

SIBoOR



VORON2 2.4R2 BUILD GUIDE

We build space shuttles with gardening tools
so anyone can have a space shuttle of their own.

VERSION 2022-07-04



Before you begin on your journey, 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 do not become the first VORON fatality. There is no special Reddit flair for that.

Please, read the entire manual before you start assembly. As you begin wrenching, please check our Discord channels for any tips and questions that may halt your progress.

Most of all, good luck!

THE VORON TEAM

PART PRINTING GUIDELINES

The Voron Team has provided the following print guidelines for you to follow in order to have the best chance at success with your parts. There are often questions about substituting materials or changing printing standards, but we recommend you follow these:

3D PRINTING PROCESS

Fused Deposition Modeling (FDM)

MATERIAL

ABS

LAYER HEIGHT

Recommended: 0.2mm

EXTRUSION WIDTH

Recommended: Forced 0.4mm

INFILL TYPE

Grid, Gyroid, Honeycomb, Triangle or Cubic

INFILL PERCENTAGE

Recommended: 40%

WALL COUNT

Recommended: 4

SOLID TOP/BOTTOM LAYERS

Recommended: 5

PRINT IT FORWARD (PIF)

Often times community members that have issues printing ABS will bootstrap themselves into a VORON using our Print It Forward program. This is a service where approved members with VORON printers can make you a functional set of parts to get your own machine up and running.

Check Discord if you have any interest in having someone help you out.

FILE NAMING

By this time you should have already downloaded our STL files from the Voron GitHub. You might have noticed that we have used a unique naming convention for the files. This is how to use them.

PRIMARY COLOR

Example `z_joint_lower_x4.stl`

These files will have nothing at the start of the filename.

ACCENT COLOR

Example `[a]_tensioner_left.stl`

We have added “[a]” to the front of any STL file that is intended to be printed with accent color.

QUANTITY REQUIRED

Example `[a]_z_belt_clip_lower_x4.stl`

If any file ends with “_x#”, that is telling you the quantity of that part required to build the machine.

HOW TO GET HELP

If you need assistance with your build, we’re here to help. Head on over to our Discord group and post your questions. This is our primary medium to help VORON Users and we have a great community that can help you out if you get stuck.



<https://discord.gg/voron>

REPORTING ISSUES

Should you find an issue in the documentation or have a suggestion for an improvement please consider opening an issue on GitHub (<https://github.com/VoronDesign/Voron-2/issues>). When raising an issue please include the relevant page numbers and a short description; annotated screenshots are also very welcome. We periodically update the manual based on the feedback we get.

THIS IS JUST A REFERENCE

This manual is designed to be a simple reference manual. Building a Voron can be a complex endeavour and for that reason we recommend downloading the CAD files off our Github repository if there are sections you need clarification on. It can sometimes be easier to follow along when you have the whole assembly in front of you.



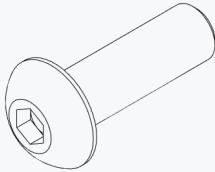
<https://github.com/vorondesign>



<https://docs.vorondesign.com/>

HARDWARE REFERENCE

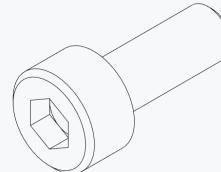
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BUTTON HEAD CAP SCREW (BHCS)

Metric fastener with a domed shape head and hex drive. Most commonly found in locations where M5 fasteners are used.

ISO 7380-1



SOCKET HEAD CAP SCREW (SHCS)

Metric fastener with a cylindrical head and hex drive. The most common fastener used on the Voron.

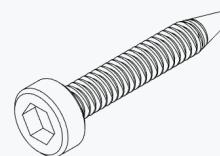
ISO 4762



FLAT HEAD COUNTERSUNK SCREW (FHCS)

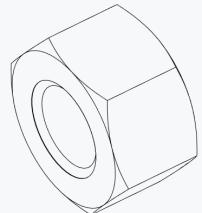
Metric fastener with a cone shaped head and a flat top.

ISO 10642



SELF TAPPING SCREW

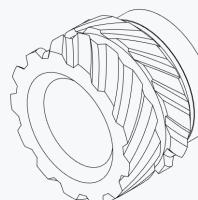
Fastener with a pronounced thread profile that is screwed directly into plastic.



HEX NUT

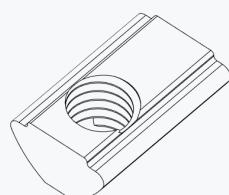
Hex nuts couple with bolts to create a tight, secure joint. You'll see these used in both M3 and M5 variants throughout this guide.

ISO 4032



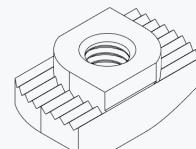
HEAT SET INSERT

Heat inserts with a soldering tip 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.



POST INSTALL T-SLOT NUT (T-NUT)

Nut that can be inserted into the slot of an aluminium profile. Used in both M3 and M5 variants throughout this guide. Often also called "roll-in t-nut".

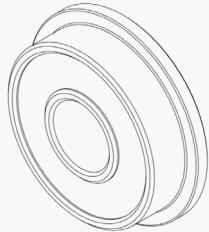


HAMMERHEAD NUT

Nut that can be inserted into the slot of an aluminium profile. Used exclusively for panel mounting, all other components use T-Slot nuts.

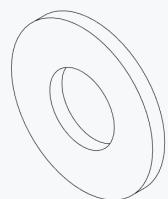
HARDWARE REFERENCE

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F695 BEARING

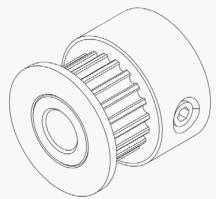
A ball bearing with a flange used in various gantry locations.



SHIM

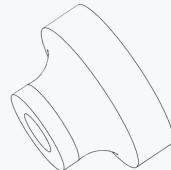
Not to be confused with stamped washers. These are used in all M5 call-out locations in this manual.

DIN 988



PULLEY

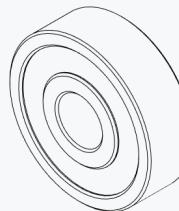
GT2 pulley used on the motion system of the Voron.



THUMB NUT

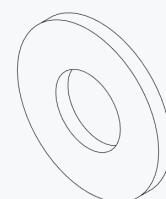
Used in the print bed as a spacer.

DIN 466-B



625 BEARING

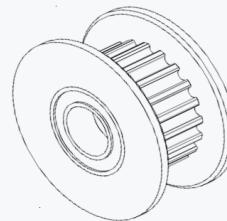
A ball bearing used on the Voron Z drives.



WASHER

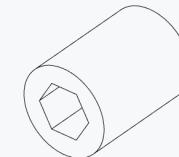
Usually stamped from sheet metal this type of spacer is not as consistent in thickness as the shims are. Only used in M3 size.

DIN 125



IDLER

GT2 idler used in the motion system of the Voron.



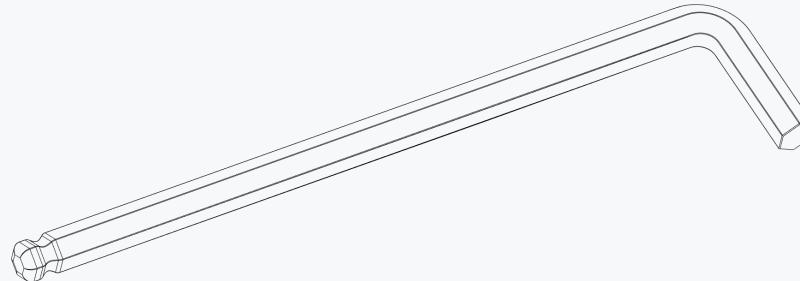
SET SCREW

Small headless screw with an internal drive. Used in pulleys and other gears. Also called a grub screw.

ISO 4026

BALL-END DRIVER

Some parts of this design require the use of a ball-end hex driver for assembly. We recommend you get a 2.0mm, 2.5mm and 3mm one.



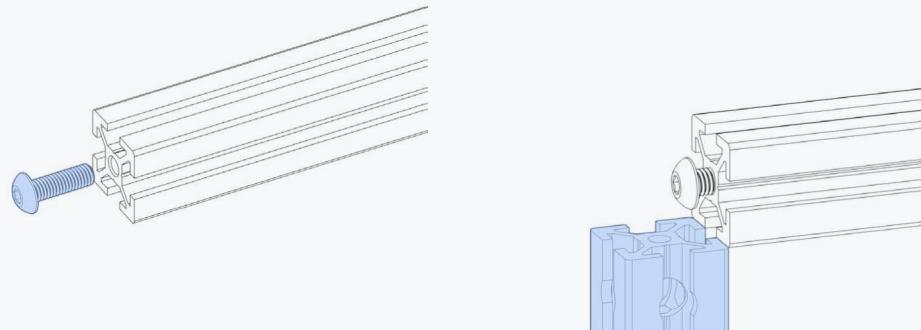
2.5MM HEX DRIVER

The 2.5mm hex driver will see a lot of use in this build. A quality driver is strongly recommended. Refer to the sourcing guide for suggestions.



ADDITIONAL TOOLS

We provide additional tool recommendations in our sourcing guide. Visit https://vorondesign.com/sourcing_guide and switch to the "Voron Tools" tab at the bottom of the page.



BLIND JOINT BASICS

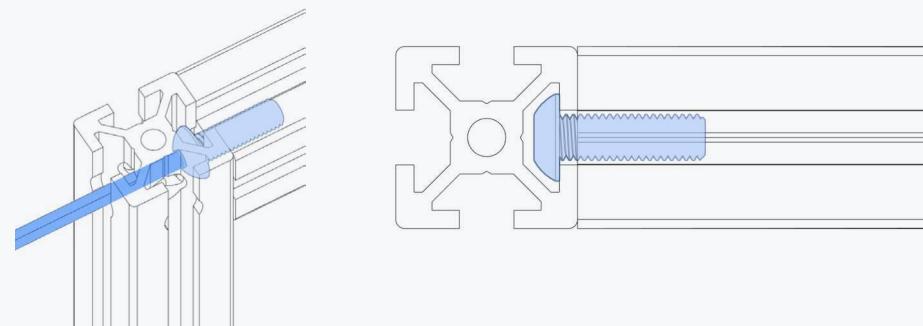
Blind Joints provide a cost effective and rigid assembly method.

The head of the BHCS is slid into the channel of another extrusion and securely fastened through a small access hole in the extrusion.

If you've never assembled one before we recommend you watch the linked guide.



<https://voron.link/onjwmcd>

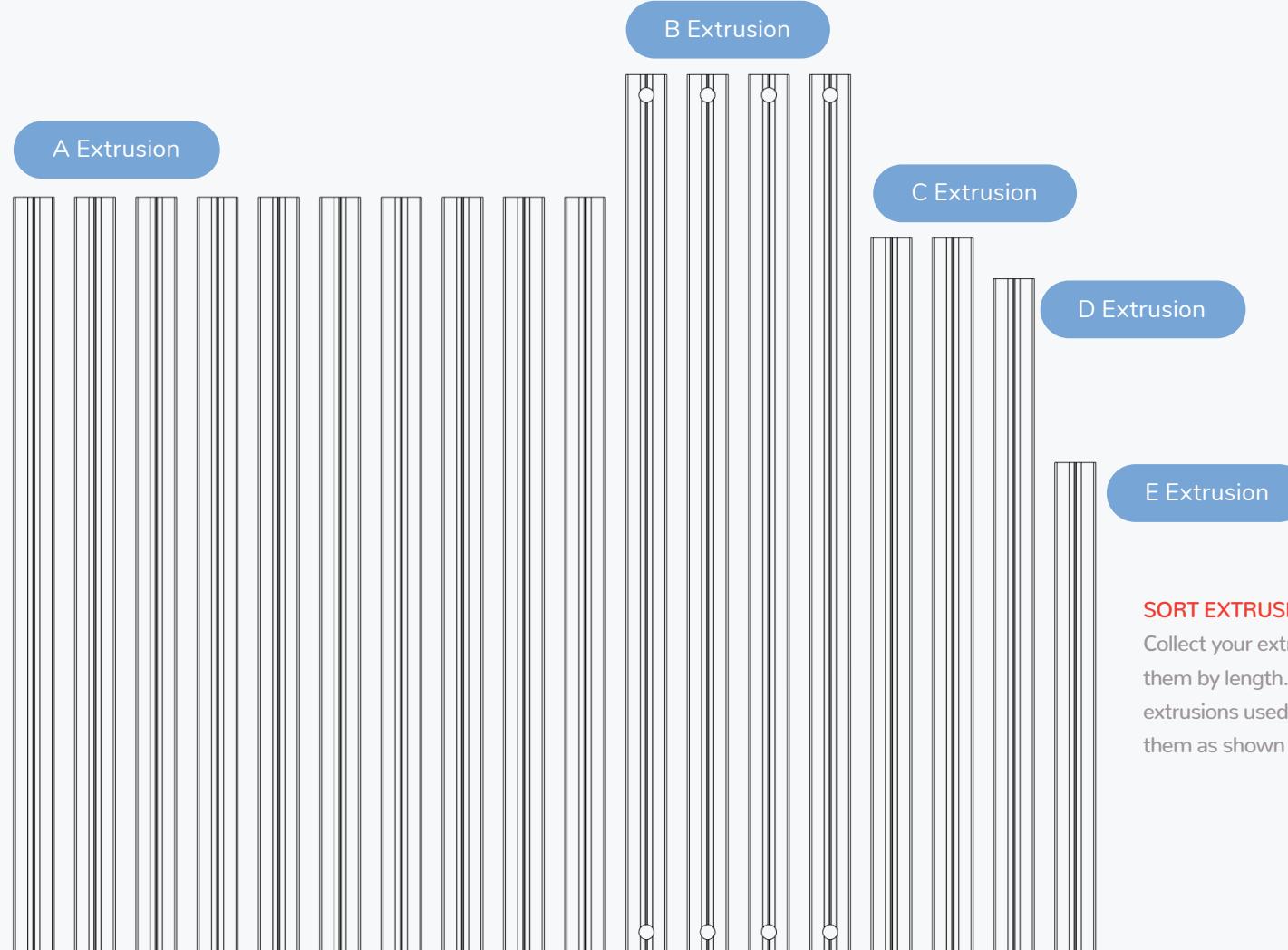


The first Voron printer was released to the public on March 10 2016.

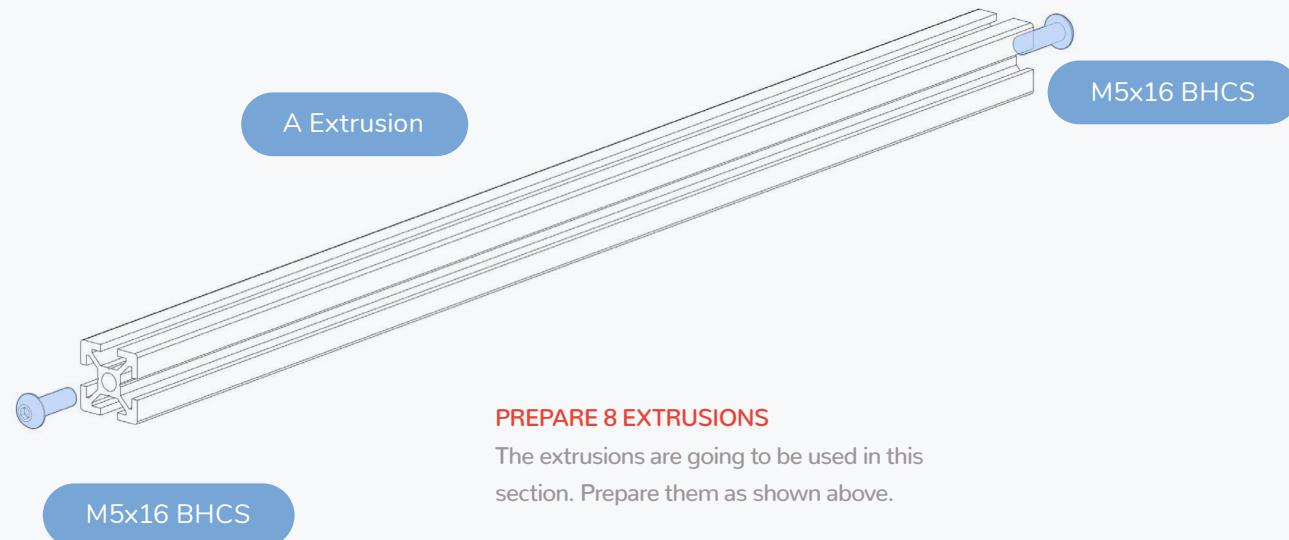
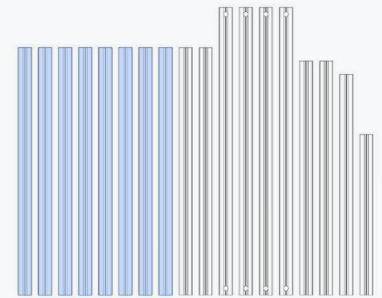
FRAME

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**SORT EXTRUSIONS**

Collect your extrusions and sort them by length. We will highlight the extrusions used in each step and label them as shown on this page.



FRAME

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FRAME ASSEMBLY

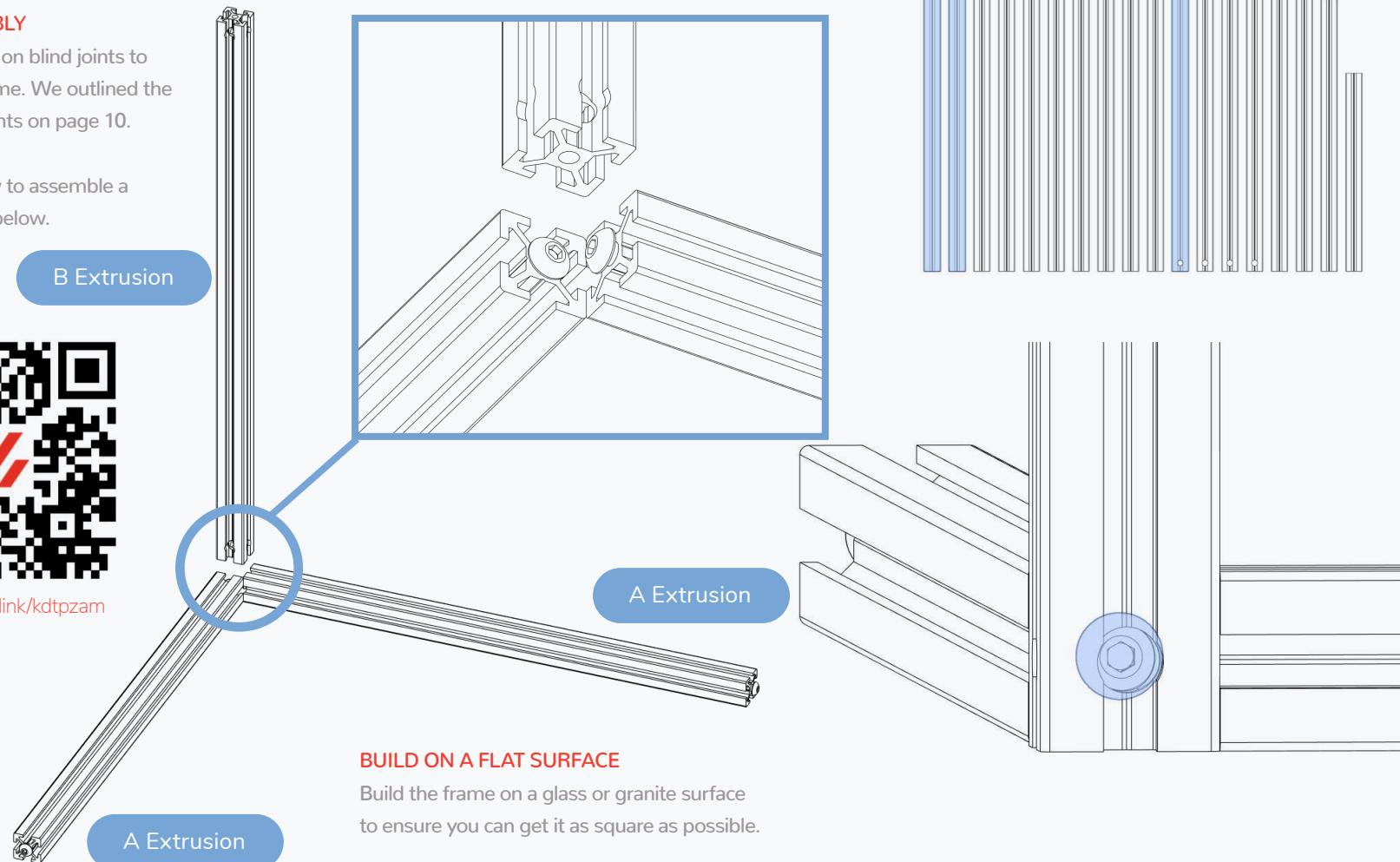
This design relies on blind joints to assemble the frame. We outlined the basics of blind joints on page 10.

More tips on how to assemble a frame are linked below.

B Extrusion



<https://voron.link/kdtpzam>

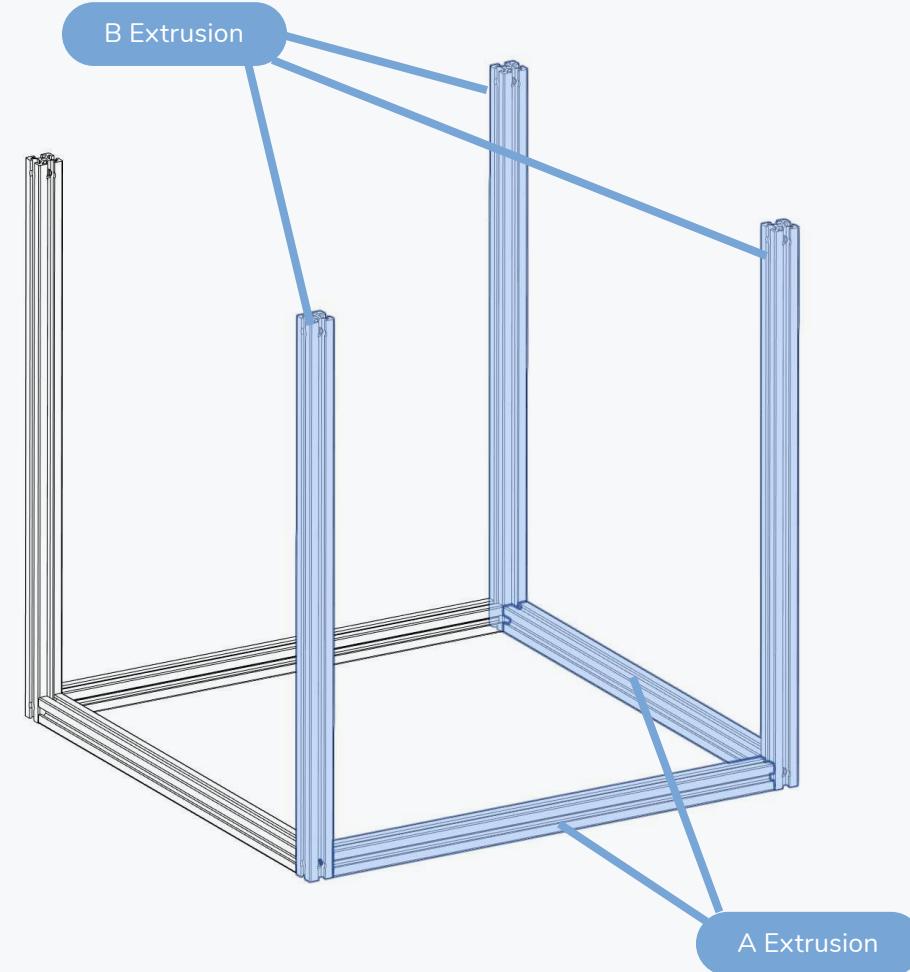
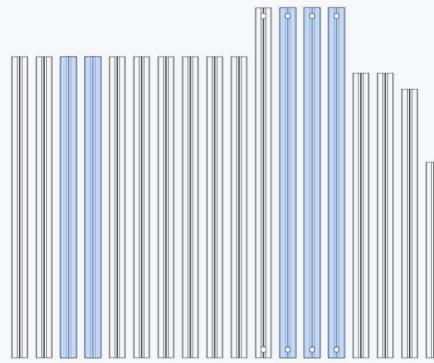


BUILD ON A FLAT SURFACE

Build the frame on a glass or granite surface to ensure you can get it as square as possible.

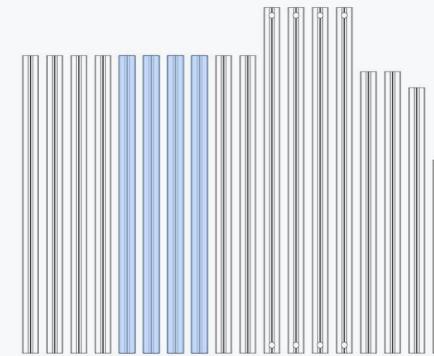
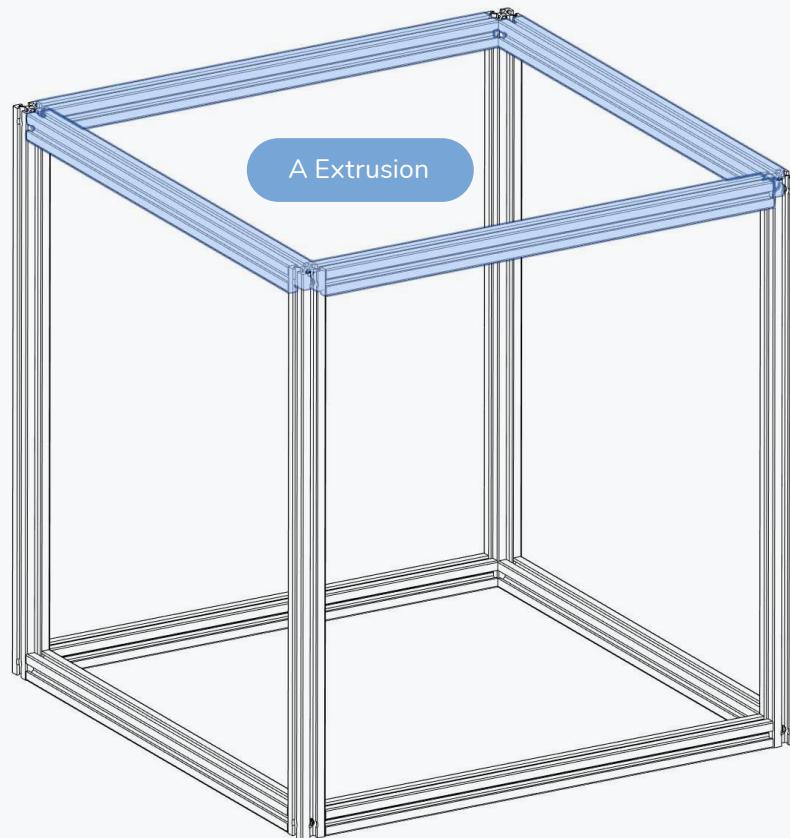
FRAME

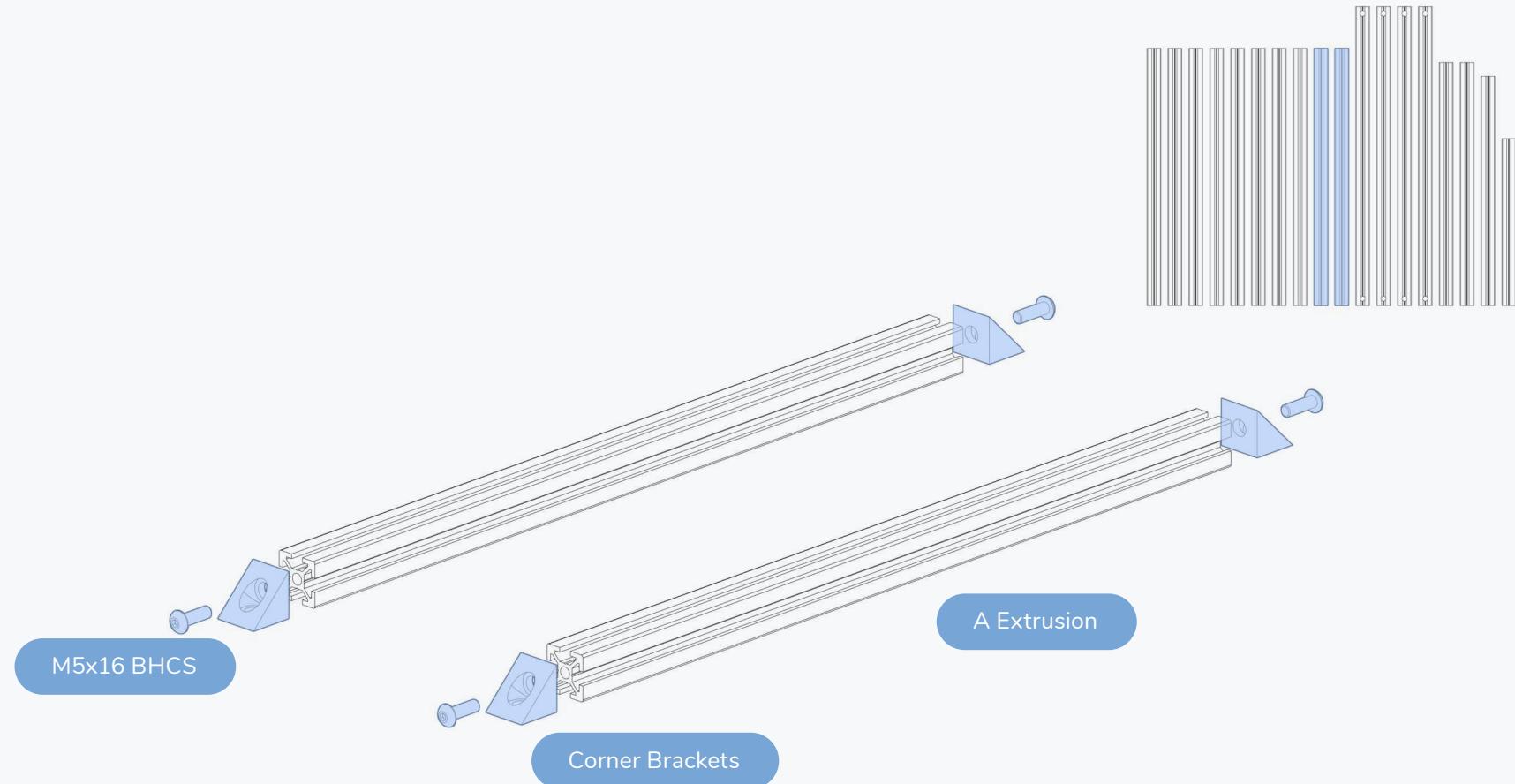
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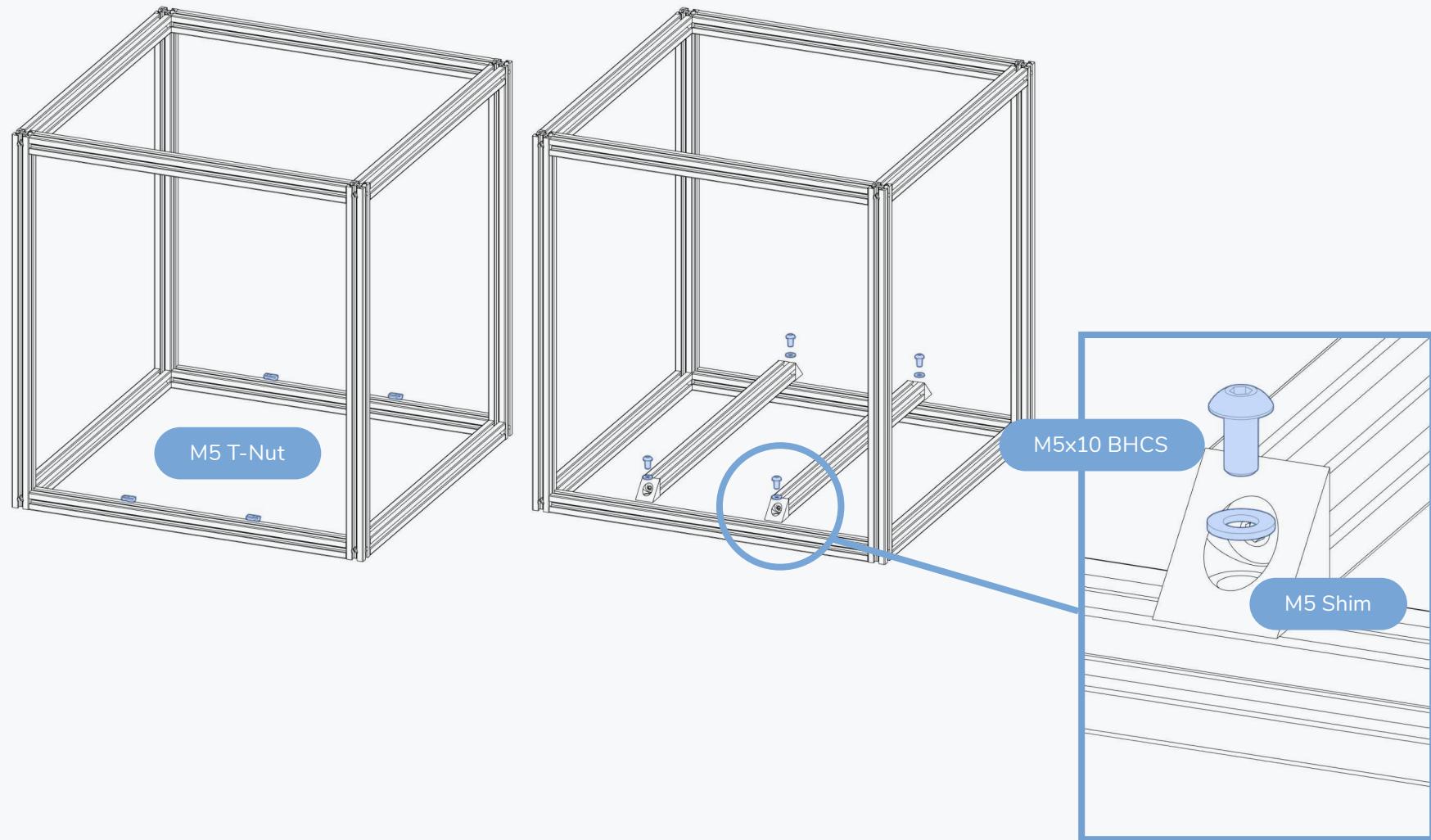


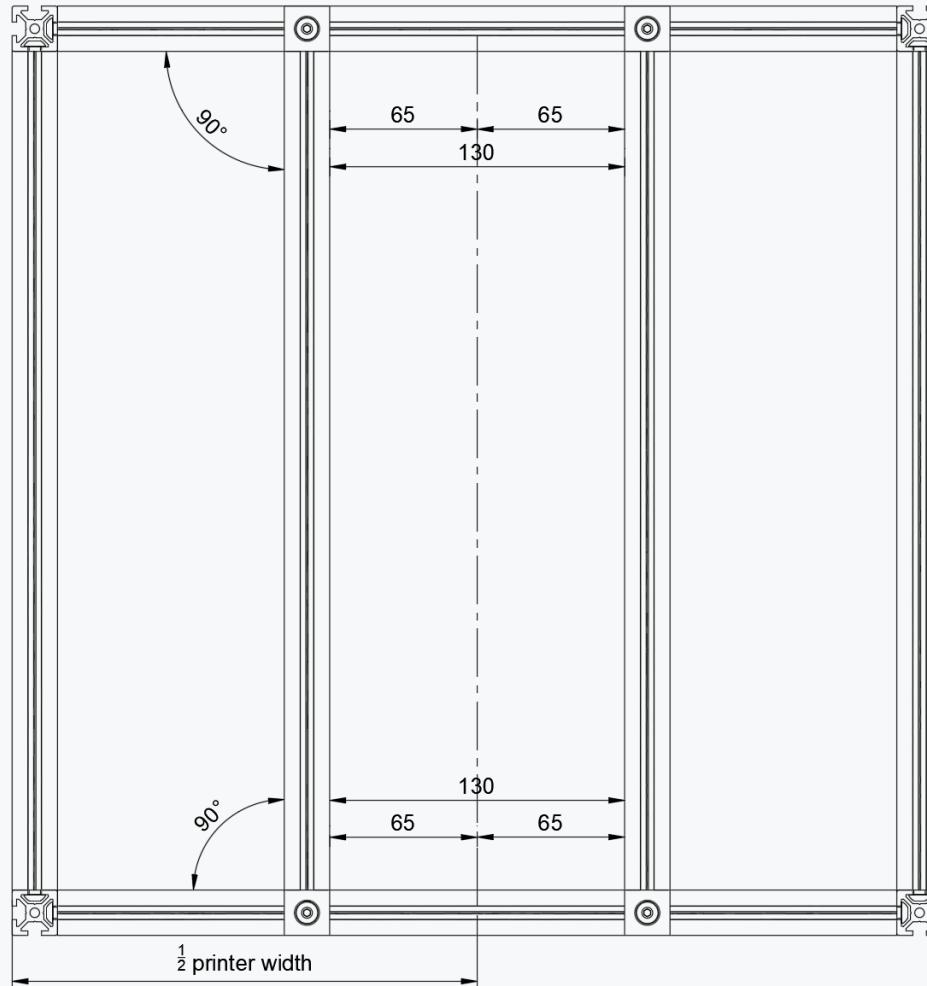
FRAME

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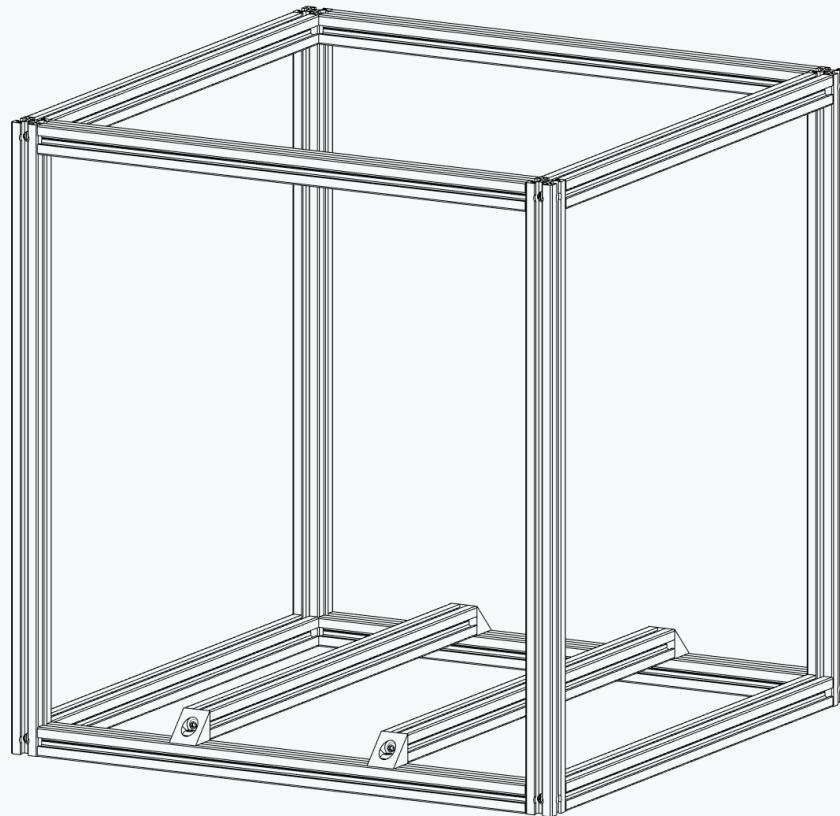
POSITION BED EXTRUSIONS

Find the centreline of the printer and position the bed extrusions as shown in the diagram to the left. The distance between the extrusions is 130mm centred on the centreline of the printer.

1/2 printer width for standard sizes:
250 spec 205mm
300 spec 230mm
350 spec 255mm

ALL UNITS ARE METRIC

If a unit is not specified assume it's metric.
All distances are called out in millimeters.

**CHECK FOR SQUARENESS**

Verify the angle of all corners and the overall squareness by measuring the diagonals. Refer to the second half of the linked video for additional information.

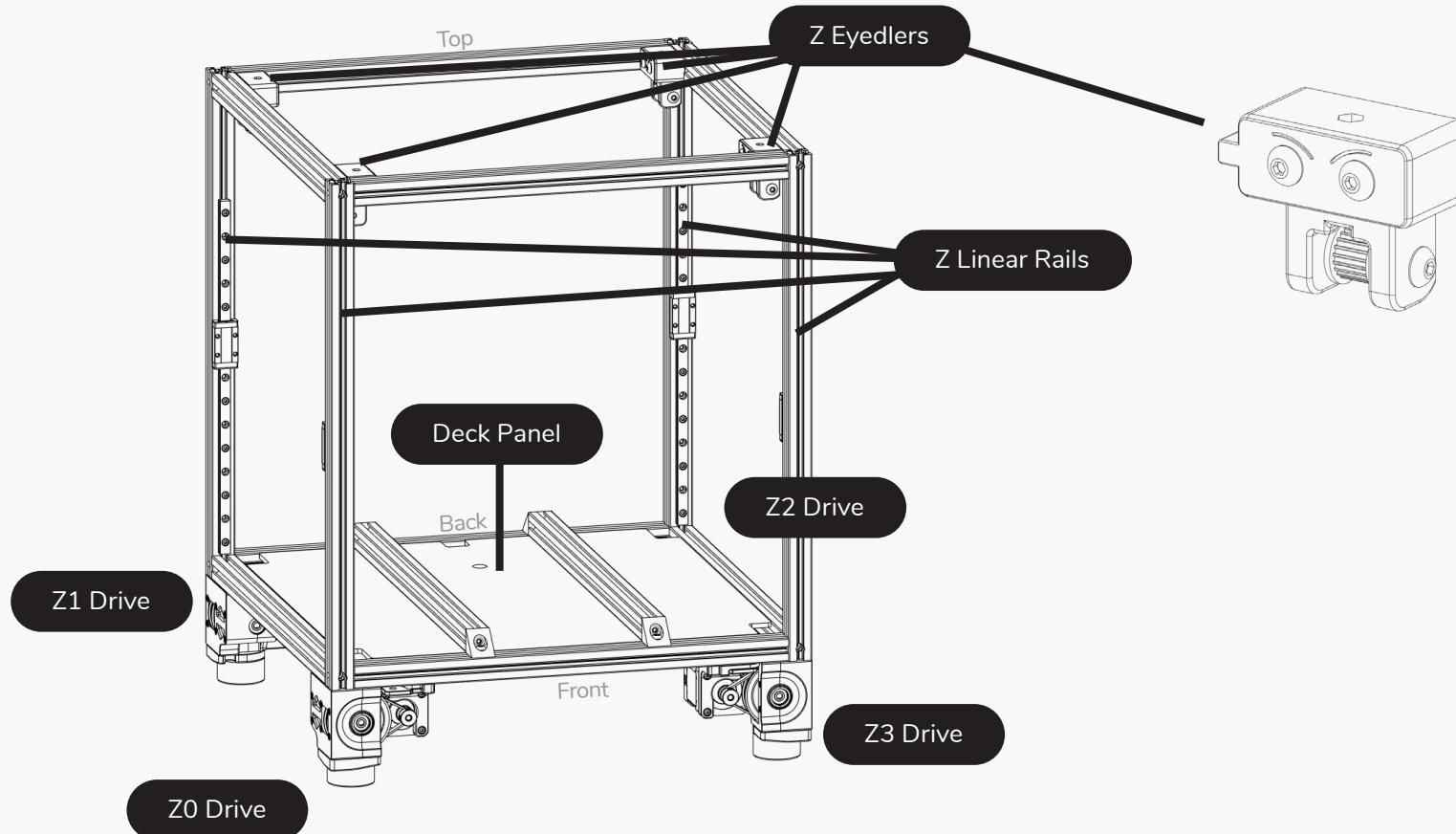


<https://voron.link/kdtpzam>

Z DRIVES

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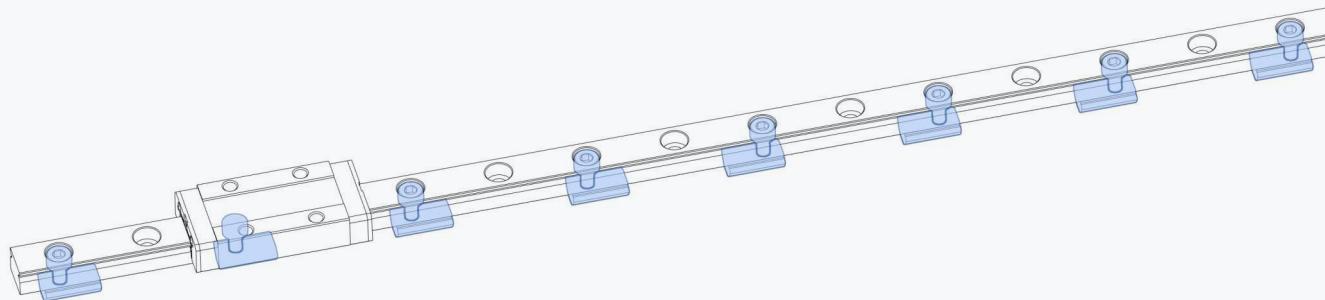
OVERVIEW

Individual chapters start with an overview of the components that will be built/added to the printer in the chapter.

HANDLE WITH CARE

The carriage can slide off the rail if not handled properly. Dropping the carriage will likely damage it.

Any marks, dents or nicks might cause the linear rail to misbehave in operation.



LINEAR RAILS - PREPARATION AND MOUNTING

Most linear rails arrive with shipping oil. To ensure a smooth gliding motion and long service life, this oil needs to be removed and its rail carriage greased. See the Voron sourcing guide for a recommended list of lubricants. We attached a link to a video guide to get you started.

We opted to skip every other mounting hole in the linear rail when designing the mounting pattern for this printer. This cuts down on mounting hardware and still meets the requirements for our use case.

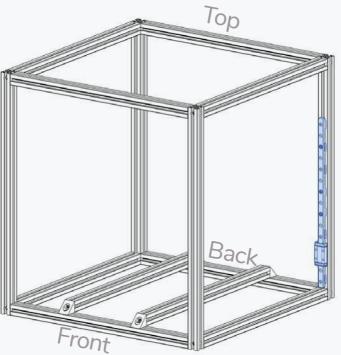
When tightening the bolts tighten them from the center outward to ensure that the rail sits flush on the extrusion.



<https://voron.link/aguOnes>

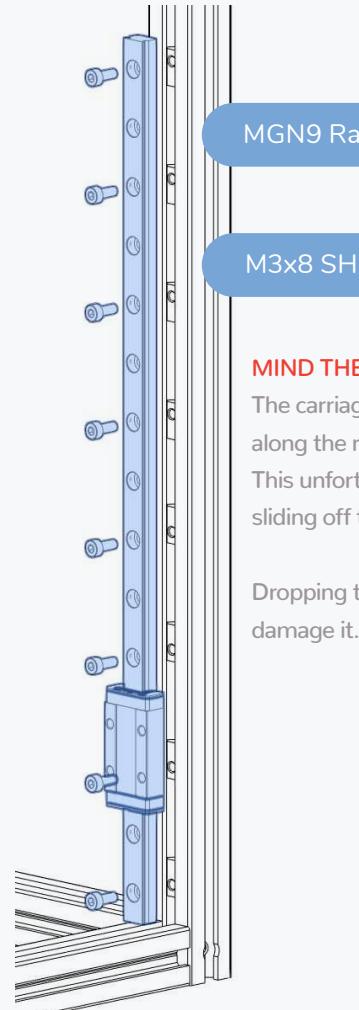
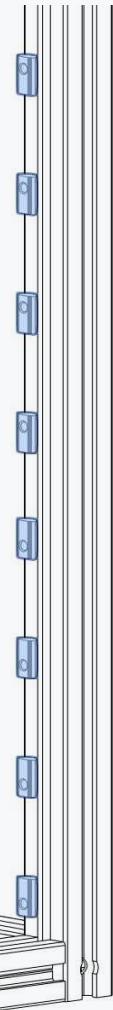
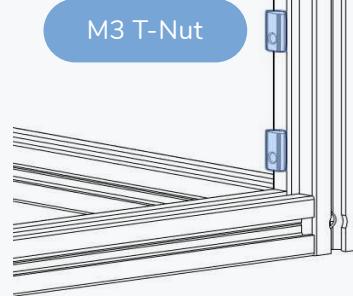
Z RAILS

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WHY IS THIS HERE?

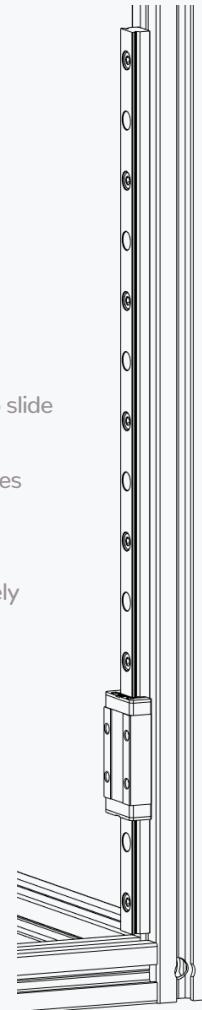
As you likely skipped over the advice to flip through the entire manual we added graphics like these to assist you with the orientation of the part before you actually put them on the printer.



MIND THE CARRIAGE

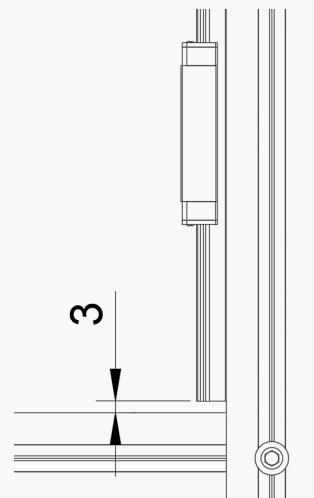
The carriages are designed to slide along the rail easily. This unfortunately also includes sliding off the rails.

Dropping the carriage will likely damage it.



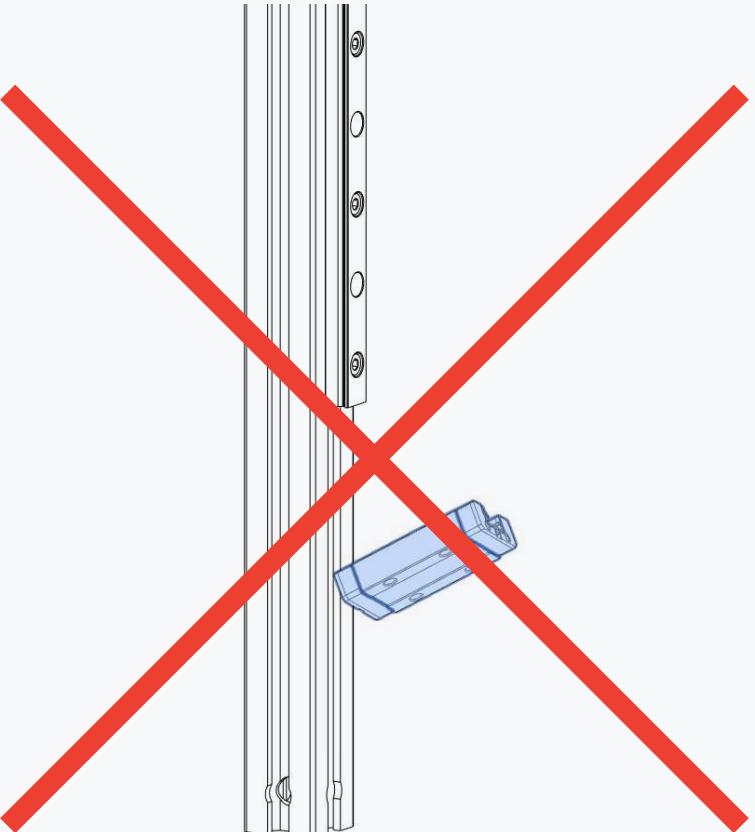
CENTRED RAIL INSTALLATION GUIDE

Use the MGN9 guides to position the rail in the center of the extrusion prior to fastening the screws.



BOTTOM GAP

Leave a gap between the printer frame and the rail. ~3mm is fine.



RAIL SAFETY

As we will turn the printer upside down during further assembly make sure to fix each carriage in position with a piece of sticky tape.

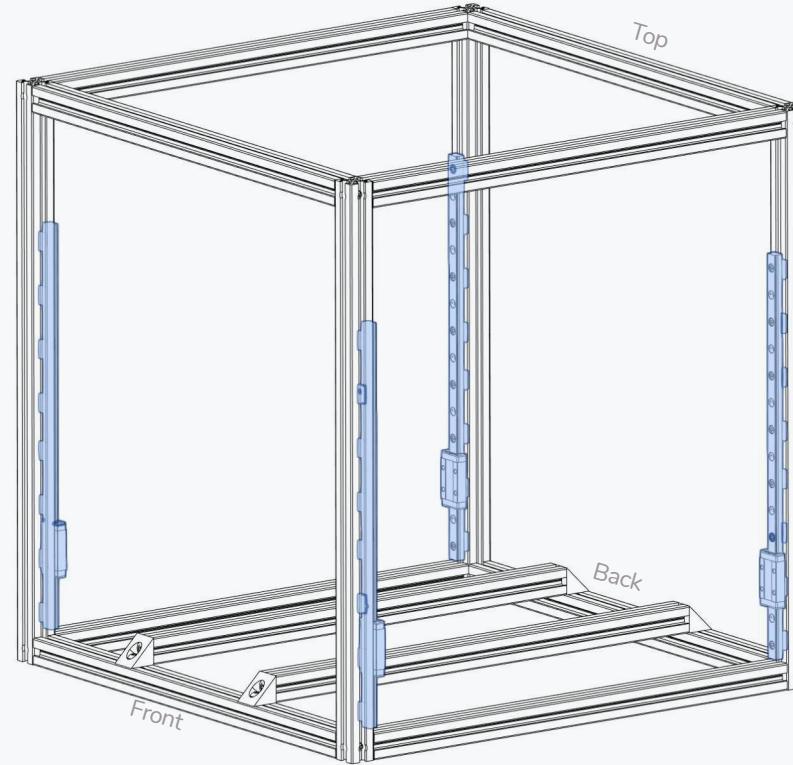
If your rails were delivered with plastic stoppers you can also temporarily reinstall them to prevent carriages from falling off their rails and spilling their bearing balls..

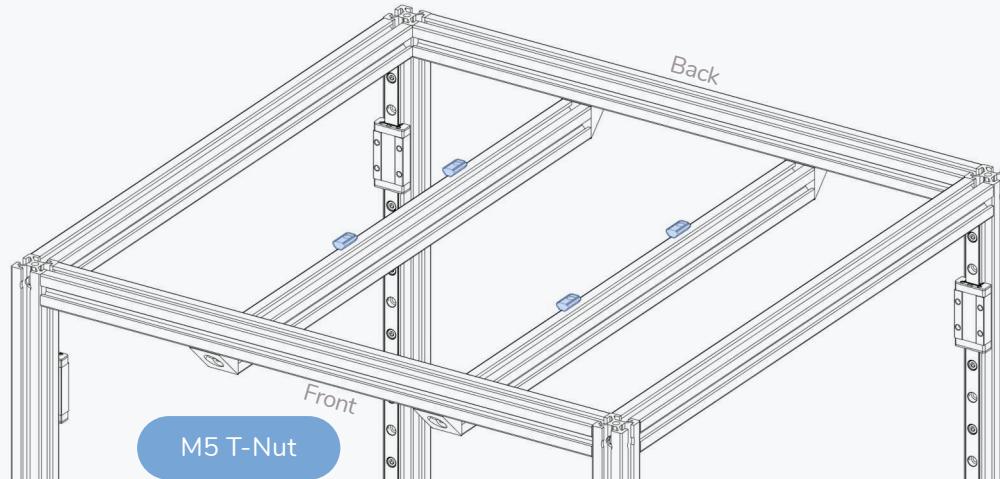
For illustration purposes only. Do not attempt to replicate.

INSTALL REMAINING Z RAILS

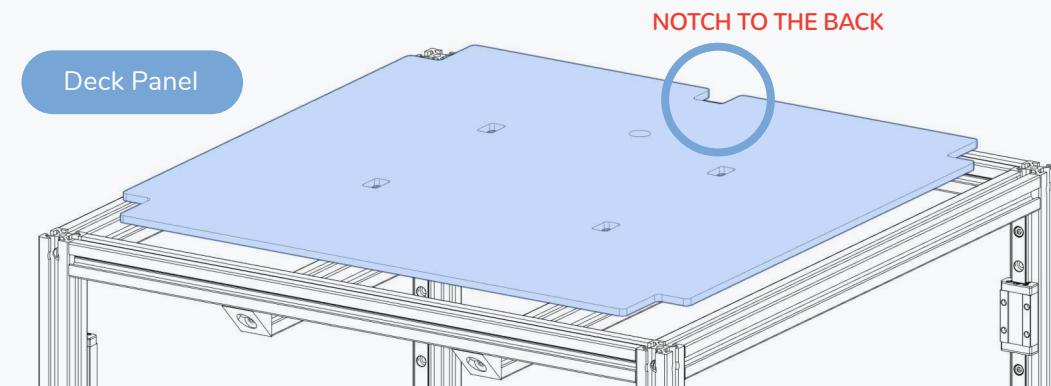
Add the remaining Z rails following the same instructions.

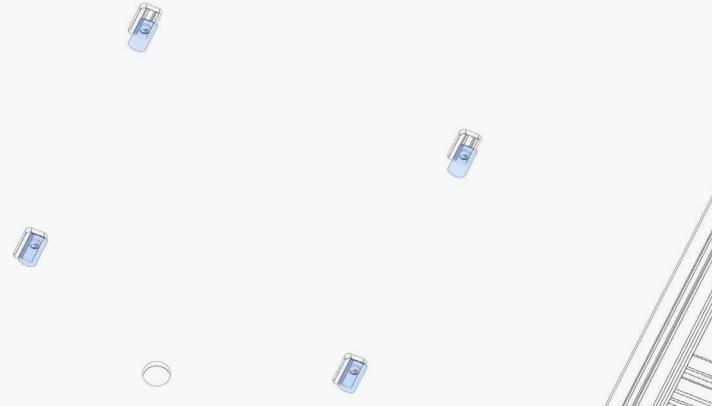
Make sure the rails face each other as shown in the graphic.



**FLIP PRINTER UPSIDE DOWN**

It's easier working with gravity than against it. But make sure the rail carriages are secure before doing so.

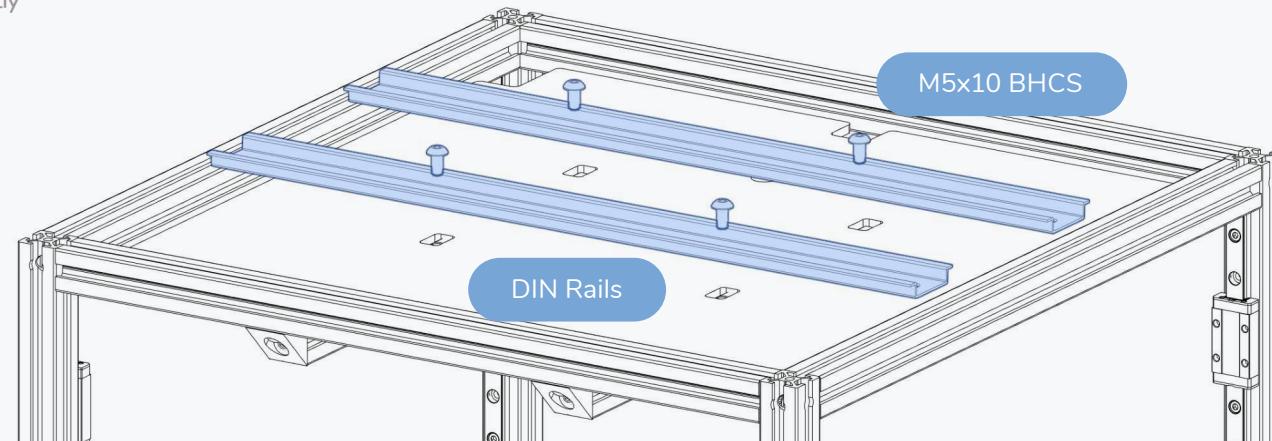


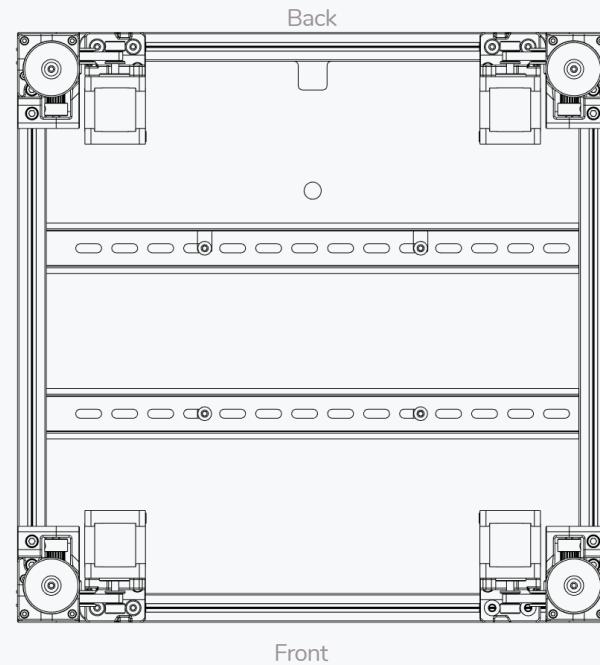
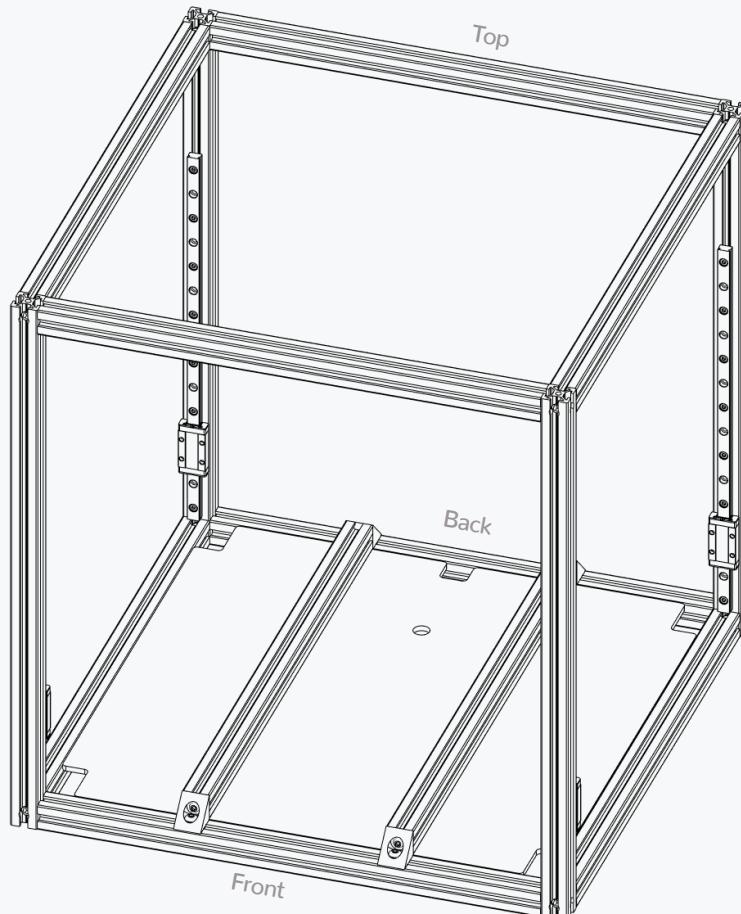
**ALIGN T-NUTS WITH HOLES**

Position the 4 T-nuts so they are directly below the 4 holes in the deck panel.

DIN RAIL SLOTS

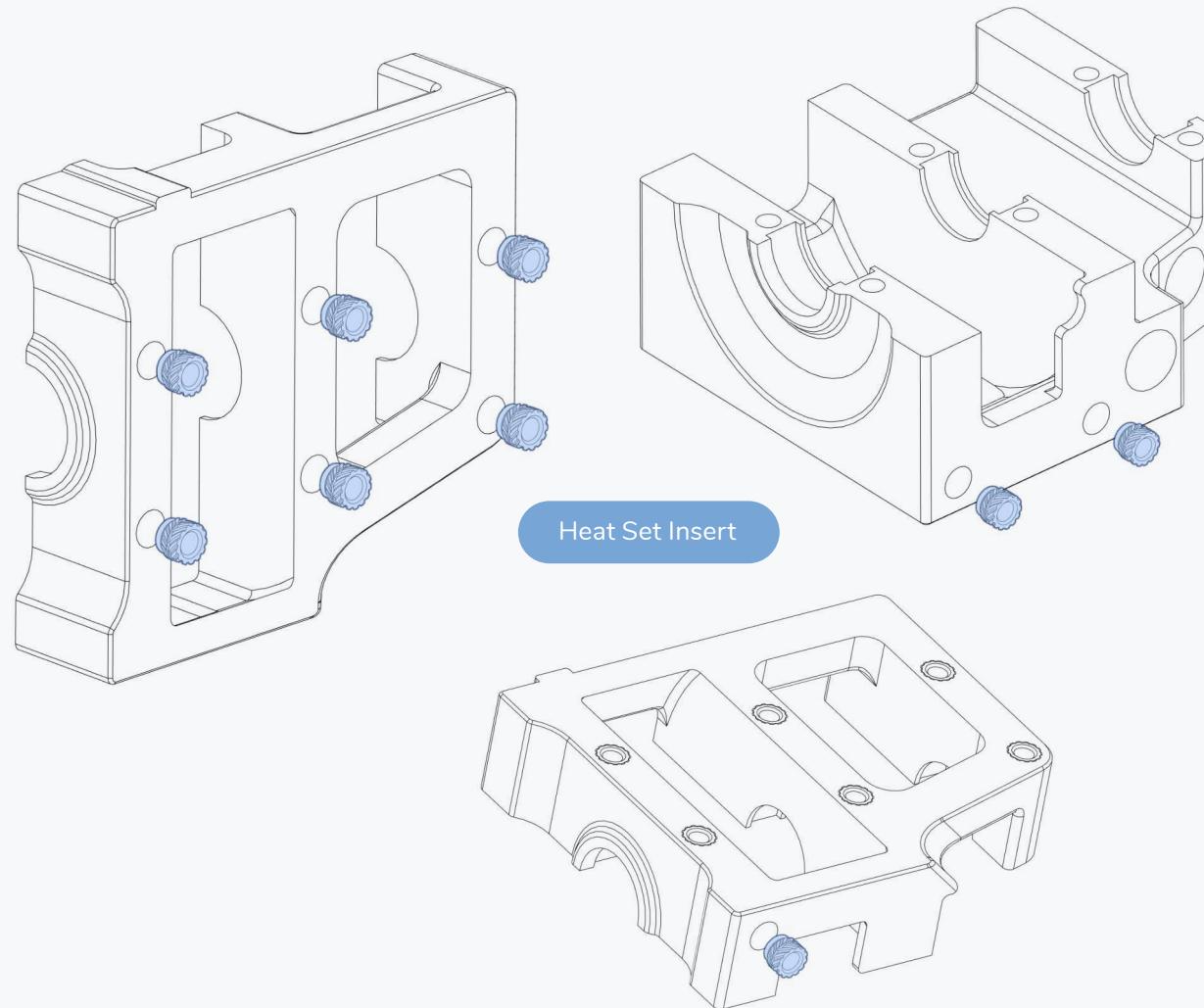
If the slots in the rails do not line up with the t-nut you can shorten the DIN rails by a few mm.





PRINTER ORIENTATION

We regularly insert graphics like the ones above to help you along the build process. The sides are labeled to make it easier to keep track.



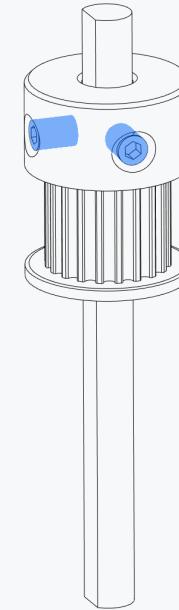
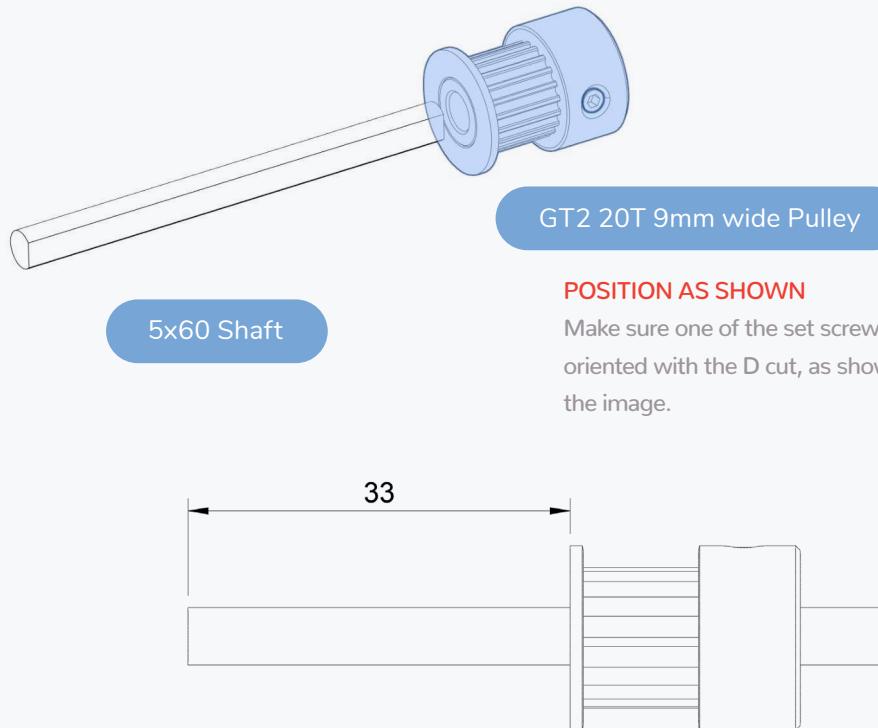
HEAT SET INSERTS

This design relies heavily on heat set inserts. Make sure you have the proper inserts (check the hardware reference for a close up picture and the BOM for dimensions).

If you've never worked with heat set inserts before we recommend you watch the linked guide.



<https://voron.link/m5ybt4d>



SET SCREWS

AKA THE ROOT OF ALL ISSUES

Insert both set screws and use thread locker on all set screws.

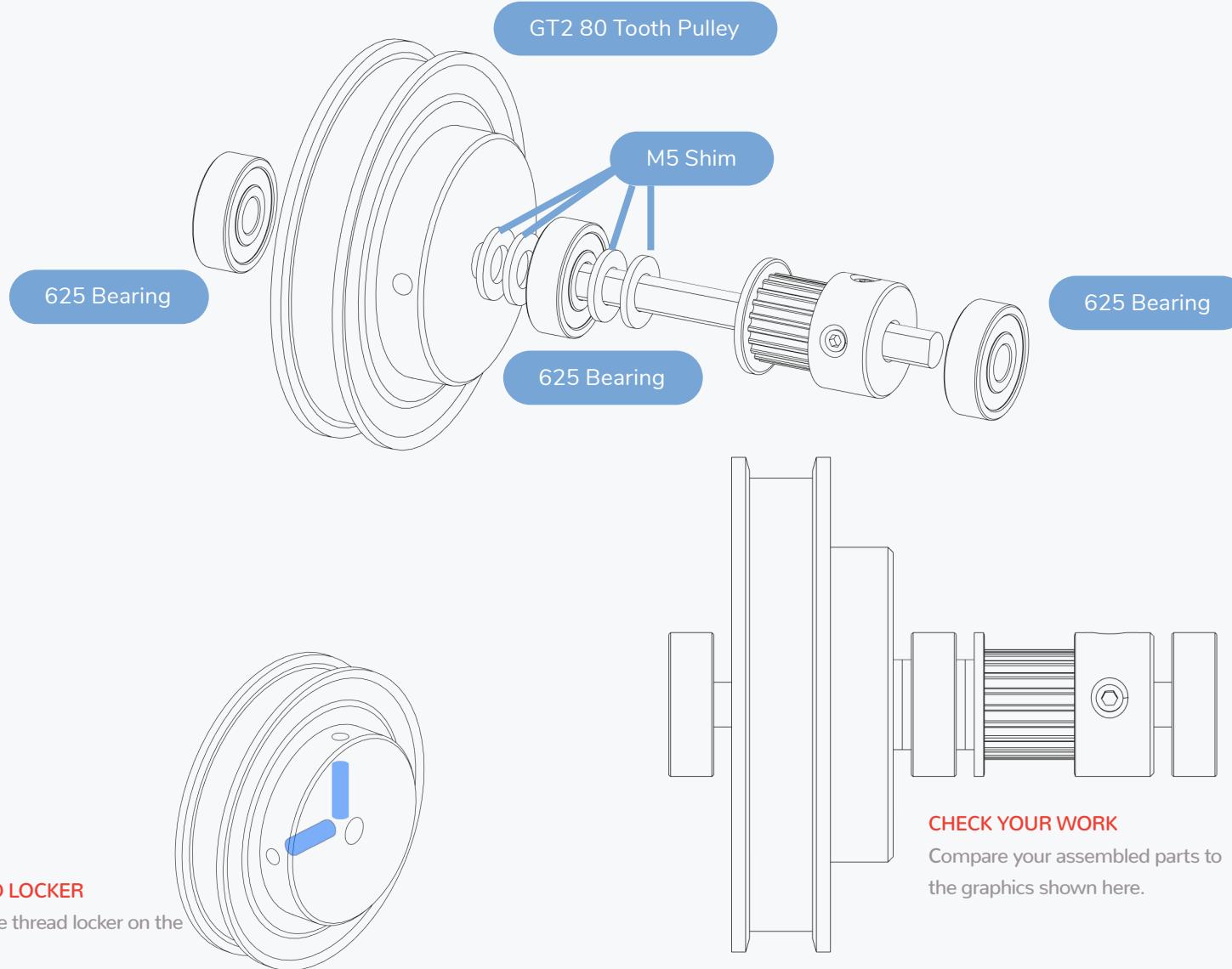
Use a high quality hex driver to prevent the hex profile from stripping. Ball-end drivers are not recommended.

Loose set screws account for the majority of issues that our users report. Save yourself hours of troubleshooting and apply thread locker to all set screws during the build.

See the product's application notes for instructions - keep away from printed parts.

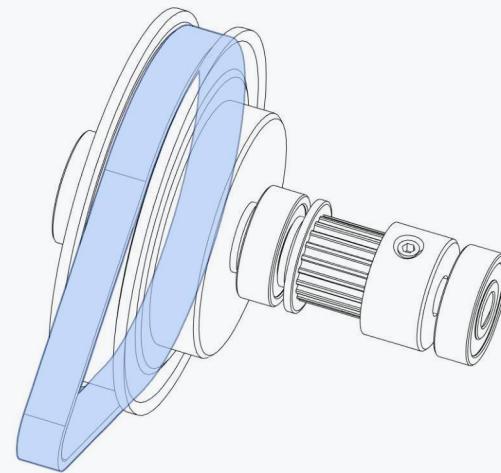
BELT DRIVE ASSEMBLY

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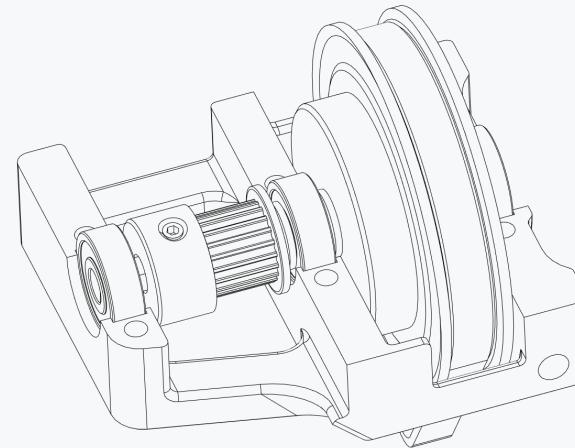
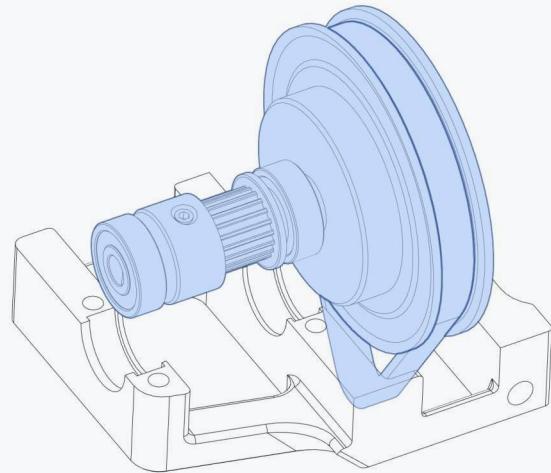


Z DRIVE

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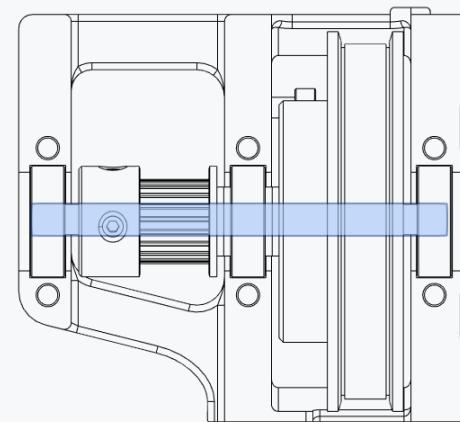


GT2 188mm Belt Loop



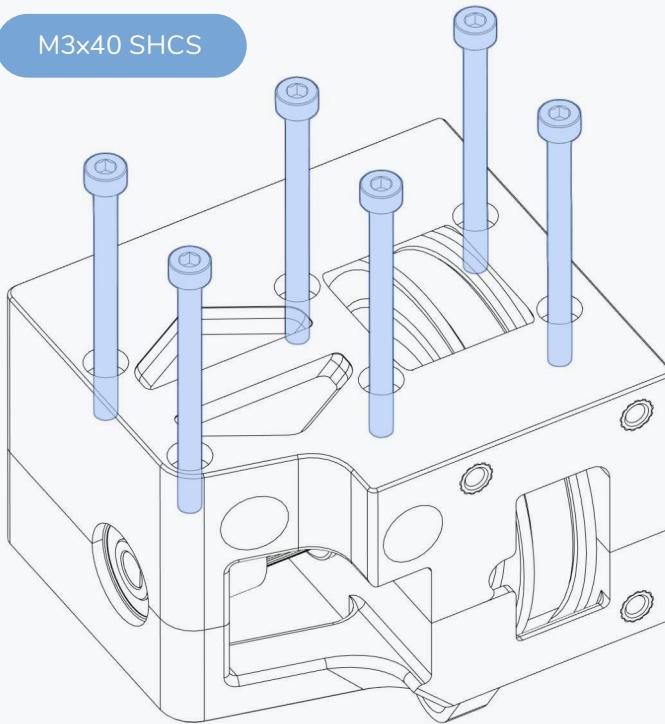
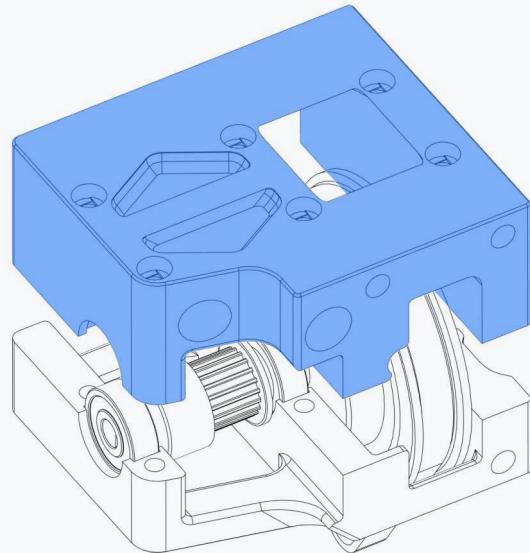
CHECK SHAFT POSITION

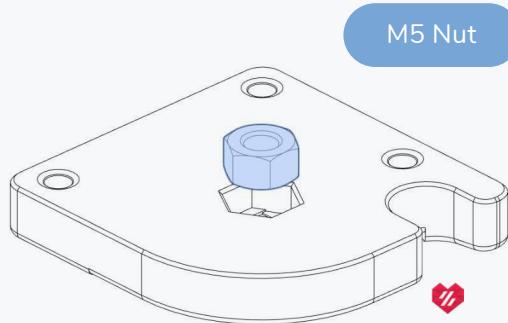
Compare your assembled parts to
the graphics shown here.



Z DRIVE

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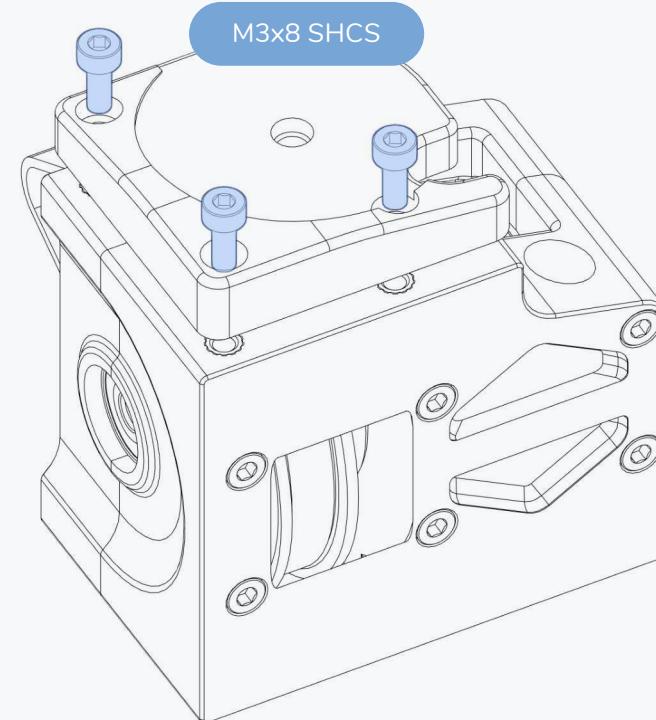




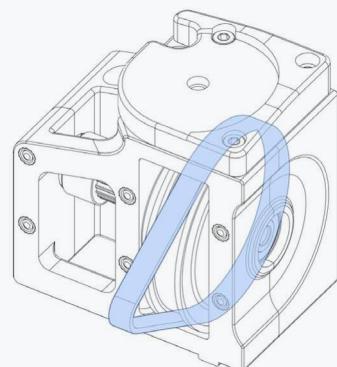
M5 Nut

ACCENT PART?

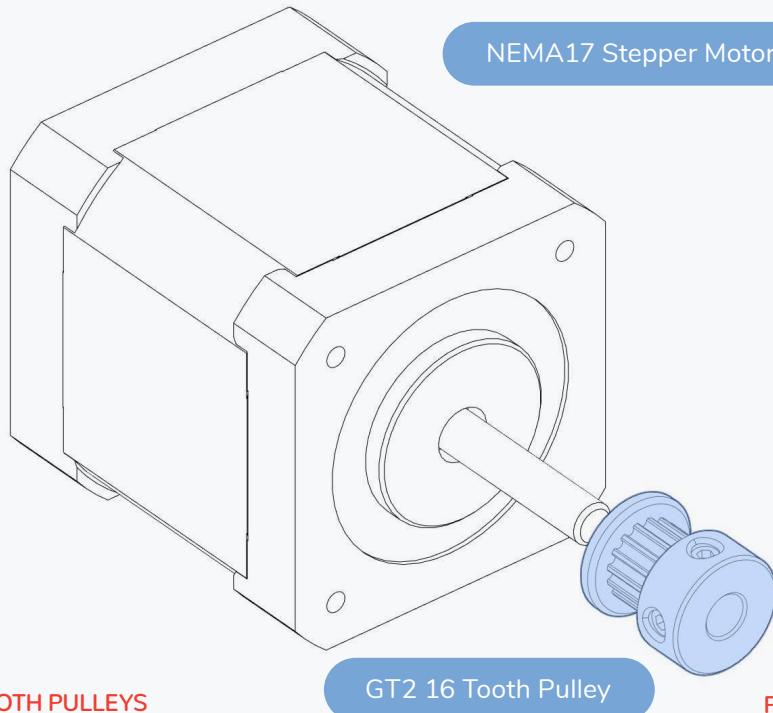
Look for Voron heart next to the part.
It indicates that this is an accent part.



M3x8 SHCS

**CHECK FOR BELT**

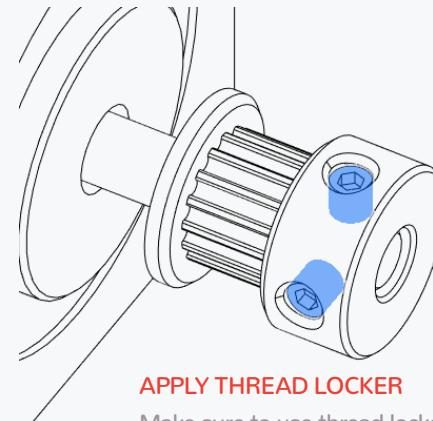
Make sure the closed belt loop is in
the part.



16 TOOTH PULLEYS

The Z drive motors are the only place in the printer that use 16 tooth pulleys!

Remove the pulleys from your work surface after you finish this chapter.

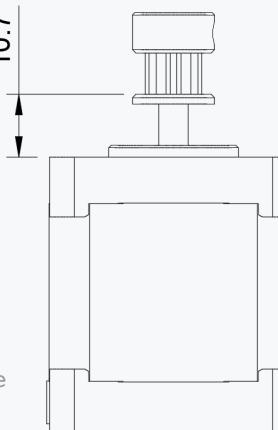


APPLY THREAD LOCKER

Make sure to use thread locker on the set screws.

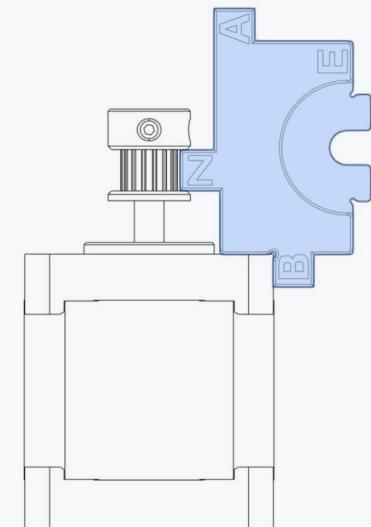


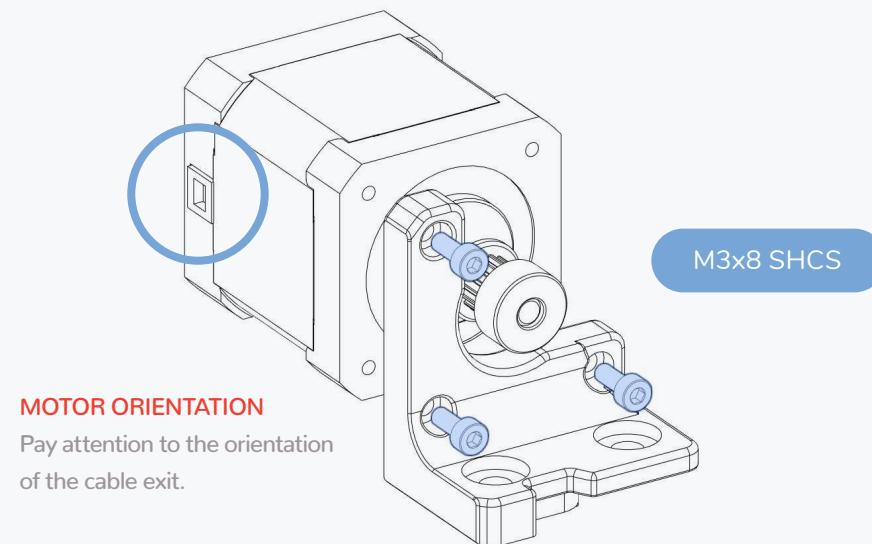
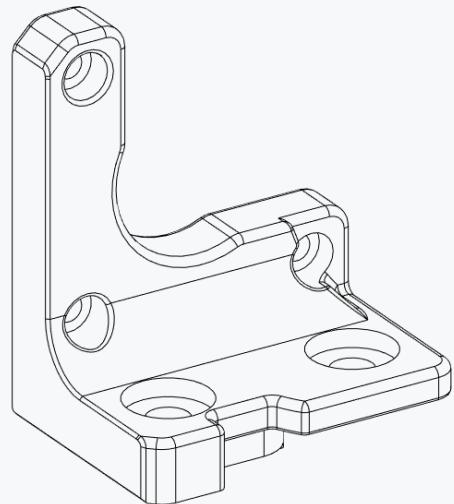
<https://voron.link/fx10m8e>



PULLEY POSITION

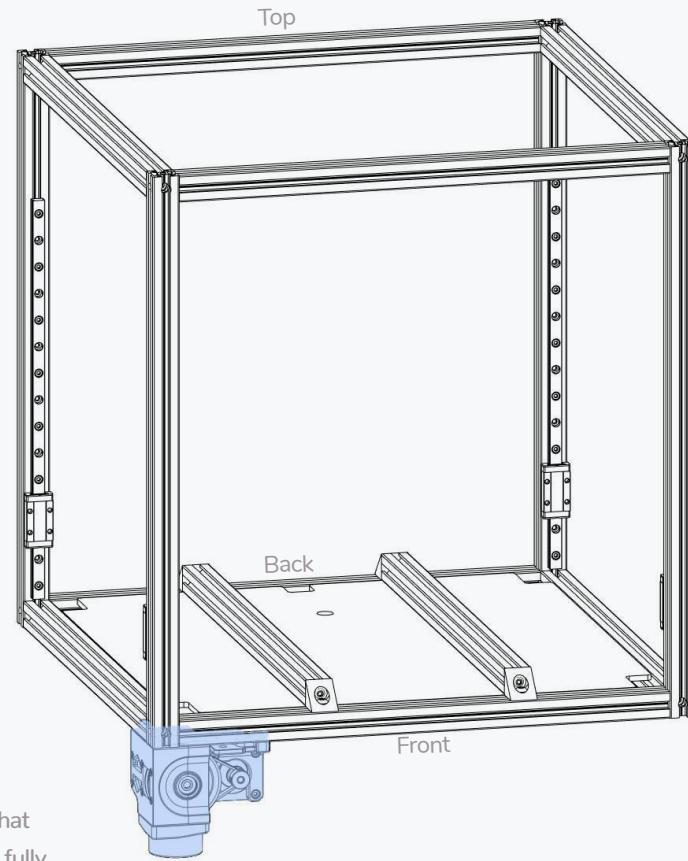
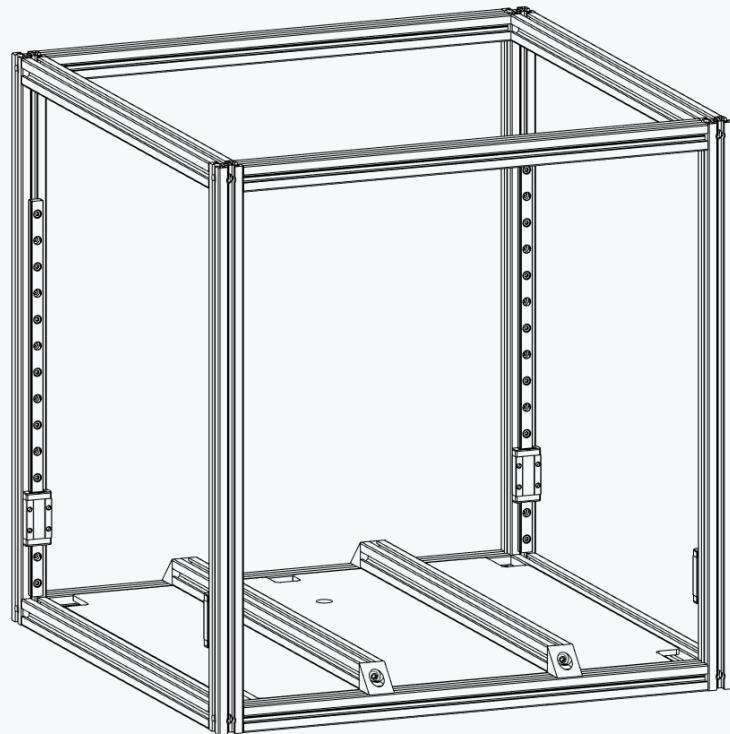
Depending on your motors, you may find that the pulley sits better in the opposite orientation. The important thing is the placement of the actual teeth.



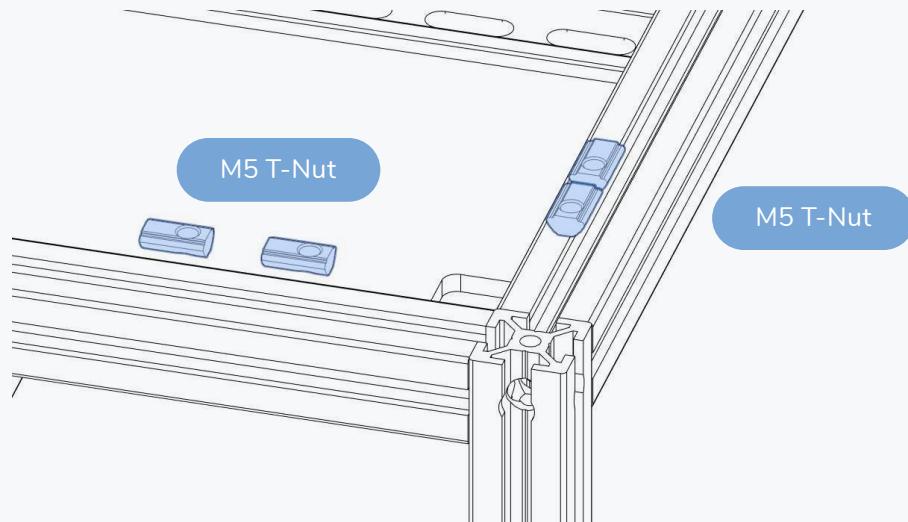


MOTOR ORIENTATION

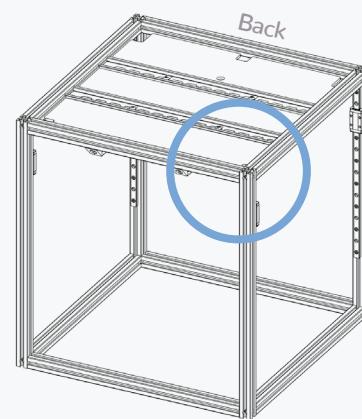
Pay attention to the orientation
of the cable exit.

**PICTURE FOR ORIENTATION**

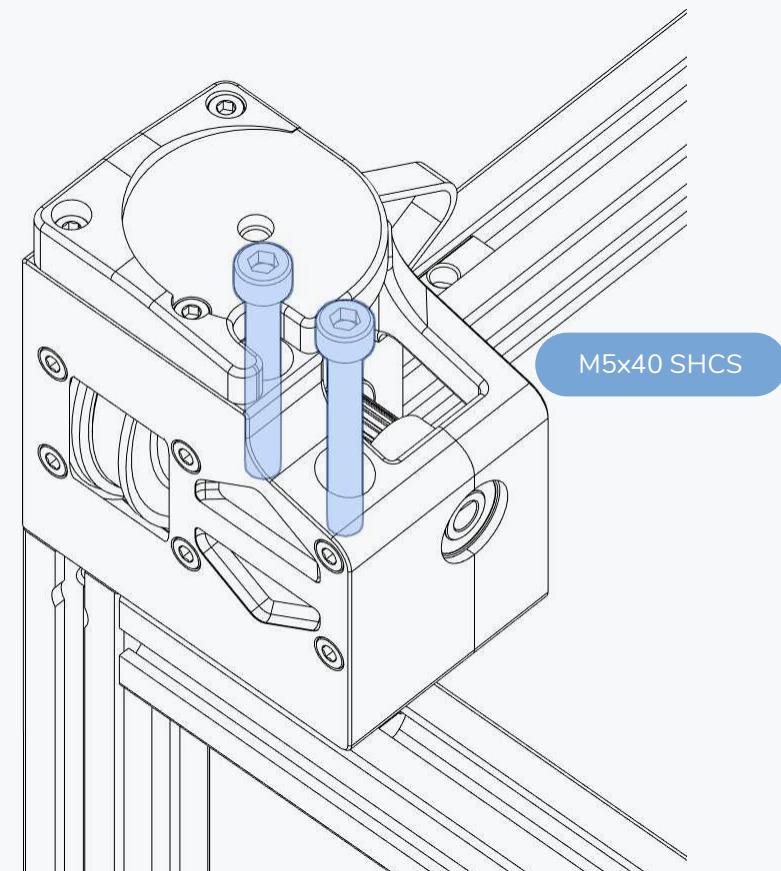
The Z0 drive is the first Z drive that will be added to the printer. The fully assembled Z Drive is highlighted in blue.

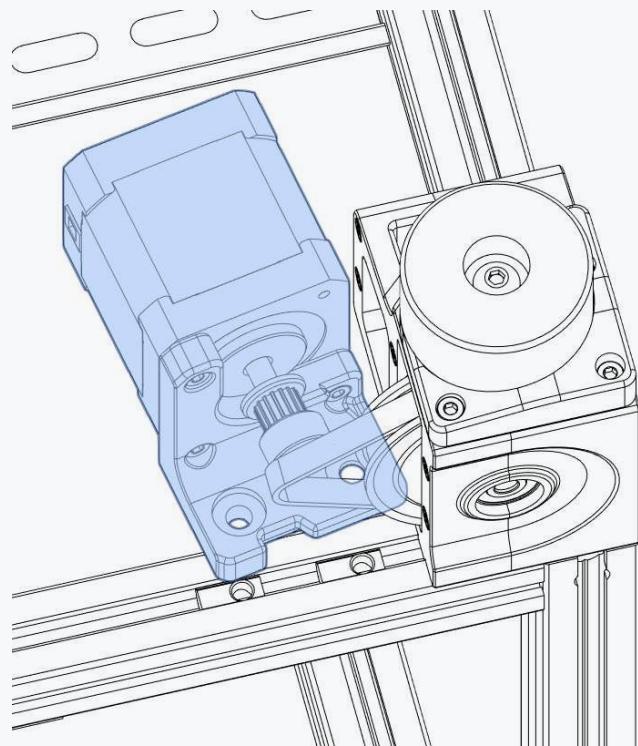
**WHICH CORNER IS THIS?**

We highlighted the corner with a circle.

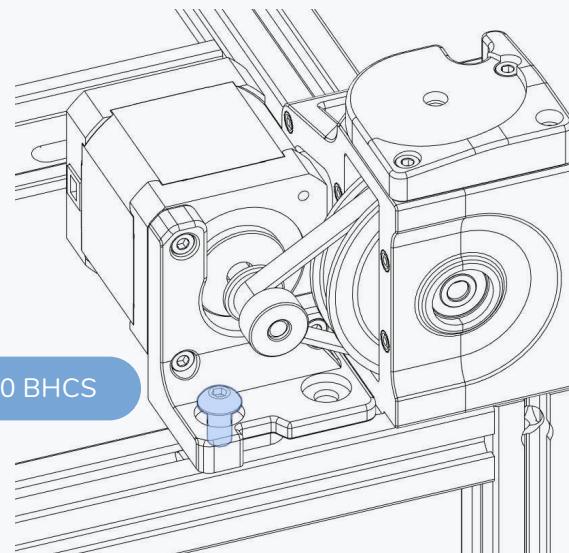
**UPSIDE DOWN ASSEMBLY**

For ease of assembly we recommend flipping the printer on its head for the next steps.

