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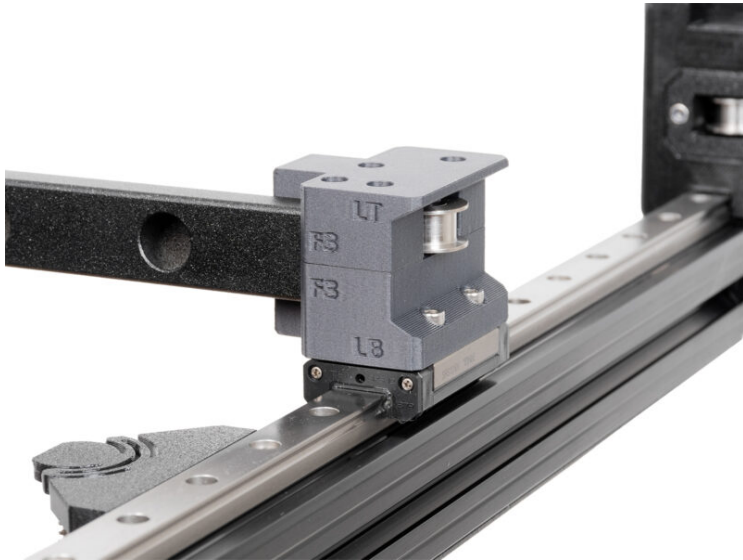
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# How to replace the CoreXY plastic parts

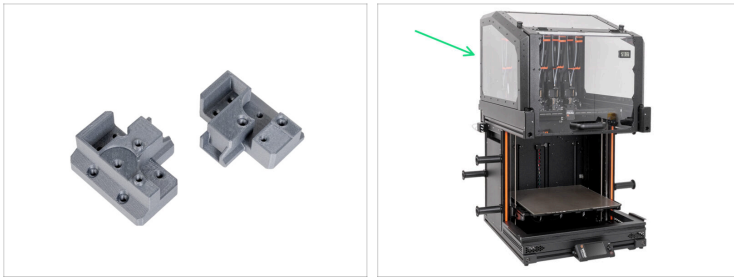


[help.prusa3d.com/g265856](https://help.prusa3d.com/g265856)

Scan the QR code to  
display the latest  
version of this  
chapter.



## STEP 1 Introduction



- ◆ This guide will take you through the installation of **CoreXY plastic parts** on the **Original Prusa XL**.
- ◆ All necessary parts are available in our eshop [prusa3d.com](https://prusa3d.com).
- 📌 Note that you have to be logged in to have access to the spare parts section.
- ◆ This manual is compatible with the Original Prusa XL Enclosure.
- ⓘ This manual is compatible with all Original Prusa XL printers.

## STEP 2 Tools necessary for this manual



- **For the following manual, please prepare:**
- Torx T10 screwdriver
- 2.5mm Allen key
- A cardboard box for use as heatbed protection during the assembly. *Hint: use the Nextruder box.*
- 4.0 mm Allen key

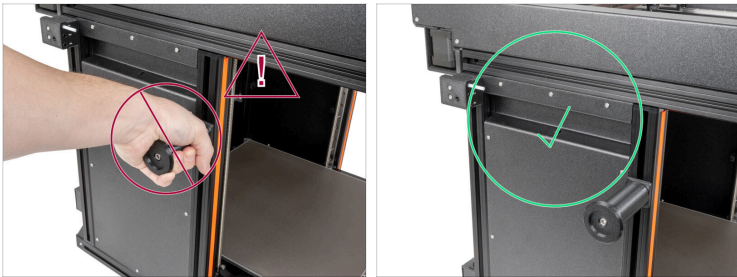
## STEP 3 Additional tools





**i** Tools that are not included but can make assembly easier, especially when installing add-ons.

- **Additional tools:**
- Side cutters for cutting zip ties and side panels cutouts

## STEP 4 Manipulating with the printer

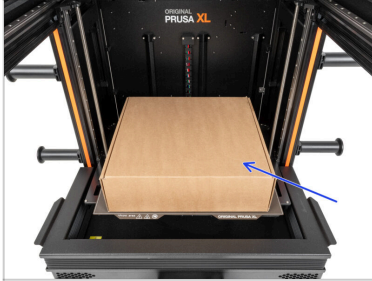


 **Never manipulate the printer by using the spoolholders or the upper metal flanges. You can damage the LED lights hidden inside.**

 When assembling, handle the base using the extrusions.

---

## STEP 5 Protecting the heatbed



- i** Before you proceed, it is recommended to protect the heatbed.
- Make sure the heatbed is cooled down to ambient temperature. Place the empty cardboard box approximately to the front center part of the heatbed.

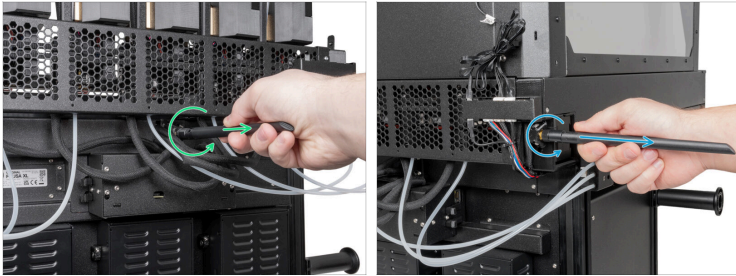
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## STEP 6 Printer unplugging



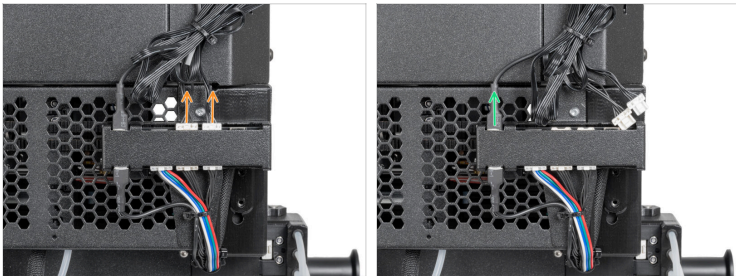
- Turn the power switch OFF (symbol "O").
- From the rear side of the printer, unplug the PSU cable.

## STEP 7 Removing the Wi-Fi antenna



- For the rear version:
  - Unscrew the antenna from the antenna connector.
- For the side version:
  - Unscrew the antenna from the antenna connector.

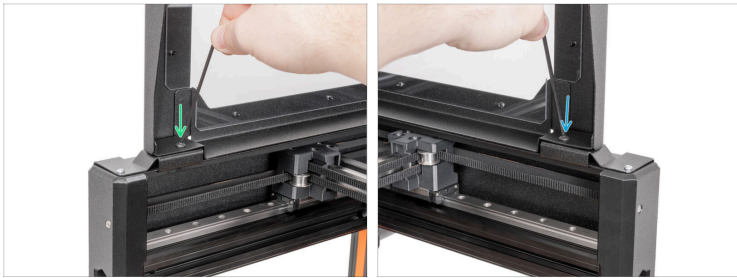
## STEP 8 Optional: Cables disconnecting



- ⓘ The next steps are for users who have an Original Prusa XL Enclosure add-on, otherwise skip to the **Belt releasing**
  - Disconnect the FAN and LED cables from the board by **pressing the safety latch**.
  - Unplug the PE faston from the connection box.

---

## STEP 9 Optional: Front side releasing



- From the front side of the enclosure:
- Open the lid.
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**

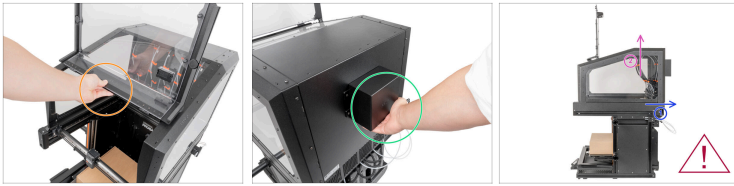
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## STEP 10 Optional: Rear side releasing



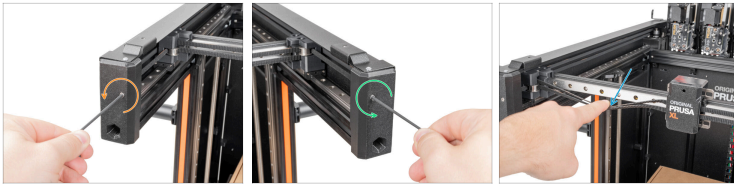
- From the rear side of the printer:
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**

## STEP 11 Optional: Enclosure removing



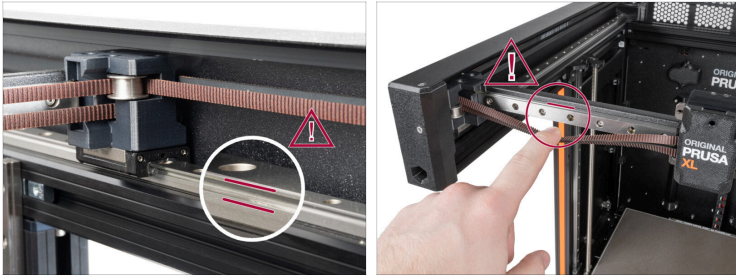
- ✦ Grasp the Enclosure on the front where is the support plate.
- ✦ Grasp the Enclosure on the back of where is the filtration cover.
- ✦ 1. Push the enclosure to the back of the printer.
- ✦ 2. Remove the Enclosure from the printer and place it on a flat surface.

## STEP 12 Belt releasing



- On the front side of the printer:
- Using a 2.5mm Allen key, release the M3 screw holding the left CoreXY tensioner. **Do not remove the screw completely.**
- Using a 2.5mm Allen key, release the M3 screw holding the right CoreXY tensioner. **Do not remove the screw completely.**
- Gently tension the belt with your finger. If the belt has a similar degree of looseness as shown in the picture, proceed to the next step.

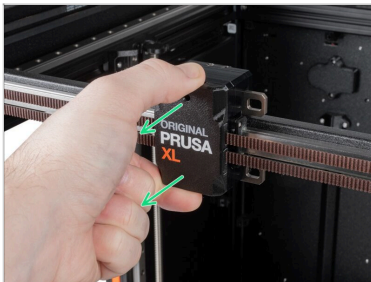
## STEP 13 CAUTION: Lubricant Handling



**⚠ CAUTION: Avoid direct skin contact with the lubricant used for the linear rails in this printer. If a contact occurs, wash your hands immediately. Especially before eating, drinking, or touching your face.**

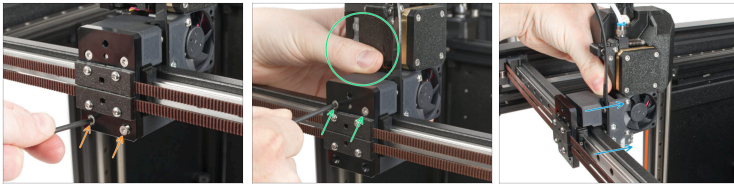
- ◆ Lubricant accumulates mainly in the linear rail channels on the linear sides.

## STEP 14 X-carrriage cover removing



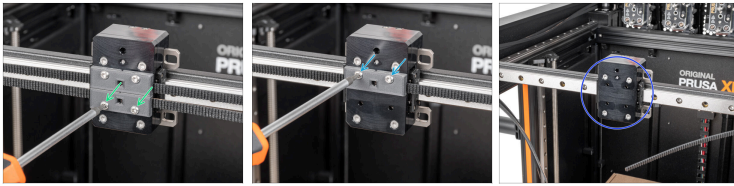
- ◆ Remove the X-carrriage cover. **Don't throw the part away!**
- ⓘ The cover snaps onto the X-carrriage. It is easily removable by hand.

## STEP 15 Single-tool Nextruder



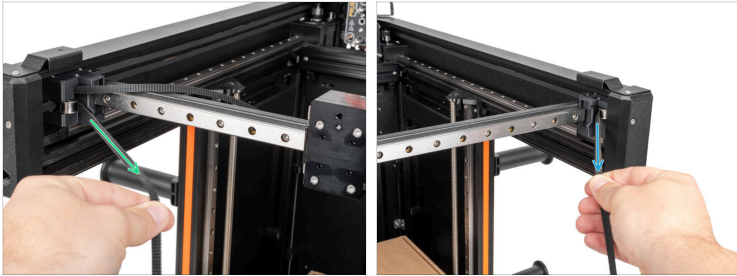
- i** This step is for **single-tool owners only**. Otherwise, ship to the next step.
- 🟠** Remove two M3x12bT screws using a T10 Torx screwdriver. **Don't throw the screws away!**
- 🟢** Hold the extruder and remove the remaining two M3x12bT screws from the top screw holes. **Don't throw the screws away!**
- 🟠** Remove the single-tool Nextruder from the X-carriage. Place the Nextruder on the box covering the heatbed.

## STEP 16 Belt clamps removing



- i** The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. **The procedure is the same, please continue.**
- ◆** Using the T10 Torx screwdriver, remove two M3x12rT screws holding the lower belt-clamp. Remove the belt-clamp. **Do not throw the parts away!**
- ◆** Using the T10 Torx screwdriver, remove two M3x12rT screws holding the upper belt-clamp. Remove the belt-clamp. **Do not throw the parts away!**
- ◆** With the belt-clamps removed, proceed to the next step.

