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1A. Introduction



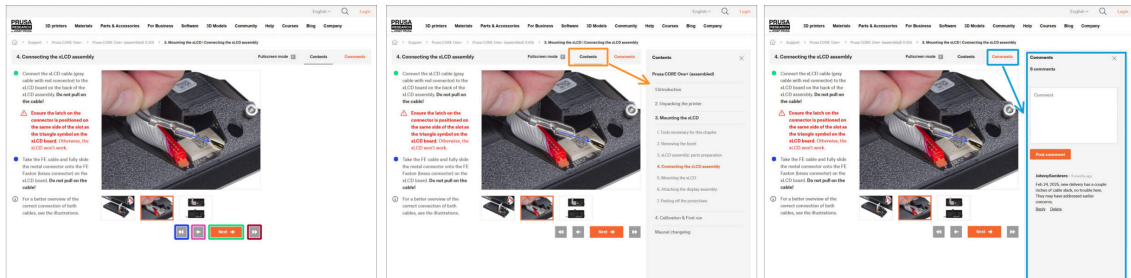
ÉTAPE 1 Informations sur le guide



- Bienvenue dans le guide de la **Conversion de l'Original Prusa MK4S en CORE One+**.
- Please prepare the upgrade kit received from Prusa Research.
- Dans la première partie du guide, nous vérifierons les composants clés de votre imprimante MK4S, suivi du démontage de l'imprimante.

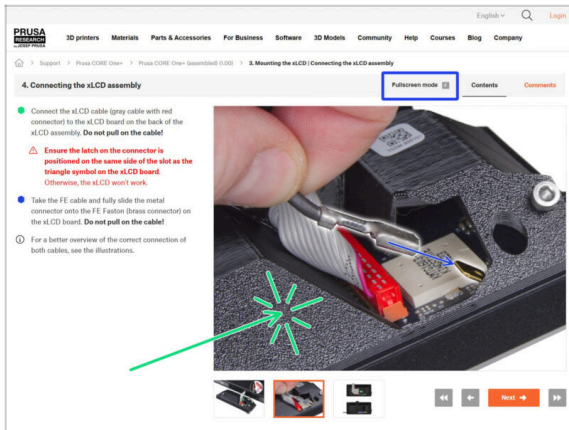
Ensuite, nous retravaillerons quelques pièces, et enfin, le processus de construction de la CORE One+ pourra commencer.

ÉTAPE 2 How to navigate through the manual



- Use the graphical navigation buttons in the bottom right corner or the arrow keys on your keyboard:
- **Next button / Right arrow key** - Moves to the next image, or to the next step if it's the last image in the step.
- **Left arrow button / Left arrow key** - Moves to the previous image, or to the previous step if it's the first image in the step.
- **Play backward button / Up arrow key** - Moves to the previous step.
- **Play forward (Next) button / Down arrow key** - Moves to the next step.
- Click on **Contents** to expand the full list of steps in this guide. This allows you to jump to any step regardless of the sequence.
- Click on **Comments** to open the discussion for a specific step and leave your feedback.

ÉTAPE 3 View high resolution images



- When you browse the guide on help.prusa3d.com, you can view the original images in high resolution for clarity.
- Just click on the image to open it in high resolution for a detailed view.
- Click on **Fullscreen mode** or press the F key to maximize your screen space and focus entirely on the instructions.

ÉTAPE 4 Compatibilité



⚠ La seule option de conversion vers la CORE One+ est à partir de la **MK4S**.

Si vous possédez un modèle d'imprimante plus ancien, vous devez d'abord le mettre à niveau vers la MK4S, puis procéder à la conversion vers la CORE One+.

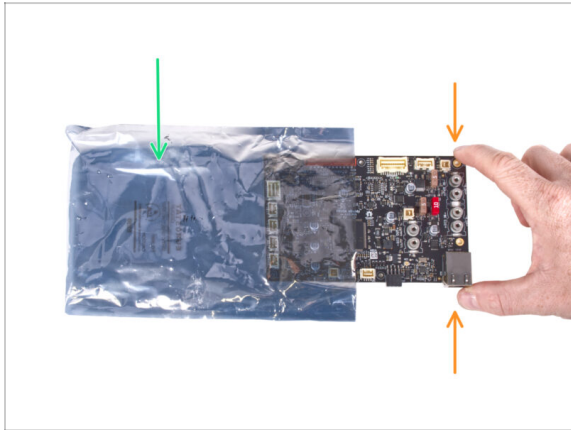
i There are two versions of the conversion package, depending on the xLCD version used in your MK4S printer.

⚠ The silver PSU is not compatible with the conversion kit.

If you have this PSU version, you will need to purchase a compatible one.

■ Pour plus d'informations, consultez les notes de compatibilité sur la [page de la boutique en ligne de la Conversion vers la CORE One+](#).

ÉTAPE 5 Important : Protection des composants électroniques

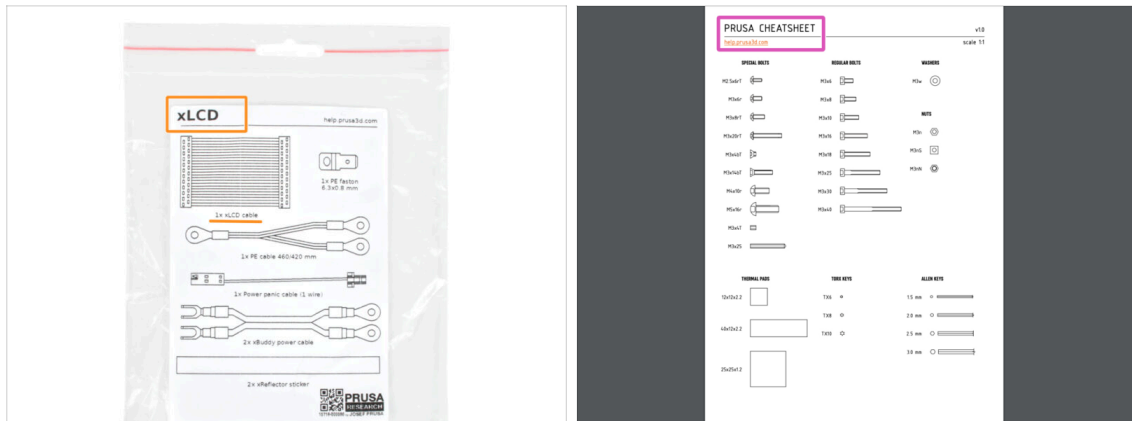


 **WARNING:** Make sure to **protect the electronics against electrostatic discharge (ESD)**. When possible, always unpack the electronics right before you need them.

Here are some tips to prevent damage to the electronics:

-  **Keep the electronics inside an ESD-safe bag** right until you are asked to install them.
-  **Always touch the sides of the board only** while handling it. Avoid touching the components on the surface.
-  **Before you touch the electronics** use any grounded conductive (metal) structure nearby to neutralize the possible static charge from your hands.
-  Be extra cautious **in rooms with carpets**, which are often a source of electrostatic energy.
-  Clothes made of wool or certain synthetic fabrics can easily gather static electricity too. It is safer to wear cotton clothing for the assembly.

ÉTAPE 6 Guide des étiquettes



- All the boxes and bags including parts for the build are labeled.
- The labels include the list of contents and part count.
- You can download a **Cheatsheet** with 1:1 fastener drawings from our site prusa.io/cheatsheet-mk4. Print it at 100 %, don't rescale it, otherwise, it won't work.
- ❗ For PRUSA veterans: Fasteners are divided into individual bags according to its type. Not into packages for individual chapters, as it was with previous printers.

ÉTAPE 7 Sachet de pièces de rechange



- There is a bag with spare parts like thermal pads, springs, etc.
- Spare fasteners are included in each bag of fasteners. The numbers in parentheses below the fastener picture indicate the number of extra pieces added to the SPARE package.

ÉTAPE 8 We are here for you!

PRUSA 3D

3D printers Materials Parts & Accessories Software 3D Models Applications Community Help Academy Blog Company

Support > Prusa CORE One > Prusa CORE One (assembly) 0.00 > 3. Mounting the xLCD / Connecting the xLCD assembly

4. Connecting the xLCD assembly

Fullscreen mode Contents Comments

5 comments

Connect the xLCD cable (gray cable with red connector) to the xLCD board on the back of the xLCD assembly. Do not pull on the cable!

Ensure the latch on the connector is positioned on the same side of the slot as the triangle symbol on the xLCD board. Otherwise, the xLCD won't work.

Take the FE cable and fully slide the metal connector into the FE Fasten (brass connector) on the xLCD board. Do not pull on the cable.

For a better overview of the correct connection of both cables, see the illustrations.

Oh look at the detail!

Post comment

JohnnyBambers · 7 days ago

Feb 24, 2025, new delivery has a couple inches of cable slack, no trouble here. They may have addressed earlier concerns.

Reply Delete

Apurkine1982 · 10 days ago

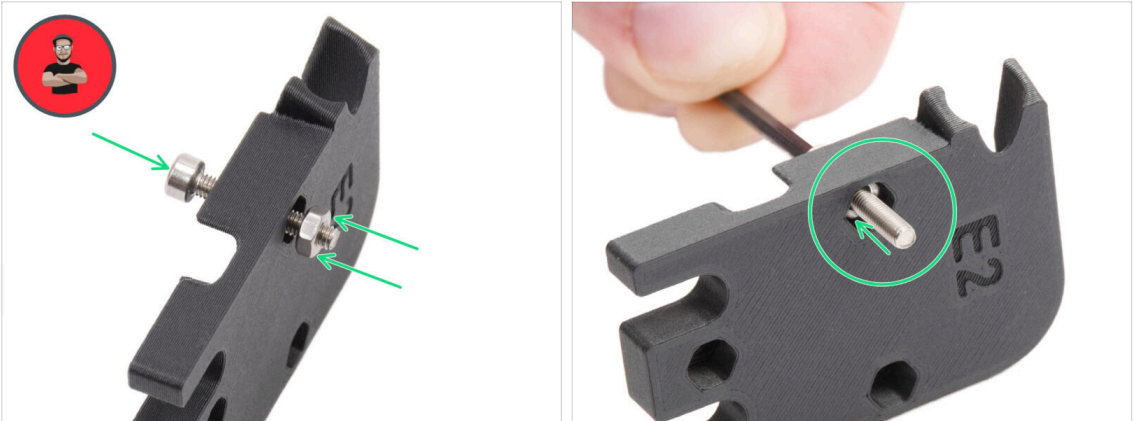
POWERED BY TRY

SUBMIT

Chat now

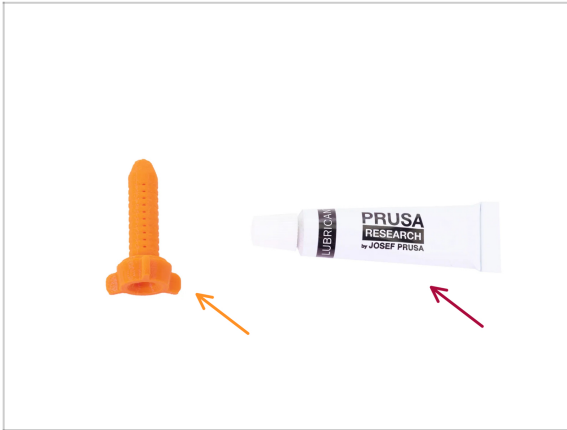
- Lost in the instructions, missing screw or cracked printed part? **Let us know!**
- You can contact us using the following channels:
 - Using comments under each step.
 - Using our 24/7 live chat here at help.prusa3d.com
 - Writing an email to info@prusa3d.com

ÉTAPE 9 Pro tip: inserting the nuts



- 3D printed parts are very precise, however, there still might be a tolerance in the printed part and the same goes for the size of the nut.
- Therefore it might happen, that the nut won't fit easily in or might be falling out. Let's see, how to fix it:
 - **Nut won't fit in:** use a screw with a thread along its entire length (typically: M3x10, M3x18) and screw it from the opposite side of the opening. While tightening the screw, the nut will be pulled in. Remove the screw afterwards.
 - **Nut keeps falling out:** Use a piece of tape to fix the nut temporarily in place, as soon as you insert the screw in, you can remove the tape. *Using glue isn't recommended as it can partly reach into the thread and you won't be able to tighten the screw properly.*
- Every time we recommend using the "screw pulling technique", you will be reminded with Joe's avatar ;)
- ① Parts in the pictures are used as an example.

ÉTAPE 10 Bearing Lubrication Pacifier



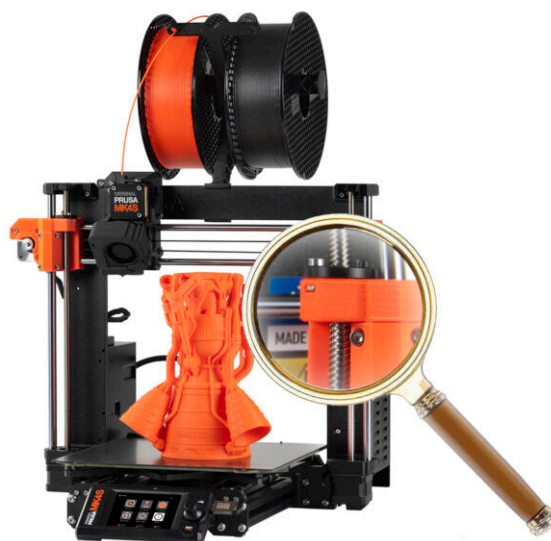
- We will reuse two LM8UU bearings from your MK4S. It is a good practice to re-lubricate them before re-using.
- For this purpose, we suggest printing the **Bearing Lubrication Pacifier from Printables**, Before disassembling the printer
- ① It is a quick print, just under 20 minutes.
- The lube tube is included in the package.

ÉTAPE 11 Préparez votre bureau



- Tidy up your desk! Tidying up decreases the probability of losing small parts.
- **Clear your workspace.** Make sure you have enough room. A nice clear flat workbench will get you the results you are aiming for.
- **Let there be light!** Make sure you are in a well-lit environment. Another lamp or even an extra flashlight will probably come in handy.
- Prepare something to contain the plastic bags and the removed packing materials so you can recycle them afterwards. Make sure there are no important parts being discarded.
- ⚠ **It's highly recommended to place a soft pad on your workbench. Some sheet metal parts have sharp edges that could scratch the surface.**
- OK, we are ready. Let's start! Go to the next chapter.

1B. Inspection de la MK4S



ÉTAPE 1 Introduction



- Some parts of your printer can be reused for upgrading, so it's essential to check their condition before starting.

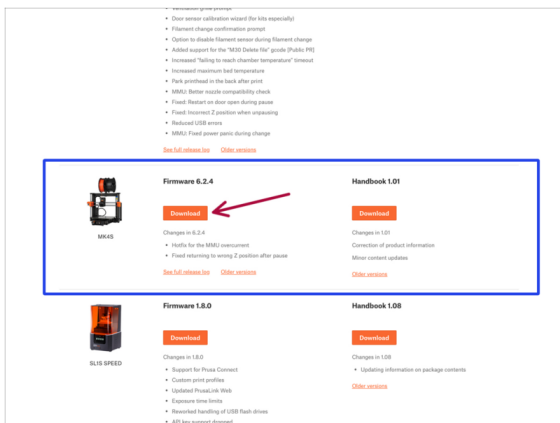
This chapter will guide you through a visual inspection of these parts. If you find any in poor condition, you'll have enough time to order replacements while still using the printer.

⚠ Do not disassemble or disconnect anything until prompted.

- Any parts that are found to be in poor condition during the inspection can be replaced with new parts. Everything is available in our [eshop](#).

i Please note that you have to be logged in to access all parts.

ÉTAPE 2 Mise à jour du Firmware

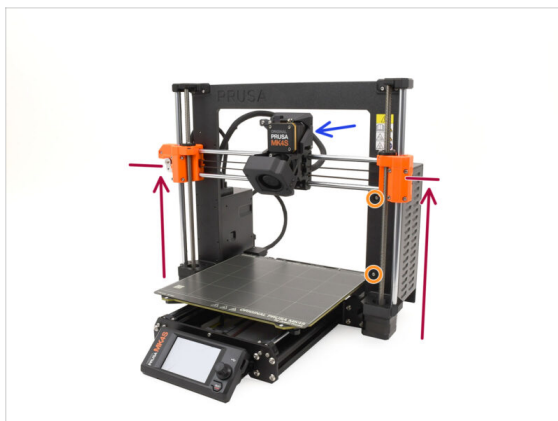


- On the printer, visit the menu **Info > Version Info** to check the firmware version.

⚠ Ensure your MK4S printer has **firmware 6.2.4 or newer before continuing. Otherwise, your newly converted CORE One will not work, and will resist updating.**

- The latest firmware can be downloaded at:
[Help.Prusa3D.com/Downloads](https://help.prusa3d.com/downloads)
- For more info, visit the [Firmware Update Article](#).

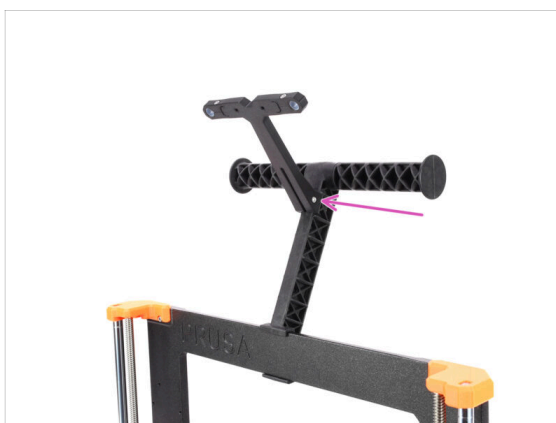
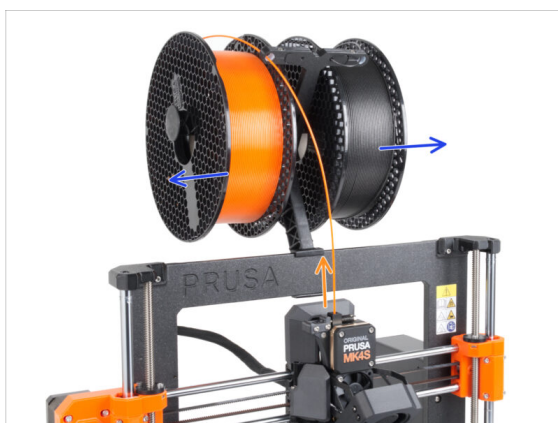
ÉTAPE 3 Préparation de l'imprimante 2



Before you start, do the following:

- Déplacez l'axe X approximativement aux 2/3 de la hauteur, de sorte que :
 - ① Pro Tip: Long press the knob and use the "Z Axis Move" option.
- The rear of the extruder is accessible.
- The PSU screws are accessible.
- All the screws on the electronics box are accessible.

ÉTAPE 4 Préparation de l'imprimante 2



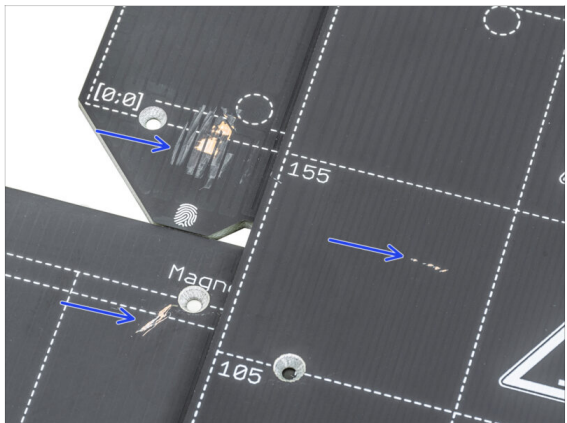
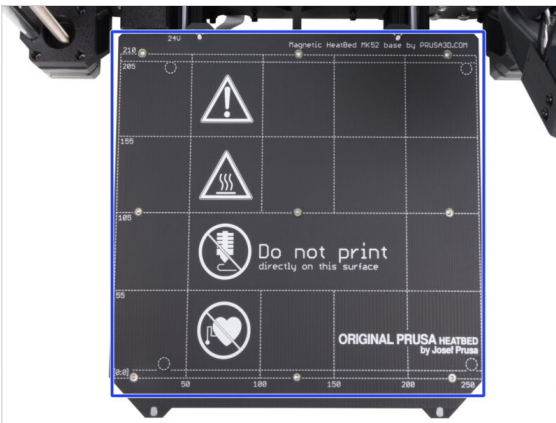
- Unload a filament, if it is loaded.
 - ① Menu Filament > Unload filament
- Remove the filament spools.
- Remove the spool holder.

ÉTAPE 5 Préparation de l'imprimante 3



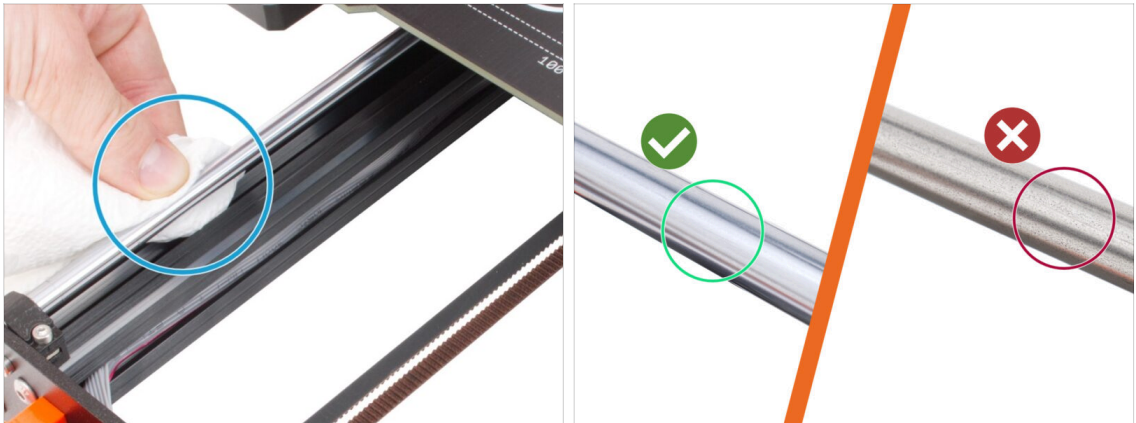
- Turn off your printer and disconnect it from the power.
- Remove the print sheet and save it for later use.

ÉTAPE 6 Inspection du plateau chauffant



- Carefully inspect the surface of the heated bed. If you find any major scratches (up to the copper layer) consider replacing it with a new piece.

ÉTAPE 7 Inspection des tiges de l'axe Y



- Wipe the entire length of the Y-axis smooth rods with a paper towel to remove any dirt.

i Carefully inspect the surface of the smooth rods up close, as we are going to reuse them.

- The surface must be clean and smooth.
- If you find very deep scratches, corrosion, or a rough surface, it is highly recommended to replace the rods.

You can purchase a new Smooth Rod Y-axis (8×330 mm) in our [eshop](#)

- Similarly, if the smooth rods are scratched or the bearings do not move smoothly (stuttering occurs), we recommend ordering new LM8UU bearings as well.

You can purchase new LM8UU bearings in our [eshop](#).

ÉTAPE 8 Haribo ?



! Keep the Haribo bag closed for now!

- This dose of energy is primarily for the printer assembly. **Wait until you are prompted to open it.**

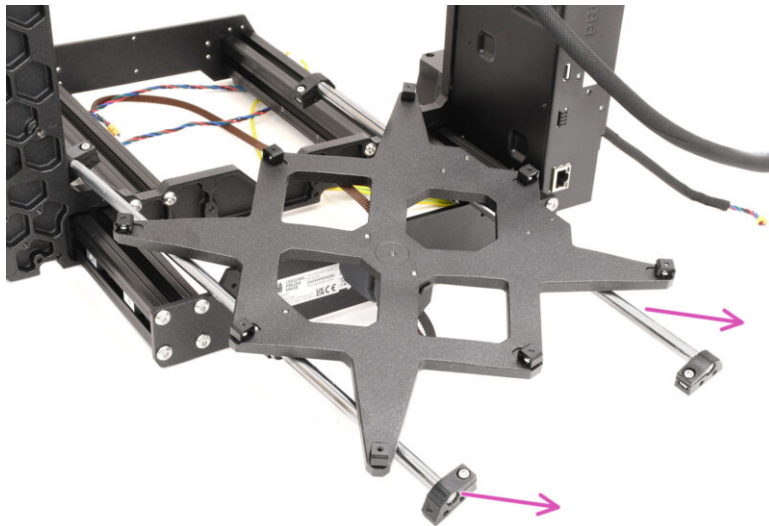
ÉTAPE 9 Commencer



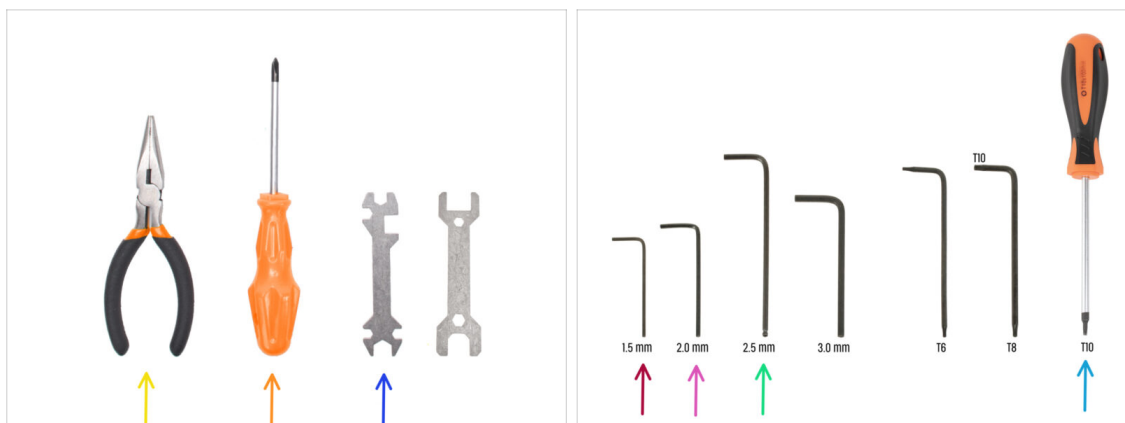
- Got everything checked? Great! Let's begin disassembling the printer.

Proceed to the next chapter.

1C. D  montage de l'imprimante



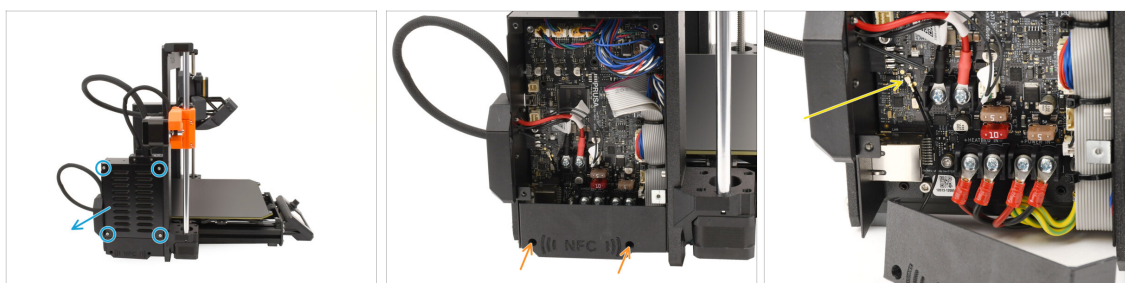
ÉTAPE 1 Outils nécessaires



● For this chapter, please prepare:

- Pince à bec fin
- Tournevis cruciforme
- Clé universelle
- Clé Allen de 1,5 mm
- Clé Allen de 2 mm
- Clé Allen de 2,5 mm
- Tournevis T10

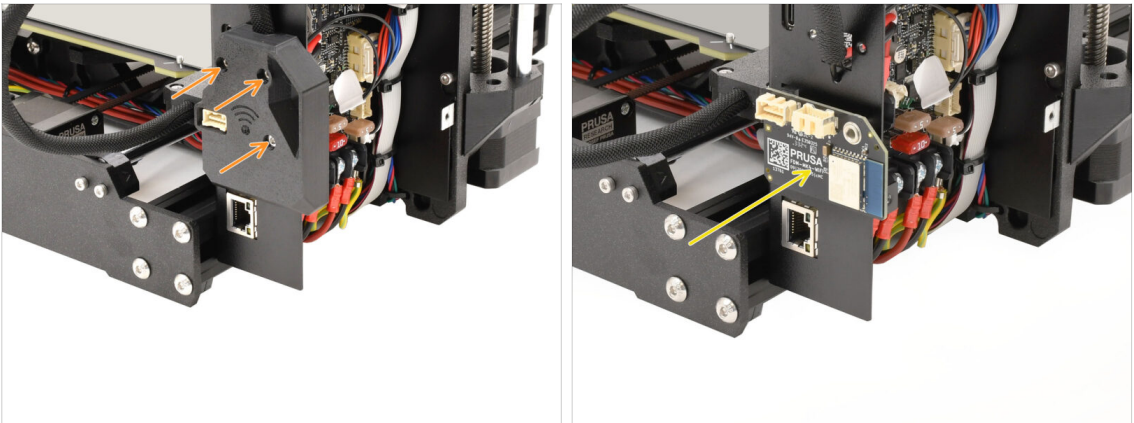
ÉTAPE 2 Démontage de l'électronique



- Let's move onto the **left** side of the printer.
- Retirez les quatre vis qui maintiennent le capot du boîtier de la xBuddy et retirez le capot.
- Using the 2.5mm Allen key, remove the two screws holding the NFC cover.
- Disconnect the NFC antenna from the xBuddy board by gently lifting the tiny connector.

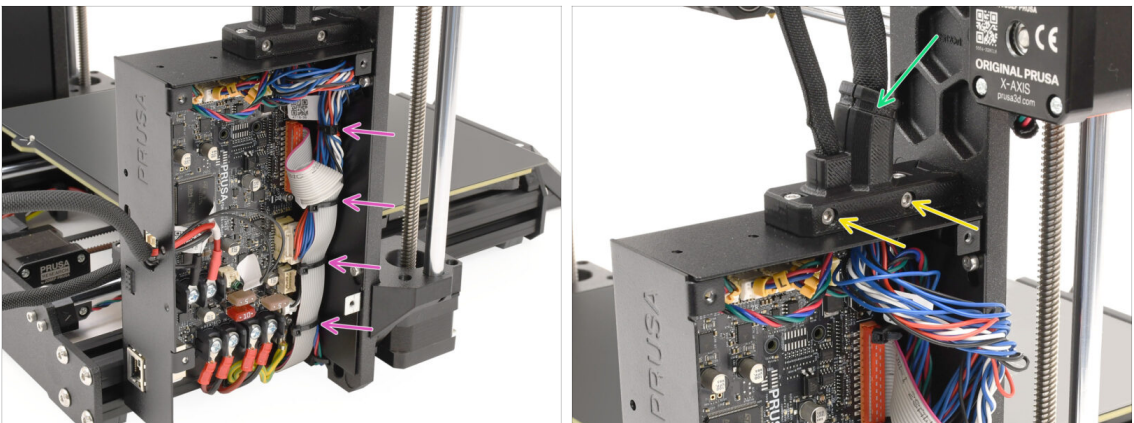
Then, remove the antenna along with the cover.

ÉTAPE 3 Démontage du Wi-Fi



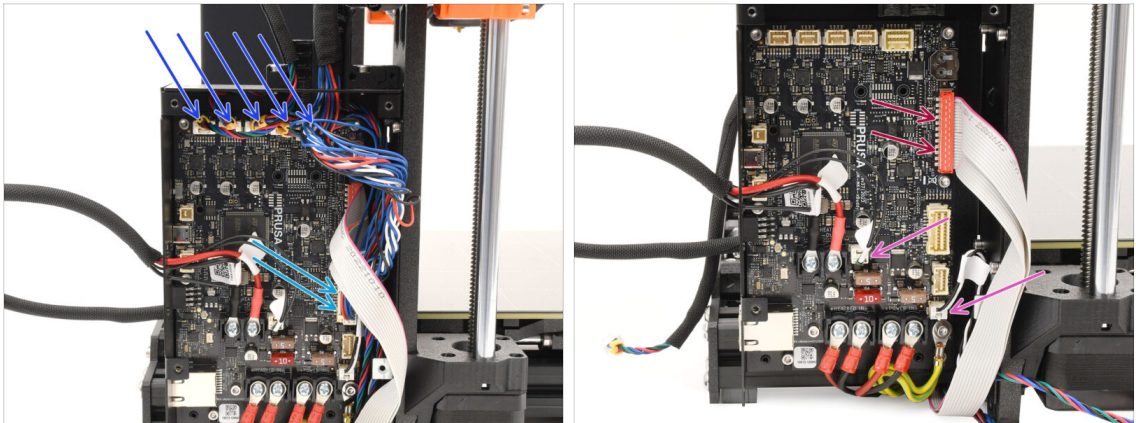
- 🟠 On the back of the electronics box, remove the three screws holding the Wi-Fi cover and remove the cover.
- 🟡 Retirez le module Wi-Fi et **conservez-le pour une utilisation ultérieure.**
- ⚠️ **Ensure you store the module and all electronic components in an ESD-safe environment to prevent damage!**

ÉTAPE 4 Démontage du faisceau de câbles



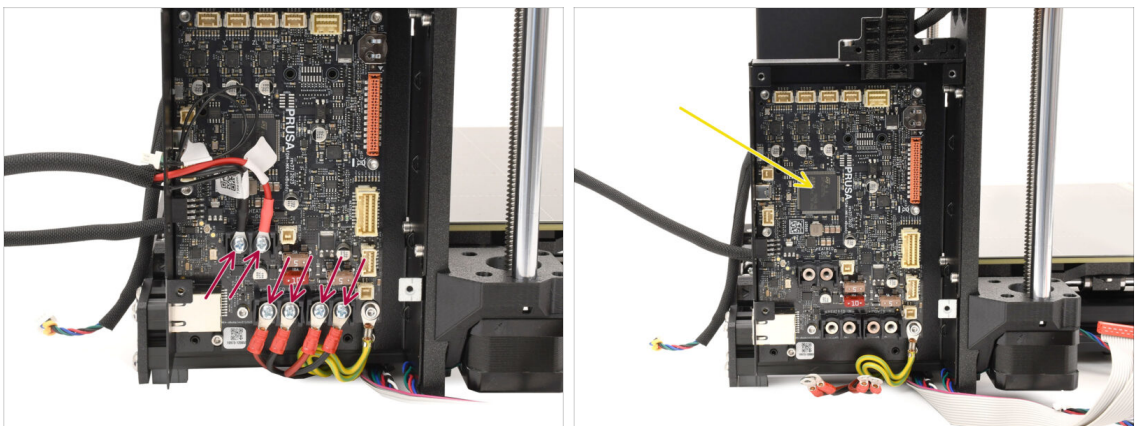
- 🟣 Remove all the zip-ties securing the cable bundle inside the xBuddy box.
- ⚠️ **Lors de la coupe des colliers de serrage, procédez avec précaution pour éviter tout dommage aux câbles ou à l'électronique !**
- 🟡 Remove the two screws on the main cable holder.
- 🟢 Cut the zip-tie holding the cover together, then remove the outer part of the holder.

ÉTAPE 5 Déconnexion des câbles 1



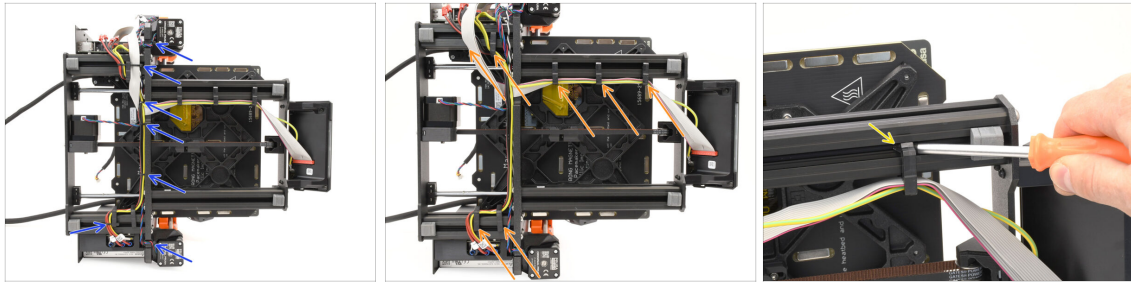
- ◆ Disconnect all the connectors on the top of the xBuddy board.
⚠ Sur chacun de ces connecteurs se trouve un loquet de sécurité, sur lequel il faut appuyer pour le déconnecter.
- ◆ Disconnect the extruder main cable connector.
- ◆ Disconnect the heatbed thermistor and power panic cables.
- ◆ Disconnect the xLCD connector by lifting it carefully up.

ÉTAPE 6 Déconnexion des câbles 2



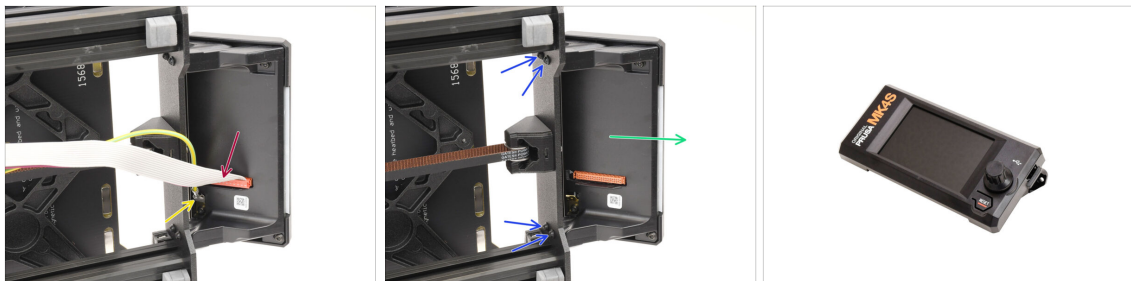
- ◆ Using the Phillips screwdriver, remove all the terminal screws holding the heatbed and power cable connectors.
- ◆ Laissez la carte xBuddy dans le boîtier de l'électronique pour le moment, car de cette façon, elle est bien protégée contre les dommages.

ÉTAPE 7 Libération du faisceau de câbles



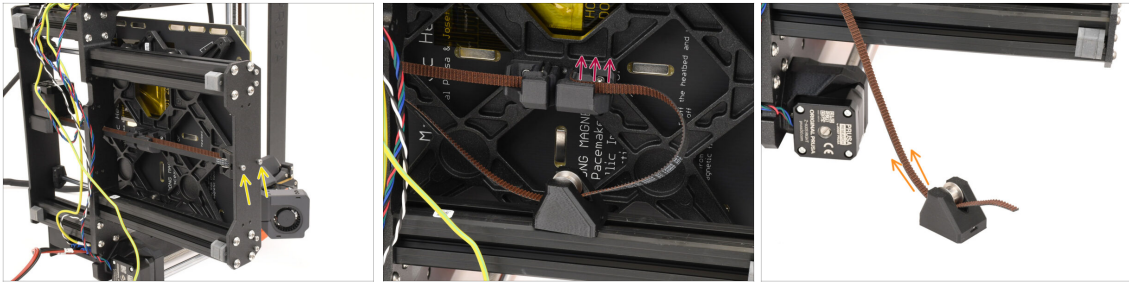
- Lay the printer onto the PSU side to access the bottom part.
- Retirez soigneusement tous les colliers de serrage qui maintiennent le faisceau de câbles
- Remove all the cable holders from the frame and detach them from the cables.
 - Pro tip: You can pry them off the metal profiles using the screwdriver.

ÉTAPE 8 Retrait du xLCD



- Disconnect the main cable from the xLCD by gently lifting the connector up.
- Déconnectez le câble de mise à la terre.
- Using the T10 screwdriver, remove the four screws holding the xLCD assembly.
- Remove the xLCD assembly and **save it for later use!**

ÉTAPE 9 Retrait du Y-idler



- ✦ Using the 2.5mm Allen key, remove the two screws holding the Y-Axis Idler on the front plate.
- ✦ Retirez l'extrémité de la courroie de l'axe Y du support situé sous le plateau chauffant pour la désengager.
- ✦ Remove the belt from the idler by pulling it out.

ÉTAPE 10 Retrait de la poulie de l'idler



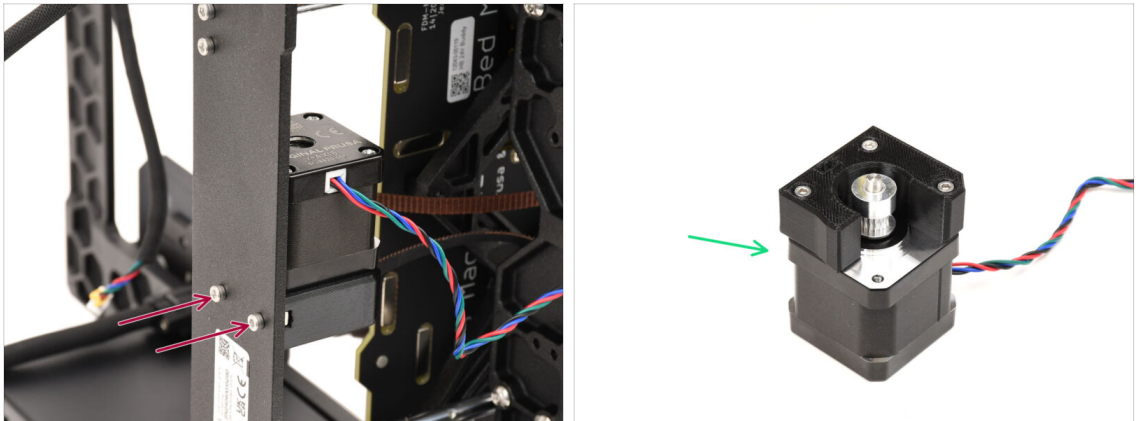
- ✦ Orient the Y-Idler as shown in the picture.

Remove the pulley by first moving it inward, then pulling it out to the side.

Refer to the groove pattern in the picture for the correct trajectory.

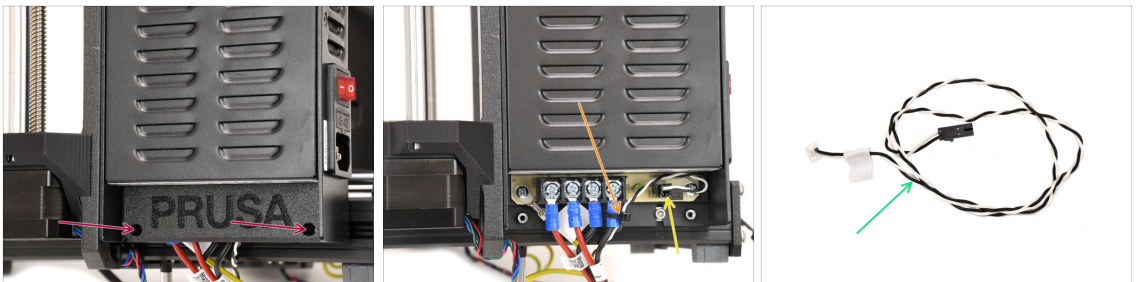
- ✦ Retirez l'arbre central de la poulie.
- ✦ **Save the pulley for later use.**

ÉTAPE 11 Retrait du moteur Y



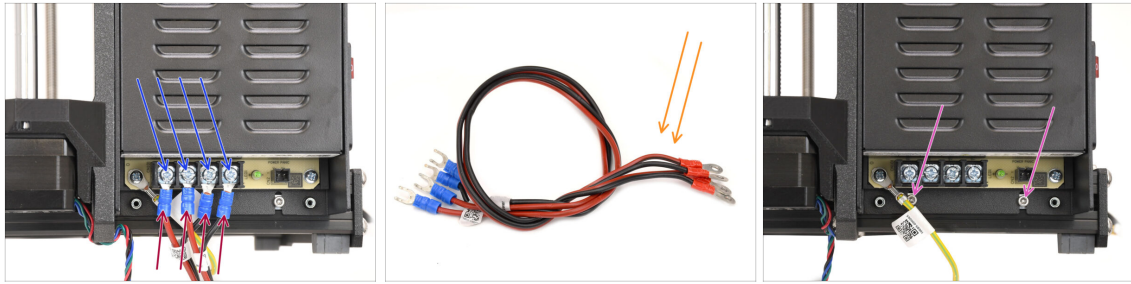
- Remove the two screws on the back of the printer, holding the Y-axis motor in place.
- Remove the Y-axis motor assembly and **save it for later use**.

ÉTAPE 12 Power Panic Cable Removal



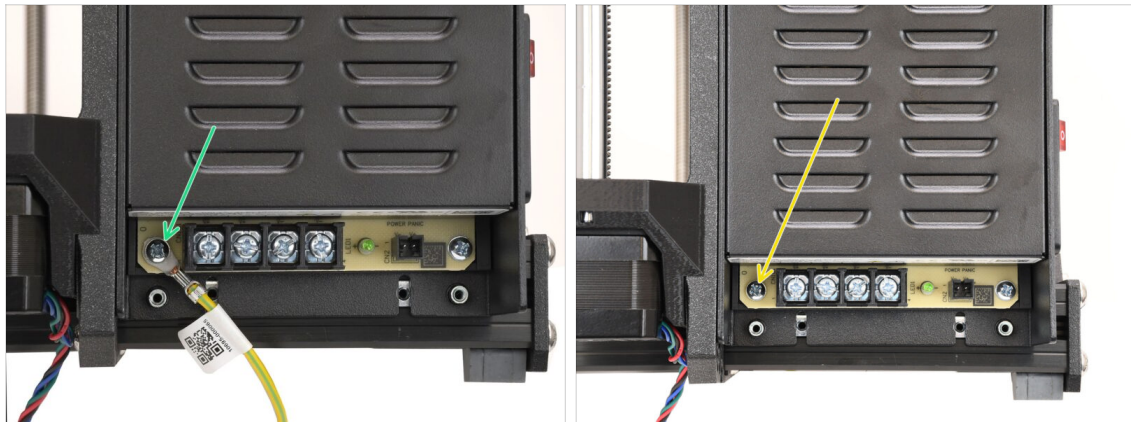
- Let's move onto the right side of the printer carcass, where the PSU lives.
- Remove the two screws securing the cover, then take off the cover.
- Carefully cut off the zip-tie holding the power panic cable.
- Save the power panic cable for later use.**
- i** The power panic cable may look different, depending on your xBuddy board version.

ÉTAPE 13 Retrait du câble d'alimentation



- ◆ Using the Phillips screwdriver, loosen the four power terminal screws. Do not remove them entirely.
- ◆ Remove the four power cable connectors by pulling them downward.
- ◆ Remove the power cables and **save them for later use**.
- ◆ Using the 2.5mm Allen key, remove the two screws holding the PSU to the printer's frame.

ÉTAPE 14 Retrait du bloc d'alimentation 1



- ◆ Remove the screw holding the grounding cable to the PSU.
- ◆ Disconnect the grounding cable—it will no longer be needed.
- ◆ Re-install the screw you previously removed.

ÉTAPE 15 Retrait du bloc d'alimentation 2

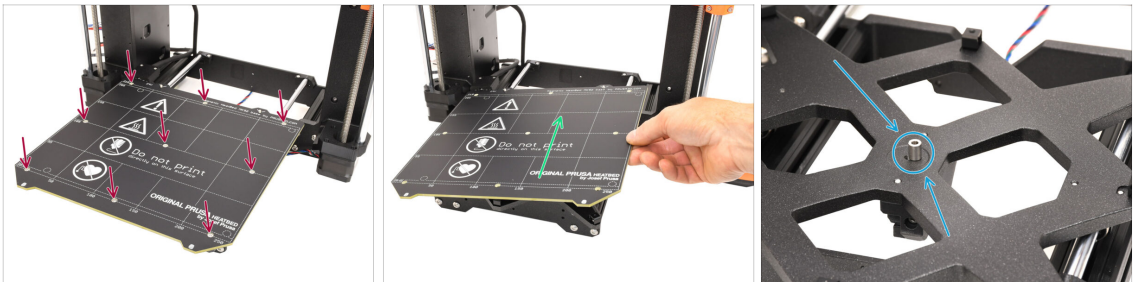


- On the front of the frame, remove the two screws holding the PSU.

⚠ The PSU might fall off to the side!

- Remove the PSU and **save it for later use**.

ÉTAPE 16 Retrait du plateau chauffant



- Let's move onto the heated bed.

- Using the T10 Torx screwdriver, remove all 9 screws holding the heated bed.

- Remove the heated bed by lifting it up. **Save it for later use.**

- There is a spacer in the middle of the heated bed. Make sure to save it for later use too!

📌 Be careful and store the heated bed on a soft surface to prevent scratching it.

ÉTAPE 17 Retrait de l'axe Y



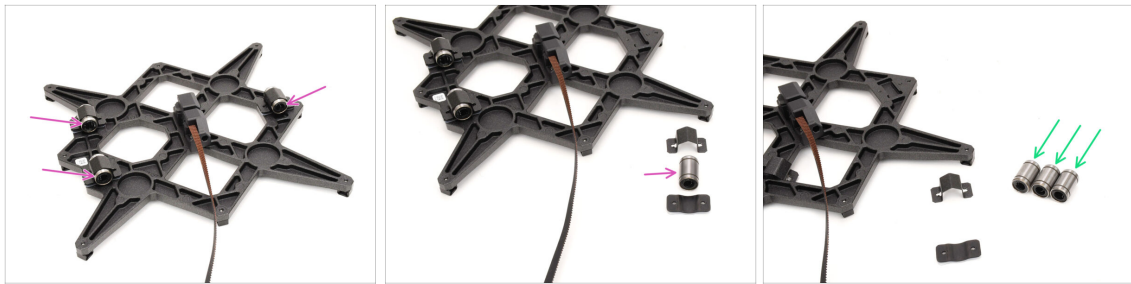
- Using the 2.5mm Allen key, remove the four screws holding the Y-axis rods to the front of the frame.
- Remove the four screws holding the Y-axis rods to the back of the frame.
- Remove the whole Y-axis assembly from the printer's frame.

ÉTAPE 18 Démontage de l'axe Y



- Retirez les quatre vis fixant les tiges aux Y-rod-holders. Ensuite, retirez les supports de tige en plastique.
- Turn the assembly around.
- Pull out both the Y-axis rods. Clean them up and **save them for later use**.
- Remove all the screws holding the bearings to the carriage.

ÉTAPE 19 Retrait des roulements



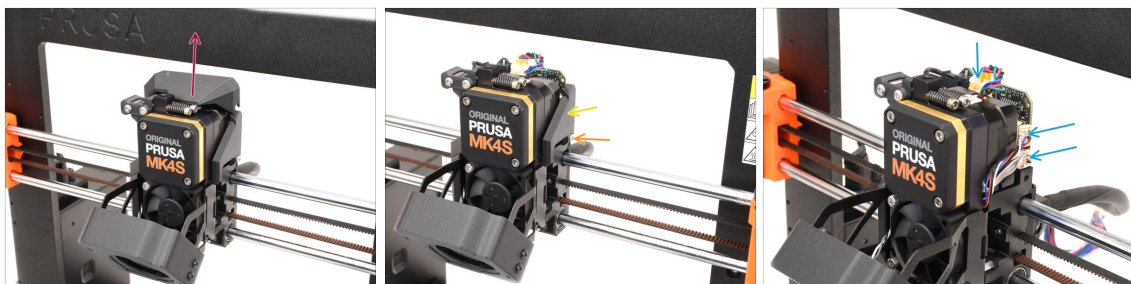
- ◆ Retirez les trois roulements des supports de roulement.
- ◆ Clean the bearings from any excess grease or dirt, and **save them for later use**.
- ❗ Deux de ce type de roulements seront utilisés pour construire la CORE One+.

ÉTAPE 20 Retrait du joint de dilatation



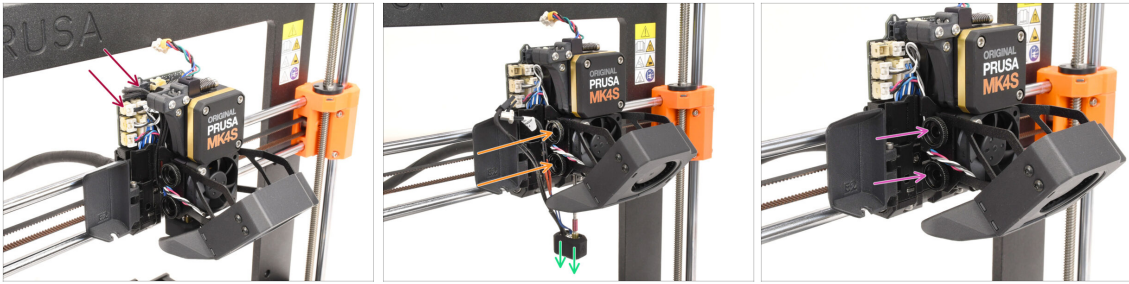
- ◆ À l'aide de la clé Allen de 2 mm, retirez les 8 joints de dilatation du Y-carriage.
- ◆ **Save the expansion joints for later use.**

ÉTAPE 21 Retrait du capot de l'extrudeur



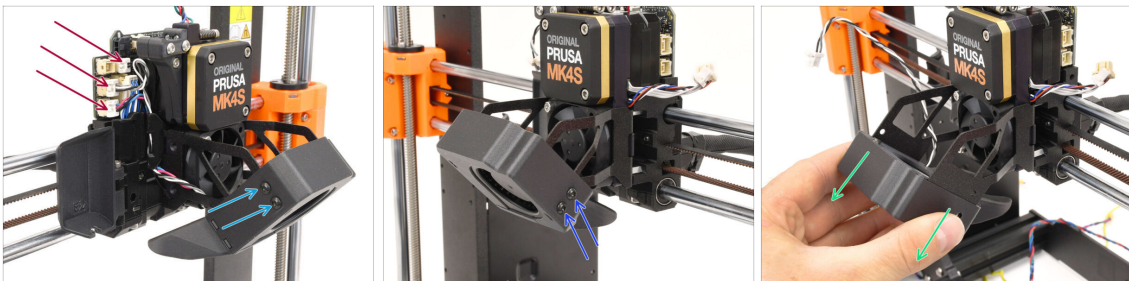
- ◆ Passons à l'extrudeur.
- ◆ Remove the top cover on the extruder by lifting it up.
- ◆ Remove the screw holding the cover on the right side.
- ◆ Remove the side cover.
- ◆ Disconnect the motor, filament sensor and loadcell cables.

ÉTAPE 22 Retrait de l'assemblage de la hotend



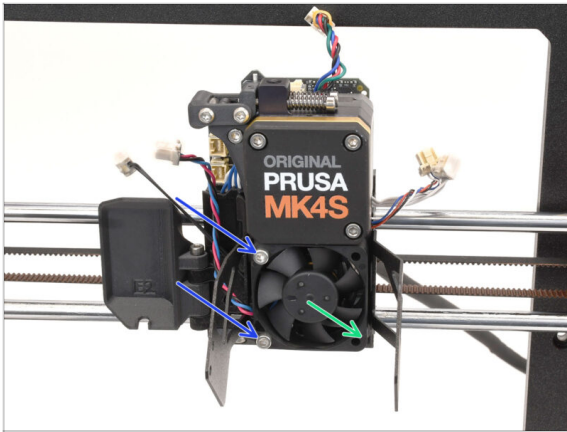
- De l'autre côté, débranchez les câbles de la thermistance de la buse et de l'élément chauffant de la buse.
- Release the two thumb screws, until the hotend assembly drops.
- Remove the hotend assembly and **save it for later use**.
- Remove the two thumb screws and save them for later use.

ÉTAPE 23 Retrait du ventilateur d'impression



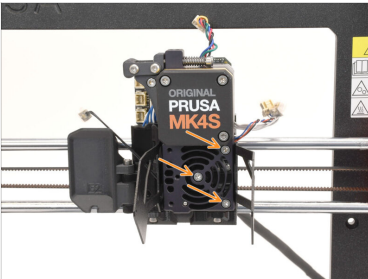
- Débranchez les câbles sur le côté gauche du Nextruder.
- Using the T10 screwdriver, remove the two screws holding the print fan on the left side.
- Remove the two screws on the right.
- Remove the print fan assembly by sliding it out. Proceed carefully to prevent damaging the cable going through the metal holder. **Save the fan assembly for later use!**

ÉTAPE 24 Retrait du ventilateur du dissipateur thermique



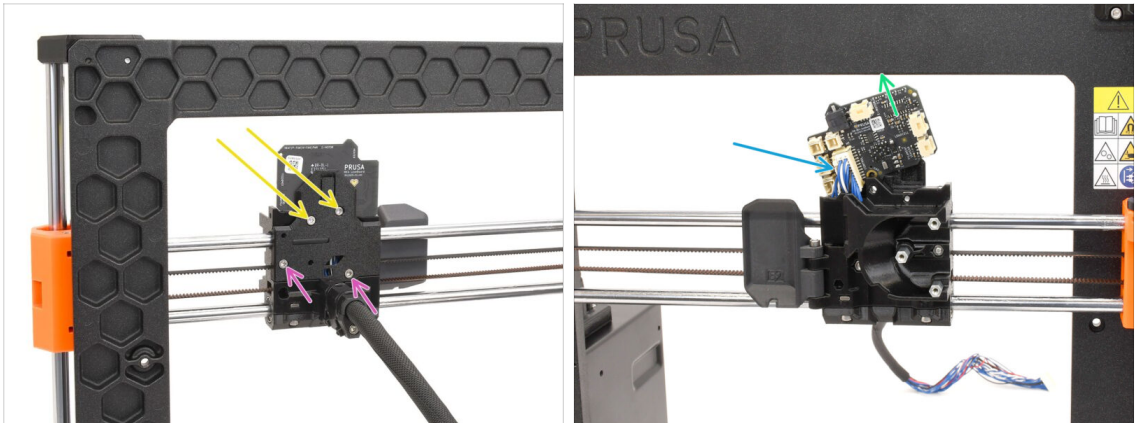
- Retirez les deux vis qui maintiennent le ventilateur de la hotend au dissipateur thermique.
- Remove the fan and **save it for later use**.
- 📌 Proceed carefully to prevent damaging the cable.

