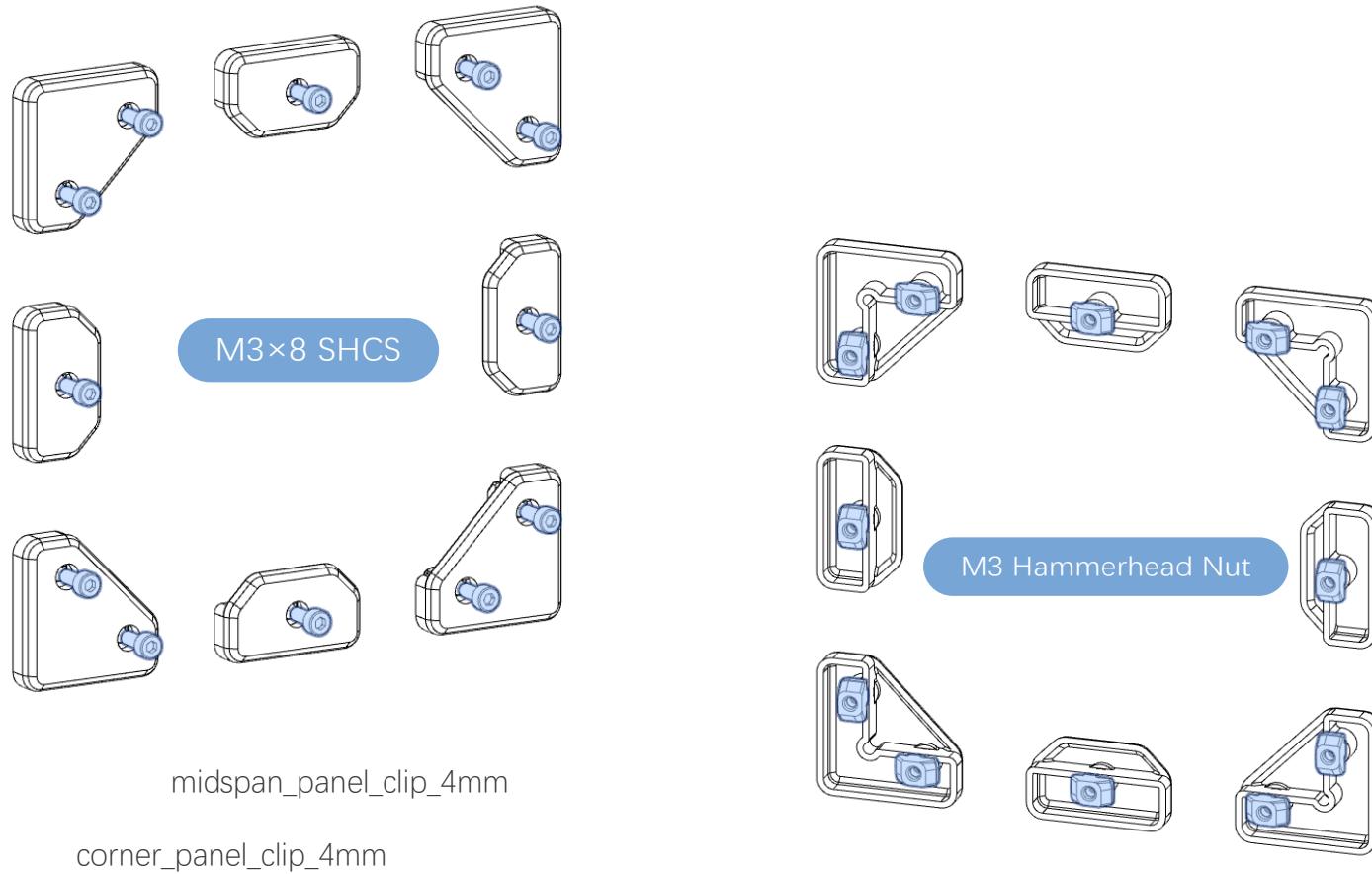
## APPLYING FOAM TAPE TO THE RIGHT SIDE

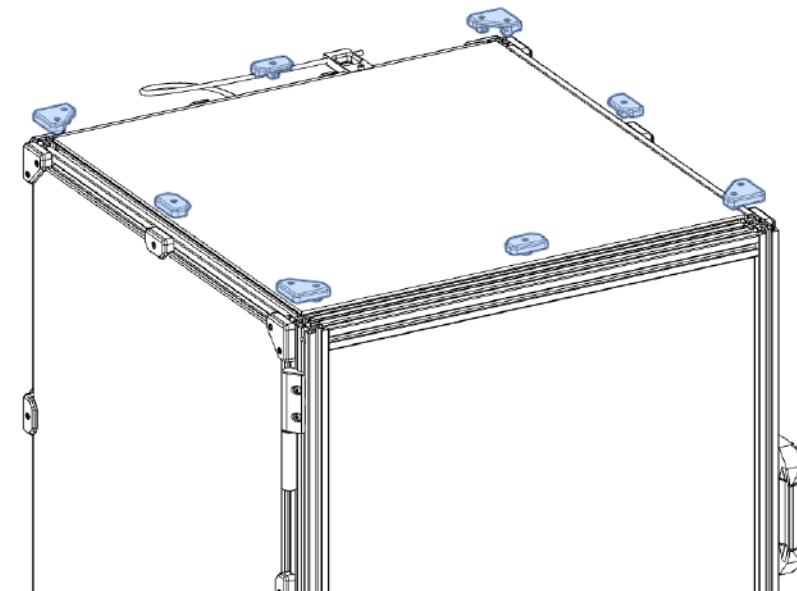
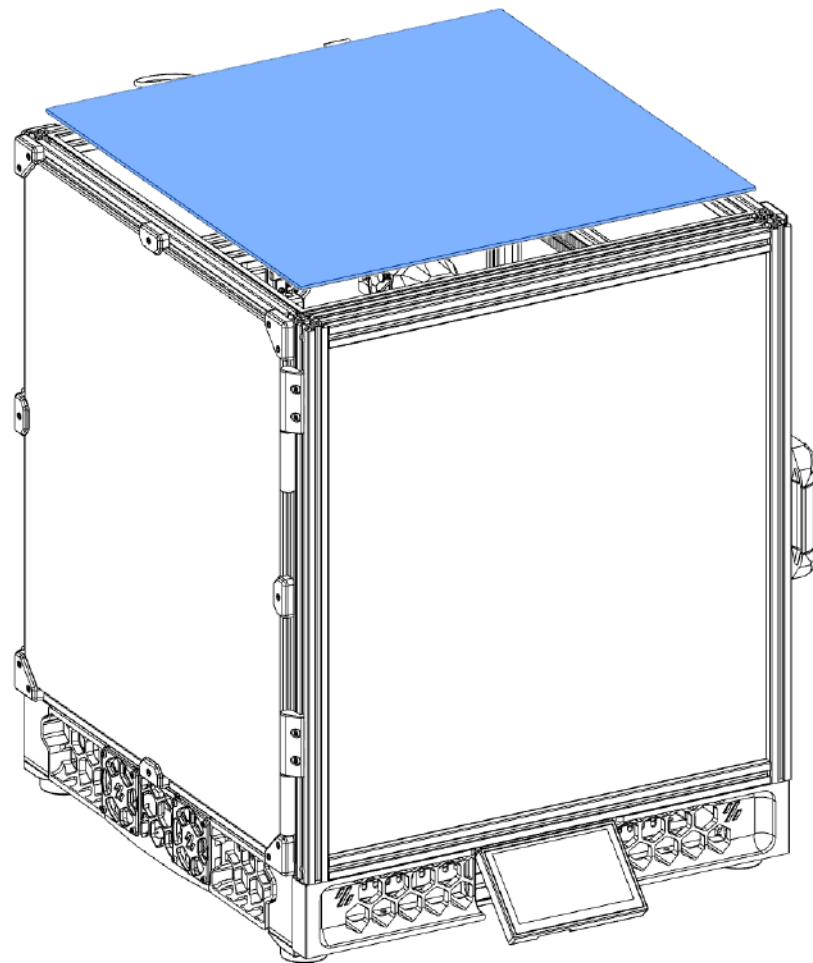
Apply Foam Tape (3mm) to the right side of the printer in the same manner. This step is not repeated here.



### APPLY FOAM TAPE

Use 1mm foam tape on the contact areas between the panels and the frame to mitigate noise from vibrations.

