

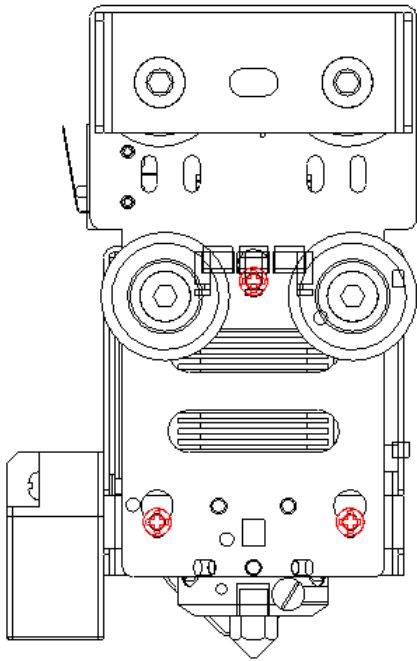


Direct Drive Extruder Installation and User Guide

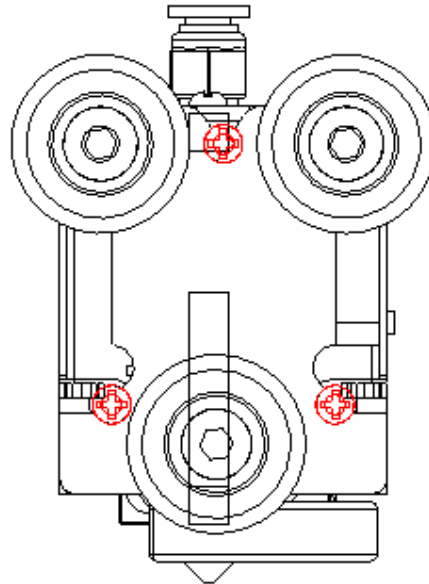
Ver: 1.0

Installation

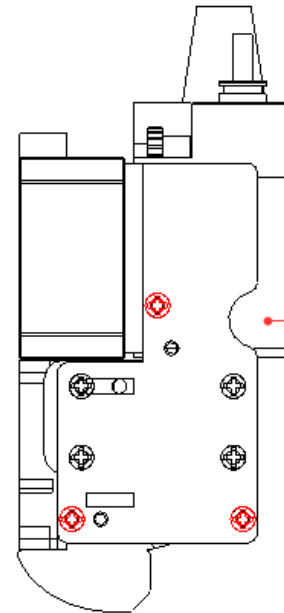
- 1. Take down the original hotend from the x carrier
- 2. Install the direct drive extruder (DDE) to the same position of the carrier