ÉTAPE 25 Retrait du Nextruder



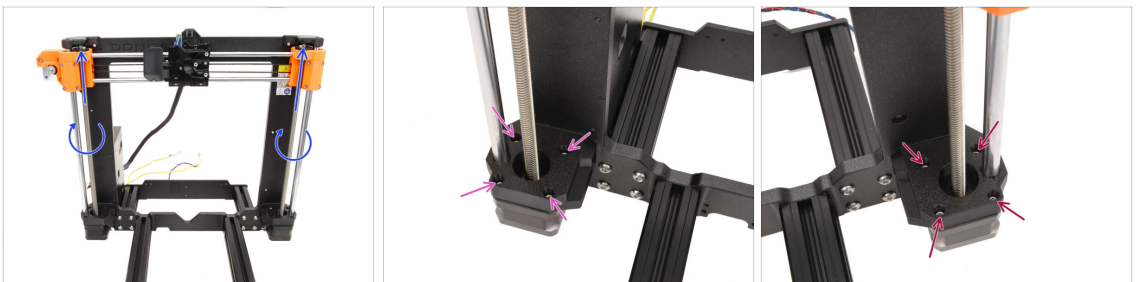
- Retirez les trois vis qui maintiennent le Nextruder au X-carriage.
⚠ **Watch out! The Nextruder might fall out!**
- Remove the Nextruder from the printer.
- Remove the Print fan support and a plastic spacer (if present). Proceed carefully to prevent damaging the heatsink thermistor cable.
- **Save the Nextruder for later use.**

ÉTAPE 26 Retrait de la LoveBoard



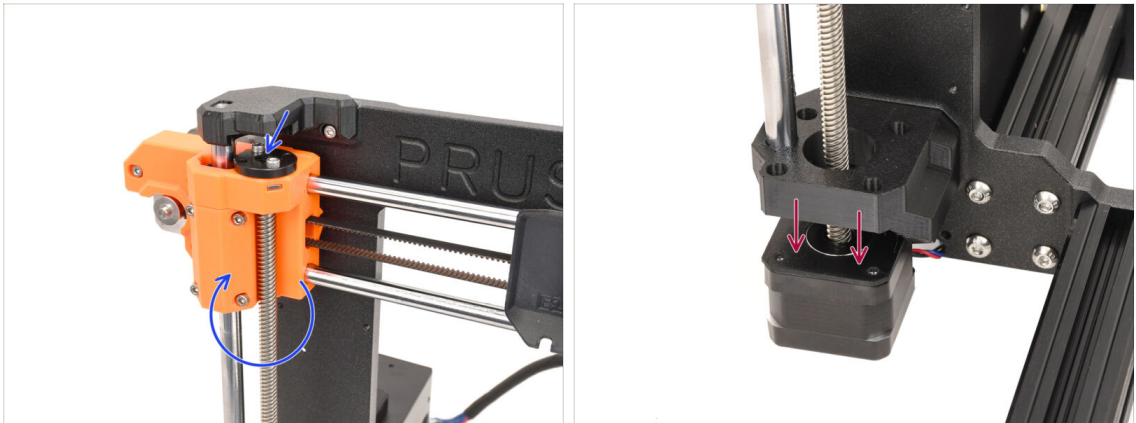
- Passez à l'arrière du X-carriage.
- Remove the two marked screws on top of the backing plate.
- Loosen the two remaining screws, but do not remove them entirely yet.
- Lift the Loveboard slightly to disconnect it from the main cable. Proceed carefully to prevent any damage to the Loveboard.
- Remove the Loveboard and save it for later use.

ÉTAPE 27 Retrait des moteurs Z



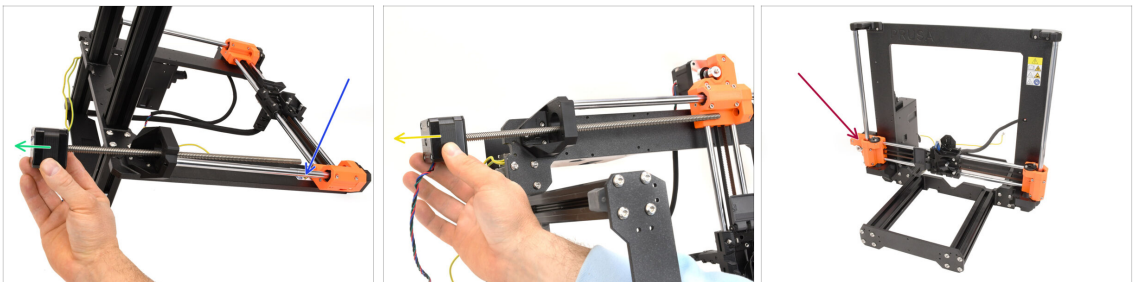
- Tournez manuellement les deux tiges filetées pour déplacer l'assemblage de l'axe X jusqu'en haut.
- Using a ball-end 2.5mm Allen key, remove all 4 screws securing the left Z motor.
- Remove the 4 screws holding the right Z motor as well.

ÉTAPE 28 Z Motors Removal 2



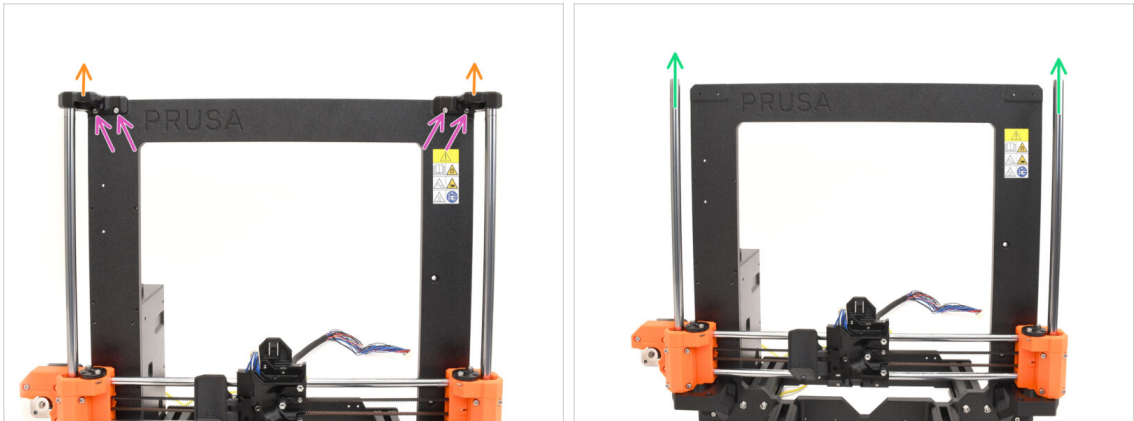
- ◆ Faites tourner les tiges filetées des deux côtés pour désengager les deux moteurs des écrous trapézoïdaux sur les pièces X-End.
- ◆ Disengage the motors on both sides from the holders. The X-axis will drop slightly.

ÉTAPE 29 Z Motors Removal 3



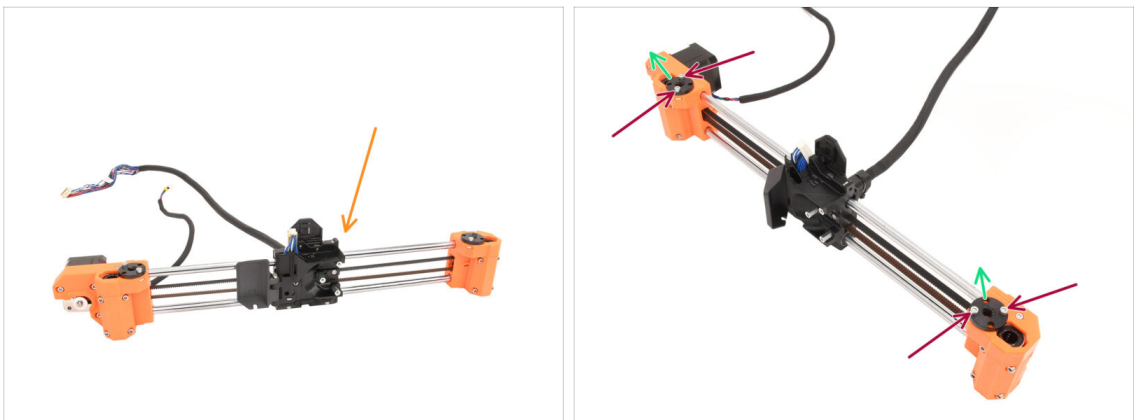
- ◆ Posez le cadre sur sa partie arrière.
- ◆ Remove the right Z motor by sliding it out. **Save it for later use.**
- ◆ Remove the left Z motor. **Save it for later use.**
- ◆ Move the frame back to the original position. **Expect that the X-axis now moves freely and may fall rapidly.**

ÉTAPE 30 Retrait des tiges de l'axe Z



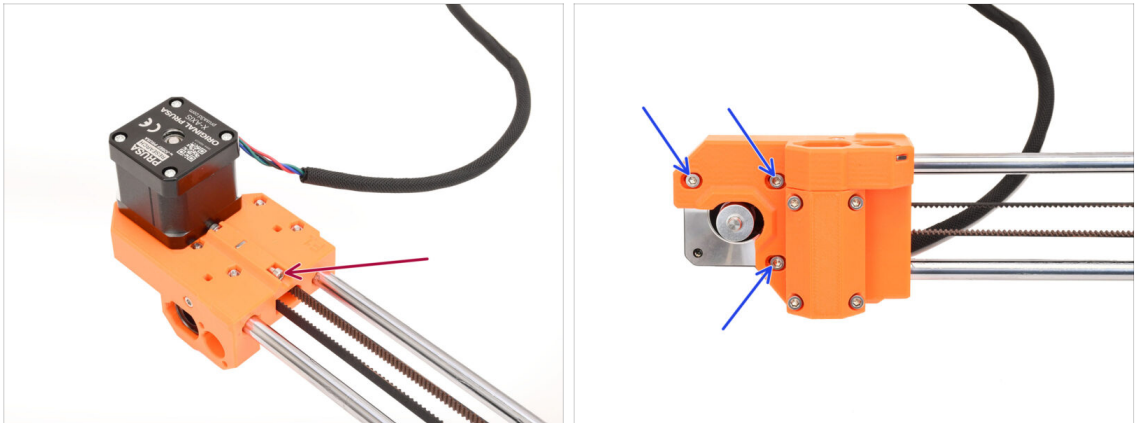
- ✿ Retirez les quatre vis qui maintiennent les pièces Z-top des deux côtés.
 - 🟠 Remove both Z-tops by pulling them up and disengaging from the rods.
 - 🟢 Pull up both Z rods and remove them from the printer.
Save both rods for later use.
- 📘 A slight wiggling motion may help to disengage them from the plastic part.

ÉTAPE 31 Retrait de l'écrou trapèze



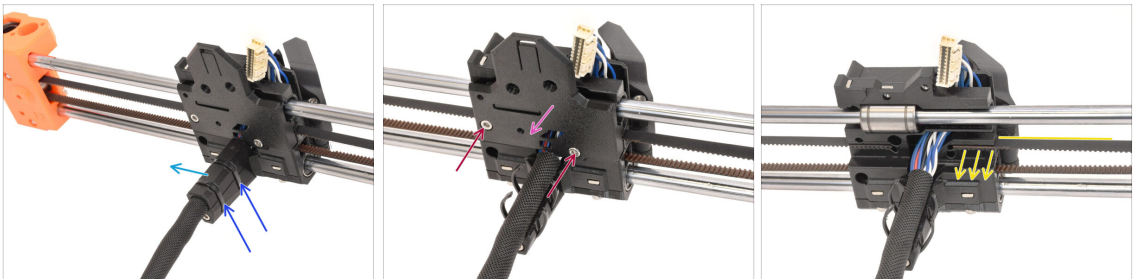
- 🟠 Retirez l'assemblage de l'axe X du cadre de l'imprimante.
 - 🔴 Remove the four screws holding the trapezoid nuts on top of both sides of the assembly.
 - 🟢 Remove both the trapezoid nuts and **save them for later use.**
- 📘 If the nuts are hard to remove, try rotating them, while pulling them up. If that doesn't help, carefully use the threaded rod on one of the Z-motors, to pry them out.

ÉTAPE 32 Libération du moteur X



- À l'arrière de l'assemblage, retirez la vis de tension de la courroie
- Loosen the three screws holding the motor on the front.
- ⓘ We need to release the belt tension, in order to release the belt in the upcoming step.

ÉTAPE 33 Libération de la courroie de l'axe X



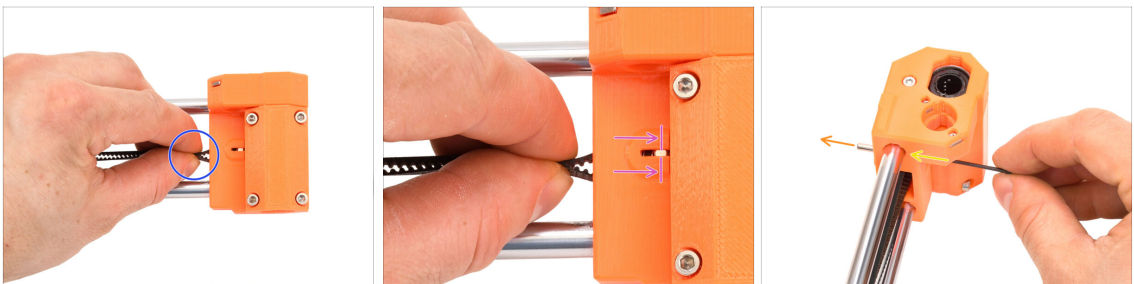
- À l'arrière de l'assemblage, coupez les deux colliers de serrage qui maintiennent le cache-câble.
- Remove the cable cover.
- Remove both screws on the back of the X-carriage.
- Remove the cover on the back of the X-carriage.
- Pull out the end of the belt on the motor side, to disengage it.

ÉTAPE 34 Retrait du moteur X



- Retirez les trois vis qui maintiennent le moteur X à l'avant de l'assemblage.
- Remove the X-Axis motor and **save it for later use**.

ÉTAPE 35 X Idler Shaft Removal



- Passons maintenant à la pièce X-end de droite.
- Use the belt as a handle for the Idler pulley inside the plastic part.
- Move the Idler **all the way inward**.

On the front, there is a small window where you can observe the idler shaft movement.

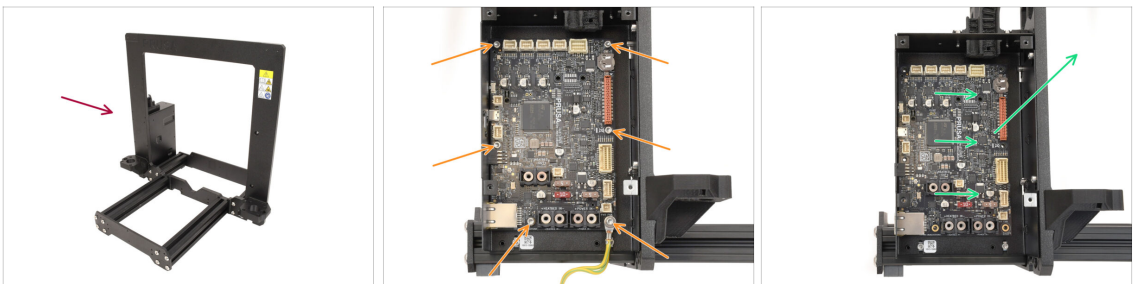
- While keeping the idler pushed all the way in, use the thinnest 1.5mm Allen key to push the shaft out of the part.
- The Idler shaft should exit the plastic part at the back. Remove it.

  TAPE 36 Retrait de l'idler de l'axe X



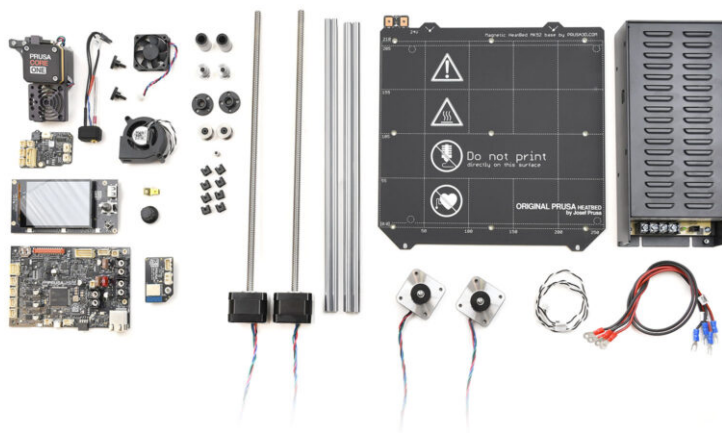
- Retirez la poulie de l'idler.
- Save the pulley for later use.

  TAPE 37 Retrait de la xBuddy

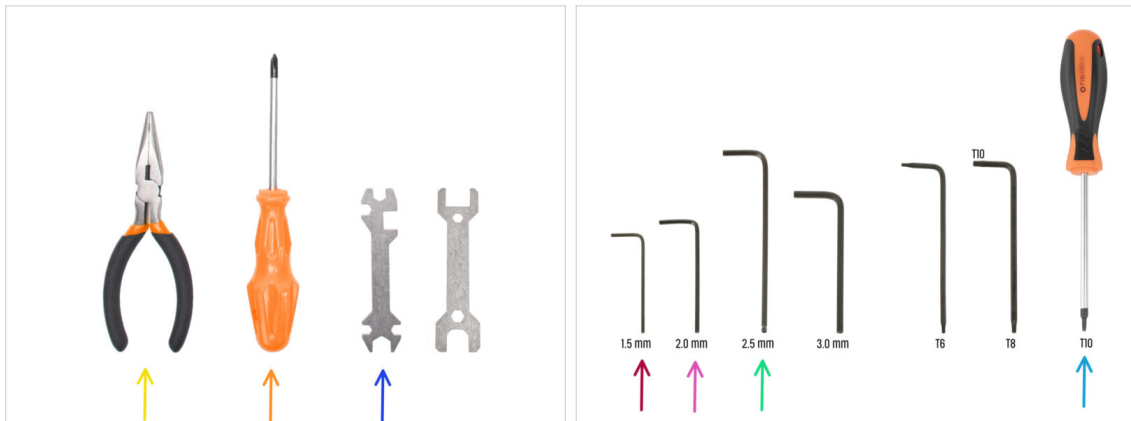


- Revenons au cadre de l'imprimante.
- Remove the six screws holding the xBuddy board in place.
- Release the xBuddy by sliding it towards the frame, then lifting it. **Save it for later use.**

1D. Préparation des composants



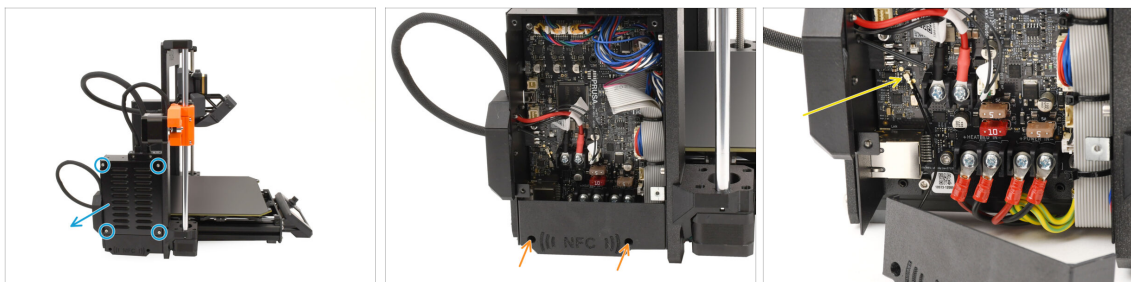
ÉTAPE 1 Outils nécessaires



● For this chapter, please prepare:

- Pince à bec fin
- Tournevis cruciforme
- Clé universelle
- Clé Allen de 1,5 mm
- Clé Allen de 2 mm
- Clé Allen de 2,5 mm
- Tournevis T10

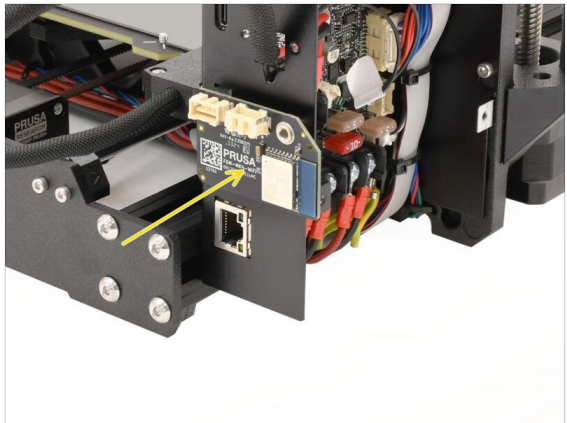
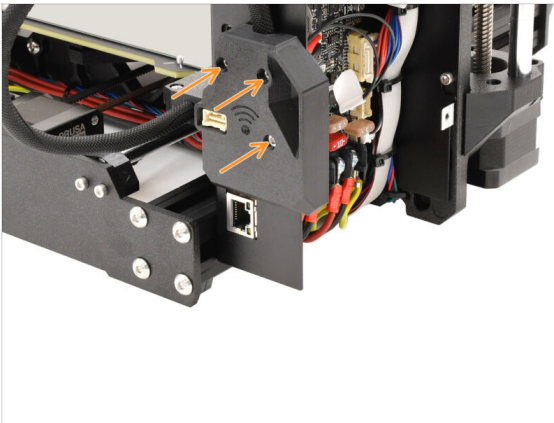
ÉTAPE 2 Démontage de l'électronique



- Let's move onto the **left** side of the printer.
- Remove the four screws holding the xBuddy box cover and remove the cover.
- Using the 2.5mm Allen key, remove the two screws holding the NFC cover.
- Disconnect the NFC antenna from the xBuddy board by gently lifting the tiny connector.

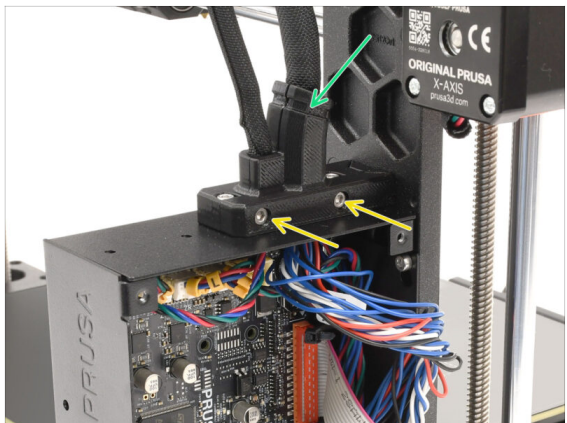
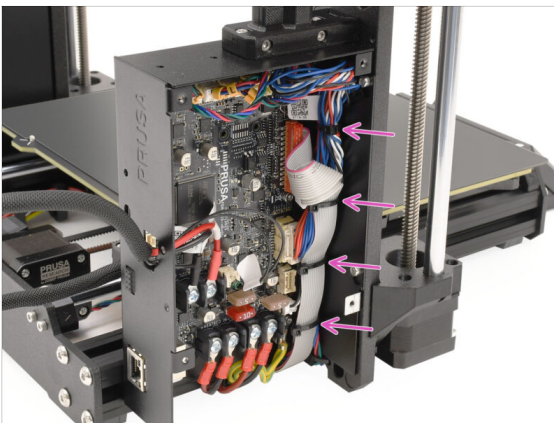
Then, remove the antenna along with the cover.

ÉTAPE 3 Démontage du Wi-Fi



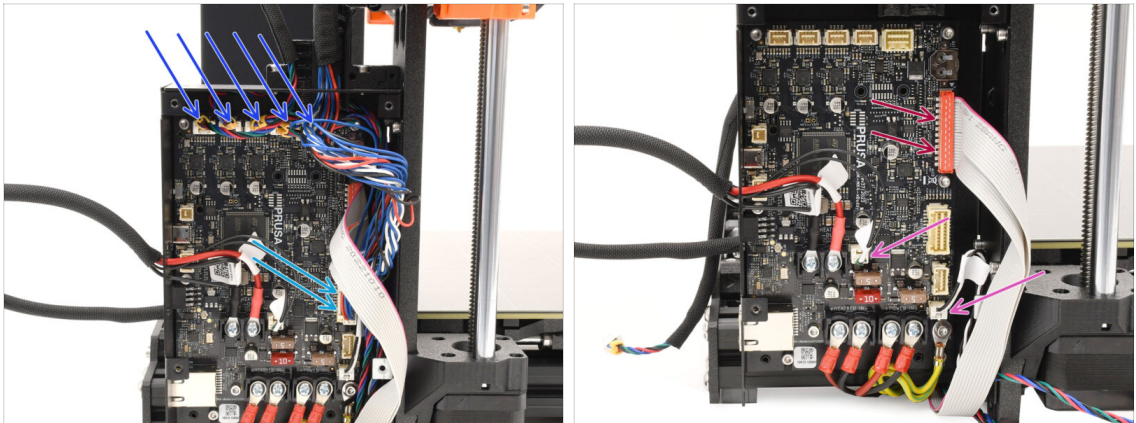
- 🟠 On the back of the electronics box, remove the three screws holding the Wi-Fi cover and remove the cover.
- 🟡 Remove the Wi-Fi module and **save it for later use**.
 - ⚠️ Ensure you store the module and all electronic components in an ESD-safe environment to prevent damage!

ÉTAPE 4 Démontage du faisceau de câbles



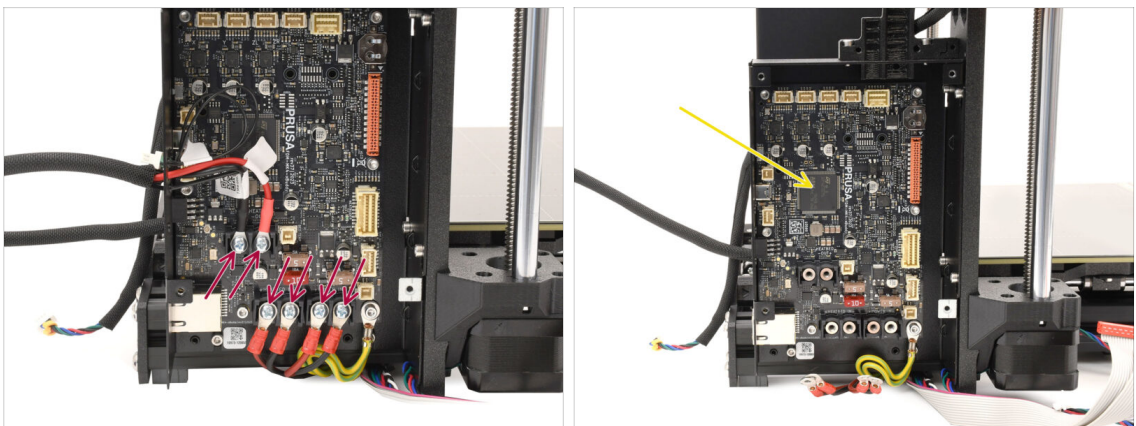
- 🟣 Remove all the zip-ties securing the cable bundle inside the xBuddy box.
 - ⚠️ When cutting the zip-ties, proceed carefully to prevent any damage to the cables or the electronics!
- 🟡 Remove the two screws on the main cable holder.
- 🟢 Cut the zip-tie holding the cover together, then remove the outer part of the holder.

ÉTAPE 5 Déconnexion des câbles 1



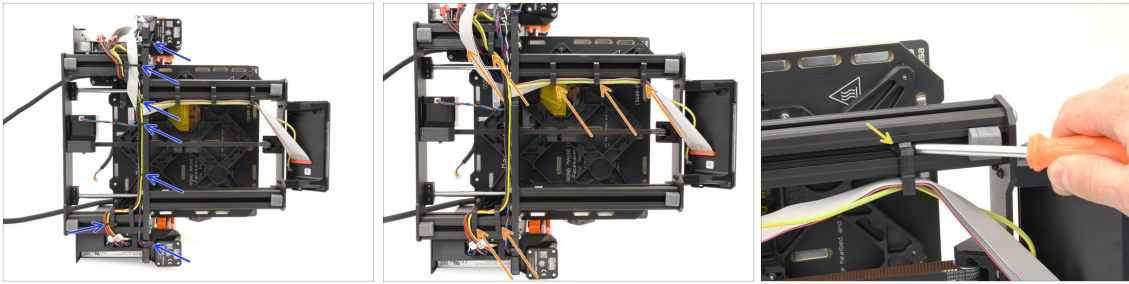
- ◆ Disconnect all the connectors on the top of the xBuddy board.
 - ⚠ There is a safety latch on each of these connectors, which must be pressed in order to disconnect it.
- ◆ Disconnect the extruder main cable connector.
- ◆ Disconnect the heatbed thermistor and power panic cables.
- ◆ Disconnect the xLCD connector by lifting it carefully up.

ÉTAPE 6 Déconnexion des câbles 2



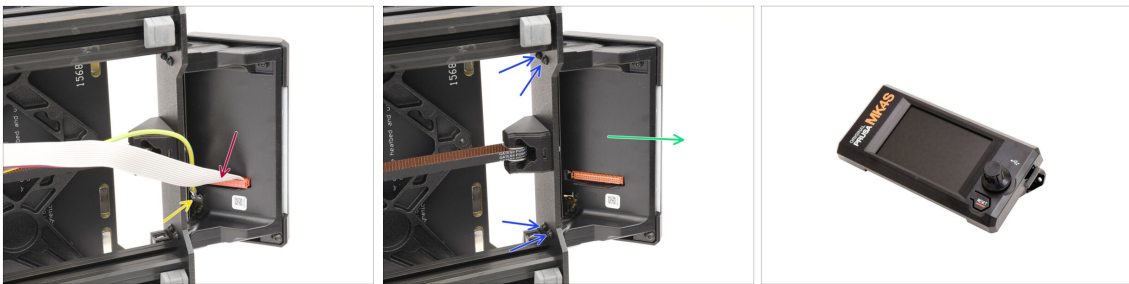
- ◆ Using the Phillips screwdriver, remove all the terminal screws holding the heatbed and power cable connectors.
- ◆ Leave the xBuddy board in the electronics box for now, as this way, it is well protected from damage.

ÉTAPE 7 Libération du faisceau de câbles



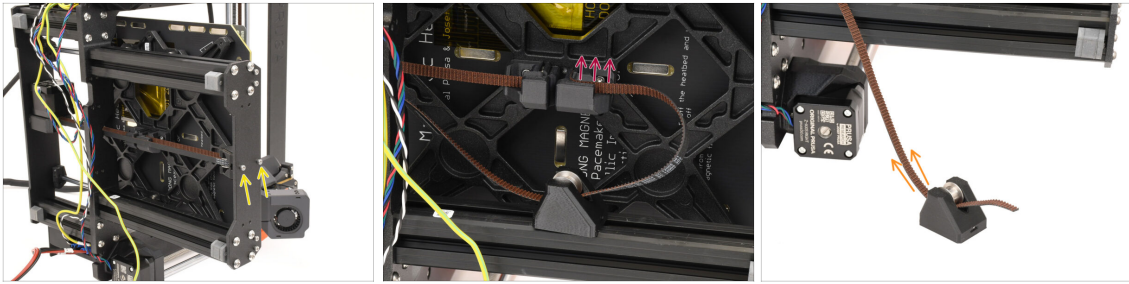
- Lay the printer onto the PSU side to access the bottom part.
- Carefully remove all the zip-ties holding the cable bundle
- Remove all the cable holders from the frame and detach them from the cables.
 - Pro tip: You can pry them off the metal profiles using the screwdriver.

ÉTAPE 8 Retrait du xLCD



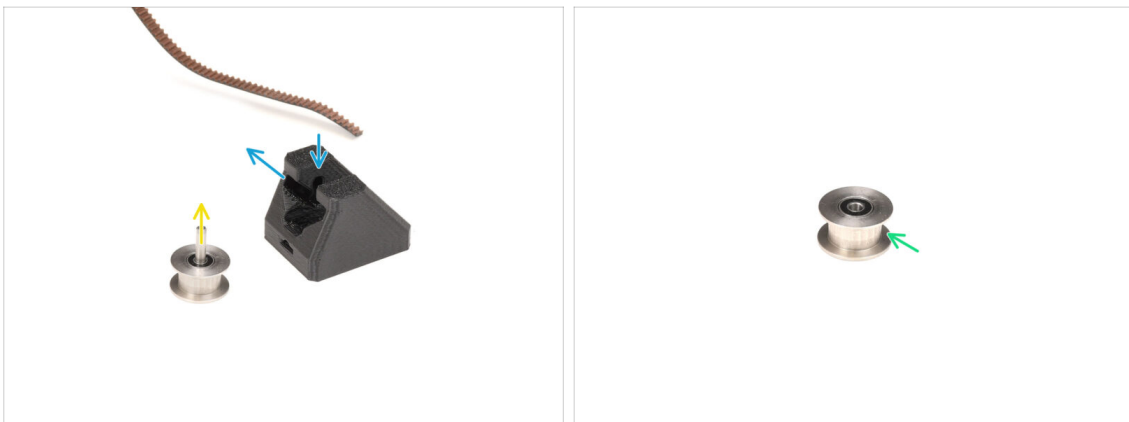
- Disconnect the main cable from the xLCD by gently lifting the connector up.
- Disconnect the grounding cable.
- Using the T10 screwdriver, remove the four screws holding the xLCD assembly.
- Remove the xLCD assembly and **save it for later use!**

ÉTAPE 9 Retrait du Y-idler



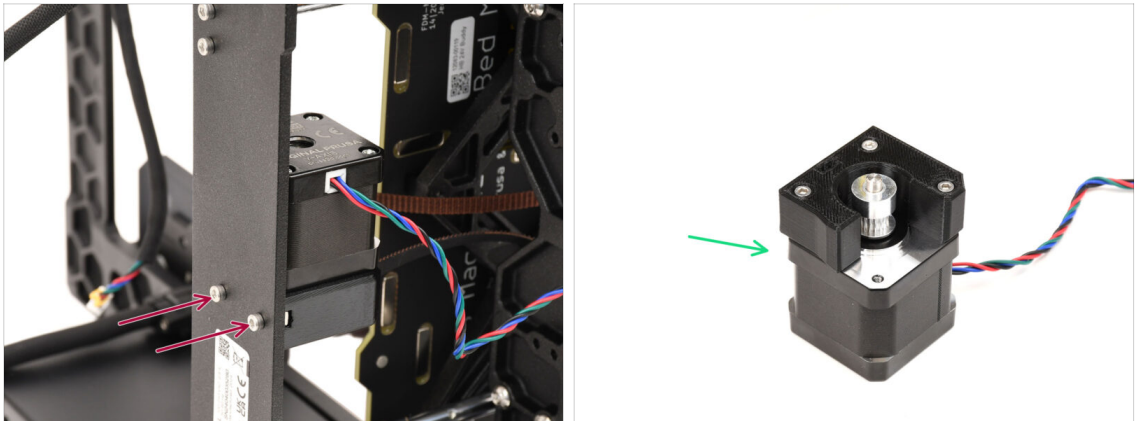
- ✦ Using the 2.5mm Allen key, remove the two screws holding the Y-Axis Idler on the front plate.
- ✦ Pull the end of the Y-axis belt out of the holder at the bottom of the heatbed to disengage it.
- ✦ Remove the belt from the idler by pulling it out.

ÉTAPE 10 Retrait de la poulie de l'idler



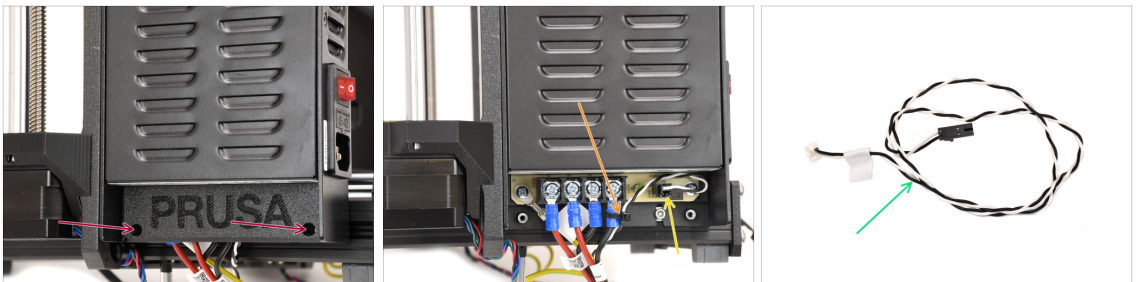
- ✦ Orient the Y-Idler as shown in the picture.
- Remove the pulley by first moving it inward, then pulling it out to the side.
- Refer to the groove pattern in the picture for the correct trajectory.
- ✦ Remove the center shaft from the pulley.
 - ✦ **Save the pulley for later use.**

ÉTAPE 11 Retrait du moteur Y



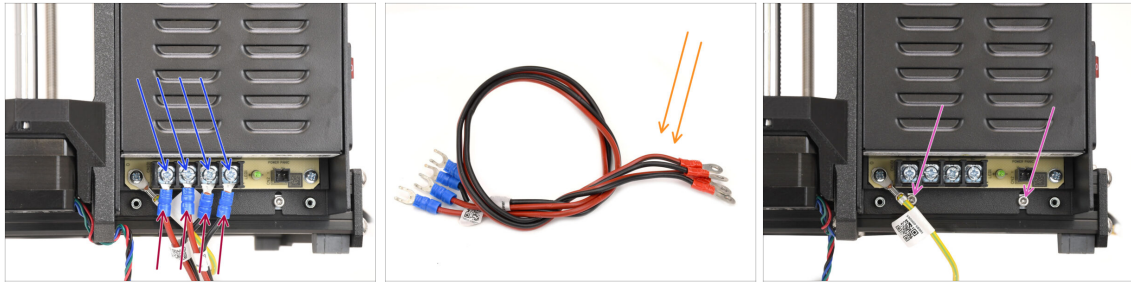
- Remove the two screws on the back of the printer, holding the Y-axis motor in place.
- Remove the Y-axis motor assembly and **save it for later use**.

ÉTAPE 12 Power Panic Cable Removal



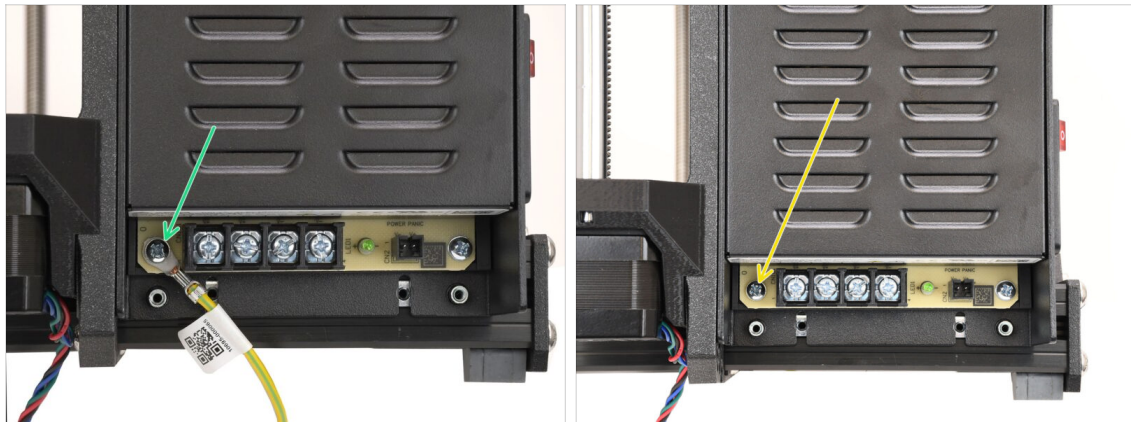
- Let's move onto the right side of the printer carcass, where the PSU lives.
- Remove the two screws securing the cover, then take off the cover.
- Carefully cut off the zip-tie holding the power panic cable.
- **Save the power panic cable for later use.**
- ① The power panic cable may look different, depending on your xBuddy board version.

ÉTAPE 13 Retrait du câble d'alimentation



- Using the Phillips screwdriver, loosen the four power terminal screws. Do not remove them entirely.
- Remove the four power cable connectors by pulling them downward.
- Remove the power cables and **save them for later use**.
- Using the 2.5mm Allen key, remove the two screws holding the PSU to the printer's frame.

ÉTAPE 14 Retrait du bloc d'alimentation 1



- Remove the screw holding the grounding cable to the PSU.
- Disconnect the grounding cable—it will no longer be needed.
- Re-install the screw you previously removed.

ÉTAPE 15 Retrait du bloc d'alimentation 2

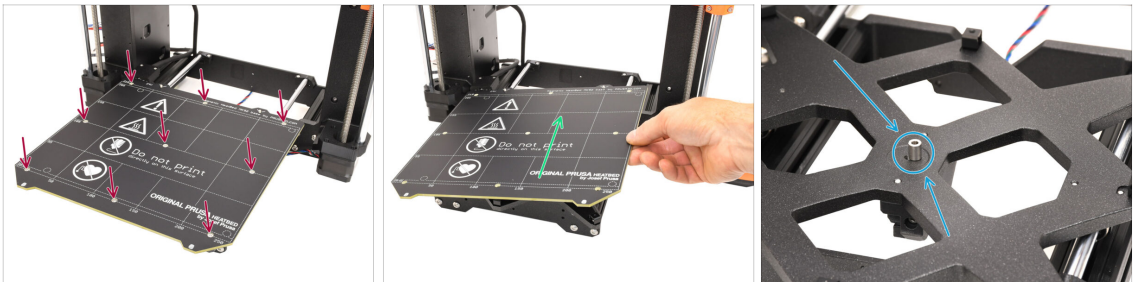


- On the front of the frame, remove the two screws holding the PSU.

⚠ The PSU might fall off to the side!

- Remove the PSU and **save it for later use**.

ÉTAPE 16 Retrait du plateau chauffant



- Let's move onto the heated bed.

- Using the T10 Torx screwdriver, remove all 9 screws holding the heated bed.

- Remove the heated bed by lifting it up. **Save it for later use.**

- There is a spacer in the middle of the heated bed. Make sure to save it for later use too!

📌 Be careful and store the heated bed on a soft surface to prevent scratching it.

ÉTAPE 17 Retrait de l'axe Y



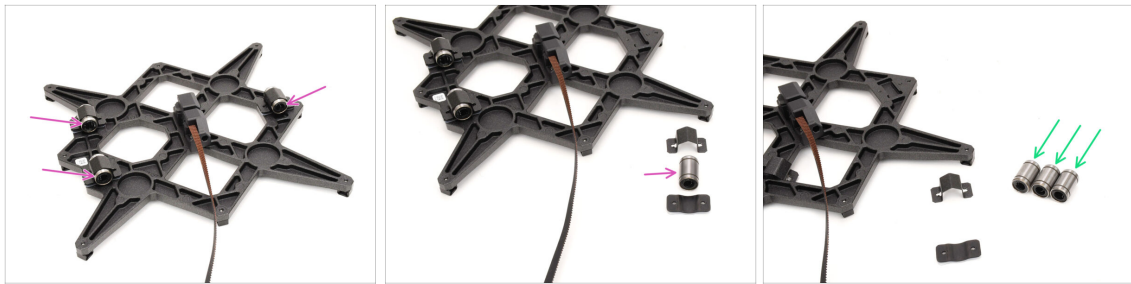
- Using the 2.5mm Allen key, remove the four screws holding the Y-axis rods to the front of the frame.
- Remove the four screws holding the Y-axis rods to the back of the frame.
- Remove the whole Y-axis assembly from the printer's frame.

ÉTAPE 18 Démontage de l'axe Y



- Remove the four screws fixing the rods to the Y-rod holders. Then, remove the plastic rod holders.
- Turn the assembly around.
- Pull out both the Y-axis rods. Clean them up and **save them for later use**.
- Remove all the screws holding the bearings to the carriage.

ÉTAPE 19 Retrait des roulements



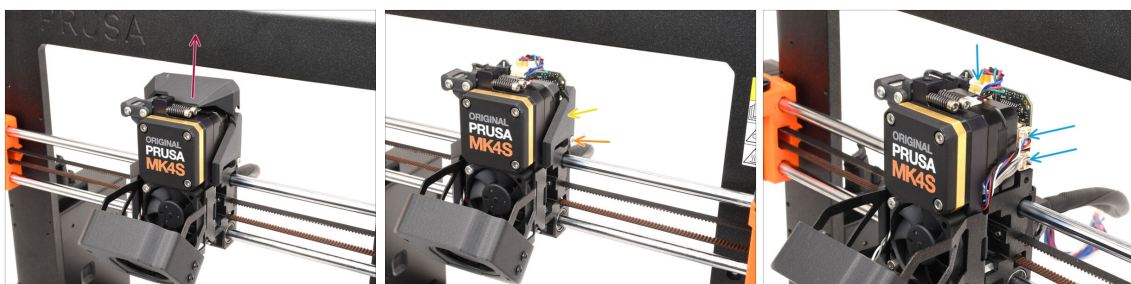
- ◆ Remove all three bearings from the bearing holders.
- ◆ Clean the bearings from any excess grease or dirt, and **save them for later use**.
- ❗ Two of this type of bearings will be used to build the CORE One.

ÉTAPE 20 Retrait du joint de dilatation



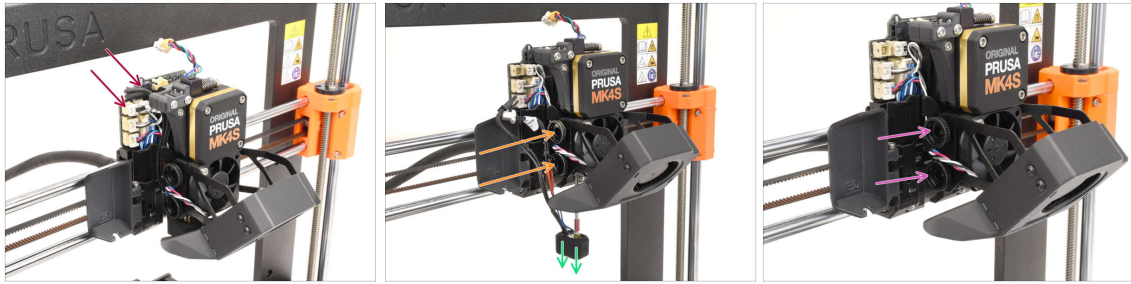
- ◆ Using the 2mm Allen key, remove all 8 expansion joints from the Y-Carriage.
- ◆ **Save the expansion joints for later use.**

ÉTAPE 21 Retrait du capot de l'extrudeur



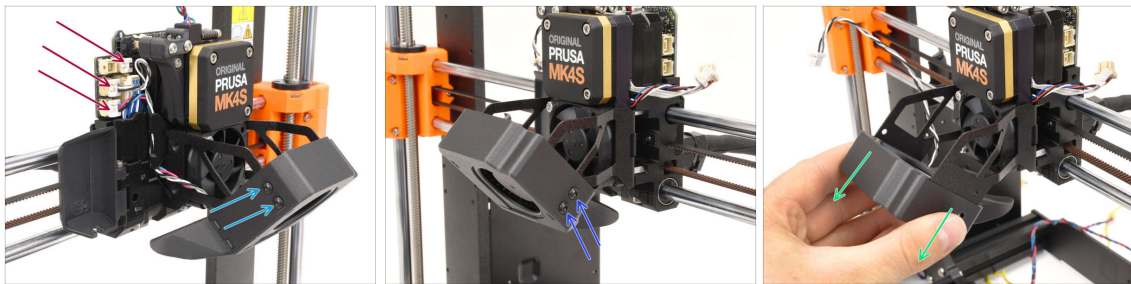
- ◆ Let's move onto the extruder.
- ◆ Remove the top cover on the extruder by lifting it up.
- ◆ Remove the screw holding the cover on the right side.
- ◆ Remove the side cover.
- ◆ Disconnect the motor, filament sensor and loadcell cables.

ÉTAPE 22 Retrait de l'assemblage de la hotend



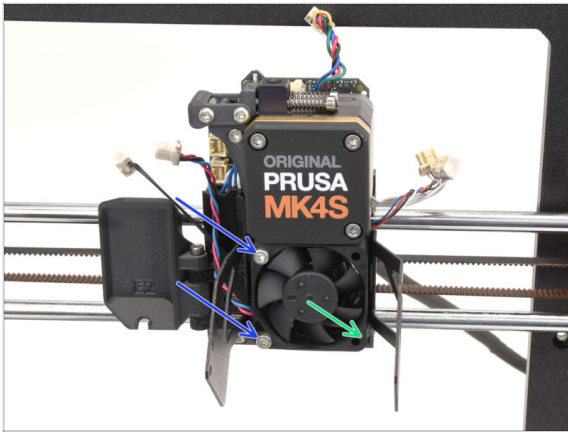
- On the opposite side, disconnect the nozzle thermistor and nozzle heater cables.
- Release the two thumb screws, until the hotend assembly drops.
- Remove the hotend assembly and **save it for later use**.
- Remove the two thumb screws and save them for later use.

ÉTAPE 23 Retrait du ventilateur d'impression



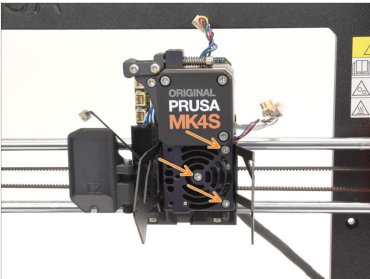
- Débranchez les câbles sur le côté gauche du Nextruder.
- Using the T10 screwdriver, remove the two screws holding the print fan on the left side.
- Remove the two screws on the right.
- Remove the print fan assembly by sliding it out. Proceed carefully to prevent damaging the cable going through the metal holder. **Save the fan assembly for later use!**

ÉTAPE 24 Retrait du ventilateur du dissipateur thermique



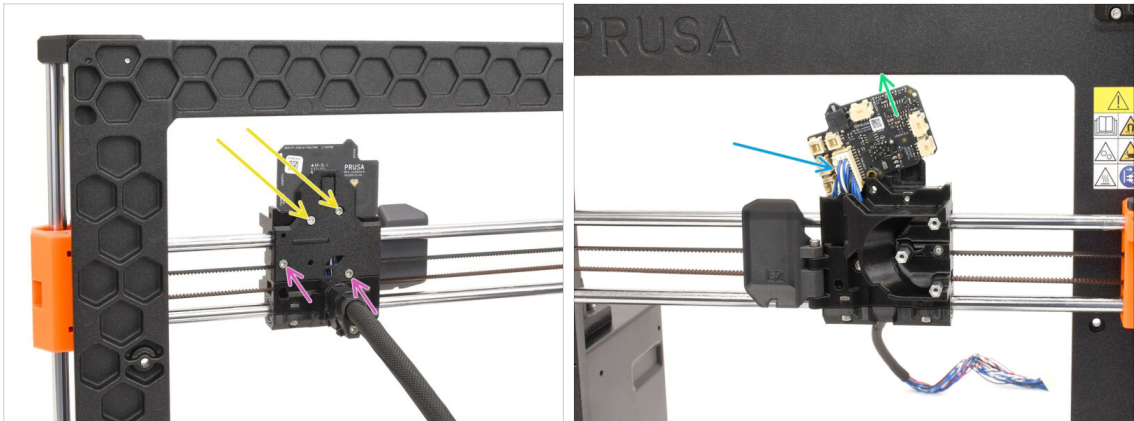
- Retirez les deux vis qui maintiennent le ventilateur de la hotend au dissipateur thermique.
- Remove the fan and **save it for later use**.
-  Proceed carefully to prevent damaging the cable.

ÉTAPE 25 Retrait du Nextruder



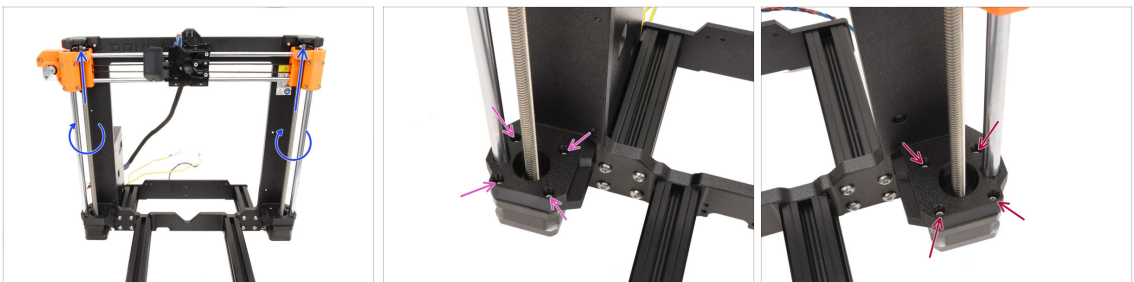
- Remove the three screws holding the Nextruder to the X-carriage.
 **Watch out! The Nextruder might fall out!**
- Remove the Nextruder from the printer.
- Remove the Print fan support and a plastic spacer (if present). Proceed carefully to prevent damaging the heatsink thermistor cable.
- Save the Nextruder for later use.**

ÉTAPE 26 Retrait de la LoveBoard



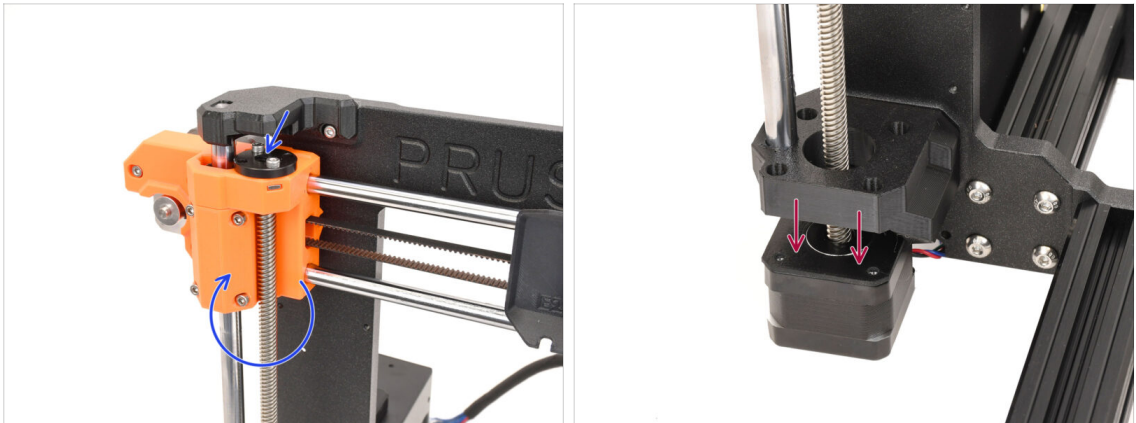
- Move onto the back of the X-carriage.
- Remove the two marked screws on top of the backing plate.
- Loosen the two remaining screws, but do not remove them entirely yet.
- Lift the Loveboard slightly to disconnect it from the main cable. Proceed carefully to prevent any damage to the Loveboard.
- Remove the Loveboard and save it for later use.

ÉTAPE 27 Retrait des moteurs Z



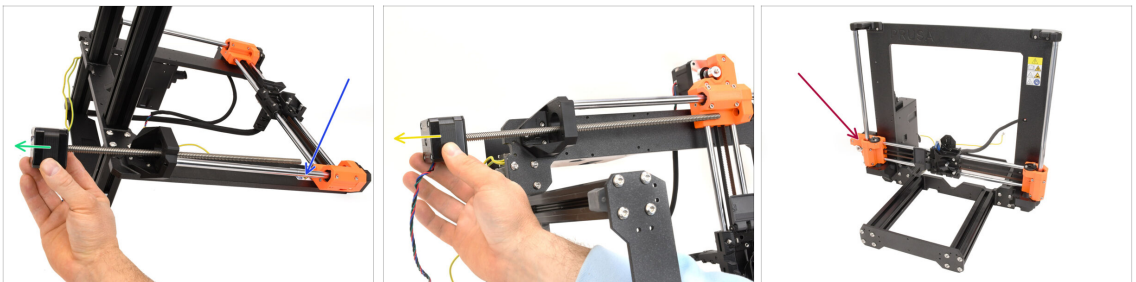
- Tournez manuellement les deux tiges filetées pour déplacer l'assemblage de l'axe X jusqu'en haut.
- Using a ball-end 2.5mm Allen key, remove all 4 screws securing the left Z motor.
- Remove the 4 screws holding the right Z motor as well.

ÉTAPE 28 Z Motors Removal 2



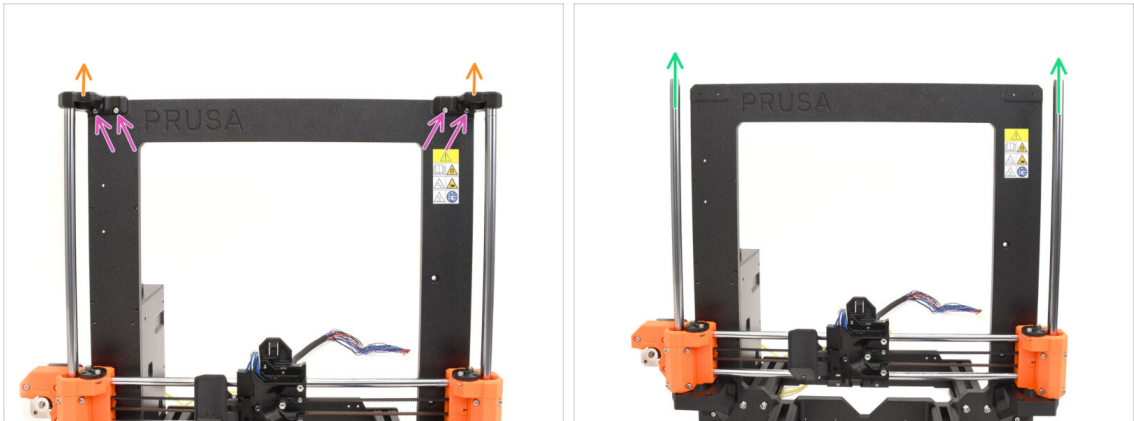
- Rotate the threaded rods on both sides to disengage both the motors from the trapezoid nuts on the X-End parts.
- Disengage the motors on both sides from the holders. The X-axis will drop slightly.

