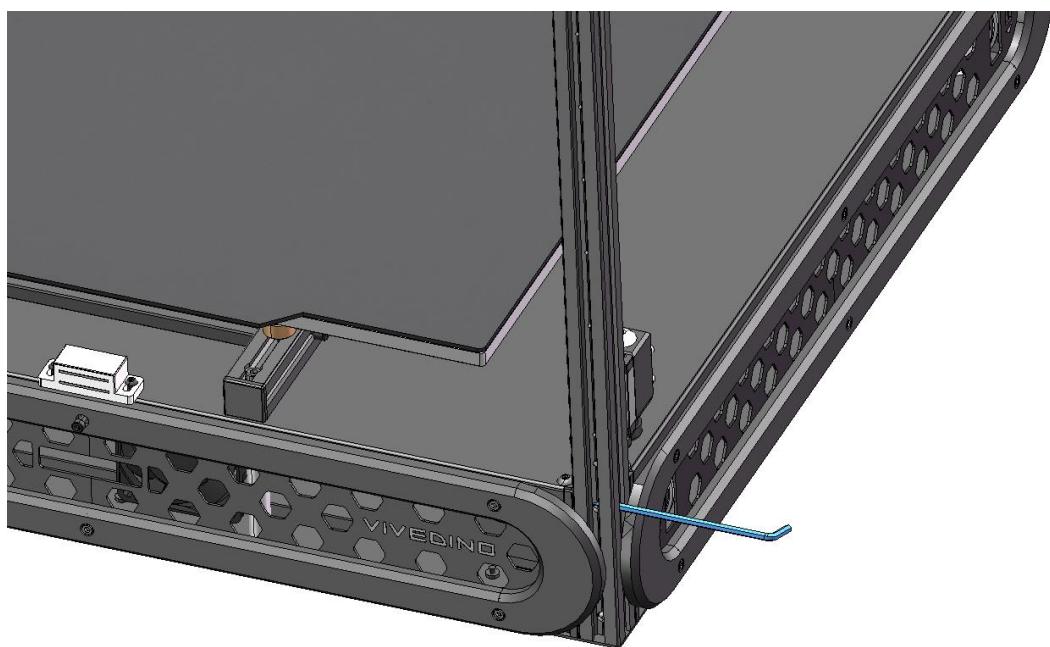


Assembly Manual

Turn the screw out 2.5mm.



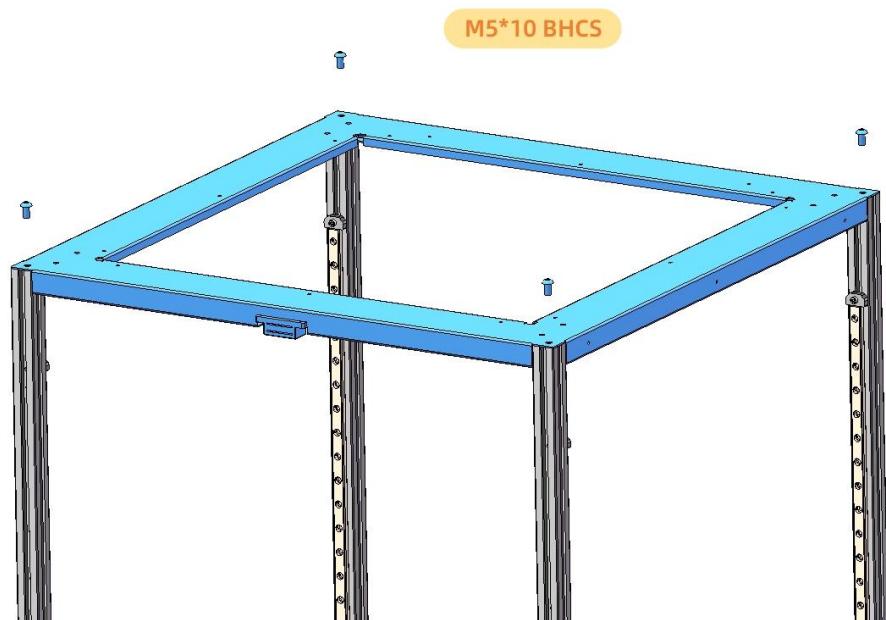
Mount the Z axis module.



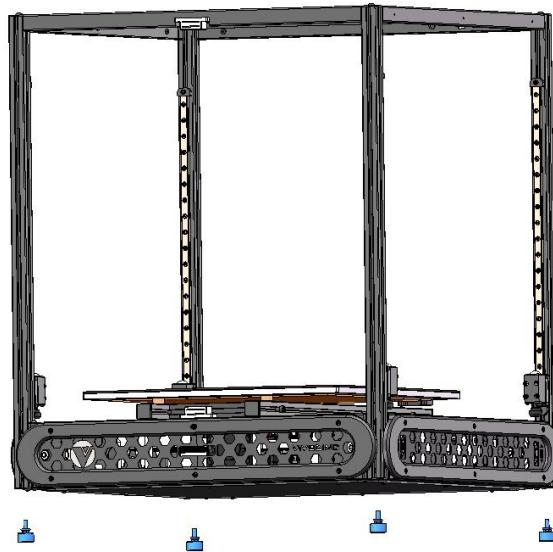
Tighten all four Z axis modules.



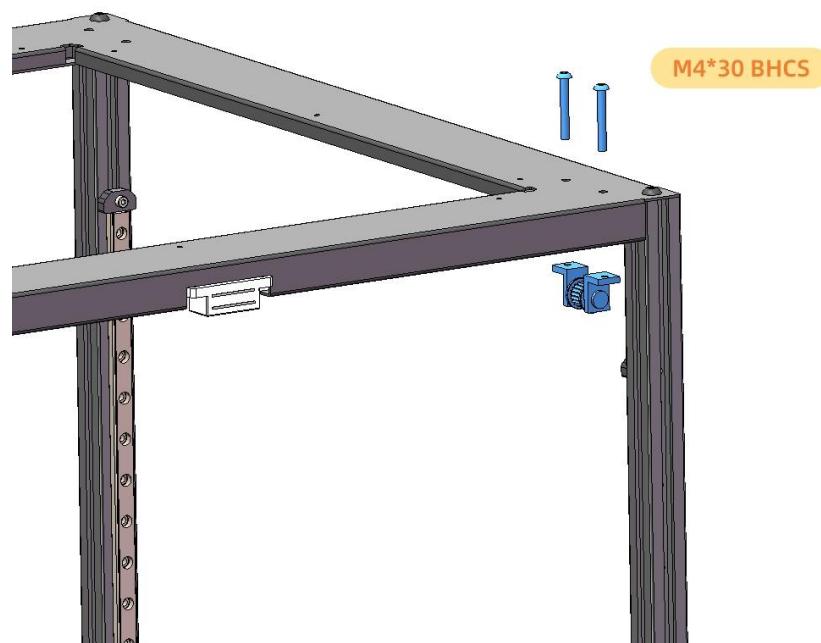
Mount the top sheet metal plate.



Mount the foot pads.



Mount the idle pulley.



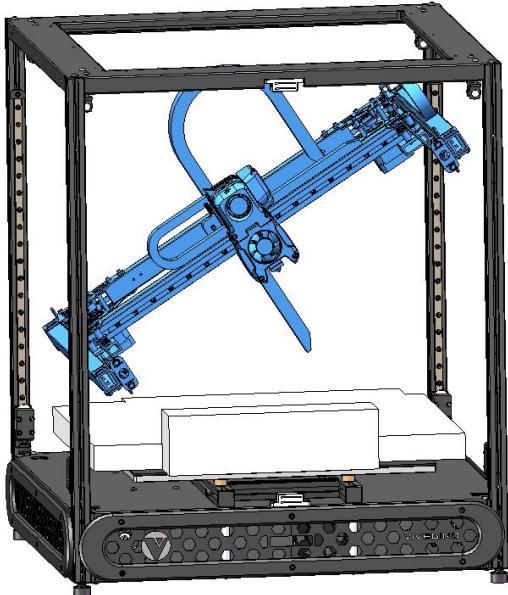
Mount all four idle pulleys.



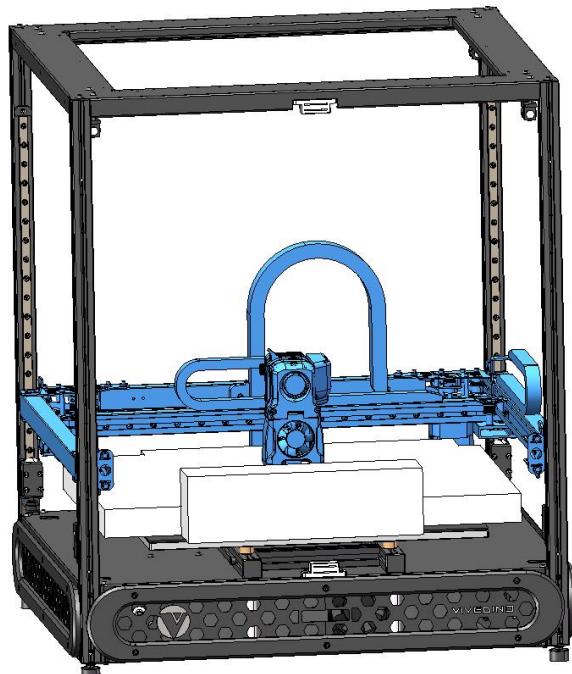
Put a foam on print plate.



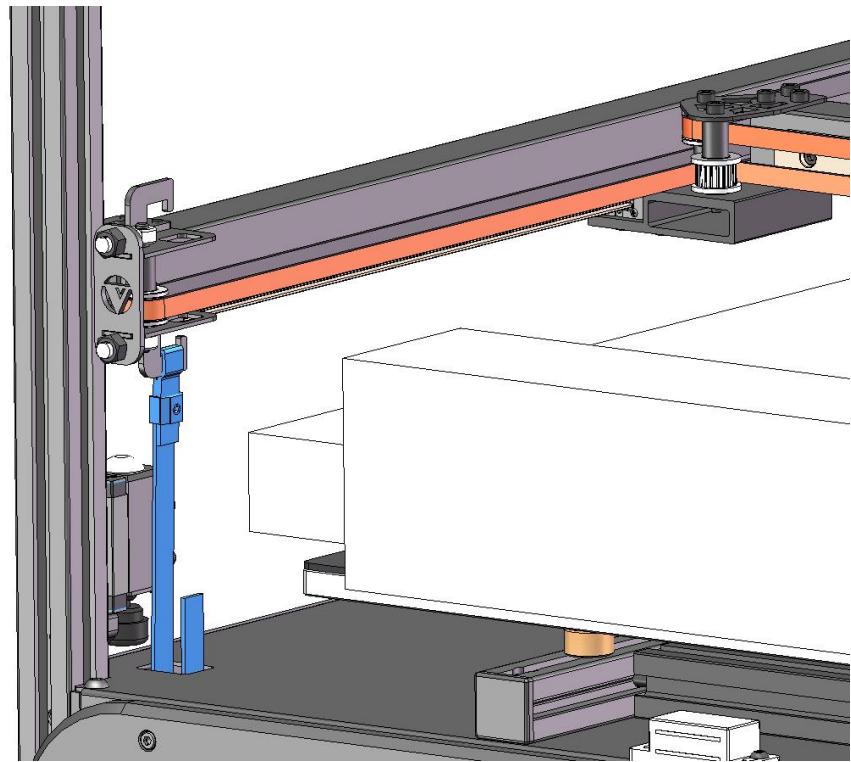
Tilt the gantry into the machine.



