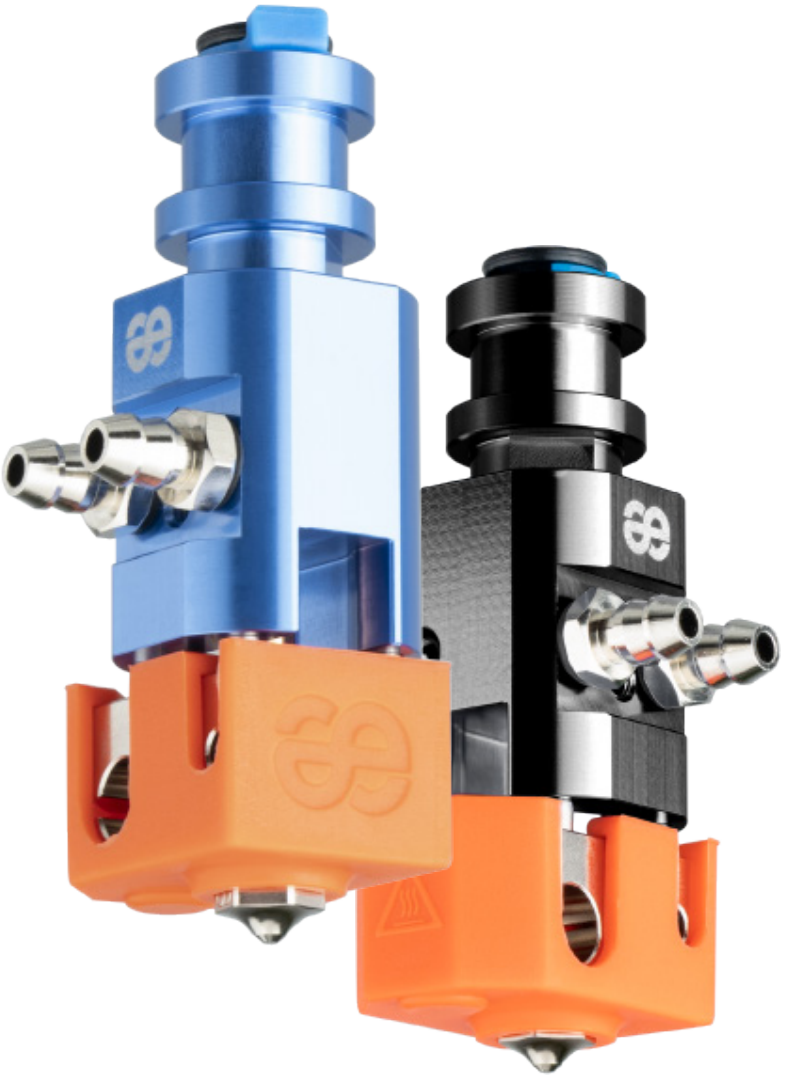
Phaetus®

Dragon Water Hotend® ST
Assembly Instruction

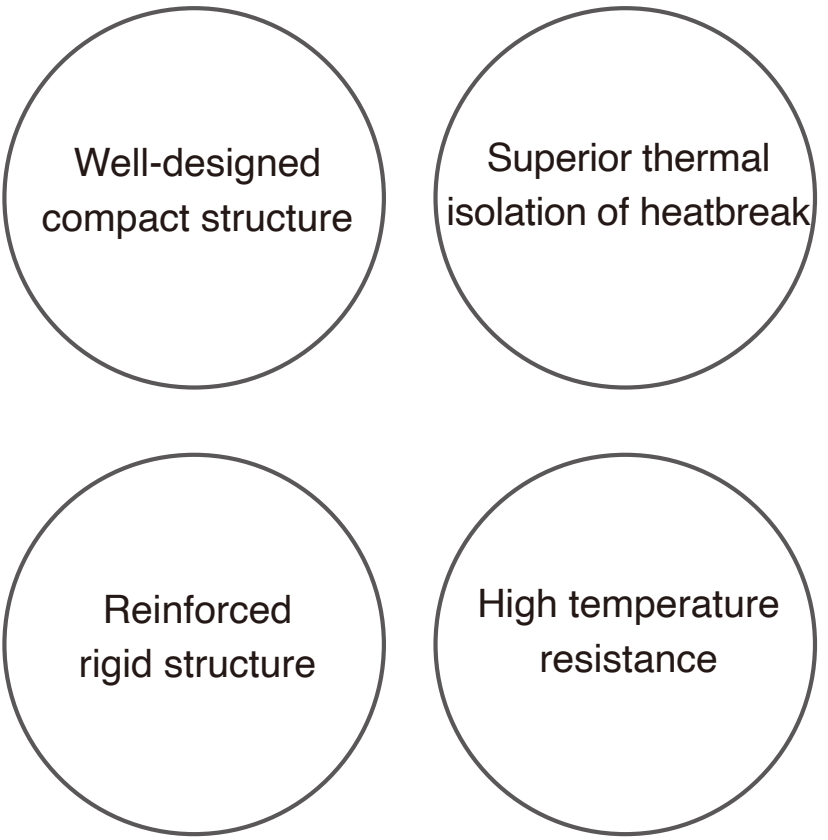
Please read and keep this manual carefully
before using our products properly

