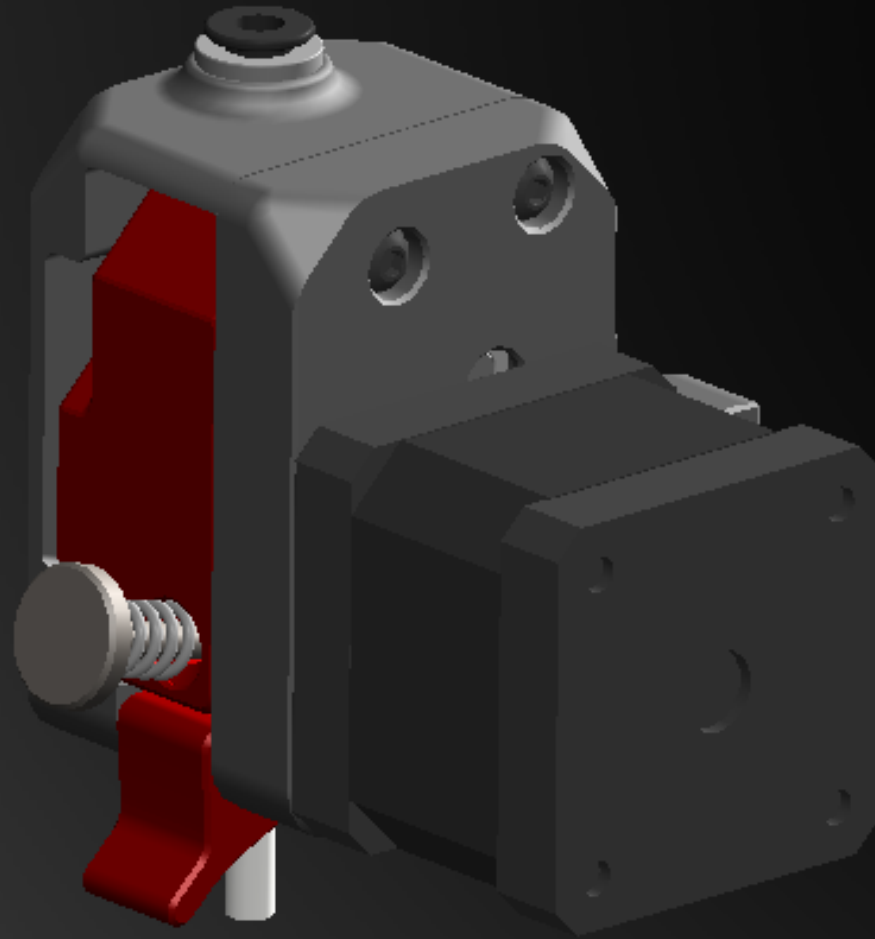


VORON

POCKETWATCH



Assembly Manual

Please, read the **entire manual** before you start assembly. As you begin wrenching, please check our Discord channel ([#voron_v0_questions](#)) for any tips and questions that may halt your progress.

Most of all, good luck!

- The VORON Development Team

| File Key | |
|-------------------|-------------------------------|
| Primary Color | nothing at start of file name |
| Accent Color | [a]_ at start of file name |
| Quantity Required | _x# near end of file name |

| Part Printing Guidelines and Standards | |
|--|--|
| Approved FDM Materials | ABS or ABS+ Only |
| Layer Height | 0.2mm |
| Extrusion Width | Forced 0.4mm |
| Infill Percentage | 40% minimum |
| Infill Type | Grid, Gyroid, Honeycomb, Triangle or Cubic |
| Wall Count | 4 minimum |
| Solid Top/Bottom Layers | 5 minimum |

Very Important Steps

Fastener Size/Type Part

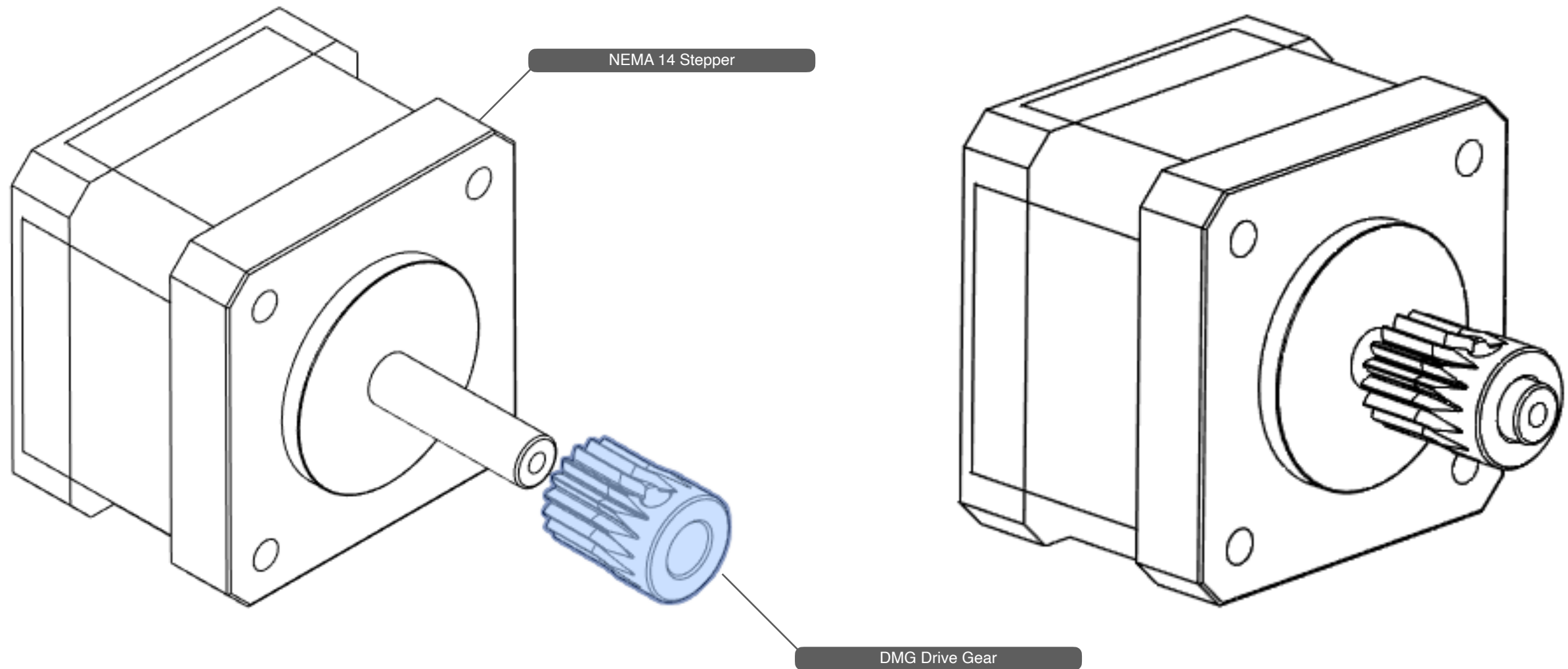
Notes and Tips

Important Definitions and Adhesives List

| Callout | Definition |
|----------------------------|---|
| BHCS | Button Head Cap Screw (ISO 7380-1) |
| SHCS | Socket Head Cap Screw (ISO 4762/DIN 912) |
| Shim | Shim Ring (DIN 988) |
| Nut | DIN934 or equivalent |
| Lock Nut | DIN985 or equivalent |
| Low Strength Thread Locker | Loctite 222 (aka "Purple") |
| Shaft Retaining Compound | Loctite 641 ("Yellow") or 609 ("Light Green") |

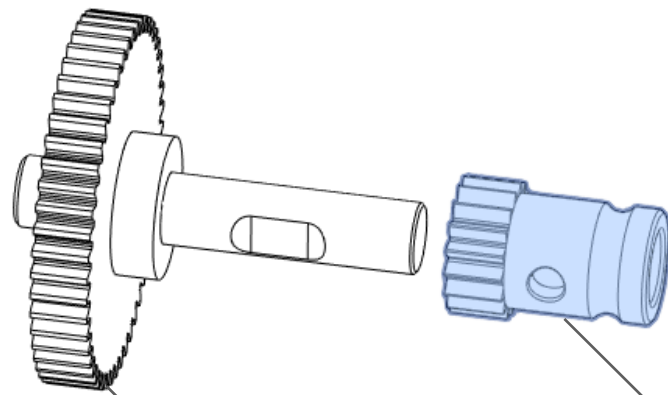
BMG Drive Gears

| Part | Qty |
|----------------|-----|
| NEMA 14 | 1 |
| BMG Drive Gear | 1 |



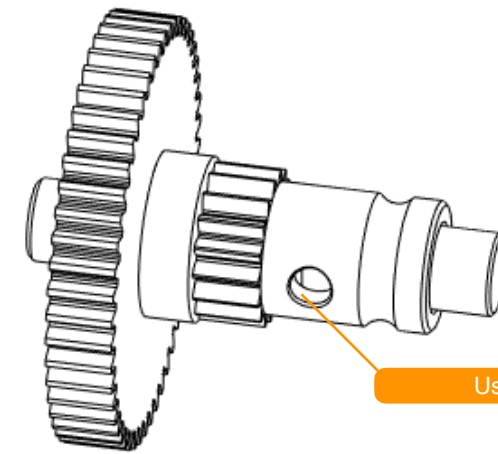
BMG Drive Gears

| Part | Qty |
|-------------------------|-----|
| BMG Filament Drive Gear | 1 |
| BMG White Gear | 1 |
| MR85 Bearing | 2 |

