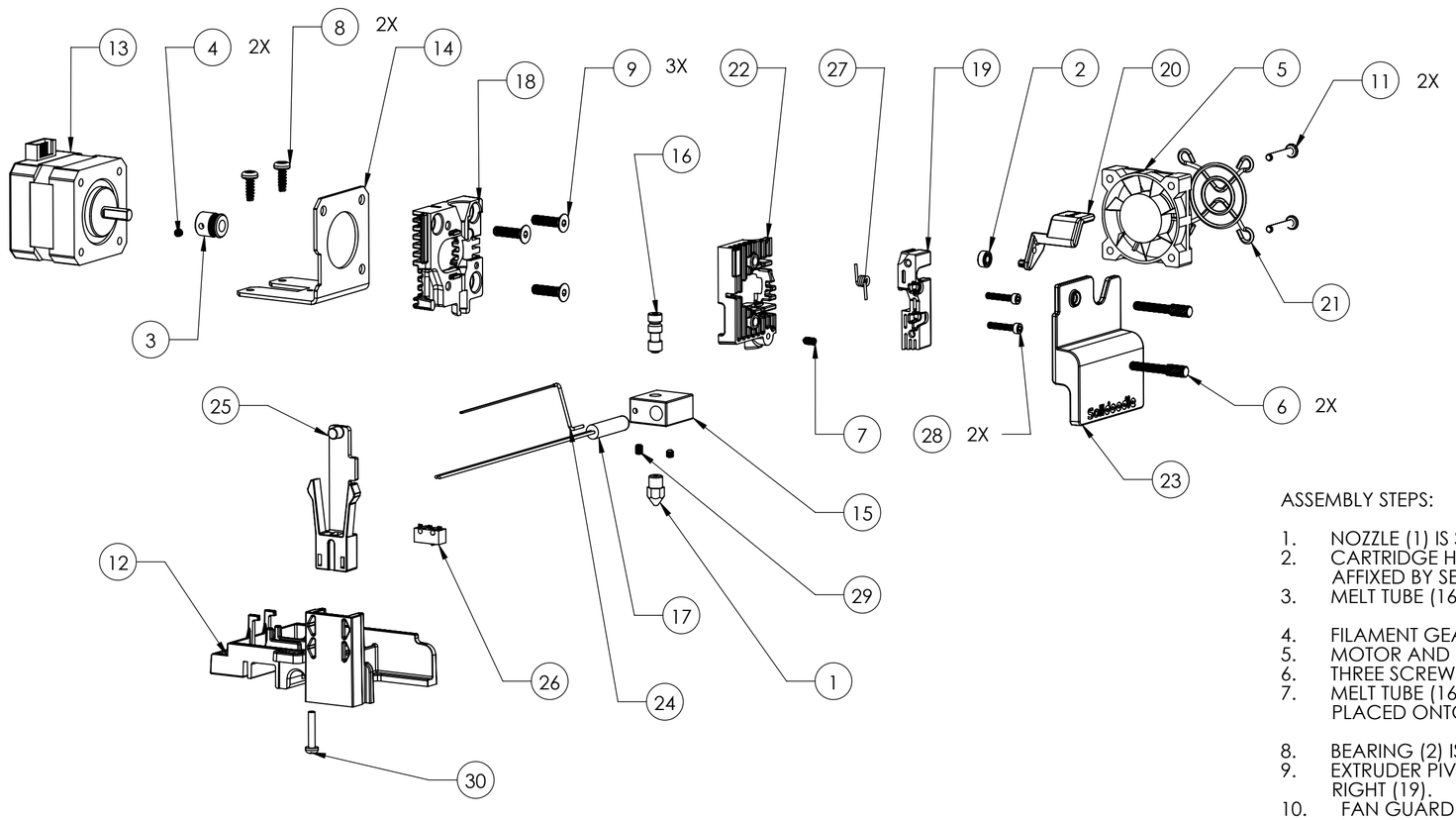
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE OF DRAWING	7/16/2014	RJT