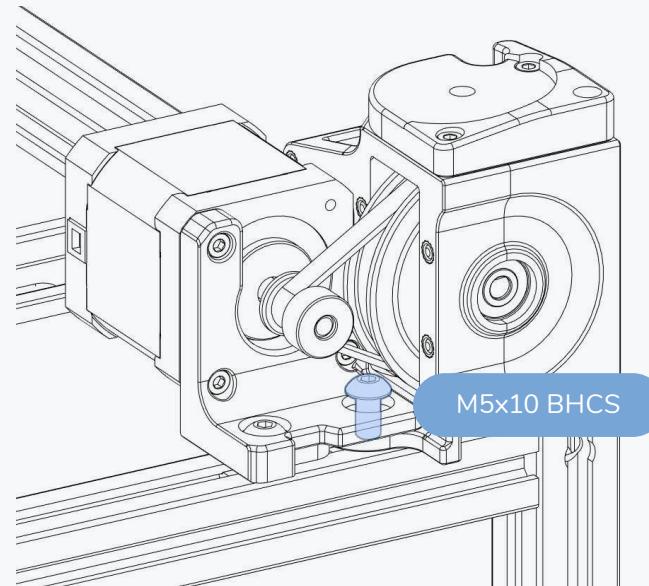
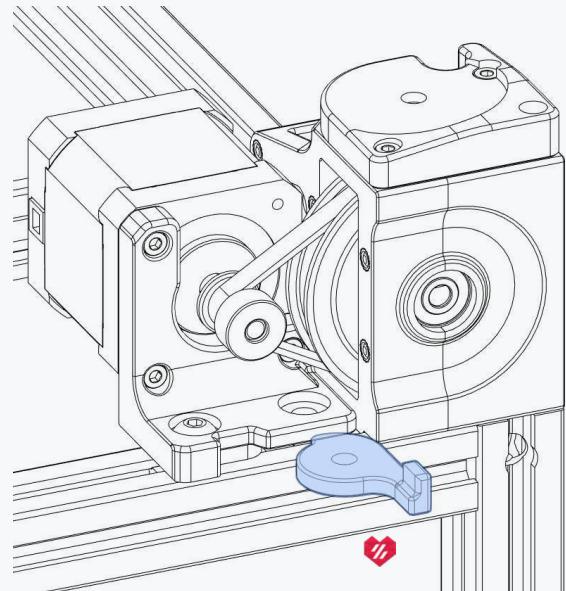


**SLIDE INTO PLACE**

Insert at an angle and slide into place.

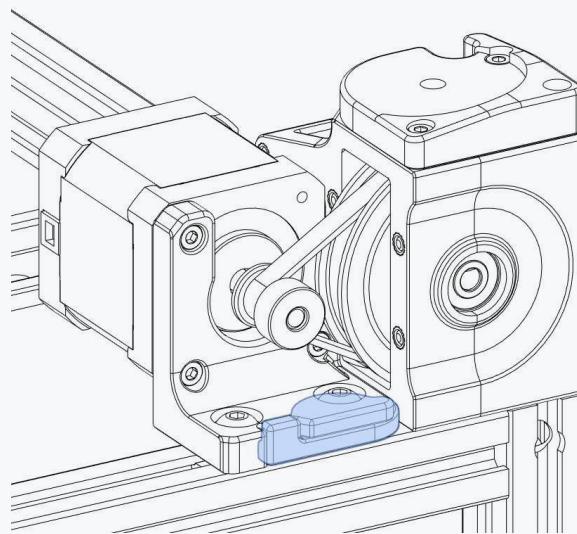
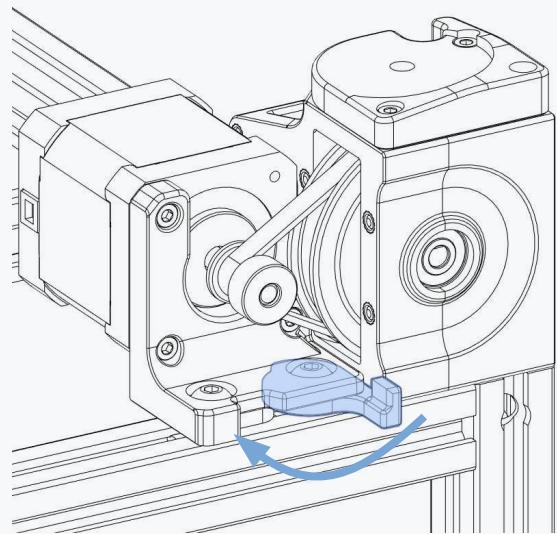
**DON'T TIGHTEN**

Leave the bolt loose for the next step.



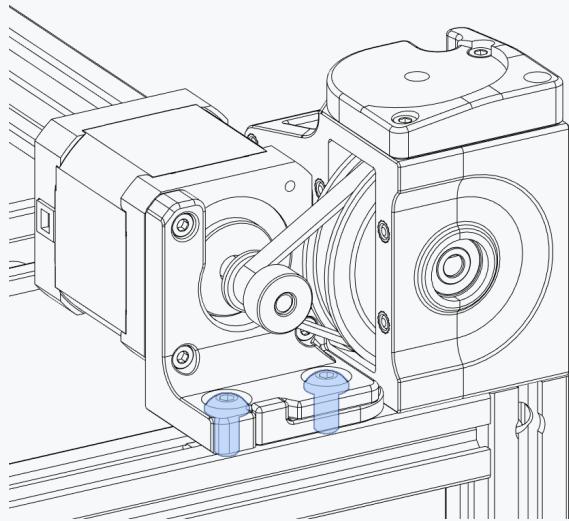
DON'T TIGHTEN

Leave the bolt loose for the next step.

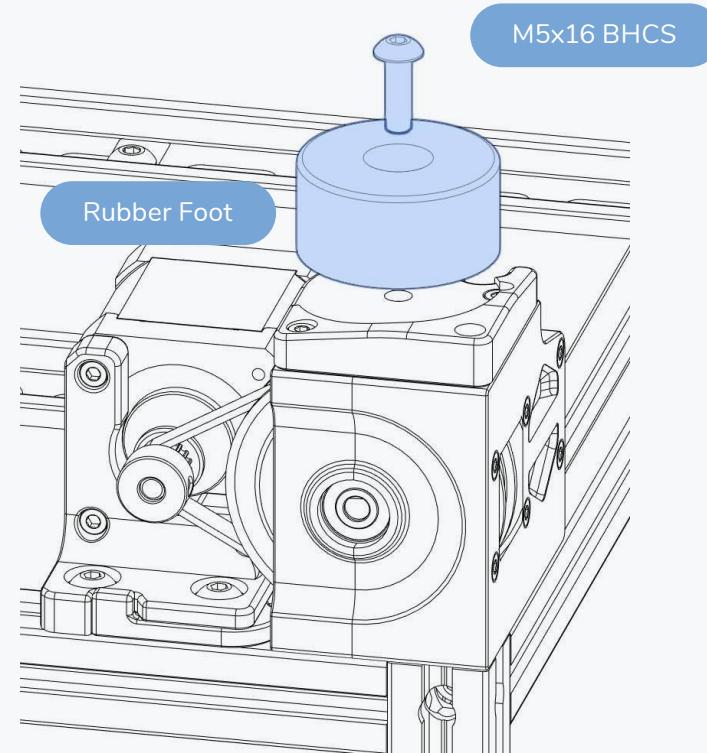


CLOSE THE BELT TENSIONER

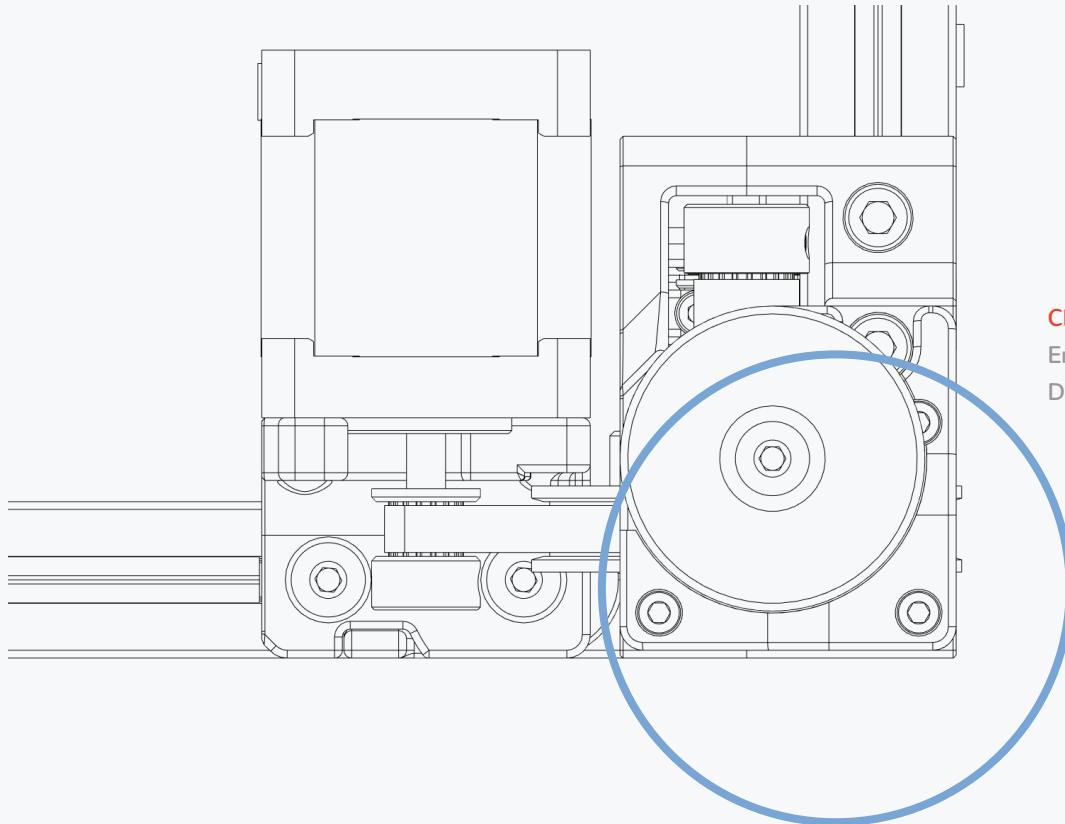
Flip the belt tensioner latch closed.

**TIGHTEN BOLTS**

After closing the tensioner the M5 bolts can be properly fastened.

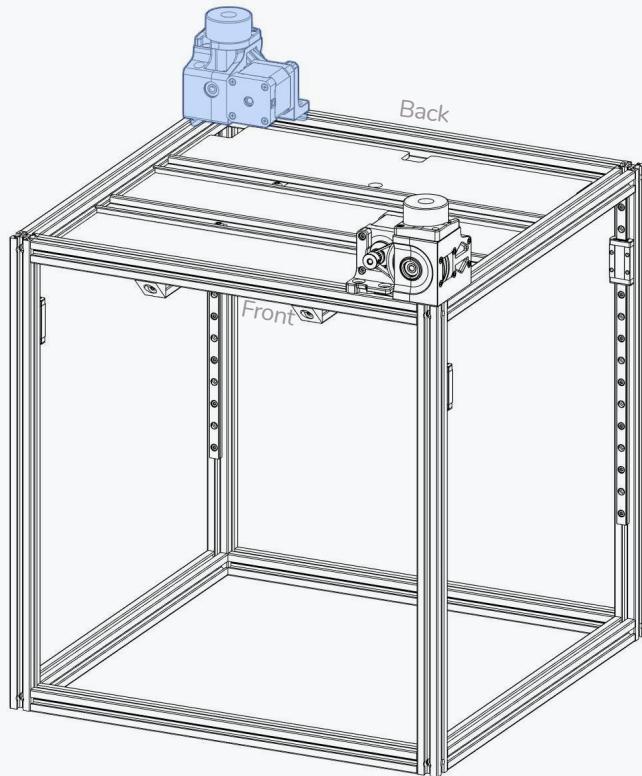


M5x16 BHCS



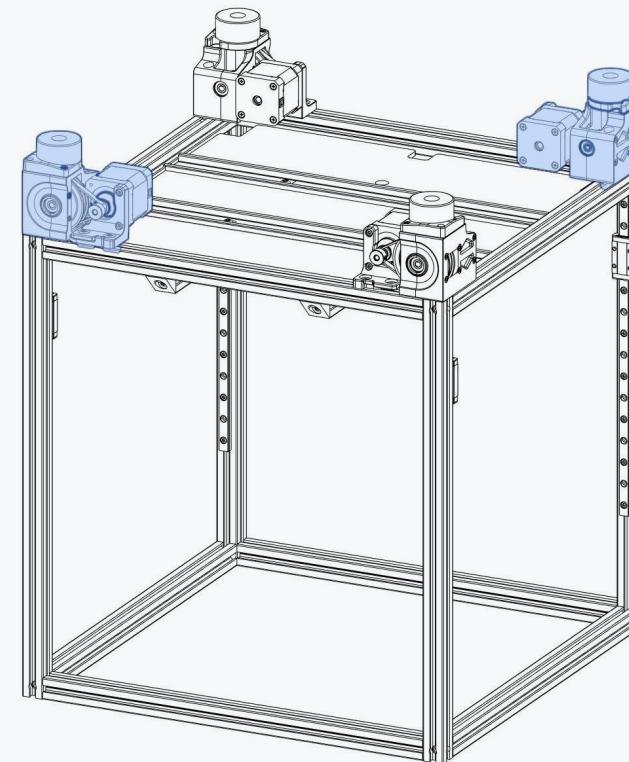
CHECK POSITION

Ensure that closing the belt tensioner did not cause the Z Drive to move/shift. If it did undo the bolts and realign.



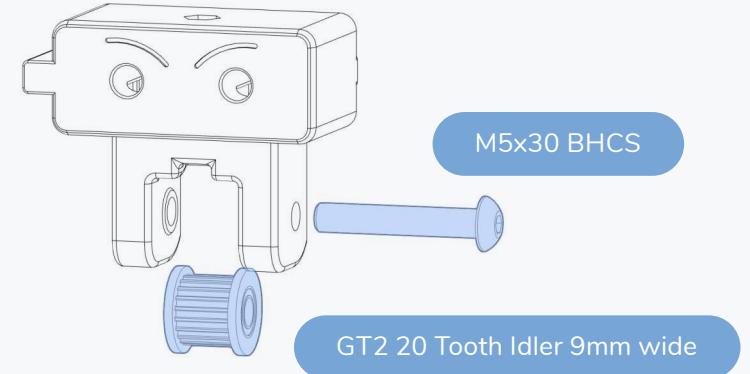
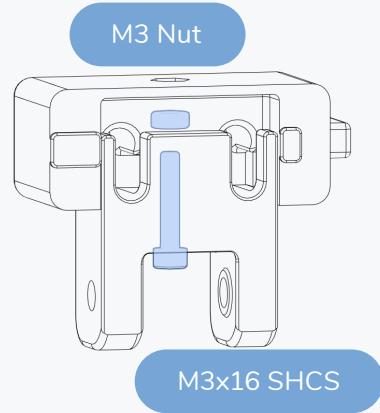
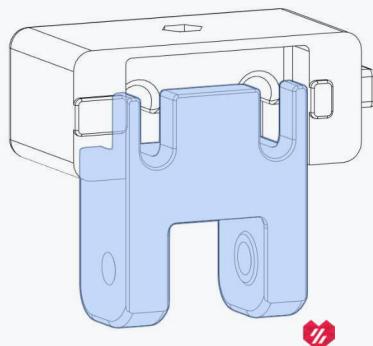
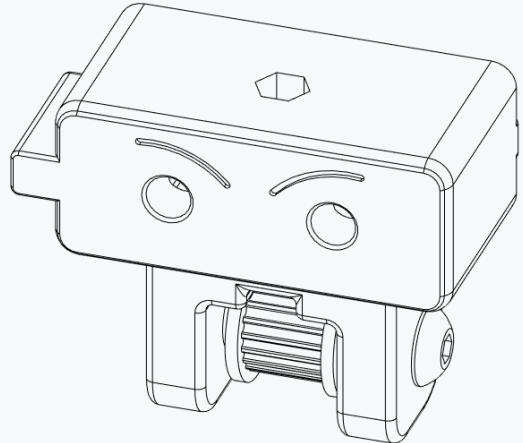
REPEAT INSTRUCTIONS FOR OPPOSING CORNER

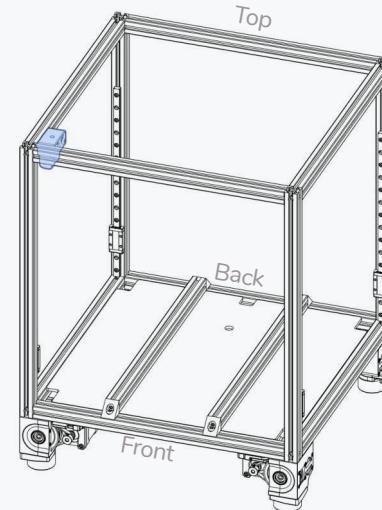
Build another Z drive, following the same instructions.



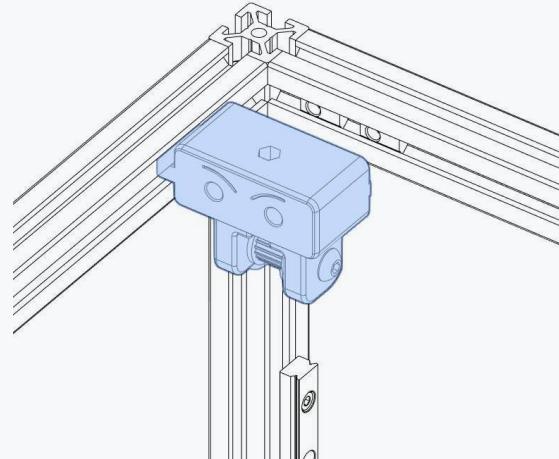
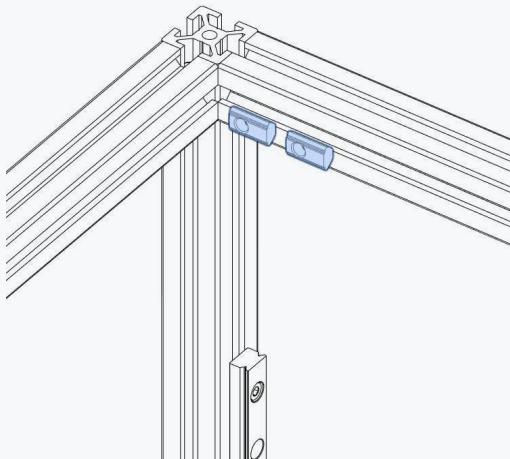
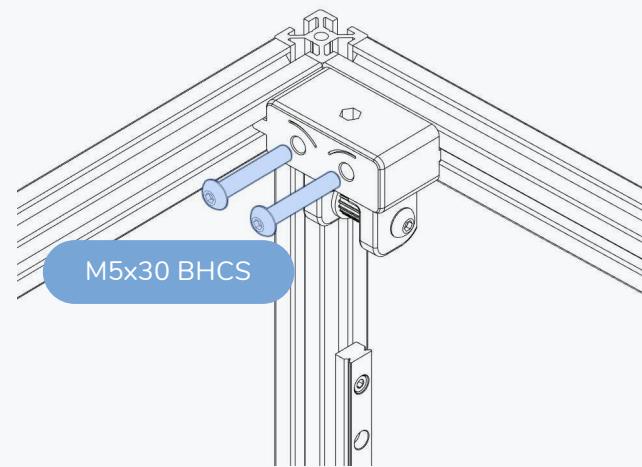
REPEAT INSTRUCTIONS FOR THE MIRRORED DRIVES

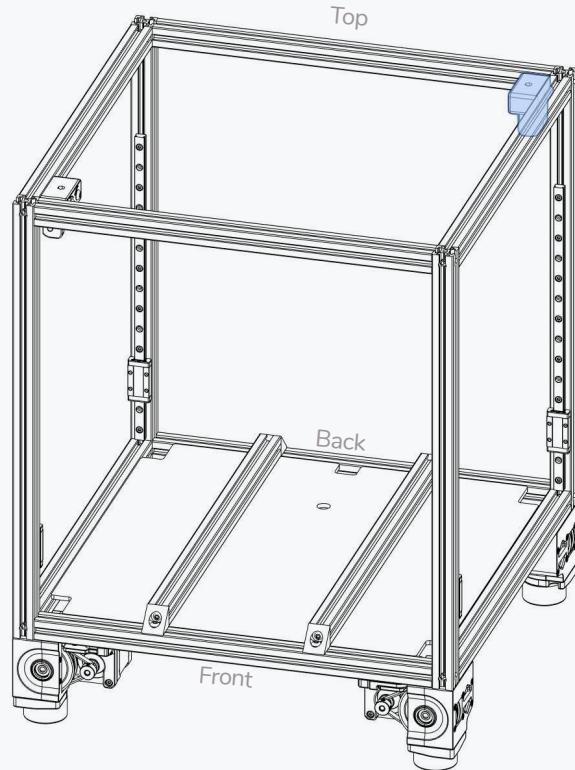
Build two more Z drives following the instructions that came before. The printed parts are mirrored.



**IDLER ORIENTATION**

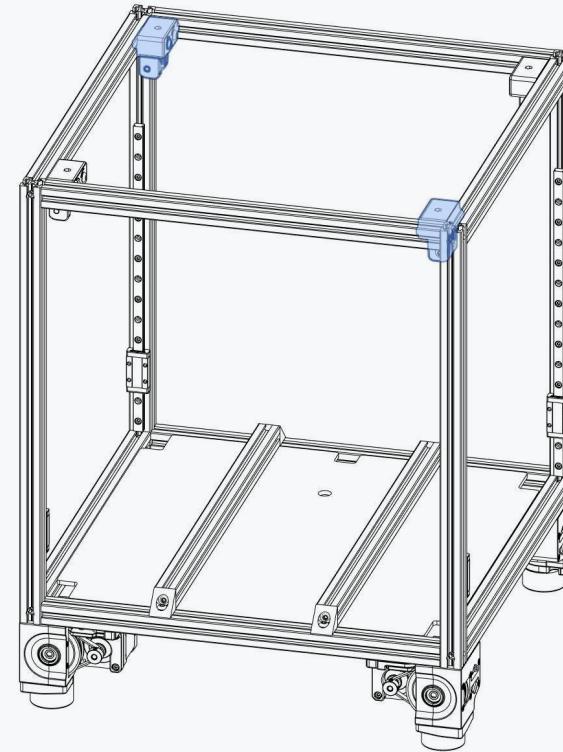
Mind the idler orientation. The idler must face in the same orientation as the pulley in the drive below it.

M5 T-Nut**M5x30 BHCS**



REPEAT INSTRUCTIONS FOR OPPOSING CORNER

Build another Z idler following the same instructions.



REPEAT INSTRUCTIONS FOR THE MIRRORED DRIVES

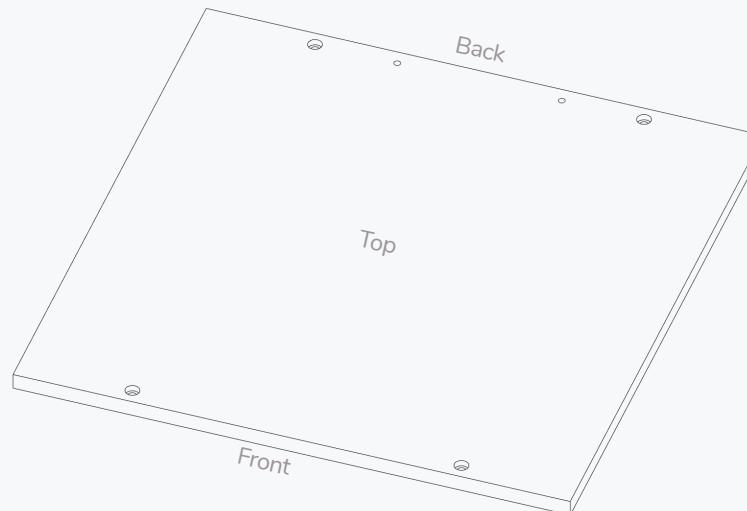
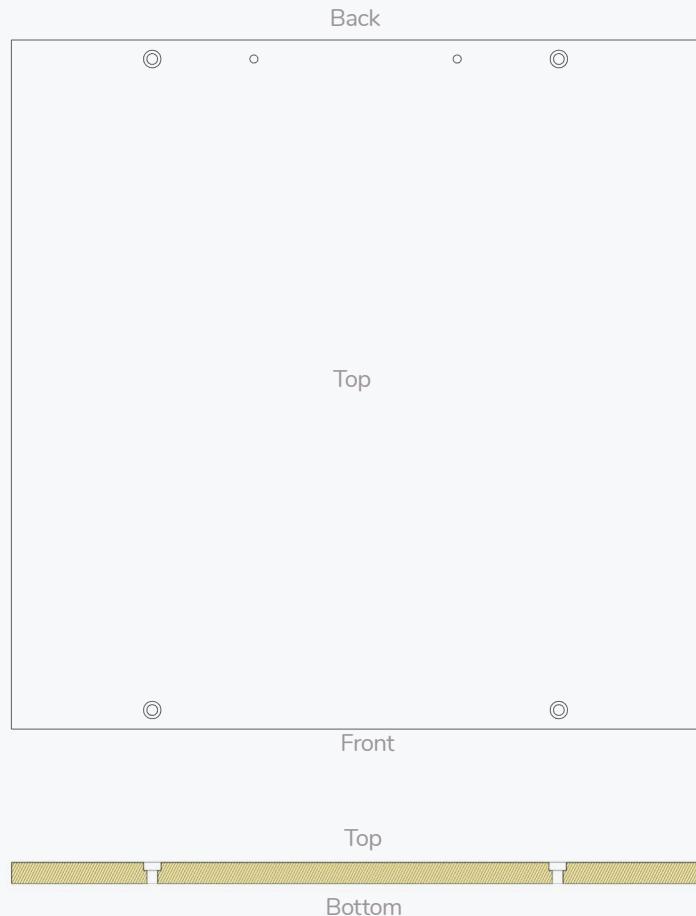
Build two more Z idlers following the instructions that came before. The printed parts are mirrored.

The first design released under the name Voron was the "Voron Geared Extruder". This was on January 28 2015.

PRINT BED

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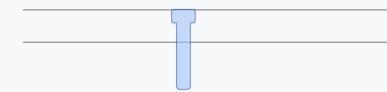


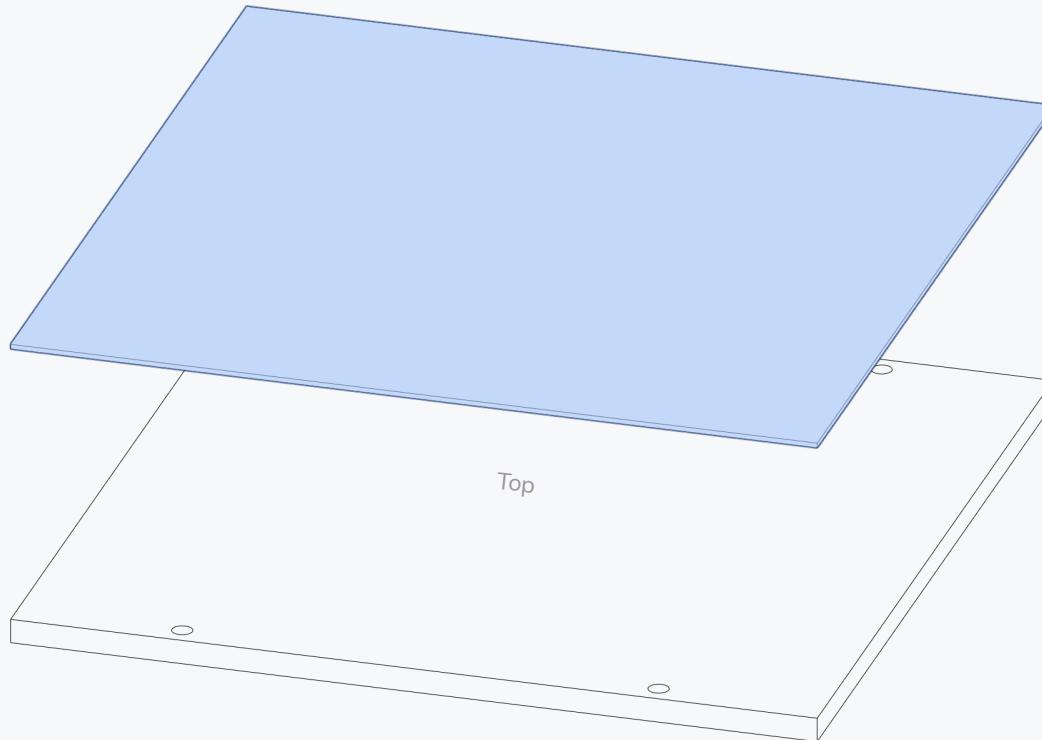


WHICH SIDE IS WHICH?

The top of the plate has mounting holes with bores that allow boltheads to sit flush/below the surface.

The plate has additional tapped holes to secure the Protective Earth (PE) connection and a thermal fuse, those are on the back side of the plate.



**MAGNET APPLICATION**

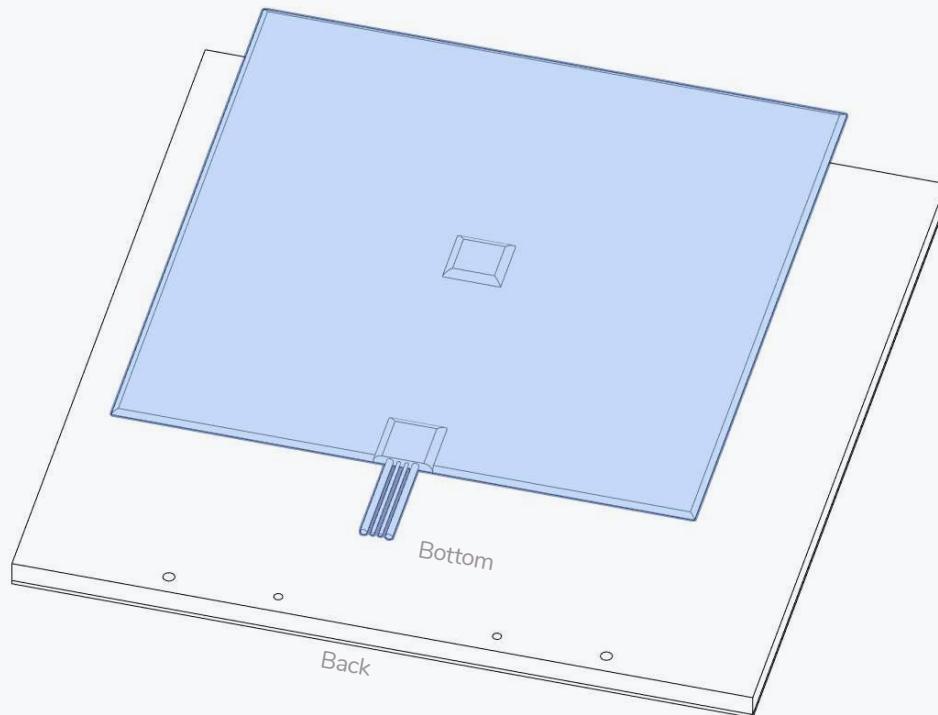
Clean the plate with isopropyl alcohol or similar cleaner prior to applying the magnet.

Use the edge of a plastic object or a small roller to firmly press the magnet on the plate to get a good bond from the adhesive backing.

If you have never done this before we recommend you watch the linked guide.



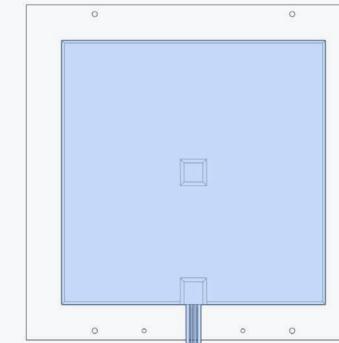
<https://voron.link/rm6tpIld>

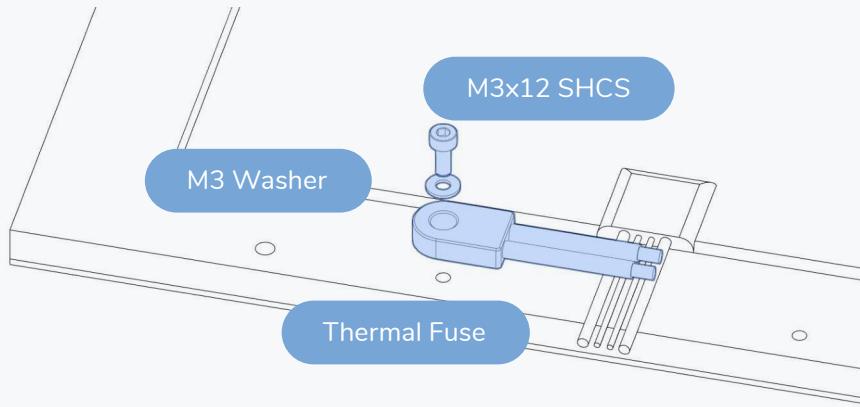


HEATER APPLICATION

The heater is installed in the same fashion as the magnet.

Centre it on the bottom side of the build plate and make sure to firmly press it onto the build plate.



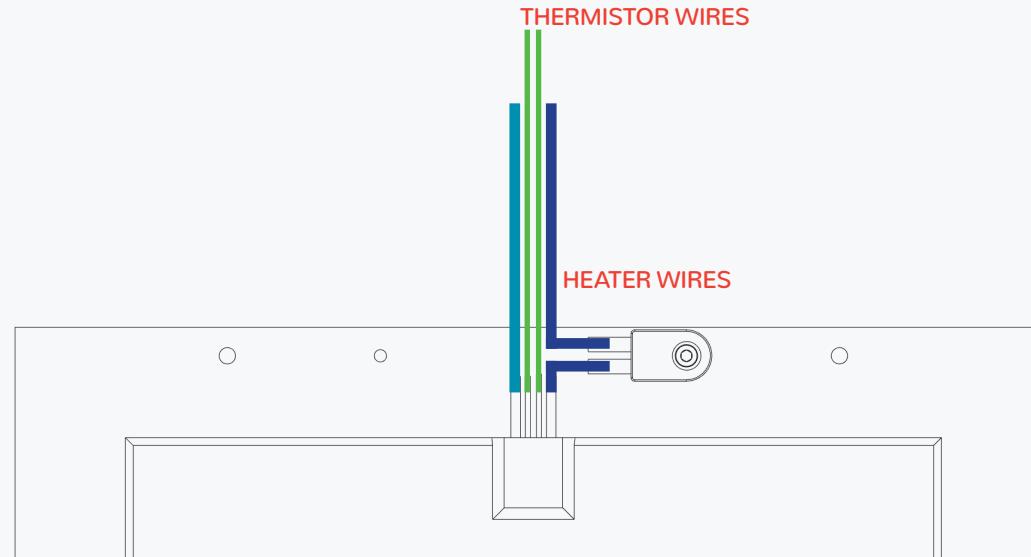


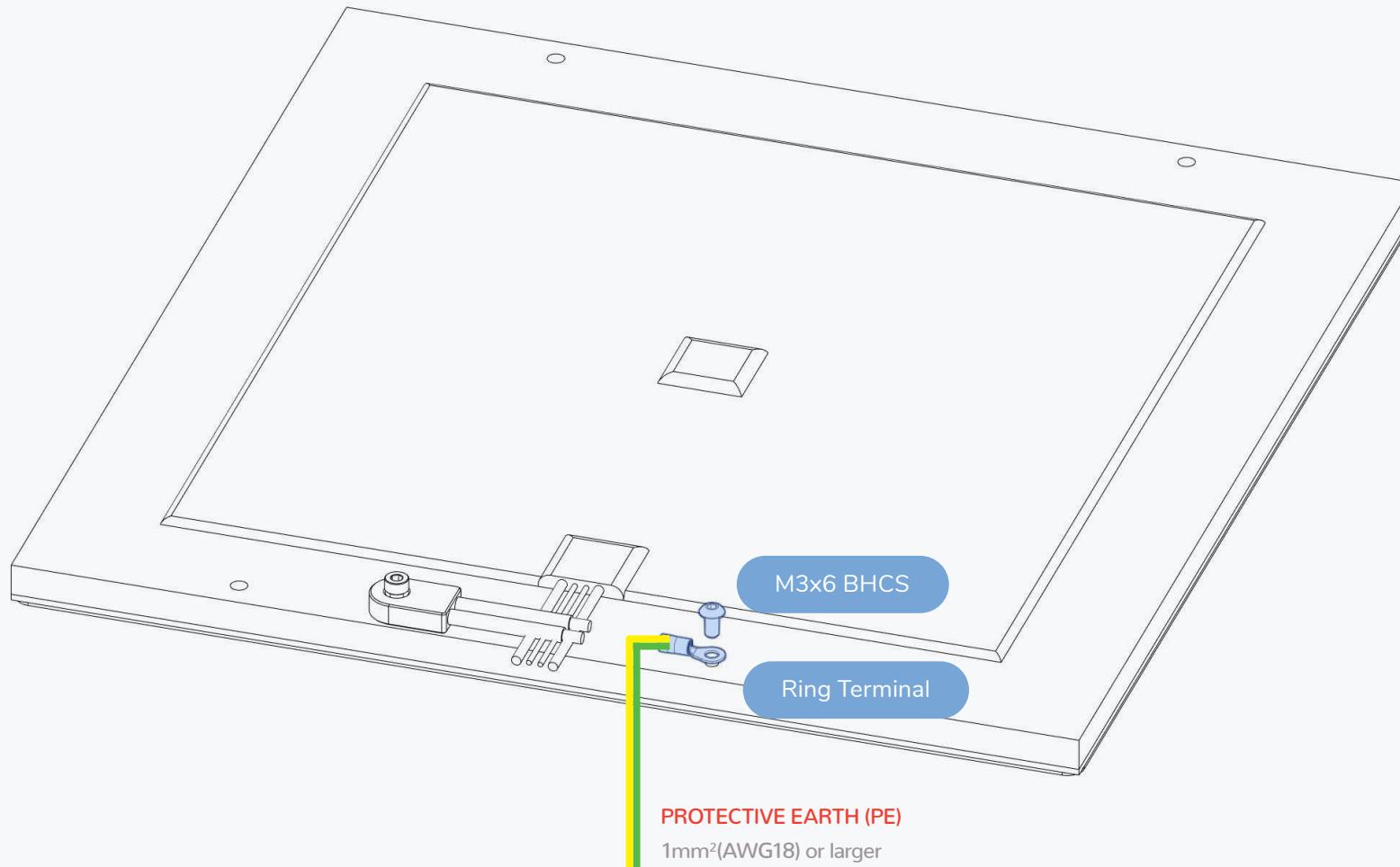
THERMAL FUSE

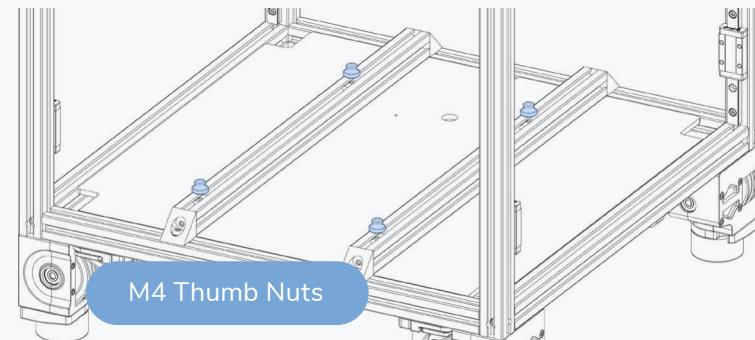
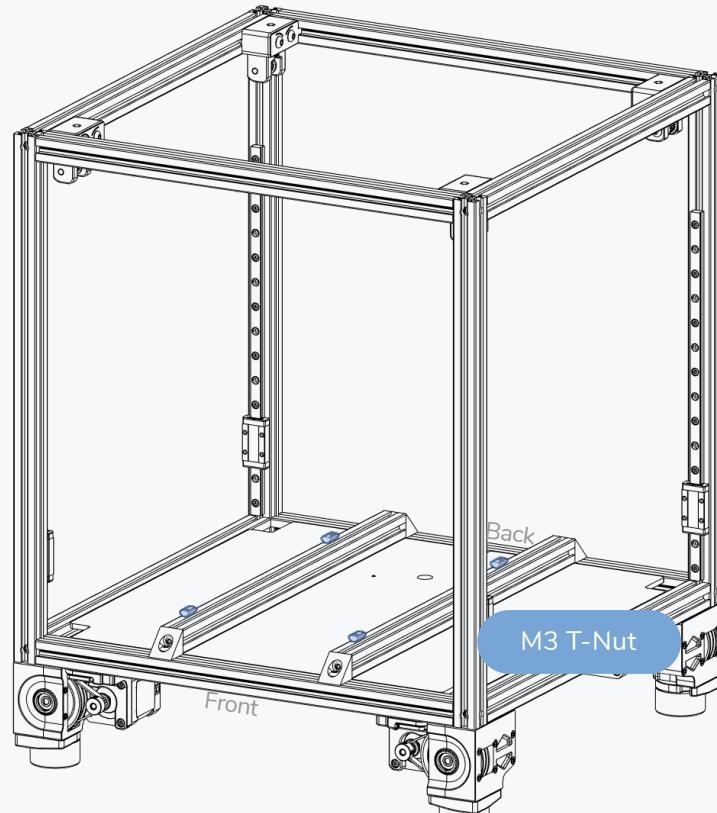
While not required to operate the printer, a thermal fuse attached to the build plate adds an additional layer of protection against potentially dangerous malfunctions.

The thermal fuse is wired in-line with the heater wires.

Depending on the tapped holes in the plate you may need to use a shorter bolt.

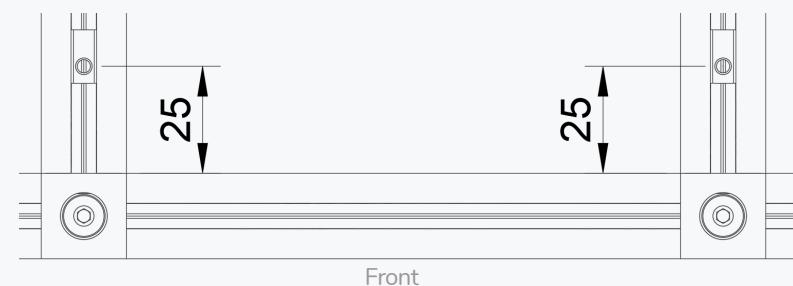


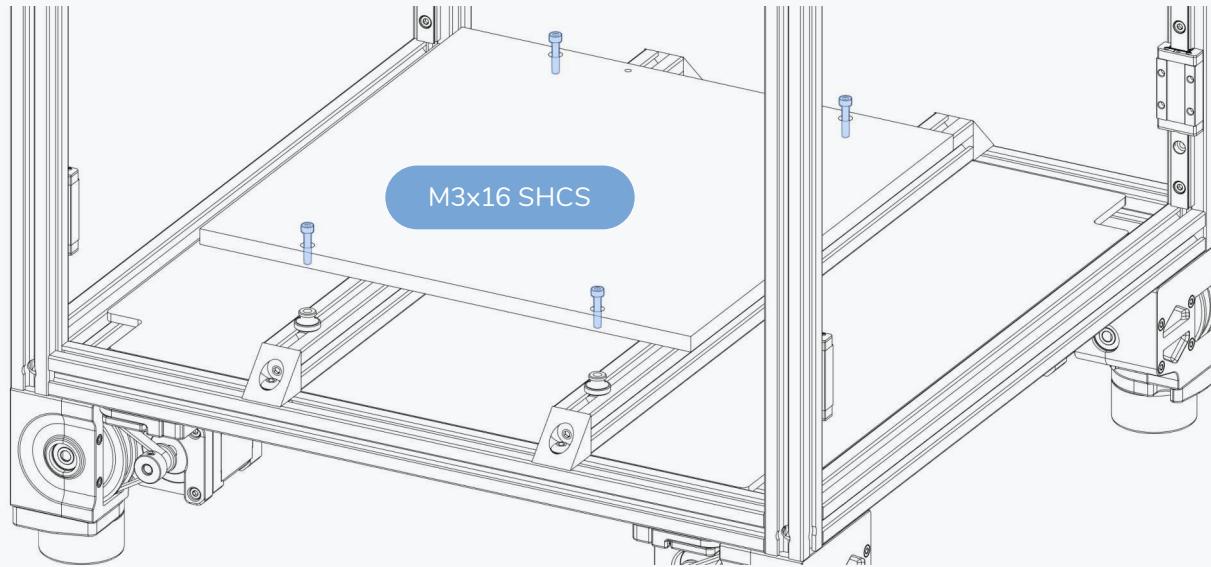




M4 NUT FOR A M3 BOLT?

We use the thumb nuts as spacers. You can replace them with different heat resistant spacers of the same length.





M3x16 SHCS

BED AND SPACER THICKNESS

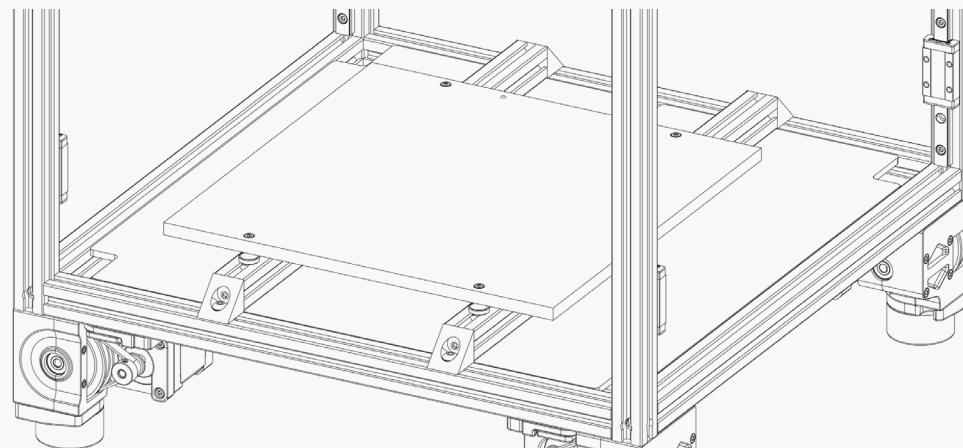
Depending on the combination of bed and spacer thickness you may need to use longer bolts to secure the bed.

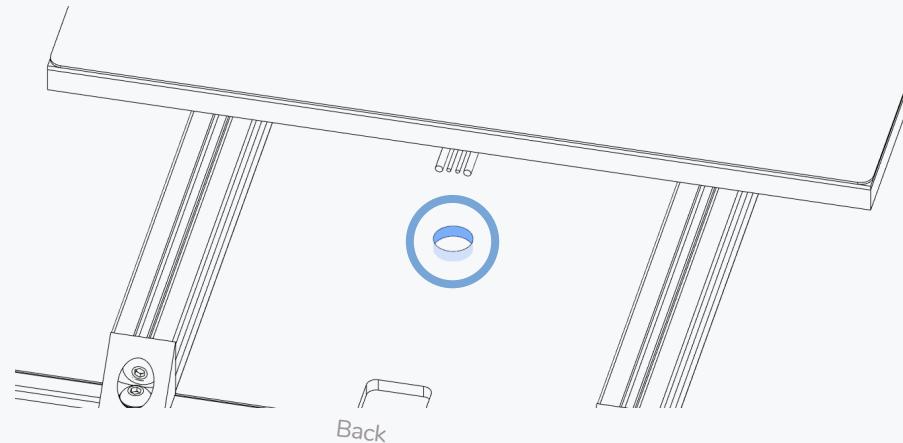
DON'T TIGHTEN

Only tighten one bolt fully.

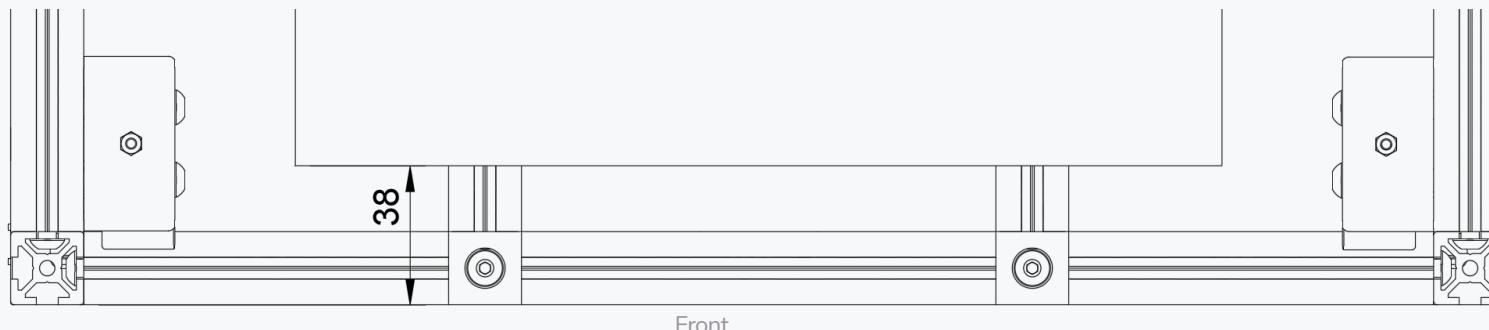
Leave the remaining bolts slightly loose.

This will allow for thermal expansion without putting additional stress on the plate.



**WIRE PASSTHROUGH**

Feed the bed related wires through the opening in the deck plate.

**VERIFY PLATE PLACEMENT**

The front edge of the print plate should sit 38mm behind the front edge of the frame.

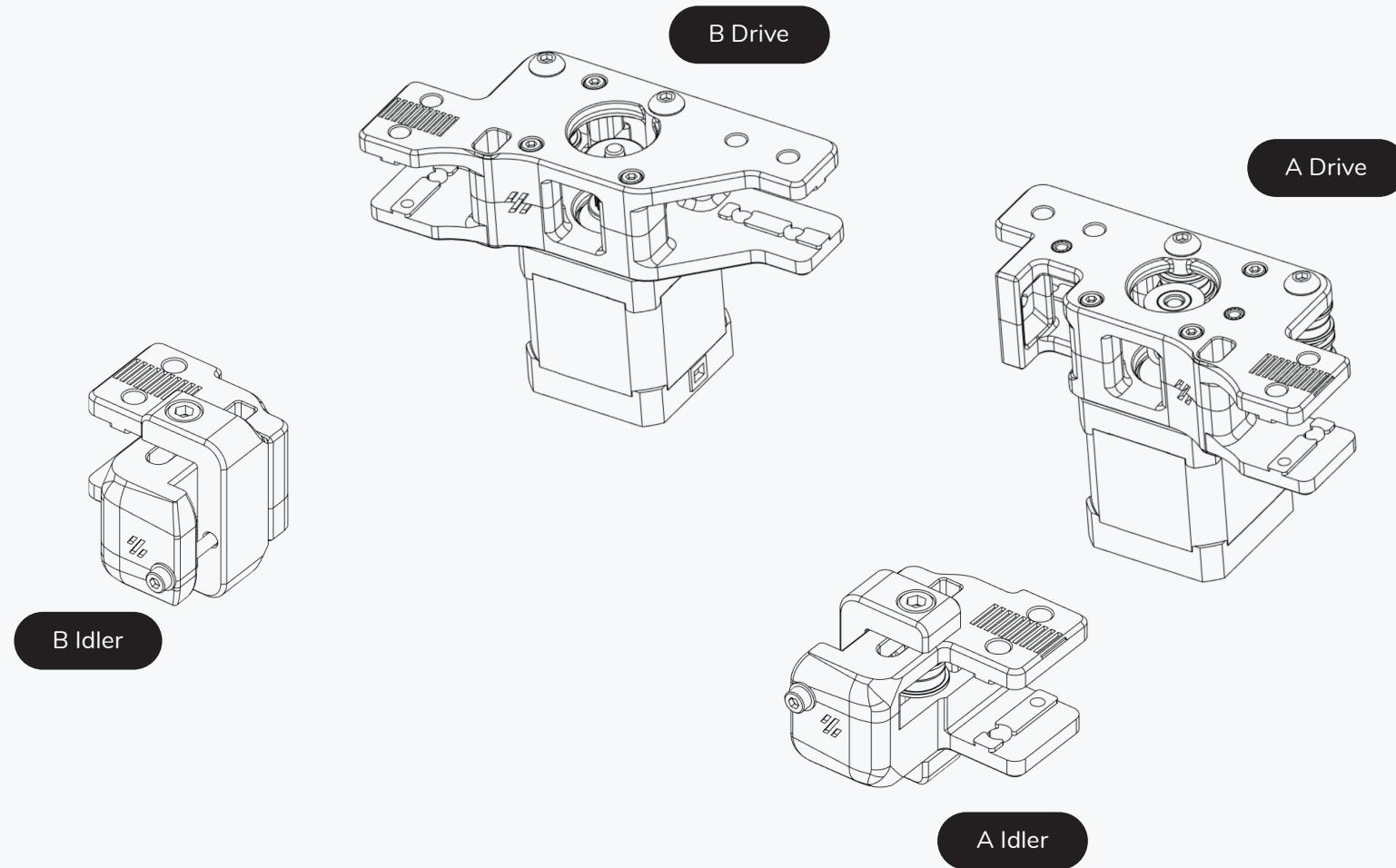
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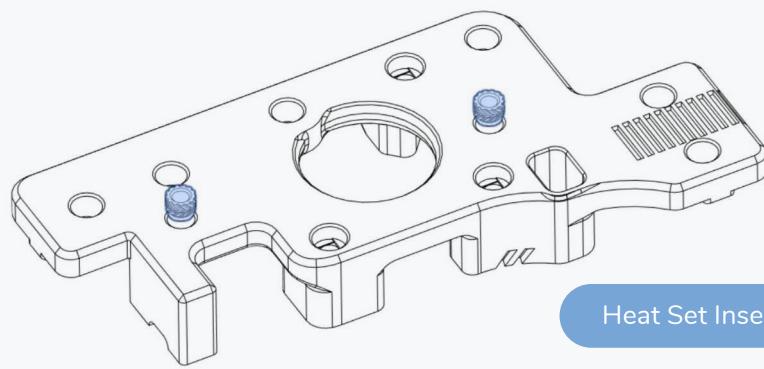
The Voron Legacy is a modernized design true to the spirit of the original Voron 1.0.

A/B DRIVES AND IDLERS

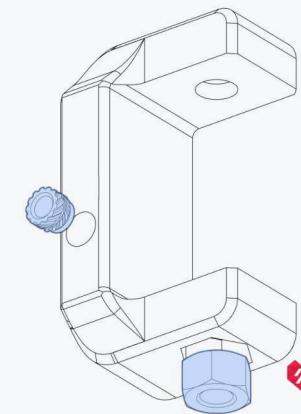
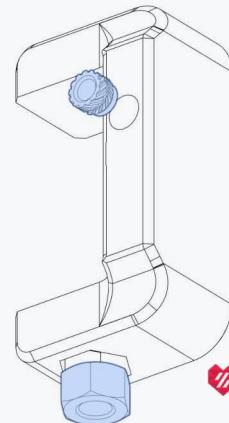
WWW.VORONDESIGN.COM



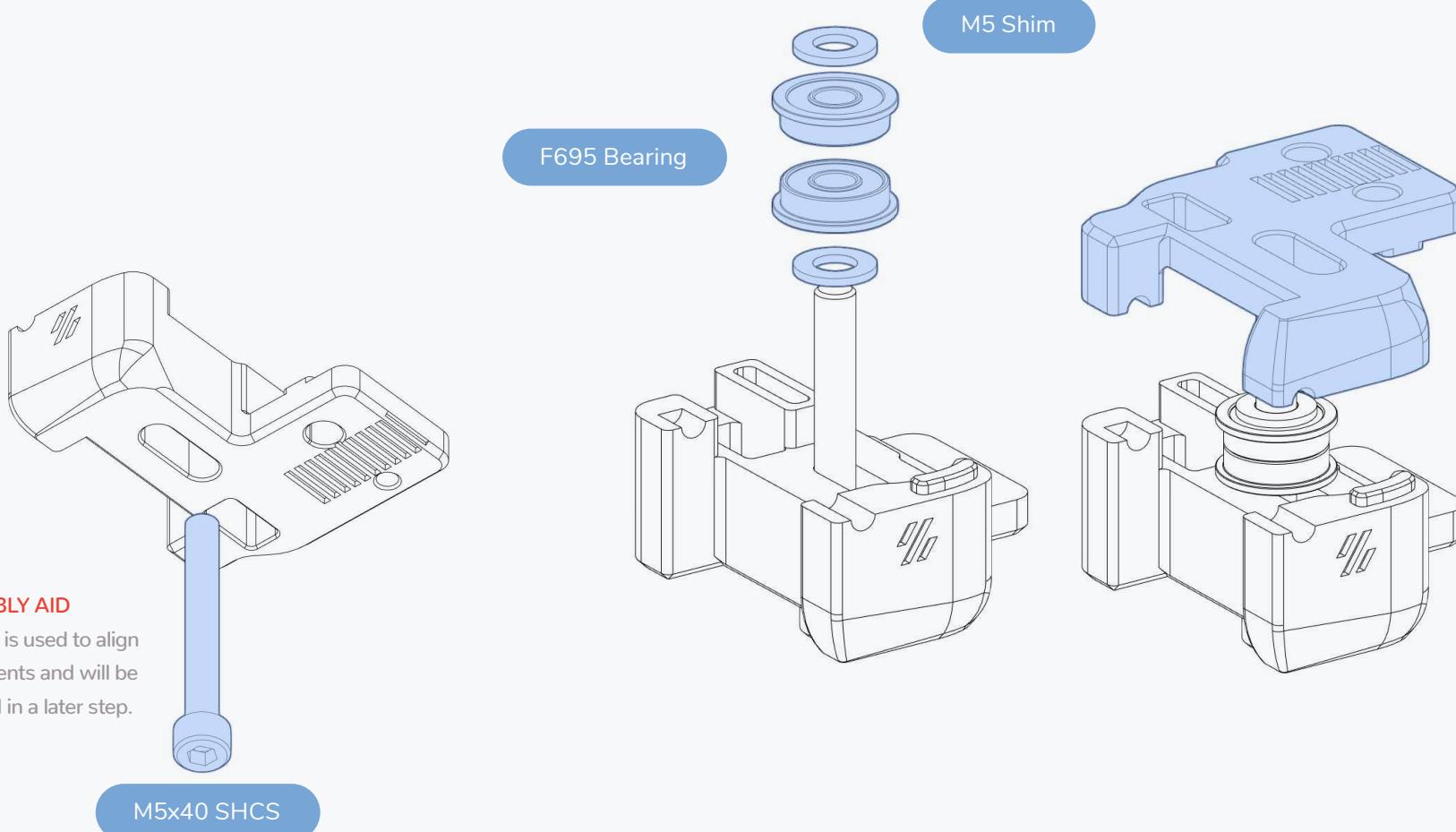


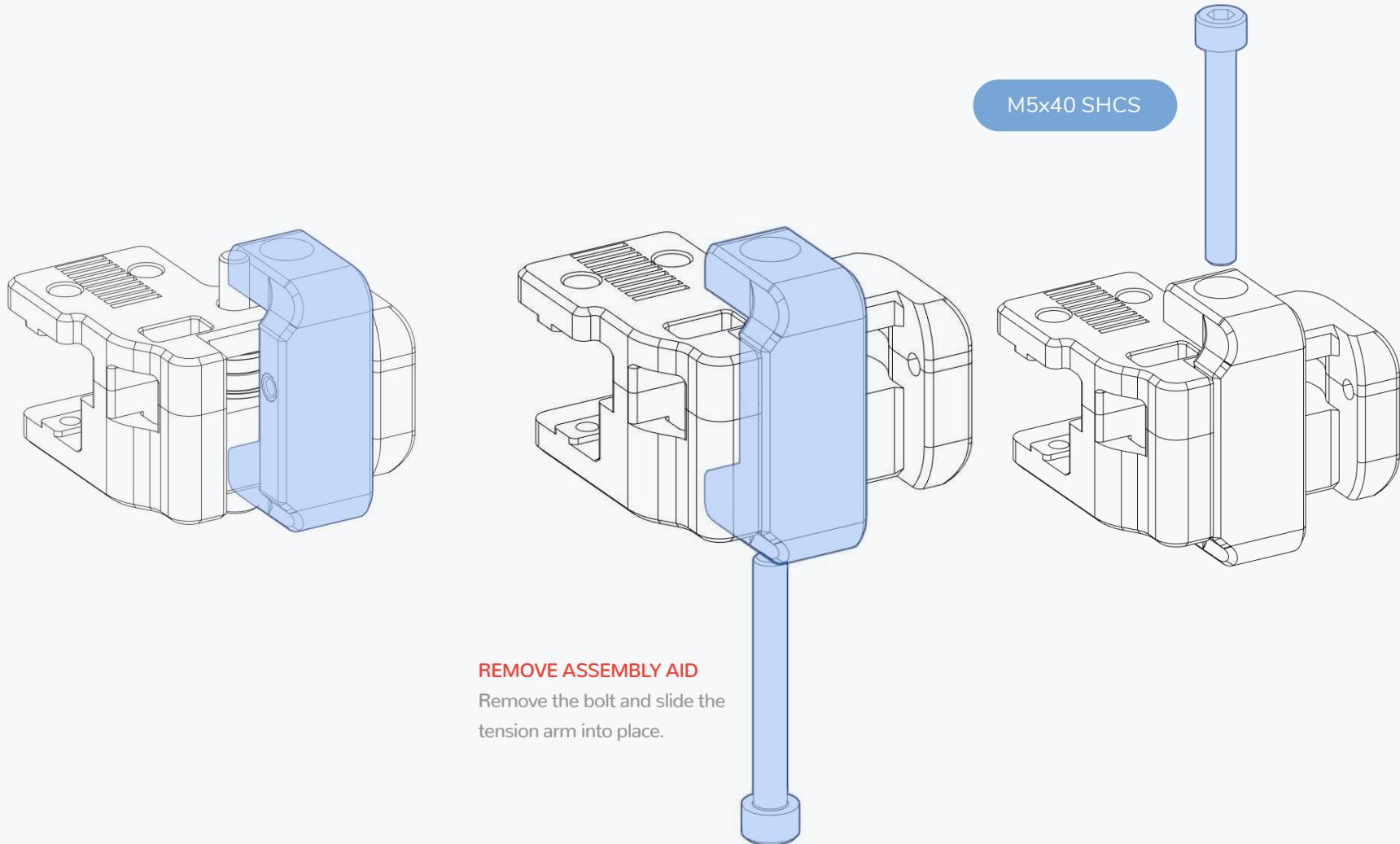


Heat Set Insert



M5 Nut

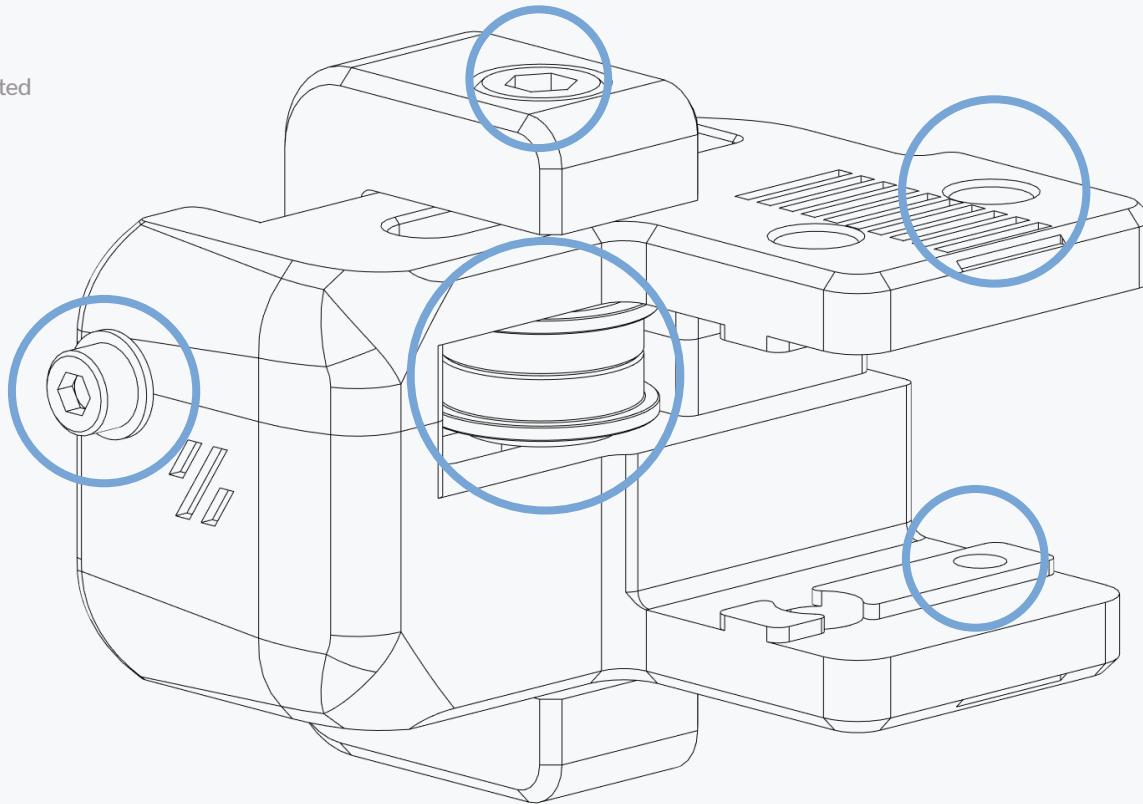






CHECK YOUR WORK

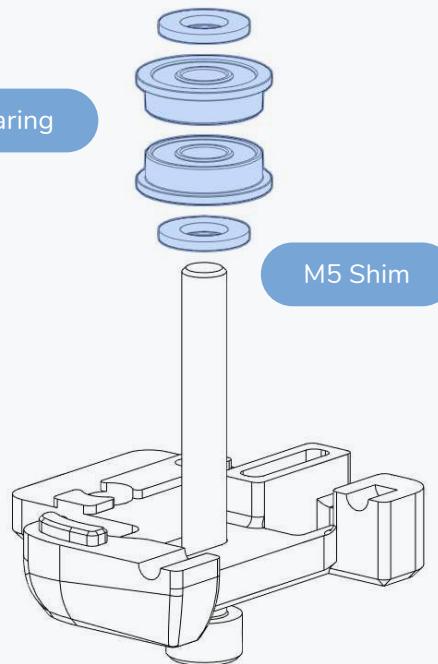
Compare your assembled parts to the graphics shown here. Pay attention to the features highlighted by the circles.



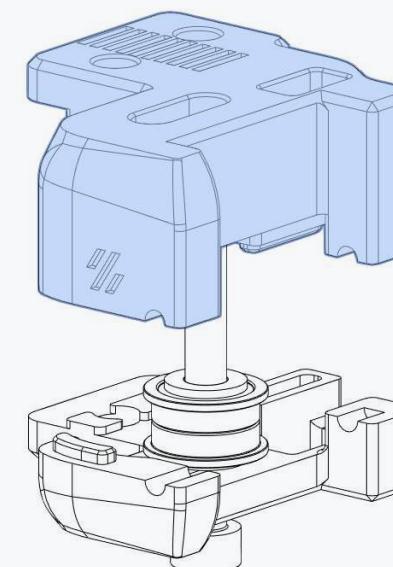
**ASSEMBLY AID**

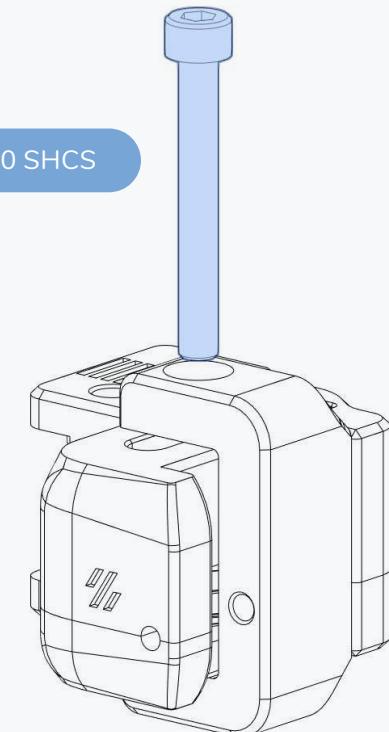
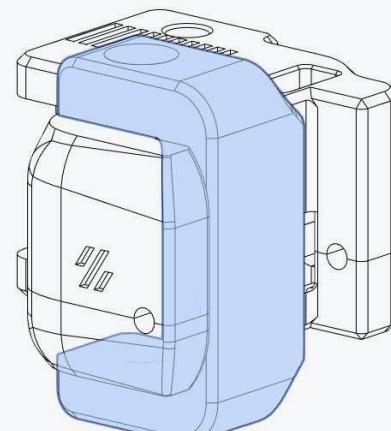
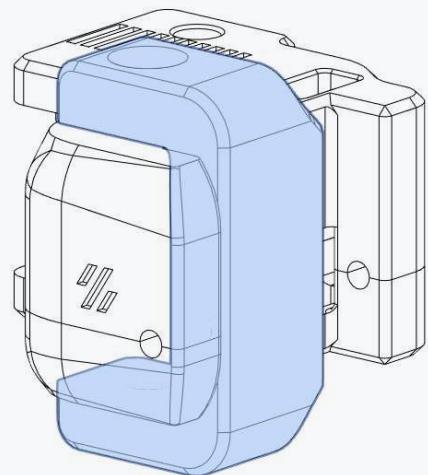
This bolt is used to align components and will be removed in a later step.

F695 Bearing



M5x40 SHCS



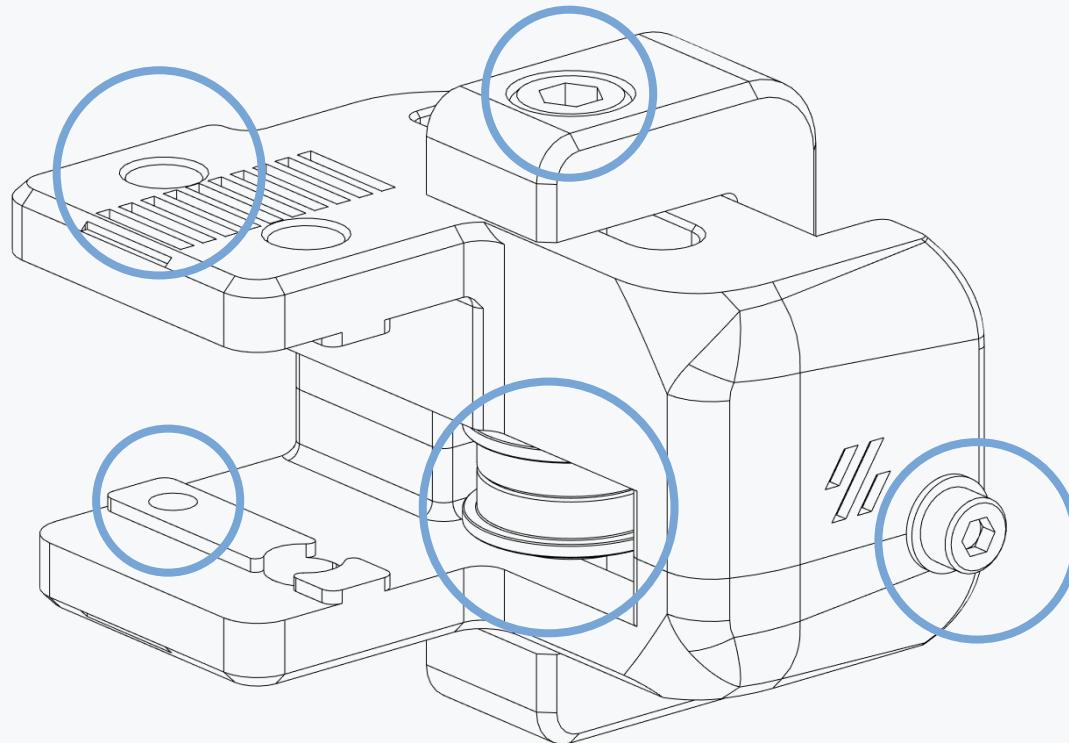
**REMOVE ASSEMBLY AID**

Remove the bolt and slide the tension arm into place.

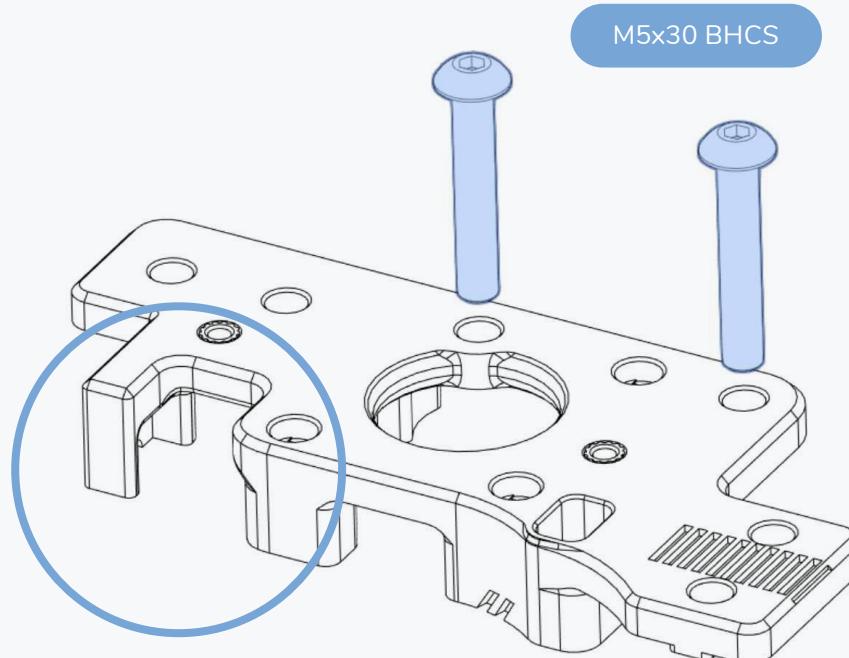
B IDLER

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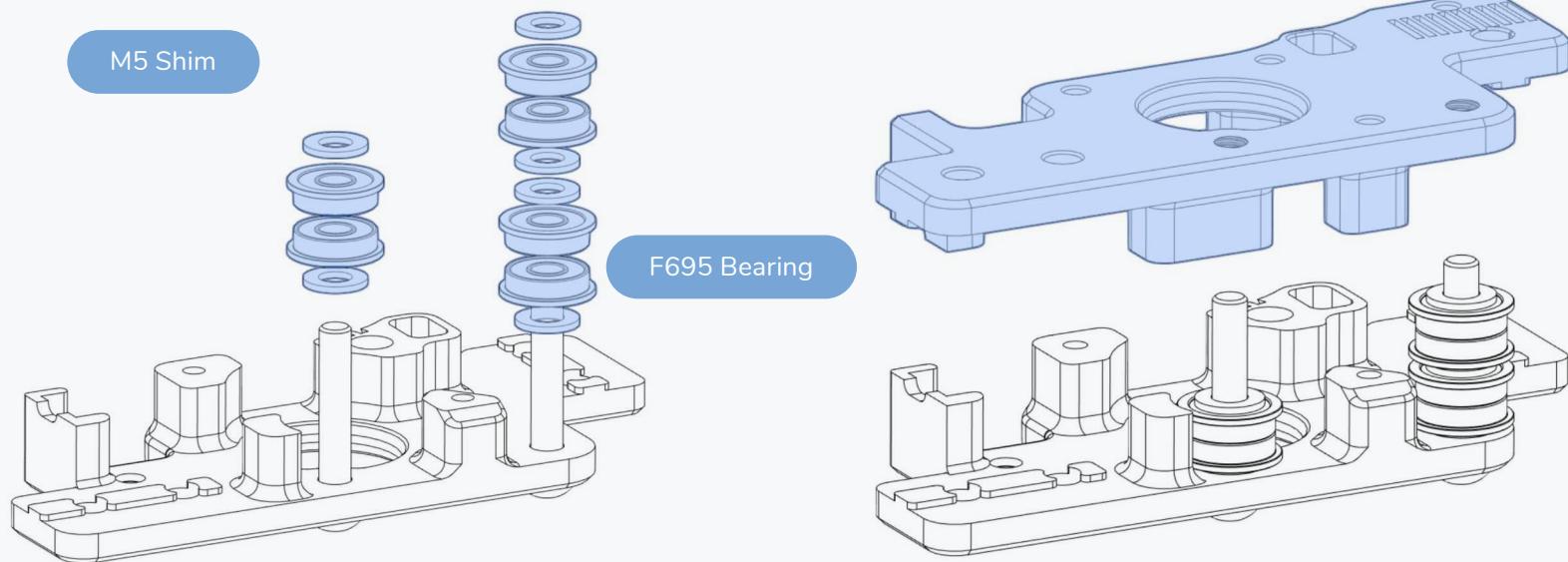


**CHECK YOUR WORK**

Compare your assembled parts to the graphics shown here. Pay attention to the features highlighted by the circles.

**CUTOUT**

The printed parts for the A drive have a cutout.

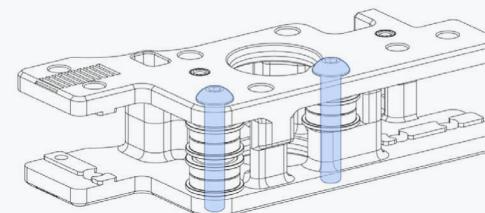


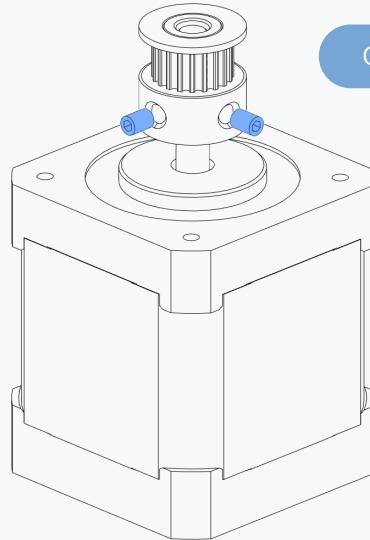
UPSIDE DOWN ASSEMBLY

For ease of assembly we recommend to assemble the A and B drives upside down.

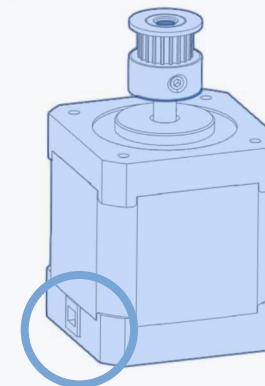
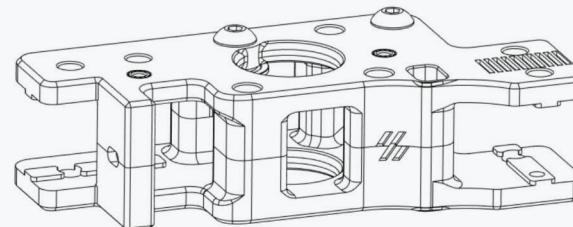
DON'T OVER TIGHTEN

The M5 bolts are threaded directly into plastic.

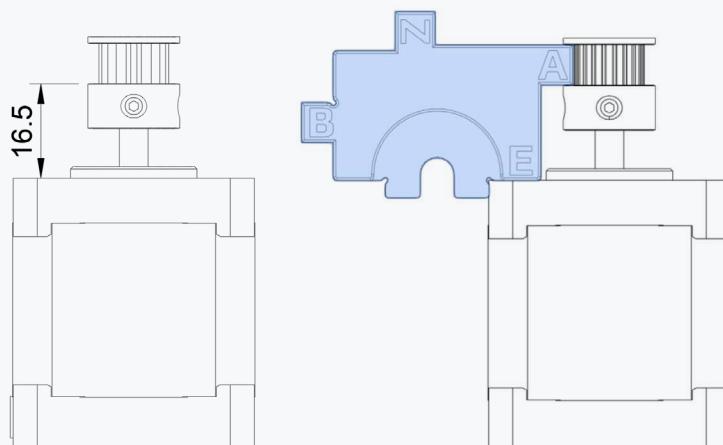


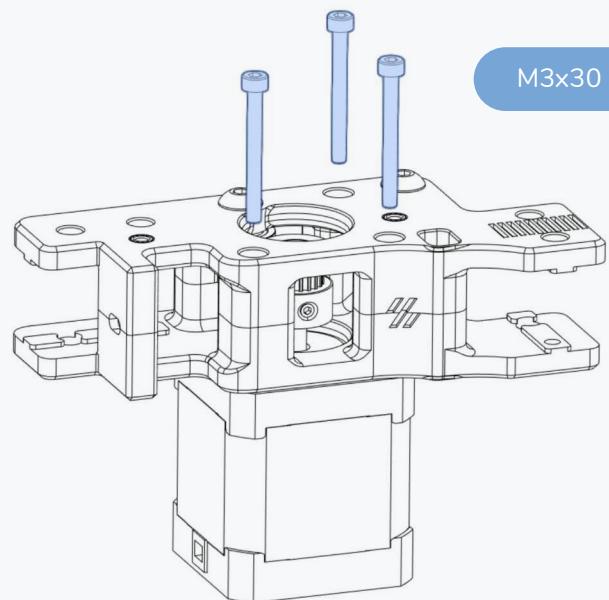
**APPLY THREAD LOCKER**

Make sure to use thread locker on the set screws.

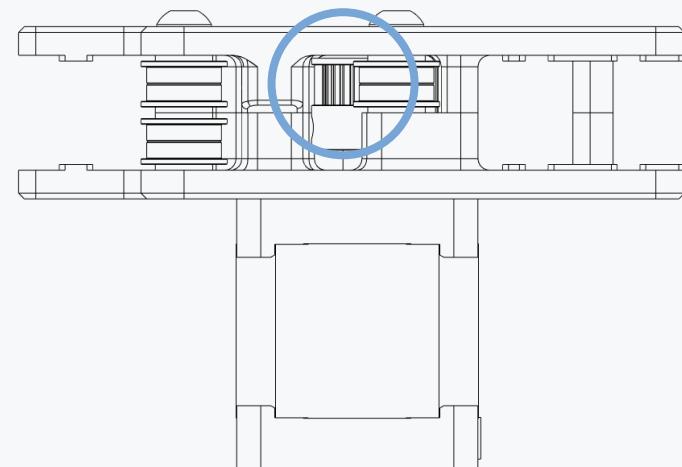
**MOTOR ORIENTATION**

Pay attention to the orientation of the cable exit. The wires from the motors will be pointing towards each other once fully assembled.



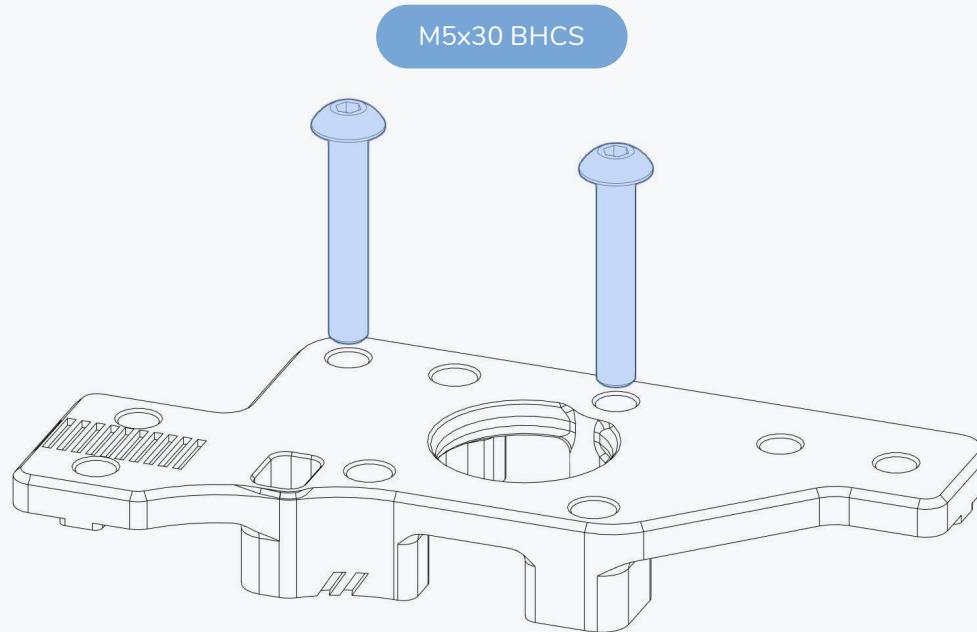


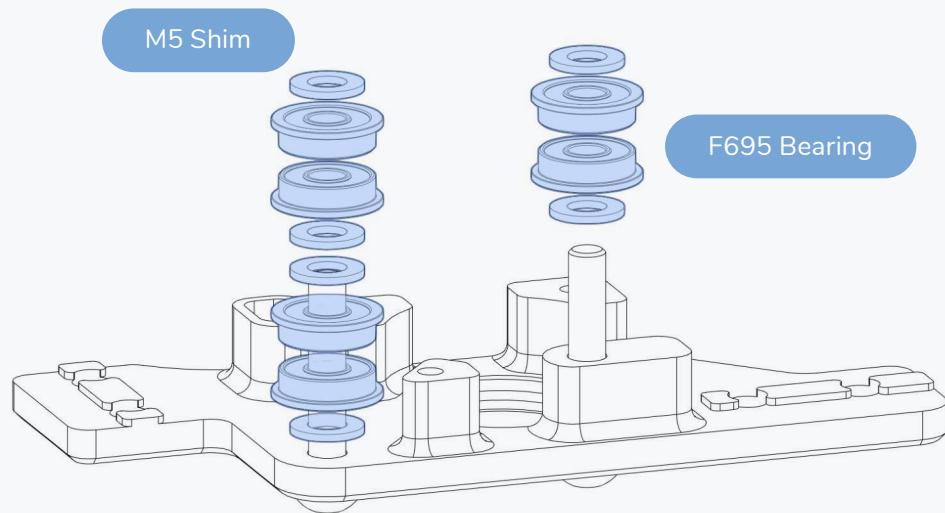
M3x30 SHCS

**CHECK YOUR WORK**

Compare your assembled part to the graphic shown here.

Pay attention to the pulley orientation and alignment with the bearing stack ups.



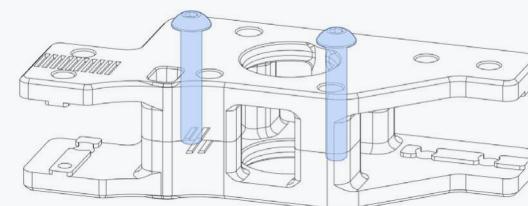
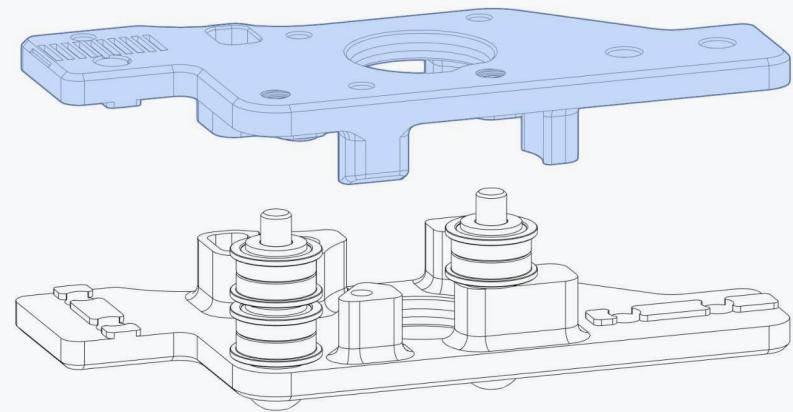


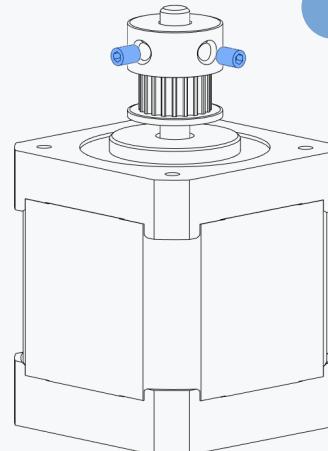
UPSIDE DOWN ASSEMBLY

For ease of assembly we recommend to assemble the A and B drives upside down.

DON'T OVER TIGHTEN

The M5 bolts are threaded directly into plastic.

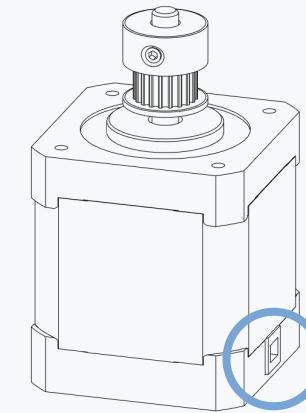
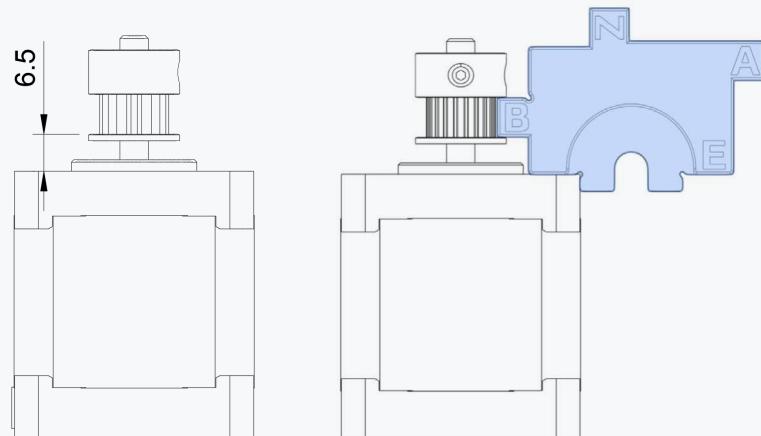
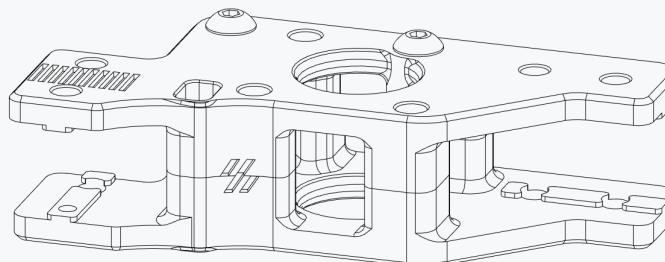




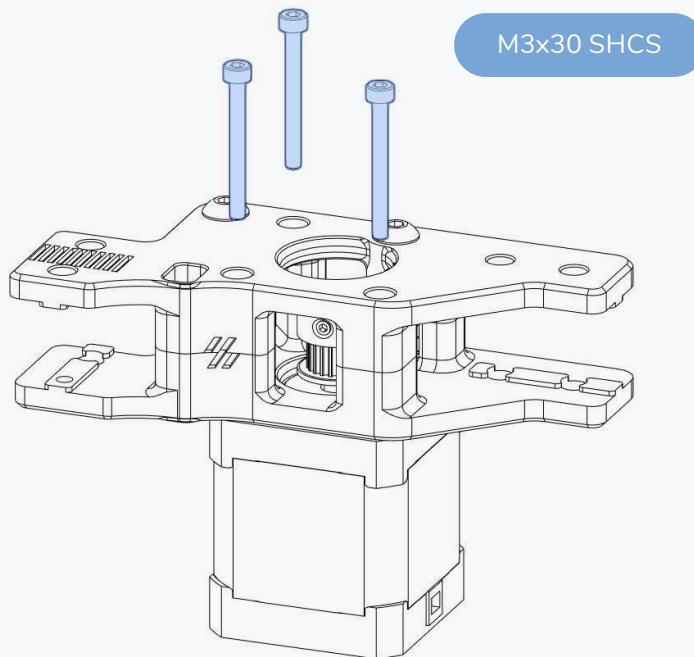
GT2 20 Tooth Pulley

APPLY THREAD LOCKER

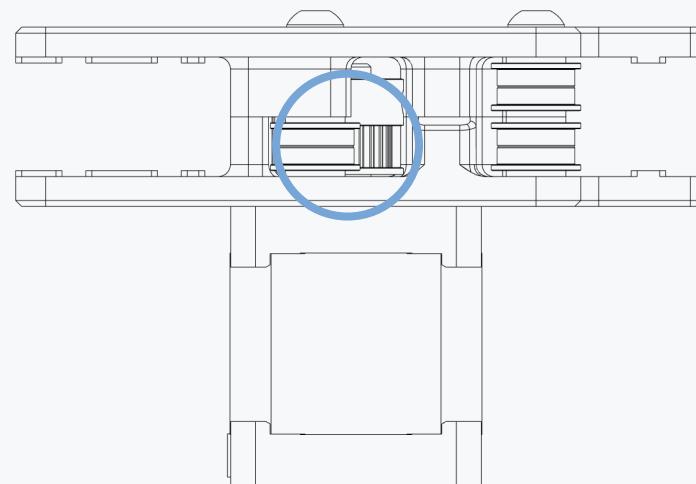
Make sure to use thread locker on the set screws.

**MOTOR ORIENTATION**

Pay attention to the orientation of the cable exit.



M3x30 SHCS



CHECK YOUR WORK

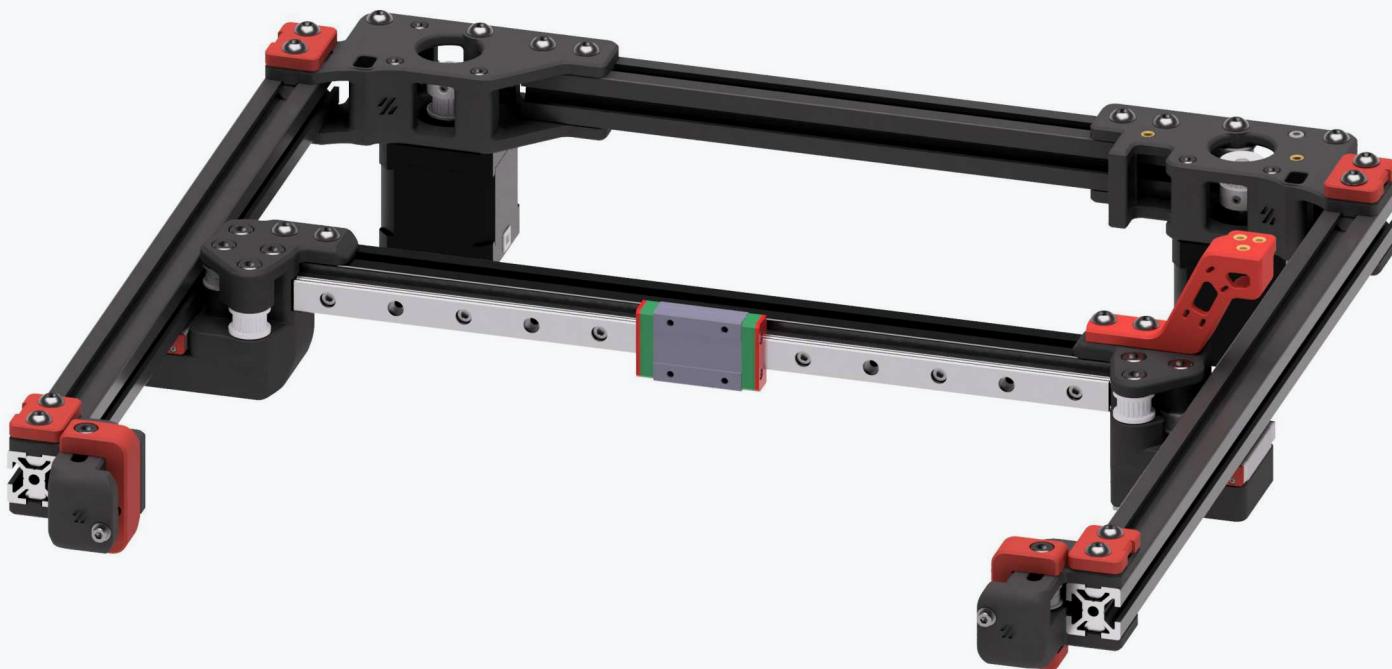
Compare your assembled part to the graphic shown here.

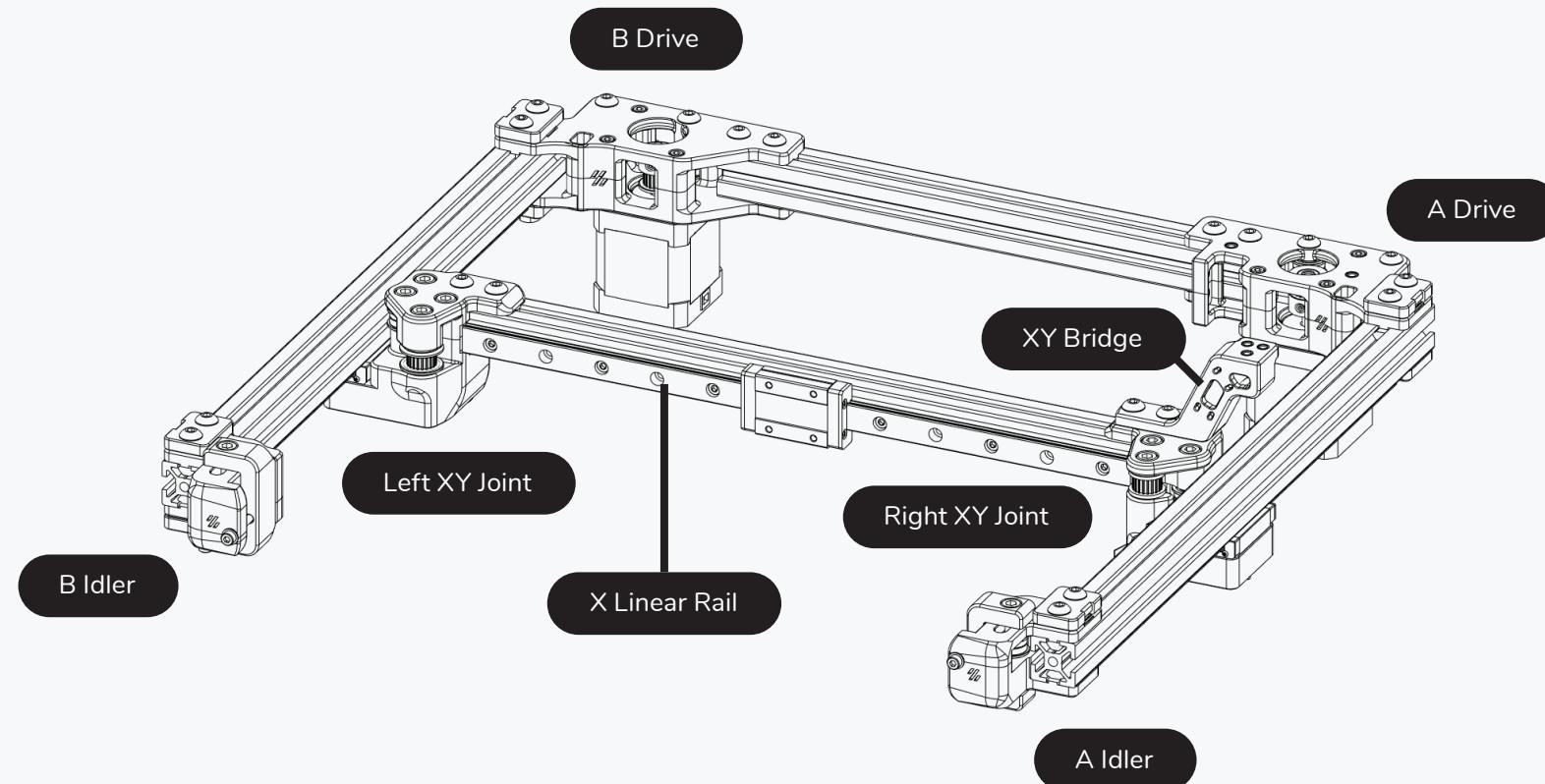
Pay attention to the pulley orientation and alignment with the bearing stacks.