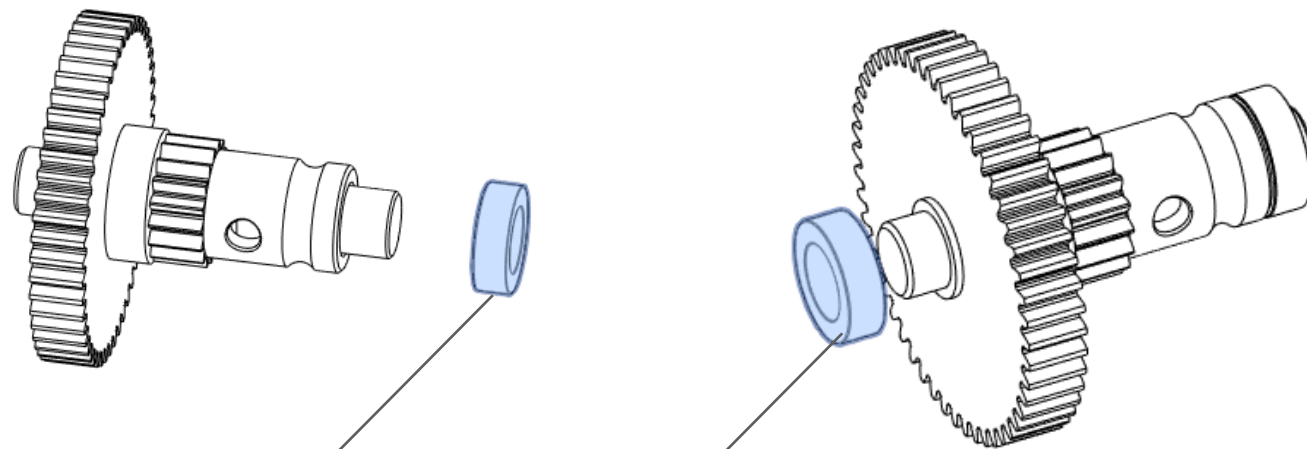


BMG White Gear

BMG Filament Drive Gear

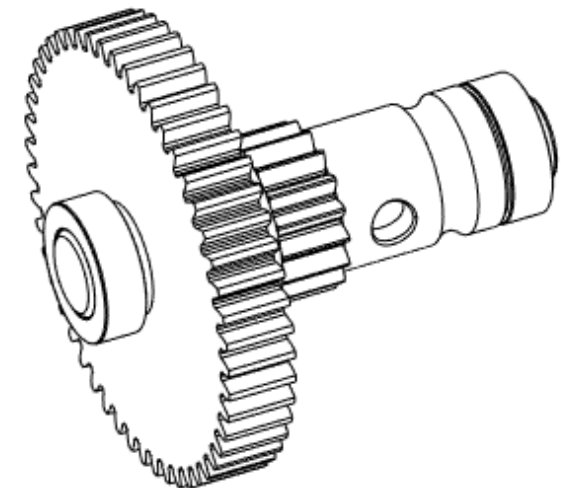


Use Thread Locker On Set Screw



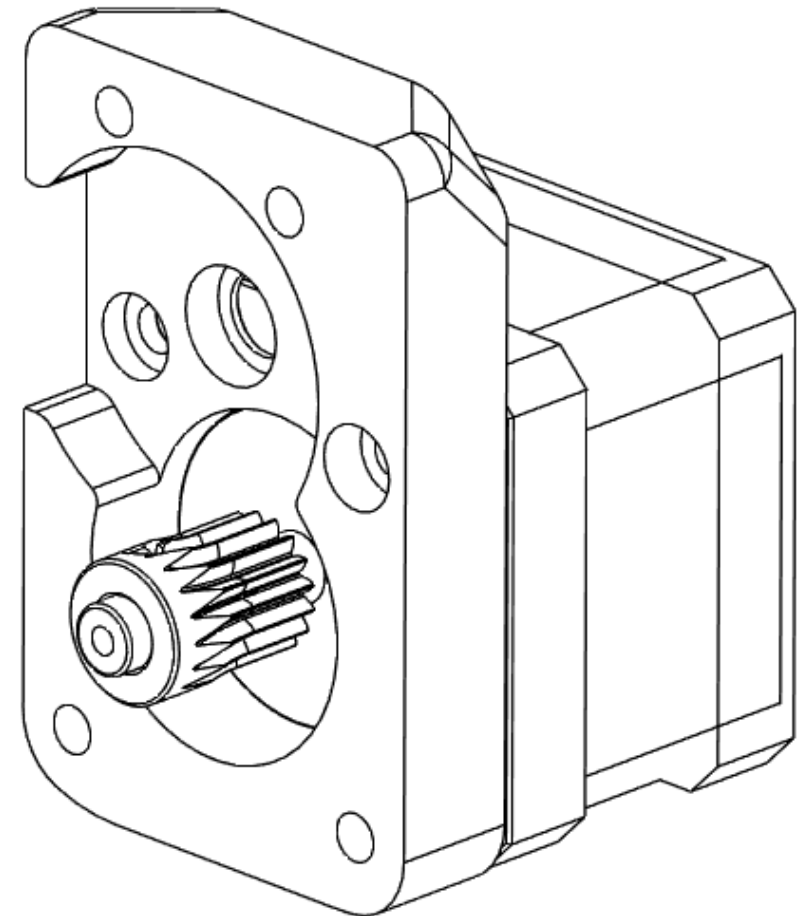
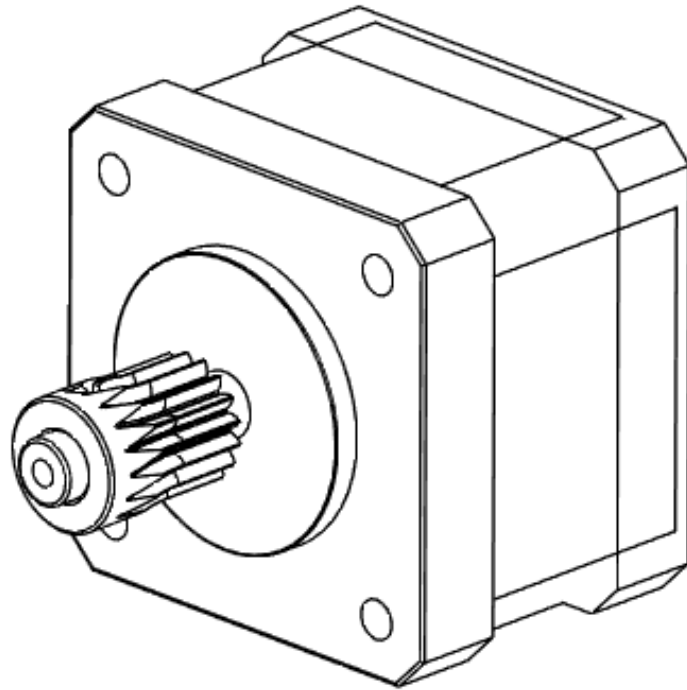
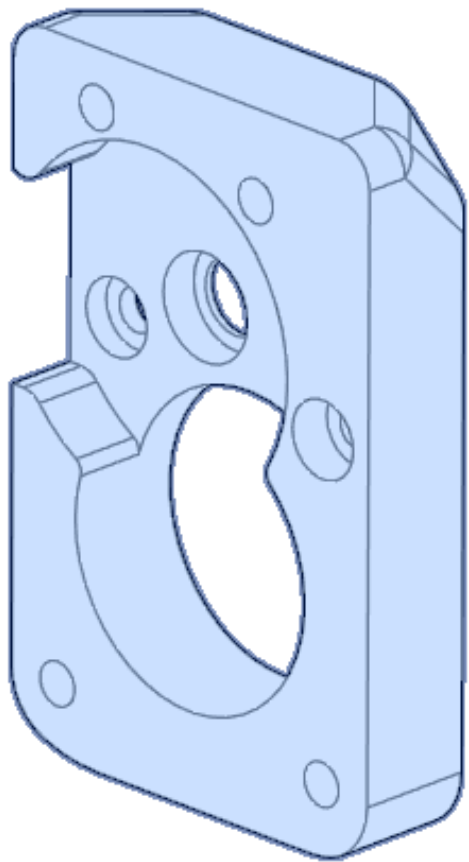
MR85 Bearing