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	1844_025	Extruder Nozzle	1
2	m3_bearing		1
3	1844_039	Print Head Gear	1
4	m3x3_set_screw_cup		2
5	1844_044	40x40x10 Fan	1
6	1844_038	Knurled Thumb Screw	2
7	m3x6_set_screw_cone		1
8	m3x10_plastite		2
9	m4x16_flat_socket_screw		3
11	m3x18_pan_screw		2
12	1844_016_rev_06	Internal - Print Car	1
13	1844_056	Stepper Motor	1
14	1844_035_rev_04	Motor Bracket	1
15	1844_018_rev_03	Internal - Melt Chamber	1
16	1844_017_rev_03	Internal - Melt Tube	1
17	1844_061	Cartridge Heater	1
18	1844_011_rev_04	Heat Sink Back	1
19	1844_012_rev_04	Heat Sink Front Right	1
20	1844_034_rev_04	Extruder Pivot Arm	1
21	1844_063	Fan Guard	1
22	1844_051_rev_04	Heat Sink Front Left	1
23	1844_027_rev_04	Extruder Cover	1
24	print_head_thermistor		1
25	1844_062_rev_05	Auto Leveler	1
26	D2F_01F_D	Auto-Leveler Microswitch	1
27	torsion_spring_extruder		1
28	m2.5x14_socket_cap_screw		2
29	m3x4_set_screw_flat		1
30	m2.9x16_sheet_metal_screw		1
31	m2.9x19_flathead_sheet_metal		1

ASSEMBLY STEPS:

1. NOZZLE (1) IS SCREWED INTO MELT CHAMBER (15).
2. CARTRIDGE HEATER (17) AND THERMISTOR (24) ARE PLACED IN MELT CHAMBER AND AFFIXED BY SET SCREWS.
3. MELT TUBE (16) IS SCREWED INTO MELT CHAMBER.

4. FILAMENT GEAR (3) IS PLACED ONTO MOTOR SHAFT (14) AND AFFIXED BY SET SCREW.
5. MOTOR AND HEAT SINK BACK (18) ARE PLACED ON SHEET METAL BRACKET (14).
6. THREE SCREWS (9) LOCK HEAT SINK BACK AND MOTOR TO SHEET METAL BRACKET.
7. MELT TUBE (16) IS PLACED IN SLOT IN HEAT SINK BACK (18), AND HEAT SINK FRONT LEFT (22) IS THEN PLACED ONTO HEAT SINK BACK (18).

8. BEARING (2) IS PLACED ONTO EXTRUDER PIVOT ARM (20).
9. EXTRUDER PIVOT ARM (20) AND BEARING (2) ARE INSERTED INTO OPENING IN HEAT SINK FRONT RIGHT (19).
10. FAN GUARD (21) IS PLACED ONTO FAN (5), AND TWO SCREWS (11) JOIN FAN AND GUARD TO HEAT SINK RIGHT (21).
11. TWO SCREWS (28) ARE PLACED INTO HEAT SINK FRONT RIGHT (19), AND TORSION SPRING (27) IS SLID OVER TOP SCREW (28).
12. TWO SCREWS (28) ARE THEN FASTENED TO HEAT SINK BACK (20), MAKING SURE TORSION SPRING IS ENGAGED WITH EXTRUDER PIVOT ARM AND HEAT SINK BACK.

13. HEAT SINK FRONT LEFT (24) IS PLACED ONTO HEAT SINK BACK (18), MAKING SURE TO LOCK MELT TUBE (16) IN PLACE.
14. MELT TUBE IS SECURED BY SET SCREW (7).
15. ONE THUMB SCREW (6) IS SCREWED INTO HEAT SINK FRONT LEFT (22), LOCKING THE HEAT SINKS TOGETHER.
16. EXTRUDER COVER (23) IS PLACED ONTO FRONT OF HEAT SINK AND SECURED BY SECOND THUMB SCREW (6).

17. MICROSWITCH (26) IS PLACED INTO AUTO-LEVELER (25).
18. AUTO-LEVELER (25) IS INSERTED INTO PRINT CAR (12).
19. MOTOR/HEAT SINK/FAN COMPONENTS ARE PLACED ONTO PRINT CAR (12) AND SCREWED IN PLACE BY TWO SCREWS (8).
    - NOTE: WIRES FROM HEATER, MICROSWITCH, AND THERMISTOR ARE ROUTED THROUGH CHANNEL IN HEAT SINKS AND ZIP TIED TO HOOK ON PRINT CAR (12).
20. SHEET METAL SCREW (30) IS INSERTED BELOW PRINT CAR AND SCREWED INTO SHEET METAL BRACKET (14).

NOTE: ASSEMBLY STEPS PROVIDED ARE THEORETICAL STEPS LAID OUT BY TOOL. KENVOX SHOULD DEVELOP ITS OWN MOST EFFICIENT METHOD FOR ASSEMBLY USING TOOL'S STEPS AS A GUIDE.