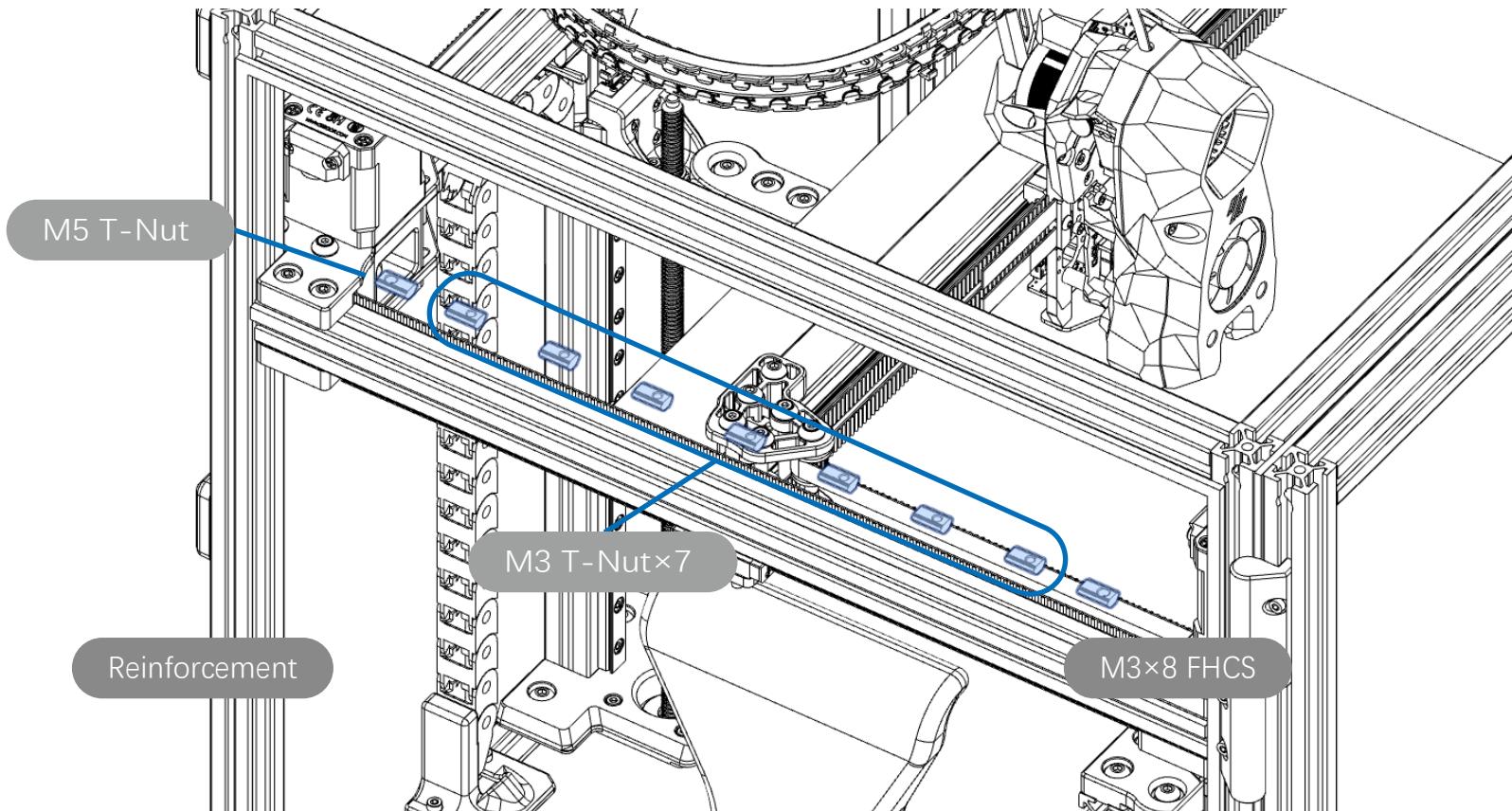




M5 T-Nut

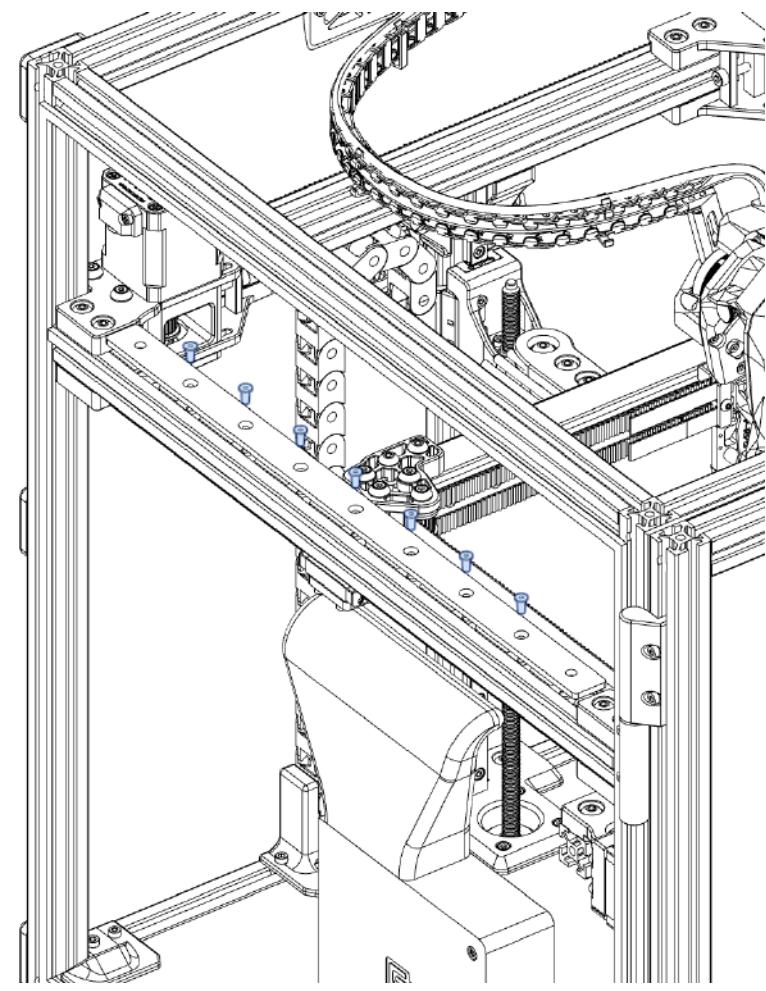
