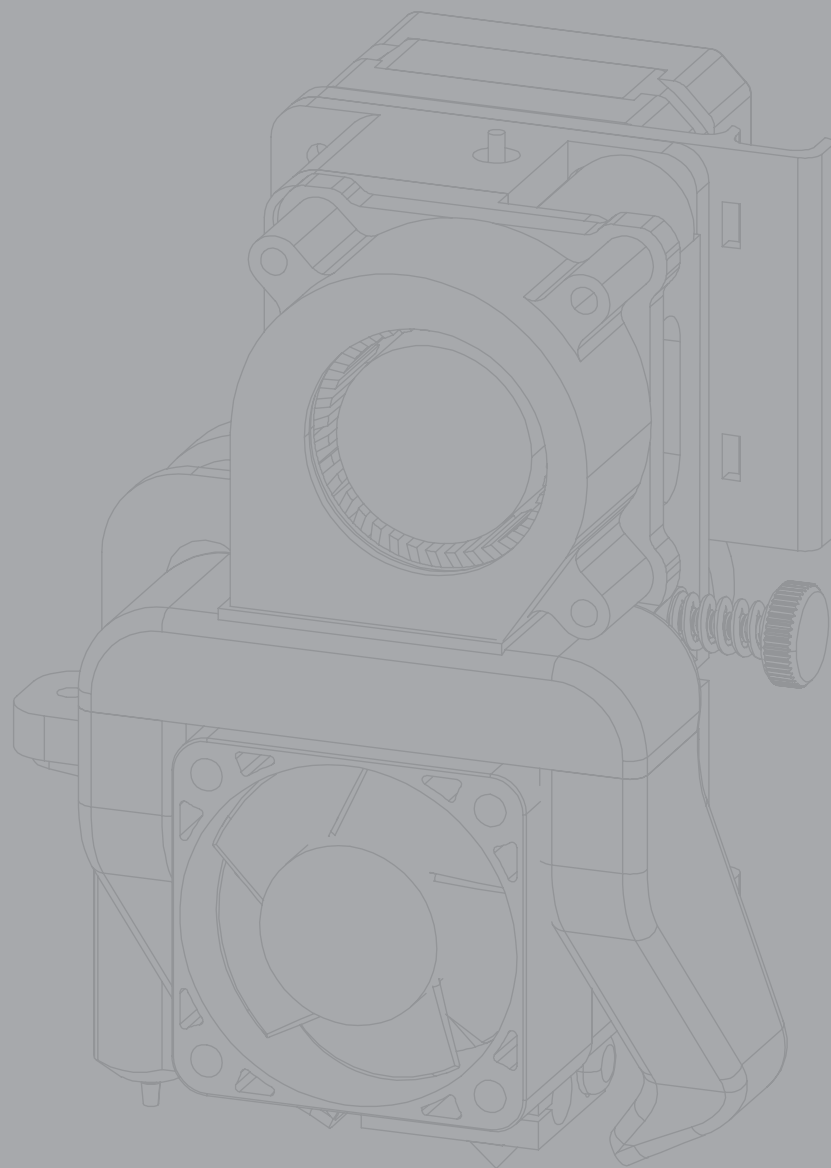




PLUMA



Initial Steps

Thanks for taking interest in the Pluma hotend shroud, as the product is currently in development, assembly and troubleshooting documentation is in development, so as a supplement, im giving this information packet to inform you of some important things.

Bill of Materials

A list of materials you will need to complete the hotend shroud; what kind, how many do you need. Specific prices and supplier used is not listed due to factors such as availability, continuity and regional variations.

Printed

Main Body	1
Tensioner Arm	1
Extruder Front Cover	1
Extruder Rear Cover	1
Part Cooling Fang	1
Auto Bed Levelling Support ³	1
BLTouch Mount ³	1

Non-printed and non-stock

Bondtech Gear Kit	1
Bondtech Shaft Assembly	1
Bondtech Motor Pinion	1
MR85 ZZ Bearing	2
M3 x 6 SHCS	9
M3 x 8 SHCS	5

M3 x 16 SHCS	3
M3 x 25 SHCS	4
M3 x 27 SHCS	1
M3 X 5 X 5 Heat Insert ⁴	8
M3 X 5 X 3 Heat Insert ⁴	4
M3 Nut	3
4020 24V Radial Fan	1
4020 24V Axial Fan ¹	1
BLTouch ³	1
NEMA 17 0.9 Pancake	1
1M BLTouch Extension Cable ³	1
0.5 M Stepper Motor Cable	1
M6 PTFE Fitting	1
Bondtech Tensioner Screw	1
4 Inch Zipties (1 Bag)	1

Stock

X Carriage Plate Assembly	1
4010 24V Axial Fan ¹	1
Hotend Assembly ²	1

¹-4020 24V Axial Fan is not needed if you intend to use the stock fan, but also have to use M3 x 12 bolts instead of the M3 x 25 bolts listed.