ÉTAPE 29 Z Motors Removal 3



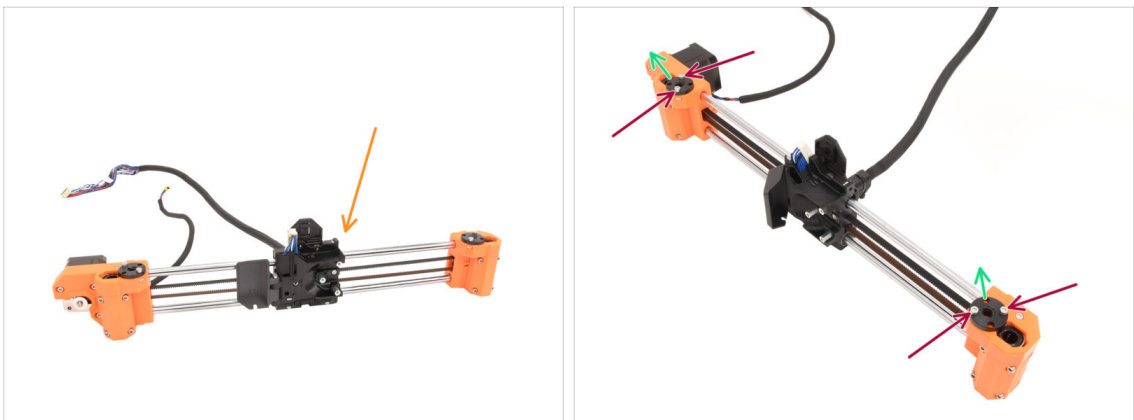
- Lay the frame onto its back part.
- Remove the right Z motor by sliding it out. **Save it for later use.**
- Remove the left Z motor. **Save it for later use.**
- Move the frame back to the original position. **Expect that the X-axis now moves freely and may fall rapidly.**

ÉTAPE 30 Retrait des tiges de l'axe Z



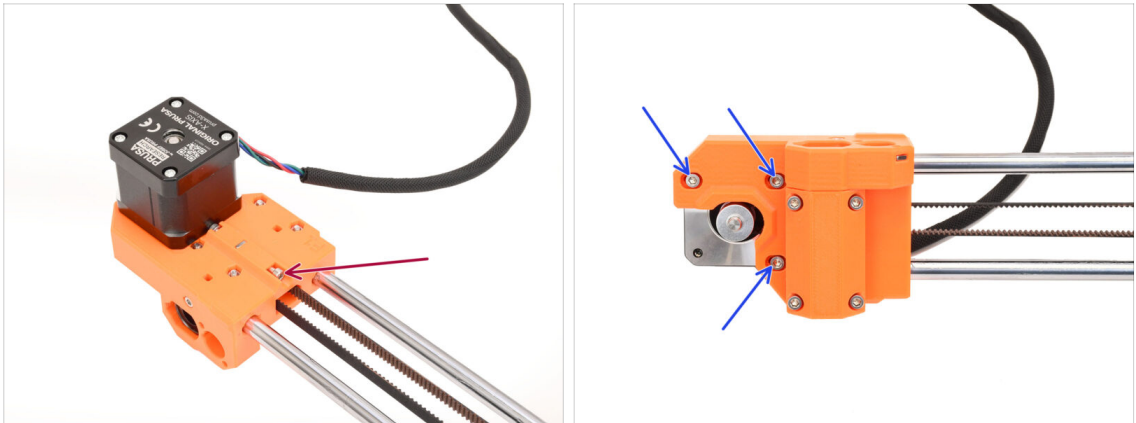
- ✿ Remove the four screws holding the Z-top parts on both sides.
 - 🟠 Remove both Z-tops by pulling them up and disengaging from the rods.
 - 🟢 Pull up both Z rods and remove them from the printer.
Save both rods for later use.
- 📘 A slight wiggling motion may help to disengage them from the plastic part.

ÉTAPE 31 Retrait de l'écrou trapèze



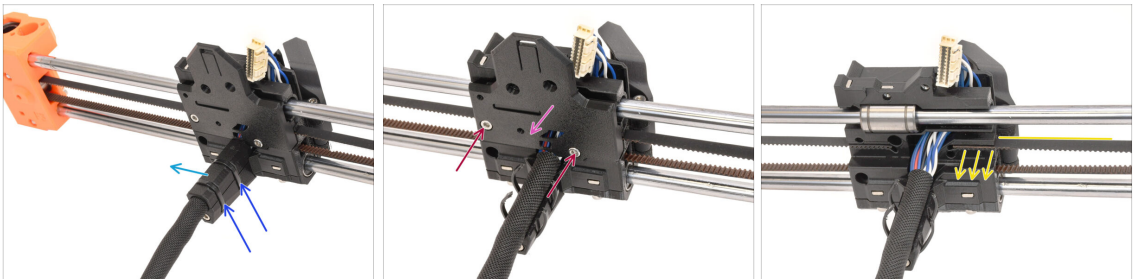
- 🟠 Remove the X-axis assembly from the printer's frame.
 - 🔴 Remove the four screws holding the trapezoid nuts on top of both sides of the assembly.
 - 🟢 Remove both the trapezoid nuts and **save them for later use.**
- 📘 If the nuts are hard to remove, try rotating them, while pulling them up.
If that doesn't help, carefully use the threaded rod on one of the Z-motors, to pry them out.

ÉTAPE 32 Libération du moteur X



- On the back of the assembly, remove the belt tensioning screw
- Loosen the three screws holding the motor on the front.
- ⓘ We need to release the belt tension, in order to release the belt in the upcoming step.

ÉTAPE 33 Libération de la courroie de l'axe X



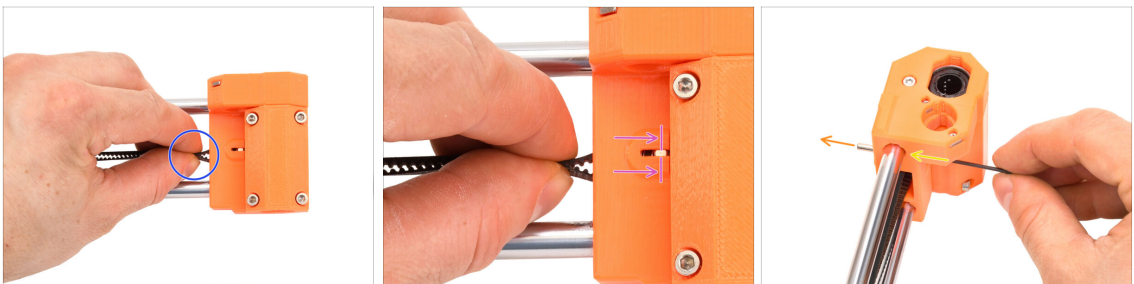
- On the back of the assembly, cut both the zip-ties holding the cable cover.
- Remove the cable cover.
- Remove both screws on the back of the X-carriage.
- Remove the cover on the back of the X-carriage.
- Pull out the end of the belt on the motor side, to disengage it.

ÉTAPE 34 Retrait du moteur X



- Remove the three screws holding the X-motor at the front of the assembly.
- Remove the X-Axis motor and **save it for later use**.

ÉTAPE 35 X Idler Shaft Removal



- Let's move onto the right X-end part.
- Use the belt as a handle for the Idler pulley inside the plastic part.
- Move the Idler **all the way inward**.

On the front, there is a small window where you can observe the idler shaft movement.

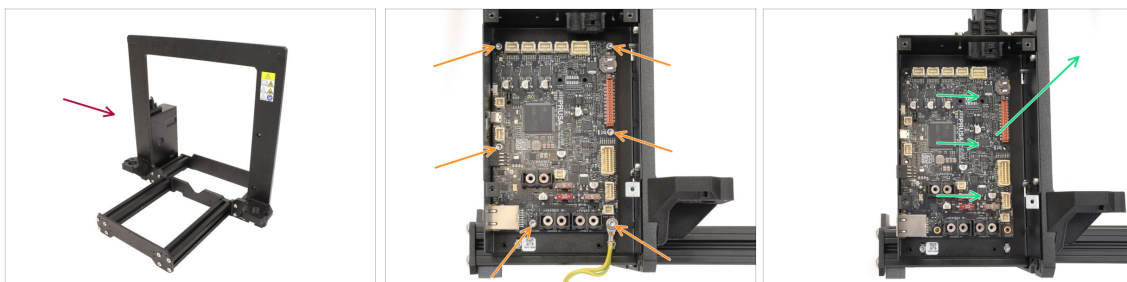
- While keeping the idler pushed all the way in, use the thinnest 1.5mm Allen key to push the shaft out of the part.
- The Idler shaft should exit the plastic part at the back. Remove it.

ÉTAPE 36 Retrait de l'idler de l'axe X



- Pull out the Idler pulley.
- Save the pulley for later use.

ÉTAPE 37 Retrait de la xBuddy

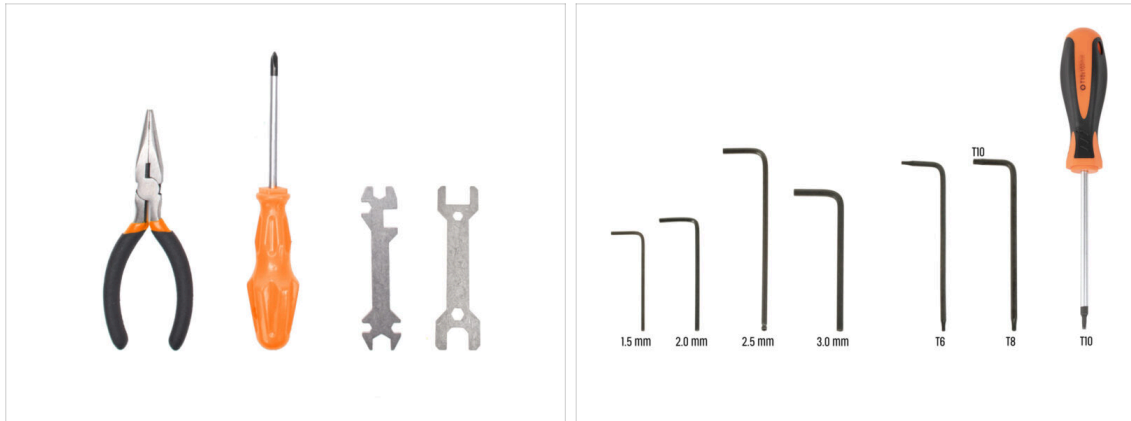


- Let's move back to the printer's frame.
- Remove the six screws holding the xBuddy board in place.
- Release the xBuddy by sliding it towards the frame, then lifting it. **Save it for later use.**

2. Assemblage de la base

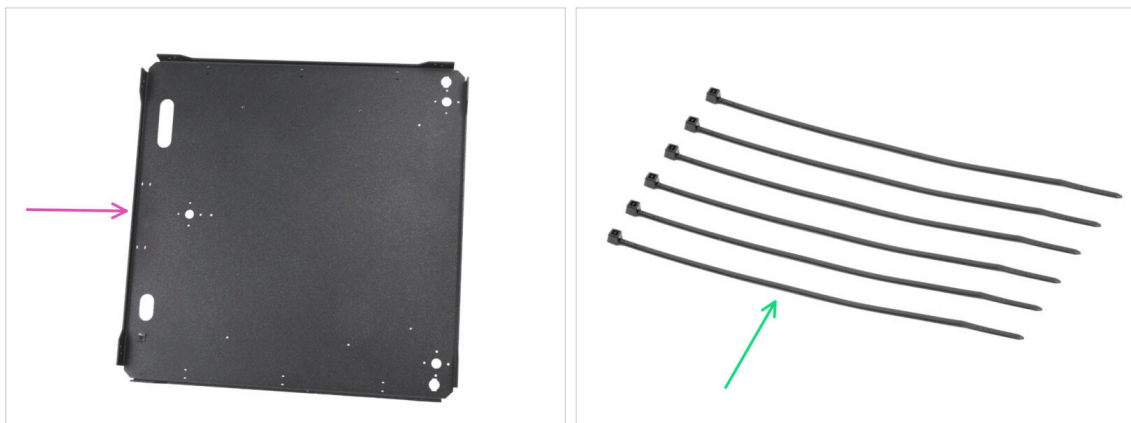


ÉTAPE 1 Tools necessary for this chapter



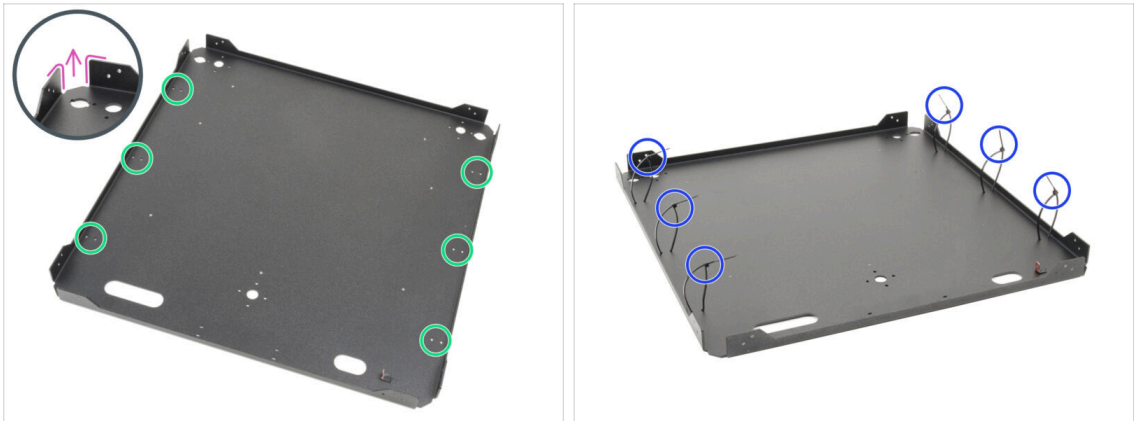
- **For this chapter, please prepare:**
- Clé 13-16
- Clé Allen de 2,5 mm
- T10 torx key / T10 torx screwdriver

ÉTAPE 2 Base assembly: parts preparation



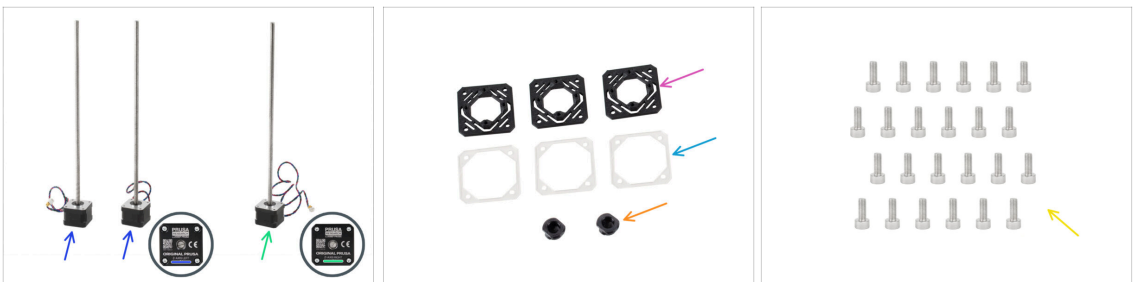
- **For the following steps, please prepare:**
- Bottom panel (1x) *found in the Metal parts 1/3 package*
- Zip tie (6x) *found in the Electronics & Fasteners package*

ÉTAPE 3 Inserting the zip ties



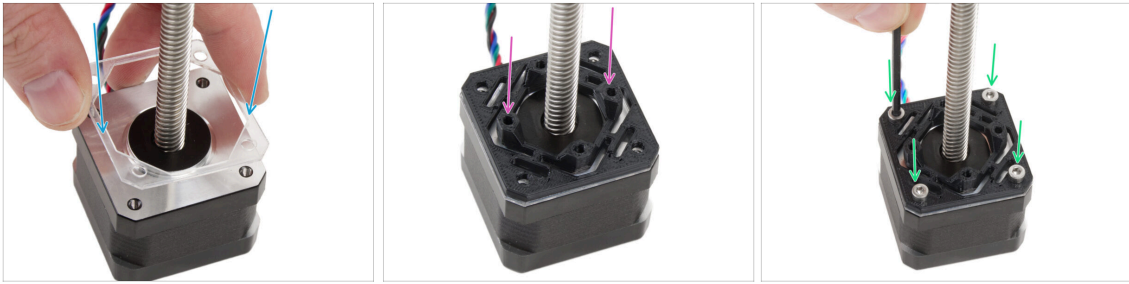
- ✿ Turn the bottom panel so that the bends of the plate are facing upwards.
- ✿ Note the twin holes for the zip ties around the perimeter of the panel.
- ✿ Insert six zip ties through the holes, placing them along both sides and partially tightening them, engaging only the first few teeth.
- ⚠ **Do not fully secure them yet, as we will route cables through them later.**
- ℹ Remarque : l'orientation des têtes des collier de serrage (à l'intérieur ou à l'extérieur de la tôle) n'a pas d'importance.

ÉTAPE 4 Base assembly: parts preparation



- ✿ **For the following steps, please prepare:**
- ✿ Z-axis left motor (2x)
 - 📌 One of these motors is in the electronics & chamber parts box.
- ✿ Z-axis right motor (1x)
- ✿ Z-motor-mount (3x) *qui se trouve dans le paquet des pièces imprimées*
- ✿ Rondelle de moteur (3x) *qui se trouve dans le paquet Électroniques & Pièces de la chambre*
- ✿ Z-rod-mount (2x) *qui se trouve dans le paquet des pièces imprimées*
- ✿ vis M3x8 (24x) *qui se trouve dans le paquet Électronique & Visserie*

ÉTAPE 5 Installing the motor mounts



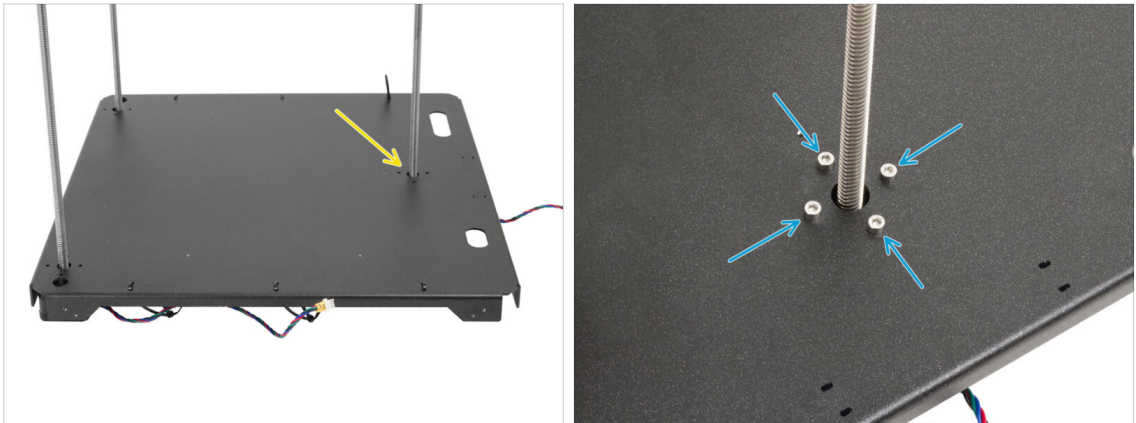
- Attach one transparent motor washer pad on each Z motor.
- Place one Z-motor-mount on each motor washer. **The protrusions on the part must be facing upwards.**
- Align holes with all the parts.
- Join all parts together with four M3x8 screws.
- Suivez la même procédure pour tous les moteurs.

ÉTAPE 6 Installing the rear motor



- Turn the bottom panel upside down.
- Locate the circle hole in the middle of the panel back side.
- Take the **Z motor right** - the motor with the longest cable. Labeled ZR on the cable.
- Push the motor threaded rod through the panel and align the holes in the panel with the holes in the motor assembly.
- ⚠ Le câble du moteur doit pointer vers l'extérieur (vers vous).**
- Poussez les deux moteurs de l'axe Z restant à travers le panneau inférieur.
- Les câbles du moteur doivent pointer vers le moteur arrière.**
- i** In the following instructions, we will refer to the **front** and **rear** sides of the assembly. The **front side** has **TWO** motors, while the **rear side** has **ONE** motor. We will remind you along the way, but it's good to keep this in mind :).

ÉTAPE 7 Securing the rear motor



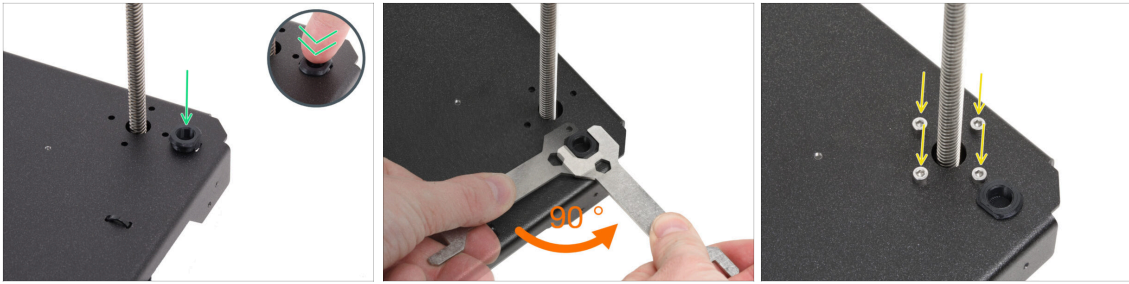
- ✦ Begin securing the motors, starting from the rear motor.
- ✦ Insert and fully tighten four M3x8 screws into the **rear motor**.
 - ⚠ Make sure the screws stay straight and do not tilt as you tighten them.
 - ⚠ Do not overtighten the screws, as they thread directly into the plastic part. For a final tightening, use the shorter part of the key as a handle to apply the correct amount of torque.

ÉTAPE 8 Installing the front motor right



- ✦ First, insert the rod-mount into the opening next to the front right Z motor.
- ✦ Use the 13-16 wrench to rotate the rod mount 90 degrees, locking it into place.
- ✦ Secure the motor using four M3x8 screws. Tighten them completely.
 - ⚠ Make sure the screws stay straight and do not tilt as you tighten them.

ÉTAPE 9 Installing the front motor left



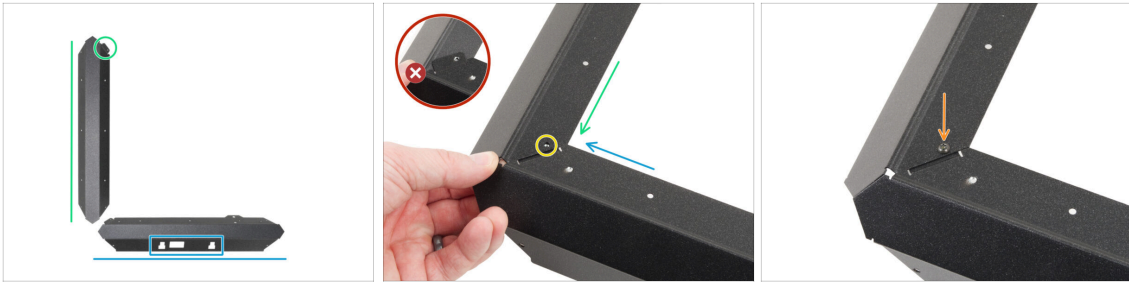
- Let's move to the front left motor (from the front view).
- ⚠ **Ensure, the motor cable still points to the rear side.**
- Insert the rod-mount into the opening next to the front right Z motor.
- Use the 13-16 wrench to rotate the rod mount 90 degrees, locking it into place.
- Fixez le moteur à l'aide de quatre vis M3x8. Serrez-les complètement.
- ⚠ **Assurez-vous que les vis restent droites et ne s'inclinent pas lorsque vous les serrez.**
- Laissez l'assemblage de côté pendant pour le moment.

ÉTAPE 10 Bottom frame: parts preparation



- **For the following steps, please prepare:**
- ⚠ **Be very careful when handling sharp sheet metal parts to avoid injury or damage.**
- ⚠ **Metal sheet profiles may look identical at first glance, but there are some differences. DOUBLE-CHECK to pick the correct ones.**
- Front profile (1x) **notice the cutouts** - found in the Metal parts 1/3 package
- Profilé arrière (1x) **avec deux trous sur le côté plat** - qui se trouve dans le paquet des pièces métalliques 1/3
- Profilé universel (2x) **pas de trous sur le côté plat** - qui se trouve dans le paquet des pièces métalliques 1/3
- Clip de fixation (2x) qui se trouve dans le paquet Électronique & Visserie
- Vis M3x4rT (4x)

ÉTAPE 11 Assembling the bottom profile: front + left



⚠ Be very careful when handling sharp sheet metal parts to avoid injury or damage.

- 🔵 Place the front profile according to the picture. The cutouts must be facing you.
- 🟢 Place one of the universal profiles on the left side. Orient the part according to the picture. **Use the flange as a guide.**
- ⬛ Attach the two profiles together.
- ⚠ **La bride de la plaque avant (flèche bleue) doit être insérée **sous** le profilé universel gauche (flèche verte), pas au dessus.**
- 🟡 Alignez les trous sur les deux pièces.
- 🟠 Assemblez les deux pièces avec la vis M3x4rT.

ÉTAPE 12 Assembling the bottom profile: left + rear



- 🟡 According to the picture, place the rear profile (with two holes on the flat side) to the universal left profile. Orient the part according to the picture. **Use the flange as a guide.**
- ⬛ Join the rear profile with the universal left profile together.
- ⚠ **Make sure the flange is under the rear profile, not on top.**
- 🟡 Align the holes in both parts.
- 🟠 Assemblez les deux pièces avec la vis M3x4rT.

ÉTAPE 13 Assembling the bottom profile: right



- Attach the universal right profile between the rear and front profile. **Ensure that:**
 - The **rear** end is **above** the rear profile flange.
 - The **front** flange is inserted **under** the front profile.
- Secure the left profile with M3x4rT on both ends.

ÉTAPE 14 Inserting the spacer pins



- Insert the spacer pin into the hole in the front profile protrusion.
- Push firmly on the spacer pin so that it fits perfectly into the hole.
- Use the same procedure for the second spacer pin.

ÉTAPE 15 Anti-vibration feet: parts preparation



● For the following steps, please prepare:

- Anti-vibration foot (4x) found in the *Electronics & Chamber parts package*
- Vis M3x4rT (8x)

ÉTAPE 16 Installing the anti-vibration feet



- Place the bottom frame according to the picture. The front profile must be facing you.



Before applying the anti-vibration feet, **wipe the metal profiles with isopropyl alcohol** and let them dry. This ensures proper adhesion.

- Peel off the protective layer from all anti-vibration feet.



Décollez soigneusement **seulement le film protecteur** de chaque pied anti-vibration. Si la couche adhésive commence à se détacher avec le film, arrêtez-vous et décollez-le d'un autre coin.

- Collez un pied anti-vibration dans chaque coin du cadre. Alignez-le avec le bord extérieur du côté plat du profilé.

ÉTAPE 17 Installing the bottom frame



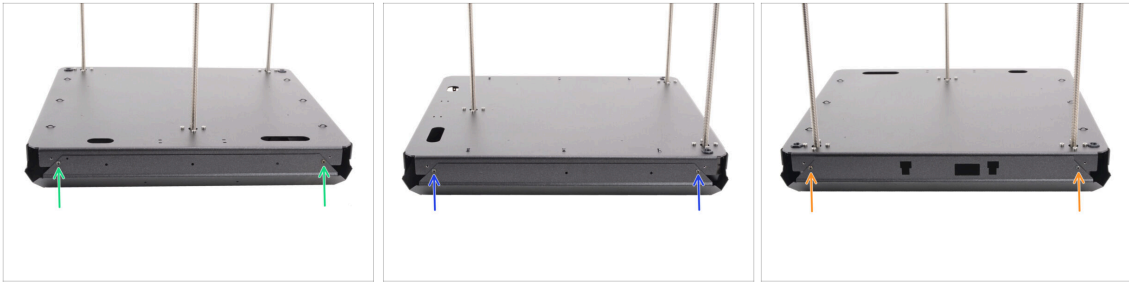
- Turn the bottom frame upside down. **The front profile must be facing you.**
- Attach the rear side of the bottom panel assembly to the rear side of the bottom frame.
- Ensure that the front side of the bottom panel assembly (with two motors) aligns with the front profile of the bottom frame (with cutouts).
- Place all the motor cables inside the center area of the bottom frame to prevent pinching.
- Abaissez lentement et soigneusement l'assemblage du panneau inférieur dans le profilé inférieur.
 - Assurez-vous que l'assemblage s'adapte parfaitement à l'intérieur du profilé inférieur.
 - Assurez-vous qu'aucune partie de l'assemblage du panneau inférieur ne dépasse du cadre inférieur
- ⚠ **Double-check that no cables are pinched.**

ÉTAPE 18 Mounting the bottom frame: right side



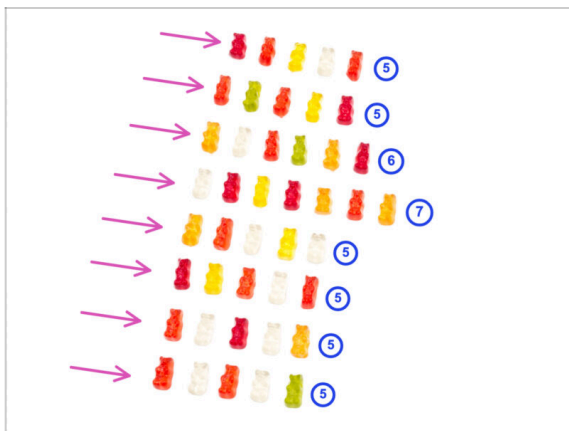
- Focus on the front right corner and right side.
- Slightly lift one of the corners of the bottom panel assembly.
- Align the threaded hole in the bottom panel with the hole in the profile.
- Join both parts together with the M3x4rT screw.
- Déplacez-vous vers le coin arrière du côté droit.
- Alignez les trous de la base et du profilé et fixez-le avec la vis M3x4rT.

ÉTAPE 19 Mounting the bottom frame: rear + left + front



- Move to the rear side of the assembly (side with one Z motor).
- Align holes in the base assembly and the profile and secure it with two M3x4rT screws.
- Focus on the left side of the assembly.
- Align holes in the base assembly and the profile and secure it with two M3x4rT screws.
- Tournez l'assemblage avec le profilé avant face à vous (profilé avec des découpes).
- Alignez les trous de l'assemblage de la base avec le profilé et fixez-les à l'aide de deux vis M3x4rT.

ÉTAPE 20 C'est l'heure des Haribo



- It's time to reward yourself!
- Stack your gummy bears in eight rows.
- Arrange the number of gummy bears in each row as shown in the picture.
- ① If you don't get the exact number in the last row, we recommend finding the nearest candy store and buying the missing ones.
- Mangez la première rangée.

ÉTAPE 21 Fini

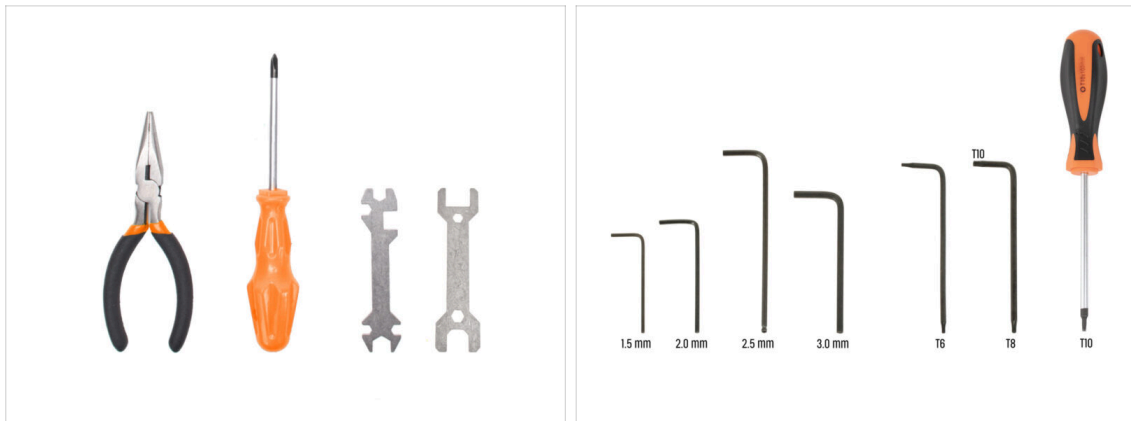


- **Congratulations!** You just assembled the **base assembly**.
- Set the assembly aside for now and let's move to the next chapter.

3. Assemblage de l'arrière



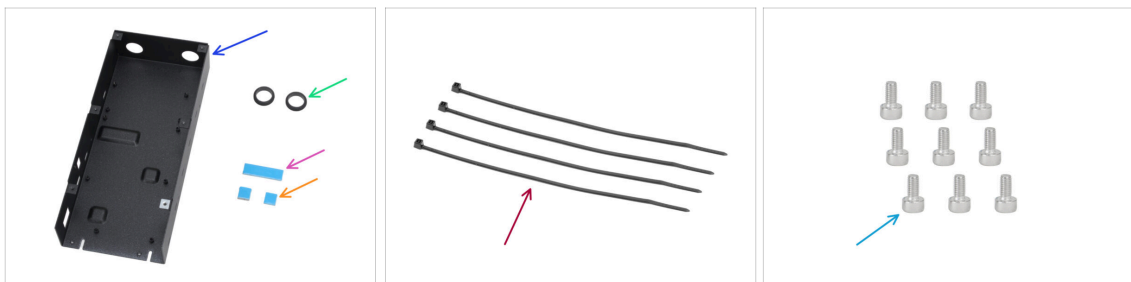
ÉTAPE 1 Tools necessary for this chapter



✦ Pour ce chapitre, veuillez préparer :

- ✦ Tournevis Philips (PH2)
- ✦ Pince à bec fin
- ✦ Clé Allen de 2,5 mm
- ✦ T10 torx key / T10 torx screwdriver

ÉTAPE 2 xBuddy: parts preparation I.

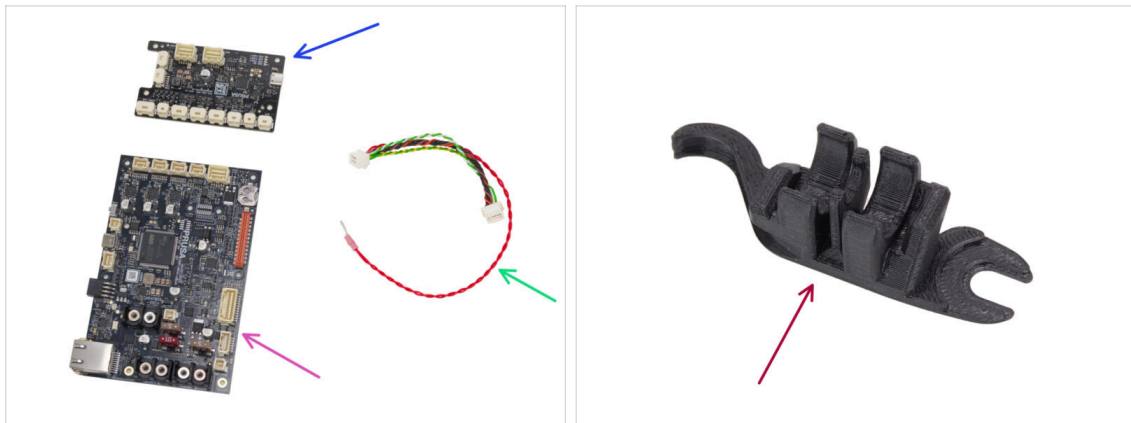


✦ Pour les étapes suivantes, merci de préparer :

- ✦ CORE One xBuddy box (1x) found in the Metal parts 3/3 package
- ✦ Grommet 19/16 mm (2x) found in the Electronics & Fasteners package
- ✦ Pad thermique 40x12x2,2 mm (1x) qui se trouve dans le paquet Électronique & Visserie
- ✦ Thermal pad 12x12x2.2 mm (2x) found in the Electronics & Fasteners package
- ✦ Collier de serrage (4x)
- ✦ Vis M3x6 (9x)

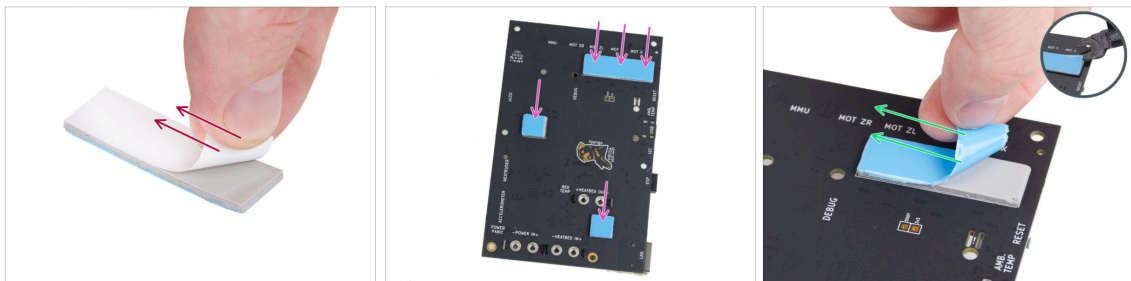
i The list continues in the next step...

ÉTAPE 3 xBuddy: parts preparation II.



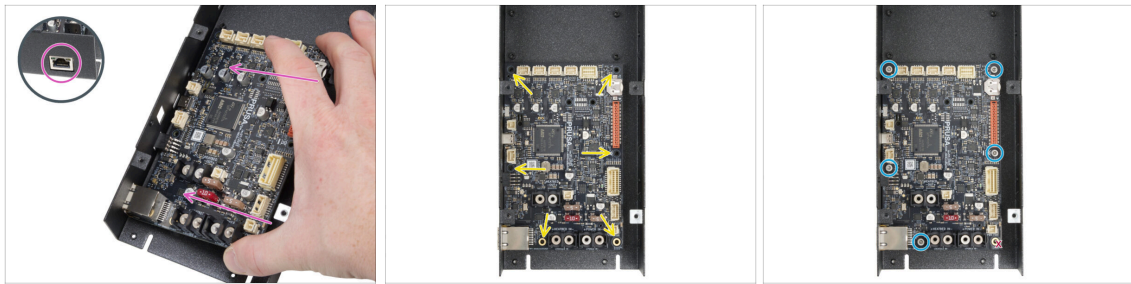
- Carte d'extension de la xBuddy (1x) *qui se trouve dans le paquet Électronique & Chambre*
- Carte xBuddy (1x)
- xBuddy extension cable (1x) *found in the Electronics & Fasteners package*
- Outil multifonction d'assemblage (1x) *qui se trouve dans le paquet des pièces imprimées*

ÉTAPE 4 Applying the thermal pads



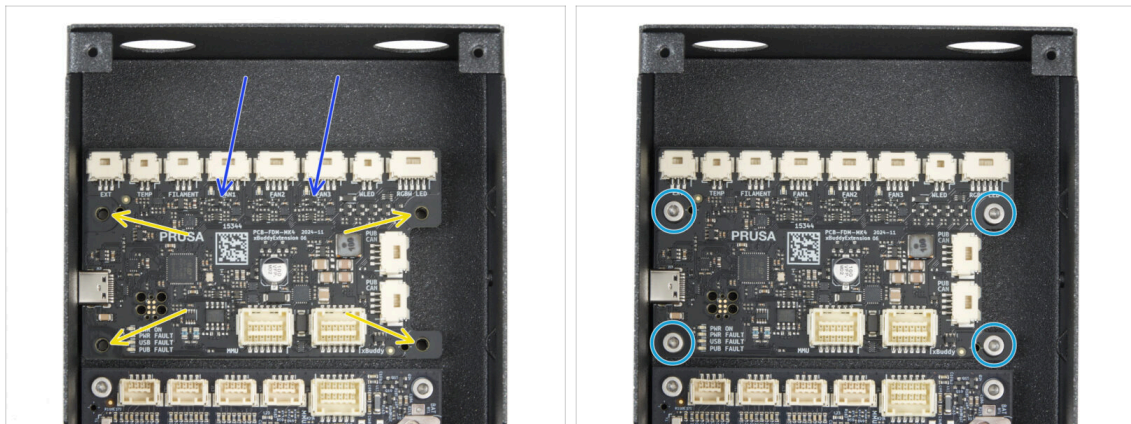
- Retirez la couche protectrice blanche de tous les pads thermiques.
- ⚠ **Always touch the sides of the electronics board while manipulating it. Avoid touching the chips, capacitors and other parts of the electronics.**
- Attach the pads onto the back of the xBuddy board. There are markings that indicate the correct size and positions.
- ① Assurez-vous que la surface de fixation du pad est propre et dégraissée.
- ⚠ **For the protection of the board's electronic components, we strongly recommend placing the xBuddy board on the soft pad. You can use the original xBuddy bubble wrap package.**
- Peel off the blue protective layer from all thermal pads.
- ① Pro tip: If the edge of the layer is difficult to lift, you can use the thin side of the Assembly-multi-tool to help separate the protective layer.

ÉTAPE 5 Installation de la xBuddy



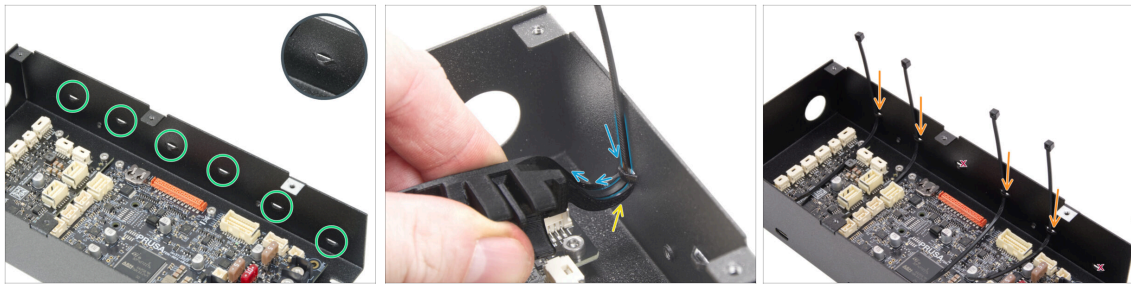
- ⚠ **Touchez toujours les côtés de la carte lorsque vous la manipulez. Évitez de toucher les puces, les condensateurs et les autres composants électroniques.**
- ✿ Insert the xBuddy board to the xBuddy box.
 - Make sure the Ethernet connector is properly inserted into the hole in the xBuddy box.
- ✿ **Avant de la fixer complètement**, alignez les trous de la carte avec les entretoises filetées du boîtier de la xBuddy.
- ✿ Fix the position of the xBuddy board by inserting five M3x6 screws. Do not fully tighten the screws. A few turns are enough for now.
- ⚠ **Put aside your instinct and leave the hole on the bottom right empty.**
- **Fully tighten all five screws. But very carefully**, otherwise you can damage the electronics board.

ÉTAPE 6 Installing the xBuddy extension



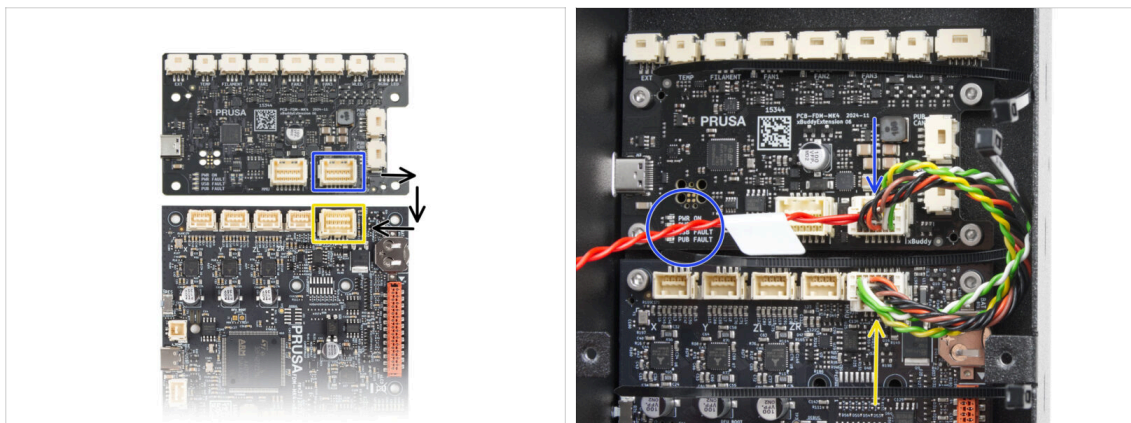
- ✿ Insérez la carte d'extension de la xBuddy dans le boîtier de la xBuddy au-dessus de la carte xBuddy. Notez l'orientation de la pièce.
- ✿ Before fully attaching it completely, center the holes in the board with the holes (columns) in the xBuddy box.
- ✿ Fix the position of the xBuddy extension board by inserting four M3x6 screws. Tighten them completely.

ÉTAPE 7 Installation des colliers de serrage



- Regardez de plus près le boîtier de la xBuddy. Le boîtier métallique comporte six perforations.
- ⚠ **Proceed very carefully. Be careful not to damage the connectors or capacitors on the xBuddy board.**
- Attach the hook on the Assembly-multi-tool below the first perforation on the left.
- Poussez le collier de serrage à travers la perforation et dans l'outil multifonction d'assemblage. Il guidera le collier de serrage dans le boîtier de l'électronique.
- ⚠ **Note the correct orientation of the zip tie. The teeth on the zip tie must be on the visible side.**
- Repeat the process at the indicated perforations.
- Skip the third and sixth perforations.

ÉTAPE 8 Connecting the xBuddy extension board



- Branchez le connecteur de l'extension de la xBuddy avec le câble rouge libre sur la carte d'extension de la xBuddy.
- Leave the red cable free for now.
- Plug the other end of the xBuddy extension cable to the xBuddy board.

ÉTAPE 9 Inserting grommets: xBuddy box



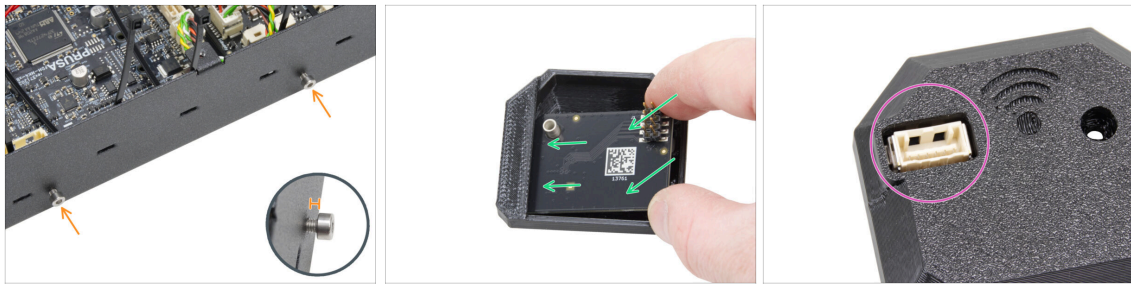
- Insérez les deux œillets dans les deux trous circulaires de la boîte xBuddy.
- Gently compress the grommet and fit it into the metal sheet, ensuring the groove locks into place

ÉTAPE 10 Wi-Fi : préparation des pièces



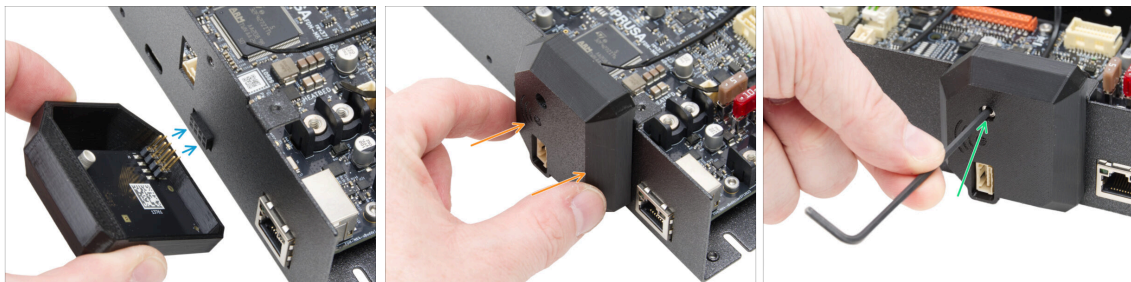
- Pour les étapes suivantes, merci de préparer :
- ESP-WiFi (1x) *reused from the MK4S*
- CORE-One-Wifi-cover (1x) *found in the Printed parts package*
- Vis M3x12 (1x)
- Vis M3x6 (2x)

ÉTAPE 11 Assemblage du Wi-Fi



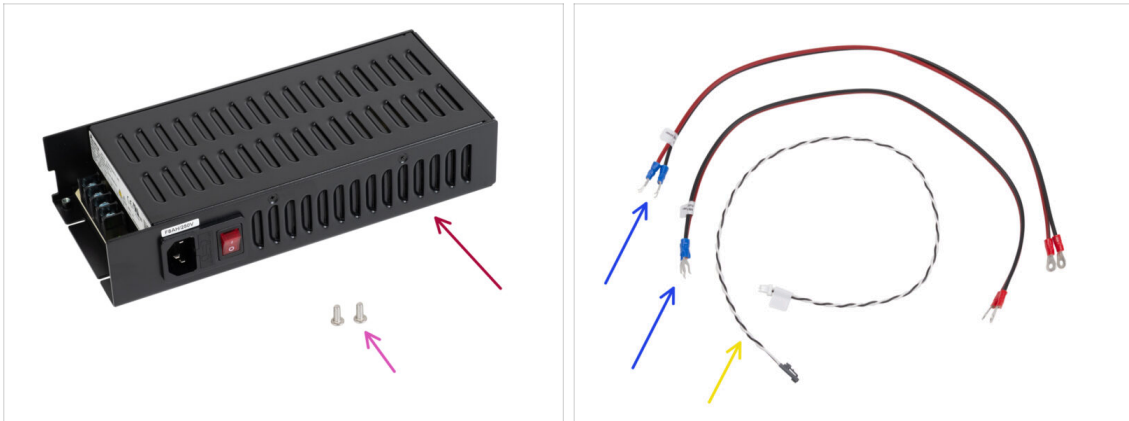
- ✚ Insérez deux vis M3x6 dans l'assemblage du boîtier de la xBuddy depuis le côté droit. **Ne les serrez pas complètement.** Laissez un espace d'au moins 4 mm (0,16 in).
- ✚ Insert the ESP-WiFi module into the WiFi-cover, positioning it just below the bridge on the left side.
- ✚ On the other side, ensure the connector fits correctly into the hole in the cover.

ÉTAPE 12 Installing the Wi-Fi assembly



- ⚠ **Soyez très prudent** lors de la manipulation et de la connexion du module ESP pour **éviter de plier et d'endommager les broches.**
- ✚ Take the WiFi cover assembly and connect the ESP module pins to the connector in the xBuddy.
- ✚ Close the WiFi cover carefully, ensuring the pins of the ESP module are properly engaged in the connector on the xBuddy.
- ✚ Secure the cover with the M3x12 screw.
- ⬛ Put the assembly aside for a while.

ÉTAPE 13 PSU assembly: parts preparation



● Pour les étapes suivantes, merci de préparer :

● Delta PSU 240 W 24 V (1x) *power supply*

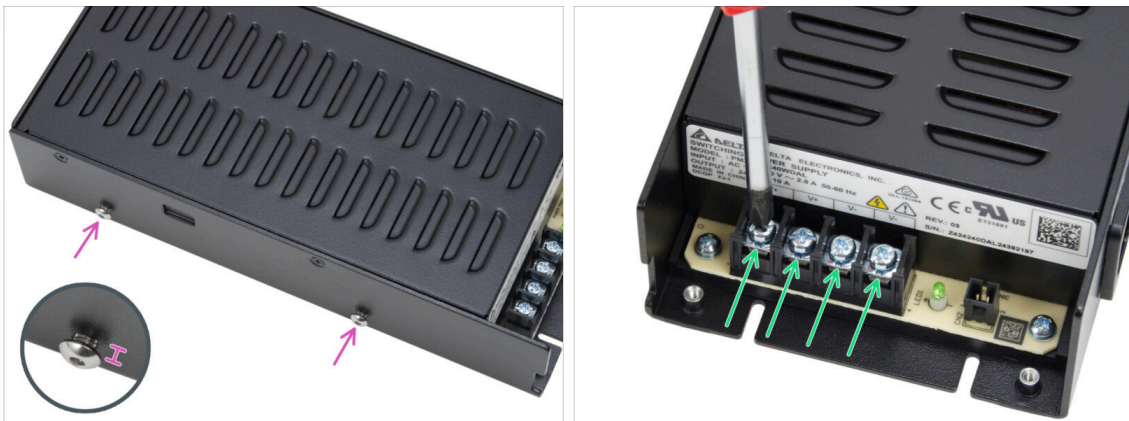
● Vis M4x6r (2x)

● xBuddy power cables (2x)

● Power panic cable (1x)

(i) The power panic cable may look different, depending on your MK4S printer / xBuddy board version.

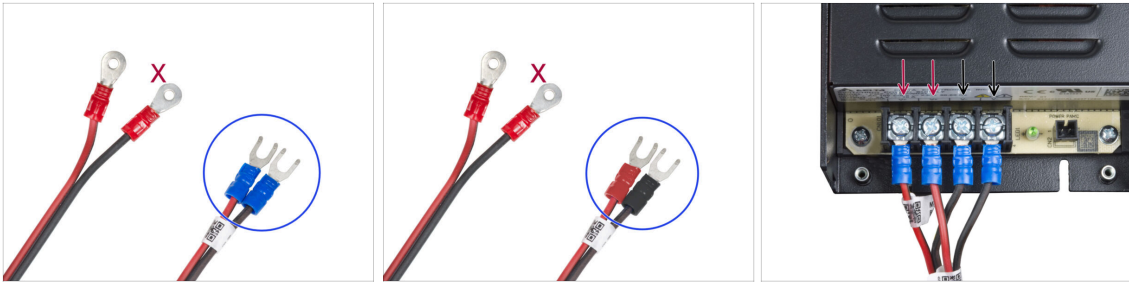
ÉTAPE 14 Préparation du bloc d'alimentation



● Insérez deux vis M4x6r dans le côté gauche du bloc d'alimentation. **Ne les serrez pas complètement.** Laissez un espace d'au moins 4 mm (0,16 in) entre la tête de la vis et le bloc d'alimentation.

● Slightly loosen all four power terminal screws on the PSU. **Do not remove them.** 3-4 turns are enough.

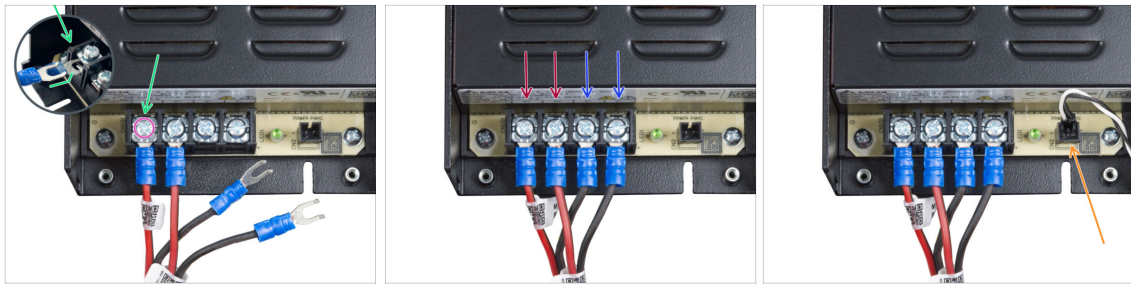
ÉTAPE 15 Informations sur les câbles d'alimentation



- i** Dans les étapes suivantes, nous connecterons les câbles d'alimentation un par un. Les vis des bornes sont déjà installées sur le bloc d'alimentation. Desserrez-les mais **ne les retirez pas complètement** afin qu'elles ne se mélangent pas avec les autres types de vis utilisés du côté de la carte xBuddy du câble. Chacun des deux câbles d'alimentation comporte deux fils.
 L'un a une **couleur rouge prédominante = positif / +**
 L'un a une **couleur noire prédominante = négatif / -**
- Note that the power cables have different connectors on each end. For now, prepare the U-shaped connectors (crimping tube color may vary).
- Note that the polarity of the terminals on the PSU is:

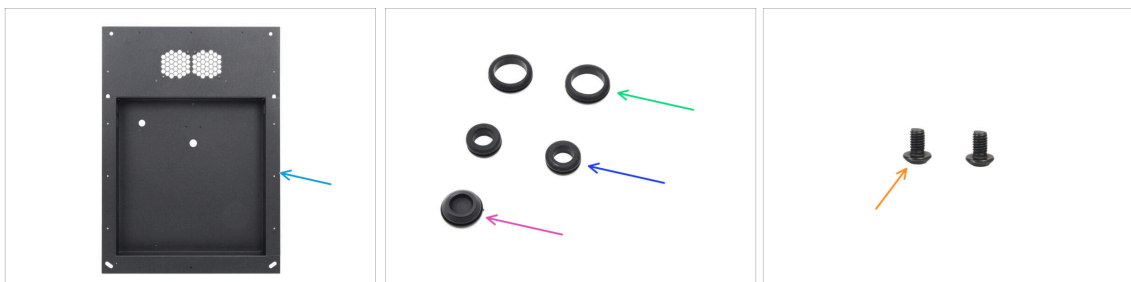
 - Positif (V+)
 - Positif (V+)
 - Négatif (V-)
 - Négatif (V-)
- i** The red cable (positive) may have a black stripe on it. Similarly, the black cable (negative) can have a red stripe on it.
- ⚠** **Do not connect any cables yet, wait until you have been prompted.**

ÉTAPE 16 Connexion de l'alimentation



- Prenez le fil ROUGE et faites glisser le connecteur à fourche jusqu'à la première borne (positive) à partir de la gauche en bas du bloc d'alimentation. Assurez-vous que la rondelle en acier est au-dessus du connecteur "fourche".
- Tighten the terminal screw firmly.
- Use the same procedure to connect the second red wire to the second terminal slot from the left.
- Connect two black wires to the third and fourth terminal slots using the same procedure.
- Plug the black connector of the power panic cable to the right most connector.
- Put the assembly aside for a while.