MR85 Bearing



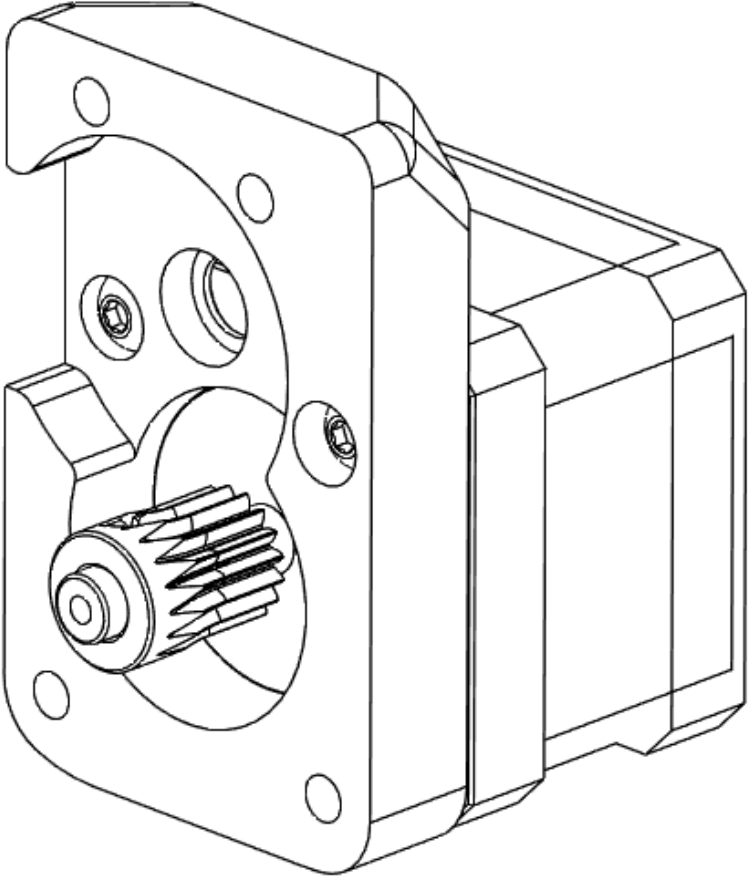
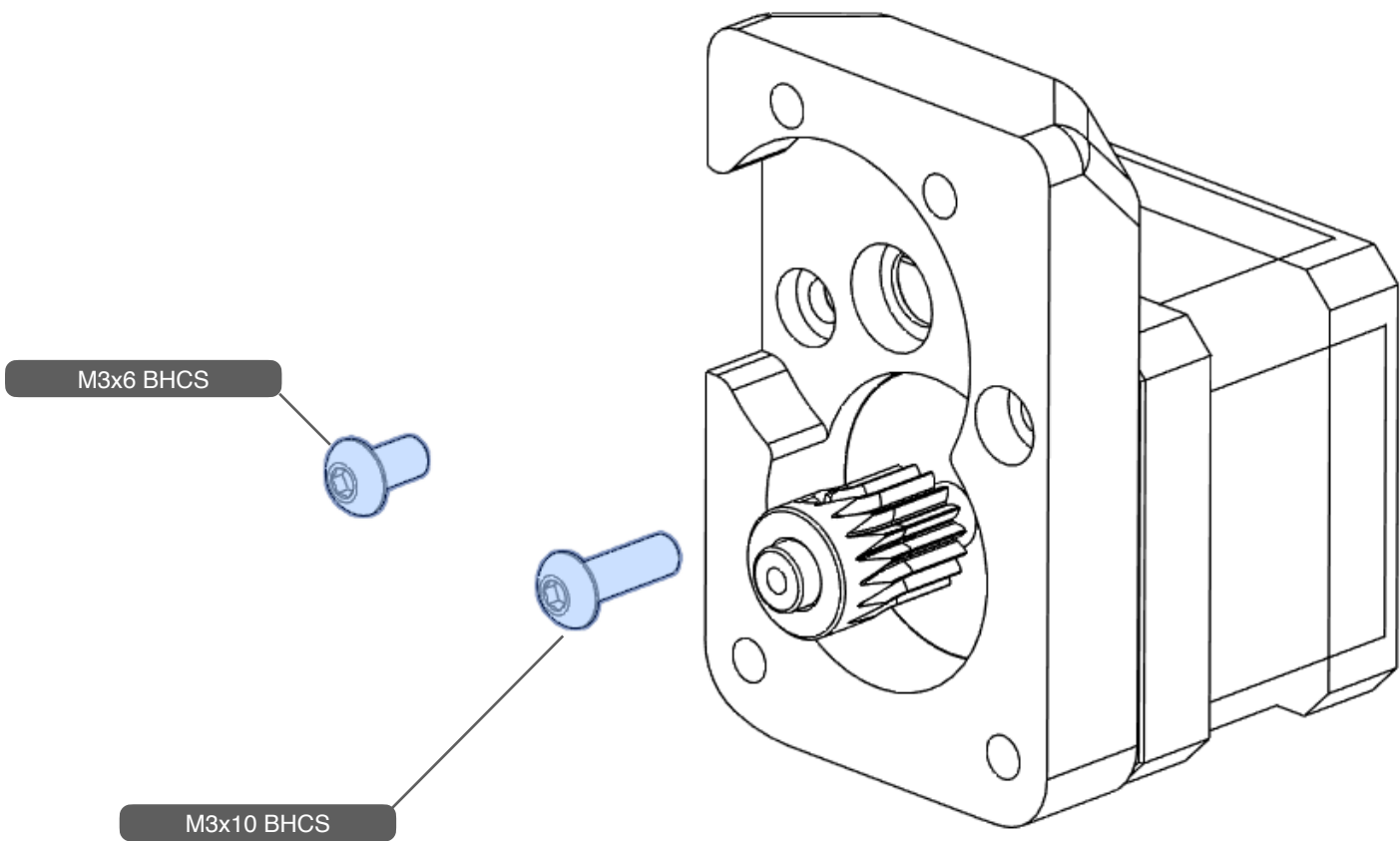
Motor Frame

