

## VORPAL 180 ASSEMBLY

Take up your sword and fight your dragons

VERSION 2023-11-10

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## PREPARATION

### PART PRINTING GUIDELINES

This printer was designed to utilize the Voron process as much as possible. Their material and print settings should be followed to ensure a mechanically sound machine.

#### 3D PRINTING PROCESS

Fused Deposition Modeling (FDM)

#### MATERIAL

ABS

#### LAYER HEIGHT

Recommended: 0.2mm

#### EXTRUSION WIDTH

Recommended: Forced 0.4mm

#### WALL COUNT

Recommended: 4

#### SOLID TOP/BOTTOM LAYERS

Recommended: 5

#### INFILL TYPE

Grid, Gyroid, Honeycomb, Triangle or Cubic

#### INFILL TYPE: FRAME PIECES

Cubic

#### INFILL PERCENTAGE

Recommended: 40%

### COLORS AND QUANTITIES

All .stl files with a suffix of "xN" need to be printed N times. Any .stl file without an "x2" style suffix is a unique part in the assembly of the printer.

The color naming convention is as follows:

[b]\_xxxx.stl → Base Color  
[p]\_xxxx.stl → Primary Color  
[a]\_xxxx.stl → Accent Color

## PREPARATION

### PRINT CALIBRATION

The Calibration\_square\_100mm.stl is provided in the Tools folder to help verify the dimensional accuracy and squareness of the printer/material used to produce parts for the Vorpai 180. ABS has a rather high shrinkage ratio and this needs to be accounted for while printing. With the larger printed pieces of the Vorpai design, accuracy becomes more crucial.

By measuring the Calibration Square with calipers, you can determine the X and Y shrinkage factor for your printer/material. Measure the X and Y dimensions separately and use the equation below to find a value to put into your slicing software.

$10000 / [\text{measured}] = \text{ScalingFactor}$

example:

X →  $10000 / 99.32\text{mm} = 100.68$

Y →  $10000 / 99.48\text{mm} = 100.52$

You can use each of these values separately or take the average and use that for both X and Y. The Z axis shrinkage is not usually an issue and should be left at 100.0. In your slicer I suggest manually setting the X/Y scale factors for every printed part. This cannot be applied to the released files because each printer and material will have unique values. This process is different and more accurate than the XY Size Compensation setting found in some slicers but will not address issues such as holes being undersized or part thickness accuracy due to over/under extrusion. A whole build plate can be scaled at once. Just be sure to uncheck the lock icon.

Using different brands of ABS or using a mix of ABS and ASA parts might require separate calibrations per material/printer.

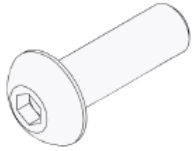
Another feature of the Calibration Square is the inclusion of 3mm holes with 20mm spacing. When calibrated well, each row of holes should line up with the holes of an MGN9 rail and allow a full row of M3 screws to be installed with no binding. The Z\_axis\_rear\_stiffener\_x2.stl in the Electronics Bay folder is a good part for verifying the scale factor due to its length and its hole pattern that should also align with an MGN9 linear rail.

The Calibration Square can also be used to verify the squareness of the printer being used to generate parts. Using a pair of heat-set inserts and M3x20 BHCS, it can be assembled with its Base in order to follow the method described in the video linked below. Keep in mind that the measured error is double the actual mm out-of-square per 100mm of the printers' gantry.

<https://youtu.be/hvVK2lOirBM?t=185>

If the lines diverge from the bottom to the top then the right side of the gantry needs to be brought forward. If the lines converge from the bottom to the top then the left side needs to be adjusted towards the front of the printer.

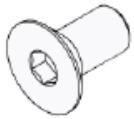
## HARDWARE



### BUTTON HEAD CAP SCREW (BHCS)

Metric fastener with a domed shaped head and hex drive. Most commonly used fastener in this build.

ISO 7380-1



### FLAT HEAD CAP SCREW (FHCS)

Metric fastener with a cone shaped head and a flat top.

ISO 10642



### SHIM

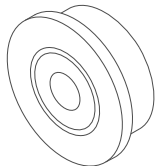
Not to be confused with stamped washers. These are used in all M3 call-out locations in this manual.

3x6x0.5 DIN 988



### HEAT SET INSERT

Heat the inserts with a soldering iron so that they melt the plastic when installed. As the plastic cools, it solidifies around the knurls and ridges on the insert for excellent resistance to both torque and pull-out.



### F623 BEARING

A ball bearing with a flange used for the gantry and Z axis idler pulleys.



### SOCKET HEAD CAP SCREW (SHCS)

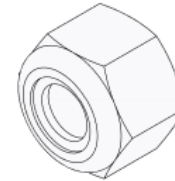
Metric fastener with a cylindrical head and hex drive. Mostly used for connecting to linear rail carriages.