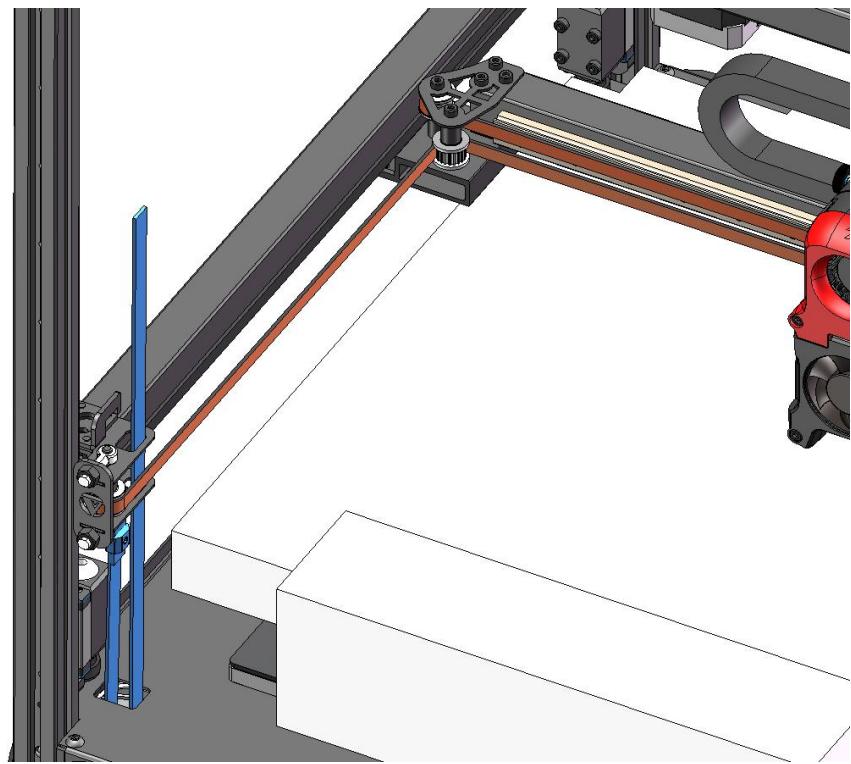
Place the gantry on foam.



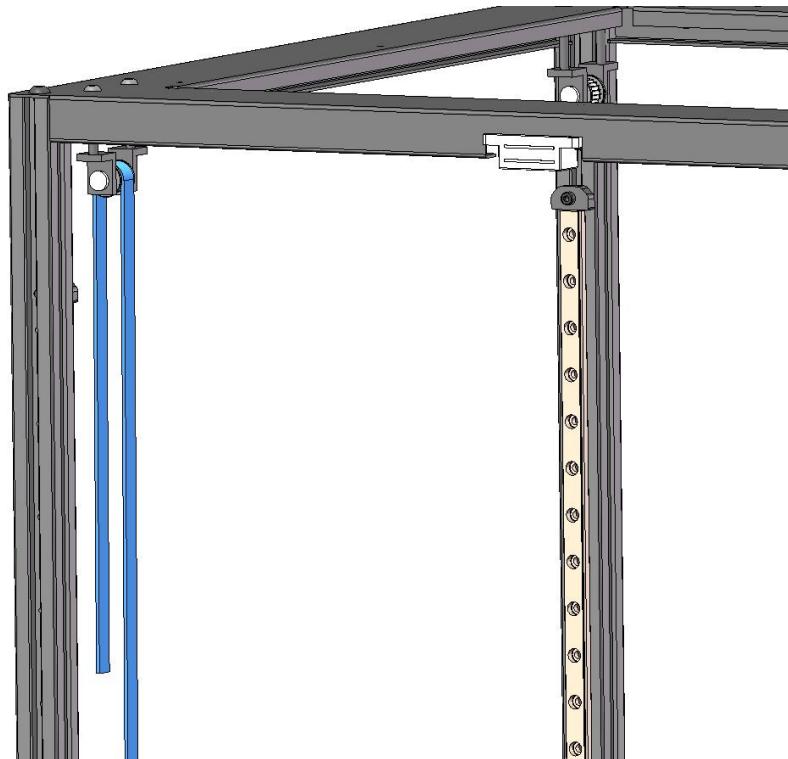
Install Z axis belt to the hook below.



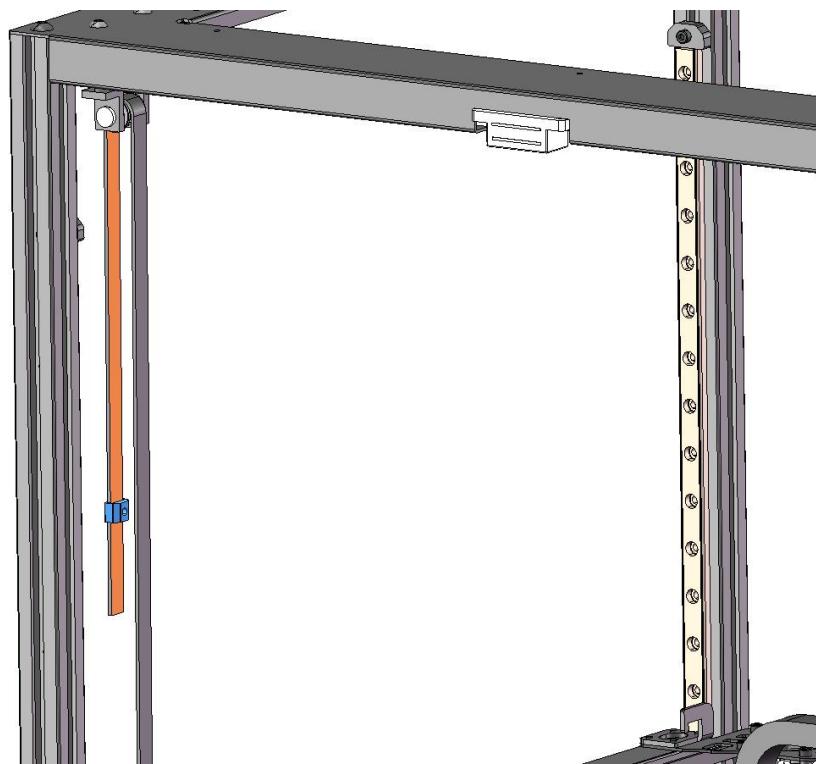
Pass the other end of belt through the sheet metals.



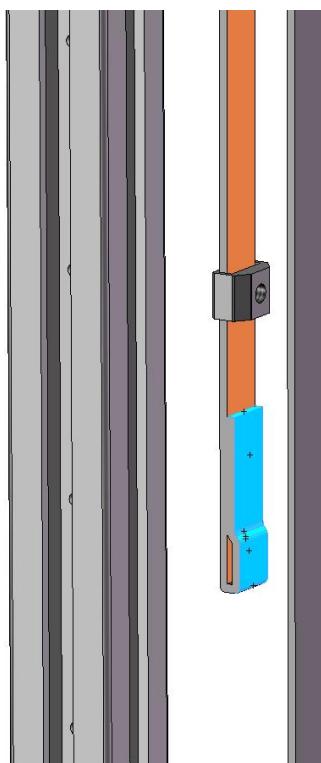
Pass belt through the top idle pulley.



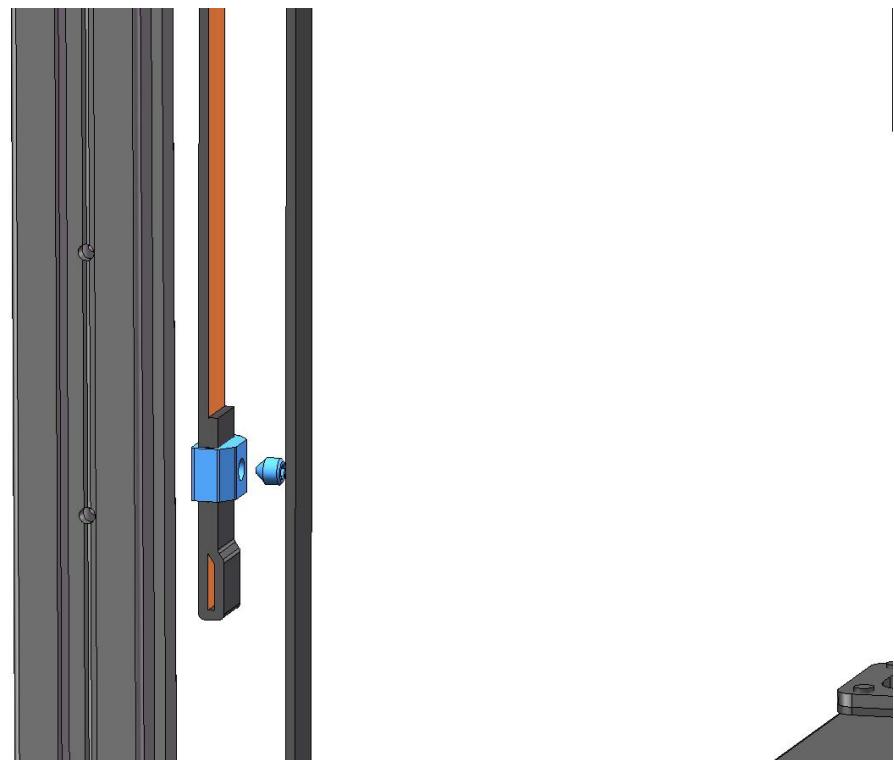
Slip a buckle into the belt.



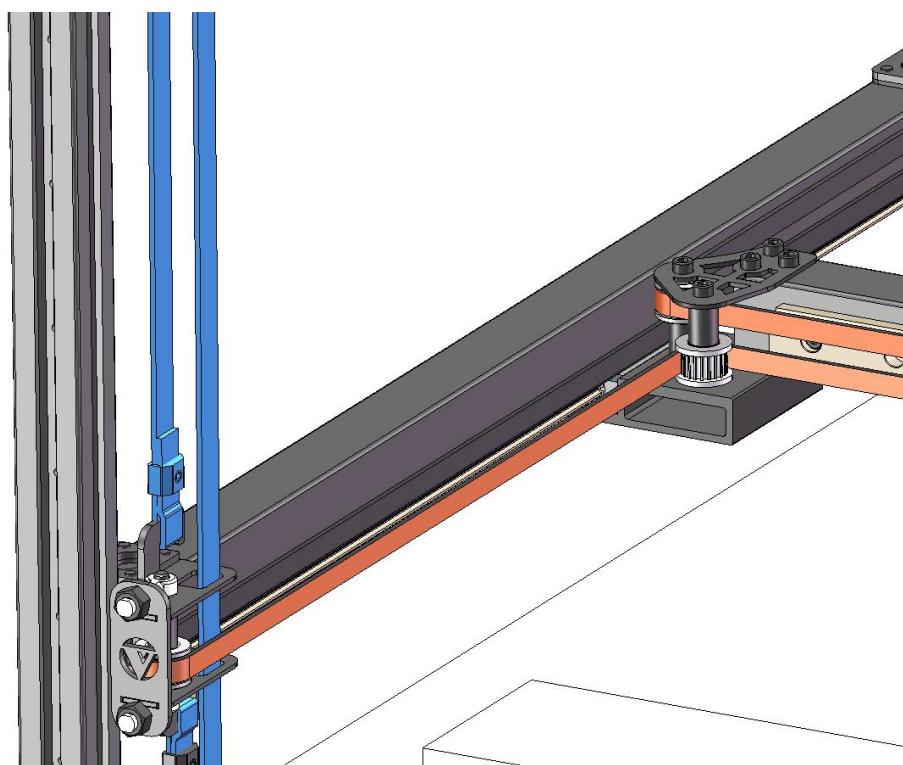
Fold the belt as shown.



