



# Satsuma 250

by Ella Fox

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## Assembly Manual

Version 2024-05-16

# Introduction



Before you begin, a word of caution.

In the comfort of your own home, you are about to assemble a robot. This machine can maim, burn, and electrocute you if you are not careful.

Please apply common sense when operating your Satsuma, and do not hesitate to ask for assistance with assembly or usage of your machine.

Before starting your build, continue to read the manual in full.

## Credits

Special thanks to these awesome people, communities, and companies for making Satsuma 250 possible <3



# About

The Satsuma 250 follows in the line of printers by Squirrelbrain. It takes design queues from the Satsuma 180.

The goal of this project is to re-imagine a Prusa MK3/MK4 as a CoreXY machine, whilst using much of the same components found in the original printers.

Whilst many of the mechanical parts can be sourced directly from Prusa, the whole the bill of materials can also be sourced from elsewhere with relative ease.

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I hope you enjoy your build as much as I did putting this together <3  
- *Ella Fox*

## Printed Part Guidelines

Depending on your goals for the printer, the material you choose to print the parts from will vary. Please use the table to configure your slicer settings accordingly.

Material	<b>Minimum (Open Frame):</b> PETG <b>Recommended (Enclosed):</b> ABS, ASA <b>Premium (Enclosed, High Temperature):</b> Annealed PC-CF
Nozzle	0.4mm or 0.5mm
Layer Height	0.2mm
Perimeter/Wall Count	4
Solid Top/Bottom Layers	5
Infill Percentage	<b>Minimum:</b> 30% <b>Recommended:</b> 40%
Infill Pattern	Grid
Extrusion Width	<b>0.4mm nozzle:</b> 0.4mm forced width <b>0.5mm nozzle:</b> 0.5mm forced width

## Frame



## Frame Preparation

A Extrusion