ISO 4762 / DIN 912



### SELF TAPPING SCREW

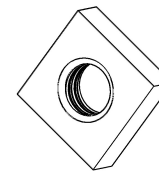
Fastener with a pronounced thread profile that is screwed directly into plastic.



### LOCK NUT

Hex nut with a nylon filled center which prevents the components from loosening.

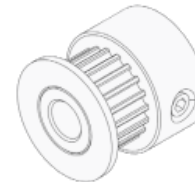
ISO 10511/DIN 982



### M3 SQUARE NUT

Used for the Z belt tensioners.

DIN 562



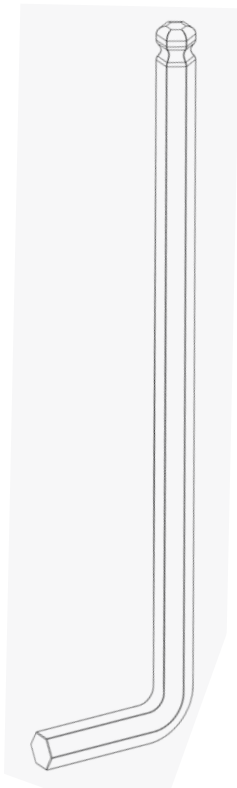
### PULLEY

16 tooth GT2 drive pulley used on the motion system of the Vorpel 180.

## TOOLS

### BALL-END DRIVER

When building the Mini Stealth toolhead, it is useful having long ball-end hex drivers. For many of the hotends with M2.5 screws you will need a 1.5mm driver. For installing most extruders with M3 button-head screws, a 2.0mm driver is needed.



