

HKBay.com

E - Extruder Assembly

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TOOLS:

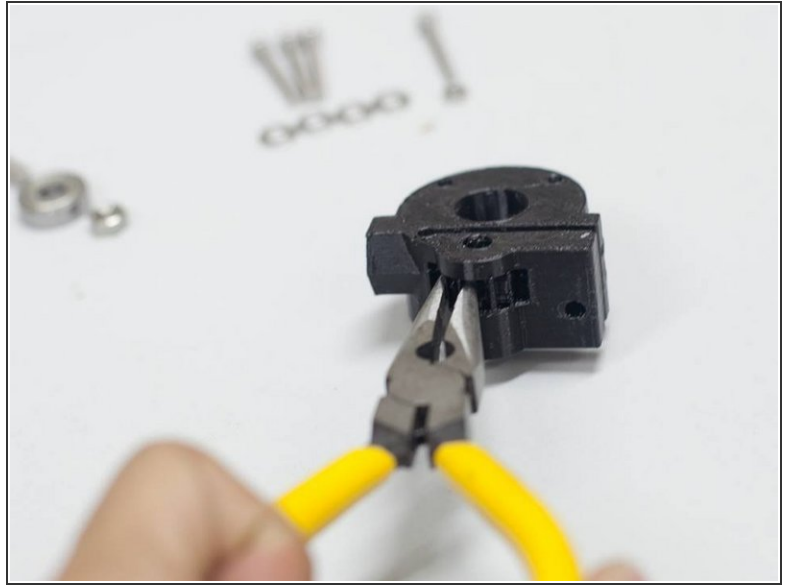
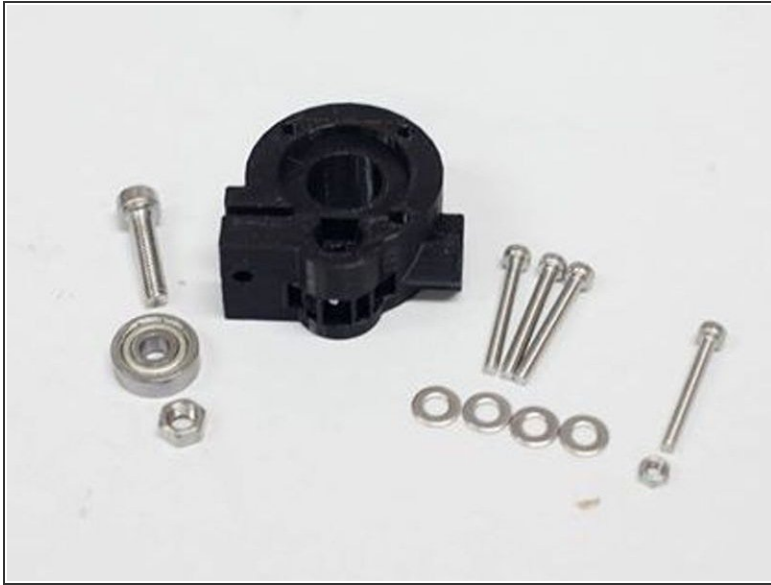
- [Hex key; ball ended, long arm, 2.5mm](#) (1)
- [Hex key: 4.0mm](#) (1)
- [Needle-nose pliers, small](#) (1)
- [Utility knife](#) (1)
- [File](#) (1)



PARTS:

- [Plastic extruder part](#) (1)
- [Big motor](#) (1)
- [Brass spur gear with grub screw](#) (1)
- [Big 625 bearing](#) (1)
- [M5x20 screw](#) (1)
- [M5 standard nut](#) (1)
- [M3x25 screw](#) (3)
- [M3x20 screw](#) (3)
- [M3 nyloc nut](#) (1)
- [M3 washers](#) (4)
- [M3x16 screws](#) (2)
- [M3 standard nuts](#) (2)
- [M3x8 screws](#) (2)
- [t-slot nuts](#) (2)

Step 1 — Remove the support material



- Use flat-nose pliers, utility knife, file etc. to remove the temporary support in the extruder gap, place the 625 bearing in this slot and screw in the M5 screw/nut to hold in place. Use a sharp knife and/or a file to remove all remaining plastics until the bearing fits in tight but can run smoothly and freely.

 Do not over-tighten the bolt.