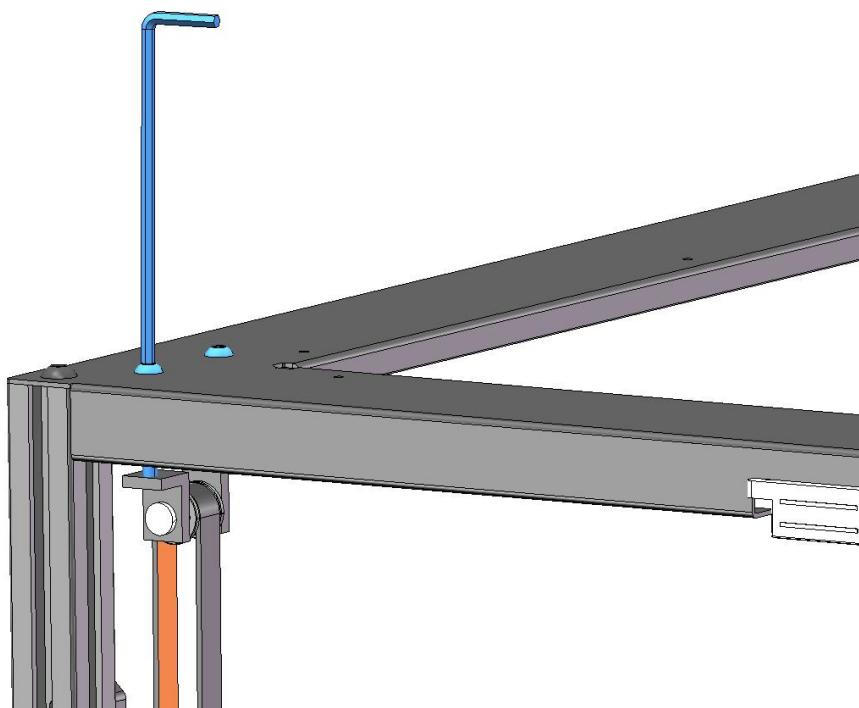
Slip the buckle onto belt and tighten it with a M3 lock screw.



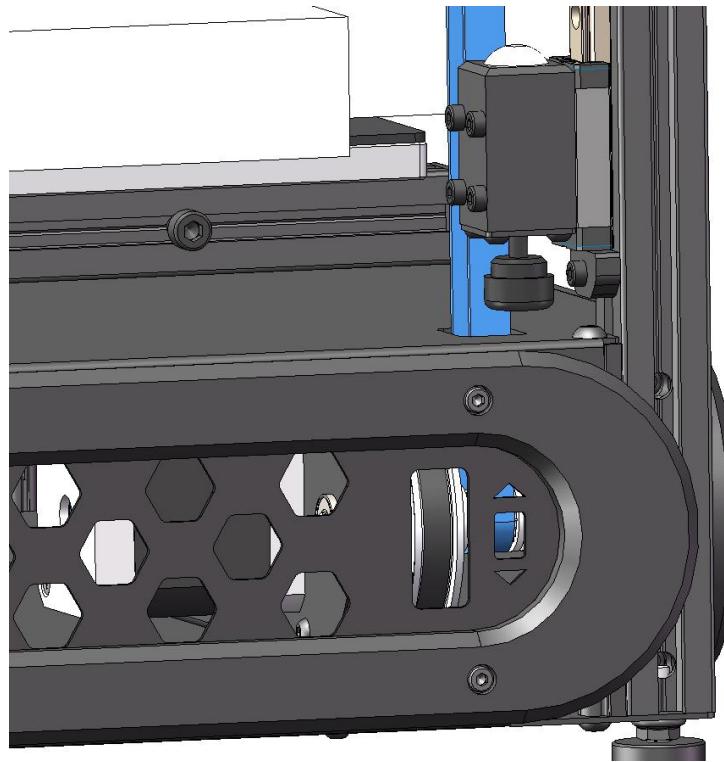
Install the belt to the hook below.



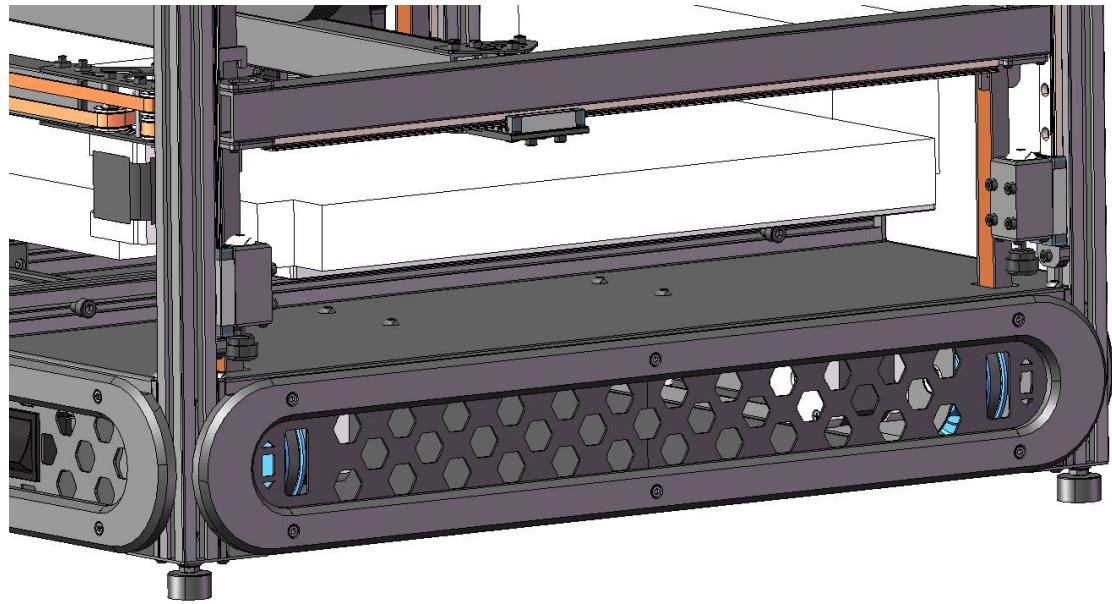
Pull the belt tight through the screws on the top.



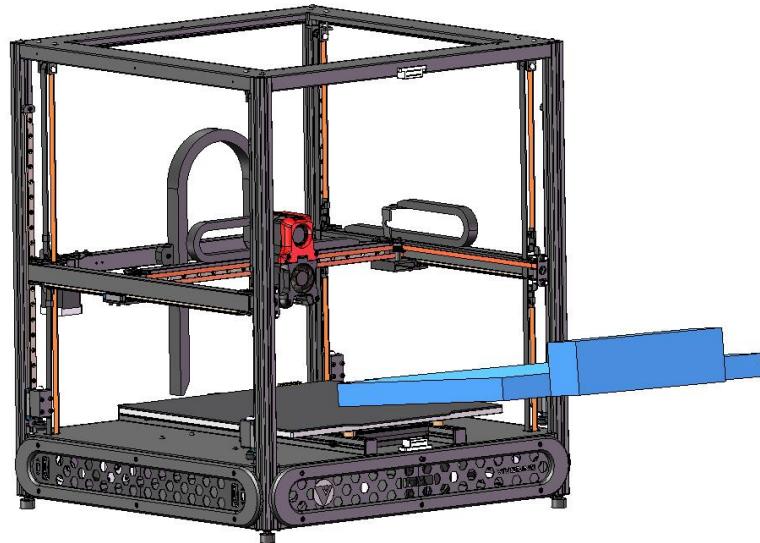
Note: viewing from the side bottom, the belt needs to be in the tooth groove of pulley.



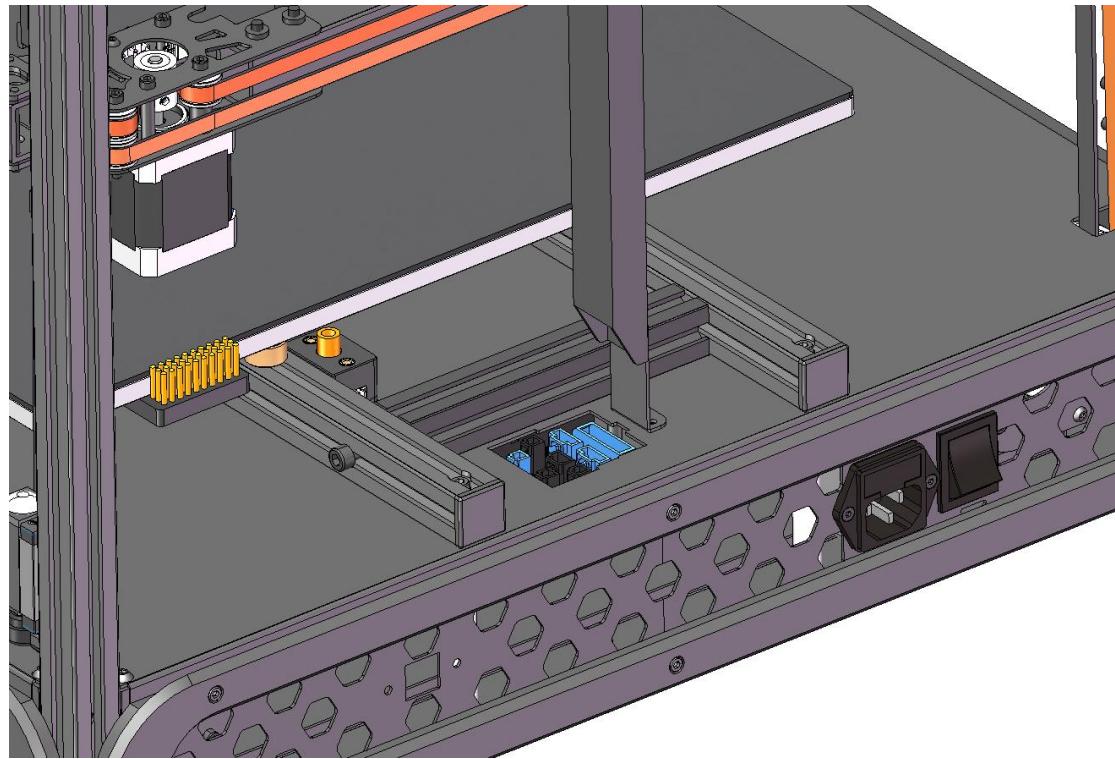
Turn four 80T pulleys by hand from the side to raise the gantry to a certain height.



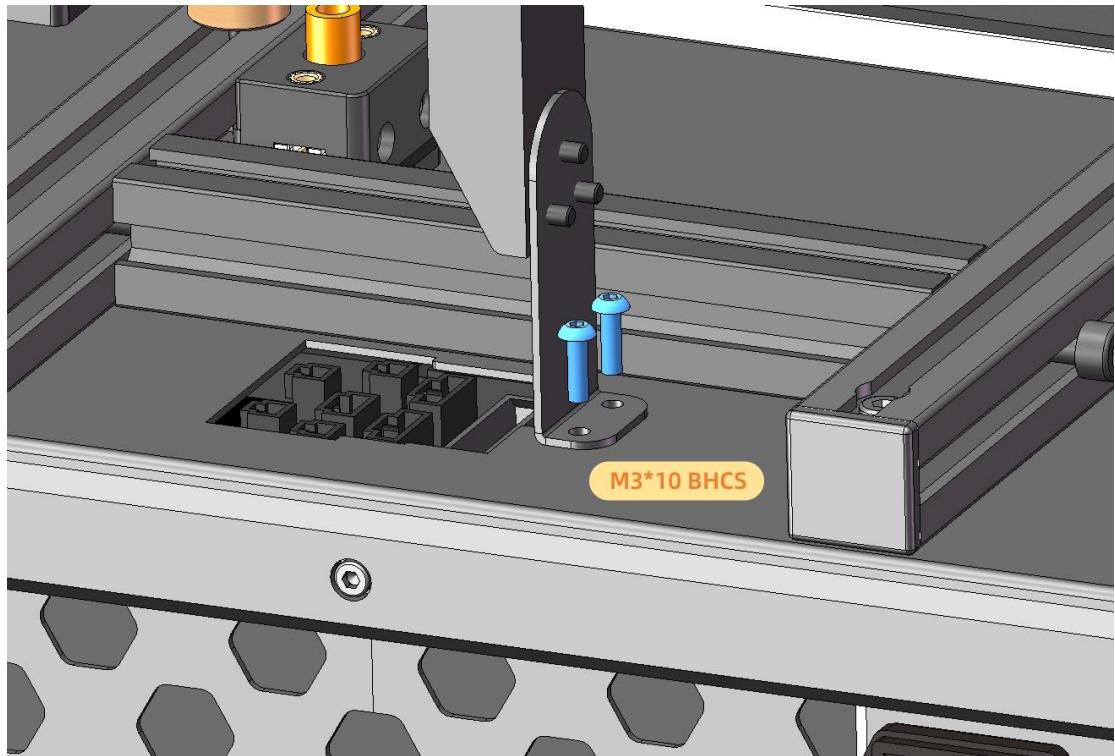
Remove the foam.