V24 (not V2.4) was an experimental design, only 2 have ever been built. It's design became the basis for the Voron2.

GANTRY

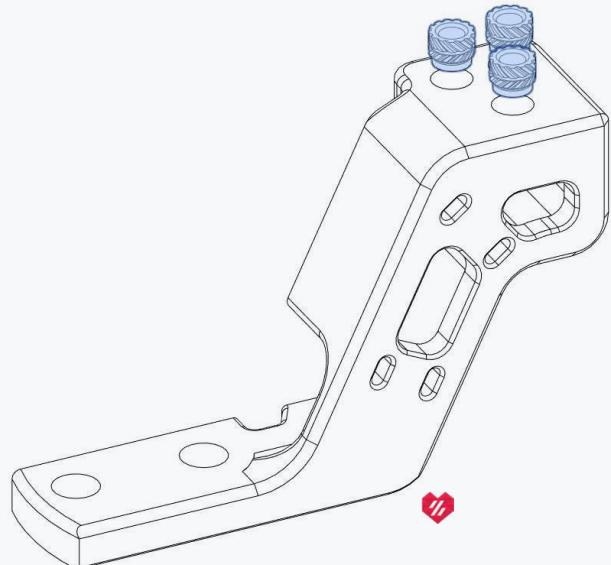
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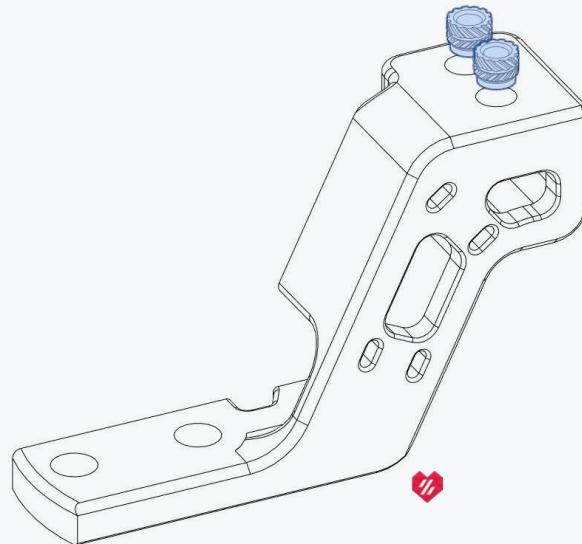


GENERIC CABLE CHAINS

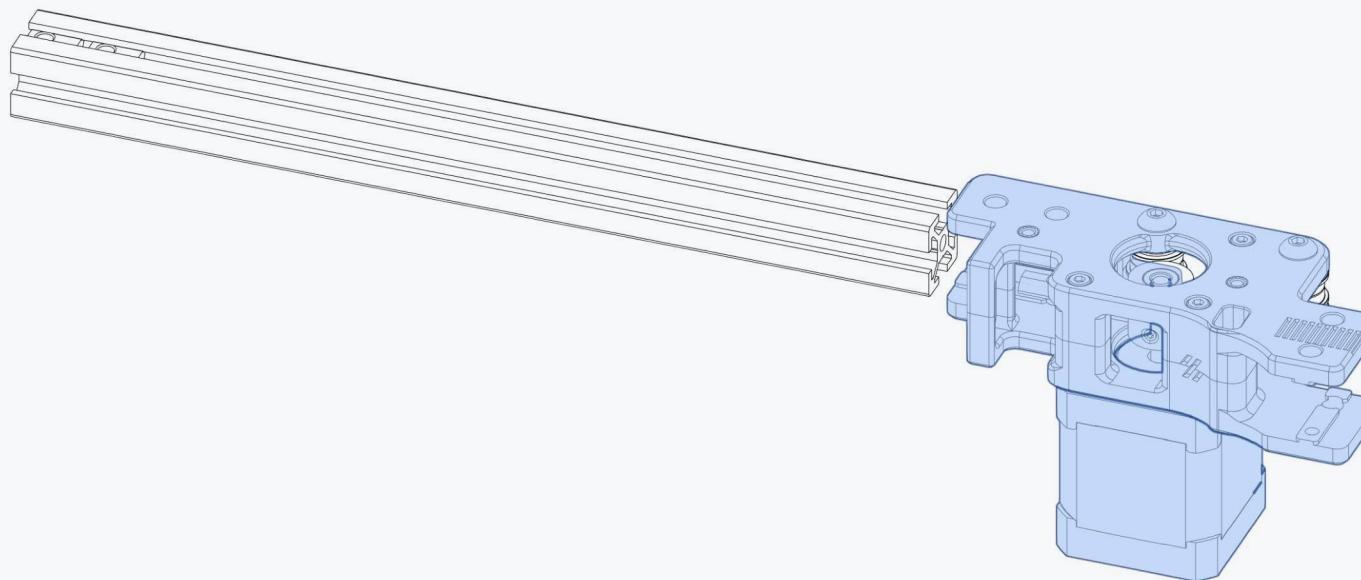
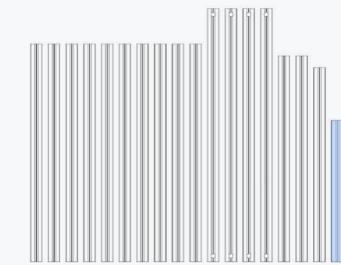
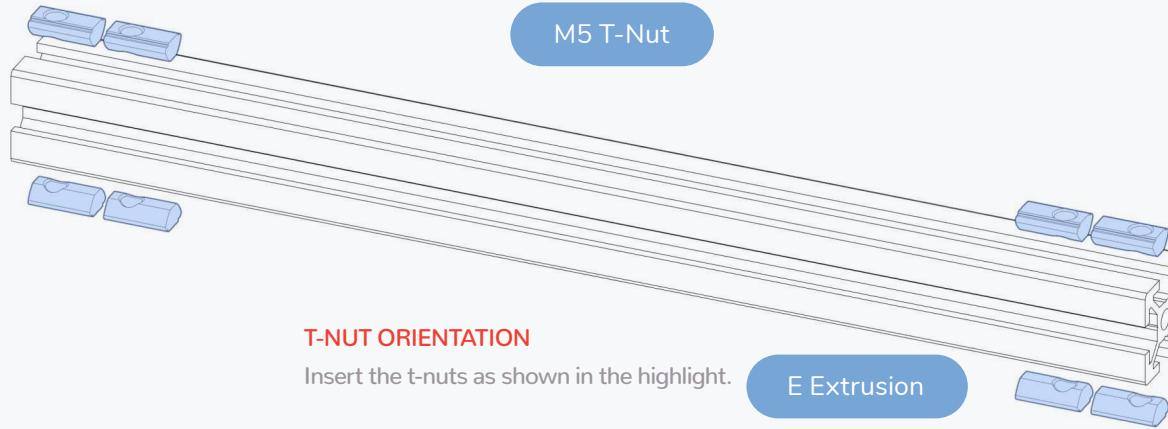
The 3 hole pattern is usually found on generic cable chains.

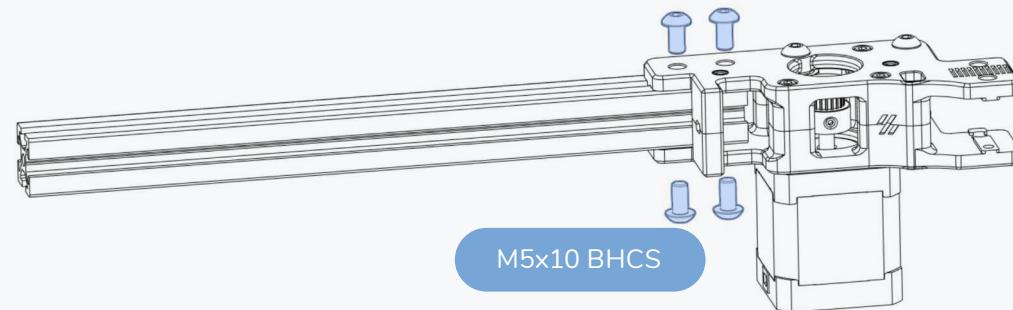
**IGUS CABLE CHAINS**

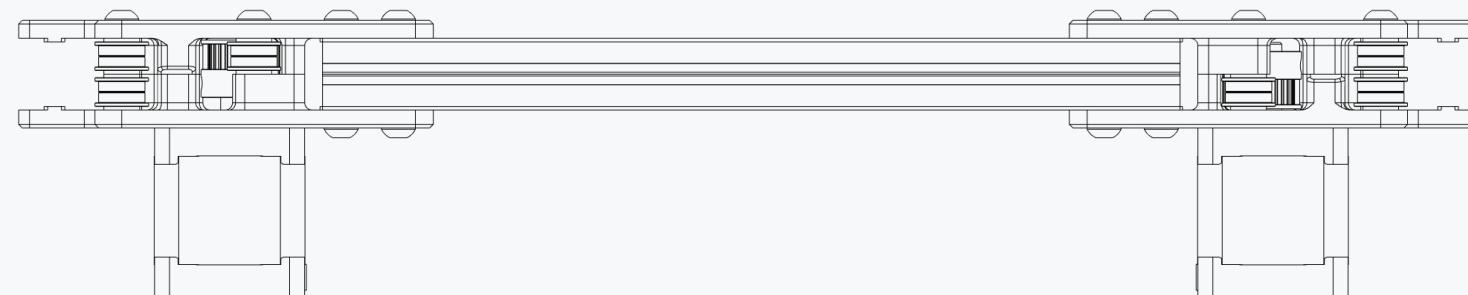
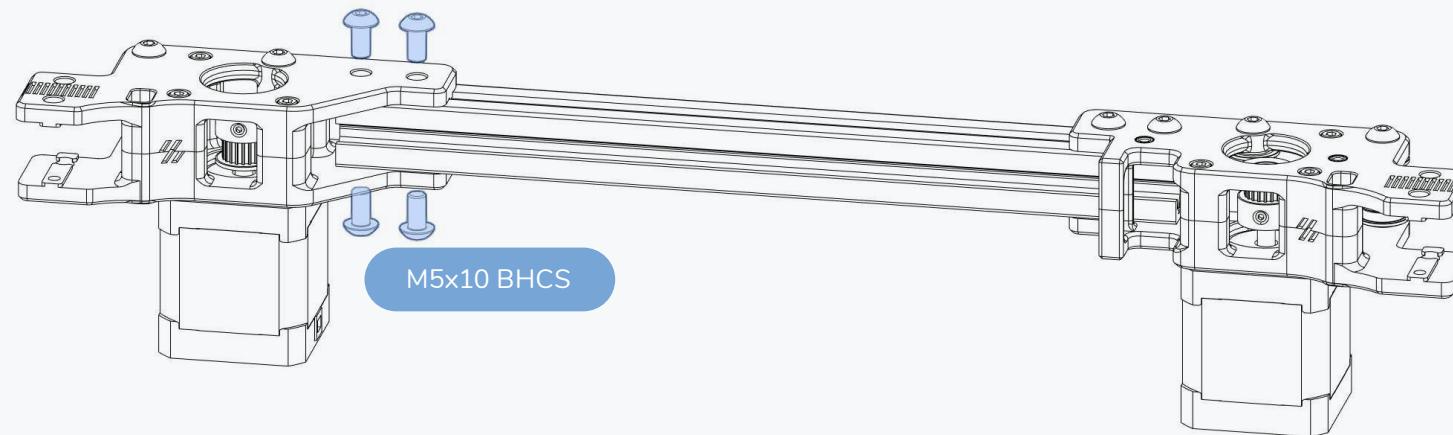
IGUS chains have 2 mounting holes.

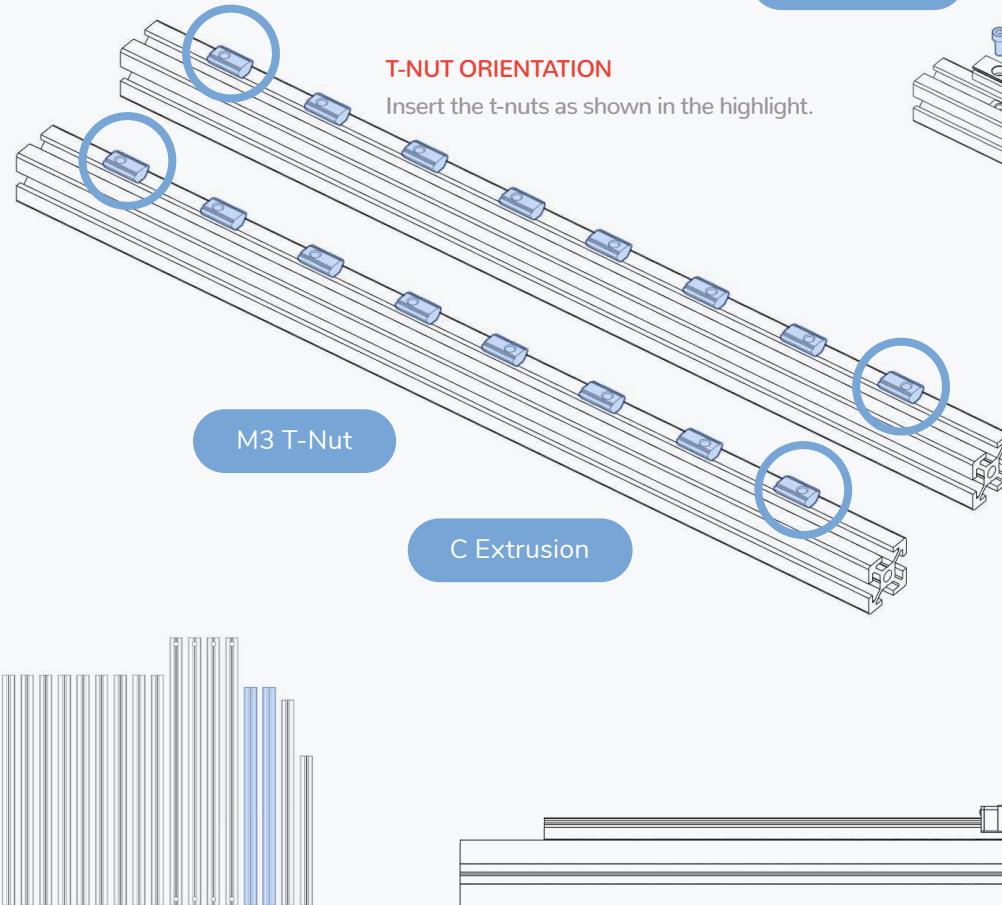
**WHICH TO CHOOSE?**

Pick the style that matches the mounting pattern of your cable chains.



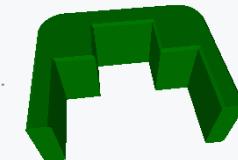






CENTRED RAIL INSTALLATION GUIDE

Use the MGN9 guides to position the rail in the centre of the extrusion prior to fastening the screws.

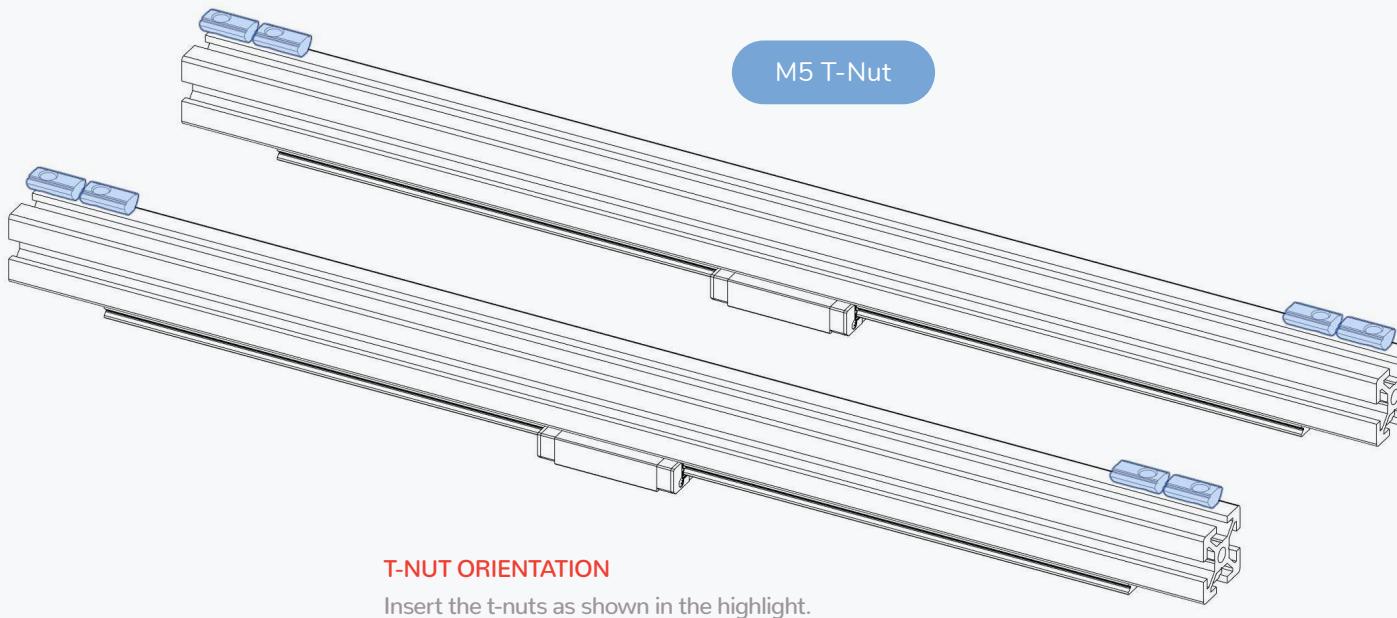


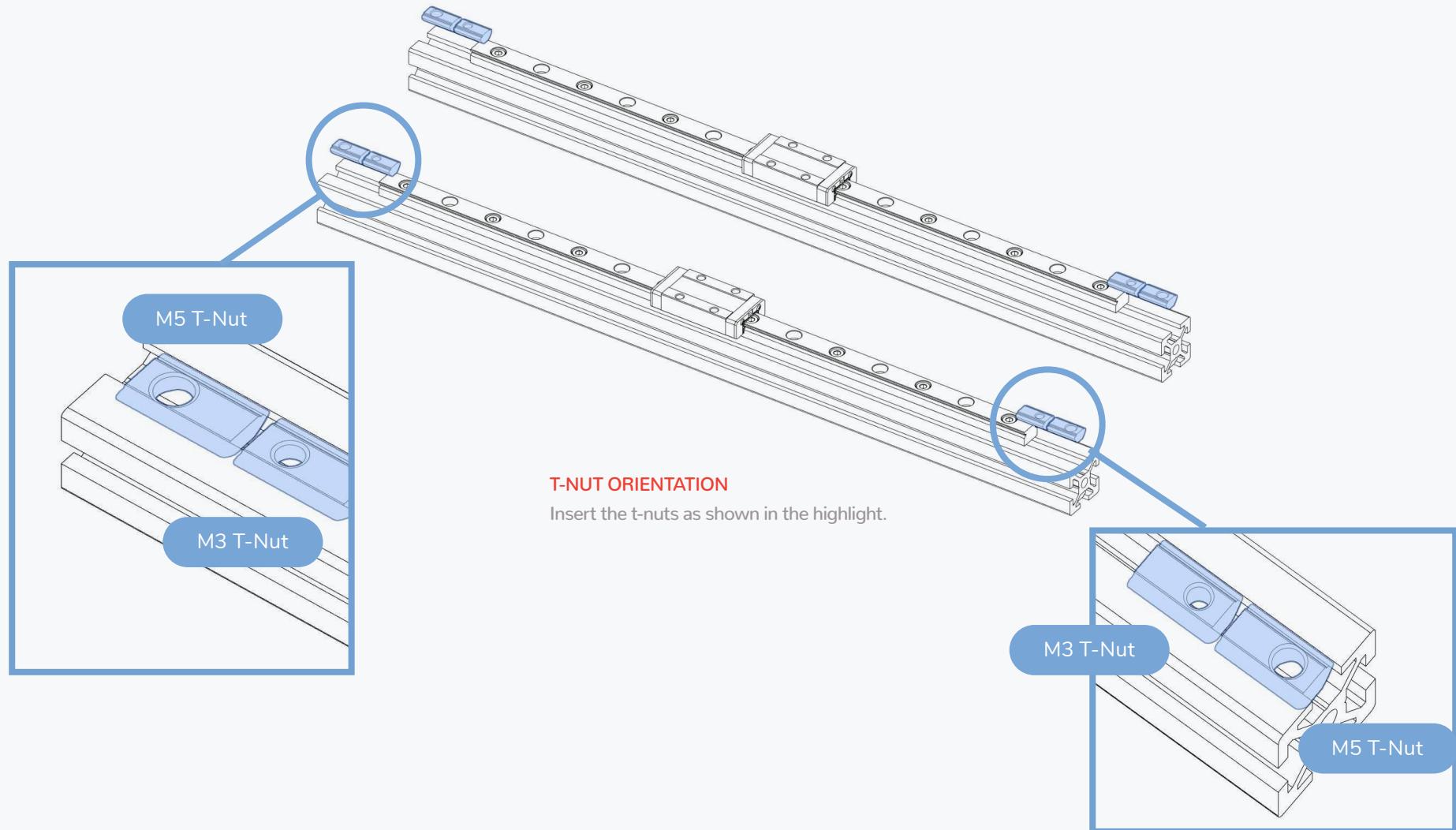
MIND THE CARRIAGE

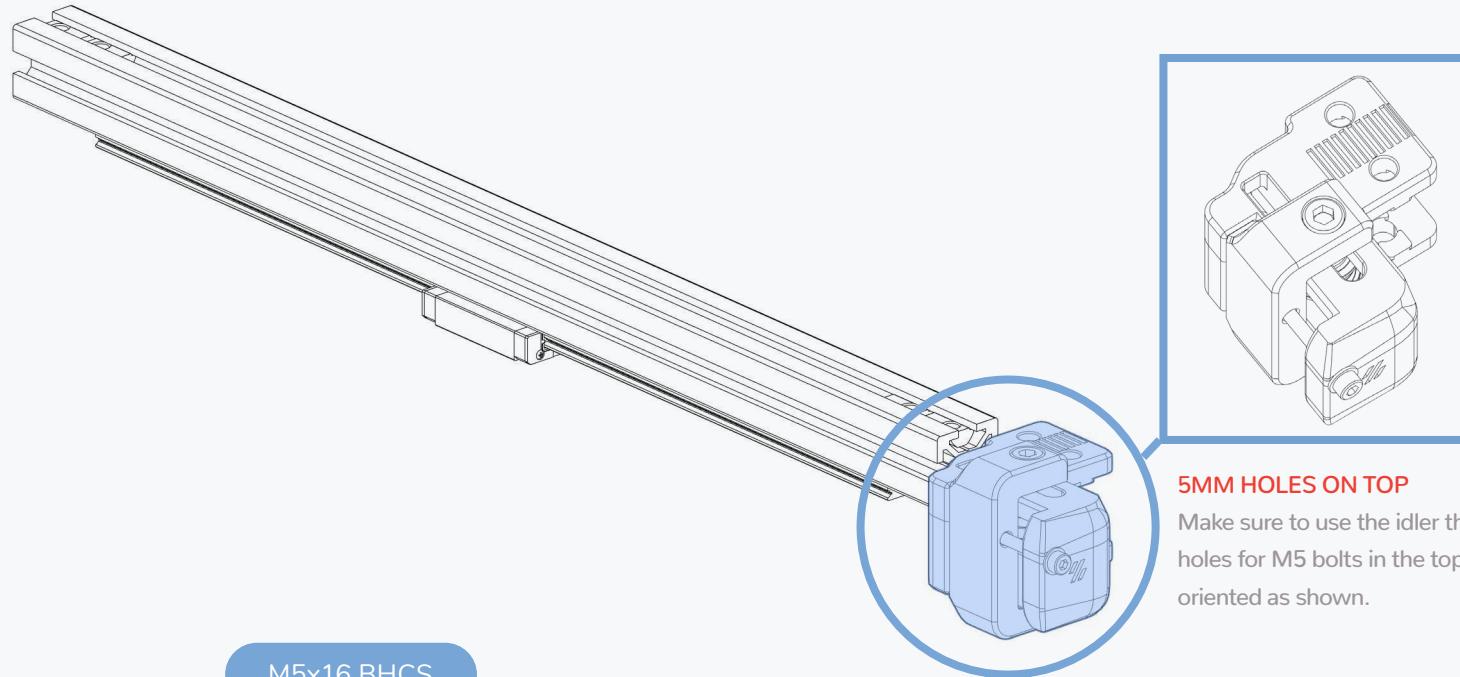
The carriages are designed to slide along the rail easily. This unfortunately also includes sliding off the rails.

Dropping the carriage likely irreparably damages it.

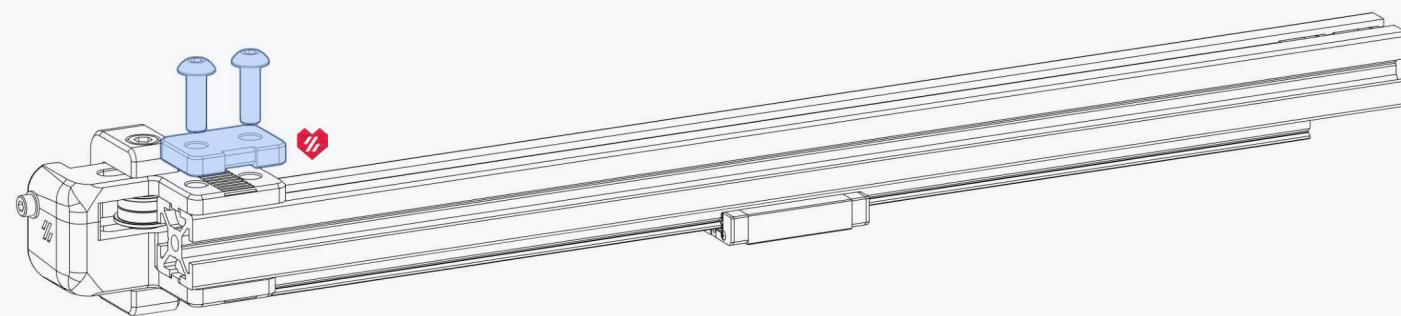


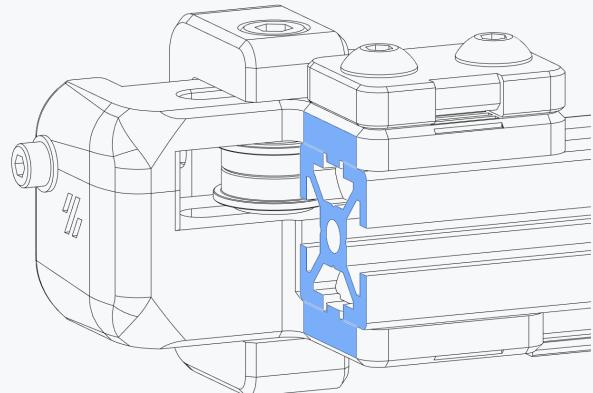




**5MM HOLES ON TOP**

Make sure to use the idler that has 2 holes for M5 bolts in the top when oriented as shown.

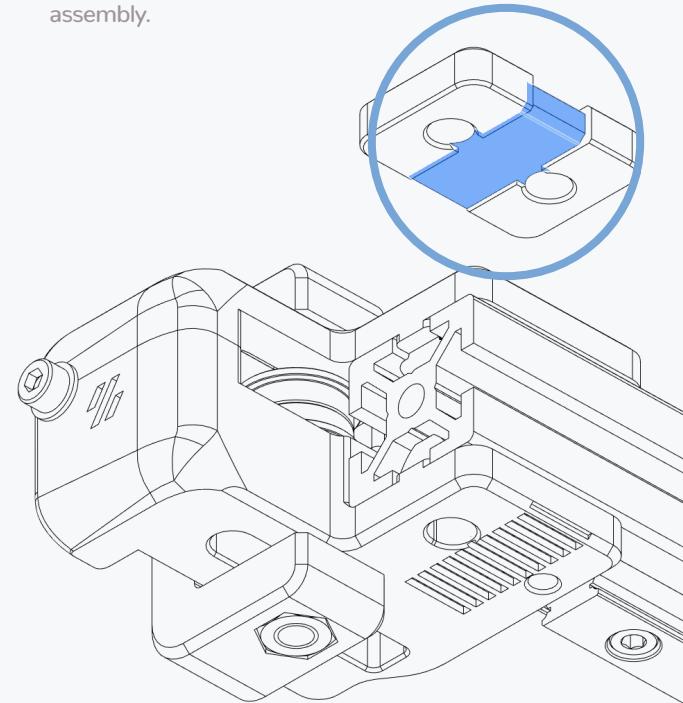


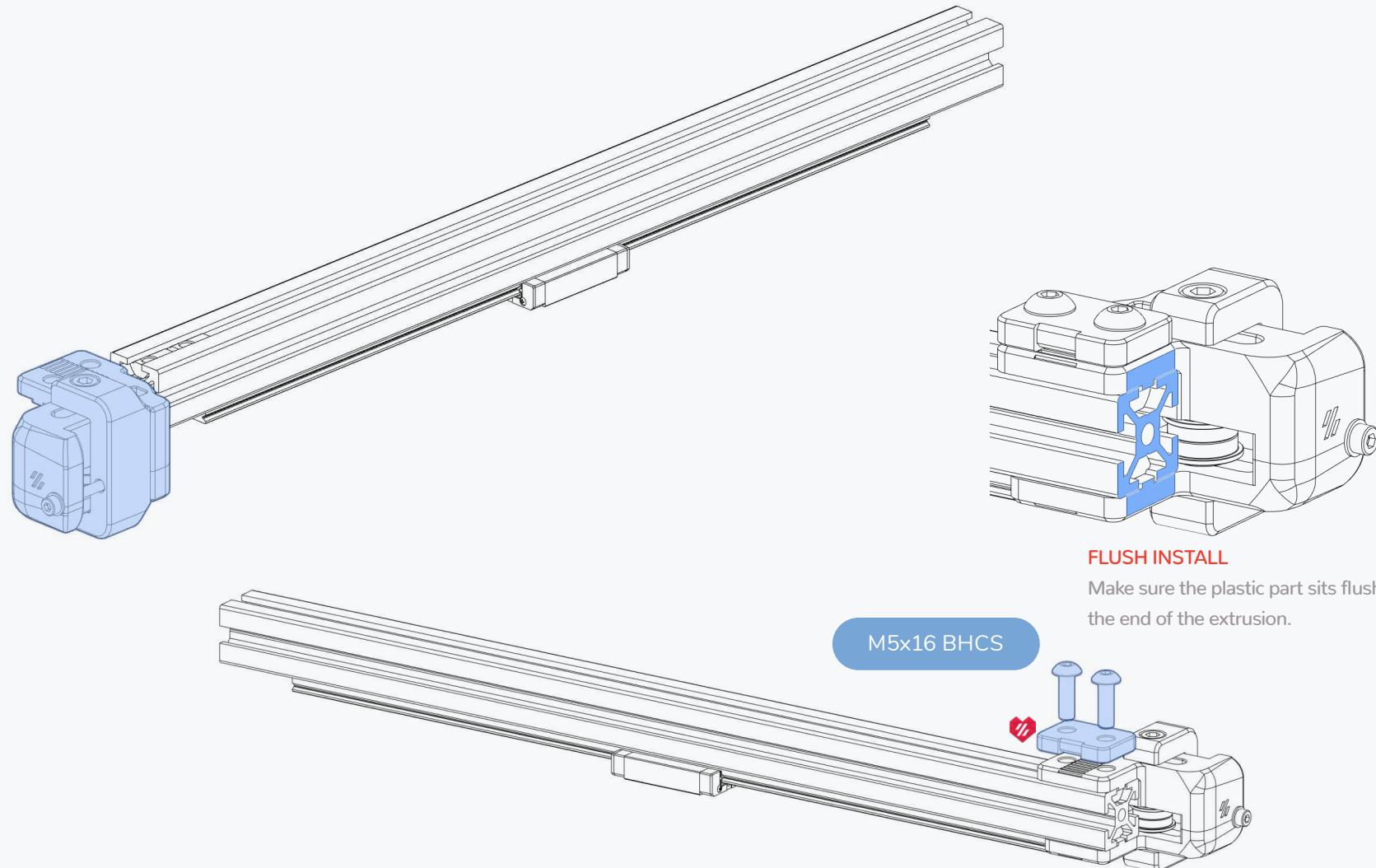
**FLUSH INSTALL**

Make sure the plastic part sits flush with the end of the extrusion. If not flush check if you installed the correct idler.

NOTCH ORIENTATION

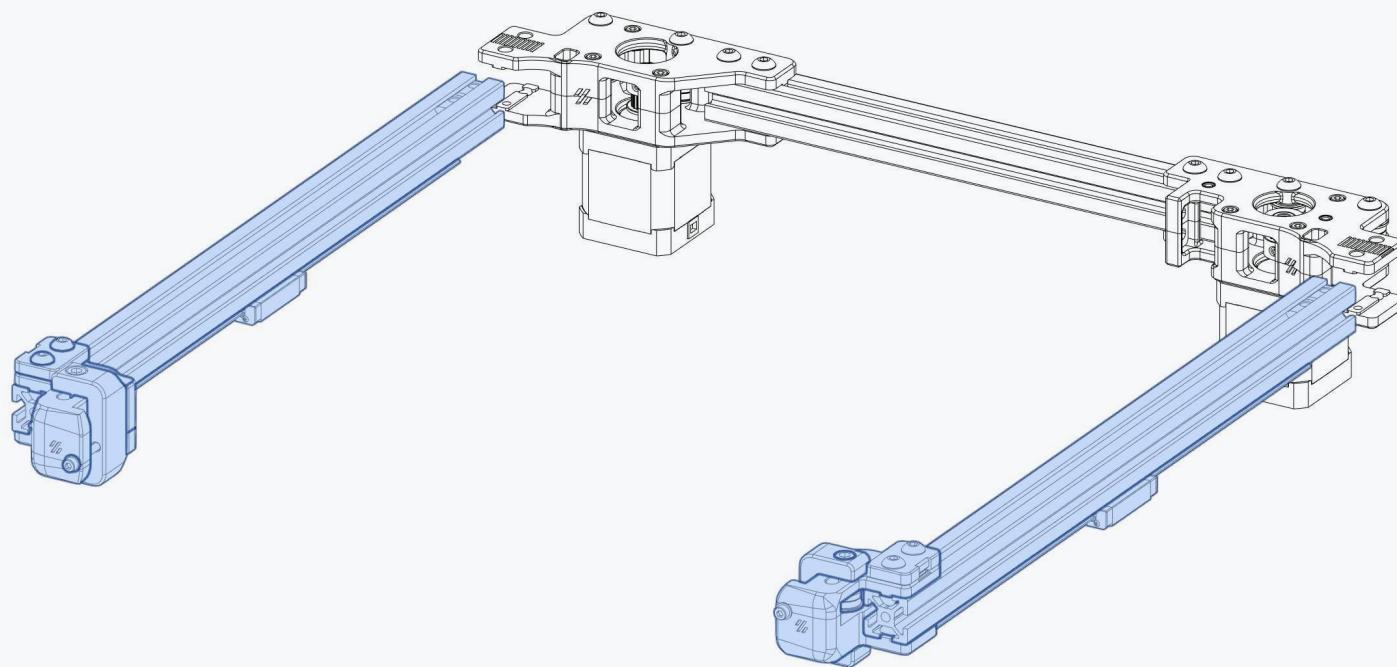
The indentation along the part is designed to clamp on the belt. The notch points away from the idler assembly.

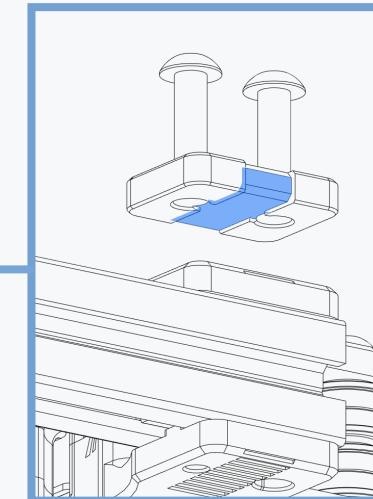
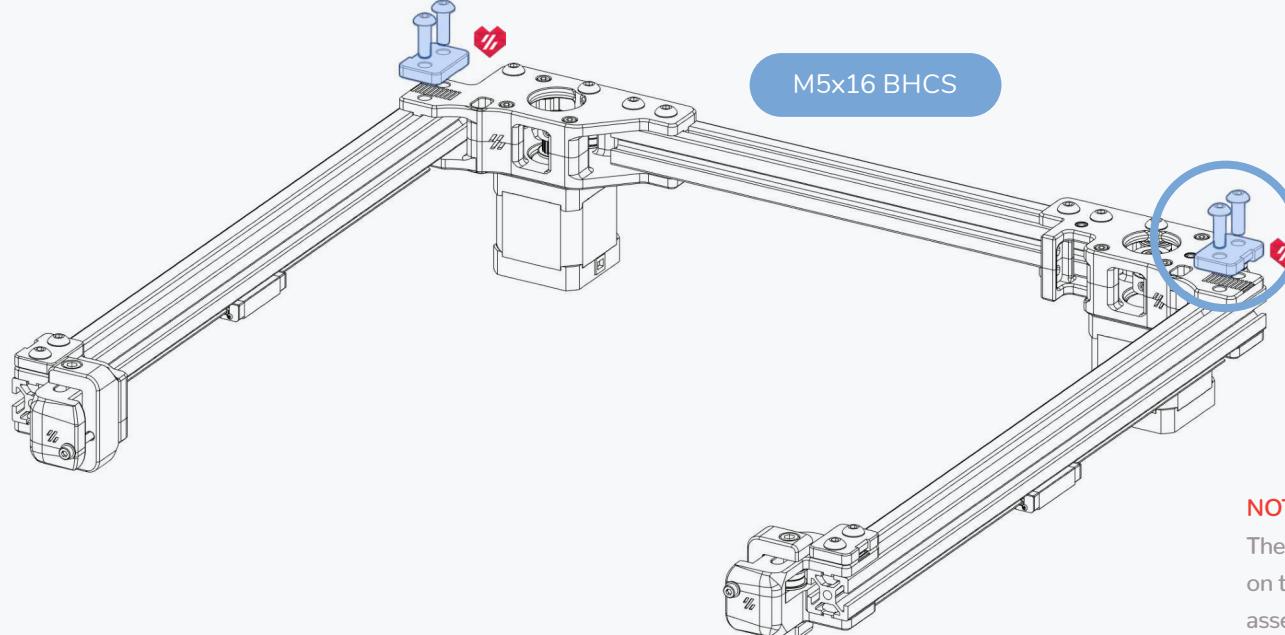


**FLUSH INSTALL**

Make sure the plastic part sits flush with the end of the extrusion.

M5x16 BHCS



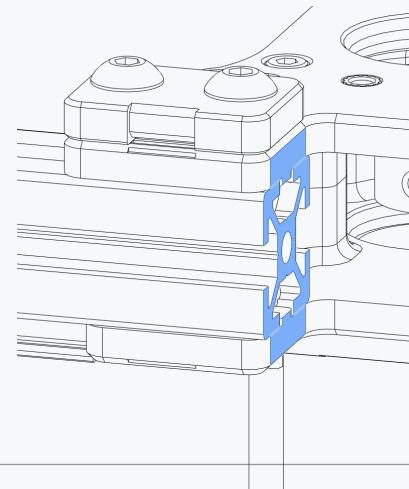


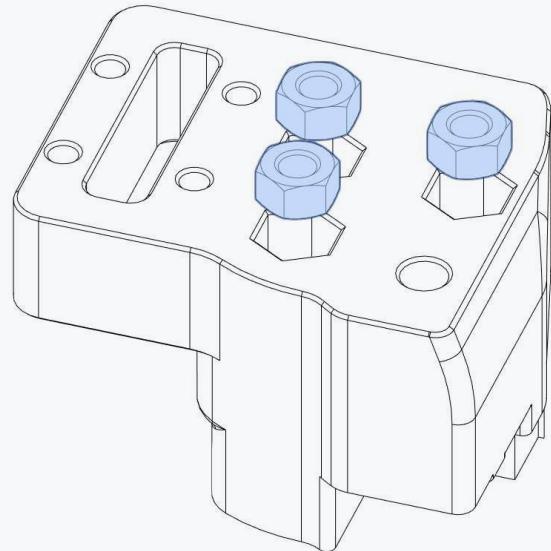
NOTCH ORIENTATION

The indentation along the part is designed to clamp on the belt. The notch points away from the drive assembly.

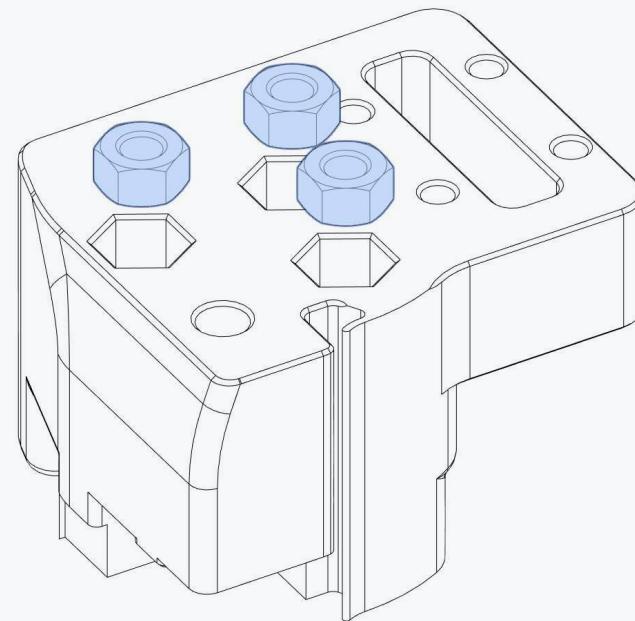
FLUSH INSTALL

Make sure the plastic part sits flush with the end of the extrusion.



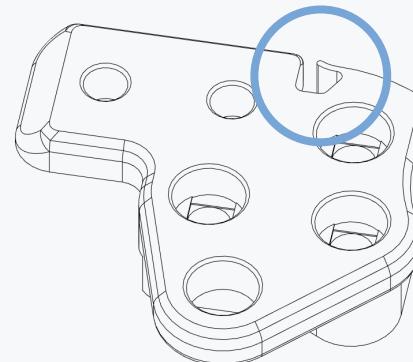


M5 Nut



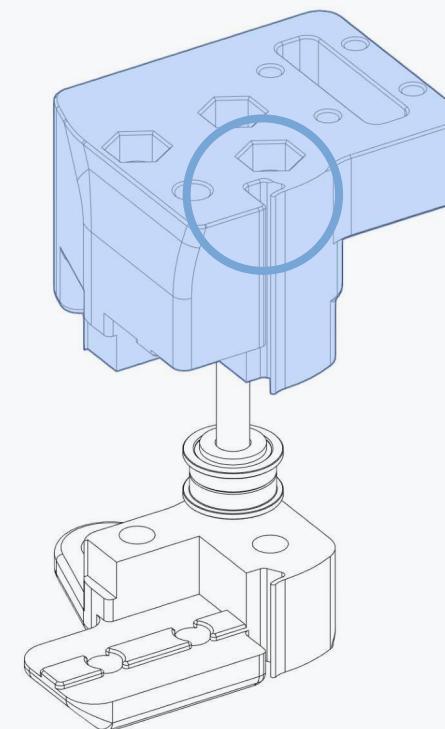
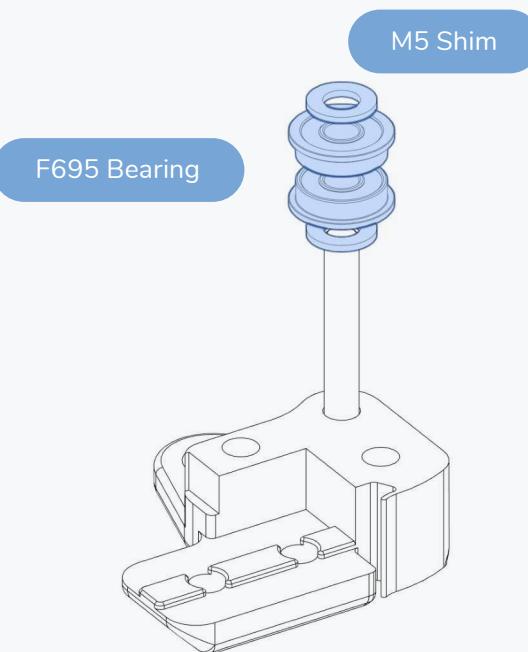
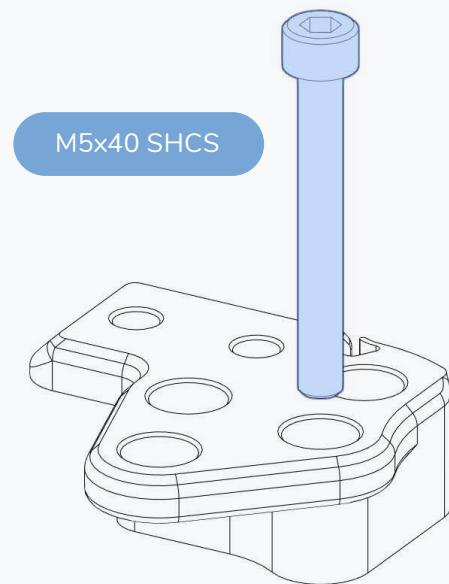
RIGHT XY JOINT

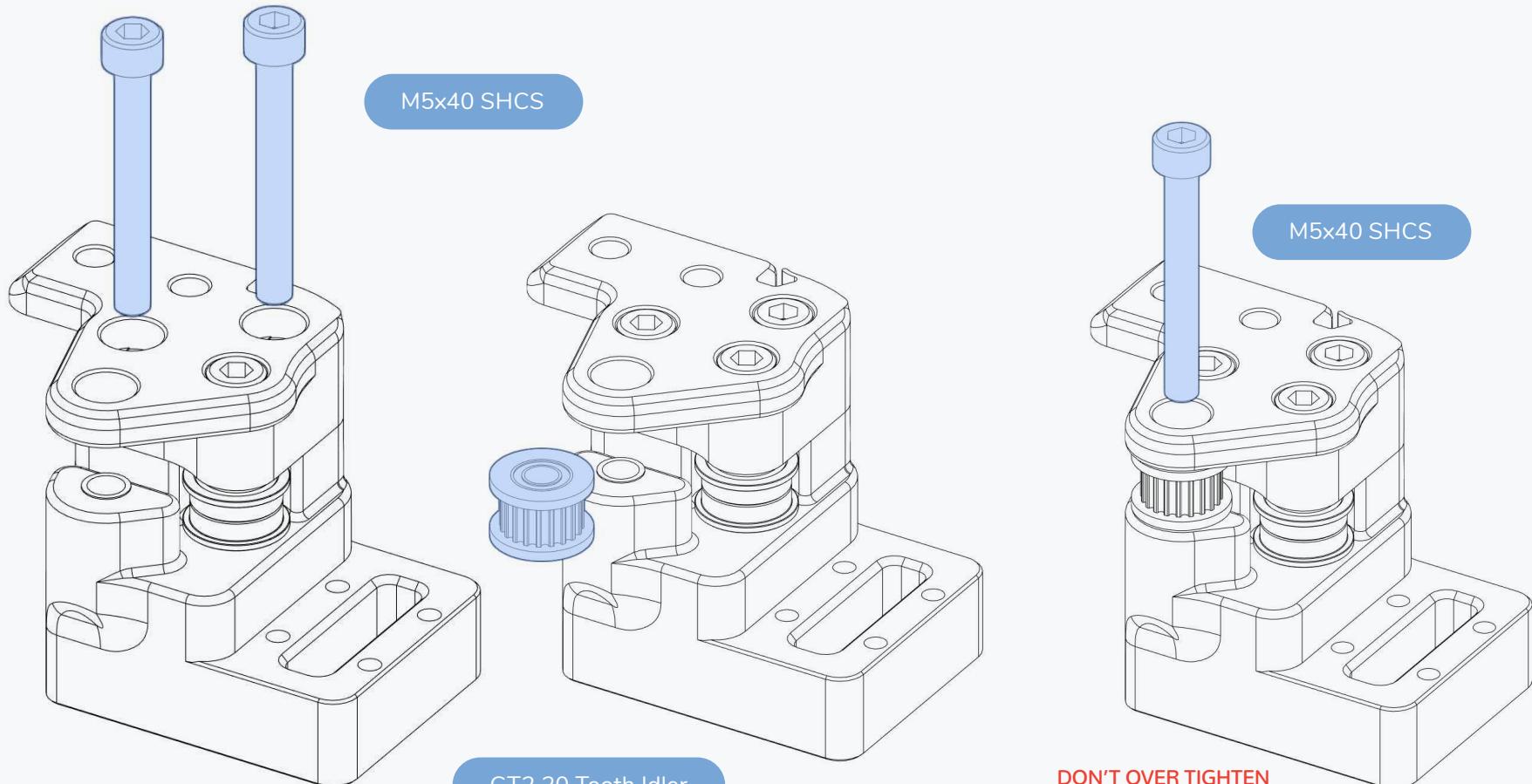
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CABLE PATH

The printed parts for the right XY joint have a small channel to guide the end stop wires..

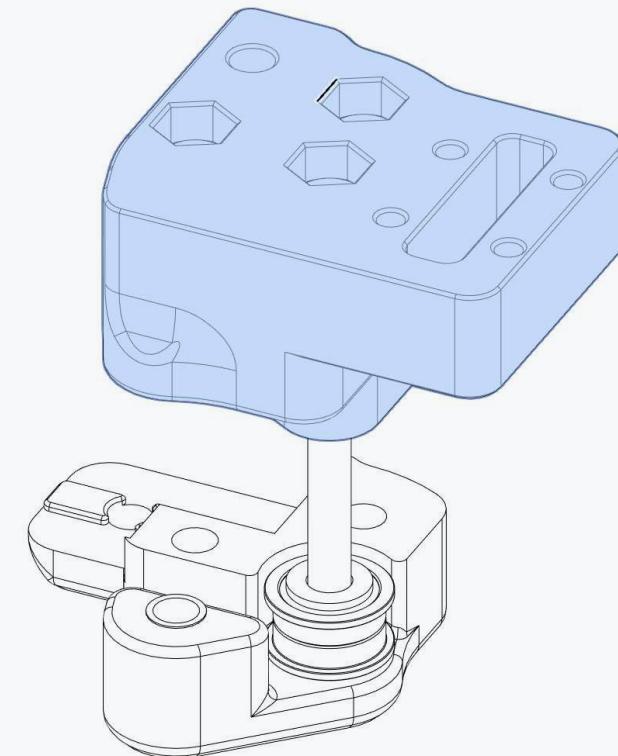
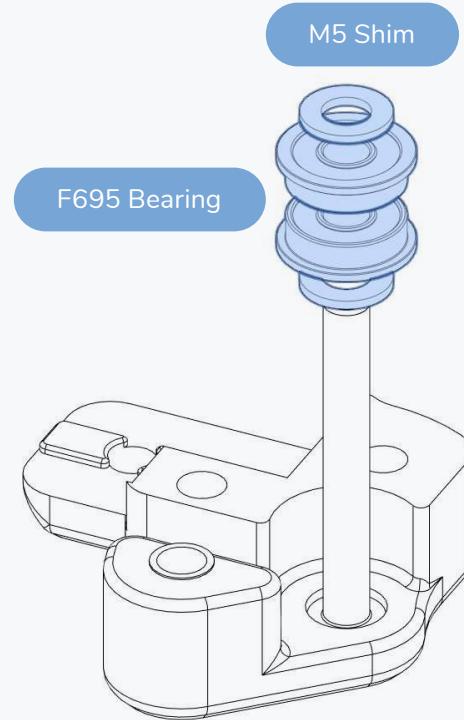
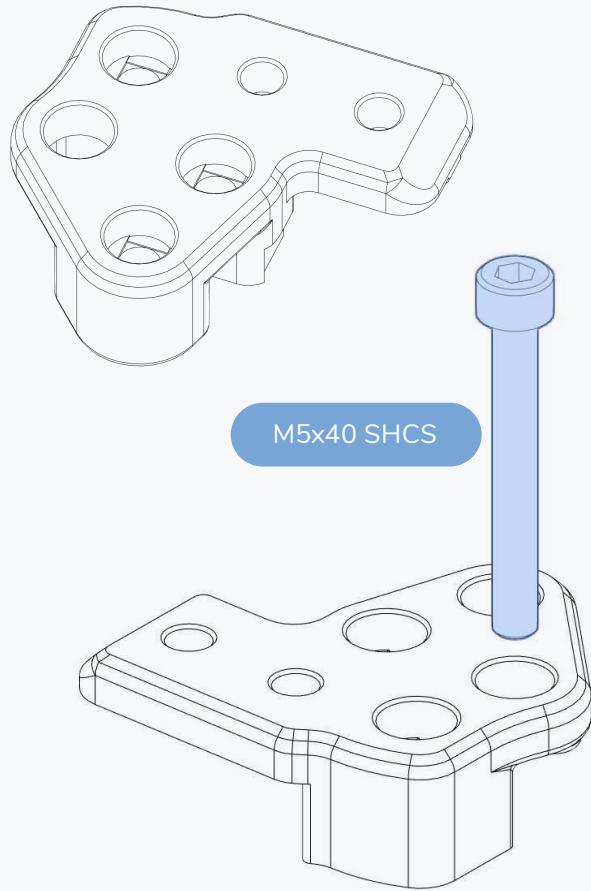


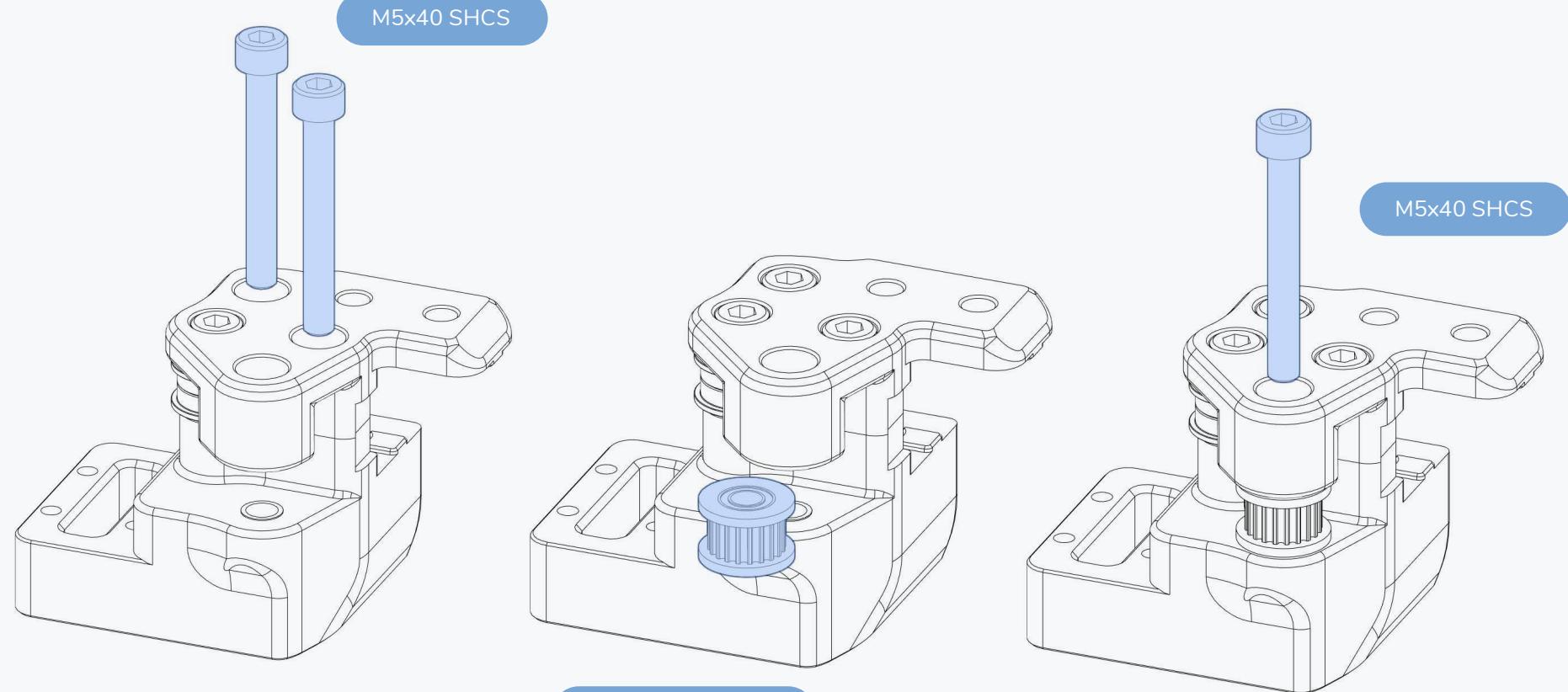
**DON'T OVER TIGHTEN**

The bolt is used to position the idler and is screwed directly into plastic.
The idler must spin freely.

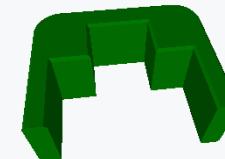
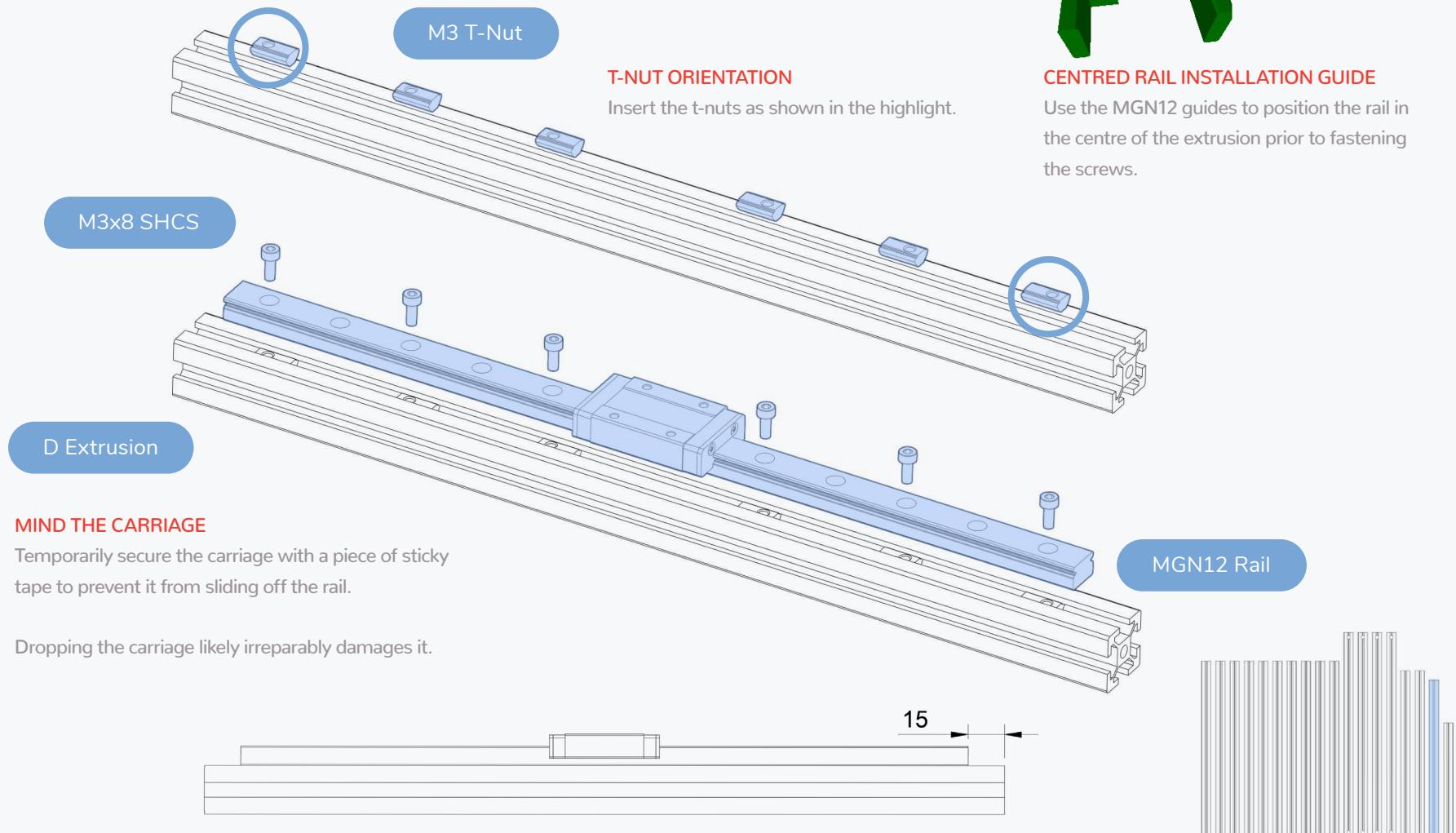
LEFT XY JOINT

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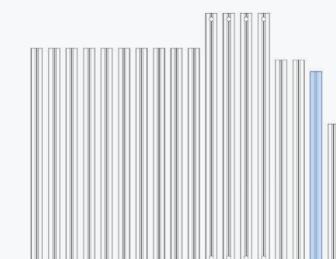


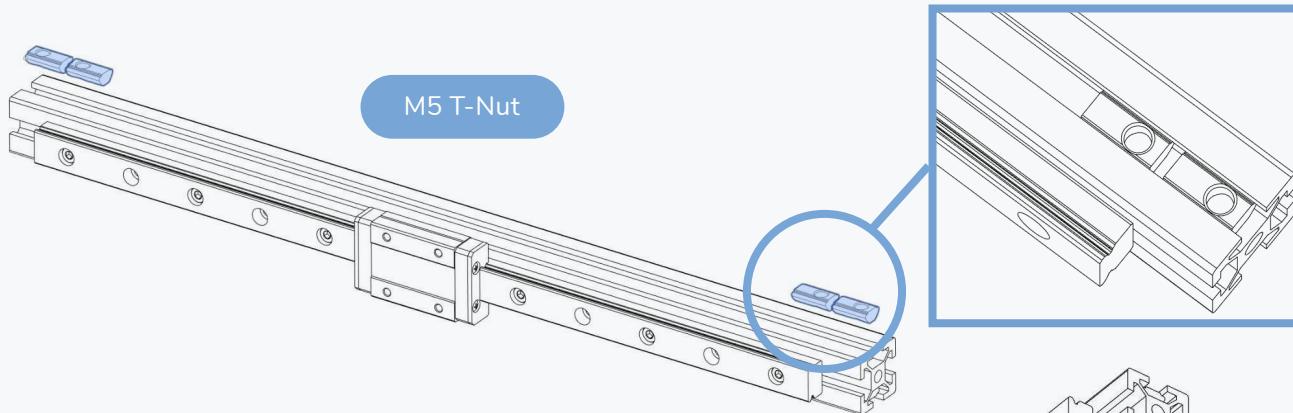
**DON'T OVER TIGHTEN**

The bolt is used to position the idler and is screwed directly into plastic.
The idler must spin freely.

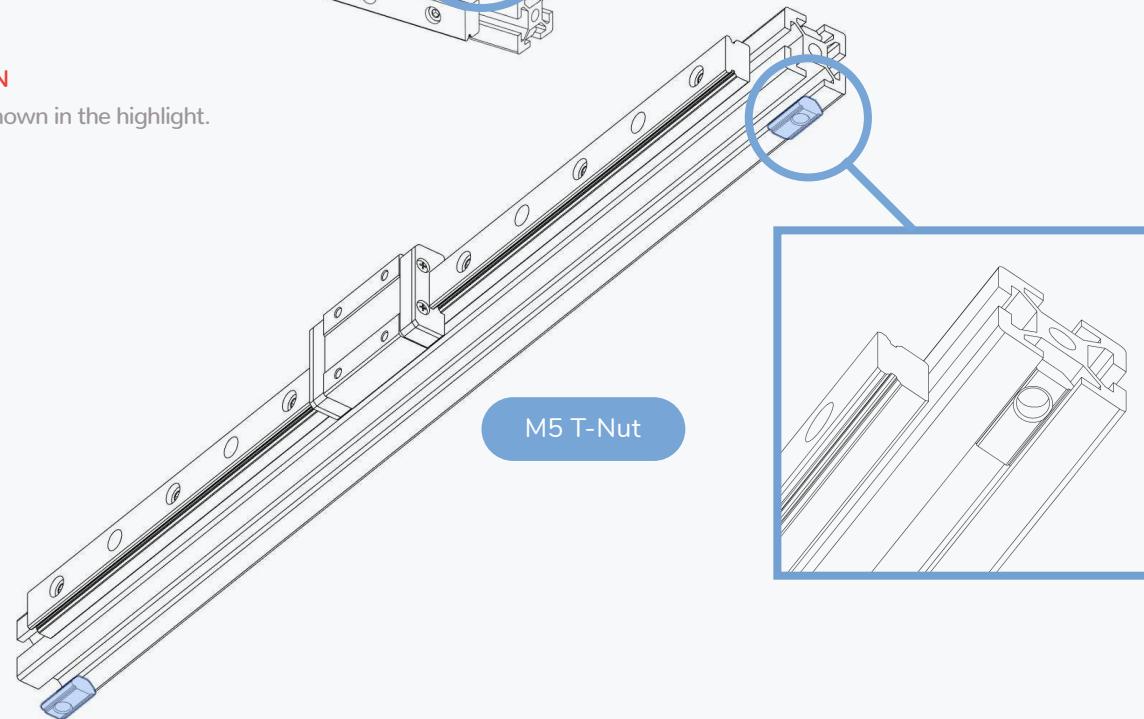
**CENTRED RAIL INSTALLATION GUIDE**

Use the MGN12 guides to position the rail in the centre of the extrusion prior to fastening the screws.



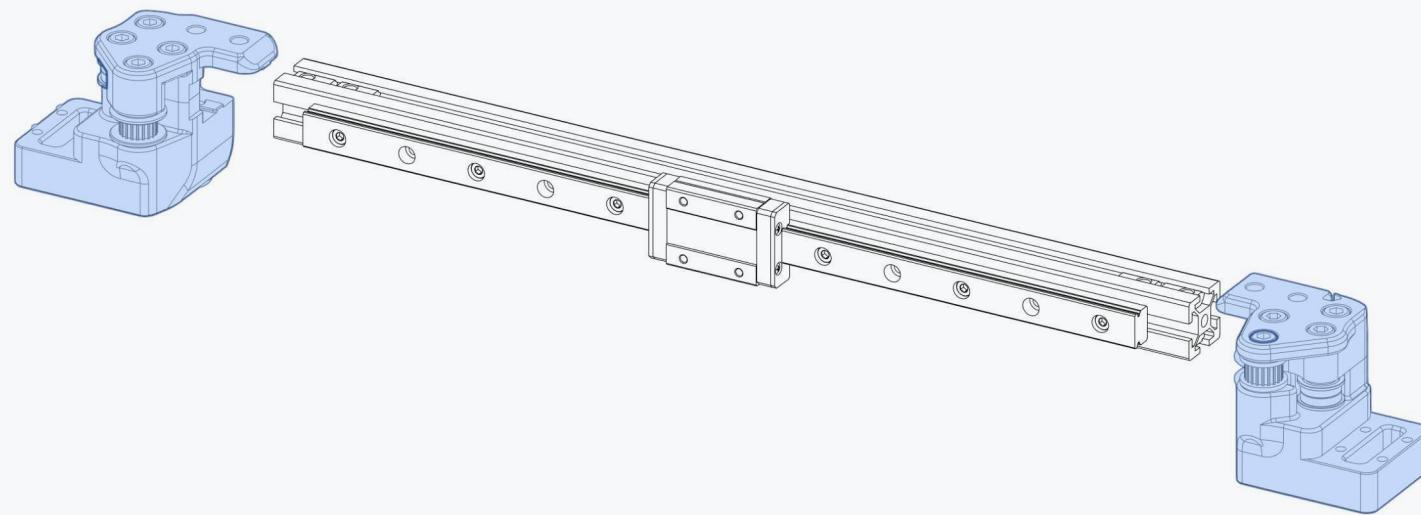
**T-NUT ORIENTATION**

Insert the t-nuts as shown in the highlight.



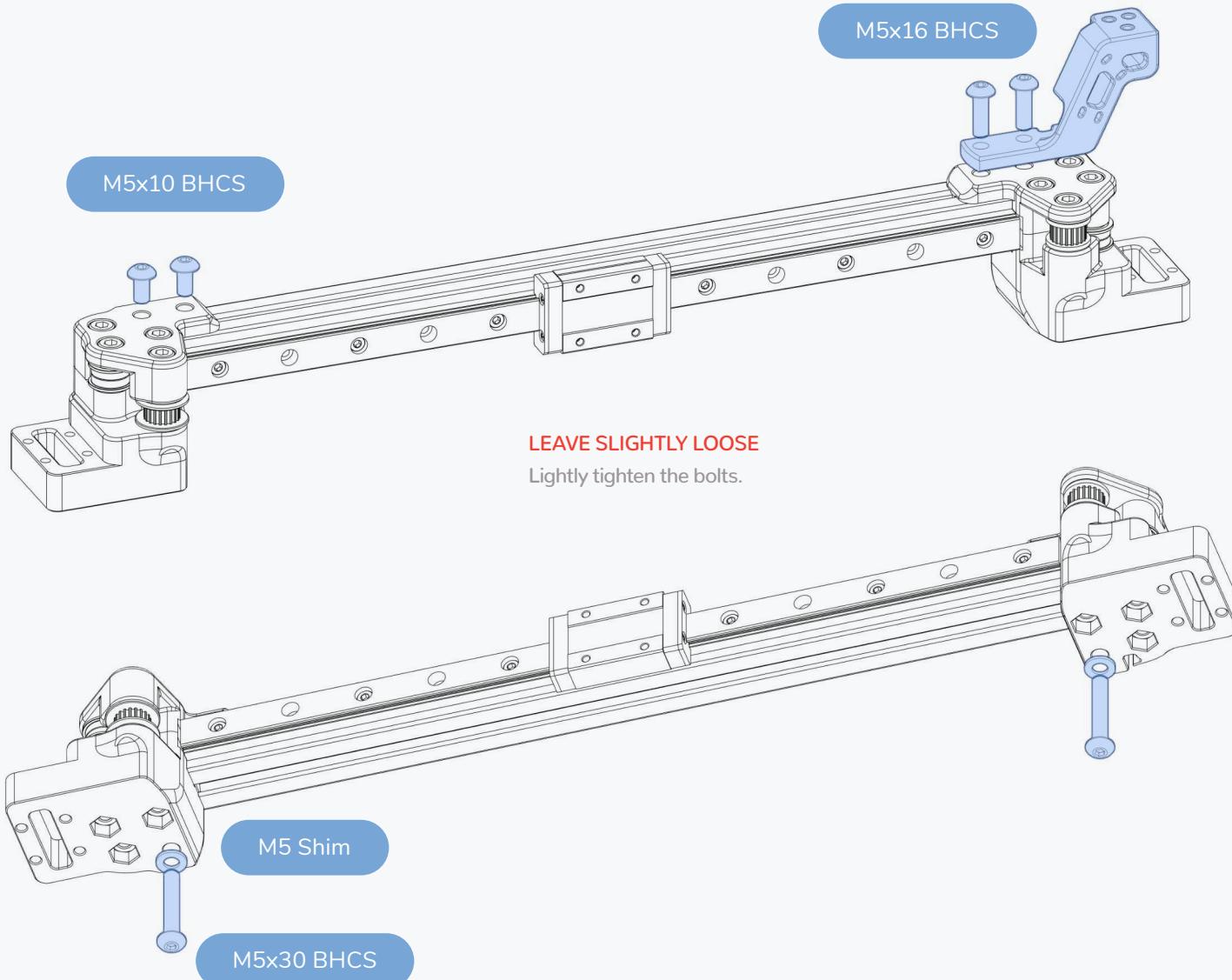
X AXIS

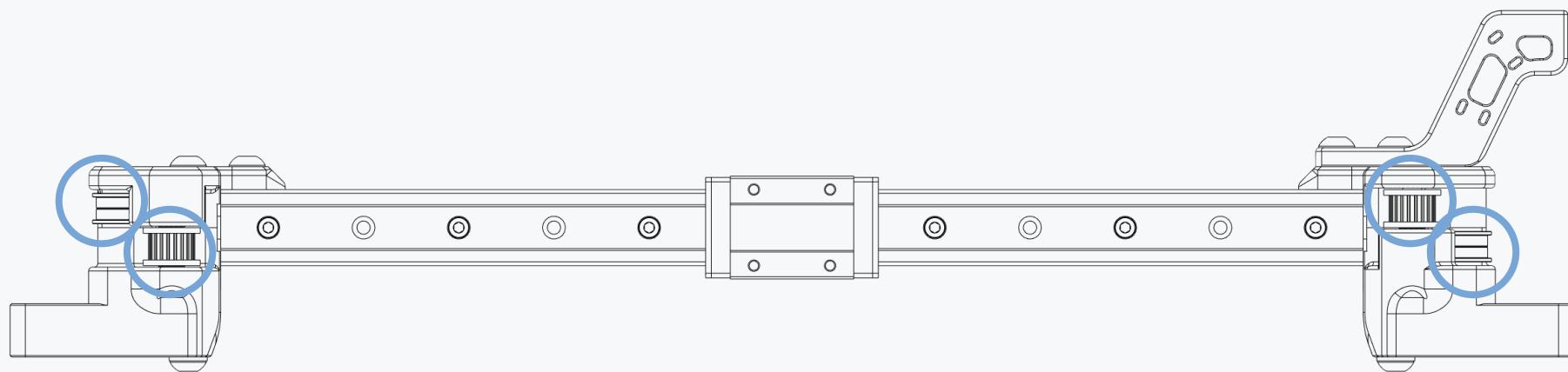
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X AXIS

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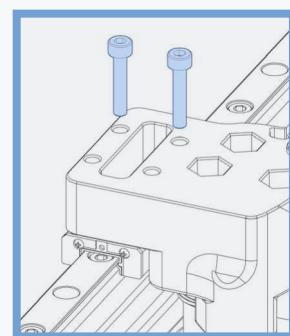
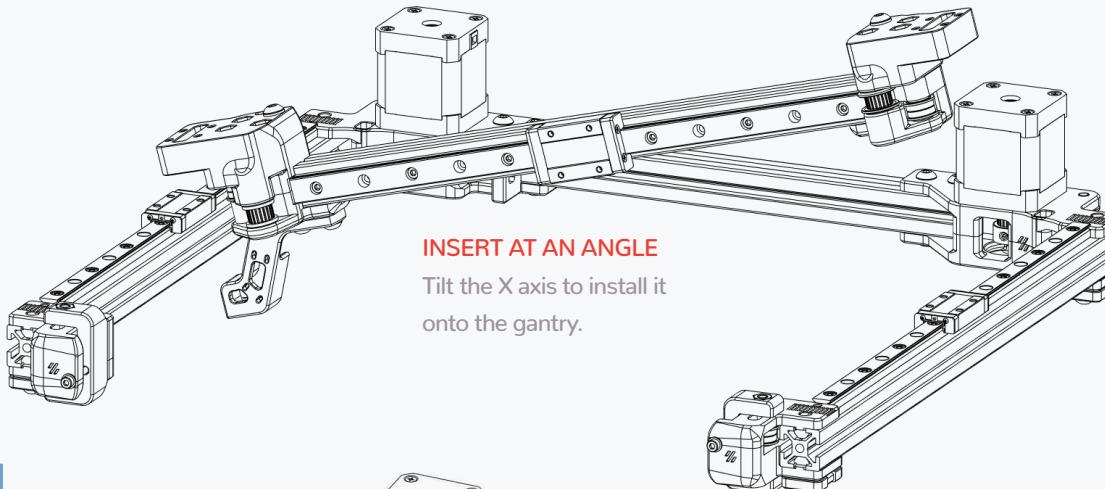
**CHECK YOUR WORK**

Compare your assembled part to the graphic shown here.

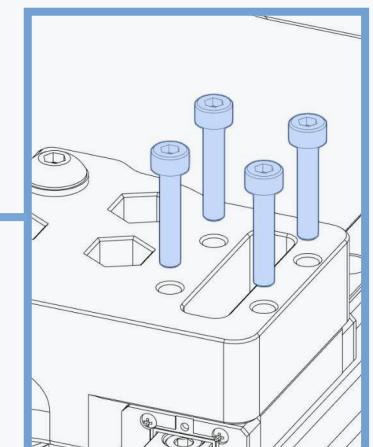
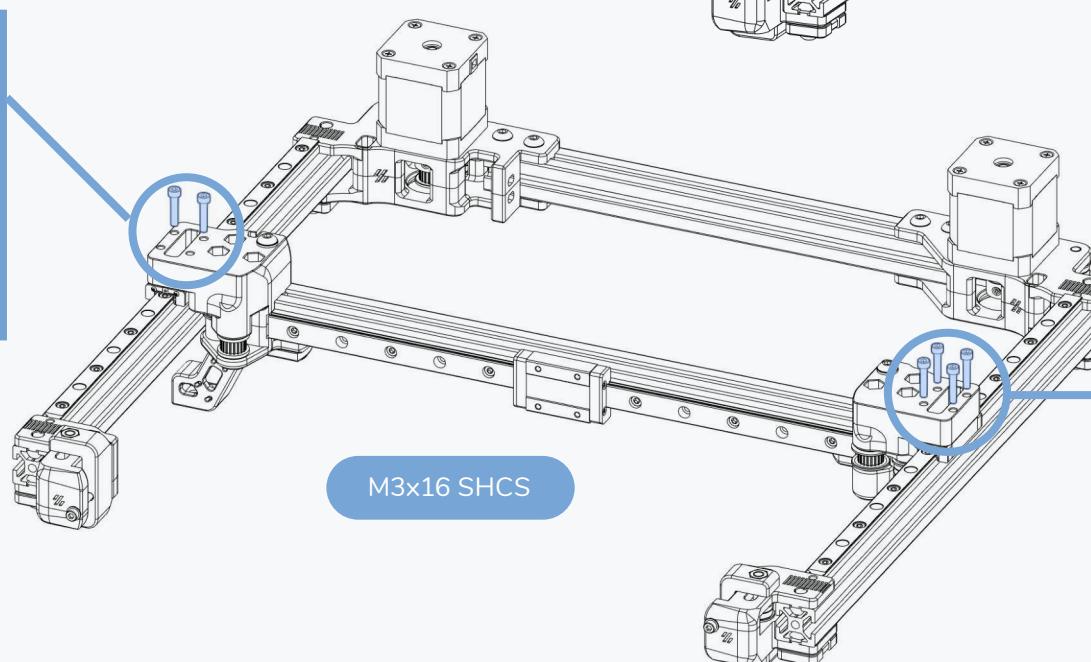
Pay attention to the pulley orientation and alignment with the bearing stack ups.

FLIP GANTRY

Turn the gantry around for the next step.

**2X BOLT ONLY**

The remaining bolts will be installed during the end-stop installation.

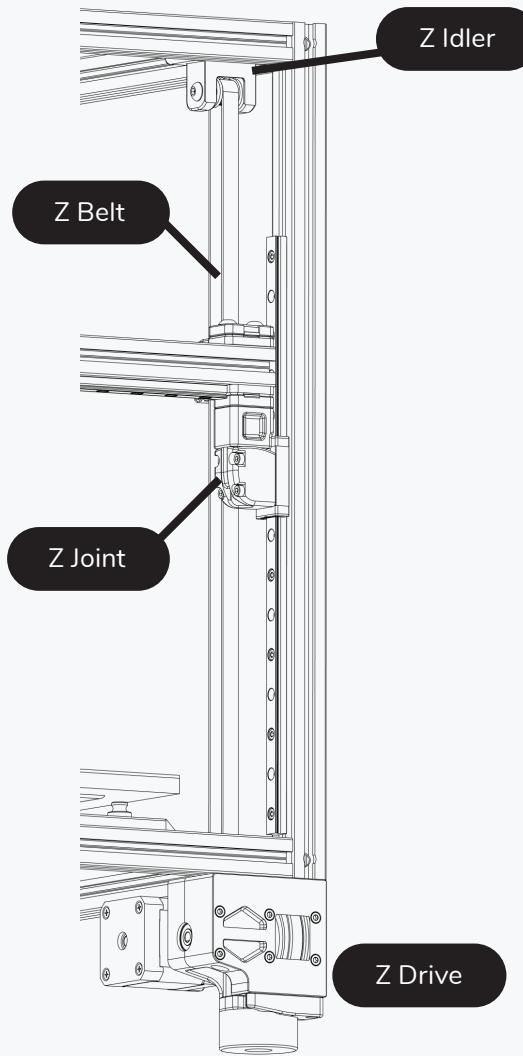


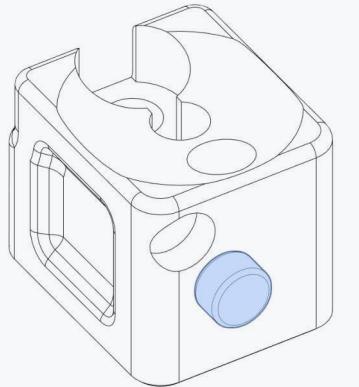
V1 and V2 are not version numbers but the printer models/lines. We renamed the V1 to Voron Trident to address the confusion this caused.

Z AXIS

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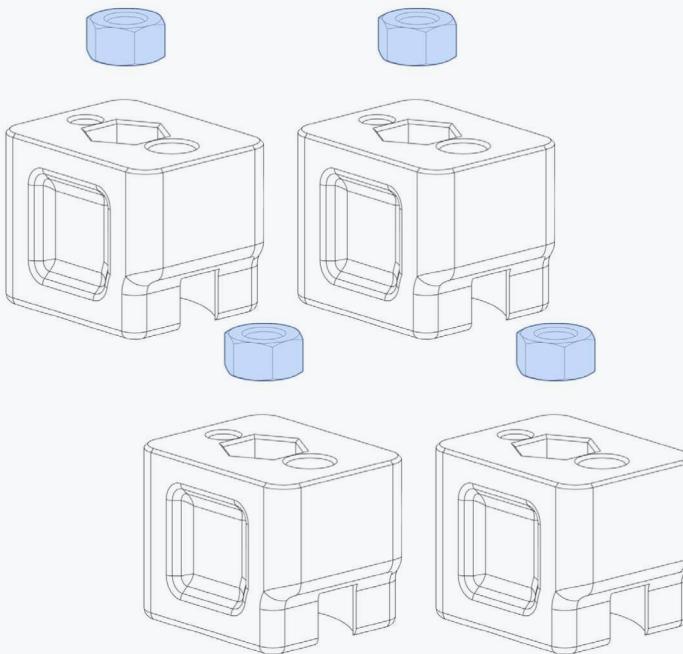


6x3 Magnet

OPTION: HALL EFFECT ENDSTOP

If you are building your printer with a Hall Effect Endstop add a magnet to the cutout.

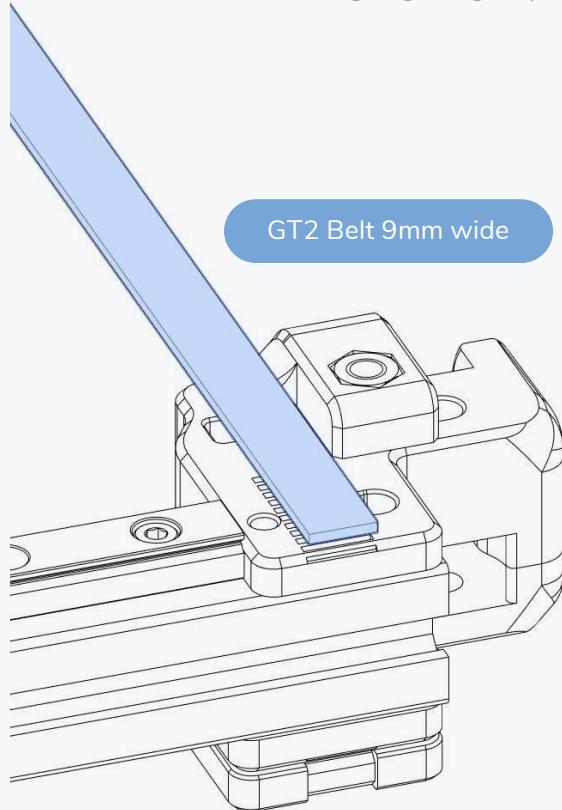
M5 Nut



Z BEARING BLOCKS

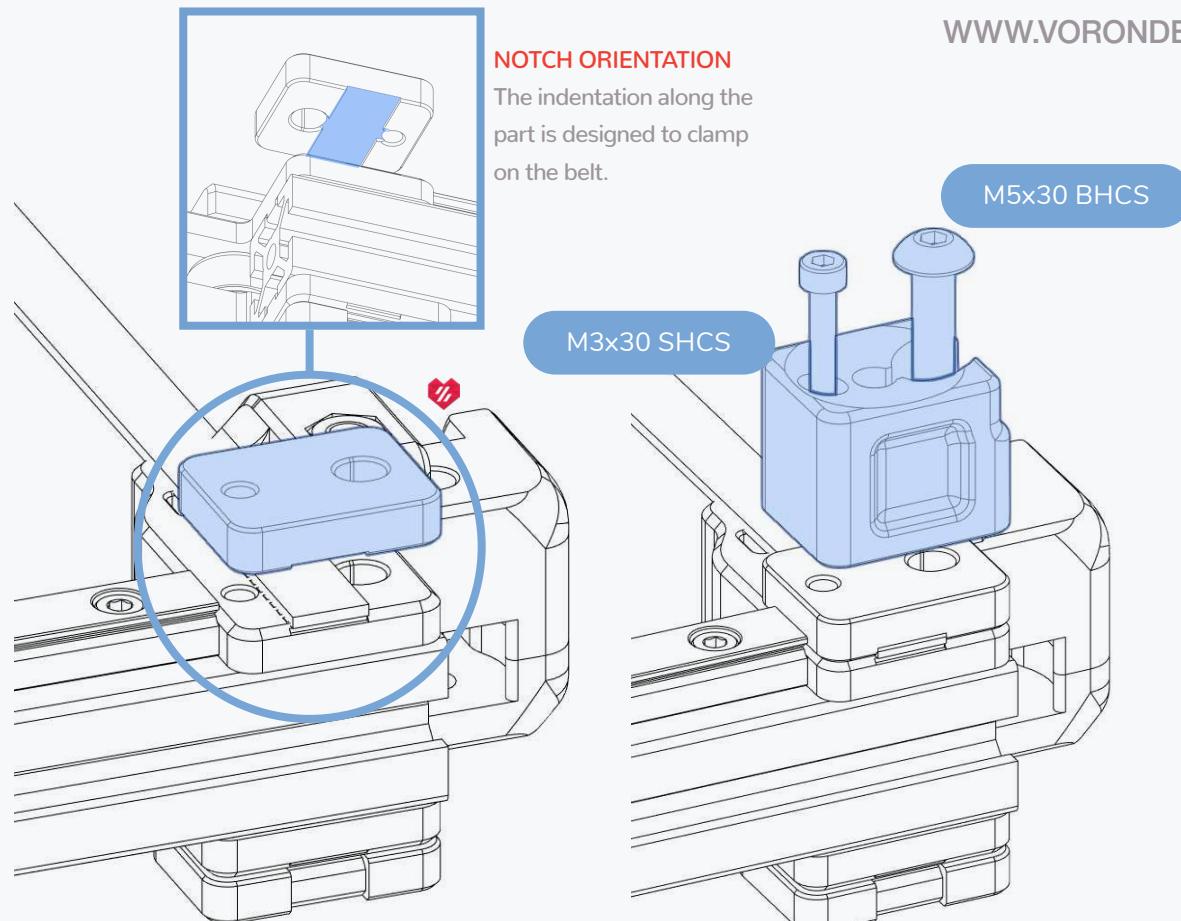
GANTRY IS STILL UPSIDE DOWN

It's a lot easier than fighting with gravity.



TEETH DOWN

The teeth of the belts are facing down into the serrations in the printed part.

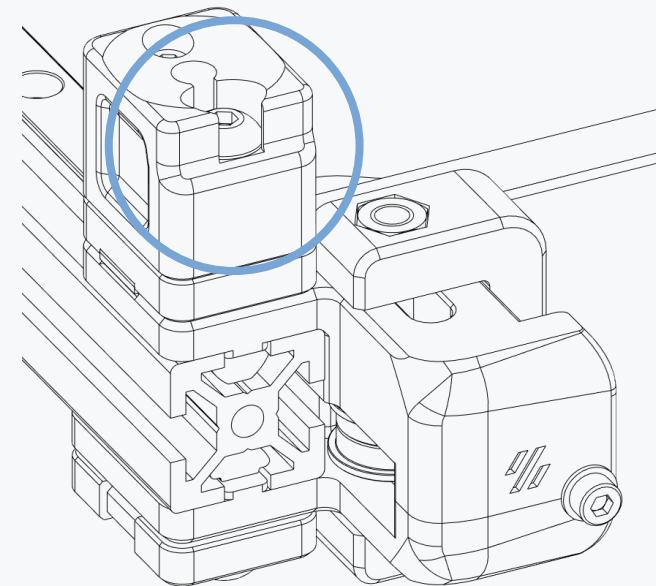
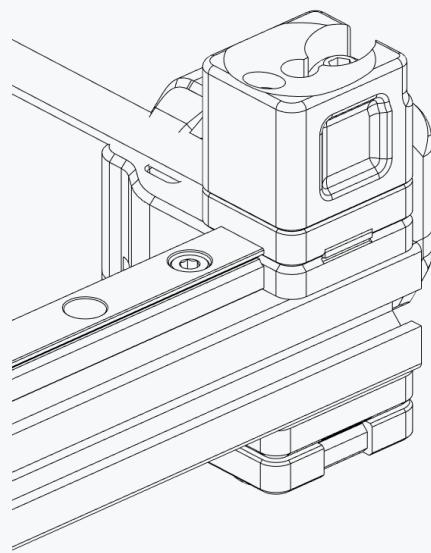


MINIMUM RECOMMENDED BELT CUT LENGTH

250 spec 1000mm

300 spec 1100mm

350 spec 1200mm

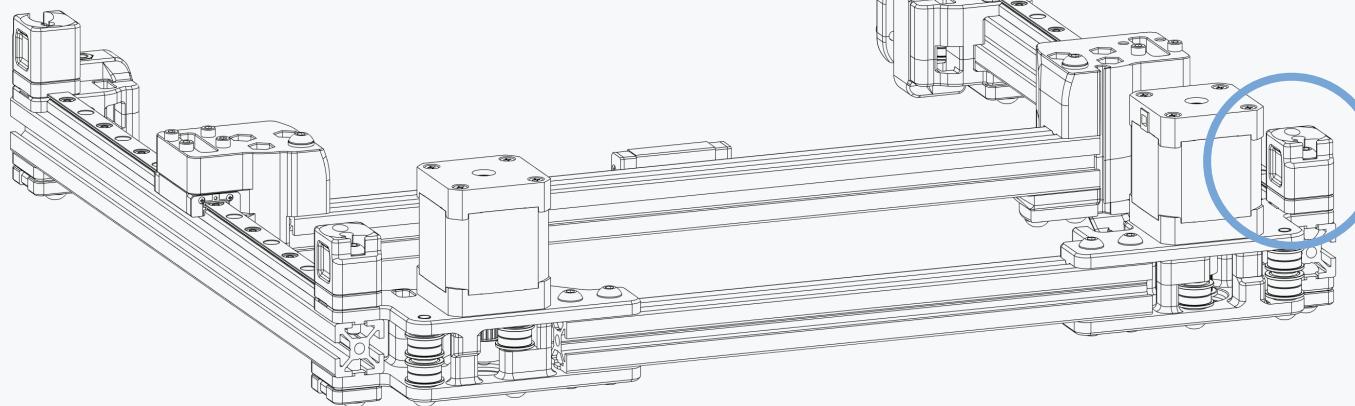
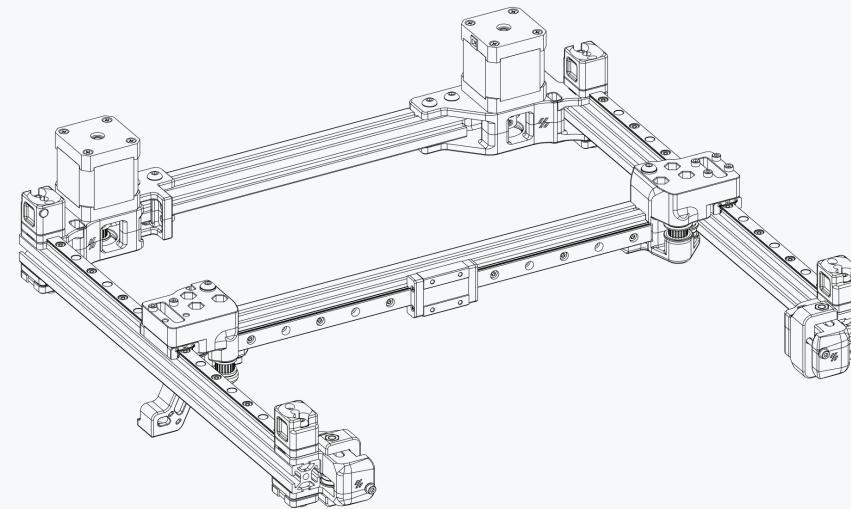


MIND THE PART ORIENTATION

The cutout goes towards the outside.

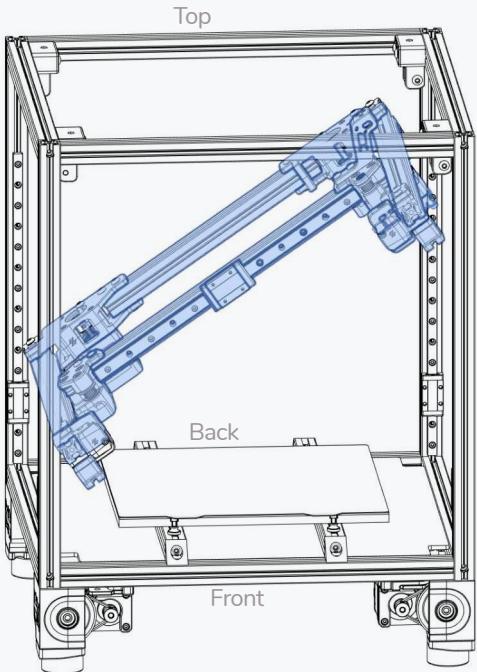
REPEAT BELT INSTALL FOR ALL 4 BLOCKS

We are not showing the belts in the pictures on this page.



OPTION: HALL ENDSTOP

Install the block with the magnet in this position. The magnet faces the XY joint.

**INSERT AT AN ANGLE**

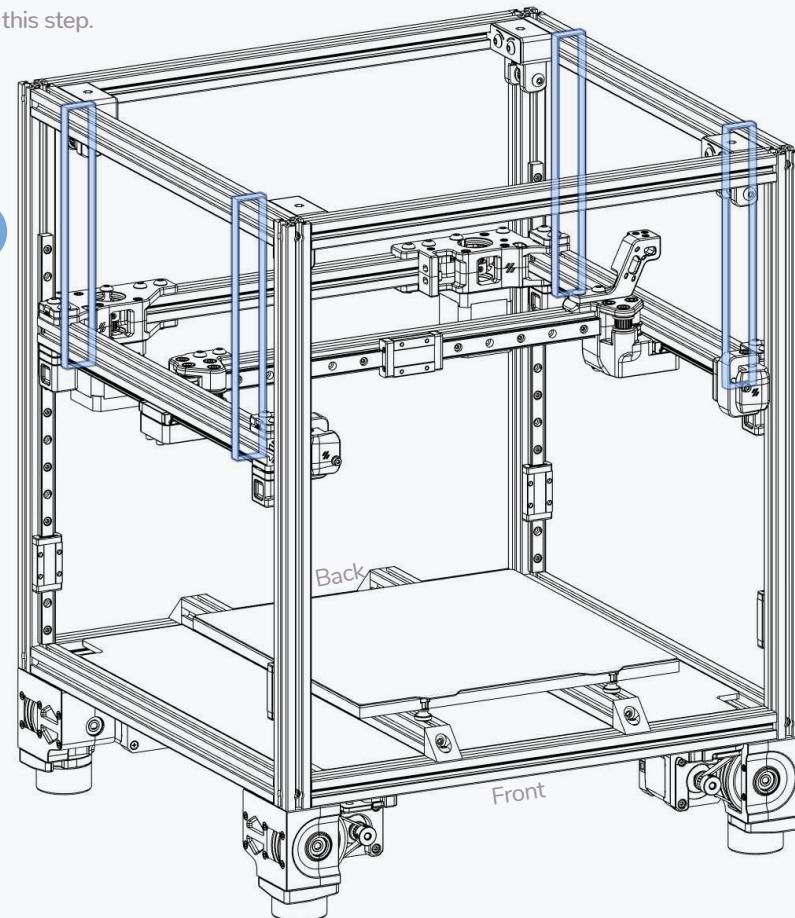
Tilt the gantry to move it past the uprights.