| Part | Qty |
|----------------|-----|
| Motor_Frame_x1 | 1 |



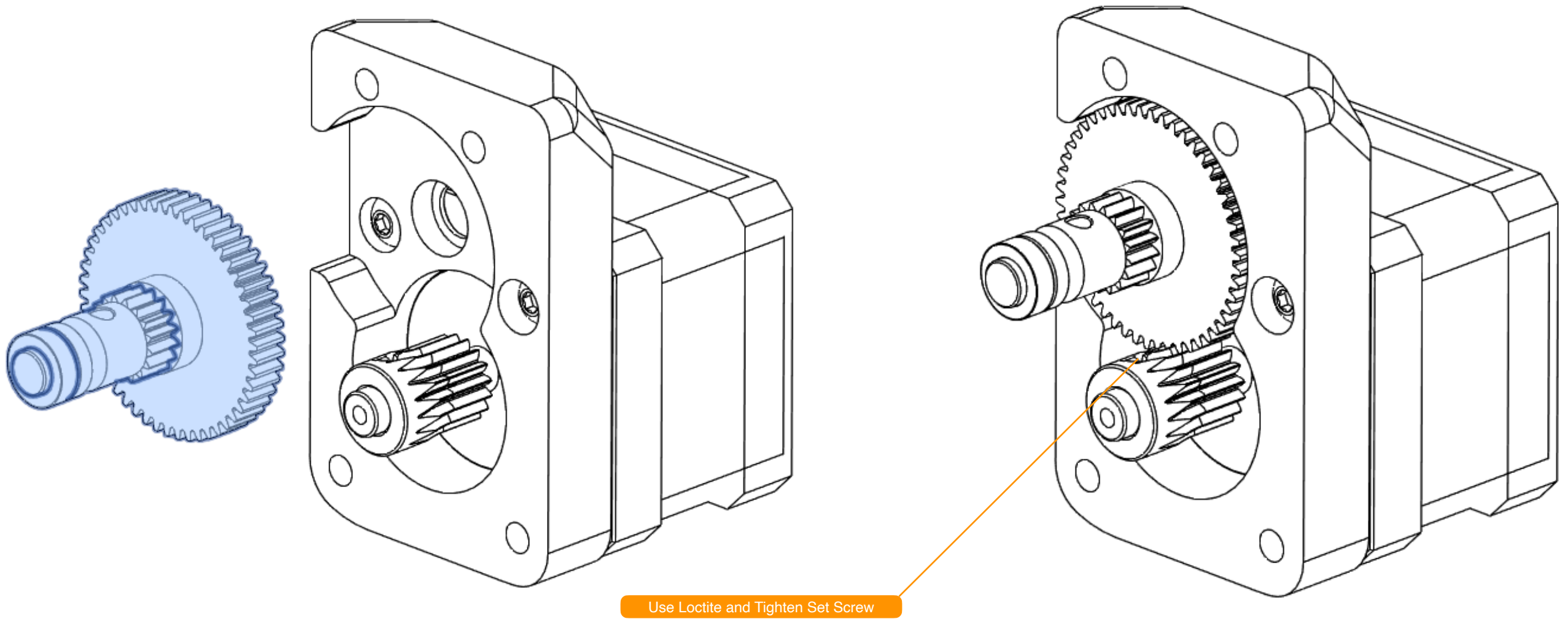
Motor Frame

| Part | Qty |
|------------|-----|
| M3x6 BHCS | 1 |
| M3x10 BHCS | 1 |



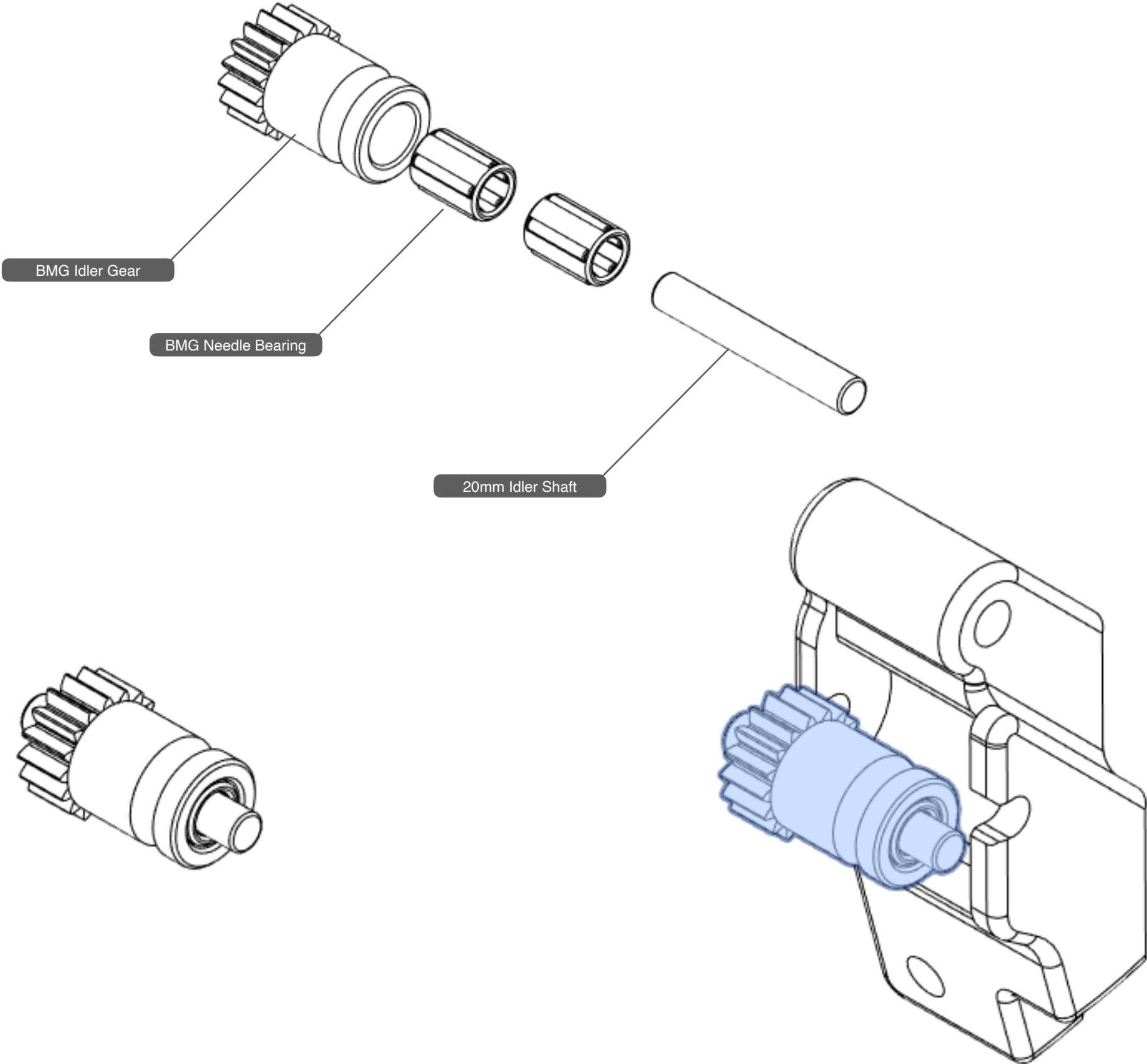
BMG Drive Gears

| Part | Qty |
|---------------------|-----|
| BMG Drive Mechanism | 1 |



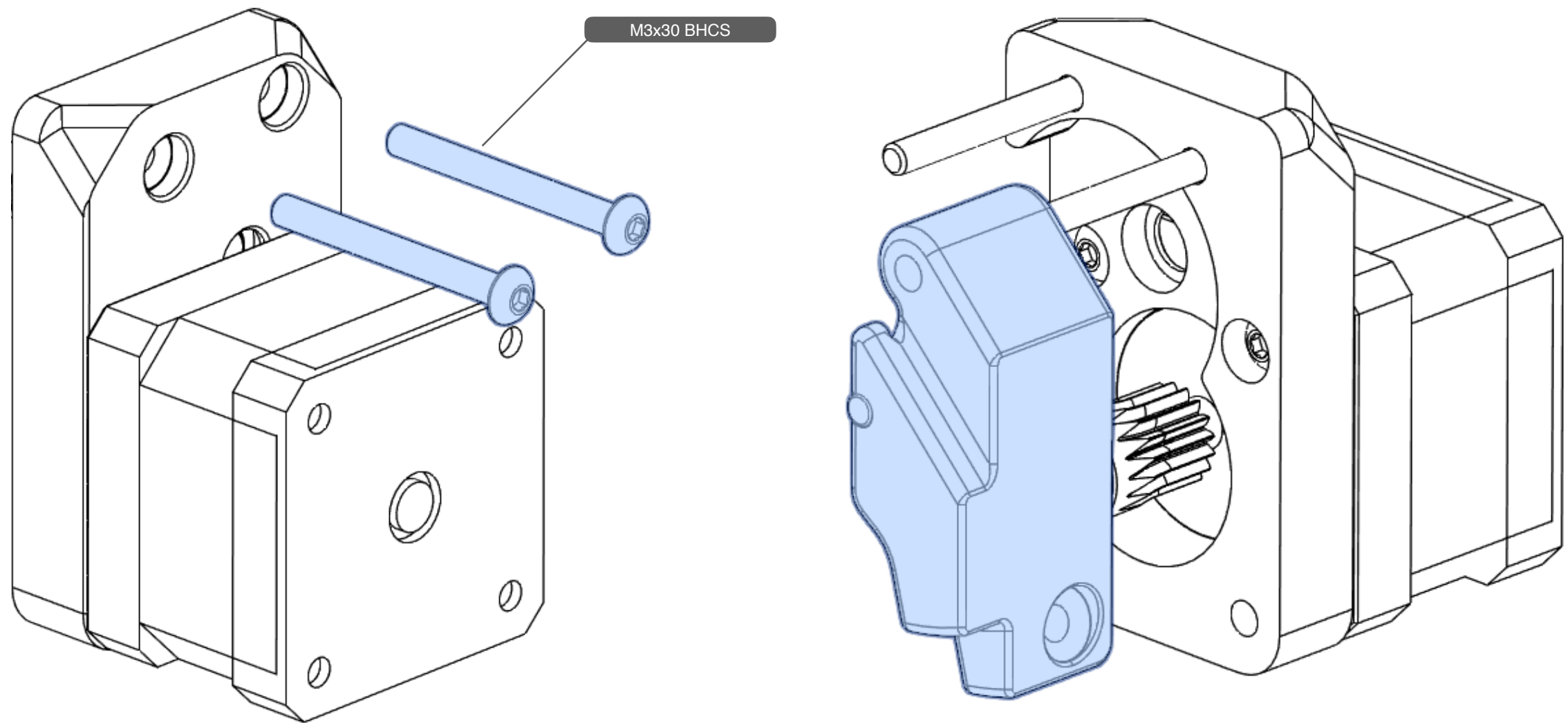
Guidler Door Assembly

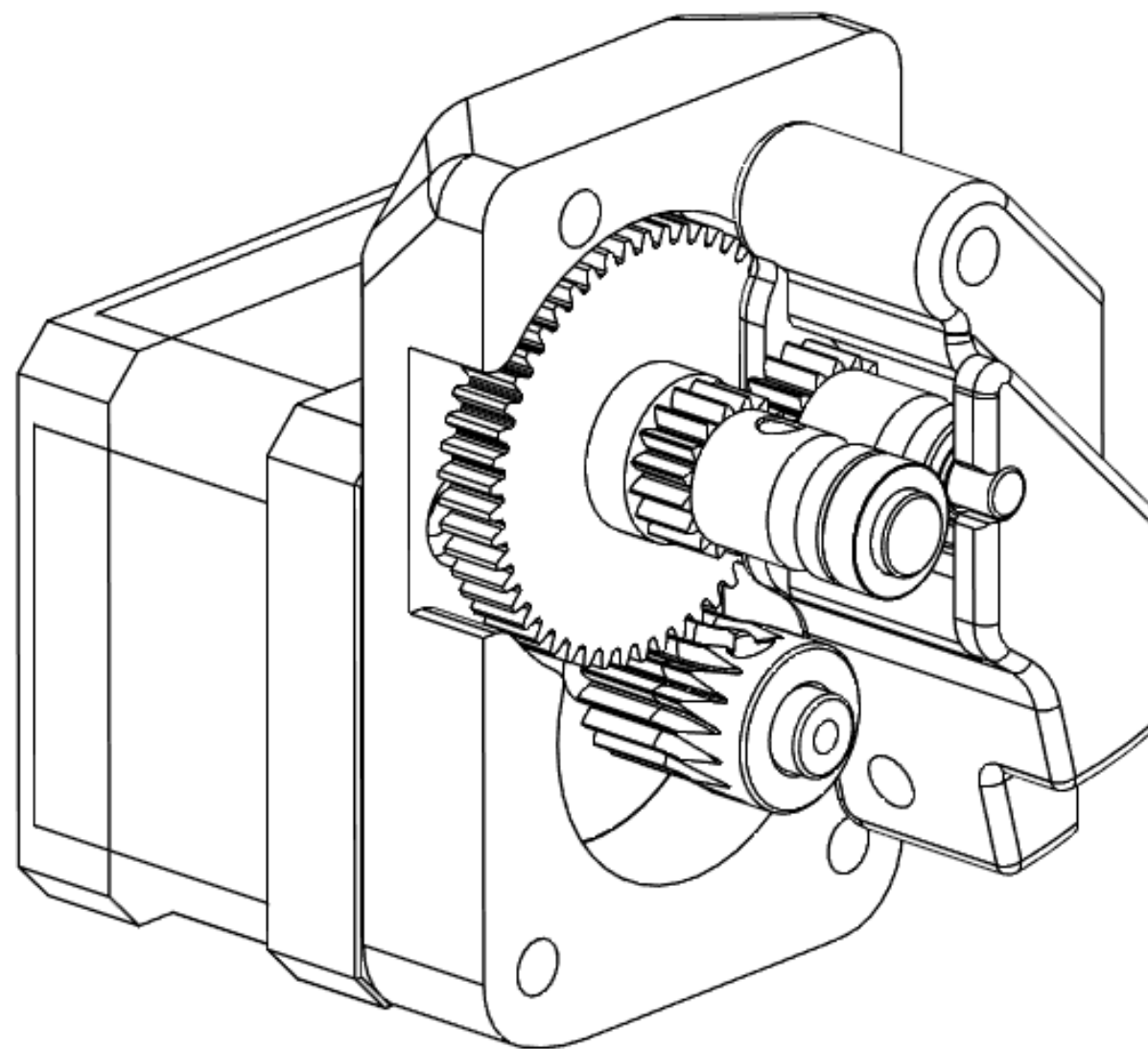
| Part | Qty |
|---------------------|-----|
| BMG Idler Gear | 1 |
| BMG Needle Bearing | 2 |
| 20mm Idler Shaft | 1 |
| [a]_Guidler_Door_x1 | 1 |



