

ZONESTAR 3D PRINTER P802M

INSTALLATION GUIDE V.03

Classification Of Screws



M3 nuts 54pcs



M8 nuts 12pcs



M8 Cushion ring
12pcs



M3*20mm Round head
screws 58pcs



M3*10mm inner
hexagon screws 17pcs



M3*14mm Flat-head
screws 4pcs



M2.5*10mm black
screws 2pcs



M3*30mm Flat-head
screws 4pcs



Plastic Pillars 4pcs

Classification Of Screws



M3*25mm Round head
screws 7pcs



M4*15mm Round head
cross screws 12pcs



M4*8mm Round head
cross screws 12pcs

(Use for locking bearings on extruder)



Thumb nuts*4



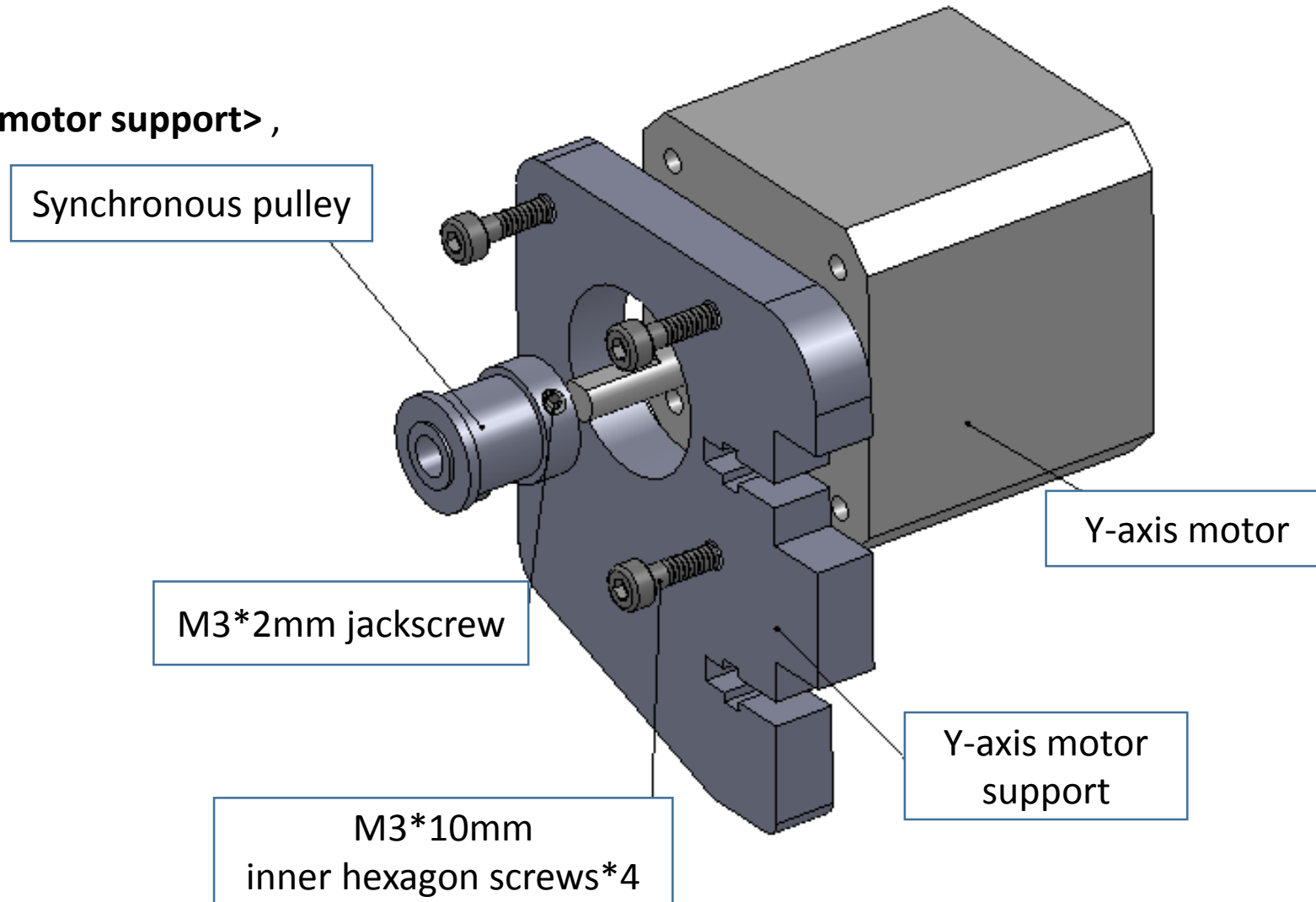
Compression springs*4



M3*22mm Round head
screws 4pcs

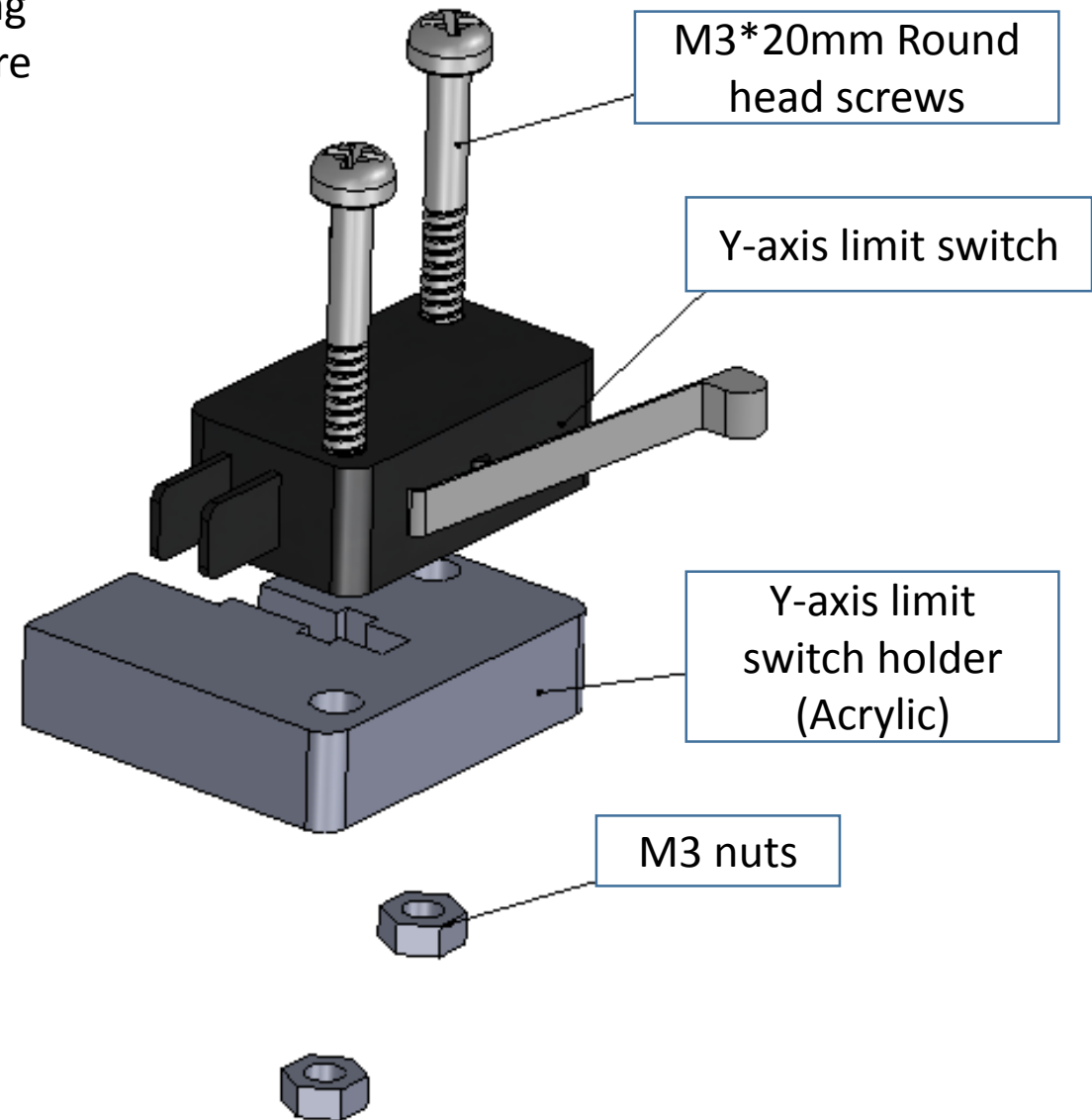
Step 1 Assemble Y-axis Motor

- ◆ Fit the **synchronous pulley** on the motor, Locking with **M3*2mm jackscrew**.
- ◆ As the picture, Put Y-axis motor on **<Y-axis motor support>** , locking with Four **M3*10mm screws**.



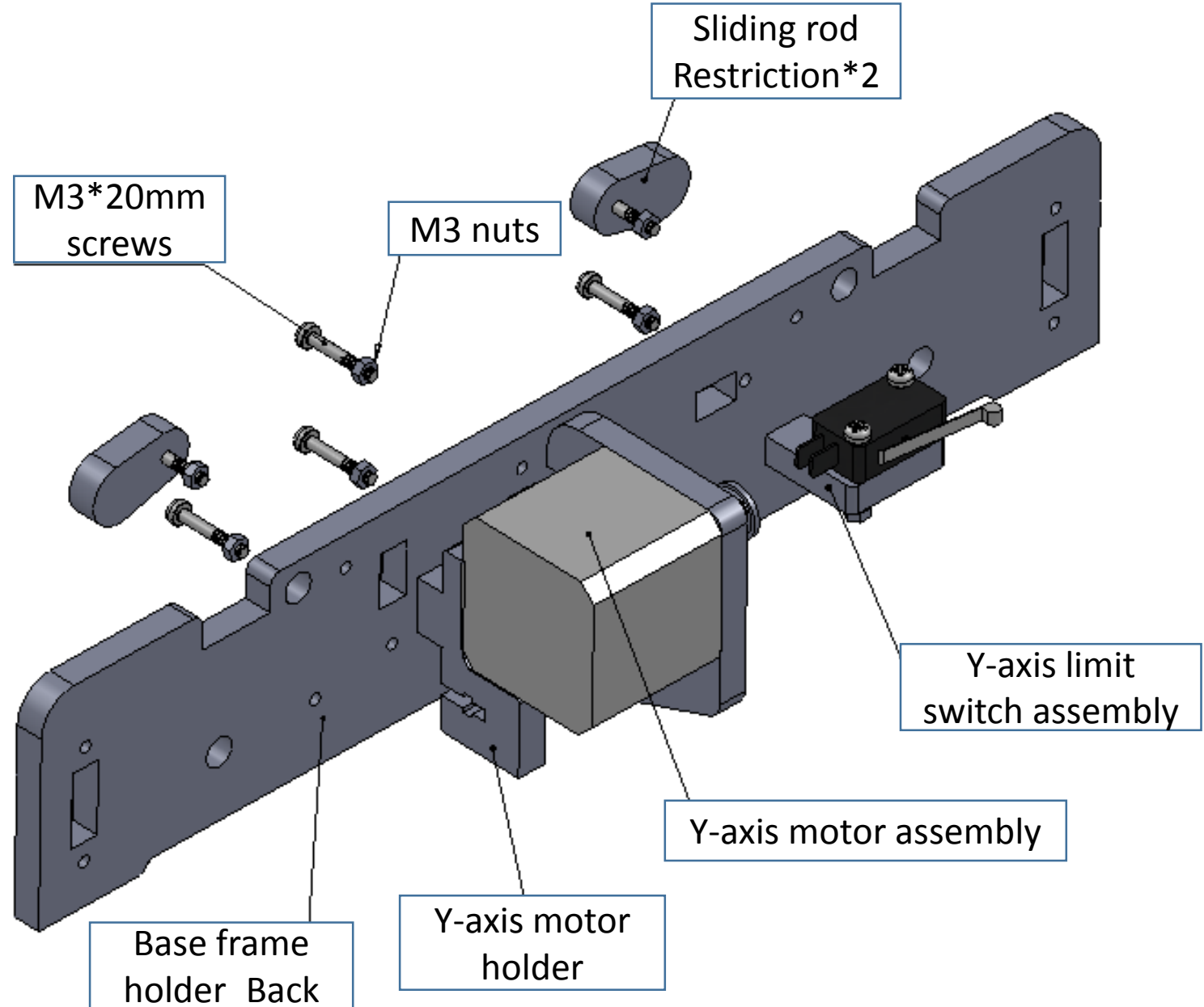
Step 2 Assemble Y-axis Limit switch

- ◆ Put the **Y-axis limit switch** and the **holder** together ,locking with two **M3*20mm Round head screws & nuts**. As picture