## STEP 17 Belts removing



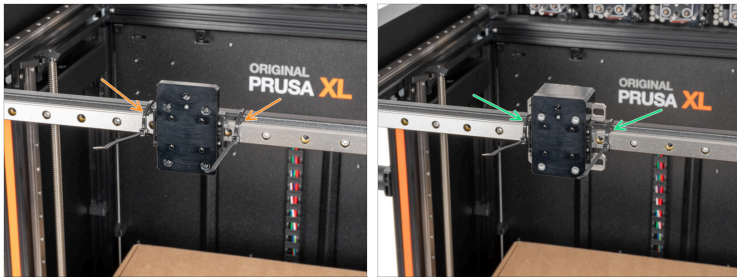
- ◆ Grasp the **bottom belt** on the **left side** of the CoreXY and pull the belt out of the printer.
- ◆ Grasp the **upper belt** on the **right side** of the CoreXY and pull the belt out of the printer.
- ◆ Throw old belts away!

## STEP 18 X-axis: parts preparation



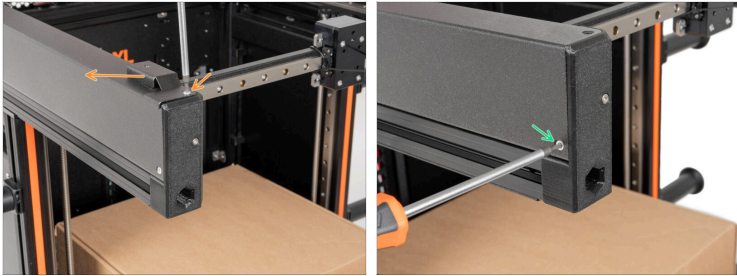
- ◆ **For the next step, please prepare:**
- ◆ Zip-tie (2x)

## STEP 19 X-axis securing



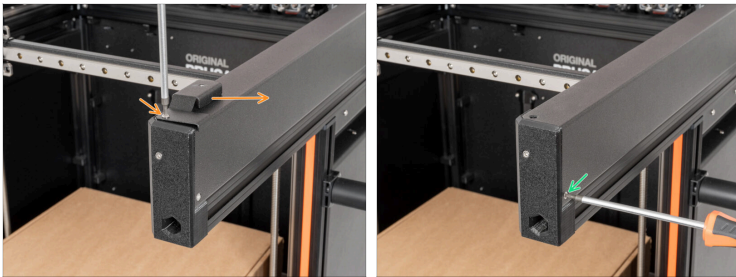
- Single-tool:
  - Secure the X-axis with zip-ties to prevent falling from the linear rail during the disassembly in the next steps.
- Multi-tool:
  - Secure the X-axis with zip-ties to prevent falling from the linear rail during the disassembly in the next steps.

## STEP 20 Front left releasing



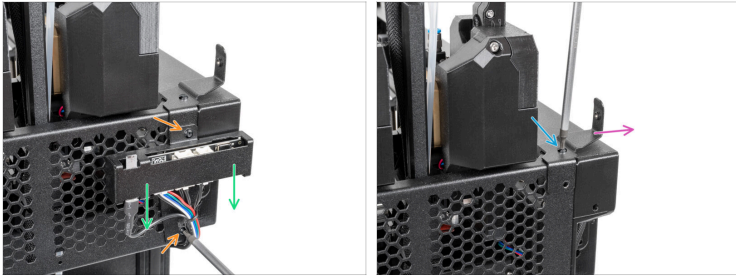
- On the front side of the printer:
- ① If you don't have the Original Prusa XL Enclosure, remove two M3x6bT screws. **Don't throw the parts away!** Continue to the next step.
- Remove the M3x10rT screw and remove the front left bracket. **Don't throw the parts away!**
- Remove the M3x6rT screw. **Don't throw the parts away!**

## STEP 21 Front right releasing



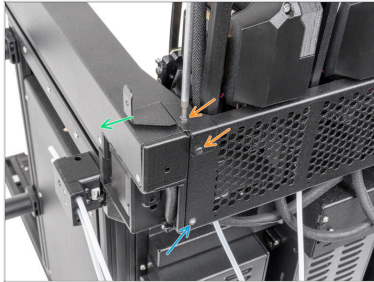
- i** If you don't have the Original Prusa XL Enclosure, remove two M3x6bT screws. Don't throw the parts away! Continue to the next step.
- o** Remove the M3x10rT screw and remove the front right bracket. Don't throw the parts away!
- o** Remove the M3x6rT screw. Don't throw the parts away!

## STEP 22 Rear right releasing



- On the rear side of the printer:
- ① If you don't have the Original Prusa XL Enclosure, remove three M3x6bT screws. **Don't throw the parts away!** Continue to the next step.
- Remove two M3x10rT screws using a T10 Torx screwdriver. **Don't throw the parts away!**
- Leave the connection box hanging freely on the cables.
- Remove the remaining M3x10rT screw using a T10 Torx screwdriver. **Don't throw the parts away!**
- Remove the fixing bracket rear left. **Don't throw the parts away!**

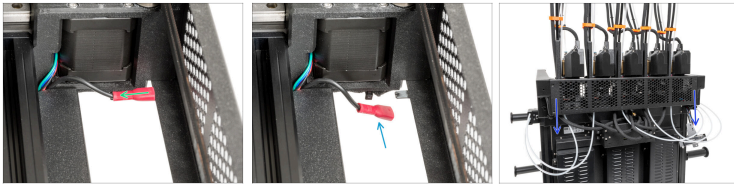
## STEP 23 Rear left releasing



**i** If you don't have the Original Prusa XL Enclosure, remove three M3x6bT screws. **Don't throw the parts away!** Continue to the next step.

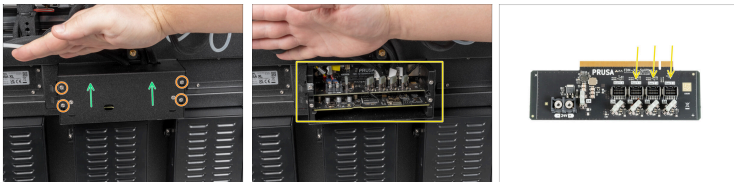
- o** Remove two M3x8bT screws using a T10 Torx screwdriver. **Don't throw the parts away!**
- o** Remove the fixing bracket rear left. **Don't throw the parts away!**
- o** Remove the M3x6bT using a T10 Torx screwdriver. **Don't throw the parts away!**

## STEP 24 CoreXY cover removing



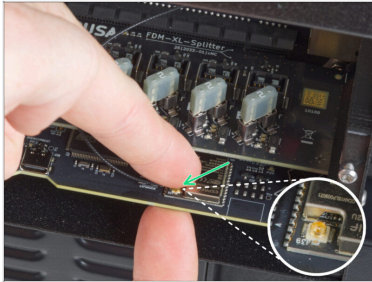
- On the right inner side of the CoreXY cover, unplug the PE connector.
- Leave the PE connector free.
- Gently pull the CoreXY cover from the printer towards you. **Do not throw the part away!**

## STEP 25 XL buddy box



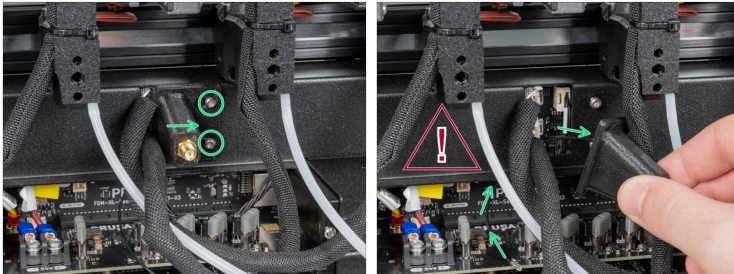
- Release (a few turns are enough) four M3 screws on the XL buddy box.
- Slide up and remove the XL buddy cover.
- i** The next line is only for five-head printers. Otherwise, skip to the next step.
- By pressing the security latch, unplug the DWARF3, DWARF4 and DWARF5 from the board.

## STEP 26 Antenna cable disconnecting



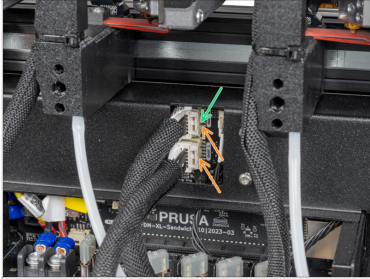
- Locate and unplug the Wi-Fi connector.
- ⓘ If you have the Wi-Fi antenna on the side of the printer, unplug the connector too.

## STEP 27 Back antenna removing



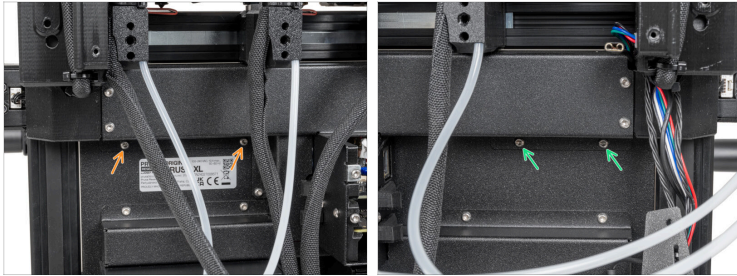
- ⓘ This step is only for the printer, which has a Wi-Fi antenna on the back of the printer.
- ⚠ **Be careful, do not damage the Wi-Fi antenna cable.**
- Loosen two screws on the cover slightly. No need to remove them completely. Push the cover to the right and remove it from the printer.

## STEP 28 Nextruder disconnecting



- ◆ In case you have a side antenna, loosen two screws on the cover slightly. No need to remove them completely. Push the cover to the right and remove it from the printer.
- ◆ In this step, select the appropriate option based on your XL printer variant:
  - ◆ **Single-tool:**  
There is only one cable. By pressing the security latch, remove the DWARF1 cable and proceed to the next step.
  - ◆ **Dual-Head & Five-Head:**  
There are two cables. By pressing the security latch, remove the DWARF1 and DWARF2 connectors from the board.

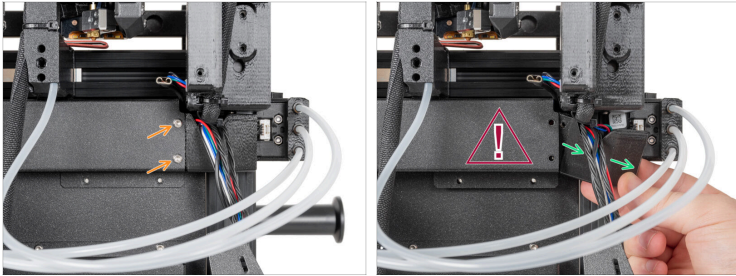
## STEP 29 Back cover releasing



- From the left side of the rear cable management upper, remove two M3x4rT screws. **Do not throw them away!**
- From the right side of the rear cable management upper, remove two M3x4rT screws. **Do not throw them away!**

---

## STEP 30 Optional: Cable cover cap removing



**i** This step is only for users who have an Original XL Enclosure. Otherwise, continue to the next step.

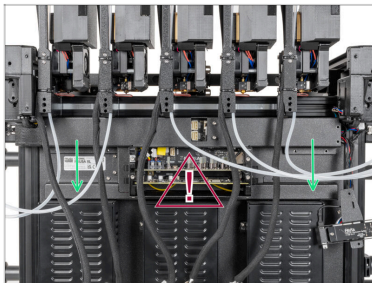
**o** Using a T10 Torx screwdriver, remove two M3x6rT screws.

**!** **Watch out for cables!**

**o** Gently remove cable-cover-cap-right.

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## STEP 31 Back cover removing

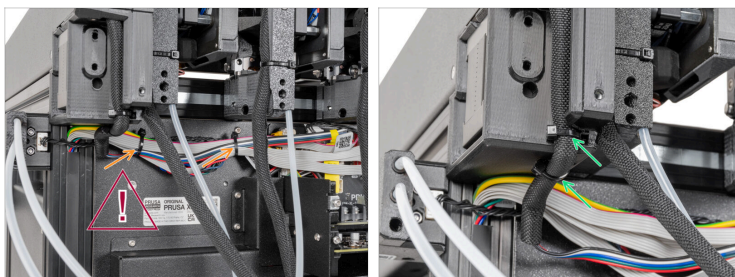


**!** **Watch out for cables!**



**o** Carefully remove the rear cable management upper from the printer.

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## STEP 32 Back right cables releasing



 **Watch out for the cables!**





-  Cut off two zip-ties holding the cables.
-  Cut off two zip-ties holding the LED cable.

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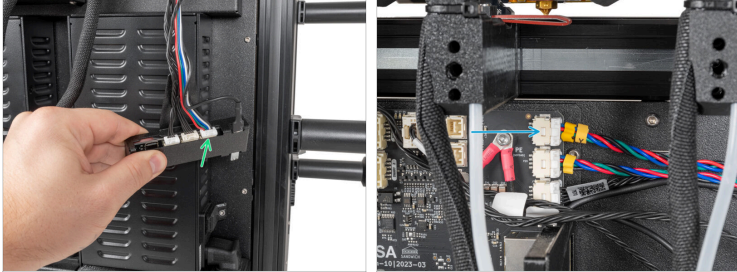
## STEP 33 Back left cables releasing



 **Watch out for the cables!**

-  Cut off two zip-ties holding the cables.
-  Cut off two zip-ties holding the LED cable.
-  **For XL Enclosure owners only.** Otherwise, ship to the next step.
-  Cut off one zip-tie holding the cables on the XL Enclosure board cover.