Door Assembly

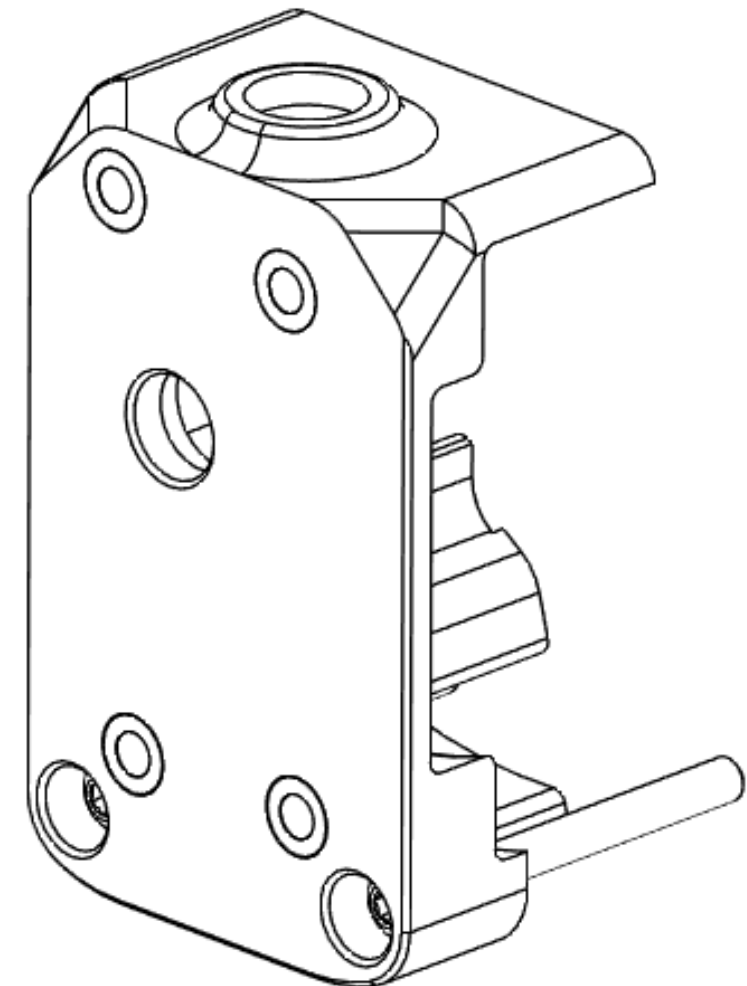
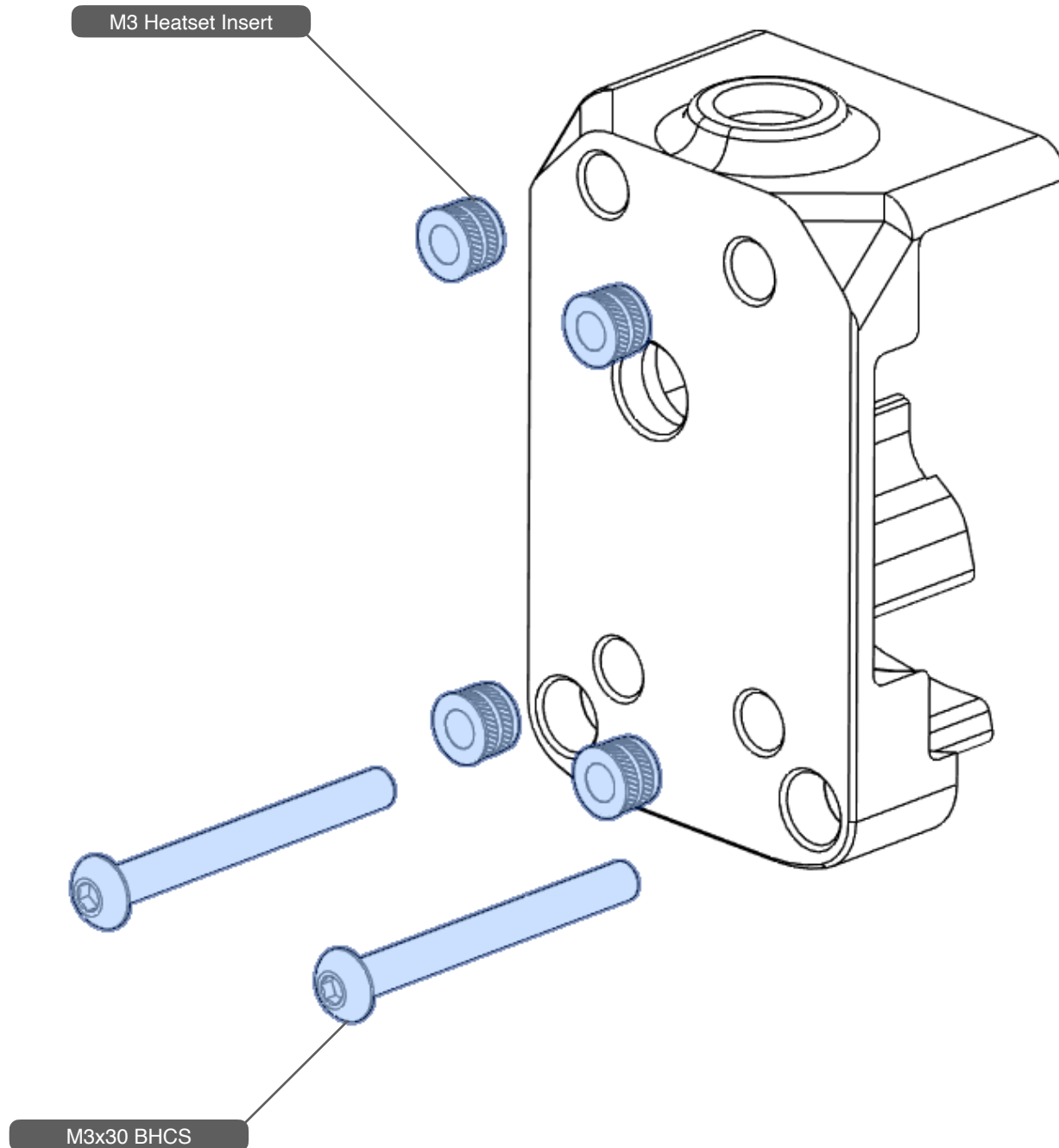
| Part | Qty |
|------------|-----|
| M3x30 BHCS | 2 |





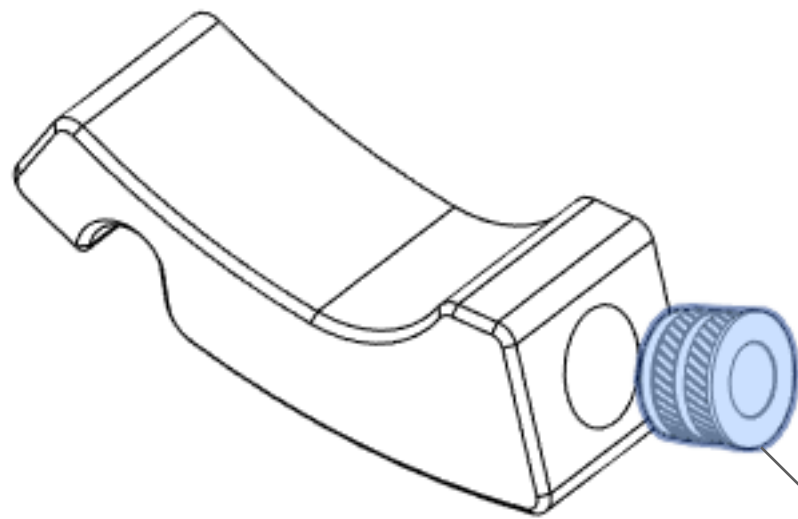
Guts Assembly

| Part | Qty |
|---------------------|-----|
| M3x30 BHCS | 2 |
| M3 Heatset Instart | 4 |
| Pocketwatch_Guts_x1 | 1 |

