

Itty Bitty Double Extruder – Assembly Instructions

Insert a pin into a **688ZZ bearing** and place it into the idler block.



Use a sharp tool to rotate the pin and lock it into position.



Drill and tap the top holes for M3 threads. Install **two M3x12 flat head screws**.



Press **two M4 nuts** and **two M3 nuts** into the base of the extruder block.



Press **four 688ZZ bearings** into the extruder block.



Install hobbled bolts and spacers into the extruder block.
(1mm spacer under the bolt head)



Press a nut into each pulley and install the pulleys onto the hobbled bolts with jam nuts.



Install the motors with **six M3x8 screws** and **six M3 washers**.



Install **20-tooth pulleys** and **belts**. Adjust belt tension and tighten motor screws.



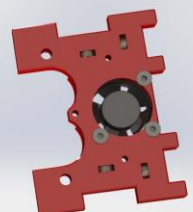
Install idler blocks to extruder with **M3x25 screws** and **M3 nuts**. Install **extension springs** on top screws.



Press **four M3 hex nuts** into the shelf using needle-nose pliers.



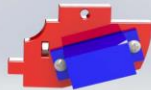
Install a 25x25x10mm fan into the shelf with **three M3x12 flat head screws**. Tap or crimp the holes in the fan so the screws will grip.



Install the Hexagon fan shroud with **two M3x6 button head screws**.



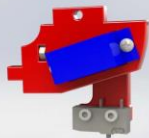
Press an **M3 nut** into each shelf bracket. Mount an HXT900 servo into the left bracket using the screws that came with the servo.



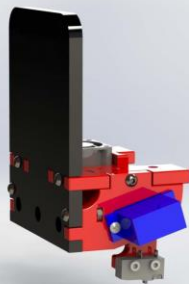
Press a servo arm into the Z probe and install it onto the servo with the screw that came with the servo.



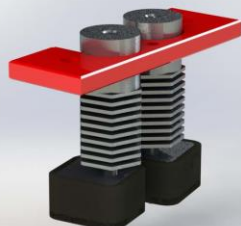
Install a snap switch to the Z probe with **two M2.5x10 screws**.



Mount the shelf and brackets to the printer back plate with **six M3x16 button head screws**.



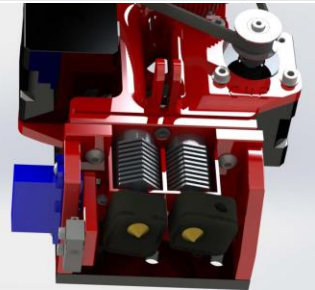
Install two hot ends into the double groove mount.



Install the groove mount to the extruder block with **two M3x12 flat-head screws** using the pressed-in nuts.



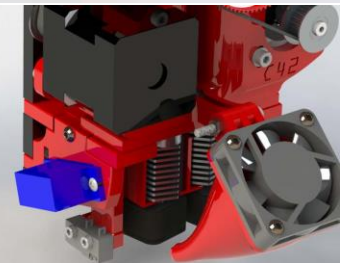
Slide the extruder assembly onto the shelf and secure it with **two M4x20 button head screws**.



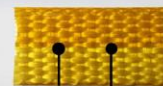
Mount a 40x40x10mm fan to the print fan shroud using **four M3x16 button head screws**.



Mount the fan shroud to the extruder with an **M3x25 screw** and an **M3 nut**.



Cut slots in the **insulator** to fit around the hot ends and install between the heat blocks and fan shroud.



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