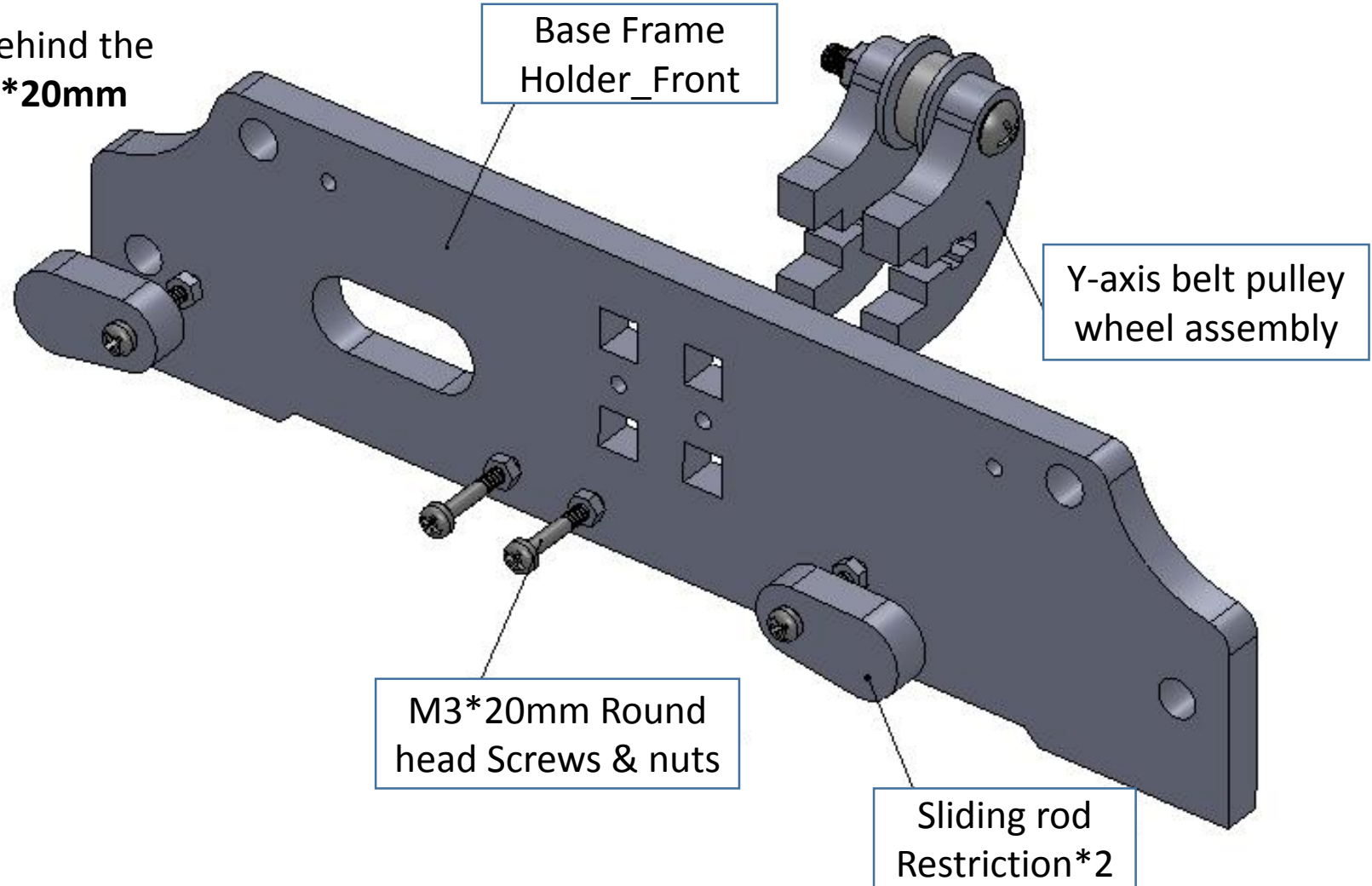
Step 3 Assemble Base Frame Holder_Back

- ◆ As the picture, put two of the **Sliding rod Restriction** in front of the **base frame holder (back)**. locking with two **M3*20mm Round head screws & nuts**.
- ◆ Put the limit switch and holder assembly on the base frame holder, locking with one **M3*20mm Round head screw & nut**.
- ◆ Put **Y-axis motor holder** on base frame holder ,locking with one **M3*20mm Round head screw & nut**.
- ◆ Put **Y-axis motor assembly** on base frame holder, locking with three **M3*20mm Round head screws & nuts**.



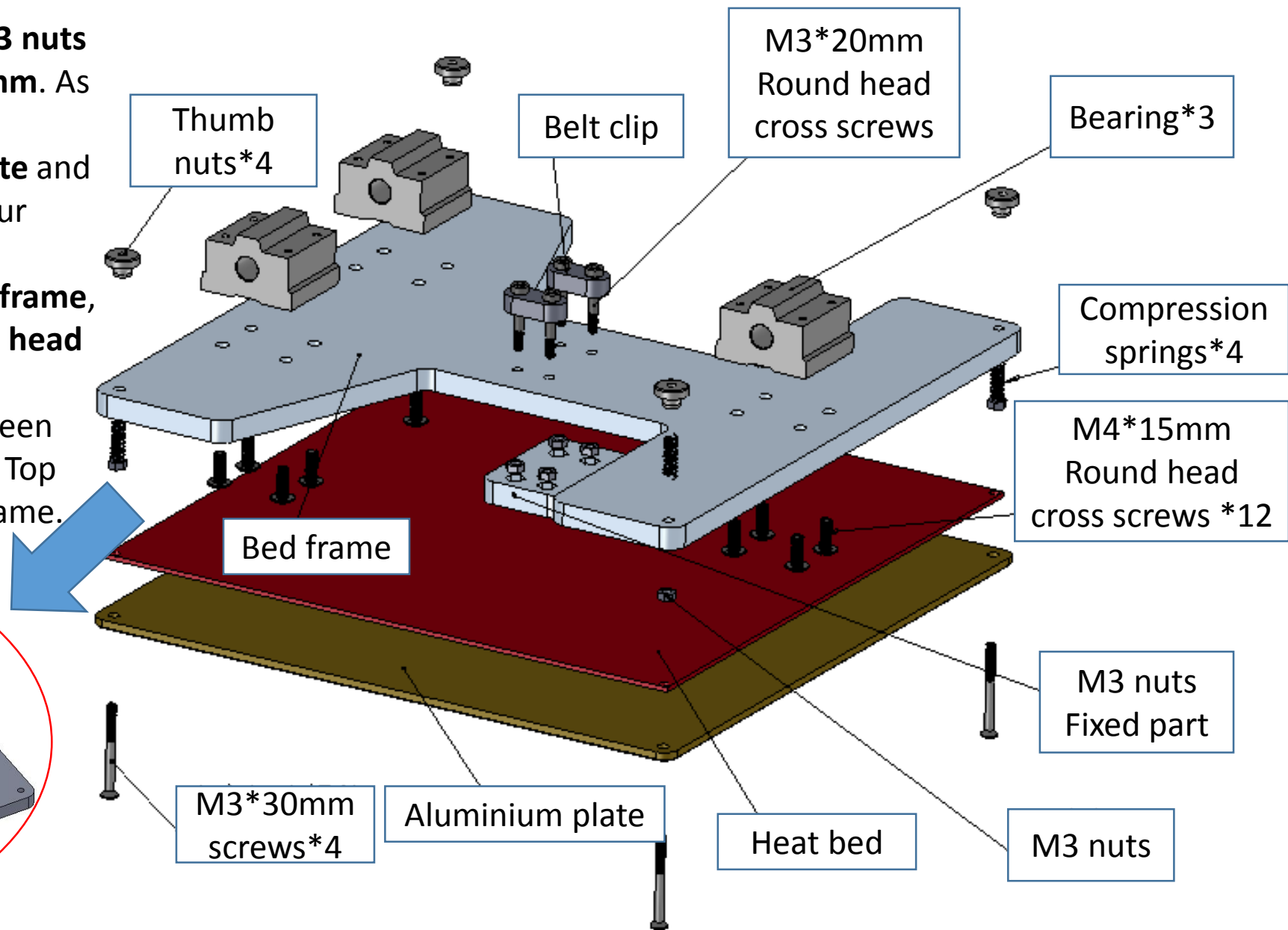
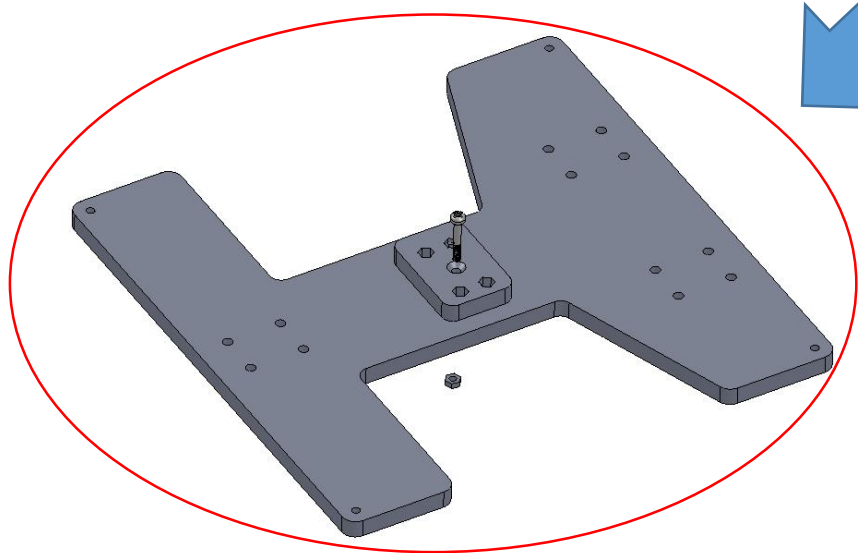
Step 4 Assemble Base Frame Holder_Front

- ◆ As the picture, put two of the **Sliding rod Restriction** in front of the **base frame holder_front**. locking with two **M3*20mm Round head screws & nuts**.
- ◆ Put **Y-axis belt pulley wheel assembly** behind the base frame holder, Locking with two **M3*20mm Round head screws & nuts**.

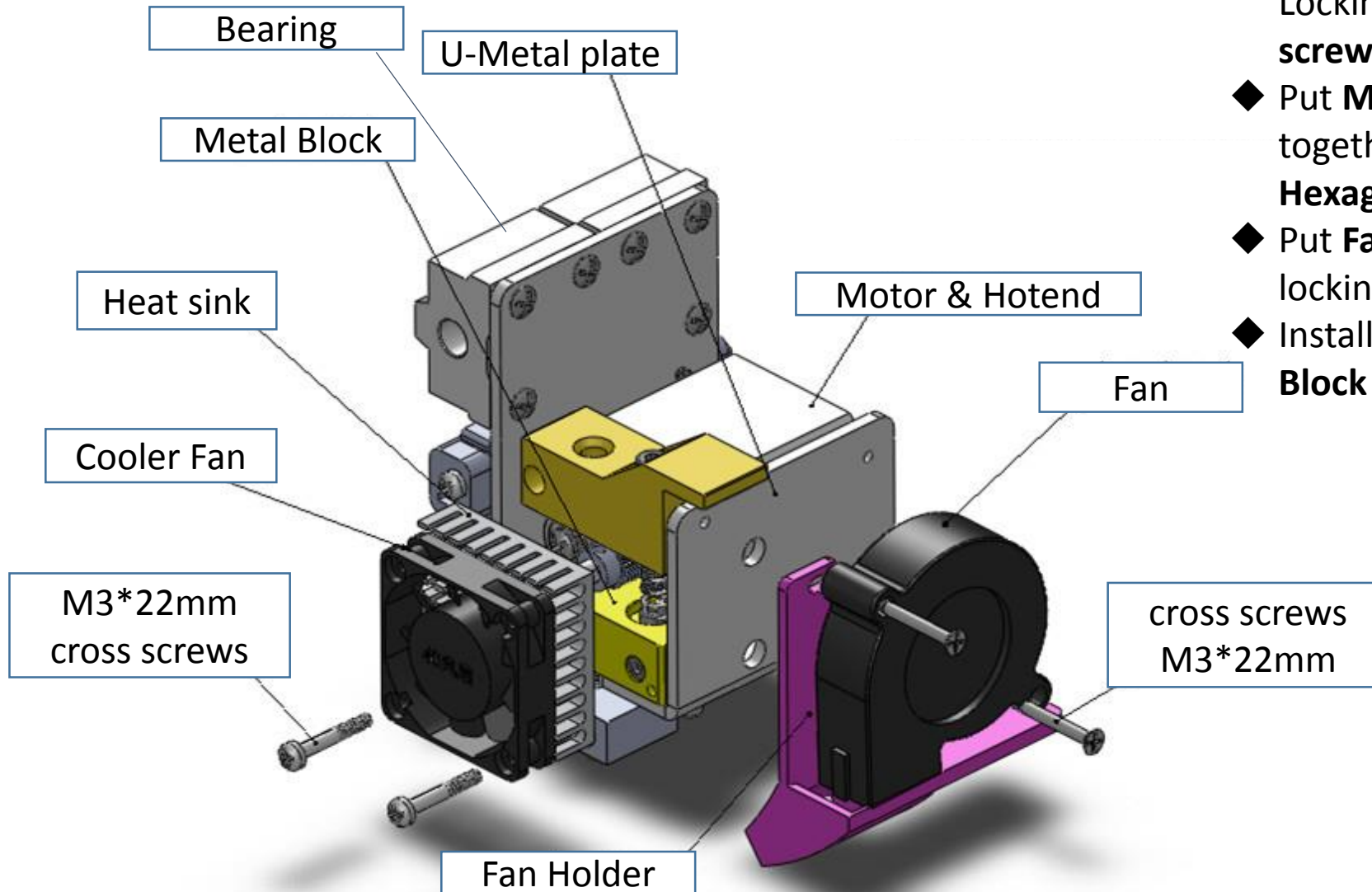


Step 5 Assemble Heat Bed Frame

- ◆ Firstly fixed the **Bed Frame** and **M3 nuts** **fixed parts** together with **M3*20mm**. As picture below.
- ◆ As the picture, put **Aluminium plate** and **heat bed** together, locking with four **M3*30mm** screws & nuts.
- ◆ Put three **bearings** under the **bed frame**, locking with twelve **M4*15 Round head cross screws**.
- ◆ Put four **compression spring** between heat bed and the bed frame. Next Top four **thumb nuts** under the bed frame.