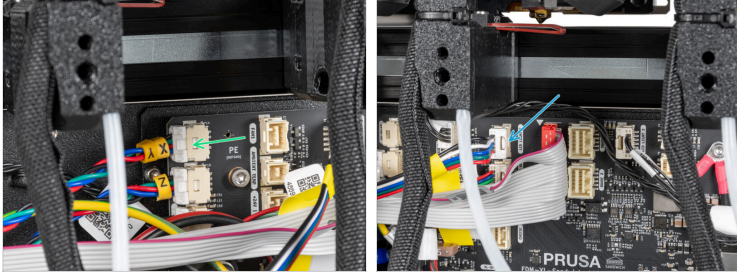
## STEP 34 Optional: Left XY motor & LED cable disconnecting



- i** These steps are for Original XL Enclosure owners. Otherwise, continue to the step **Side antenna removing**
- By pressing the safety latch, unplug the LED cable from the connection box.
  - By pressing the safety latch, unplug the XY motor cable.

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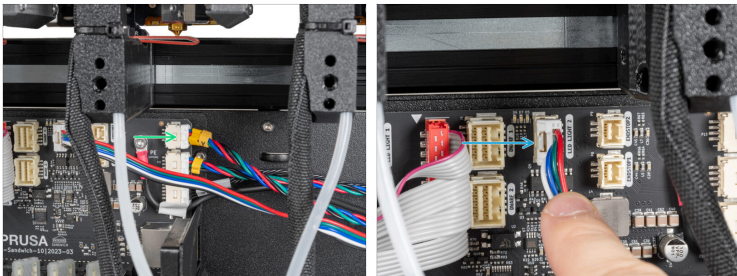
## STEP 35 Optional: Right XY motor & LED cable disconnecting



- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable from the connector.

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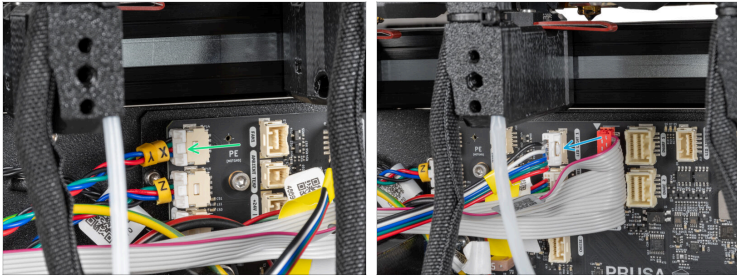
## STEP 36 Left XY motor & LED cable disconnecting



- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

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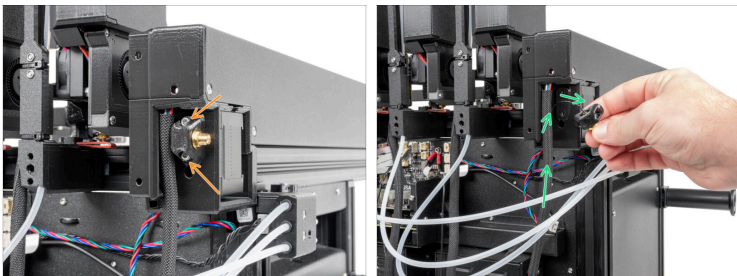
## STEP 37 Right XY motor & LED cable disconnecting



- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

---

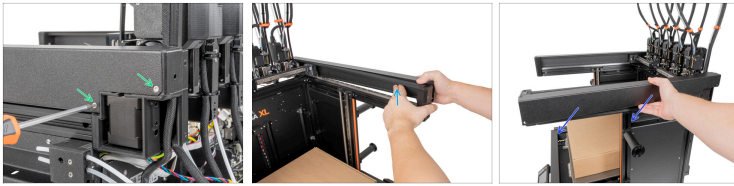
## STEP 38 Side antenna removing



- i** **These steps are for side antenna owners only.** Otherwise, continue to the next step.
- Remove two M3x10 screws using a 2.5 Allen key. **Don't throw the screws away.**
- Gently pull out the antenna cable from the black cotton sleeve. Put the antenna aside.

---

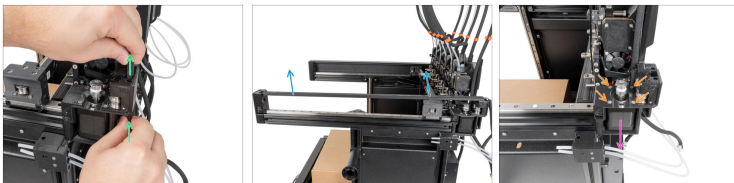
## STEP 39 CoreXY right metal cover remove



- From the right side of the printer:
- Using the T10 Torx screwdriver, remove two M3x6bT screws. **Don't throw the parts away!**
- Push the cover from the inner side.
- Remove the CoreXY cover. **Don't throw the parts away!**

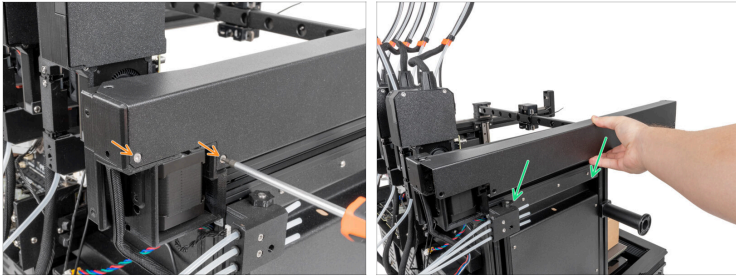
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## STEP 40 CoreXY-back-right disassembly



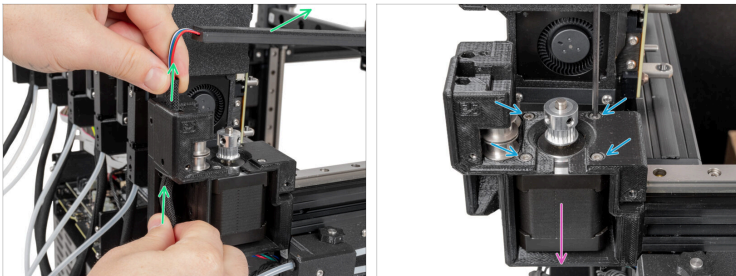
- Gently remove the LED strip cable from the CoreXY back.
- Remove the LED strip panel from the printer. **Don't throw the part away!**
- Using the 2.5mm Allen key, remove four M3x10 screws.
- Remove the XY motor.

## STEP 41 CoreXY left metal cover remove



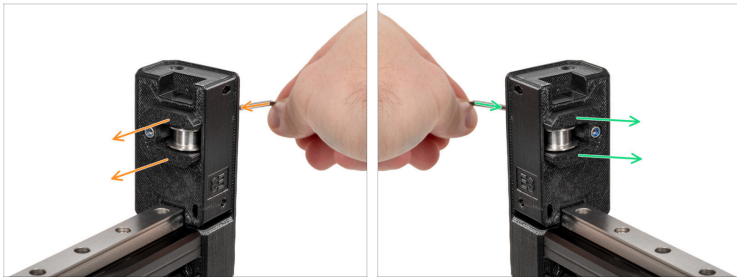
- From the left side of the printer:
- Using the T10 Torx screwdriver, remove two M3x6bT screws. **Don't throw the parts away!**
- Push the cover from the inner side and remove the CoreXY cover. **Don't throw the parts away!**

## STEP 42 CoreXY-back-left disassembly



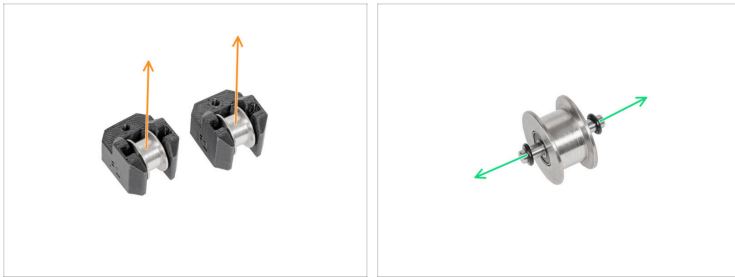
- Gently remove the LED strip cable from the CoreXY back. Remove the LED strip panel from the printer. **Don't throw the part away!**
- Using the 2.5mm Allen key, remove four M3x10 screws.
- Remove the XY motor.

## STEP 43 CoreXY-tensioner removing



- From the front side of the printer:
- Untighten the screw and remove the right CoreXY-tensioner. **Do not remove the screw.**
- Untighten the screw and remove the left CoreXY-tensioner. **Do not remove the screw.**

## STEP 44 CoreXY-tensioner disassembling



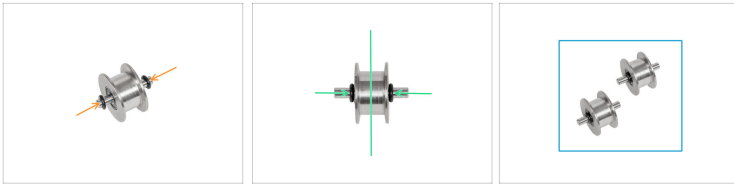
- Remove each single pulley with a pin from the CoreXY-tensioners. **Throw the old plastic parts into the bin.**
- From each single pulley, remove the two O-rings. **Throw the old O-rings into the bin.**
- ⓘ Leave the pins in the single pulleys, we'll reassemble them in the next steps.

## STEP 45 CoreXY-tensioner: parts preparing



- **For the next steps, please prepare:**
- CoreXY-tensioner (2x)
- M3nN nut (2x)
- O-ring (4x)

## STEP 46 Single pulley reassembly



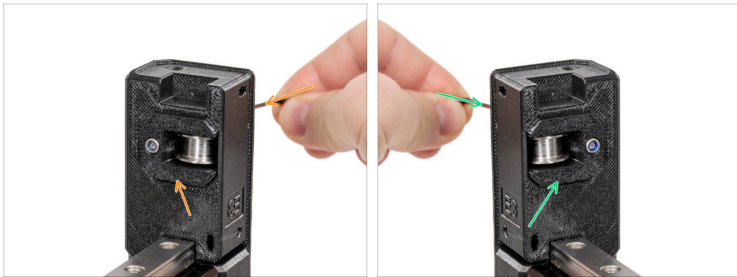
- Place an O-ring on each end of the pin.
- Push the O-rings towards the centre to keep the pulley in the centre.
- Prepare both pulleys.

## STEP 47 CoreXY-tensioner preparing



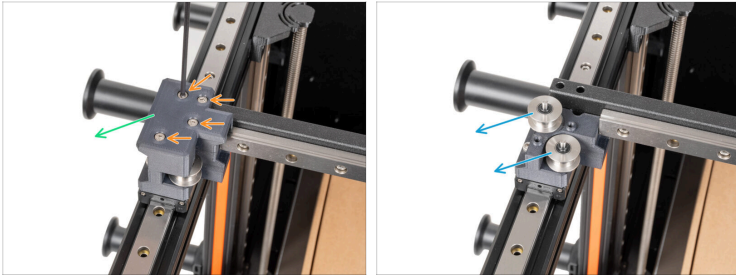
- Insert one M3nN nut into each CoreXY-tensioner.
- Insert each prepared single pulley into the CoreXY-tensioners.

## STEP 48 CoreXY-tensioner securing



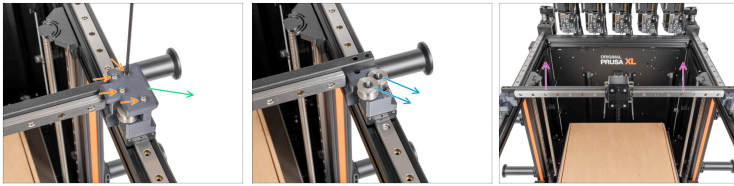
- ✚ Insert the prepared CoreXY-tensioner into the CoreXY-front-left and secure it with the screw. **A few turns are enough for now!**
- ✚ Insert the prepared CoreXY-tensioner into the CoreXY-front-right and secure it with the screw. **A few turns are enough for now!**

## STEP 49 Y-carriage-left-top disassembly



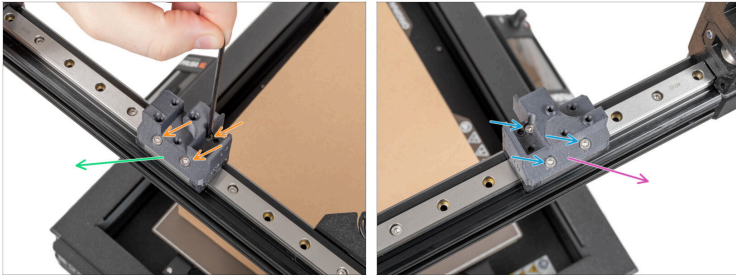
- 🟠 Using a 2,5mm Allen key, remove four M3x30 screws. **Don't throw the screws away!**
- 🟢 Remove the Y-carriage-left-top. **Throw the old plastic part into the bin.**
- 🟡 Remove two single pulleys with the pins from the Y-carriage-left-base. **Put them aside, we'll reassemble them later.**

## STEP 50 Y-carriage-right-top disassembly



- ✦ Using a 2,5mm Allen key, remove four M3x30 screws. **Don't throw the screws away!**
- ✦ Remove the Y-carriage-right-top. **Throw the old plastic part into the bin.**
- ✦ Remove two single pulleys with the pins from the Y-carriage-right-base. **Put them aside, we'll reassemble them later.**
- ✦ Remove the X-axis with a **secured tool-changer (x-carriage)**. **Put the part aside.**

## STEP 51 Y-carriage base disassembly



- Remove three M3x10 from the Y-carriage-right-base. **Don't throw the screws away!**
- Remove the Y-carriage-right-base. **Throw the old plastic part into the bin.**
- Remove three M3x10 from the Y-carriage-left-base. **Don't throw the screws away!**
- Remove the Y-carriage-left-base. **Throw the old plastic part into the bin.**

## STEP 52 Single pulley reassembly: parts preparation

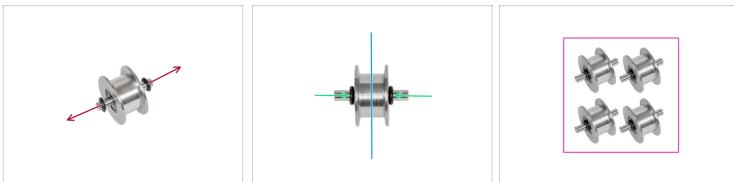


● For the next steps, please prepare:

● O-ring (8x)

● Assembled Single pulley (4x) *removed in previous steps*

## STEP 53 Single pulley reassembly



● Remove the old O-rings from each of the individual belt pulleys. **Throw the old O-rings into the bin.**

● Place a new O-ring on each end of the pin.