²- A microswiss or similar all metal hotend that uses the stock mounting is also compatible.

³-Only needed if Auto Bed Levelling is used.

⁴-(thread size x outer diameter x length)

General Information

Just some information to clarify some expected difficulties in assembly, if you have any questions, please contact me at contact.sacepcion@gmail.com

Insert locations

all M3 x 5 x 5 inserts go inside the main body except for the location shown in figure 1, which require an M3 x 5 x 3 insert. the rest of the M3 x 5 x 3 inserts go to the fan mount location in the part cooling fang

Hotend to shroud Bowden tube

the hotend to shroud bowden distance is currently 28.7 mm for the microswiss and unknown for the stock hotend, will require guess and check.

0.5 meter stepper Cable

The stepper cable outlined in the BOM is intended to be spliced into the existing extruder stepper cable.

SHCS Screw locations

M3 x 6 - Auto bed levelling support, front cover and part cooling fang

M3 x 8 - Extruder screws, bltouch mount

M3 x 16 - Part cooling fan

M3 x 25 - 4020 axial fan, substitute with M3 x 12 if using a 4010 axial

M3 x 27 - since this is an odd size, you can cut an M3 x 30+ bolt to 27mm instead, intended for use on the tensioner hinge

M3 nut - Bltouch Mount and auto bed levelling support

Print Settings

General - up to 0.32mm layer height, at least 4 walls and 30-50% infill

Material - PETG/ABS or Equivalent (PLA not recommended)

Supports - Yes for the part cooling fang and main body

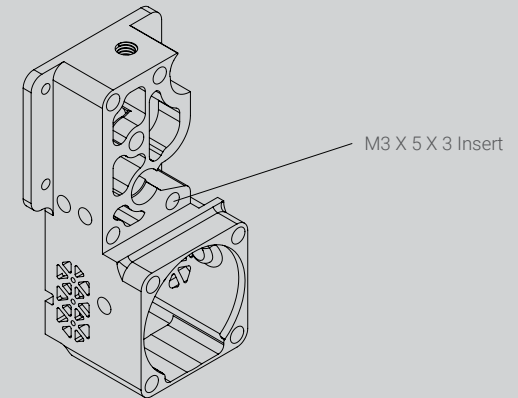


Figure 1: M3 x 5 x 3 insert location in the main body

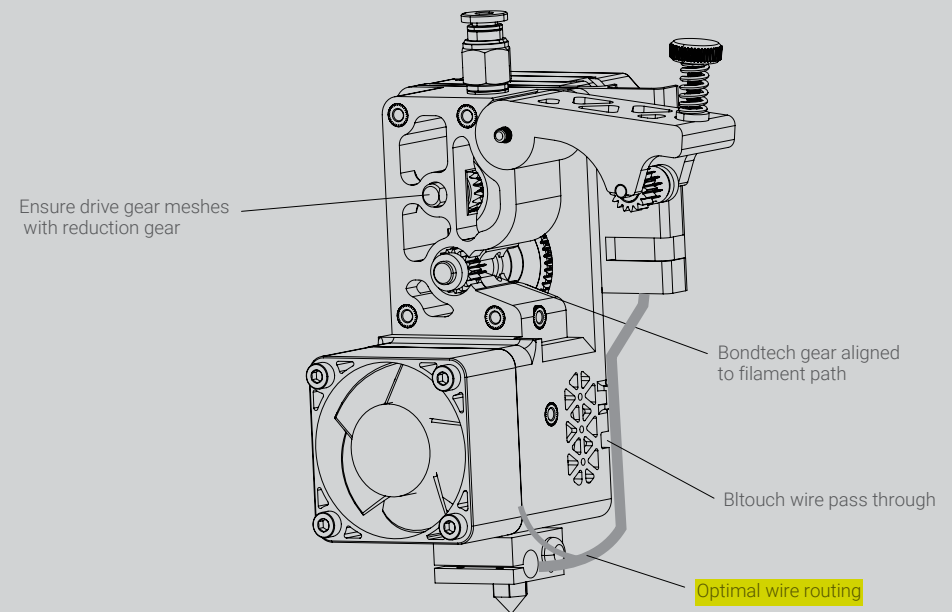


Figure 2: General Assembly Notes