Plug the cables of drag chain into below socket according to label aside.



Fix the sheet metal for Z axis drag chain.

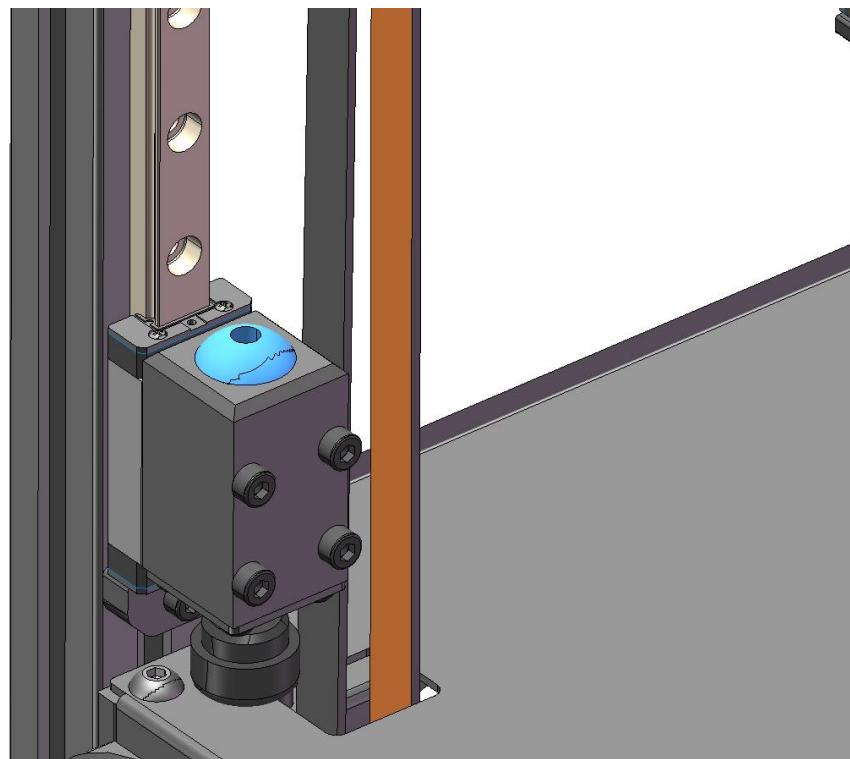


Rotate 80T pulleys to make four corners of gantry be in same height.

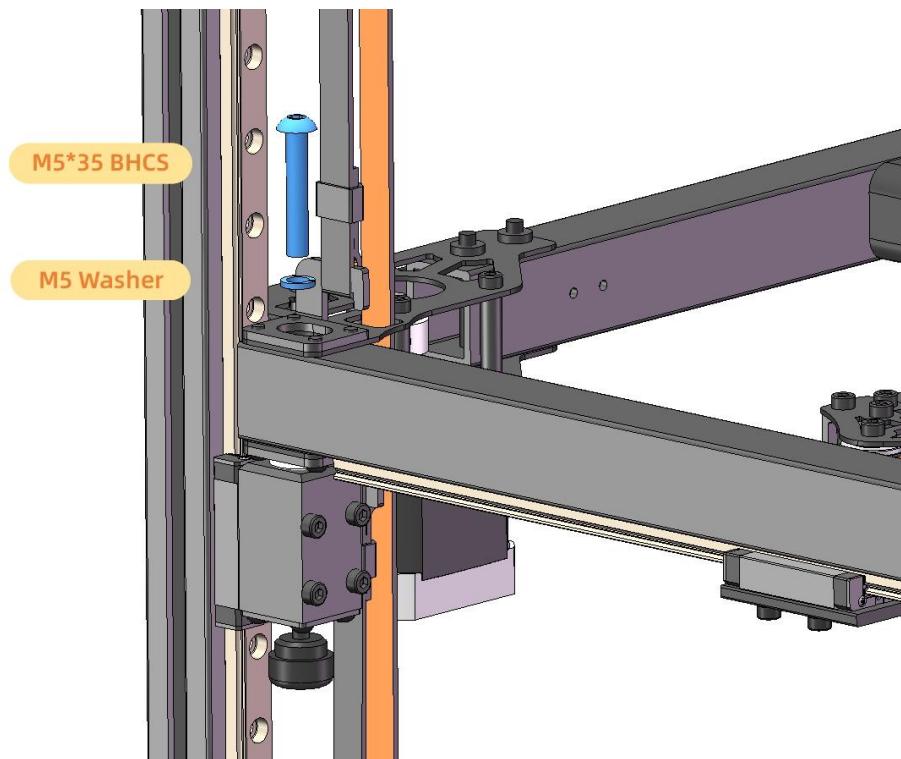
(Note: the height error between four corners should not exceed 1mm, please measure height by ruler)



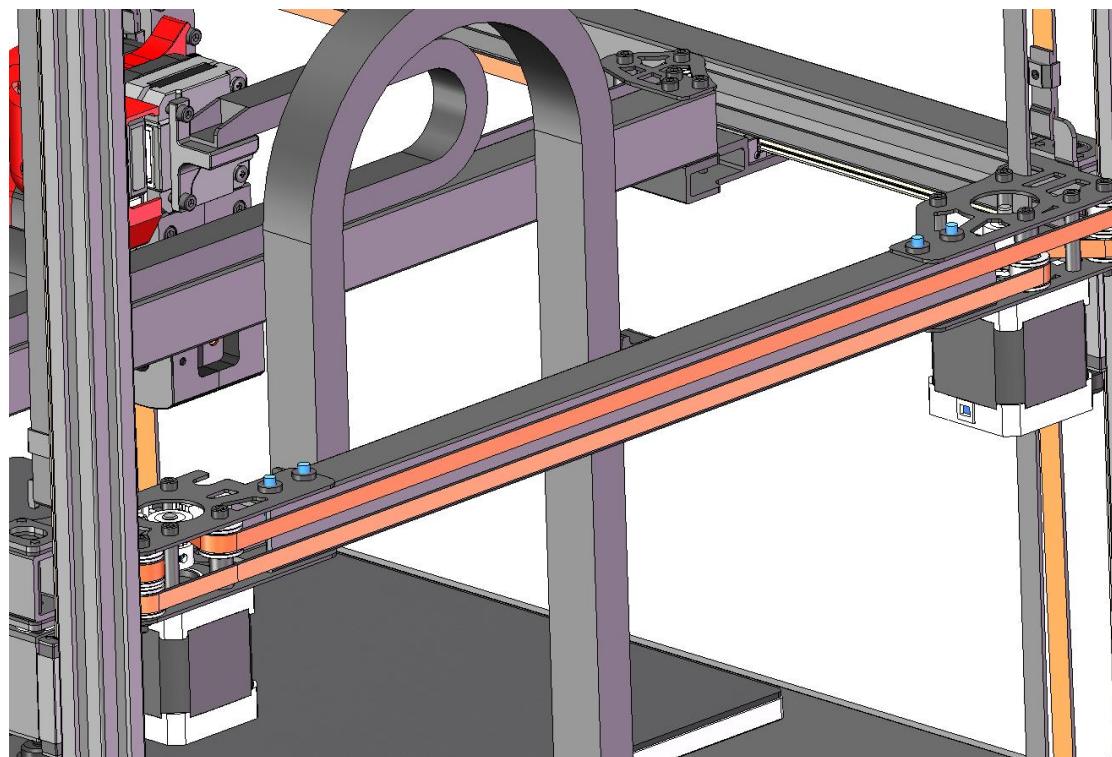
Slide the screw holes of four movable hinges to the center.



Insert M5 screw and elastic gasket, the screw should be aligned with the threaded hole of movable hinge. Rotate the screw a little to prevent the movable hinge from falling off, but don't tighten the screw completely in this step. Install all four movable hinges in the same way.



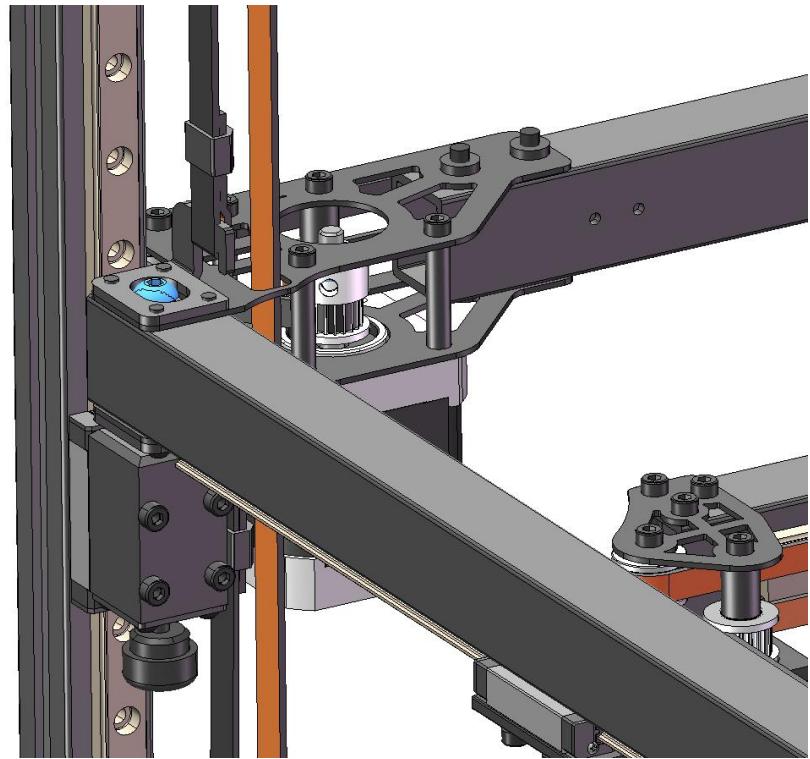
If it's difficult to align the screws with the threaded holes on movable hinges, please loosen four M4 screws at the back of gantry for adjustment. Tighten back these M4 screws until all four holes are aligned.



Tighten the 4 thumb screws counterclockwise to secure the movable hinges.