### HEX-BIT DRIVER SET

NICE TO HAVE

NEEDED FOR BUILD

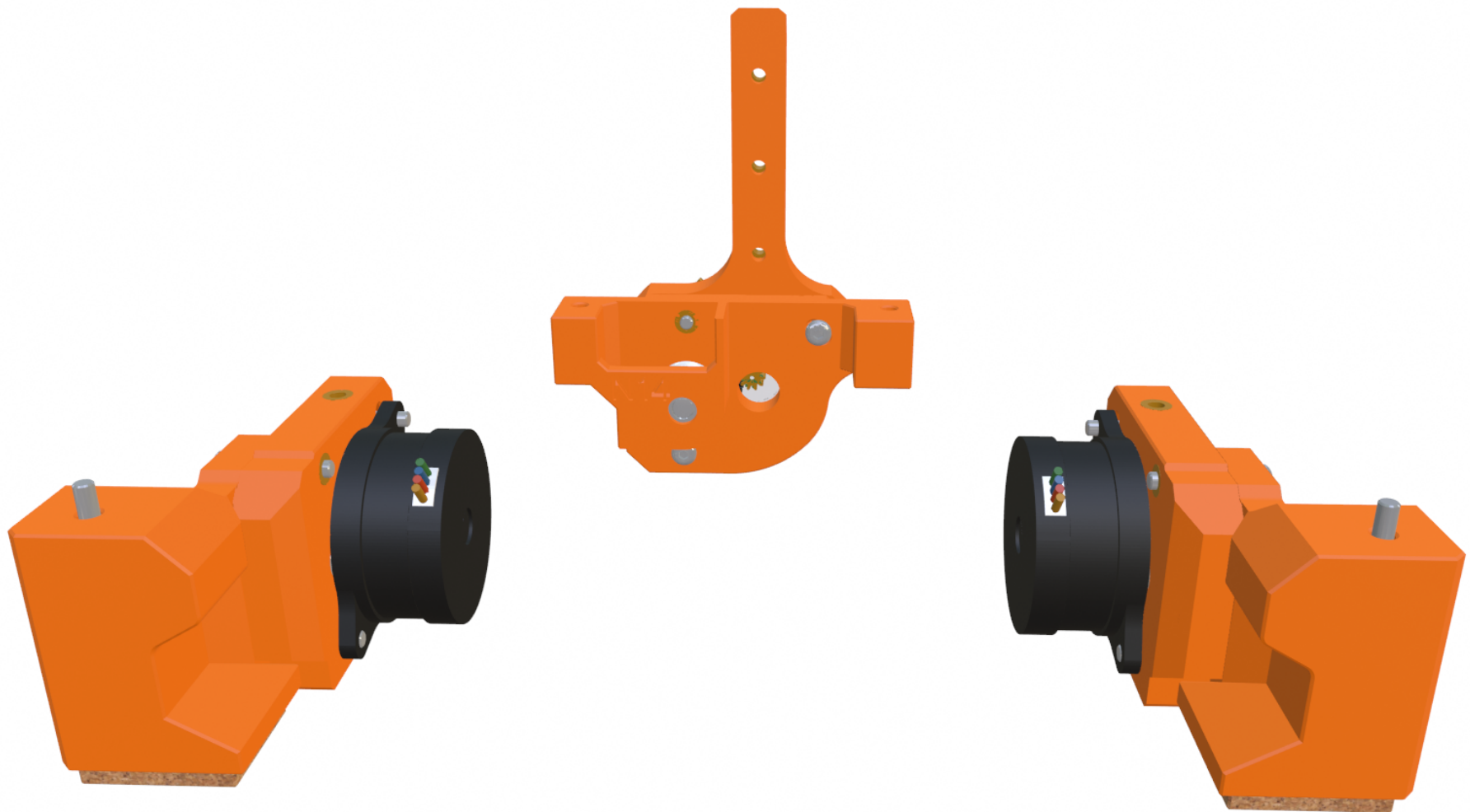


Find .stl in Tools folder. Print in ABS or ASA with standard Voron/Vorpel settings.  
Hex-bit should be a very tight fit.

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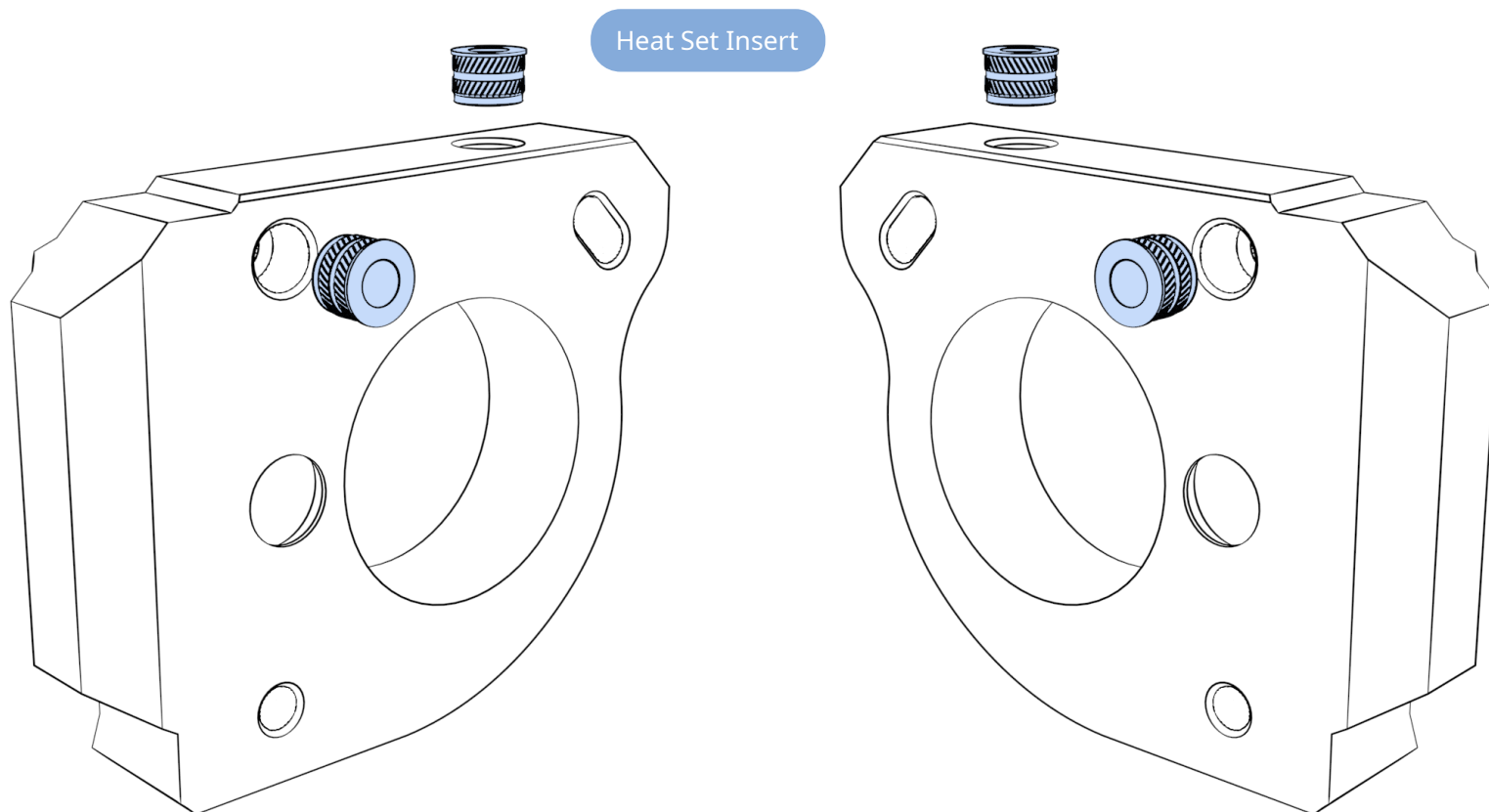
## Z DRIVES ASSEMBLY