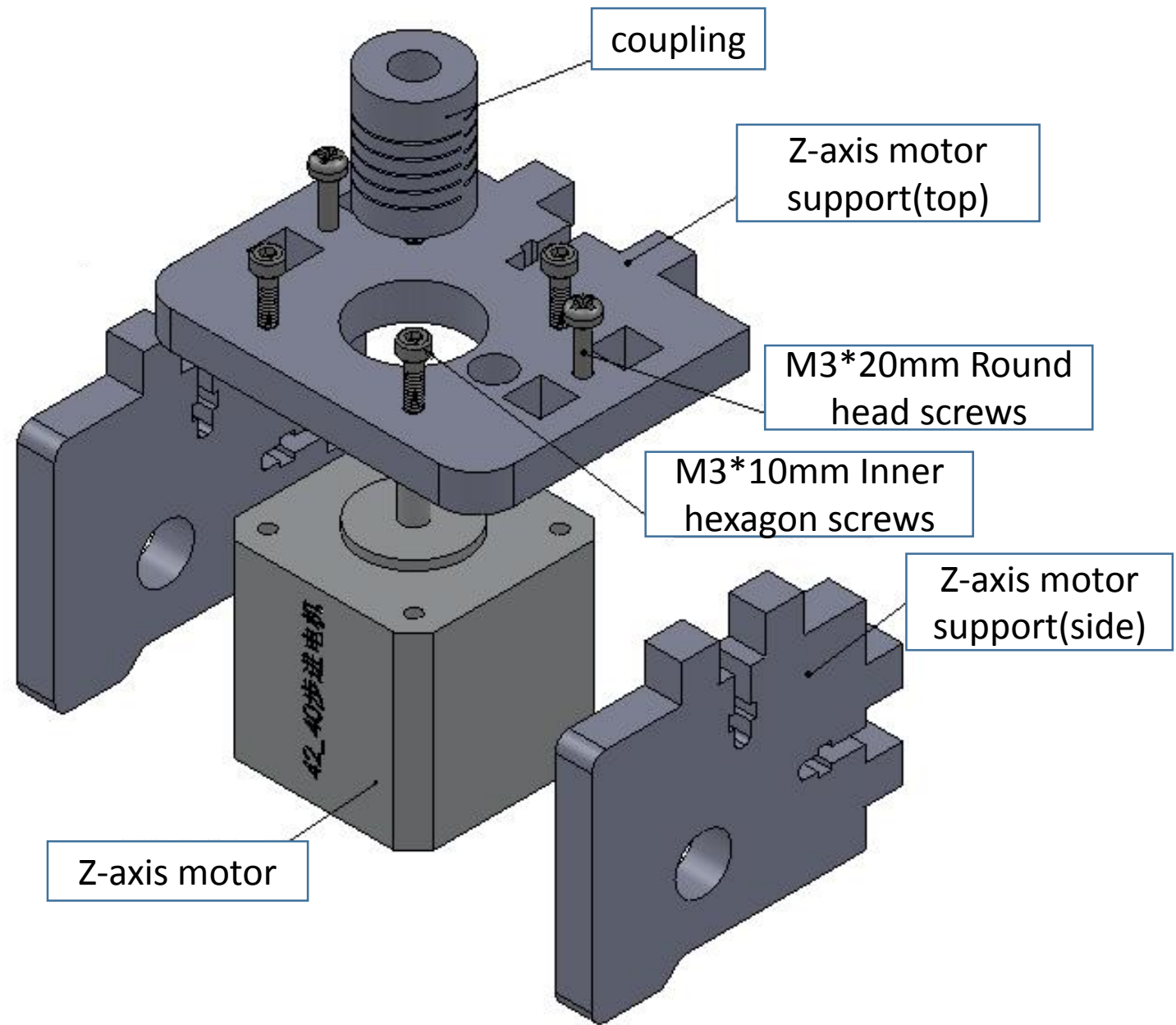
Step 6 Assemble Extruder



- ◆ Install 3pcs **Bearings** to the **U-Metal Plate**, Locking with 12pcs **M4*8mm Round head Cross screws**.
- ◆ Put **Motor& Hotend module** and **U-Metal plate** together , locking with 2pcs **M3*10mm Inner Hexagon screws** .
- ◆ Put **Fan** and **Fan Holder** to the U-Metal plate, and locking with 2pcs **M3*22mm Cross screws**
- ◆ Install **Cooler Fan** and **Heat sink** on the **Metal Block** use 2pcs **M3*22mm cross screws** .

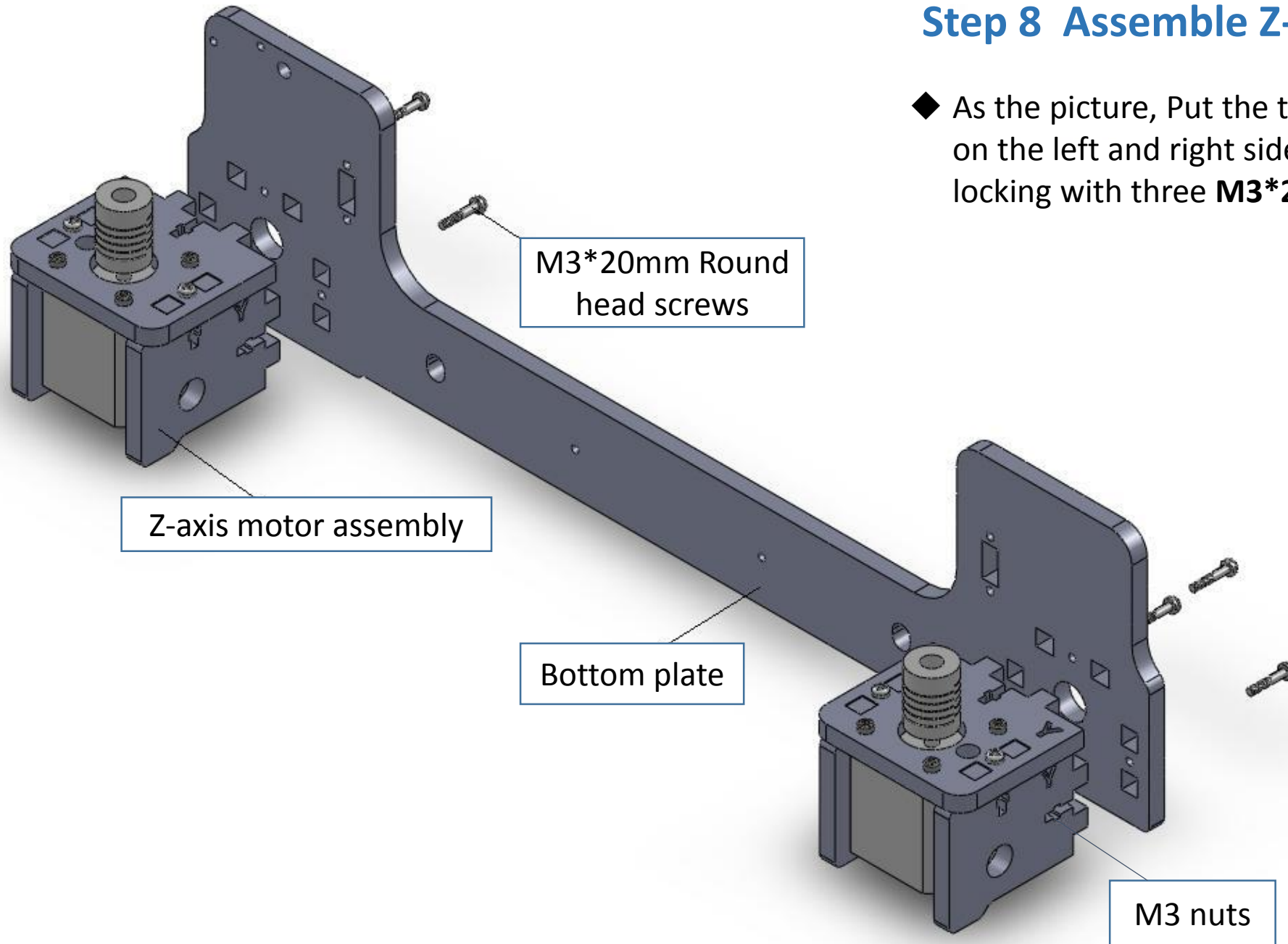
Step 7 Assemble Z-axis motor

- ◆ Put two **Z-axis motor support(side)** in two sides of the motor, Cover the **Z-axis motor support(top)** on the top, locking with **M3*20mm Round head screws & nuts**.
- ◆ The cable of Z-axis motor is back of the Z-axis motor support. Locking **Z-axis motor** with four **M3*10mm Inner hexagon screws**.
- ◆ Put the **coupling** on the motor, locking with the jackscrews.
- ◆ Another Z-axis motor is the same assembly.



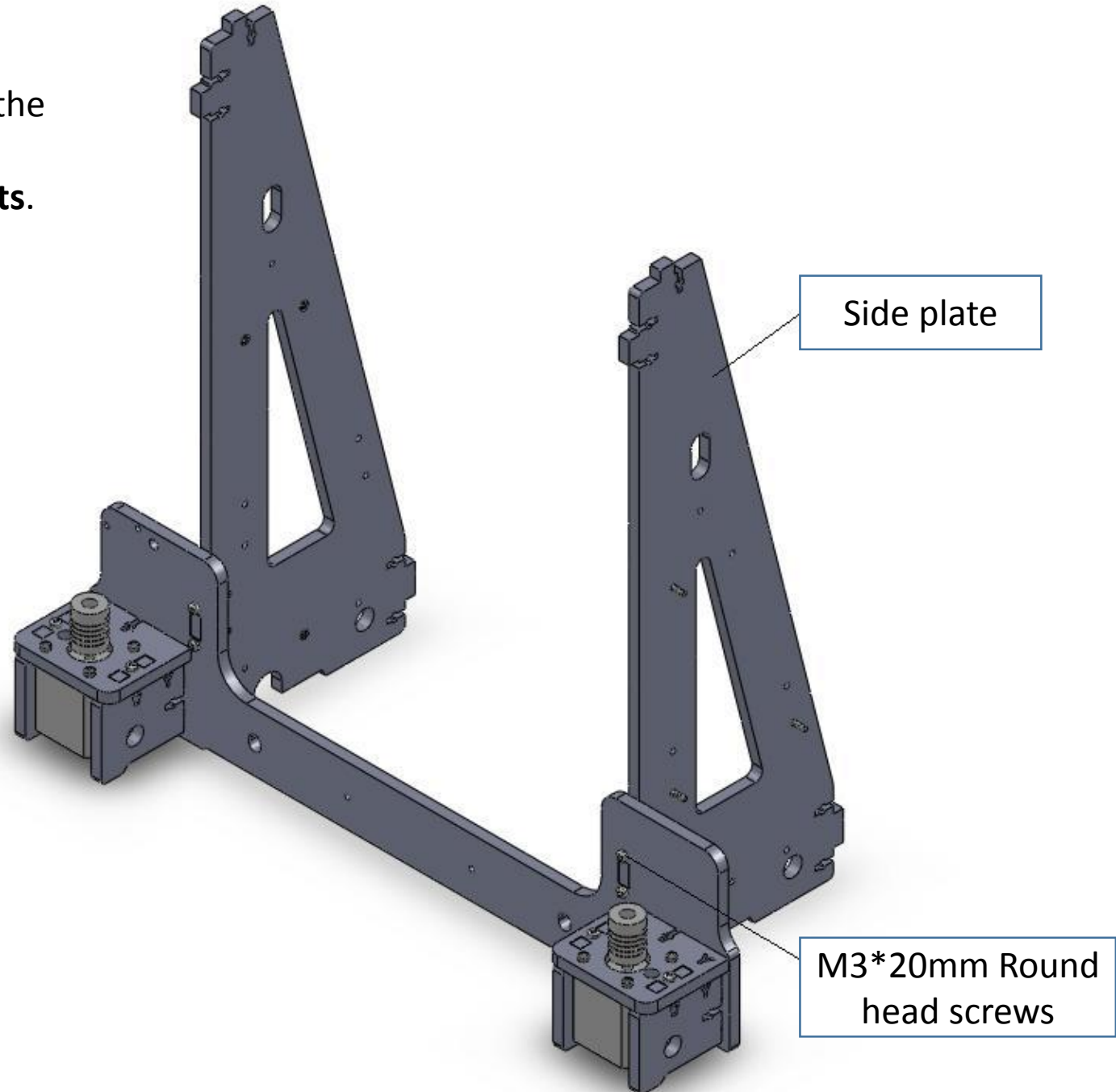
Step 8 Assemble Z-axis

- ◆ As the picture, Put the two **Z-axis motors assembly** on the left and right side of the **Bottom plate**, locking with three **M3*20mm screws & nuts**.