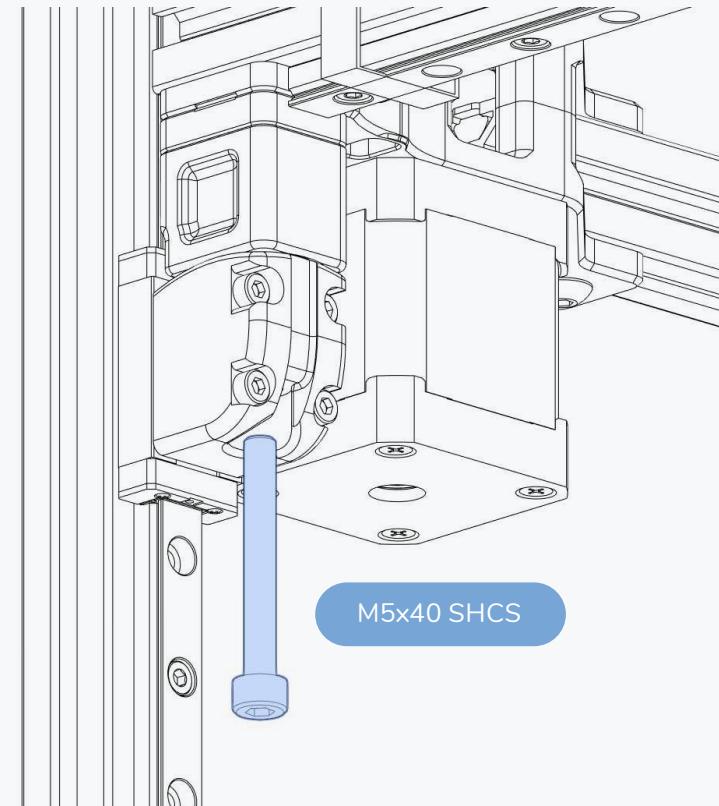
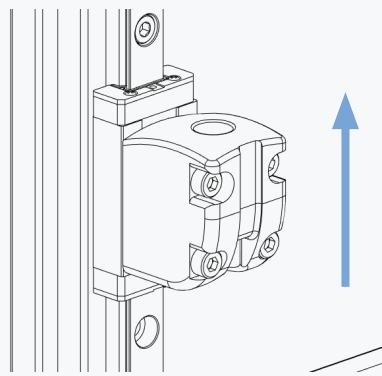
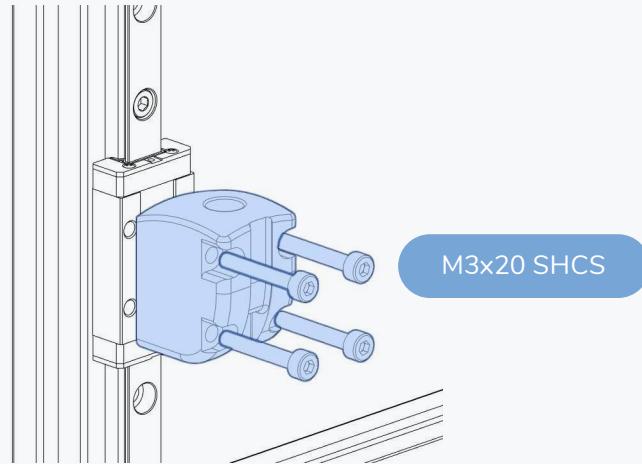


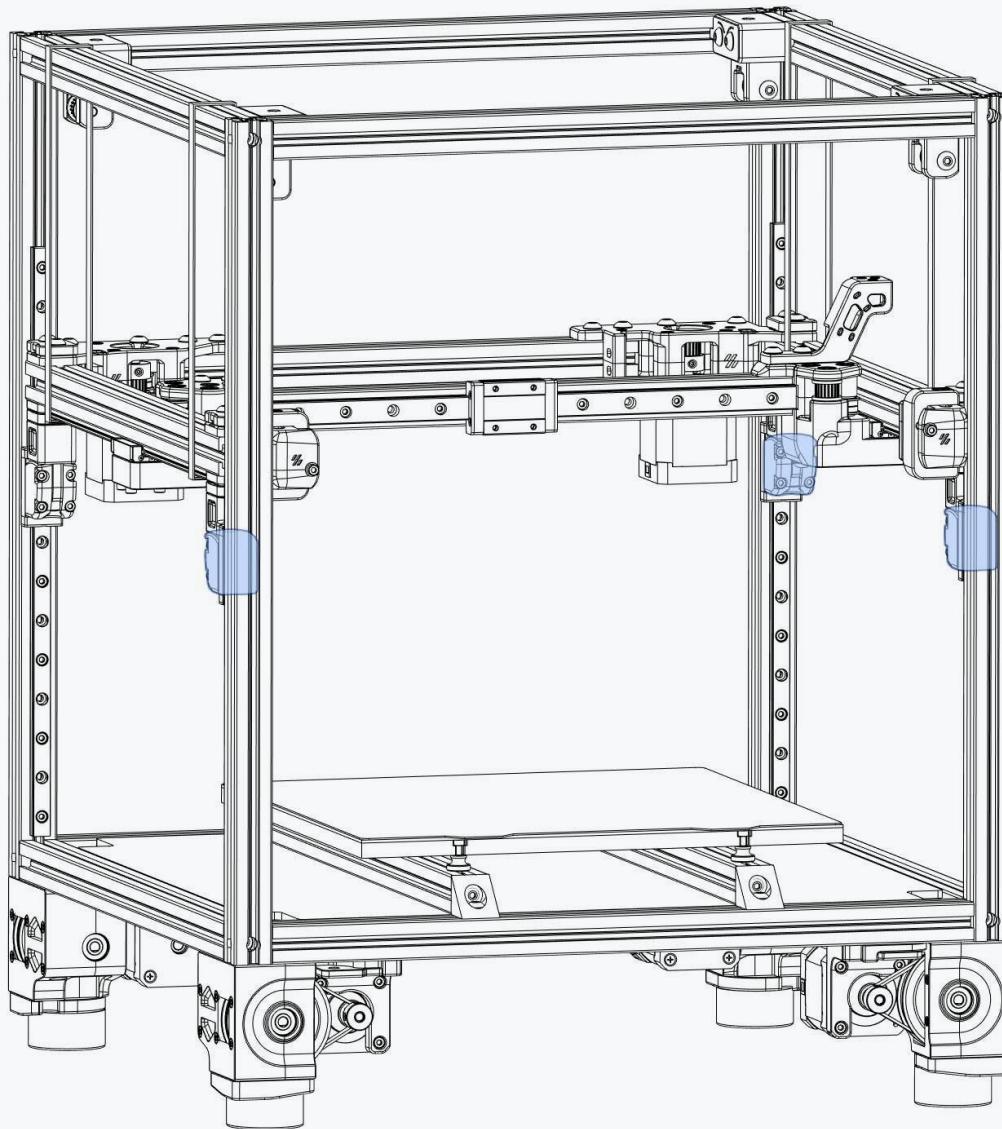
Long Zipties

A HELPING HAND

Secure the gantry with long zipties or similar while the gantry is being installed. An extra pair of hands helps with this step.

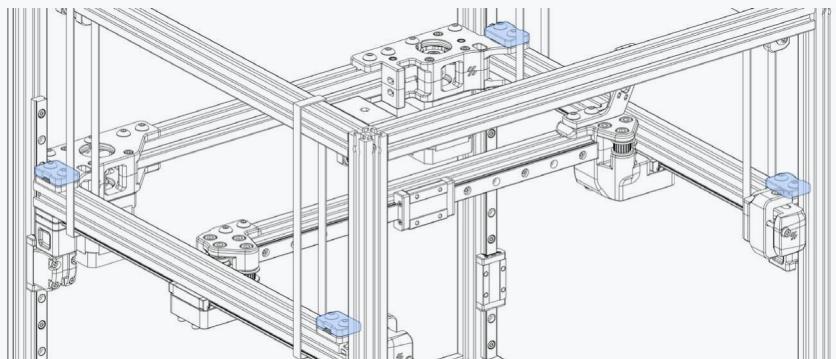




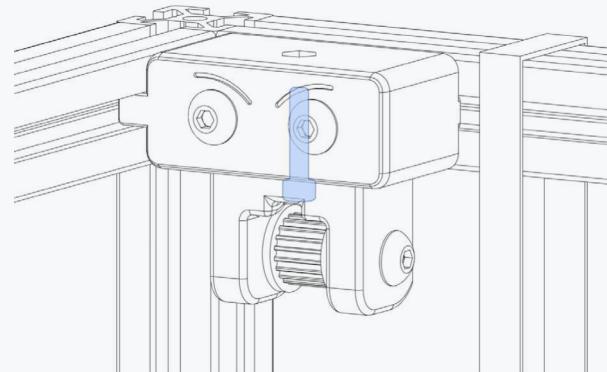


INSTALL REMAINING JOINTS

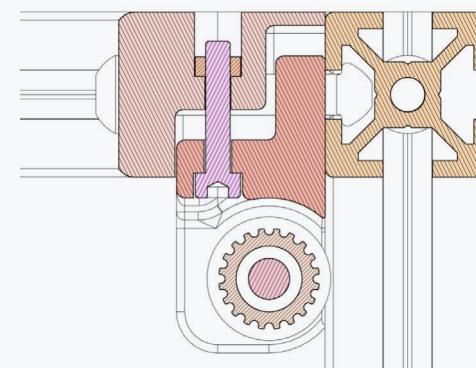
Add the other 3 joints repeating the same steps.

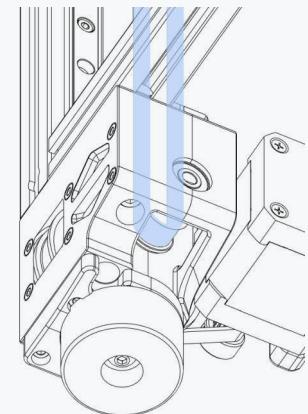
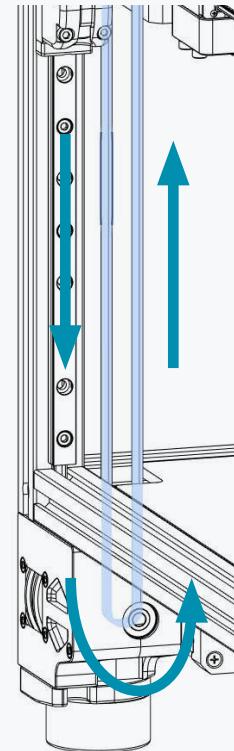
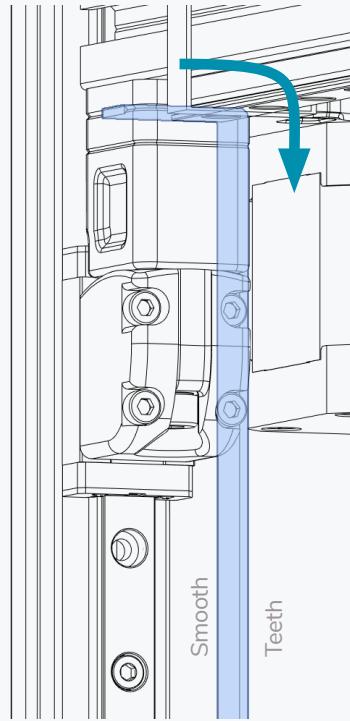
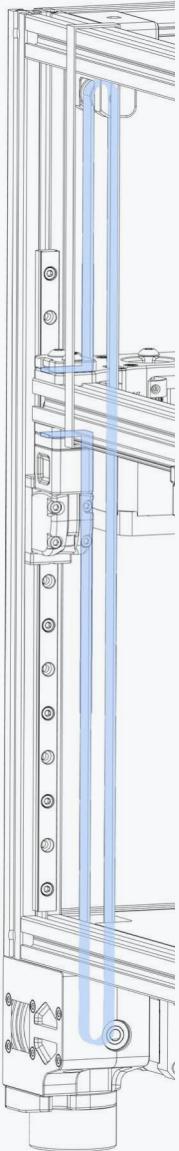
**LOOSEN TOP BELT CLAMPS**

Undo the top belt clamps, we'll be installing the belts in the next steps.

**EXTEND IDLER**

Loosen the idler bolt to extend the idler. Once extended to the maximum before becoming undone tighten 4 turns. Repeat for all 4 idlers.

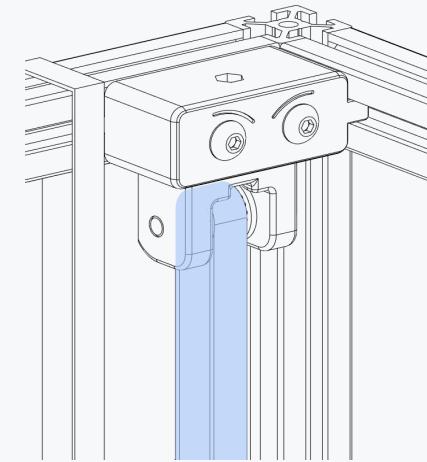
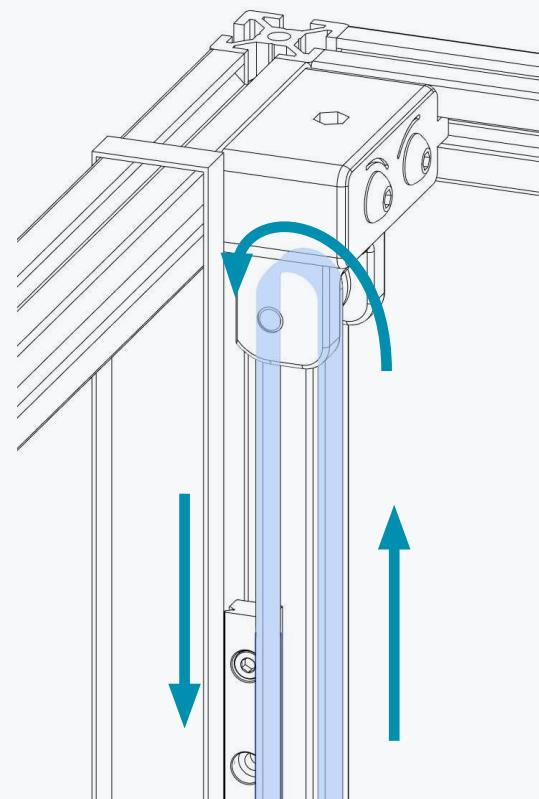
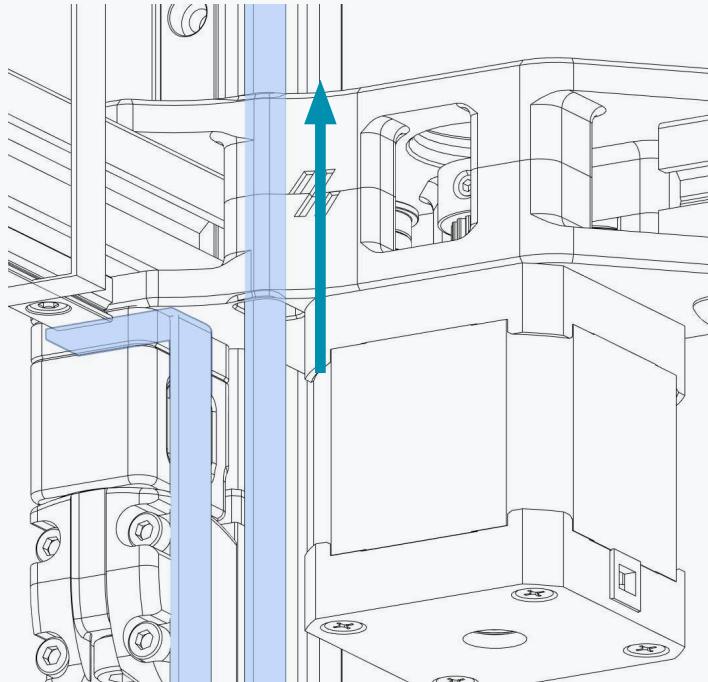


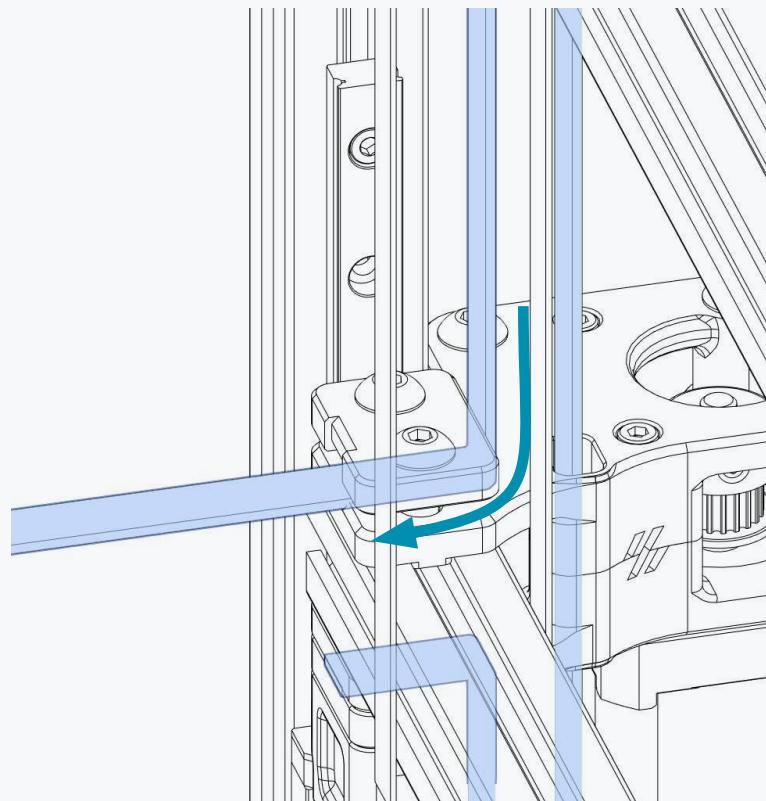


Z BELT ROUTING

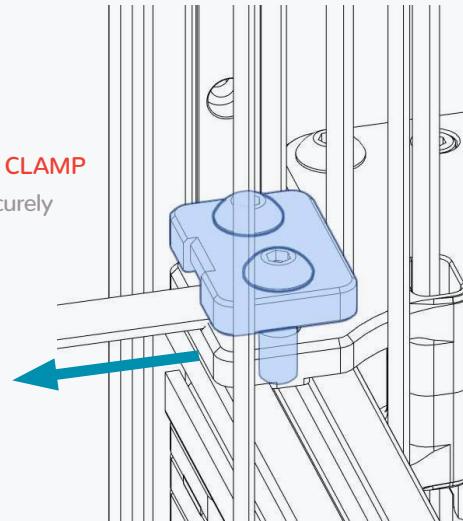
Follow the path pointed out by the arrows.
Needle nose pliers, tweezers or similar tools
can help in this step.

The belt teeth are on the inside of the loop.

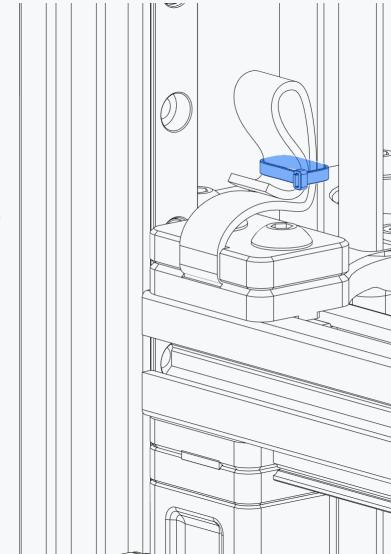


**PULL TIGHT AND SECURE BELT CLAMP**

Pull on the end of the belt and securely fasten the top belt clamp.

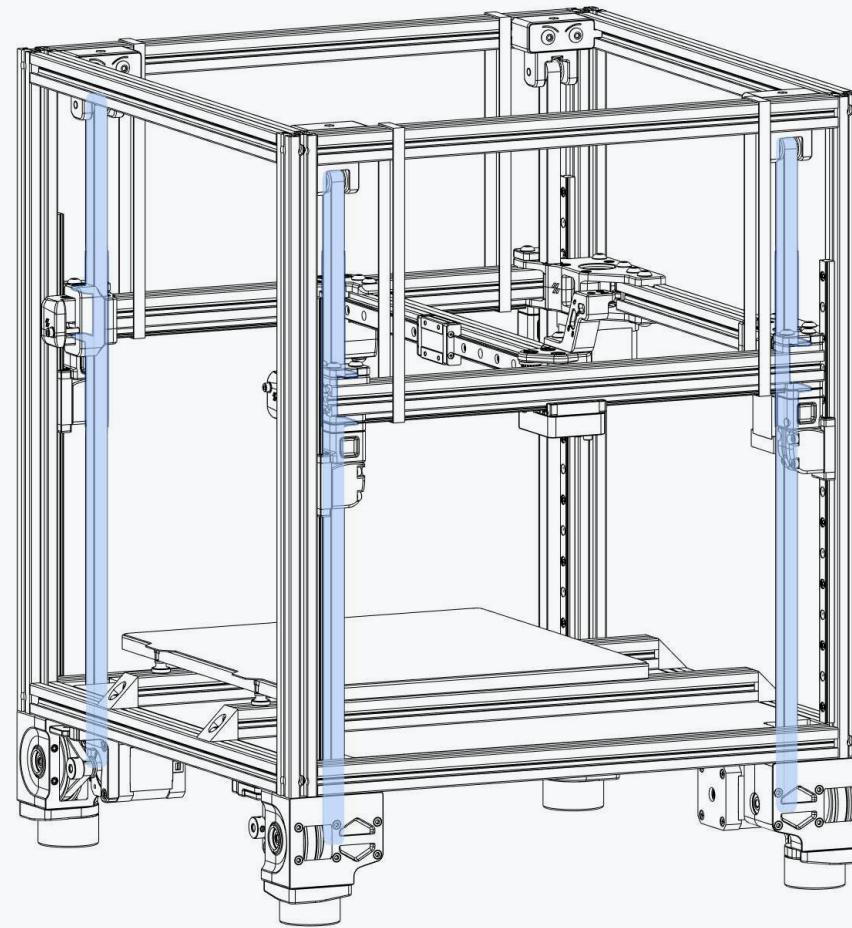
**EXCESS BELT**

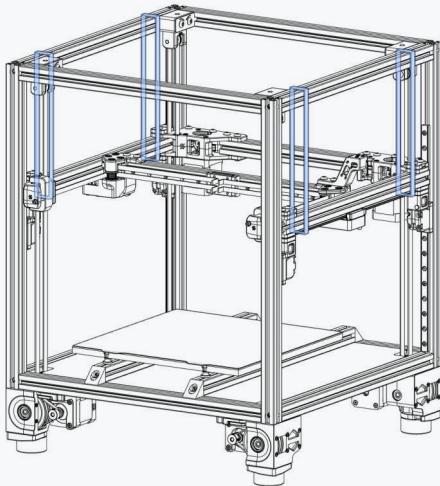
Fold the excess belt over and use a small ziptie to secure the end.



INSTALL REMAINING Z BELTS

Repeat the install instructions for the other 3 Z belts.



**REMOVE ZIPTIES**

With the belts installed the gantry will stay in position.

SQUARING THE GANTRY

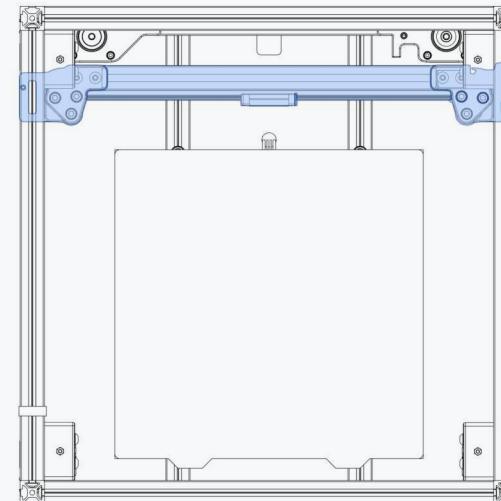
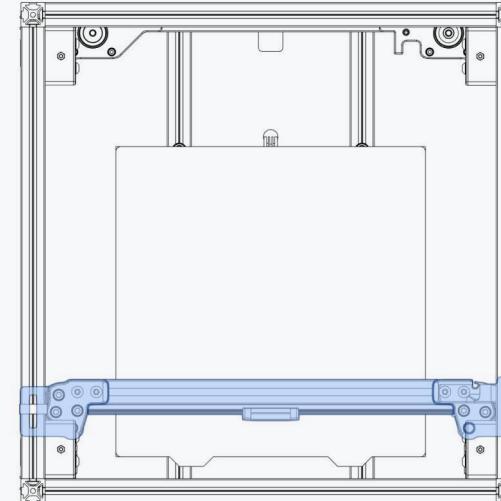
Move the gantry all the way back until it hits the A and B drive on both sides.

Fully tighten all screws on the X axis.

You may need to adjust the distance between the A and B drive to square the gantry. To do this loosen the bolts that secures the B drive to the rear gantry extrusion. Repeat the steps above and secure the fasteners again.



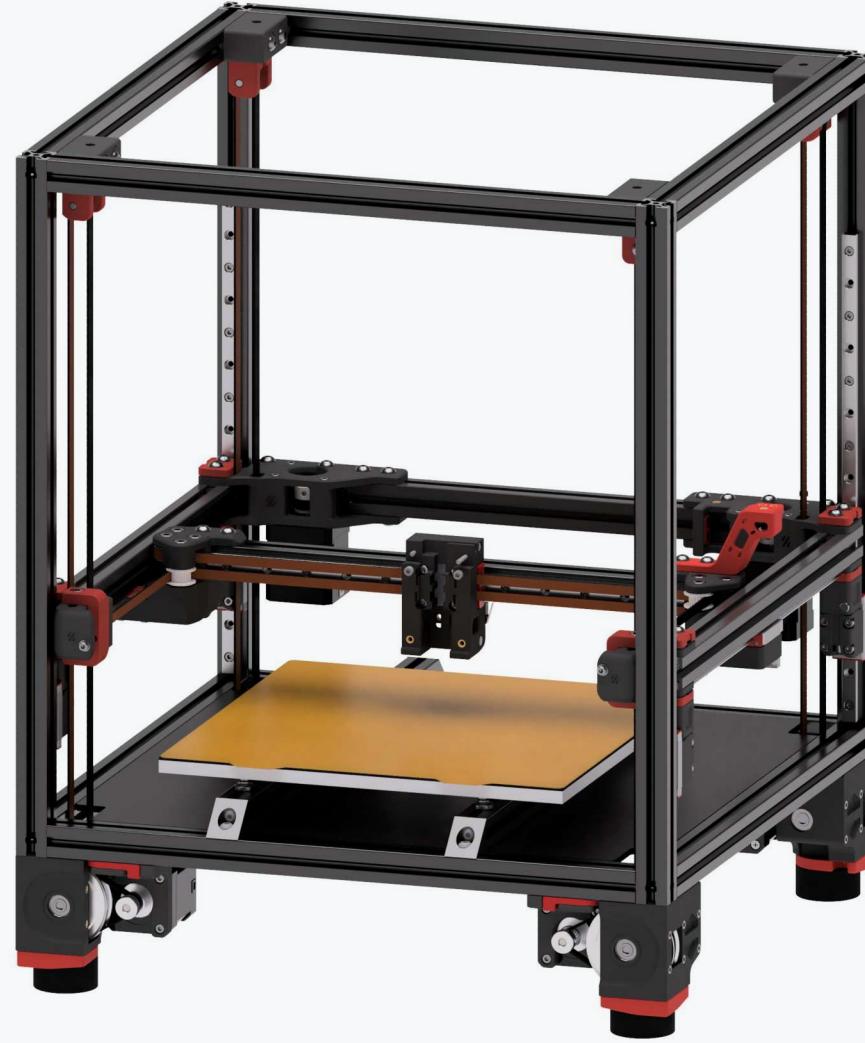
<https://voron.link/cekh81>



Voron2.0 was never officially released.

A/B BELTS

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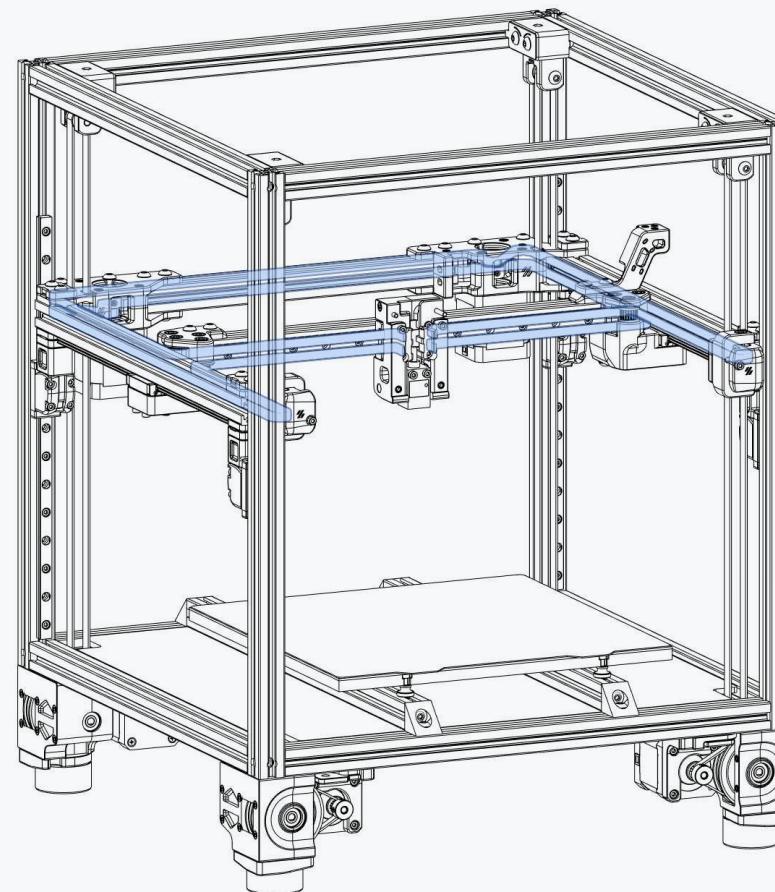
THE VORON BELT PATH

Voron printers use a belt path based on the popular CoreXY pattern.

The individual belt paths are stacked on top of each other and the crossing often found in CoreXY designs is omitted. Compared to many other implementations, the motors are moved to a less intrusive position. To learn more about the principles behind CoreXY visit <https://voron.link/ef72dd6>

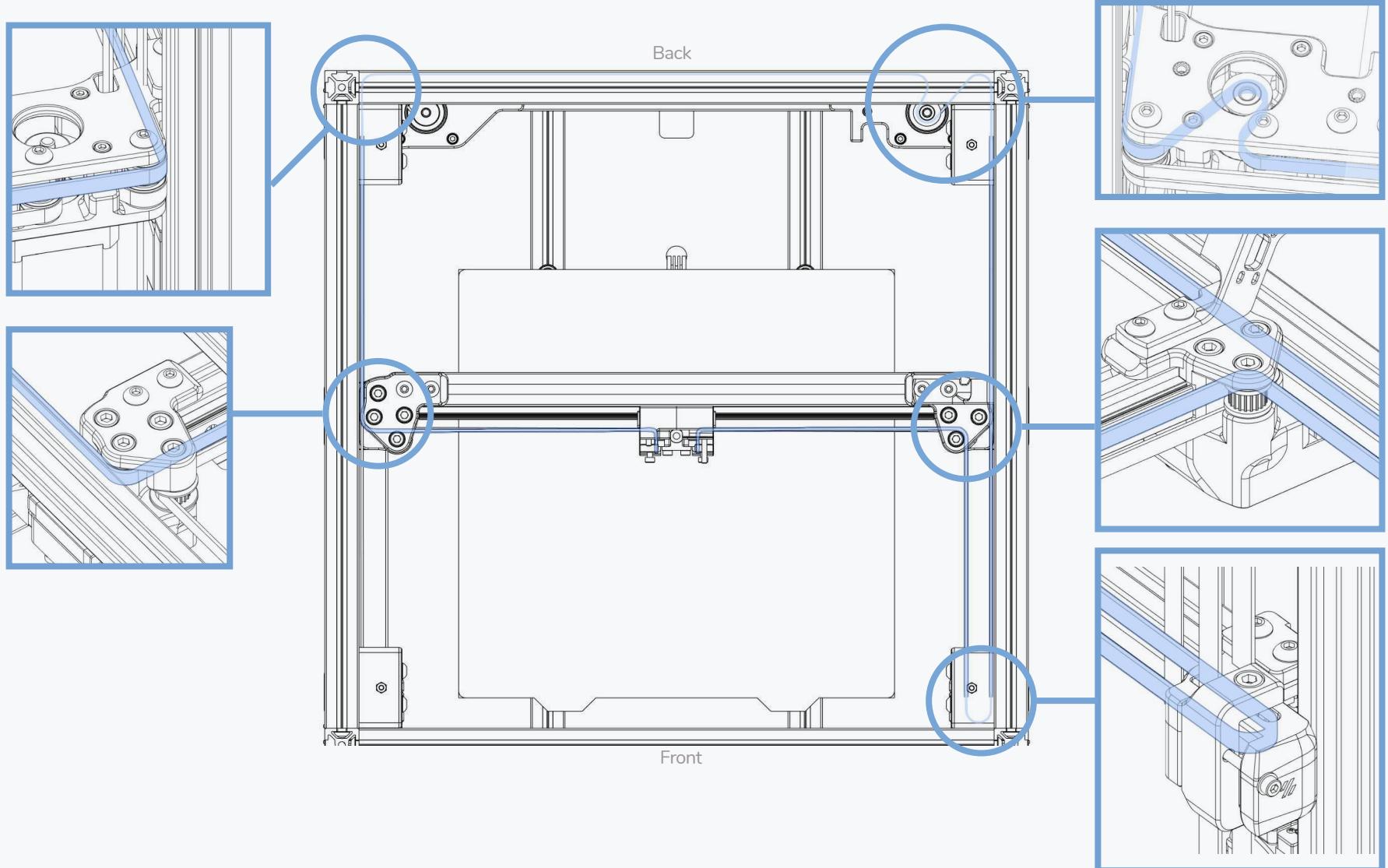
Equal belt tension is important to the proper function of a CoreXY motion system.

We recommend to run one belt to get the required length, remove the belt from the printer and cut the second belt to the exact same length.
As both belt paths have the same length this is an easy way of getting a consistent tension.



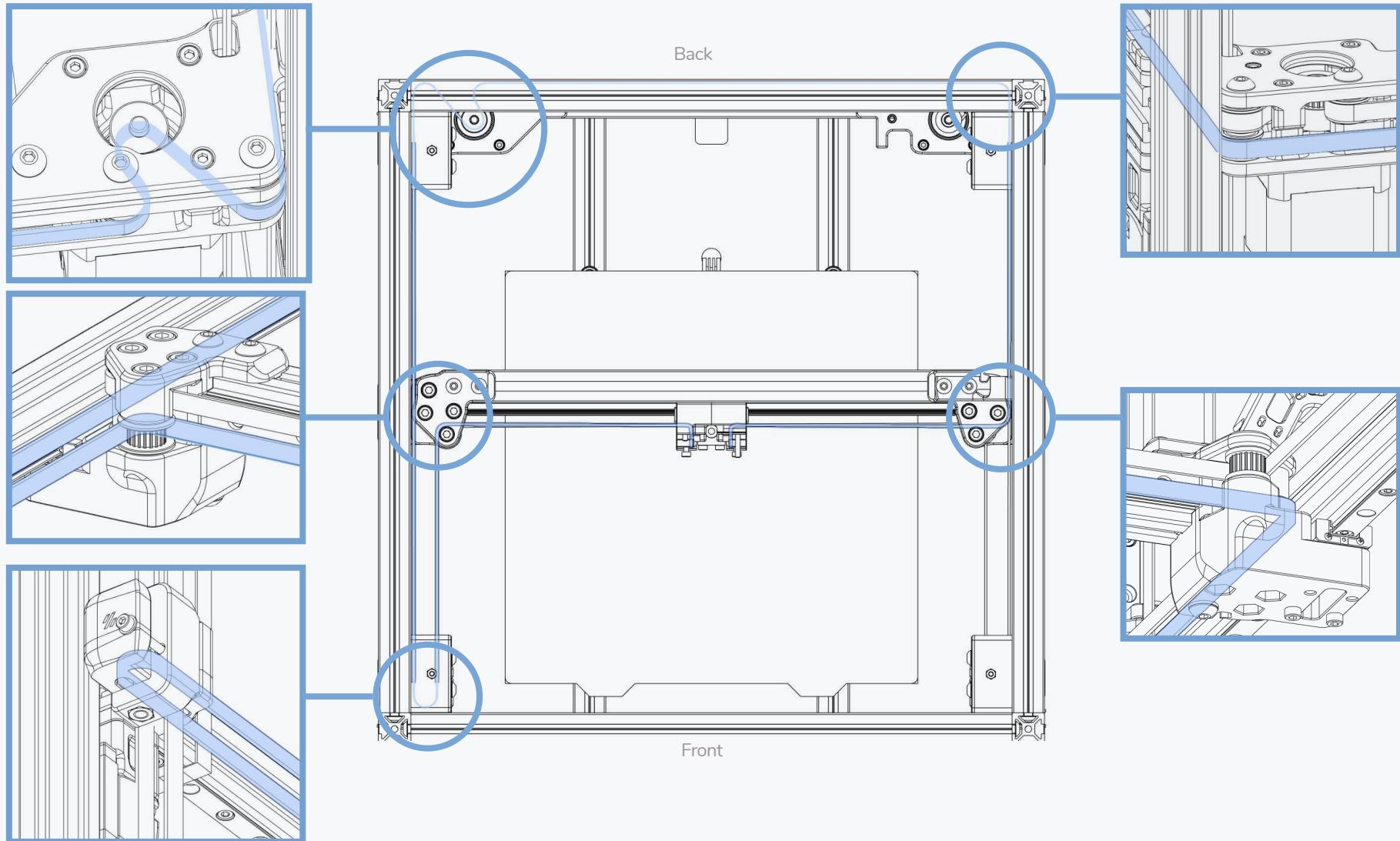
OVERVIEW - A BELT

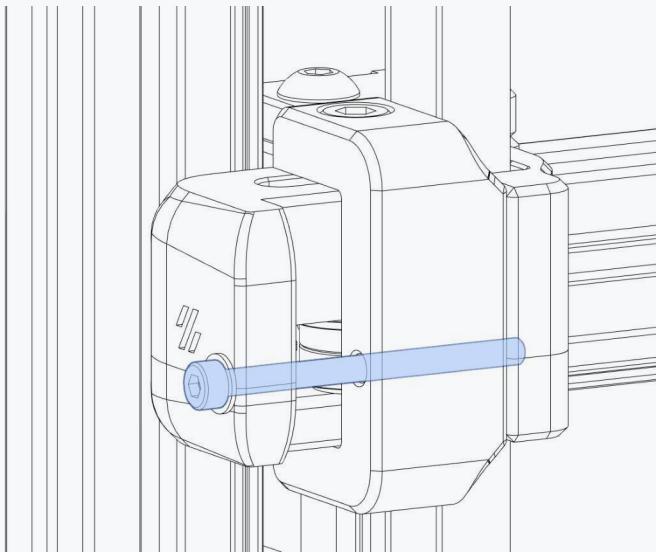
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OVERVIEW - B BELT

WWW.VORONDESIGN.COM



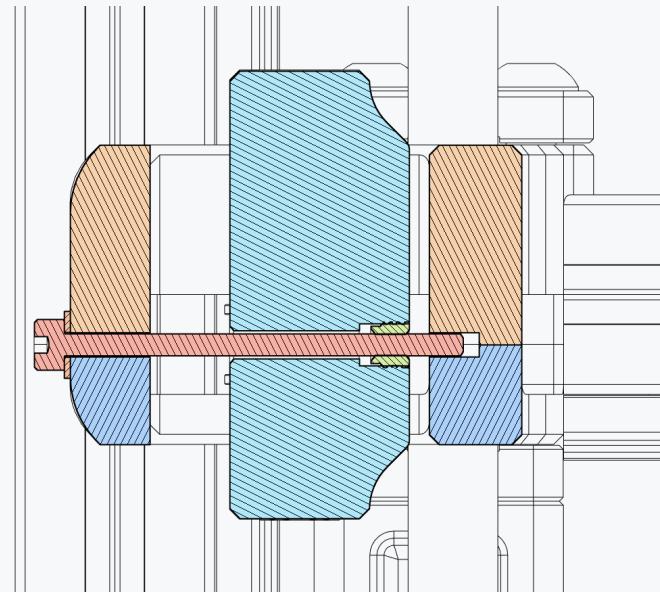


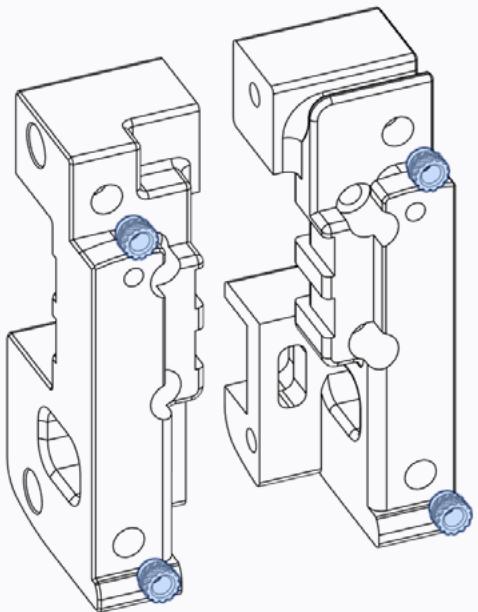
EXTEND IDLER

Loosen the idler bolt to extend the idler.

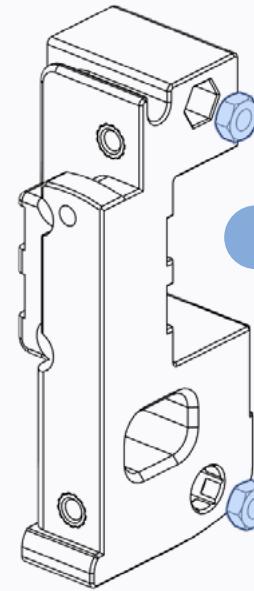
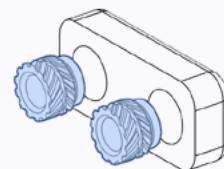
Once extended to the maximum tighten 4 turns.

Repeat for the second idler.





Heat Set Insert



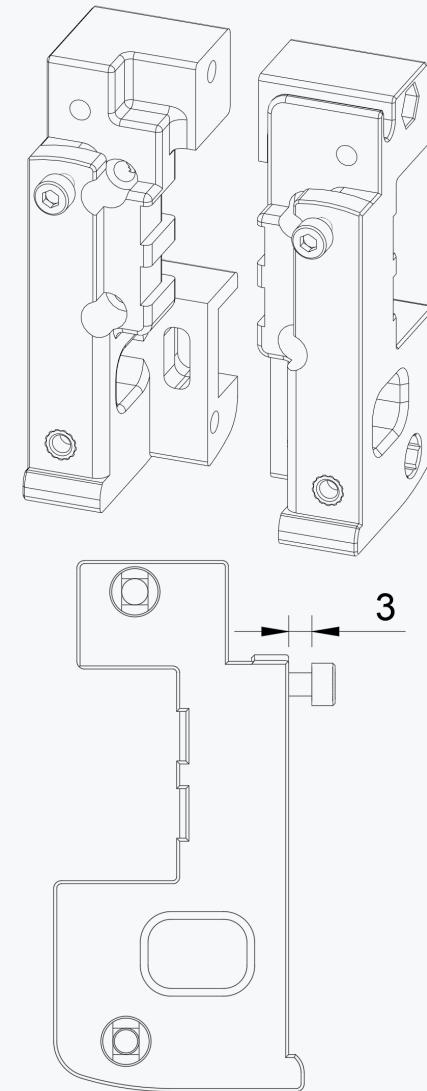
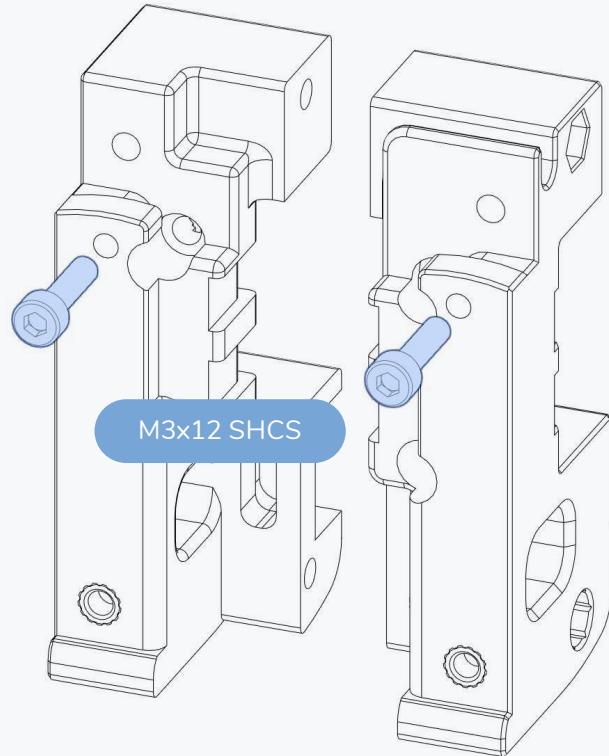
M3 Hex Nut

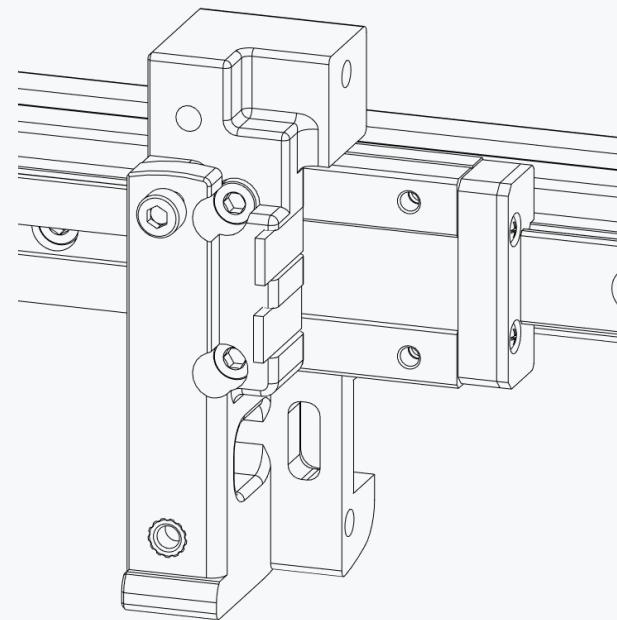
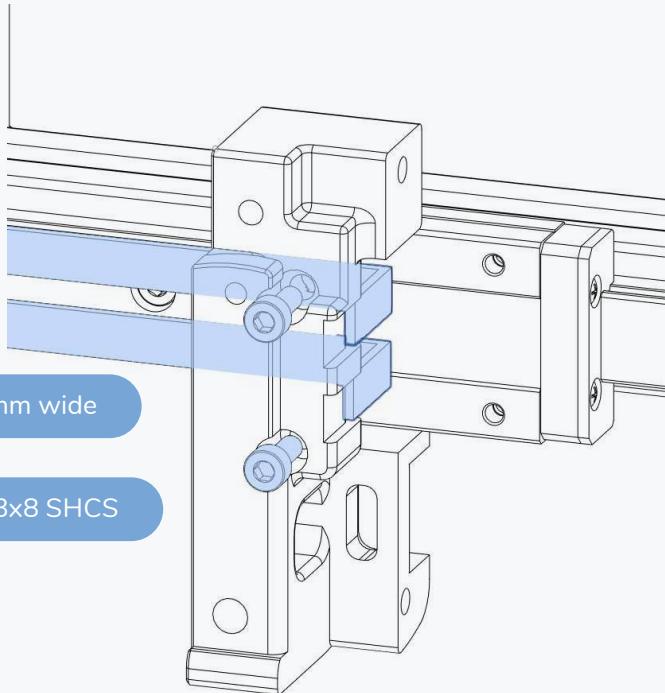
PRINTER SPECIFIC PARTS

We provide different versions of the carriage to fit our different printer designs. Be sure to pick the right one for your printer. the next few pages may look slightly different if you are building a Switchwire printer.

X CARRIAGE

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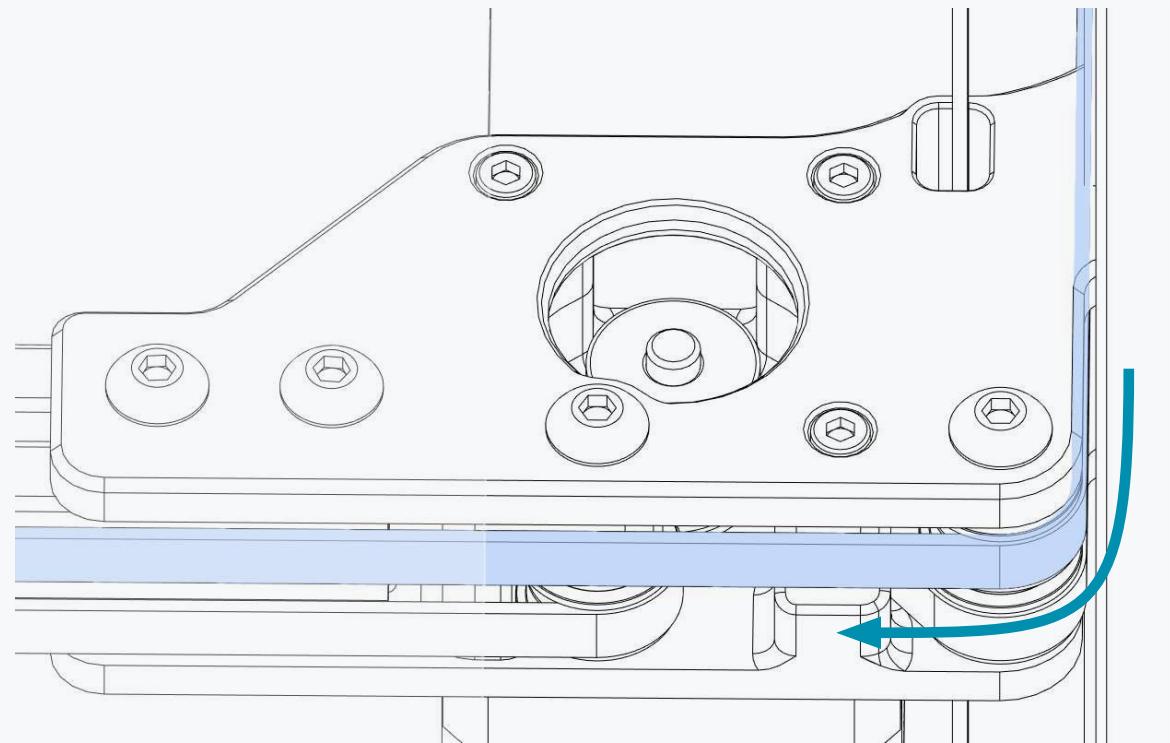
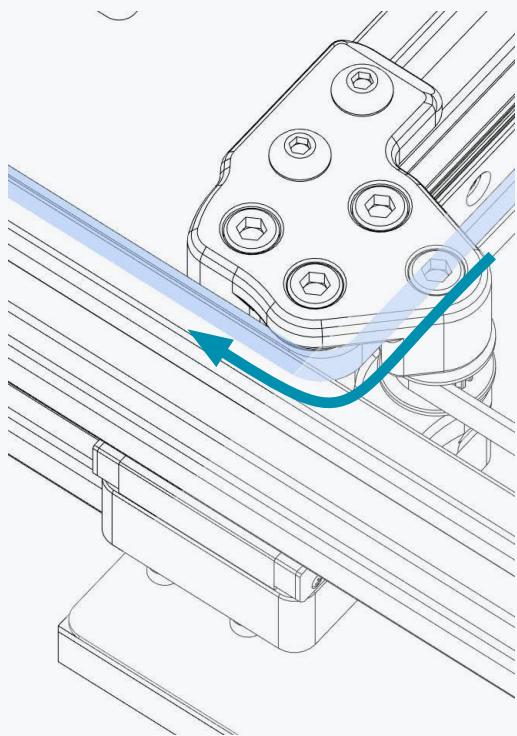




CLAMP BELTS

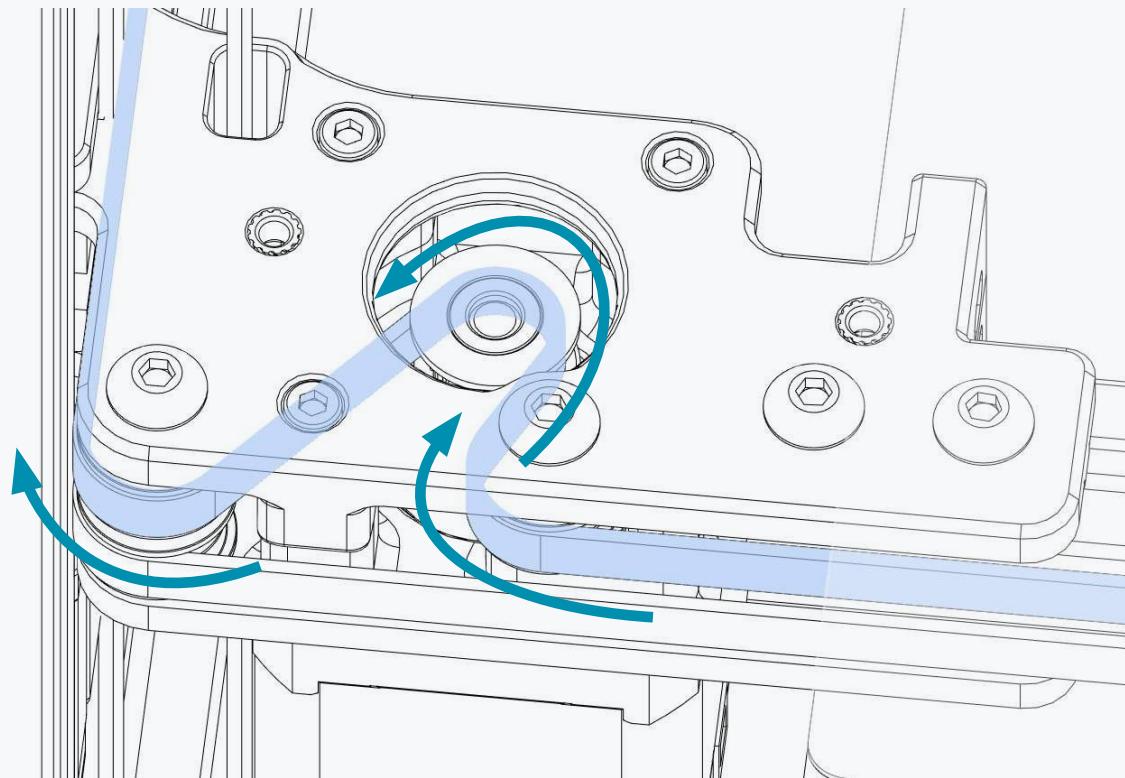
Clamp both A and B belts in place by installing the left X carriage part.

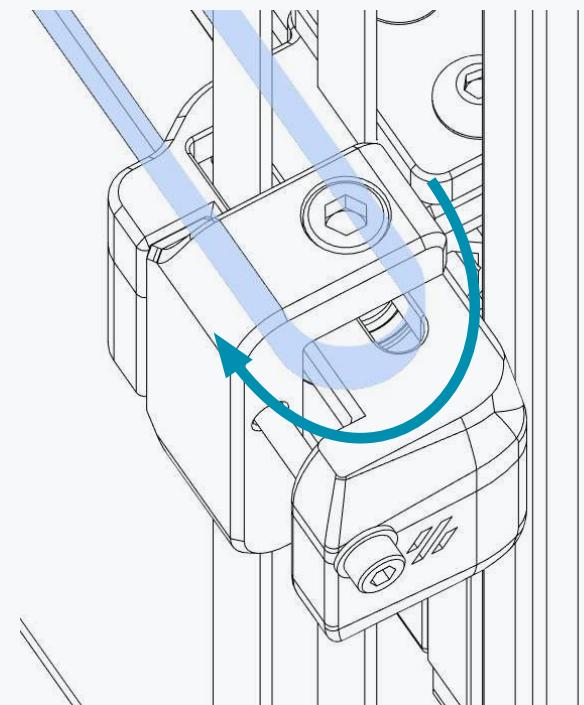
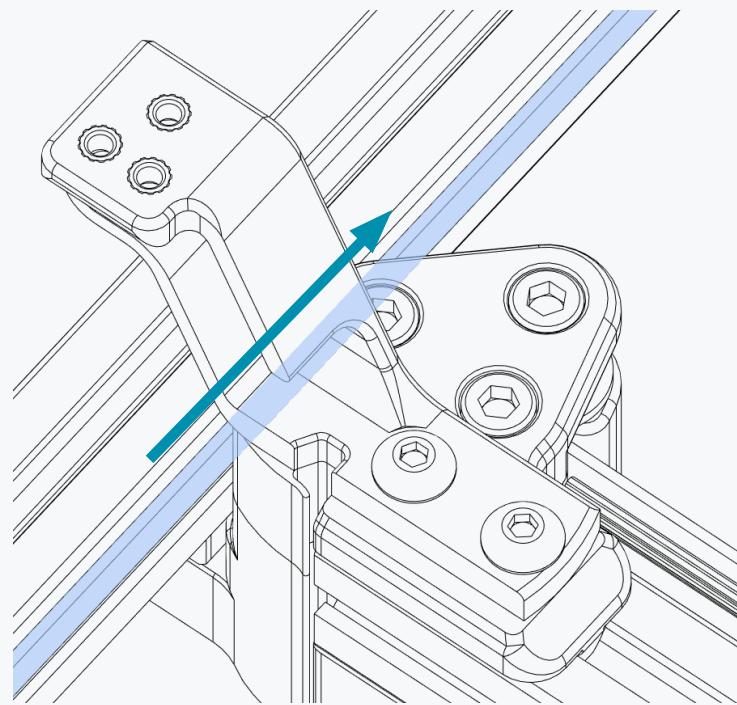
The belt teeth face away from the extrusion.



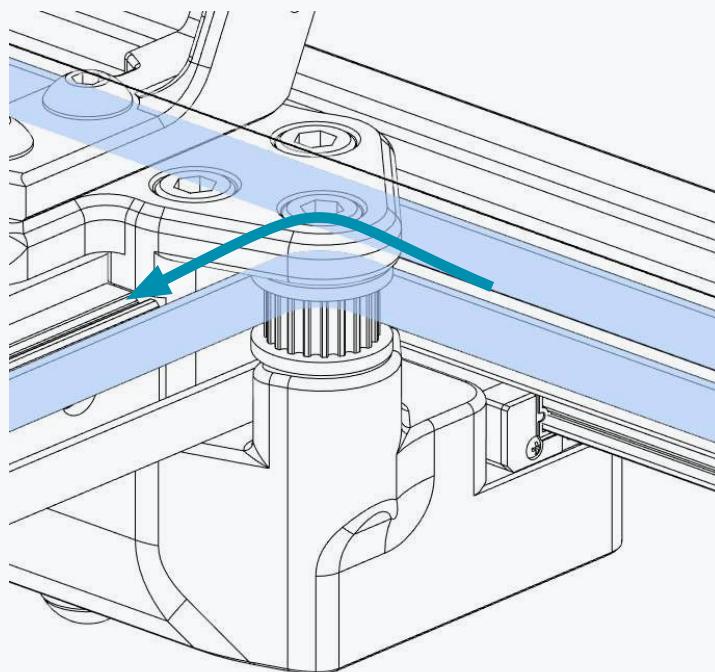
A BELT ROUTING

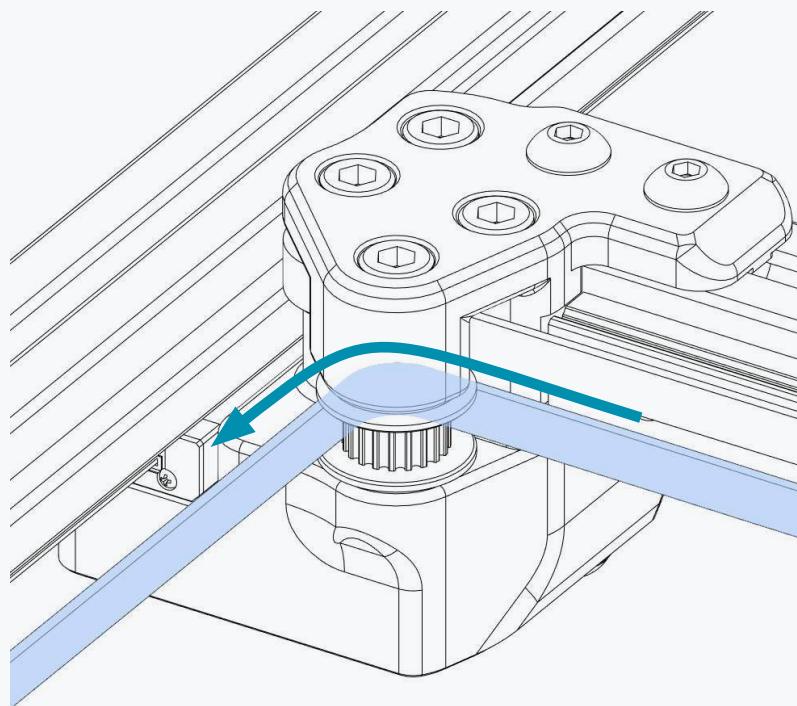
Follow the path pointed out by the arrows.
Needle nose pliers, tweezers or similar tools
can help in this step.



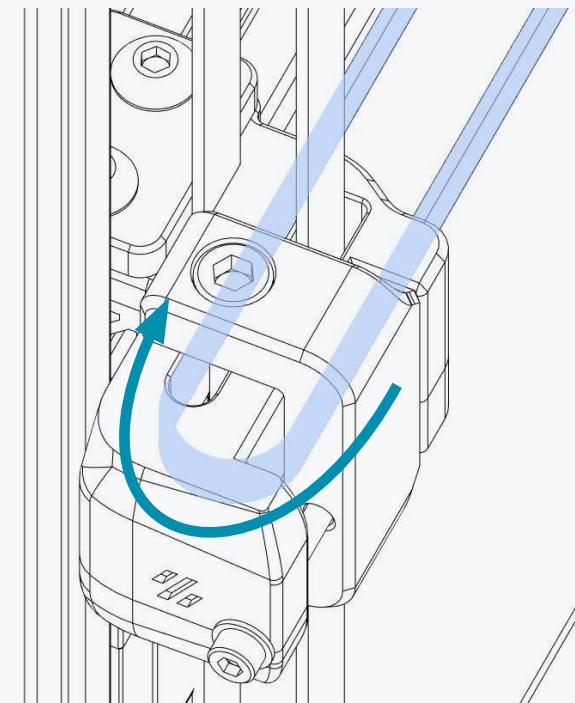
**BELTING IDLERS**

If you're having trouble guiding the belts around the bearing stack temporarily remove the M3x40 SHCS to get better access.



**B BELT ROUTING**

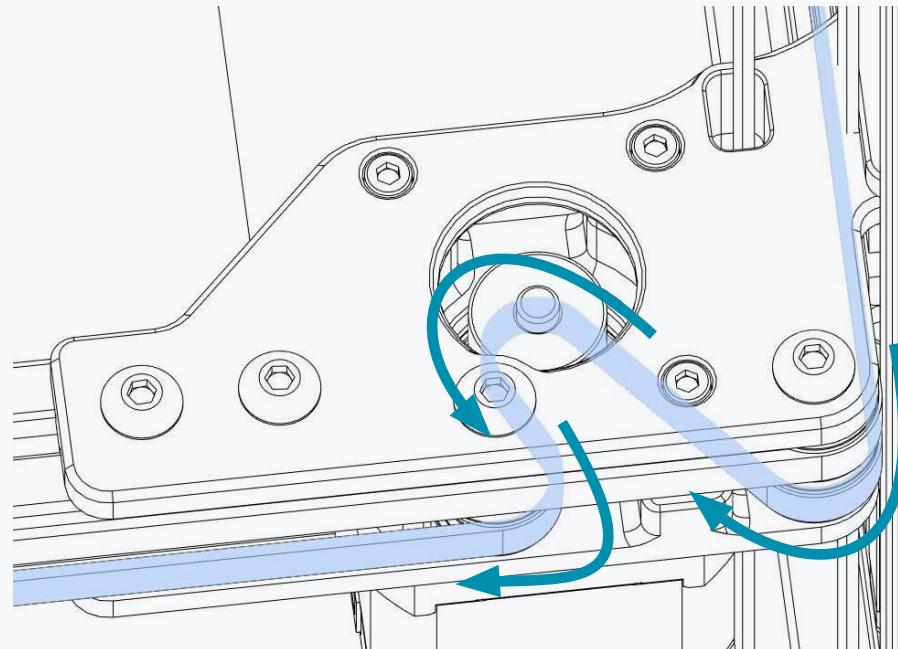
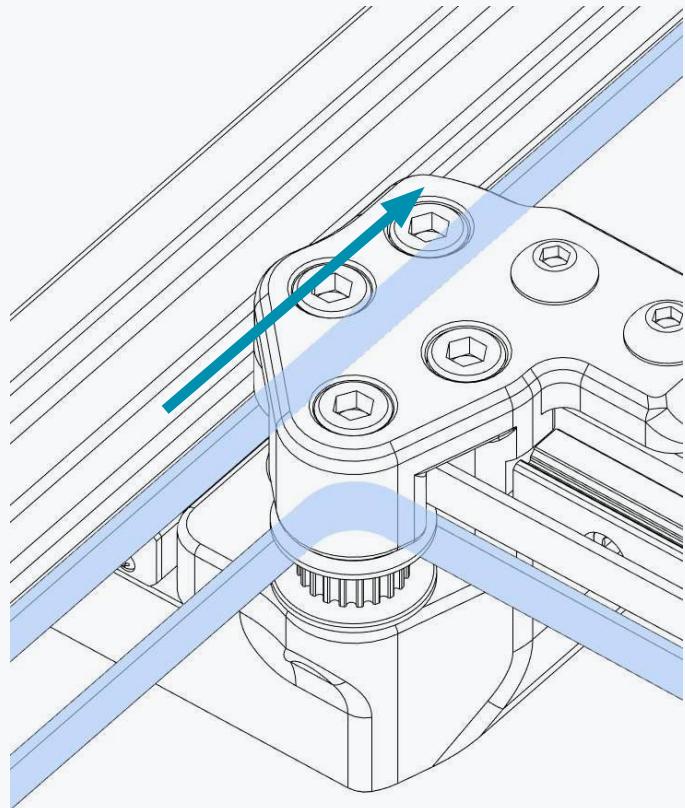
Follow the path pointed out by the arrows.
Needle nose pliers, tweezers or similar tools
can help in this step.

**BELTING IDLERS**

If you're having trouble guiding the belts around
the bearing stack temporarily remove the M3x40
SHCS to get better access.

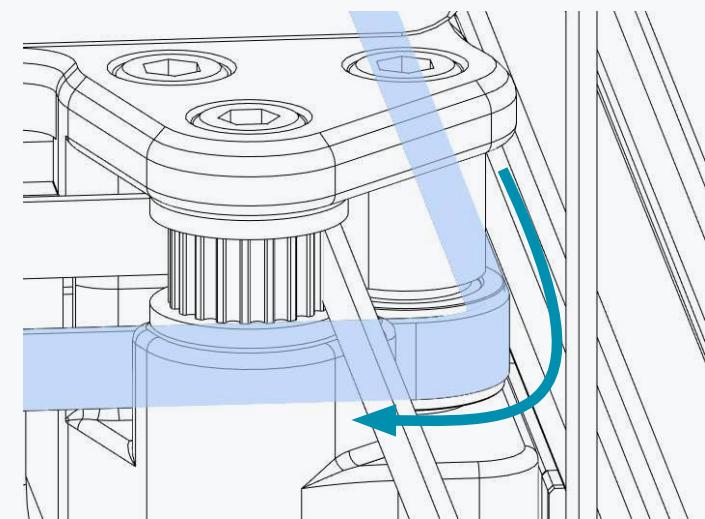
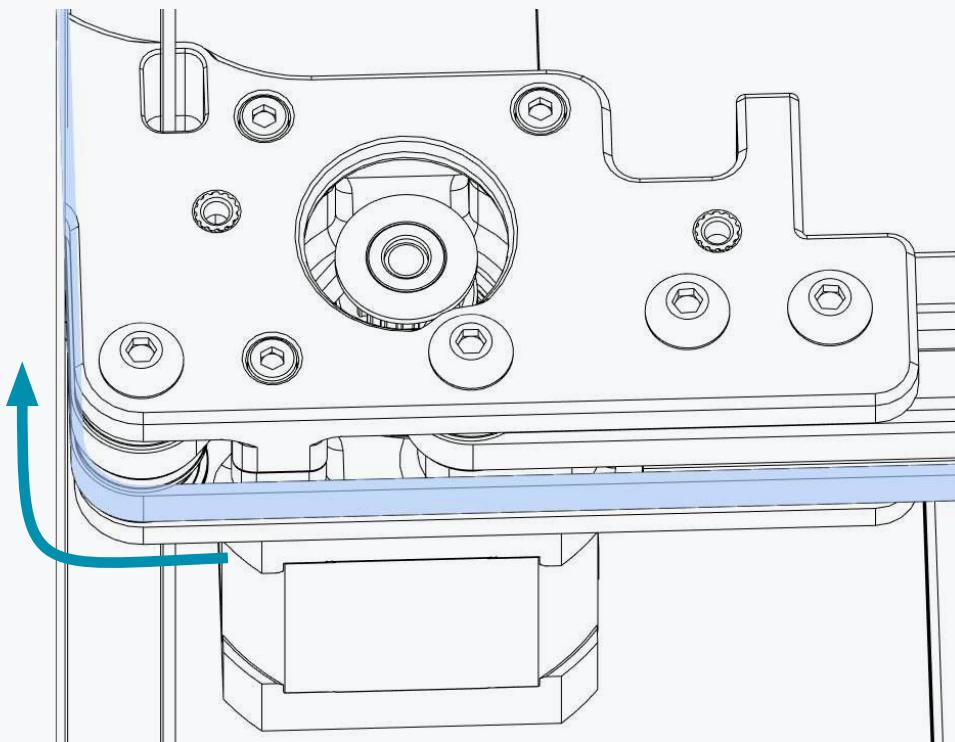
B BELT

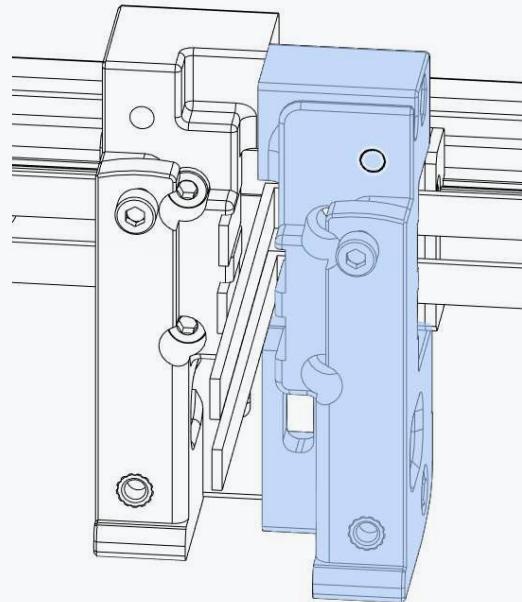
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B BELT

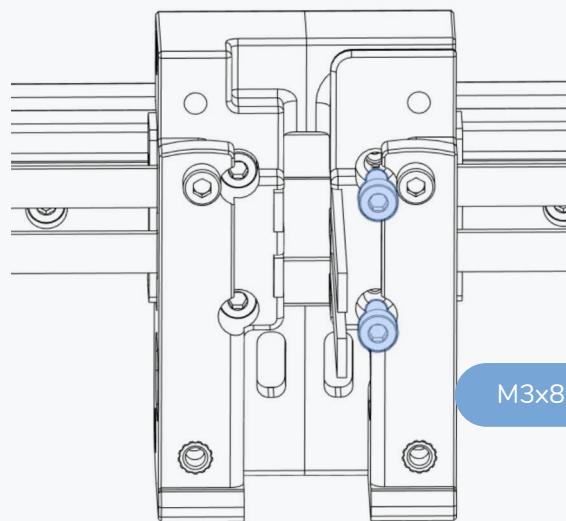
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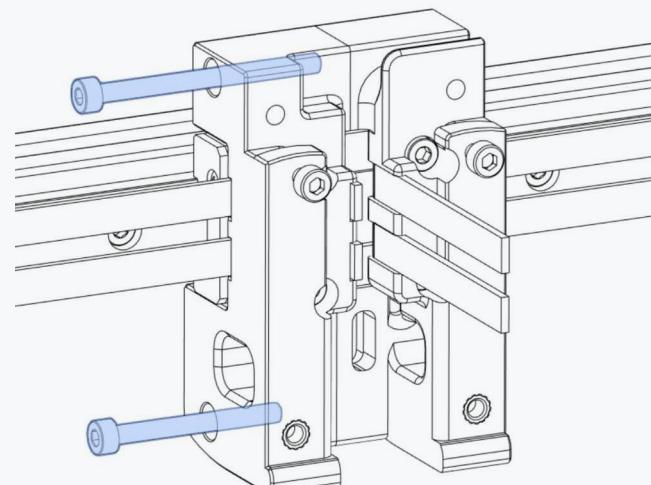
X CARRIAGE

Use the second part of the X carriage to capture the belt ends.



M3x8 SHCS

M3x40 SHCS



M3x30 SHCS

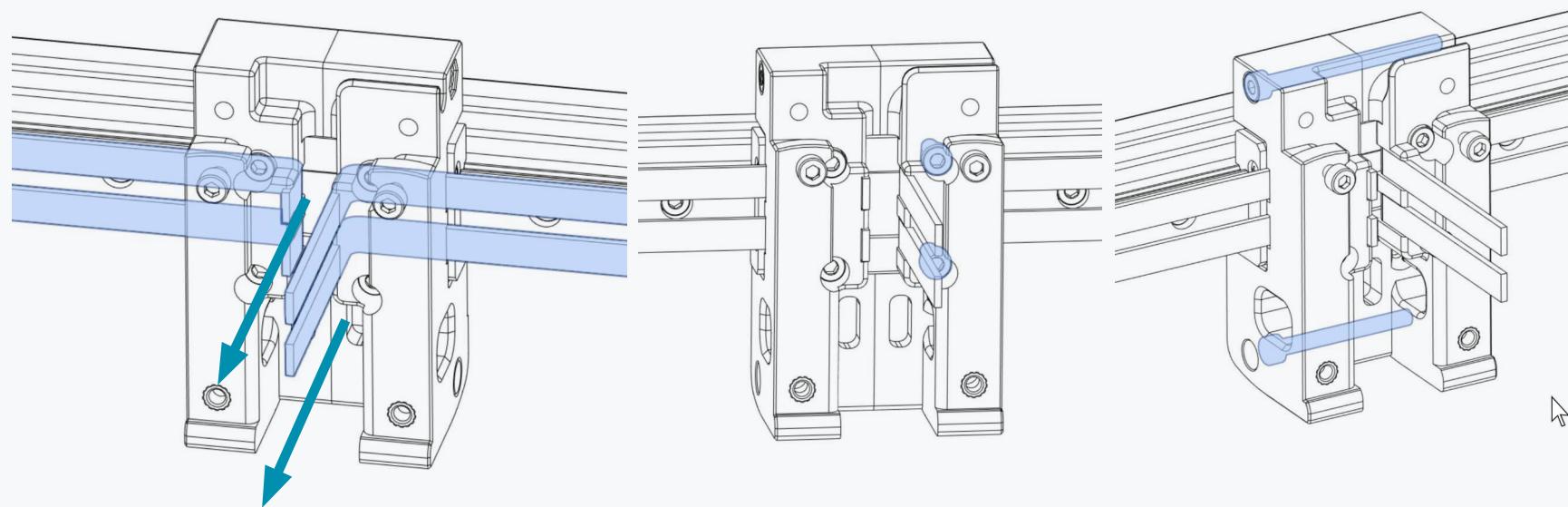
LEAVE LOOSE

Lightly tighten the bolts.

FIX BELTS

Lightly tighten the screws.

The belt must still be able to move.

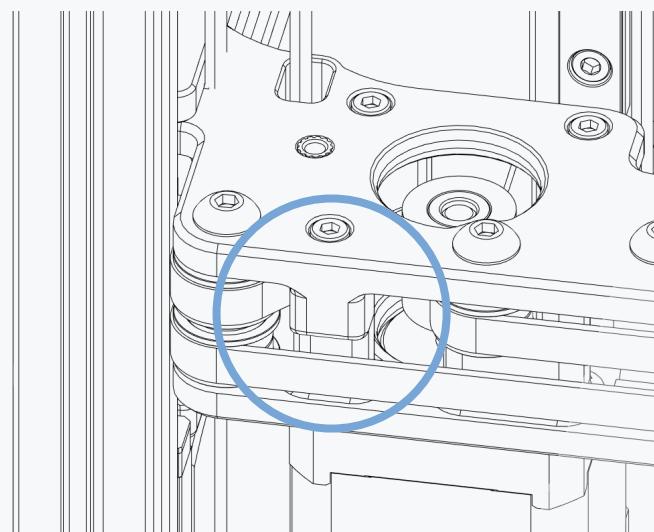
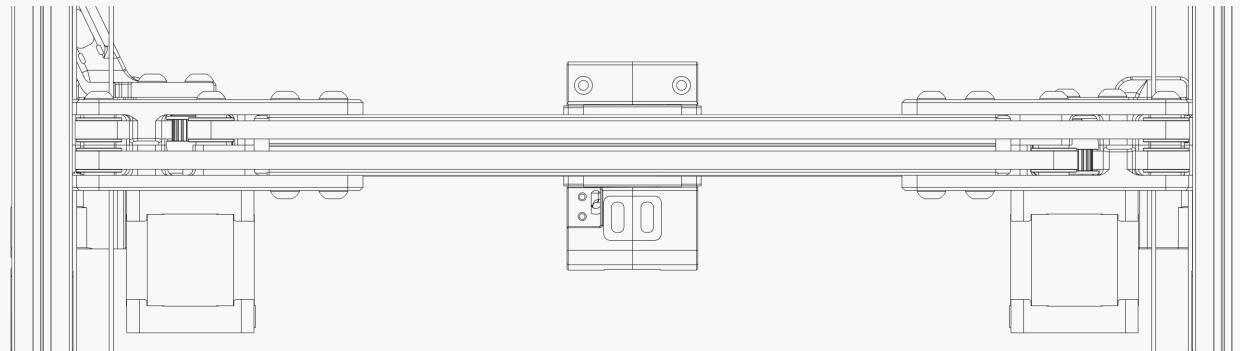
**PULL TIGHT**

Grab both belt ends with a pair of pliers and pull the belt tight.

As both belts are cut to the exact same total length and the belt paths are equal length in this design make sure the same length of belt protrudes from the carriage.

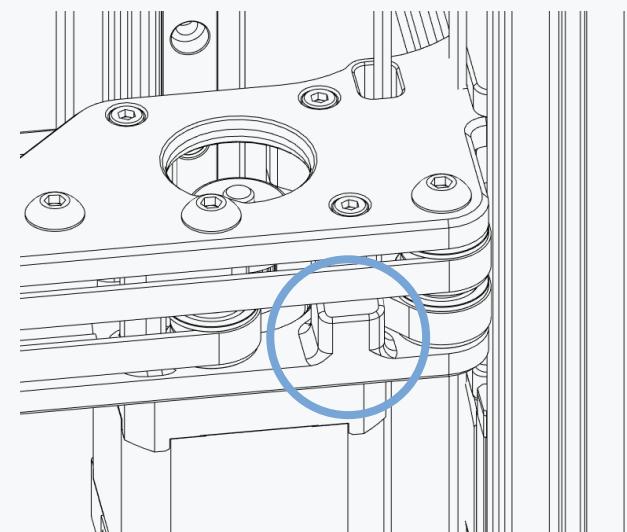
TIGHTEN BOLTS

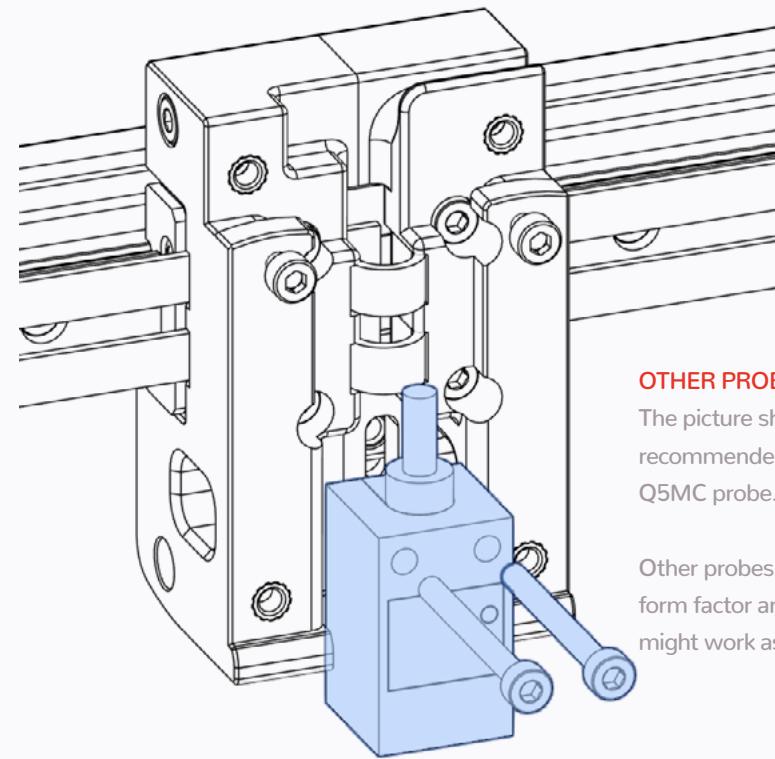
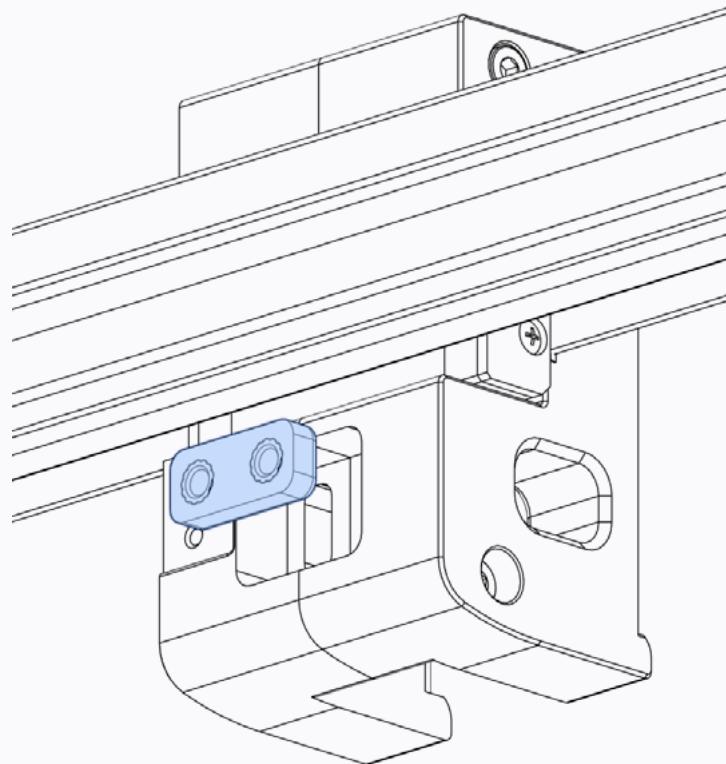
Fully tighten the carriage bolts.



CHECK YOUR WORK

Make sure that the belt is not riding on the plastic parts.

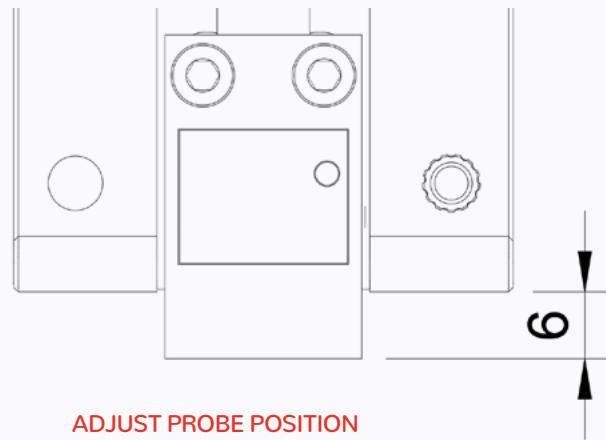


**OTHER PROBE TYPES**

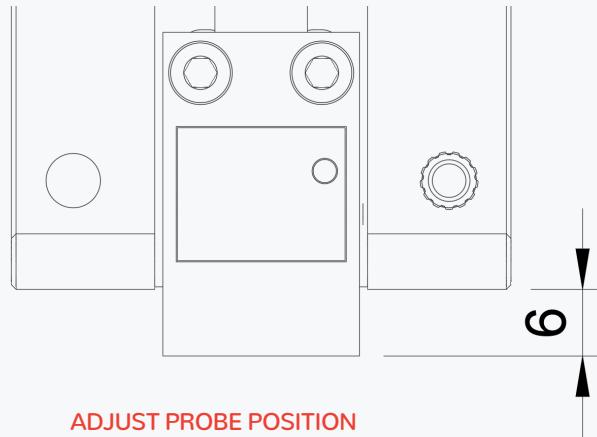
The picture shows the recommended Omron TL-Q5MC probe.

Other probes with a similar form factor and characteristics might work as well.

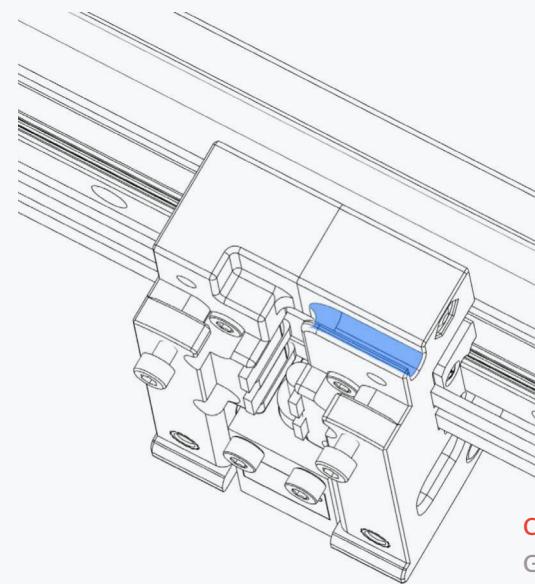
Omron Style Probe**M3x30 SHCS**

**ADJUST PROBE POSITION**

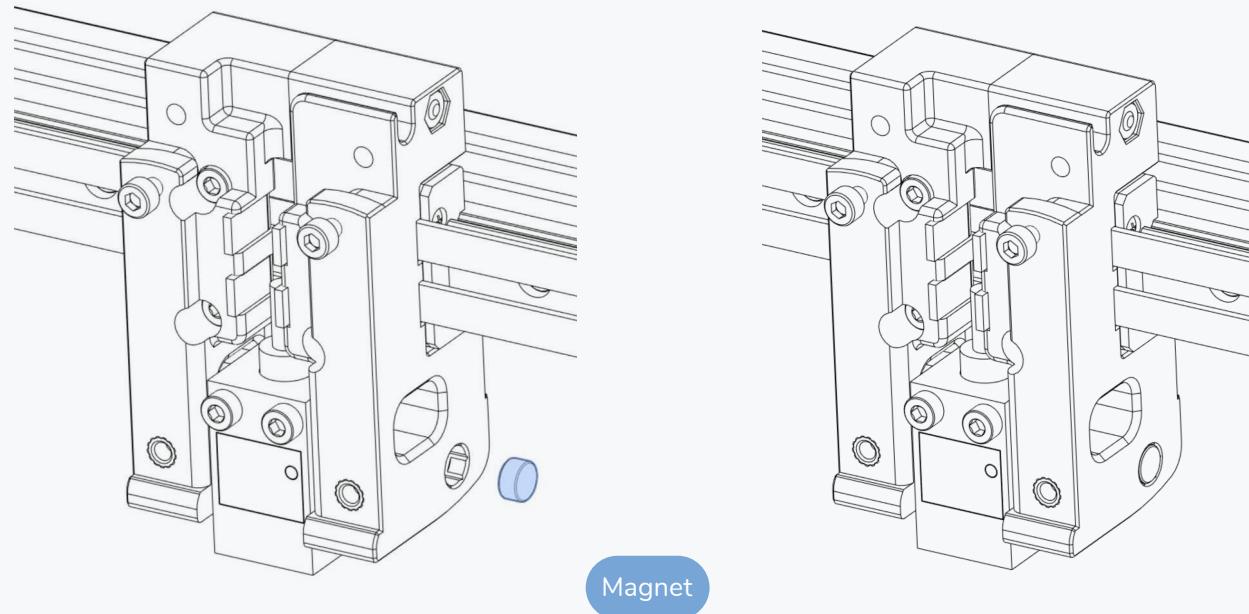
The position can be fine-tuned later. Set an initial position of about 6mm below the plastic part.

**ADJUST PROBE POSITION**

The position can be fine-tuned later. Set an initial position of about 6mm below the plastic part.

**CHANNEL FOR PROBE CABLE**

Guide the probe cable into the highlighted slot.

**OPTION: HALL EFFECT ENDSTOP**

If you are using a Hall Effect Endstop
insert a 3x6 magnet into the highlighted
position.



VORON STEALTHBURNER

We build space shuttles with gardening tools
so anyone can have a space shuttle of their own.

VERSION 2023-05-05



Before you begin on your journey, 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 do not become the first VORON fatality. There is no special Reddit flair for that.

Please, read the entire manual before you start assembly. As you begin wrenching, please check our Discord channels for any tips and questions that may halt your progress.

Most of all, good luck!

THE VORON TEAM

PART PRINTING GUIDELINES

The Voron Team has provided the following print guidelines for you to follow in order to have the best chance at success with your parts. There are often questions about substituting materials or changing printing standards, but we recommend you follow these:

3D PRINTING PROCESS

Fused Deposition Modeling (FDM)

MATERIAL

ABS

LAYER HEIGHT

Recommended: 0.2mm

EXTRUSION WIDTH

Recommended: Forced 0.4mm

INFILL TYPE

Grid, Gyroid, Honeycomb, Triangle or Cubic

INFILL PERCENTAGE

Recommended: 40%

WALL COUNT

Recommended: 4

SOLID TOP/BOTTOM LAYERS

Recommended: 5

PRINT IT FORWARD (PIF)

Often times community members that have issues printing ABS will bootstrap themselves into a VORON using our Print It Forward program. This is a service where approved members with VORON printers can make you a functional set of parts to get your own machine up and running.

Check Discord if you have any interest in having someone help you out.

FILE NAMING

By this time you should have already downloaded our STL files from the Voron GitHub. You might have noticed that we have used a unique naming convention for the files. This is how to use them.

PRIMARY COLOUR	ACCENT COLOUR 	CLEAR/TRANSPARENT	OPAQUE	QUANTITY REQUIRED
Example z_joint_lower_x4.stl These files will have nothing at the start of the filename.	Example [a]_tensioner_left.stl We have added “[a]” to the front of any STL file that is intended to be printed with accent color. The parts are marked with a heart in the manual.	Example [c]_led_diffuser.stl We have added “[c]” to the front of any STL file that is intended to be printed with clear or transparent filament (cloudy is better than clear; white or light grey may also work in a pinch).	Example [o]_led_diffuser_mask.stl We have added “[o]” to the front of any STL file that is intended to be printed with an opaque filament (blocks light, dark colours and blacks).	Example [a]_z_belt_clip_lower_x4.stl If any file ends with “_x#”, that is telling you the quantity of that part required to build the machine.

HOW TO GET HELP

If you need assistance with your build, we’re here to help. Head on over to our Discord group and post your questions. This is our primary medium to help VORON Users and we have a great community that can help you out if you get stuck.



<https://discord.gg/voron>

REPORTING ISSUES

Should you find an issue in the documentation or have a suggestion for an improvement please consider opening an issue on GitHub (<https://github.com/VoronDesign/Voron-Afterburner/issues>). When raising an issue please include the relevant page numbers and a short description; annotated screenshots are also very welcome. We periodically update the manual based on the feedback we get.

THIS IS JUST A REFERENCE

This manual is designed to be a simple reference manual. Building a Voron can be a complex endeavour and for that reason we recommend downloading the CAD files off our Github repository if there are sections you need clarification on. It can sometimes be easier to follow along when you have the whole assembly in front of you.



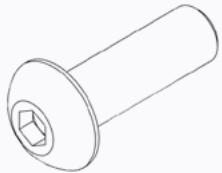
<https://github.com/vorondesign>



<https://docs.vorondesign.com/>

HARDWARE REFERENCE

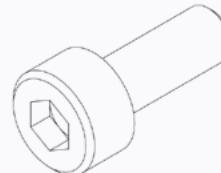
WWW.VORONDESIGN.COM



BUTTON HEAD CAP SCREW (BHCS)

Metric fastener with a domed shape head and hex drive. Most commonly found in locations where M5 fasteners are used.

ISO 7380-1



SOCKET HEAD CAP SCREW (SHCS)

Metric fastener with a cylindrical head and hex drive. The most common fastener used on the Voron.

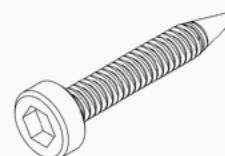
ISO 4762



FLAT HEAD CAP SCREW (FHCS)

Metric fastener with a flat head and hex drive.

ISO 10642



SELF TAPPING SCREW

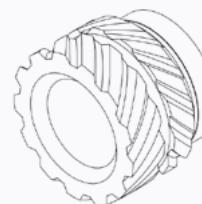
Fastener with a pronounced thread profile that is screwed directly into plastic.



WASHER

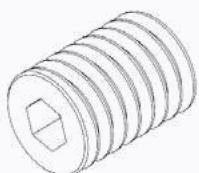
Usually stamped from sheet metal this type of spacer is not as consistent in thickness as the shims are. Only used in M3 size.

DIN 125



HEAT SET INSERT

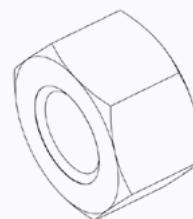
Heat inserts with a soldering tip so that they melt the plastic when installed. As the plastic cools, it solidifies around the knurls and ridges on the insert for excellent resistance to both torque and pull-out.



SET SCREW

Small headless screw with an internal drive. Used in pulleys and other gears. Also called a grub screw.

ISO 4026



HEX NUT

Hex nuts couple with bolts to create a tight, secure joint.

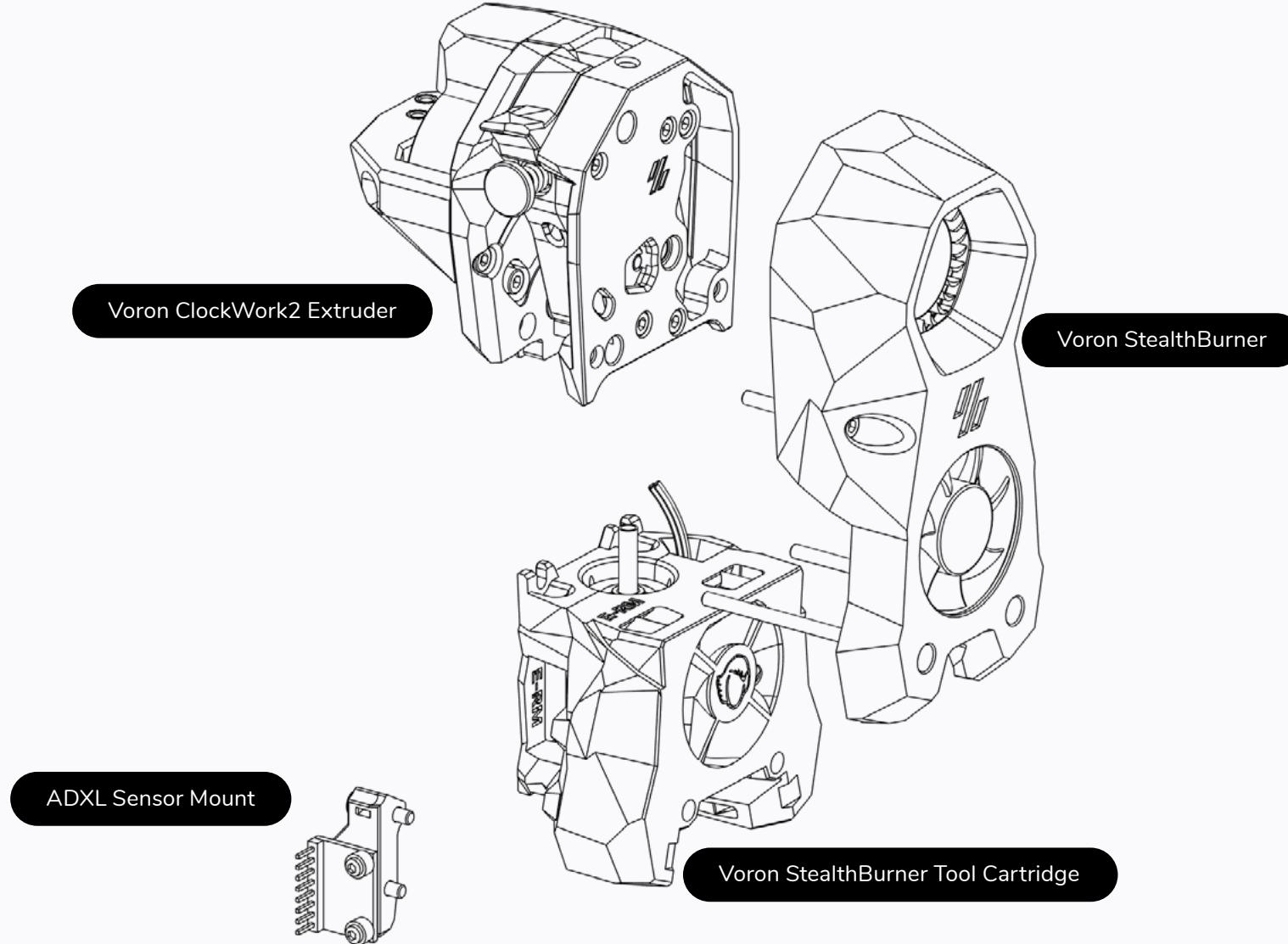
ISO 4032

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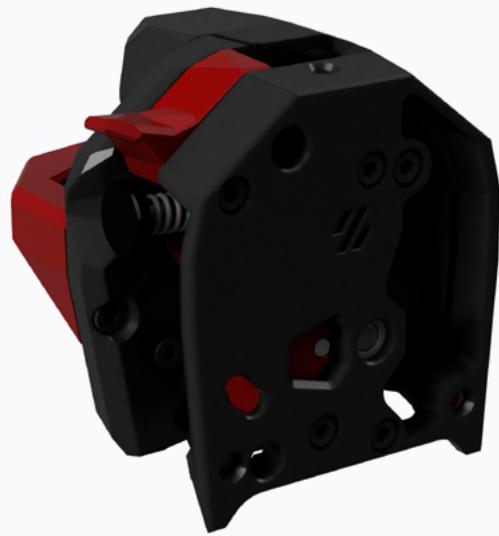
OVERVIEW

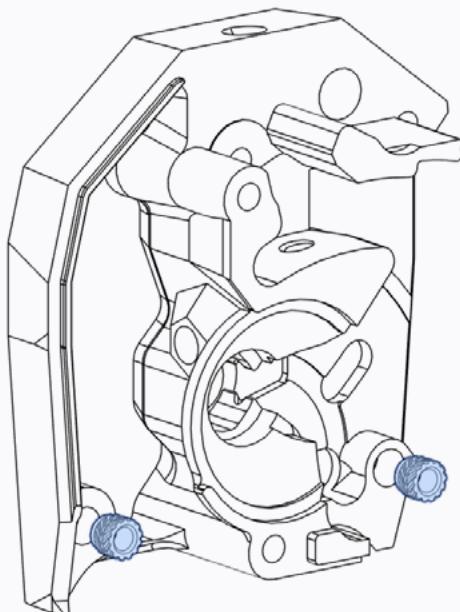
WWW.VORONDESIGN.COM



VORON CLOCKWORK2

WWW.VORONDESIGN.COM



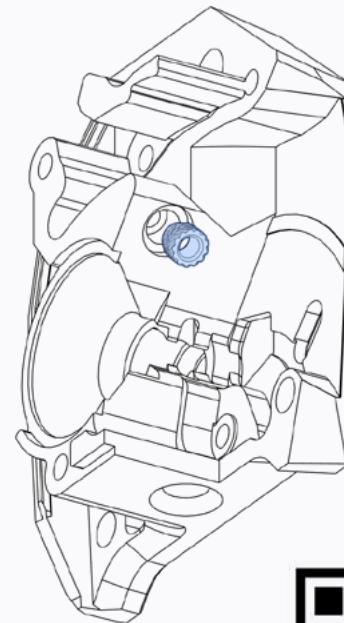


HEAT SET INSERTS

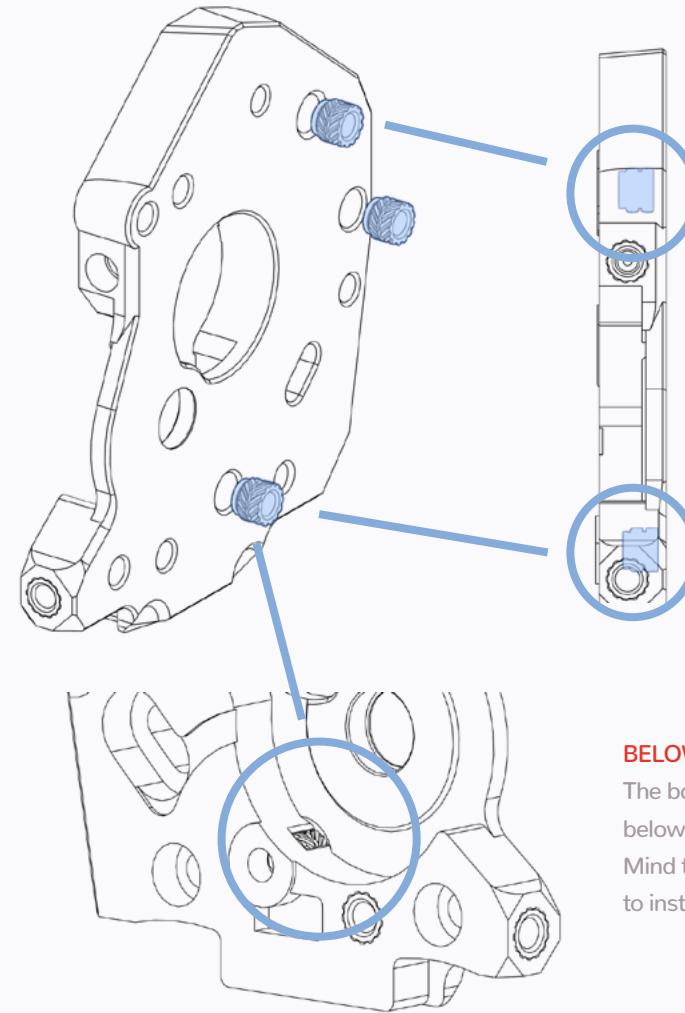
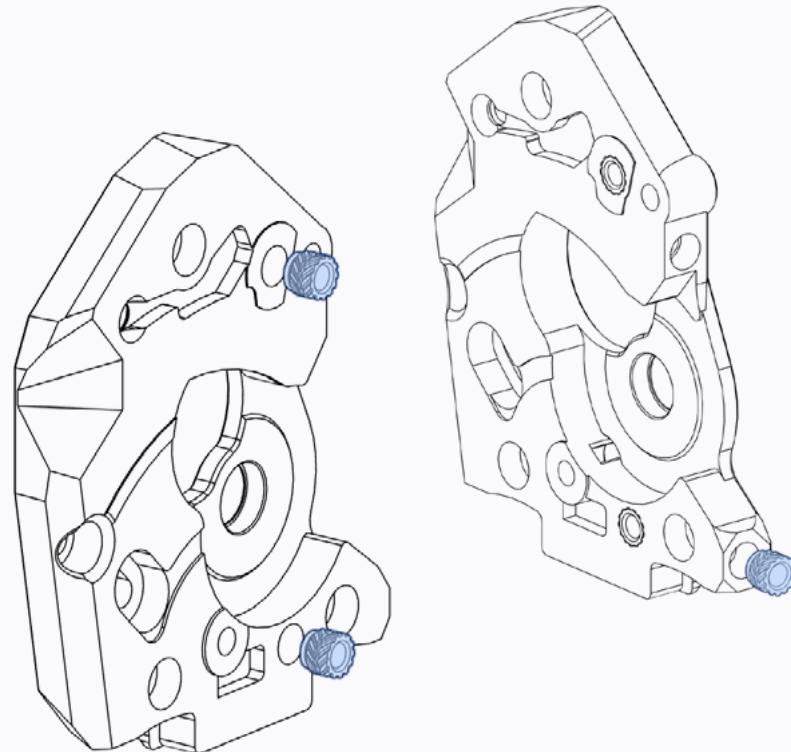
This design relies heavily on heat set inserts. Make sure you have the proper inserts (check the hardware reference for a close-up picture and the [Sourcing Guide](#) for dimensions).