Product Appearance



Thank you for buying Phaetus'
Dragon Water Hotend.

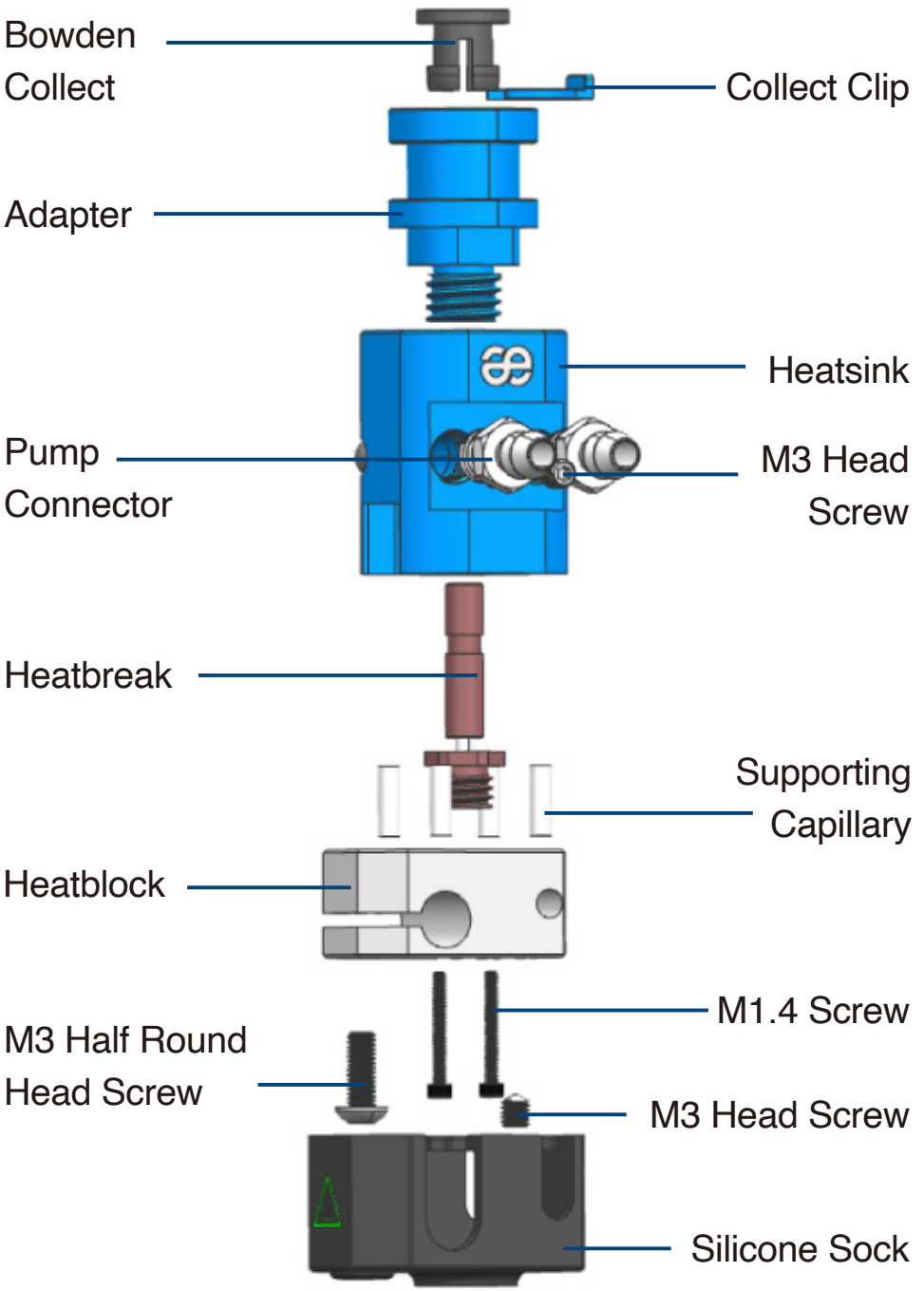
Product Features



Compatible Filaments

Compatible with all consumables, including: PLA, ABS, PETG, TPU, PP, PC, Nylon, PEEK, PEI.

Product Exploded View



Specifications

Product Name: Dragon Hotend WST
Product Size: 30.0mm*26.5mm*62.2mm
Default Nozzle: Plated copper 0.4/1.75mm
Product Color: Blue/Black
Product Net Weight: 67.4g

Parts & Accessories

M2.5x8 screws *4pcs
M2.5x12 screws *4pcs
M1.4x12 screws *2pcs
H1.27 / H1.5 / H2.0 hexagon bar *1pcs
H8.0 open wrench *1pcs
Heat conducting silicone grease
Brass sleeve

Product Advantage

· Heatbreak with an ultra-thin wall thickness as thin as 0.1mm, realizing an excellent thermal insulation.

· Increased rigid support structure guarantee the heatbreak remaining intact under the impact of external force.