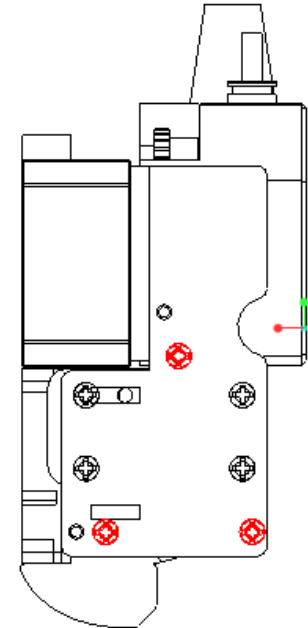
Z9 print head



Z6 print head



Fixing Screws for
Z5/Z8/Z9/Z10

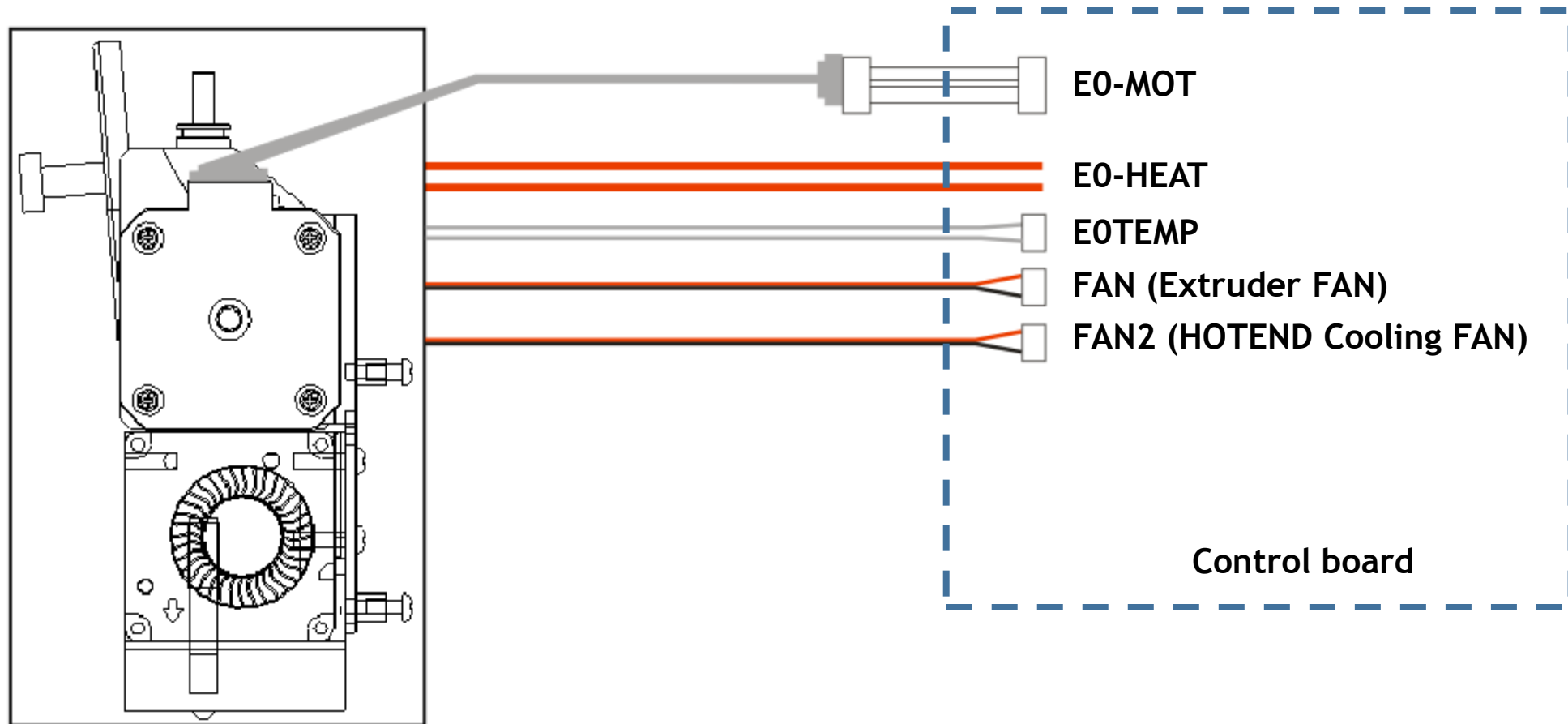


Fixing screws for
Z6/Z5X

Loosen or remove 3 screws to take down
the hotend from X carrier

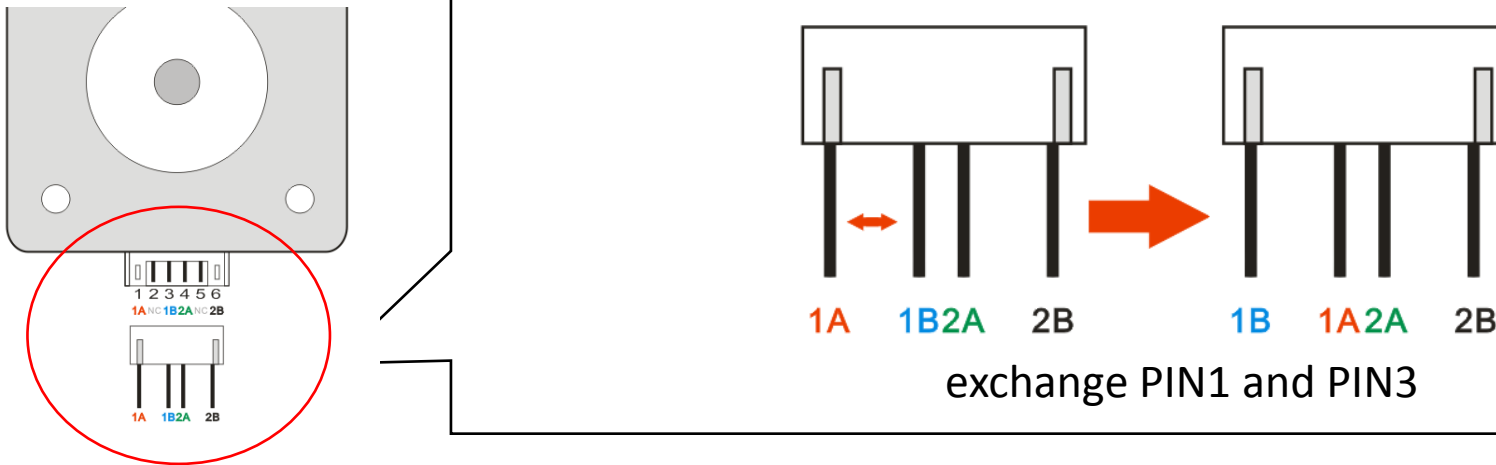
Install the DDE to the x carrier,
note the Z6 and Z5X is different with other 3d
printer model s

Wiring



Wiring

You may need to change the stepper motor working direction, please refer to the below picture simply to exchange PIN1 and PIN3 of the motor cable, the motor working direction will be reversed:



TIPS: Use a knife to turn up the clip of the terminal and then pull out the wiring



Set steps/mm parameter of extruder

You may need to change the **steps/mm** parameter of the extruder, there are two method to set the **steps/mm** parameter:

NOTE: 400 steps / mm is for the driving circuit with micro step setting 16:1. if your motor drive controllers are different, please set according to the following parameters:

$$E \text{ Steps/mm} = 200 * \text{microsteps} / 8$$

1. Add **“M92 E400”** command in the “start gcode” of slicing software:

You can add a **“M92 E400”** command in the “start gcode” of slicing software, when printing from SD card, it will change the steps/mm to 400.

PS: The parameter won't be stored to the printer.

2. Set on LCD screen:

- For LCD128x64:

Configuration>>Advanced settings>>Steps/mm>>Estpe/mm: **400 (change to 400)**

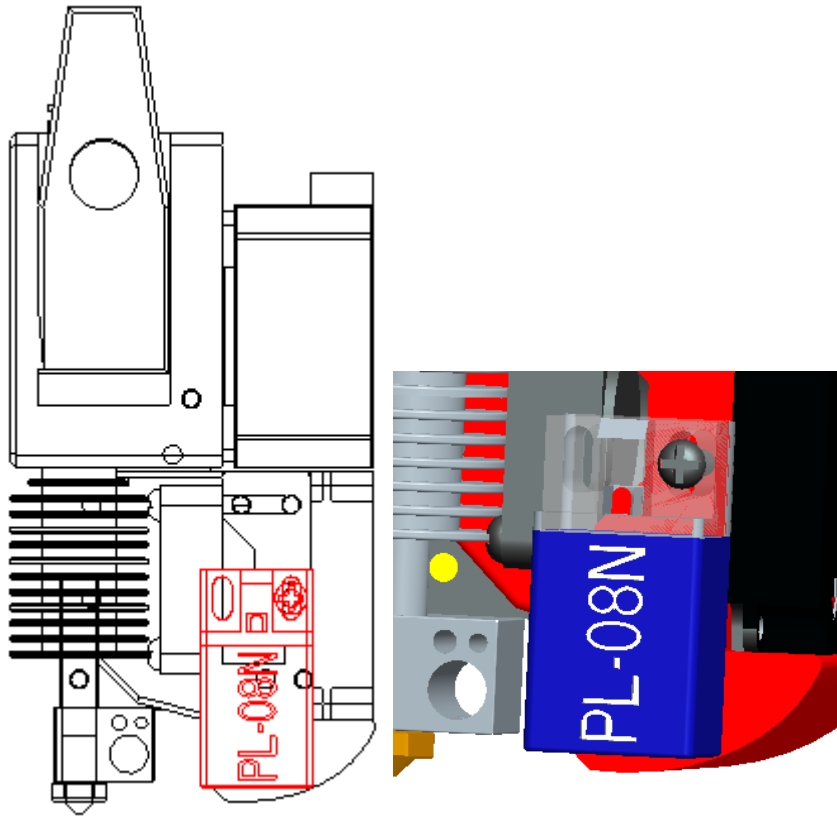
Configuration>>Store settings

- For LCDDWIN(4.3INCH-TFT):