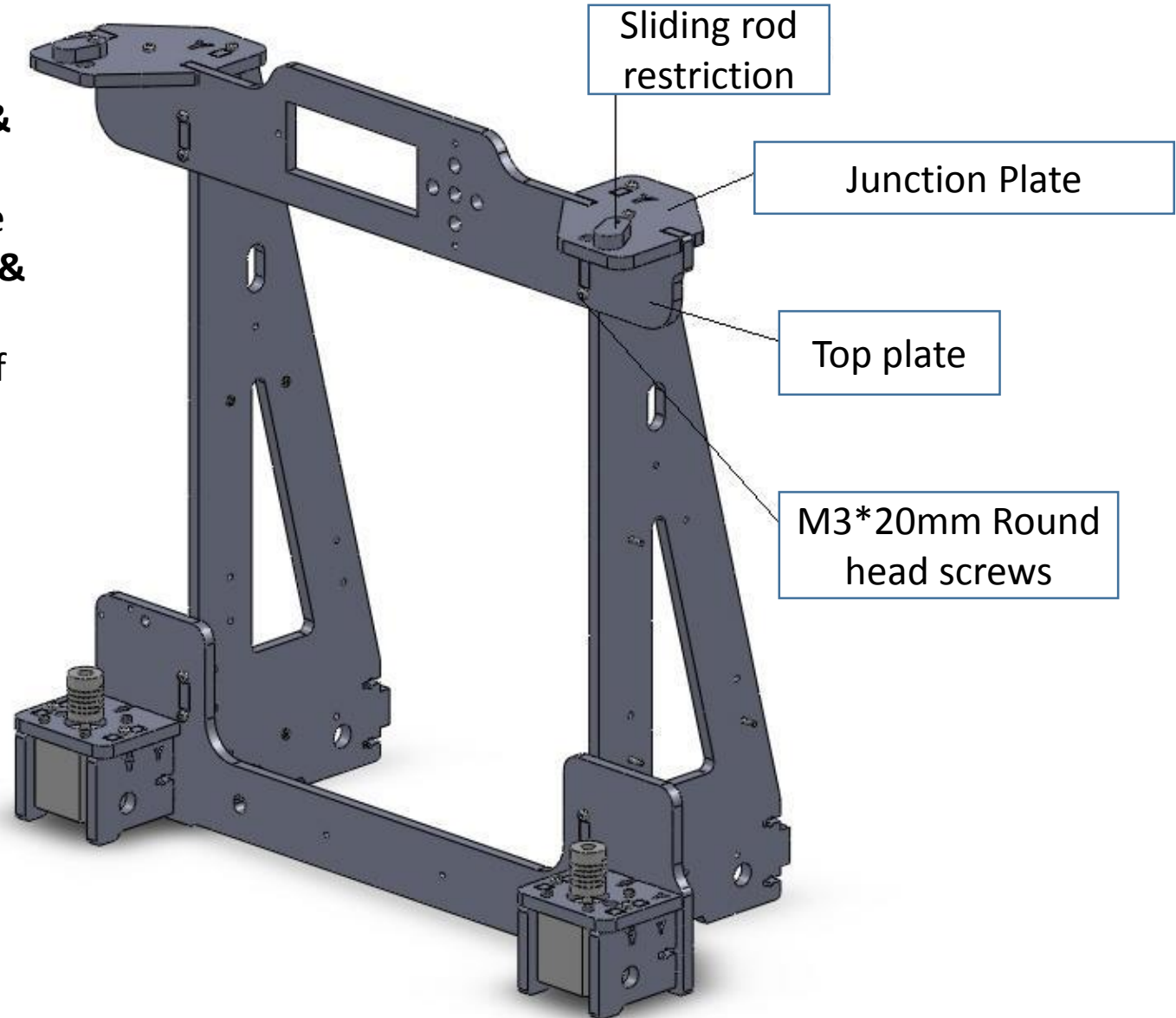
Step 9 Assemble Side plate

- ◆ As the picture, Put the two **Side plate** on the left and right side of the **Bottom plate** , locking with four **M3*20mm screws & nuts**.



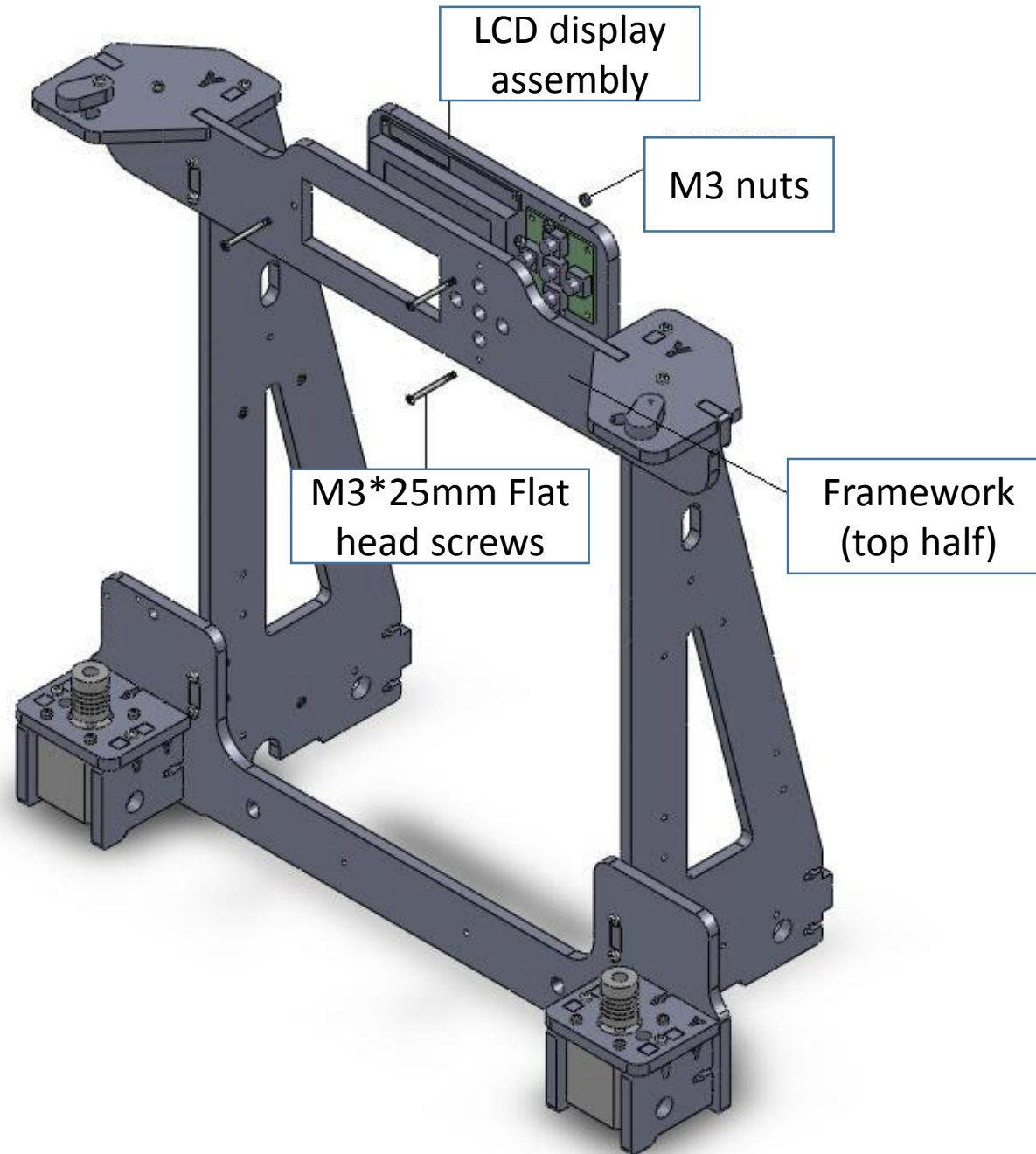
Step 10 Assemble Top plate & Junction Plate

- ◆ As the picture, Put the **Top plate** on **Side Plate**, locking with four **M3*20mm screws & nuts**.
- ◆ Put the two **Junction Plate** on the top of the **Side plate**, locking with four **M3*20 screws & nuts**.
- ◆ Put two **sliding rod restriction** on the top of left and right sides. Locking with one **M3*20mm Round head screw & nut** each.



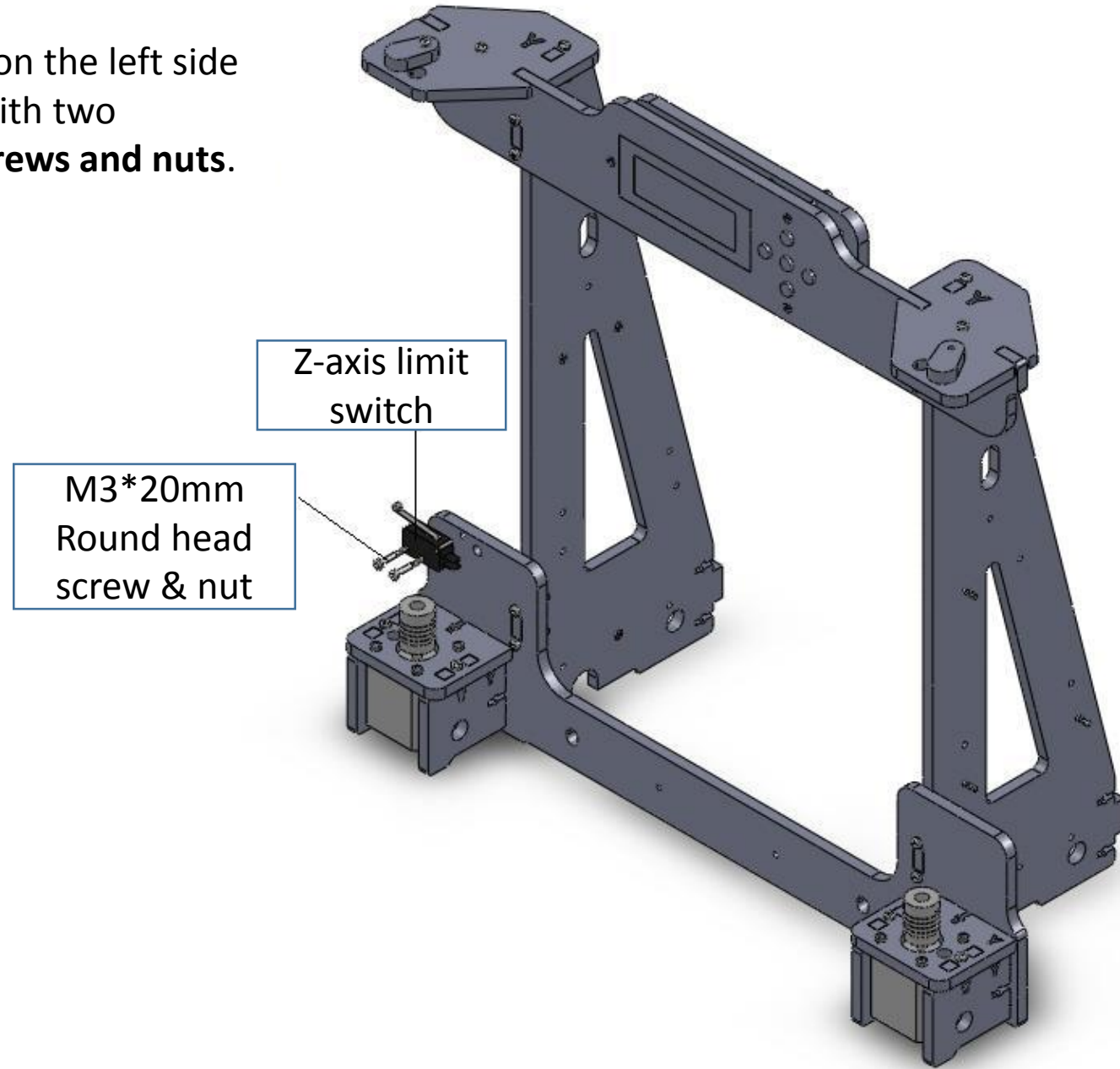
Step 11 Install LCD display

- ◆ Put the **LCD display** on the top of the **Top plate**, locking with three **M3*25mm flat_head screws & nuts**