ÉTAPE 17 Back panel: parts preparation



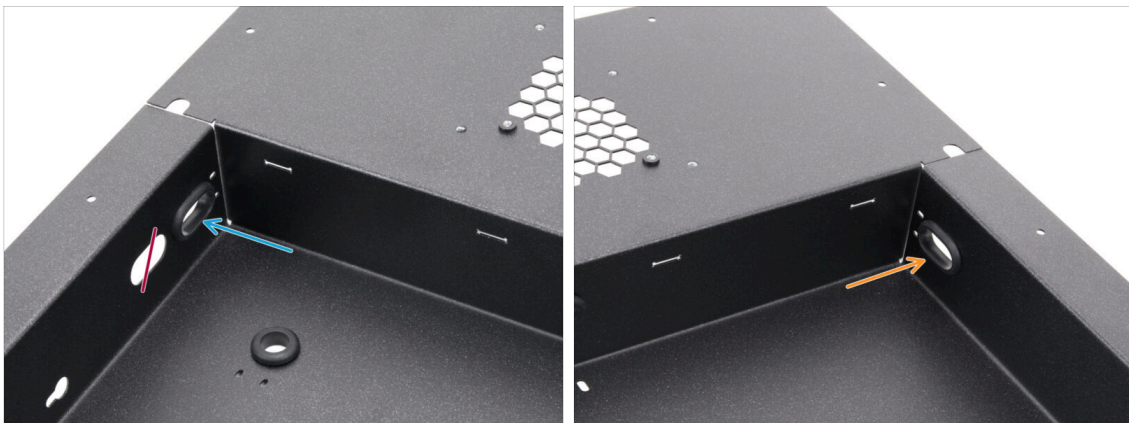
- **Pour les étapes suivantes, merci de préparer :**
- Back panel (1x) *found in the Metal parts 1/3 package*
- Grommet 19/16 mm (2x) *large one - found in the Electronics & Fasteners package*
- Grommet 13.5/10 mm (2x) *small one - found in the Electronics & Fasteners package*
- Sealing plug 15.5 mm (1x) *found in the Electronics & Fasteners package*
- Vis M3x4rT (2x)

ÉTAPE 18 Installing grommets: back panel top



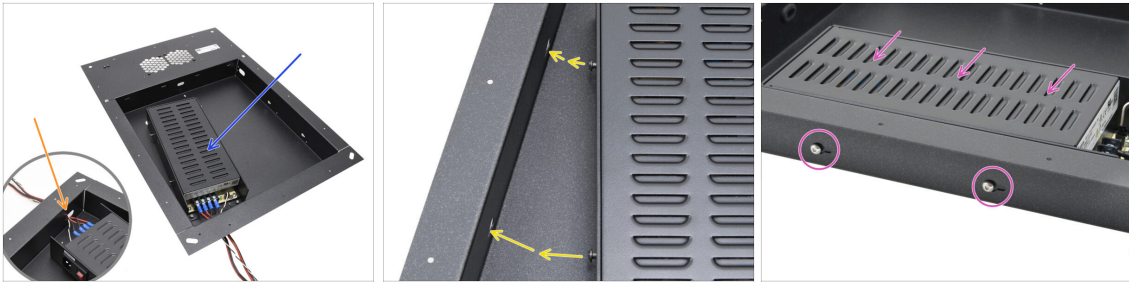
- Positionnez le panneau arrière comme indiqué sur la première image. Utilisez les deux trous ovales comme référence.
- Insert the sealing plug into the center hole.
 - The sealing plug is not symmetrical.** Insert the side with the smaller diameter facing downward.
- Insert one small grommet to the left circle hole.
- Insert one small grommet into the oval hole.

ÉTAPE 19 Installation des œillets : côtés



- Concentrez-vous sur le côté supérieur gauche du panneau arrière et localisez deux trous ovales.
- Insert one large grommet into the oval hole closest to the corner.
- Move to the right top side of the back panel and insert one large grommet to the oval hole.

ÉTAPE 20 Alignement du bloc d'alimentation



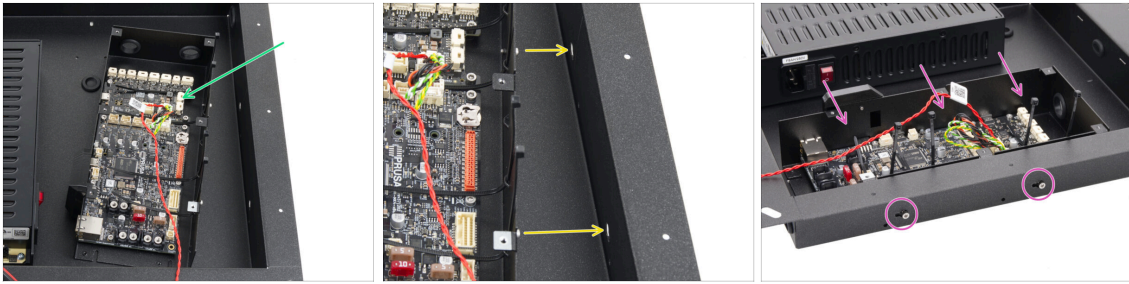
- ◆ Insérez soigneusement le bloc d'alimentation dans la poche du panneau arrière.
- ◆ Push the cable bundle through the opening on the bottom of the panel.
- ◆ Align the screws on the PSU to the holes on the left side of the back panel.
- ◆ Slide the PSU so that the screws go through the holes.

ÉTAPE 21 Montage du bloc d'alimentation



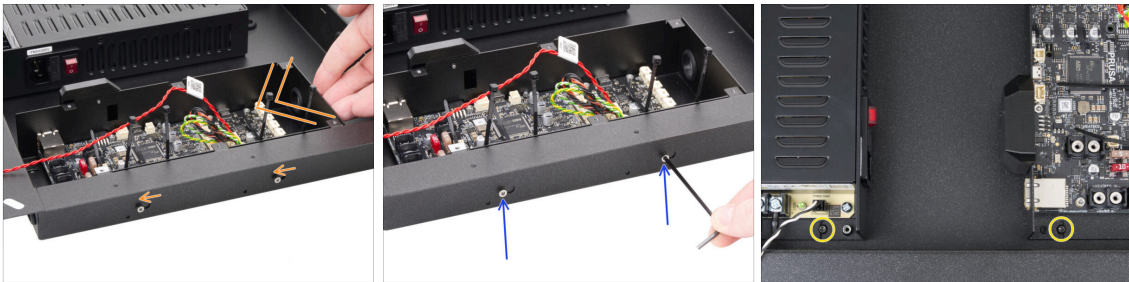
- ◆ Gently slide the PSU so that the position of the screws moves to the end position of the keyhole-shaped holes.
- ◆ Maintain the PSU position and fully tighten both screws.

ÉTAPE 22 Aligning the xBuddy box assembly



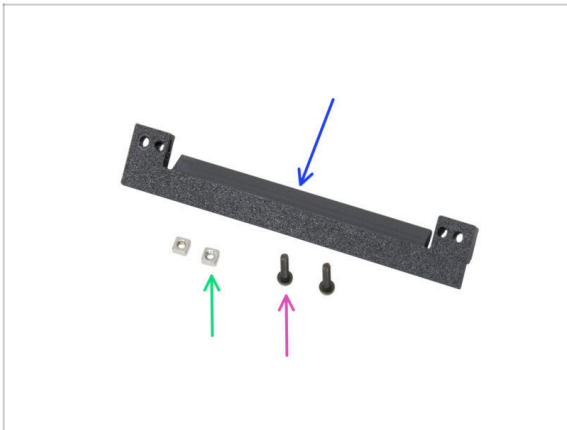
- 🟢 Carefully insert the xBuddy box assembly into the rear panel pocket.
- 🟡 Align the screws on the xBuddy box to the holes on the right side of the back panel.
- 🟣 Slide the xBuddy box so that the screws go through the holes.

ÉTAPE 23 Mounting the xBuddy box



- 🟠 Gently slide the xBuddy box assembly so that the position of the screws moves to the end position of the keyhole-shaped holes.
- 🔵 Maintain the xBuddy box position and fully tighten both screws.
- 🟡 Fix the PSU and xBuddy box assembly to the back panel by tightening the two M3x4rT screws.

ÉTAPE 24 PSU-cable-cover : préparation des pièces : préparation des pièces



- For the following steps, please prepare:
- PSU-cable-cover (1x) found in the Printed parts package
- Écrou M3nS (2x)
- Vis M3x10rT (2x)

ÉTAPE 25 Préparation du PSU-cable-cover



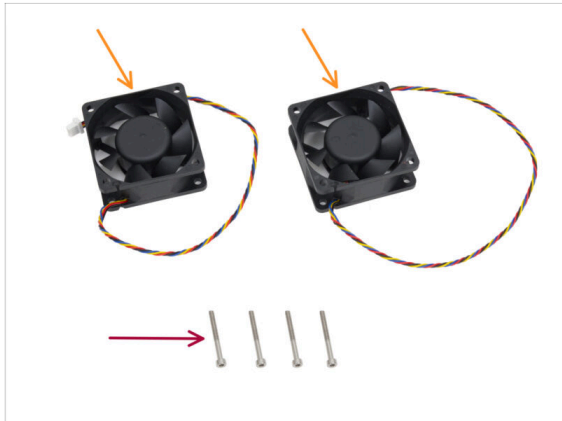
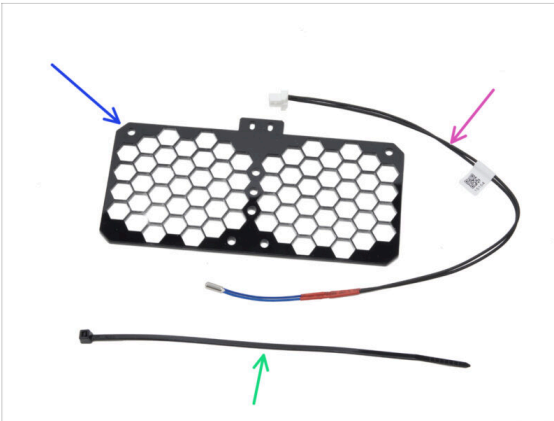
- Insert one M3nS nut into the hole on each end of the PSU-cable-cover.
- Ensure the holes are aligned.

ÉTAPE 26 Installation du PSU-cable-cover



- Attach the PSU-cable-cover inbetween the PSU and the xBuddy box.
- Secure the cover with two M3x10rT screws in the outermost holes of the part.

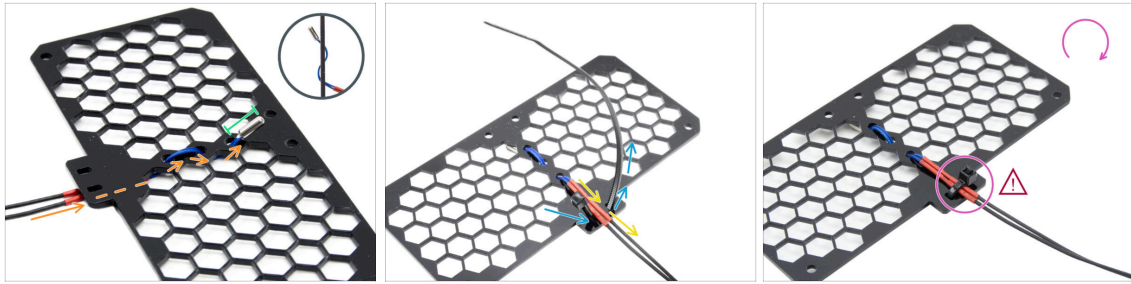
ÉTAPE 27 Chamber fans: parts preparation



■ For the following steps, please prepare:

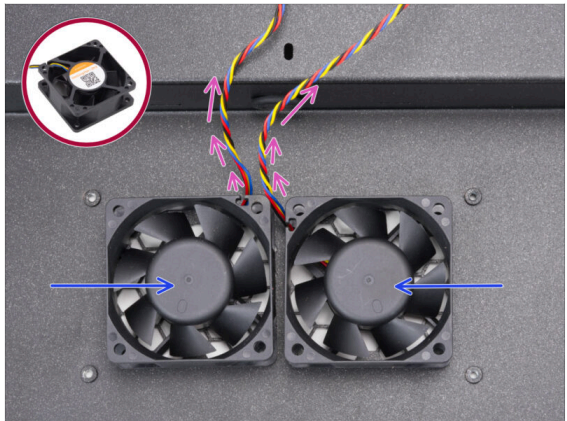
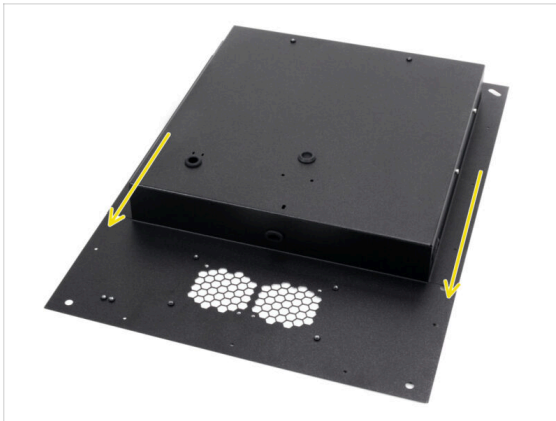
- Fan grid (1x) *found in the Electronics & Chamber parts package*
- Chamber thermistor 260 mm (1x) *found in the Electronics & Chamber parts package*
- Collier de serrage (1x)
- Cooling fan (2x) *found in the Electronics & Chamber parts package*
- Vis M3x30 (4x)

ÉTAPE 28 Assembling the fan grid



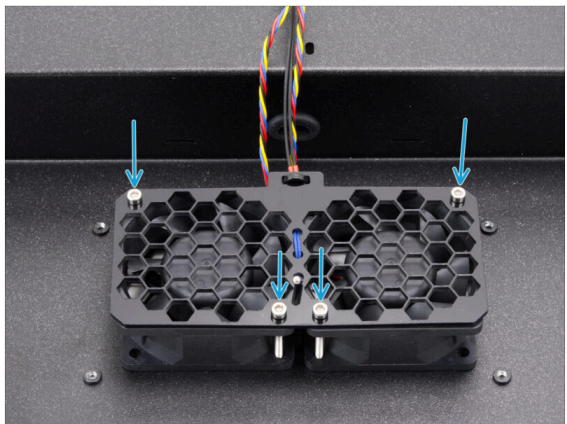
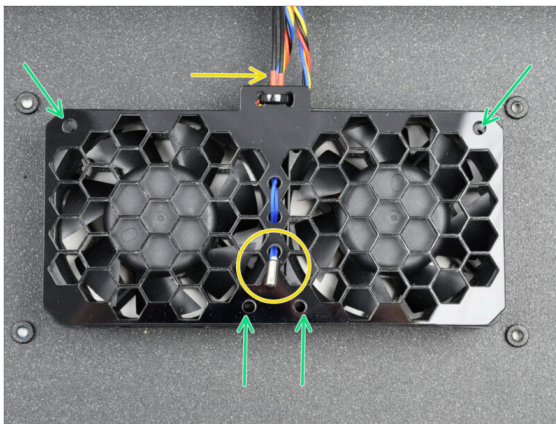
- 🟠 Guide the thermistor cable under the grid. Thread it in the direction shown in the picture.
- 📌 The grid has both sides the same.
- 🟢 Leave the whole thermistor part sticking out.
- 🟡 Turn the grid over and push the zip tie through the pair of holes on the grid's protrusion.
- 🟡 Route the thermistor cable in between the zip tie parts.
- 🟣 Carefully secure the thermistor cable by tightening the zip tie. **Do not overtighten it, it may damage the cable.**
- ⚠️ **Make sure that the header of the zip tie is facing the same way as in the picture. It must be on the same side as where the cable starts.**
- ⬛ Put the assembly aside for a while.

ÉTAPE 29 Fixation des ventilateurs



- ✦ Place and orient the back panel according to the picture. The grid cutouts must be facing you.
- ✦ Attach both fans to the grid in the back panel.
 - ⚠ **Le côté du ventilateur sans l'autocollant doit être orienté vers le haut.**
 - ✦ Orient the fans so that the cables run from the corners in the centre.
 - ⬛ Let the cables hang freely for now, ensuring they are not pinched during handling.

ÉTAPE 30 Covering the cooling fans



- ✦ Place the fan grid assembly on the cooling fans.
 - ⚠ **Make sure that the thermistor is pointing up and its cable runs under the grid.**
- ✦ Alignez les trous des ventilateurs, de la grille de ventilation et du panneau arrière.
- ✦ Secure the fan assembly to the back panel with four M3x30 screws.
 - ⚠ **Do not overtighten the screws to avoid damaging the grid.**

ÉTAPE 31 Rear profiles: parts preparation



For the following steps, please prepare:

- Rear profile (2x) found in the Metal parts 1/3 package

i Prenez les deux plus longs.

Notez que les deux autres plus longs diffèrent par des découpes.

- Rivet en nylon (11x)
- Vis M3x4rT (4x)
- 2.9x6.5sT self-tapping screw (1x)

ÉTAPE 32 Installing the rear profiles



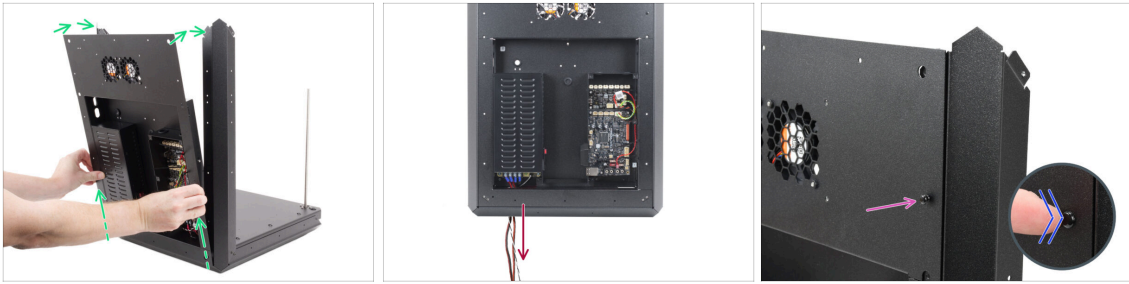
- Take the bottom assembly and turn it so the rear side (with one motor in the center) faces you.



Focus on the right rear corner—the side with the longest oval opening in the bottom panel.

- Fixez le profilé arrière au coin droit, à l'aide de l'**extrémité sans brides**.
- Align the hole on the rear side and secure it with the M3x4rT screw.
- Secure the corner on the other side with a second M3x4rT screw - each corner will be secured with two M3x4rT screws.
- Proceed the same with the second rear profile on the rear left corner.

ÉTAPE 33 Mounting the back panel



- 🟢 Slightly lift the back assembly and gently place it on the base assembly and rear profiles.
- 🔴 Pull the power cables through the opening in the bottom assembly.
- 🟡 Insérez un rivet en nylon à travers le panneau arrière et le profilé arrière sur le côté supérieur droit.
- 🟠 Push the rivet head with your finger until it is fully seated.

ÉTAPE 34 Securing the Back panel



- 🟡 Install all eleven nylon rivets around the back panel assembly to secure it.
- 🟠 Install the 2.9x6.5 self-tapping screw into the bottom left opening on the back panel.

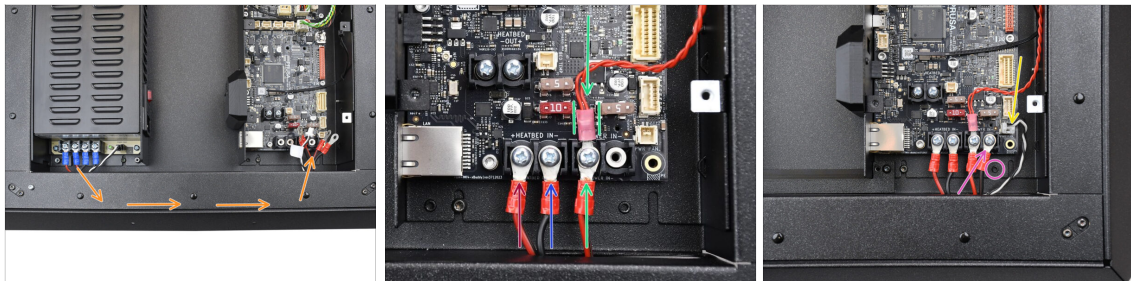
🔧 Ne serrez pas trop pour éviter d'arracher le filetage auto-taraudé.

ÉTAPE 35 Power Terminal Screws Preparation



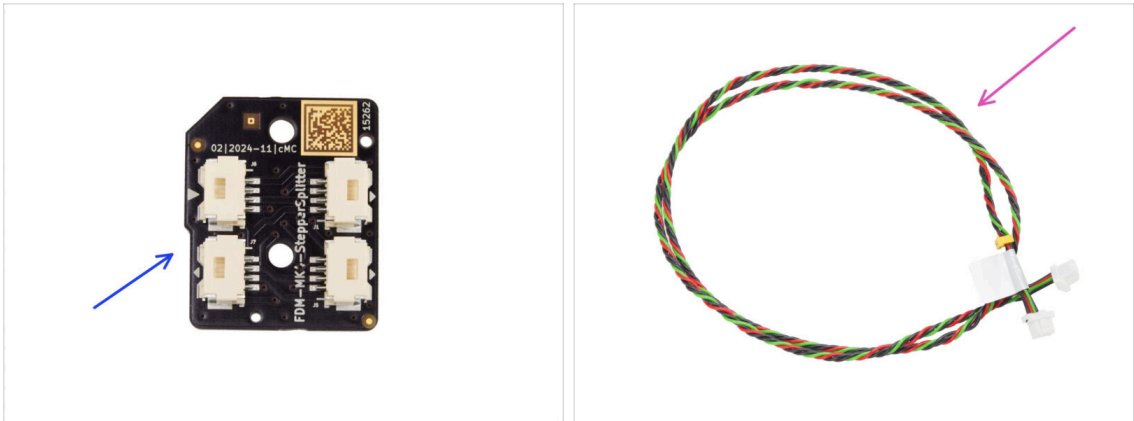
- For the following steps, prepare:
- 6-32 Power Terminal Screw (4x)

ÉTAPE 36 Connecting the power cables



- Guide the power cable bundle through the rear panel, towards the xBuddy board.
- Take one red cable from the PSU and connect it to the leftmost terminal on the xBuddy board using the 6-32 terminal screw. Tighten it firmly but do not overtighten.
- Fixez le câble d'alimentation noir à la deuxième borne. Serrez-le fermement, mais évitez de trop serrer.
- Take the second red cable from the PSU and stack it with the red cable from the extension board.
Secure **both cables together** in the third terminal using the terminal screw.
-  Carefully guide the xBuddy extension cable between the fuses, ensuring it does not press against any of them.
- Attach the last black PSU cable to the xBuddy, **making sure it does not obstruct the threaded hole underneath.**
- Connect the power panic cable to the bottom right connector on the xBuddy board.

ÉTAPE 37 Stepper splitter: parts preparation



● For the following steps, please prepare:

- Stepper splitter (1x) found in the *Electronics & Chamber parts package*
- Câble de la carte splitter des moteurs pas-à-pas (1x) qui se trouve dans le paquet *Électronique & Visserie*

ÉTAPE 38 Guiding the Stepper splitter cable



● Very carefully turn the assembly on its back (back panel).

● **It is recommended to support the rear of the assembly** with a soft, raised pad to prevent it from resting on the protruding Wi-Fi module.

① Conseil : utilisez le rembourrage en mousse du paquet des pièces en tôle ou un carton vide.

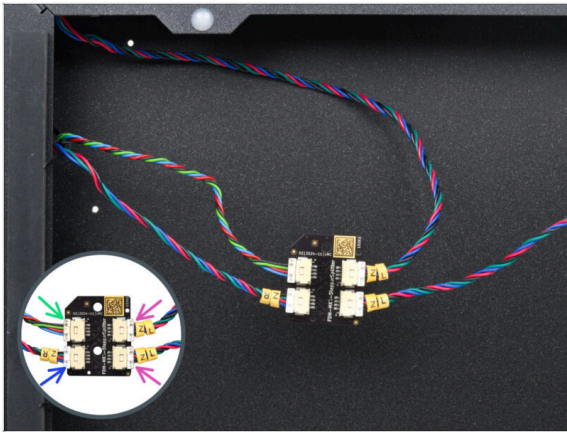
● Guide the Stepper splitter cable through the three zip ties on the left side.

● For now, leave the side with the label hanging freely outside.

● Guide the Z-axis motor R cable through the three zip ties on the left side.

⚠ **Do not tighten the zip ties at this moment.**

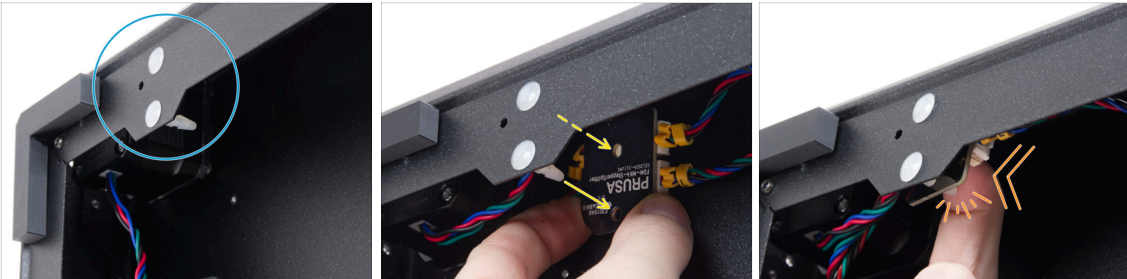
ÉTAPE 39 Connecting the Stepper splitter



● Connect the Z motor cables to the stepper splitter:

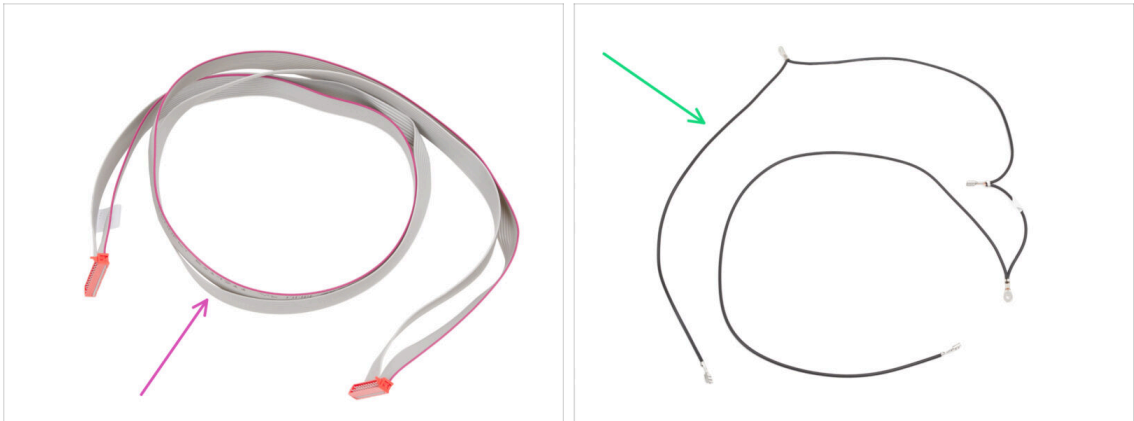
- Câble de la carte splitter des moteurs pas-à-pas
- Moteur R de l'axe Z
- Moteur L de l'axe Z
- Moteur L de l'axe Z

ÉTAPE 40 Mounting the Stepper Splitter



- Locate two spacer pins in the bottom frame.
- From the inside of the frame, prepare the Stepper splitter and attach its holes opposite the pins.
 - Vérifiez la bonne orientation de la pièce grâce au logo sur la carte. **Le logo est à l'envers.**
- Push the aligned Stepper Splitter onto the pins until you feel a click - this secures the Stepper Splitter. Push in the center of the board.
- ❗ It is necessary to apply a significant pressure to seat the part in. Yet, be very careful not to damage the components.

ÉTAPE 41 LCD cable: parts preparation



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

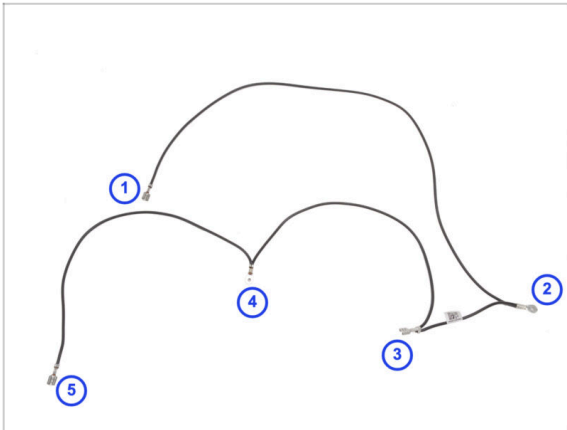
- xLCD cable (1x) found in the *Electronics & Fasteners* package
- Câble FE principal (1x) qui se trouve dans le paquet *Électronique & Visserie*

ÉTAPE 42 Guiding the LCD cable



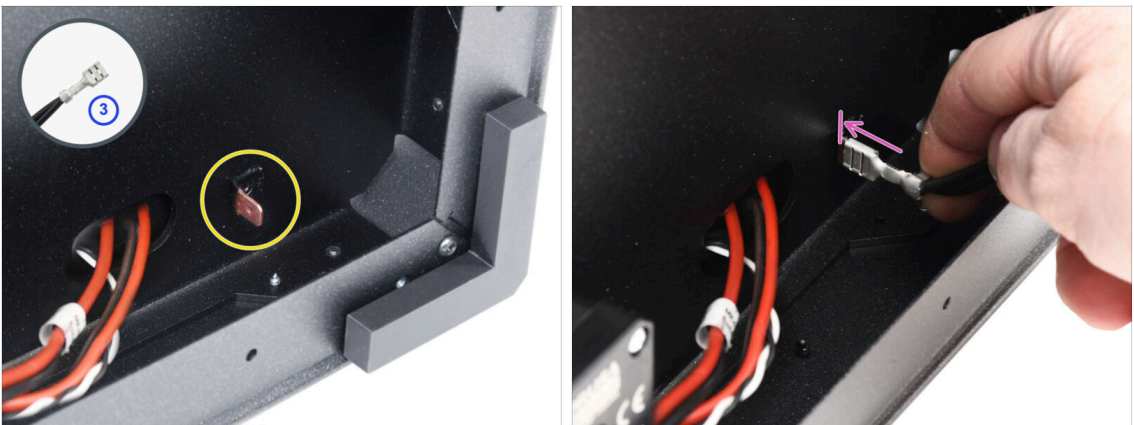
- Guide the Stepper splitter cable through the oval hole to the electronics.
- Take the end of the xLCD cable with the QR code label.
- Poussez quelques centimètres du câble du xLCD (l'extrémité avec l'étiquette QR code) à travers le trou ovale du panneau inférieur.
 - ① The cable must be slightly folded to pass through the hole.
- Guide the xLCD cable through the zip ties on the left side of the frame.
- Guide the xLCD cable through the rectangular opening in the front profile. Keep protruding approximately 6 cm (2.36 in).
- Leave the cable hang freely for now.

ÉTAPE 43 Main FE cable INFO



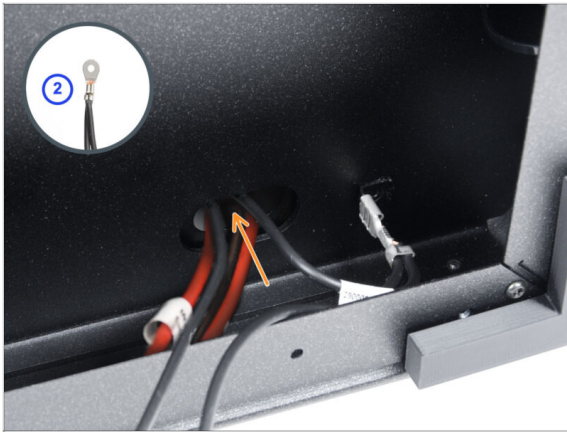
- Lay out the Main FE cable as shown in the picture, ensuring each connector is positioned accordingly.
- The connectors are numbered in the picture for reference only. This numbering will be used in the following steps to help with proper connections.
- ⓘ Remarque : nous indiquerons toujours quel connecteur utiliser dans les étapes suivantes. Il est toutefois judicieux de garder à l'esprit cet aperçu pour faciliter le montage.

ÉTAPE 44 Connecting the FE cable (no 3.)



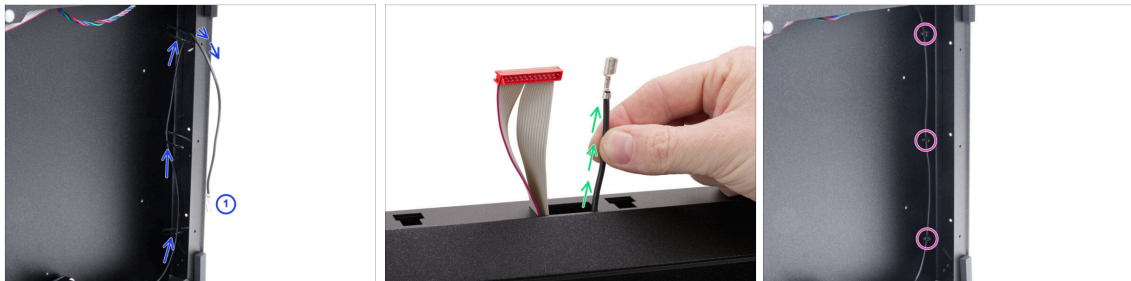
- Prepare the connector number 3.
- ⓘ That's the female faston connector in the middle of the cable.
- Localisez le connecteur Faston mâle dans le coin inférieur droit.
- Slide the FE cable connector completely onto the Faston connector.

ÉTAPE 45 Guiding the FE cable (no. 2)



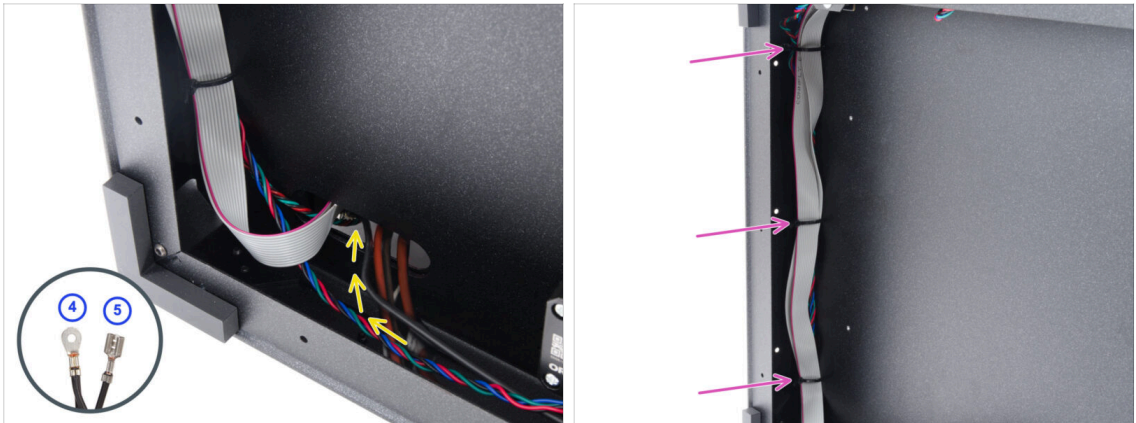
- Take the FE cable connector number 2.
- ⓘ The round connector nearby.
- Insérez le connecteur sans serrer dans le trou du panneau inférieur.

ÉTAPE 46 Guiding the FE cable (no. 1)



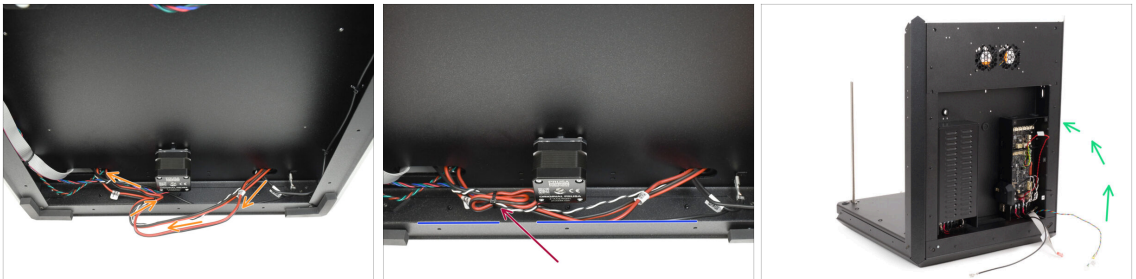
- Take the connector number 1 and guide it through the zip ties on the right side of the frame.
- ⓘ That is the long part with just one faston connector at the end.
- Poussez le connecteur à travers l'ouverture rectangulaire du profilé avant. Laissez dépasser d'environ 6 cm (2,36 in).
- Leave the cable hang freely for now.
- Tighten all three zip ties. Cut off the excess.

ÉTAPE 47 Guiding the FE cable (no. 4 and 5)



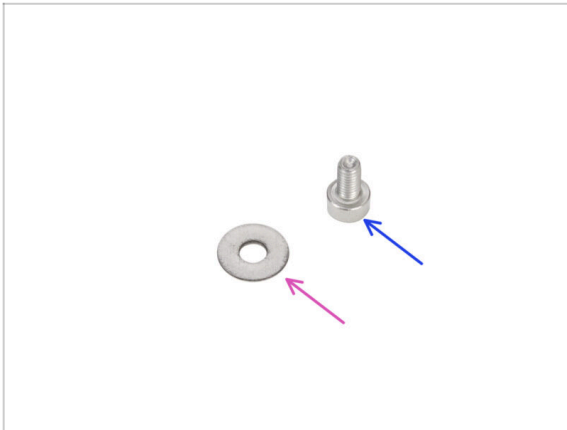
- ◆ Take the FE cable connectors number 4 and 5.
- ◆ Push both connectors through the leftmost hole in the bottom. Leave them free for now.
- ◆ Serrez les trois colliers de serrage sur le côté gauche du cadre. Coupez l'excédent.
 - ◆ There's no need to fully tighten the zip ties. However, the cables must still be easy to move for any necessary length adjustment during connection.

ÉTAPE 48 Nettoyage du faisceau de câbles



- ◆ On the bottom, loop the power cable bundle around the Z-motor cable to shorten it.
- ◆ Secure the loop to the Z-motor cable with a zip-tie.
 - ◆ Assurez-vous que les câbles sont maintenus à une distance raisonnable du profilé métallique, tout en évitant qu'ils ne soient trop serrés.
- ⚠ This prevents cables from hanging below the metal profiles, where they could get caught and damaged. High current flows through these cables, so damaging them might cause a serious harm to the printer and its surroundings!
- ◆ Carefully lift the printer upright.

ÉTAPE 49 FE cable - xBuddy: parts preparation



● For the following steps, please prepare:

● Rondelle M3w (1x)

● Vis M3x6 (1x)

ÉTAPE 50 Connecting the FE cable: xBuddy



● Put the printer back on its feet. And focus on the rear side.

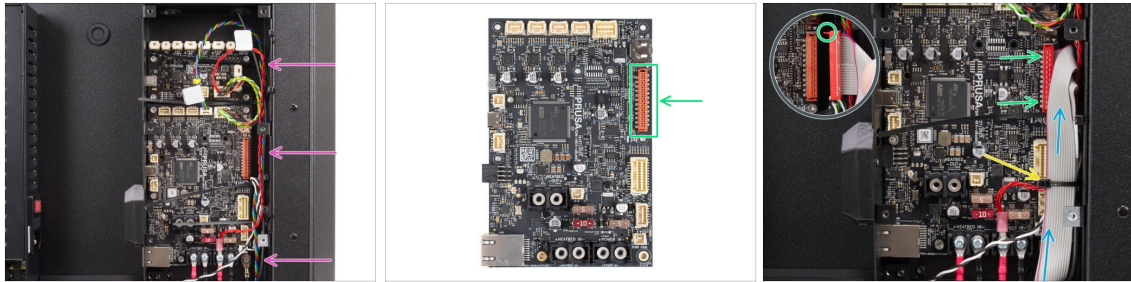
● Take the connector number 4 and connect it to the xBuddy using the M3x6 screw and M3w washer.

⚠ La rondelle M3 doit être entre la tête de vis et le connecteur.

● Guide the FE cable (number 5) alongside the xBuddy box and pass it through the right-side holes out of the box.

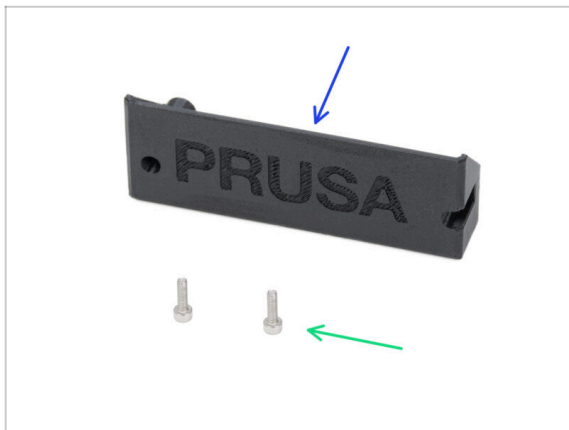
● Guide the Stepper splitter cable alongside the xBuddy box and connect it to the second slot from the right in the top row on the xBuddy board (labeled ZR).

ÉTAPE 51 Plugging the xLCD cable



- ◆ Arrange the cables as shown - route all cables along the right side of the xBuddy box.
- ⚠ Make sure all the cables guide through the zip ties in the xBuddy box, not under them.
- ◆ Placez le câble du xLCD sur les autres câbles et acheminez-le vers le haut.
- ◆ Connect the xLCD to the slot on the right side of the xBuddy. **Note the safety latch on the xLCD cable connector. The latch must fit into the upper side of the connector.**
- ◆ Secure the cable arrangement by tightening the bottom zip tie.
- ⚠ Do not overtighten the zip tie, as it may damage the wires.
- ◆ Carefully cut off the excess length of the zip tie. **Avoid cutting cables!**

ÉTAPE 52 PSU-cover : préparation des pièces : préparation des pièces



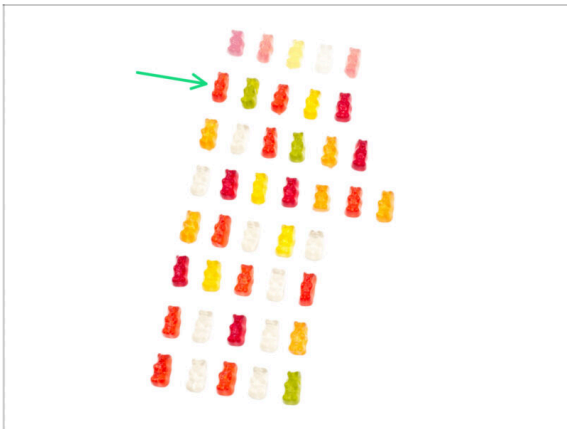
- ◆ For the following steps, please prepare:
- ◆ CORE-One-PSU-cover (1x) found in the Printed parts package
- ◆ Vis M3x10 (2x)

ÉTAPE 53 Connecting the FE cable: PSU



- ➊ Remove the screw from the PSU board. **Do not discard it!**
- ➋ Ensure the FE connector (number 2) is routed into the PSU compartment.
- ➌ Insérez la vis retirée dans le connecteur du câble FE et revissez-la sur la carte d'alimentation.
- ➍ Note the correct orientation of the connector.
- ➎ Rotate the connector counter-clockwise, positioning it so it doesn't block the threaded hole underneath.
- ➏ Attach the PSU-cover over the PSU connectors and secure with two M3x10 screws.

ÉTAPE 54 C'est l'heure des Haribo



- ➐ Time to recharge for the next chapter!
- ➑ Eat the second row.
- ⚠ **Pas de triche — mangez uniquement le nombre indiqué !**

ÉTAPE 55 Fini

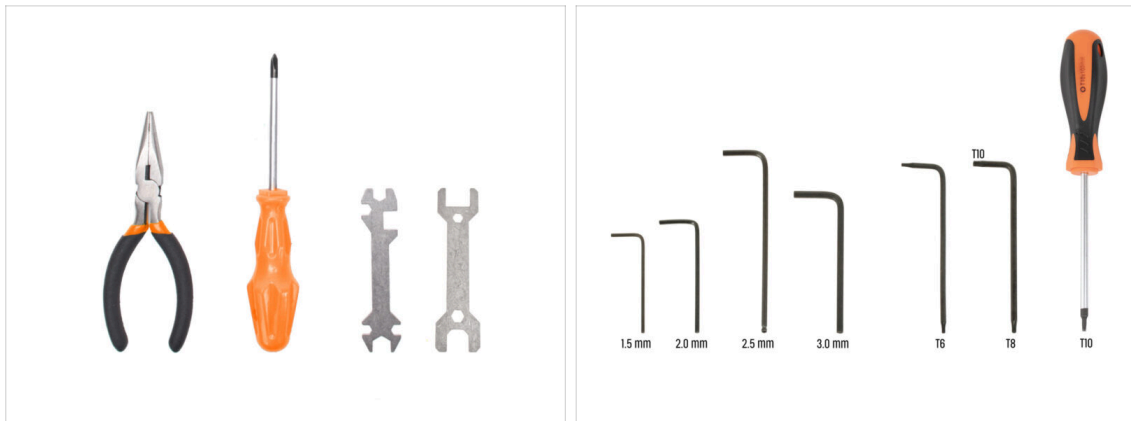


- Congratulations! The back assembly is installed.
- Now continue to the next chapter.

4. Assemblage du plateau chauffant



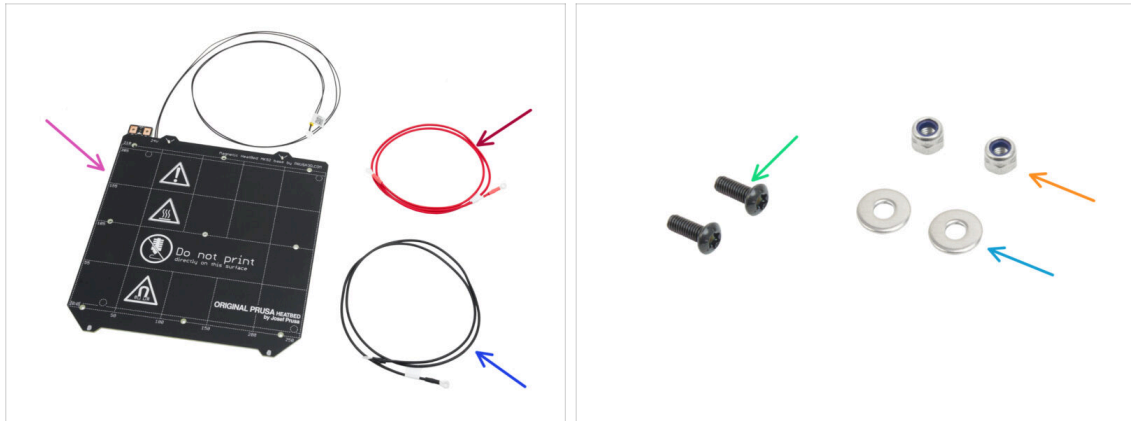
ÉTAPE 1 Tools necessary for this chapter



● **For this chapter, please prepare:**

- Pince à bec fin
- Clé universelle
- Clé 13-16
- Tournevis Philips (PH2)
- Clé Allen de 2,5 mm
- Clé Allen de 2,0 mm
- T10 torx key / T10 torx screwdriver

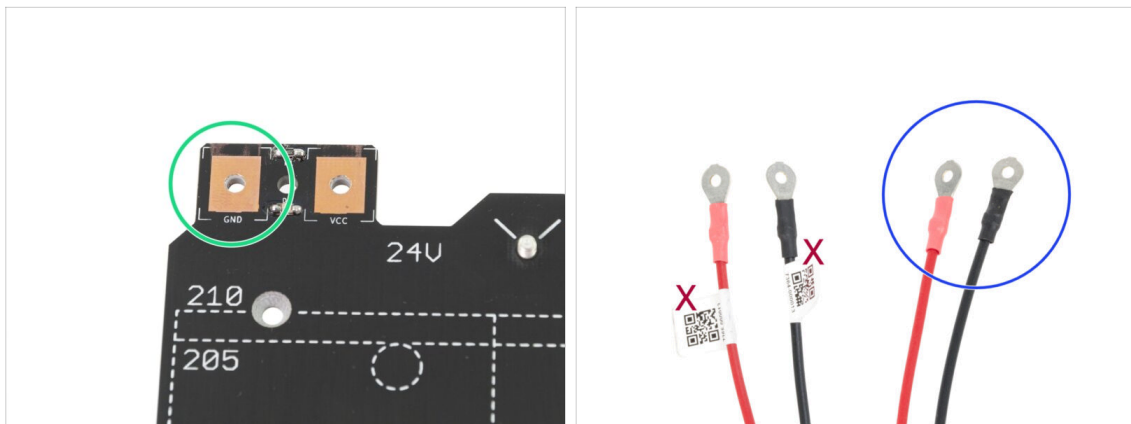
ÉTAPE 2 Plateau chauffant : préparation des pièces



For the following step please prepare:

- Heatbed MK52 24V (1x)
- Heatbed cable red (1x) *found in the Electronics & Fasteners package*
- Heatbed cable black (1x) *found in the Electronics & Fasteners package*
- Vis M3x10rT (2x)
- Écrou M3nN (2x)
- Rondelles M3w (2x)

ÉTAPE 3 Heatbed Cable Assembly 1

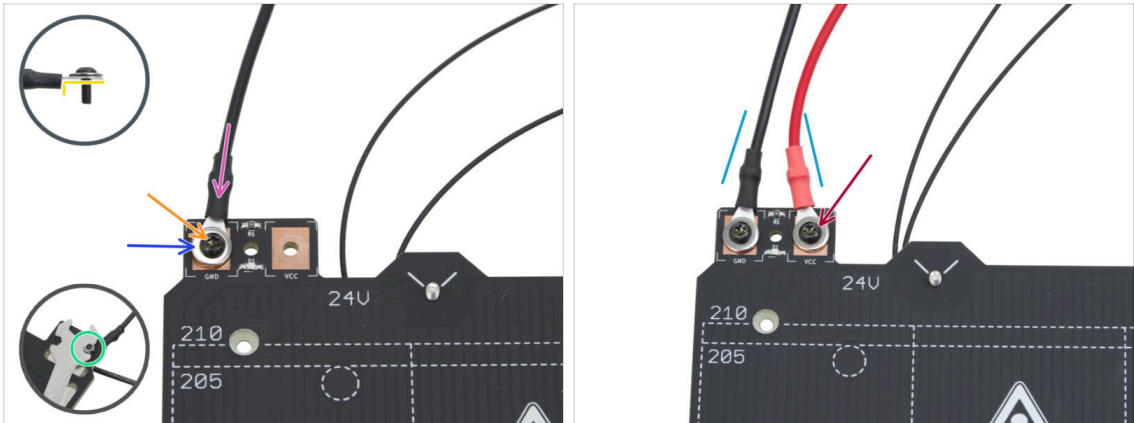


- Follow the polarity markings on the heatbed:

The pad labeled **GND** should be coupled with the **BLACK WIRE**.

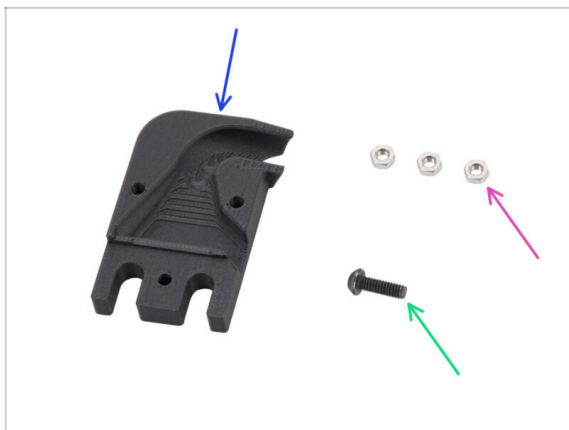
- Take both power cables. Note the labels on each. Use the unlabeled ends for the heatbed connection.

ÉTAPE 4 Heatbed Cable Assembly 2



- Place the black cable onto the "GND" pad.
- Orient the lug connector with the thicker part facing downward.
- Place the M3w washer on top of the connector.
- Insert the M3x10rT screw through all the components.
- Attach the M3nN nut onto the M3x10rT screw from below and tighten it slightly.
- Using the same technique, attach the red cable to the "VCC" pad.
- Guide the heatbed cables slightly inward in a "V" shape, **then fully tighten the nuts from below.**

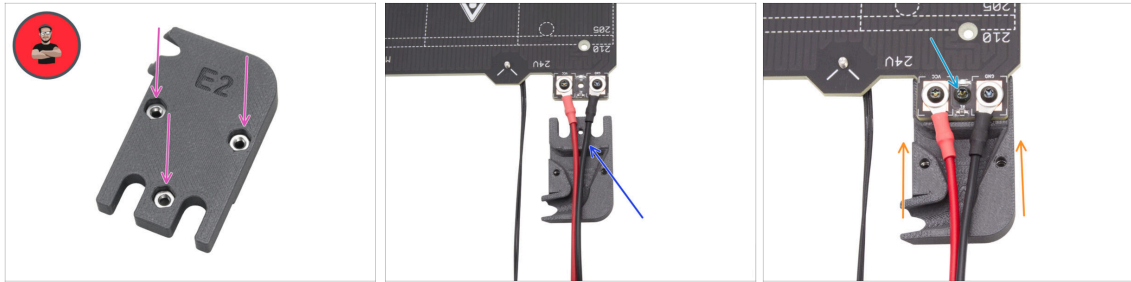
ÉTAPE 5 Bed-cable-cover-bottom : préparation des pièces



● For the following steps, please prepare:

- Bed-cable-cover-bottom (1x)
- Écrou M3n (3x)
- Vis M3x10rT (1x)

ÉTAPE 6 Attaching the cable cover



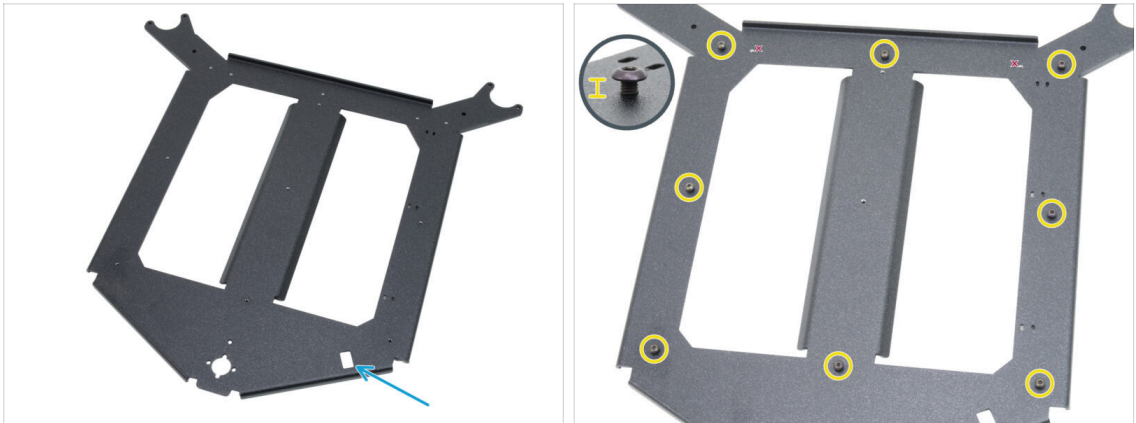
- ✿ Insert three M3n nuts into the Bed-cable-cover-bottom part.
- ❗ Pro tip: Use the screw-pulling technique.
- ⬛ Make sure the nuts are fully inserted and held in place.
- ✿ Insert the Bed-cable-cover-bottom under the heatbed cables. Note the orientation of the part.
- ✿ Slide the Bed-cable-cover-bottom under the cable joint of the heatbed.
- ✿ Line up the hole in the heatbed with the cable cover and secure it with the M3x10rT screw.

ÉTAPE 7 Heatbed carriage: parts preparation



- ⬛ **For the following steps, please prepare:**
- ✿ Heatbed carriage (1x) *found in the Metal parts 1/3 package*
- ✿ Joint de dilatation (8x)
- ✿ vis M3x4r (8x)
- 🔧 The Fasteners package includes both M3x4r and M3x4rT screws. Make sure you have the correct type prepared.