NEMA 14 OPTION



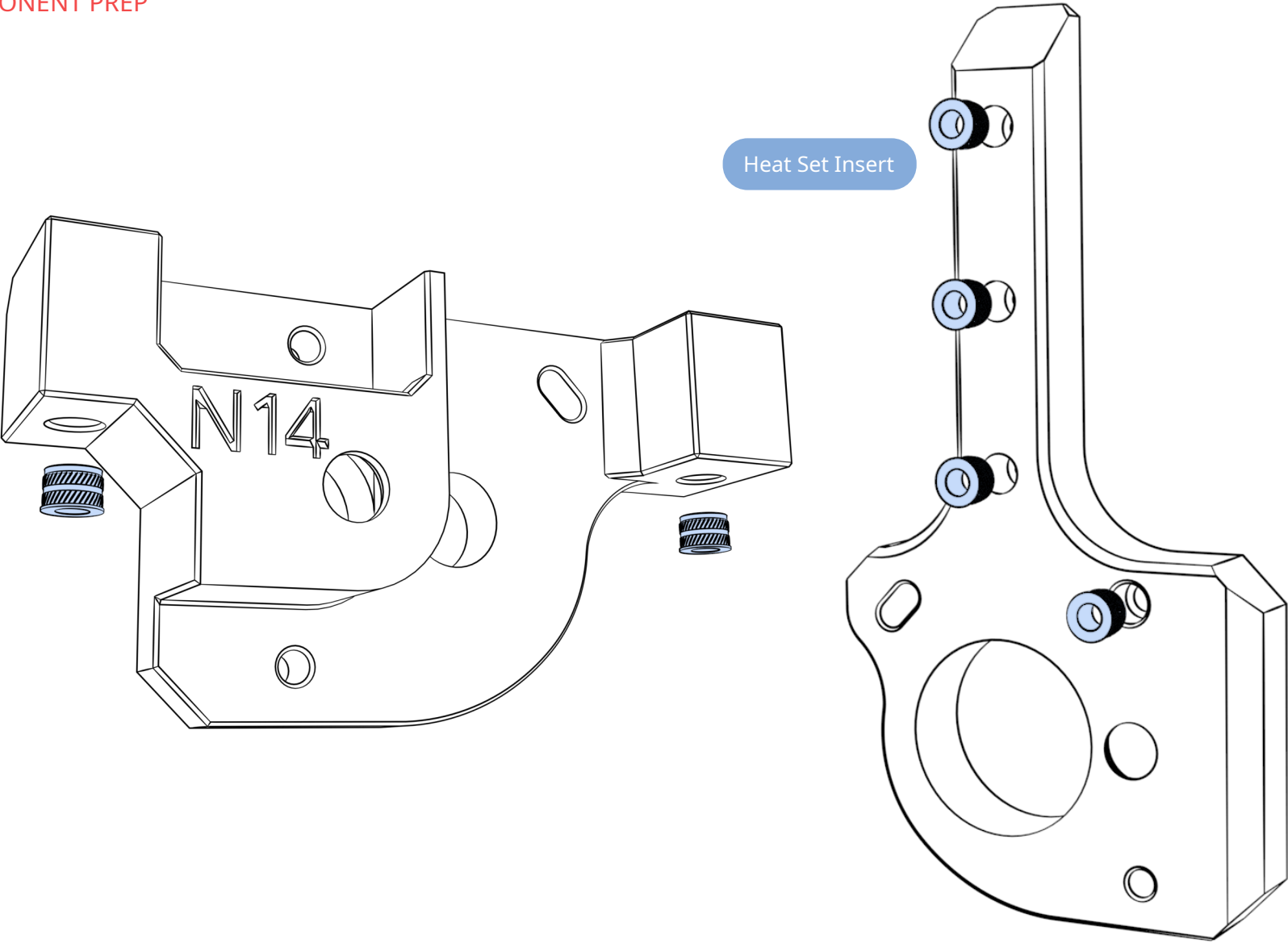


## COMPONENT PREP



[a]\_Motor\_mount\_front\_left\_Nema14.stl  
[a]\_Motor\_mount\_front\_right\_Nema14.stl

COMPONENT PREP



[a]\_Z\_axis\_drive\_rear\_Nema14.stl  
[a]\_Motor\_mount\_rear\_Nema14.stl