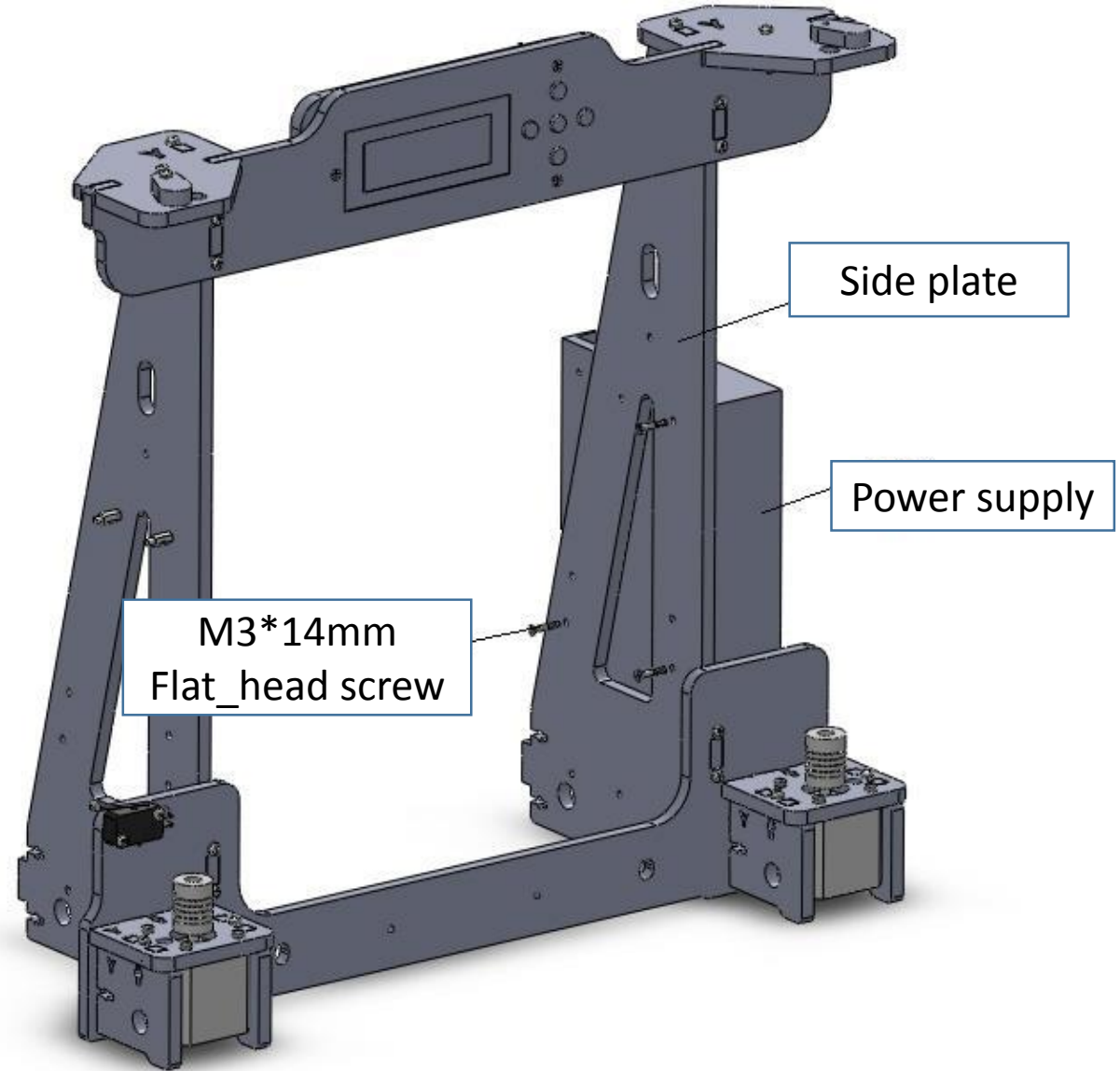
Step 12 Install Z-axis Limit switch

- ◆ Put the **Z-axis limit switch** on the left side of **Bottom plate**, Locking with two **M3*20mm Round head screws and nuts**.



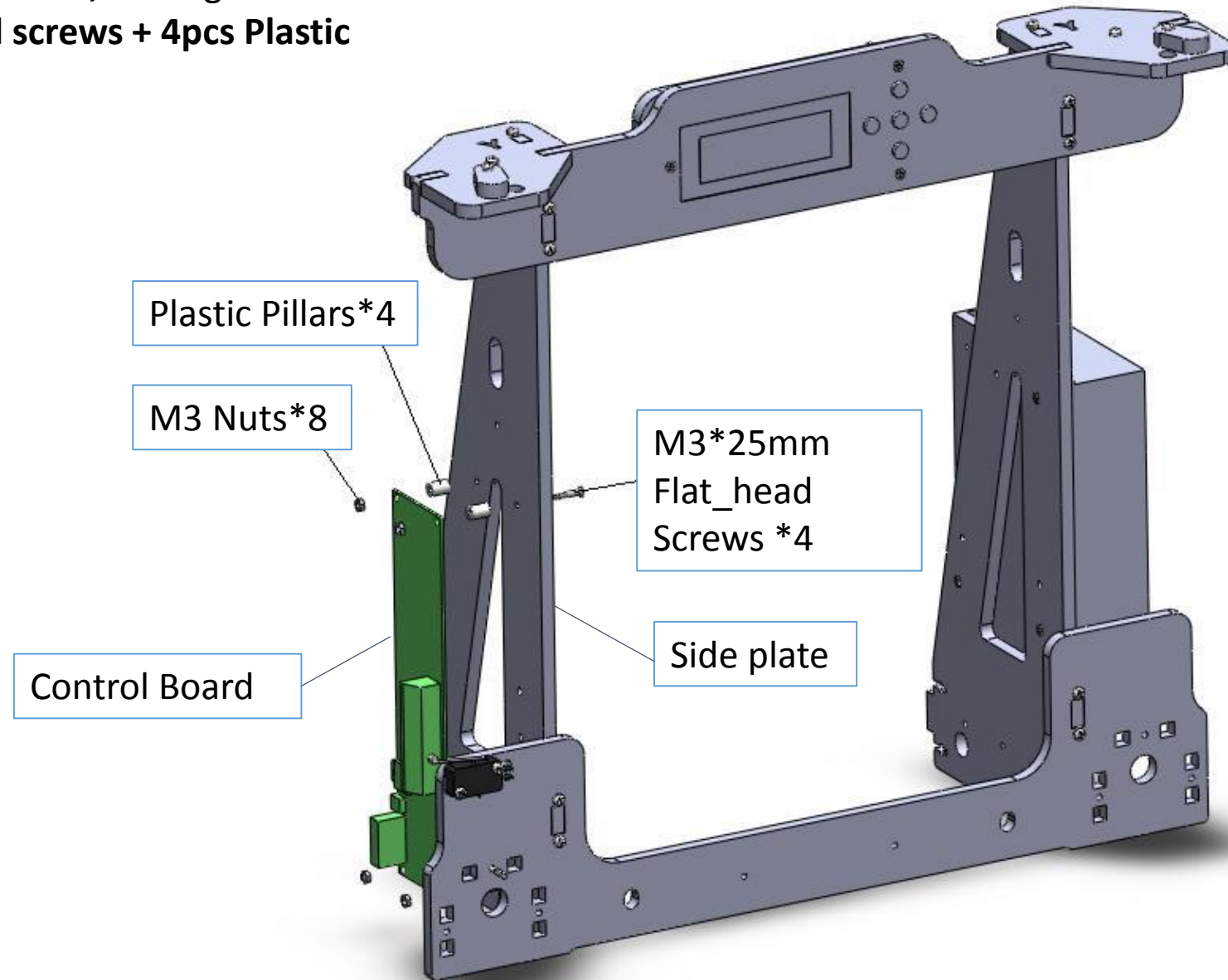
Step 13 Install Power supply

- ◆ Put **Power supply** on the right of the **side plate** , locking with three **M3*14mm Flat_head screws and nuts**.



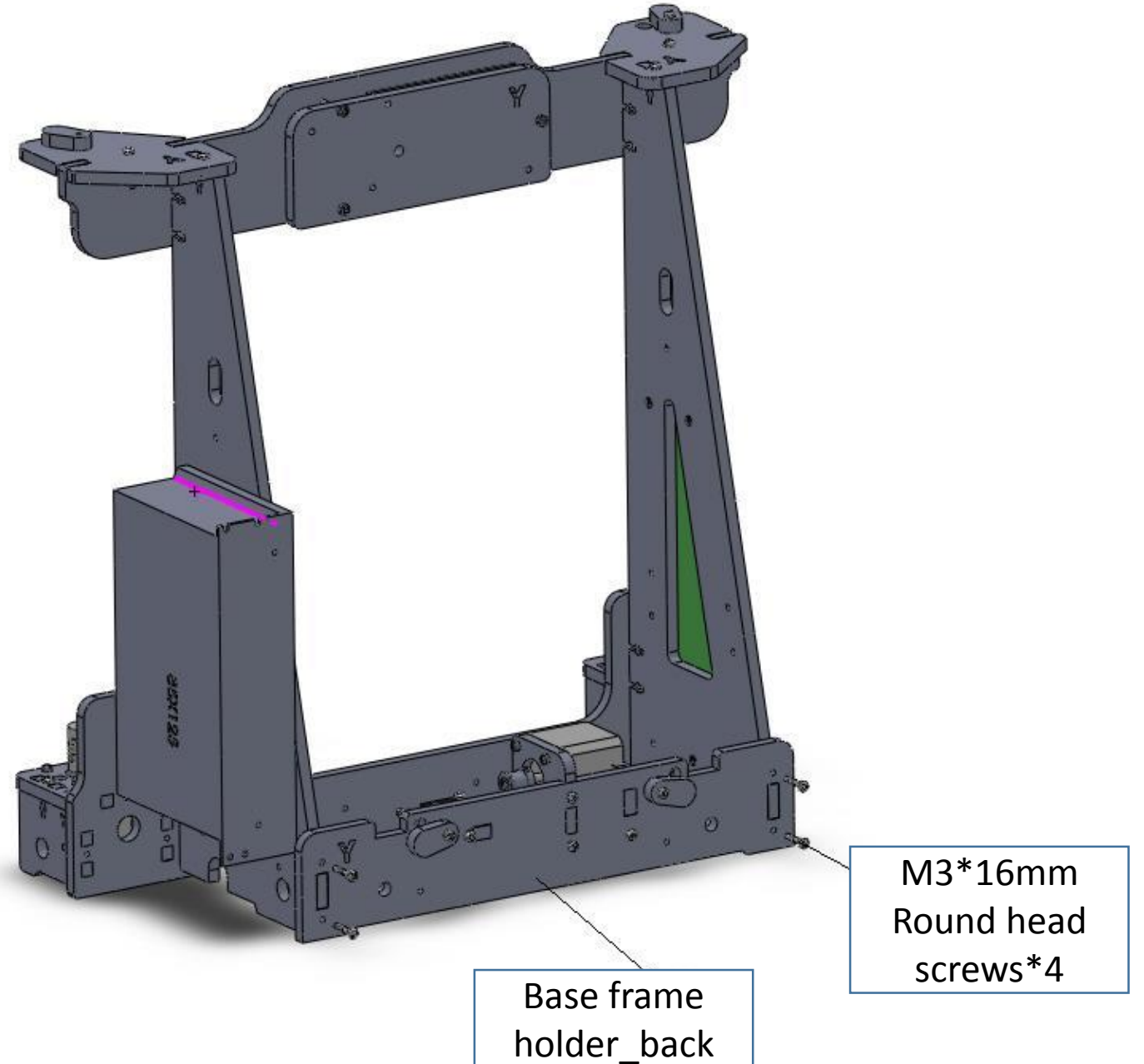
Step 14 Install PCBA Control Board

- ◆ Install **Control Board** as picture , locking with Four **M3*25mm Flat head screws** + **4pcs Plastic pillars** + **4pcs M3 nuts**