If you've never worked with heat set inserts before we recommend you watch the linked guide.

Heat Set Insert



<https://voron.link/m5ybt4d>



BELOW SURFACE

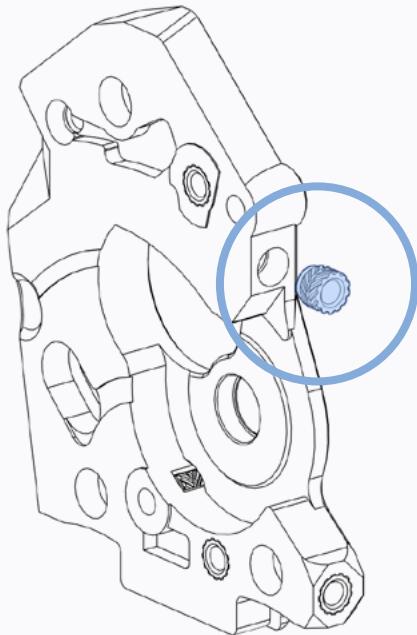
The top heatset insert needs to sit below the surface of the printed part.

BELOW SURFACE

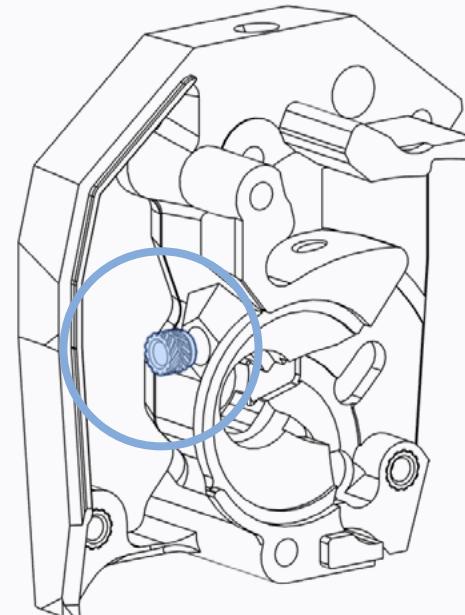
The bottom heatset insert needs to sit below the surface of the printed part.
Mind the cutout in the part and make sure to install it straight.

OPTION: TOOLHEAD PCB

If you opt to use a toolhead PCB, add additional heat set inserts into locations highlighted below.



Heat Set Insert

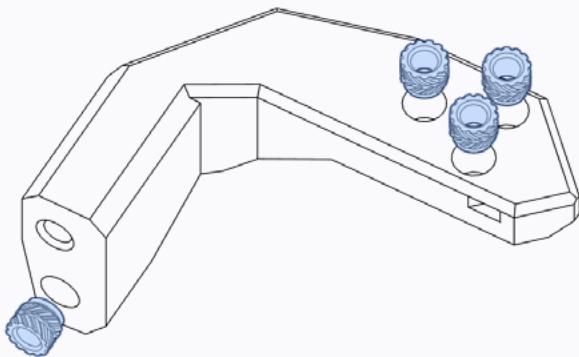


HEAT SET INSERT

Be careful when inserting this heat set insert. It's easy to accidentally touch the left side of the part with the soldering iron.

GENERIC CABLE CHAINS

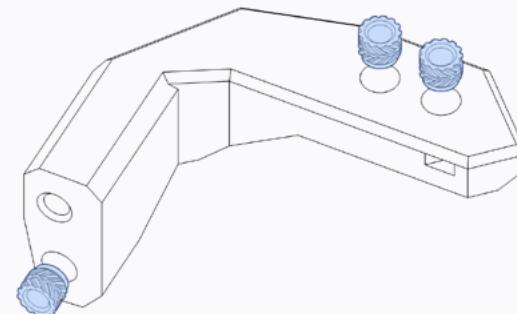
The 3-hole pattern is usually found on generic cable chains.



Heat Set Insert

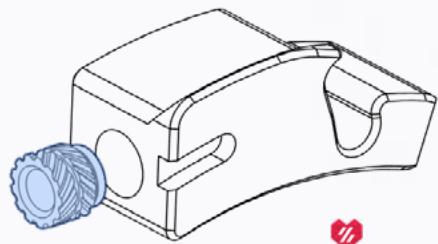
IGUS CABLE CHAINS

IGUS chains have 2 mounting holes.

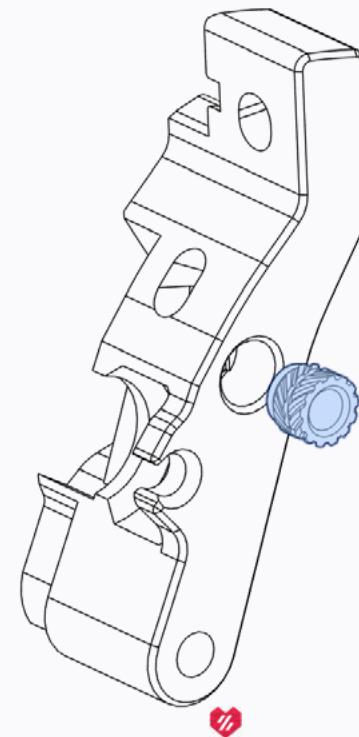
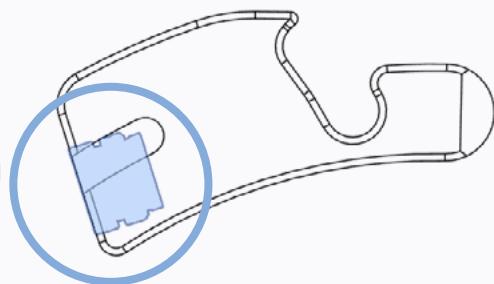


PRINTER SPECIFIC MOUNTS

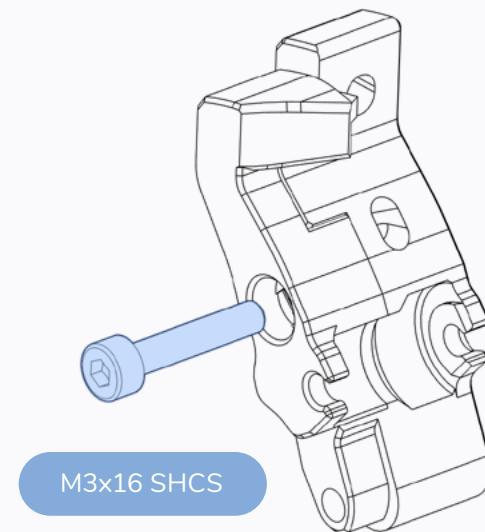
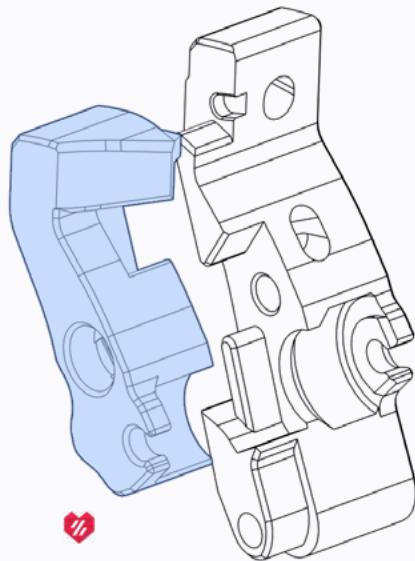
V2, Trident and Legacy use the same printed parts. Extra parts are included for SwitchWire.

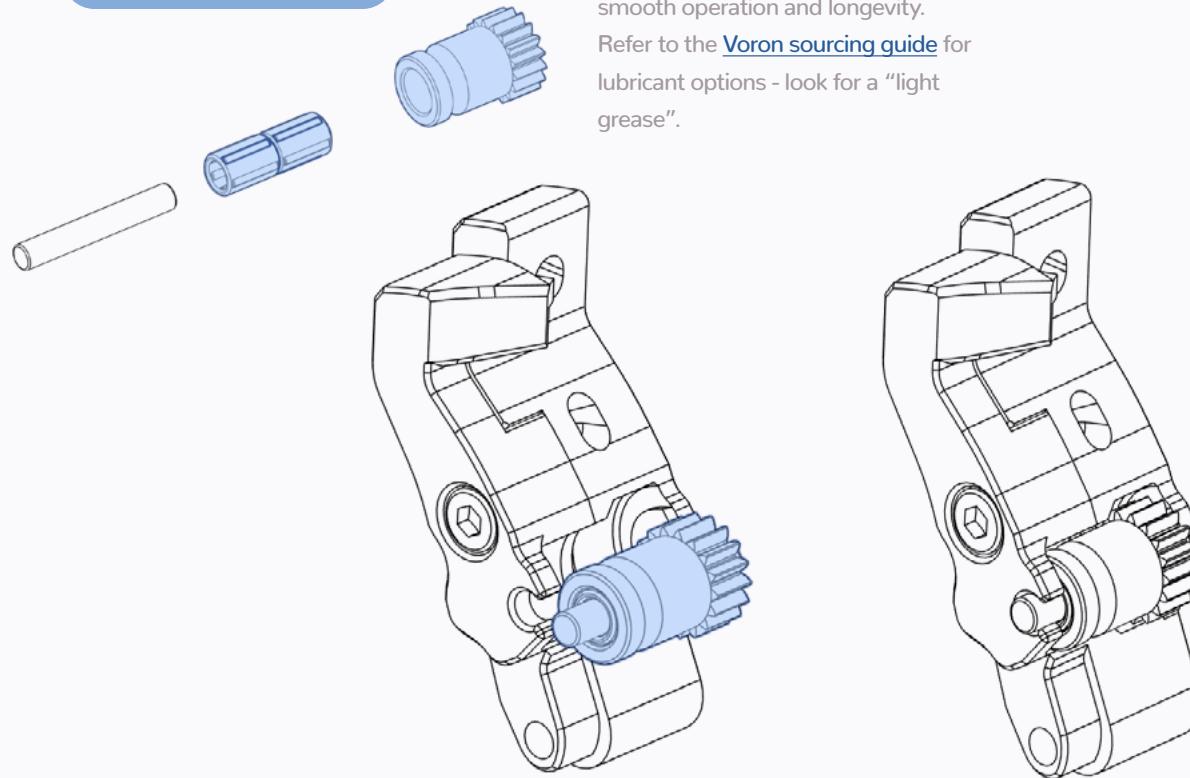
**FLUSH WITH SURFACE**

The heatset insert needs to sit flush or slightly below the surface of the printed part.

**ACCENT PART?**

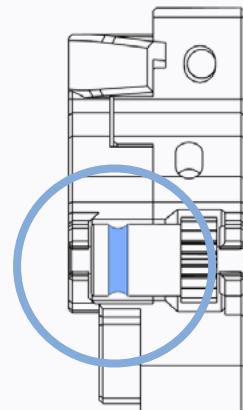
Look for Voron heart next to the part.
It indicates that this is a part that is
usually printed in the accent color.



BMG Idler Assembly**LUBRICATE BEARINGS**

A lubrication film is required to ensure smooth operation and longevity.

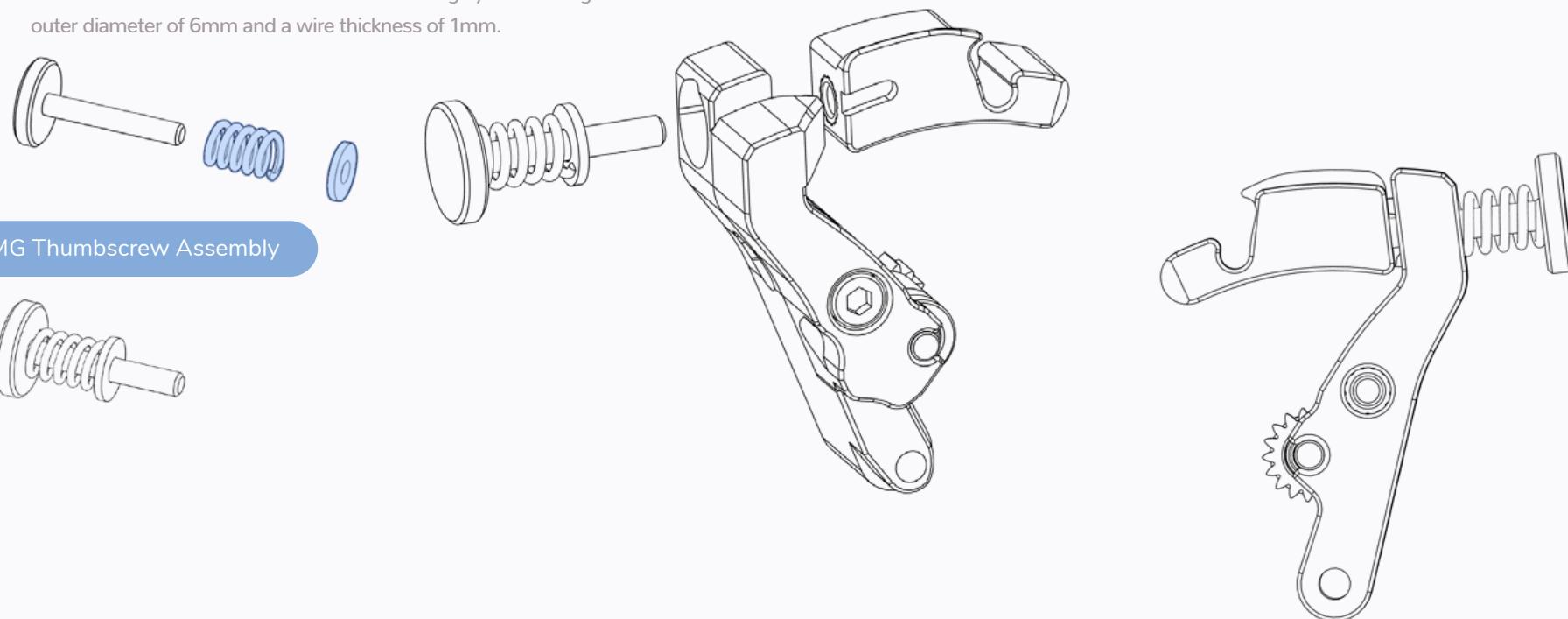
Refer to the [Voron sourcing guide](#) for lubricant options - look for a "light grease".

**MIND ORIENTATION**

Make sure to orient the idler assembly as shown above.

A NOTE ON SPRINGS

Longer/shorter/stiffer springs will change the tension characteristics and have an impact on how well the tension mechanism works. Consider buying the [original Bondtech part](#) as those are known to work well. If sourced from a different vendor check if it's roughly 12mm long with an outer diameter of 6mm and a wire thickness of 1mm.

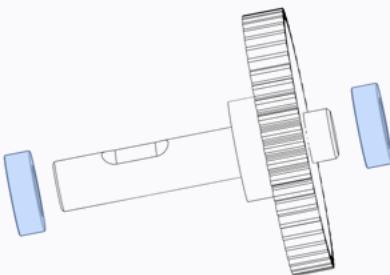


CHECK BEARING FIT

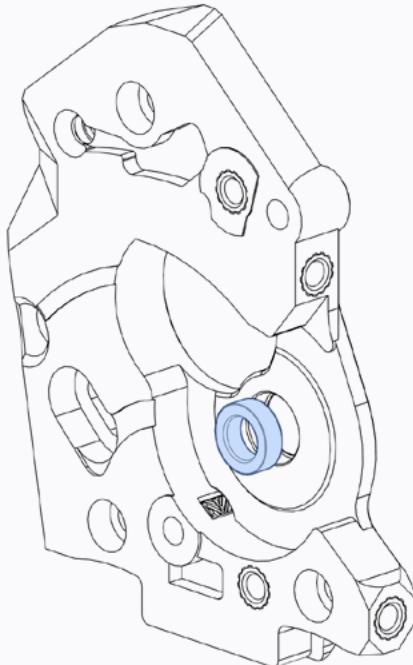
The bearings must slip on and off the shaft easily to allow the gear to self-centre.

Pressing the bearings on the shaft will damage them.

Lightly sand the shaft if required.



MR85 Bearing

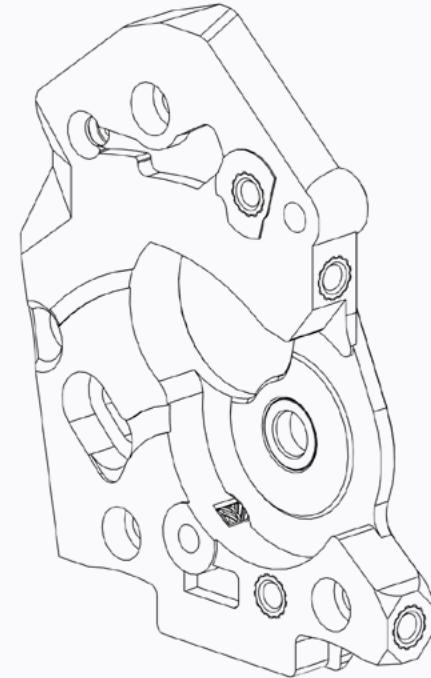


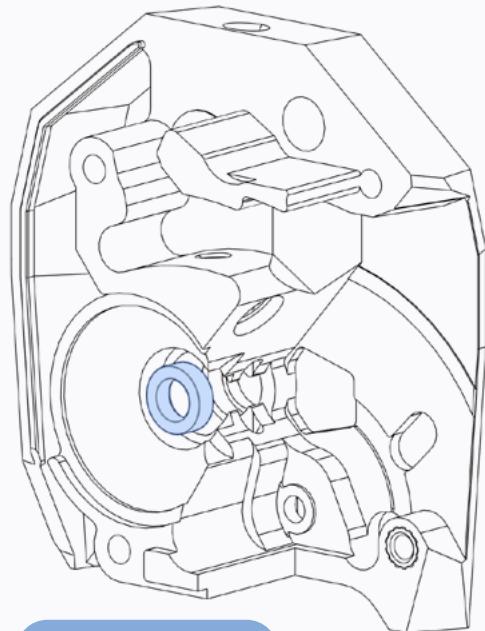
MR85 Bearing

BEARING FIT

Fully seat the bearing into the plastic pocket. Apply even pressure to insert them. Avoid pressing on the inner ring of the bearing.

If the fit is too tight the printed parts are likely over-extruded.

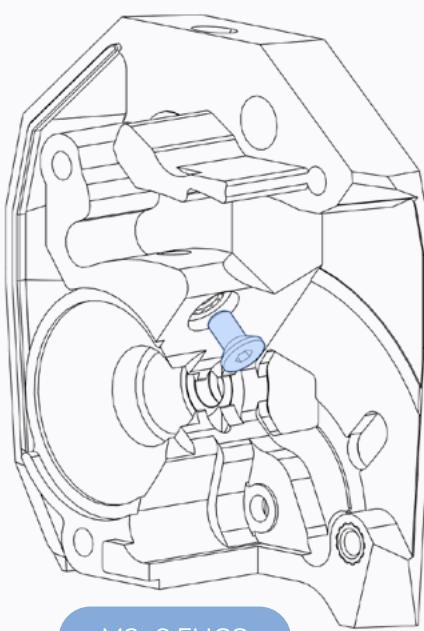




MR85 Bearing

BEARING FIT

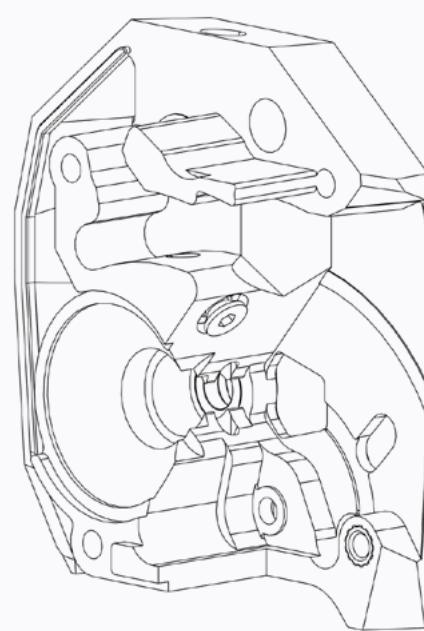
Fully seat the bearing into the plastic pocket.
Apply even pressure to insert them. Avoid
pressing on the inner ring of the bearing.



M3x6 FHCS

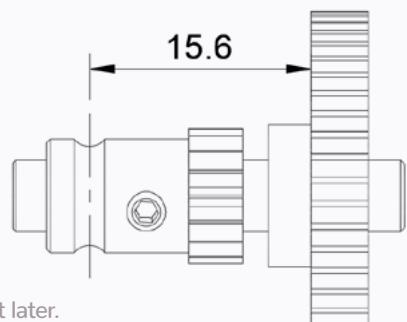
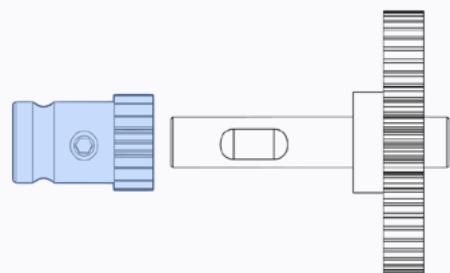
THREAD LOCKER PLEASE

Adding a small amount of medium strength
thread locker to this flat head screw will keep
it from coming loose over time..



A NOTE ON GEARS

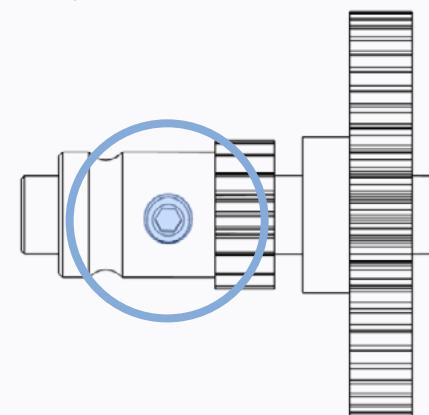
Poorly made gears often cause print quality issues. For best performance consider sourcing the [original Bondtech parts](#).

**INITIAL POSITION**

The final position is set later.

DRIVE GEAR

Make sure the set screw in the filament drive gear is seated against the notch in the shaft. Carefully tighten the set screw, the head is easy to strip.

**THREAD LOCKER**

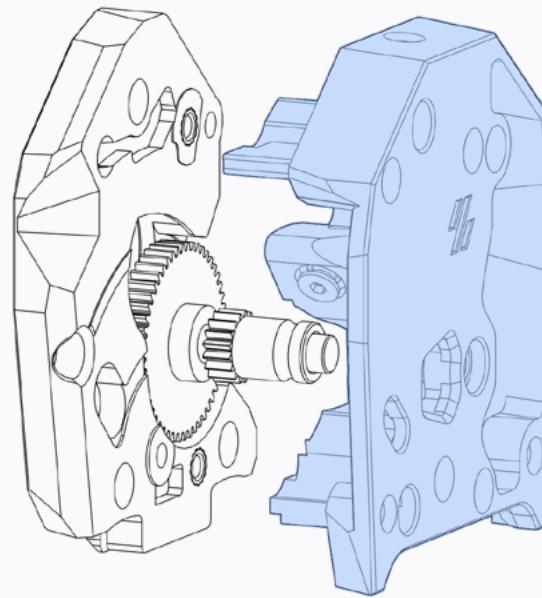
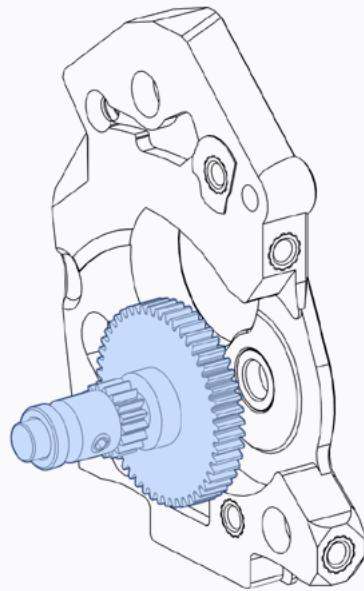
The final position of the drive gear is set in a later step. Common thread lockers have a long enough working time to complete the steps without issues.

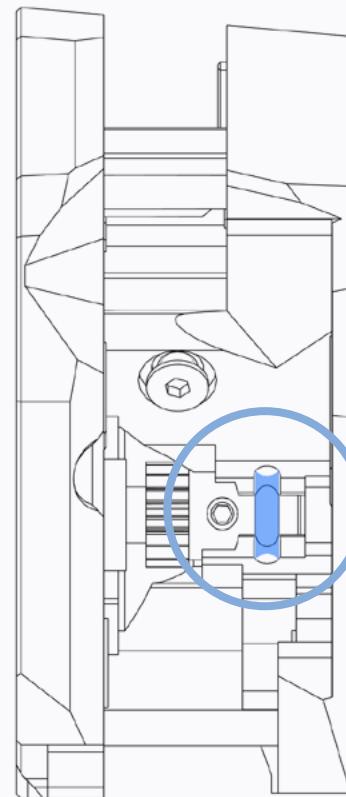
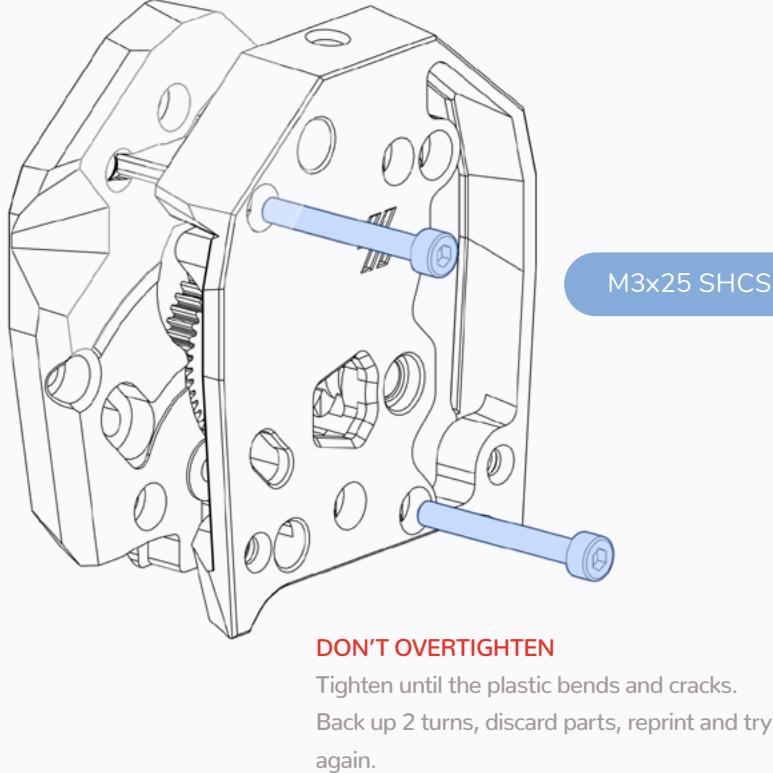
Familiarize yourself with the steps on the next 3 pages before you apply thread locker.

Complete the steps on the next 3 pages after applying the thread locker.

MAIN BODY

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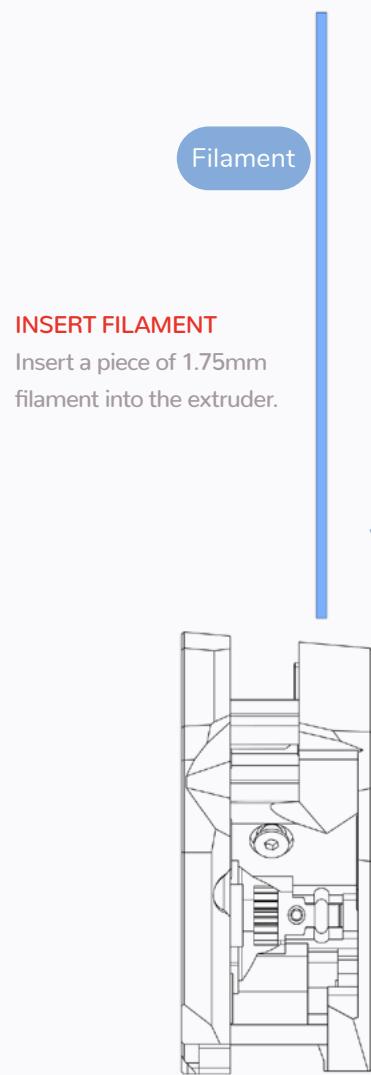


**INITIAL ALIGNMENT CHECK**

Check if the filament path aligns with the toothed section of the drive gear.

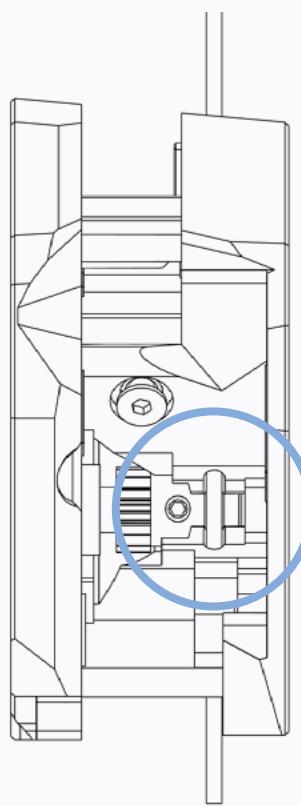
DRIVE ALIGNMENT

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INSERT FILAMENT

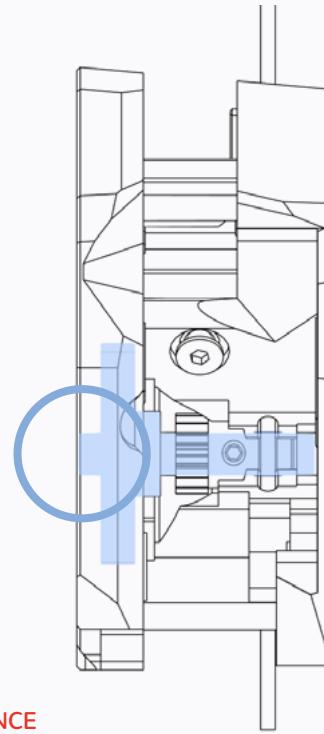
Insert a piece of 1.75mm filament into the extruder.



CHECK ALIGNMENT

With the filament inserted, verify if the filament path and drive gear are aligned.

Loosen the set screw and adjust the position of the drive gear if required.



CHECK FOR CLEARANCE

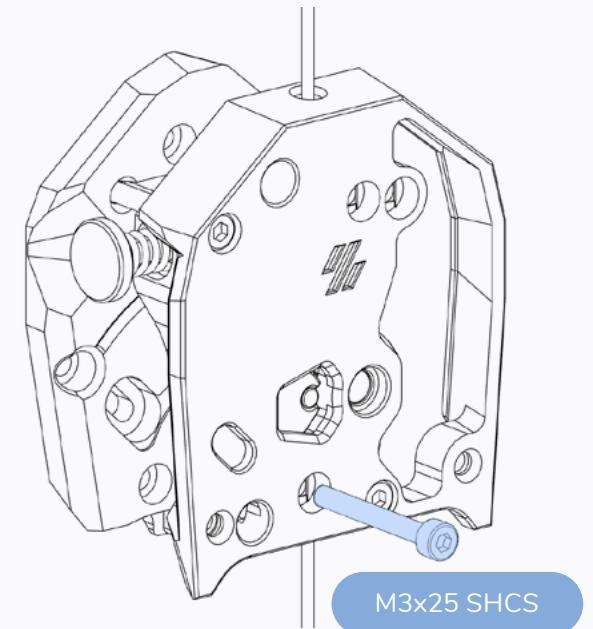
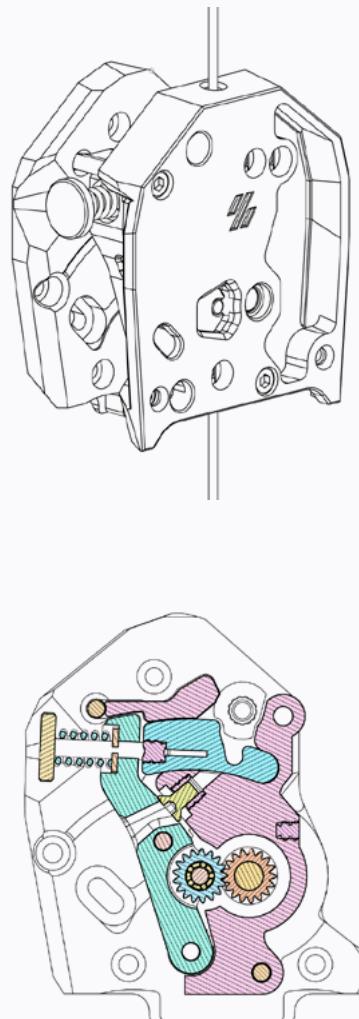
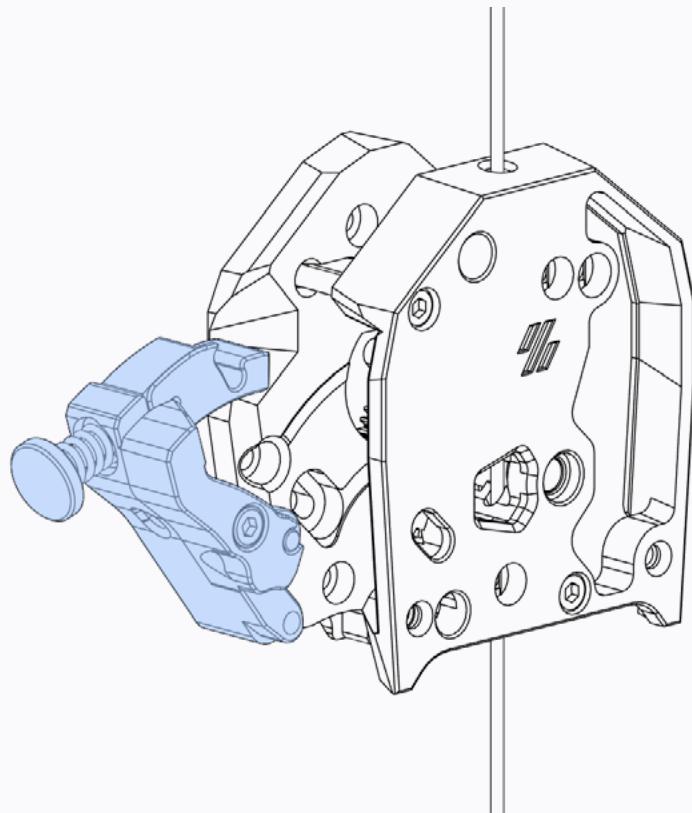
The drive shaft must not touch the motor housing. Make sure it does not sit above the surface of the printed part.

Check if the shaft has sufficient clearance when fully seated.

Depending on the shafts tolerances you may need to adjust the position of the drive gear or sand the face of shaft.

TENSION ARM

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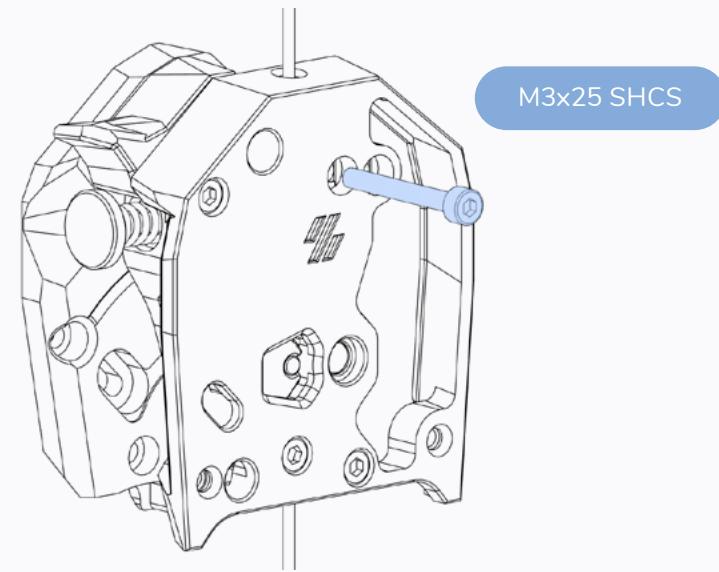
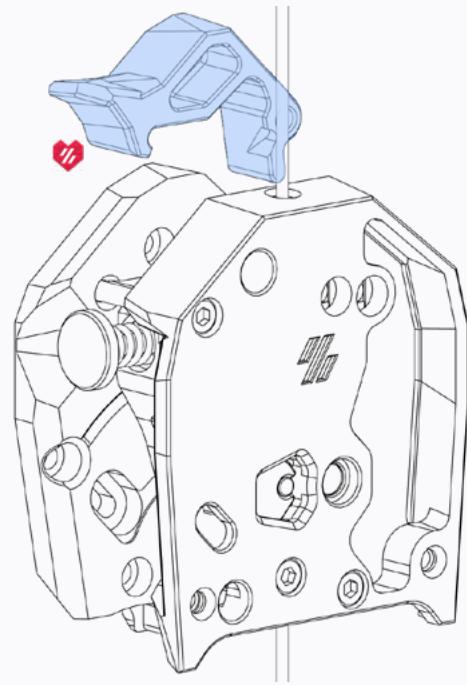


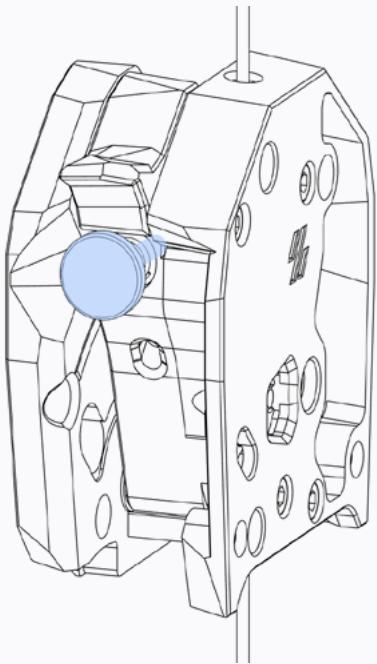
DON'T TIGHTEN

The tensioning arm must move freely. Tightening the bolt may lock it in place.

LATCH

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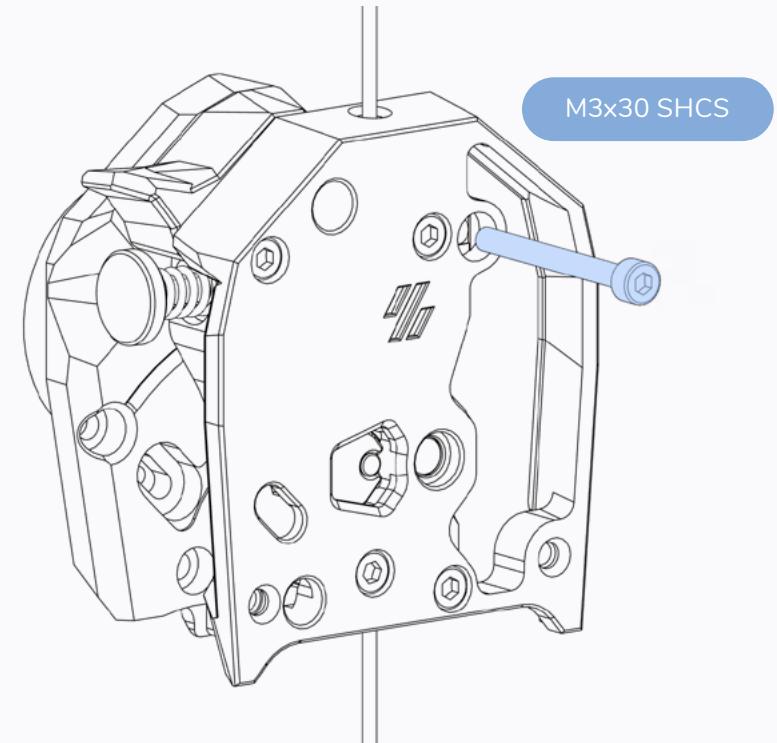
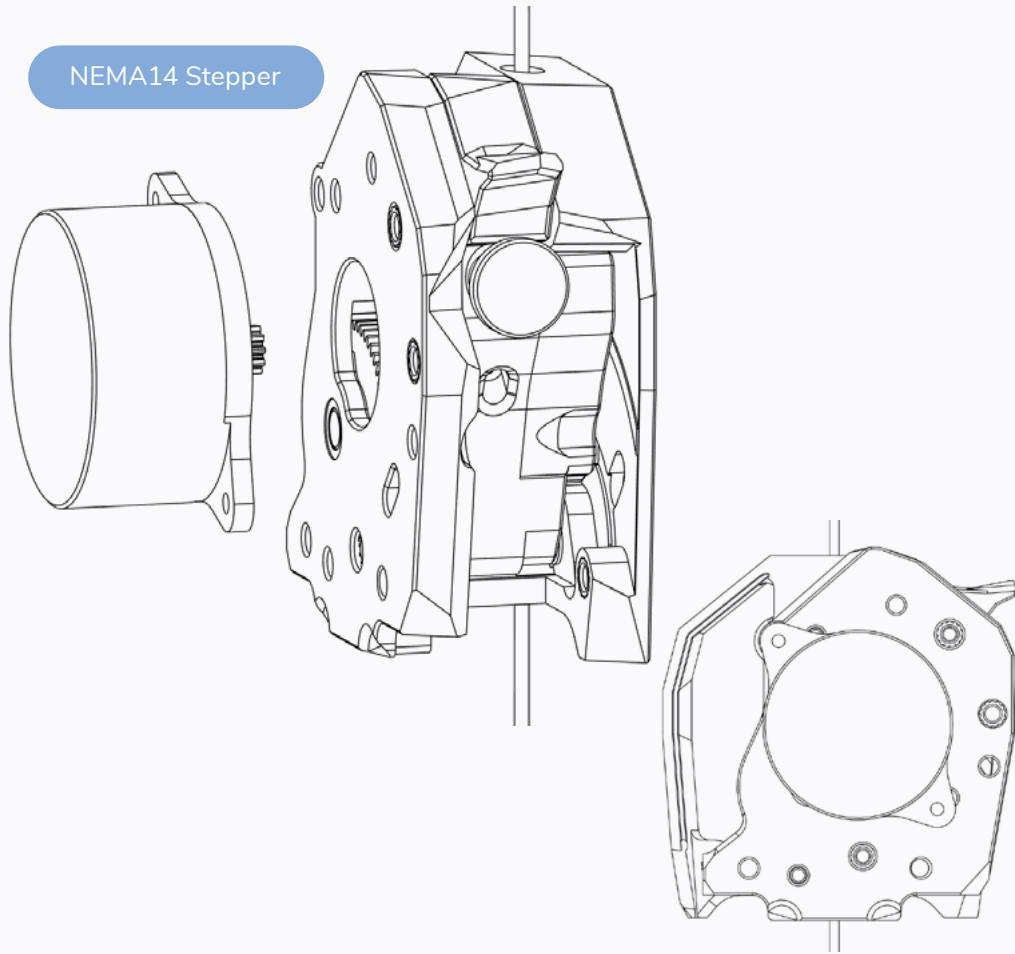


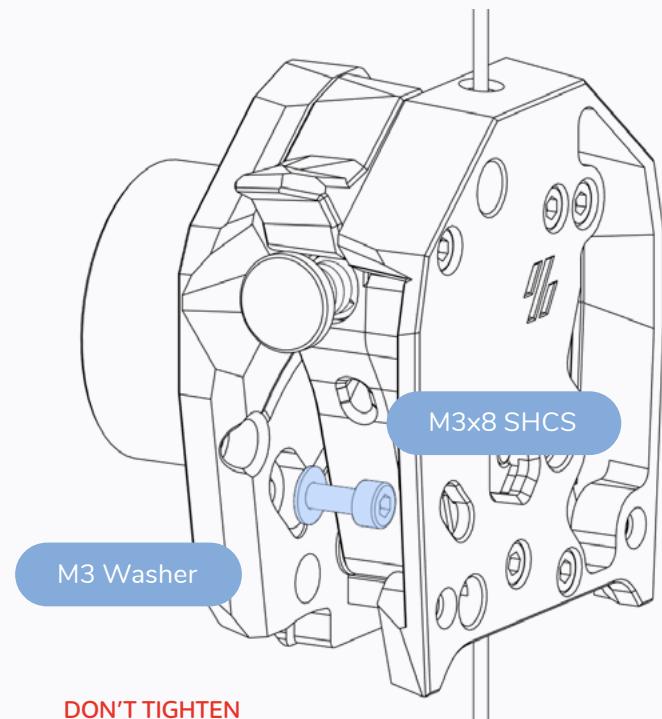
**TENSION KNOB**

Turning the thumb screw clockwise will increase the tension and grip on the filament. Too much tension will result in print issues.

**ANTI SQUISH THINGYMAJIG**

Softer and flexible materials will deform and extrude poorly under too much tension. ClockWork2 adds an adjustment feature to set the minimum distance between the drive gear and the idler, limiting the squish on the filament, and to prevent the gears from meshing too tightly or binding up the extruder.

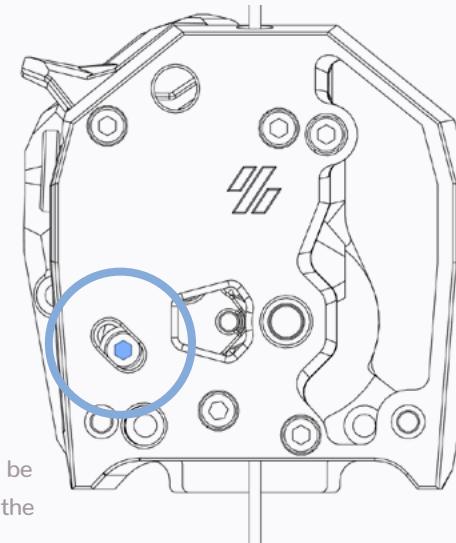


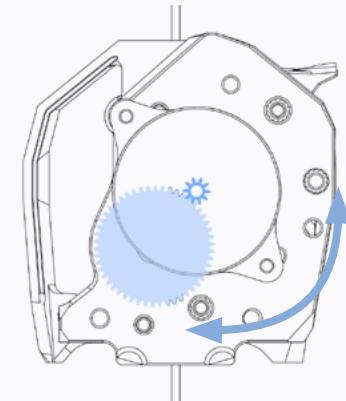
**DON'T TIGHTEN**

The motor position will be adjusted in the next steps. Don't fully tighten just yet.

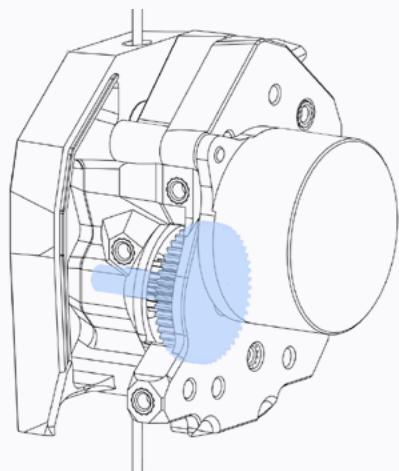
ACCESS HOLE

The second motor bolt can be accessed from the front of the extruder.

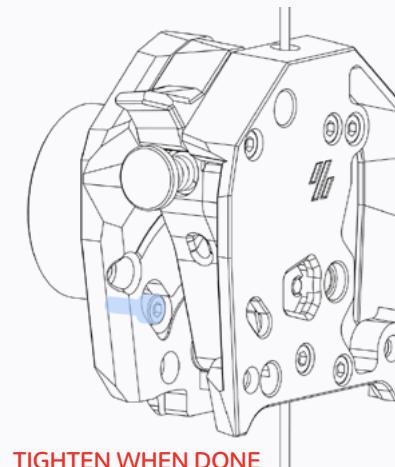


**SET GEAR MESHING**

Adjust the stepper motor position so that the motor and extruder gear teeth fully mesh /overlap with each other. There should be a very small gap between the faces of the gear teeth; the gears must not press tightly against each other.

**CHECK GEAR PLAY**

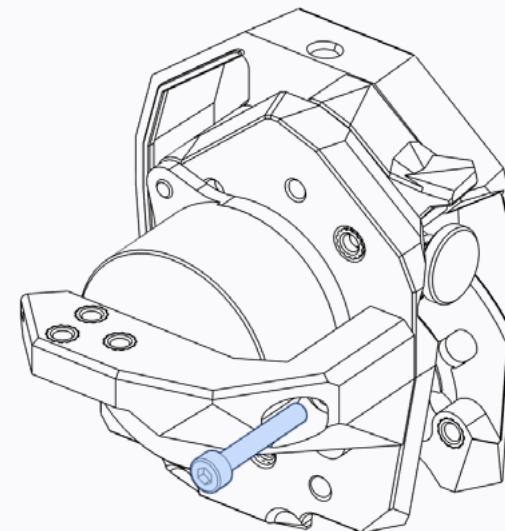
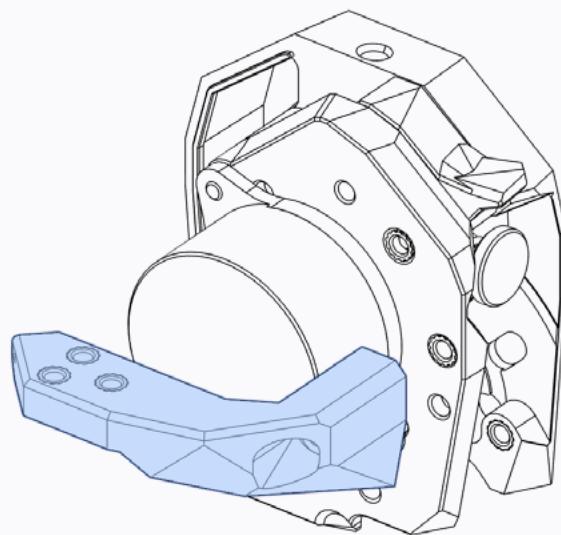
The gear should have a slight play and should not be fully tight against the pinion. Adjust the position of the motor until you have a faint play.

**TIGHTEN WHEN DONE**

Don't forget to tighten the second motor bolt after adjusting.



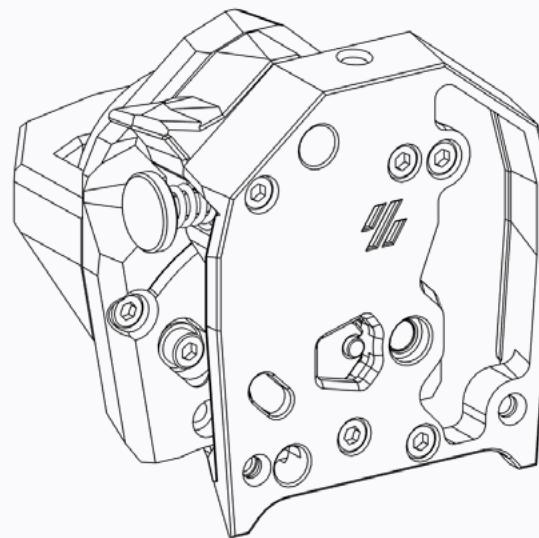
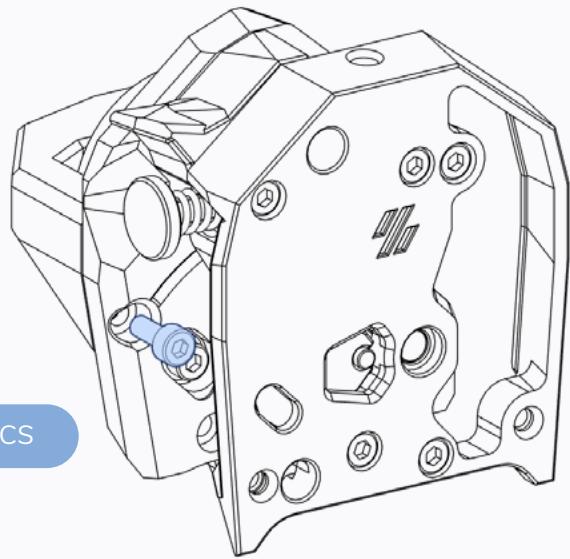
<https://voron.link/u6ehxsw>

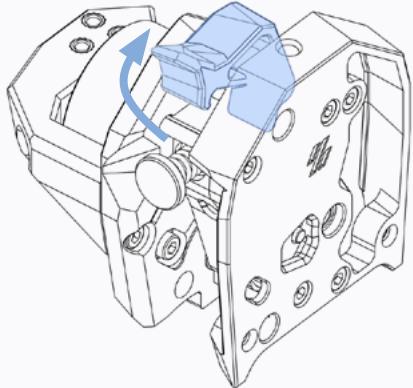


M3x20 SHCS

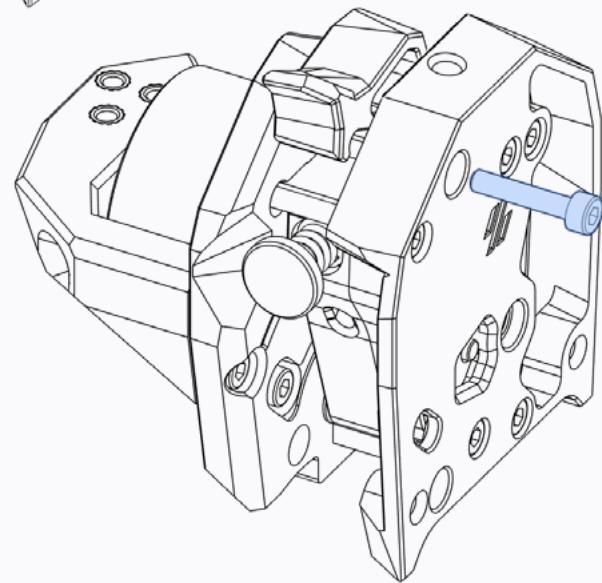
CABLE BRIDGE

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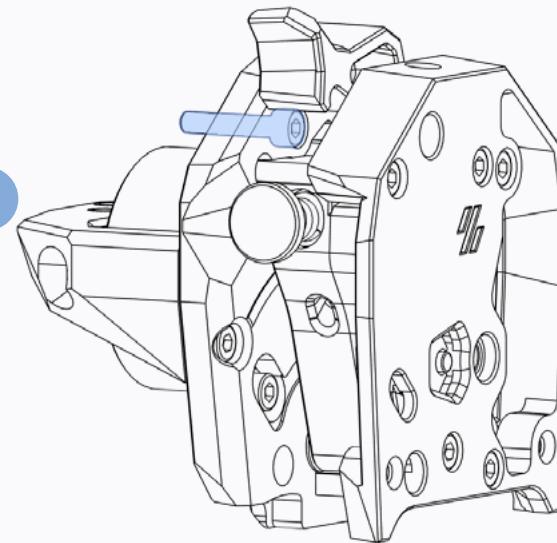


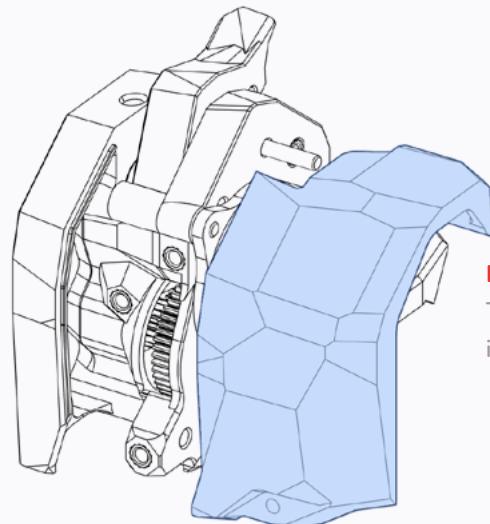
**OPEN LATCH**

Undo the filament latch to expose the bolt pocket for the cable cover.

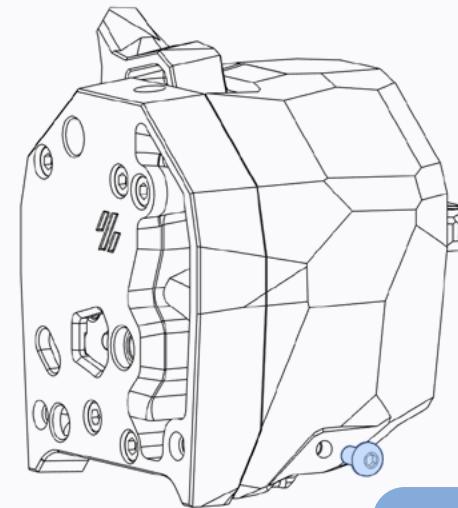


M3x16 SHCS

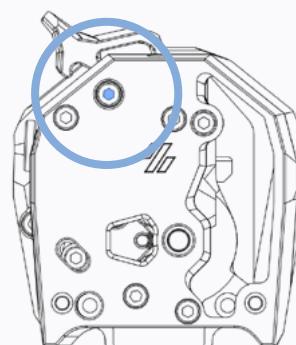


**DON'T OVER-TIGHTEN**

The bolt is threaded directly into plastic.



M3x6 BHCS

**ACCESS HOLE**

The bolt drive can be accessed from the front of the extruder.

StealthBurner development started on 2021-04-13 with a simple: "I'm going to regret saying this but, 'How hard could it be?'"

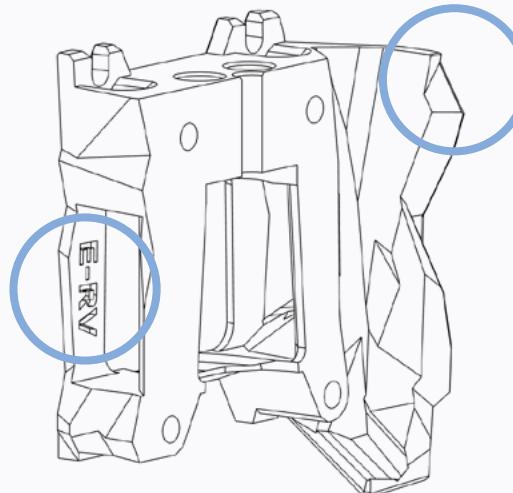
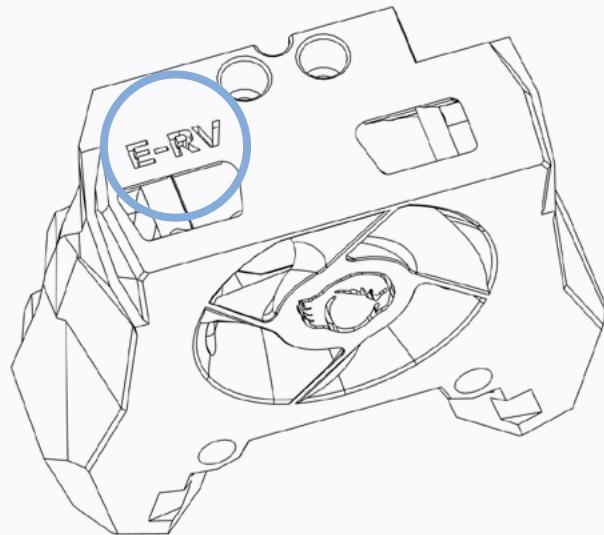
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IDENTIFYING PRINTED PARTS

The hotend type is embossed on the printed parts.

Make sure they match your hotend.

**AVAILABLE MOUNTS**

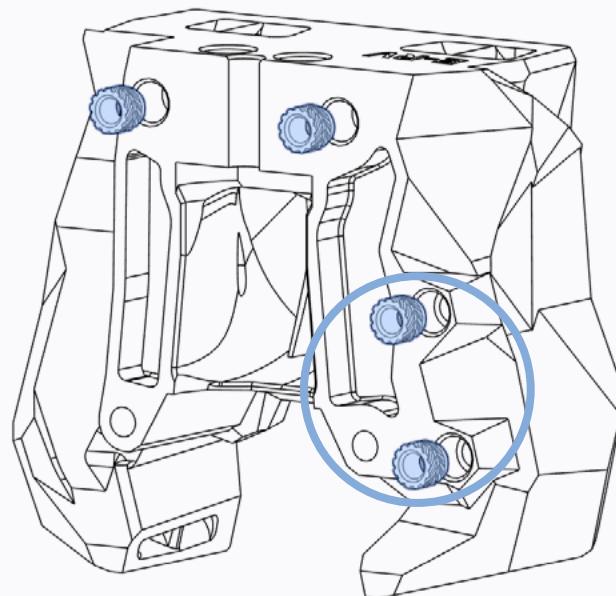
We also provide mounts for other hotends. They are assembled in a similar manner.

For a full list of available mounts and their identification code, see the readme file included in the toolheads folder.

MISSING CORNER? CW1? CW2?

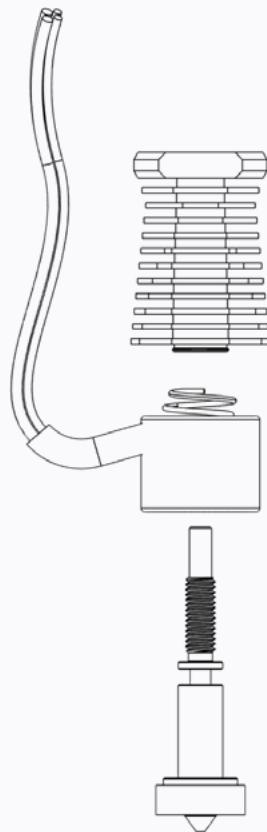
We also provide tool cartridge parts for ClockWork1, and other extruders designed as an alternative to CW1. They are identical except for an opening in the highlighted corner to help with wire routing for those designs.

Heat Set Insert



OPTION: ADXL PCB MOUNT

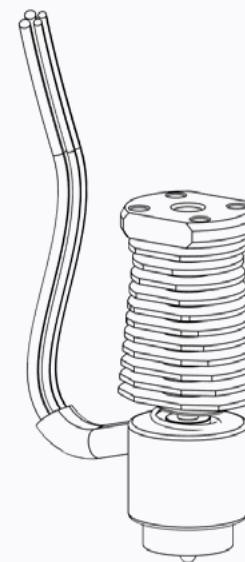
To use the optional ADXL PCB for Klipper's Input Shaper calibration, add additional heat set inserts into the holes in highlighted location.



Revo Voron Heatsink

Revo HeaterCore

Revo Nozzle



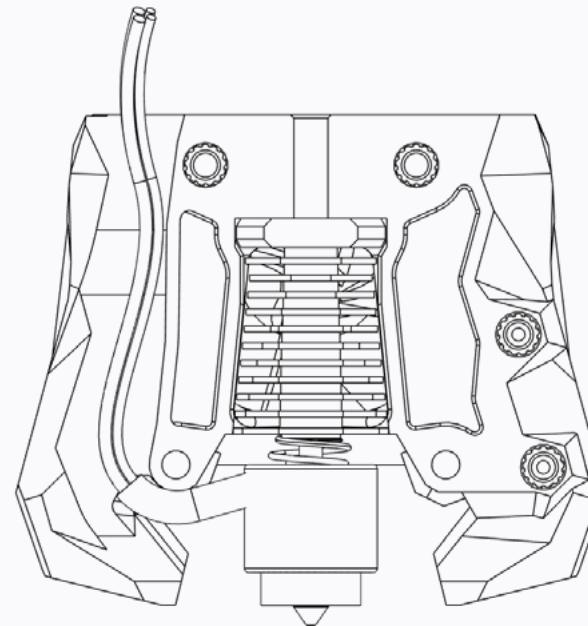
HOTEND WIRE ROUTING

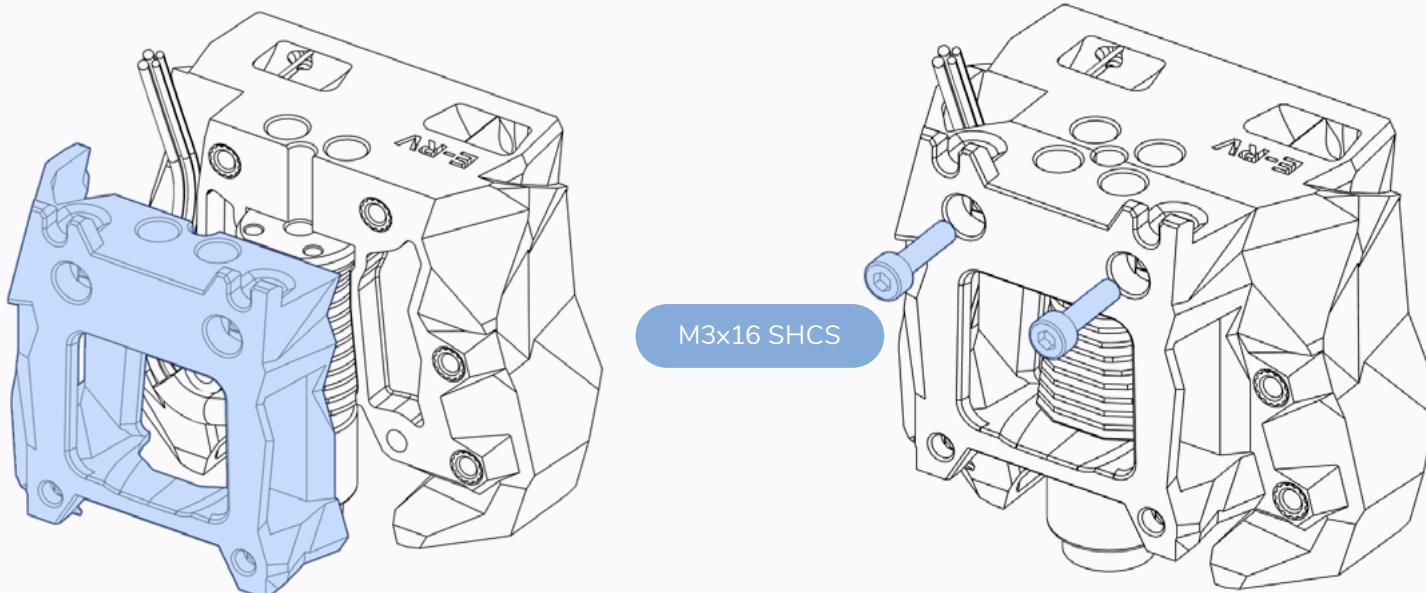
Route the wires as shown to the right. This is universal to all hotend types.

BEND STRAIN RELIEF

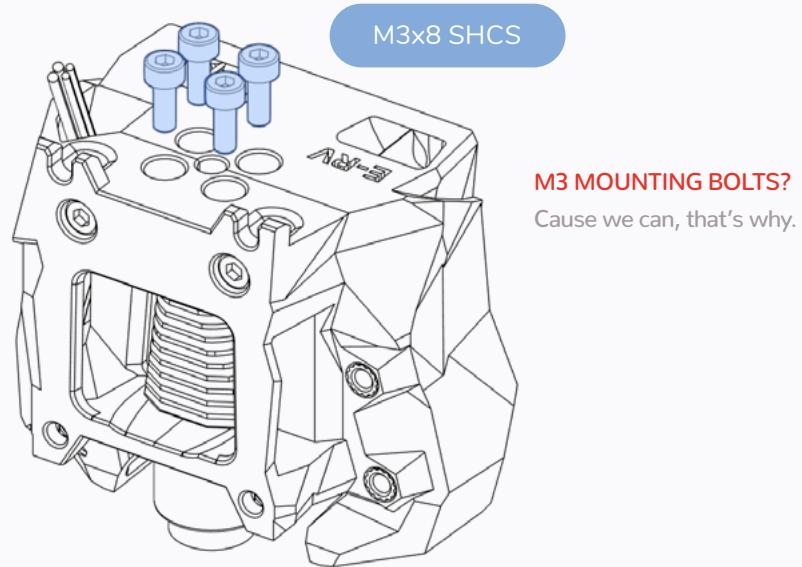
Carefully bend the strain relief to clear the printed part. Firmly hold the HeaterCore to prevent bending the Revo Nozzle.

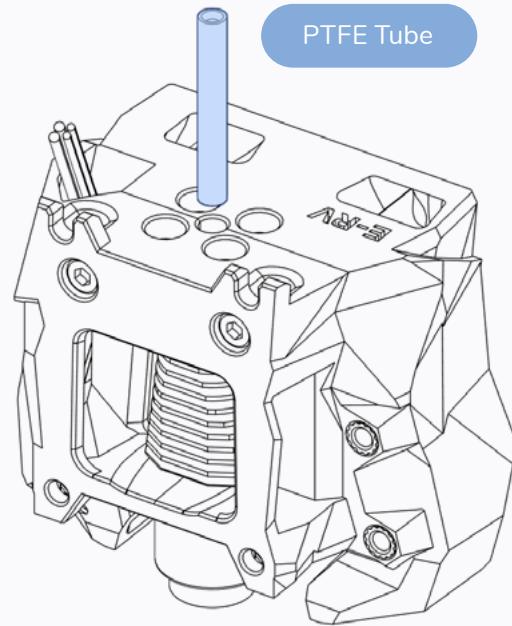
It is critical that the Revo Nozzle is fully hand tightened into the heatsink. You MUST bend the strain relief to achieve this.





M3x16 SHCS



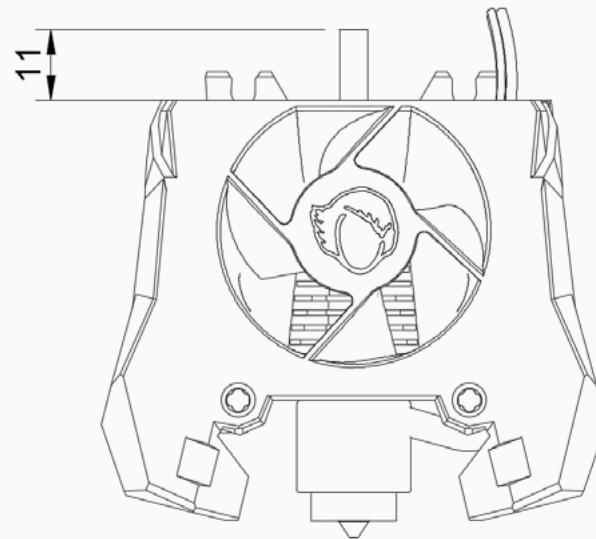


PTFE Tube

PTFE STICKOUT

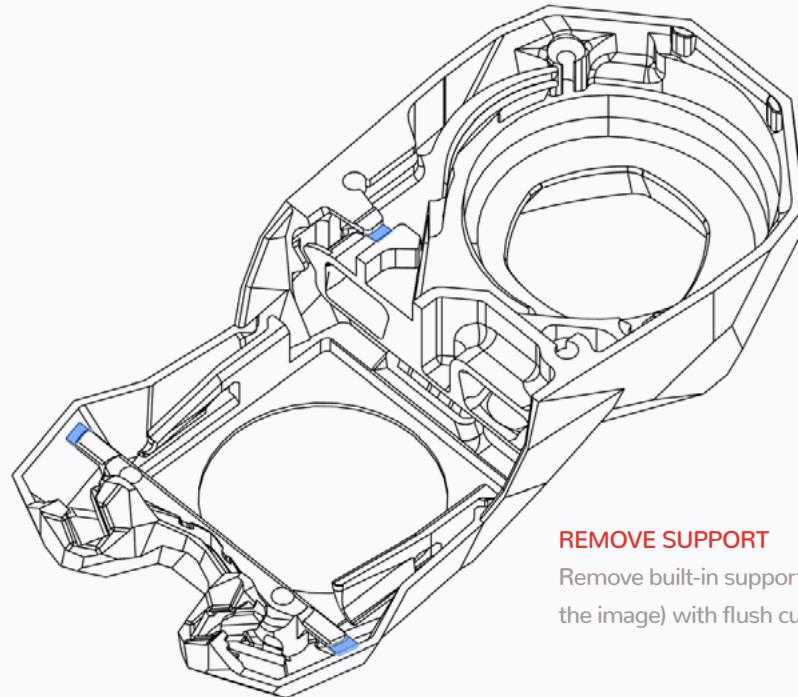
The PTFE tube should stick out 11mm above the surface of the printed part.

The stick out length might vary if you use an extruder other than the ClockWork2.



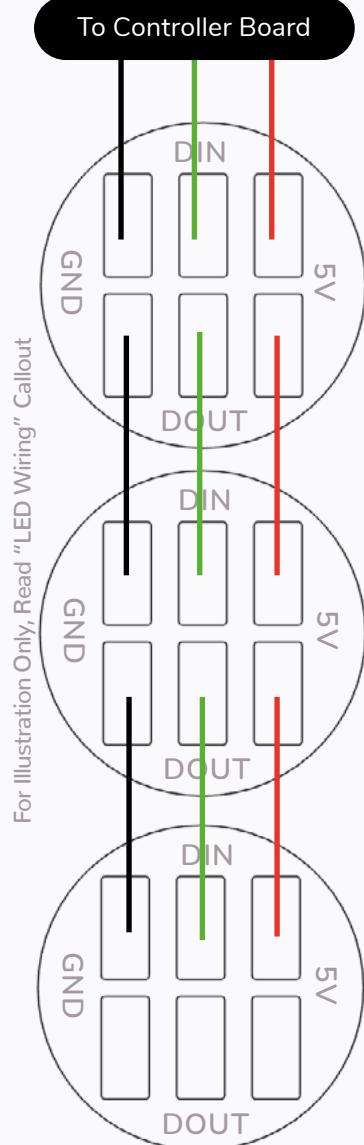
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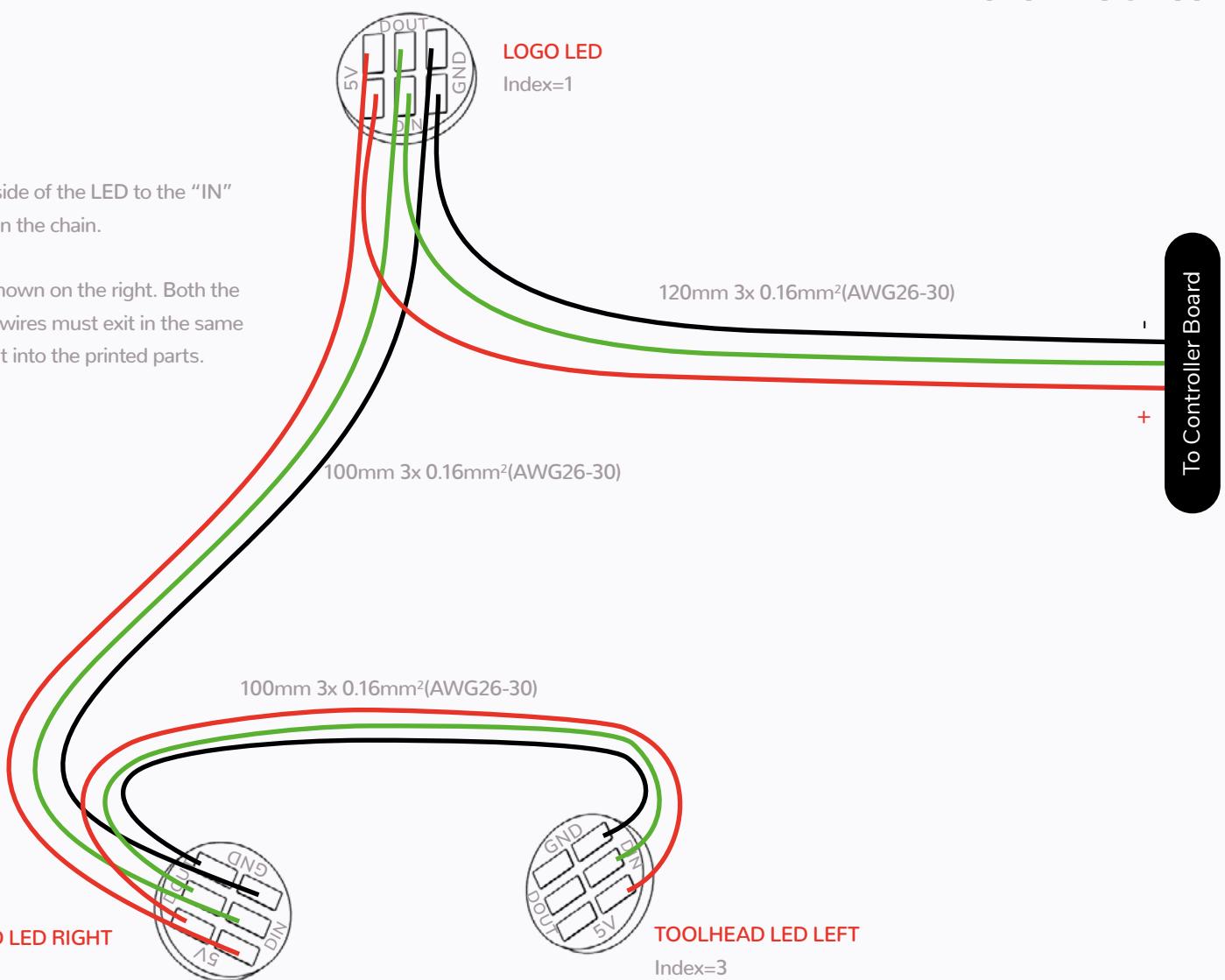
REMOVE SUPPORT

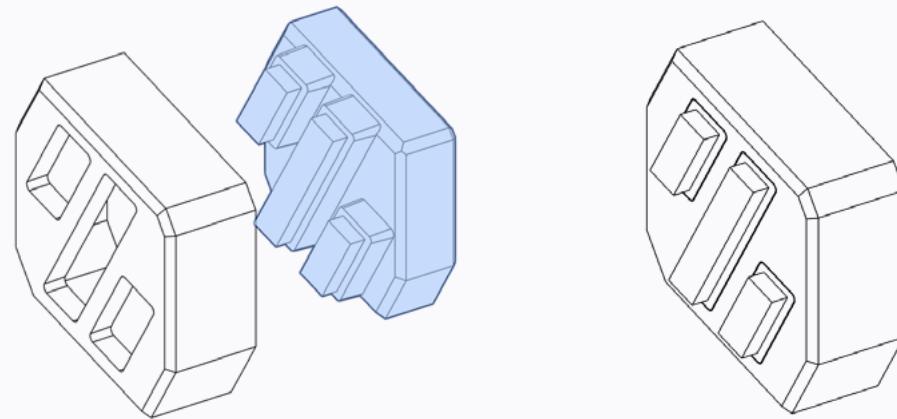
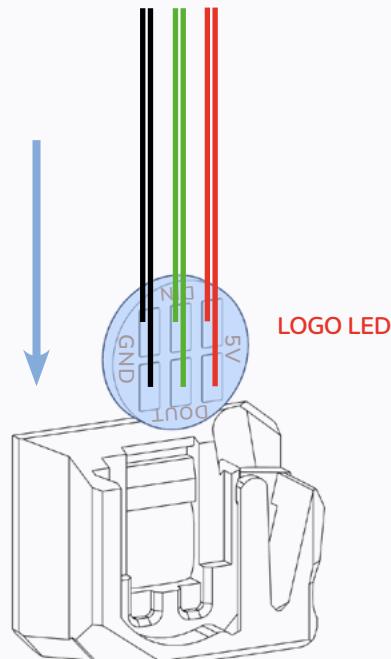
Remove built-in supports (highlighted in the image) with flush cutters.

**LED WIRING**

Connect the "OUT" side of the LED to the "IN" side of the next LED in the chain.

Solder the wires as shown on the right. Both the "IN" and the "OUT" wires must exit in the same direction in order to fit into the printed parts.





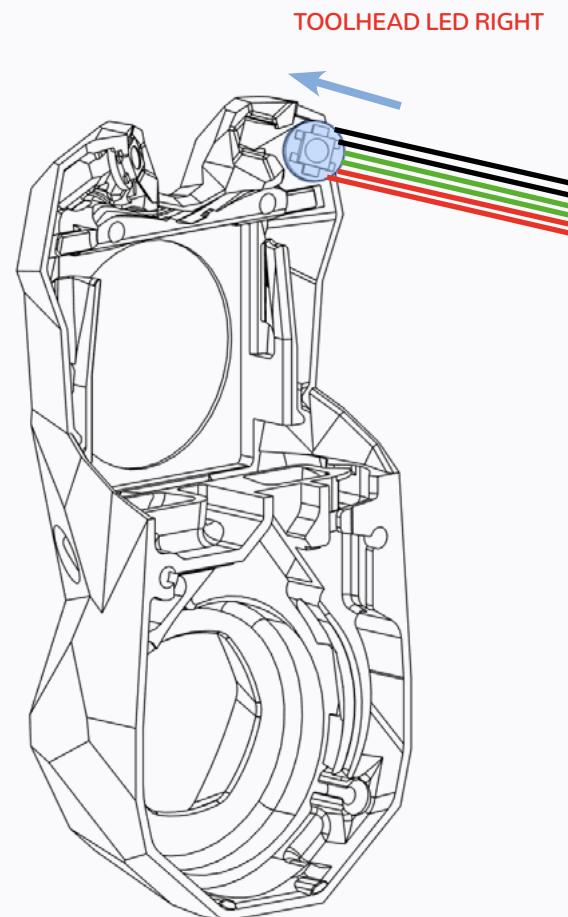
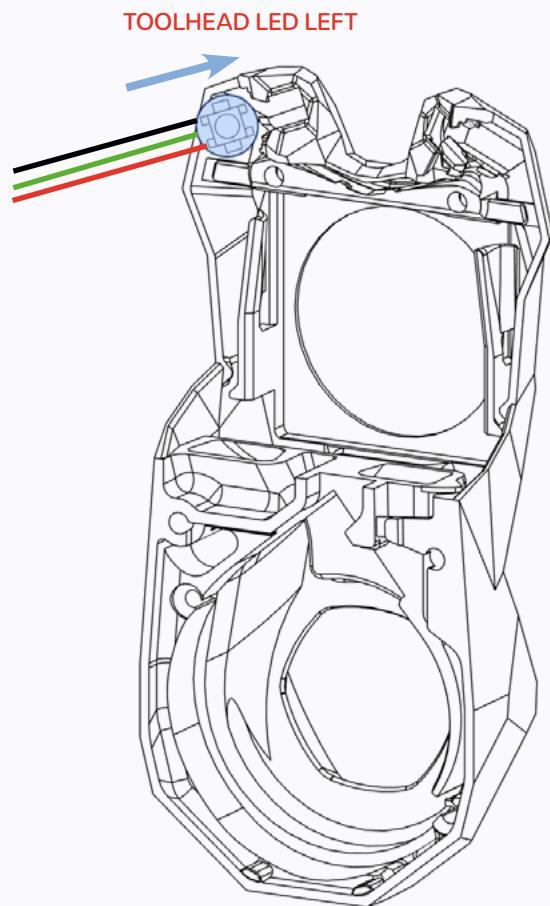
LED DIFFUSER AND MASK

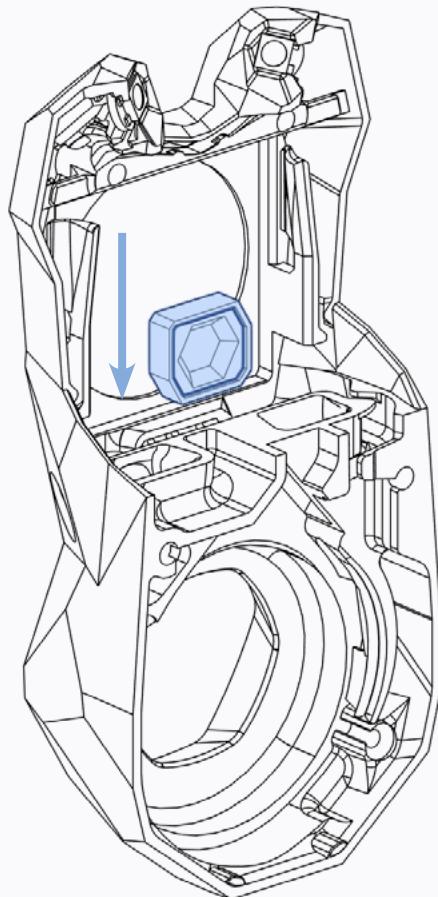
The diffuser (highlighted part) is printed in a translucent filament to evenly spread the light.

The mask (part to the left) is printed in an opaque filament to prevent the light from leaking, resulting in a crisp logo.

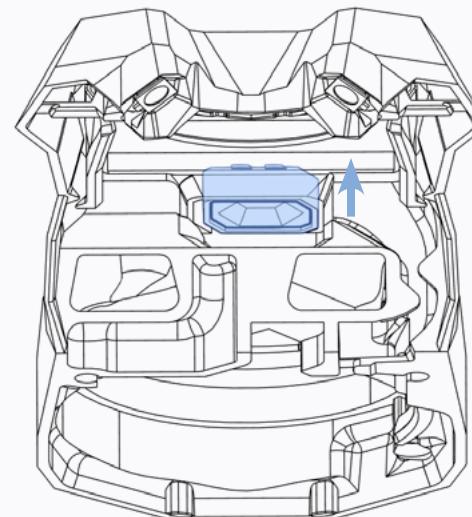
LEDS

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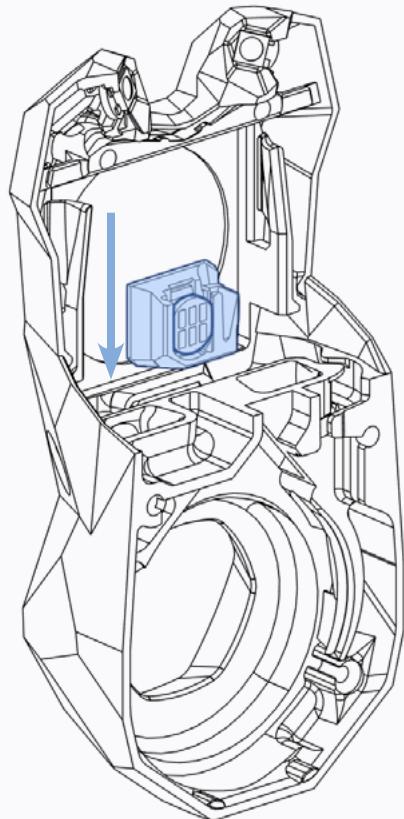
**DIFFUSER INSERTION**

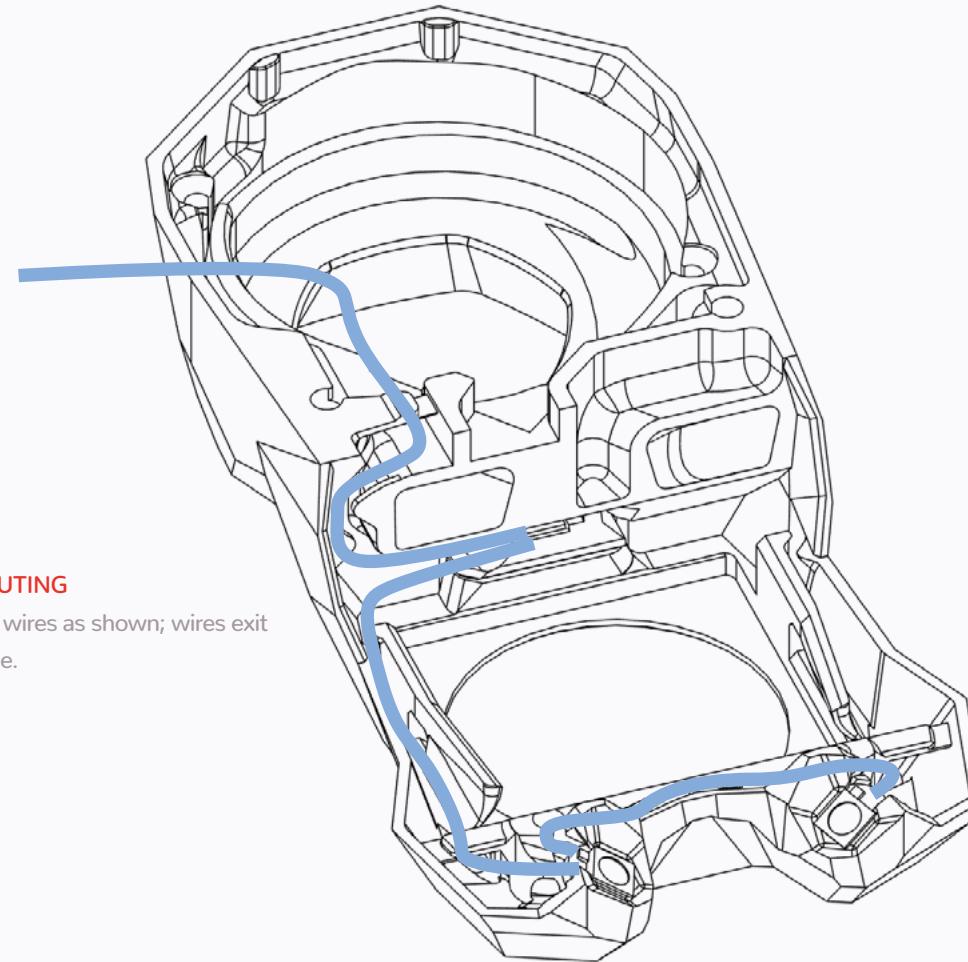
Insert the printed parts and push them towards the front.



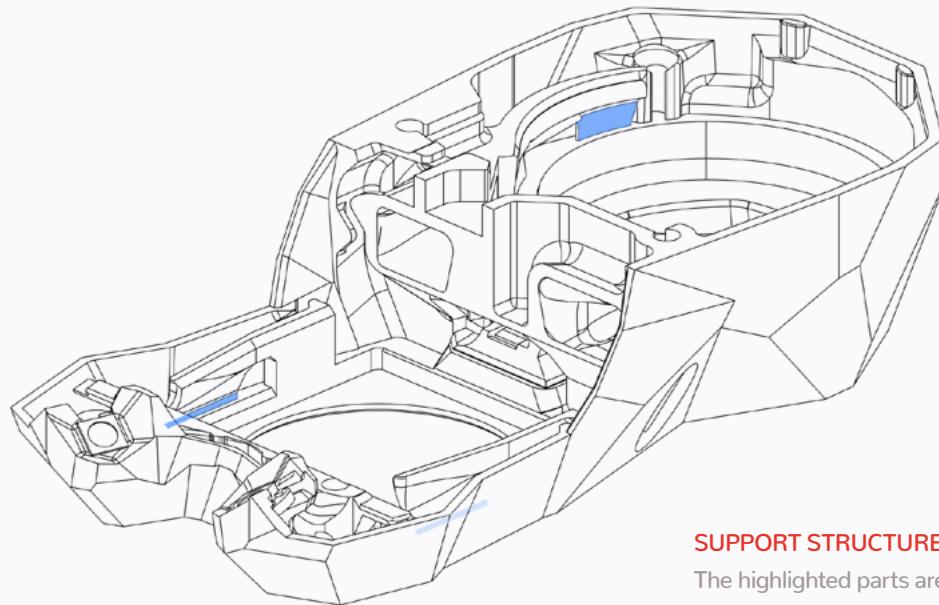
LEDS

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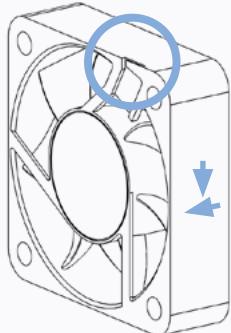
**LED WIRE ROUTING**

Route the LED wires as shown; wires exit on the right side.

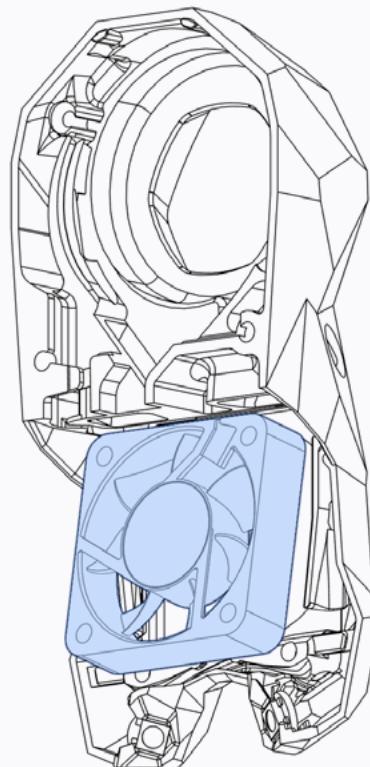


SUPPORT STRUCTURE

The highlighted parts are build-in support structures. They are designed to break during the fan installation.

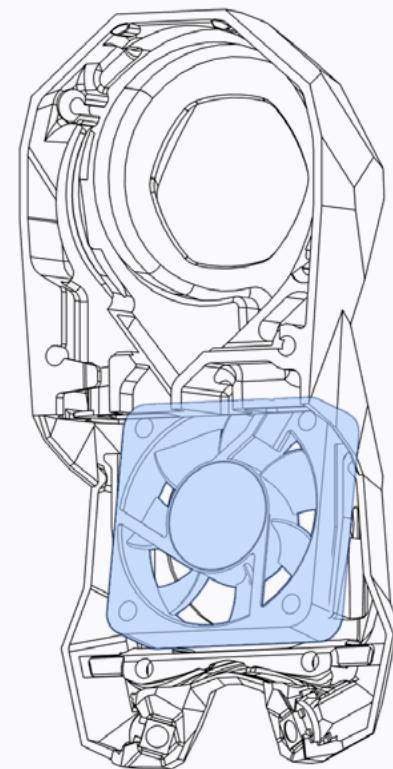
**FAN ORIENTATION**

Rotate the fan so that the wires exit on the top and the air is pushed "inwards".

**FAN INSERTION**

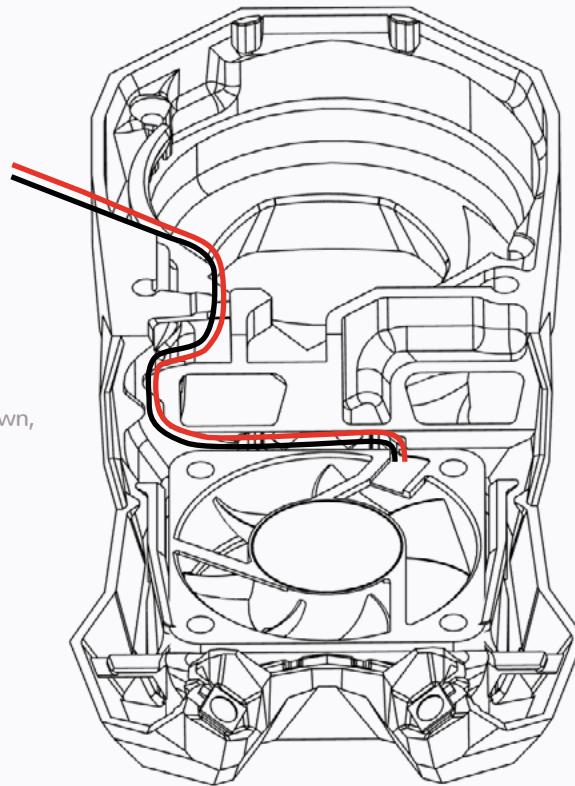
Insert the fan at a slight angle and clip it into place.