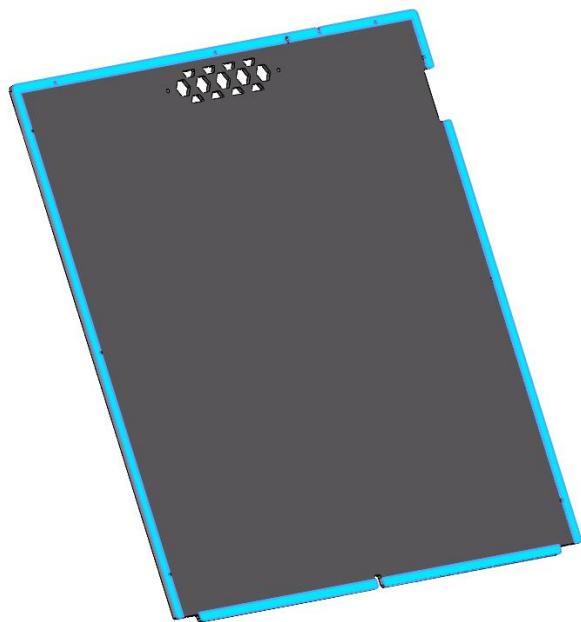
Tighten the four M5 screws diagonally by hex wrench.



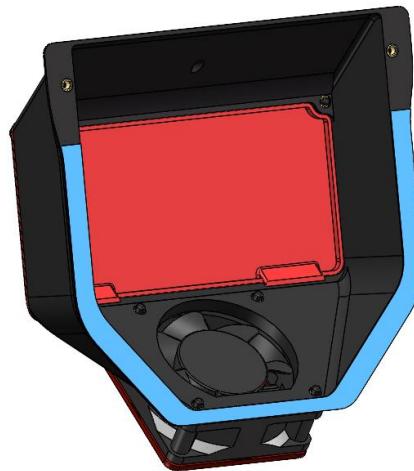
Turn the thumb screws clockwise to release the movable hinges. If the movable hinges are not released, the leveling effect of the gantry will be affected.



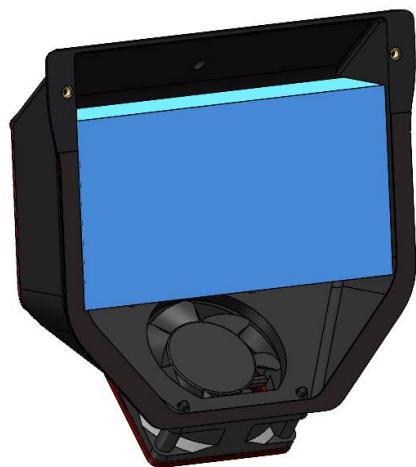
Glue 1mm foam tape onto the inner side of the black backboard as shown.



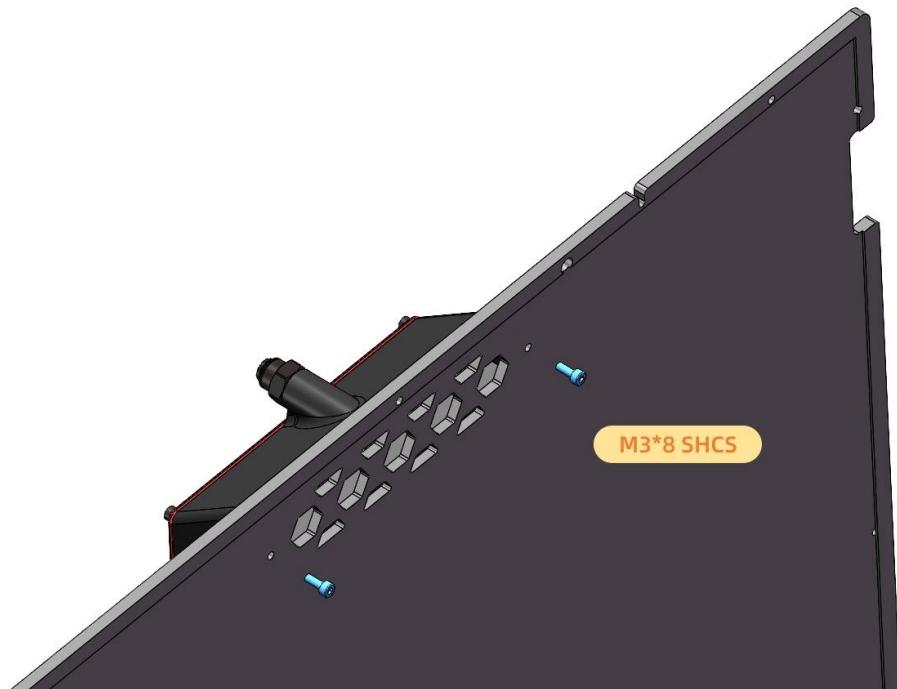
Glue VHB tape to the air filter as shown.



Put the activated carbon cotton into the air filter.



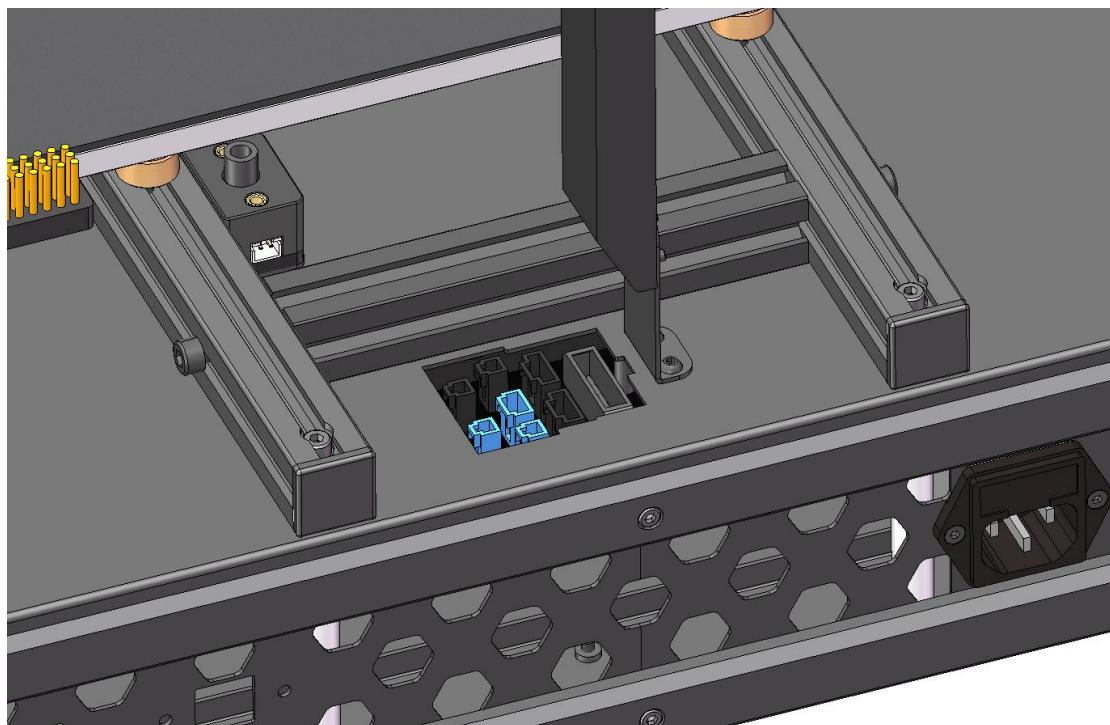
Attach air filter to the outside of the black backboard.



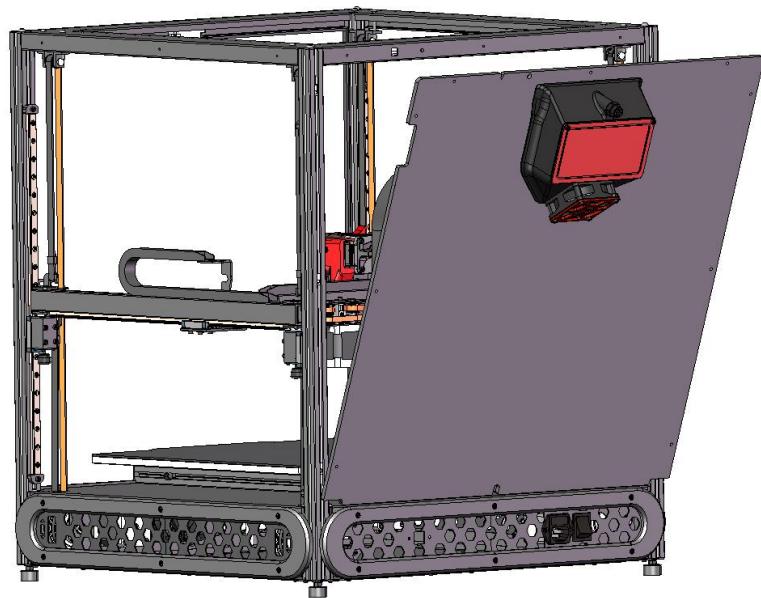
Put 6pcs M3 T-nuts in below positions.



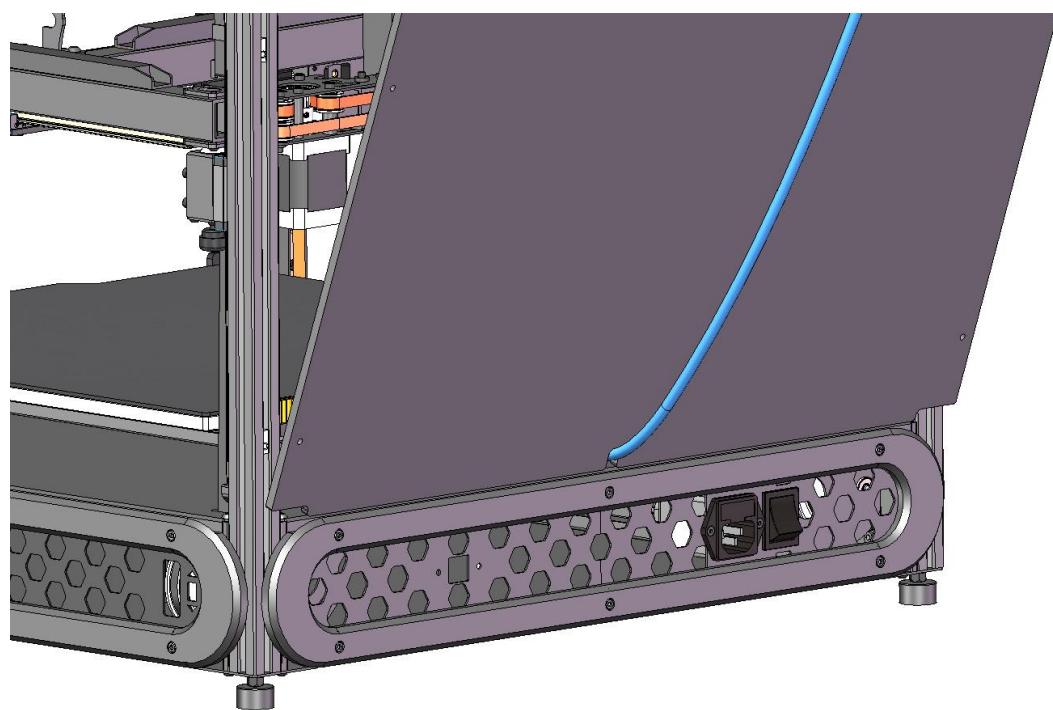
Plug the cables for air filter, LED light and filament runout sensor.