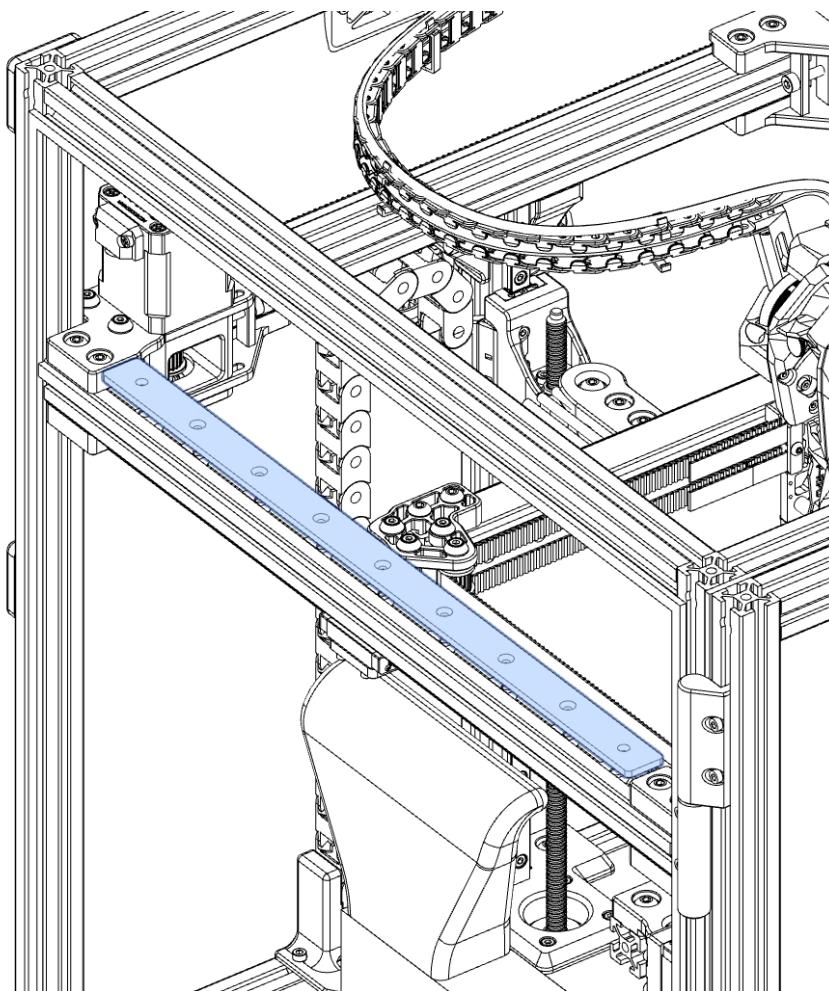
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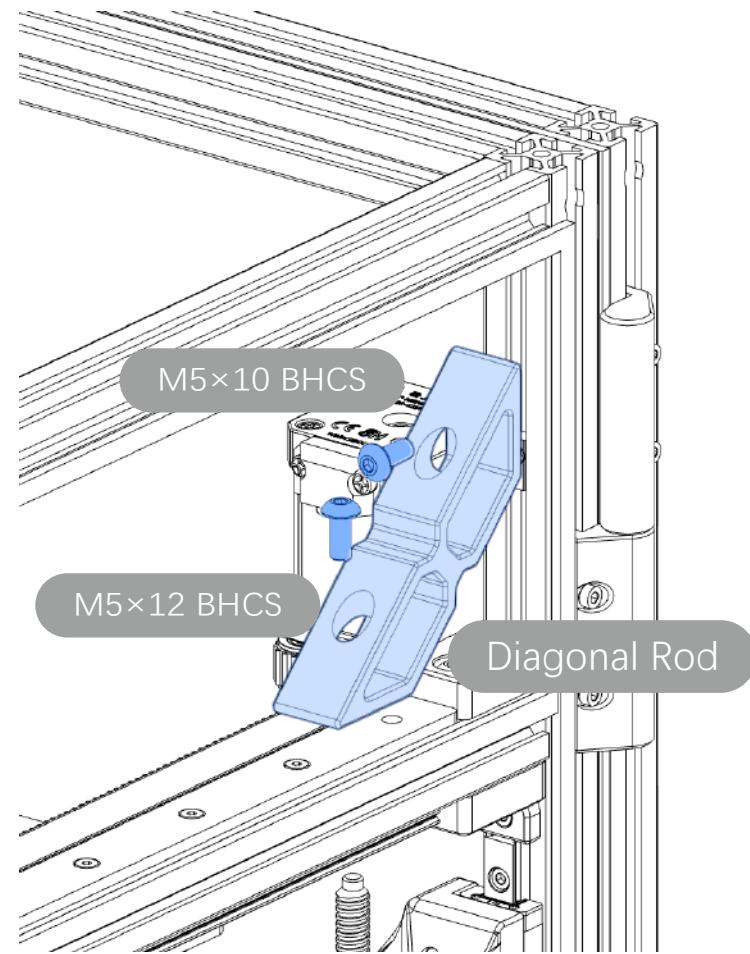