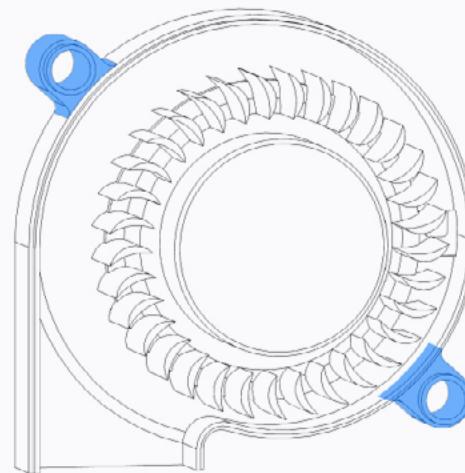
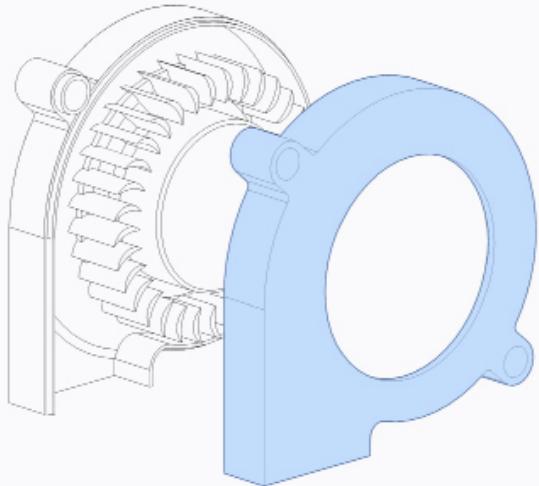
Mind the fan orientation.



FAN WIRE ROUTING

Route the fan wires as shown,
exiting on the right side





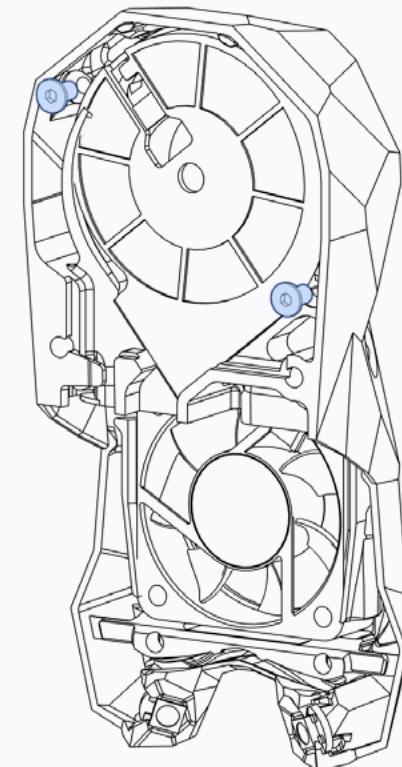
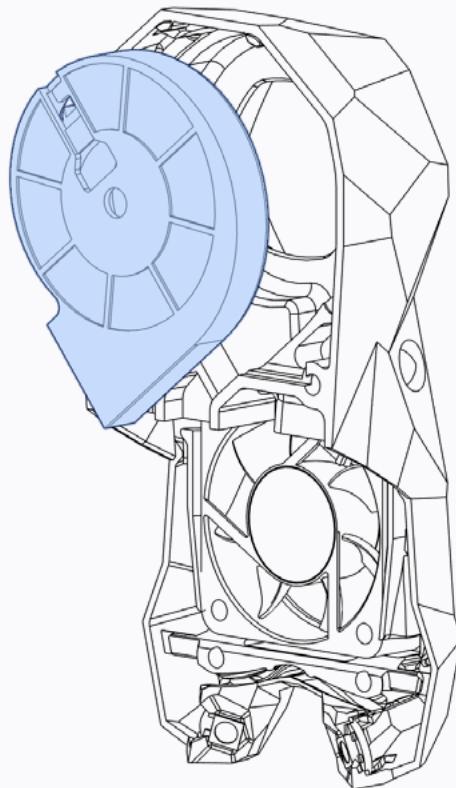
FAN PREPARATION

Remove the front of the 5015 fan. Clip off and file down the stock mounting ears.

There's a trimming jig STL included in the release to make this task easier.

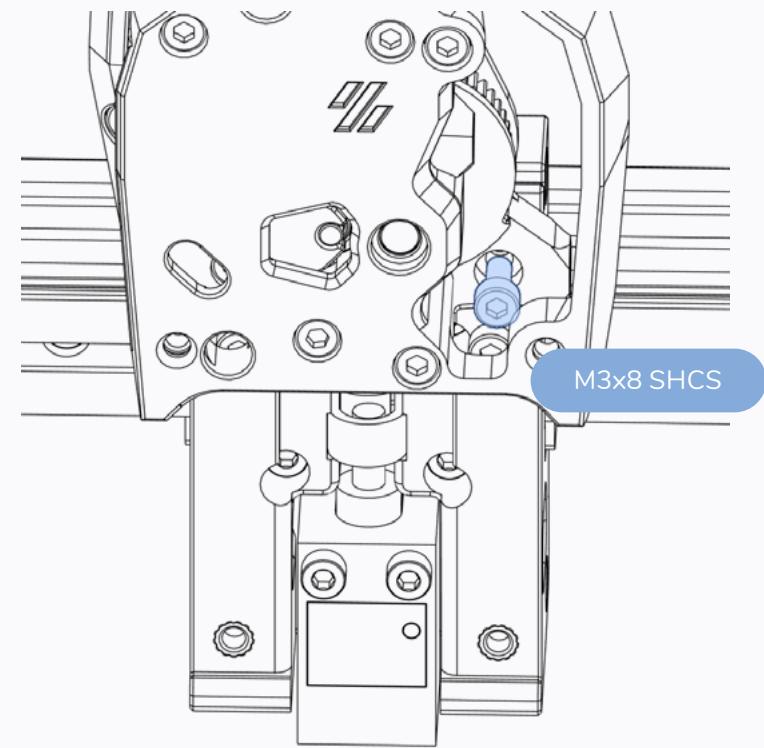
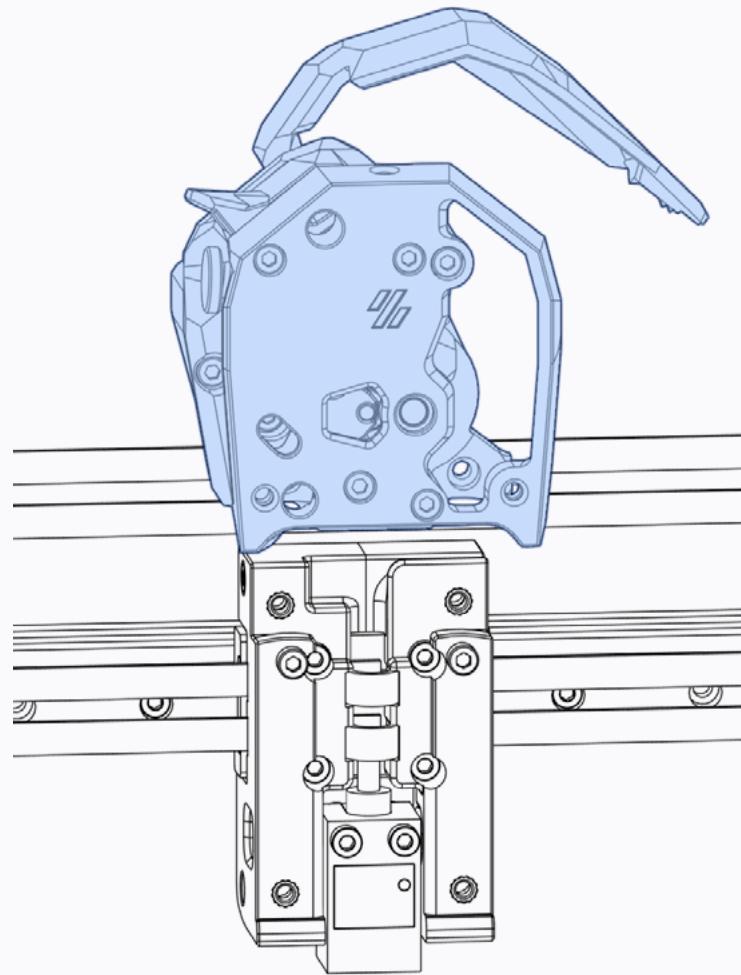
PART COOLING FAN

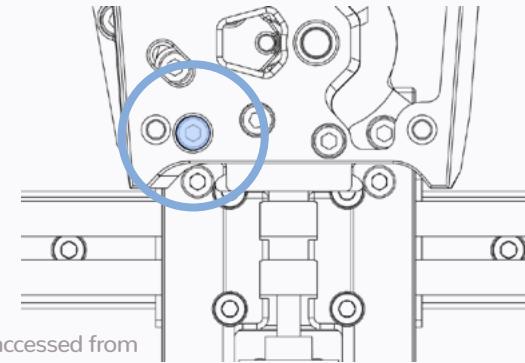
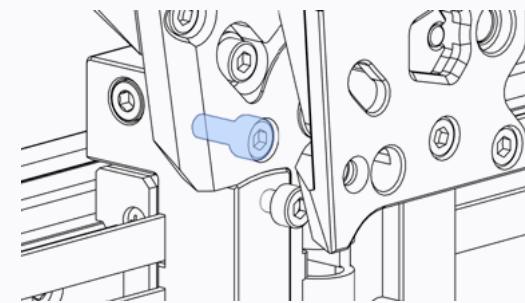
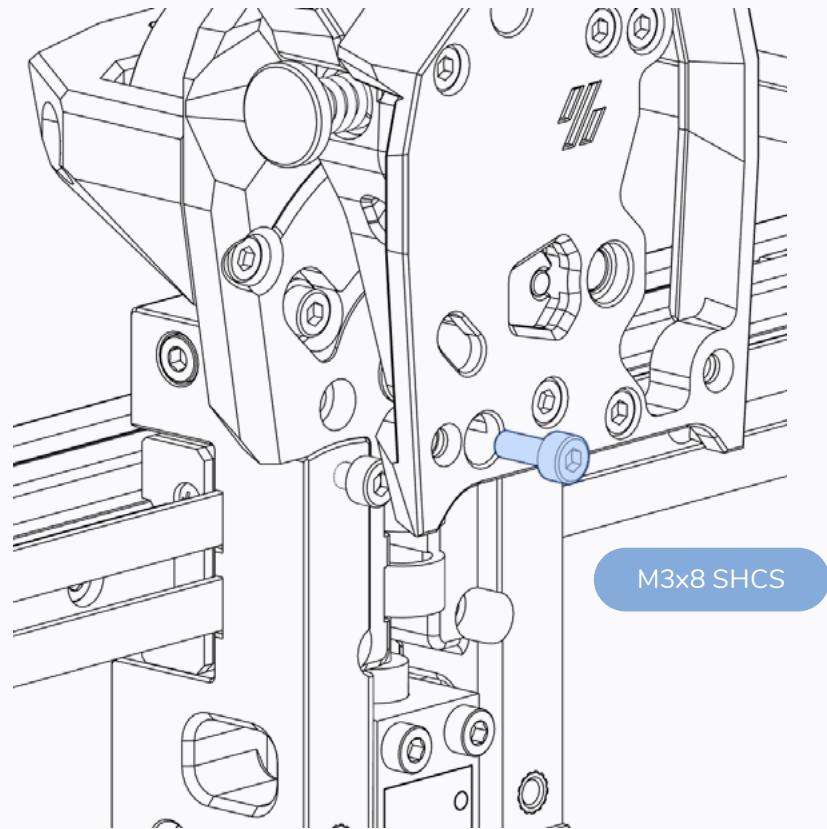
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CW2 MOUNTING

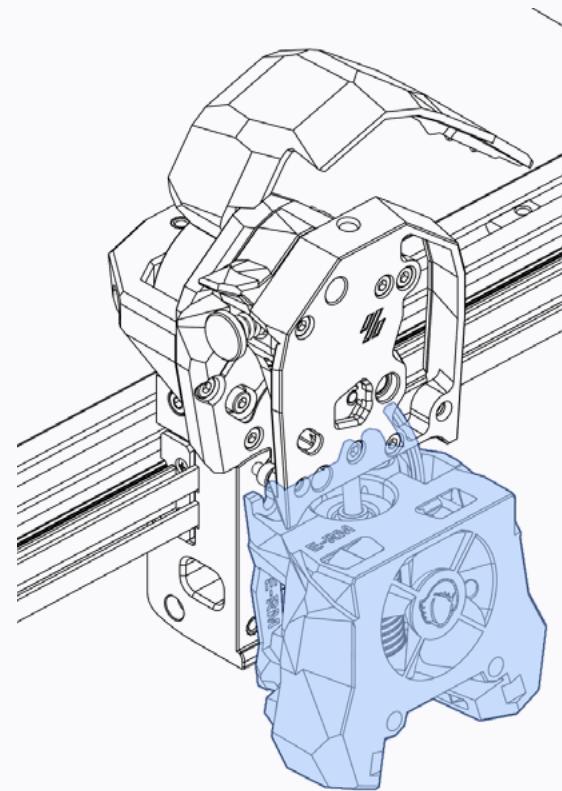
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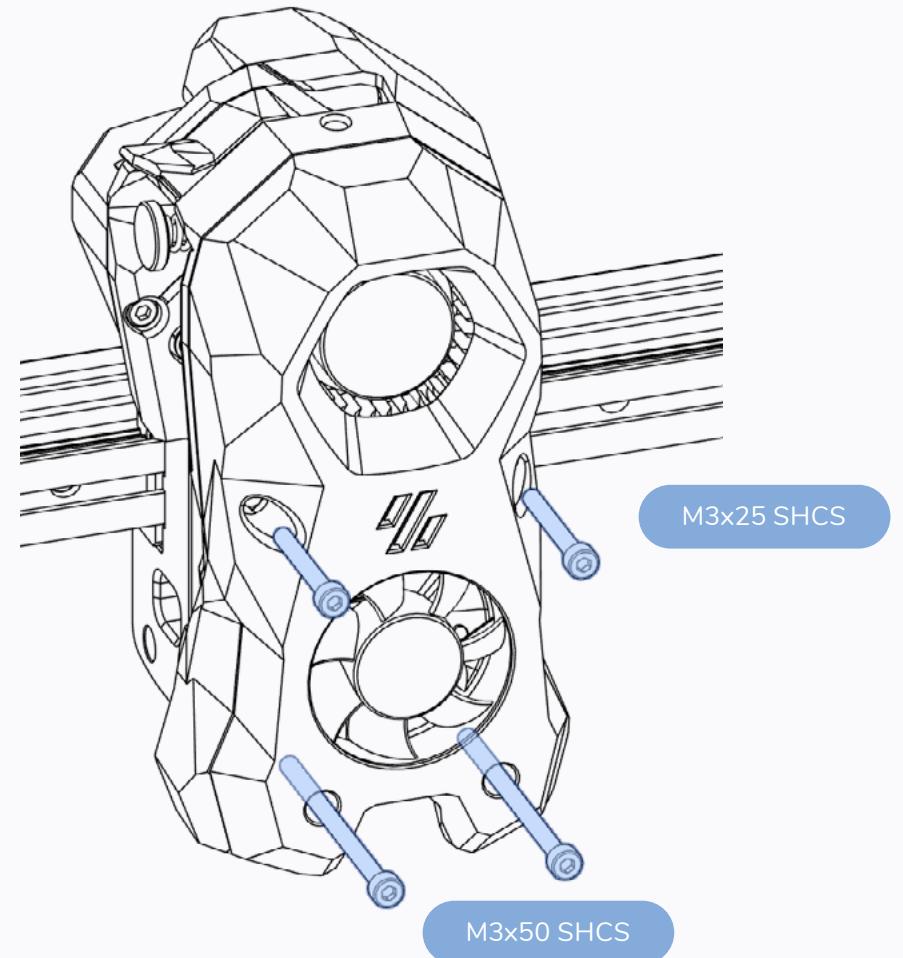
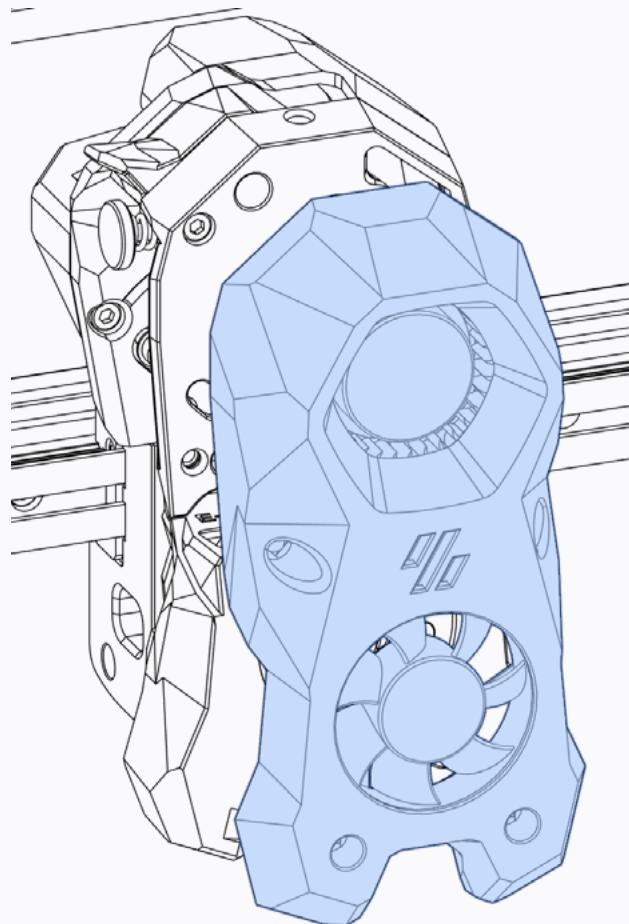
TOOL CARTRIDGE MOUNTING

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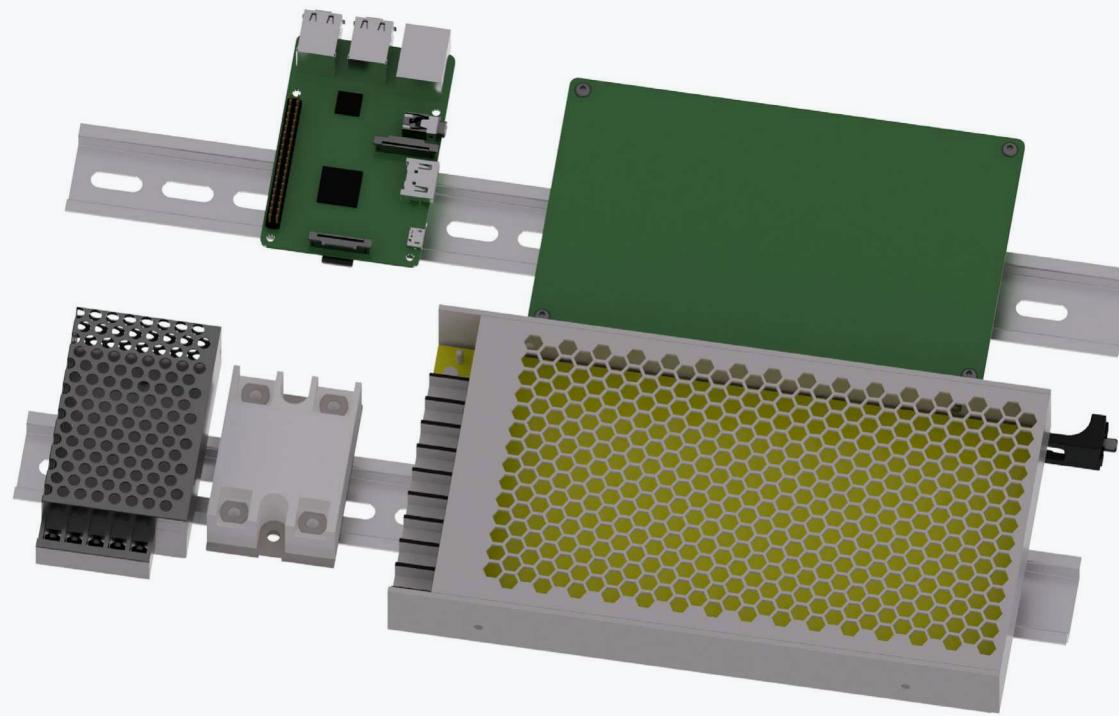


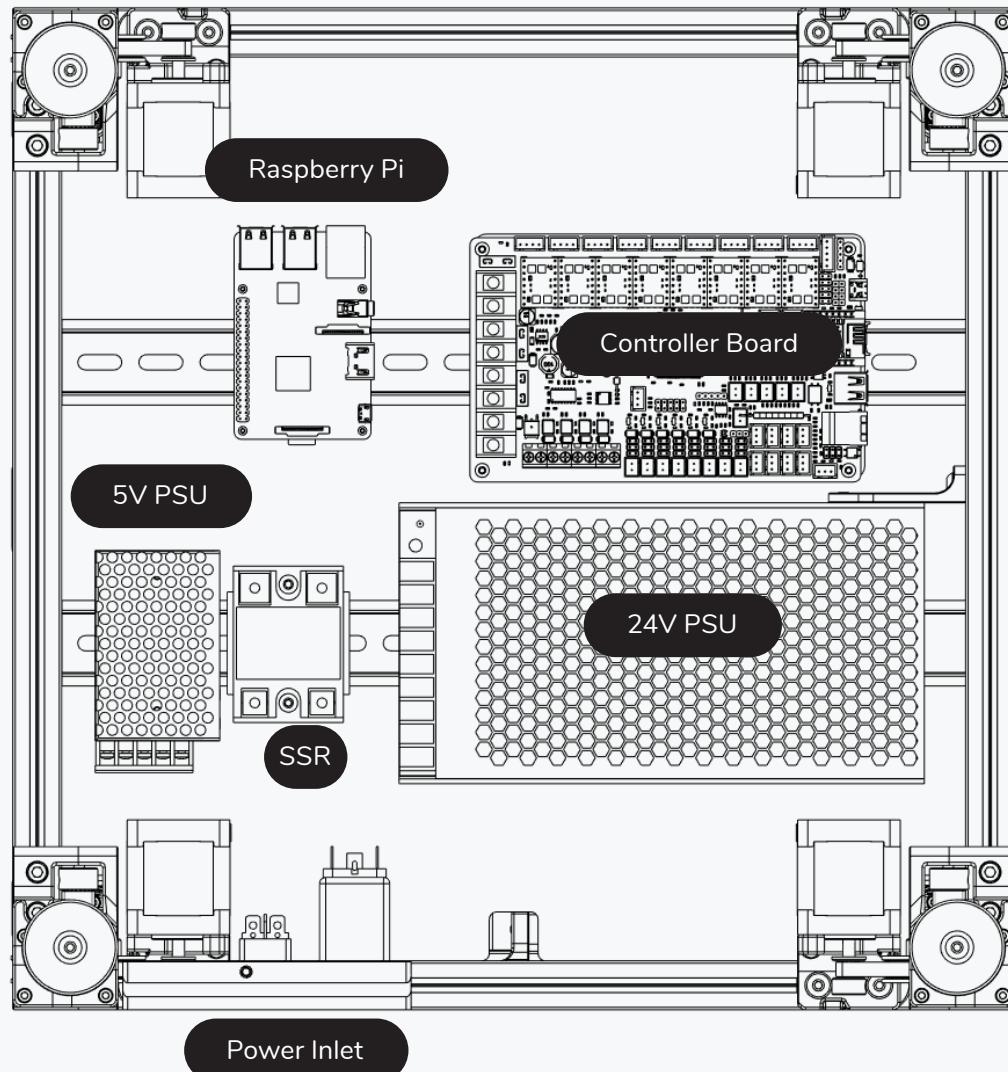
SB MOUNTING

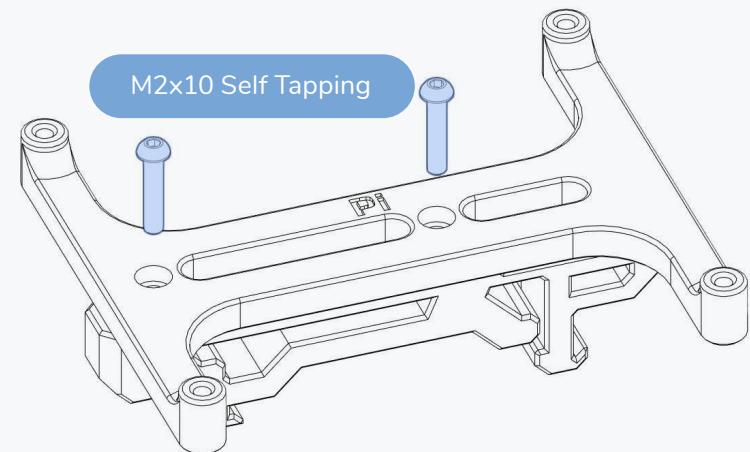
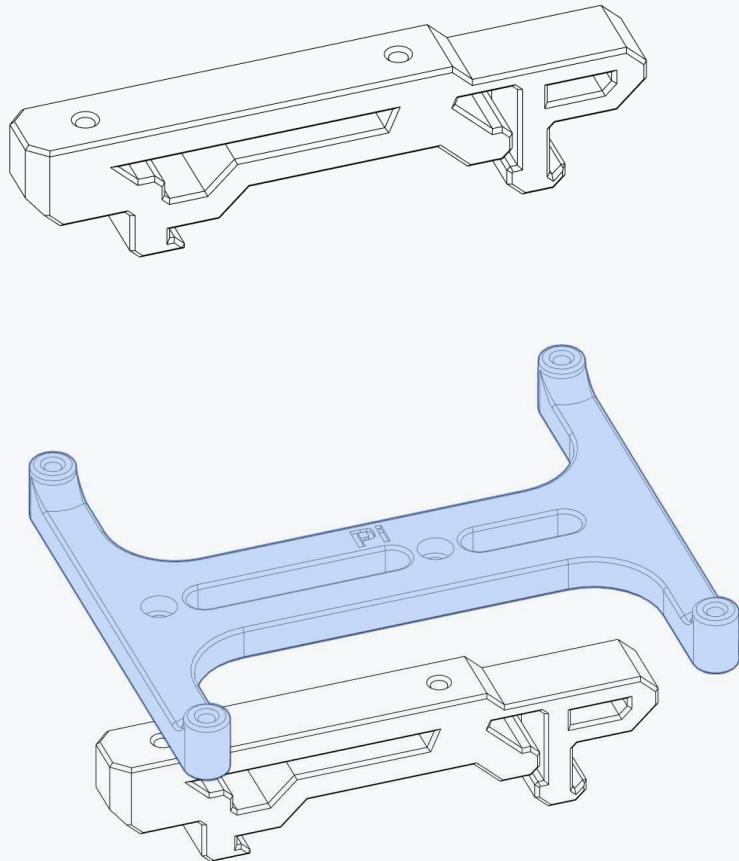
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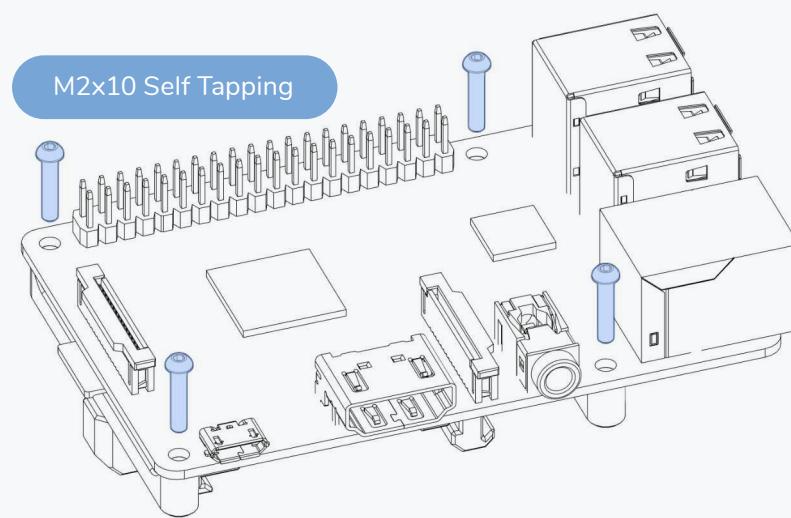
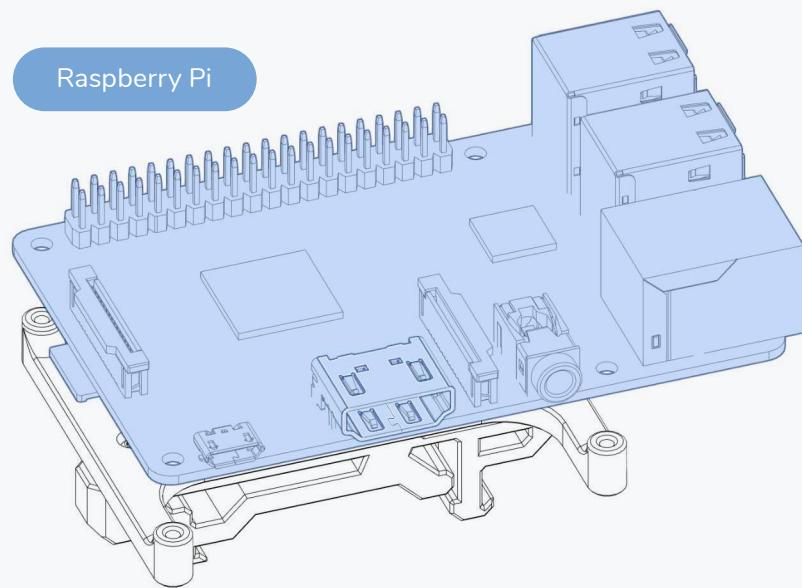


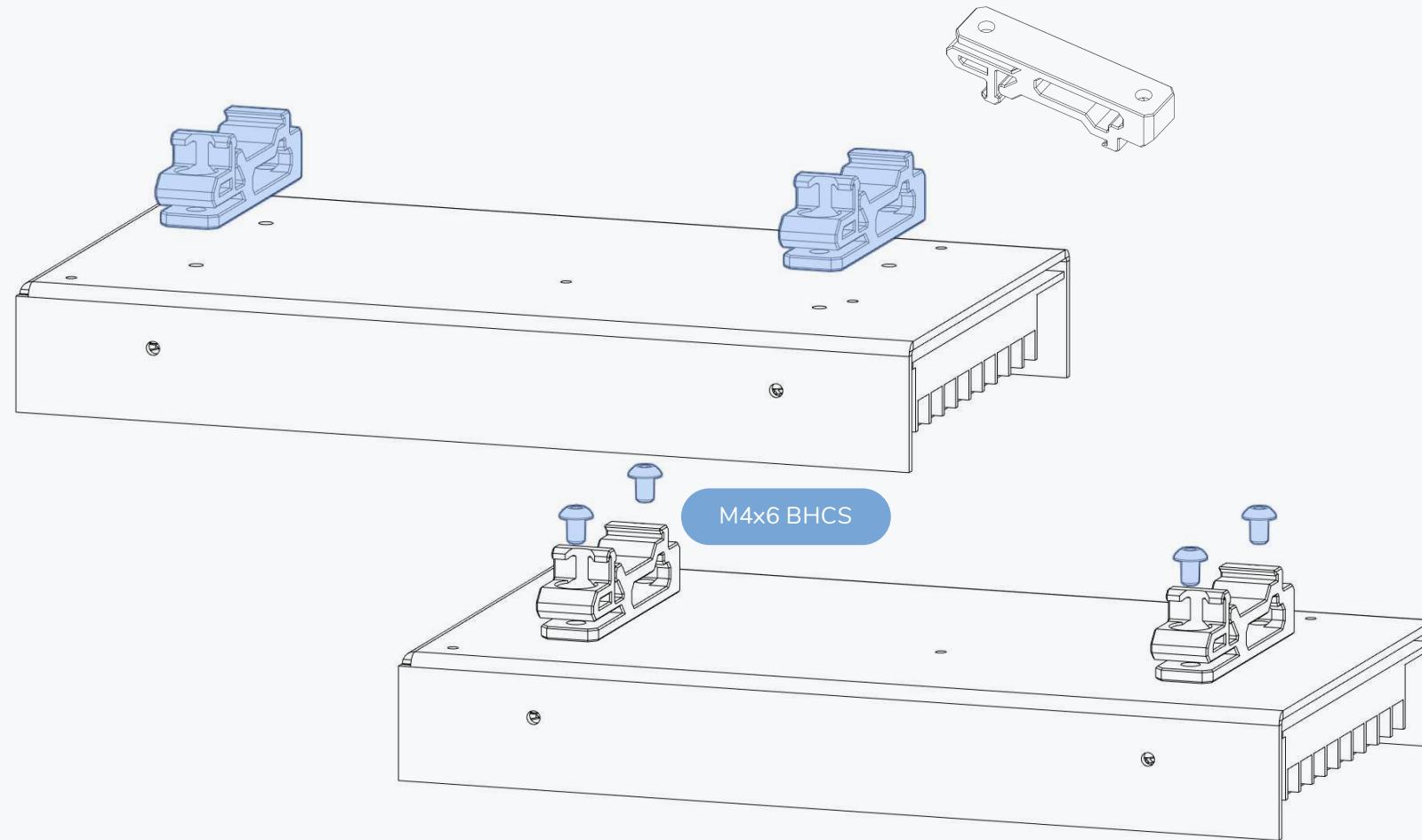
Yeah, it went about as expected.

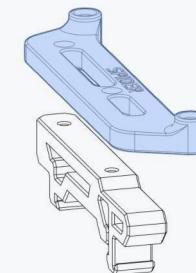
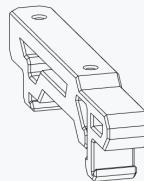
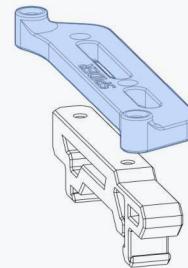
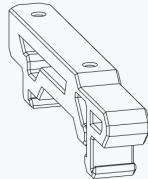








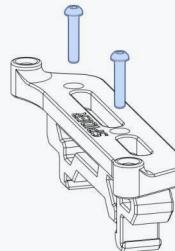




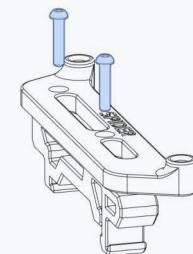
AVAILABLE MOUNTS

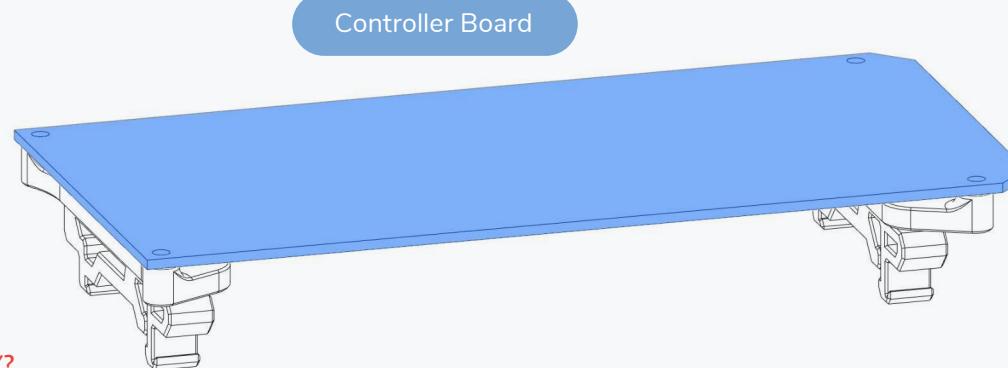
We also provide mounts for other controller boards.

They are assembled in a similar manner.

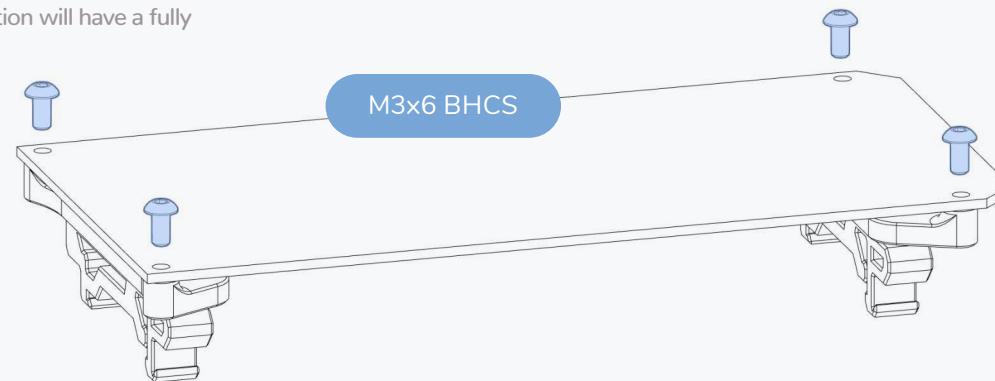


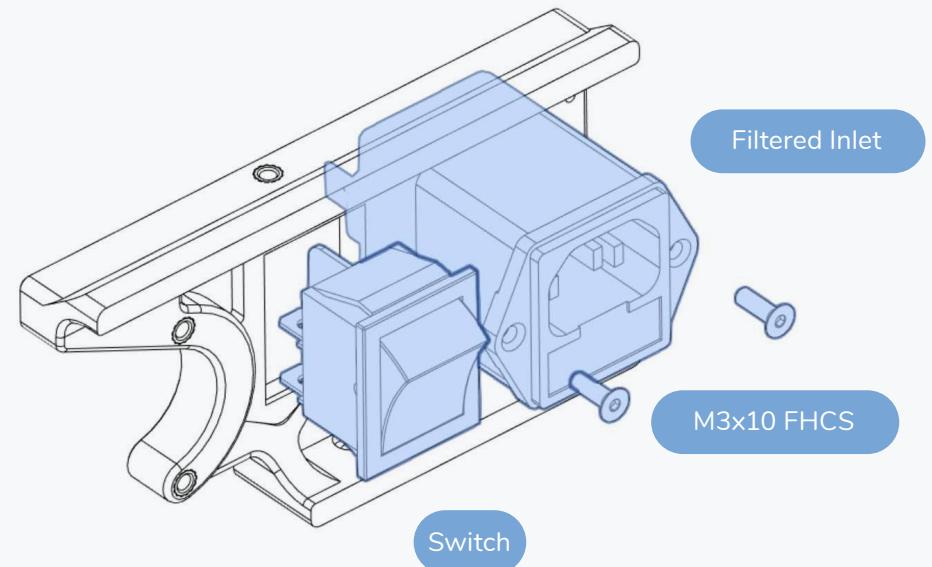
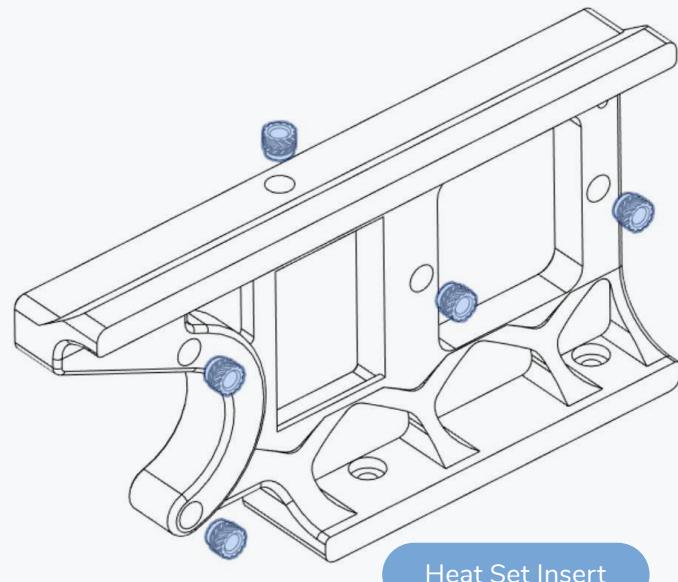
M2x10 Self Tapping

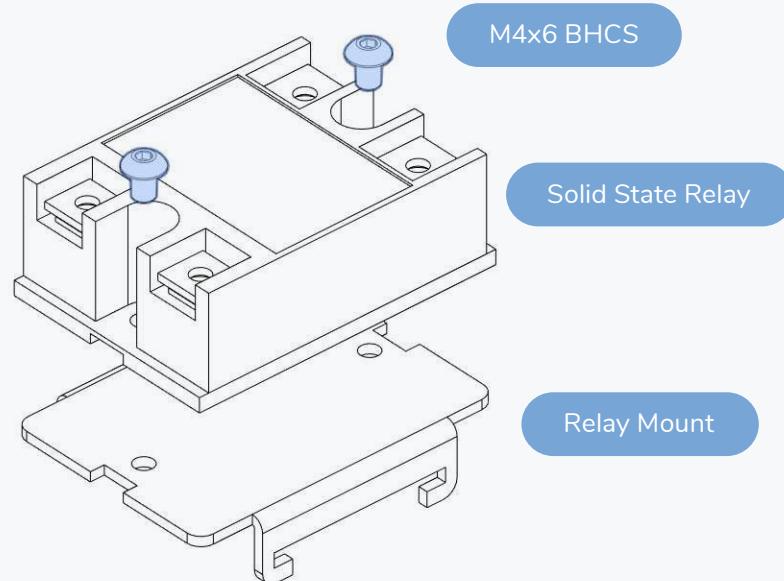


**WHY DOES IT LOOK THAT WAY?**

We used a dummy to keep the file size of the printers CAD manageable. The wiring section will have a fully featured image.



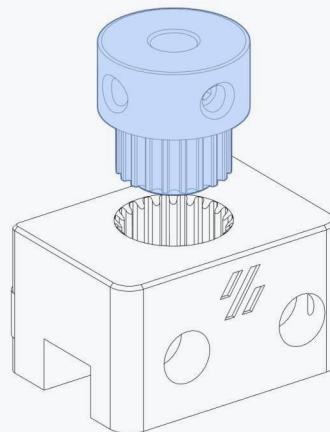


**WHERE CAN I FIND THE RELAY MOUNT?**

The SSR mount is an off the shelf part. Look for a metal bracket in your pile of parts.
There is no printed mount.

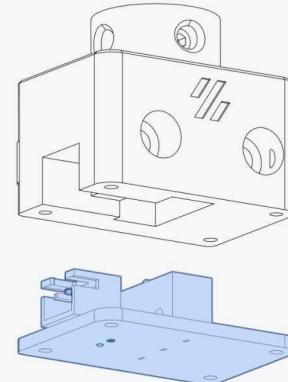
OPTION: Z ENDSTOP BOARD

GT2 20 Tooth Pulley

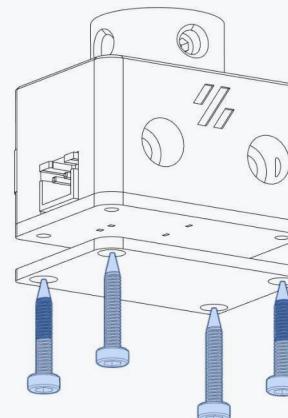


PRESS FIT

Apply the required force to fully seat the pulley in the printed part.

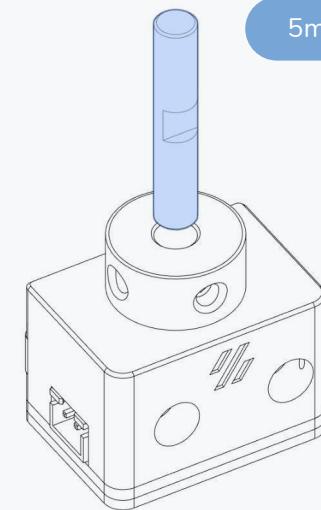


Microswitch Z Endstop Board



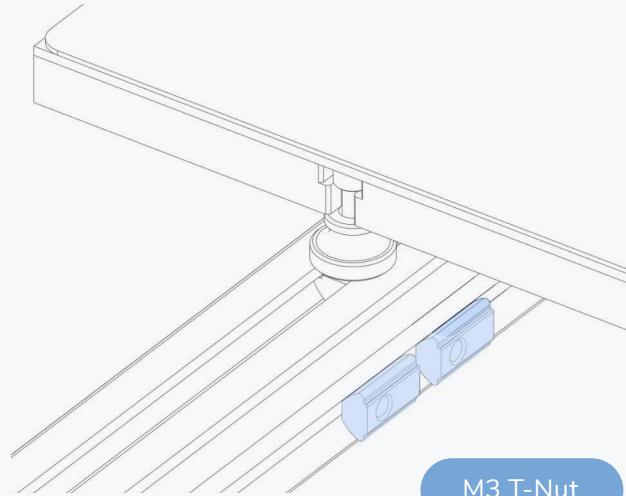
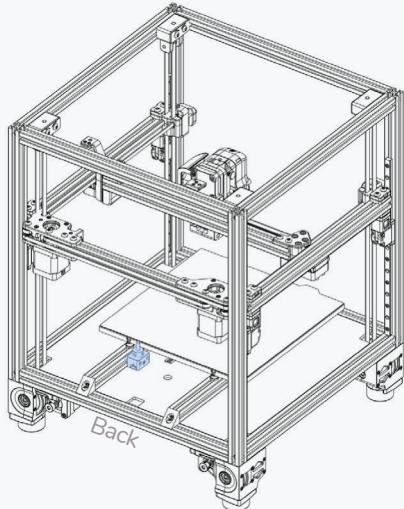
M2x10 Self Tapping

5mm Shaft

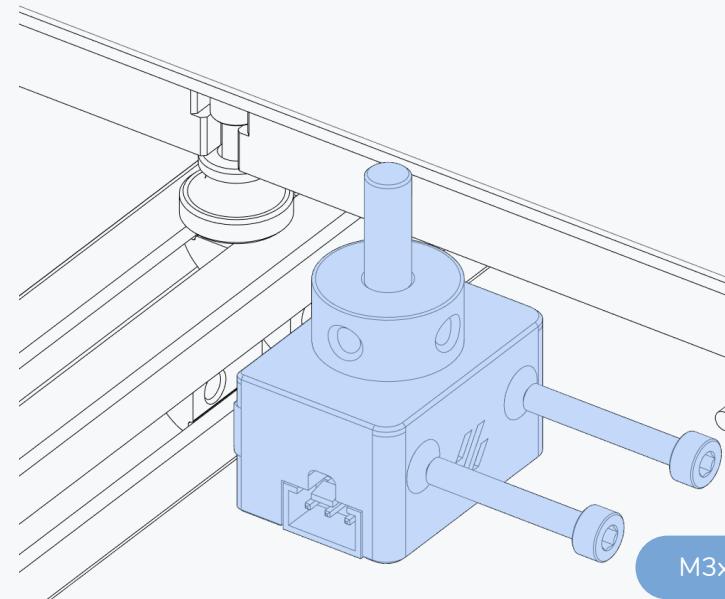


ADDITIONAL INFORMATION

Visit voron.link/3bwwnqy for design files and BOM.



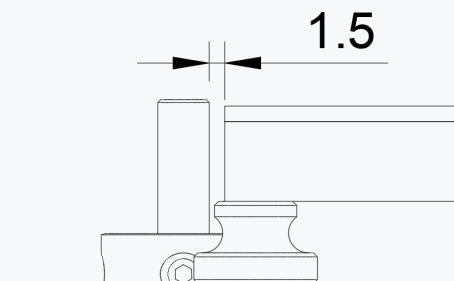
M3 T-Nut



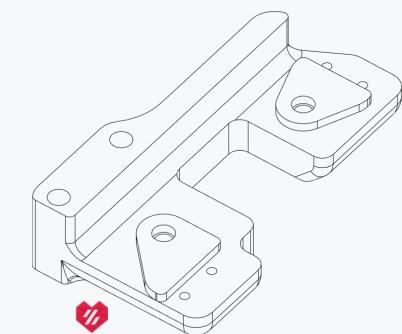
M3x20 SHCS

ADJUST Z ENDSTOP POSITION

The shaft of the Z Endstop must not touch the print bed.
Adjust the position if required.

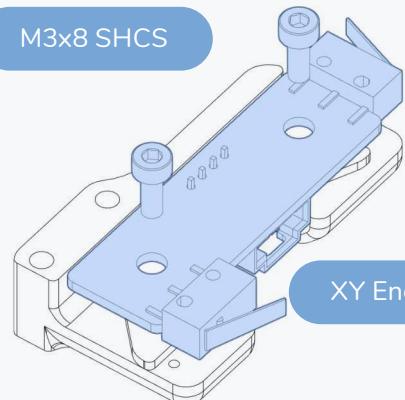


OPTION: XY ENDSTOP BOARD

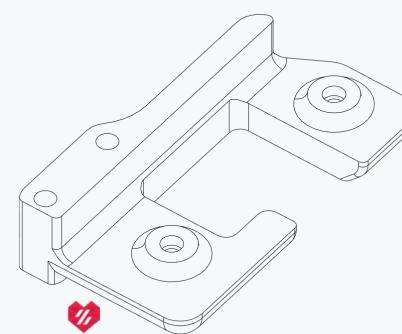


M3x8 SHCS

XY Endstop Board

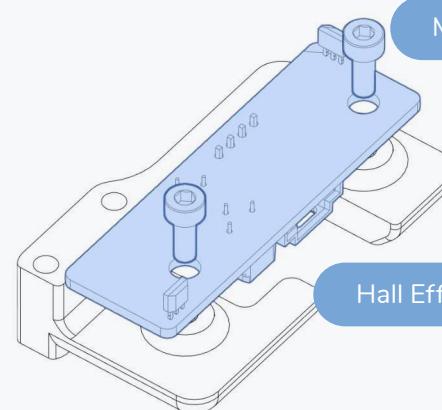


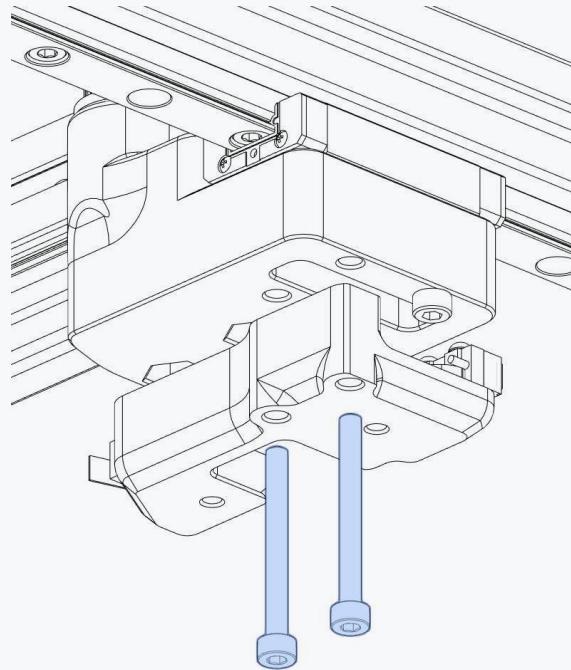
OPTION: HALL EFFECT ENDSTOP BOARD



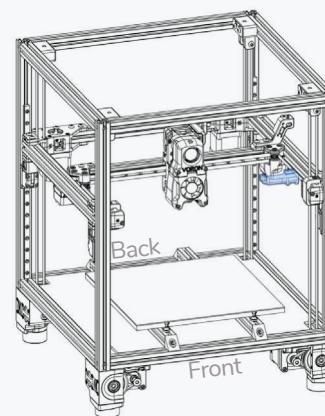
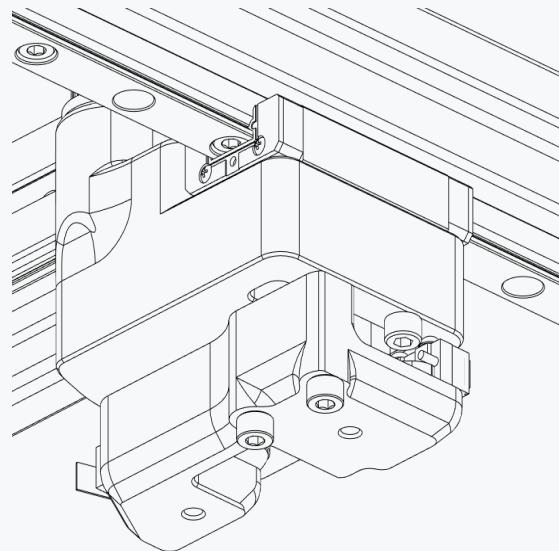
M3x8 SHCS

Hall Effect Endstop Board





M3x30 SHCS

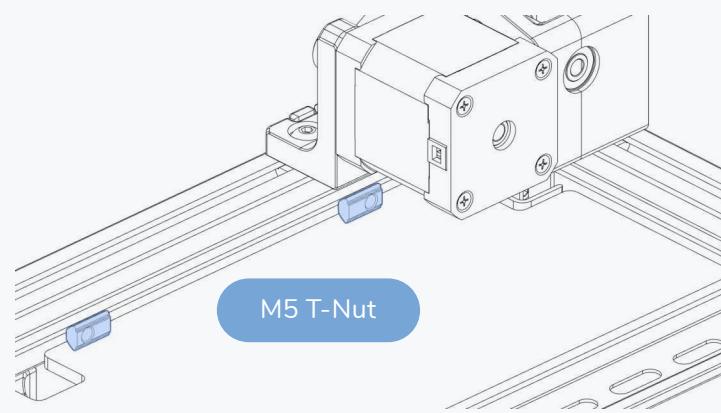


ALTERNATE MAINS DISTRIBUTION - WAGO

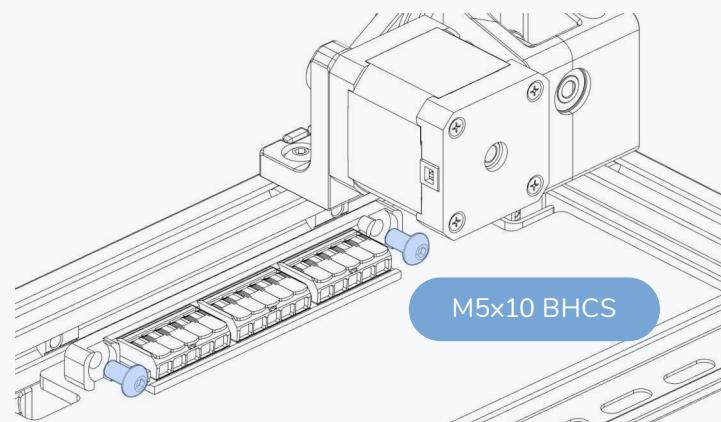
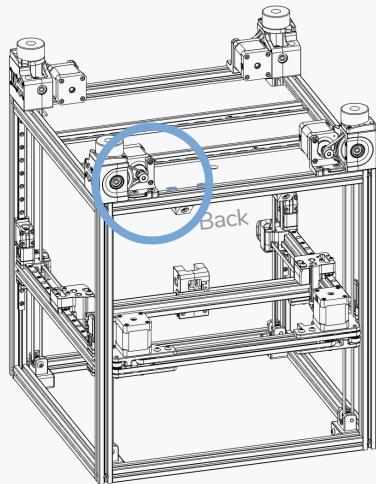
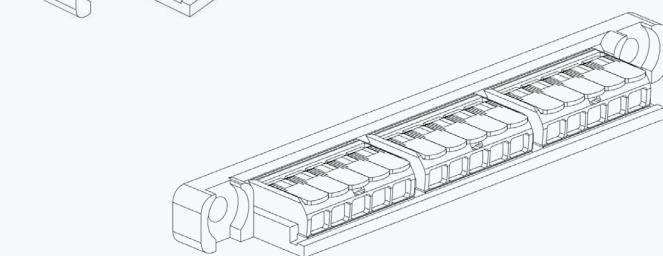
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WAGO 221 415 Clamps



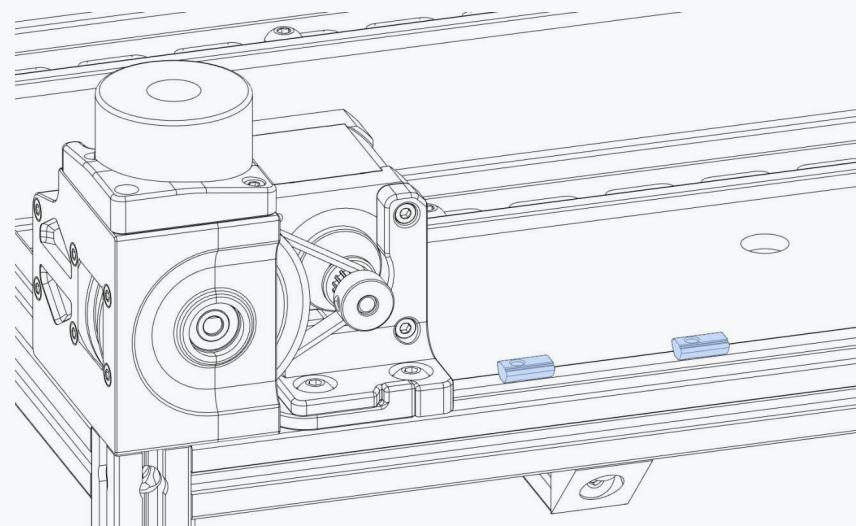
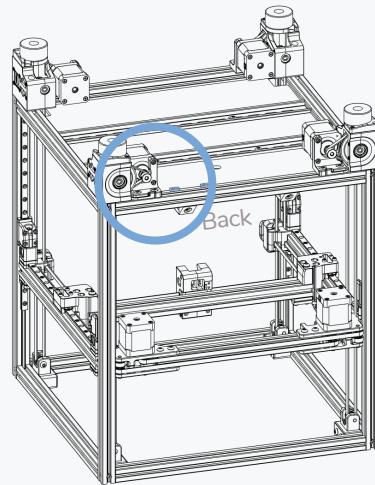
M5 T-Nut



M5x10 BHCS

UPSIDE DOWN ASSEMBLY

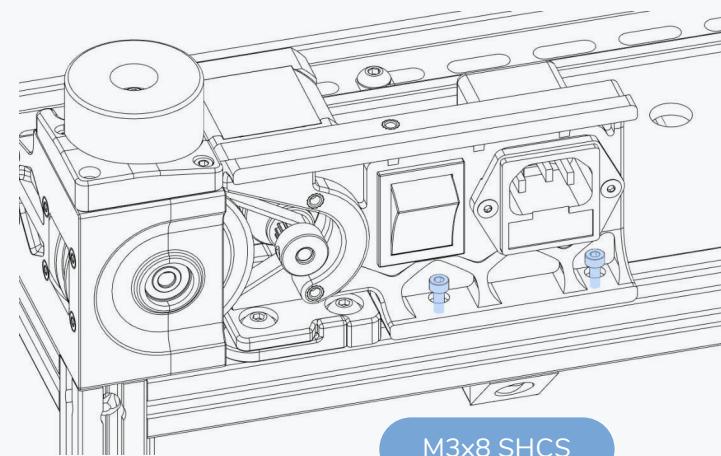
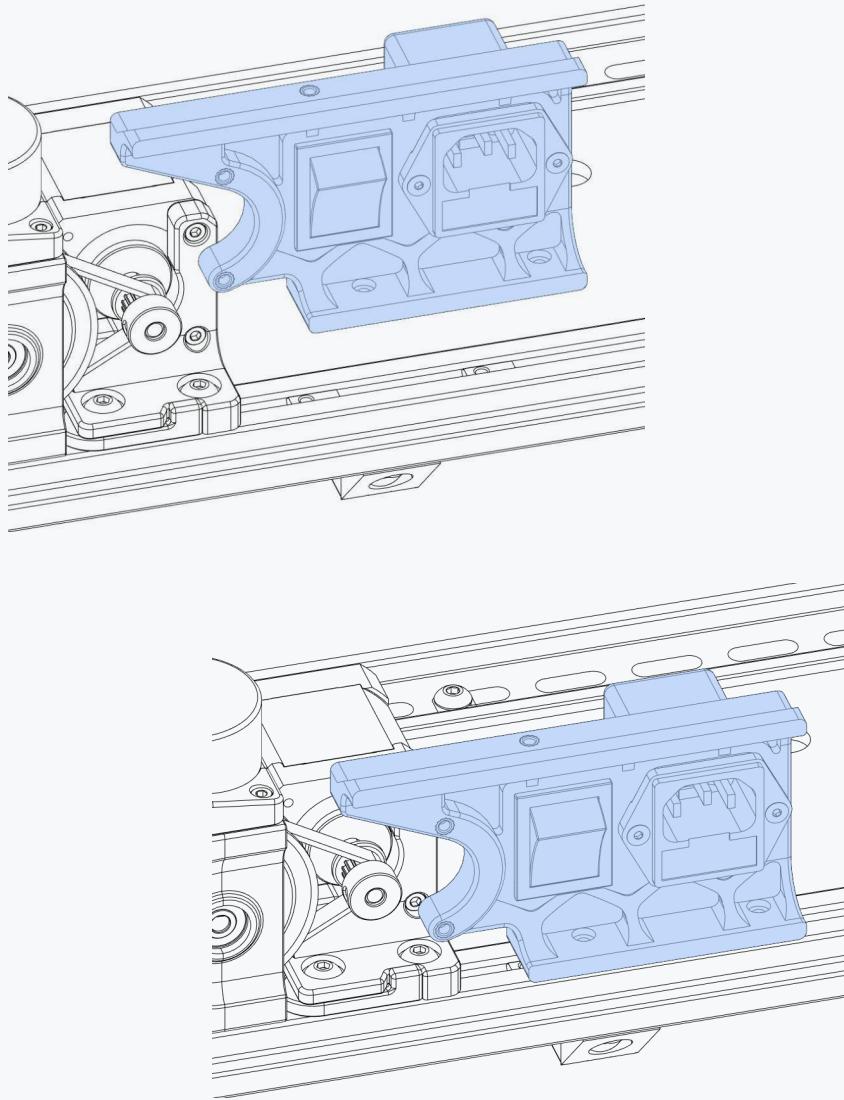
For ease of assembly we recommend to flip the printer on its head for the next steps. Hope you don't regret building a 350.

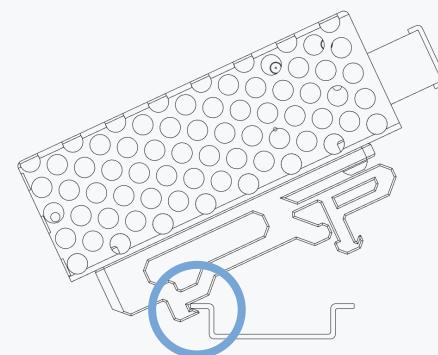
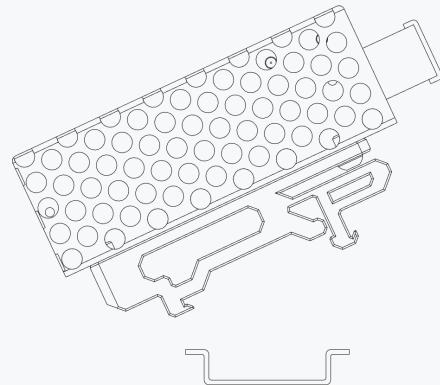


M3 T-Nut

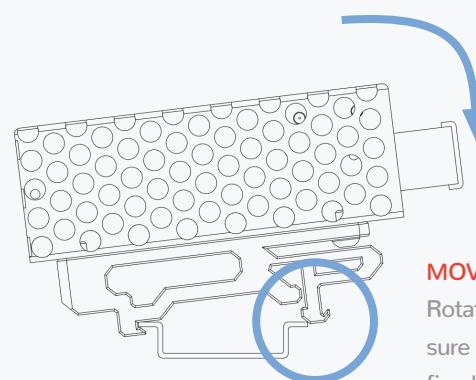
POWER INLET

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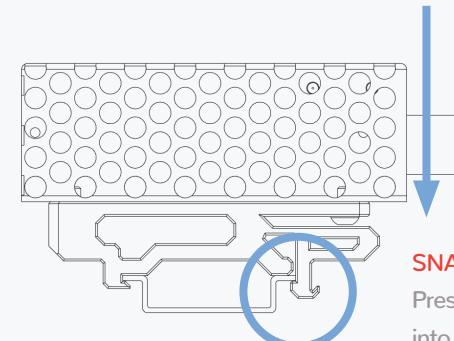


**HOOK FIXED SIDE**

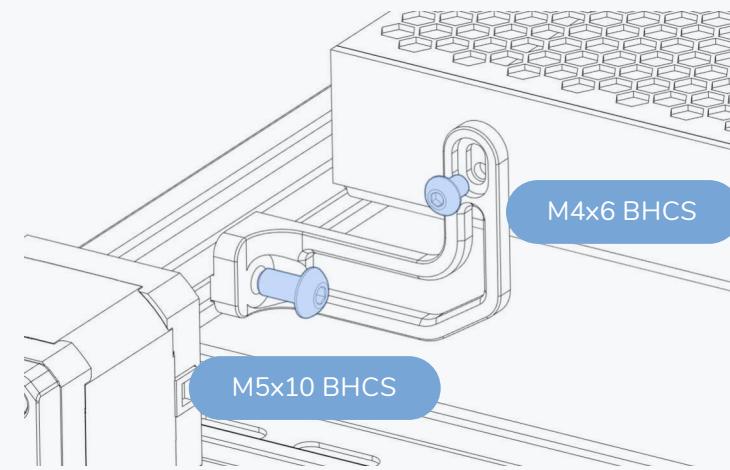
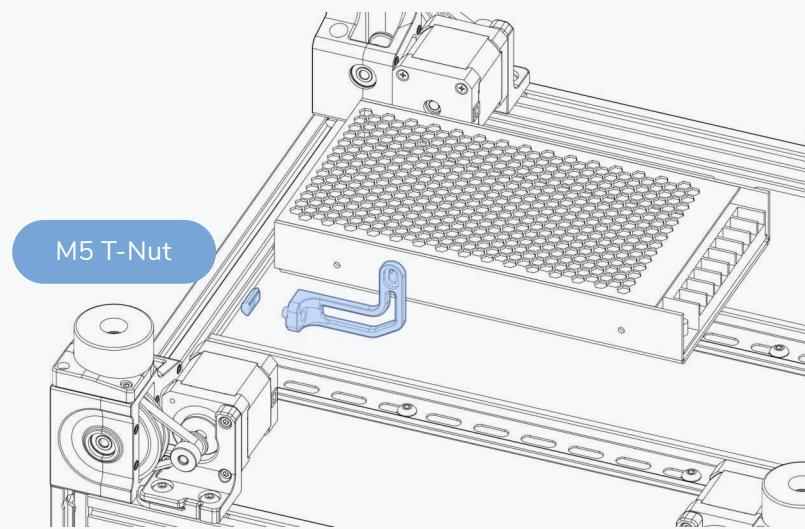
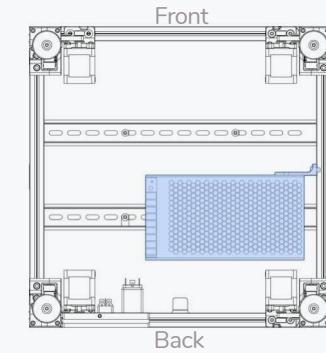
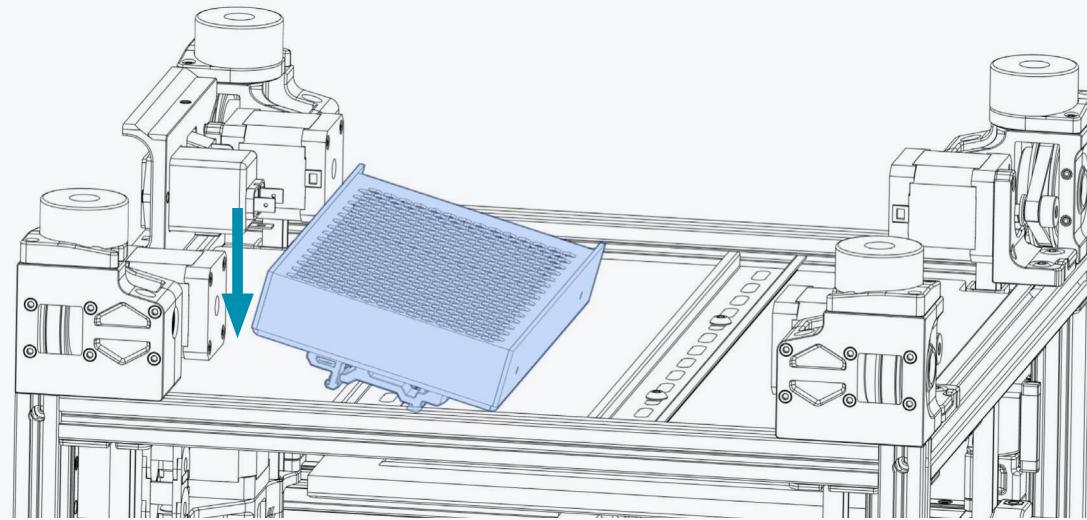
Hook the fixed side of the printed mount on side of DIN rail.

**MOVE INTO POSITION**

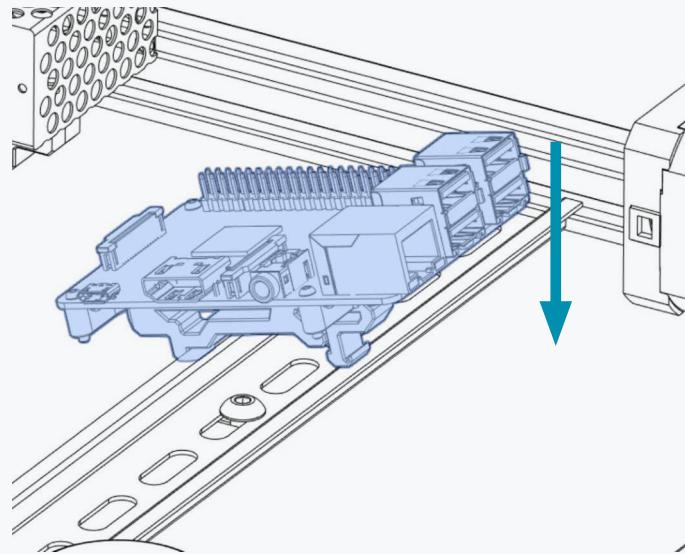
Rotate the part into place, make sure it does not unhook from the fixed side.

**SNAP INTO PLACE**

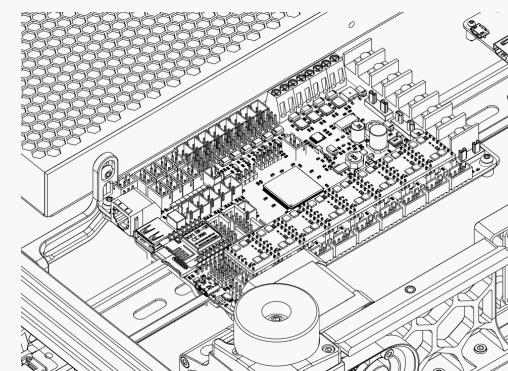
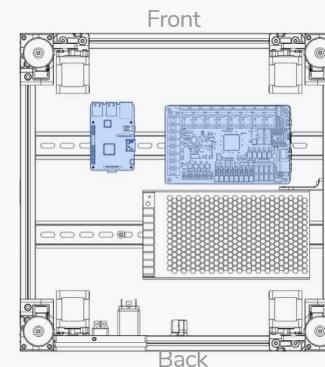
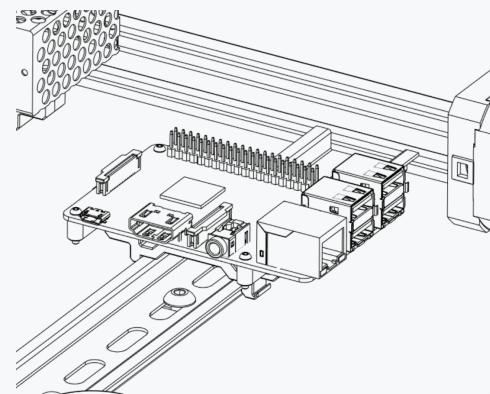
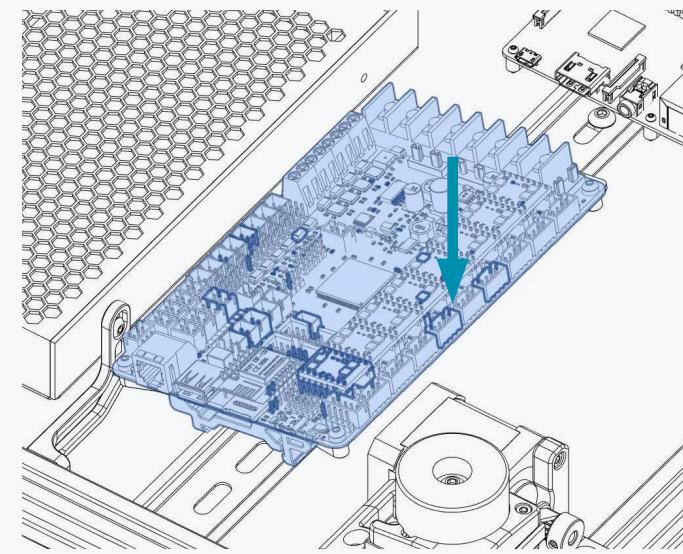
Press to snap the free side into place. The part should now sit securely on the DIN rail.



PI & CONTROLLER

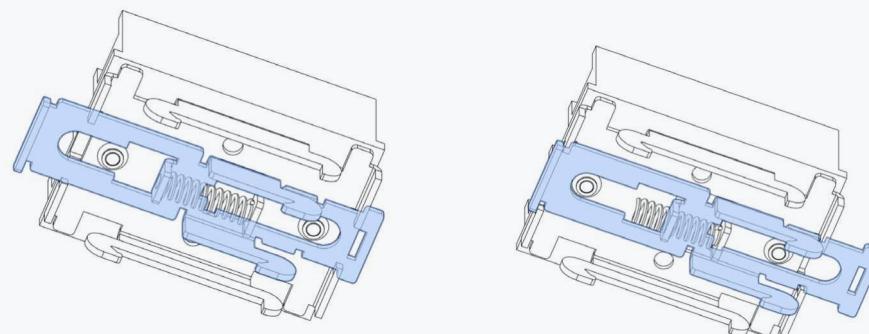
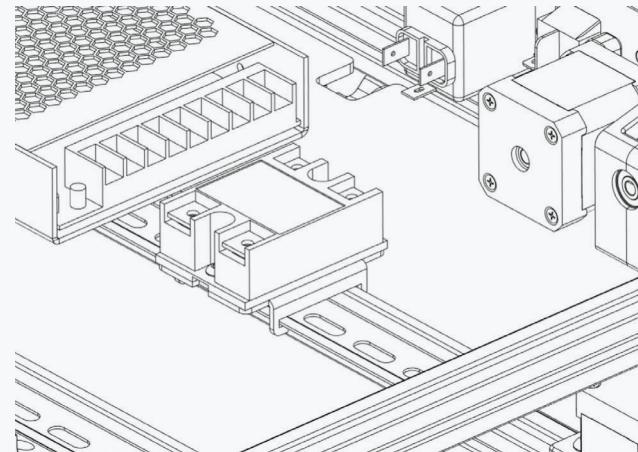
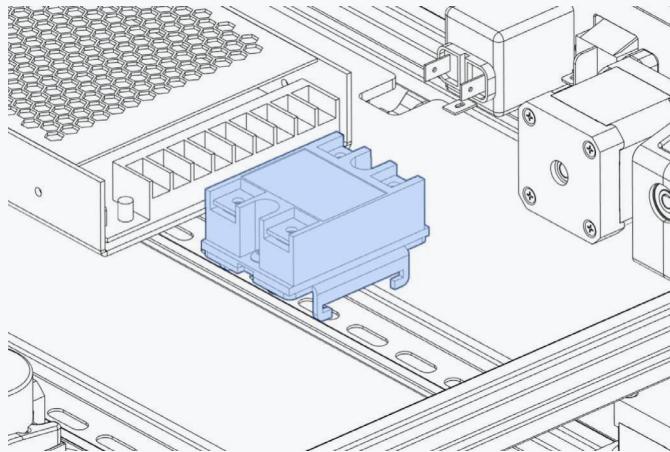


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SOLID STATE RELAY

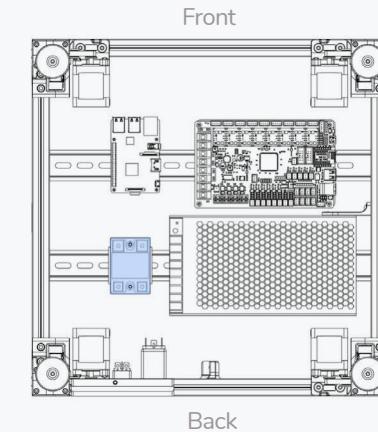
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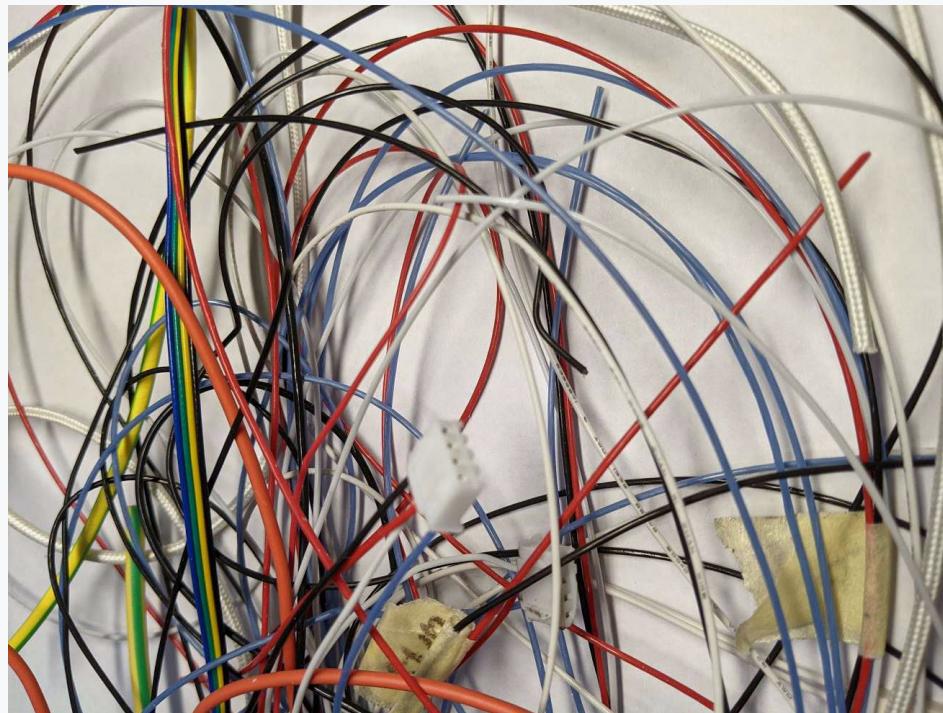
SPRING-LOADED

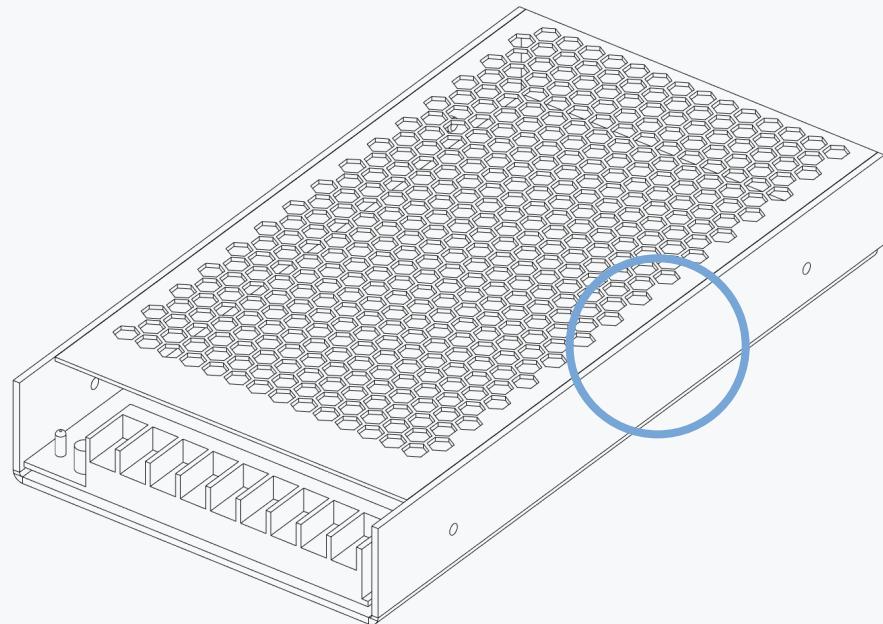
Use a flat head screw driver to pull the latch open. It will lock open.

Be careful when releasing the latch, it will snap back into place. Mind your fingers.



By Feburary 2019 over 100 Voron2 printers had been built and serialized.

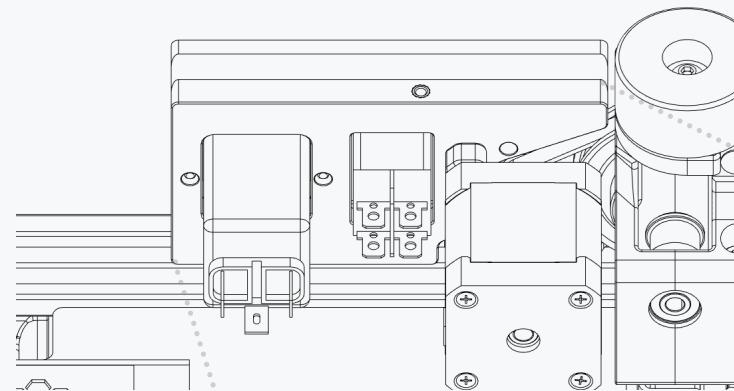


**INPUT VOLTAGE SWITCH**

Check the input voltage switch of the power supply. It is located in the highlighted area.

Make sure the selection matches your local mains voltage. Refer to the Mean Well LRS-200 datasheet for possible settings (voron.link/e0szdyh).

POWER INLET



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ATTACH 250MM OF WIRE

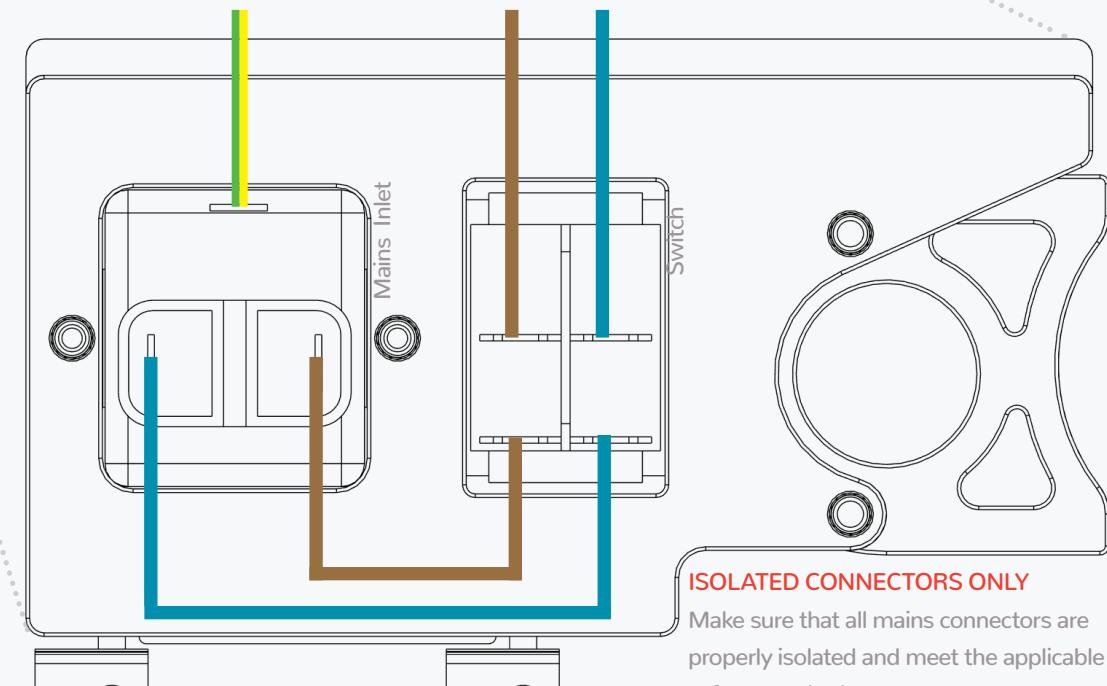
Cables should be at least 1mm² (AWG18) or thicker depending on local regulations.

MAINS INLET WIRING

We show the wiring in the IEC colour scheme. Depending on your region the colour scheme and wiring standards will differ.

Mains wiring should only be done by qualified personnel trained in local regulations and safety standards. Depending on your local regulations you may be forbidden from wiring the mains side and/or putting the printer into operation; seek professional assistance.

Failure to observe those could result in bodily harm.



ISOLATED CONNECTORS ONLY

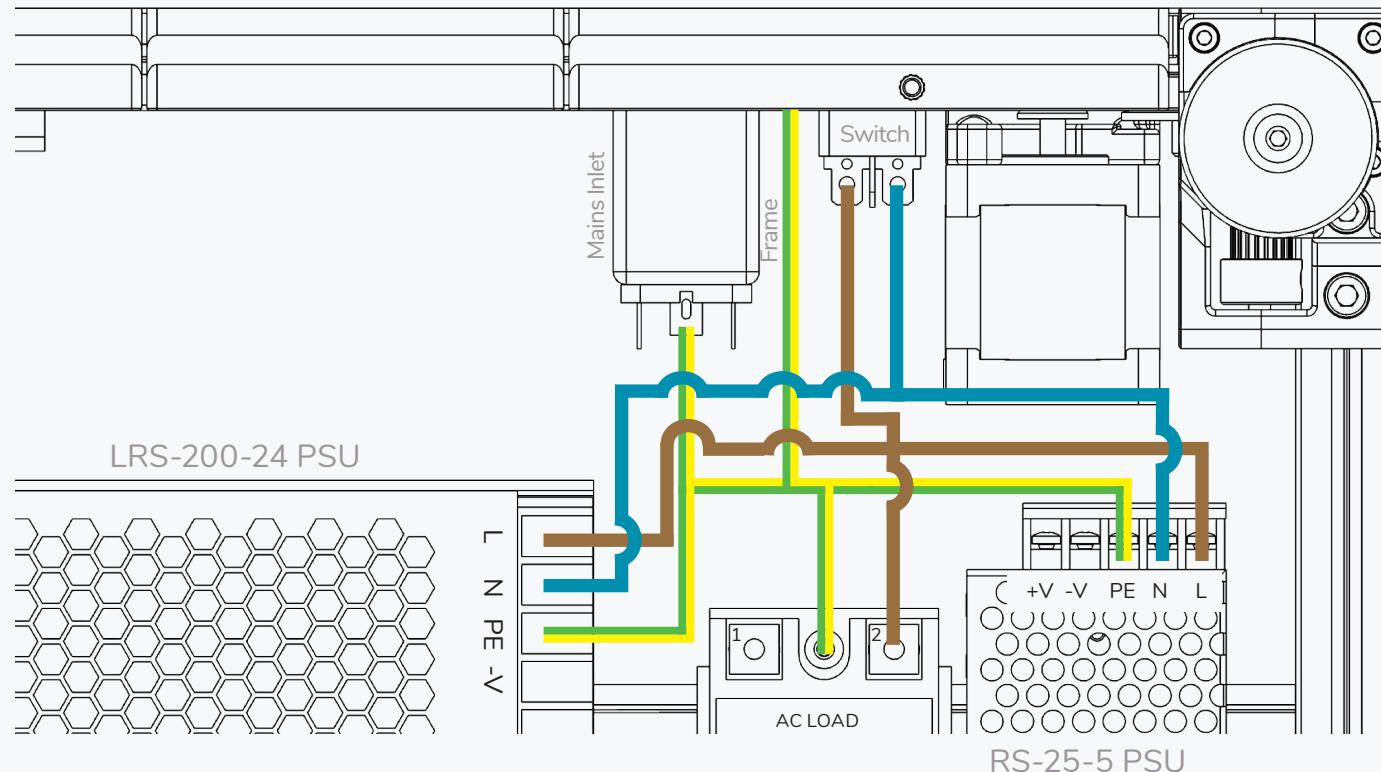
Make sure that all mains connectors are properly isolated and meet the applicable safety standards.

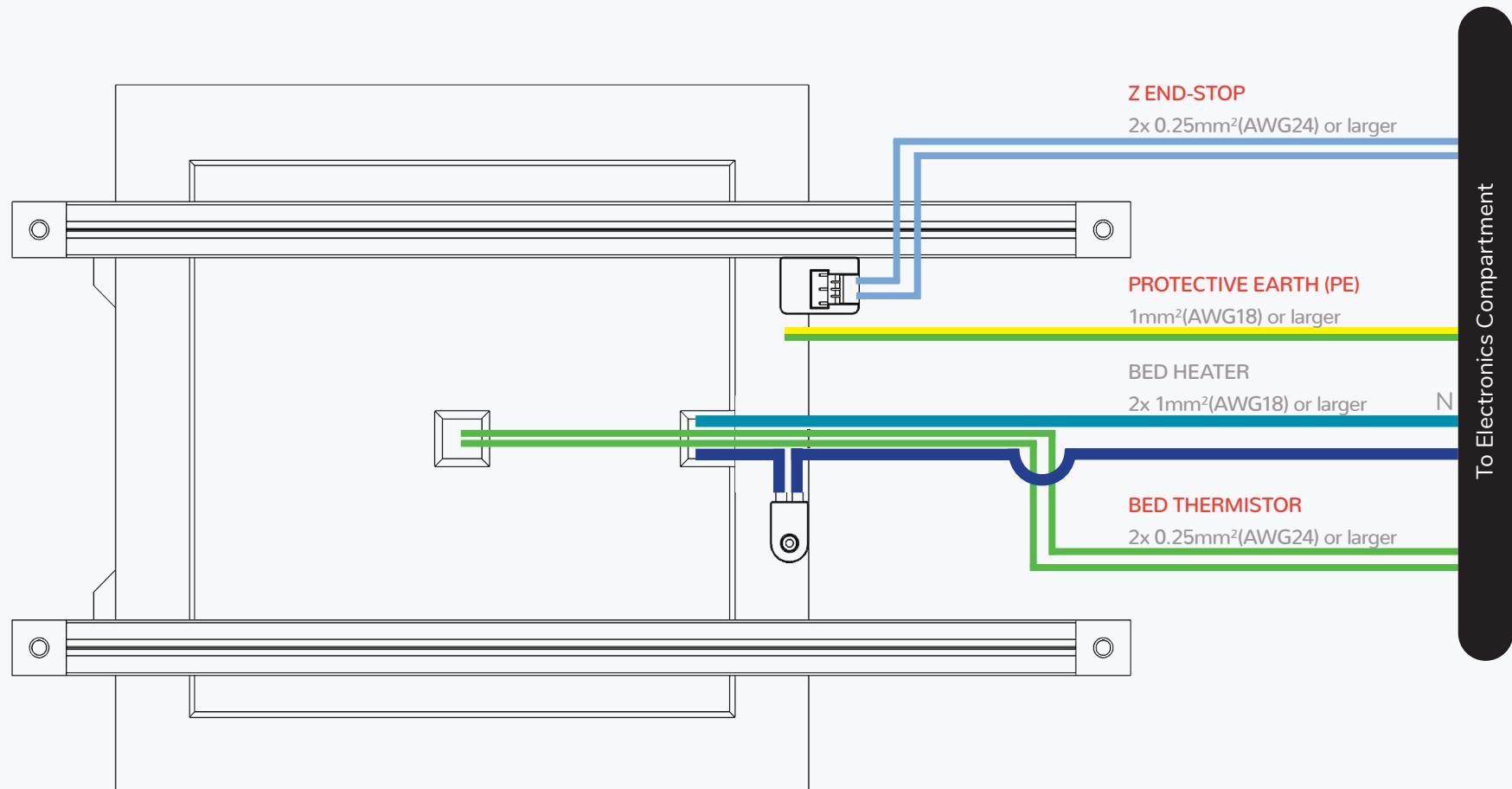
MAINS WIRING CONTINUED

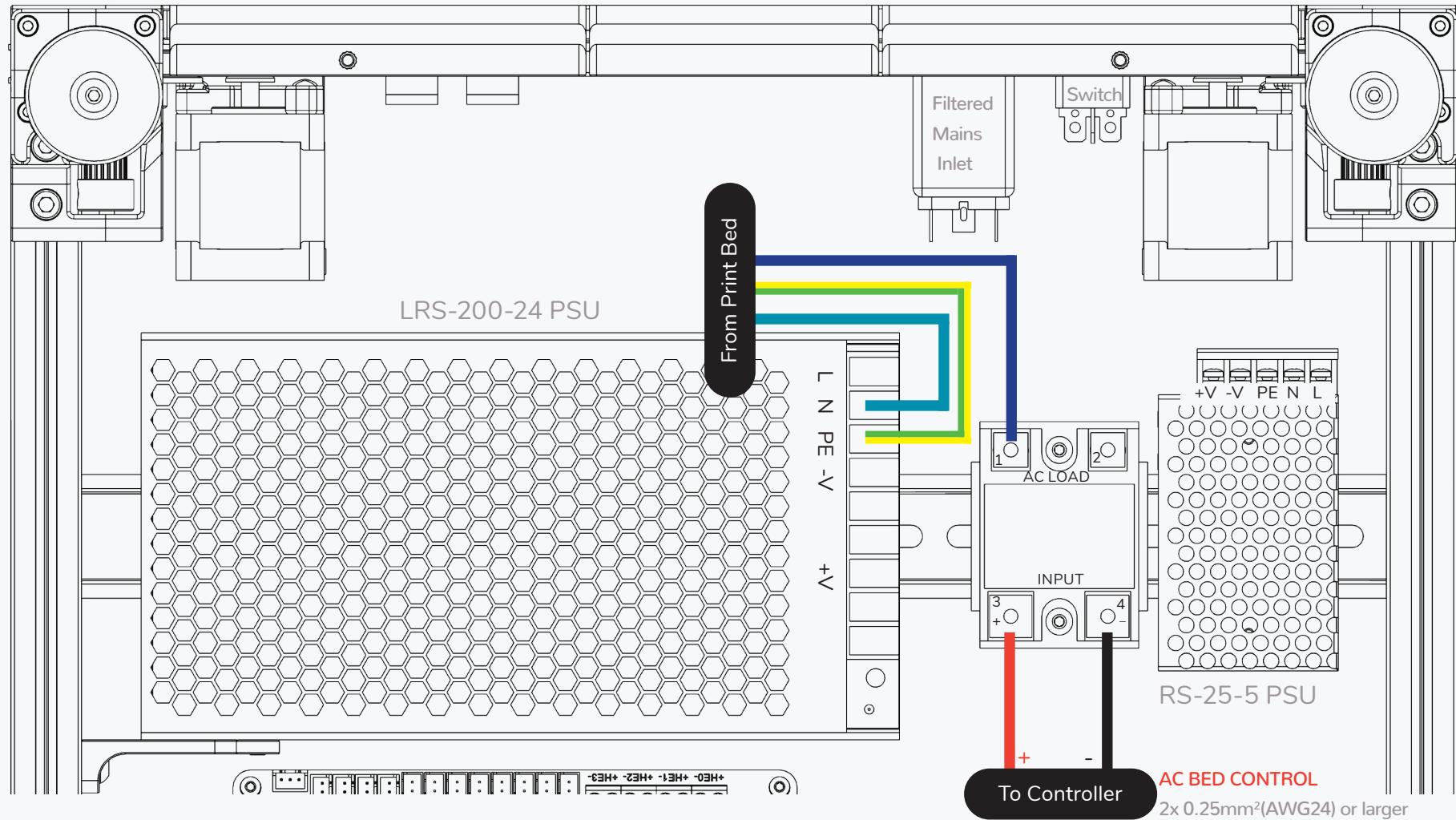
Secure the wires with cable clips / cable tie anchors.

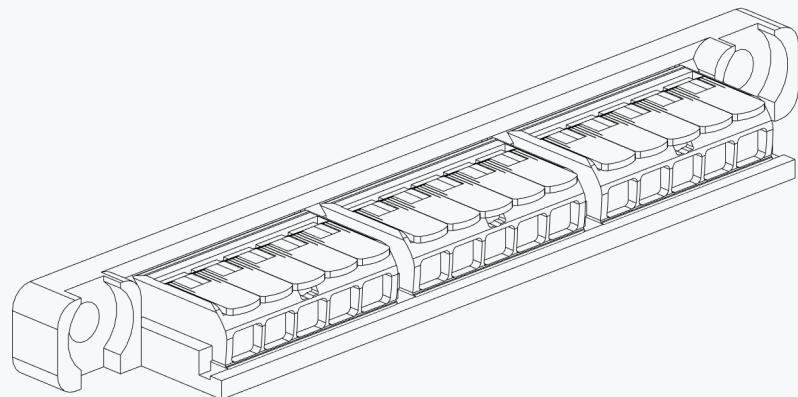
The bed heater is powered by AC voltage and receives its PE in a later step.

Observe your local regulations in regards to the Protective Earth connections for the frame/other components.