● Push the O-rings towards the centre to keep the pulley in the centre.

● Prepare all four single pulleys.

## STEP 54 X-axis: parts preparation



◆ **For the next steps, please prepare:**

◆ X-axis (1x) *removed in the previous steps*

◆ M3nN nut (8x)

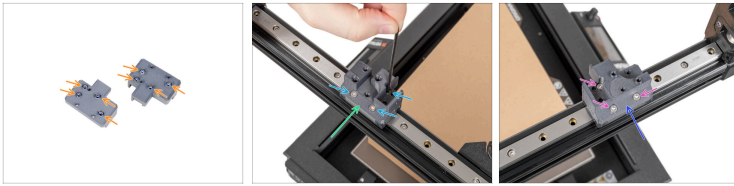
◆ M3x10 screw (6x) *removed in the previous steps*

⚠ **The printed parts of the Y-carriage are marked with printed letters. Look at the third picture.**

◆ Y-carriage-right-base (1x) *marked RB*

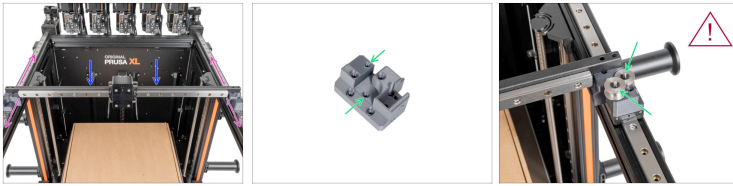
◆ Y-carriage-left-base (1x) *marked LB*

## STEP 55 Y-carriage base assembly



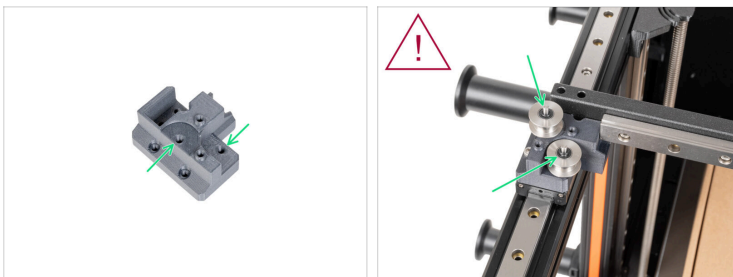
- ✦ Insert M3nN nuts into the Y-carriage bottoms.
- ✦ Place the **Y-carriage-right-base (RB)** onto the linear rail carts.
- ✦ Secure the Y-carriage-right-base (RB) with three M3x10 screws.
- ✦ Place the **Y-carriage-left-base (LB)** onto the linear rail carts.
- ✦ Secure the Y-carriage-left-base (LB) with three M3x10 screws.

## STEP 56 Y-carriage-right-base assembly



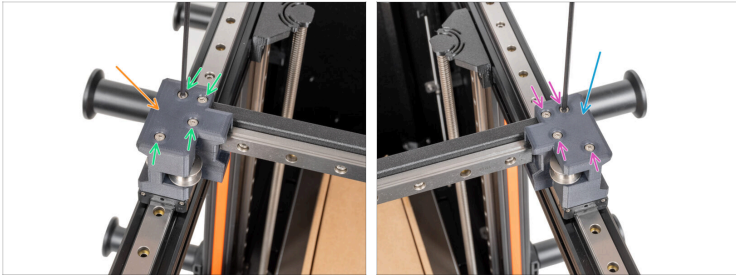
- ◆ Insert the X-axis onto Y-carriage bases.
- ◆ To ensure that the X-axis is properly seated in the base of the Y-carriage, slide the X-axis back and forth a few times.
- ⚠ Make sure that the individual pulleys are complete with all the necessary parts! **Especially O-rings!**
- ◆ Insert two prepared single pulleys into marked holes in the Y-carriage-right-base. See the picture.

## STEP 57 Y-carriage-left-base assembly



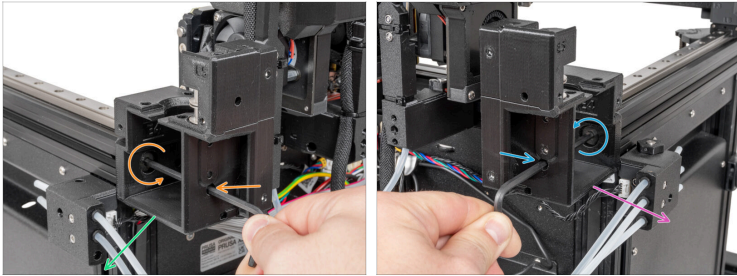
- ⚠ Make sure that the individual pulleys are complete with all the necessary parts! **Especially O-rings!**
- ◆ Insert two prepared single pulleys into the marked holes in the Y-carriage-left-base. See the picture.

## STEP 58 Y-carriage top assembly



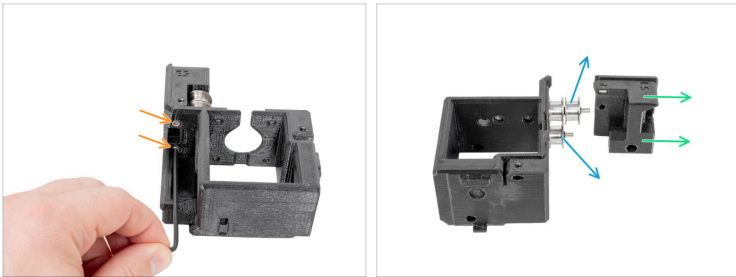
- Attach the **Y-carriage-left-top (LT)** onto the Y-carriage-left-base.
- Secure the Y-carriage-left-top with four M3x30 screws. **Do not overtighten, make sure the pulleys can rotate freely.**
- Attach the **Y-carriage-right-top (RT)** onto the Y-carriage-right-base.
- Secure the Y-carriage-right-top with four M3x30 screws. **Do not overtighten, make sure the pulleys can rotate freely.**
- Well done! The X-axis parts are replaced, let's continue.

## STEP 59 CoreXY-back removing



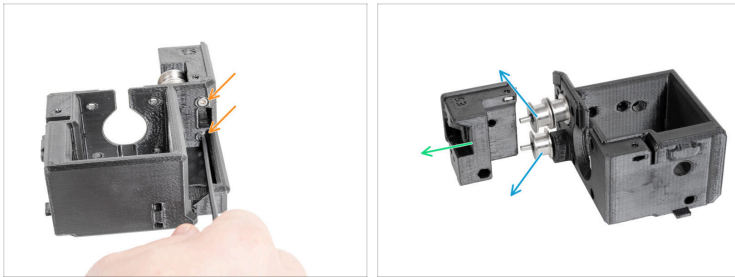
- ✦ Insert the 4mm Allen key through the hole and remove the M8x16 screw.
- ✦ Remove the CoreXY-back-right from the printer.
- ✦ Insert the 4mm Allen key through the hole and remove the M8x16 screw.
- ✦ Remove the CoreXY-back-right from the printer.

## STEP 60 CoreXY-back-left disassembling



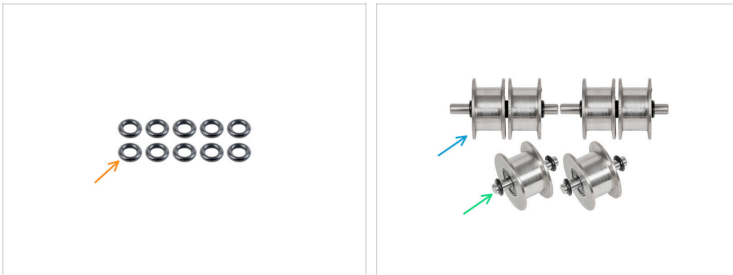
- ✦ Using a 2.5mm Allen key, remove two M3x35 screws.
- ✦ Remove the CoreXY-back-right-top from the CoreXY-back-right. **Don't throw the parts away, we'll need some distance nuts.**
- ✦ Remove the double pulley and the single pulley. **Don't throw the parts away!**
- ⓘ Leave the pins in the pulleys, we'll reassemble them in the next steps.

## STEP 61 CoreXY-back-right disassembling



- ✦ Using a 2.5mm Allen key, remove two M3x35 screws.
- ✦ Remove the CoreXY-back-right-top from the CoreXY-back-right. **Don't throw the parts away, we'll need some distance nuts.**
- ✦ Remove the double pulley and the single pulley. **Don't throw the parts away!**
- ⓘ Leave the pins in the pulleys, we'll reassemble them in the next steps.

## STEP 62 Pulley reassembly: parts preparation



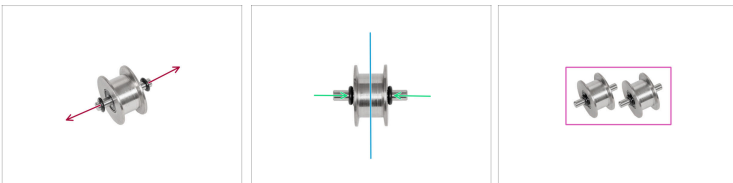
■ For the next steps, please prepare:

■ O-ring (10x)

■ Assembled Single pulley (2x) *removed in previous steps*

■ Assembled Double pulley (2x) *removed in previous steps*

## STEP 63 Single pulley reassembly



■ Remove the old O-rings from each of the individual belt pulleys. **Throw the old O-rings into the bin.**

■ Place a new O-ring on each end of the pin.

■ Push the O-rings towards the centre to keep the pulley in the centre.

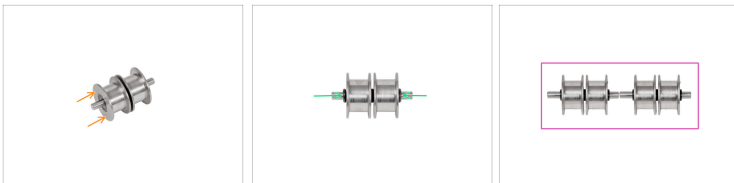
■ Prepare both single pulleys.

## STEP 64 Double pulley disassembly



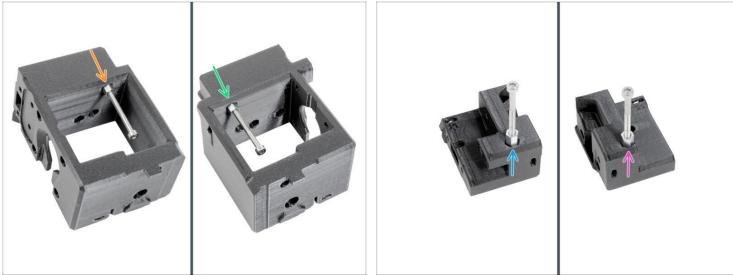
- 🟠 From each side of the pin, remove the O-ring. **Throw the old O-rings into the bin.**
- 🟢 Remove the pulley. **Put it aside.**
- 🟡 Remove the remaining O-Ring. **Throw the old O-Ring into the bin.**
- 🟣 Attach a **new** O-Ring on the pin. See the picture.

## STEP 65 Double pulley reassembly



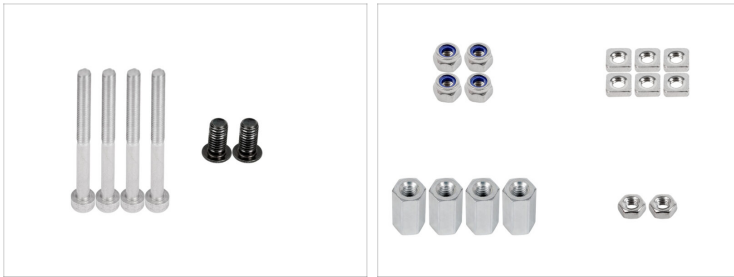
- 🟠 Attach the removed pulley back onto the pin. See the picture.
- 🟢 Attach on each side one **new** O-ring. See the picture.
- 🟣 Prepare both double pulleys.
- ⬛ Good job. Single and double pulleys are prepared. Let's continue.