Solidoodle

631 Hicks St., Brooklyn, NY 11231

ENGINEERED		PREPARED FOR
DRAWN		PROJECT 1844
CHECKED		JOB NUMBER
APPROVED		PART NAME Solidoodle_print_head

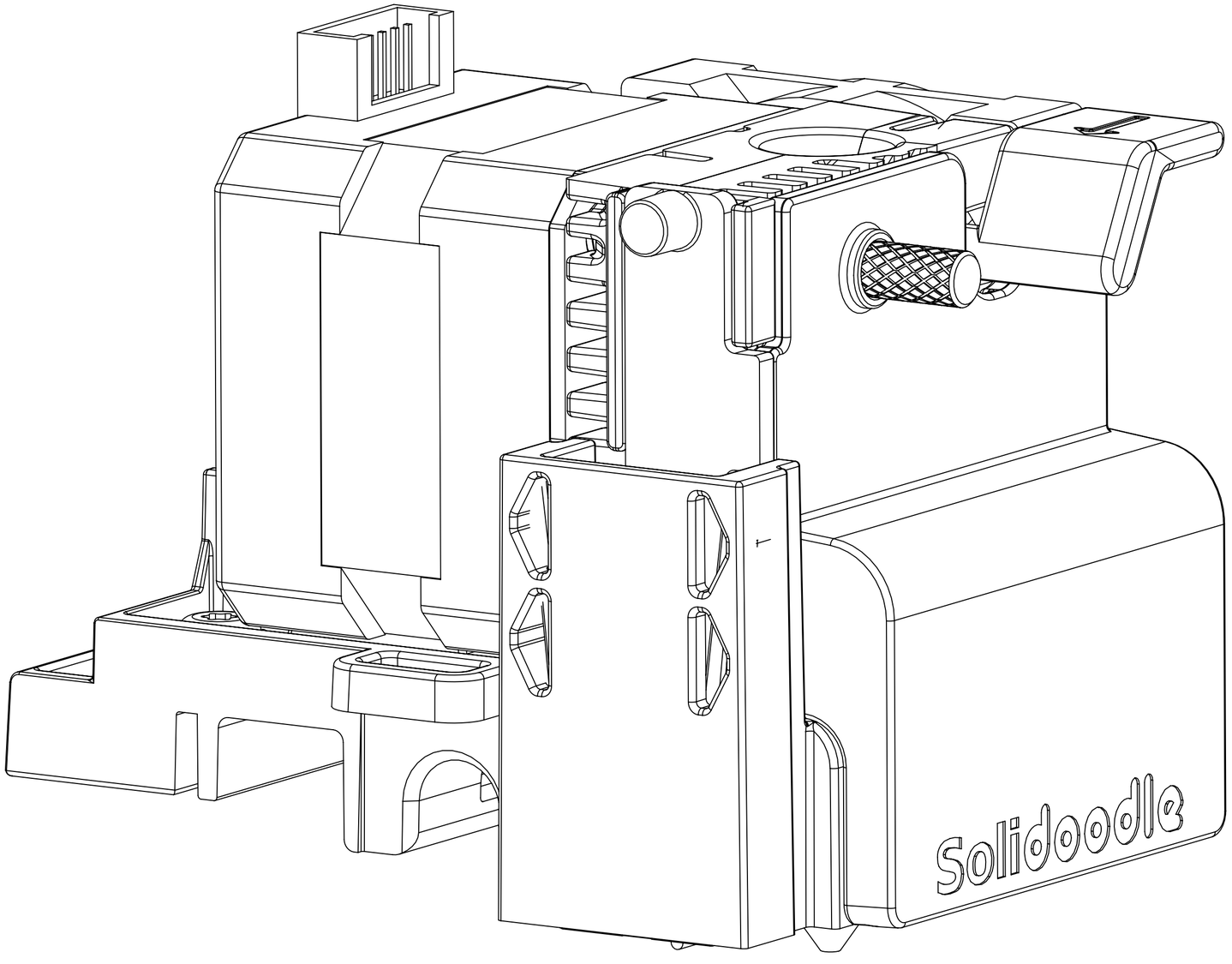
DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED. DO NOT SCALE.

UNSPECIFIED TOLERANCES: X ±.5; .X ±.1; .XX ±.05; X° ±.5°

THIRD ANGLE PROJECTION

SIZE	PART NUMBER	REVISION
C	Solidoodle_print_head	1

SCALE 1:2 SHEET 1 OF 2



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UNSPECIFIED TOLERANCES		
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	.X	±.1
	.XX	±.05
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THIRD ANGLE PROJECTION

SIZE	PART NUMBER	REVISION
C	Solidoodle_print_head	1

SCALE 3:1 SHEET 2 OF 2