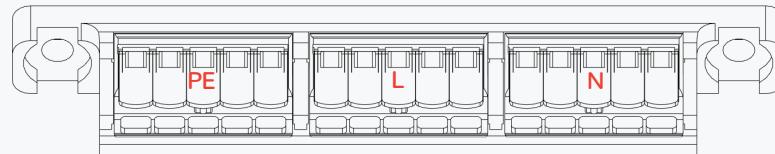


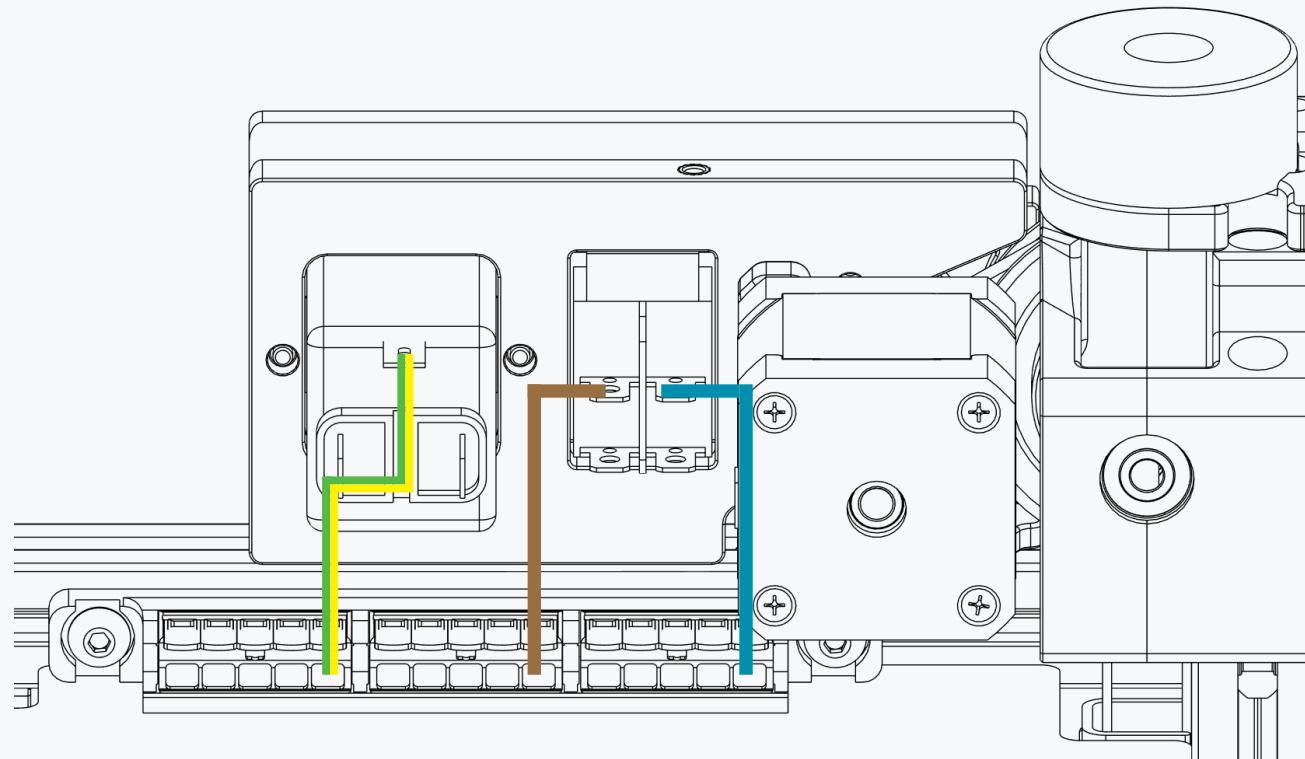


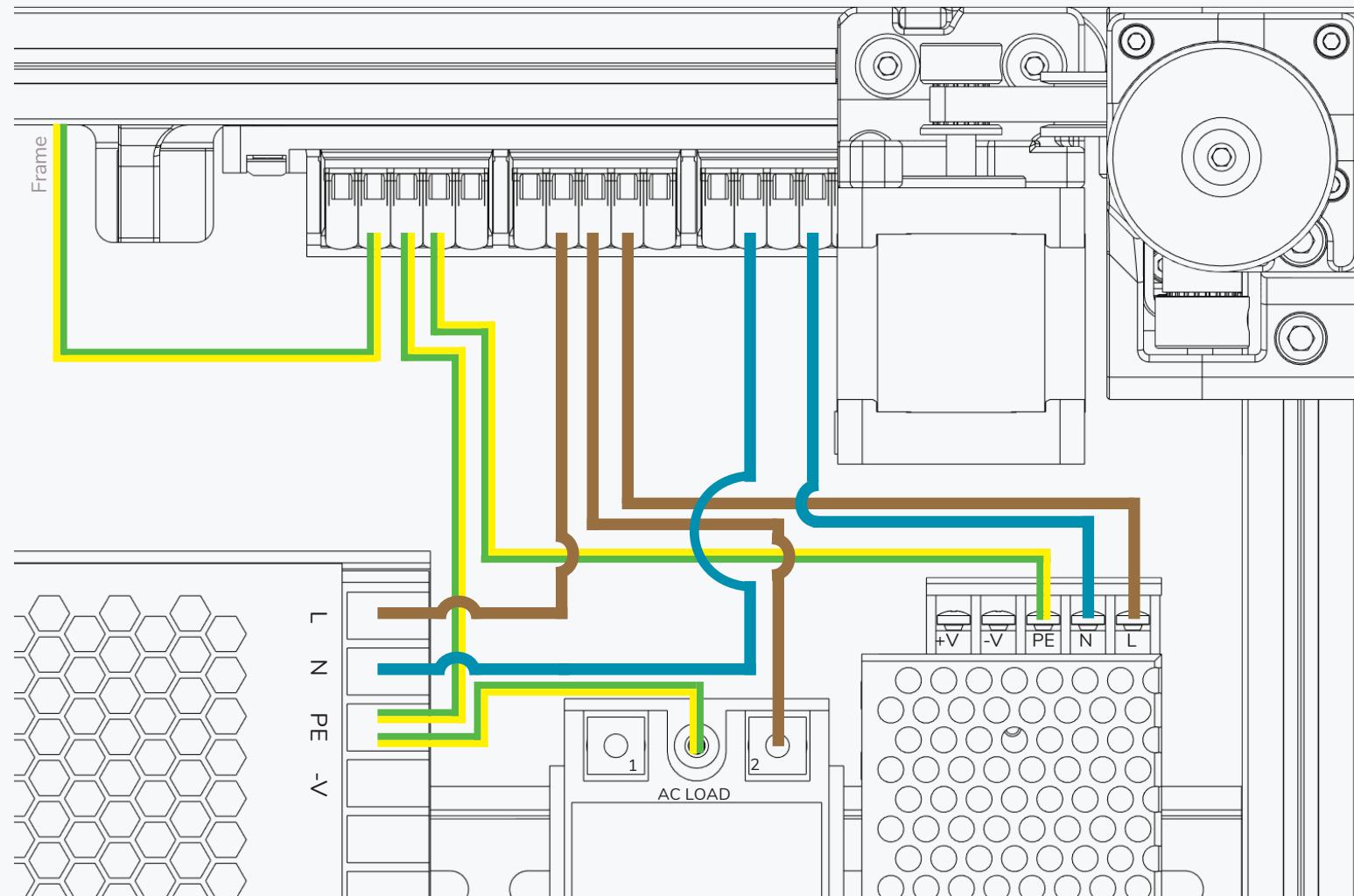
OPTION: WAGO CLAMPS FOR MAINS

WAGO wire clamps allow for a clean and easy wiring of the mains side.

You may want to label your clamps as shown below.

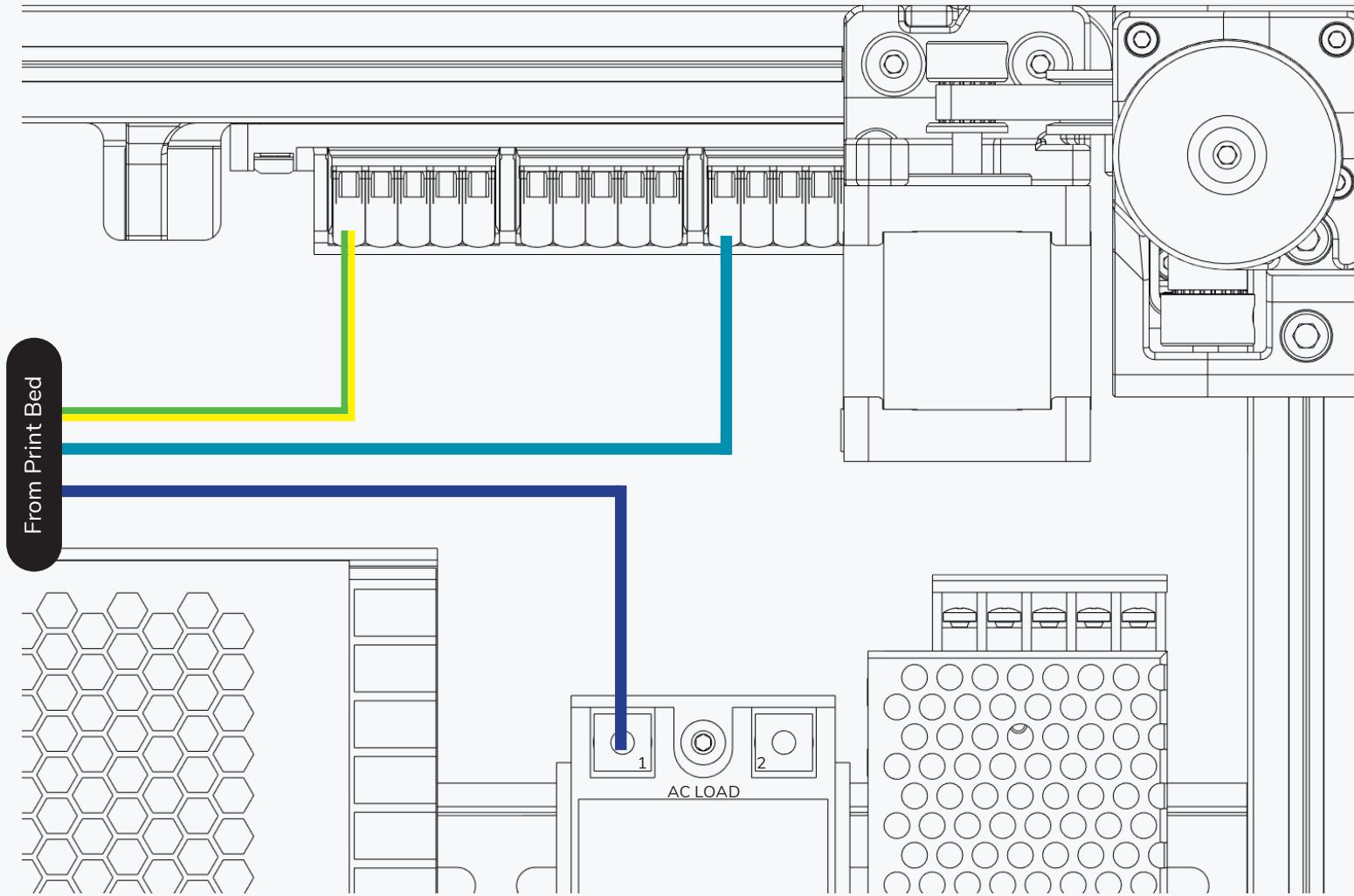


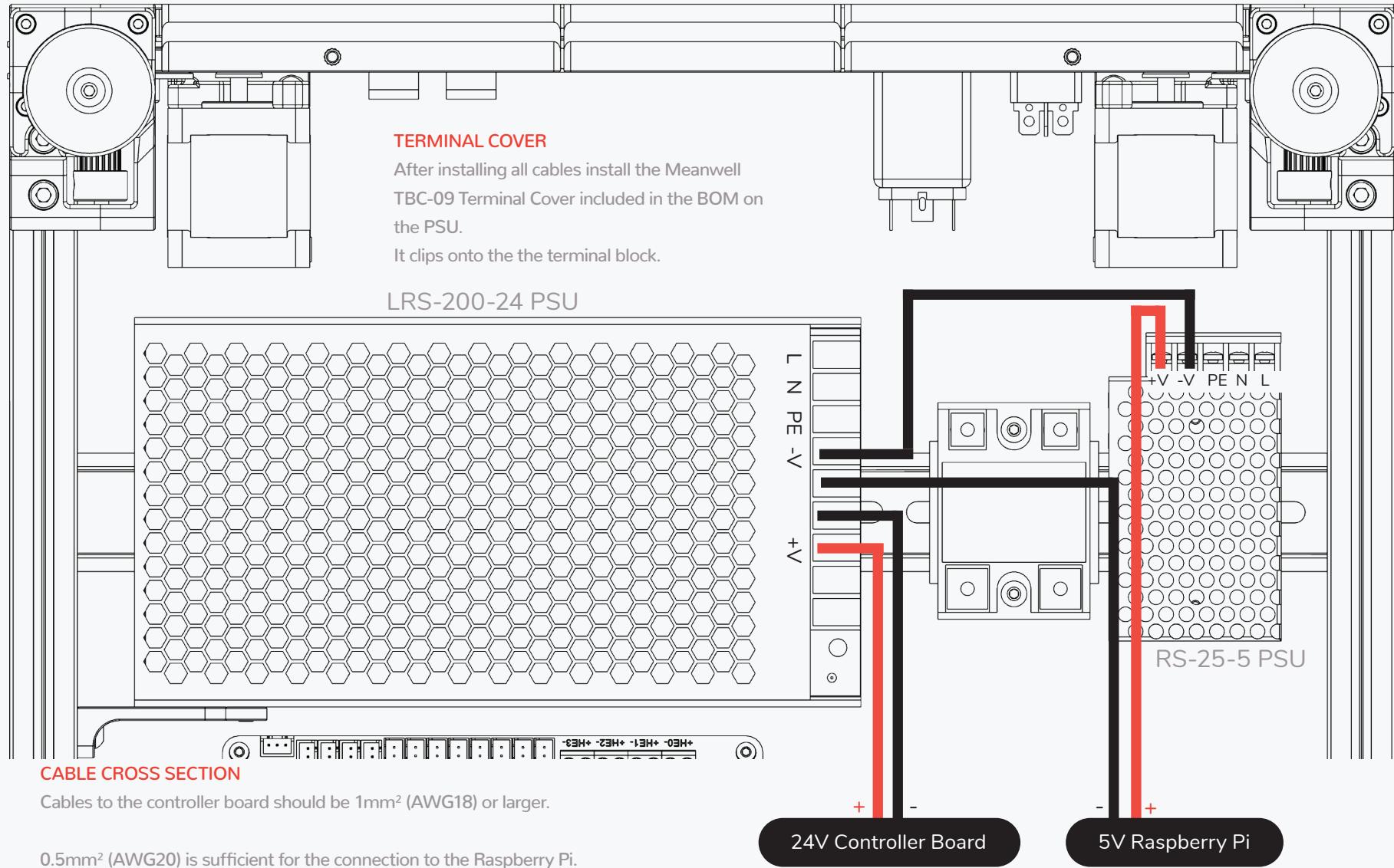




ALTERNATE MAINS WIRING - WAGO CLAMPS

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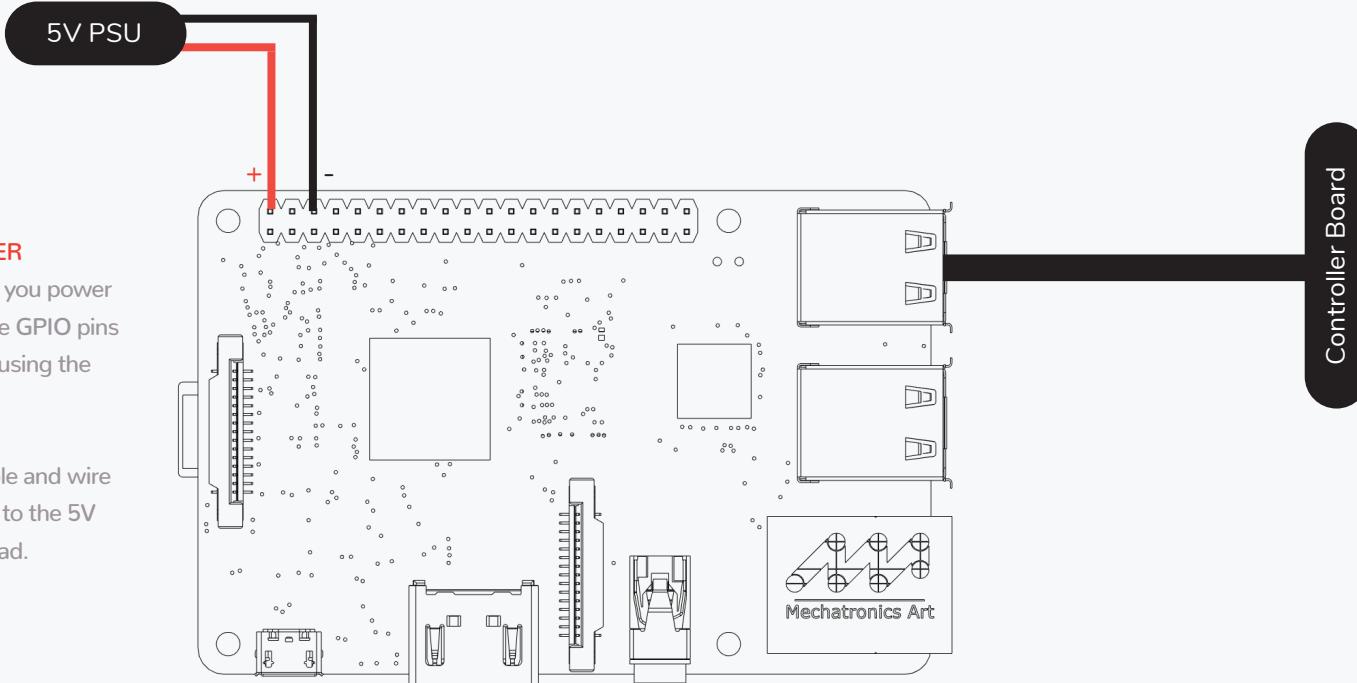




RASPBERRY PI POWER

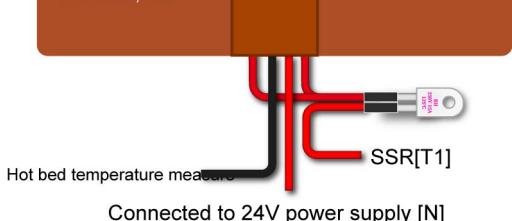
While we suggest that you power the Raspberry Pi via the GPIO pins you may also power it using the "Power-In" USB port.

Cut a suitable USB cable and wire the + and ground lines to the 5V DC/DC converter instead.



110V connection

110V voltage is used in the United States, Canada, Japan (100V), Taiwan, China Province of China, etc

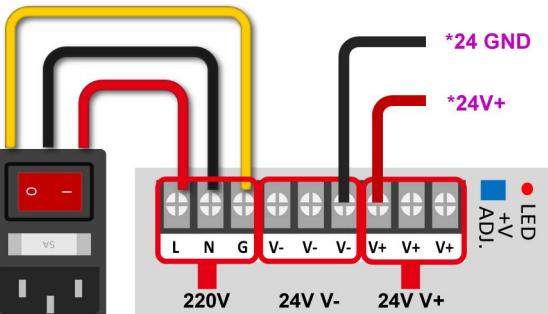


220V connection

About 120 countries and regions such as the mainland of China, Hong Kong, the United Kingdom, Germany, France, Italy, Australia, India, Singapore, Thailand, the Netherlands, Spain, Greece, Austria, the Philippines, Norway and so on use AC 220V voltage areas;



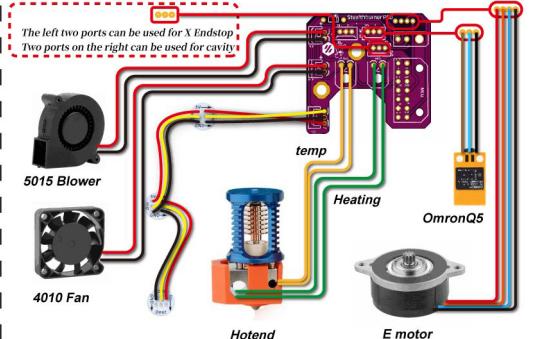
For some batches of hot beds, the second red line is on the left side of the hot bed instead of the right side, but the method used is the same.



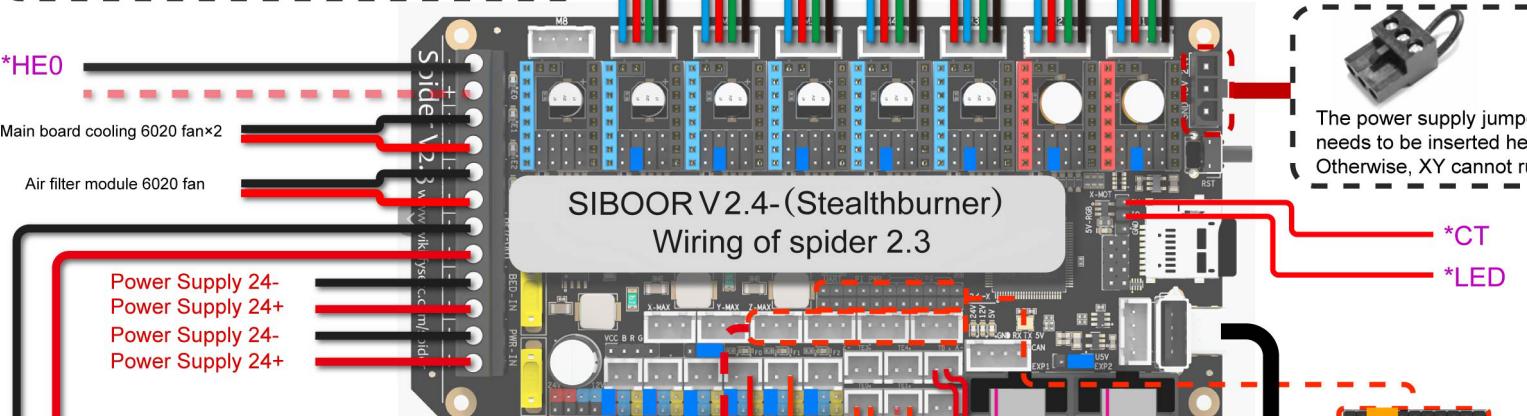
Schematic diagram of MW power supply

The positive and negative poles shall be strictly distinguished during installation

Input and output. Otherwise, it will cause short circuit and burn!



The kit has its own made adapter cable. A total of 16 cables are led out. Two are connected to the power supply, and 13 are connected to the Spider motherboard. the 14PIN line in this figure is preceded by '*'.



Schematic diagram of SSR

The white covers on both sides of the relay can be opened

1. The positive and negative poles shall be distinguished for wiring. In this figure, red represents the positive pole and black represents the negative pole.
2. All wiring work, jumper cap, drive insertion and removal must be carried out in the case of power failure, otherwise the consequences of damage (including but not limited to the main board, upper computer, power supply, adapter board)
3. The blue rectangle on the motherboard represents the need to insert the jumper cap.
4. The account and password of Orange Pie are: klipper
5. All cables are not included in the kit, and some need to be crimped and manufactured by themselves.
6. Some of the cables in the motherboard wiring diagram are dotted lines because of the adapter board used by the kit. The fan and probe share the positive pole, and the thermal sensor, probe and heating rod share the negative pole. Therefore, the dotted cable does not need to be plugged.

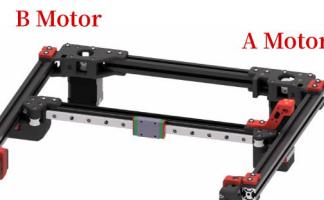
XY Endstop PCB



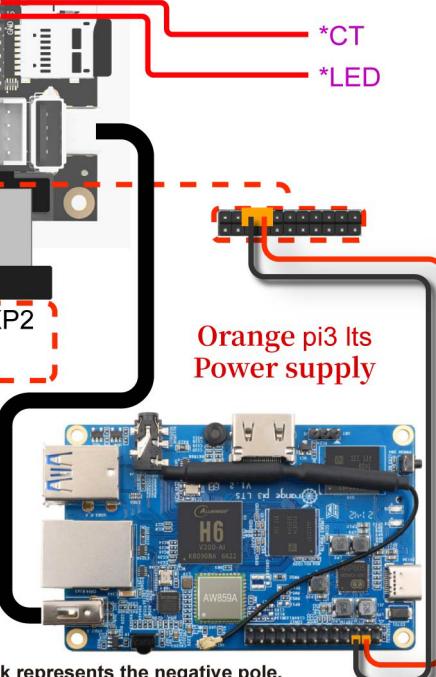
Z Endstop PCB

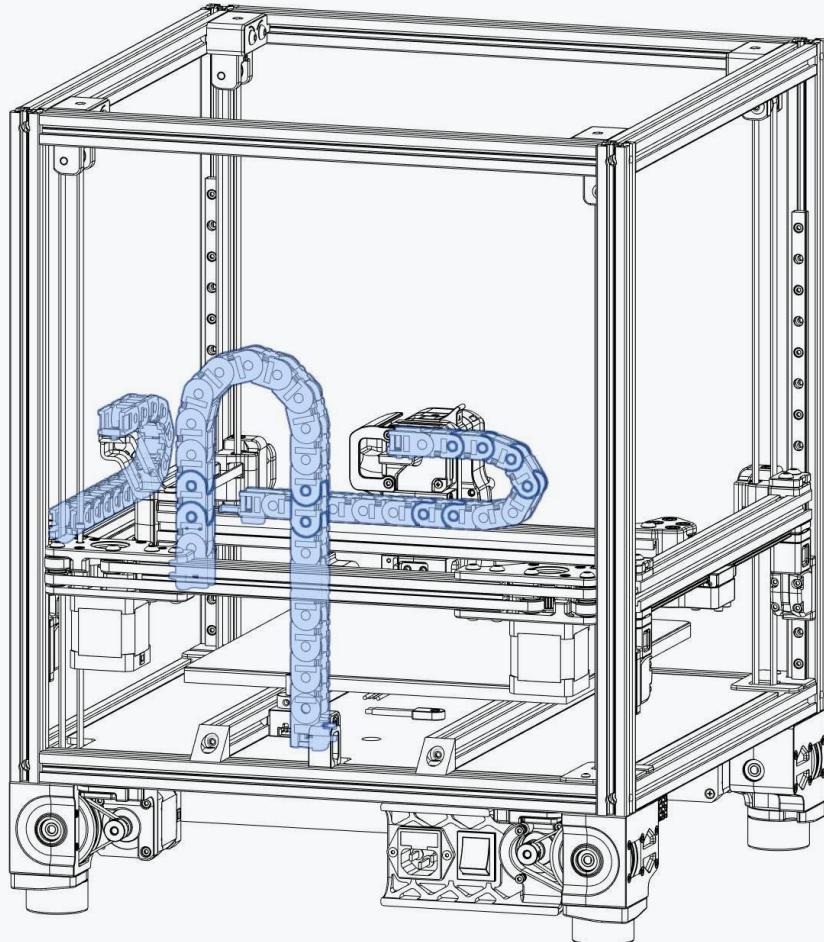


The kit has its own made XYZ limit lead, which is plug and play, and does not need to be made manually.



The power supply jumper needs to be inserted here, Otherwise, XY cannot run

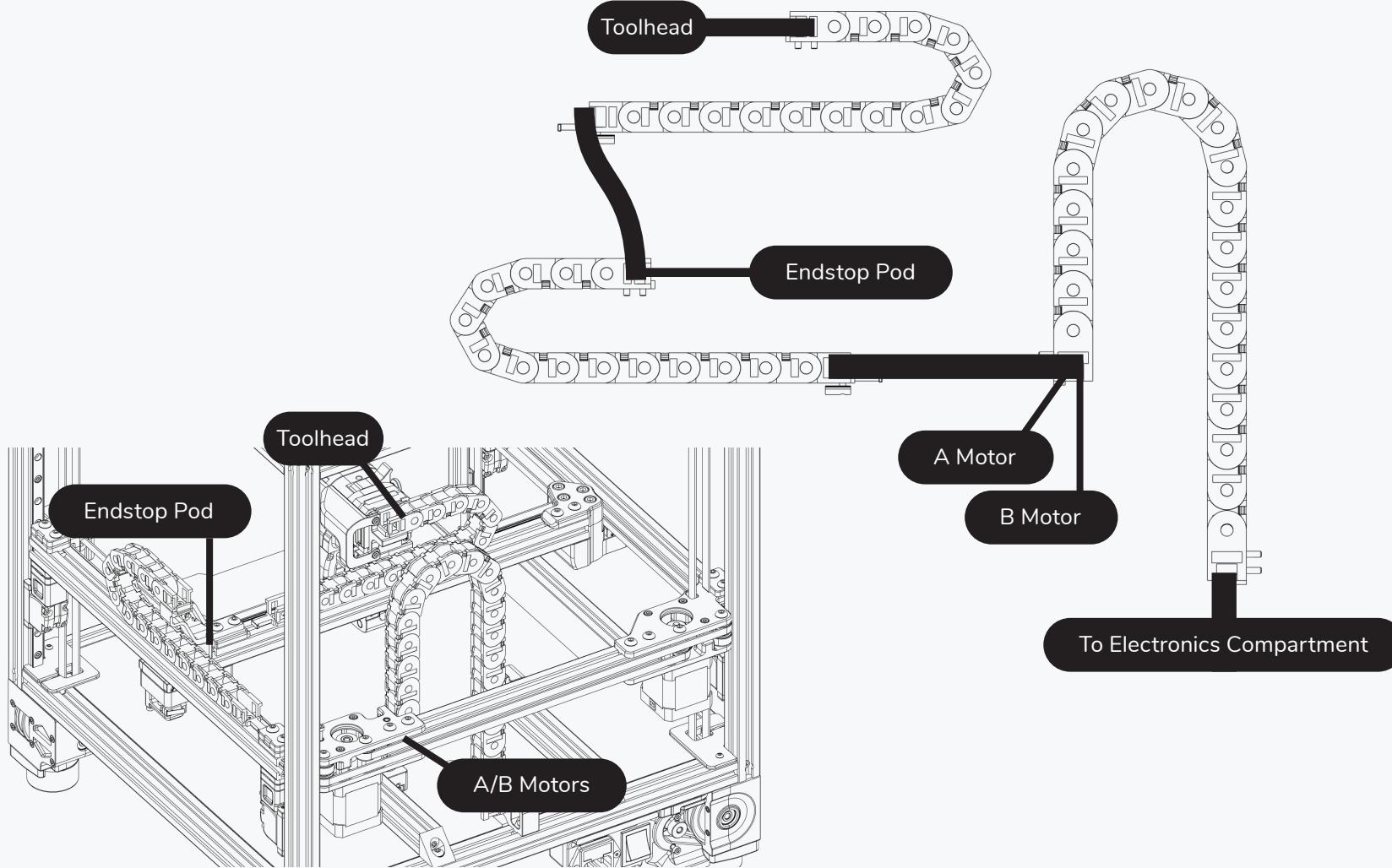


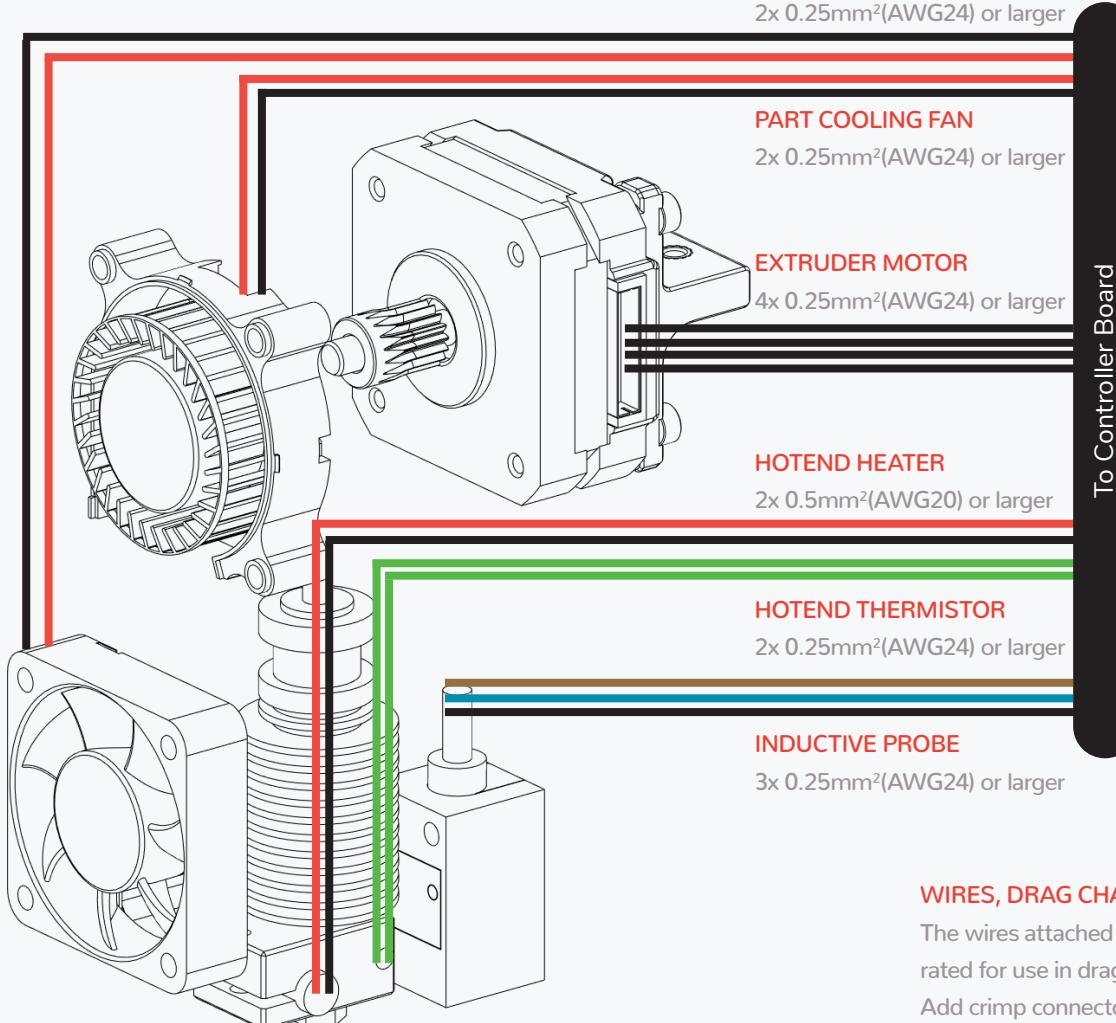


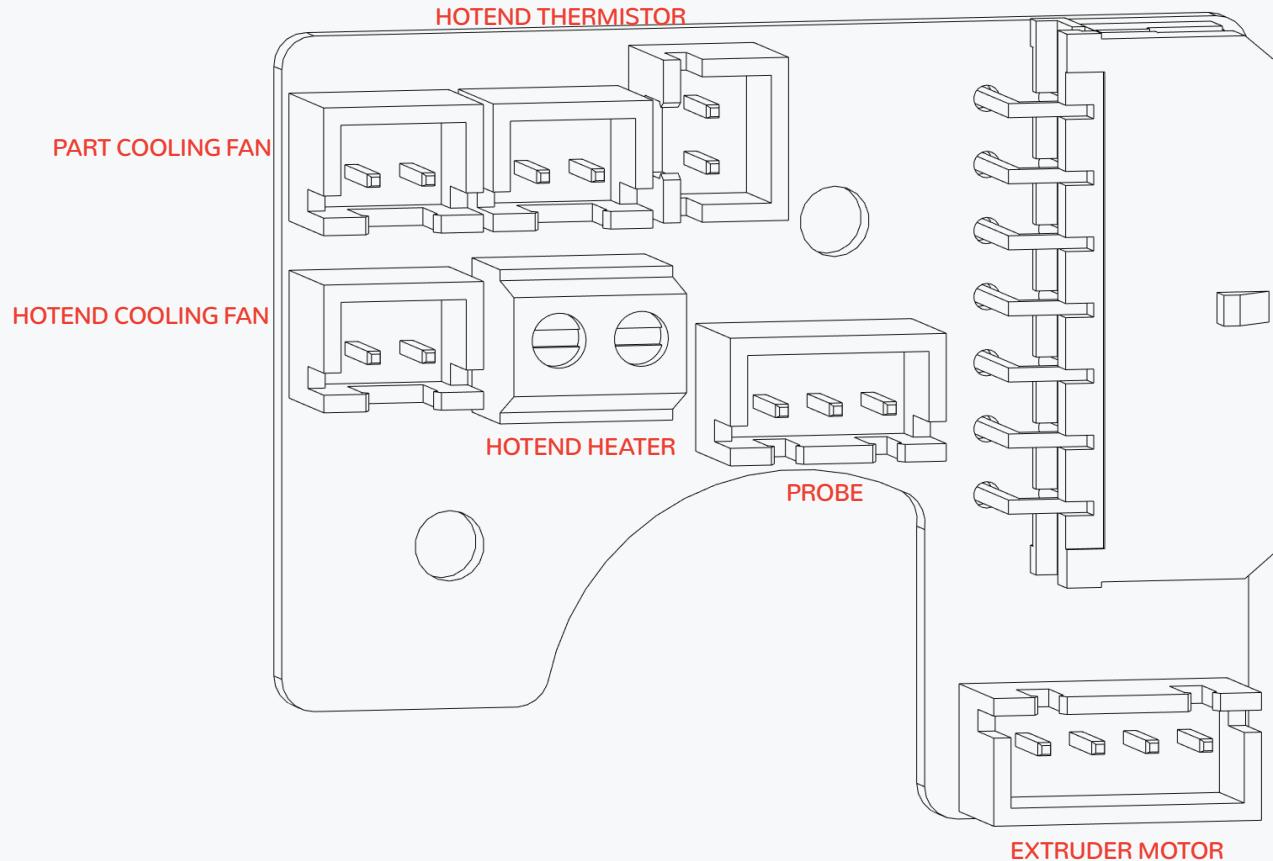
CABLE CHAINS INSTALL

You can opt to install the chains now and fish the wires through the chains or build the complete harness outside of the printer and install it in one go. Either approach does work.

If you sourced a pre-built wire harness completing the harness outside of the printer is recommended.



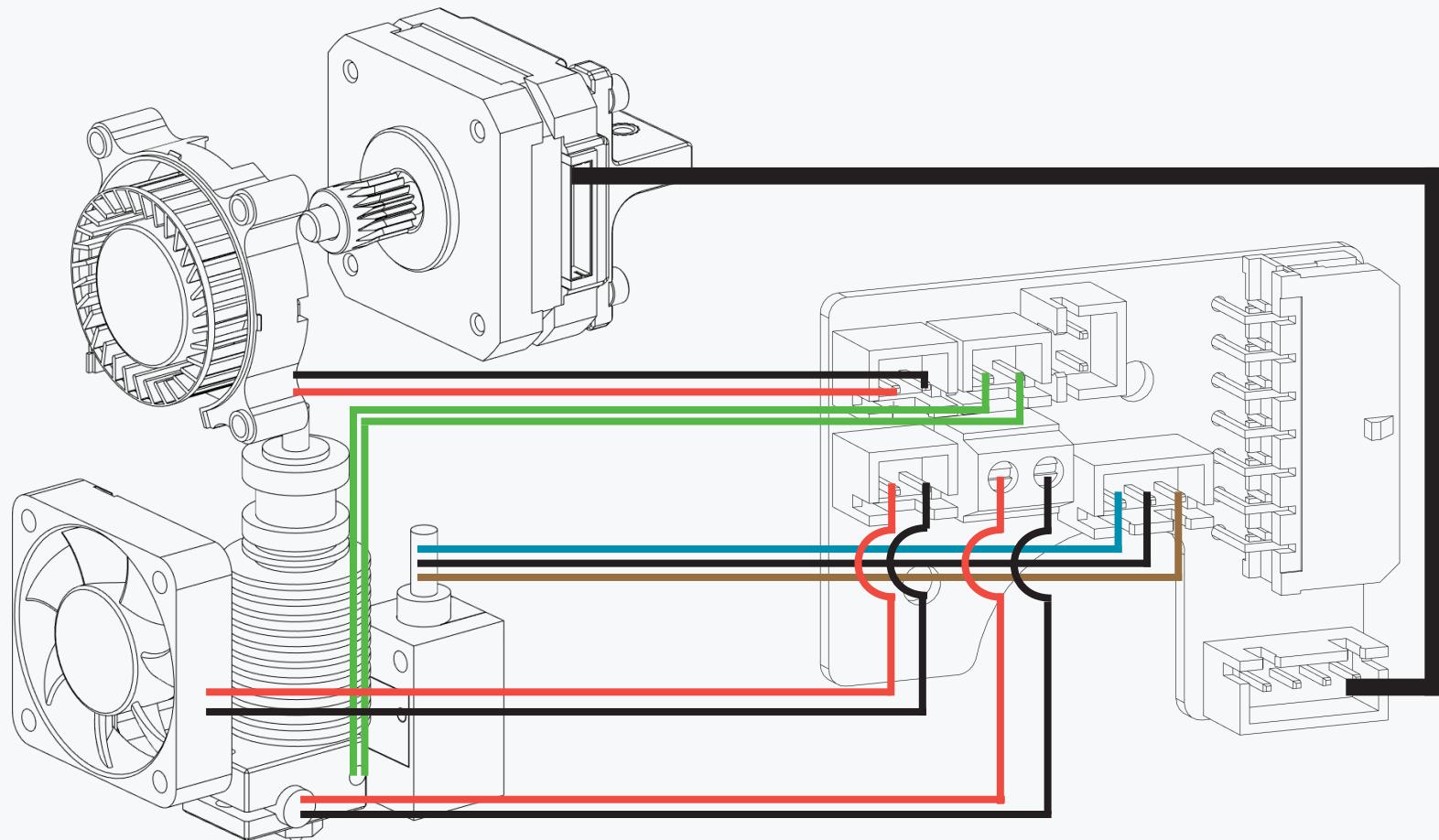


**OPTION: TOOLHEAD PCB**

The layout of the toolhead pcb changed over the versions. For a full breakdown visit the link below.

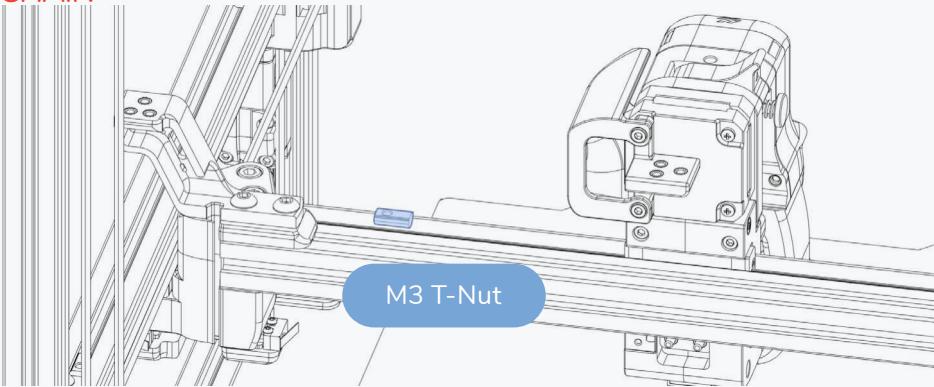


<https://voron.link/zopduze>

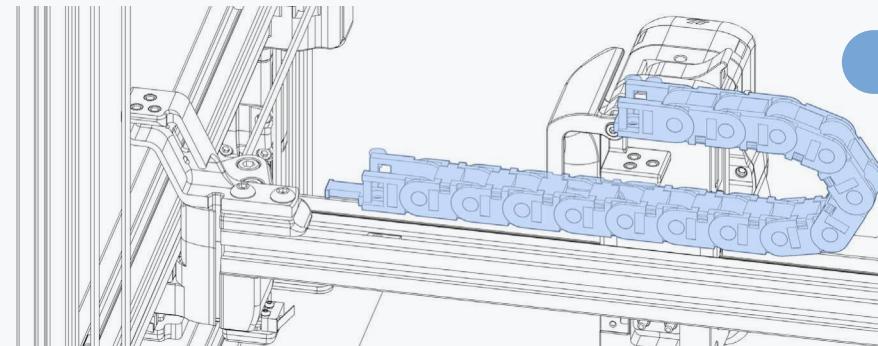


X CABLE CHAIN

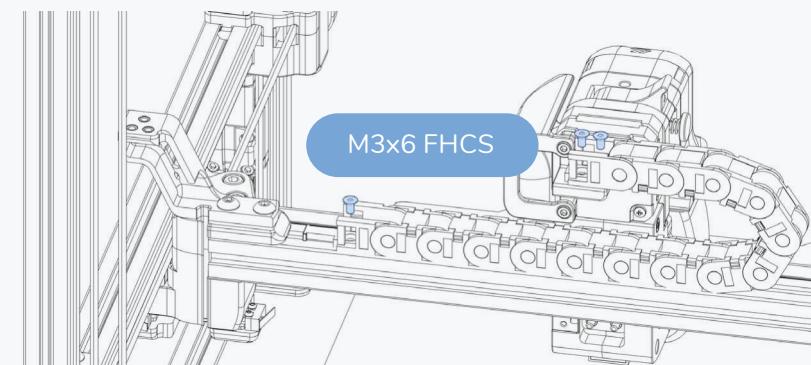
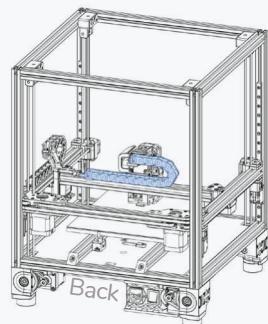
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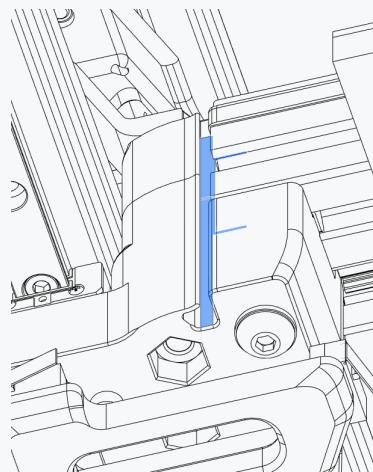
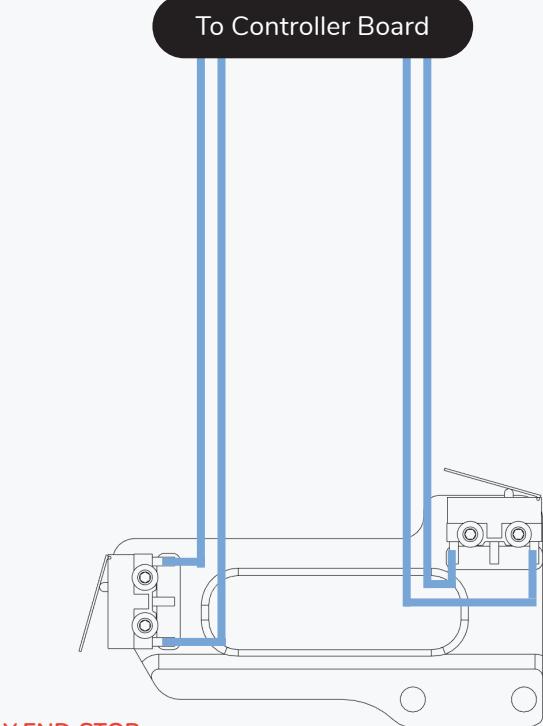
M3 T-Nut



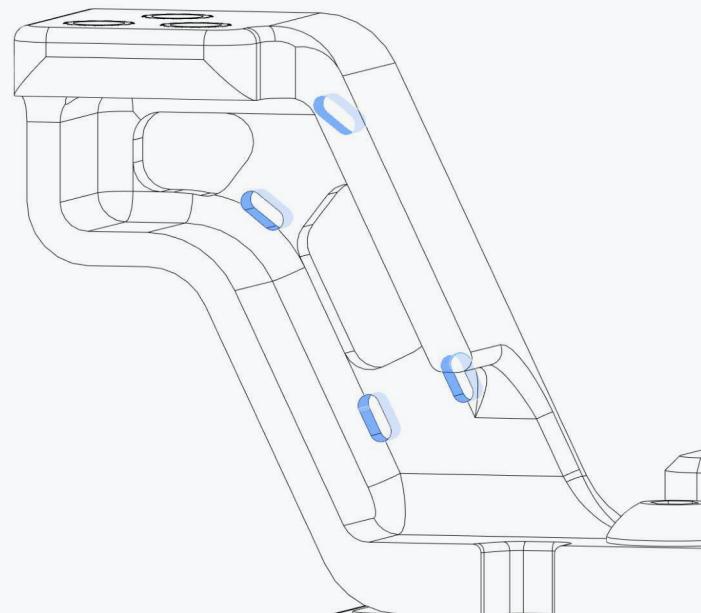
Cable Chain



M3x6 FHCS



Y END-STOP
2x 0.25mm²(AWG24) or larger

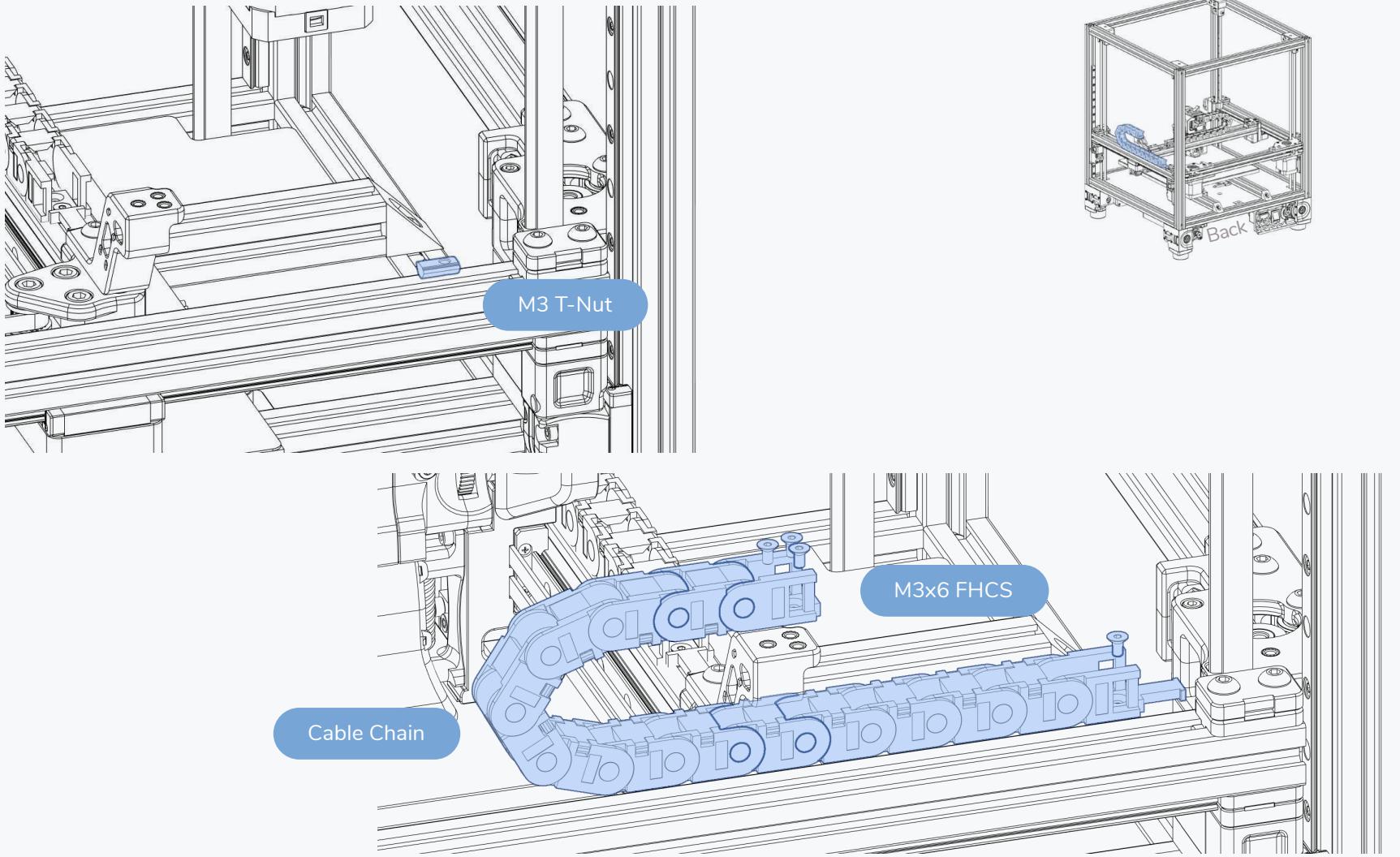


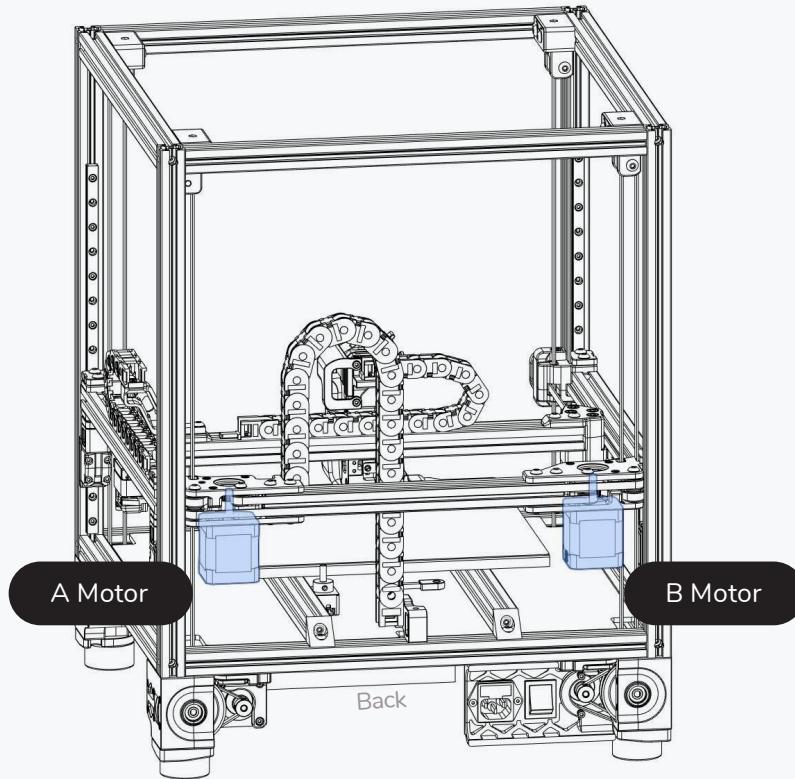
ZIP TIE LOOPS

Secure the wire bundle to the strain relief using small zip ties.

OPTION: ENDSTOP BOARD/HALL EFFECT BOARD

Those boards utilize a 4 pin connector instead. Please refer to <https://voron.link/djhygyu> and <https://voron.link/d6qb7o6> for details.



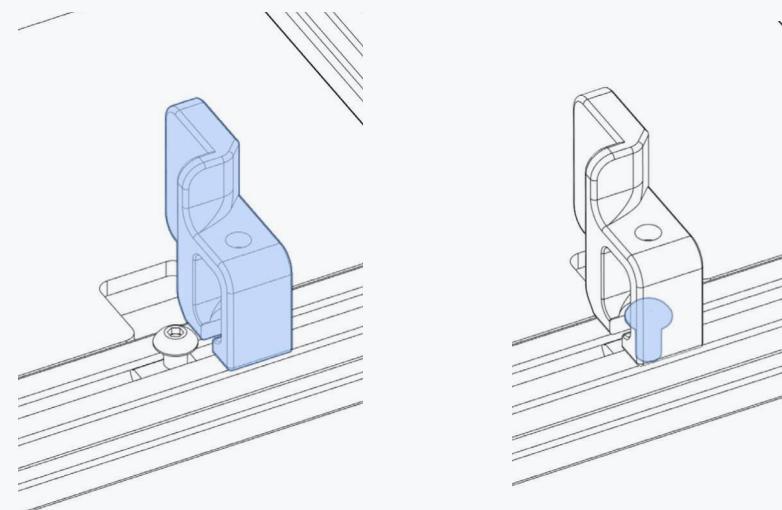
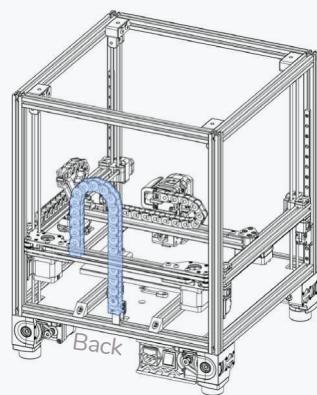
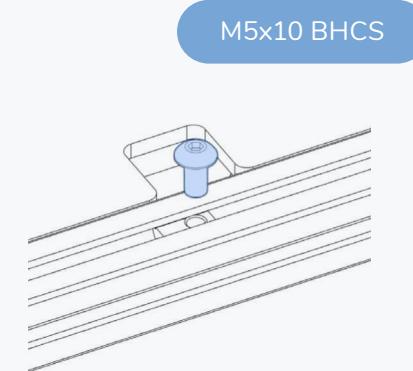
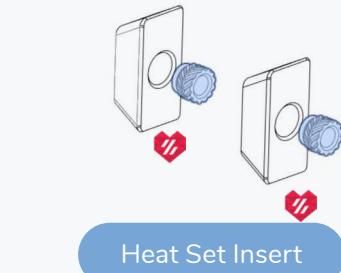


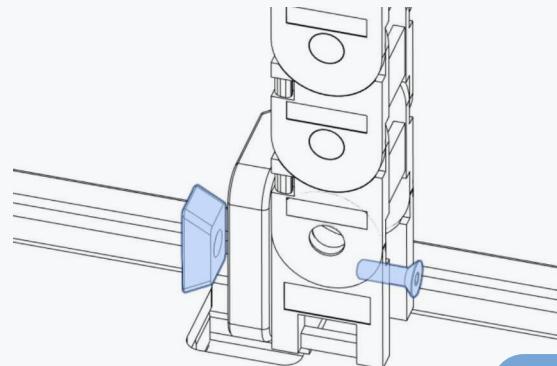
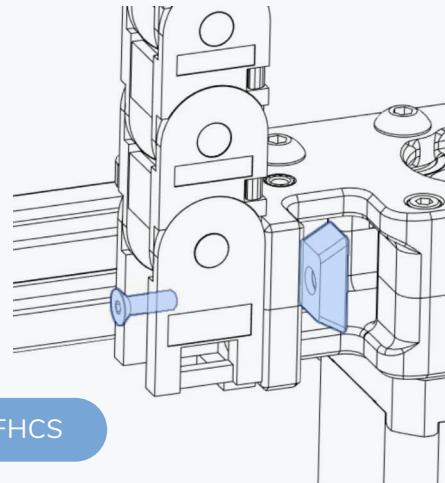
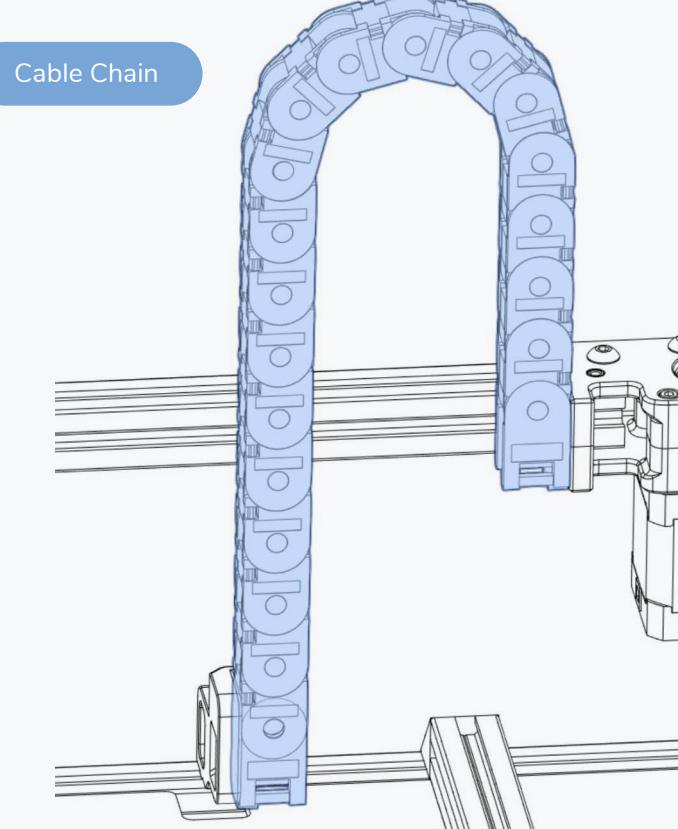
SECURING MOTOR CABLES

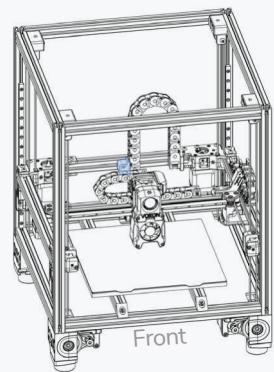
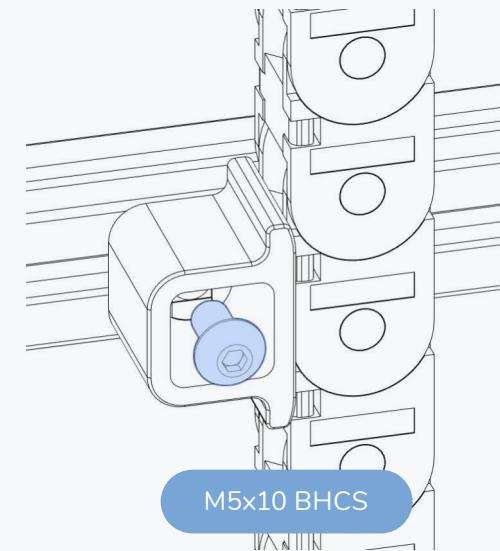
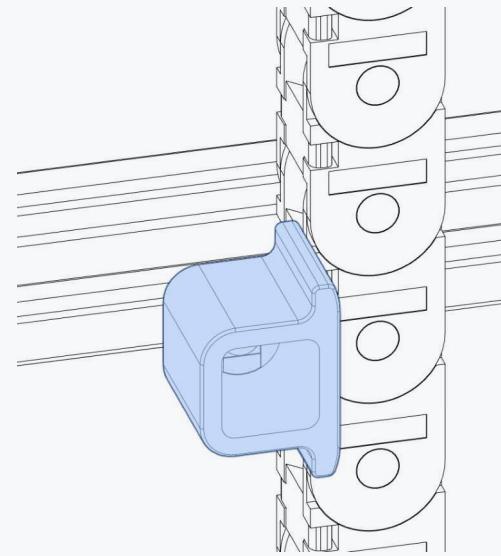
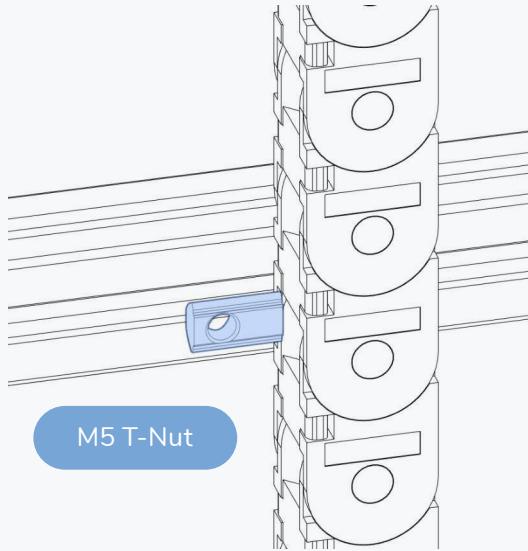
Secure the wire bundles along the small extrusion that sits between the drives with small zip ties.

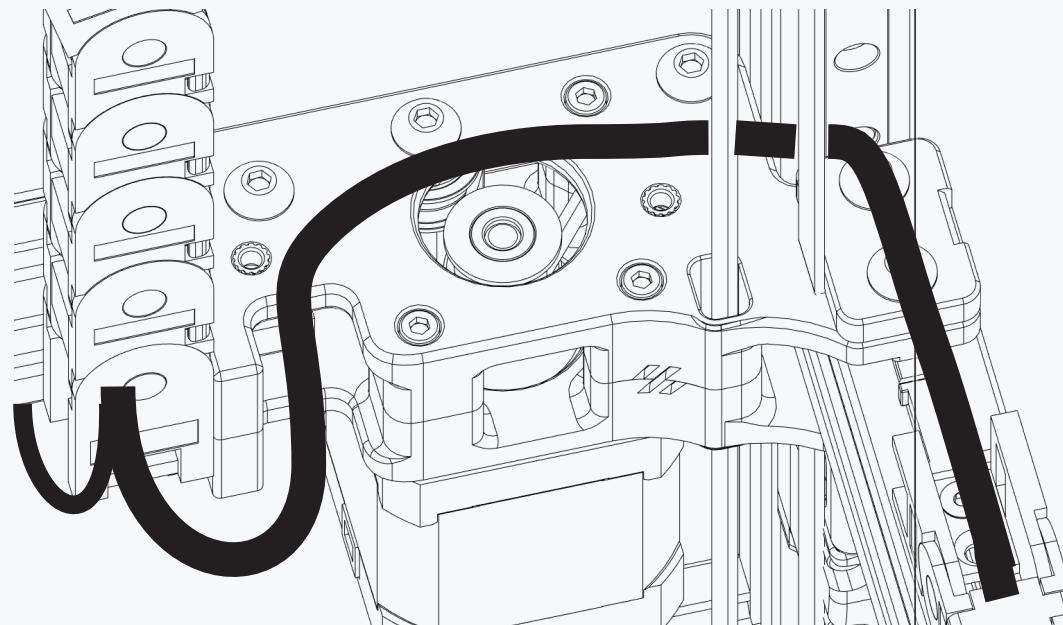
Z CABLE CHAIN

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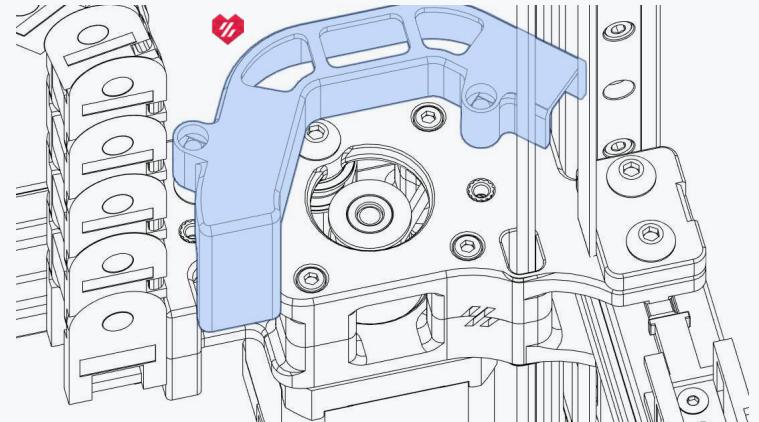




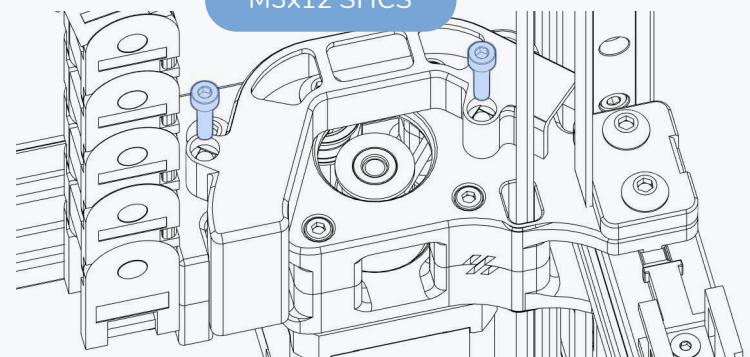


**WIRE PATH**

Guide the wire bundle behind the Z belt and over the A drive as shown above. Secure it with zip ties on the strain relief of the cable chains.



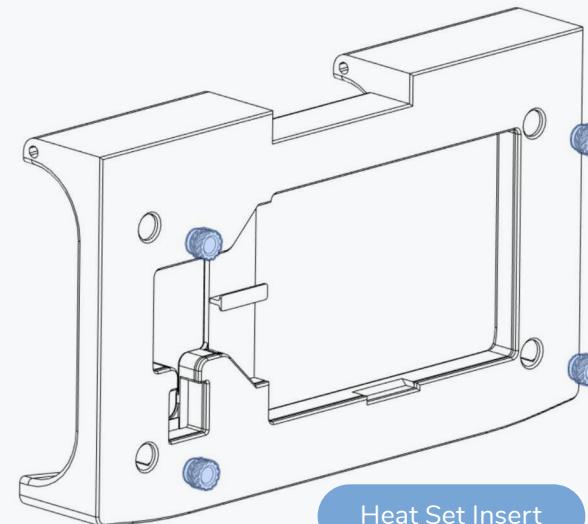
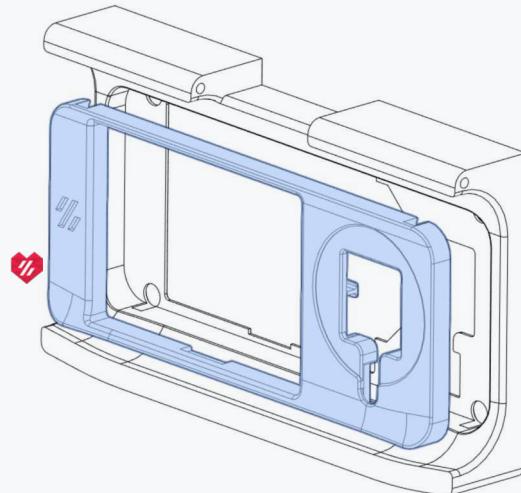
M3x12 SHCS



SKIRTS

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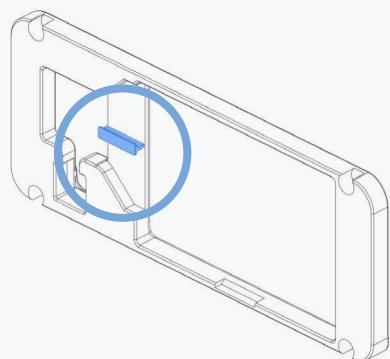




Heat Set Insert

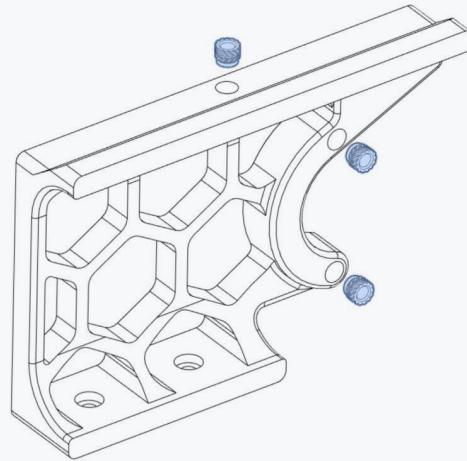
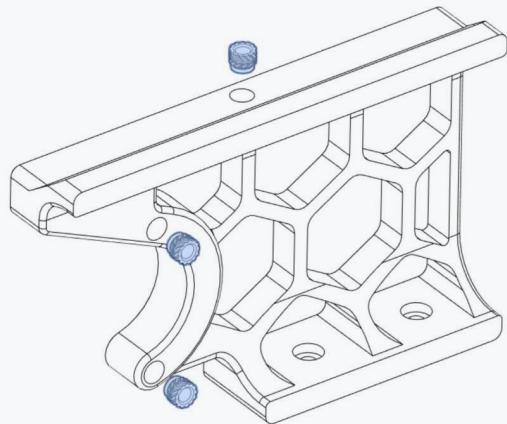
FRONT COVER

The front cover is held in place by the heat set inserts. Hold the front face firmly in place while inserting the heat set inserts.

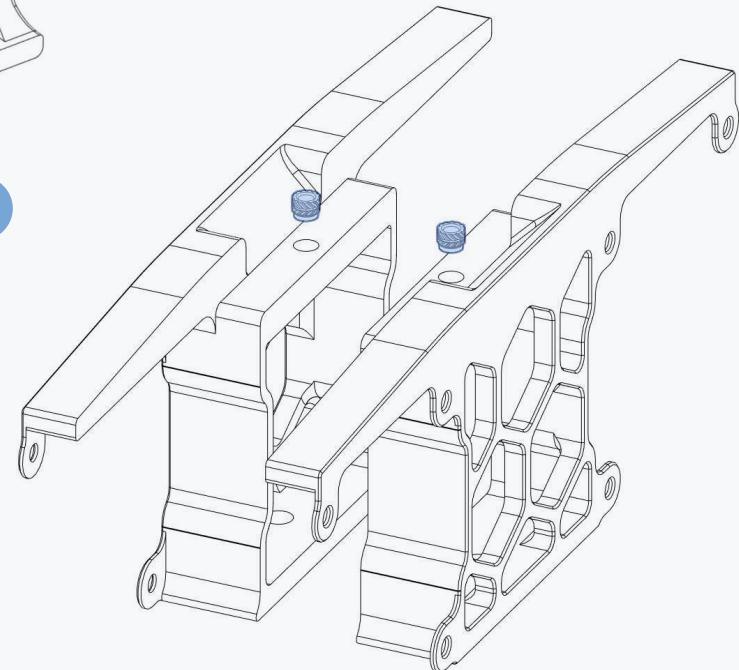
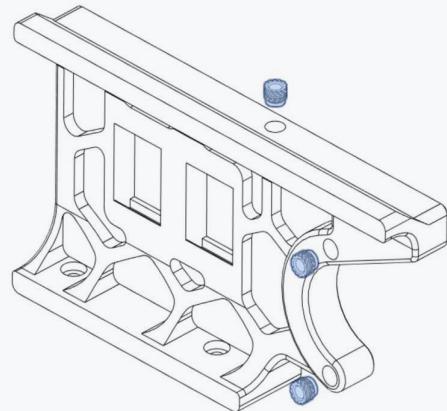


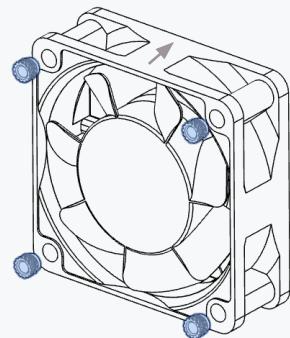
BUILT-IN SUPPORT

Remove the highlighted section. It's a built-in support for printability.

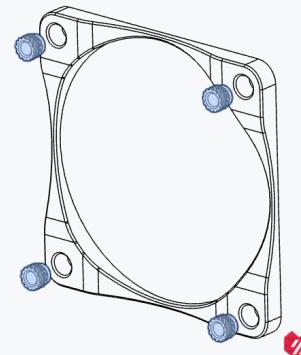


Heat Set Insert

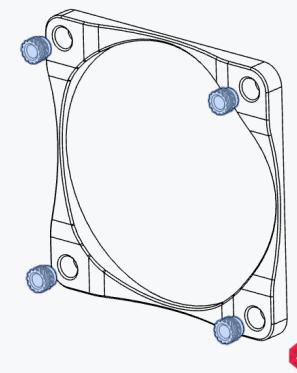
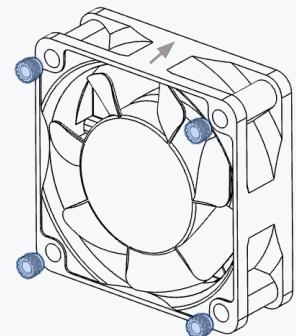


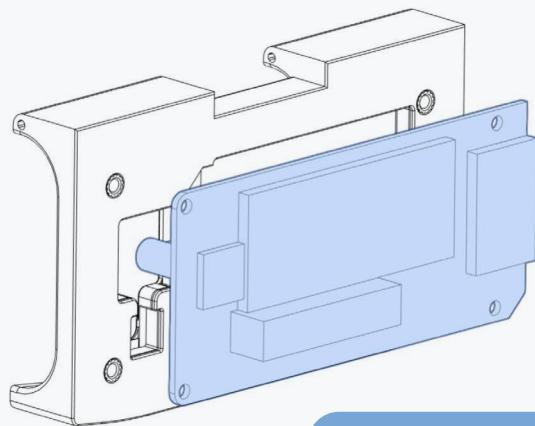


60x20 Fan

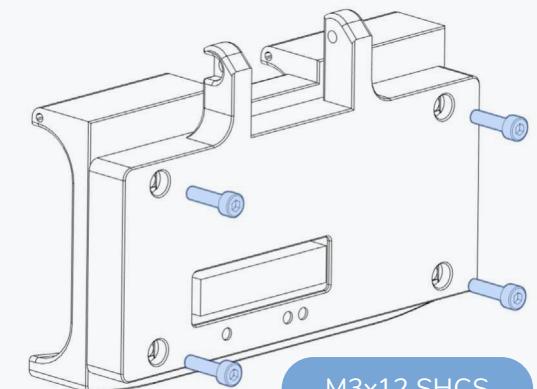
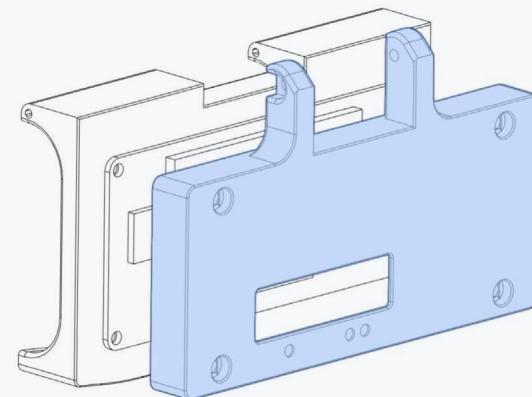


Heat Set Insert

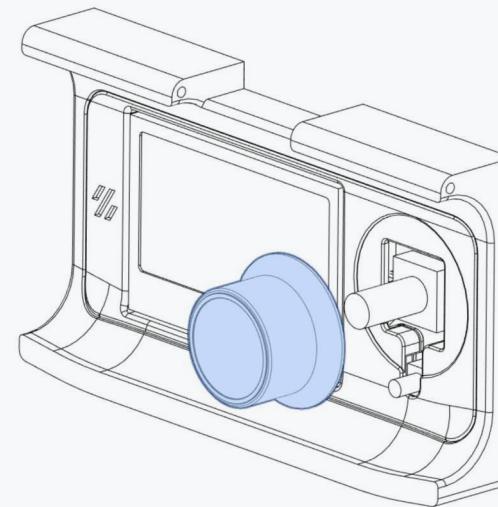
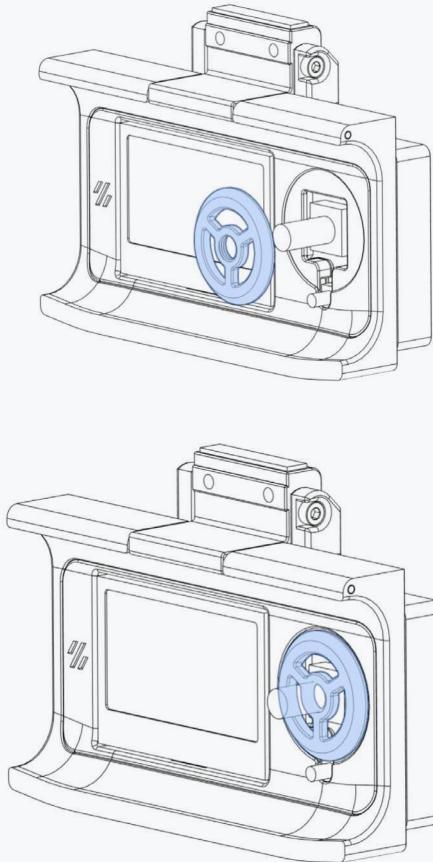




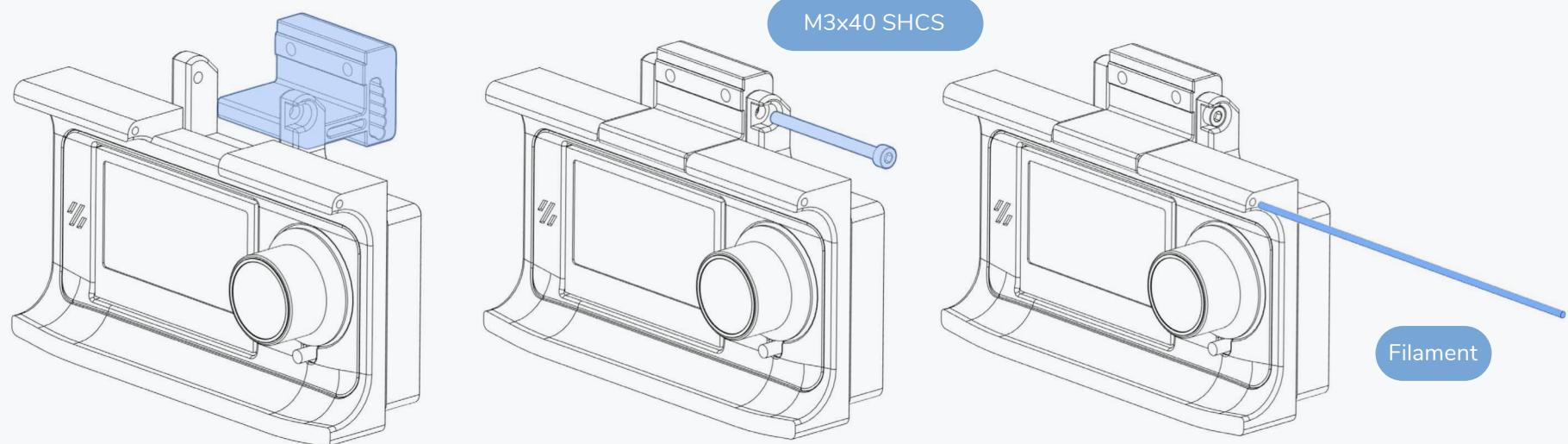
Mini 12864 Screen

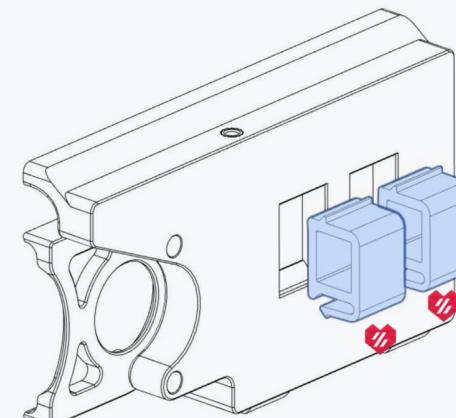
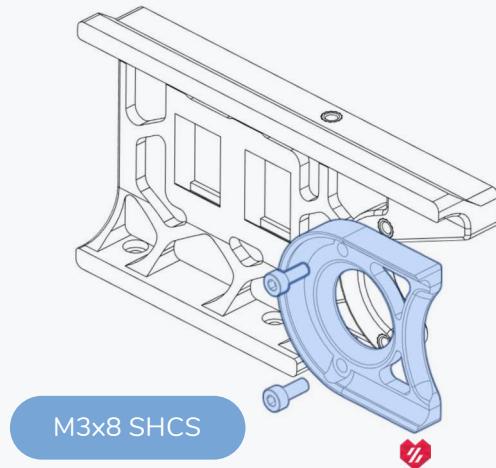
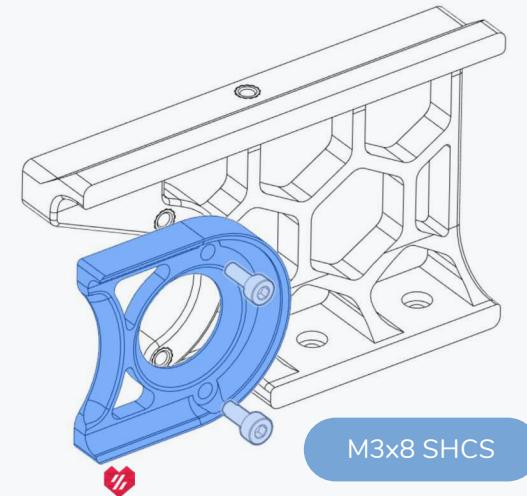
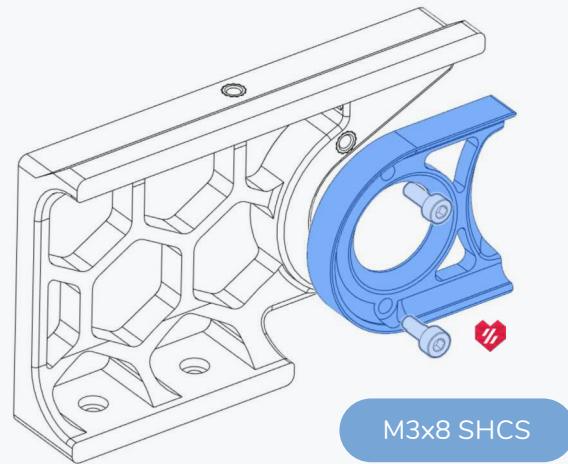


M3x12 SHCS

**OPTION: LIGHT BLOCKER**

Some LCDs come with a smaller encoder knob. This extra piece prevents excess light bleed. Threads onto the encoder before the knob is pressed on.

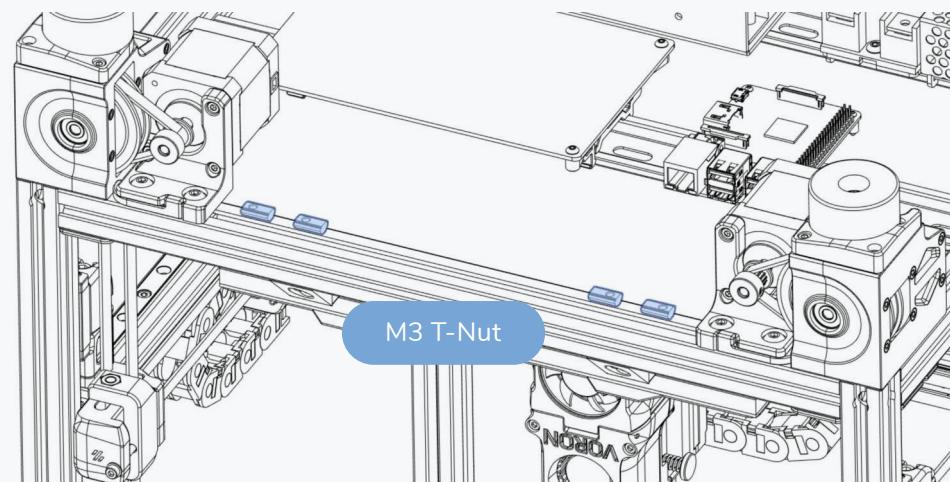
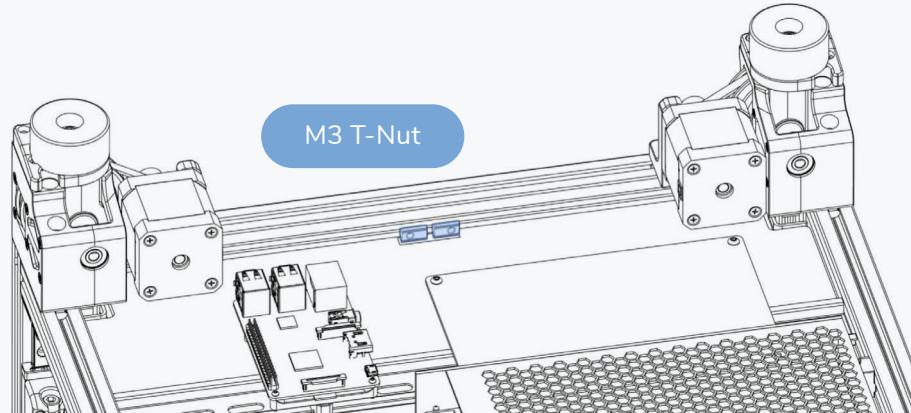


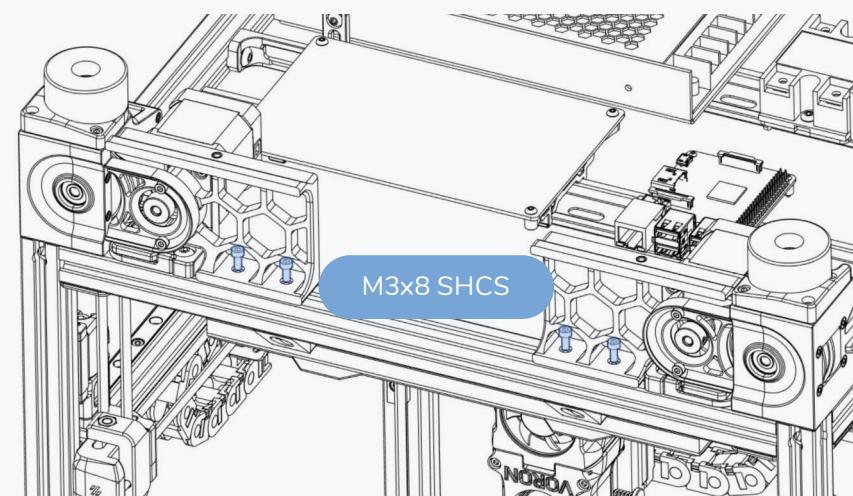
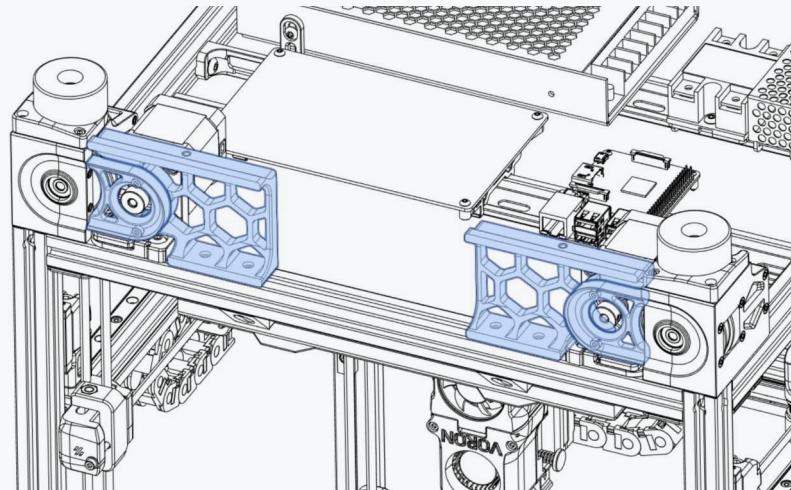


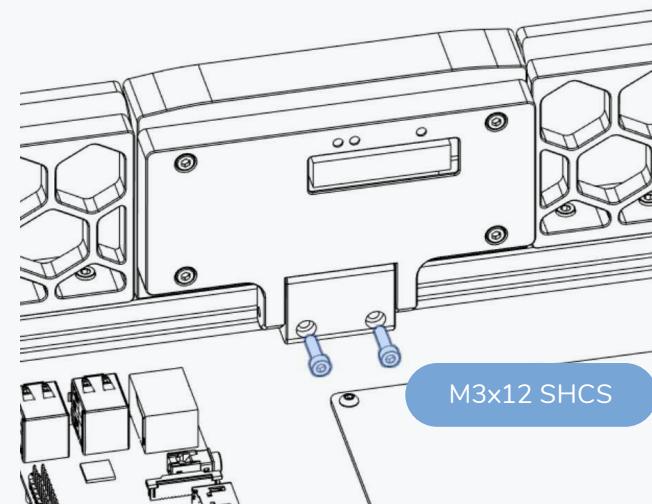
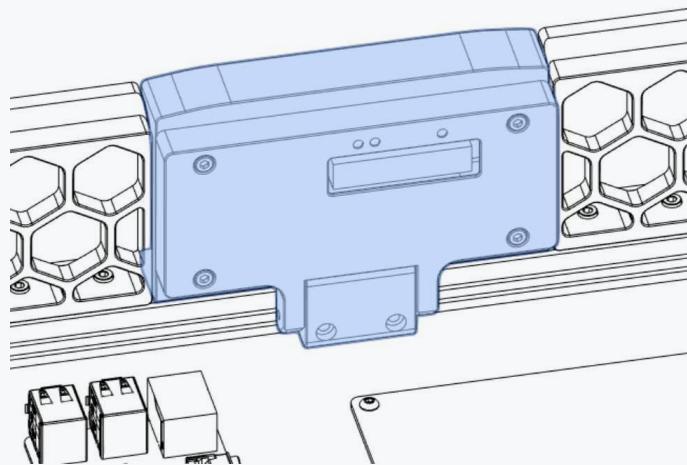
OPTION: KEYSTONE INSERTS

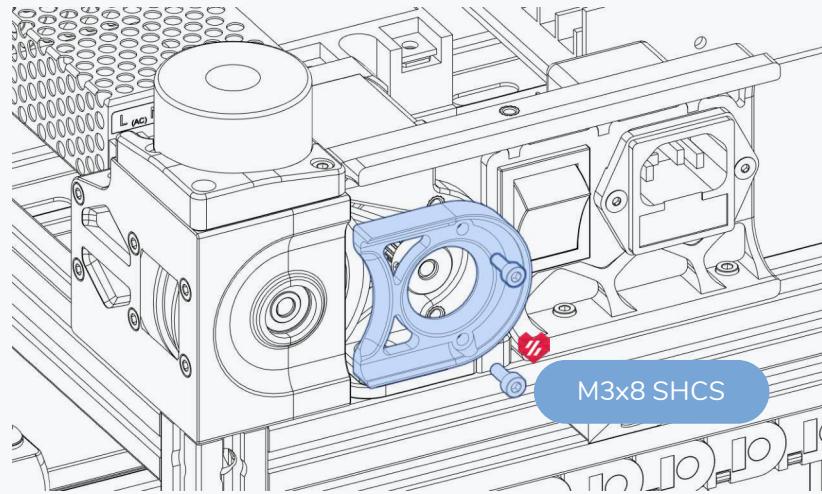
The picture is showing blanks for the keystone slots.

Alternatively you can add modules for USB or ethernet and expose ports of the Raspberry PI on the back of the printer.