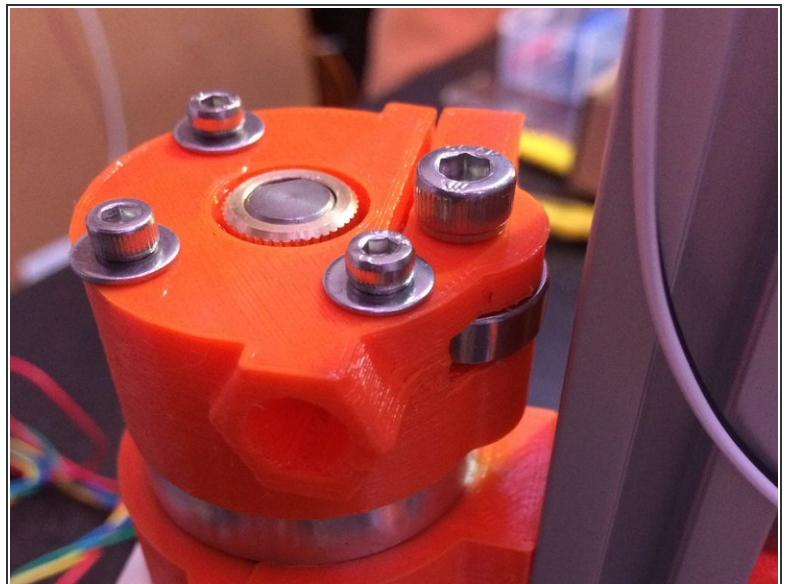
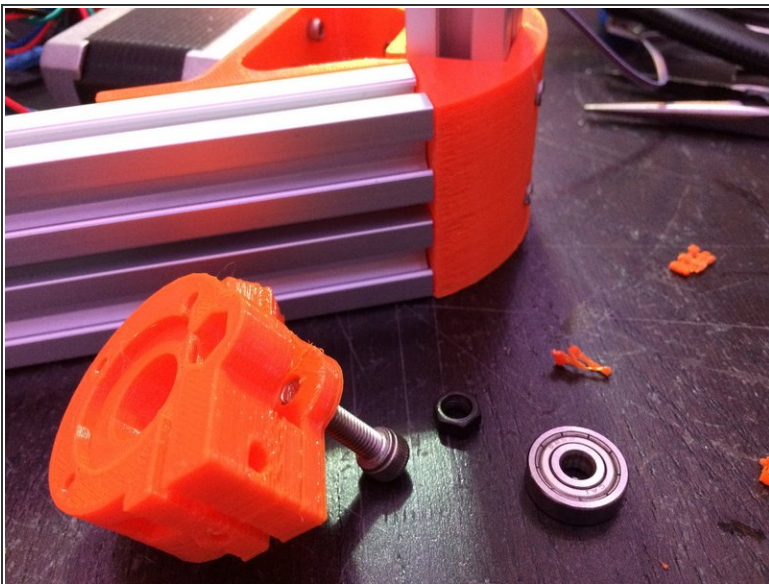
Step 2 — Mount spur gear



- Mount the spur gear on the stepper-motor and tighten the grub screw so that it's positioned towards the motor and touches the flat surface of the shaft.

⚠ The grub screw should connect with the flat surface of the shaft. The gear should be flush with the top of the shaft.

Step 3 — Mount Extruder



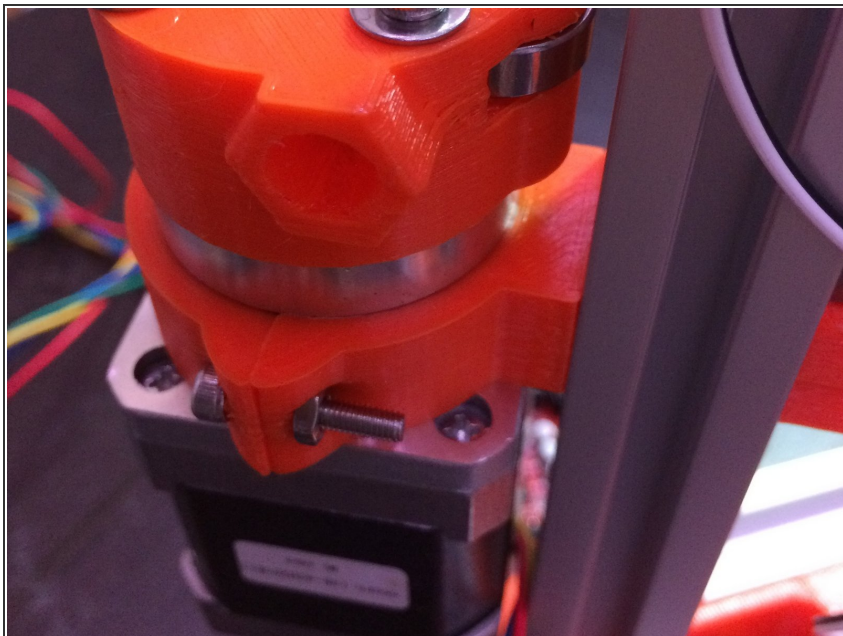
- Mount the plastic extruder assembly on the stepper motor with bearing facing towards the cables, using 3 M3x25 screws.

Step 4



- Then horizontally mount the M3x20 screw and washer through this hole and place a nyloc nut on the end.

Step 5



- Then fit extruder-holder to the back of Z-tower (opposite the LCD cables).
- ❗ As the t-slot nuts are too close together, they need to be slid into the profile from the top, before attaching the top frame!
- Attach the motor to the extruder holder with two M3x16 screws and standard nuts, cables pointing towards the tower.
- ❗ Mount the extruder at about the same level as the lower endstop holder.