## STEP 66 Spacers removing



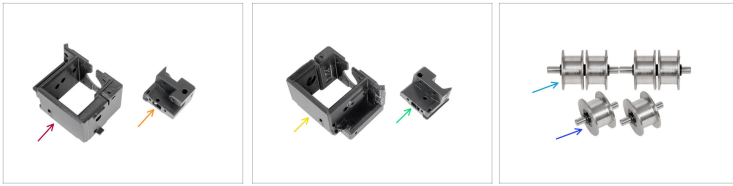
- i** *Hint: You can use an M3x35 to remove the M3x10 spacer nut.*
- o** Remove one M3x10 spacer nut from CoreXY-back-left. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
  - o** Remove one M3x10 spacer nut from CoreXY-back-right. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
  - o** Remove one M3x10 spacer nut from CoreXY-back-left-top. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
  - o** Remove one M3x10 spacer nut from CoreXY-back-right-top. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
  - o** Throw your old CoreXY-backs & tops in the bin, we don't need them anymore.

## STEP 67 Back assembly: parts preparation









- ◆ **For the next steps, please prepare:**
- ◆ M3x35 screw (2x) *removed in previous steps*
- ◆ M8x16 screw (2x) *removed in previous steps*
- ◆ M3nN nut (4x)
- ◆ M3nS nut (6x)
- ◆ M3x10 spacer nut (4x) *removed in previous steps*
- ◆ M3n nut (2x) *for side antenna owners only*
- ⓘ The list continue in the next step.

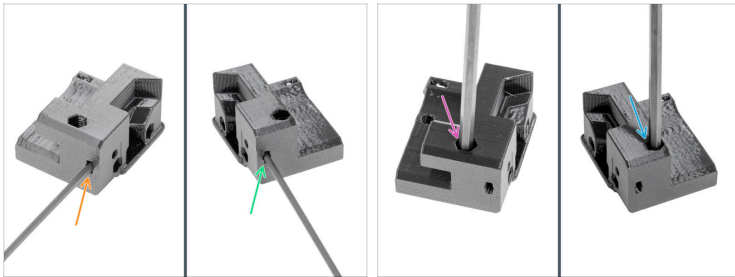
## STEP 68 Back assembly: parts preparation



**For the next steps, please prepare:**

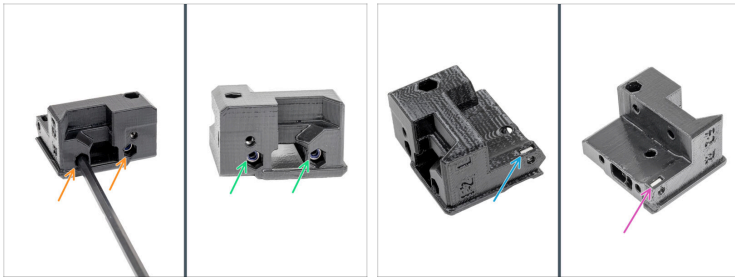
-  CoreXY-back-left (1x)
-  CoreXY-back-left-top (1x)
-  CoreXY-back-right (1x)
-  CoreXY-back-right-top (1x)
-  Reassembled double pulley (2x)
-  Reassembled single pulley (2x)

## STEP 69 CoreXY-back-top preparing: part one



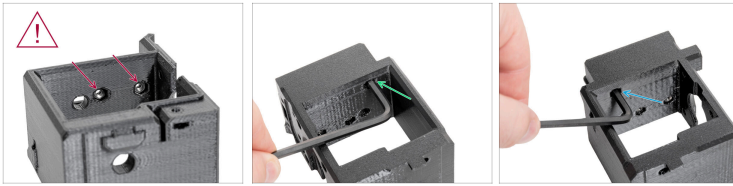
- Insert one M3nS nut into the CoreXY-back-left-top. Push it with a 2.5 mm Allen key. See the first picture.
- Insert one M3nS nut into the CoreXY-back-right-top. Push it with a 2.5 mm Allen key. See the first picture.
- Insert one M3x10 spacer nut into the CoreXY-back-left-top. Push it with a 4.0 mm Allen key. See the second picture.
- Insert one M3x10 spacer nut into the CoreXY-back-right-top. Push it with a 4.0 mm Allen key. See the second picture.

## STEP 70 CoreXY-back-top preparing: part two



- ✚ Insert two M3nN nut into the CoreXY-back-right-top. Push it with a 4.0 mm Allen key. See the first picture.
  - ✚ Insert two M3nN nut into the CoreXY-back-left-top. Push it with a 4.0 mm Allen key. See the first picture.
  - ✚ Insert one M3nS nut into the CoreXY-back-left-top. Push it with a 2.5 mm Allen key. See the second picture.
  - ✚ Insert one M3nS nut into the CoreXY-back-right-top. Push it with a 2.5 mm Allen key. See the second picture.
- ⚠ Double-check that you have inserted all the nuts as described in steps 68 and 69 (nice). You don't want to find out later that you missed a nut. Trust me on this.

## STEP 71 CoreXY-back preparing: part one



- ⬢ **Only if you have an antenna on the left:** Insert two M3n into the inside of the CoreXY-back-left. See the picture
- ⬢ Insert one M3x10 spacer nut into the CoreXY-back-left. Push it with a 4.0 mm Allen key. See the second picture.
- ⬢ Insert one M3x10 spacer nut into the CoreXY-back-right. Push it with a 4.0 mm Allen key. See the third picture.

## STEP 72 CoreXY-back preparing: part two



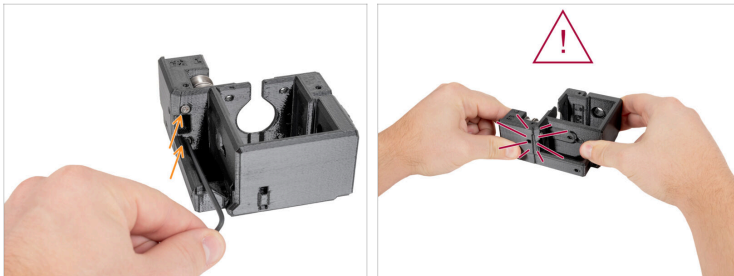
- ✦ Insert one M3nS nut into the CoreXY-back-right. Push it with a 2.5 mm Allen key. See the first picture.
- ✦ Insert one M3nS nut into the CoreXY-back-left. Push it with a 2.5 mm Allen key. See the second picture.
- ⚠ Double-check that you have inserted all the nuts as described in steps 70 and 71. You don't want to find out later that you missed a nut. Trust me on this.

## STEP 73 CoreXY-back-left-top preparing



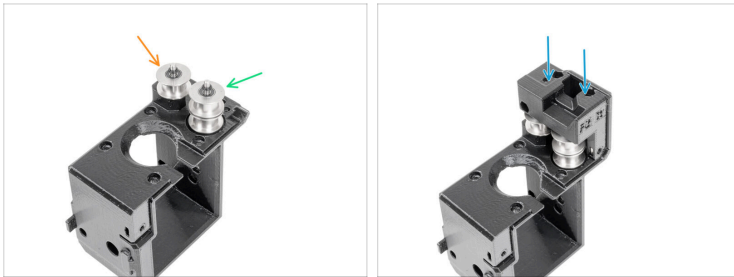
- ✦ Insert the prepared double pulley into the CoreXY-back-left. See the picture.
- ✦ Insert the prepared single pulley into the CoreXY-back-left. See the picture.
- ✦ Attach the CoreXY-back-left-top onto the pulleys and the CoreXY-back-left. See the picture.

## STEP 74 CoreXY-back-left-top securing



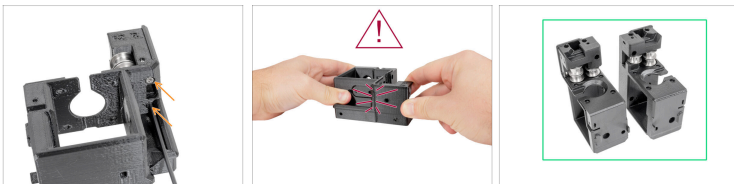
- ✦ Insert and tighten two M3x35 screws.
- ⚠ **The parts must be tightened together. Check that the parts do not move. Tighten the M3x35 screws if necessary.**

## STEP 75 CoreXY-back-right-top preparing



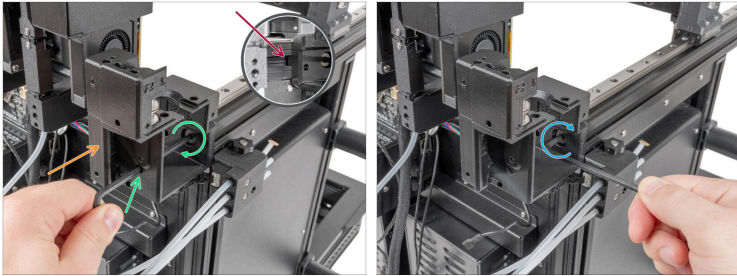
- ✦ Insert the prepared single pulley into the CoreXY-back-right. See the picture.
- ✦ Insert the prepared double pulley into the CoreXY-back-right. See the picture.
- ✦ Attach the CoreXY-back-right-top onto the pulleys and the CoreXY-back-right.

## STEP 76 CoreXY-back-right-top securing



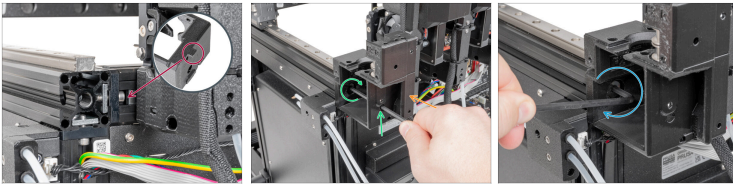
- ✦ Insert and tighten two M3x35 screws.
- ⚠ **The parts must be tightened together. Check that the parts do not move. Tighten the M3x35 screws if necessary.**
- ✦ Well done. Both CoreXY-backs are ready to be attached to the printer.

## STEP 77 CoreXY-back-left securing



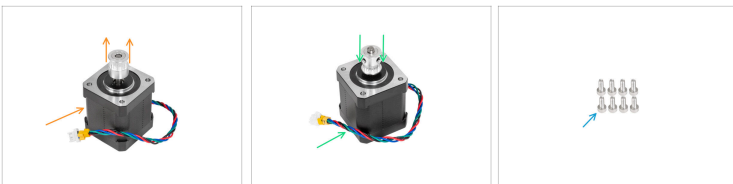
- Both CoreXY-backs have a printed piece that fits inside the extrusion. See picture.
- Attach the CoreXY-back-left to the printer.
- Secure the CoreXY-back-right with an M8x16 screw using a 4.0 mm Allen key.
- Tighten the screw with the shorter side of the 4.0 mm Allen key.

## STEP 78 CoreXY-back-right securing



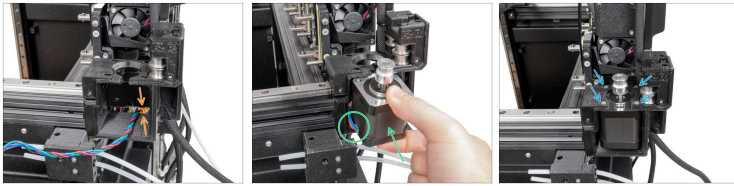
- ◆ The right CoreXY-back-right has a printed piece that fits into the extrusion between the screw and the tch-insert. See picture.
- ◆ Attach the CoreXY-back-right to the printer.
- ◆ Secure the CoreXY-back-right with an M8x16 screw using a 4.0 mm Allen key.
- ◆ Tighten the screw with the shorter side of the 4.0 mm Allen key.

## STEP 79 XY-motor: parts preparation



- ◆ **For the next steps, please prepare:**
- ⚠ **Look how are GT2-16 pulleys oriented on each motor. See the pictures.**
- ◆ XY-motor right (1x) *removed in previous steps*
- ◆ XY-motor left(1x) *removed in previous steps*
- ◆ M3x8 screw (8x) *removed in previous steps*

## STEP 80 Right XY-motor securing



- ✦ Insert the cable through the CoreXY-back-right and under the fifth tool-head (if installed). See the picture.
- ✦ Insert the motor into the CoreXY-back-right. **The motor cable has to be oriented to the left.** See the picture.
- ✦ Insert and secure four M3x8 using a 2.5mm Allen key.

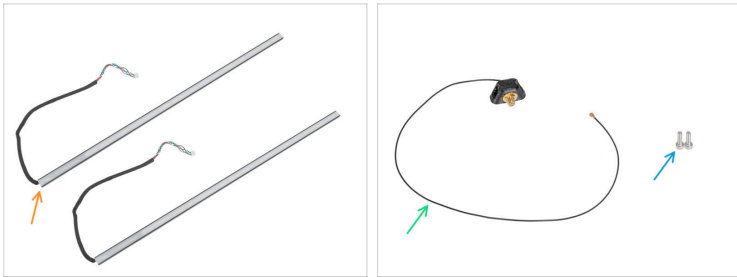
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## STEP 81 Left XY-motor securing



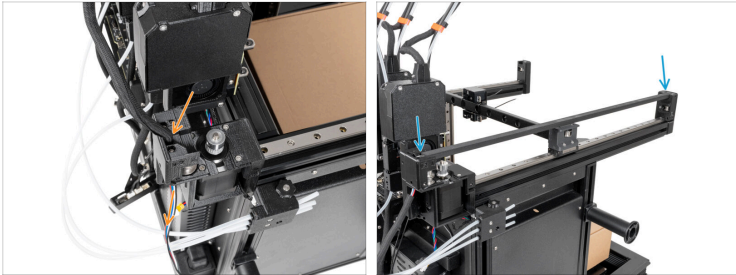
- ✦ Insert the cable through the CoreXY-back-left.
- ✦ Insert the motor into the CoreXY-back-left. The motor cable has to be oriented to the right. See the picture.
- ✦ Insert and secure four M3x8 using a 2.5mm Allen key.