ÉTAPE 8 Preparing the heatbed carriage



- Place the heatbed carriage in front of you in the same orientation as in the picture.
- Make sure the **rectangular cutout is facing you on the right side**.
- Insert eight M3x4r screws around the heatbed carriage.
- ⚠ **Do not tighten completely, leave a gap of approximately 3 mm (0.12 in).**

ÉTAPE 9 Installing the expansion joints



- Attach one expansion joint to any M3x4 screw in the same orientation as shown.
- Note the U-shaped "groove" for the screw inside the expansion joint - point it towards the screw.
- Slide the expansion joint onto the screw.
- Grasp the expansion joint in the rectangular cutout of the universal wrench.
- Position the key with the expansion joint in its correct orientation as shown in the illustration.
- **Maintain the expansion joint in the correct position** and firmly tighten the M3x4r screw through the expansion joint with a 2.0 mm Allen key.
- ⚠ **Repeat this procedure for all other expansion joints. Follow their correct position!**

ÉTAPE 10 RGB LED strip: parts preparation



● For the following steps, please prepare:

● RGB LED strip 166 mm (1x) *found in the Electronics & Fasteners package*

⚠ Avoid direct contact with the LED and resistors on the LED strip.

● LED status cover (1x) *found in the Electronics & Chamber parts package*

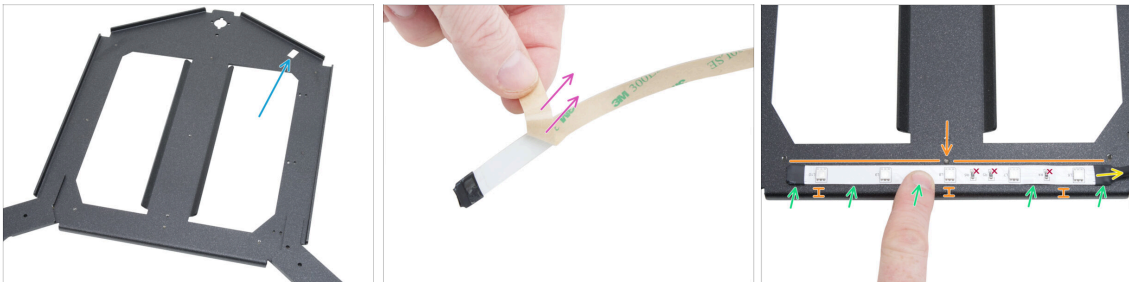
● LED strip diffuser (1x) *found in the CoreXY parts + Hinges set package*

● Spacer 3.2/6x5 mm (2x) *found in the Electronics & Fasteners package*

● Vis M3x10rT (2x)

● Collier de serrage (3x)

ÉTAPE 11 Installing the LED strip



● Place the heatbed carriage in front of you in the same orientation as in the picture.

● Make sure the **rectangular cutout** is far from you and **on the right side**.

● Carefully peel off the protective (paper) layer from the RGB LED strip.

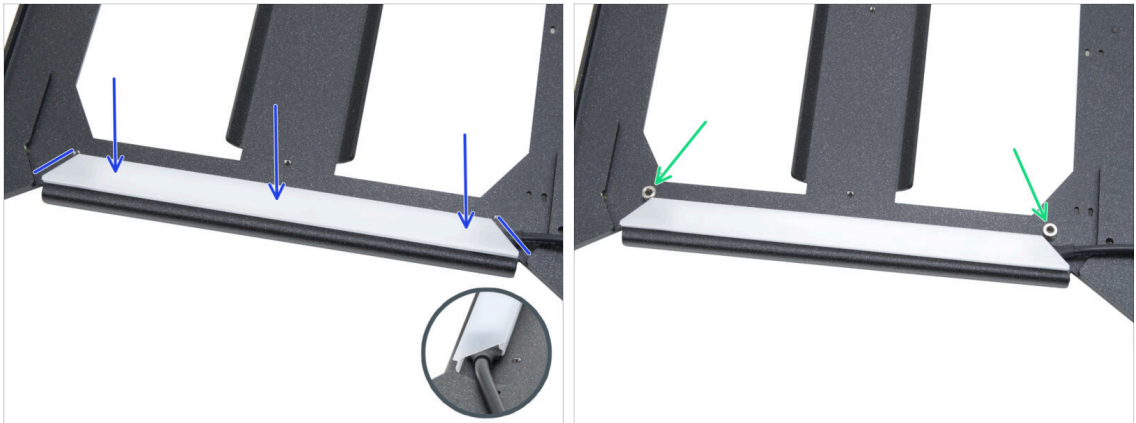
⚠ After removing the protective layer, the RGB LED strip is adhesive.

● Stick the RGB LED strip evenly to the front of the heatbed carriage, approximately 3 mm (0.12 in) from the folded edge.
Align the middle LED with the screw on the carriage.

● The RGB LED strip **cable must point to the right**.

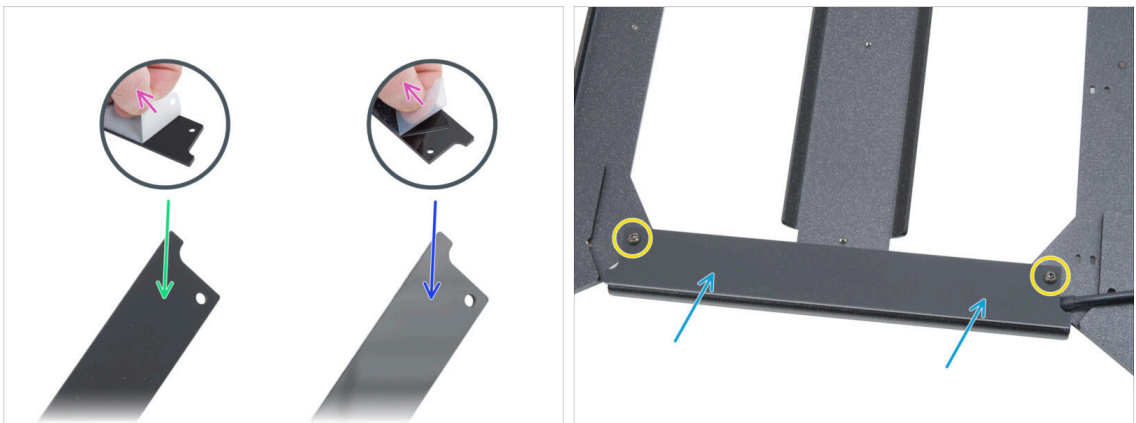
● After sticking, press lightly on the blank areas of the strip to ensure adhesion. **Do not touch LEDs and resistors!**

ÉTAPE 12 Attaching the LED strip diffuser



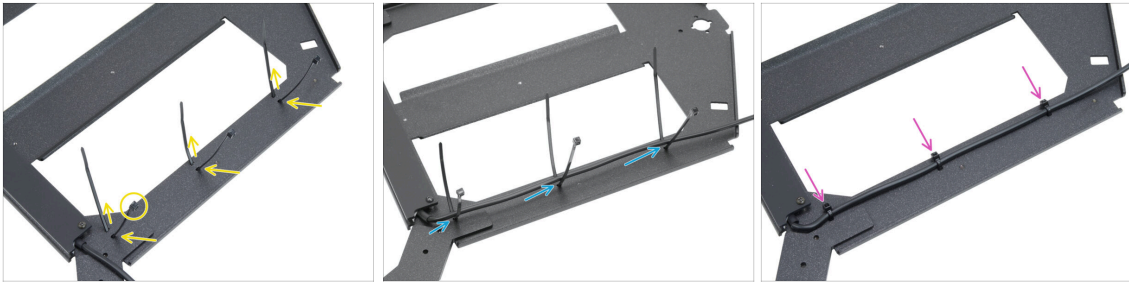
- Place the LED strip diffuser over the RGB LED strip. Note the orientation of the part - according to the beveled edges.
- Place two spacers 3.2/6x5 mm on the holes in the edges of the LED assembly.

ÉTAPE 13 Covering the RGB LED strip



- From both sides of the LED status cover, peel off the protective layers.
- Note that one side of the cover is matte.
- The other side of the cover is glossy.
- Attach the LED strip cover to the assembly, **matte side up**.
- Secure all parts together by inserting and tightening two M3x10rT screws. **Do not overtighten the screws**, as it may crack the cover.

ÉTAPE 14 Guiding the RGB LED strip cable



- ✦ Thread the three zip ties along the **RIGHT SIDE** of the heatbed carriage. Make sure the zip tie heads are facing outward.
- ✦ Guide the RGB LED strip cable through all zip ties.
- ✦ Then tighten all three zip ties. Cut off excess zip ties.

ÉTAPE 15 Préparation de la lubrification des roulements



- ✦ **For the following steps, prepare:**
 - ✦ LM8UU Bearing (2x) *removed from the MK4S printer*
 - ✦ Prusa lubricant applicator 8mm (1x)
 - ✦ Lubrifiant Prusa (1x)
 - ✦ Several paper towels to wipe oil and grease from the bearing surface.
- ⚠ **Use the lubricant wisely, less is better! Using too much of the lubricant may cause issues.**

ÉTAPE 16 Lubrification des roulements

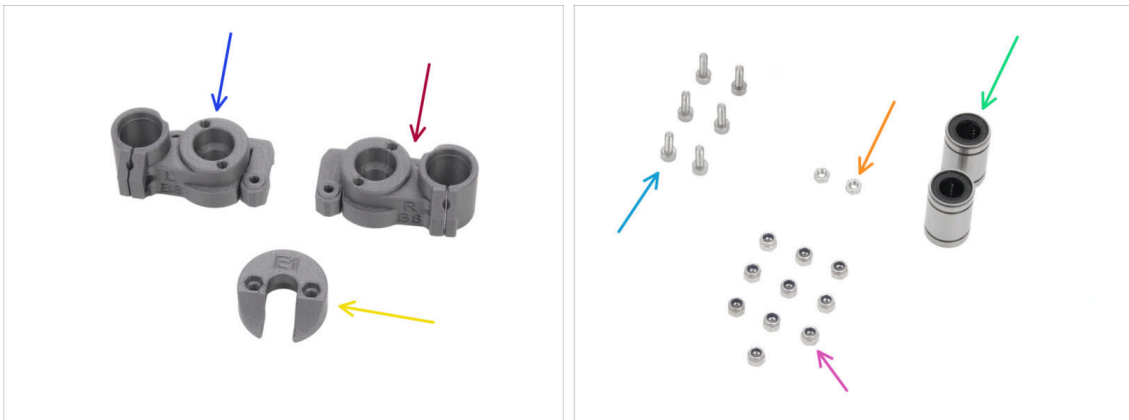


 Use any piece of fabric as a pad to protect your working surface from grease.

 **Make sure the bearing is clean inside.**

-  Wipe the preservative oil off the bearing surface with a paper towel.
-  It is necessary to lubricate all 4 rows of balls inside the bearing.
-  Screw the tube into the applicator.
-  Carefully slide the entire bearing onto the applicator.

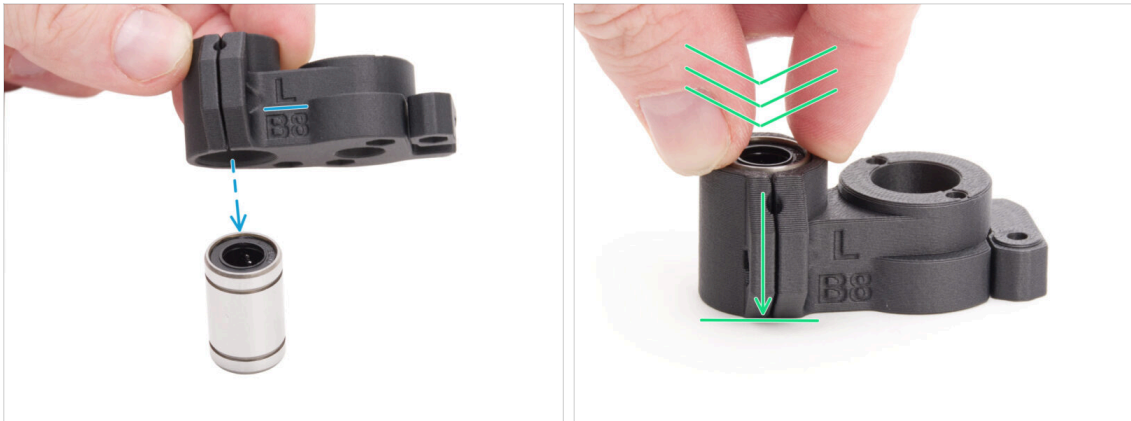
ÉTAPE 17 Bed mounts: parts preparation



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

-  CORE-One-bed-mount-left (1x) *found in the Printed parts package*
-  CORE-One-bed-mount-right (1x) *found in the Printed parts package*
-  CORE-One-bed-spacer-rear (1x) *found in the Printed parts package*
-  LM8UU bearing (2x) *freshly lubricated*
-  Vis M3x10 (6x)
-  Écrou M3n (2x)
-  Écrou M3nN (10x)

ÉTAPE 18 Assembling the bed mounts



- Place the CORE-One-bed-mount-left onto the bearing, ensuring the correct orientation.
- Press the part onto the bearing, applying more force to ensure it moves all the way down. You will feel a click, indicating that the plastic part and bearing are correctly seated.
- ⚠ The bearing must be fully enclosed within the part and must not protrude.
- Follow the same procedure with CORE-One-bed-mount-right.

ÉTAPE 19 Securing the bed mounts



- Insert one M3n nut into the CORE-One-bed-mount-left.
- Position the CORE-One-bed-mount-left according to the picture:
 - Position the bearing so that two ball rows face the bottom of the part, not just one.
- Keep the bearing in the position and secure it by inserting and tightening one M3x10 screw.
- ⚠ Ensure that the top surface of the bearing is flush with the top surface of the plastic part.
- Follow the same procedure with CORE-One-bed-mount-right.

ÉTAPE 20 Bed mounts: inserting the nuts



- Insert four M3nN nuts into both bed mounts.
- Make sure they are inserted completely inside.

ÉTAPE 21 Assemblage du CORE-One-bed-spacer-rear



- Insert two M3nN nuts into the CORE-One-bed-spacer-rear.
- Insert the nuts down as much as possible.

ÉTAPE 22 Installation du bed-mount-right



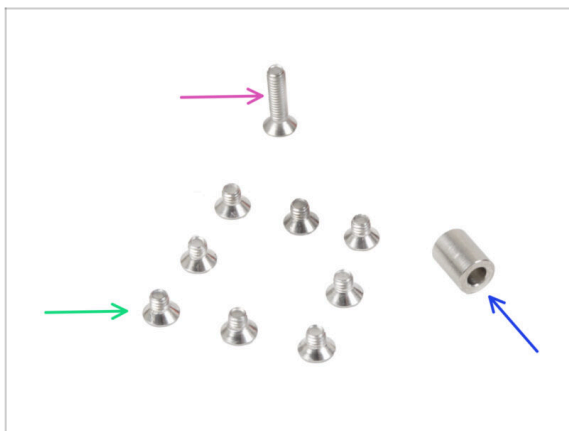
- Turn the heatbed carriage piece with the "forks" facing you and with the **expansion joints facing up**.
- Take the CORE-One-bed-mount-**right** part and slide it **under the right fork** - with the bearing on the right.
- Fix it with two M3x10 screws.

ÉTAPE 23 Installation du bed-mount-left



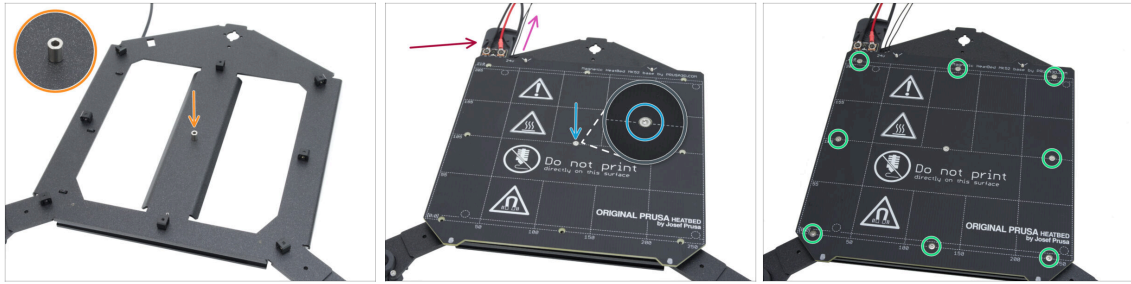
- Take the One-bed-mount-**left** part and slide it **under** the **left** fork - with the bearing on the left.
- Fix it with two M3x10 screws.

ÉTAPE 24 Mounting the heatbed: parts preparation



- **For the following steps, please prepare:**
- Vis M3x12bT (1x)
 - ⓘ The screw may also be labeled M3x12cT.
- Spacer 6x3.1x8 mm (1x) *from the disassembled printer*
- Vis M3x4bT (8x)
 - ⓘ The screw may also be labeled M3x4cT.

ÉTAPE 25 Montage du plateau chauffant



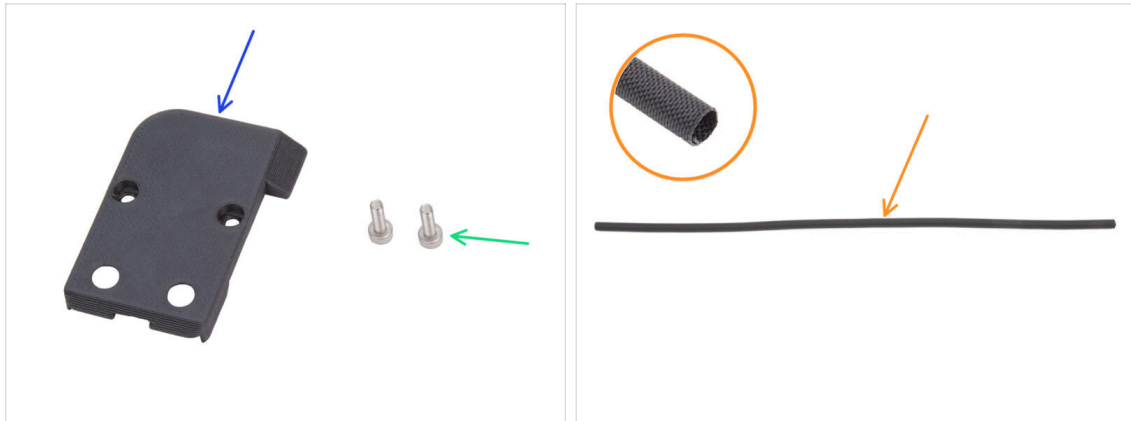
- Place the spacer onto the heatbed carriage on the side with the expansion joints and align it with the hole in the center.
- Put the heatbed on the heatbed carriage and secure it by the M3x12bT. **Do not fully tighten the screw yet.**
 - Make sure the heatbed thermistor cable (the thinnest pair) is routed alongside the heatbed power cables. Do not route it around or across any expansion joints.
- ⚠ **Ensure the correct orientation of the part. Use the heatbed cables as a guide.**
- Insert the M3x4bT screws into the remaining holes in the heatbed. **Do not fully tighten the screws yet.**

ÉTAPE 26 Serrage du plateau chauffant



- ⚠ **IMPORTANT:** The heatbed must be tightened in a specific order. Repeat the sequence multiple times, ensuring the final tightening after at least two rounds.
- After all screws are in place, tighten them in the following sequence:
 - Vis du centre
 - First four screws (edges)
 - Last four screws (corners)
- ⚠ Tighten the screws gently, but firmly.

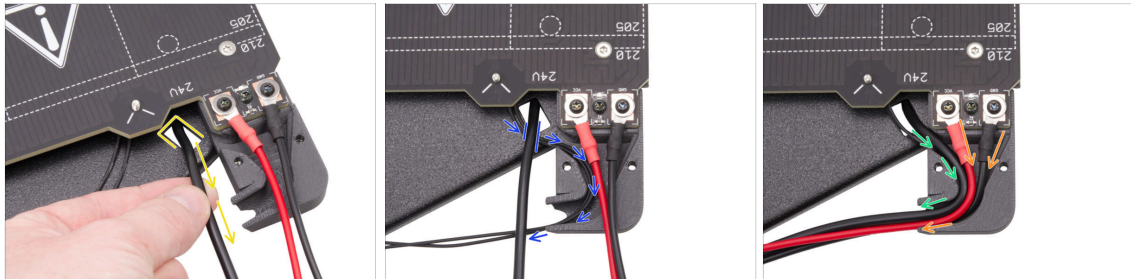
ÉTAPE 27 Covering the cables: parts preparation



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

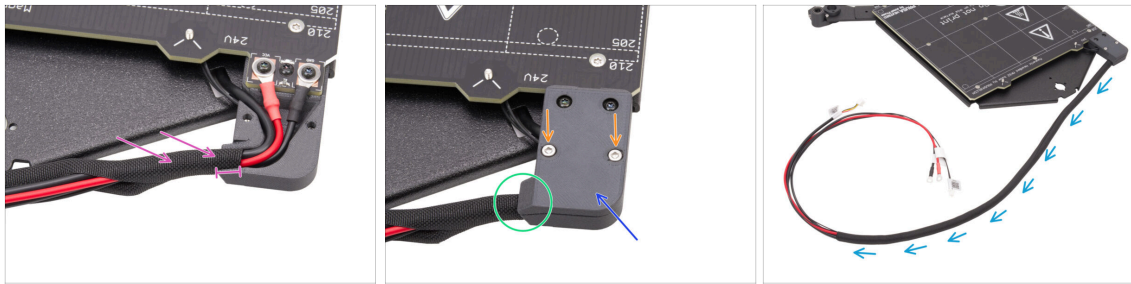
- CORE-One-bed-cable-cover-top (1x) found in the Printed parts package
- Vis M3x10 (2x)
- Gaine textile 520 x 8 mm (1x) qui se trouve dans le paquet Électronique & Pièces de la chambre

ÉTAPE 28 Guiding the heatbed cables



- Pull the RGB LED strip cable from the bottom through the rectangular cutout to the top.
- Guide the heatbed thermistor cable under the RGB LED cable, and insert the heatbed thermistor cable into the cable channel in the cable cover.
- Route the RGB LED strip cable through the cable channel.
- Guide the heatbed power cables through the cable channel.

ÉTAPE 29 Covering the heatbed cables



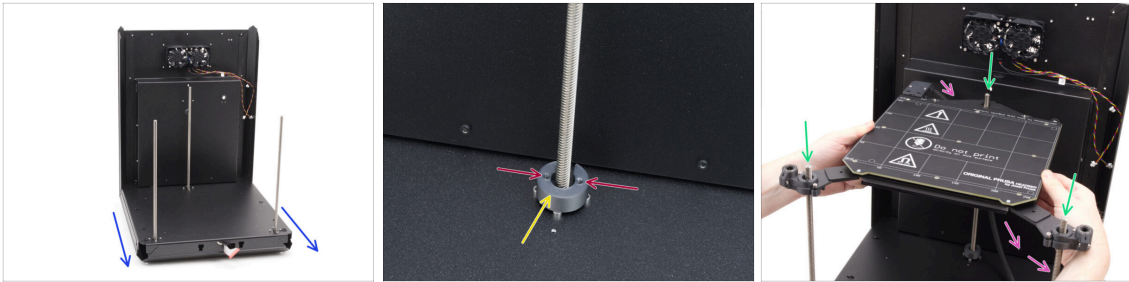
- ◆ Thread approximately 5 cm (2 in) of the textile sleeve onto the heatbed cable bundle and slide the textile sleeve 1 cm (0.39 in) into the cable channel.
- ◆ Attach the CORE-One-bed-cable-cover-top on the heatbed cables.
- ◆ Make sure the textile sleeve is still in place - inside the cable cover. **Do not pull on the textile sleeve.**
- ◆ Secure the top cover with two M3x10 screws.
- ◆ Wrap the rest of the textile sleeve around the cable bundle.

ÉTAPE 30 Mounting the heatbed: parts preparation



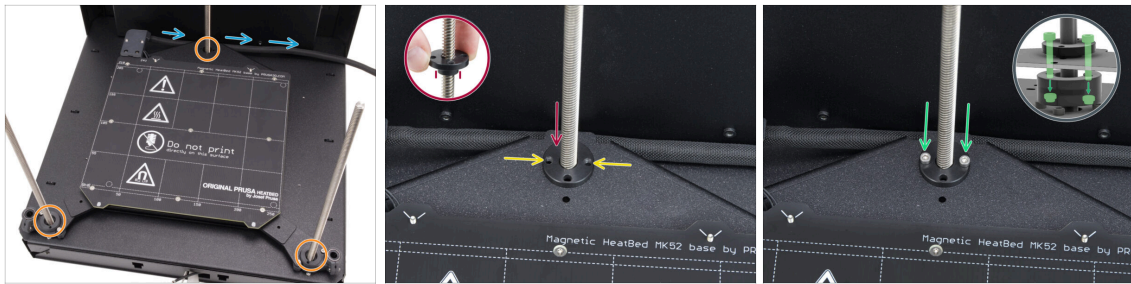
- ◆ **For the following steps, please prepare:**
- ◆ Écrou trapézoïdal (3x)
 - ① Two of these trapezoidal nuts are from the disassembled printer. The last one is in the Electronics and Chamber parts package.
- ◆ Vis M3x18 (6x)

ÉTAPE 31 Attaching the heatbed assembly



- Take the back and base assembly and orient the front side towards you.
- Place the CORE-One-bed-spacer-rear onto the rear motor screw heads, making sure it stays in place.
 - ⚠ Note the orientation of the part and holes as shown. The holes must be parallel to the motor screw heads.
- Very carefully thread the heatbed assembly onto the threaded rods of the Z motors, then gently lay it down onto the base.
 - ⚠ Keep in mind that there is a spacer on the rear motor. Avoid the spacer by the heatbed cable.
- The heatbed cable must run **under the heatbed** and **behind the rear motor**.

ÉTAPE 32 Mounting the heatbed assembly: rear motor



- ❖ Ensure the heatbed assembly is seated correctly—all threaded rods pass through the correct holes.
- ❖ Double-check that the heatbed cable bundle (textile sleeve) runs properly—it **must go under the heatbed assembly** and **behind the threaded rod** of the rear motor.
- ❖ Manually thread the trapezoidal nut onto the rear Z motor. Screw the nut all the way down until it seats into the heatbed carriage.
 - ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- ❖ Align the holes in the trapezoidal nut, carriage and bed-spacer-rear.
 - i It doesn't matter which holes you use in the trapezoidal nut.
 - i Tip: You can push a 1.5 mm Allen key through the holes in all the parts to align them.
- ❖ Secure the trapezoidal nut, heatbed carriage and bed-spacer-rear together with two M3x18 screws.

ÉTAPE 33 Mounting the heatbed assembly: front motor left



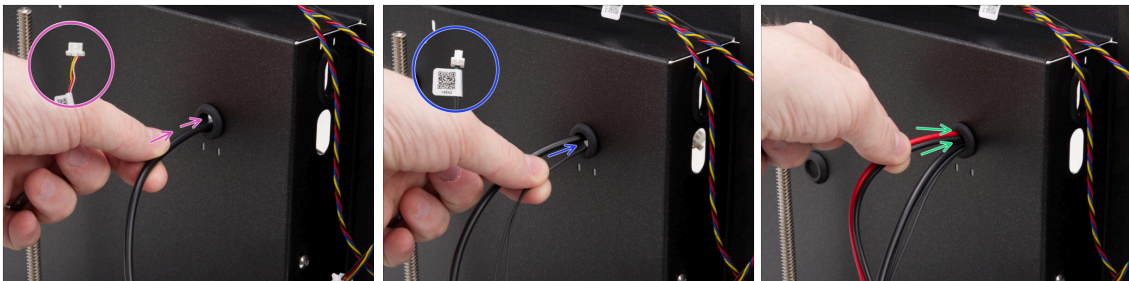
- ❖ Manually thread the trapezoidal nut onto the **left** Z motor. Screw the nut all the way down until it seats into the plastic part.
 - ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- ❖ Align the holes in the trapezoidal nut with those in the plastic part. Either pair of holes can be used.
- ❖ Secure all the part together with two M3x18 screws.

ÉTAPE 34 Mounting the heatbed assembly: front motor right



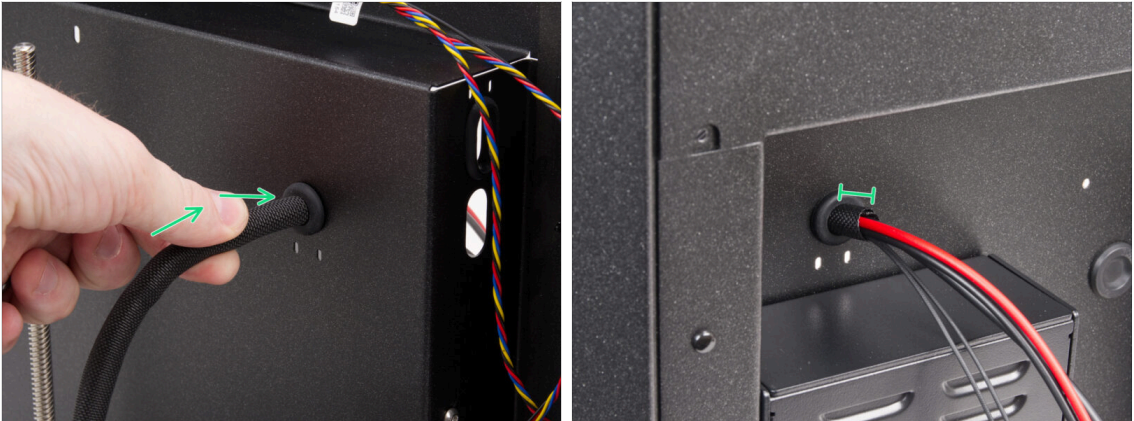
- Manually thread the trapezoidal nut onto the **right** Z motor. Screw the nut all the way down until it seats into the plastic part.
- ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- Align the holes in the trapezoidal nut with those in the plastic part. Either pair of holes can be used.
- Secure all the part together with two M3x18 screws.

ÉTAPE 35 Attaching the heatbed cables I.



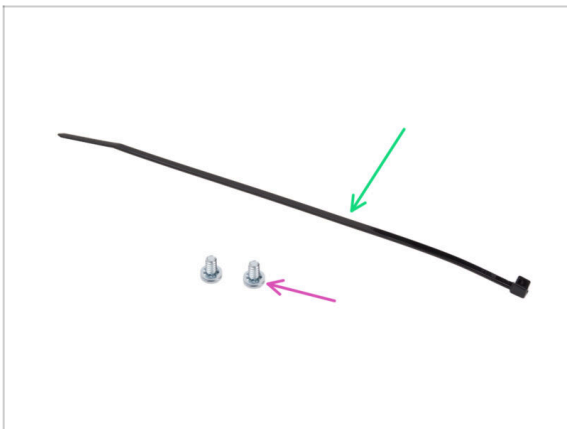
- Locate the grommet hole at the top right of the rear assembly and push the heatbed cables through in the following order:
 - Guidez d'abord le câble de la bande LED RGB à travers le trou.
 - Route the thermistor cable through.
 - Finally, insert both power cables through the hole.

ÉTAPE 36 Attaching the heatbed cables II.



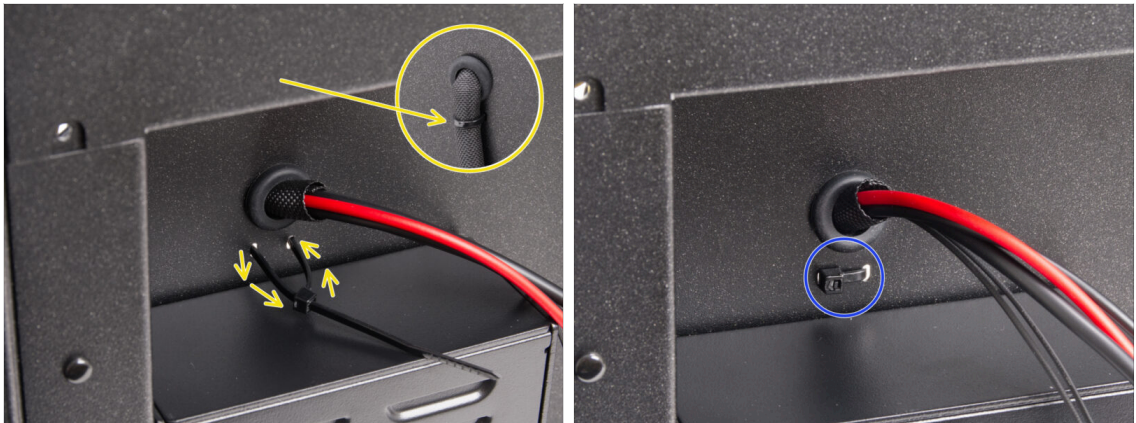
- Push the heatbed cables and the textile sleeve through the grommet hole.
- No more than 1 cm (0.39 in) of the textile sleeve should protrude from the back side.

ÉTAPE 37 Securing the heatbed cables: parts preparation



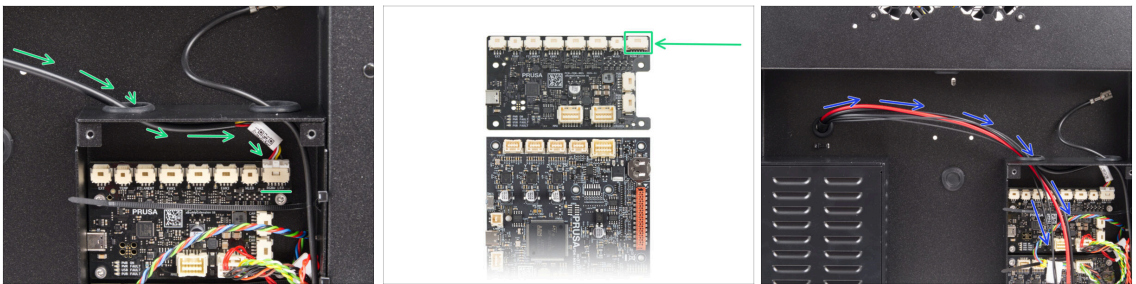
- For the following steps, please prepare:
- Collier de serrage (1x)
- 6/32" terminal screw (2x)

ÉTAPE 38 Securing the textile sleeve



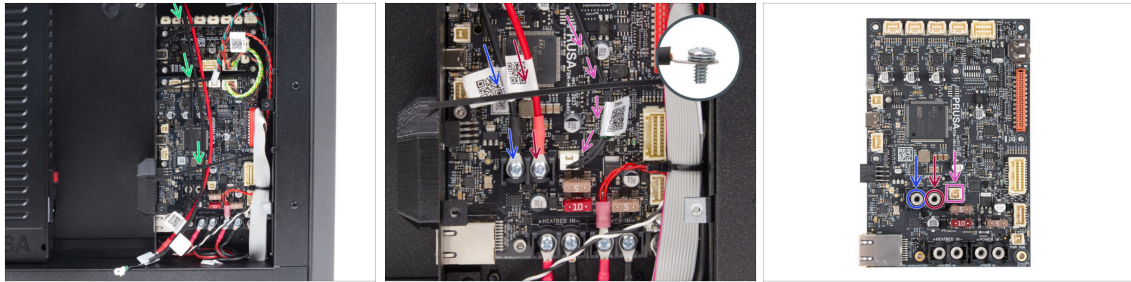
- Guide the zip tie through the two holes under the heatbed cables and make a loop around the heatbed cable bundle (textile sleeve) on the inside.
- Tighten the zip tie firmly and cut off the excess.

ÉTAPE 39 Guiding the heatbed assembly cables



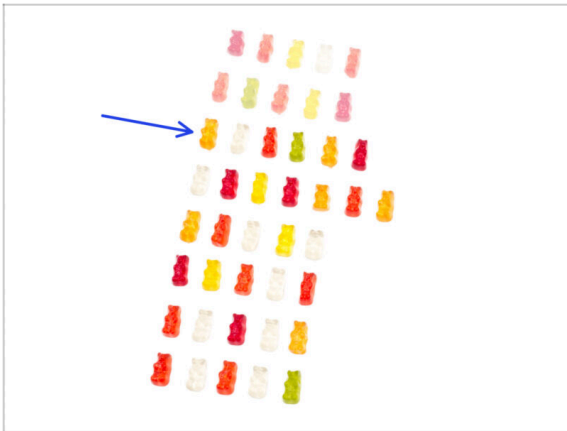
- Route the RGB LED strip cable through the left hole in the xBuddy box and connect it to the first slot on the xBuddy board labeled 'RGBW LED.'
- Connect it to the first slot from the right on the xBuddy extension board.
- Guide the heatbed power cables along with the thermistor through the left hole. Leave the cables hanging freely for now.

ÉTAPE 40 Connecting the heatbed power cables



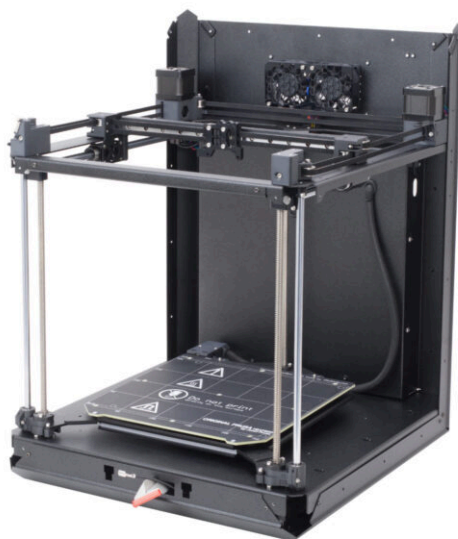
- Ensure that none of the heatbed cables run over the zip ties—they must be guided underneath.
- Using the 6-32 terminal screw, connect the **black** power cable to the **left** terminal on the xBuddy board. Tighten firmly.
- Using the 6-32 terminal screw, connect the **red** power cable to the **right** terminal. Tighten firmly.
- Plug the heatbed thermistor connector to the connector next to the power terminals.

ÉTAPE 41 C'est l'heure des Haribo



- Time for another quick energy boost!
- Eat the third row.
 - With one extra treat. You deserve it!

5. Assemblage du CoreXY



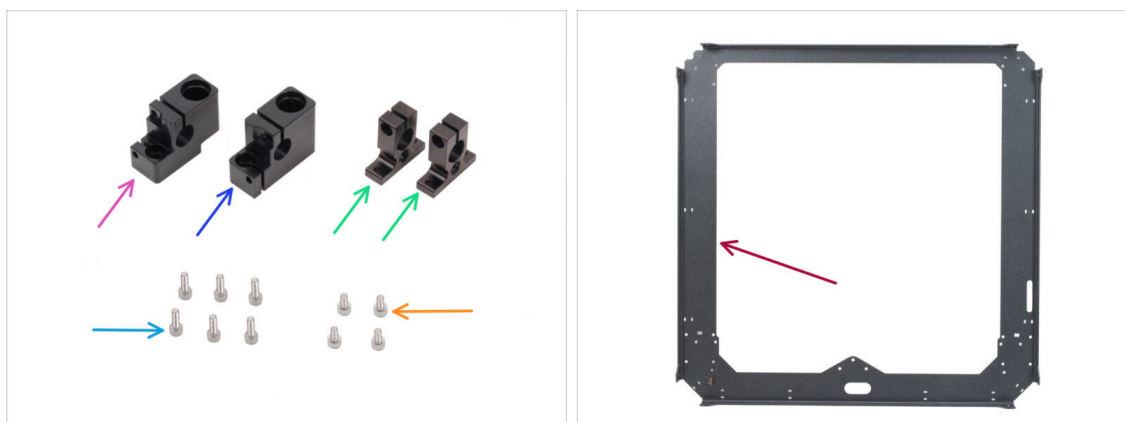
ÉTAPE 1 Tools necessary for this chapter



● Pour ce chapitre, veuillez préparer :

- Pince à bec fin
- Clé Allen de 2,0 mm
- Clé Allen de 2,5 mm
- T10 torx key / T10 torxy screwdriver

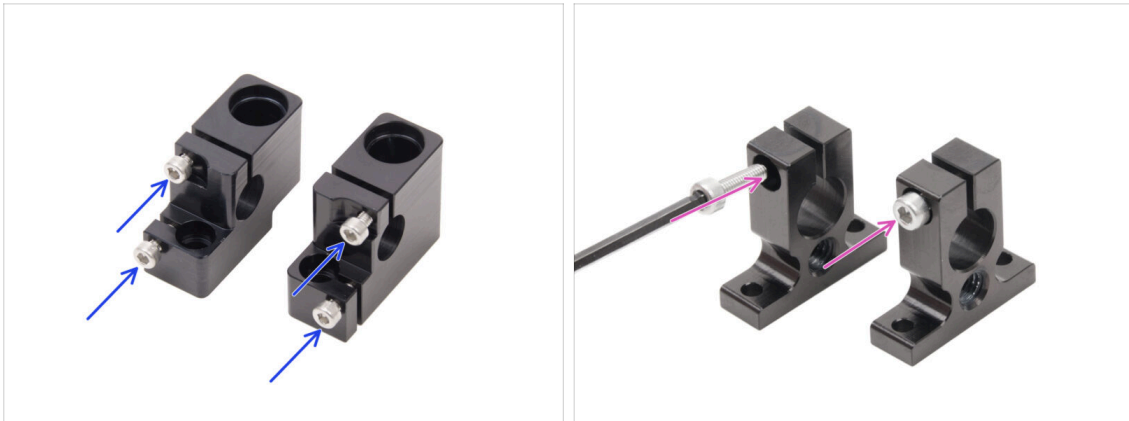
ÉTAPE 2 Rod holders: parts preparation



● Pour les étapes suivantes, merci de préparer :

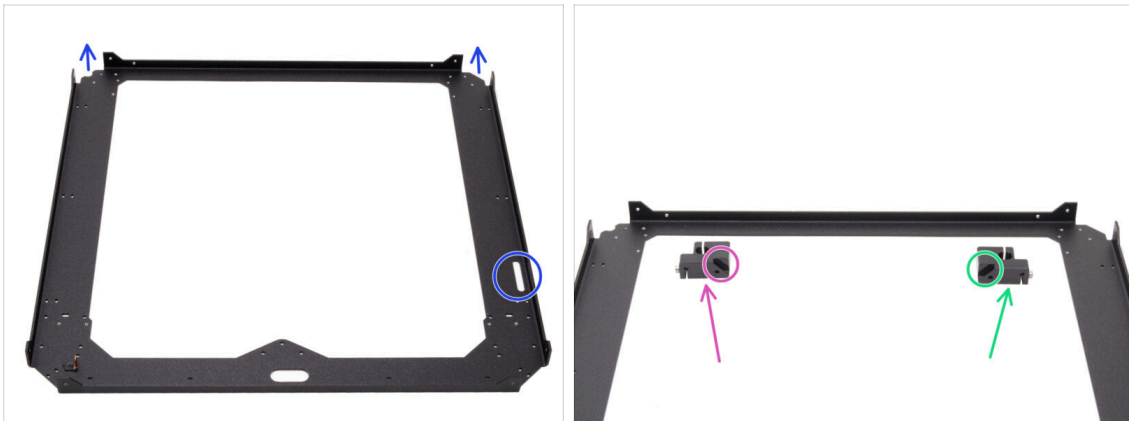
- Rod holder left (1x) *found in the CORE XY parts + hinges + HB set package*
- Rod holder right (1x) *found in the CORE XY parts + hinges + HB set package*
- Rod holder rear (2x) *found in the CORE XY parts + hinges + HB set package*
- Vis M3x10 (6x)
- Vis M3x6 (4x)
- CoreXY plate (1x) *found in the Metal parts 1/3 package*

ÉTAPE 3 Assembling the rod holders



- ◆ Insérez deux vis M3x10 dans le support de tige gauche et deux dans le support de tige droite.
 - ◆ **Do not tighten them completely**, a few turns are enough for now.
- ◆ Insert one M3x10 screw into each Rod holder rear. Insert from the **side with the screw head hole**.
 - ◆ **Do not tighten them completely**, a few turns are enough for now.

ÉTAPE 4 Preparing the front rod holders



- ◆ Placez la plaque du CoreXY comme indiqué - les **parties pliées de la plaque doivent pointer vers le haut**.
 - ◆ Divide the Rod holder left and the Rod holder right into the sides of the front:
 - ⚠ **Ensure you are preparing the correct part for the correct side. Use the chamfers on both parts as a reference for alignment.**
 - ◆ **Support de tige gauche**
 - ◆ **Support de tige droit**

ÉTAPE 5 Installing the front rod holders



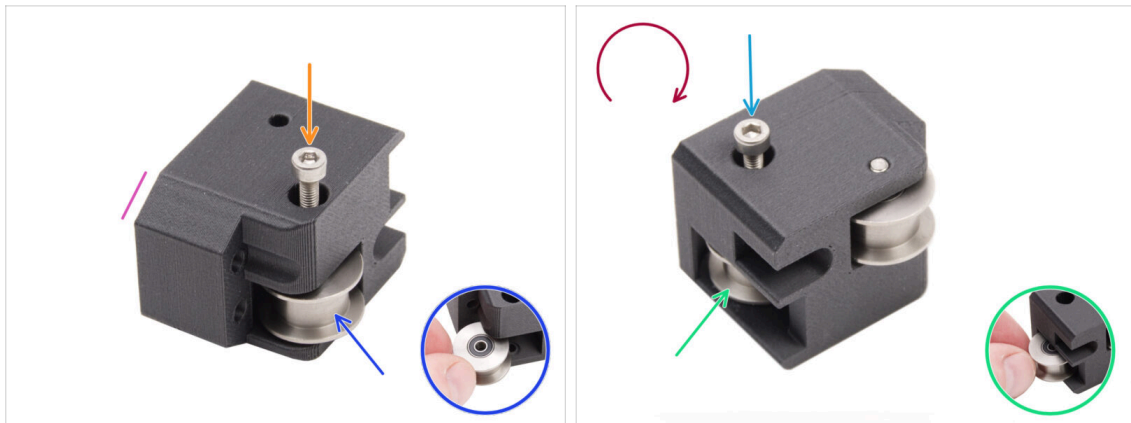
- Placez le support de tige gauche dans le coin avant gauche sur les trous filetés correspondants.
- Secure it with two M3x6 screws.
- Place the Rod holder right to the right front corner on the corresponding threaded holes.
- Secure it with two M3x6 screws.

ÉTAPE 6 XY carriage: parts preparation



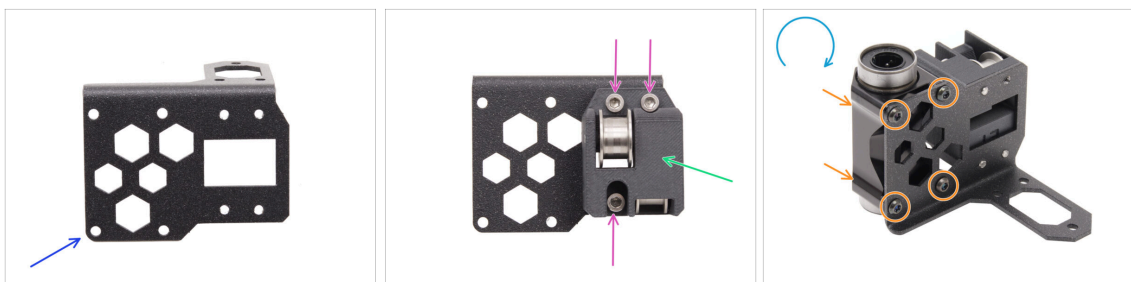
- **Pour les étapes suivantes, merci de préparer :**
- Linear holder left (1x) *found in the Metal parts 1/3 package*
 - Linear holder right (1x) *found in the Metal parts 1/3 package*
 - XY-carriage (2x) *found in the Printed parts package*
 - LM10LUU linear bearing (2x) *found in the CORE XY parts + hinges + HB set package*
 - GT2-20 Idler pulley (4x) *found in the Electronics & Fasteners package*
 - M3x8rT black screw (8x)
 - Vis M3x18 (10x)

ÉTAPE 7 Assemblage des XY-carriages



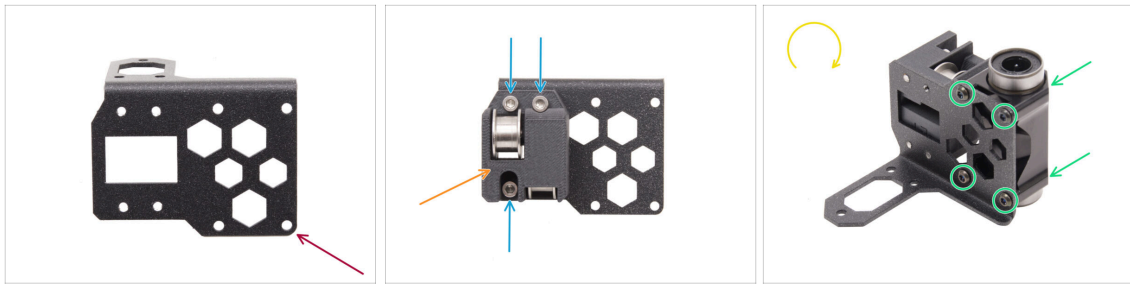
- ◆ Prenez l'un des XY-carriage et orientez-le comme indiqué. Utilisez le côté biseauté comme guide.
- ◆ Insert the GT2-20 Idler pulley into the XY-carriage.
- ◆ Push one M3x18 screw through the pulley and tighten it completely down.
- ◆ Turn the part upside down.
- ◆ Insert another GT2-20 Idler pulley into the XY-carriage.
- ◆ Secure it with the M3x18 screw. Tighten it completely down.
- ◆ Repeat the same procedure with the second XY-carriage.

ÉTAPE 8 Assembling the linear holder left



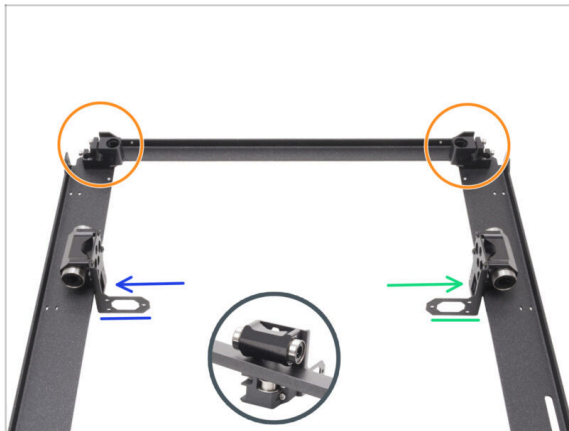
- ◆ Préparez le support linéaire **gauche** et positionnez-le comme sur l'image.
- ◆ Attach one of the XY-carriages to the Linear holder.
- ◆ Installez-le sur le support linéaire avec trois vis M3x18.
- ◆ Turn the Linear holder upside down.
- ◆ From the XY-carriage side, attach the LM10LUU linear bearing to the holder and secure it with four M3x8rT screws.

ÉTAPE 9 Assembling the linear holder right



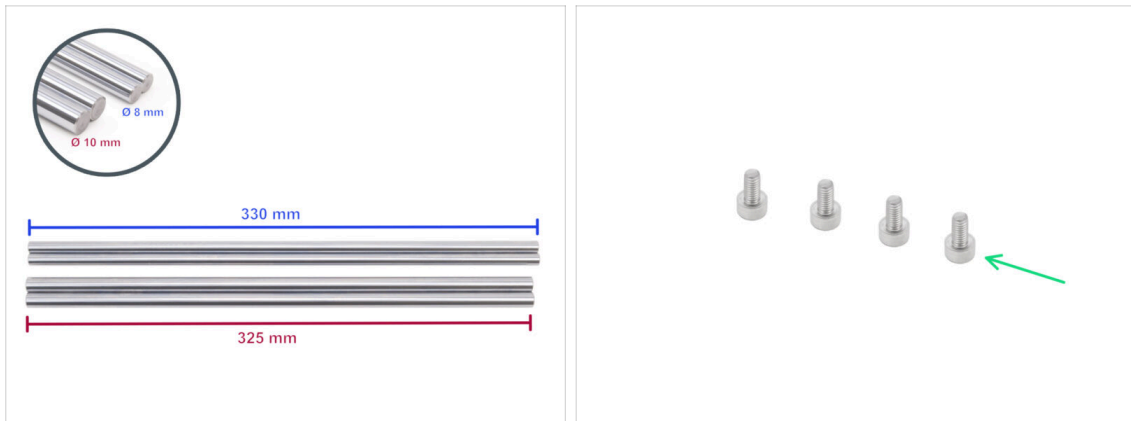
- ◆ Préparez le support linéaire **droit** et positionnez-le comme sur l'image.
- ◆ Attach one of the XY-carriages to the Linear holder.
- ◆ Installez-le sur le support linéaire avec trois vis M3x18.
- ◆ Turn the Linear holder upside down.
- ◆ From the XY-carriage side, attach the LM10LUU linear bearing to the holder and secure it with four M3x8rT screws.

ÉTAPE 10 Attaching the linear holder assemblies



- ◆ Positionnez la plaque du CoreXY comme indiqué sur l'image, en vous assurant que les supports de tige avant sont orientés vers le haut.
- ◆ Slightly lift the CoreXY plate and from the plate's inner side loosely attach the Linear holder of the assemblies.
- ◆ **Support linéaire gauche**
- ◆ **Support linéaire droit**
- ① The linear holders are now only loosely seated.

ÉTAPE 11 Informations sur les tiges lisses



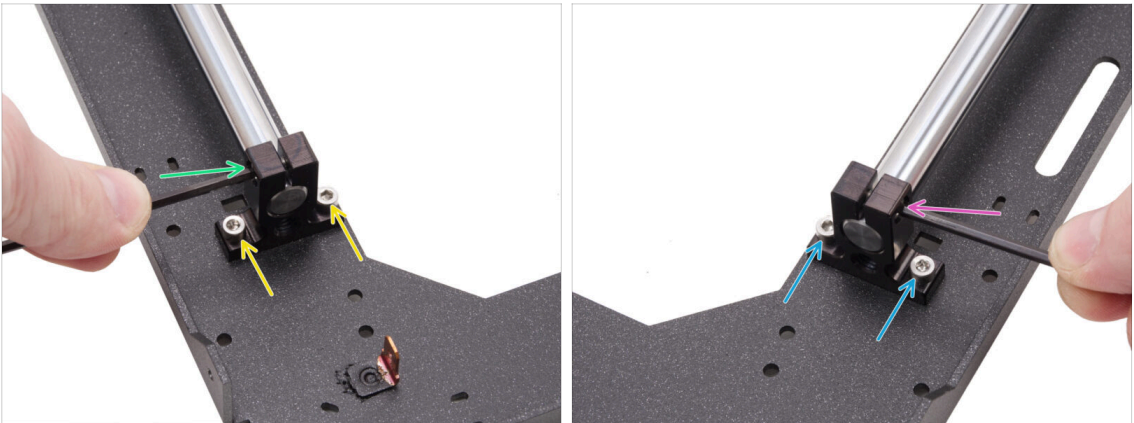
- L'imprimante nécessite différentes tailles de tiges lisses. Assurez-vous d'avoir les bonnes :
 - Smooth rod 330 x 8 mm (2x)
 - Smooth rod 325 x 10 mm (2x)
originally from the Z-axis,
are needed for the following steps.
- Préparez également :
 - Vis M3x6 (4x)

ÉTAPE 12 Mounting the smooth rods



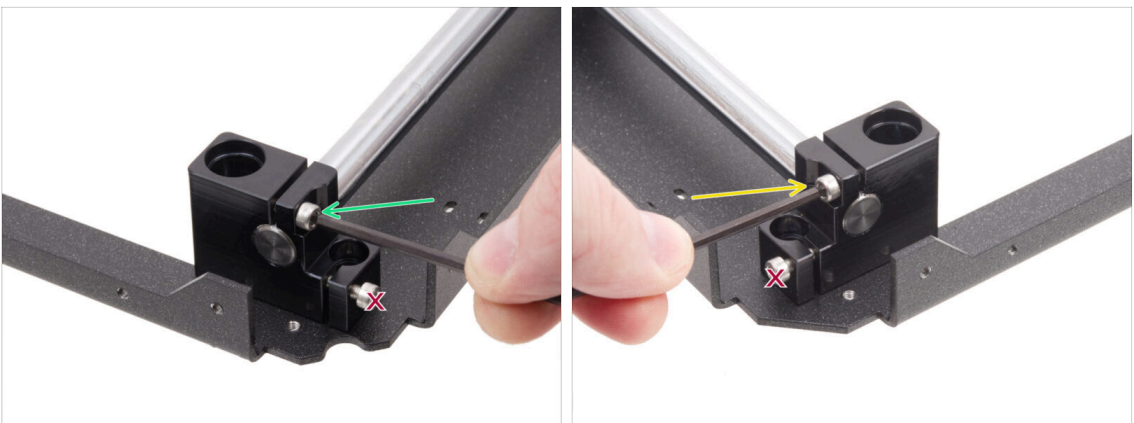
- Faites glisser les deux supports de tige arrière sur les deux tiges lisses de 10 mm.
- Line up the ends of the rods with the holders.
- Push both 10mm smooth rods through the LM10LUU bearing to the front rod holders.
- Make sure the screws on the rear rod holders are pointing out of the frame.
- Line up the front end of the 10mm smooth rods with the front rod holders.