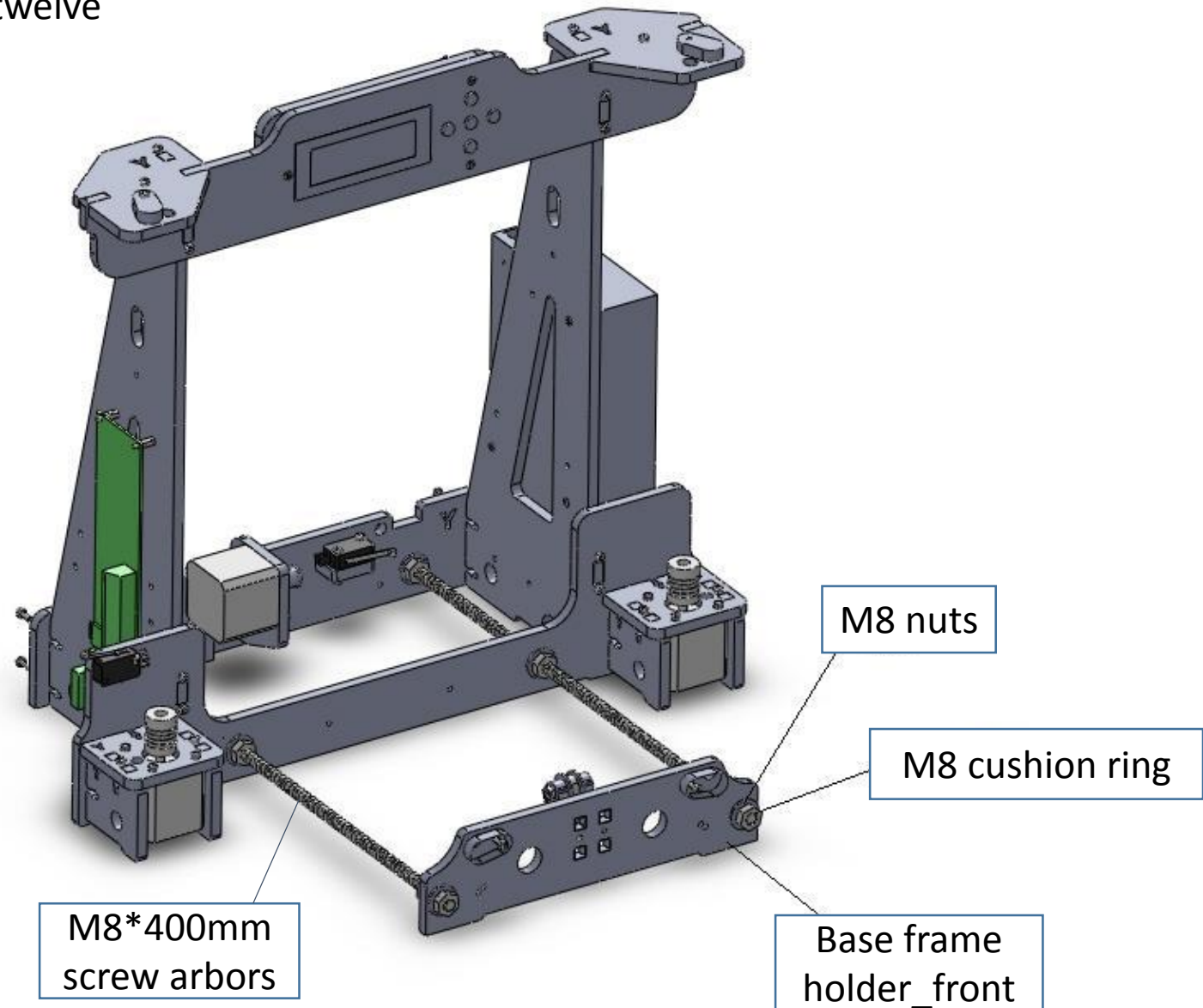
Step 15 Install Base frame holder_Back

- ◆ Put the **Base frame holder_back** back of **Side plate**, locking with four **M3*20mm Round head screw**



Step 16 Install Base Frame Holder_Front

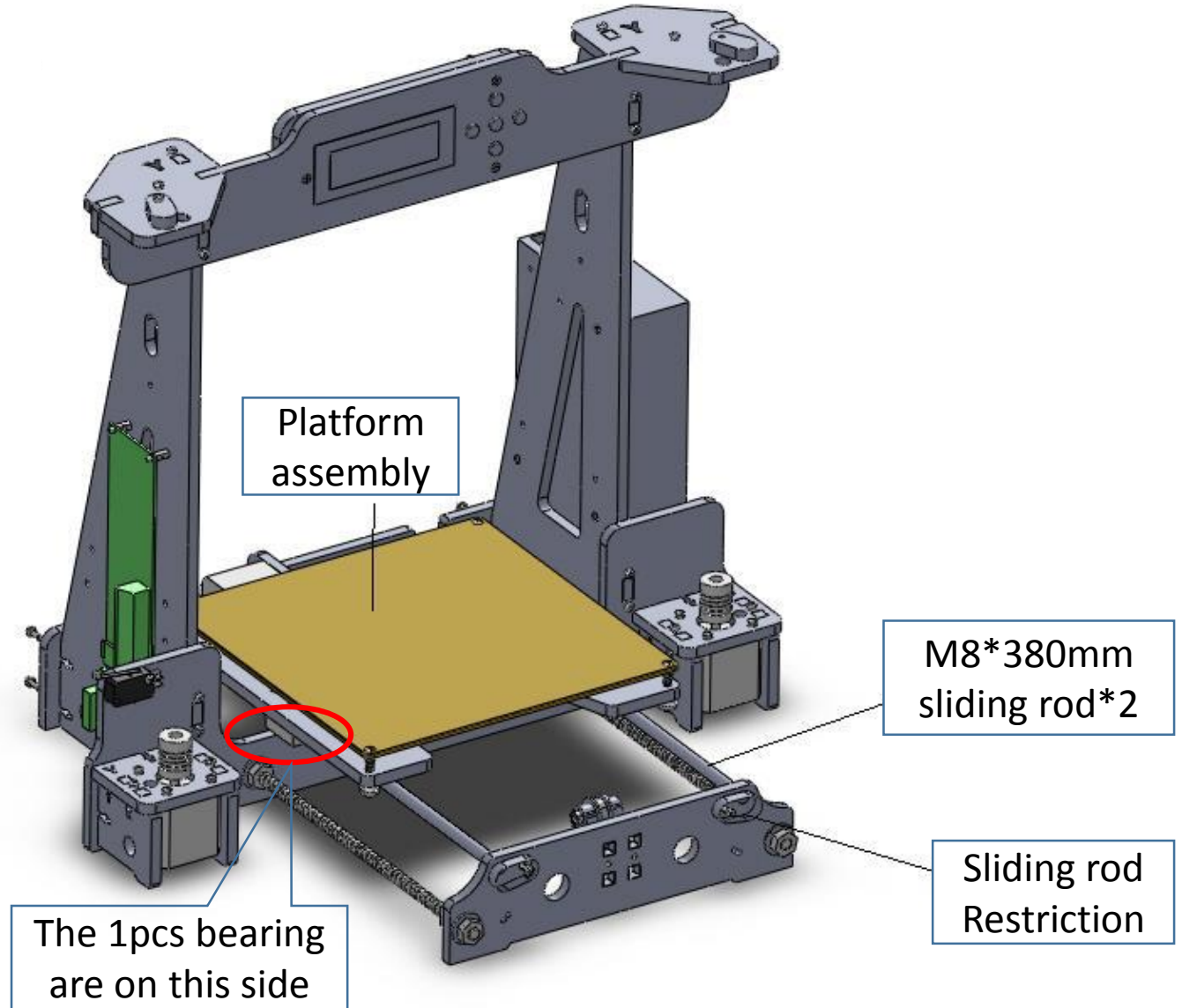
- ◆ Through the **Frame Holder_Front & Back** by two **M8*400mm screw arbors**, locking with twelve **M8 Nuts & cushion ring**.



Step 17 Instal Platform Assembly

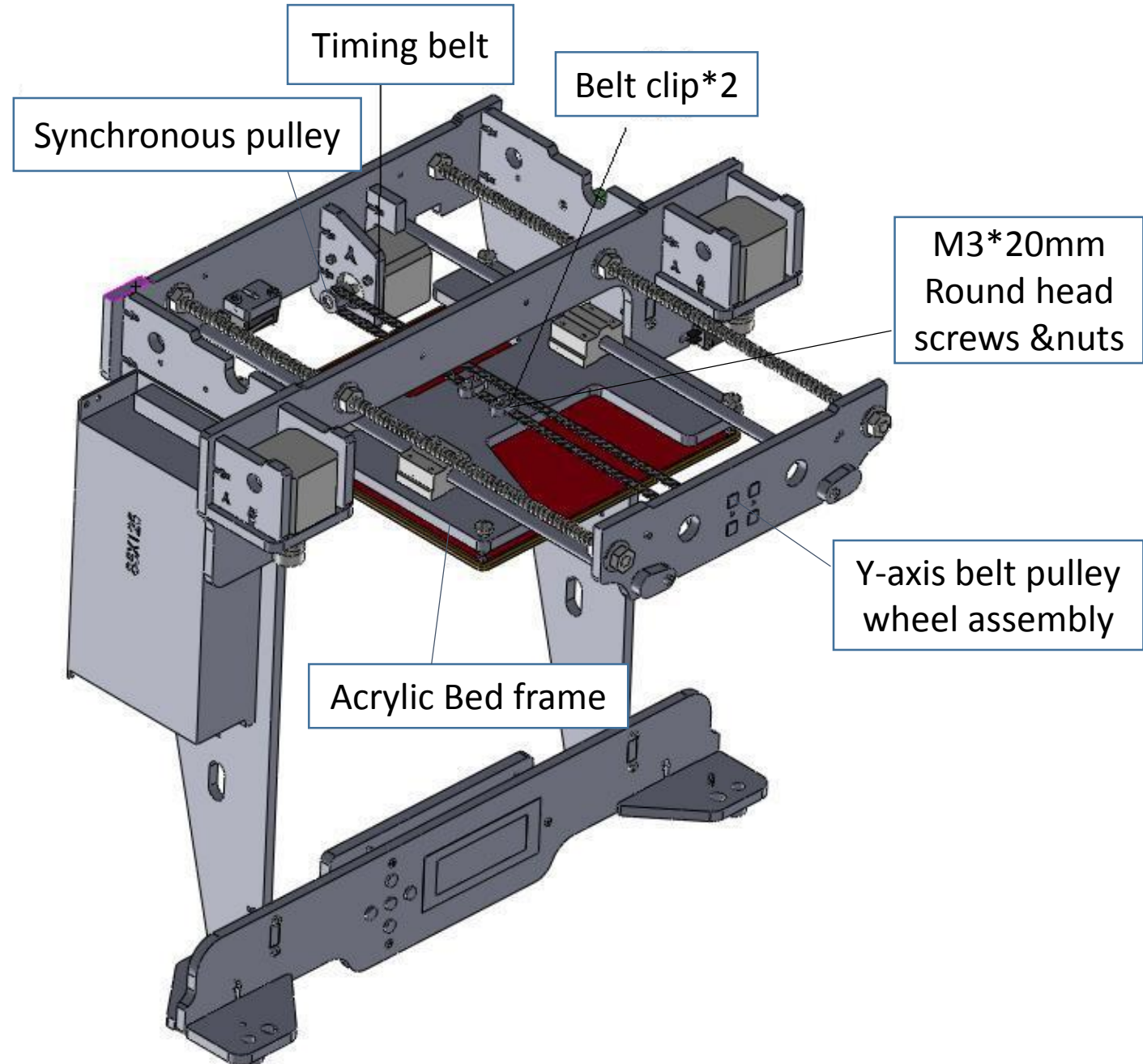
- ◆ As the picture , through the platform on the base by two of **M8*380mm Sliding rod**. Fix both end by Sliding rod restriction

Attention: Put the 1pcs bearing on the hotbed on the left side , and put the hotbed wires on back side .