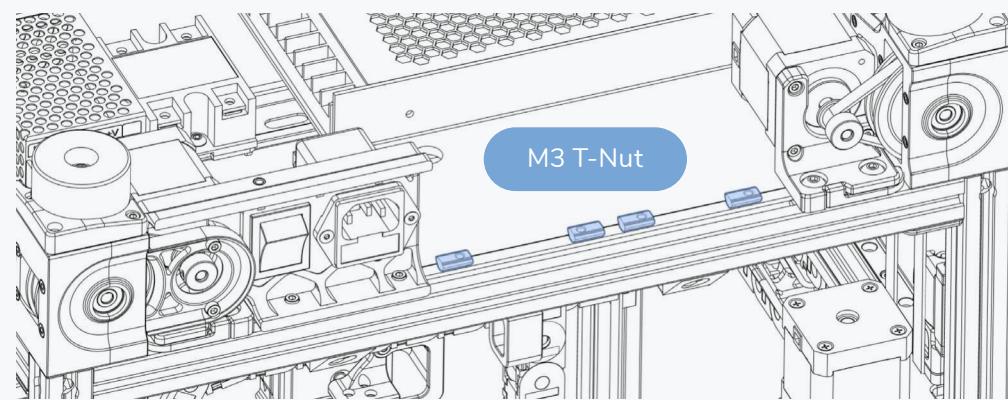








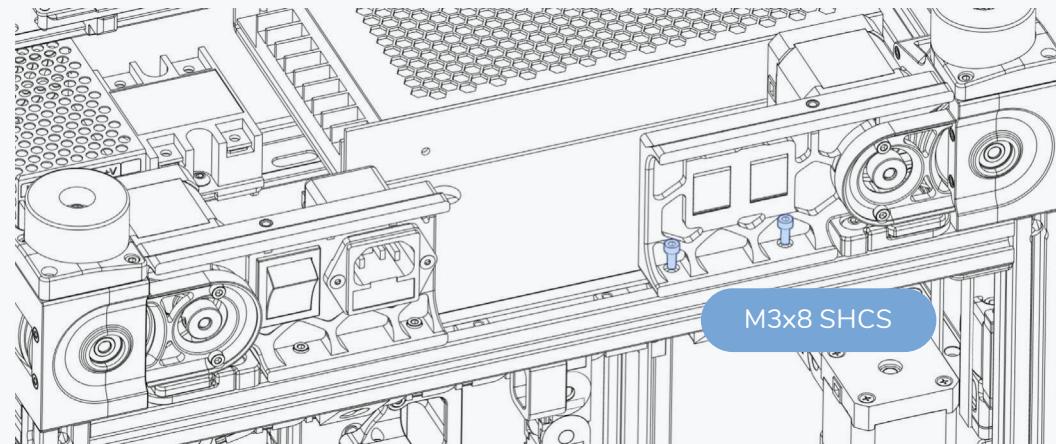
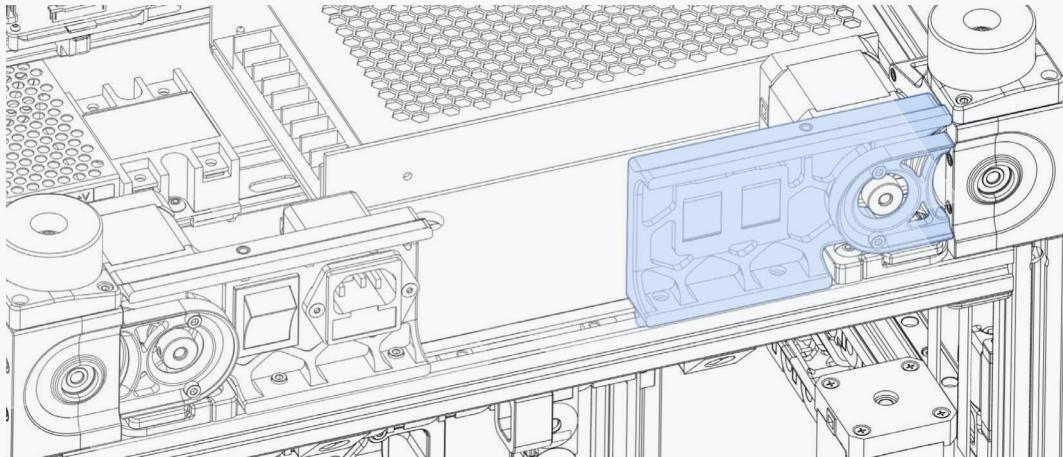
M3x8 SHCS



M3 T-Nut

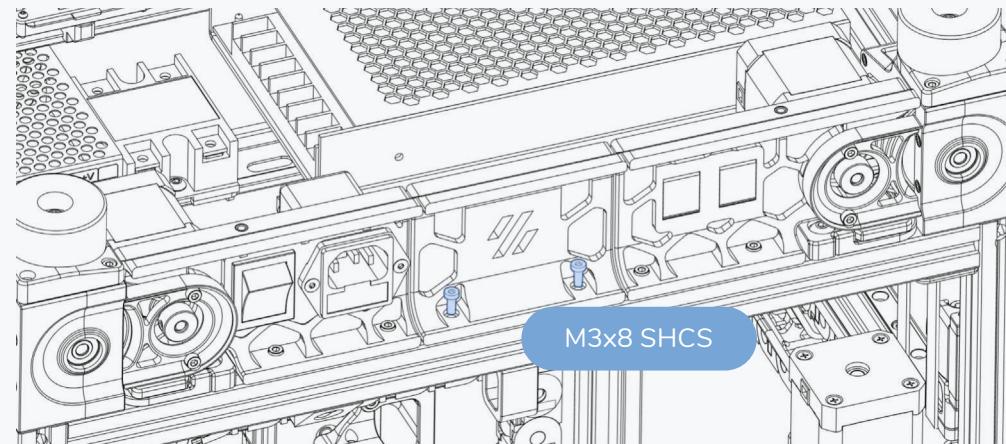
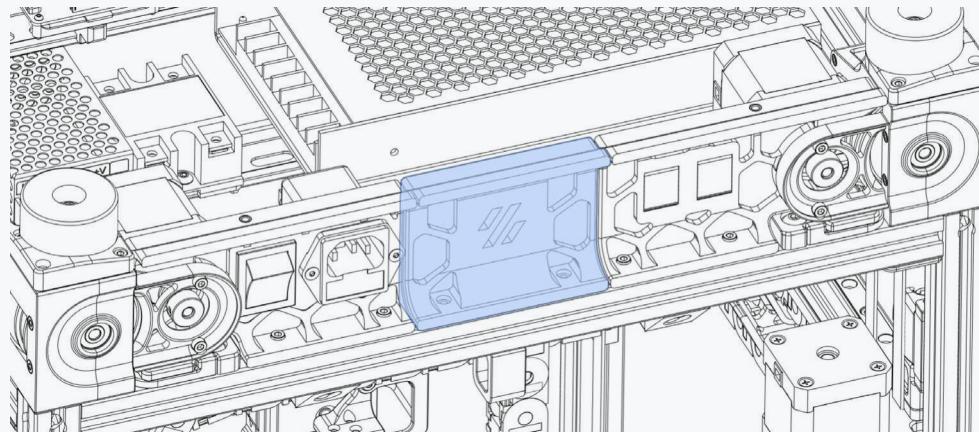
SKIRTS

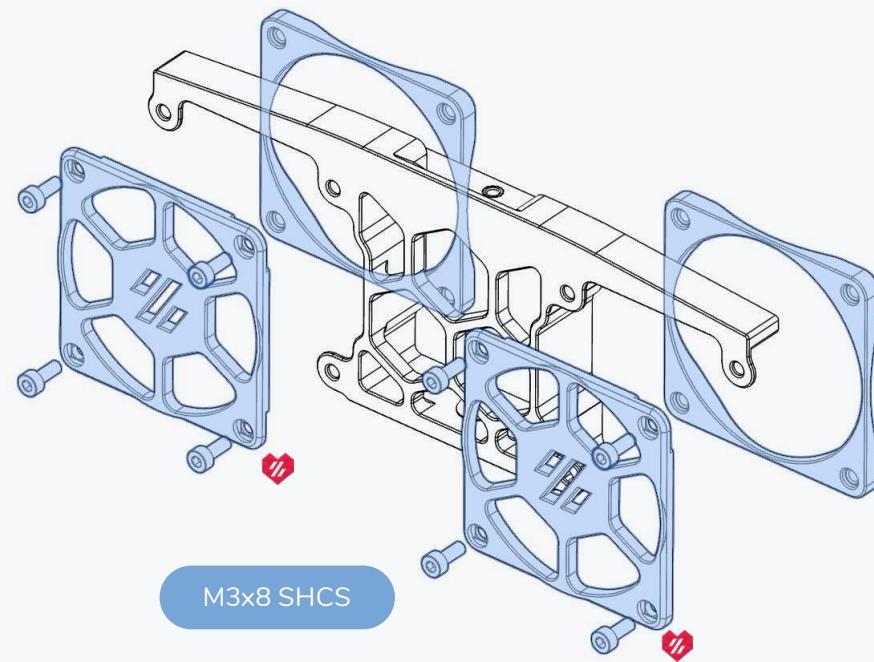
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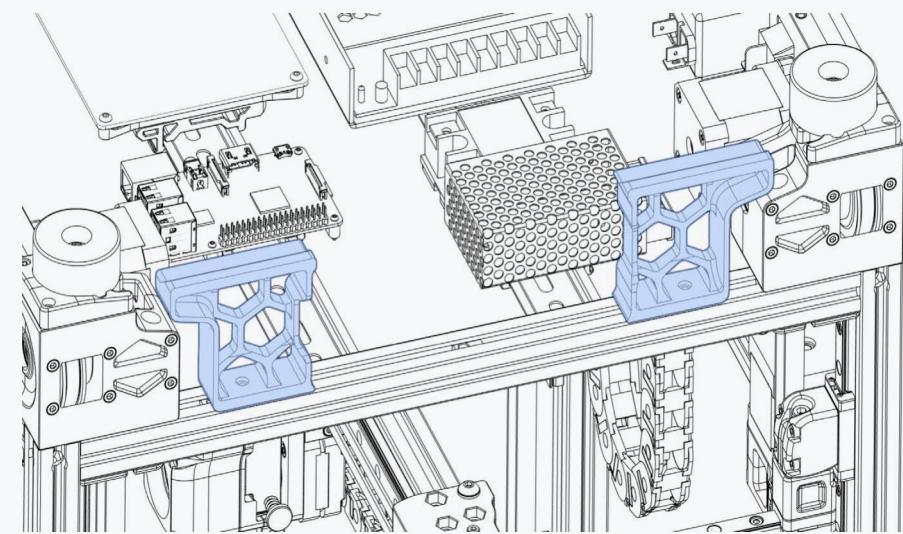
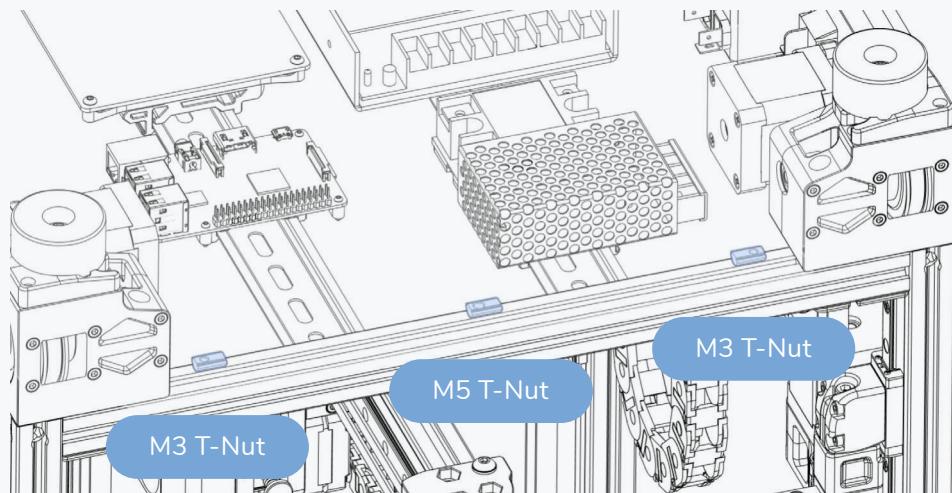


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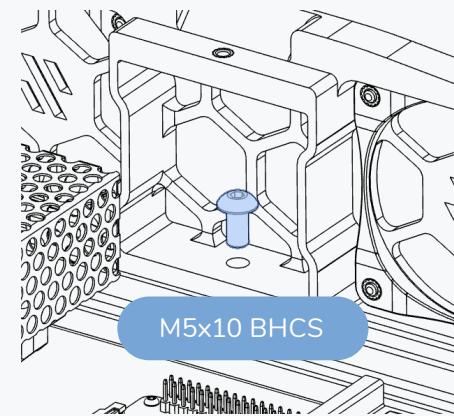
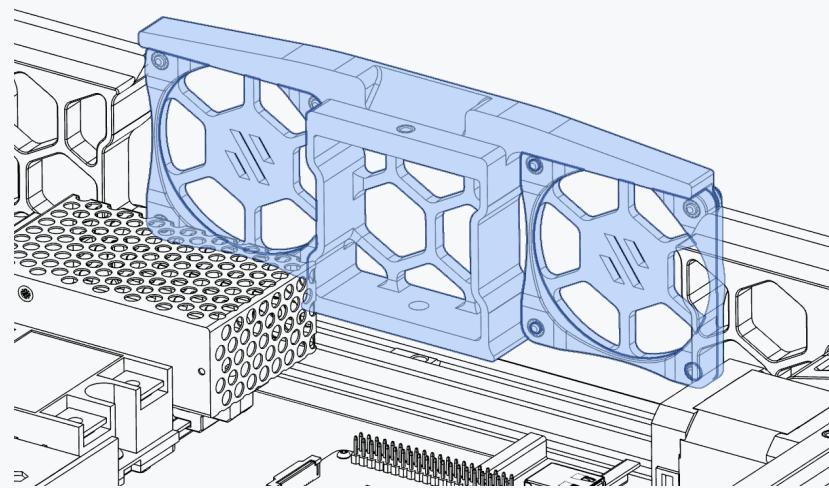
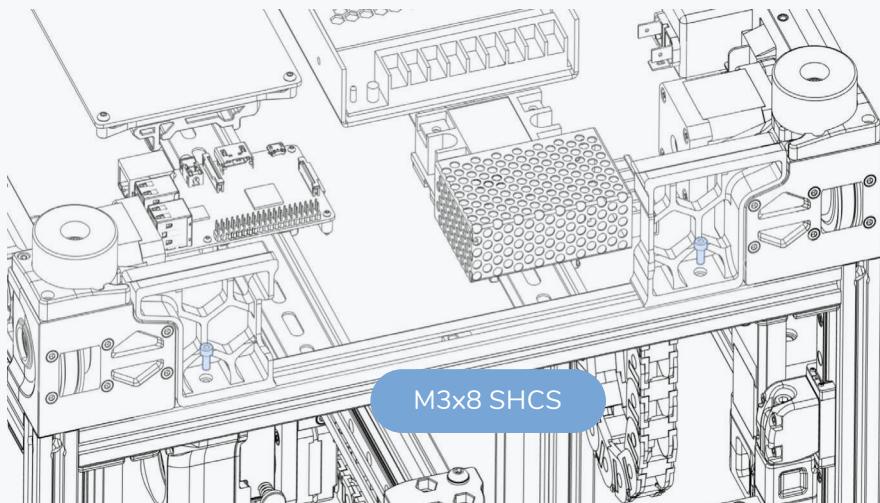


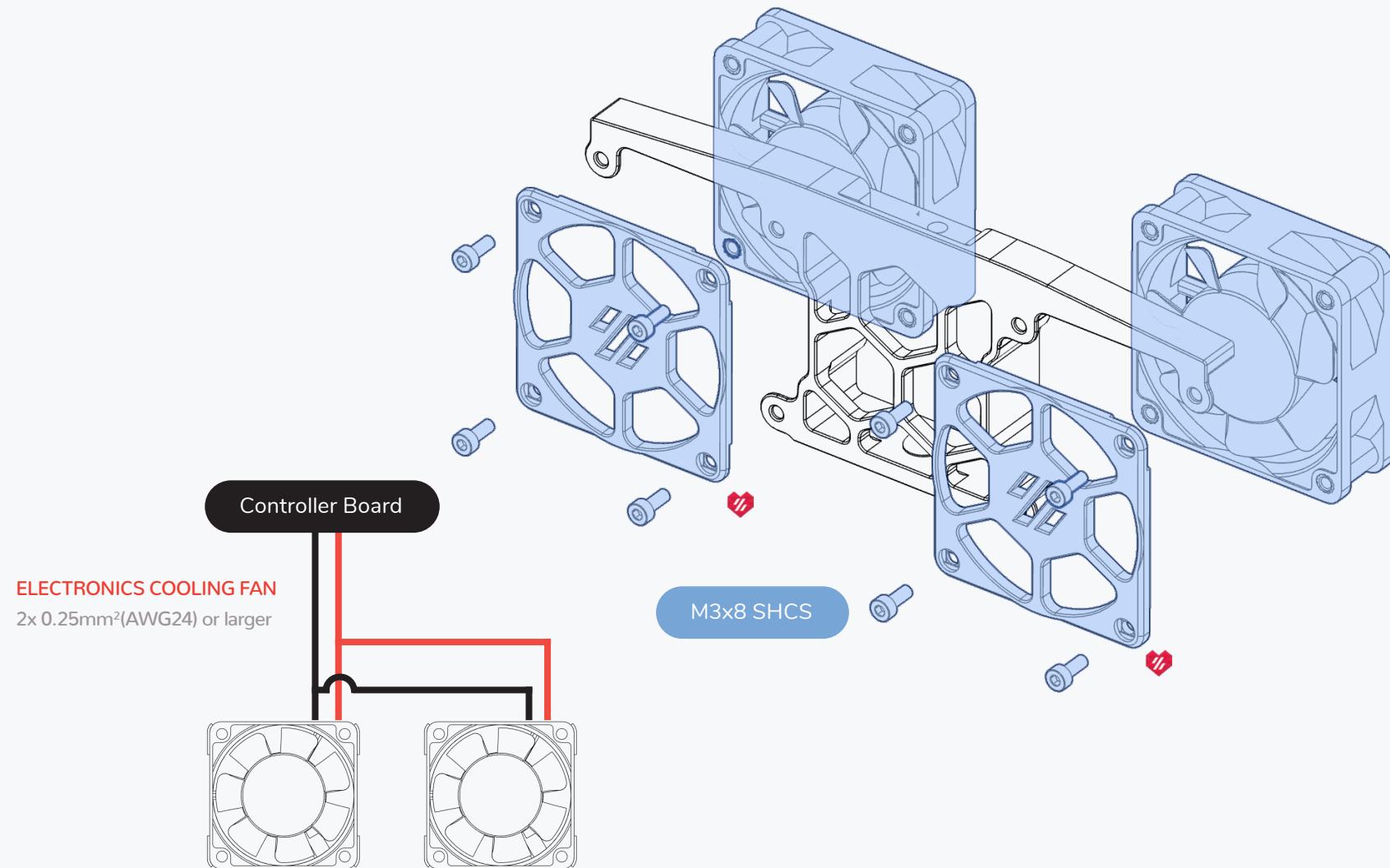




SKIRTS

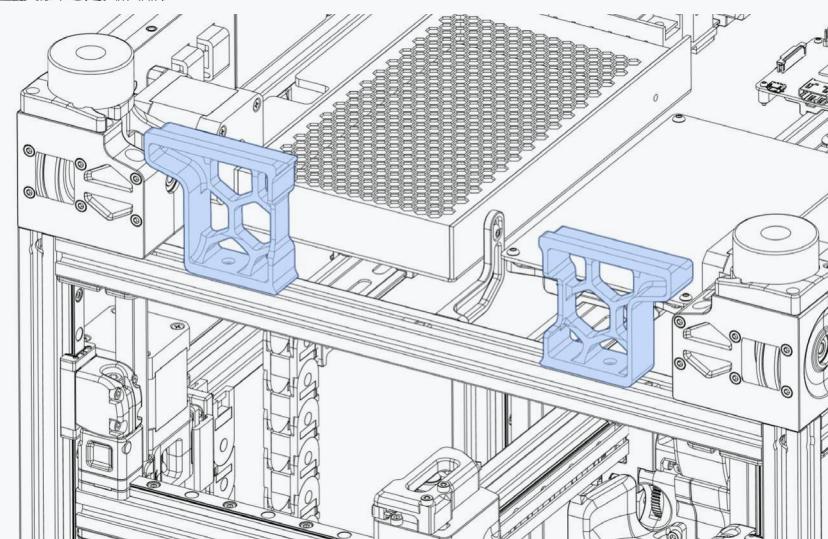
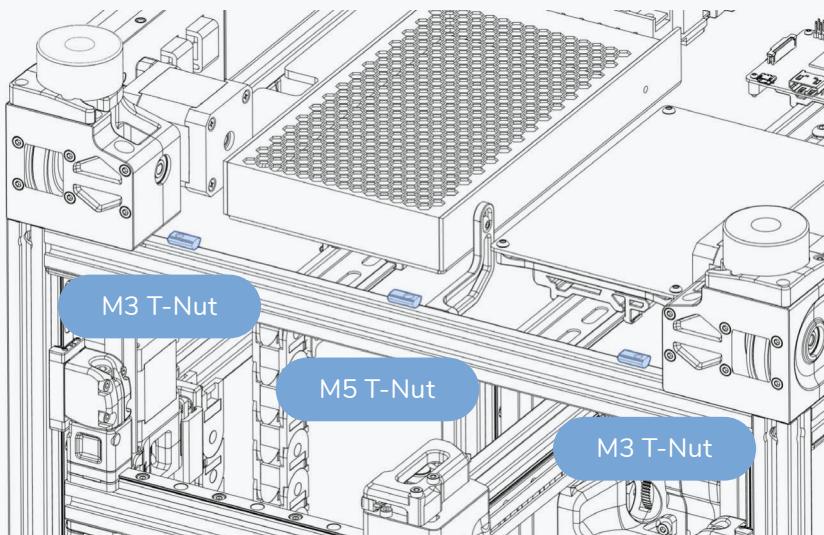
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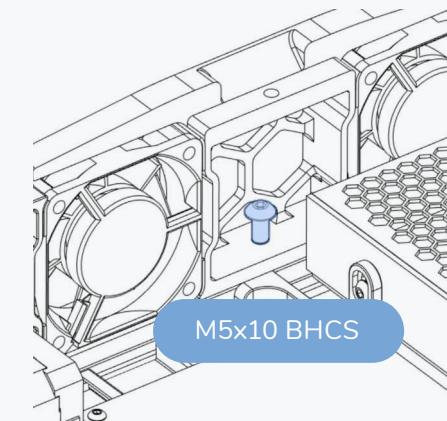
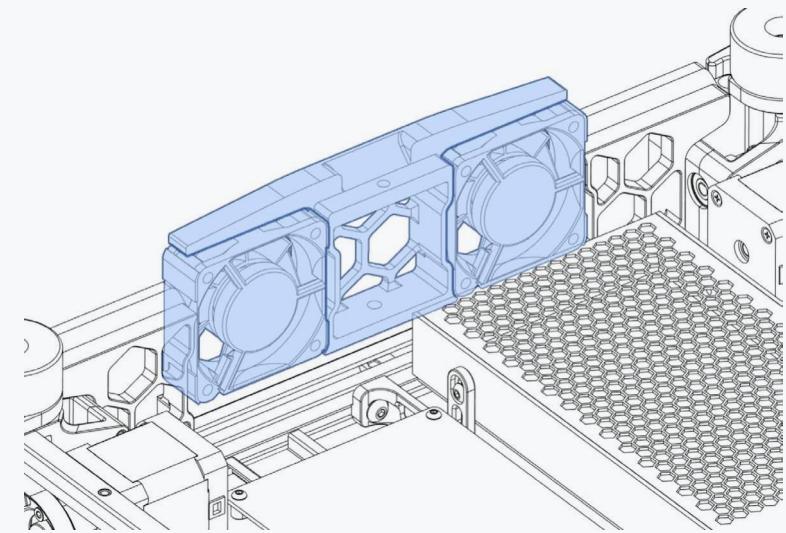
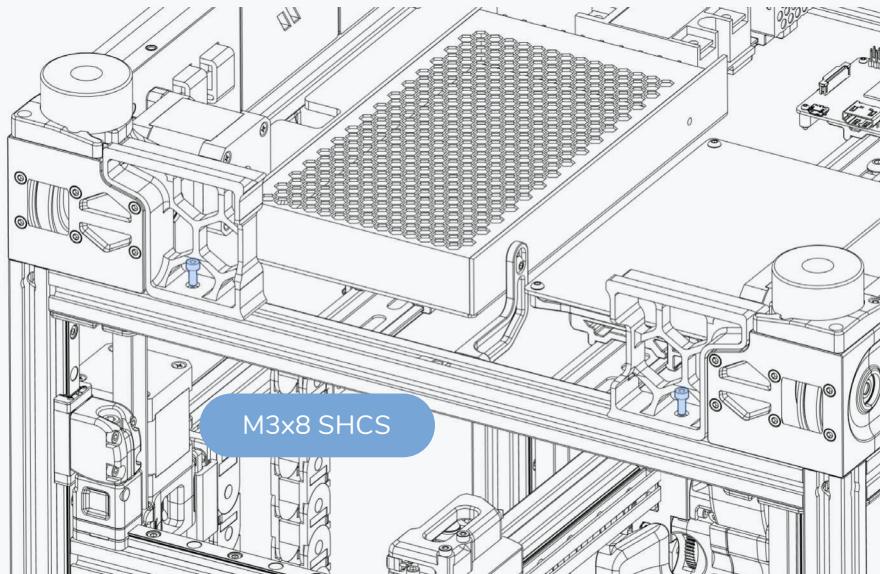
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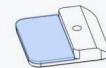
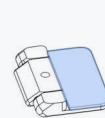
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SKIRTS

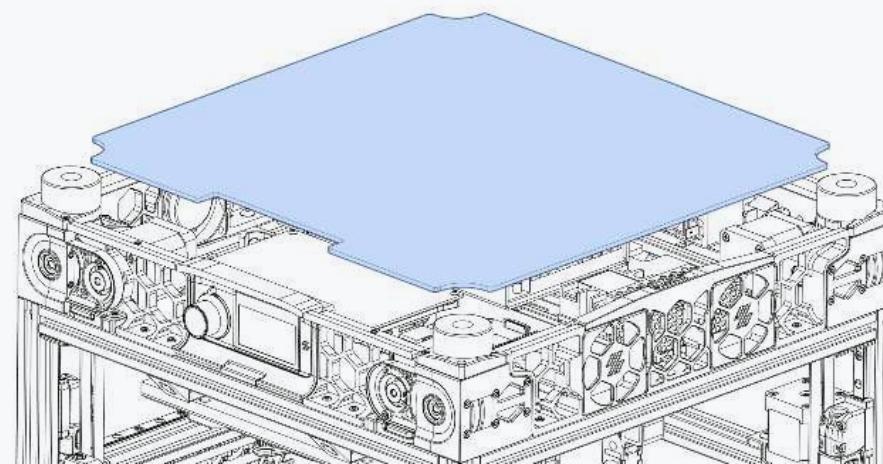
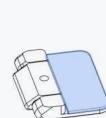
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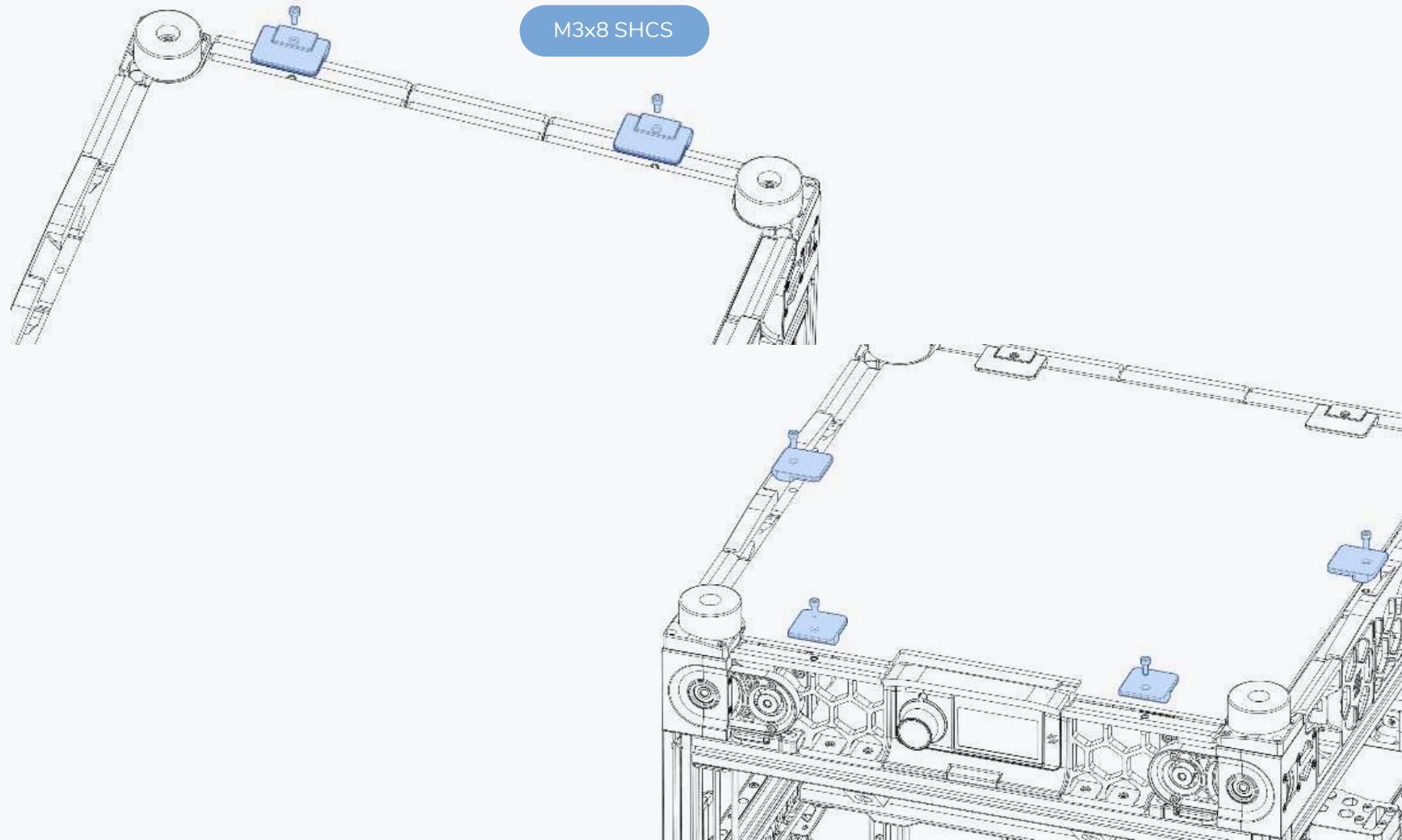


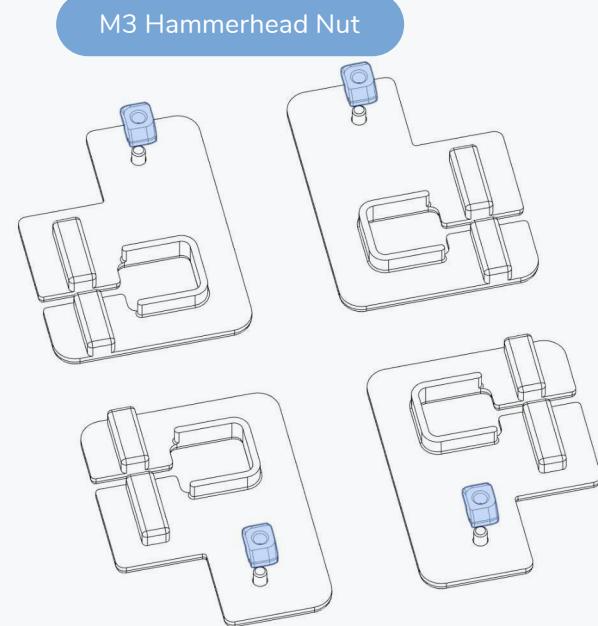
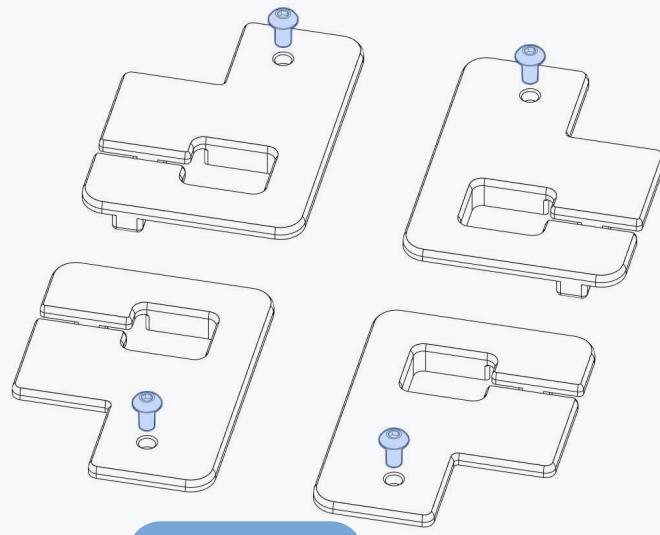


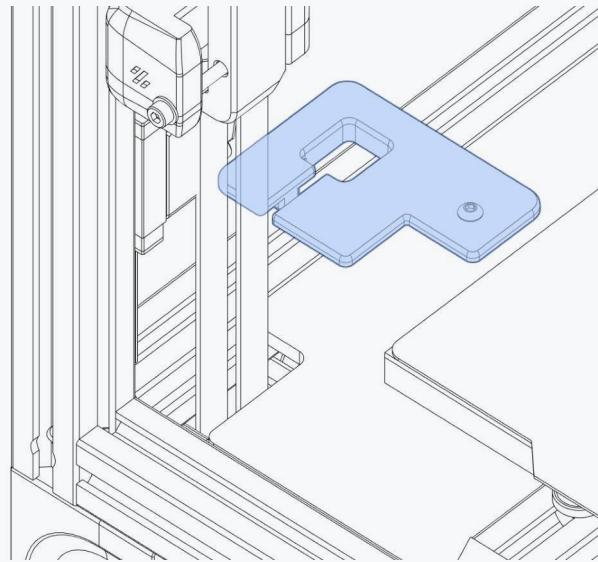
APPLY VHB TAPE

VHB Tape is a double sided adhesive tape.



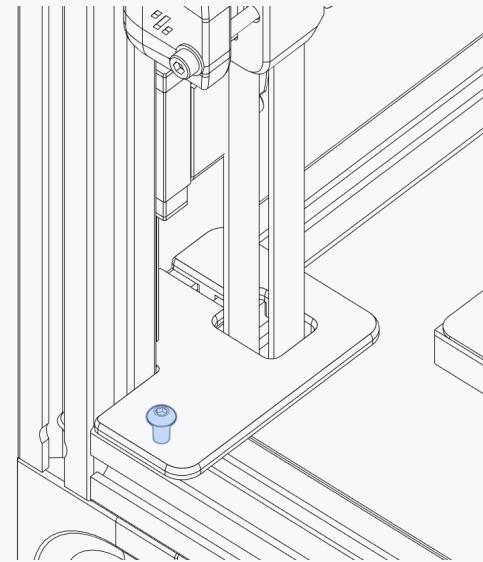
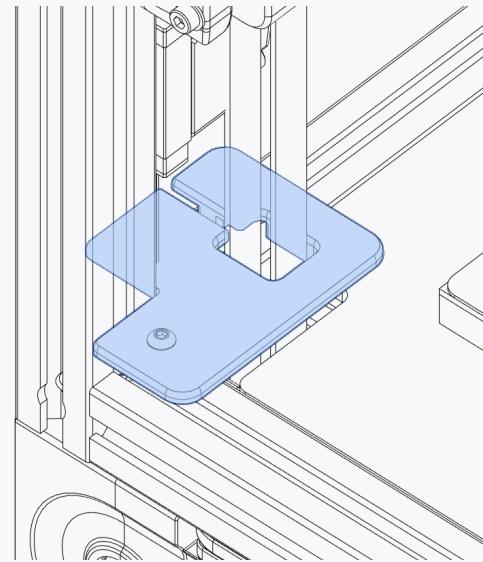






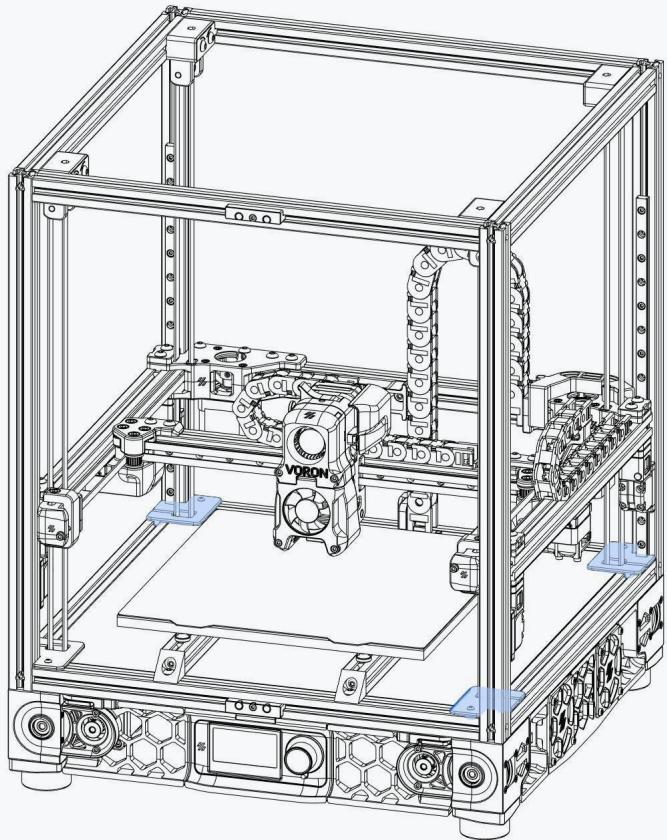
PINCH BELT

Pinch the Z belt loop flat
and slide the cover in place.



TURN TO FASTEN

The hammerhead nut will rotate and
lock into place when you fasten the
screw. At least that's the theory.



REPEAT FOR REMAINING COVERS

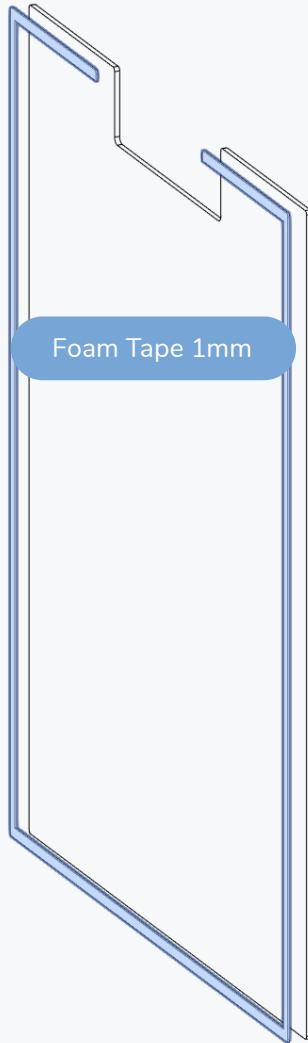
Repeat the assembly steps and install the remaining 3 covers.

Voron2.4 was released on May 13 2020. Between the releases of 2.4 and 2.4R2 over 2500 Voron2 printers have been build and serialized.

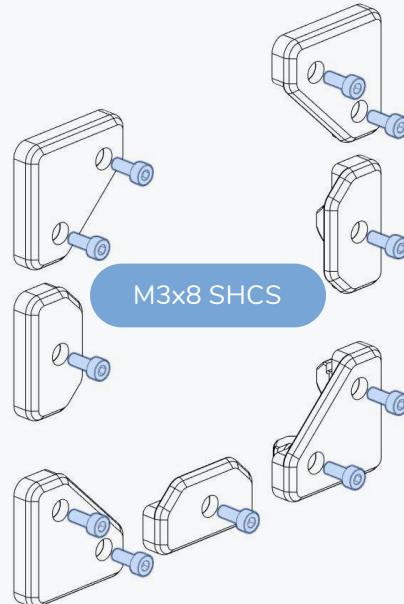
PANELS

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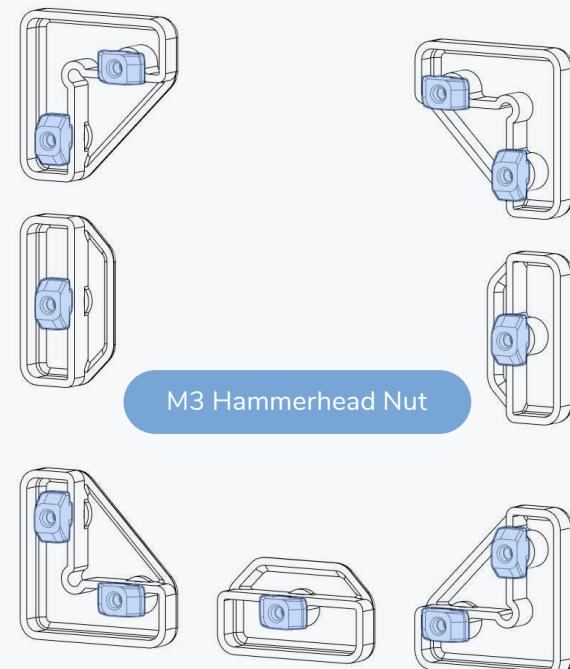


**APPLY FOAM TAPE**

Use foam tape on the contact areas between the panels and the frame to mitigate noise from vibrations.

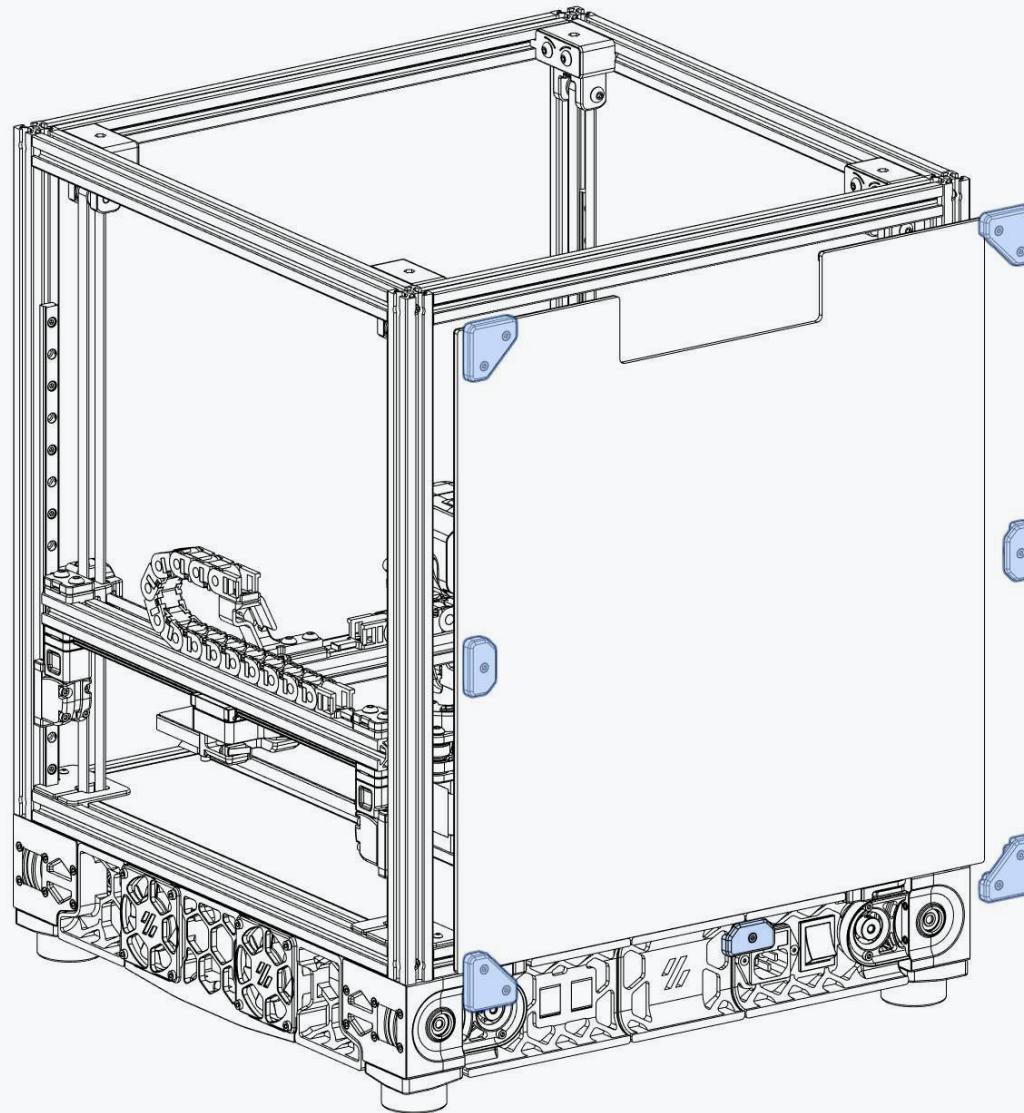
**HAMMERHEAD NUTS?**

A drop of thread locker will turn the hammerhead nuts into a 1/4 turn quick release for the panels. Best done once the assembly is finished.



BACK PANEL

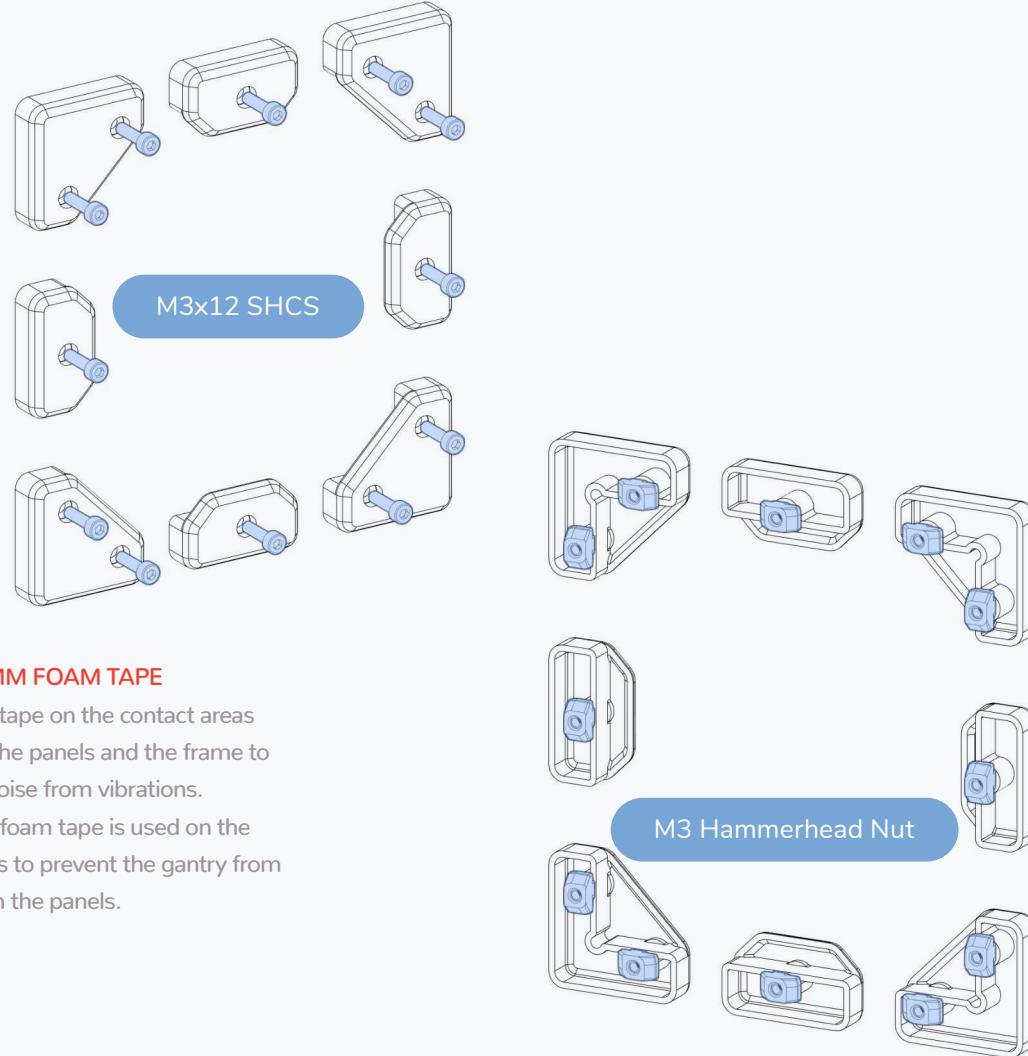
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**APPLY 3MM FOAM TAPE**

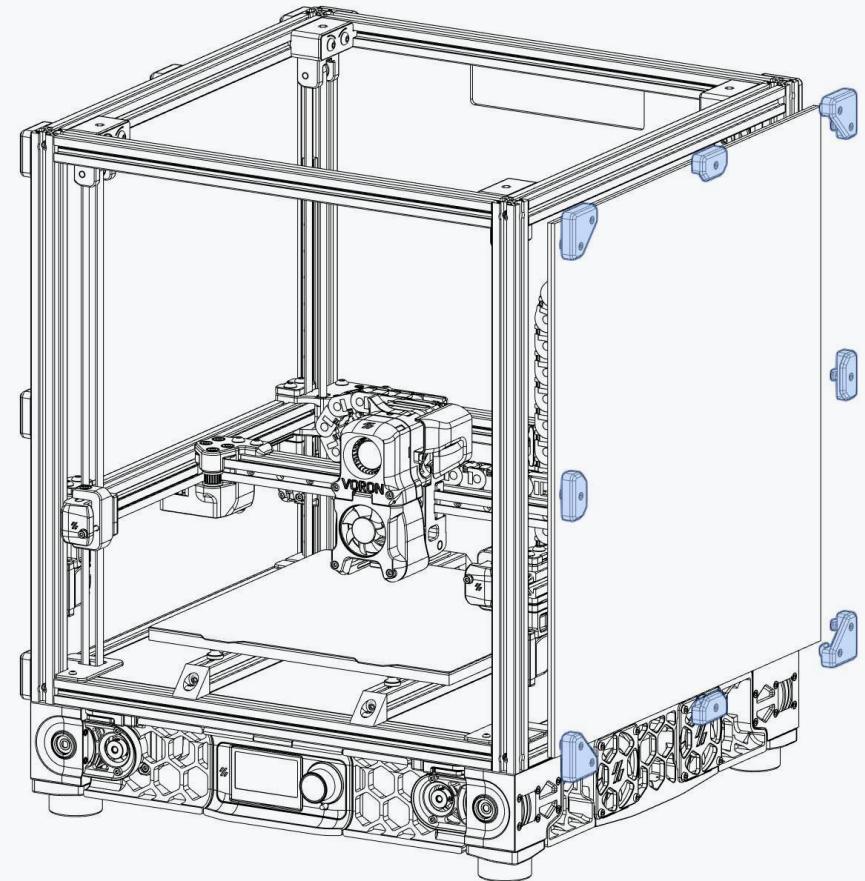
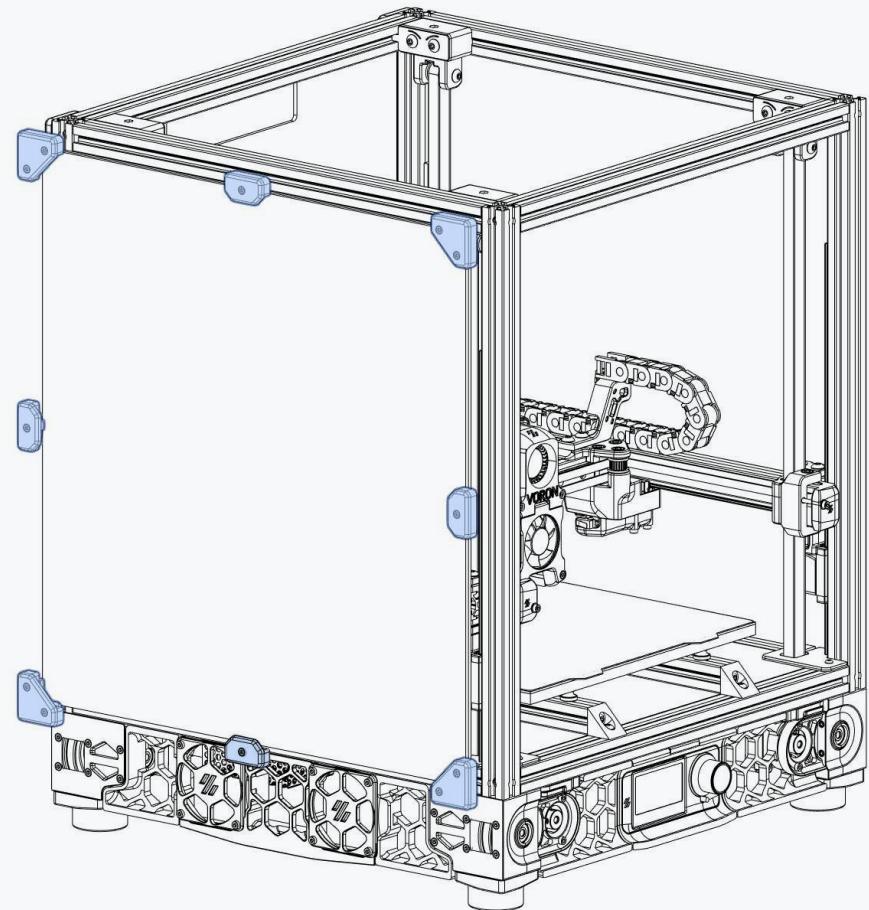
Use foam tape on the contact areas between the panels and the frame to mitigate noise from vibrations.

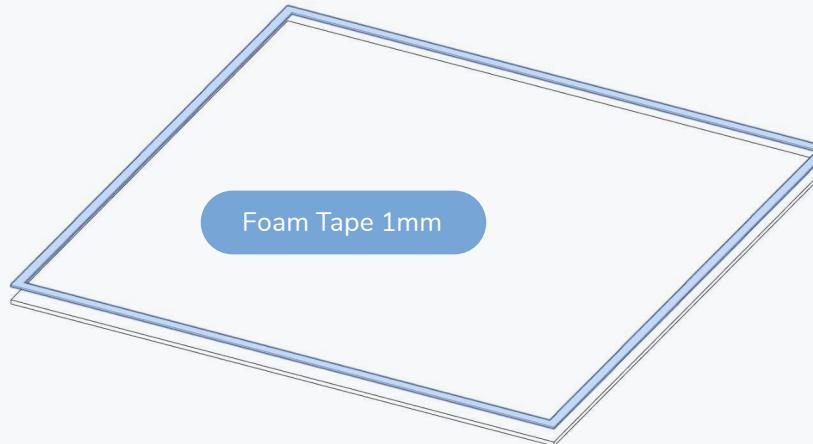
The 3mm foam tape is used on the side panels to prevent the gantry from rubbing on the panels.



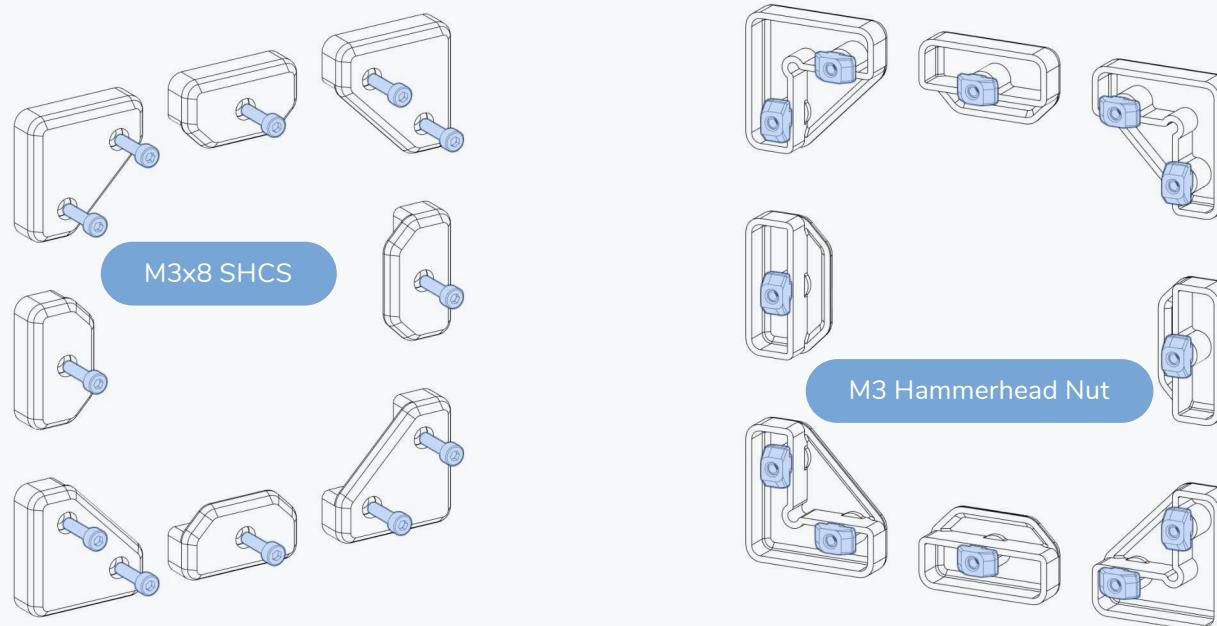
SIDE PANELS

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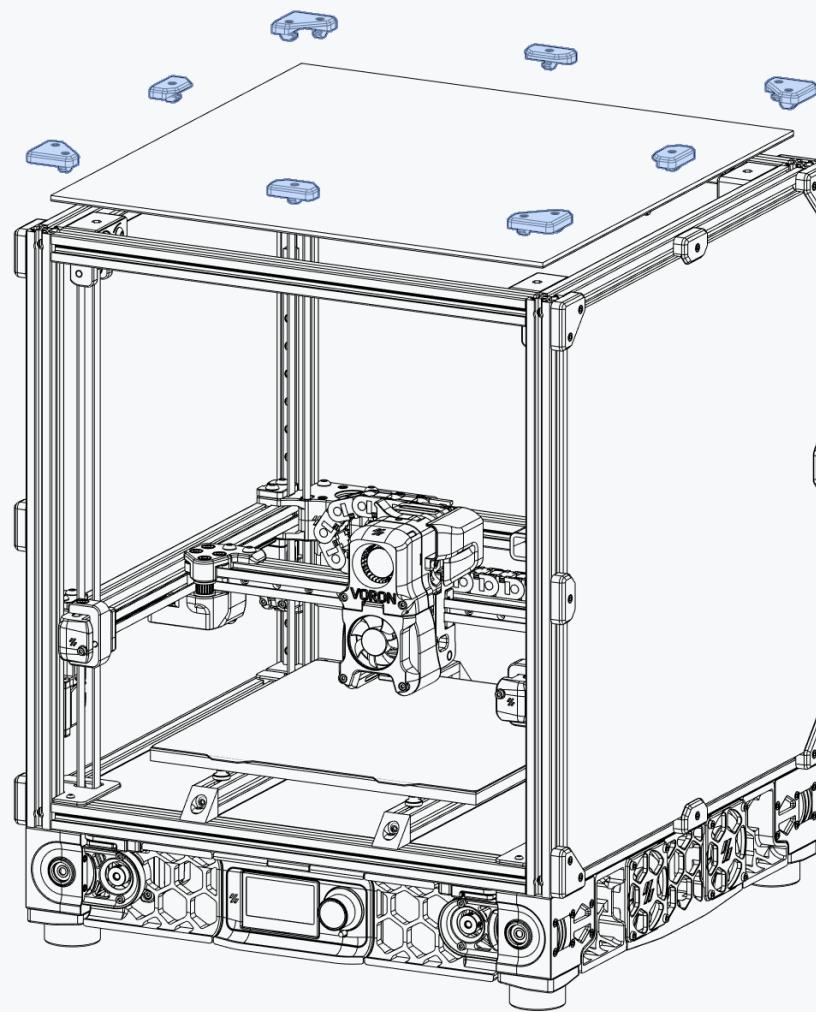
**APPLY FOAM TAPE**

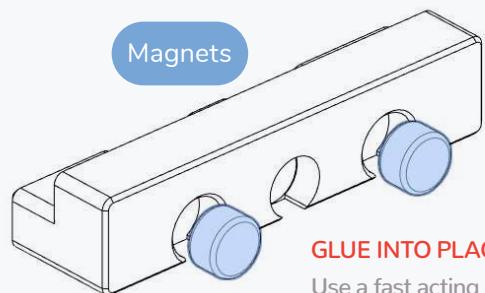
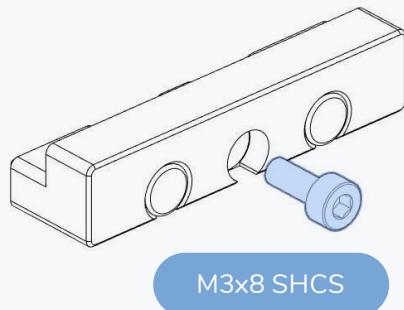
Use foam tape on the contact areas between the panels and the frame to mitigate noise from vibrations.



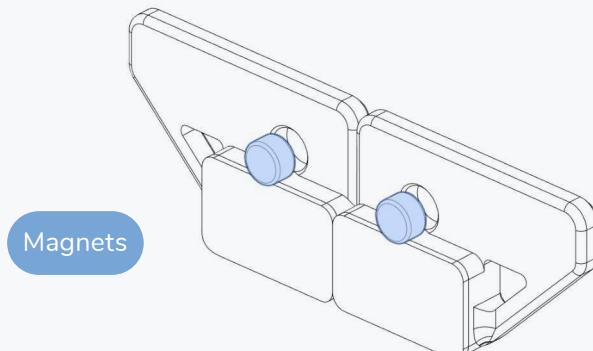
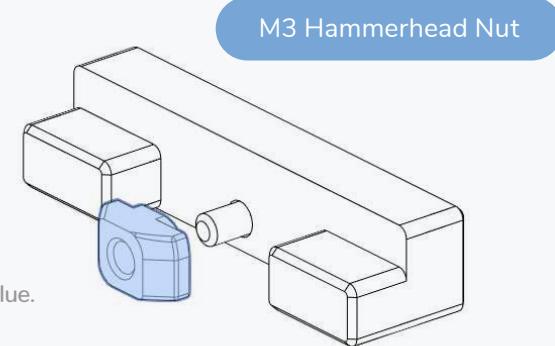
TOP PANEL

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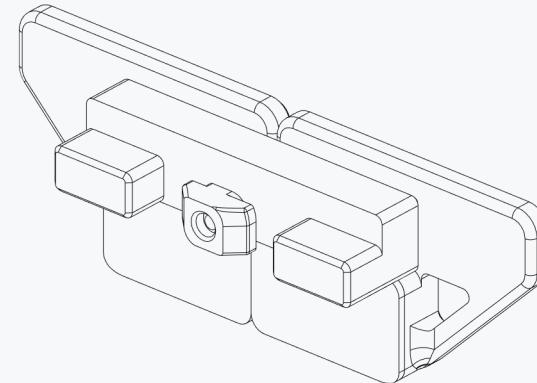


**GLUE INTO PLACE**

Use a fast acting glue like super-glue.

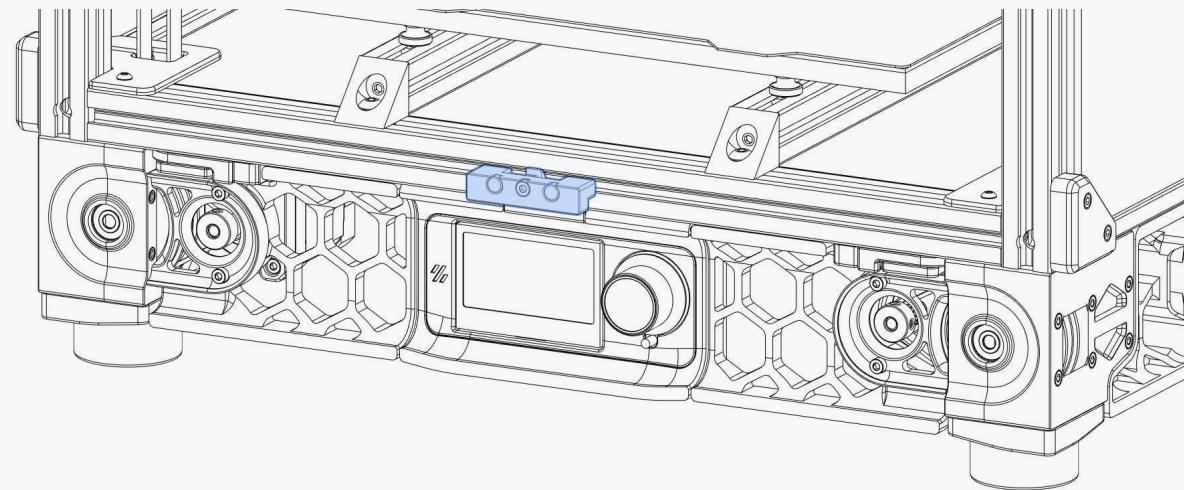
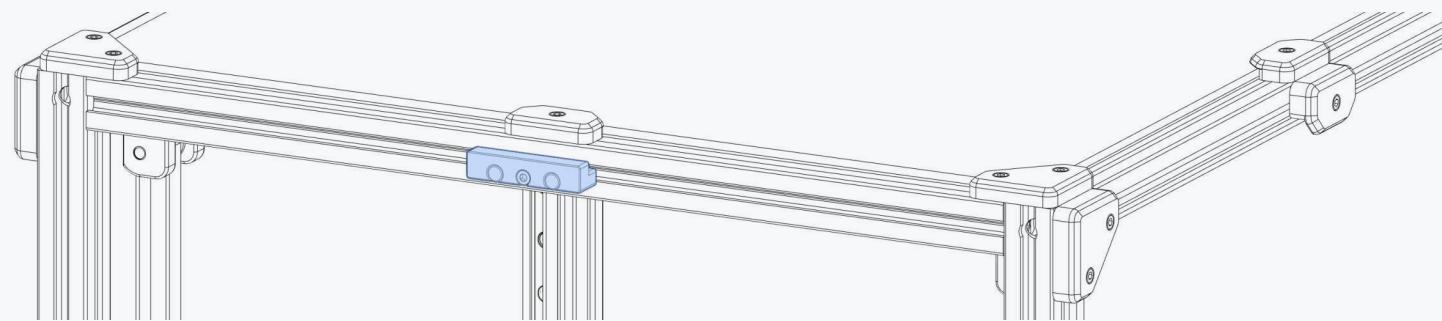
**MIND THE MAGNET POLARITY**

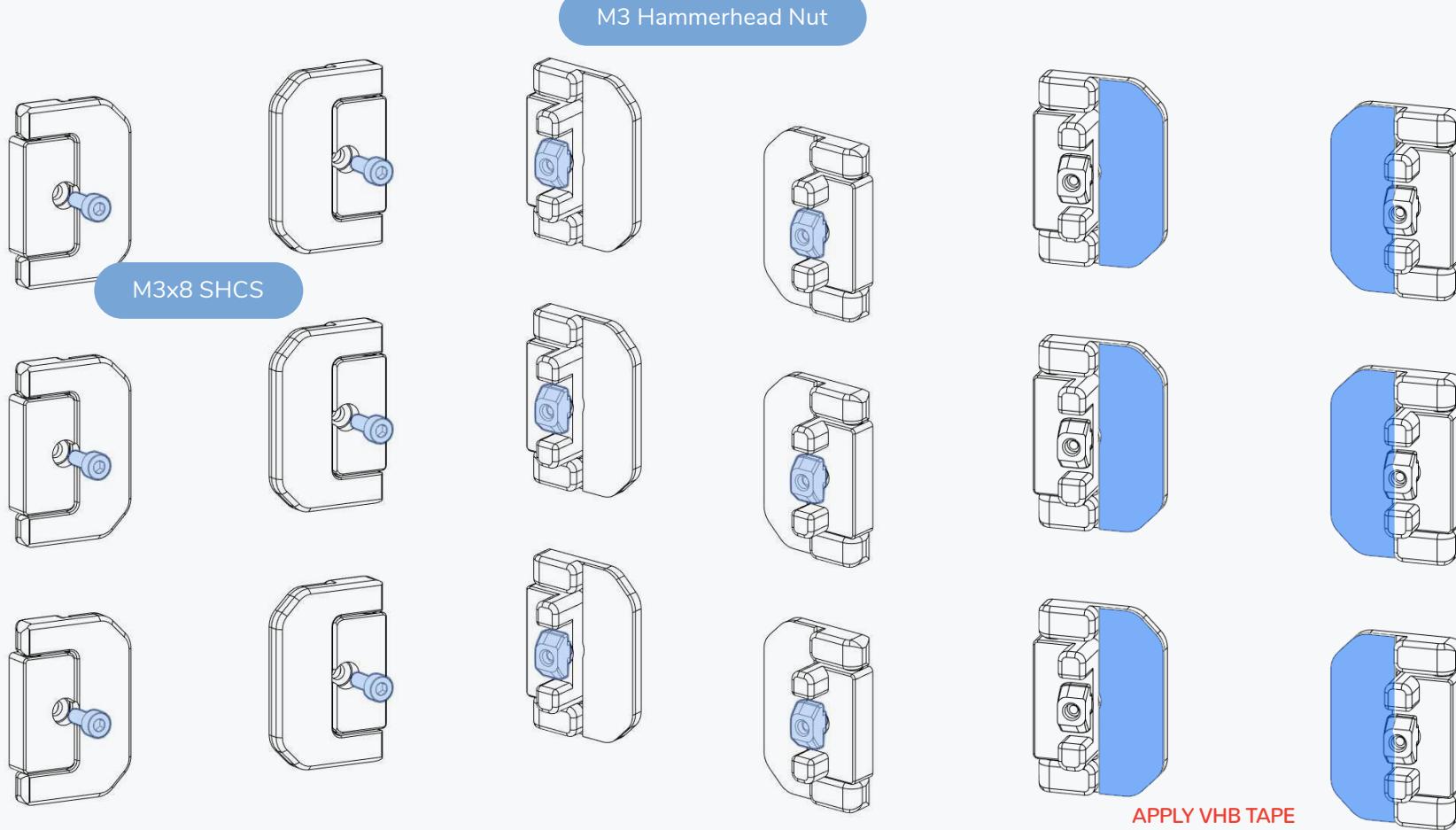
Ensure that the magnets are facing in the right direction prior to gluing them into place.



DOORS

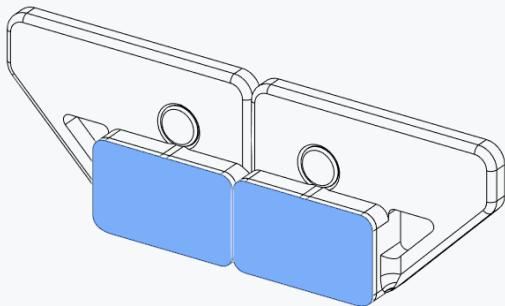
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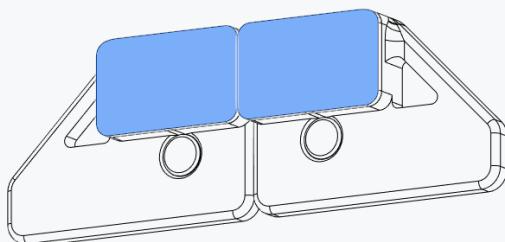


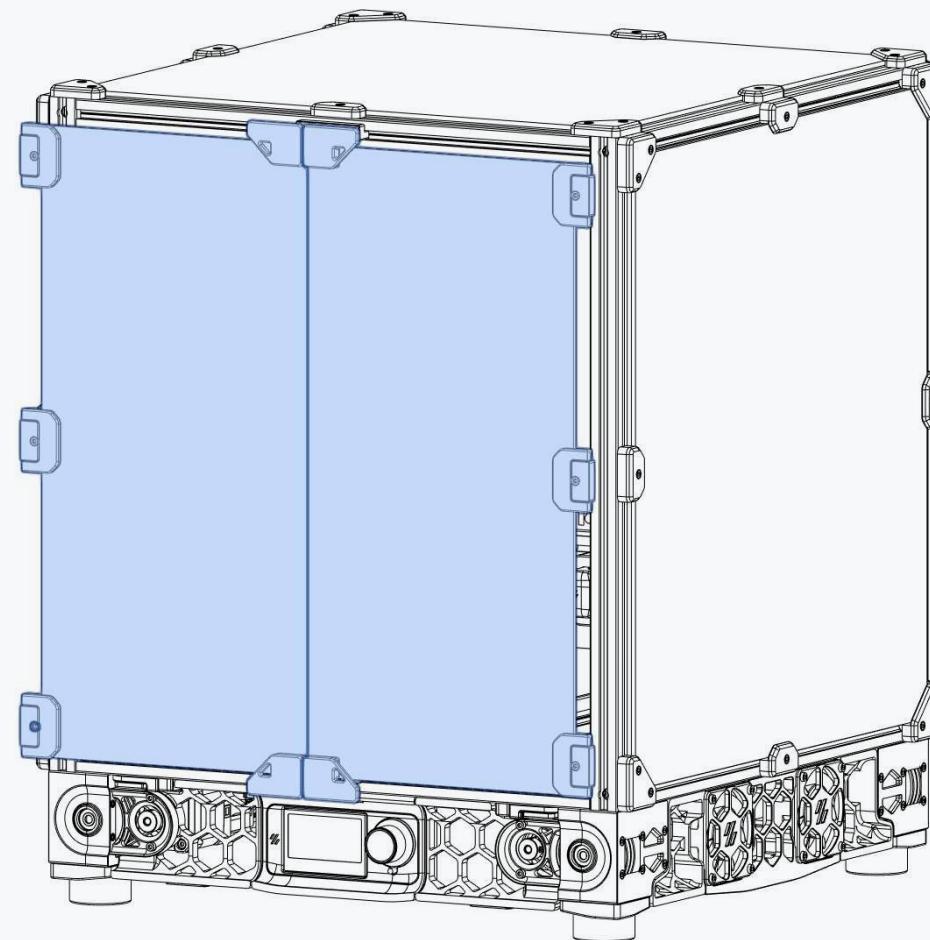
APPLY VHB TAPE

VHB Tape is a double sided
adhesive tape.

**APPLY VHB TAPE**

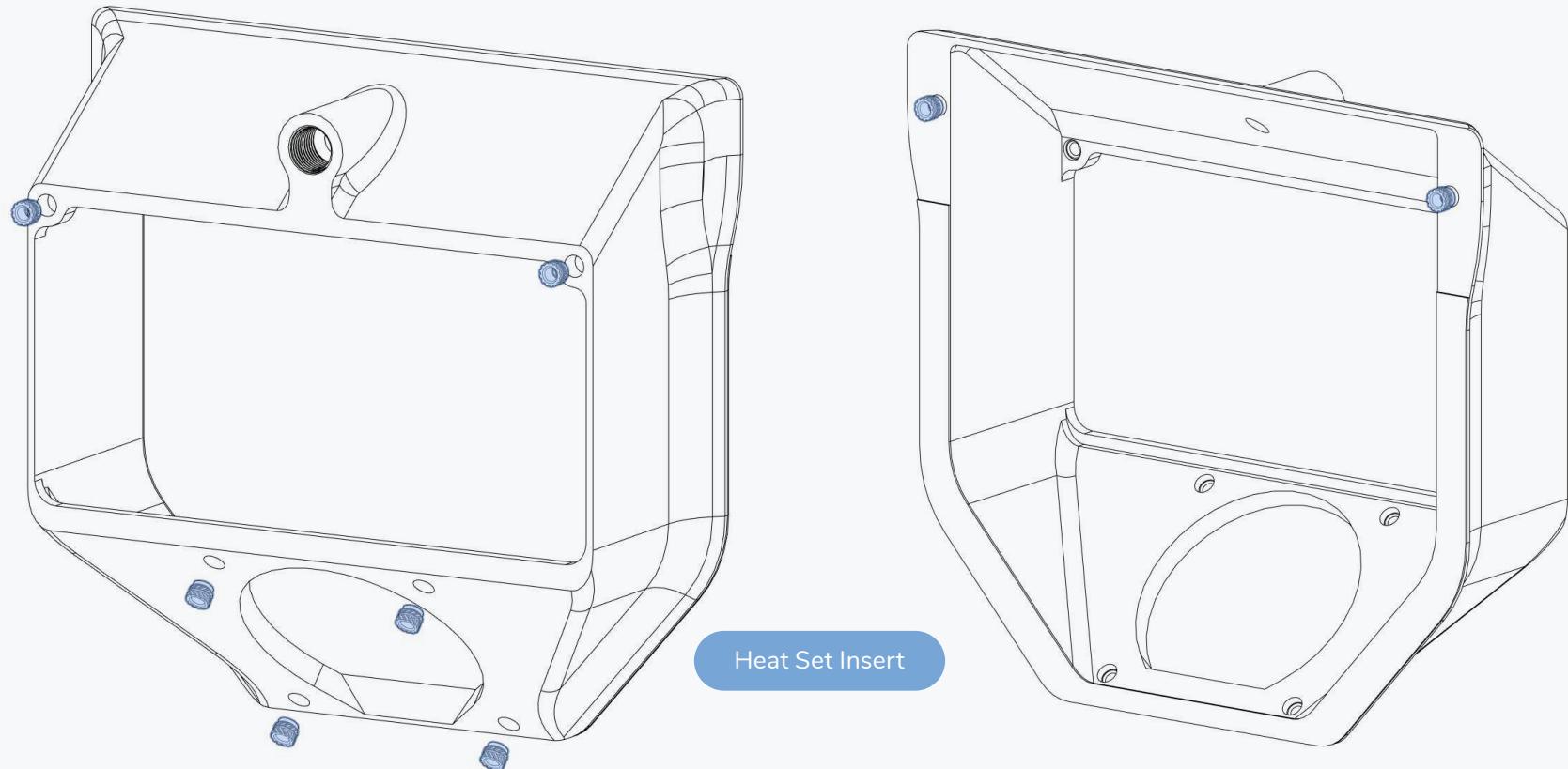
VHB Tape is a double sided adhesive tape.

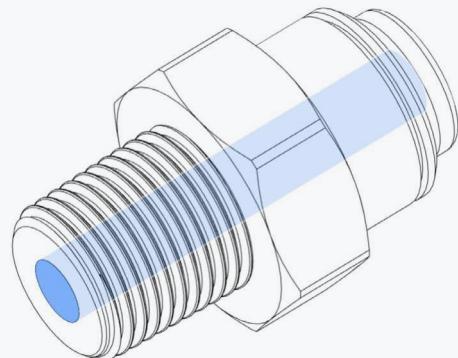




EXHAUST

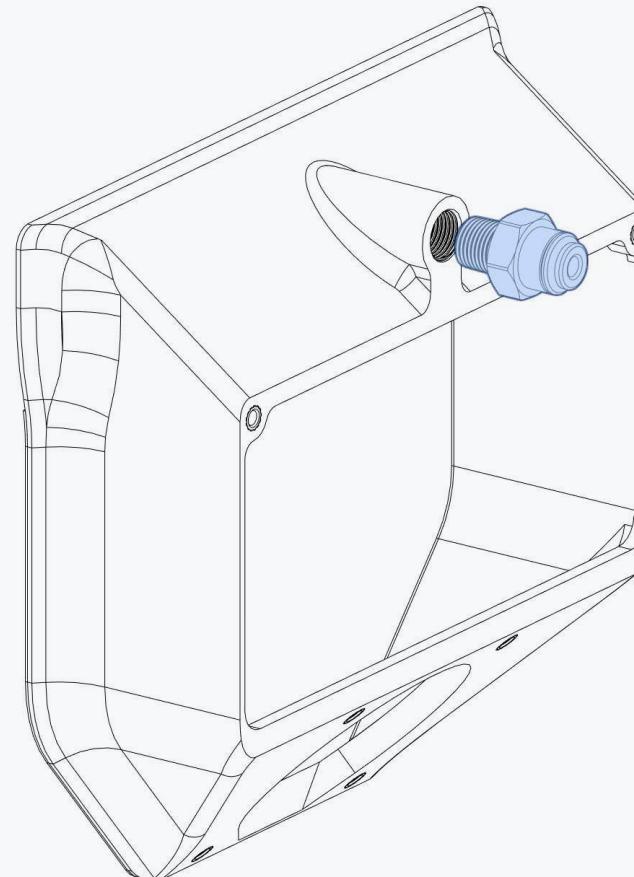
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**BSPP ADAPTER**

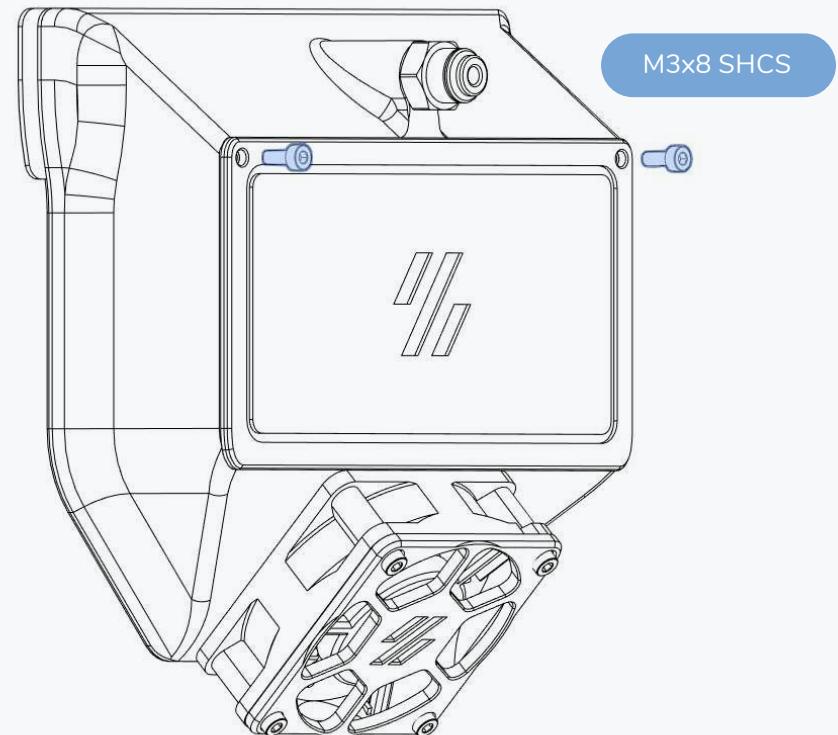
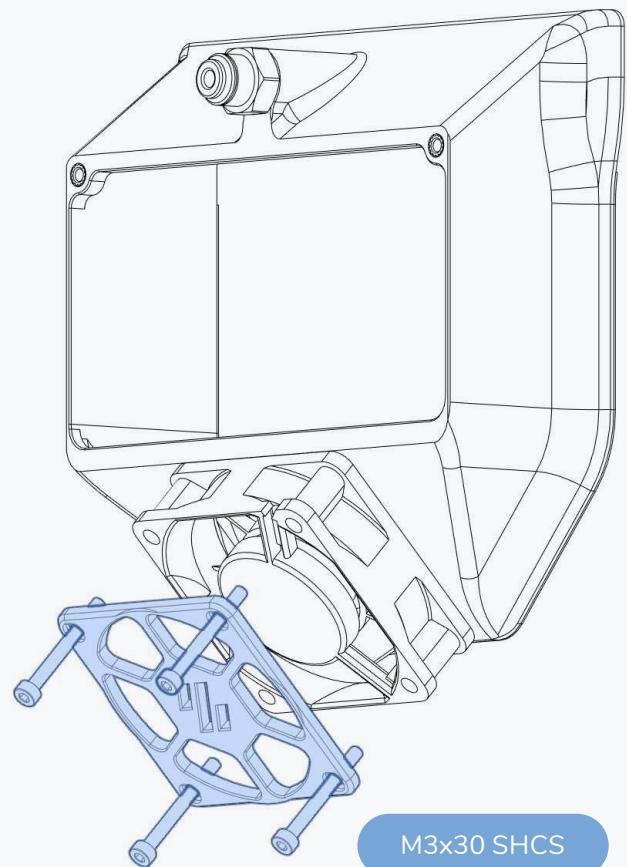
Some adapters have a small lip that prevents the PTFE tube from passing through.

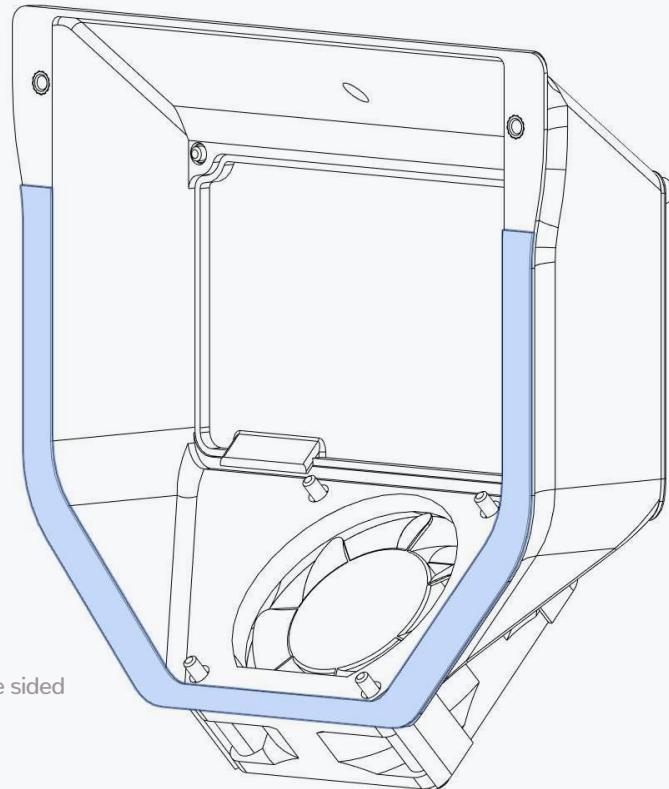
Inspect the adapter and if necessary use a drill to carefully remove the lip.



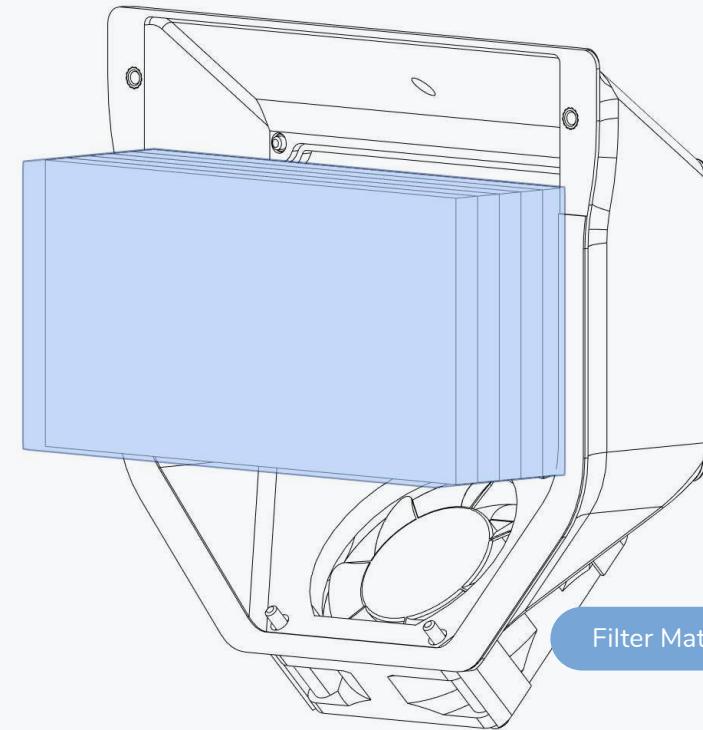
EXHAUST

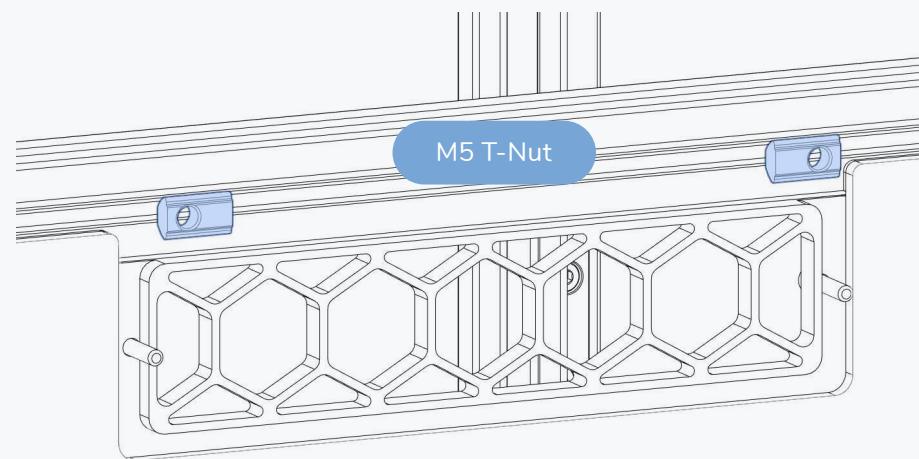
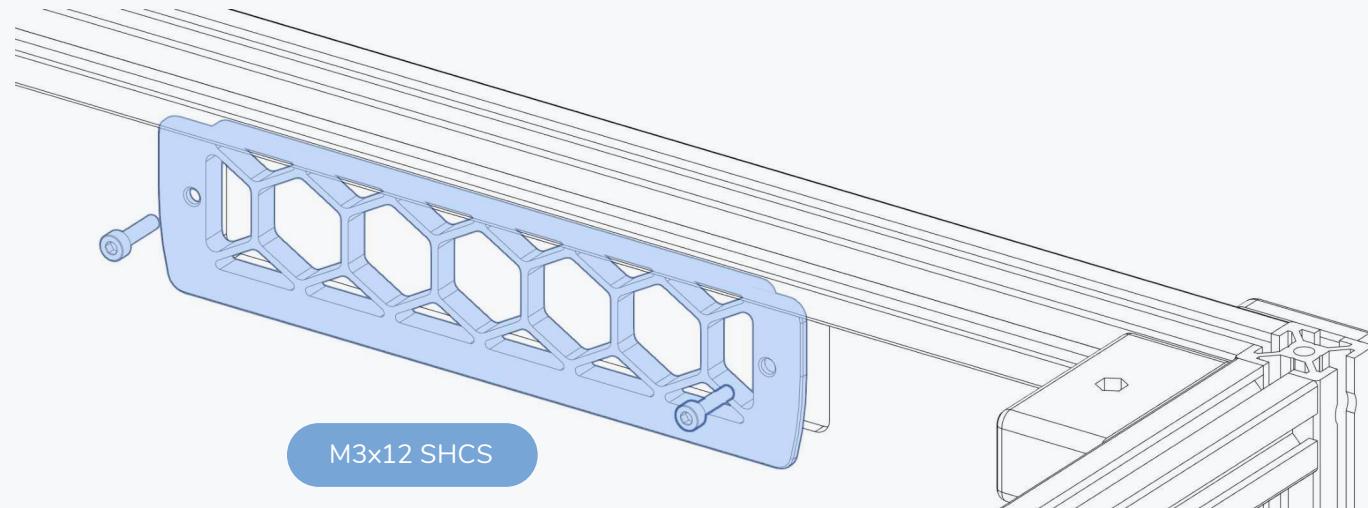
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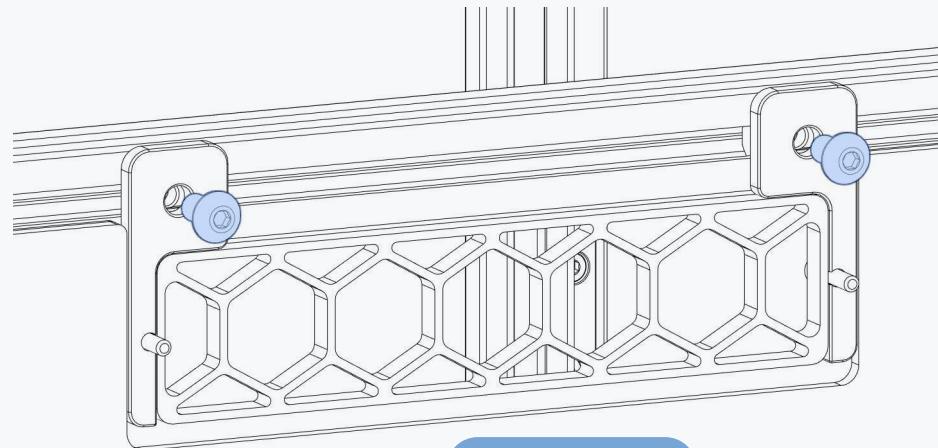
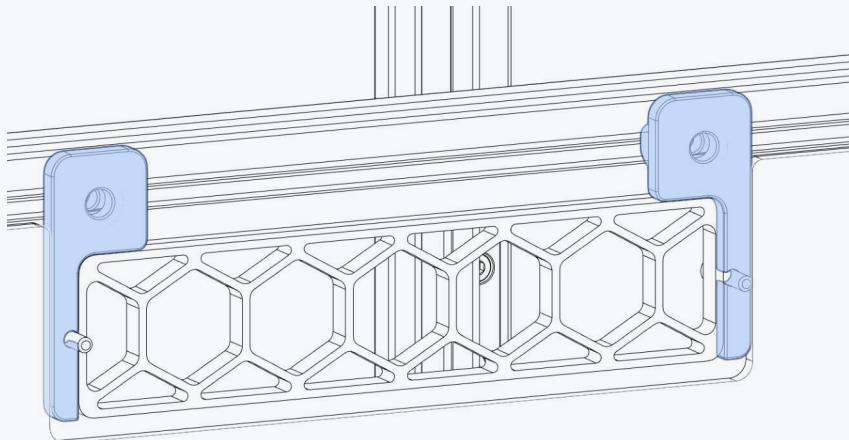


**APPLY VHB TAPE**

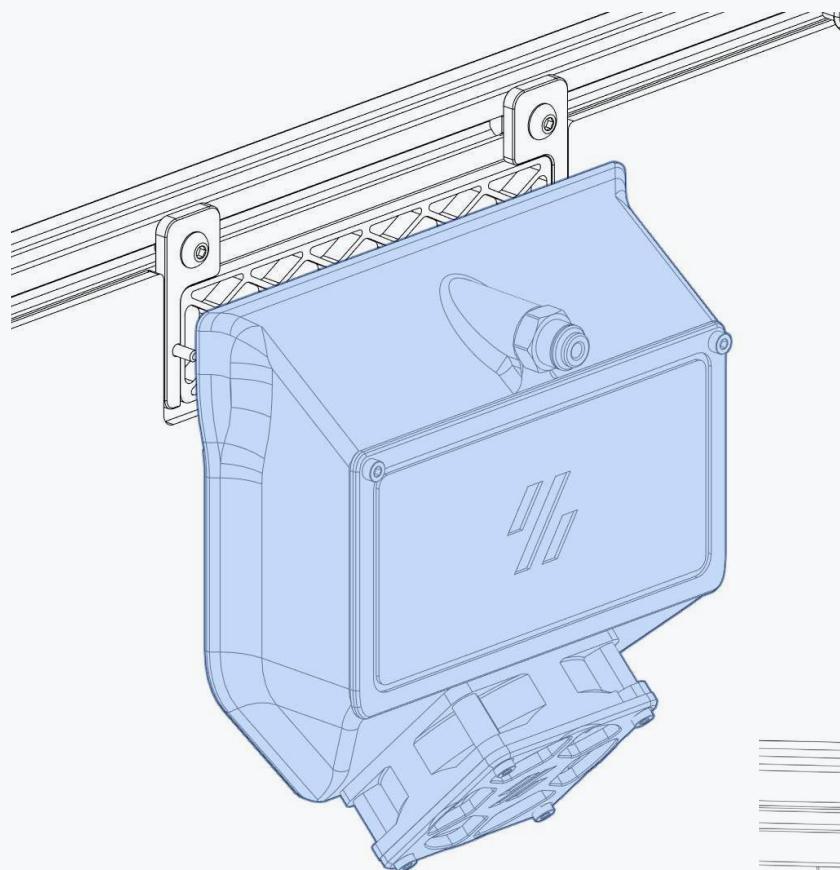
VHB Tape is a double sided adhesive tape.

**Filter Material**

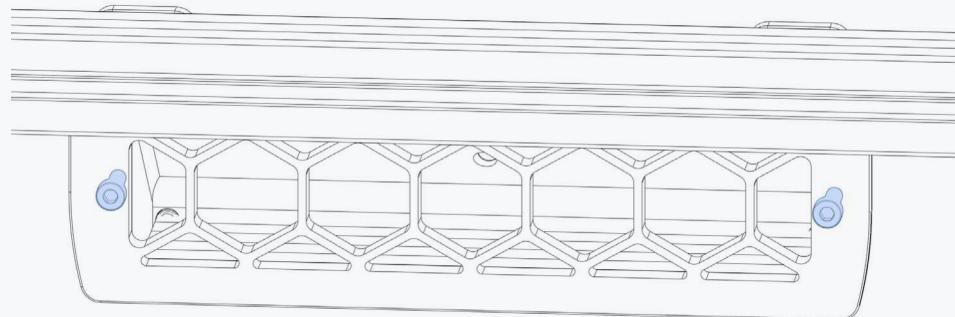




M5x10 BHCS

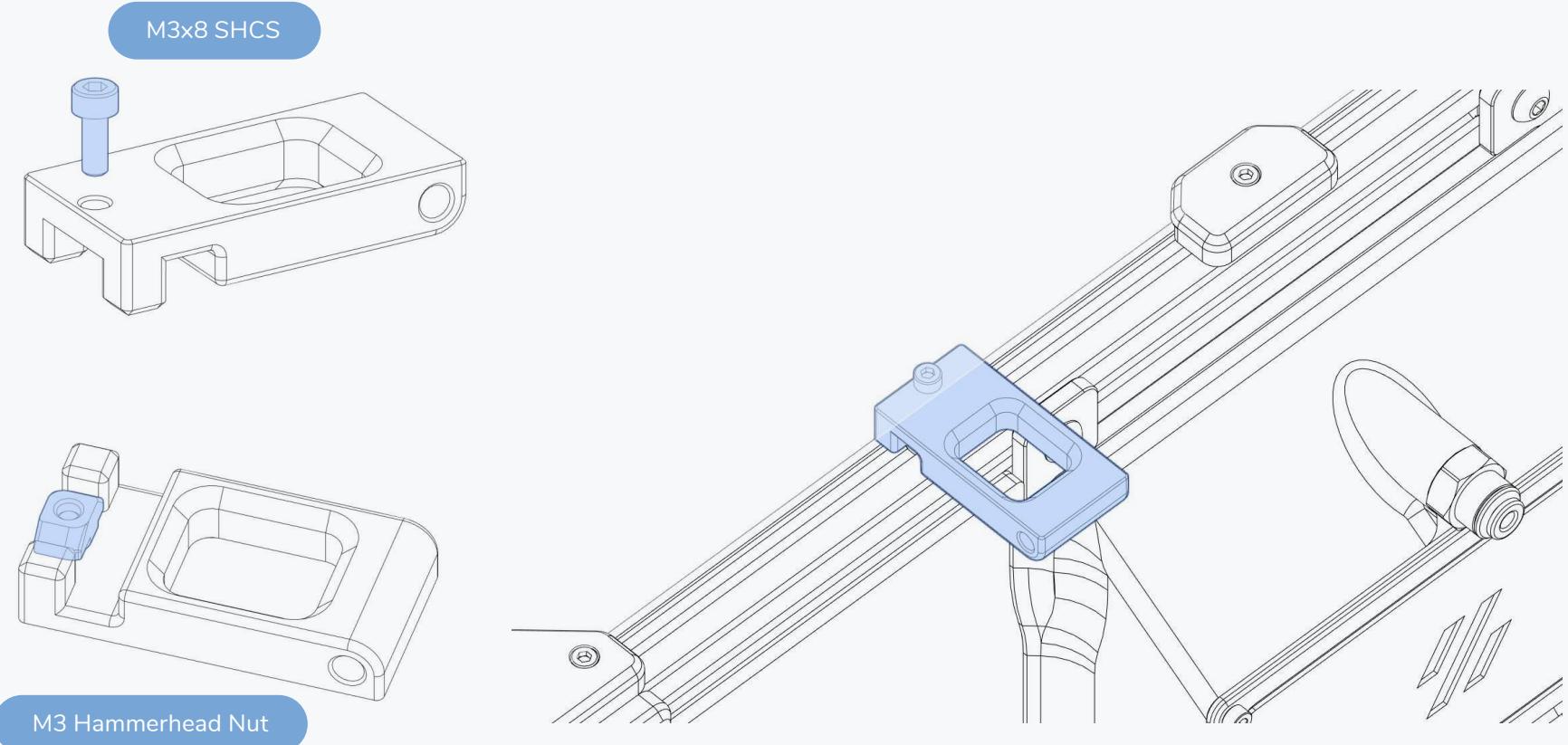
**REMOVE TAPE BACKING**

Attach the exhaust assembly to the back panel and secure it with the bolts on the other side of the exhaust gril.

TIGHTEN BOLTS

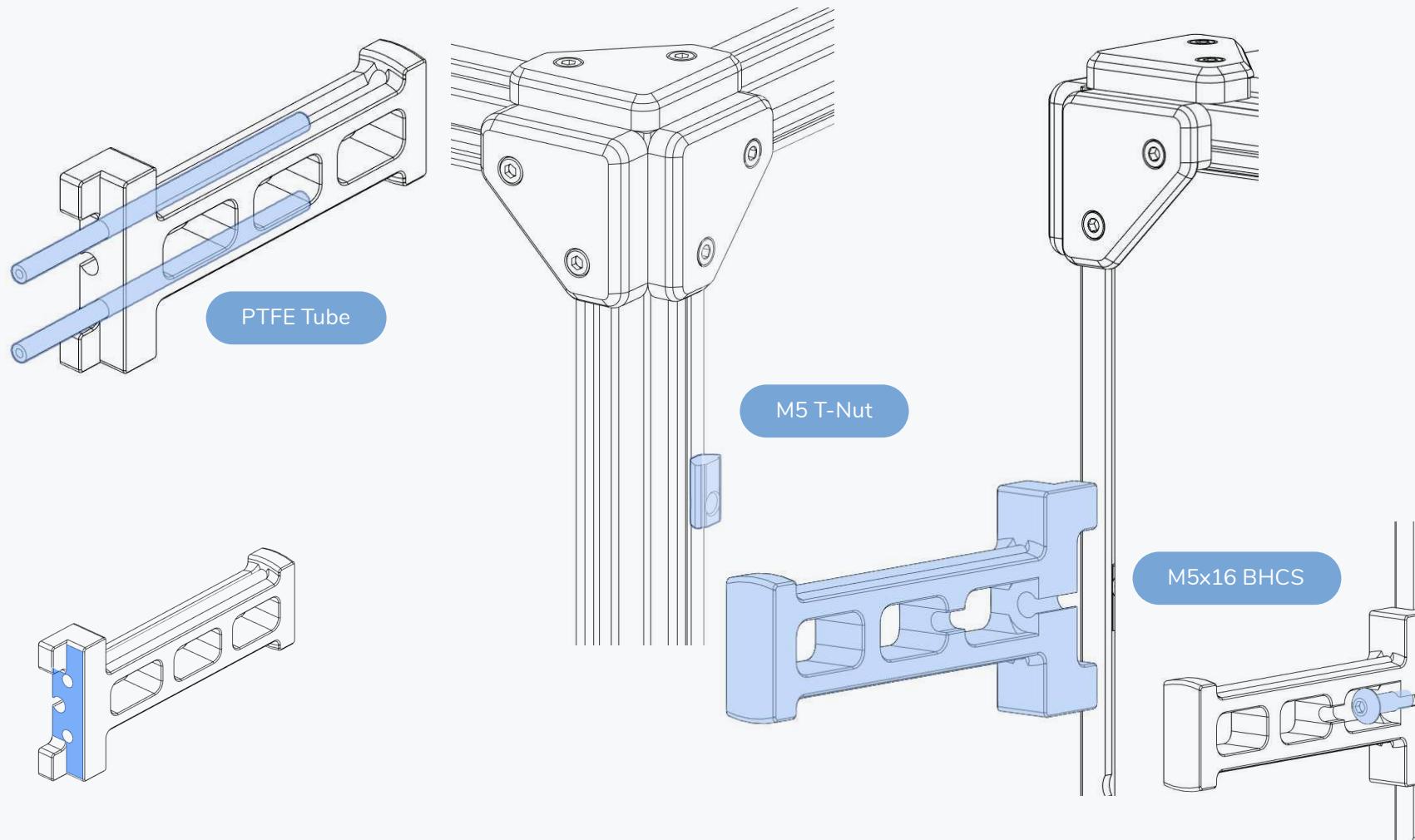
SPOOL HOLDER

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SPOOL HOLDER

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ASSEMBLY COMPLETED! ... NEXT STEP: SETUP & CALIBRATION

This manual is designed to be a reference manual for the build process of a Voron2 printer. Additional details about the build and background on advanced topics can be found on our documentation page linked below.

The software setup and other initial setup steps with your new printer can also be found on our documentation page. We recommend starting [here](#).



<https://docs.vorondesign.com/>



<https://github.com/VoronDesign/Voron-2>

HOW TO GET HELP

If you need assistance with your build, we're here to help. Head on over to our Discord group and post your questions. This is our primary medium to help VORON Users and we have a great community that can help you out if you get stuck. Alternativly, you can use our subreddit.



DISCORD

<https://discord.gg/voron>



<https://www.reddit.com/r/VORONDesign>

REPORTING ISSUES

Should you find an issue in this document or have a suggestion for an improvement please consider opening an issue on GitHub (<https://github.com/VoronDesign/Voron-2/issues>).

When raising an issue please include the relevant page numbers and a short description; annotated screenshots are also very welcome.

We periodically update the manual based on the feedback we get.

Enjoy your printer.



Website
www.vorondesign.com

Github
github.com/vorondesign

Docs
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