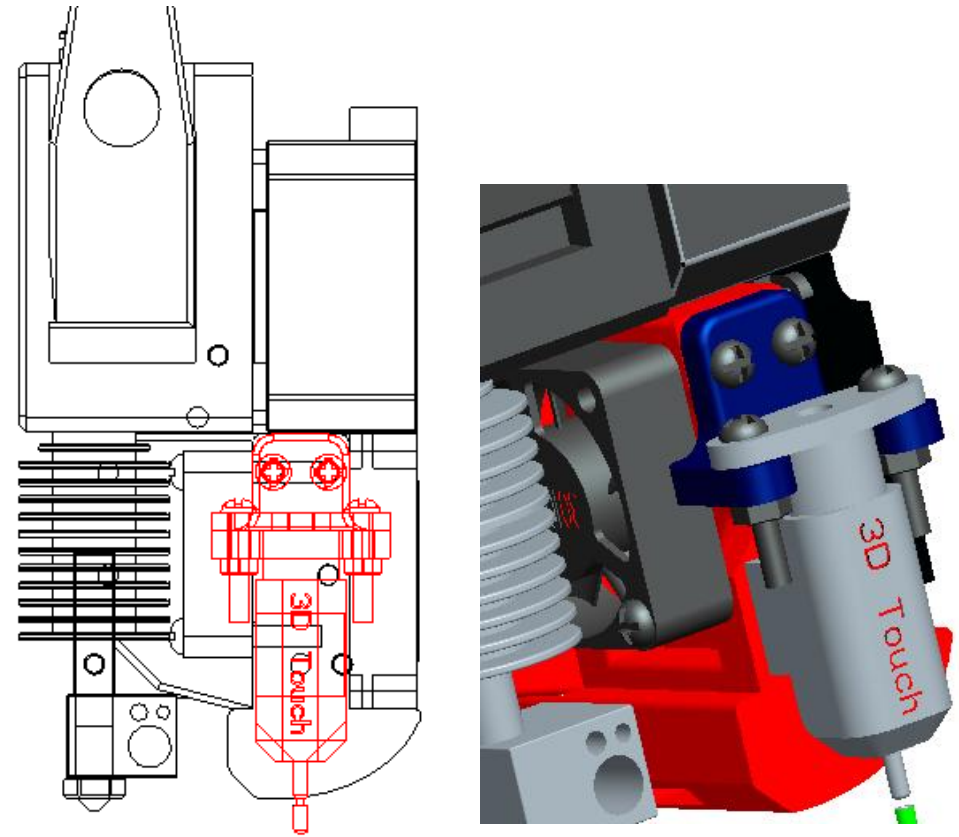
Config>>Motion>>Steps/mm>>Steps/mm E:

Config>>Store settings

Install the bed leveling sensor



PL-08N proximity sensor



Bltouch(3DTouch) sensor

Slicing settings

Slice settings are usually related to the shape of the printed model, the filament type and the printer, etc. The main parameter you need to pay attention to is about the retraction settings. The following settings are for your reference:

Filament type	Retraction length	Retraction speed	Print speed
PLA/PLA+/PETG/ABS	6~16mm	20~30mm/s	80 mm/s Max
Silk-PLA	12~16mm	25~30mm/s	60 mm/s Max
TPU(95A)	1~8mm	20~30mm/s	50 mm/s Max
TPU(87A)	1~5mm	0~20mm/s	30 mm/s Max
TPU(83A)	0~3mm	0~10mm/s	25mm/s Max