ÉTAPE 13 Securing the rear rod holders



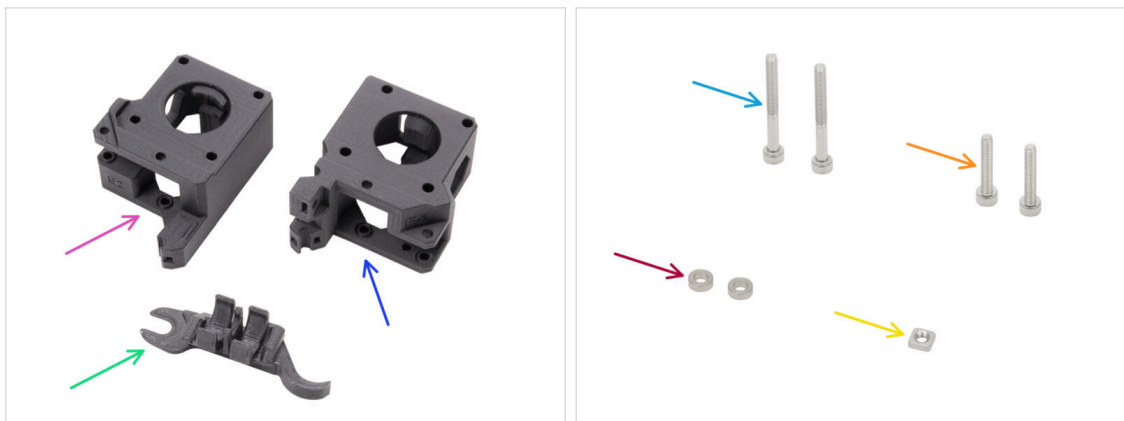
- Alignez le support de tige arrière gauche avec les trous filetés de la plaque.
- Fix it with two M3x6 screws.
- Firmly tighten the screw in the rod holder.
- Line up the right rear rod holder with the threaded holes in the plate.
- Fix it with two M3x6 screws.
- Firmly tighten the screw in the rod holder.

ÉTAPE 14 Securing the front rod holders



- Concentrez-vous sur le support avant gauche (maintenant à droite) et fixez la tige en serrant la vis dans le support.
- ⚠ **Do not tighten the bottom screw.**
- Focus on the front right holder (now on the left) and secure the rod by tightening the screw in the holder.
- ⚠ **Do not tighten the bottom screw.**

ÉTAPE 15 Motor mounts: parts preparation

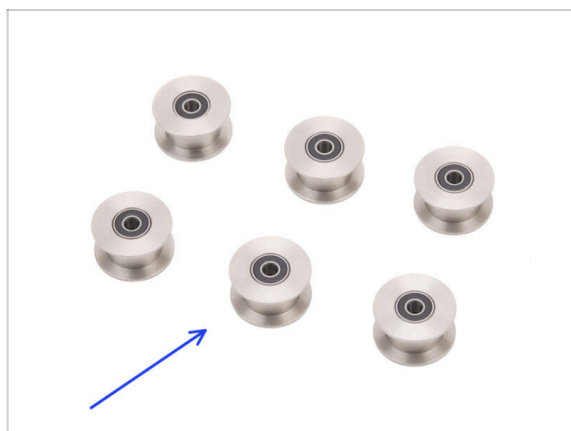


● Pour les étapes suivantes, merci de préparer :

- XY-motor-mount-left (1x) *found in the Printed parts package*
- XY-motor-mount-right (1x) *found in the Printed parts package*
- Assembly-multi-tool (1x) *you already used*
- Vis M3x30 (2x)
- Vis M3x18 (2x)
- Spacer 3.2/6x2 (2x) *found in the Electronics & Fasteners package*
- Écrou M3nS (1x)

❗ The list continues in the next step...

ÉTAPE 16 Motor mounts: part preparation



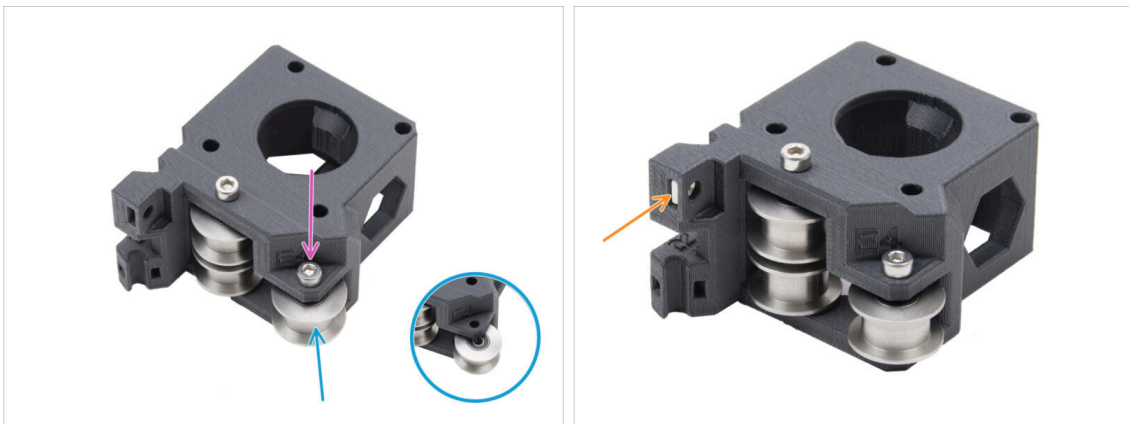
- Poulie de renvoi GT2-20 (6x) *qui se trouve dans le paquet Électronique & Visserie*

ÉTAPE 17 Assembling the XY-motor-mount-right I.



- ◆ Insérez une poulie dans la position inférieure de l'outil multifonction d'assemblage.
- ◆ Insert the spacer 3.2 on the pulley.
- ◆ Insérez la deuxième poulie dans l'outil multifonction d'assemblage.
- ◆ Insert the whole assembly into the XY-motor-mount-right.
 - ◆ Position the part according to the picture. Note the beveled corner.
- ◆ Align holes in both parts and secure it with the M3x30 screw.
 - 🔧 La pièce en plastique n'a pas de filetage préformé, donc la vis le créera au fur et à mesure que vous serrez. Une légère résistance est attendue.
- ◆ Retirez l'outil multifonction d'assemblage.

ÉTAPE 18 Assembling the XY-motor-mount-right II.



- ◆ Insérez une autre poulie dans le XY-motor-mount-right.
- ◆ Secure it with M3x18 screw.
 - 📌 La pièce en plastique n'a pas de filetage préformé, donc la vis le créera au fur et à mesure que vous serrez. Une légère résistance est attendue.
- ◆ Insert the M3nS nut into the XY-motor-mount-right.

ÉTAPE 19 Assembling the XY-motor-mount-left I.



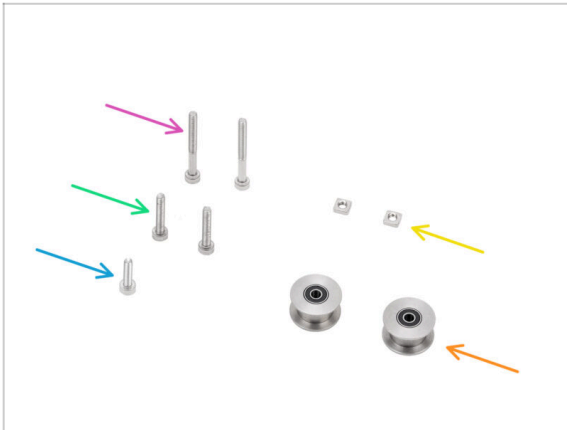
- ✿ Insérez une poulie dans la position inférieure de l'outil multifonction d'assemblage.
- ✿ Insert the spacer 3.2 on the pulley.
- ✿ Insérez la deuxième poulie dans l'outil multifonction d'assemblage.
- ✿ Insert the whole assembly into the XY-motor-mount-left.
 - ⬛ Position the part according to the picture. Note the bevel next to the screw hole.
- ✿ Align holes in both parts and secure it with the M3x30 screw.
 - ⓘ La pièce en plastique n'a pas de filetage préformé, donc la vis le créera au fur et à mesure que vous serrez. Une légère résistance est attendue.
- ✿ Retirez l'outil multifonction d'assemblage.

ÉTAPE 20 Assembling the XY-motor-mount-left II.



- ✿ Insérez une autre poulie dans la pièce.
- ✿ Secure it with M3x18 screw. **Do not overtighten the screw.**
 - ⓘ La pièce en plastique n'a pas de filetage préformé, donc la vis le créera au fur et à mesure que vous serrez. Une légère résistance est attendue.

ÉTAPE 21 Belt tensioners: parts preparation I.



✖ Pour les étapes suivantes, merci de préparer :

🟡 GT2-20 Idler pulley (2x) *you have removed from the MK4S*

🟡 Vis M3x30 (2x)

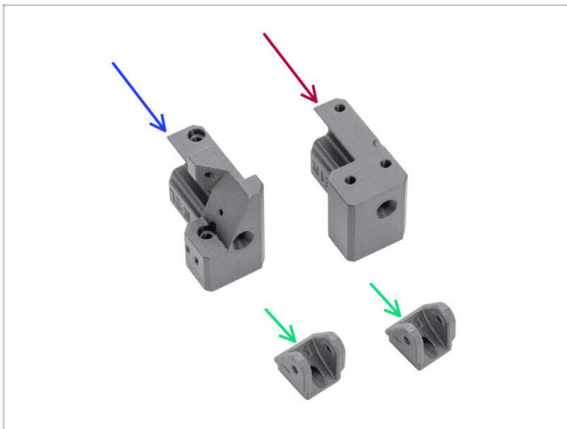
🟢 Vis M3x18 (2x)

🟢 Vis M3x12 (1x)

🟡 Écrou M3nS (2x)

📄 The list continues in the next step...

ÉTAPE 22 Belt tensioners: parts preparation II.



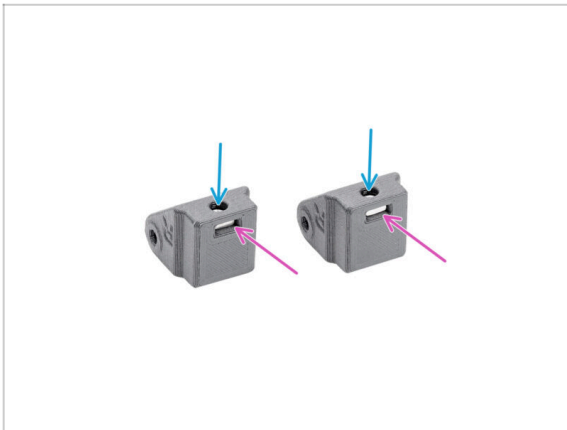
✖ Pour les étapes suivantes, veuillez préparer :

🟢 Belt-tensioner-left (1x) *found in the Printed parts package*

🟢 Belt-tensioner-right (1x) *found in the Printed parts package*

🟢 Belt-tensioner-pulley (2x) *found in the Printed parts package*

ÉTAPE 23 Préparation des poulies du tendeur



- ✚ Insérez un écrou M3nS dans chaque Belt-tensioner-pulley.
- ✚ Assurez-vous que les écrous sont correctement insérés dans les pièces. Les trous dans les écrous et les pièces **doivent être alignés**.
- ⬛ Gardez les deux pièces dans cette position.

ÉTAPE 24 Assembling the belt tensioner left I.



- ✚ Appliquez une petite quantité de Prusa Lubricant sur la pointe des deux vis M3x30.
- ✚ Répartissez le lubrifiant uniformément sur tout le filetage.
- ⓘ Astuce : utilisez la pointe d'un collier de serrage pour répartir le lubrifiant.
- ✚ Slide the Belt-tensioner-**left** onto the Belt-tensioner-pulley.
- ⬛ **Ensure the parts are oriented correctly**, as shown.
- ✚ Insert the M3x30 screw through the Belt-tensioner-left into the Belt-tensioner-pulley. **Do not tighten completely!** 3-4 turns are sufficient.

ÉTAPE 25 Assembling the belt tensioner left II.



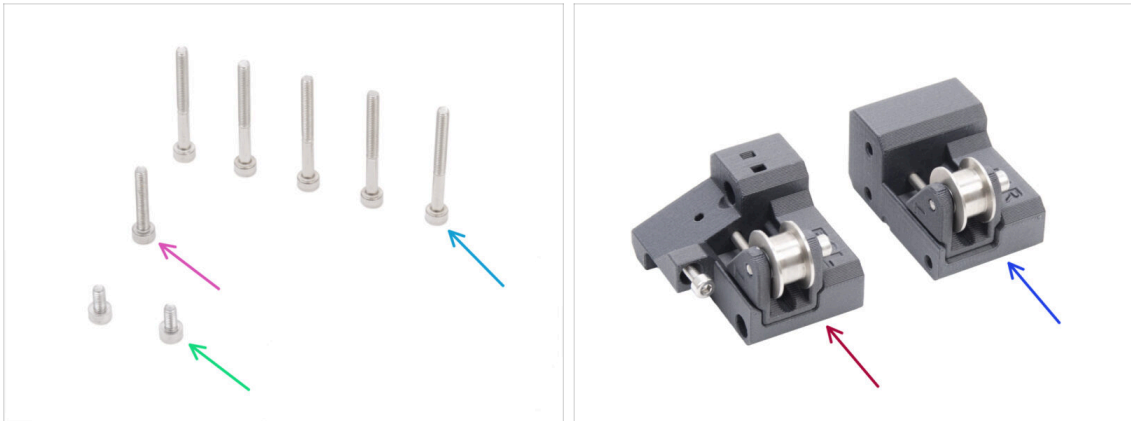
- Insérez la poulie de renvoi GT2-20 dans la Belt-tensioner-pulley.
- Secure it with the M3x18 screw.
 - ⓘ La pièce en plastique n'a pas de filetage préformé, donc la vis le créera au fur et à mesure que vous serrez. Une légère résistance est attendue.
- Insert the M3x12 screw into the Belt-tensioner-left. Tighten slightly—five turns are enough. It must not protrude through the other side.
 - ⓘ Note: This screw, referred to as the tensioning screw, will later be used to adjust the door sensor.

ÉTAPE 26 Assembling the belt tensioner right



- Faites glisser le Belt-tensioner-**right** sur la Belt-tensioner-pulley.
- **Ensure the parts are oriented correctly**, as shown.
- Insert the M3x30 screw through the Belt-tensioner-right into the Belt-tensioner-pulley. **Do not tighten completely!** 3-4 turns are sufficient.
- Insert the GT2-20 Idler pulley pulley into the Belt-tensioner-pulley-right.
- Secure it with the M3x18 screw.
 - ⓘ La pièce en plastique n'a pas de filetage préformé, donc la vis le créera au fur et à mesure que vous serrez. Une légère résistance est attendue.

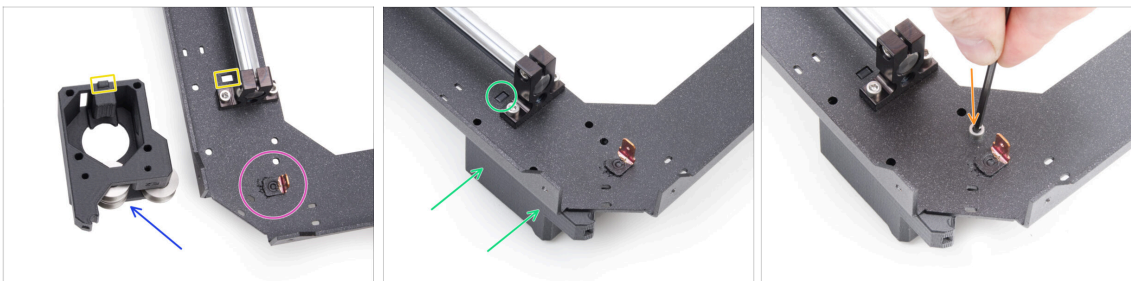
ÉTAPE 27 Installing the belt tensioners: parts preparation



● Pour les étapes suivantes, merci de préparer :

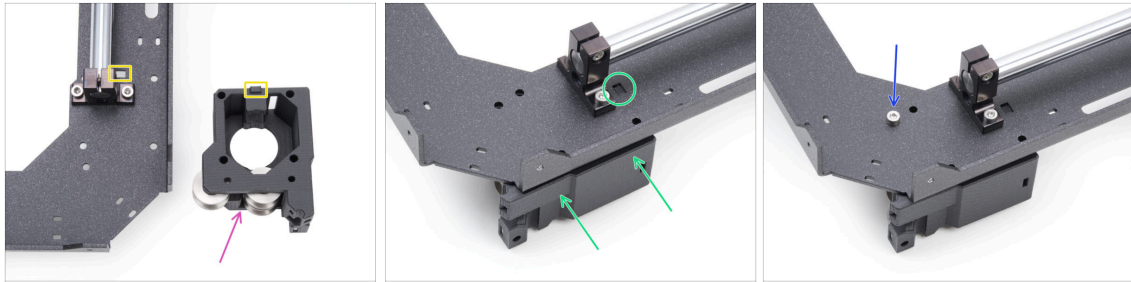
- Vis M3x30 (5x)
- Vis M3x18 (1x)
- Vis M3x6 (2x)
- Belt tensioner left assembly (1x) *you assembled earlier*
- Belt tensioner right assembly (1x) *you assembled earlier*

ÉTAPE 28 Installing the motor mount left



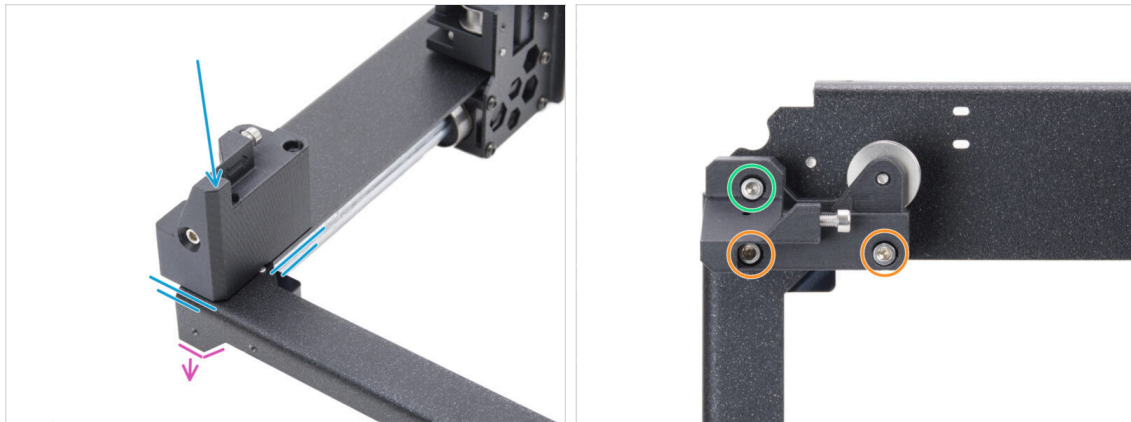
- Localisez le coin de la plaque du CoreXY avec le connecteur Faston dessus. Il se trouve sur la face inférieure de l'assemblage.
- Position the motor-mount-**left** on the CoreXY plate as shown in the picture.
- Note the rectangular protrusion on the motor-mount-left and the rectangular cutout on the CoreXY plate.
- Faites glisser le motor-mount-left sous la plaque du CoreXY, en vous assurant que la saillie rectangulaire s'insère dans la découpe.
- Align the holes in both parts and secure them with an M3x6 screw in the designated hole

ÉTAPE 29 Installing the motor mount right



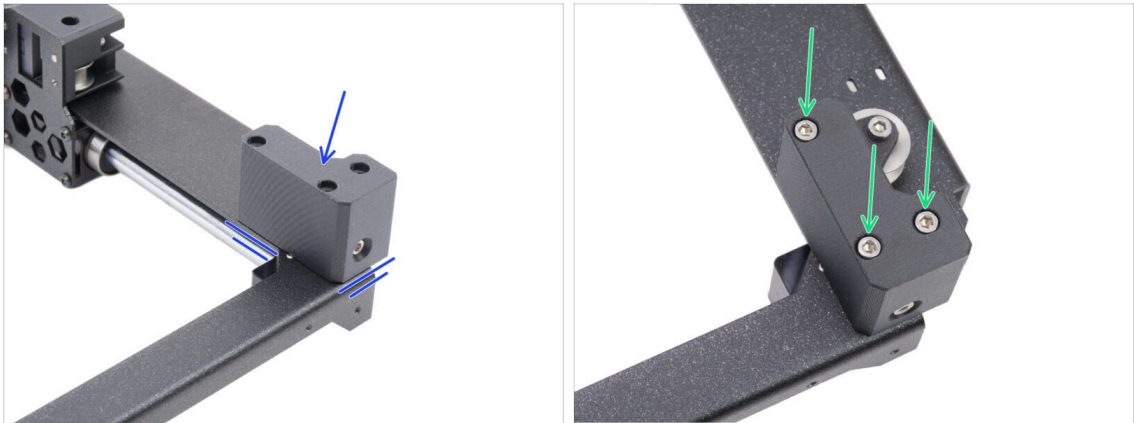
- ◆ Positionner le motor-mount-**right** sur la plaque du CoreXY comme indiqué sur l'image.
- ◆ Notez la saillie rectangulaire sur le motor-mount-right et la découpe rectangulaire sur la plaque du CoreXY.
- ◆ Faites glisser le motor-mount-right sous la plaque du CoreXY, en vous assurant que la saillie rectangulaire s'insère dans la découpe.
- ◆ Align the holes in both parts and secure them with an M3x6 screw in the designated hole

ÉTAPE 30 Installation du belt-tensioner-left



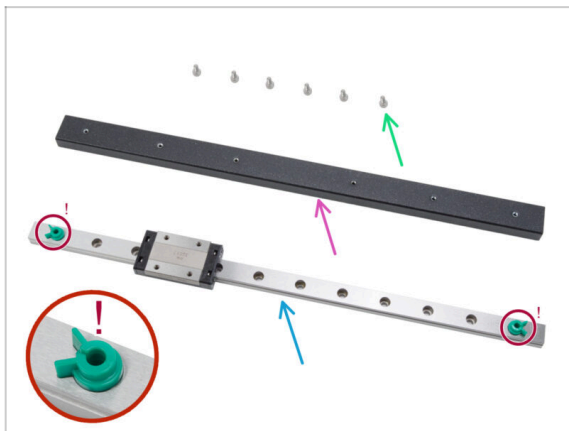
- ◆ Retournez l'assemblage du CoreXY de manière à ce que les parties pliées soient orientées vers le bas. Concentrez-vous sur le coin avant gauche de l'assemblage.
- ◆ Place the belt-tensioner-**left** assembly in the front left corner of the CoreXY plate. Align it with the front and inner side edges.
 - ◆ Line up the holes in both parts.
 - ◆ Secure the part with two M3x30 screws.
 - ◆ Insert and tighten one M3x18 screw.

ÉTAPE 31 Installation du belt-tensioner-right



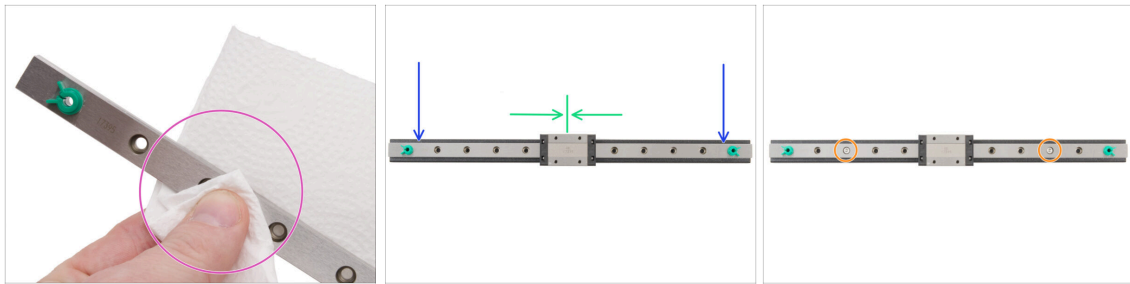
- Place the belt-tensioner-**right** assembly in the front right corner. Align it with the front and inner side edges.
- Line up the holes in both parts.
- Secure the part with three M3x30 screws.

ÉTAPE 32 Linear rail: parts preparation



- For the following steps, please prepare:
 - Vis M3x6 (6x)
 - Linear rail beam (1x) *found in the Metal parts 3/3 package*
 - Linear rail (1x) *found in the Electronics & Chamber parts package*
- ⚠ **Under no circumstances remove the green anti-ejection safety pins.** Wait for the prompt in the instructions.
- Piece of cloth or a paper towels to wipe the preservative lubricant from the linear guide.

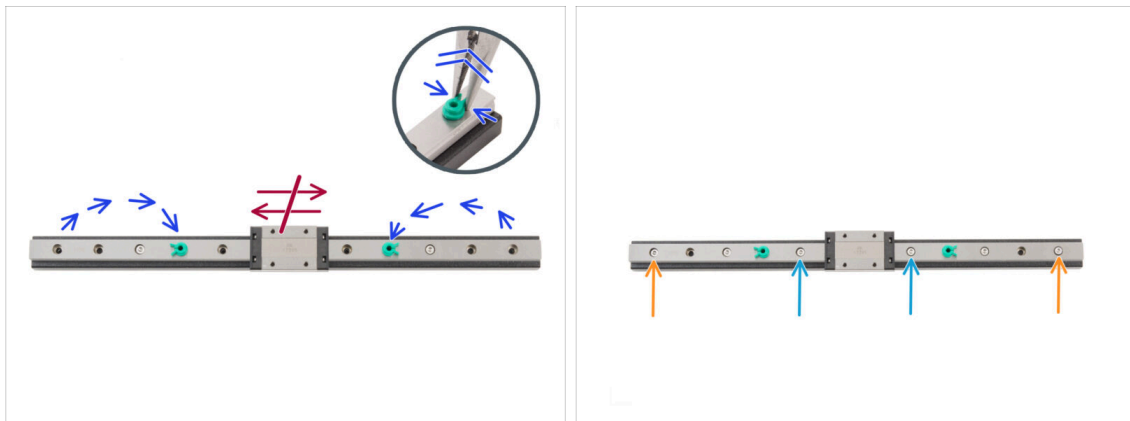
ÉTAPE 33 Attaching the linear rail



⚠ Under no circumstances remove the green anti-ejection safety pins. Wait for the prompt in the instructions.

- ✎ Immediately after removing the linear guide from the package, wipe off the preservative lubricant with a paper towel.
- ⬢ Attach the linear rail on the linear rail beam and line up the holes in both parts.
- 🟡 Insert and slightly tighten two M3x6 screws into the third holes from both ends.
- 🟢 Move the linear carriage approximately to the center of the rail.

ÉTAPE 34 Securing the linear rail

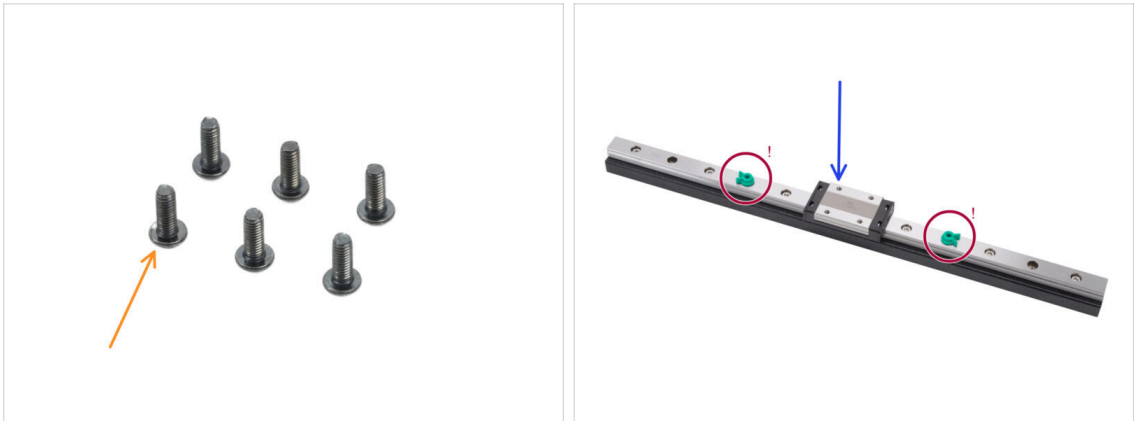


⚠ Do not move the linear carriage in any way in this step.

- ⬢ Relocate the safety pins from each end to the fourth holes from the ends of the linear rail.
- ⬢ Gently squeeze the safety pin with needle-nose pliers and pull it out.
- ⬢ Insert two M3x6 screws into the fifth holes from the ends of the rail. **Tighten just slightly.**
- 🟡 Insert two M3x6 screws into the first holes in the rail. **Tighten just slightly.**

⚠ Do not remove the safety pins from the rail.

ÉTAPE 35 Installing the linear rail: parts preparation



⬛ For the following steps, please prepare:

🟡 Vis M3x8rT (6x)

ⓘ There are both M3x8rT and M3x8 screws in the kit. Make sure you have prepared the correct ones.

🟢 Linear rail assembly (1x) *you assembled earlier*

⚠️ **Do not remove the safety pins.**

ÉTAPE 36 Installing the linear rail assembly



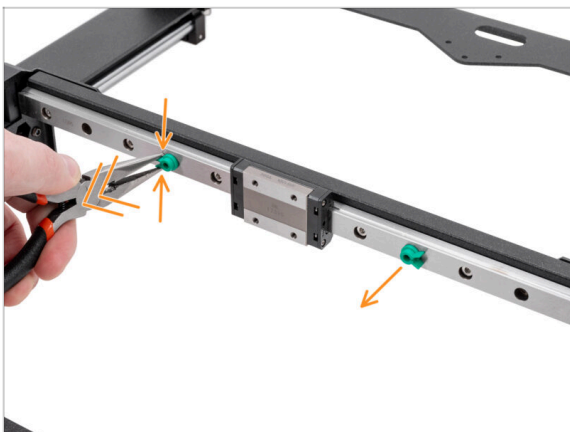
🟢 Position the assembly with the motor mounts facing you.

🟢 Move both linear holders approximately to the center of the Y-axis.

🟡 Attach the linear rail assembly to the holders from the front side of the assembly.

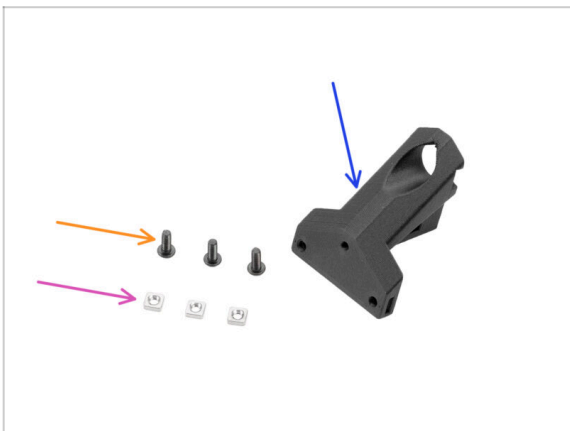
🟡 Fixez-le avec trois vis M3x8rT à l'arrière, sur les côtés gauche et droit.

ÉTAPE 37 Linear rail: removing the safety pins



- Gently squeeze both safety pins with needle-nose pliers and pull them out of the linear rail.
- i You can discard the safety pins as they are no longer needed.

ÉTAPE 38 Bed-stop : préparation des pièces



- **For the following steps, please prepare:**
- Bed-stop-rear (1x) *found in the Printed parts package*
- Écrou M3nS (3x)
- Vis M3x8rT (3x)

ÉTAPE 39 Assemblage du bed-stop



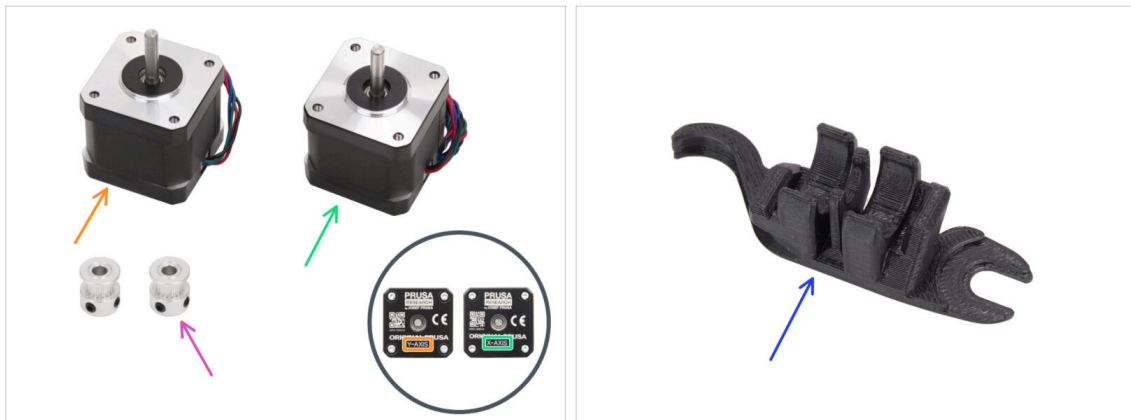
- Insert two M3nS nuts into the bed-stop from one side.
- Insert one M3nS nut into the bed-stop from the other side.

ÉTAPE 40 Montage du bed-stop



- Position the CoreXY assembly as shown, ensuring the motor mounts face upwards.
- Focus on the triangle protrusion on the metal part.
- Insert the bed-stop-rear **under** the protrusion at the back of the CoreXY plate.
- Alignez les trois trous des deux pièces.
- Secure both parts together with three M3x8rT screws.
- i** The upper screw is screwed into plastic with no pre-cut thread. It cuts the thread as it's tightened. Slight resistance is expected.

ÉTAPE 41 X&Y motors: parts preparation



- For the following steps, please prepare:
- Moteur de l'axe Y (1x)
- Moteur de l'axe X (1x)
- i** Notez que les moteurs sont marqués comme axes X et Y afin de les distinguer. Nous continuerons à suivre ce marquage.
- Poulie T16-2GT (2x)
- Assembly-multi-tool (1x) *you already used*

ÉTAPE 42 Installing the X-axis pulley



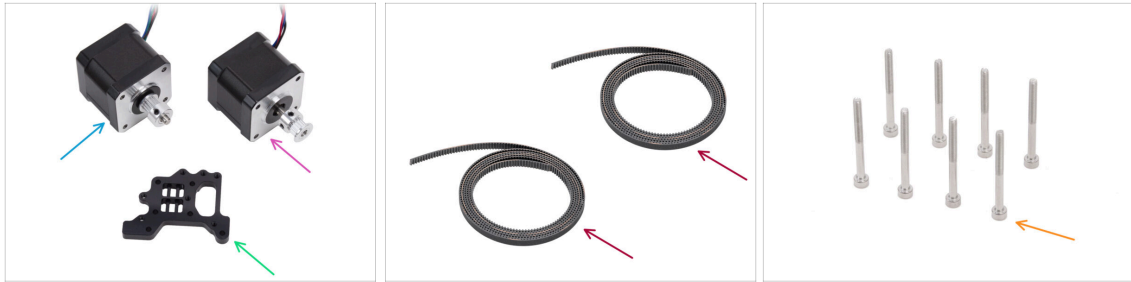
- Prepare the **X-axis** motor.
- Note the flat part on the motor shaft.
- ⚠ Slide the Pulley on, **note the CORRECT orientation.**
- Faites tourner l'arbre du moteur avec la partie plate face à vous.
- Using the fork on the Assembly-multi-tool set a gap between the pulley and the motor.
- Push the pulley on the tool and firmly tighten the screw against the flat part on the shaft.
- Rotate the pulley and firmly tighten the second grub screw.
- ⚠ Vérifiez à nouveau l'orientation de la poulie. Le **côté denté de la poulie doit être du côté du moteur.**

ÉTAPE 43 Installing the Y-axis pulley



- Prepare the **Y-axis** motor.
- Note the flat part on the motor shaft. Rotate the motor shaft with the flat part facing you.
- ⚠ Faites glisser la poulie et **notez la BONNE orientation. L'orientation de la poulie de l'axe Y est DIFFÉRENTE de celle de l'axe X. Assurez-vous que les dents de la poulie sont orientées à l'opposé du moteur. Utilisez le crochet le plus large de l'outil d'assemblage.**
- À l'aide du crochet de l'outil multifonction d'assemblage, placez la partie courbée la plus épaisse entre la poulie et le moteur.
- ⚠ **N'essayez pas de l'accrocher autour de l'arbre. Posez simplement l'outil contre le moteur et assurez-vous que la pointe du crochet glisse entre le moteur et la poulie.**
- Push the pulley on the tool and firmly tighten the screw against the flat part on the shaft.
- Rotate the pulley and firmly tighten the second grub screw.
- ⚠ **Vérifiez à nouveau l'orientation de la poulie. Les dents doivent être tournées à l'opposé du moteur.**

ÉTAPE 44 XY belts: parts preparation



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

- X-axis motor assembly (1x) *you assembled earlier*
- Y-axis motor assembly (1x) *you assembled earlier*
- Courroie XY (2x) *qui se trouve dans le paquet de pièces CORE XY + charnières + ensemble HB*
- Nexttruder holder (1x) *found in the CORE XY parts + hinges + HB set package*
- Vis M3x35 (8x)

ÉTAPE 45 Informations sur les courroies XY

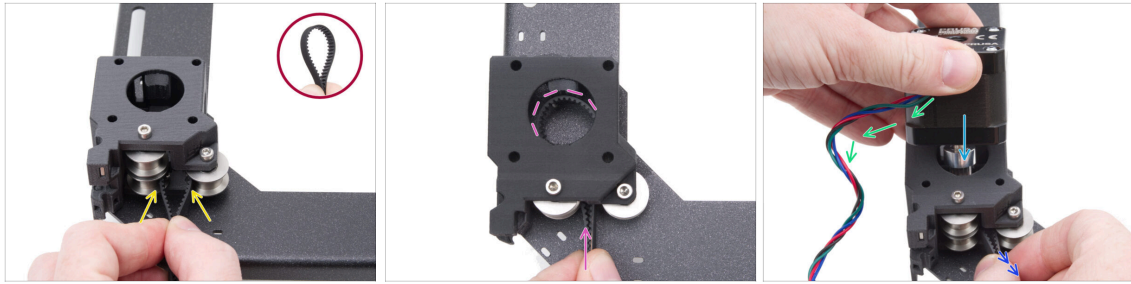


❗ The next steps cover belt installation and guiding on the core XY assembly. Before starting, refer to the illustration for an overview and better understanding of each belt's path.

- X-axis belt - at the **top position**
- Y-axis belt - at the **bottom position**

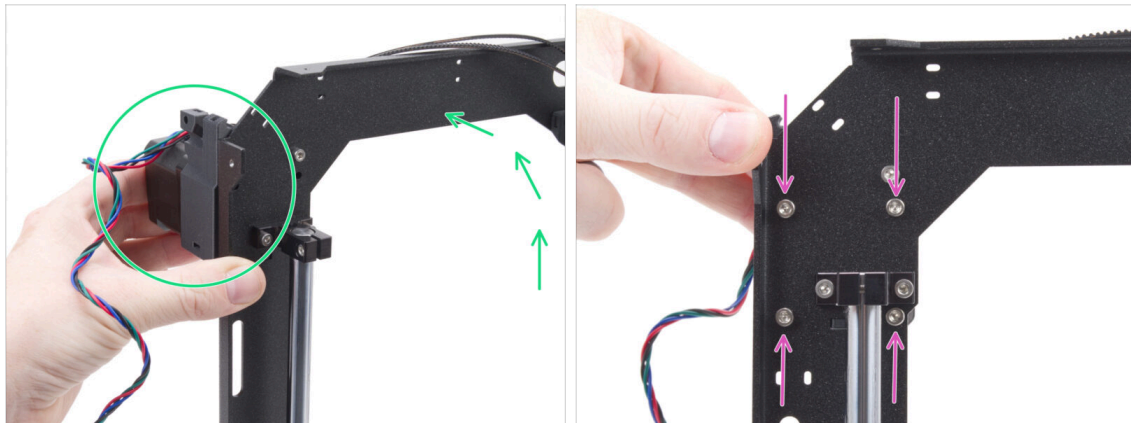
■ Guidons les courroies étape par étape...

ÉTAPE 46 Y belt guiding: Y motor pulley



- From the back of the CoreXY, focus on the motor-mount on the **left** side.
- Create a loop anywhere on the belt so the **belt teeth are pointing inside** the loop.
- Push this loop through the space between the lower pulleys inside the motor mount.
- Poussez suffisamment pour que la boucle suive le trou rond supérieur du support moteur aussi étroitement que possible.
- Insert the **Y** motor into the motor holder, the pulley must be in the middle of the belt loop.
- Insert the Y motor pulley into the motor mount, ensuring the pulley is centered within the belt loop.
Fully attach the motor to the motor-mount with the motor cable facing you.
- Pull lightly on the belt loop to encircle the pulley.

ÉTAPE 47 Securing the Y-axis motor



- Firmly grasp the Y-axis motor assembly and position the CoreXY assembly vertically. **Do not drop the motor!**
- ⚠ Be careful not to pull the entire belt out of the motor.
- Keep holding the motor with one hand. With the other hand, secure the motor using four M3x35 screws on the underside of the frame. **Tighten firmly.**
- Remettez l'assemblage du CoreXY en position horizontale.

ÉTAPE 48 Y belt guiding: Y motor mount



- 🟠 Guide the left end of the belt around the lower left pulley.
- 🟡 Push the belt through the part and guide it to the front of the CoreXY plate.
- ⚠️ **Don't pull too long so you don't pull the whole belt out.** Remember that the other end is loose. The whole process would then have to be repeated.

ÉTAPE 49 Y belt guiding: belt tensioner



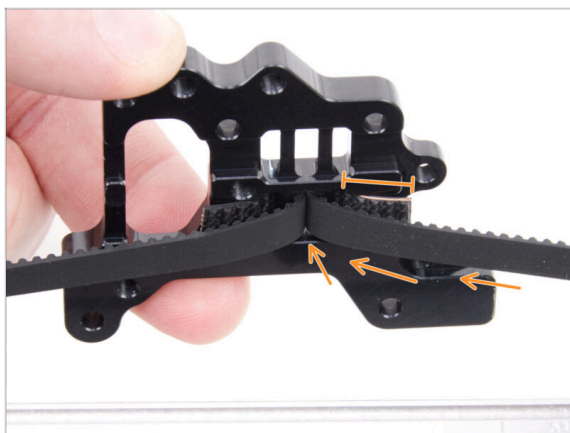
- 🟠 Guidez la courroie autour de la poulie dans le tendeur de courroie.
- 🟡 Push the belt around the front pulley in the linear assembly.
- 🟢 Prepare the Nextruder holder in the same orientation as in the picture. Note the holes for securing the belts.
- 🟢 Poussez l'extrémité de la courroie à travers le trou du milieu dans le trou de gauche de la rangée du bas - laissez 4 à 5 dents dépasser.
- 📄 The belt is secured on this end. You can leave it free for now.

ÉTAPE 50 Y belt guiding: X motor mount



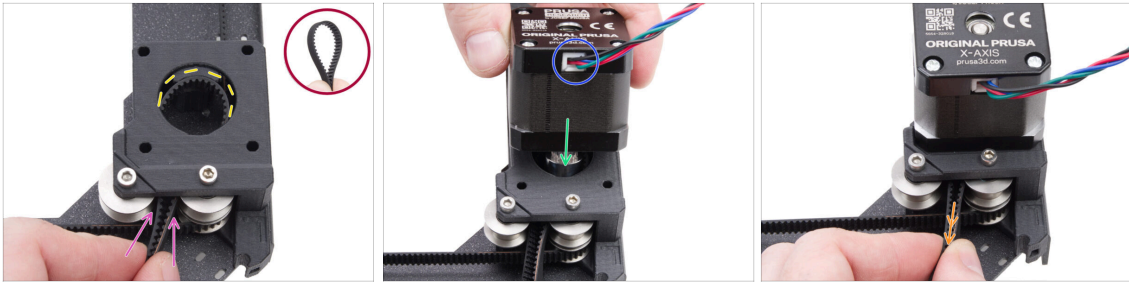
- ⬛ Back to the other end of the Y belt.
- 🟡 Take the other end of the belt and guide it around the lower pulley in the X motor mount.
- 🟣 Push it through the motor mount to the front.
- 🟢 Acheminez la courroie autour de la poulie inférieure droite dans le support du rail linéaire.

ÉTAPE 51 Y belt guiding: securing the belt



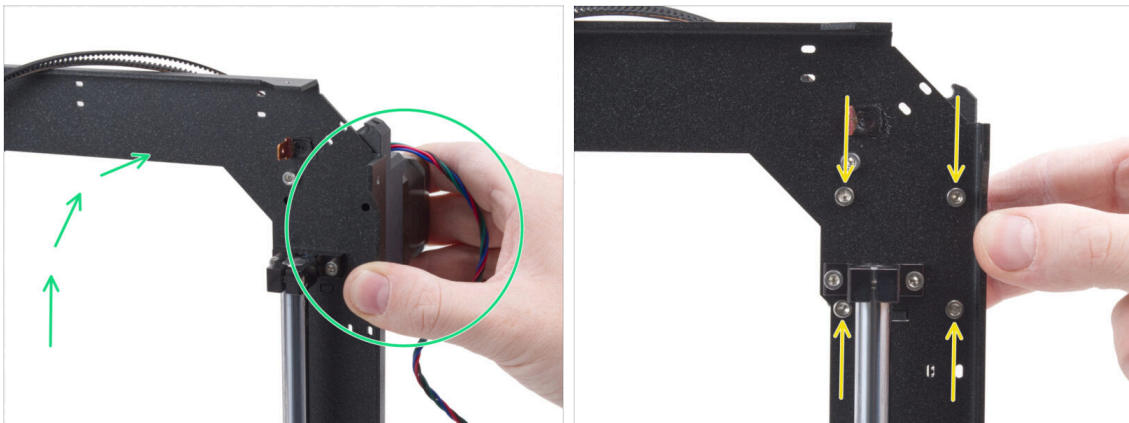
- 🟠 Push the end of the belt through the middle hole to the right hole in the bottom row of the Nextruder holder - leave 4-5 teeth sticking out.
- 📌 ⓘ If it's difficult to reach the Nextruder holder with the belt, you can loosen the belt tensioner screw on the front of the assembly.
- 📌 ⚠ Don't forget to adjust it back after securing the belt.

ÉTAPE 52 X belt guiding: X motor pulley



- From the back of the CoreXY, focus on the motor-mount on the **right** side.
- Create a loop anywhere on the second belt so the belt teeth are pointing inside the loop.
- Push this loop through the space between the upper pulleys inside the motor mount.
- Poussez suffisamment pour que la boucle suive le trou rond supérieur du support moteur aussi étroitement que possible.
- Insert the **X** motor pulley into the motor mount, ensuring the pulley is centered within the belt loop.
- Ensure the motor cable is facing you (rear).
- Pull lightly on the belt loop to encircle the pulley.

ÉTAPE 53 Securing the X-axis motor



- Saisissez fermement l'assemblage du moteur de l'axe X et positionnez l'assemblage du CoreXY verticalement. **Ne faites pas tomber le moteur !**
- ⚠ **Be careful not to pull the entire belt out of the motor.**
- Keep holding the motor with one hand. With the other hand, secure the motor using four M3x35 screws on the underside of the frame. **Tighten firmly.**
- Remettez l'assemblage du CoreXY en position horizontale.

ÉTAPE 54 Y belt guiding: X motor mount



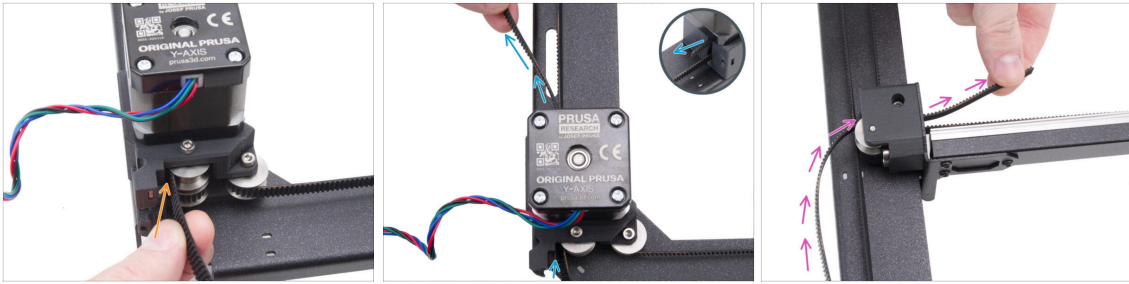
- Guide the right end of the belt around the upper right pulley.
- Push the belt through the part and guide it to the front of the CoreXY plate.
- ⚠ **Don't pull too long so you don't pull the whole belt out.** Remember that the other end is loose. The whole process would then have to be repeated.

ÉTAPE 55 X belt guiding: belt tensioner



- Guidez la courroie autour de la poulie dans le tendeur de courroie.
- Push the belt around the front upper pulley in the linear assembly.
- Route the end of the belt through the middle hole into the right hole - leave 4-5 teeth sticking out.
- ① La courroie est fixée à cette extrémité. Vous pouvez la laisser libre pour le moment.

ÉTAPE 56 X belt guiding: Y motor mount



- Take the other end of the belt and guide it around the upper pulley in the Y motor mount.
- Push the belt through the motor mount.
- Acheminez la courroie autour de la poulie avant supérieure dans le support du rail linéaire.

ÉTAPE 57 X belt guiding: securing the belt



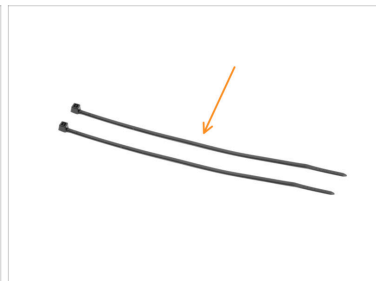
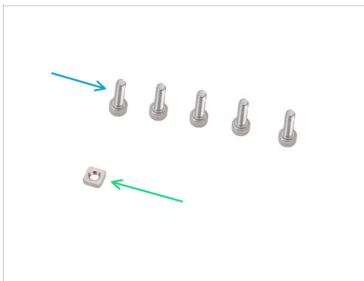
- Push the end of the belt through the middle hole to the left hole in the upper row of the Nextruder holder - leave 4-5 teeth sticking out.

ÉTAPE 58 Checking the belt guidance



Before proceeding, recheck the belt routing according to the illustration.

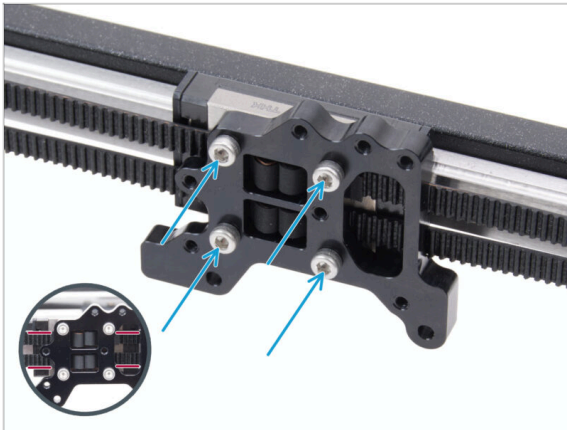
ÉTAPE 59 Bowden guide: parts preparation



● For the following steps, please prepare:

- Bowden-guide (1x) *found in the Printed parts package*
- Vis M3x10 (5x)
- Écrou M3nS (1x)
- Collier de serrage (2x)

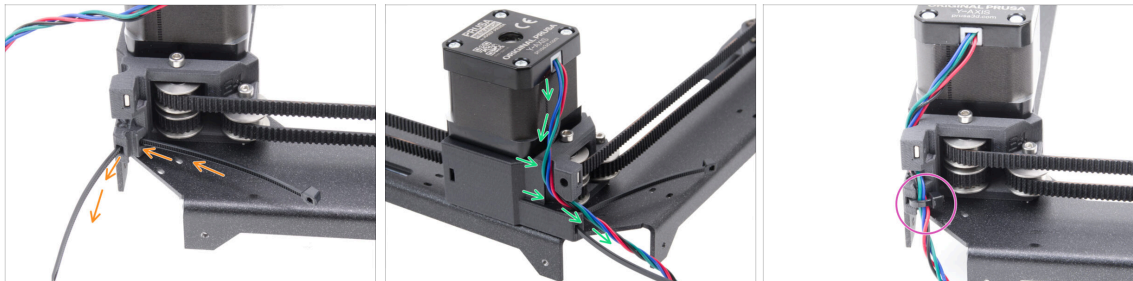
ÉTAPE 60 Securing the Nextruder holder



- Attach the Nextruder holder to the linear rail carriage and secure it using four M3x10 screws.

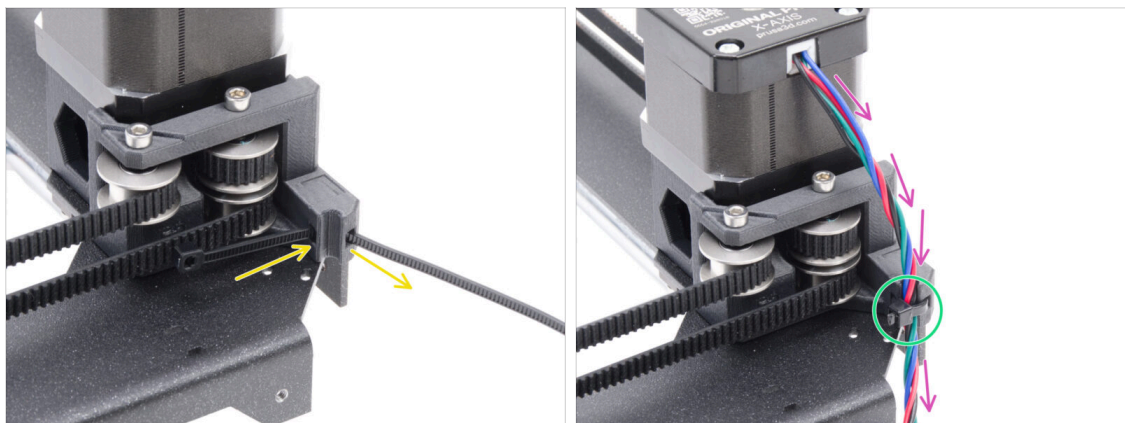
CAUTION: Ensure no belt obstructs the screw. Avoid screwing through the belt!

ÉTAPE 61 Securing the Y motor cable



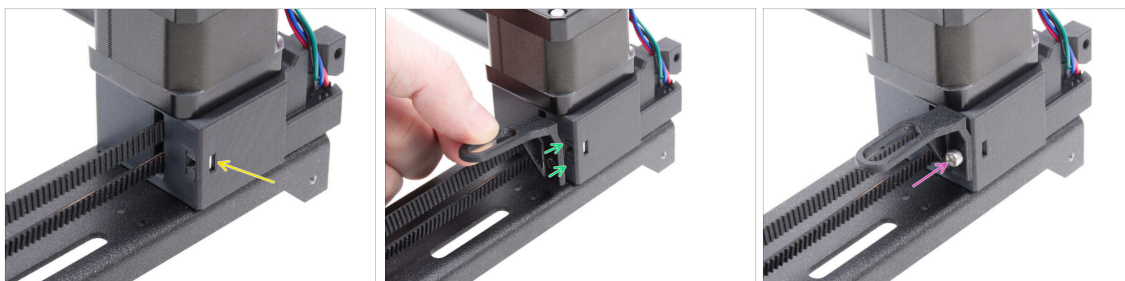
- Poussez le collier de serrage à travers le motor-mount-right (moteur de l'axe Y).
- Route the Y motor cable through the cable channel in the motor-mount-right and over the zip tie.
- Secure the cable with a zip tie and trim the excess.

ÉTAPE 62 Securing the X motor cable



- Poussez le collier de serrage à travers le motor-mount-left (moteur de l'axe X).
- Route the X motor cable through the cable guide in the motor-mount-right and over the zip tie.
- Secure the cable with a zip tie and trim the excess.

ÉTAPE 63 Installing the bowden guide



- Insérez l'écrou M3nS dans le motor-mount-right (moteur de l'axe Y).
- Attach the bowden-guide to the motor-mount-right.
⚠ Note the correct orientation of the part.
- Fixez le bowden-guide en place à l'aide de la vis M3x10.

ÉTAPE 64 White LED strip: parts preparation



For the following steps, please prepare:

White LED strip (1x) found in the Electronics & Fasteners package

CoreXY strut (1x) found in the Metal parts 1/3 package

i La pièce est insérée dans une découpe en mousse et peut ne pas être immédiatement visible au premier coup d'œil.

Vis M3x4rT (2x)

ÉTAPE 65 Sticking the White LED strip



Carefully peel off the protective (paper) layer from the White LED strip.

⚠ After removing the protective layer, the LED strip is adhesive.

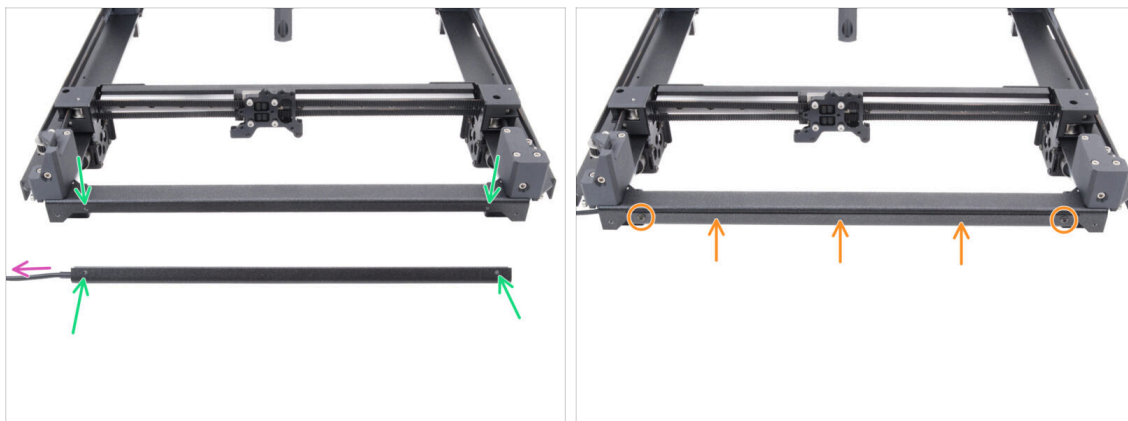
Position the White LED strip near the CoreXY strut to check alignment, but **do not attach it yet**.