## STEP 82 LED strip: parts preparation



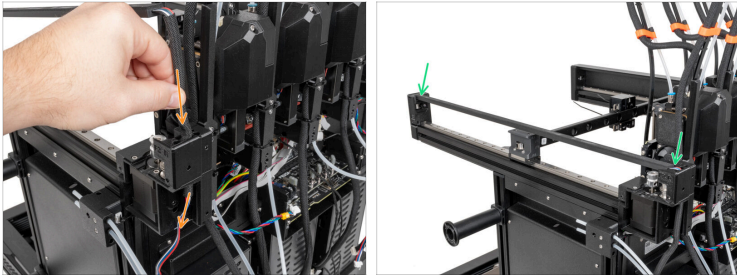
- **For the next steps, please prepare:**
- LED strip (2x) *removed in previous steps*
- For side antenna owners only:
- Side antenna assembly (1x) *removed in previous steps*
- M3x10 screw (2x) *removed in previous steps*

## STEP 83 Left LED strip attaching



- ◆ Insert the power cable of the LED strip through the hole in the CoreXY back.
- ⓘ The LED strip panel must face down with the white diffuser facing downwards.
- ◆ Attach the back side of the LED strip panel onto the CoreXY-back-left and CoreXY-front-left.

## STEP 84 Right LED strip attaching



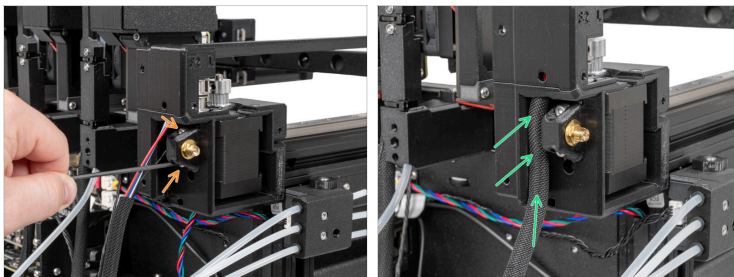
- ✦ Insert the power cable of the LED strip through the hole in the CoreXY-back-right.
- ⓘ The LED strip panel must face down with the white diffuser facing downwards.
- ✦ Attach the back side of the LED strip panel onto the CoreXY-back-right and CoreXY-front-right.

## STEP 85 Side antenna preparing



- i** These steps are for **side antenna owners only**. Otherwise, ship to the step Core XY cover: parts preparation
- On the back side, where was your antenna used to be:
- Insert the end of the antenna cable into the black textile sleeve.
- Push the antenna cable through the sleeve.
- At the top, pull the antenna cable out of the sleeve a little. See the picture.

## STEP 86 Side antenna securing



- Attach and secure the side antenna with two M3x10 screws using a 2.5 mm Allen key.
- Lift the textile sleeve and push it into the CoreXY back-left. See the picture.

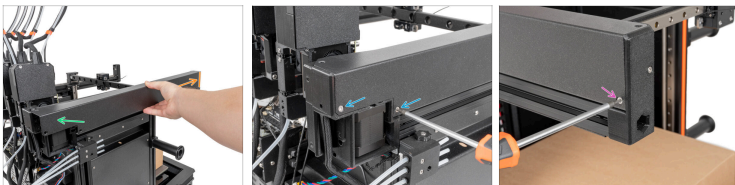
## STEP 87 CoreXY cover: parts preparation



◆ For the next steps, please prepare:

- ◆ CoreXY cover left (1x) *removed in previous steps*
- ◆ CoreXY cover right (1x) *removed in previous steps*
- ◆ M3x6bT screw (6x) *removed in previous steps*

## STEP 88 CoreXY cover left securing



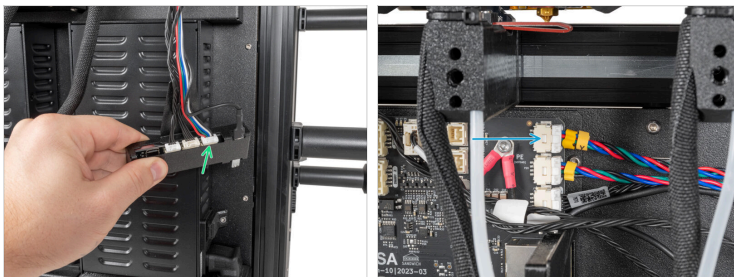
- ◆ Insert the front (straight) part of the Cover CoreXY left into the CoreXY-front-left and slide the cover into place.
- ◆ Push the rear side of the Cover CoreXY left panel into the CoreXY-back-left.
- ◆ Insert two M3x6bT into the holes and tighten them using a T10 Torx screwdriver.
- ◆ Insert one M3x6bT into the hole and tighten it using a T10 Torx screwdriver.

## STEP 89 CoreXY cover right securing



- 🟠 Attach the Cover CoreXY right onto the printer.
- 🟢 Push the rear side of the Cover CoreXY right into the CoreXY-back-right.
- 🟡 Insert two M3x6bT into the holes and tighten them using a T10 Torx screwdriver.
- 🟣 Insert one M3x6bT into the hole and tighten it using a T10 Torx screwdriver.

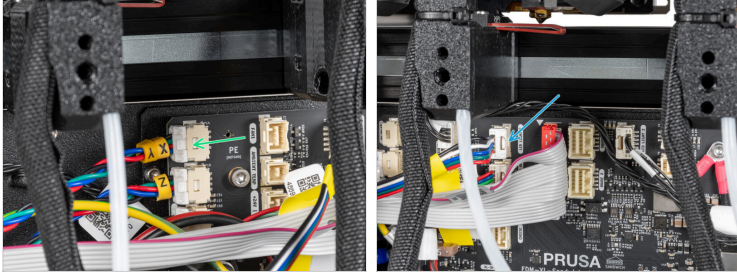
## STEP 90 Optional: Left XY motor & LED cable connecting



- 📘 These steps are for Original XL Enclosure owners. Otherwise, continue to the step **Left XY motor & LED cable disconnecting**
- 🟢 Connect the LED cable to the connection box.
- 🟡 Connect the XY motor cable.

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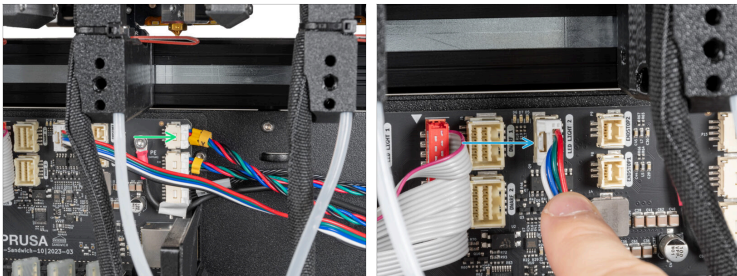
## STEP 91 Optional: Right XY motor & LED cable connecting



- Connect the XY motor cable.
- Connect the LED cable to the LED Light 1 connector.

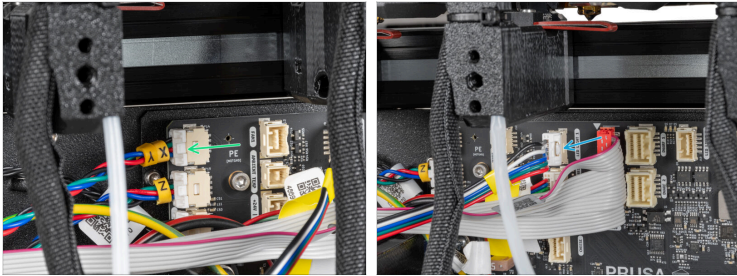
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## STEP 92 Left XY motor & LED cable connecting



- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

## STEP 93 Right XY motor & LED cable connecting



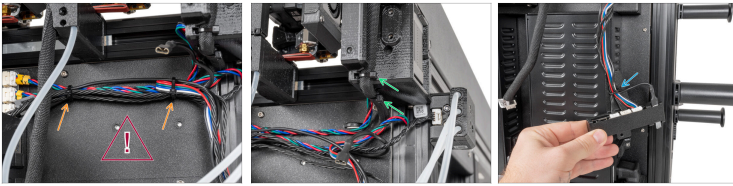
- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

## STEP 94 Back cables securing: part preparation



- For the next step, please prepare:**
- Zip-tie (9x)

## STEP 95 Back left cables securing



**ATTENTION: Do not overtighten the zip ties! Otherwise, you risk damaging the cables.**

- Insert the zip-tie through the metal cut-out and secure all cables. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.
- From the bottom side of the CoreXY-back-left, insert two zip-ties around the LED strip cable. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.
- **For XL Enclosure owners only.** Otherwise, ship to the next step.
- Secure the cables carefully to the XL enclosure board cover. **Do not overtighten the zip-tie.** Cut the end of the zip-tie.

## STEP 96 Back right cables securing



**ATTENTION: Do not overtighten the zip ties! Otherwise, you risk damaging the cables.**

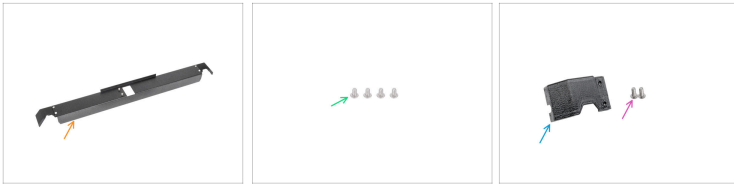


Insert the zip-tie through the metal cut-out and secure all cables. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.



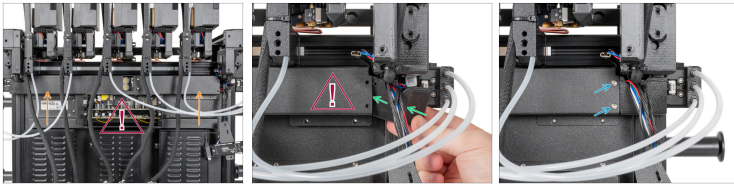
From the bottom side of the CoreXY-back-left, insert two zip-ties around the LED strip cable. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.

## STEP 97 Back cover: parts preparation







- **For the next steps, please prepare:**
- Rear cable management upper (1x) *you removed in the previous steps*
- M3x4rT screws (4x) *you removed in the previous steps*
- **For XL Enclosure owners only.** Otherwise, skip to the next step.
- Cable-cover-cap-right (1x) *removed in previous steps*
- M3x8rT screw (2x) *removed in previous steps*

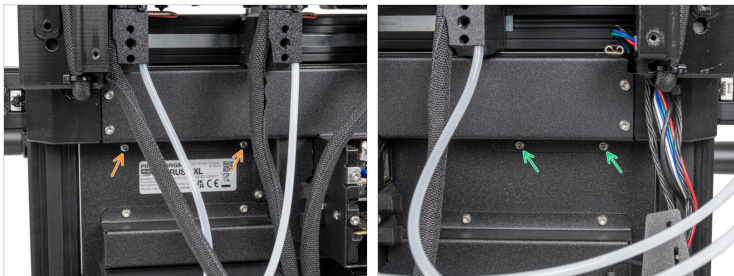
## STEP 98 Back cover attaching





### **Watch out for cables!**

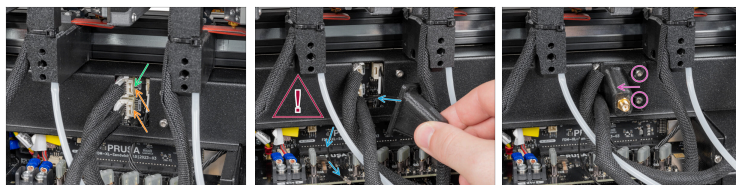
-  Carefully attach the rear cable management upper to the printer.
-  **This step is only for users who have an Original XL Enclosure.** Otherwise, continue to the next step.
-  Gently insert the cable-cover-cap-right.
-  Insert and secure two M3x8rT screws using a T10 Torx screwdriver.

## STEP 99 Back cover securing



-  On the left side of the rear cable management upper, insert and secure two M3x4rT screws.
-  On the right side of the rear cable management upper, insert and secure two M3x4rT screws.

