Itty Bitty Double Extruder  
Assembly Instructions

1. Drill and tap with an M3 tap:
   1. Idler block holes x
   2. Shelf holes x
   3. Print fan shroud x
   4. 25mm fan x
2. Drill and tap with an M2 tap:
   1. Switch mount holes in Z probe arm x
3. Clean-up
   1. Remove support from filament channels x
   2. Clean out countersinks for 25mm fan in shelf x
   3. Clean out countersinks in groove mount plate x
   4. Fit groove mount to shelf x
   5. Sand fan mount fingers for fit
4. Idler blocks
   1. Mount bearings with cam pins x
   2. Install spring screws x
5. Extruder block
   1. Press in captured nuts (4) x
   2. Press in bearings x
   3. Install hobbed bolts with spacers x
   4. Press nuts into pulleys and install with lock nuts x
   5. Install motors loosely x
   6. Install motor pulleys and belts x
   7. Install idler blocks x
   8. Install extension springs x
6. Shelf assembly
   1. Press hex nuts into shelf x
   2. Install 25mm fan x
   3. Install lower fan shroud x
   4. Install servo into side bracket and press in nut x
   5. Install Z probe onto servo x
   6. Install switch onto Z probe x
   7. Install brackets and shelf onto printer x
7. Hot ends
   1. Install hot ends into groove mount x
   2. Attach groove mount to extruder block x
   3. Mount entire assembly onto shelf x
8. Print cooling fan
   1. Attach fan to shroud x
   2. Mount shroud onto extruder block x