⚠ Notez la découpe rectangulaire sur le support, orientez le câble de la bande vers le même côté.

Stick the White LED strip evenly to the strut - on the side with the rectangular cutout.

After sticking, press lightly on the blank areas of the strip to ensure adhesion. **Do not touch LEDs and resistors!**

ÉTAPE 66 Installing the white LED assembly



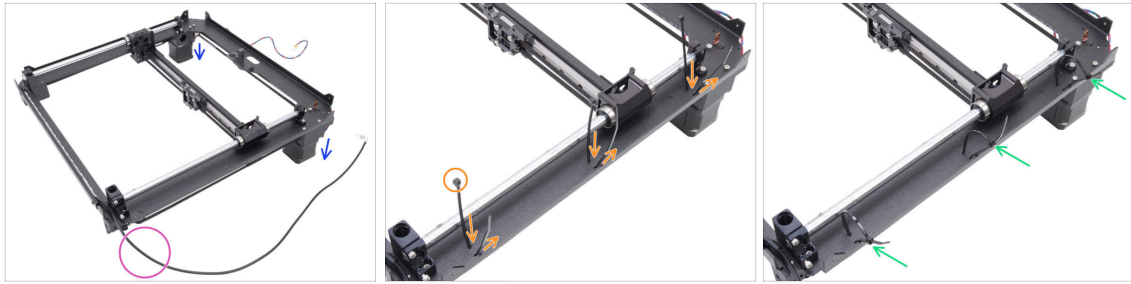
- Take the white LED assembly and attach it to the front of the CoreXY assembly. Align the holes of both parts.
- **The white LED strip cable must point to the left.**
- Attach the LED assembly to the CoreXY plate and secure it with two M3x4rT screws.

ÉTAPE 67 Door sensor & White LED strip: parts preparation



- **For the following steps, please prepare:**
- Door sensor (1x) *found in the CORE XY parts + hinges + HB set package*
- M2.5x10 screw (1x) *silver*
- Collier de serrage (4x)

ÉTAPE 68 Inserting the zip ties



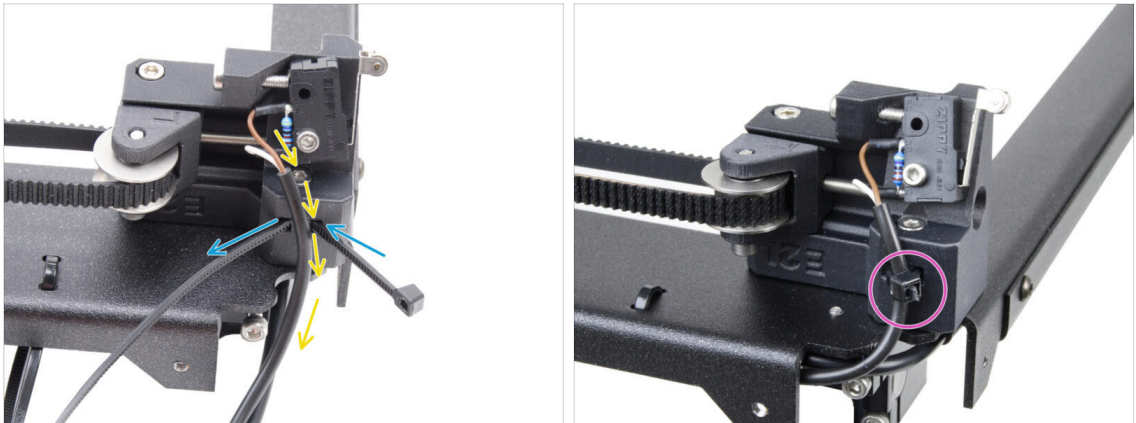
- ◆ Flip the CoreXY assembly upside down and rest it on the motors.
- ◆ Position it with the white LED strip cable facing toward you.
- ◆ Thread three zip ties through the CoreXY plate, ensuring the zip tie heads point inward.
- ◆ Serrez partiellement les colliers de serrage, juste assez pour attraper les premières dents.
- ⚠ **Do not fully secure them yet, as we will route cables through them later.**
- ◆ Flip the assembly back with the motors facing upwards.

ÉTAPE 69 Installing the door sensor



- ◆ Place the door sensor on the left belt tensioner. The lever of the door sensor must face forward.
- ◆ Secure the door sensor with the M2.5x10 screw.
- ◆ Tighten the bolt fully and then loosen 1/4 turn. The sensor must be allowed to move.
- ◆ Depuis l'arrière du tendeur de courroie, serrez la vis M3x12 de manière à ce qu'elle touche le capteur de porte.

ÉTAPE 70 Securing the door sensor cable



- ◆ Push the zip tie through the hole in the left belt tensioner.
- ◆ Guide the door sensor cable through the zip tie.
- ◆ Tighten the zip tie to secure the door sensor cable. Cut off the excess.

ÉTAPE 71 Guiding the cables: LED and door sensor



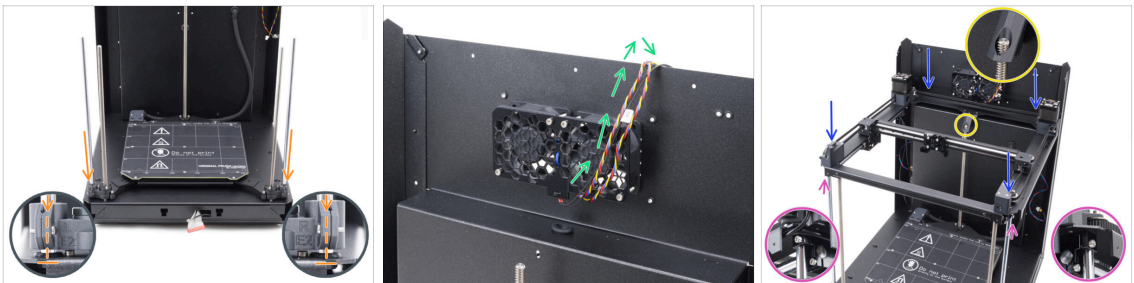
- ◆ Prepare a cardboard box. You can use any box from the kit. *The box used in the picture is for illustrative purposes only.*
- ◆ Flip the CoreXY assembly upside down, positioning the smooth rods on top.
- ◆ Slightly lift and support the front side of the CoreXY assembly with the cardboard box.
- ⚠ **Be careful not to damage the door sensor.**
- ◆ Route the white LED strip cable and the door sensor cable through the zip ties.
- ◆ Tighten all the zip ties to secure the cables. Cut off the excess zip ties.
- ◆ **Cables must be slightly taut and straight.** Excess slack or bends may cause collisions with the Y-axis and lead to damage.

ÉTAPE 72 Smooth rods: parts preparation



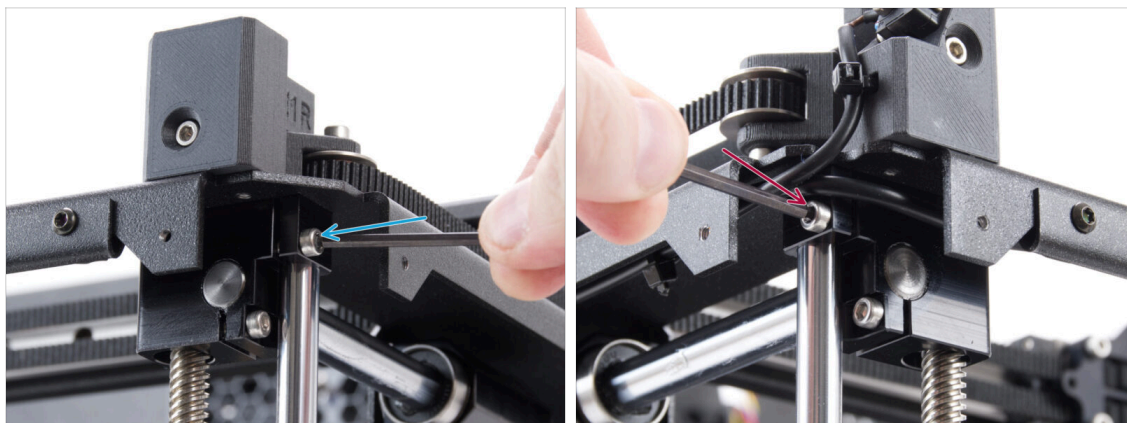
- For the following steps, please prepare:
- Smooth rod 330 x 8 mm (2x) *originally from the Y-axis.*
- Vis M3x8rT (1x)

ÉTAPE 73 Installing the CoreXY assembly



- Carefully insert both smooth rods through the heatbed assembly bearings and into the rod mount part in the base assembly.
- ⚠ **It is a requirement to insert the smooth rod in the axis with the bearing very slowly to prevent the balls from shooting out of the bearing.**
- Temporarily hang the cables from the cooling fans over the rear panel. **There must be a space between the cables and the back panel pocket.**
- Exercise extreme caution when placing the assembly on the smooth rods and back panel assembly.
- ⚠ **Ensure that no cables are pinched.**
 - Ensure both smooth rods are properly seated in the rod holders.
 - The threaded rod of the rear Z motor must pass through the bed-stop-rear part.
- ⚠ **WARNING: When handling the printer, DO NOT lift it by the CoreXY assembly. Always lift it by the base of the entire assembly.**

ÉTAPE 74 Securing the smooth rods

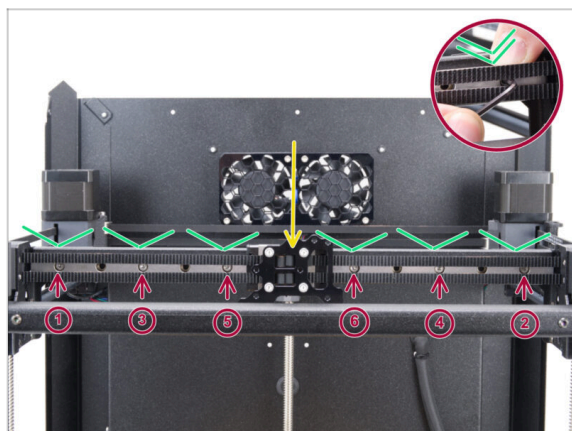


⚠ Check that both smooth rods are seated correctly in the holders.

🔵 Firmly tighten the right M3x10 screw to secure the smooth rod.

🔴 Firmly tighten the left M3x10 screw to secure the smooth rod.

ÉTAPE 75 Aligning the linear rail

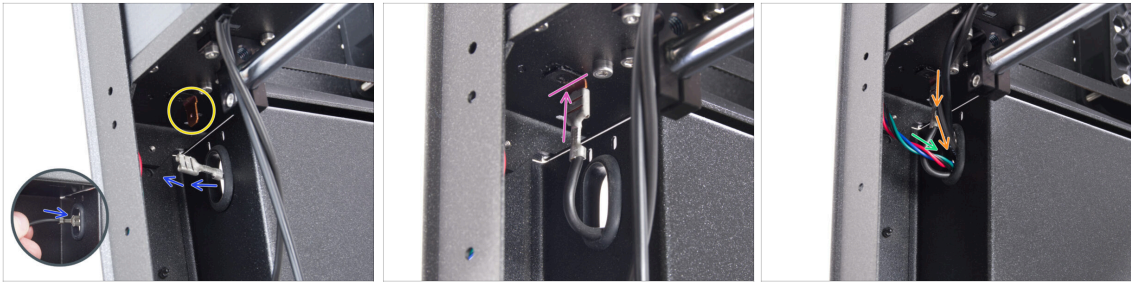


🟡 Move the linear rail carriage to the center.

⚠ Firmly tighten all screws in the order shown in the picture.

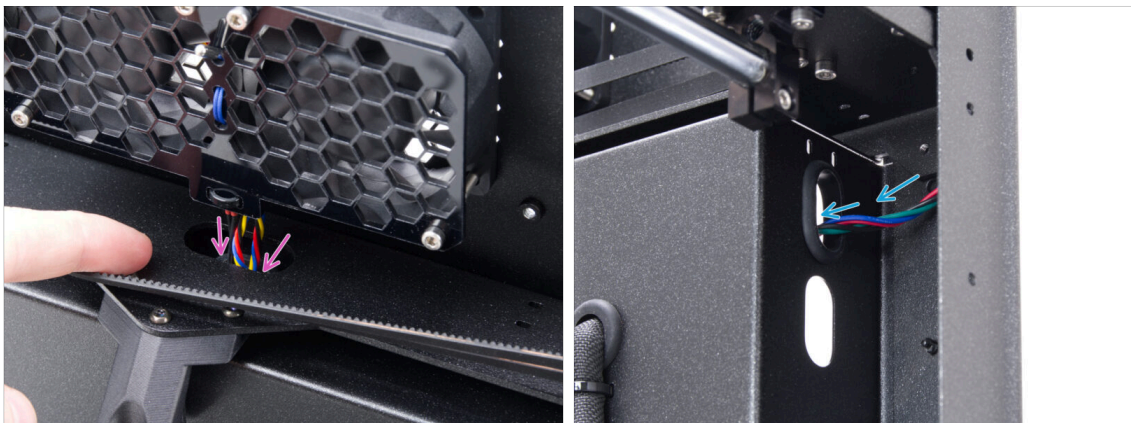
🟢 Push the linear rail down while tightening.

ÉTAPE 76 Guiding the corexy cables



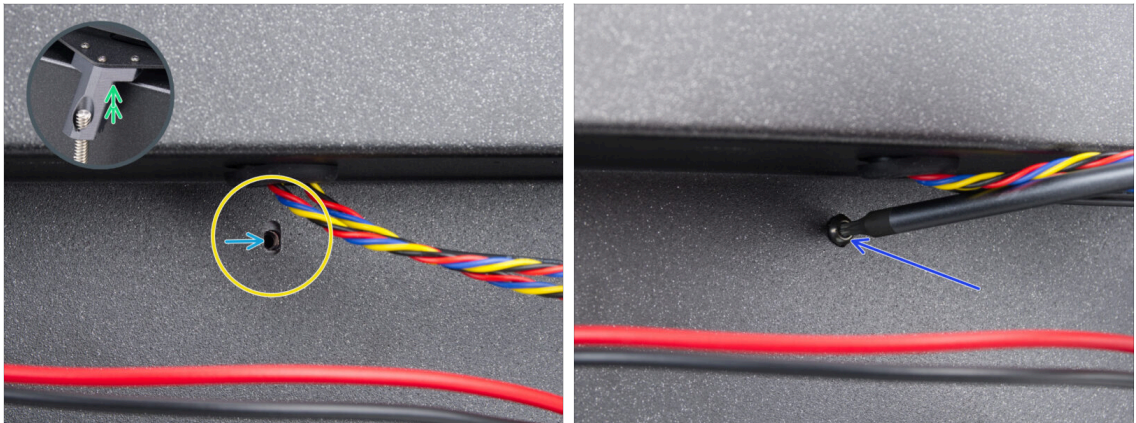
- From the back of the printer, push the FE connector through the oval hole.
- Locate the FE cable connector (number 5) in the rear left corner - under the CoreXY assembly.
- Plug the FE connector onto the Faston on the underside of the CoreXY plate.
- On the same side, push the X motor cable through the oval hole in the back panel.
- Push the White LED strip and Door sensor cables through the oval hole in the back panel.

ÉTAPE 77 Guiding the cooling fan cables



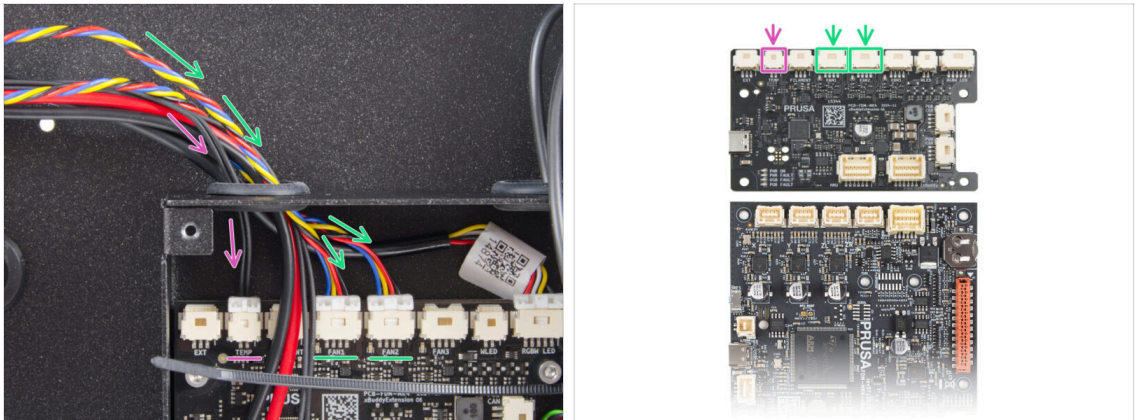
- Push the cooling fan and thermistor cables through the oval hole in the back panel.
- On the right back corner, locate the Y motor cable and push it through the upper oval hole in the back panel.

ÉTAPE 78 Fixation du bed-stop



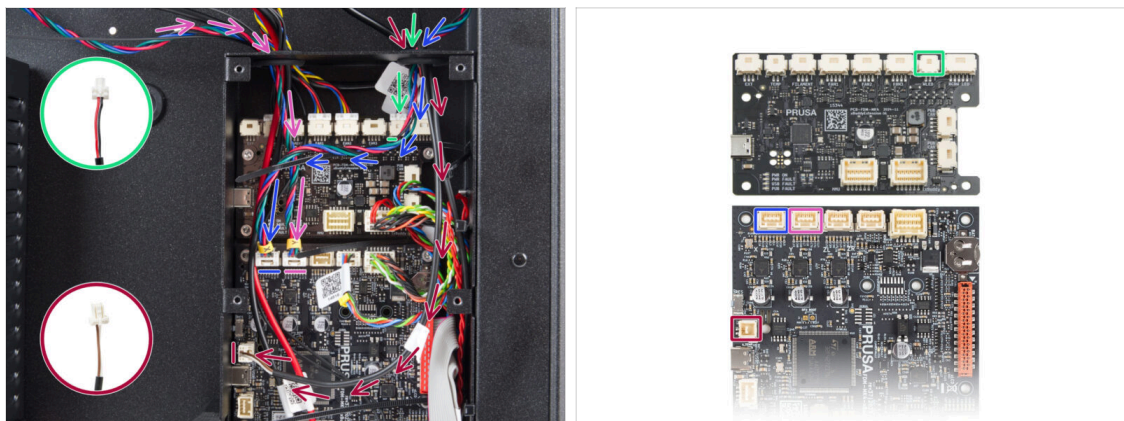
- From the back side, locate the oval screw hole under the cooling fans.
- The oval hole must be flush with the hole in the bed-stop part on the opposite side.
- To compensate, slightly raise the rear of the CoreXY assembly - just a few millimeters.
- After aligning the holes, secure them with an M3x8rT screw.

ÉTAPE 79 Connecting the cooling fans cables



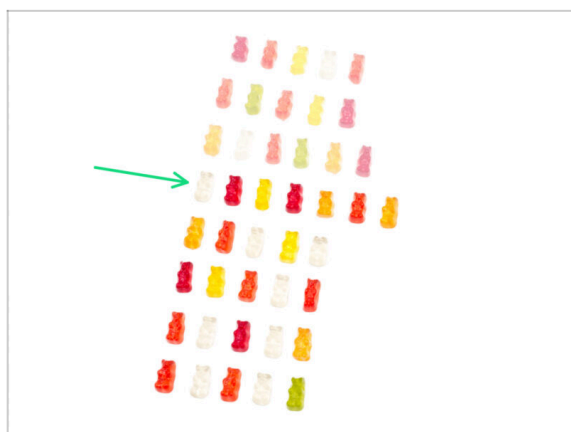
- Route the cooling fan cables through the left hole in the xBuddy box and plug them into the fourth and fifth slots on the xBuddy extension board labeled FAN 1 and FAN 2.
- ⓘ The connection order does not matter, both cables are the same.
- Guide the chamber thermistor cable together with the cooling fan cables.
- Connect it to the second slot from the left on the xBuddy extension board labeled TEMP.

ÉTAPE 80 Connecting the corexy cables



- Guide the X motor cable through the right hole in the xBuddy box. Connect it to the first slot from the left on the xBuddy board.
- Guide the door sensor cable through the right hole in the xBuddy box. Connect it to the lower slot on the left side of the xBuddy board.
- Guide the white LED strip cable through the right hole in the xBuddy box. Connect it to the second slot from the right on the xBuddy extension board.
- Guide the Y motor cable through the left hole in the xBuddy box. Connect it to the second slot from the left on the xBuddy board.

ÉTAPE 81 C'est l'heure des Haribo



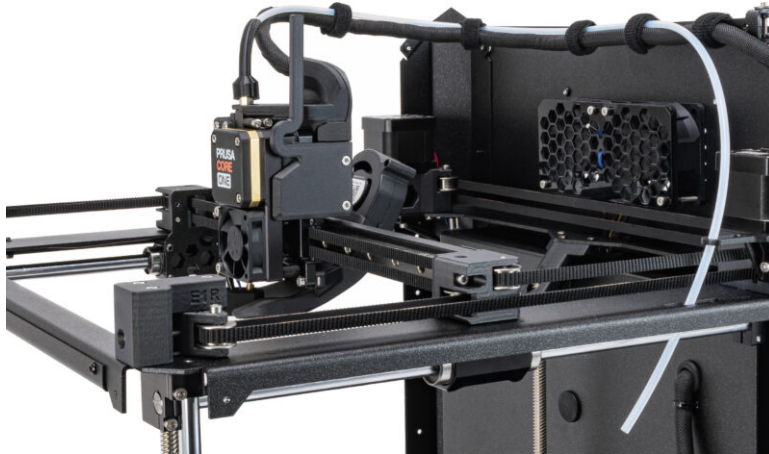
- Think it's snack o'clock again.
- You deserve to eat the whole bag, but keep... Eat just the fourth row.

ÉTAPE 82 Fini

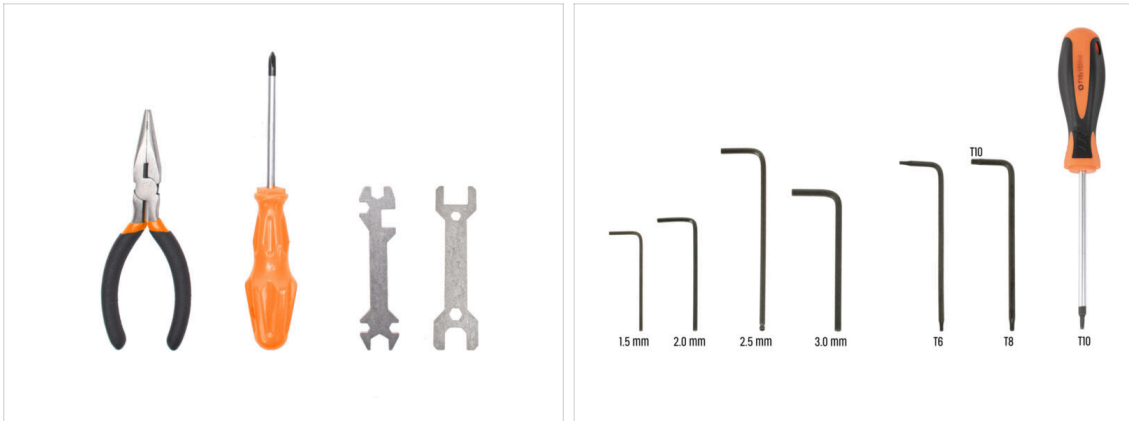


- ◆ Congratulations! You have just assembled and installed the CoreXY assembly.
- ◆ Let's go to the next chapter.

6. Assemblage du Nextruder

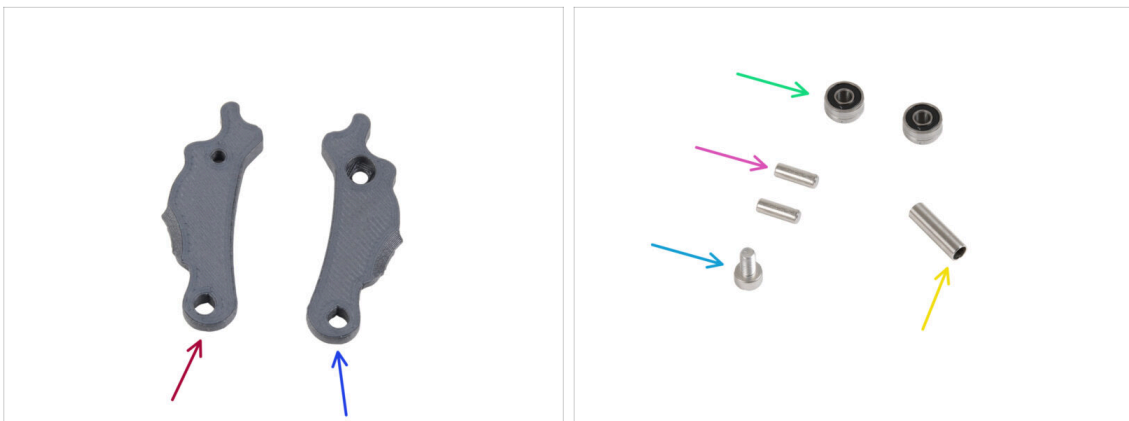


ÉTAPE 1 Tool necessary for this chapter



- **For this chapter, please prepare:**
- Clé universelle
- Clé Allen de 1,5 mm
- Clé Allen de 2,5 mm
- Clé Torx T6
- T10 torx key / T10 torx screwdriver

ÉTAPE 2 Nextruder idler assembly: parts preparation



- **For the following steps, please prepare:**
- Idler-lever-a (1x) *qui se trouve dans le paquet Électronique*
- Idler-lever-b (1x) *found in the Electronics package*
- Bearing 693 2RS (2x) *found in the Electronics package*
- Pin 2.9x8.5 (2x) *found in the Electronics package*
- Vis M3x6 (1x)
- Tubular spacer 13.2x3.8x0.35 (1x) *found in the Electronics package*

ÉTAPE 3 Assembling the extruder idler



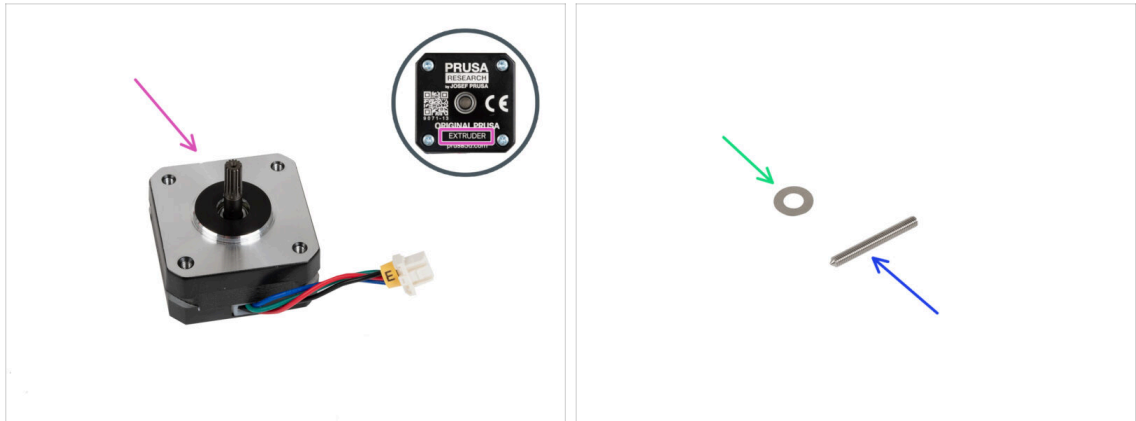
- Place both bearings into the Idler-lever-a.
- Insérez la goupille 2,9x8,5 dans chaque roulement 693 2RS, comme indiqué sur la photo.
- Close it up with the Idler-lever-b part and secure it with the M3x6 screw. **Do not overtighten the screw.** Both bearings must be able to rotate without significant resistance.
- From the same side, push the tubular spacer into the assembly. The "bottom" of the tubular spacer must be flush with the bottom part of the Idler assembly.

ÉTAPE 4 Assembling the extruder: parts preparation I.



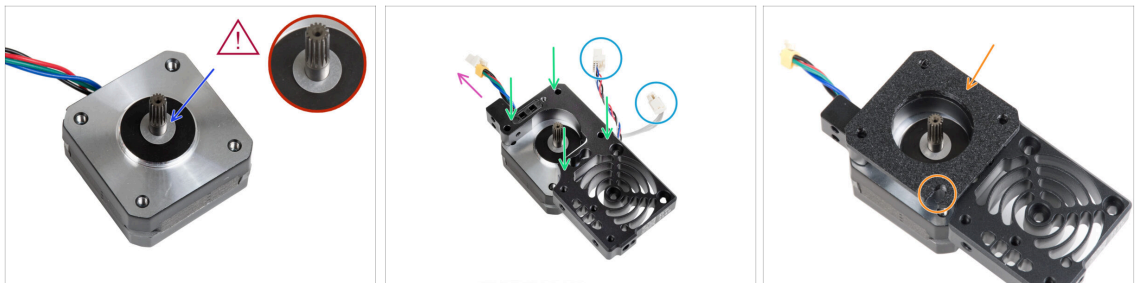
- **For the following steps, please prepare:**
- PG-assembly (1x) *qui se trouve dans le paquet Électronique*
- Heatsink assembly (1x) *found in the Electronics package*
- Main-plate (1x) *found in the Electronics package*
- PG-ring (1x) *found in the Electronics package*
- PG-assembly-adapter (1x) *found in the Electronics package*
- **i** The list continues in the next step...

ÉTAPE 5 Assembling the extruder: parts preparation II.



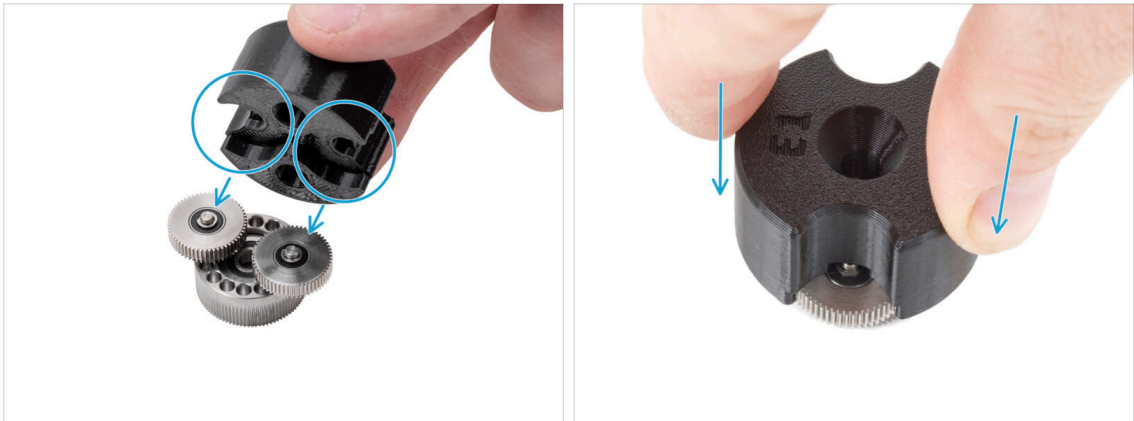
- ◆ Extruder motor (1x) *found in the Motors package*
- ◆ Entretoise 5x10x0,1 mm (1x) *qui se trouve dans le paquet Électronique*
- ◆ Socket set screw M3x25 (1x) *found in the Electronics & Fasteners package*

ÉTAPE 6 Assemblage de l'extrudeur



- ◆ Place the 5x10x0.1 spacer over the shaft on the extruder motor.
- ◆ Placez le dissipateur thermique sur le moteur de l'extrudeur. Notez l'orientation des deux pièces.
- ◆ The motor cable must be facing "up".
- ◆ The heatsink cables must be on the right side.
- ◆ Place the main-plate on the heatsink. Note the orientation of the part. Use the cutout as a guide.
- ⚠ **Before proceeding to the next step, make sure that the 5x10x0.1 spacer is placed on the extruder motor.**

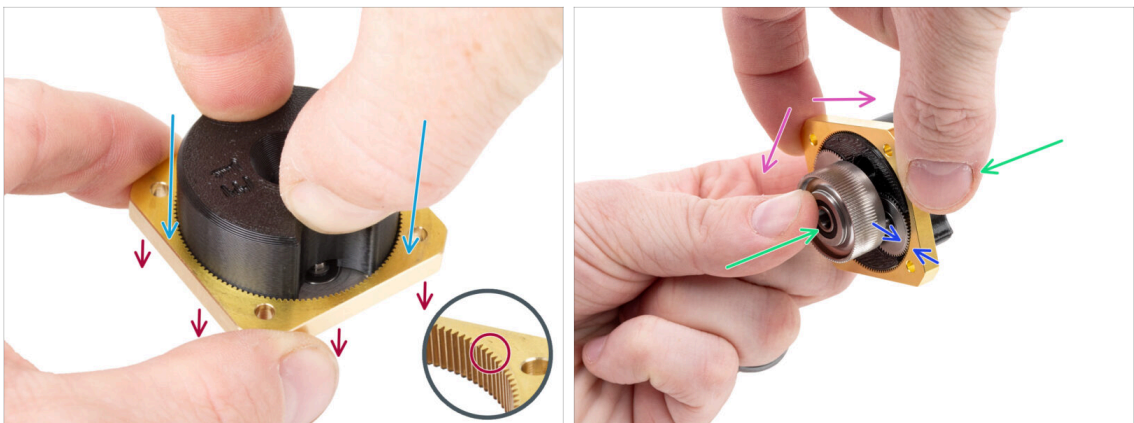
ÉTAPE 7 Assemblage du réducteur



i The following instructions need to be done correctly and carefully. Achieve better understanding and successful assembly by watching the video alongside the guide: prusa.io/PG-assembly

- Après avoir regardé la vidéo, suivez les étapes de ce guide.
- Attach the PG-assembly-adapter on the PG-assembly. Note the pockets for the gears in the adapter.

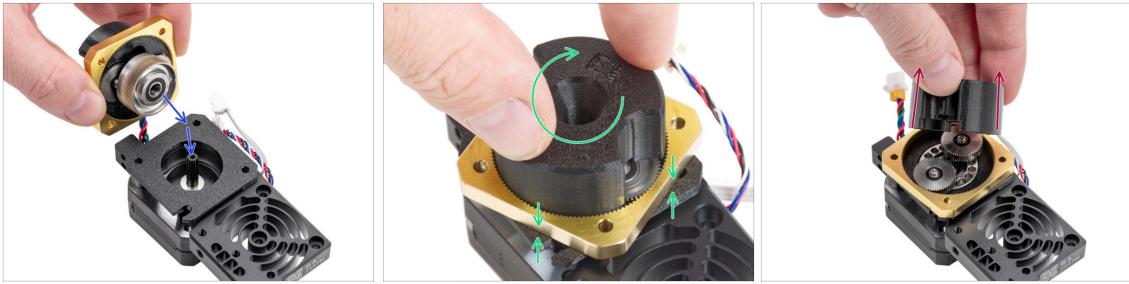
ÉTAPE 8 Assemblage de PG-ring



⚠ Do not assemble the gearbox without the PG-assembly-adapter. This tool is intended to ensure that the gears are correctly fit together.

- Faites glisser le PG-ring sur l'adaptateur.
- Note there is a chamfer on one side of the PG-ring teeth. This side must be facing down (to the PG-assembly).
- Grasp the entire assembly in one hand so that it can be rotated with the PG-ring.
- With the other hand, slide the PG-ring onto the PG assembly in a wobbling motion (move the PG-ring left and right repeatedly) - a quarter turn is enough.
- Stop when the surfaces of the gears are approximately flush with the surface of the PG ring.

ÉTAPE 9 Assemblage du PG-assembly



 **Proceed very carefully in this step.**

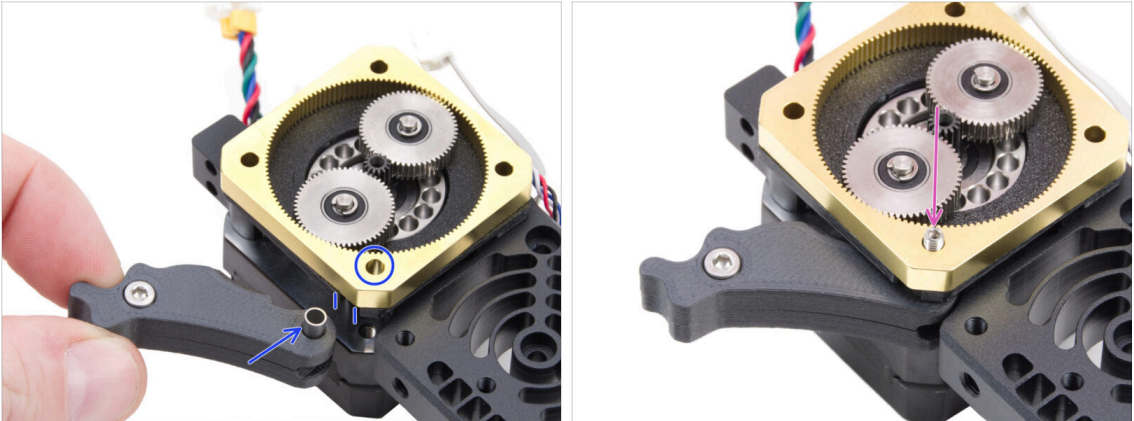
-  Maintenez la position du PG-assembly et fixez-le sur l'arbre du moteur de l'extrudeur.
-  Very gently and freely rotate with the whole PG assembly (PG-assembly-adapter, PG-assembly and PG-ring) until it drops down so that there is no gap between the assembly and the main-plate. **Do not push on the assembly.**
-  Retirez le PG-assembly-adapter.

ÉTAPE 10 Vérification du PG-assembly



-  Attach the PG-assembly-adapter back on the PG-assembly again to verify that all parts are properly seated.
-  Faites pivoter avec le PG-assembly-adapter. **L'assemblage PG doit pouvoir tourner facilement sans avoir à exercer beaucoup de force.**
-  Remove the PG-adapter. You will no longer need it during assembly. We recommend keeping it for maintenance.
-  Ensure that the PG-assembly is not sticking out above the PG-ring. It should be positioned lower than the level of the PG-ring's surface or at the same level as the ring.
-  Ensure that the gap between the PG-ring and the Main-plate is minimal. If a significant gap is observed, disassemble the planetary gear assembly and reposition it.

ÉTAPE 11 Assembling the Nextruder idler



- Insert the idler assembly between the PG-ring and the extruder motor. There is a cutout for the spacer in the main-plate. Line up the idler spacer with the hole in the PG-ring.
- Fixez les deux pièces avec la vis sans tête 3x25. **Ne serrez pas trop la vis ! La vis dépasse du PG-ring après le serrage.**

ÉTAPE 12 Gear lubrication: parts preparation



- **For the following steps, please prepare:**
- Capot Avant (1x) *qui se trouve dans le paquet des pièces imprimées*
 - ① Le logo sur le boîtier avant du Nextruder restera **PRUSA CORE ONE**.
- Vis M3x25 (3x)
- Lubricant (1x) *found in the Electronics & Fasteners package*
- Several paper towels to wipe grease from your hands.

ÉTAPE 13 Lubrification de l'engrenage



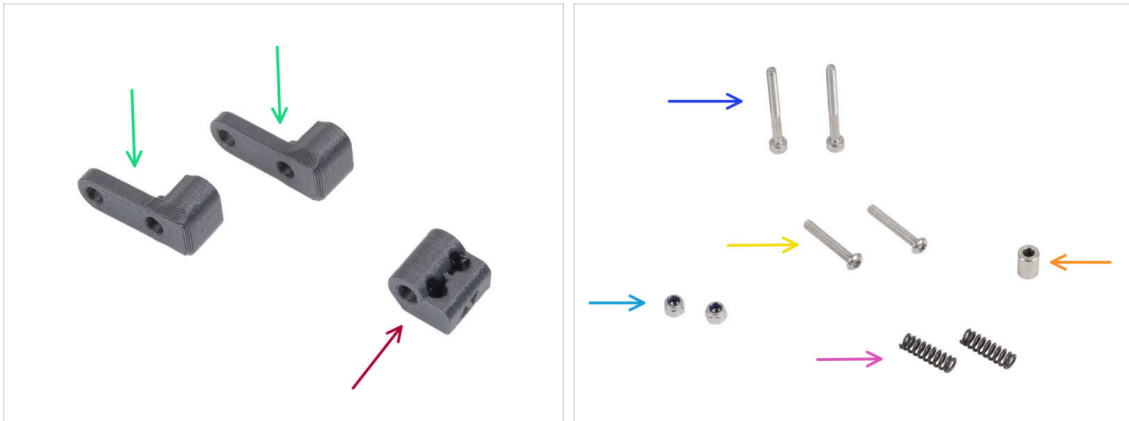
- Remove the cap from the lube. Use the spike on the opposite side of the cap to pierce a hole in the lube tube opening.
- Appliquez une petite quantité de lubrifiant sur la pointe du collier de serrage, puis étalez-le sur les engrenages.
- Apply a small amount of Prusa Lubricant **all around** the PG-ring and PG-assembly teeth.
- Close the lubricant; it is no longer needed for the assembly.

ÉTAPE 14 Covering the planetary gear



- Using the paper towel, wipe off the lubricant residue from the face surface of the PG-ring.
- Placez le capot avant sur le réducteur et fixez-le avec trois vis M3x25. **Ne les serrez pas complètement** à ce moment-là.
- ① The screws on the front case will be completely tightened during the self-test in the final chapter.

ÉTAPE 15 Assembling the Idler-swivel: parts preparation



● For the following steps, please prepare:

- Idler-swivel (2x) *qui se trouve dans le paquet Électronique*
- Idler-nut (1x) *found in the Electronics package*
- Vis M3x30 (2x)
- Vis M3x20rT (2x)
- Écrou M3nN (2x)
- Spring 15x5 (2x) *found in the Electronics package*
- Spacer 6x3.1x8 (1x) *found in the Electronics package*

ÉTAPE 16 Assemblage de l'idler-swivel



- Push the M3x20rT screw all the way through one of the idler-swivel.
- Faites glisser l'entretoise sur la vis.
- Place the second idler-swivel from the opposite side on the screw.
- From the other side, attach the M3nN nut onto the screw. Hold the nut using the universal wrench and tighten the screw. **Tighten just lightly!** The spacer must rotate freely.

ÉTAPE 17 Assemblage de l'Idler-nut



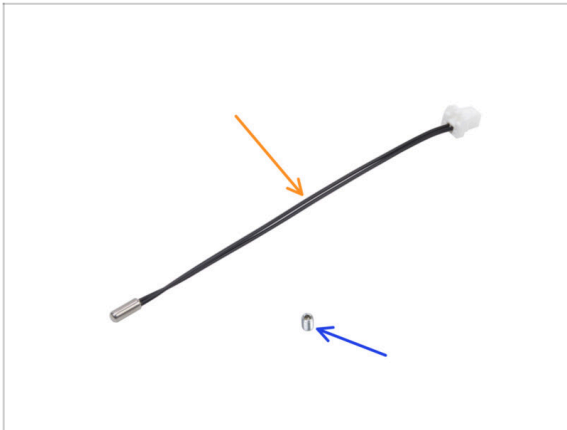
- ✚ Insert the Idler-nut into the Idler-swivel assembly. Make sure that both parts are oriented correctly according to the picture.
- ✚ Fixez les deux pièces ensemble en insérant la vis M3x20rT du même côté, comme la première vis.
- ✚ Secure the screw with M3nN nut. **Do not overtighten the nut.** It must be possible to move with the Idler-swivel on the Idler-nut.

ÉTAPE 18 Mounting the Idler-swivel assembly



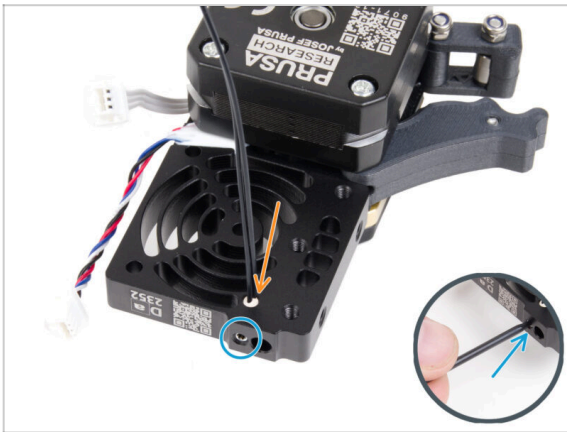
- ✚ Attach the spring 15x5 on both M3x30 screws.
- ✚ Poussez les deux vis avec les ressorts dans les trous de la saillie du dissipateur thermique. Il n'y a pas de filetage à l'intérieur.
- ✚ Attach the Idler-swivel assembly on the screws. See the correct orientation of the Idler-nut. The side with version marking must be visible. See the picture.
- ✚ Tighten both screws. **Stop tightening as soon as the screw tips reach the front face of the idler nut.**

ÉTAPE 19 NTC thermistor: parts preparation



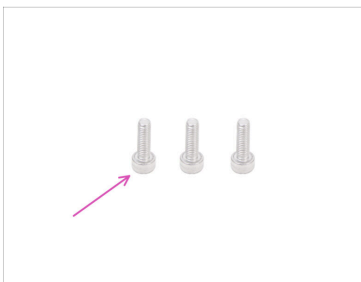
- For the following steps, please prepare:
- Thermistance NTC 90 mm (1x) *qui se trouve dans le paquet Électronique*
- M3x4T grub screw (1x)

ÉTAPE 20 Assembling the NTC thermistor



- On the **extruder motor side**, insert the NTC thermistor into the hole in the heatsink.
- Fixez-la avec la vis de blocage M3x4T. Vissez-la à fond. **Serrez doucement, mais fermement** à l'aide de deux doigts et du côté court de la clé Torx T6. Appliquer plus de force peut causer des dommages permanents au filetage.

ÉTAPE 21 Mounting the Nextruder: parts preparation



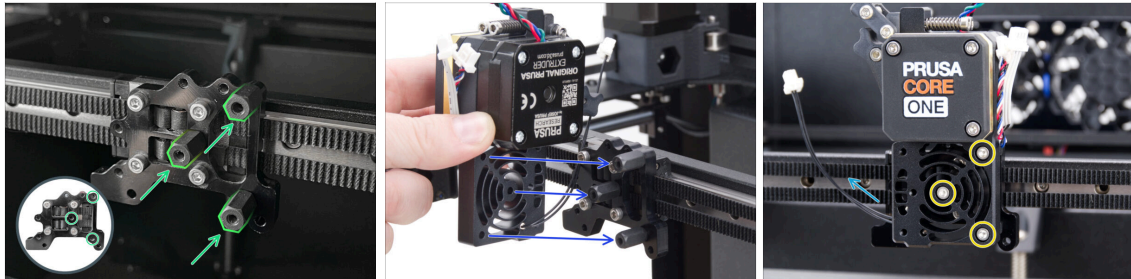
- For the following steps, please prepare:
- Entretoise du Nextruder (3x) *qui se trouve dans le paquet Électronique & Visserie*
- Vis M3x10 (3x)
- Cardboard box (1x) *used as temporary heatbed protection*
- ① Hint: You can use any cardboard box from the kit package.

ÉTAPE 22 Protection du plateau chauffant



- Place an empty cardboard box on the heatbed, ensuring it covers as much of the surface as possible.
- i** Cela protégera le plateau chauffant des chutes de pièces.

ÉTAPE 23 Montage du Nextruder



- Screw three Nextruder spacers to the Nextruder holder. Tighten the spacers firmly.
- Placez l'assemblage du Nextruder sur les entretoises.
- Align the holes in the Nextruder with the spacers and secure it with three M3x10 screws. **Do not overtighten the screws.**
- Ensure the NTC cable is pointing to the left.

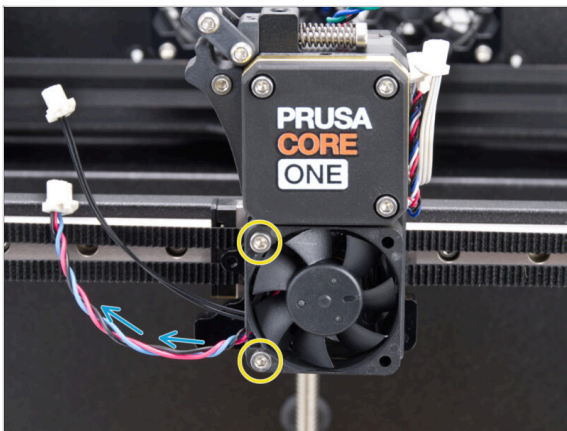
ÉTAPE 24 Ventilateur de la Hotend : préparation des pièces



◆ For the following steps, please prepare:

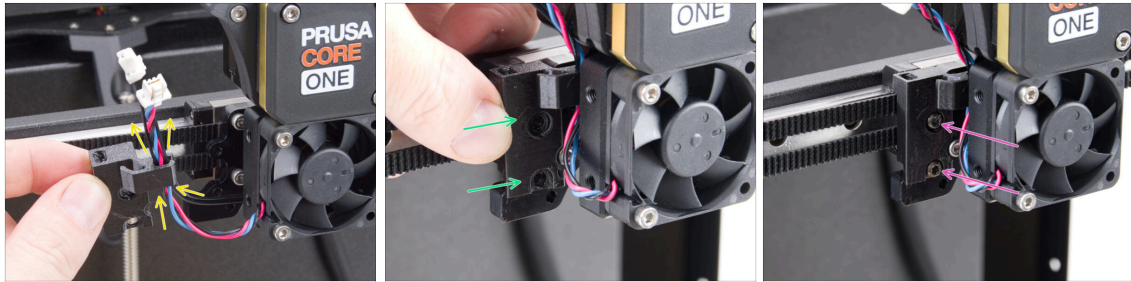
- ◆ Ventilateur de la Hotend (1x) *qui se trouve dans le paquet Électronique*
- ◆ Hotend-cable-clip (1x) *found in the Printed parts package*
- ◆ Vis M3x4rT (2x)
- ◆ Vis M3x18 (2x)

ÉTAPE 25 Installation du ventilateur de la Hotend



- ◆ Attach the hotend fan onto the heatsink with two M3x18 screws on the left side. **Tighten the screw gently, but firmly, otherwise the plastic housing may crack.**
- ⚠ There is a sticker on the hotend fan, the sticker must be on the rear side of the fan - not visible.
- ◆ The cable must be pointing towards the lower-left corner.

ÉTAPE 26 Guidage des câbles du ventilateur de la Hotend



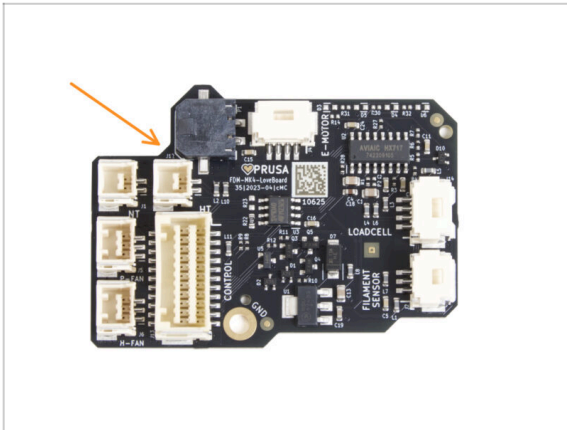
- ✦ Take the Hotend-cable-clip in the same position as shown and guide the **heatsink fan cable** together with the **NTC thermistor cable** through the right cable hook.
- ✦ Attach the Hotend-cable-clip to the Nextruder holder.
- ✦ Secure it using two M3x4rT screws.

ÉTAPE 27 LoveBoard: parts preparation I.



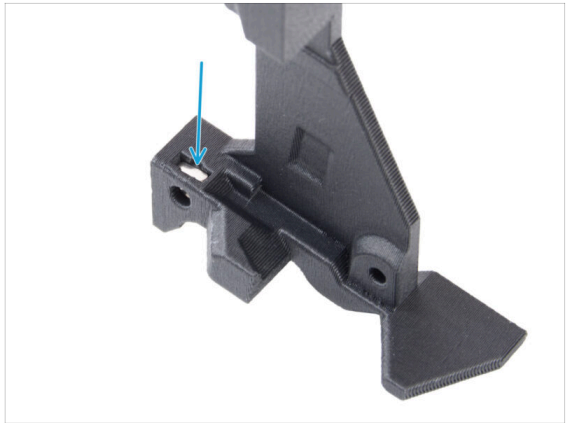
- ✦ **For the following steps, please prepare:**
- ✦ Printhead-cover (1x) *found in the Printed parts package*
- ✦ Loveboard-mount (1x) *found in the Printed parts package*
- ✦ Main cable (1x) *found in the Electronics & Fasteners package*
- ⓘ Note: Cable color may vary depending on the batch. This does not affect the procedure.
- ✦ Vis M3x10 (4x)
- ✦ Vis M3x8rT (1x)
- ✦ Écrou M3nS (5x)
- ⓘ The list continues in the next step...

ÉTAPE 28 LoveBoard: parts preparation II.



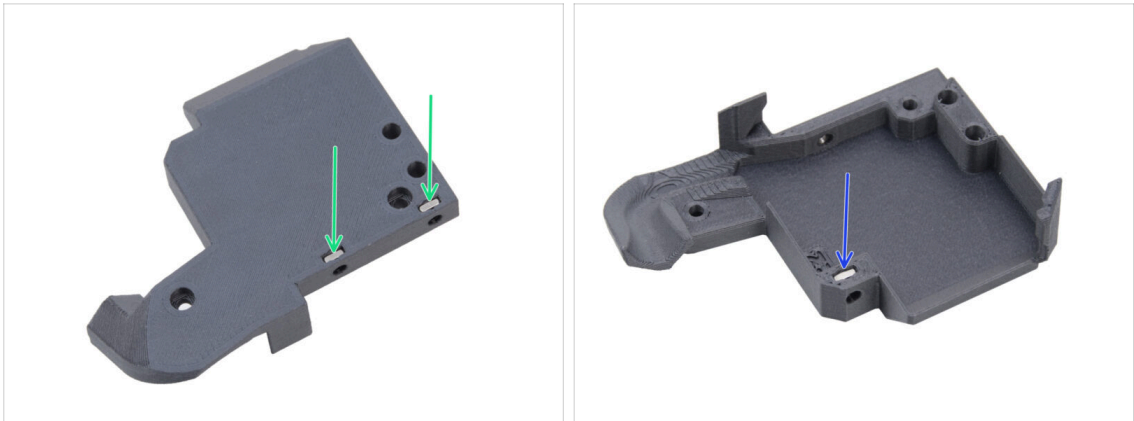
- For the following steps, please prepare:
- LoveBoard (1x) found in the Electronics package

ÉTAPE 29 Assemblage du Loveboard-mount



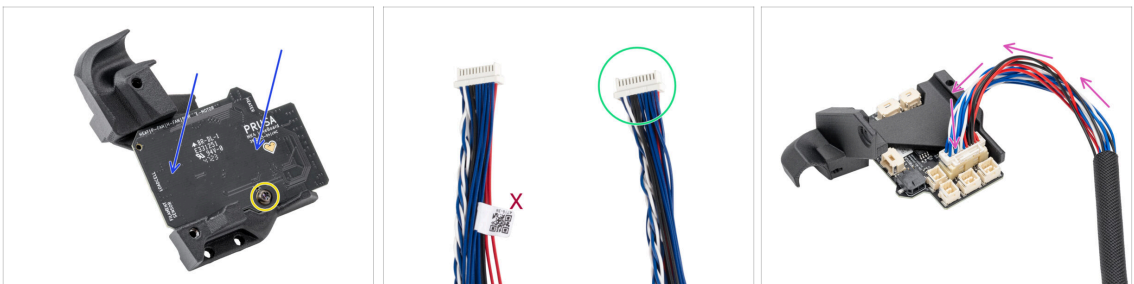
- Locate the U-shaped cable channel on the Loveboard-mount and insert an M3nS nut into the nearby hole.
- Use a 2.5mm Allen key to push the nut all the way in.
- On the opposite side of the part, insert an M3nS nut and push it into place.

ÉTAPE 30 Assemblage du Printhead-cover



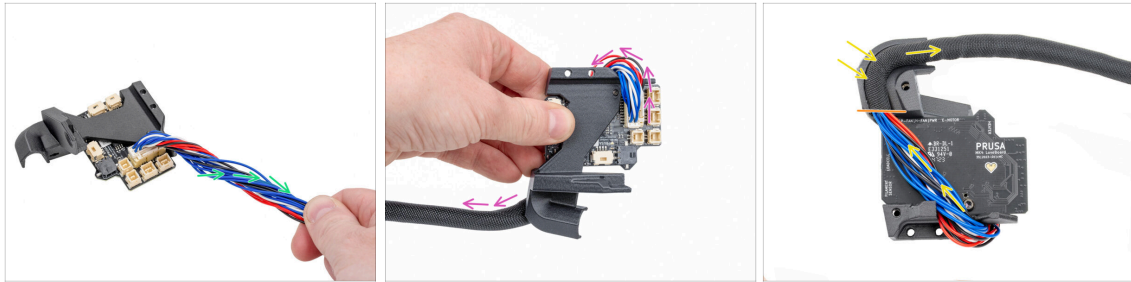
- From the back of the printhead-cover, insert two M3nS nuts into the part.
- From the other side of the printhead-cover, insert one M3nS nut into the part.