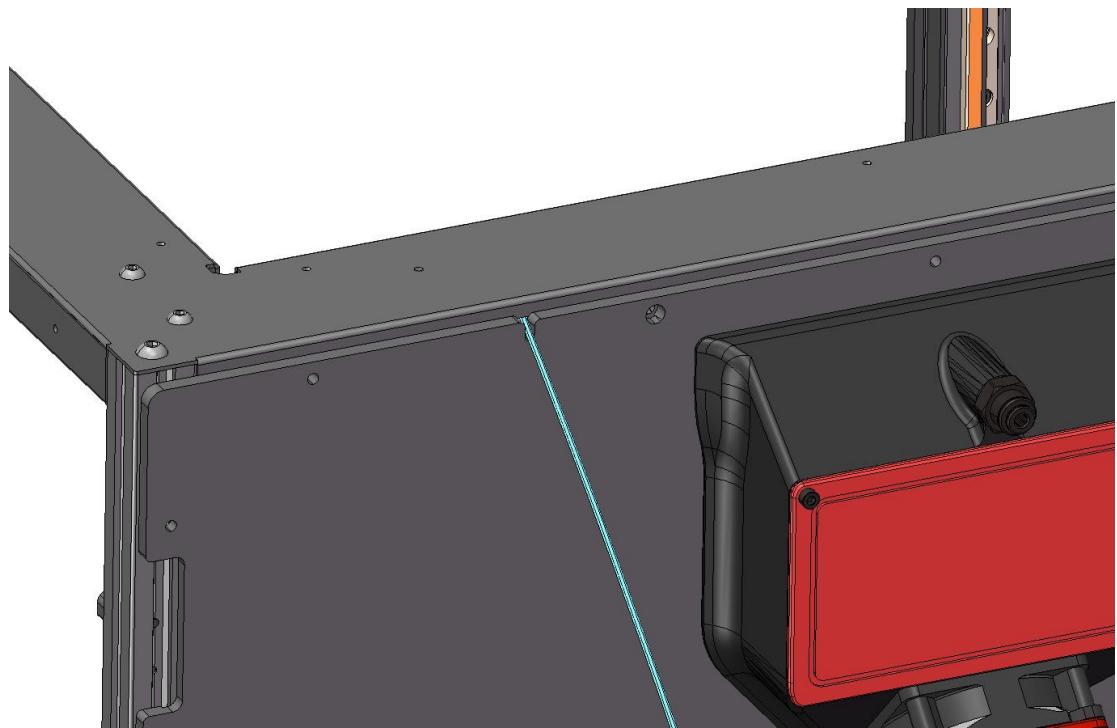
Place the backboard on the bottom frame.



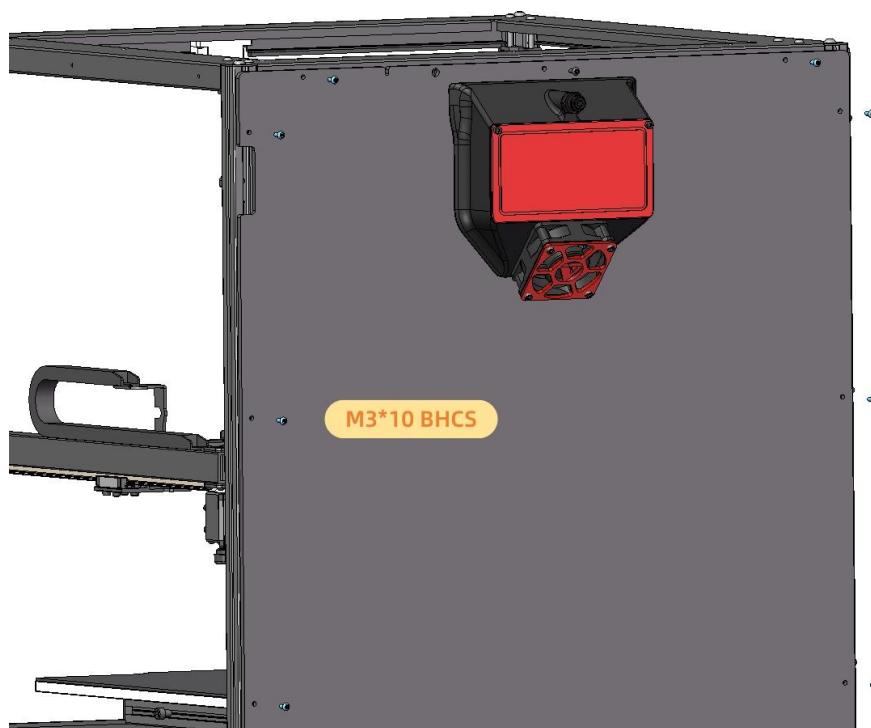
Pass three cables through the bottom slot of backboard.



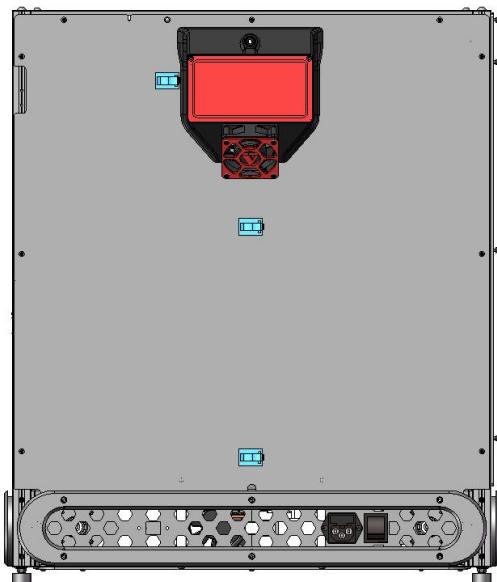
Close the backboard and pass the LED cable through the top slot.



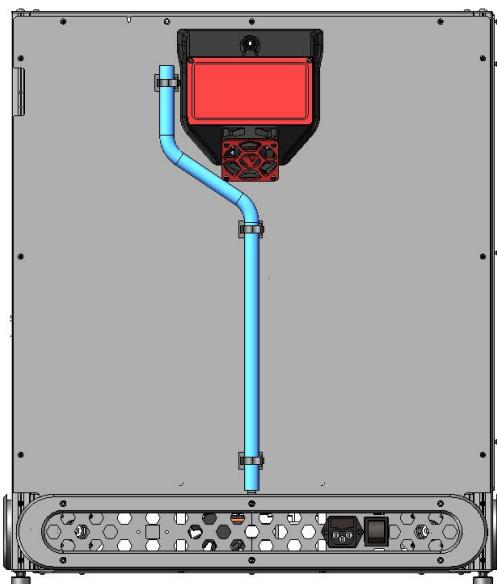
Fix the backboard with screws.



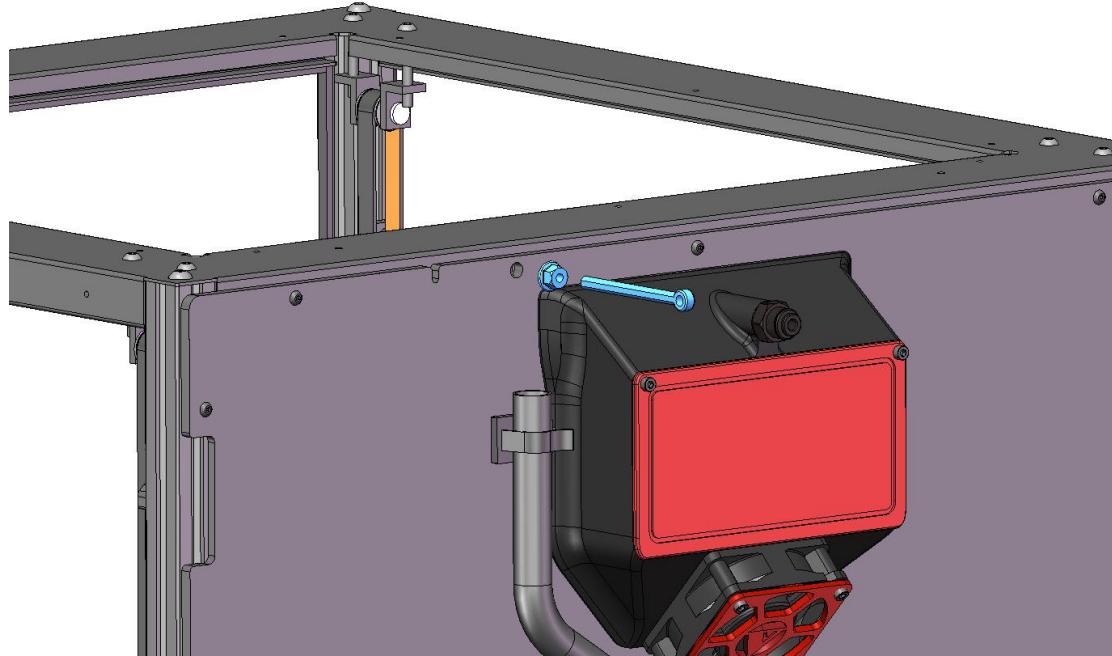
Stick the cable buckles to the positions as shown.



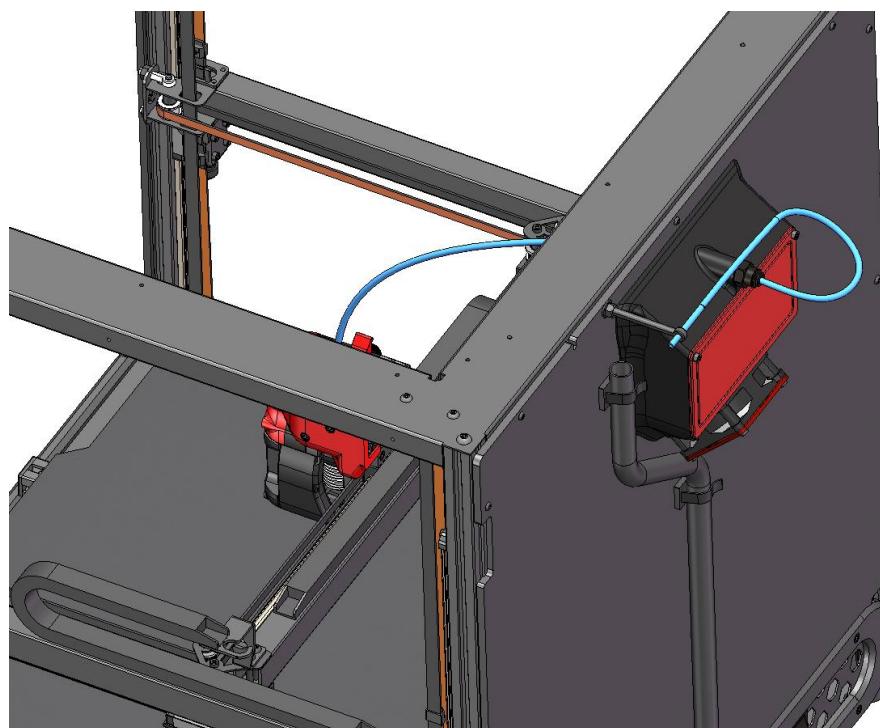
Put the cables into the sheath and fix the buckles.