## STEP 100 Antenna cover attaching



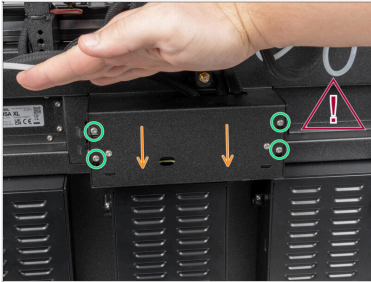
- ◆ In this step, select the appropriate option based on your XL printer variant:
  - ◆ Single-tool: There is only one cable. Connect the first dock (from the right side) cable to the upper slot labeled DWARF 1.
  - ◆ Dual-Head & Five-Head: Connect the second dock (from the right side) cable to the lower slot labeled DWARF 2.
- ⓘ The next step is only for the printer, which has a **Wi-Fi antenna on the back** of the printer. Otherwise, skip to the following one.
- ⚠ **Be careful, do not damage the Wi-Fi antenna cable.**
- ◆ Push the antenna cable through the opening in the cable cover (metal sheet) and guide it behind the cover to the electronics box.
- ◆ Attach the antenna-holder on the screws and push the cover to the left. Tighten the screws.


## STEP 101 Antenna & Nextruder connecting





- ◆ Locate and connect the Wi-Fi cable to the Wi-Fi connector.
- ⓘ Those steps are only for printers with more than 2 Nextruders. **Otherwise go to the next step.**
- ◆ Connect the third, fourth and fifth (from the right) Nextruder to the splitter:
  - ◆ Third Nextruder.
  - ◆ Fourth Nextruder.
  - ◆ Fifth Nextruder.
- ◆ XL splitter with connected Nextruders has to look like this.


## STEP 102 XL buddy box attaching



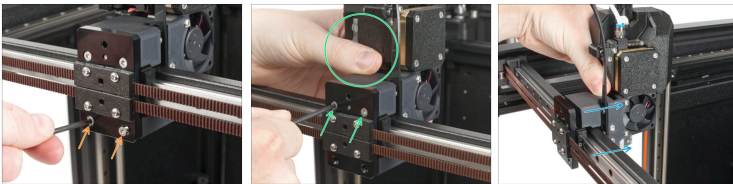
 **Be careful, do not pinch any cables!**


 Put the XL buddy box cover back on the printer.

 Check Nextruders cables, they have to be inside the cutout in the cover.


 With a T10 key tighten the four screws.


## STEP 103 Single-tool Nextruder



 This step is for **single-tool owners only**. Otherwise, skip to the next step.




 Remove two M3x12bT screws using a T10 Torx screwdriver. **Don't throw the screws away!**

 Hold the extruder and remove the remaining two M3x12bT screws from the top screw holes. **Don't throw the screws away!**

 Remove the single-tool Nextruder from the X-carriage. Place the Nextruder on the box covering the heatbed.






## STEP 104 Belt attaching: important information



-  It is important to attach the belts correctly to the printer. Do not rush.
-  Always Compare pictures with your printer.
-  Make sure, that no belt is twisted.

## STEP 105 Belts attaching: parts preparation



-  The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. **The procedure is the same, please continue.**
-  **For the following steps, please prepare:**
  -  New XY belts (2x)
  -  XL-belt-clamp (2x) *removed in previous steps*
  -  M3x12rT screws (4x) *removed in previous steps*

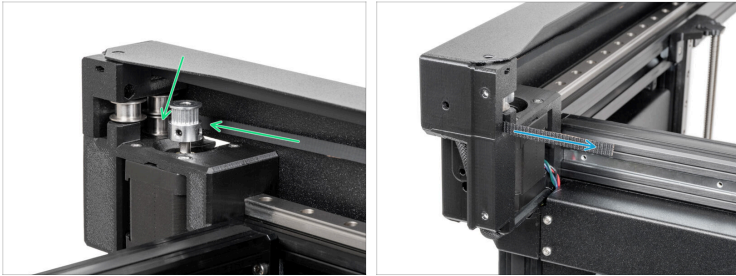
## STEP 106 Lower belt attaching: right front side



- ◆ From the front side of the printer:
- ◆ Take one of the belts.
- ◆ Insert the one end of the belt into the front lower section of the Y-carriage-right-base.
- ◆ The belt has to be facing toward the printer with the teeth showing (not the smooth side of the belt).
- ⓘ Double check, that you have the teeth showing side facing towards the machine.
- ◆ On the inner side of the Y-carriage-right-base pull the the belt.
- ⚠ Don't pull the belt too much, it can fall out from the Y-carriage-right-base and the whole process of the belt attaching has to be repeated from the start.

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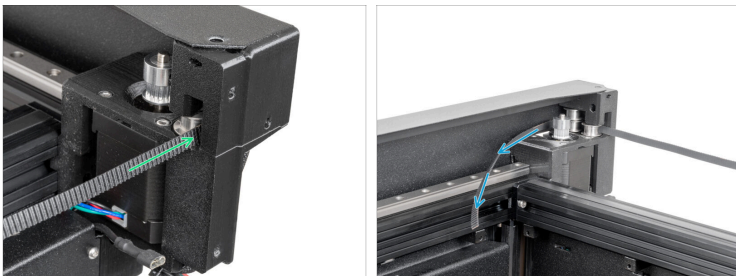
## STEP 107 Lower belt attaching: right rear side



- ◆ Pull the belt some more and insert it behind the lower pulley.
- ◆ Pull the belt, which is now inserted through the lower pulley.

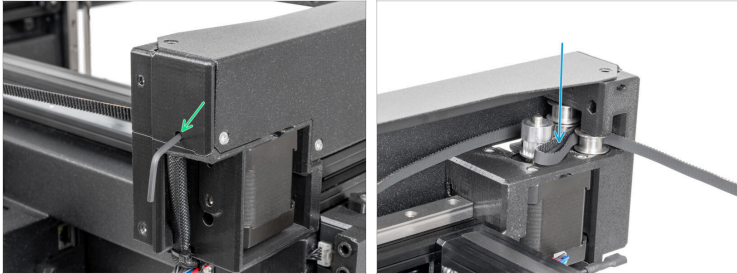
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## STEP 108 Lower belt attaching: left rear side



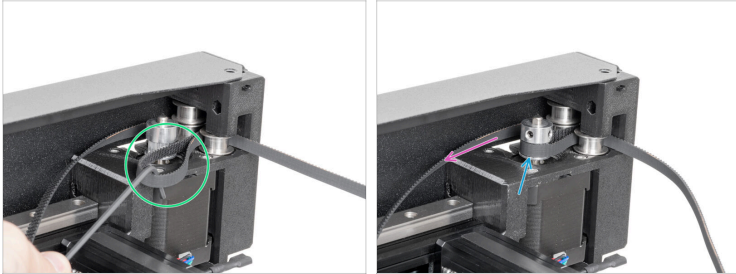
- ◆ Pull the belt some more and insert it behind the lower pulleys.
- ◆ Pull the belt, which is now inserted through the lower pulleys.

## STEP 109 Lower belt attaching: motor pulley belt preparing



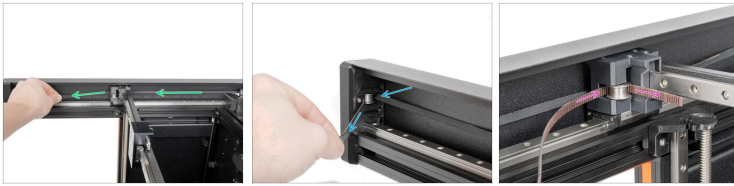
- From the rear side of the printer:
- Insert the 2.5 mm Allen key through the hole to create a loop on the belt.
- When the loop is created, you can remove the Allen key. **Do not pull the belt!**

## STEP 110 Lower belt attaching: motor pulley belt securing



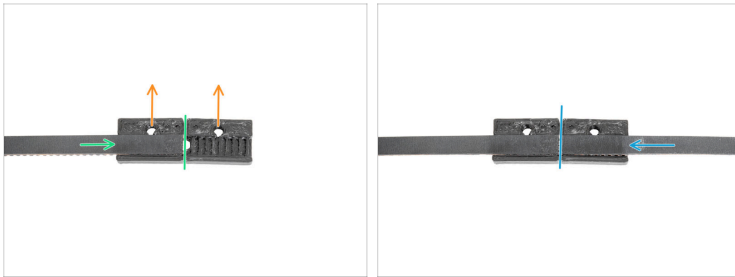
- From the front side of the printer:
- Using a shorter side of the 2.5 mm Allen key, pull gently the belt to create larger loop.
- Attach the loop on the motor pulley.
- Pull the belt to secure its position on the pulley.

## STEP 111 Lower belt attaching: left side



- i** When you pull on the belt you will feel more resistance from the XY motor, that's perfectly fine.
- ◆** Pull the belt some more and guide it behind the Y-carriage-left-base.
- ◆** Wrap the belt around the pulley on the front left side.
- ◆** Wrap the belt around the pulley in the Y-carriage-left-base.

## STEP 112 Lower belt attaching: belt clamp



- i** The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. The procedure is the same, please continue.
- i** This image has been taken outside the printer on a white background for better visibility and definition. Follow this step on your printer.
- Prepare one belt-clamp facing with the holes for the screws facing up.
- Attach the left end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- Attach the right end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- i** The belt-clamp with the belts will be turned by 180° and attached to the X-carriage.

## STEP 113 Lower belt attaching: belt clamp securing



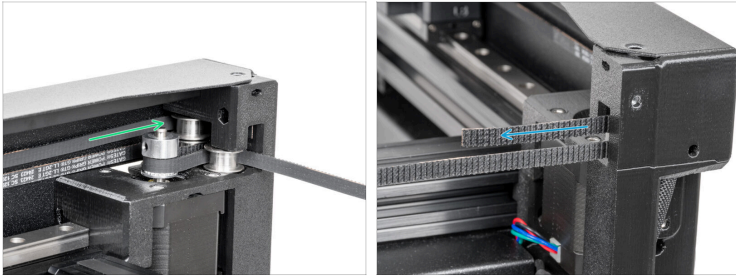
- ◆ Turn the prepared belt-clamp by 180° and attach the belt-clamp with the belts on the X-carriage.
- ◆ Check the belts if they are in their position. If not repair the position by the previous step.
- ◆ Insert two M3x12rT screws and secure them using a T10 Torx screwdriver.
- ◆ Well done! One of the belts is fastened. Let's try the second one.

## STEP 114 Upper belt attaching: left front side



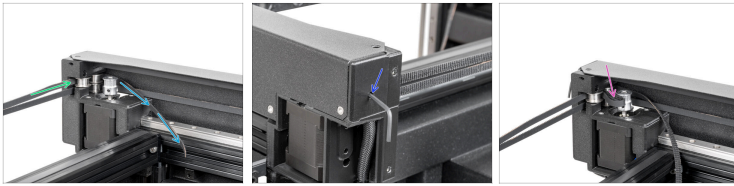
- ◆ From the front side of the printer:
- ◆ Take the second belt.
- ◆ Insert the one end of the belt into the front upper section of the Y-carriage-left-base.
- ◆ The belt has to be facing toward the printer with the teeth showing (not the smooth side of the belt).
- ⓘ Double check, that you have the teeth showing side facing towards the machine.
- ◆ On the inner side of the Y-carriage-left-base pull the belt.
- ⓘ Don't pull the belt too much, it can fall out from the Y-carriage-left-base and the whole process of the belt attaching has to be repeated from the start.

## STEP 115 Upper belt attaching: left rear side



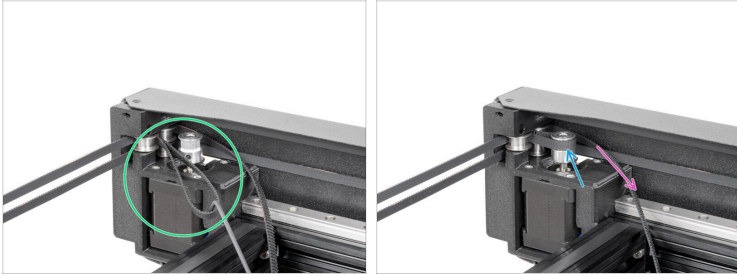
- ◆ Pull the belt more and insert it behind the upper pulley.
- ◆ Pull the belt, which is now inserted through the upper belt pulley.

## STEP 116 Upper belt attaching: right rear side



- i** *Hint: For the simplest possible assembly, remove the fifth Nextruder **(for Five-head users only)** and place it on top of the box on the heating heatbed.*
- ◆** Pull the belt more and insert it behind the upper pulleys.
- ◆** Pull the belt, which is now inserted through the upper pulleys.
- ◆** From the rear side of the printer:
- ◆** Insert the 2.5 mm Allen key through the hole to create a loop on the belt.
- ◆** When the loop is created, you can remove the Allen key. Do not pull the belt!
- ◆** Proceed to the next step.

## STEP 117 Upper belt attaching: motor pulley belt securing



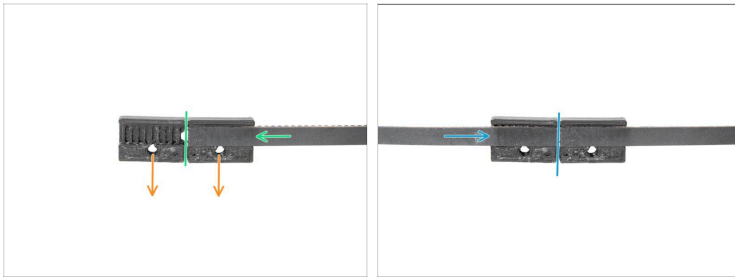
- From the front side of the printer:
- Using a shorter side of the 2.5 mm Allen key, pull gently the belt to create larger loop.
- Attach the loop on the motor pulley.
- Pull the belt to secure its position on the pulley.