· Integral frame rigid structure makes nozzle replacement more convenient without grasping the heatblock.

· The inner hole roughness of nozzle and heatbreak Ra0.3, which allow a more smooth movement of filament, resulting a higher resolution prints.

· Standard hotend and high flow hotend share the same overall dimension, which realize a zero barrier for interchangeability.

· The hotend is mainly composed of copper alloy material which has the advantage of faster heating and better heat dissipation.

· Standard all metal kit, with overall high temperature resistance up to 500 °C.

· Flexible combined structure design makes a strong compatibility.

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欢迎使用

Welcome

Bienvenu

Willkommen

Bienvenida

Välkommen

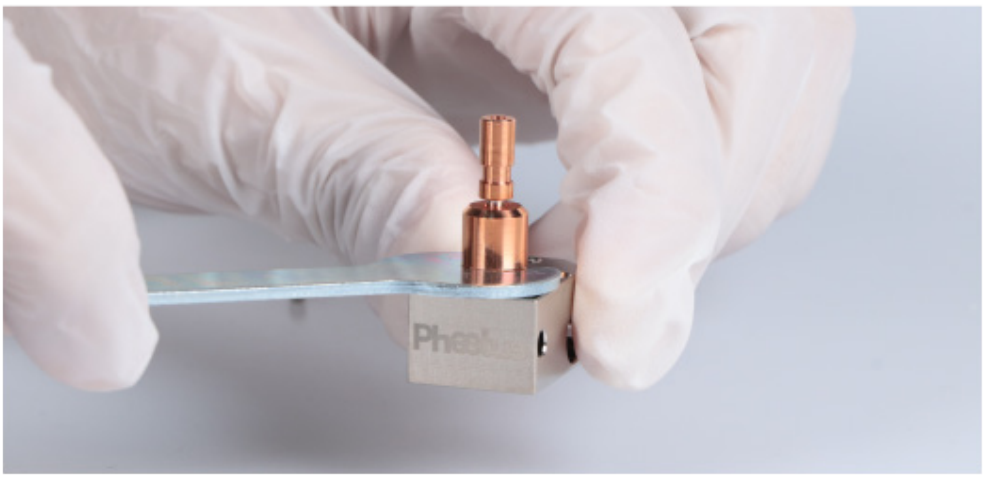
This user guide helps you get started
using Dragon Water Hotend
And discover all the amazing things it
can do on a 3D printer