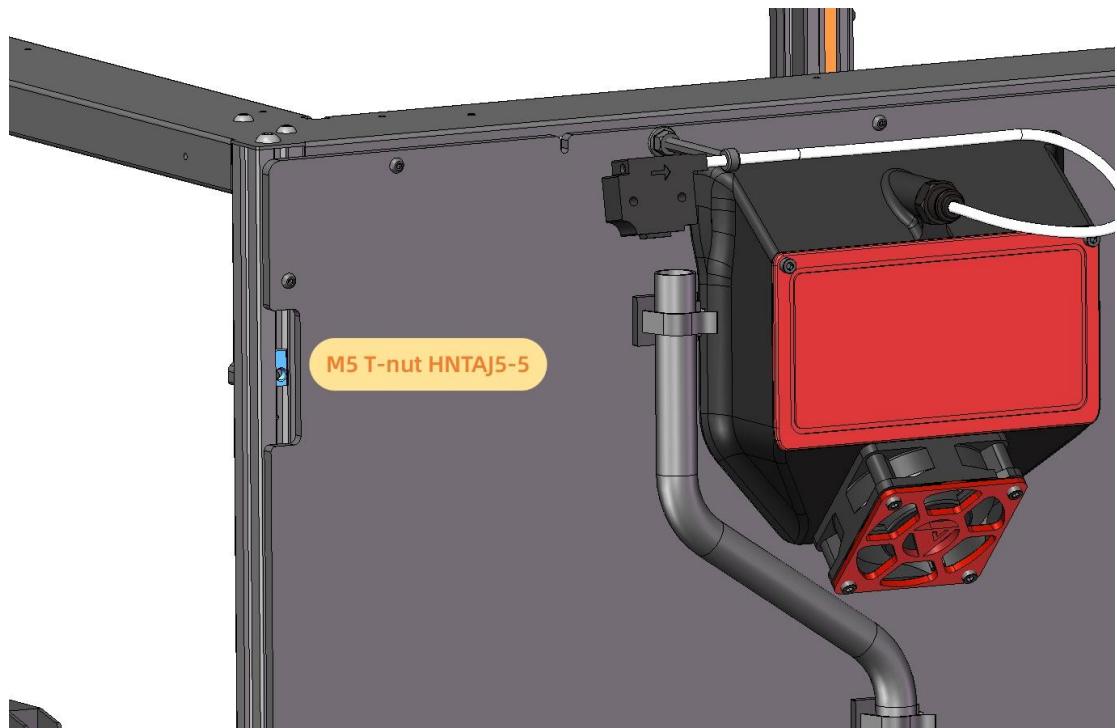
Install the screw bracket for PTFE tube.



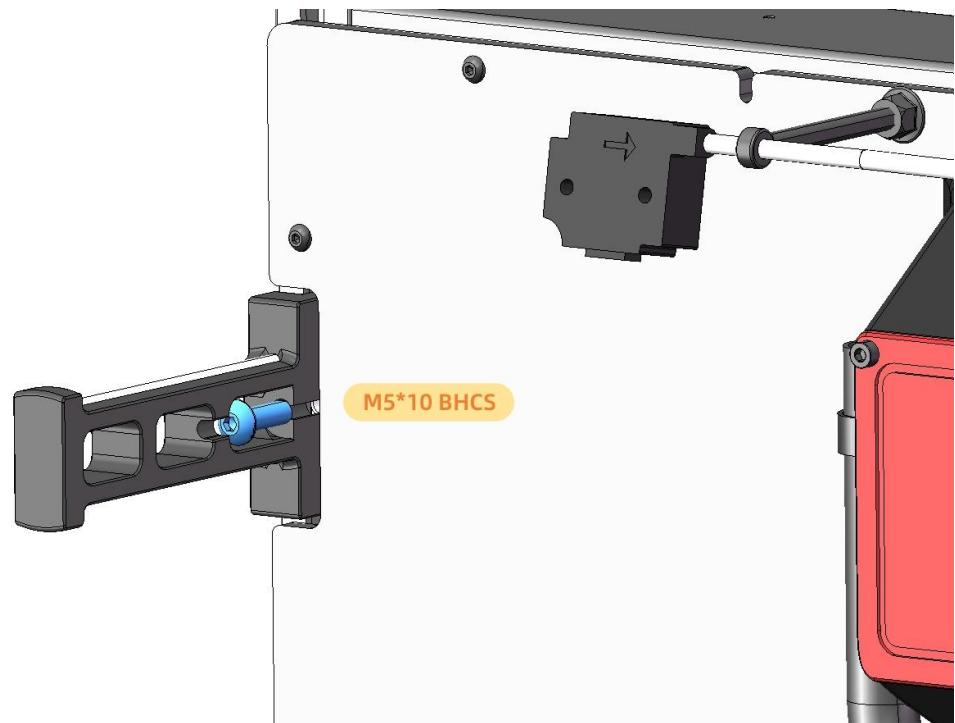
Move the extruder to the front left corner and install the PTFE tube.
(Note: please reserve enough length of PTFE tube inside chamber, or else, the extruder will be pulled up during print)



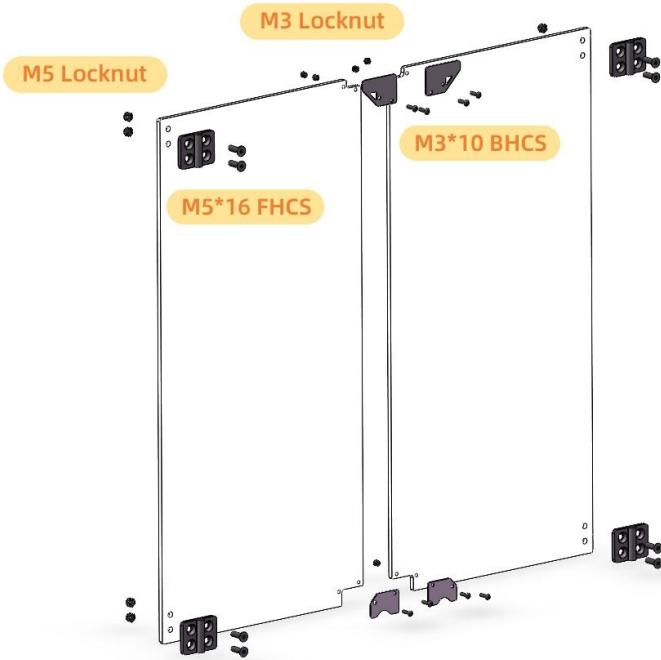
Put a M5 T-nut in below position.



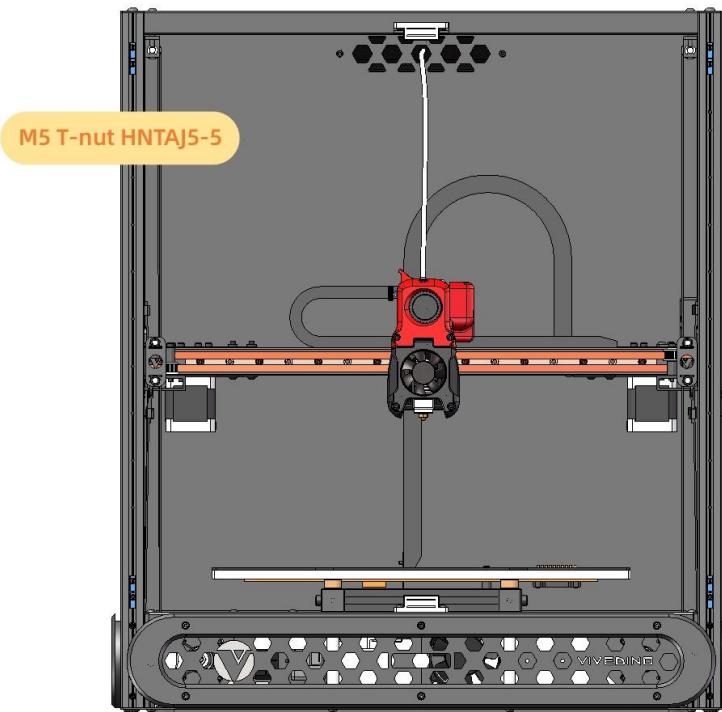
Install the filament spool holder.



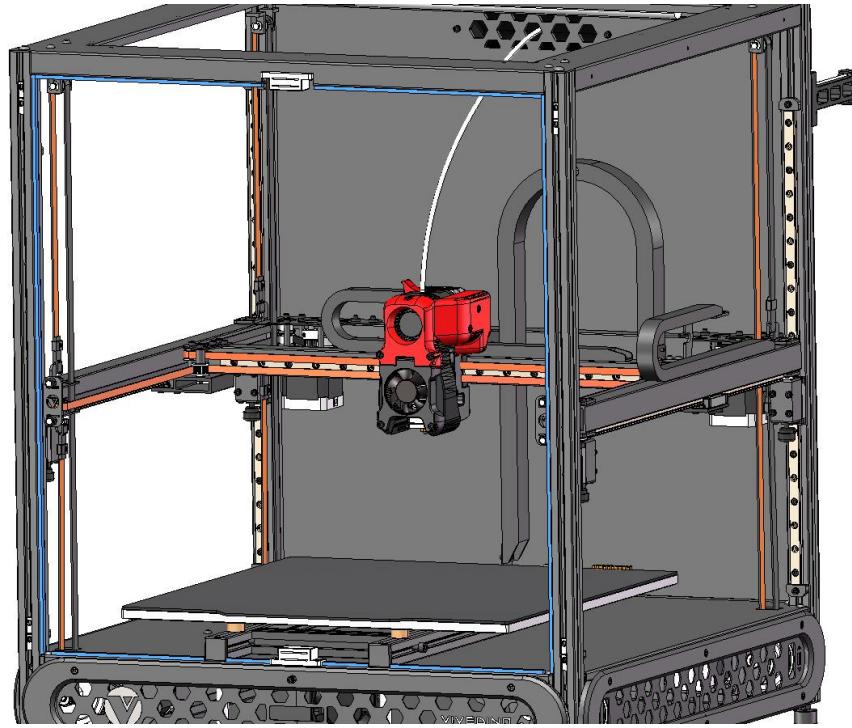
Install the front door as shown.



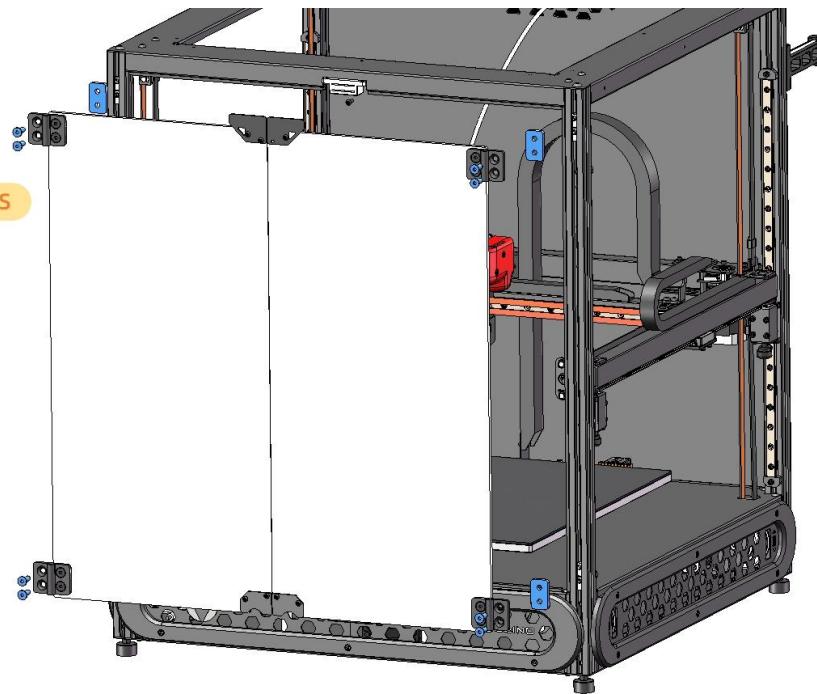
Put 8pcs M5 T-nuts in below positions.



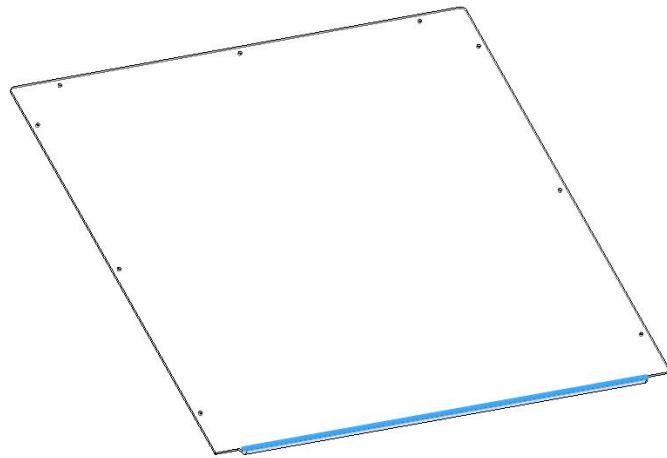
Glue 3mm foam tape to the frame for sealing as shown.