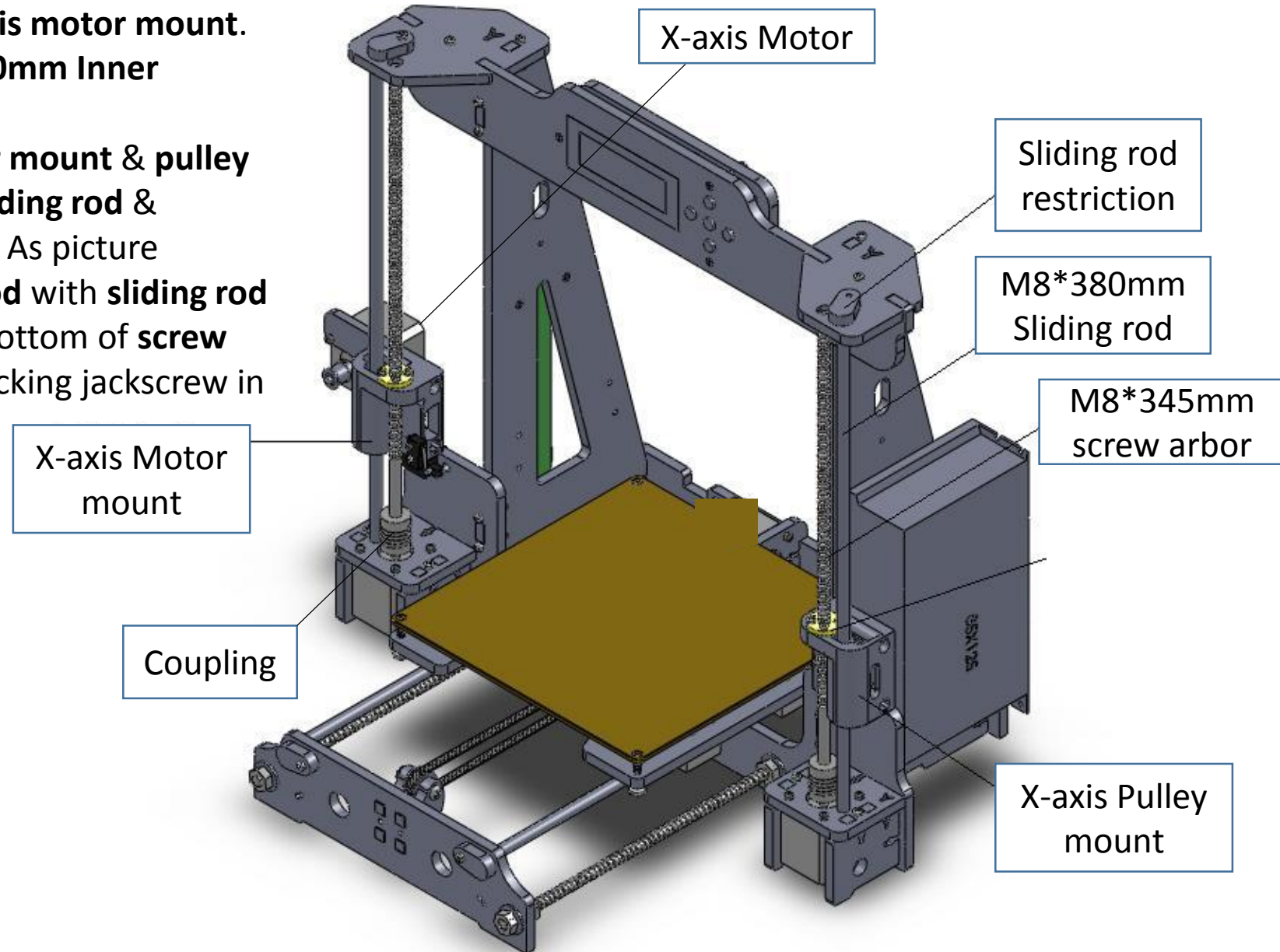
Step 18 Instal Y-axis Timing belt

- ◆ As the picture, Lock one end of the **timing belt** in **belt clip**, the other end through the Y-axis motor and belt pulley wheel on the base frame holder. Then tense the belt and lock in the other belt clip with **M3*20mm Round head screws & nuts**.



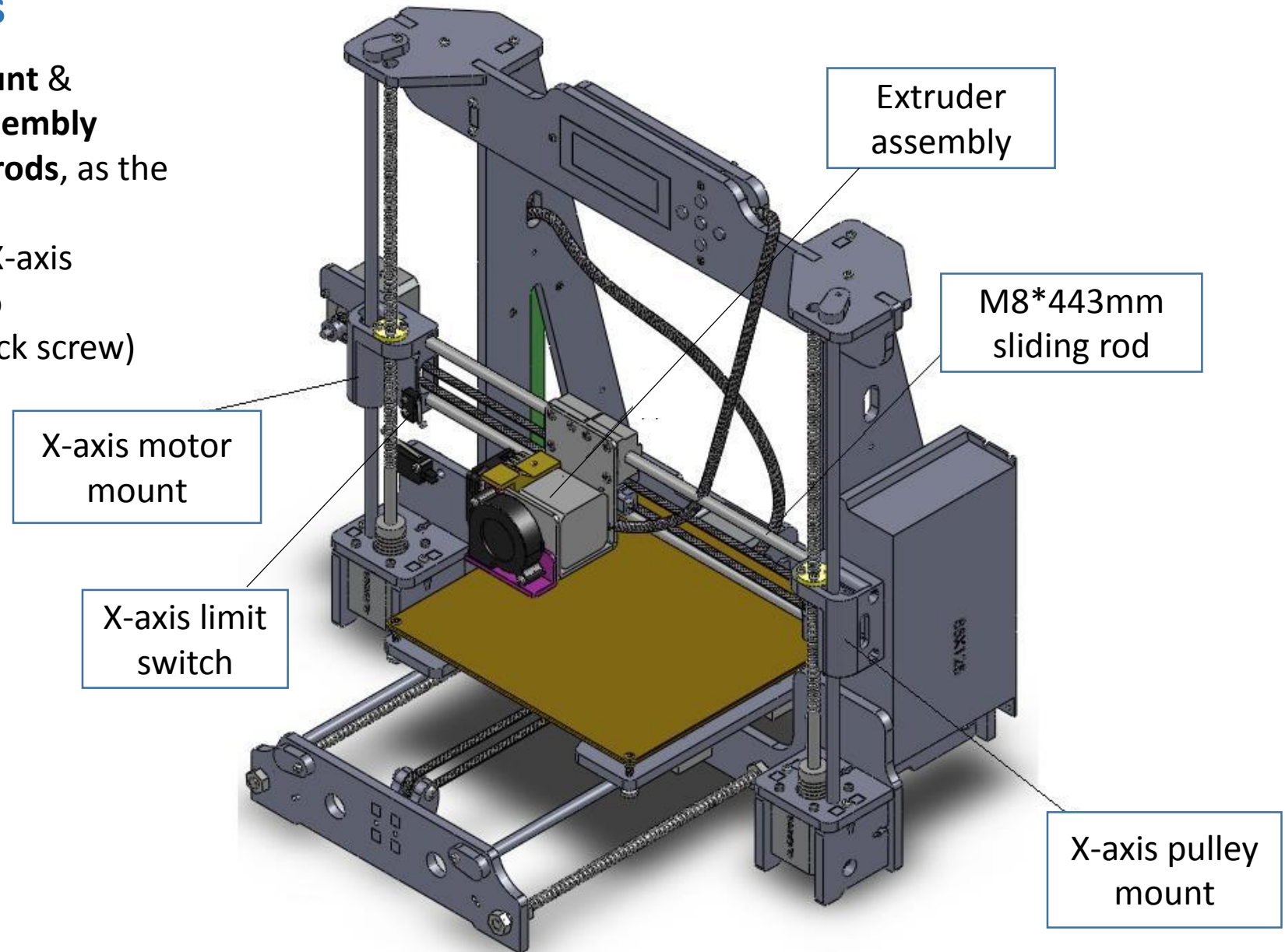
Step 19 Instal X-axis Motor & Pulley mount

- ◆ Put **X-axis motor** on **X-axis motor mount**.
Locking with three **M3*10mm Inner hexagon screws**.
- ◆ Through the **X-axis motor mount & pulley mount** by **M8*380mm sliding rod** & **M8*345mm screw arbor**. As picture
- ◆ Limit the top of **sliding rod** with **sliding rod restriction**, connect the bottom of **screw arbors** with **couplings**, locking jackscrew in coupling.



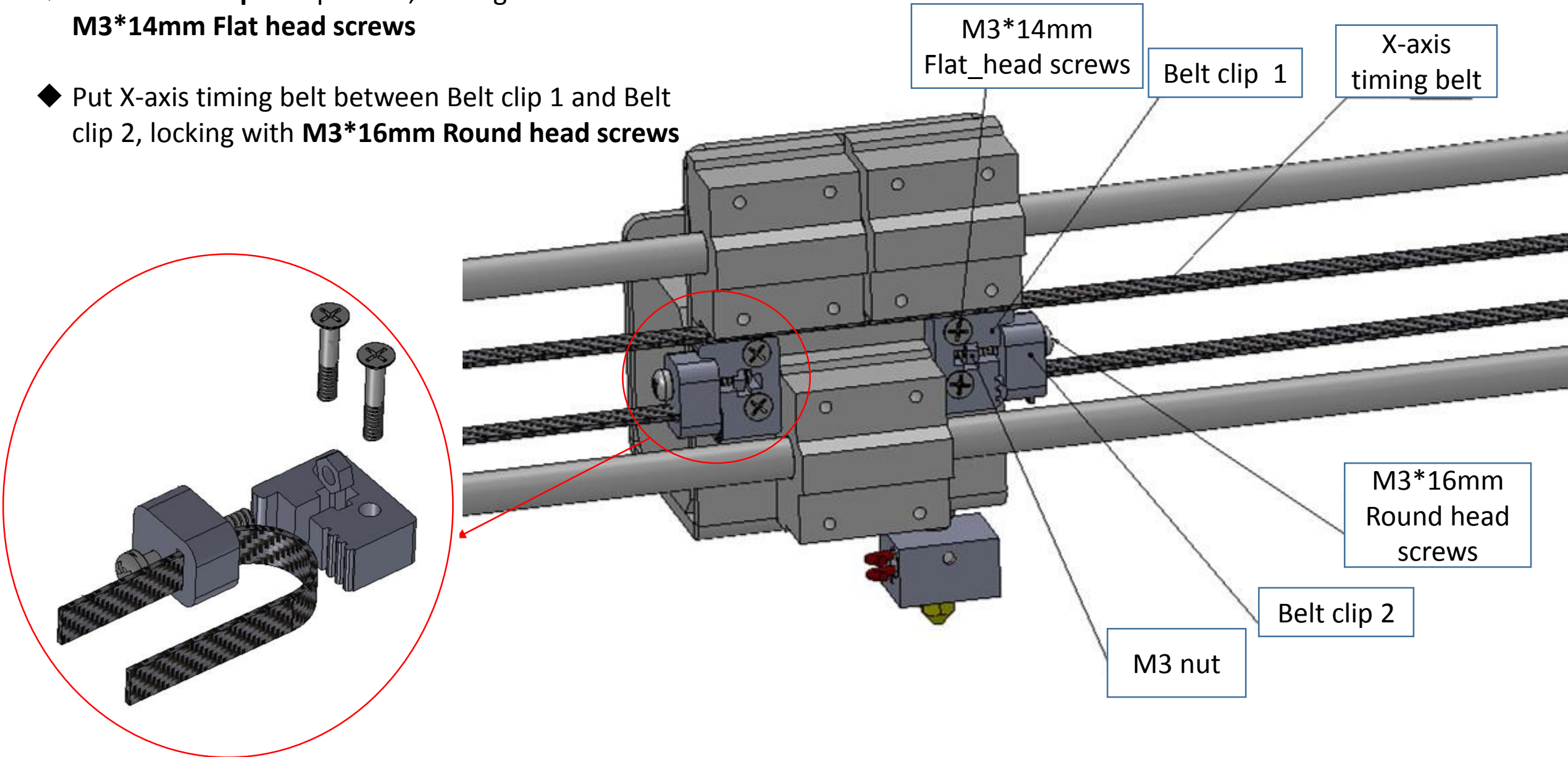
Step 20 Assemble X-axis

- ◆ Through the X-axis **motor mount** & **Pulley mount** and **Extruder assembly** using two **M8*443mm sliding rods**, as the picture.
- ◆ Put **X-axis limit switch** on the X-axis motor mount, locking with two **M2.5*10mm screws** (small black screw)



Step 21 Instal X-axis Timing Belt

- ◆ Install **Belt clip 1** as picture , locking with **M3*14mm Flat head screws**
- ◆ Put X-axis timing belt between Belt clip 1 and Belt clip 2, locking with **M3*16mm Round head screws**

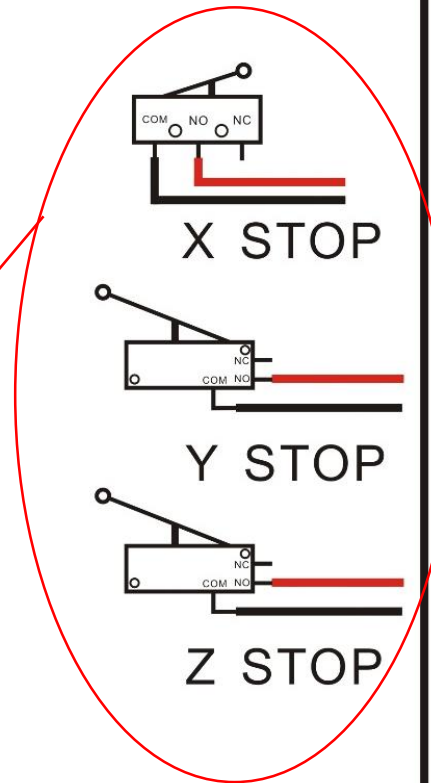
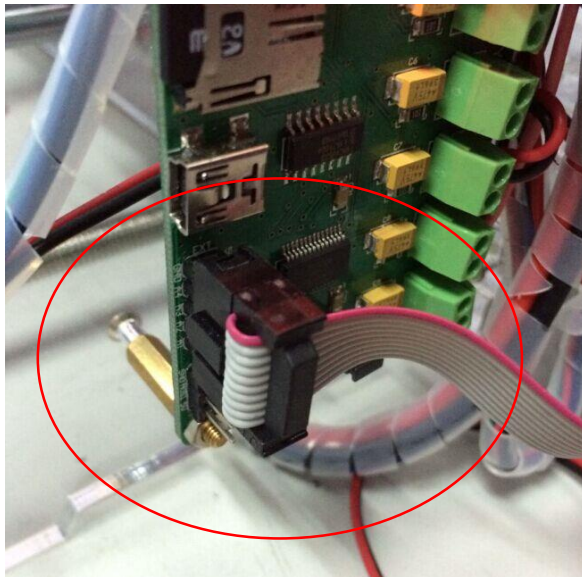


Step 22 Control Board Wiring Diagram

◆ The method of connecting wire is as picture

!NOTE!: The wires connected to POWER SUPPLY and HETBED must be AWG14 or thicker one.