## STEP 118 Upper belt attaching: right side



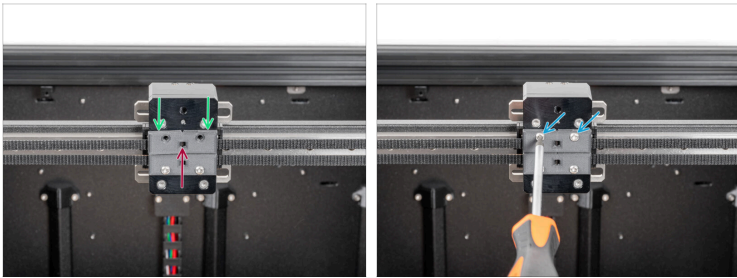
- i** When you pull on the belt you will feel more resistance from the XY motor, that's perfectly fine.
- ◆** Pull more the belt and stretch the belt behind the Y-carriage-right-base.
- ◆** Pull the belt around the pulley on the right front side.
- ◆** Pull the belt around the pulley in the Y-carriage-right-base.

## STEP 119 Upper belt attaching: belt clamp



- i** The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. The procedure is the same, please continue.
- i** This image has been taken outside the printer on a white background for better visibility and definition. Follow this step on your printer.
- Prepare one belt-clamp facing with the holes for the screws facing down.
- Attach the right end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- Attach the left end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- i** The belt-clamp with the belts will be turned by 180° and attached to the X-carriage.

## STEP 120 Lower belt attaching: belt clamp securing



- ◆ Turn the prepared belt-clamp by 180° and attach the belt-clamp with the belts on the X-carriage.
- ◆ Check the belts if they are in their position. If not repair the position by the previous step.
- ◆ Insert two M3x12rT screws and secure them using a T10 Torx screwdriver.
- ◆ Well done! Both of the belts are fastened.

## STEP 121 Belt tensioning



- On the front side of the printer:
- Using a 2.5mm Allen key, slightly tighten the M3 screw holding the left CoreXY tensioner.
- Using a 2.5mm Allen key, slightly tighten the M3 screw holding the right CoreXY tensioner.
- Do not fully tension the belt, proceed to the next step, where is a video about the adjusting of the belts tension.

---

## STEP 122 Belt tensioning: video

- On the Original Prusa XL, adjusting the belt to the optimal tension is crucial to achieving good quality on the prints. A loose belt can cause Layer shifting, Ghosting, or other print abnormalities, like getting an irregular shape instead of a perfect circle. An over-tightened belt can cause an irregular movement in the X and Y axes.
- We have our own belt tuner. The application determines the belt tension by measuring the frequency of the vibration generated by strumming it. Follow the instructions in the video below to adjust the belt.

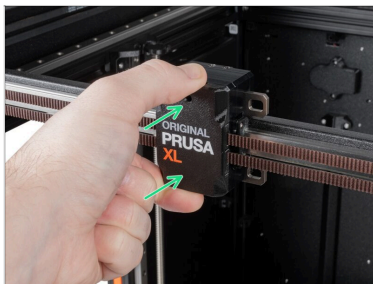
## STEP 123 X-carriage cover: parts preparation



- For the following steps, please prepare:
- X-carriage-cover (1x)

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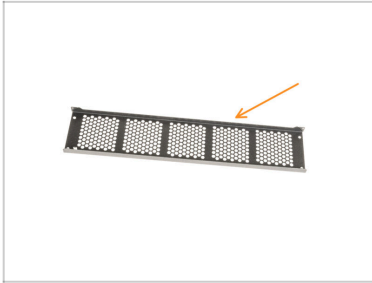
## STEP 124 X-carriage cover attaching



- Attach the X-carriage cover.

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## STEP 125 Core XY cover: parts preparation



- For the next step, please prepare:
- CoreXY cover (1x)

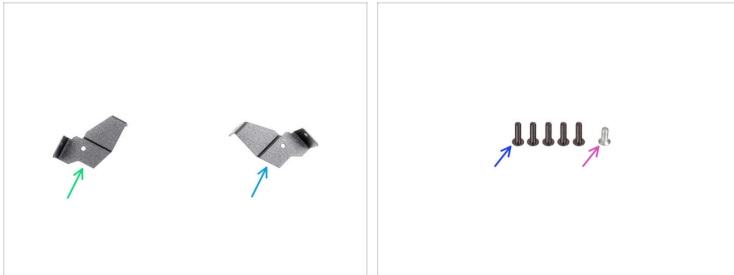
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## STEP 126 CoreXY cover attaching



- Gently attach the CoreXY cover on the back of the CoreXY.
- On the inner side of the CoreXY cover, connect the PE connector.

## STEP 127 Optional: Fixing brackets: parts preparation

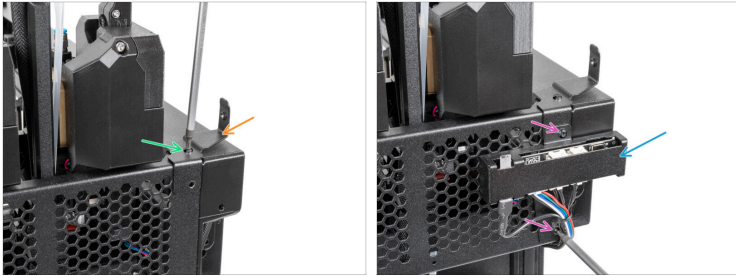


**i** The next steps are for users who have an Original Prusa XL Enclosure add-on, otherwise skip to the **CoreXY securing: parts preparation**

**■ For the next steps, please prepare:**

- Fixing bracket back left (1x)
- Fixing bracket back right (1x)
- M3x10rT screw (5x)
- M3x6bT (1x)

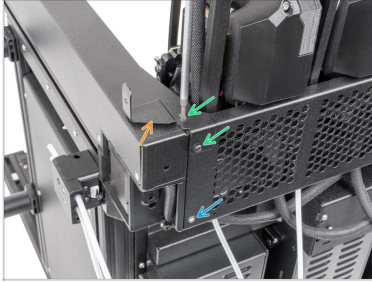
## STEP 128 Optional: Rear left securing



- Turn the printer so the rear side is facing you.
- Attach the fixing bracket rear left.
- Secure the fixing bracket rear left with the M3x10rT screw.
- Gently attach the XL enclosure board assembly.  
**Don't pinch any cable!**
- Secure the XL enclosure board assembly with two M3x10rT screws.

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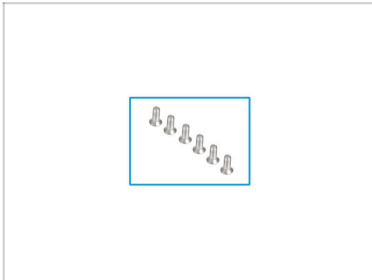
## STEP 129 Optional: Rear right securing



- Attach the fixing bracket rear left.
- Secure the fixing bracket rear left with two M3x10rT screws.
- Secure the M3x6bT screw using a T10 Torx screwdriver.

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## STEP 130 Core XY securing: parts preparation



- For the following steps, please prepare:**
- M3x6bT screws (6x) *removed in previous steps*

## STEP 131 CoreXY cover securing



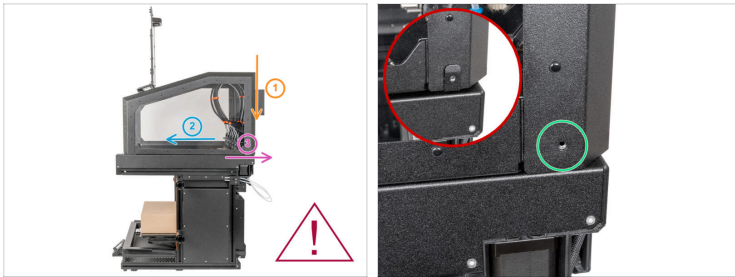
- ◆ Insert four M3x6bT screws and tighten them using a T10 Torx screwdriver.
- ◆ Insert two M3x6bT screws and tighten them using a T10 Torx screwdriver.
- ◆ If you have an Original Prusa XL Enclosure, please proceed to the next step. Otherwise proceed to the **Installing the Wi-Fi antenna**.


## STEP 132 Optional: Enclosure preparing





- On the assembled Enclosure, open the lid.
- Grasp the Enclosure on the front where is the support plate.
- Grasp the Enclosure on the back of where is the filtration cover.




## STEP 133 Optional: Enclosure attaching




 For this step, call somebody to help you attach the enclosure to the printer.

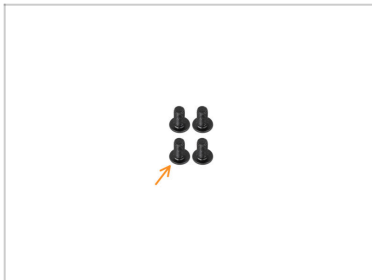
 **Don't pinch any Enclosure cable.** Watch out for cables!


 Carefully attach the enclosure to the printer in three steps:


-  1. Place the enclosure on the printer.
-  2. Push the enclosure to the front of the printer.
-  3. Push the enclosure to the back of the printer.

 Align the holes for the screws.

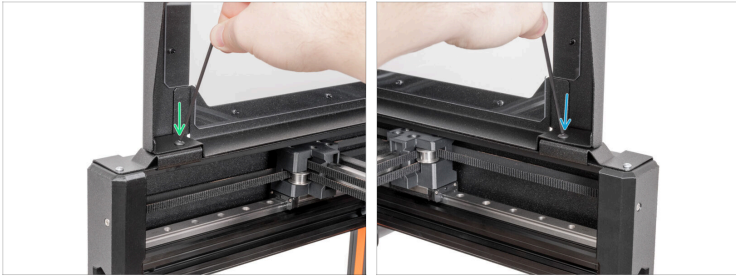
## STEP 134 Optional: Enclosure securing: parts preparation




 For the next steps, please prepare:

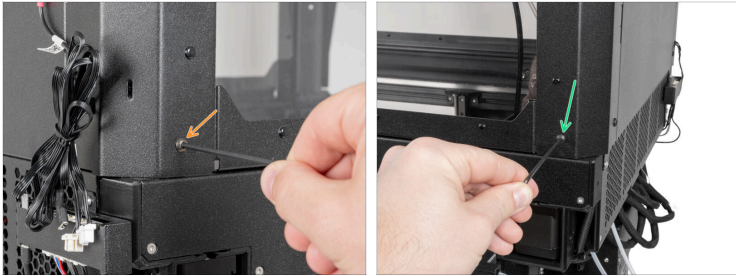
 M4x8r screw (4x)

## STEP 135 Optional: Front side securing



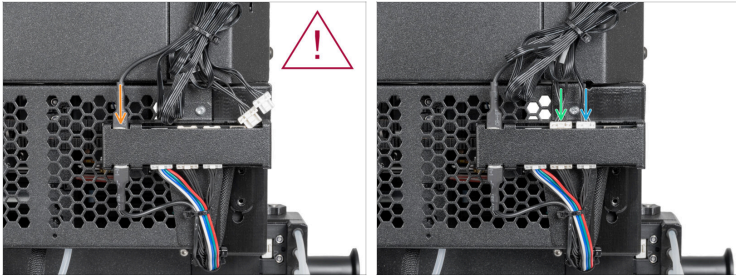
- From the front side of the enclosure:
  - Secure the left bottom corner with an M4x8r screw to the fixing-bracket-front-left using a 2.5mm Allen key.
  - Secure the right bottom corner with an M4x8r screw to the fixing-bracket-front-right using a 2.5mm Allen key.
-  **Close the lid.** This prevents the lid from closing by gravity during handling.

## STEP 136 Optional: Rear side securing



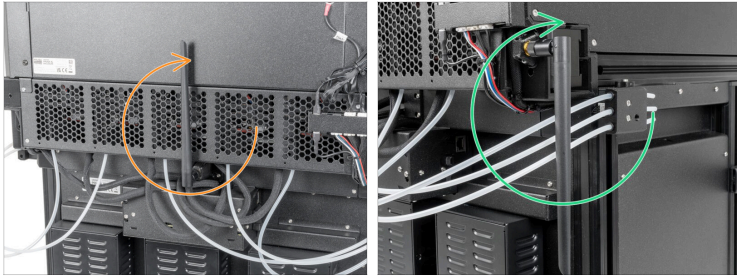
- From the rear side of the printer:
- Secure the left bottom corner with an M4x8r screw to the fixing-bracket-back-right using a 2.5mm Allen key.
- Secure the left bottom corner with an M4x8r screw to the fixing-bracket-back-left using a 2.5mm Allen key.

## STEP 137 Optional: Enclosure cables connecting



- Attach the PE faston to the connection box.
- ⚠ **Fully secure the PE cable to the XL Enclosure board cover.**
- Take the LED cable (5 wires) and connect the end of the cable to the left connector on the FDM XL Enclosure splitter.
- Take the fan cable (4 wires) and connect the end of the cable to the right connector on the FDM XL Enclosure splitter.

## STEP 138 Rotating the Wi-Fi antenna



- Wi-Fi antenna on the back of the printer:
  - Turn the back antenna upwards.
- Wi-Fi antenna on the side of the printer:
  - Turn the side antenna upwards.

## STEP 139 Printer connecting



- Turn the power switch ON (symbol "I").
- From the rear side of the printer, plug the PSU cable.

## STEP 140 Good job



Well done, the printer is ready.



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