Assembly Steps

1. Insert the bowden collect into the top of the adapter, insert the collect clip between the bowen collect and the adapter to secure the bowden collect;

2. Screw the adapter into the heatsink;

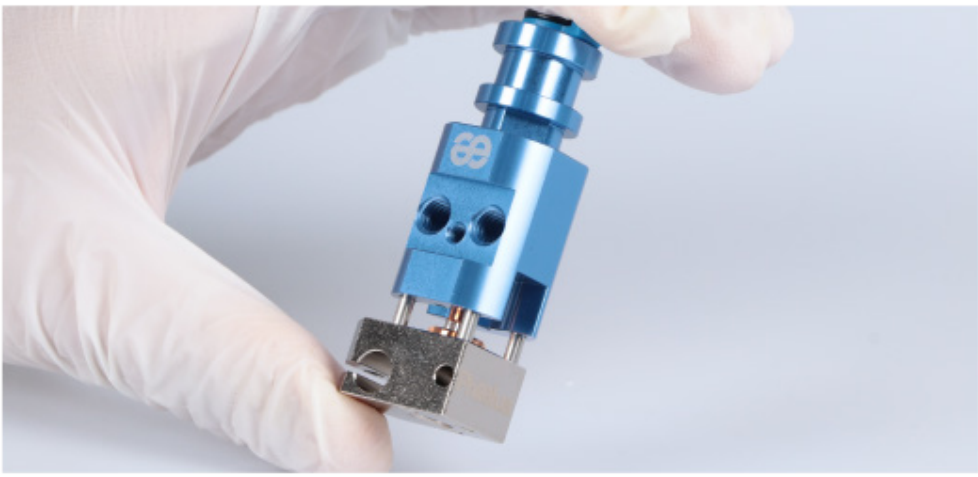
3. Screw the heatbreak into side A of the heatblock using an open – ended wrench (about 4.5NM torque);



4. Insert the 4 supporting tubes into the 4 round holes at the bottom of the heatsink;

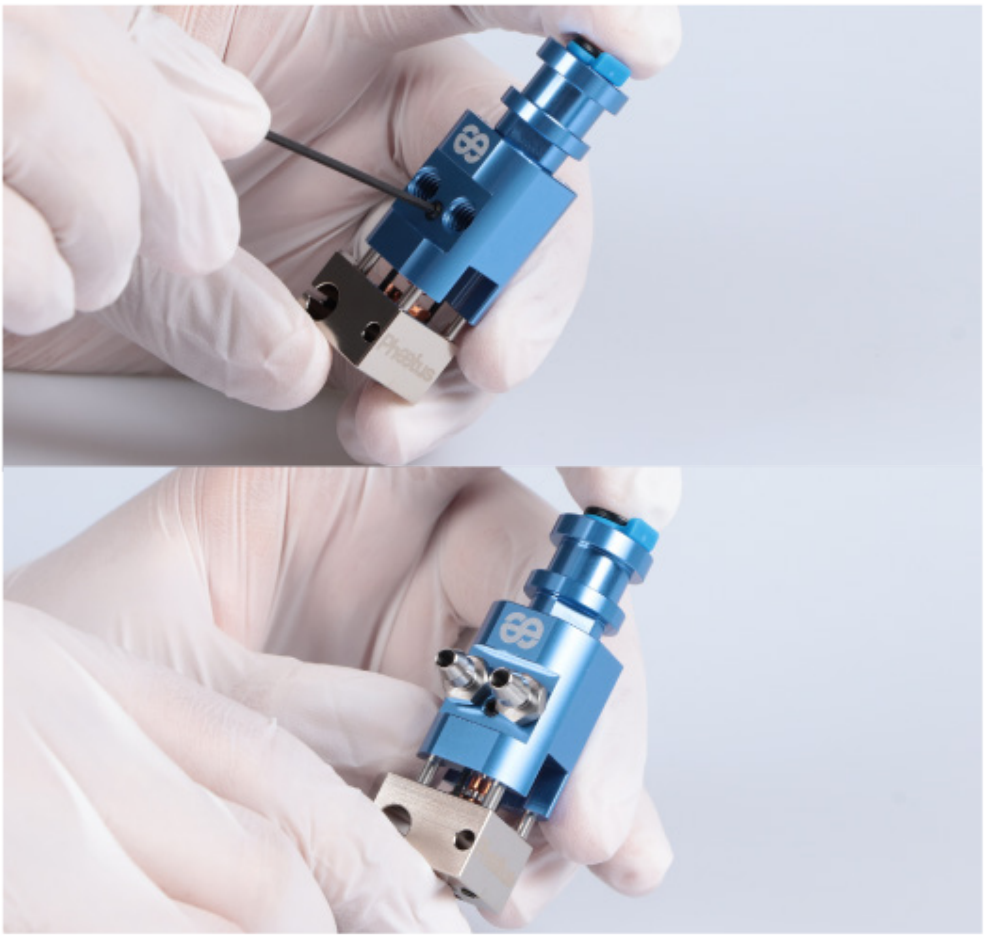
5. Align the 4 supporting tubes at the bottom of the assembled heatsink, insert them into the 4 round holes on side A of the heatblock, and press them firmly (Note that the side with small beads