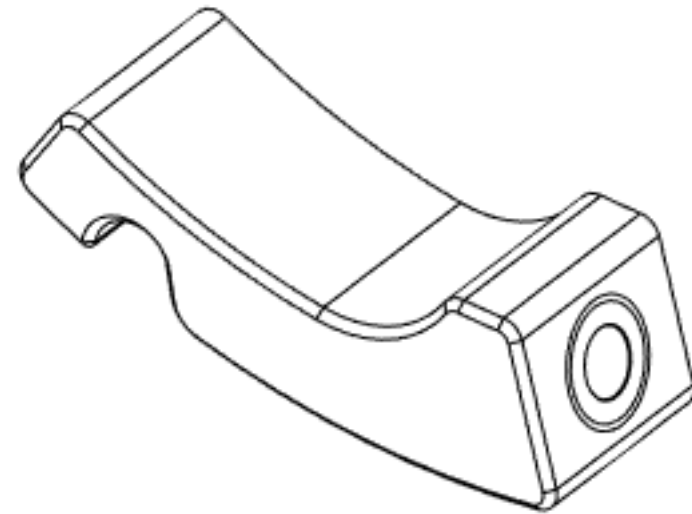


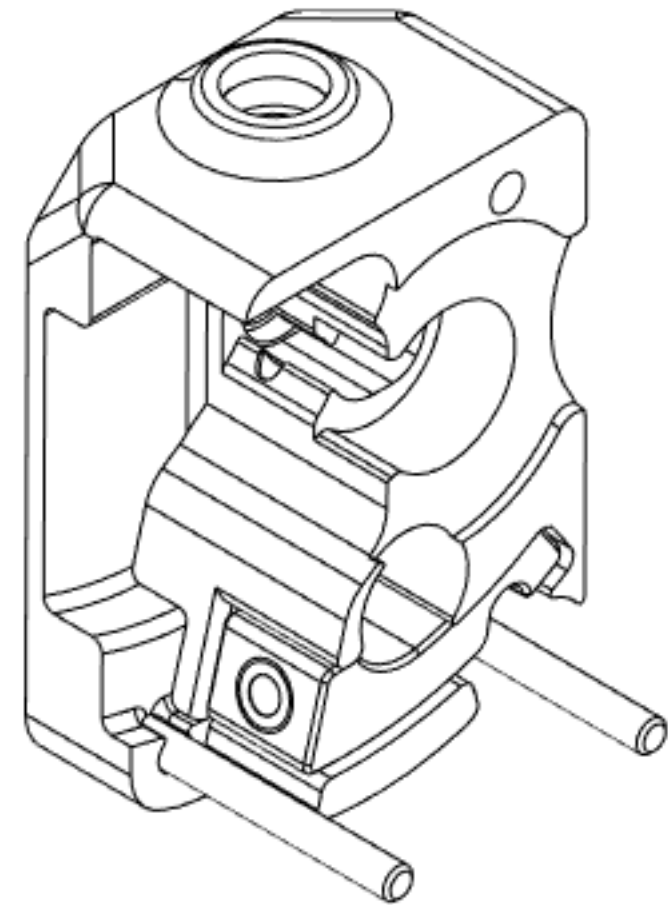
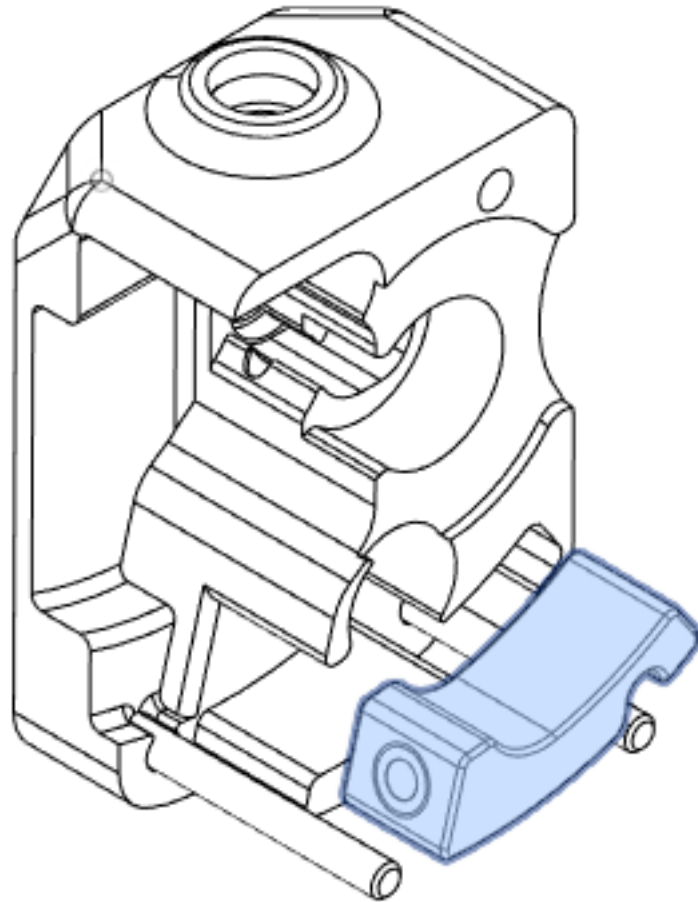
Heatset Insert

| Part | Qty |
|----------------------|-----|
| [a]_Latch_Shuttle_x1 | 1 |
| M3 Heatset Insert | 1 |



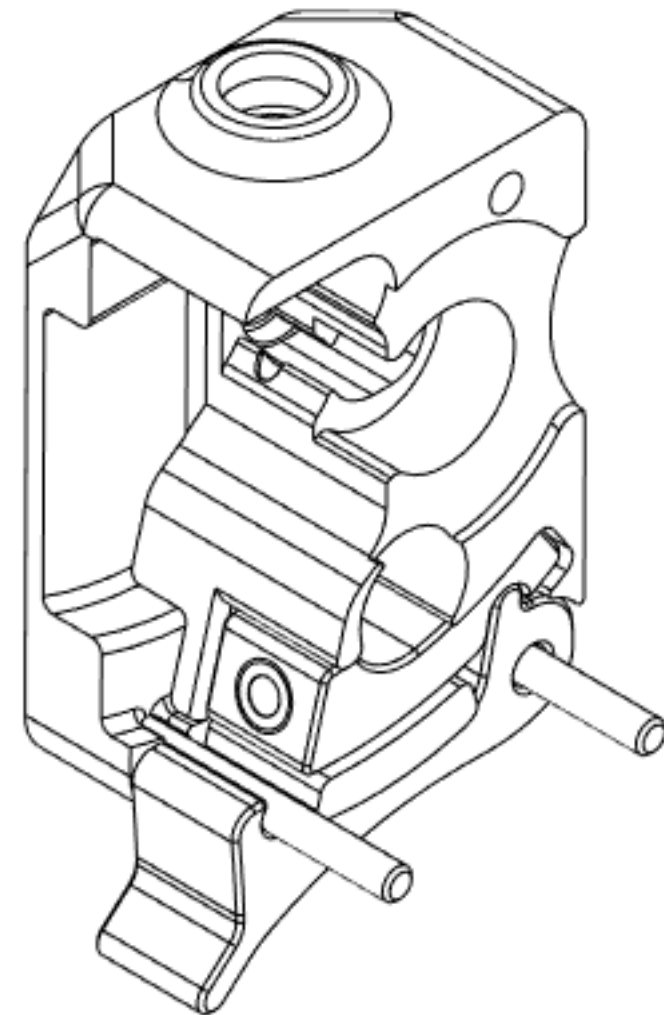
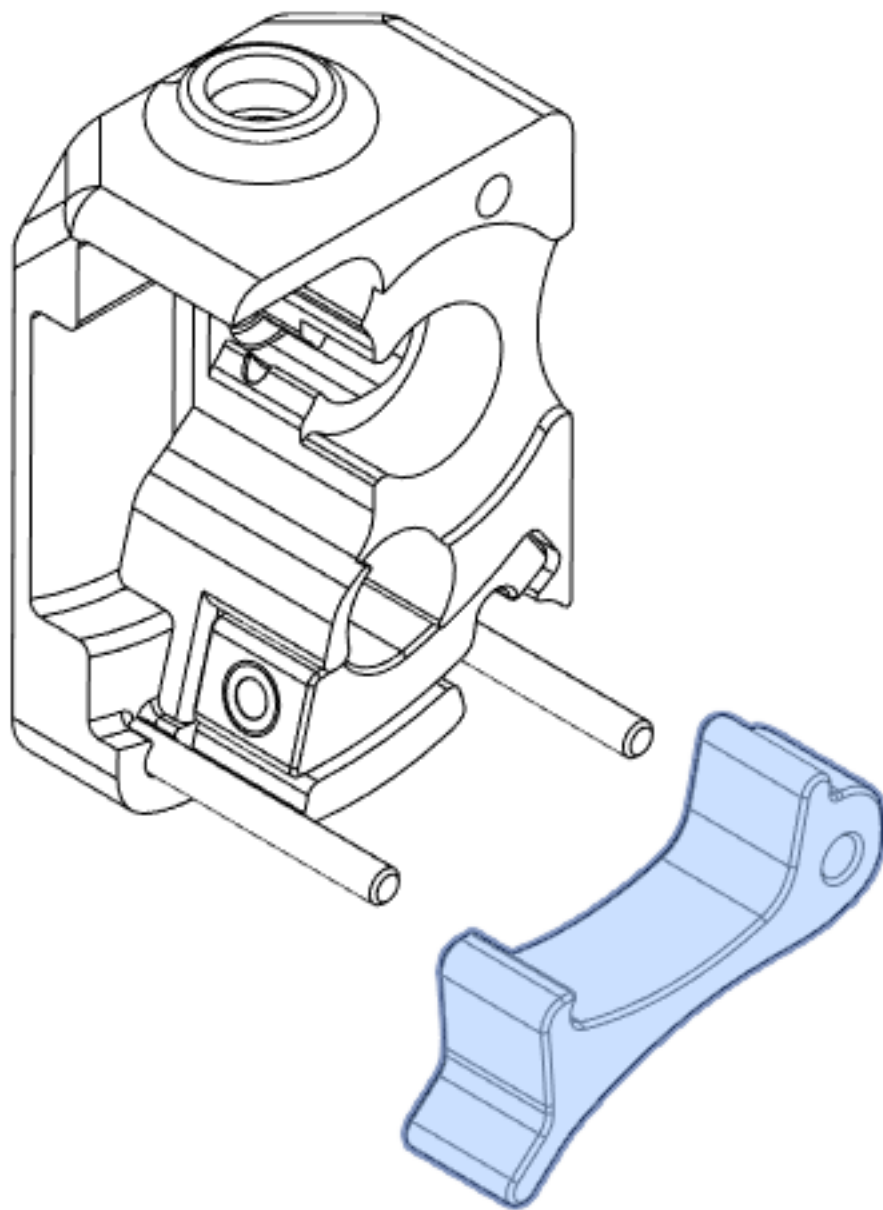
M3 Heatset Insert