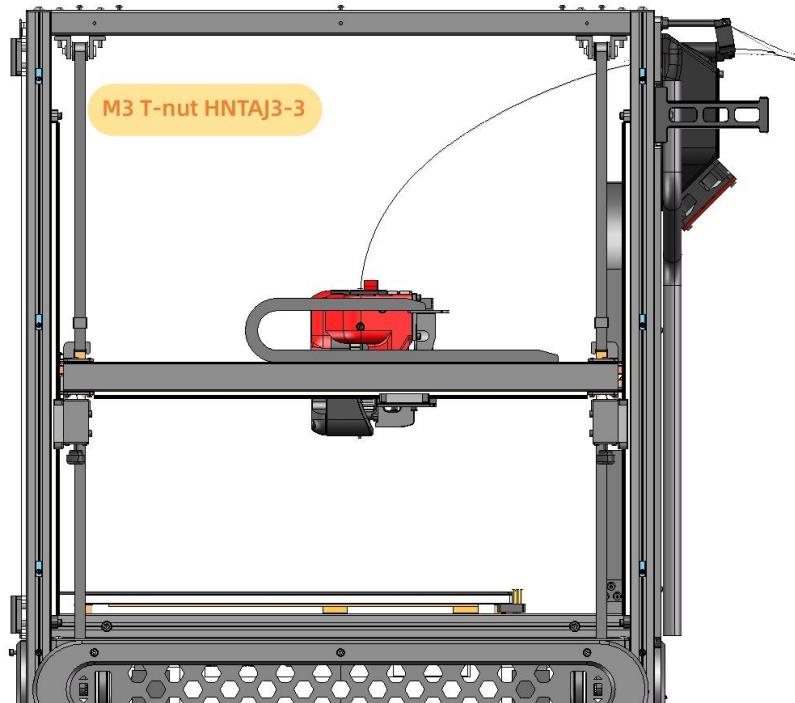
Attach the front door onto frame by screws.



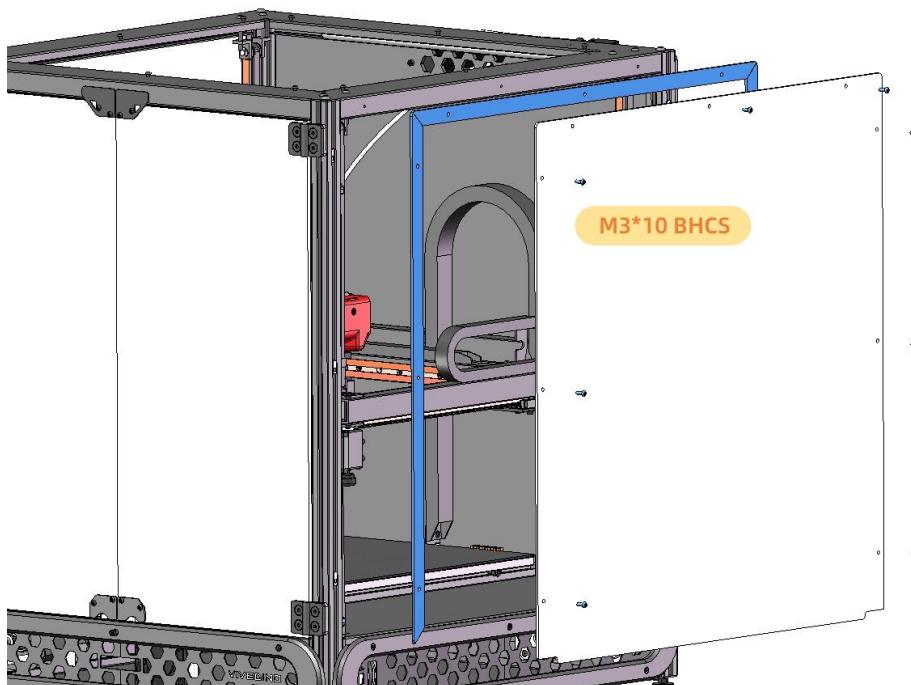
Glue 3mm foam tape on side panels as shown.



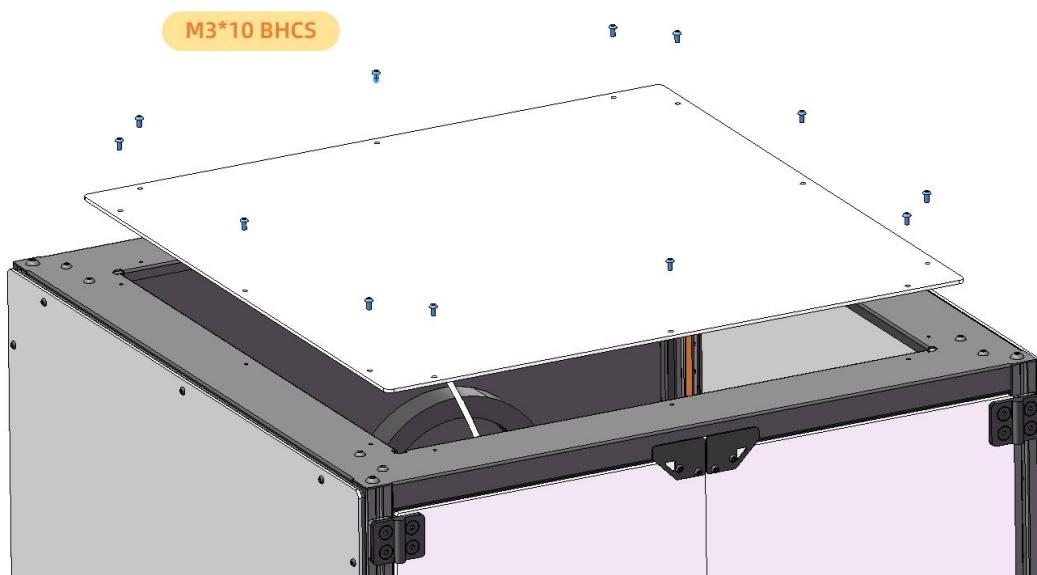
Put 6pcs M3 T-nuts in the side of frame.



Attach the side panel onto frame as shown.



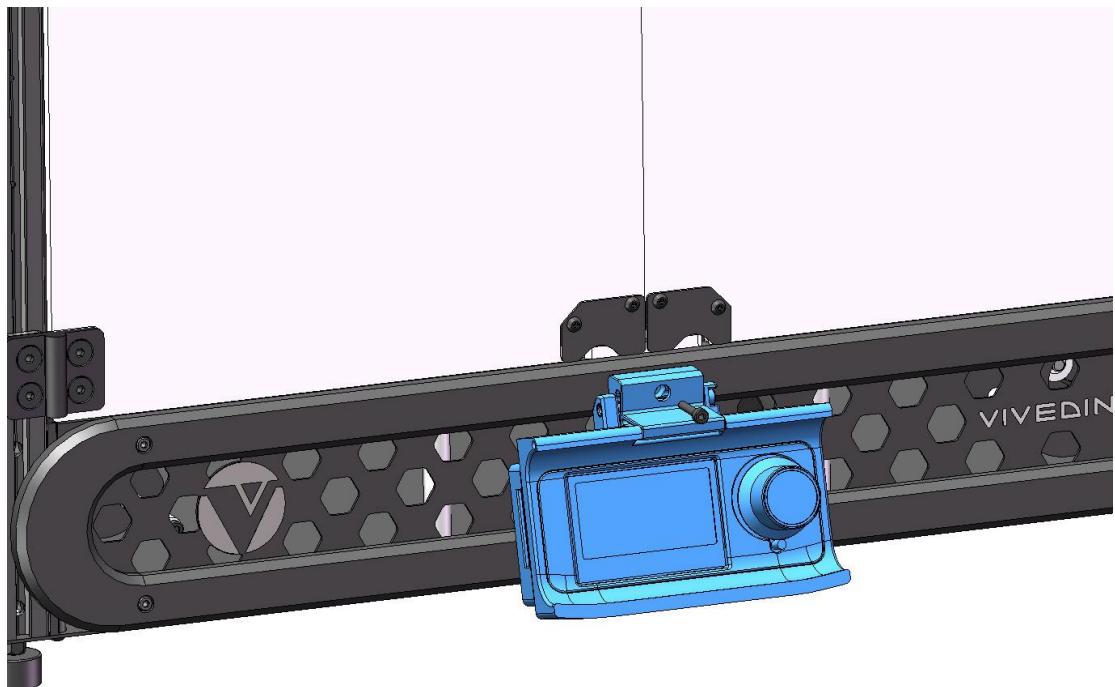
Install the top panel as shown.



Remove the screw in below position.



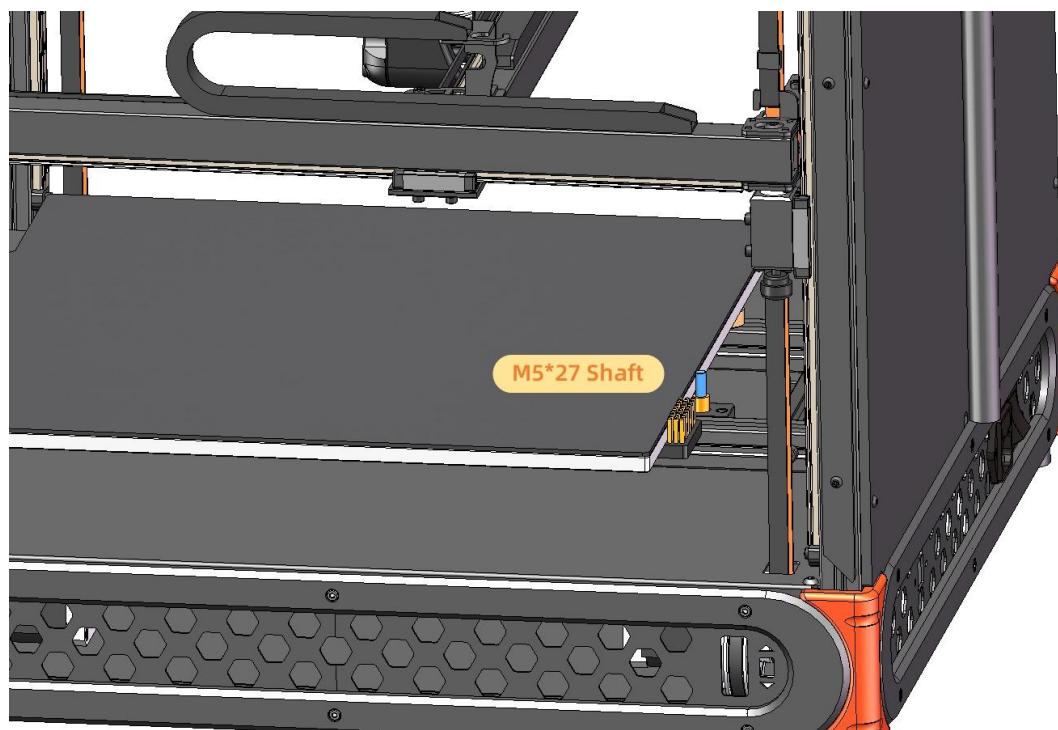
Connect two ribbon cables according to the label behind screen, then mount the screen by screw.



Install four corner guards.



Put the shaft into Z axis limit block.



Rotate four foot pads to level the machine and lock the pads by the nuts as shown.