on the side of the heatsink is opposite to the side engraved with Phaetus logo on the heatblock);



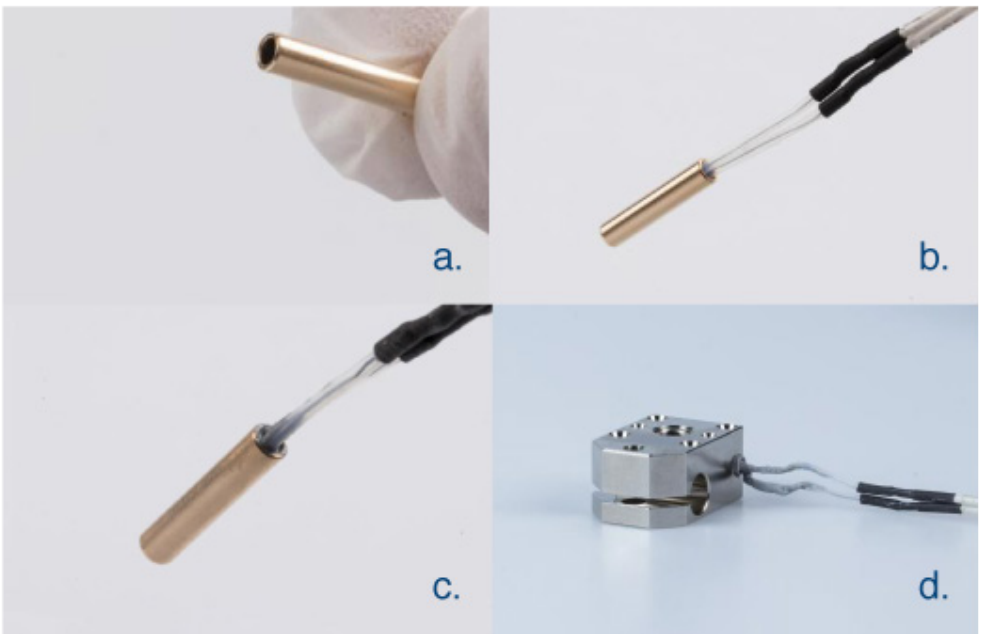
6. On side B (4 holes) of the heatblock, screw the 3 screws shown in the following figure into the corresponding screw holes using an appropriate hexagon bar (Warning: Excessive tightening of the M1.4*12 screw will damage the thread, or lead to screw fracture and hexagon nut sliding teeth, etc.);

7. Screw the M3 head screw and water connector into the 3 corresponding screw holes on the side of the heatsink;



8. Put the silicone sock on the heatblock;

9. If you are using a glass ball thermocouple, first install the thermocouple into the brass sleeve in the accessories kit (the brass sleeve is shown below), seal the port with the thermal adhesive carried in the accessories kit, then put it into the heatblock and lock it with the head screw.



Hot – Tightening

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

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

3. Gently tighten the nozzle while fixing the heatblock with a wrench, and finally tighten the nozzle with a smaller 7.0mm wrench. This will keep the nozzle close to the heatbreak and ensure that the hotend does not leak.

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

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