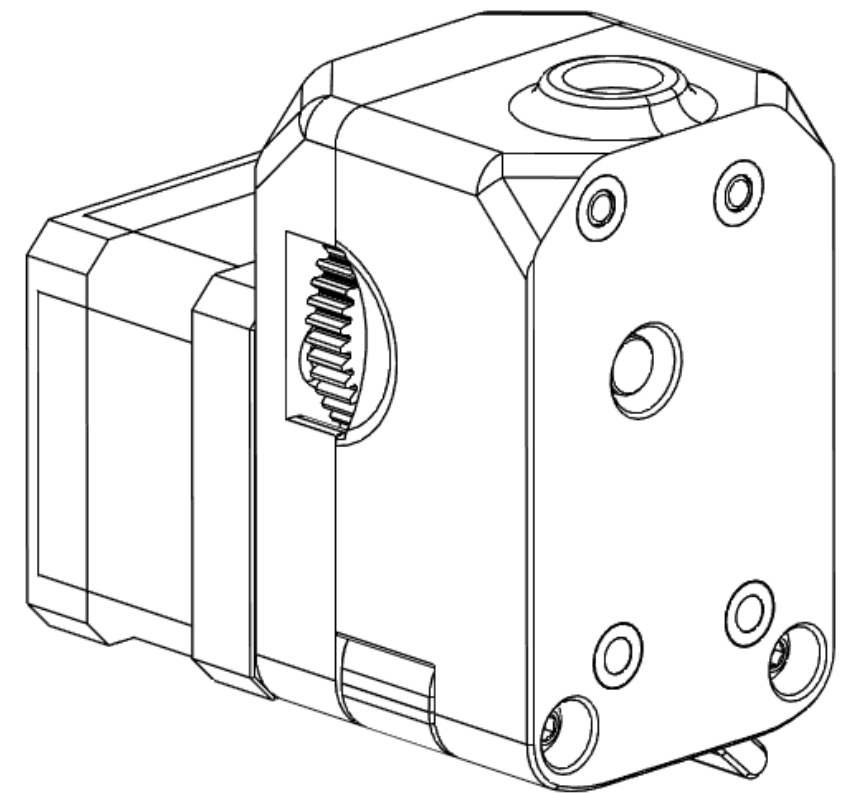
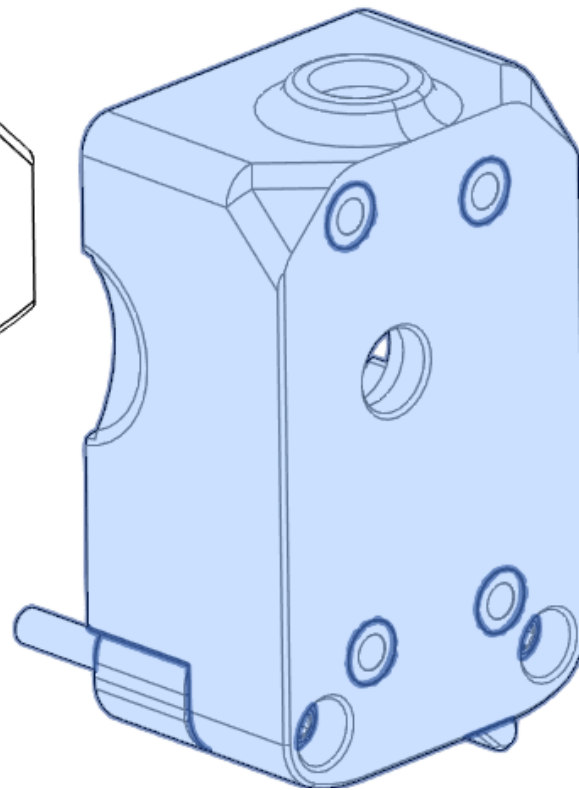
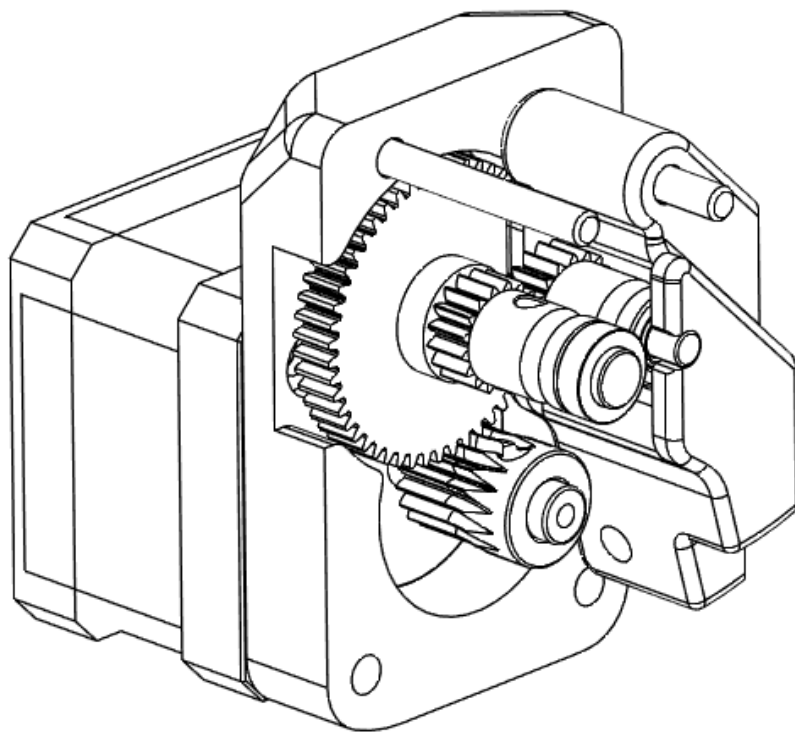




