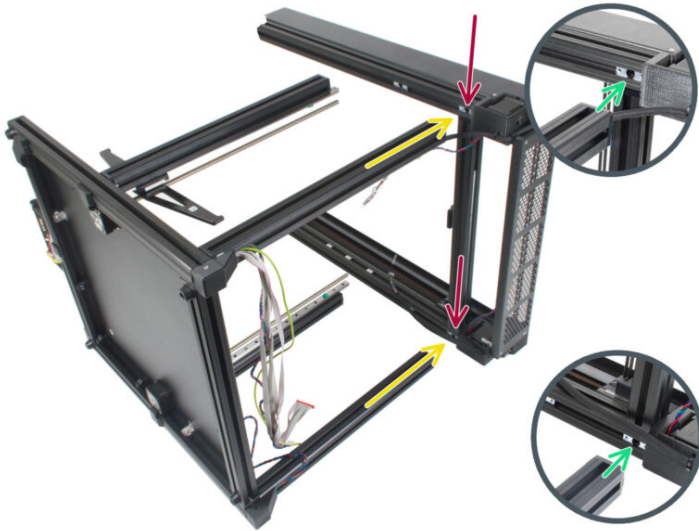


Table of Contents

- How to replace a profile insert (XL) 3**
 - Step 1 - Introduction 4
 - Step 2 - Necessary tools 5
 - Step 3 - Printer preparation 6
 - Step 4 - Releasing the CoreXY 7
 - Step 5 - Releasing the front corner 8
 - Step 6 - Replacing the profile insert 9
 - Step 7 - Assembling the front corner 10
 - Step 8 - Good job! 11

How to replace a profile insert (XL)

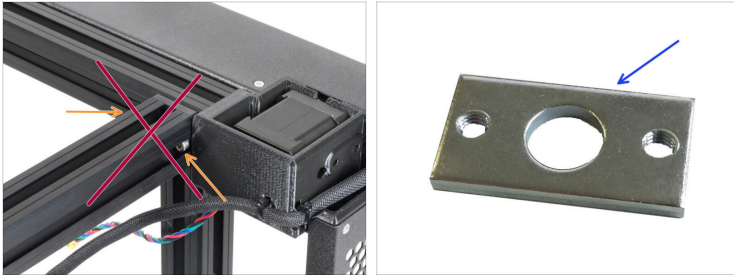


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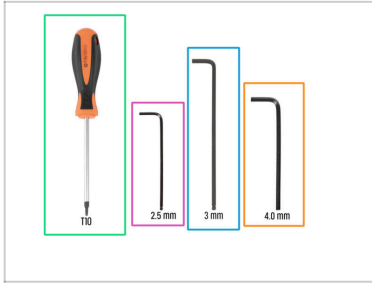
STEP 1 Introduction



This is a follow-up to the assembly instructions. It is assumed that you have the printer at some stage of the build.

- ◆ This guide assumes that you are at this step of the assembly guide, and found an issue while tightening one of the side extrusions to one of the profile inserts. We'd replace a profile insert only during this stage of the assembly.
- ⓘ The following instructions are compatible with all Original Prusa XL versions.
- ◆ An extra profile insert is included in SPARE bag.

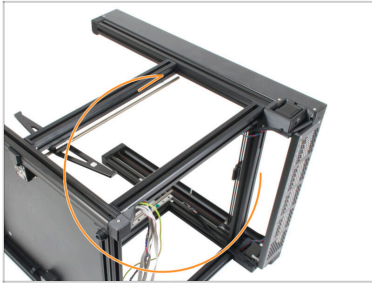
STEP 2 Necessary tools



● **For the following guide, please prepare:**

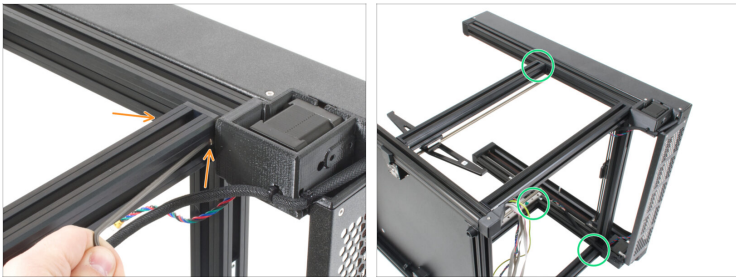
- Torx T10 screwdriver
- 2.5mm Allen key
- 3mm Allen key
- 4mm Allen key

STEP 3 Printer preparation



- ◆ **Are you left or right-handed?** The printer should be already laying on one of the sides of your choice from this step of the assembly manual: Installing the CoreXY assembly.
- ◆ If you are a left-hander rotate it carefully on the opposite right side (see the picture). We are going to detach and reattach the upper CoreXY part and tighten the screws to interconnect both parts together. The instructions are the same, choose the side which suits you better for this procedure.

STEP 4 Releasing the CoreXY



- Using the 3mm Allen key, loosen the M4x12 screws, two per each upper joint of the side extrusions. First use the short part of the Allen key, then the long part.
- Repeat this procedure on the three remaining extrusions.

STEP 5 Releasing the front corner



- ◆ Using the TX10 screwdriver, loosen two M3x8bT screws on the side where the profile insert has to be replaced.
- ◆ Using the 2.5mm Allen key, release the M3x22 screw on the side where the profile insert has to be replaced.
- ◆ Loosening this screw loosens the belt and its tensioner with the idler pulley. Extract at once the tensioner, the pulley, and the belt.
- ◆ Using the 4mm Allen key, release the M8x16ulp bolt on the side where the profile insert has to be replaced.



Do not throw the screws away, we'll use them later!

STEP 6 Replacing the profile insert



- **For the following step, please prepare:**
 - Profile insert (1x)
 - Carefully lift the top CoreXY
 - The faulty profile insert can be now slid off from the bottom side of the top CoreXY aluminum extrusion. Throw the faulty profile insert away.
 - Insert the new profile insert from the bottom side of the top CoreXY aluminum extrusion.
 - Place the top CoreXY onto the side aluminum extrusions.

STEP 7 Assembling the front corner

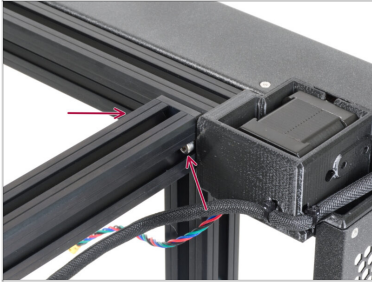


- ✦ Using the 4mm Allen key, tighten the M8x16ulp bolt on the side where the profile insert was replaced.
- ✦ Insert at once the tensioner, the pulley, and the belt as shown in the picture. Align the M3x22 screw with the hole in the tensioner.
- ✦ Using the 2.5mm Allen key, tighten the M3x22 screw.
- ✦ Using the TX10 screwdriver, tighten two M3x8bT screws on the side where the profile insert was replaced.
- ✦ Follow this dedicated article to readjust your belt tension, referring to the 'Belt tuner' and 'Alignment' paragraphs.



Do not worry if the belt tension is not yet perfectly tuned after this intervention. You can resume the belt tension adjustment at a later time with the printer assembled and running.

STEP 8 Good job!



That's it! You successfully replaced the profile insert on your Original Prusa XL.



You can now continue with the rest of the assembly of your Original Prusa XL.