Wire the X Y Z axis Limit switches "COM" and "NO" these 2 ends , as pictures



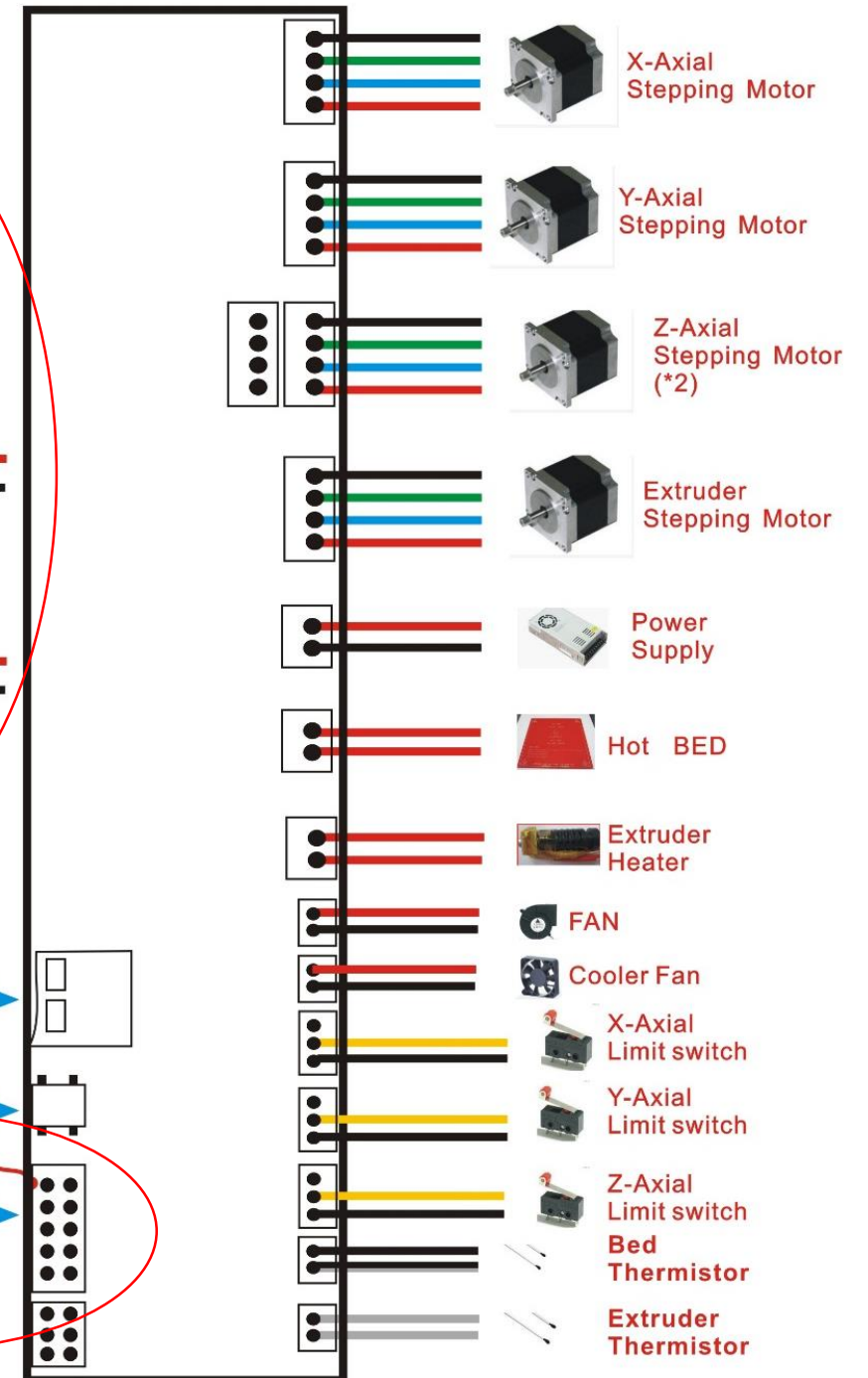
Micro SD Card



USB Cable



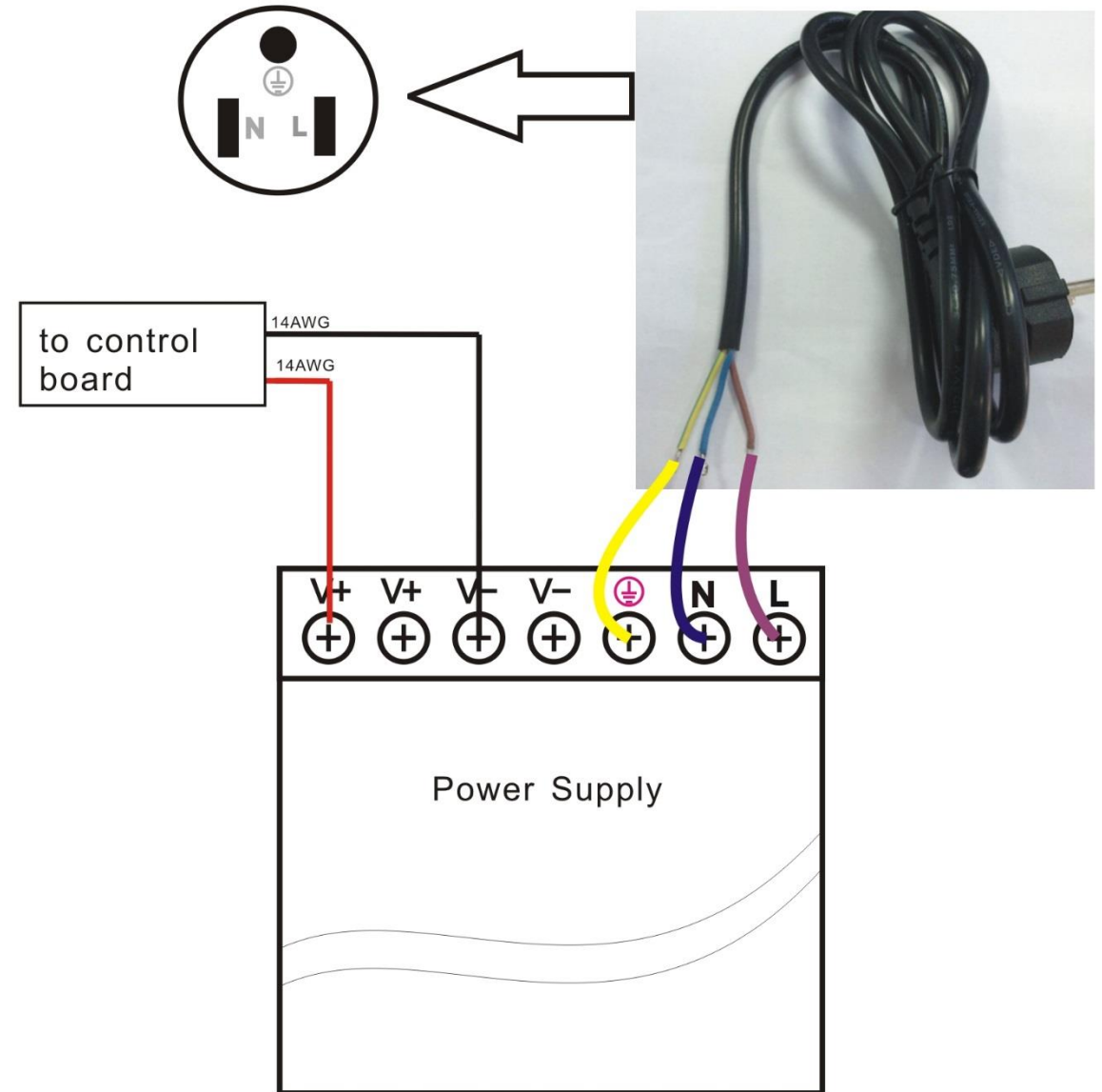
LCD 2004+Keypad



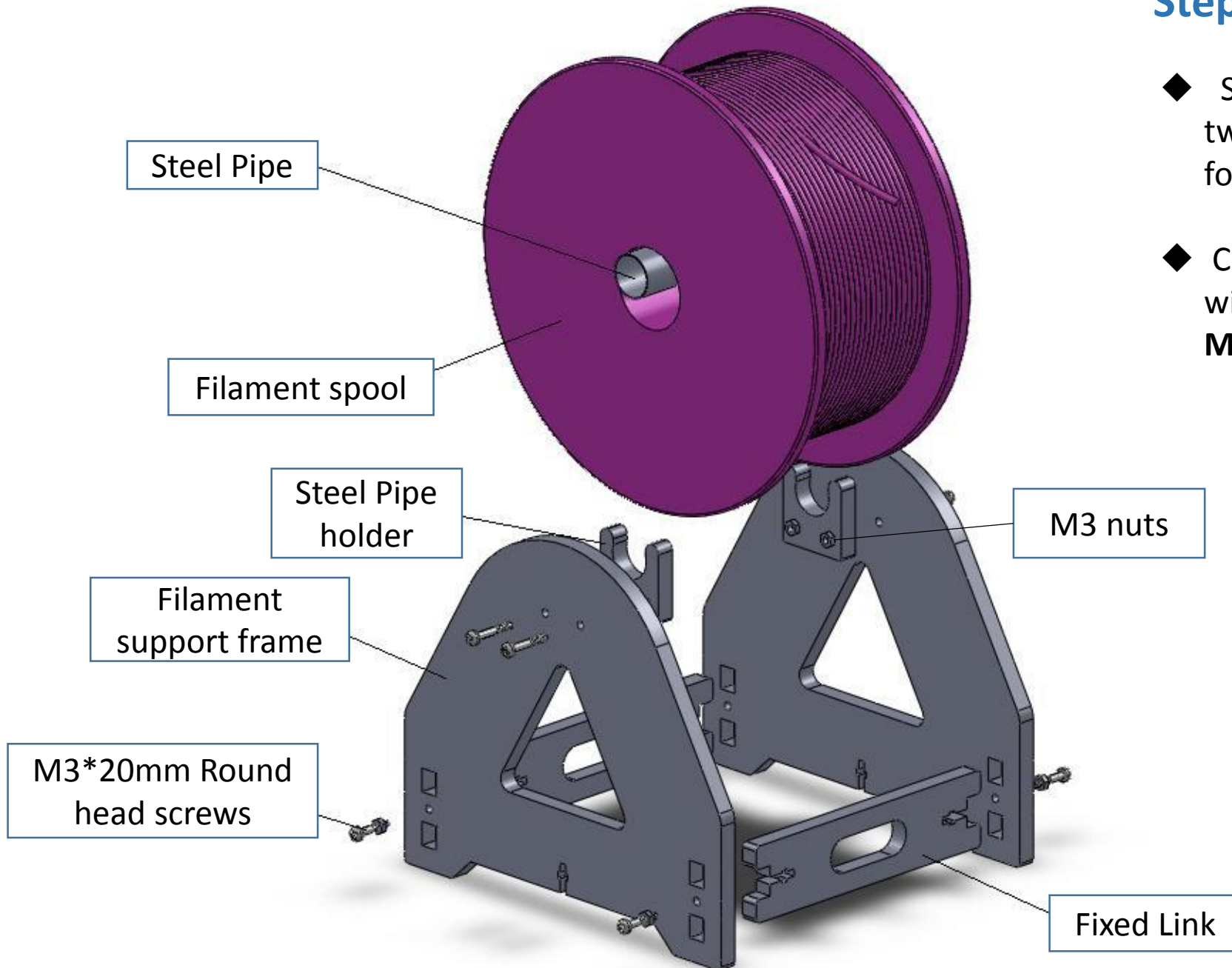
Step 23 AC Power Connector Wiring Diagram

◆ Connect Power cable as the picture (Right)

Note: There are different voltages in different country. Please select the appropriate voltage by switch before power on. As the picture below.



Step 24 Assemble Filament Feeder



- ◆ Separately put two **Steel Pipe holder** on two **Filament support frame**, locking with four **M3*20mm Round head screws & nuts**.
- ◆ Connect the two **Filament support frames** with two **Fixed links**, locking with four **M3*20mm Round head screws & nuts**

Installation Finished