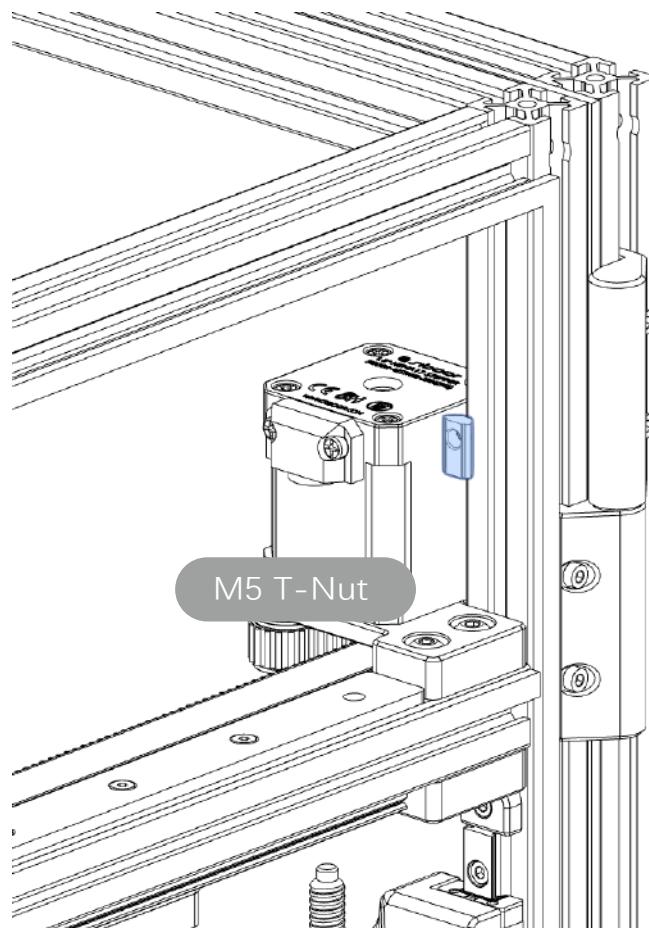
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Trident [JUNE] ASSEMBLY