Install Latch

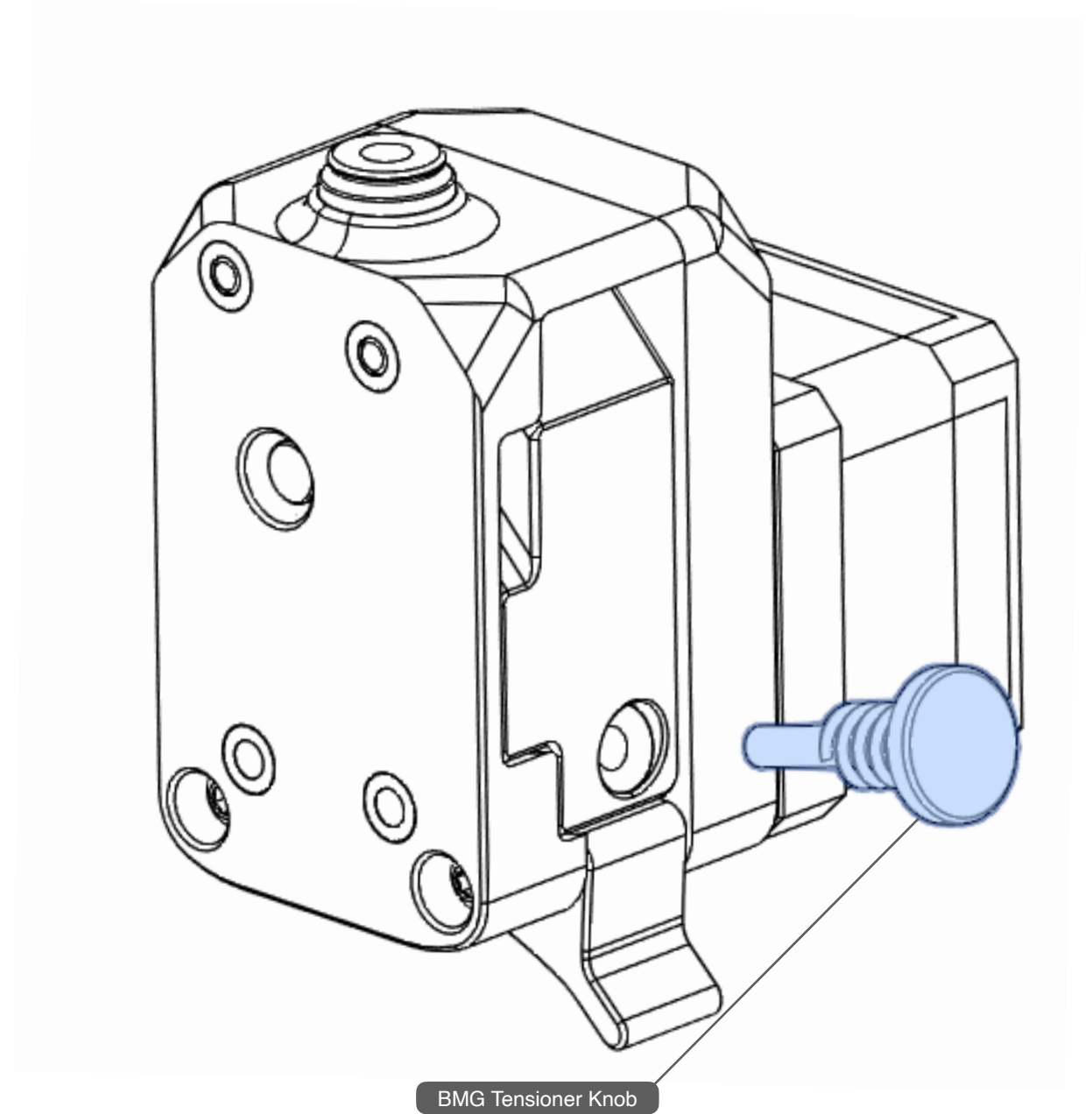
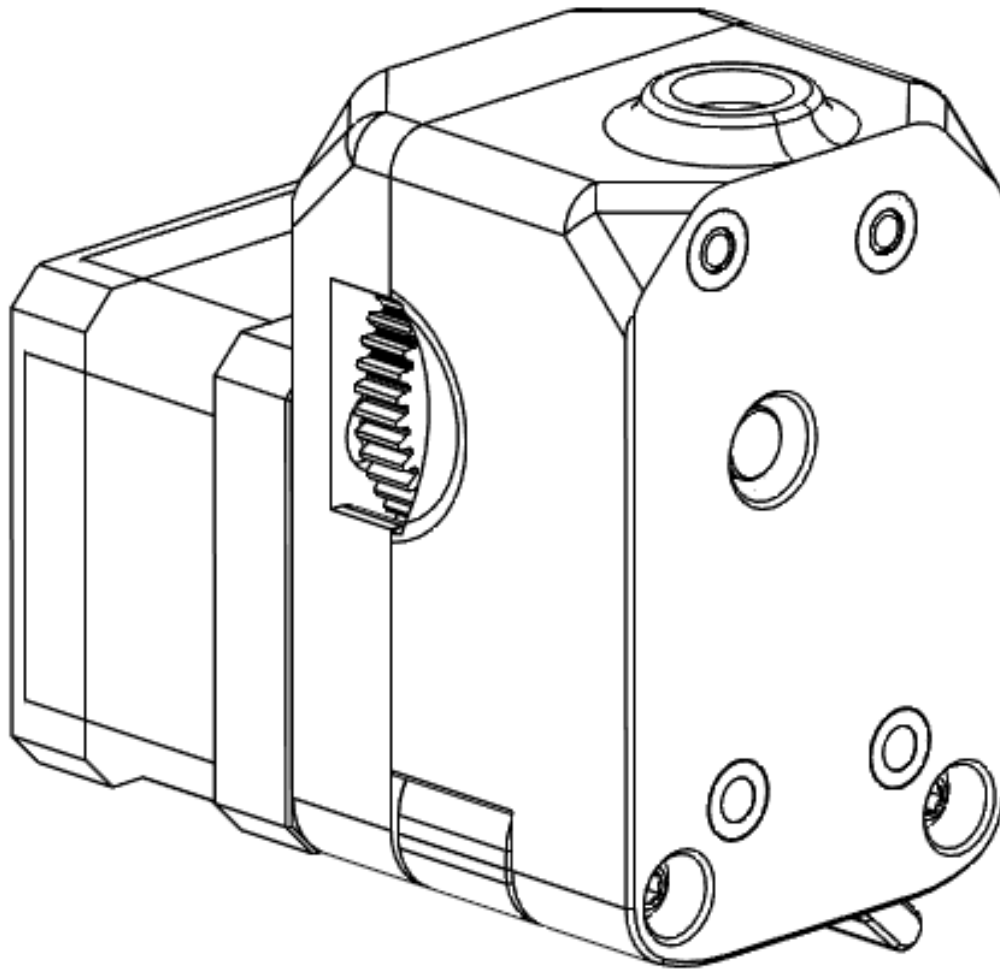
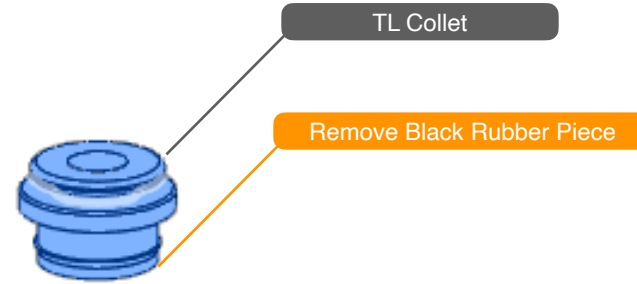
| Part | Qty |
|--------------|-----|
| [a]_Latch_x1 | 1 |



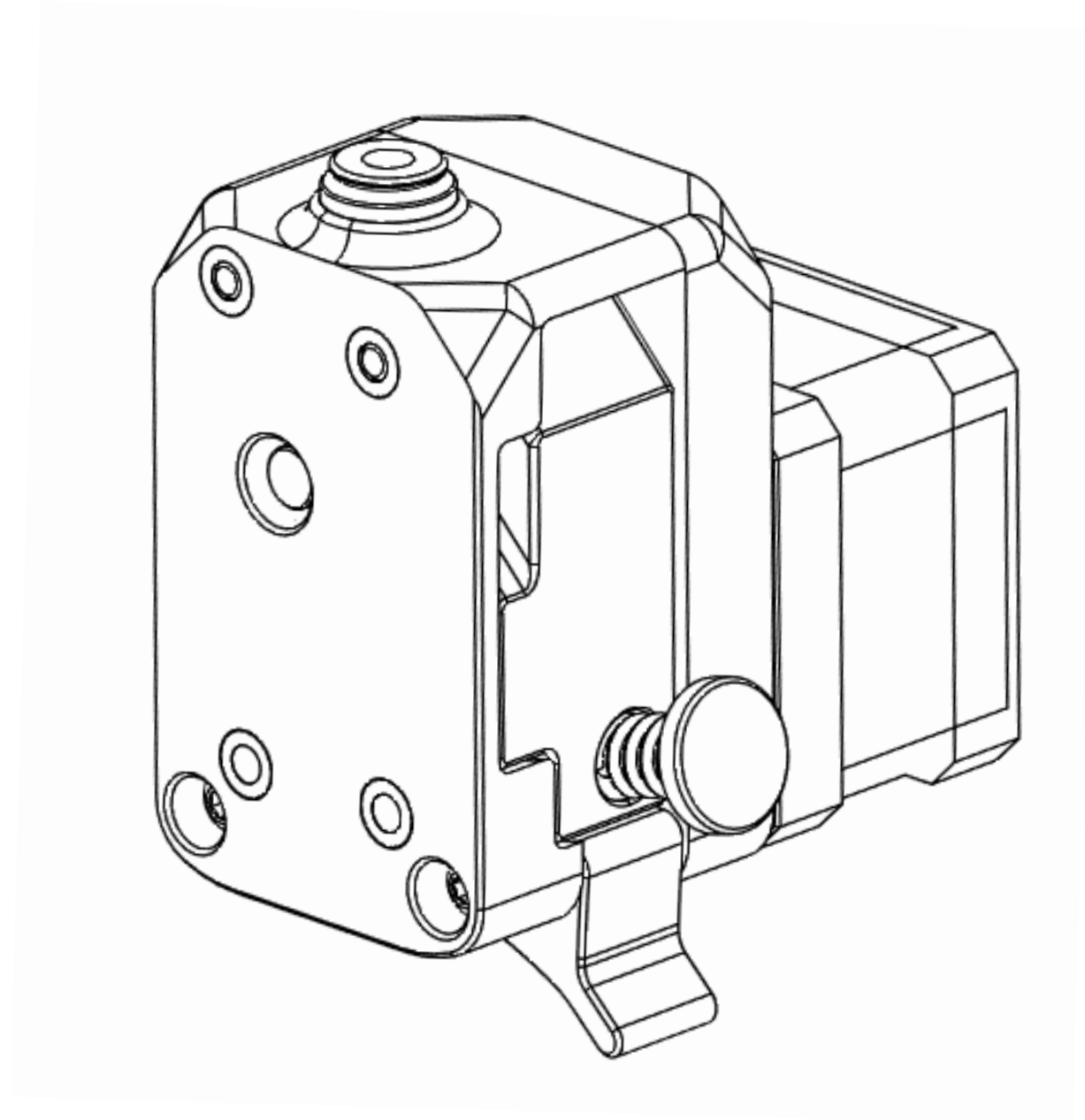


Final Touches

| Part | Qty |
|------------|-----|
| TL Collet | 1 |
| BMG Knob | 1 |
| BMG Spring | 1 |



YAY!



Thanks!

| Brought To You By; In No Particular Order | | | | | |
|--|-----------|-------------|---------------|---------------|----------------|
| russiancatfood | Chron | etherwalker | Lolmodule | Strubinator | brick_sandwich |
| 8Bit Poro | codeXmas | xanin | louielc | synlor | carnufex |
| aMpeX | daveidmx | fermion | Maglin | tameike | E.Lariviere |
| Andreq | Defib | fessyfoo | Medewsa | Thebrakshow | eddie |
| andylsun | dgcaste | fujimonster | Minasokoni | Timmit99 | insurgus |
| Arksine | DocJeeves | Fulg | Nemgrea | tinpec | johnprime |
| ArmyAg08 | doowrednu | Hackdoggo | pnewb | Trunkmonky | resam |
| bahahah | Drbpgh | lakabos | pnokel | Ubernero | Stephan |
| Boff | dunar | Immutef | railgunner13f | _unregistered | wile.e.coyote |
| <i>our husbands/wives/children/pets/significant others: for putting up with our shit, and dealing with our aliexpress packages</i> | | | | | |