ÉTAPE 31 Assemblage de la LoveBoard



- Place the LoveBoard to the Loveboard-mount. Note the correct orientation - the connectors must be facing downwards.
- Align the holes with both parts and secure the board with the M3x8rT screw. **Do not overtighten it**, it might damage the part.
- Take the end of the extruder main cable without the white label.
- Turn the Loveboard-mount upside down and connect the Main cable to the LoveBoard.

ÉTAPE 32 Guiding the main cable



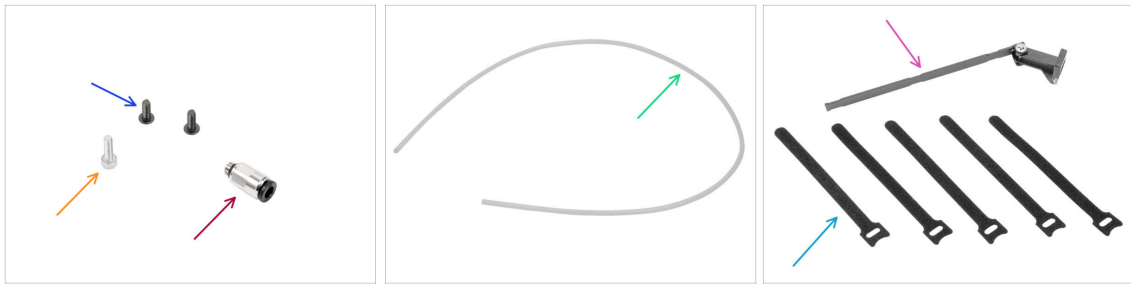
- ✚ Twist the main cable half a turn.
- ✚ Fold the main cable over the LoveBoard to its opposite side.
- ⬛ Turn the LoveBoard assembly upside down.
- ✚ Guide the main cable over the LoveBoard through the cable channel in the Loveboard-mount.
- ✚ L'extrémité de la gaine textile doit être alignée avec le bord de la pièce en plastique.

ÉTAPE 33 Mise en place du cache de la LoveBoard



- ✚ Insert two M3x10 screws into the Loveboard-holder.
 - ⚠ Ensure you insert the screws from the correct side. Use the LoveBoard logo on the board as a reference.
- ✚ Cover the LoveBoard with the Printhead-cover.
 - ⚠ **Avoid pinching any wires in the main cable.**
- ✚ Fix both parts together using two M3x10 screws.
- ✚ Check that there is no large gap or pinched textile sleeve between the parts.

ÉTAPE 34 Swingarm: parts preparation I.



● For the following steps, please prepare:

● Vis M3x8rT (2x)

● Vis M3x10 (1x)

● Fitting M5-4 (1x) *found in the Electronics & Fasteners package*

● PTFE tube 710 x 4 x 2.5 (1x) *found in the CoreXY parts + Hinges set package*

● Swingarm assembly (1x) *found in the Metal parts 3/3 package*

● Cable tie (5x) *found in the Electronics & Fasteners package*

ⓘ Packed in a stack and must be separated.

ⓘ The list continues in the next step...

ÉTAPE 35 Swingarm: parts preparation II.

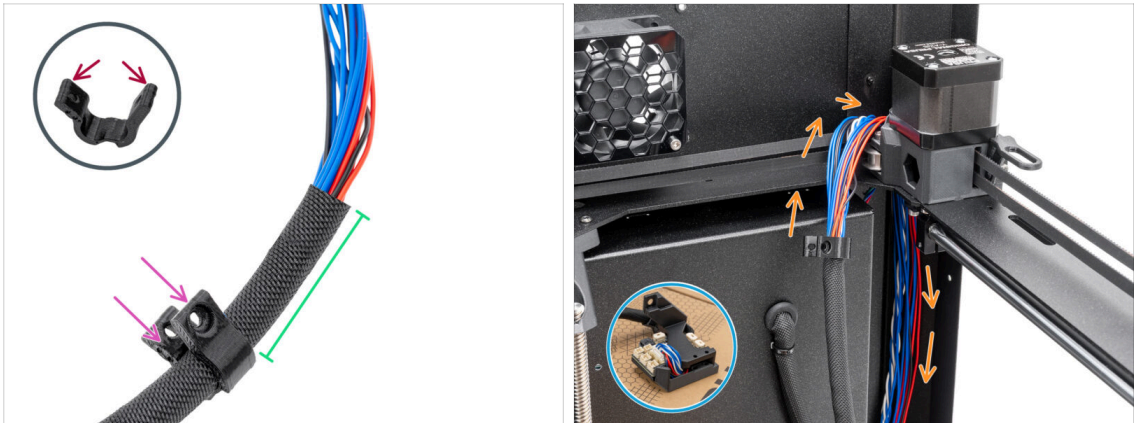


● For the following steps, please prepare:

● Bowden-bend (1x) *found in the Printed parts package*

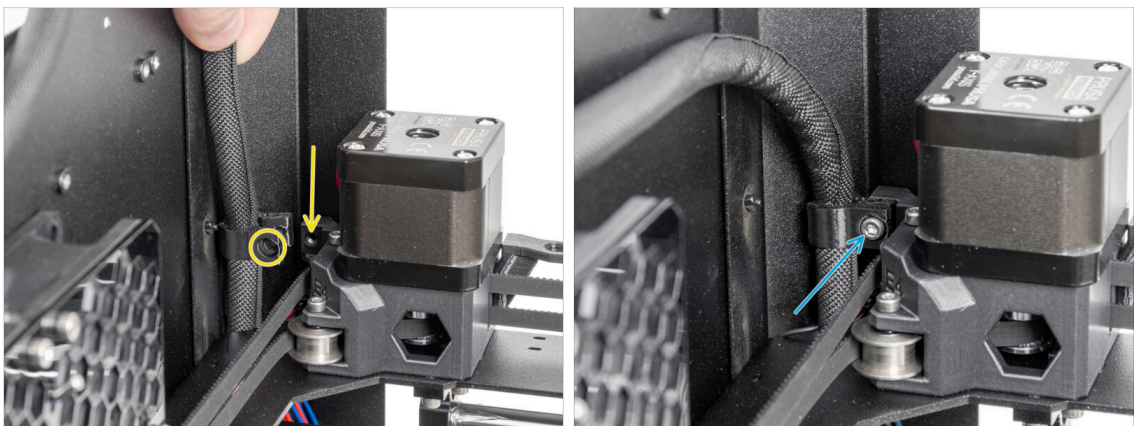
● Main-cable-clip (1x) *found in the Printed parts package*

ÉTAPE 36 Guiding the main cable



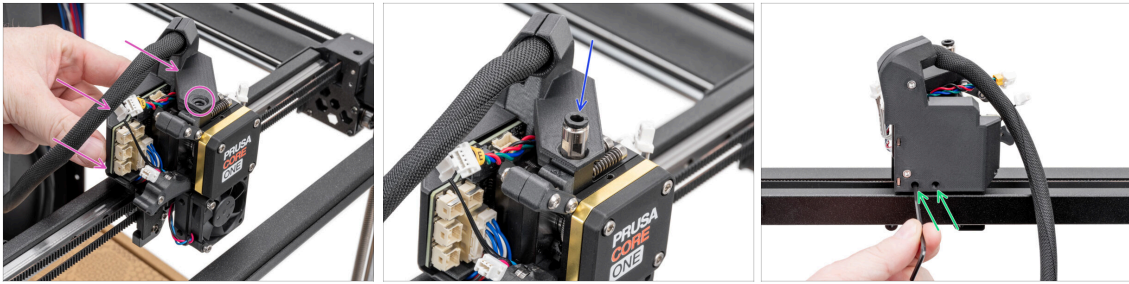
- Carefully open the Main-cable-clip. Be careful not to crack the part.
- Insert the main cable into the Main-cable-clip.
- Placez le Main-cable-clip à environ 5-15 cm (2-6 pouces) de l'extrémité de la gaine textile et fermez le clip.
- Place the LoveBoard assembly on the cardboard box on the heatbed.
- Push the main cable behind the CoreXY assembly in the right rear corner.

ÉTAPE 37 Mounting the main cable



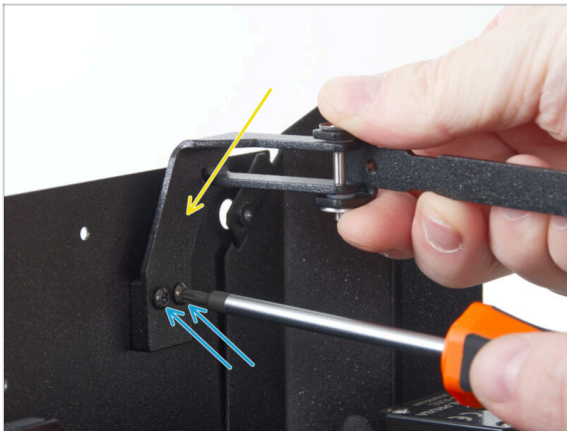
- In the right corner of the printer on the Y motor assembly, locate the hole in the plastic part and align it with the main-cable-clip.
- Fix the main-cable-clip with the cable to the hole using the M3x10 screw.

ÉTAPE 38 Fixation de l'assemblage de la LoveBoard



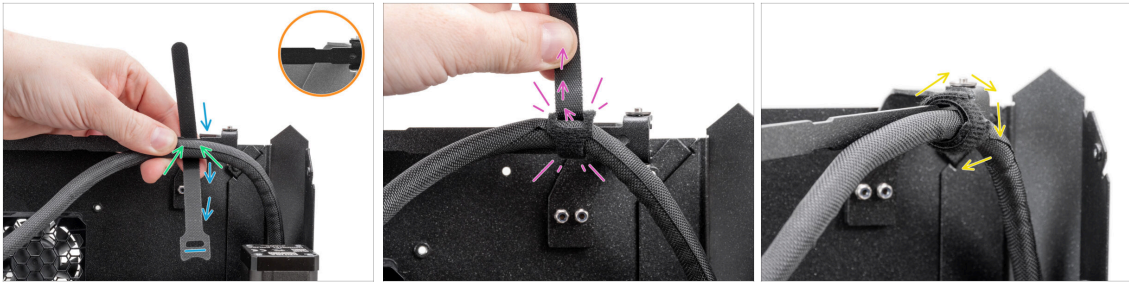
- ◆ From the back of the Nextruder, attach the LoveBoard assembly to the Nextruder.
- ◆ Align the hole in the Loveboard-mount with the threaded hole in the top of the heatsink (Nextruder).
- ◆ Insert and tighten the fitting M5-4 to the heatsink. Use the universal wrench.
- ◆ From the back of the Nextruder, tighten the two M3x10 screws to secure the LoveBoard assembly.

ÉTAPE 39 Montage du SwingArm



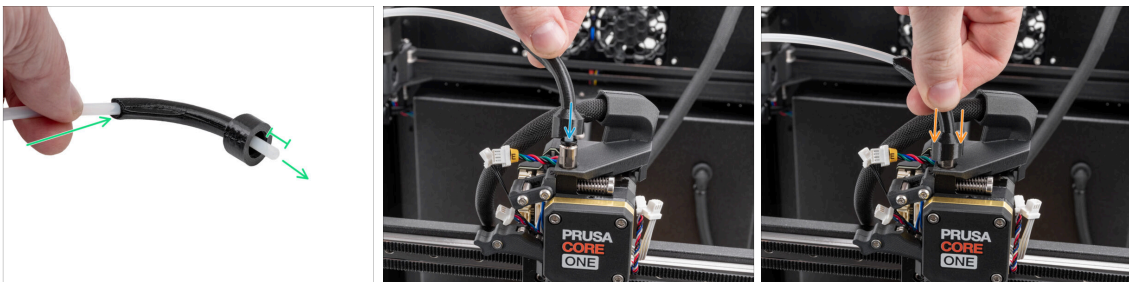
- ◆ Attach the swingarm assembly to the pair of threaded holes on the back panel near the top right corner.
- ◆ Secure it with two M3x8rT screws.
- ⚠ Do not overtighten the screws, as this may strip the threads.

ÉTAPE 40 Fixation du câble principal



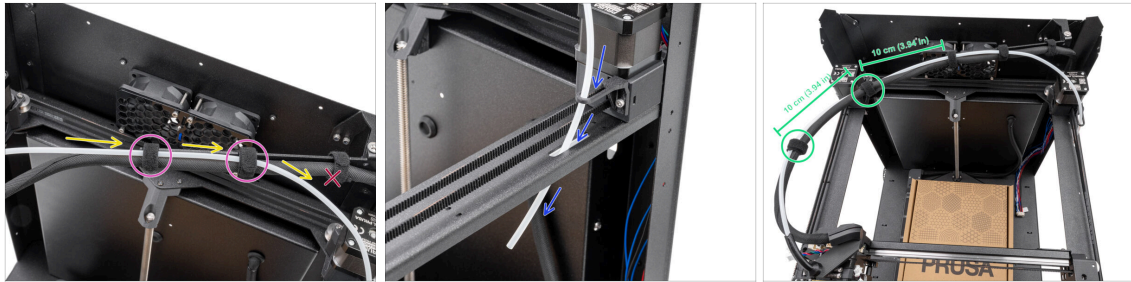
- 🟠 Notice the cutouts on the swingarm.
- 🟢 Position the main cable at the first cutout on the swingarm.
- 🔵 Place one cable tie behind the first cutout on the swingarm, ensuring the correct orientation of the zip strip.
- 🟡 Thread the cable tie through its eyelet, wrapping it around the swingarm and main cable.
- ⬛ Tighten the cable tie as much as possible.
- 🟡 Wrap the cable tie around.

ÉTAPE 41 Insertion du tube PTFE



- 🟢 Push one end of the PTFE tube through the bowden-bend and keep protruding at least 1 cm (0.39 in) of the tube.
- 🔵 Insert the PTFE tube into the fitting M5-4 on the Nextruder. Push it all the way down.
- 🟠 Slide bowden-bend down to cover the fitting M5-4.

ÉTAPE 42 Fixation du tube PTFE



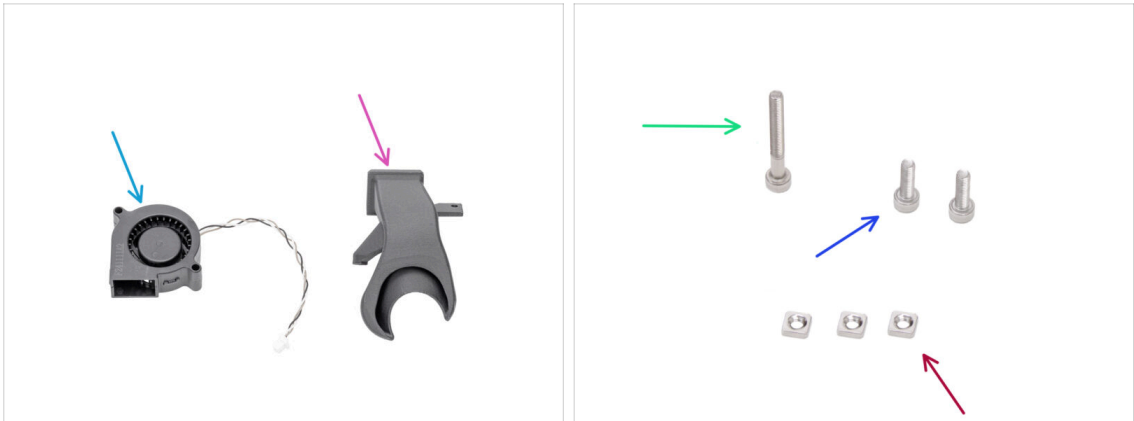
- ◆ Route the PTFE tube in parallel with the main cable, ensuring the PTFE tube stays above the main cable.
- ◆ Secure the PTFE tube and main-cable to the swingarm using two cable ties to the remaining cutouts.
- ⚠ Do not pass the PTFE tube through the first cable tie on the swingarm.
- ◆ Push the free end of the PTFE tube through the Bowden guide and CoreXY plate downward. Leave the end hanging freely.
- ◆ Merge the PTFE tube and main-cable with the remaining two cable ties, leaving a 10 cm (3.94 in) distance between them.

ÉTAPE 43 Vérification du mouvement



- ◆ Manually move the XY axes to their end positions several times and ensure that:
 - ◆ The main cable is not too tight and does not pull the Nextruder backward.
 - ◆ Le câble principal ne forme pas un arc excessivement grand.
 - ◆ Si le câble est trop tendu ou forme un grand arc, desserrez légèrement la vis du main-cable-clip et tirez le câble vers le haut ou vers le bas de quelques millimètres. Ensuite, serrez la vis et testez à nouveau.

ÉTAPE 44 Ventilateur d'impression : préparation des pièces



● For the following steps, please prepare:

- Print fan (1x) found in the Electronics package
- Fan-shroud (1x) found in the Printed parts package
- Vis M3x25 (1x)
- Vis M3x10 (2x)
- Écrou M3nS (3x)

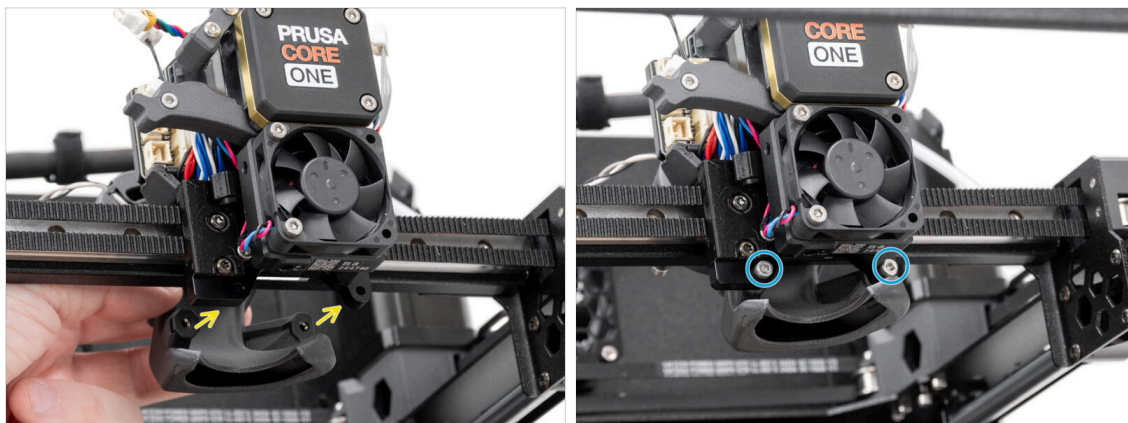
ÉTAPE 45 Assemblage du fan-shroud



- Insert two M3nS nuts from one side into the fan-shroud.
- From the other side, insert one M3nS nut into the fan-shroud.
- Insert the print fan into the fan-shroud as shown. See the correct orientation of the parts.
- Secure both parts together with one M3x25 screw.

⚠ Do not overtighten the screws to avoid damaging the fan housing.

ÉTAPE 46 Installation l'assemblage du ventilateur d'impression



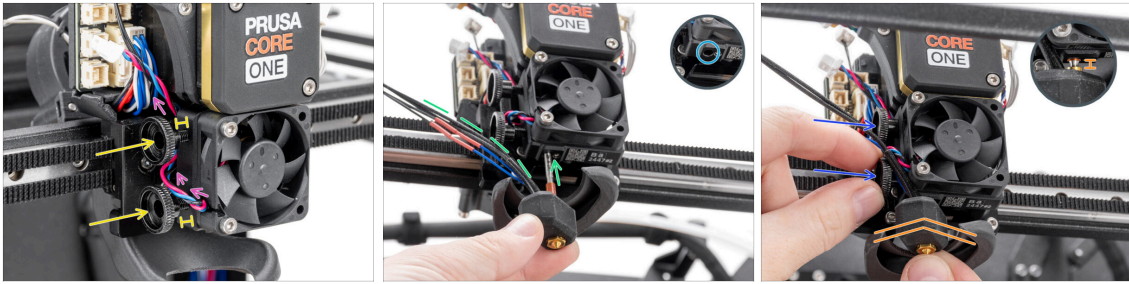
- Attach the print fan assembly to the back of the Nextruder.
- Align the holes in the Nextruder bracket with the holes in the fan-shroud.
- Secure the fan-shroud to the Nextruder holder using two M3x10 screws.

ÉTAPE 47 Hotend : préparation des pièces



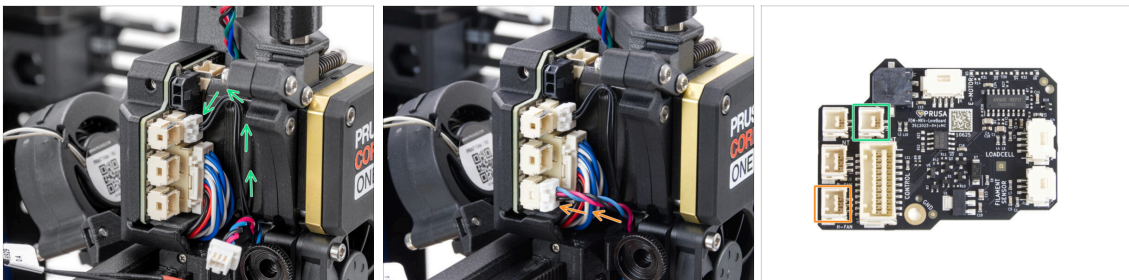
- **For the following steps, please prepare:**
- Thumb screw (2x) found in the Electronics package
- Prusa Hotend assembly (1x) found in the Electronics package

ÉTAPE 48 Installation de la hotend



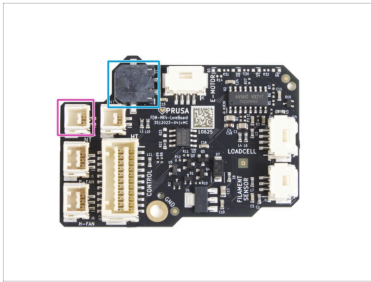
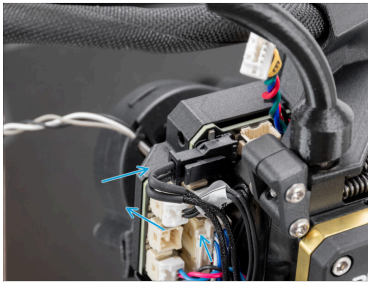
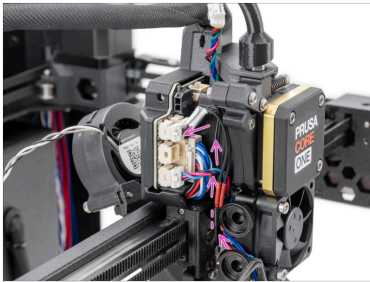
- ✿ Route the heatsink fan cable above the first threaded hole in the heatsink.
 - ✿ Insert two thumb screws into the heatsink. **Do not tighten them completely.** Two turns are enough for now.
 - ✿ Look closely at the underside of the heatsink and find the hole for the hotend assembly.
 - ✿ Insert the hotend assembly tube in the hole and slide the whole thing into the heatsink.
 - ✿ Point the cables to the left according to the photo.
 - ✿ Push the hotend assembly all the way into the heatsink. There should be approximately a 2 mm (0.08 in) gap between the heatsink and the brass part of the nozzle.
 - ✿ While pushing the hotend assembly in, **firmly tighten both thumb screws.**
- ⚠ **Avoid pinching any cable between the screws and the heatsink!**

ÉTAPE 49 Connexion des câbles du dissipateur thermique



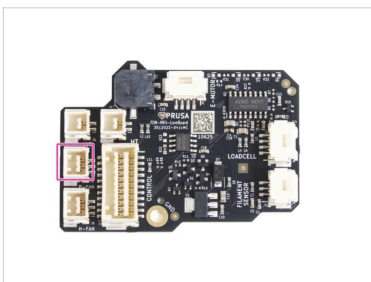
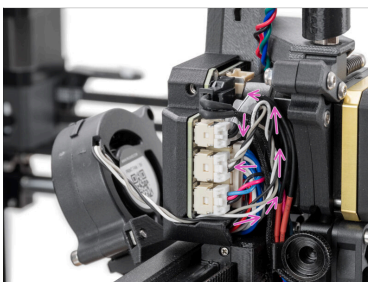
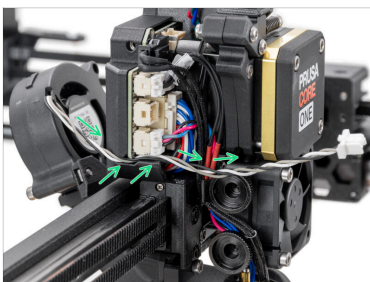
- ✿ Plug the NTC thermistor cable into the connector above the main cable on the LoveBoard.
- ✿ Branchez le câble du ventilateur de la Hotend sur le connecteur inférieur de la rangée gauche de la LoveBoard.

ÉTAPE 50 Connexion des câbles de la hotend



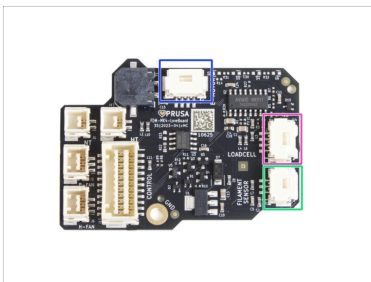
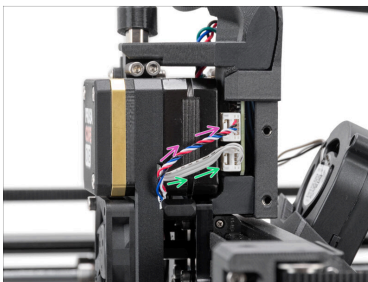
- ◆ Guide the hotend thermistor through the cable-clip on the Nextruder and connect it to the LoveBoard.
- ◆ Guide the hotend heater through the cable-clip on the Nextruder and connect it to the LoveBoard.

ÉTAPE 51 Connexion du câble du ventilateur d'impression



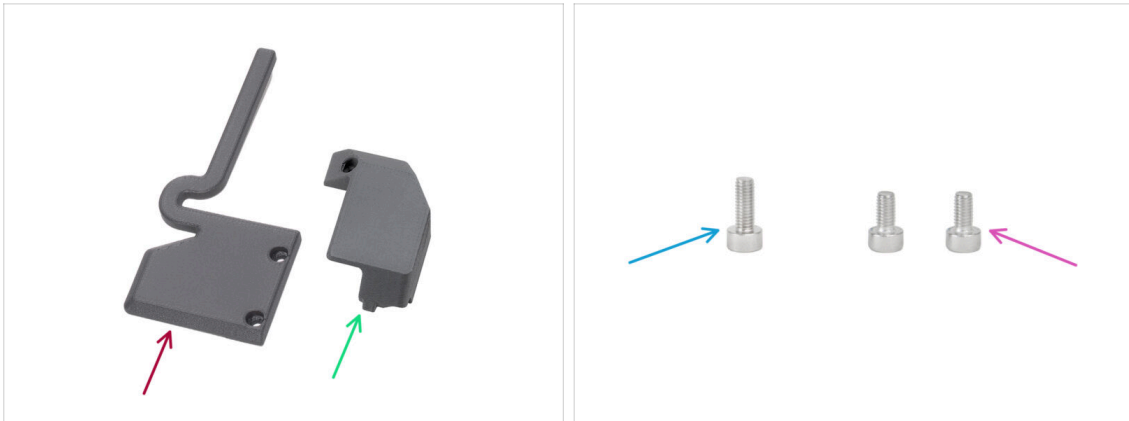
- ◆ Guide the print fan cable through the channel in the plastic cover.
- ◆ Create a loop with the print fan cable in the cable area and plug it into the middle connector in the LoveBoard.

ÉTAPE 52 Connexion du câble du moteur E



- ◆ Plug the Nextruder motor (labeled E) to the top-facing connector.
- ◆ Plug the loadcell cable (lower cable) to the upper connector on the right side of the Nextruder.
- ◆ Plug the filament sensor (upper cable) to the lower connector.

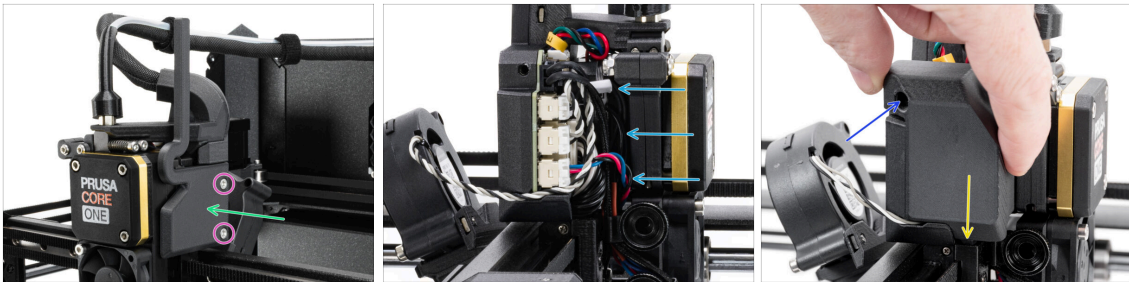
ÉTAPE 53 Capots de la LoveBoard : préparation des pièces



● For the following steps, please prepare:

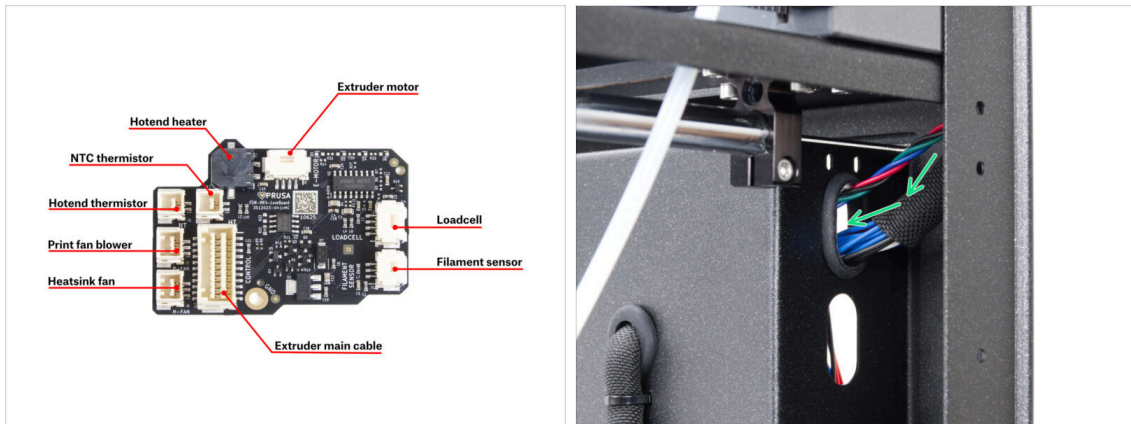
- Printhead-cover-right-lever (1x)
- Print-head-cover-right (1x) *found in the Printed parts package*
- Vis M3x10 (1x)
- Vis M3x6 (2x)

ÉTAPE 54 Mise en place du cache de la LoveBoard



- Placez le Printhead-cover-right-lever sur le côté droit du Nextruder.
- ⚠ Do not pinch the cables!
- Secure the cover with two M3x6 screws.
- Squeeze the wiring harness as far inward to the LoveBoard as possible so that it does not protrude out and interfere with the fitting of the cover.
- Attach the Print-head-cover-left on the left side of the Nextruder.
- **Note the protrusion on the underside of the cover - the protrusion must fit into the counterpart on the Nextruder.**
- Secure the cover with one M3x10 screw.

ÉTAPE 55 LoveBoard : vérification du câblage : vérification du câblage



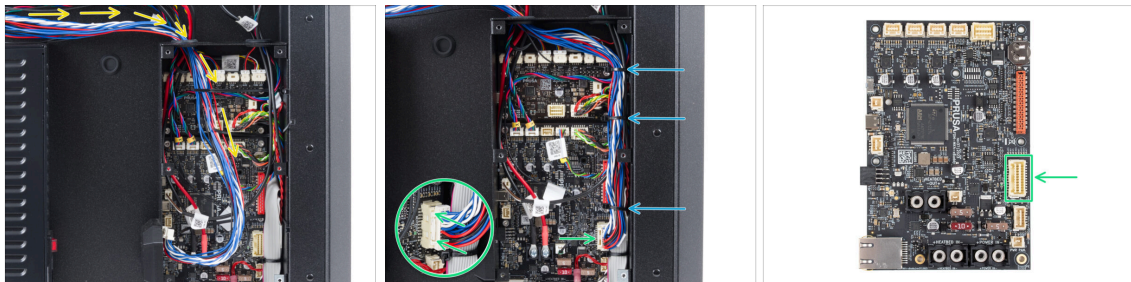
⚠ Avant de couvrir l'électronique, vérifiez la connexion de tous les câbles.

i Click on the picture to open it in the high-resolution preview.

➡ Guide the main-cable through the upper hole on the right side of the back panel assembly.

⬛ Leave the end of the cable hanging freely for now.

ÉTAPE 56 Guidage du câble principal



⬛ Faites pivoter l'imprimante de manière à ce que l'arrière soit face à vous.

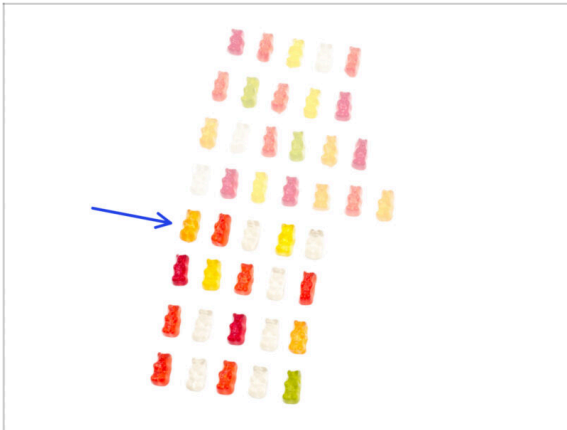
➡ Faites passer le câble principal à travers le trou de gauche dans le boîtier de la xBuddy.

➡ Plug the main-cable to the slot on the right side of the xBuddy board.

i If the cable does not reach the connector or is too tight, go back to step **Guiding the main cable** and pull the cable slightly downward from the main-cable-clip.

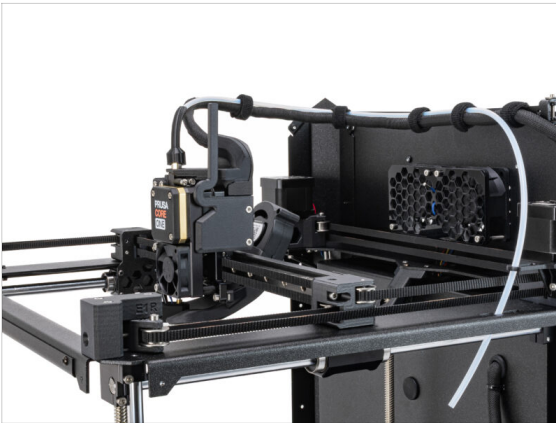
➡ Fixez les câbles avec les colliers de serrage pré-installés dans le boîtier de la xBuddy. Coupez soigneusement l'excédent, **évit**ez de couper les câbles.

ÉTAPE 57 C'est l'heure des Haribo



- Montez en puissance et avancez !
- Eat the fifth row.
- Encore faim ?

ÉTAPE 58 Fini

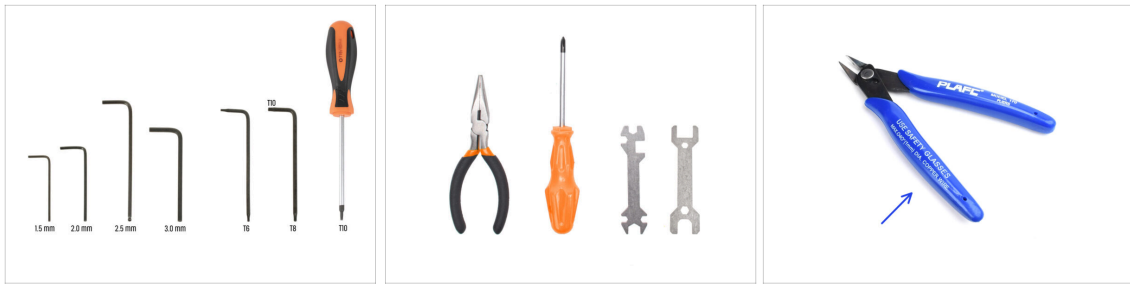


- Félicitations ! Vous venez d'assembler avec succès le Nextruder.
- Let's move to the next chapter.

7. Bodywork & Electronics



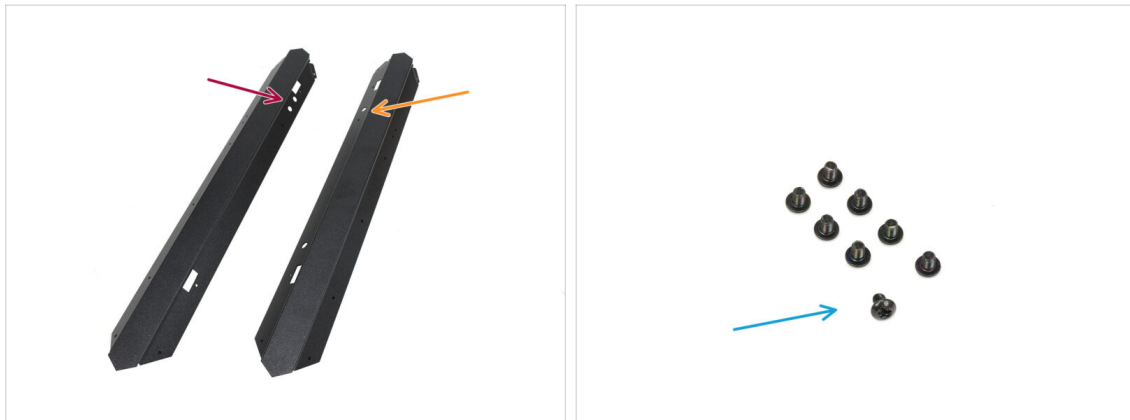
ÉTAPE 1 Tools necessary for this chapter



● For the following steps, please prepare:

- Clé Allen de 2,5 mm
- Clé Allen de 1,5 mm
- Clé Torx T10
- Pince à bec fin
- Pince coupante (optionnelle)

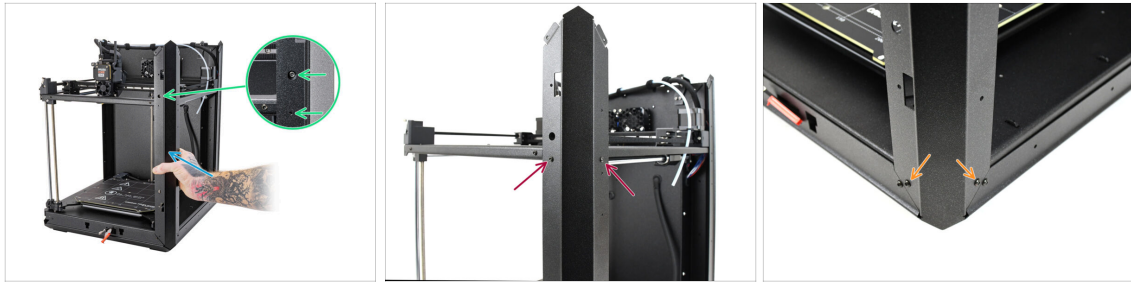
ÉTAPE 2 Front profiles: parts preparation



● For the following steps, please prepare:

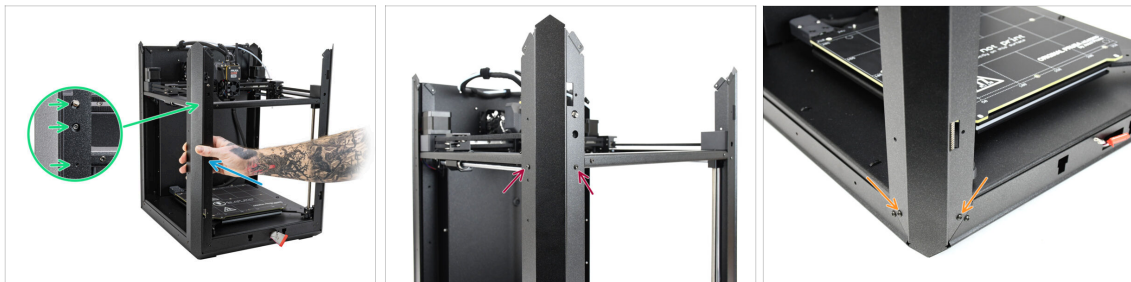
- Front Left Profile (1x) *found in the Metal parts 1/3 package*
 - ① The one with the two circular openings on top.
- Profilé avant droit (1x) *qui se trouve dans le paquet des pièces métalliques 1/3*
 - ① The one with one circular opening on top.
- Vis M3x4rT (8x)

ÉTAPE 3 Installing the front right profile



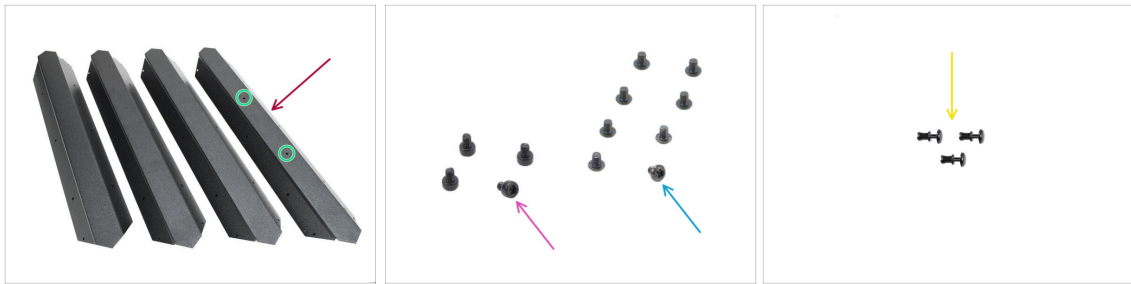
- Attach the Front Right Profile to the printer.
 - i Ensure you are using the correct profile—it should have **one large round opening** for the belt tensioning screw.
- Align the profile so that the calibration screw opening and the smaller bolt opening line up with the thread.
- Secure the profile to the CoreXY assembly using two M3x4rT screw
- Fix the profile at the bottom using the two M3x4rT screws.

ÉTAPE 4 Installing the front left profile



- Attach the Front Left Profile to the printer.
 - i Ensure you are using the correct profile—it should have **two large round openings** for the door sensor and the belt tensioning screw.
- Align the profile so that the openings match. **Be careful not to bend the door sensor lever!**
- Secure the profile to the CoreXY assembly using two M3x4rT screw
- Fix the profile at the bottom using the two M3x4rT screws.

ÉTAPE 5 Top profiles: parts preparation



- Top Profile (4x) *found in the Metal parts 1/3 package*
- Note that one of the profiles has two openings in the middle—this one belongs at the back.
- Vis M3x4rT (8x)
- M3x4 screw (4x) *with the different head type*
- Rivet en nylon (3x)

ÉTAPE 6 Assembling the top profiles I.



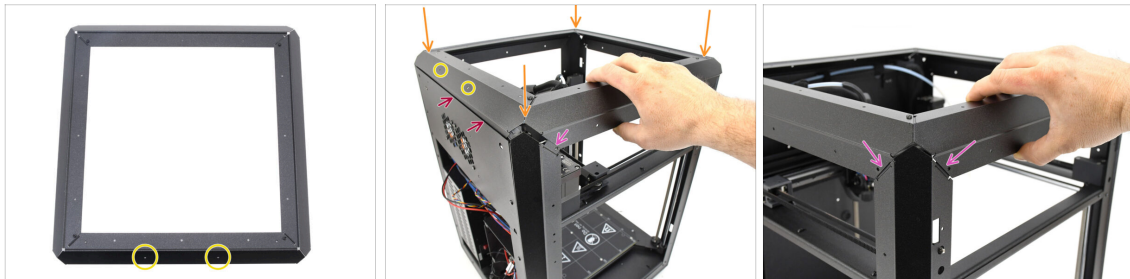
- ⚠ Be very careful when handling sharp sheet metal parts to avoid injury or damage.
- According to the picture, place the top profile with two holes on the flat side.
- Orient the part according to the picture. **Use the flange as a guide.**
- Place any other of the top profiles on the left side. Orient the part according to the picture. **Use the flange as a guide.**
- Attach the two profiles together.
 - ⚠ The flange of the front plate (blue arrow) must be inserted **under** the left universal profile (green arrow), not on top of it.
- Align the holes in both parts and join both parts together with the M3x4 screw.
- Using the same procedure, join the other two profiles to form a corner, securing them with an M3x4 screw.

ÉTAPE 7 Assembling the top profiles II.



- ✦ Attach the corner profile assembly to the first one, aligning the holes on the flanges with the holes in the profiles.
- ⚠ Ensure the flanges are positioned **underneath** the profiles.
- ✦ Join the both profile assemblies using two M3x4 screws.

ÉTAPE 8 Aligning the top profiles



- ✦ Find the profile with **two openings in the middle**—this part should be positioned at the **rear of the printer**.
- ✦ Add the top profile assembly onto the printer, making sure the two openings are facing the back.
 - ✦ The protruding part of the rear profile must be positioned behind the back sheet metal plate.
 - ✦ On the sides and front, the profiles must sit on top of the tabs with threaded openings.

ÉTAPE 9 Installing the top profiles



- Once all the top profiles are properly aligned, fix them in place using the remaining 8 M3x4rT screws in the corners.
- Attach the back panel to the top profile with three nylon rivets.

ÉTAPE 10 CoreXY fixing screws: parts preparation



- For the following steps, please prepare:
- Vis M3x4rT (4x)

ÉTAPE 11 Fixing the CoreXY assembly



- Align the CoreXY assembly so the threaded holes match the screw openings in the rear profiles. You may need to push the assembly upward to align the holes.
- Fix the CoreXY assembly using the four M3x4rT screws in the marked openings.

ÉTAPE 12 Side sensor base: parts preparation



- **For the following steps, please prepare:**
- Filament-sensor-body (1x)
- Filament-sensor-lever (1x)
- Filament-sensor-switch (1x)
- Vis M3x10 (1x)
- 10x6x2mm magnet (2x) *found in the Electronics & Fasteners package*
- 7mm Ferromagnetic Ball (1x) *found in the Electronics & Fasteners package*
- Rondelle M3w (1x)

ÉTAPE 13 Assembling the side sensor base



- ✚ Insert one of the magnets into the dedicated opening in the Lever.
- ✚ Insert the ball into the corresponding opening on the inside of the sensor base.
- ✚ Insert the lever with the magnet into the Base.

ⓘ The part with the magnet should be positioned next to the ball.

Note that the ball will be attracted to the magnet—ensure it stays securely in place.

- ✚ Fixez le levier en place à l'aide de la rondelle M3w et de la vis M3x10. Serrez-le juste quelques tours pour l'instant - suffisamment pour le maintenir en place.

⚠ **Ne serrez pas complètement la vis. Sinon, le levier ne bougera pas et le capteur ne fonctionnera pas !**

ÉTAPE 14 Test du levier



- ✚ Verify the lever is able to move freely.
- ✚ Si le levier ne bouge pas librement ou ne peut pas bouger du tout, desserrez la vis d'un quart de tour et testez à nouveau son mouvement.

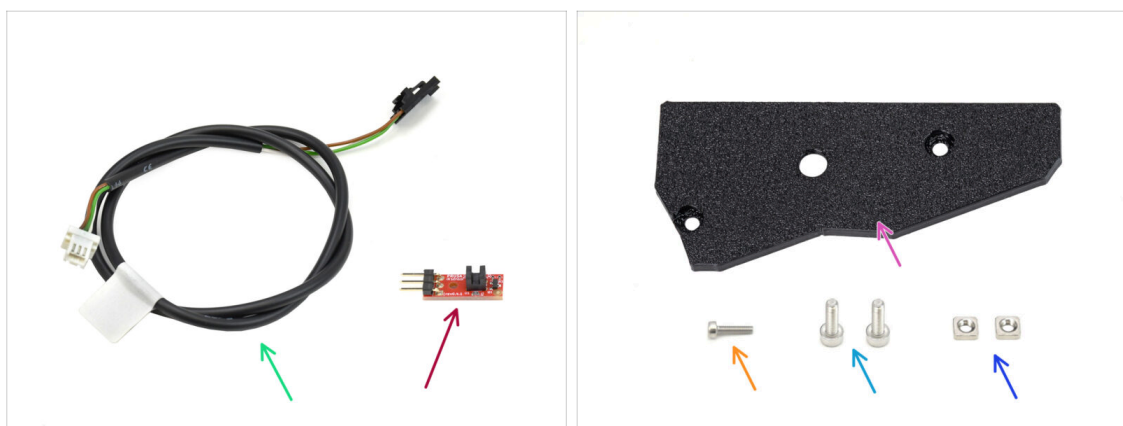
⚠ **La vis ne doit pas être complètement serrée ; sinon, le levier ne pourra pas bouger librement.**

ÉTAPE 15 Assemblage du commutateur



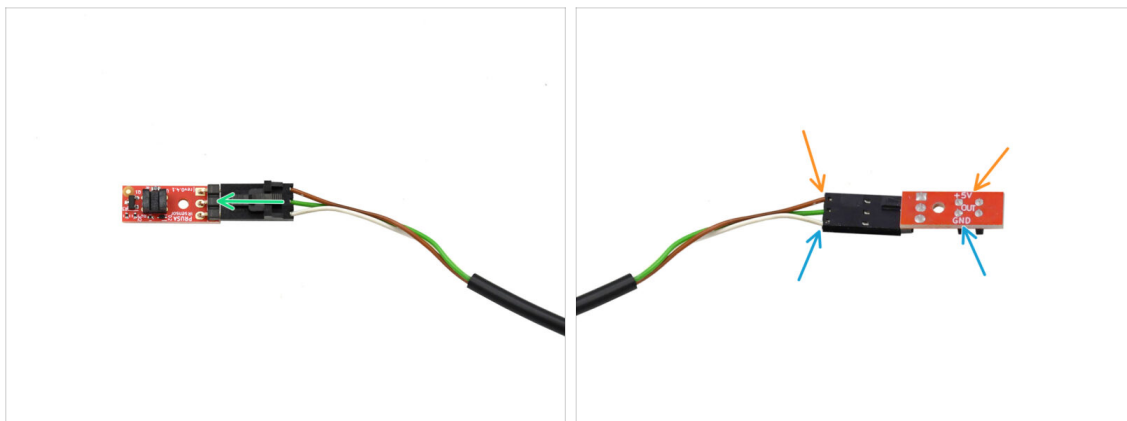
- Insérez le deuxième aimant 10x6x2 dans le filament-sensor-switch.
- Installez le filament-sensor-switch dans le filament-sensor-body.
- Déplacez le filament-sensor-switch vers la position d'extrémité gauche de sorte que les aimants se fassent face.
- Assurez-vous que **les aimants se repoussent** - ils devraient s'éloigner l'un de l'autre.
- **S'ils s'attirent** - se tirent l'un vers l'autre : retirez l'aimant du filament-sensor-switch et inversez sa polarité. Vérifiez-le à nouveau.
- ❗ *Conseil de pro : Utilisez une clé hexagonale fine ou une clé Torx pour retirer l'aimant du filament-sensor-switch*

ÉTAPE 16 IR Sensor: parts preparation



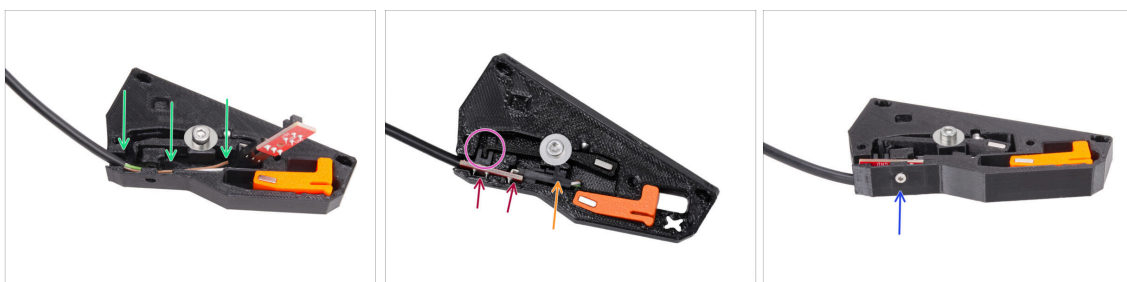
- **For the following steps, please prepare:**
- Side Filament Sensor Cable (1x) *found in the Electronics & Fasteners package*
- IR Filament Sensor (1x) *found in the Electronics & Chamber parts package*
- Side Filament Sensor Cover (1x) *found in the Printed package*
- Vis M2x8 (1x)
- Vis M3x10 (2x)
- Écrou M3nS (2x)

ÉTAPE 17 Connecting the IR sensor



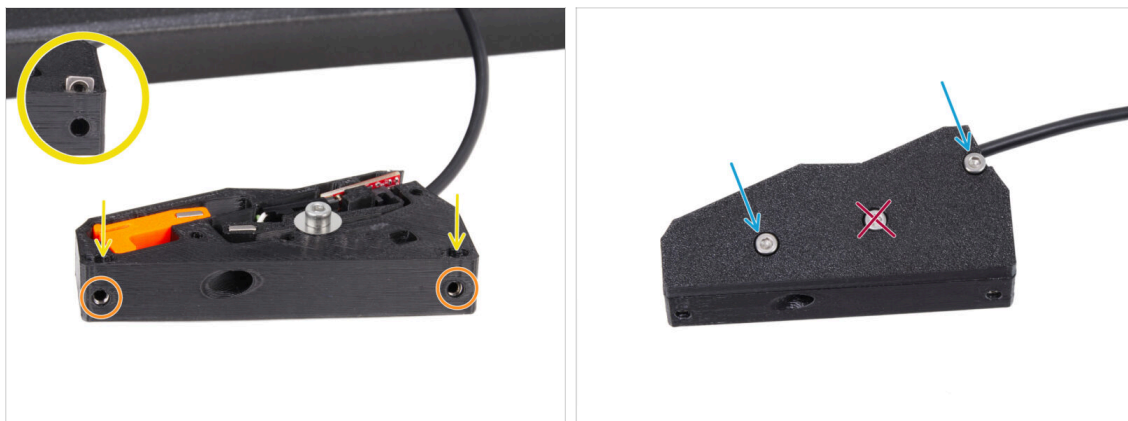
- Plug the cable into the IR filament sensor.
- ⚠ Ensure the connector is oriented correctly before plugging it in!
- On CORE One, the brown cable must connect to the +5V pin.
- The white cable connects to the GND pin.

ÉTAPE 18 Installing the IR sensor



- First, insert the cable into the groove. The black connector should be approximately in the middle of the sensor base.
- Insert the IR sensor itself into the dedicated groove.
- The lever must fit into the optical gate part of the sensor.
- Make sure neither the connector nor the cables touch the lever, as this could prevent the sensor from functioning correctly.
- Using the 1.5mm Allen key, fix the sensor in place with the M2x8 screw.

ÉTAPE 19 Installing the side sensor cover



- ✚ Insert the two M3nS nuts into the designated openings. Use a 1.5mm Allen key to **push them all the way in.**
 - ✚ Look from the side to ensure the threads in the nuts align with the openings.
 - ✚ Add the cover part onto the assembly.
 - ✚ Fix the cover in place using two M3x8 screws on the sides.
- ⚠ **Ne serrez pas la vis du milieu ! Sinon, le capteur cesserait de fonctionner.**

ÉTAPE 20 Side filament sensor: parts preparation



- ⬛ **For the following steps, please prepare:**
- ✚ Side Filament Sensor Assembly (1x) *you assembled earlier*
- ✚ Collet (1x) *found in the Electronics & Fasteners package*
- ✚ Collier de serrage (3x)

ÉTAPE 21 Installing the side filament sensor



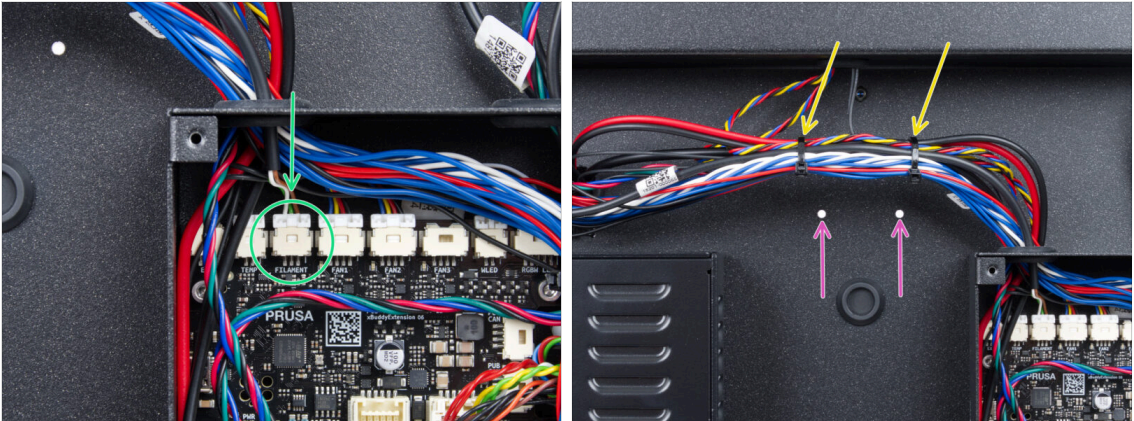
- Install one zip-tie into the marked openings. We will use it to attach a cable underneath the metal profile.
 - Insérez le collet dans l'ouverture marquée sur l'assemblage du capteur.
 - Attach the sensor assembly onto the PTFE tube in the printer.
- ⚠ Make sure to push the tube all the way in!

ÉTAPE 22 Guide the filament sensor cable



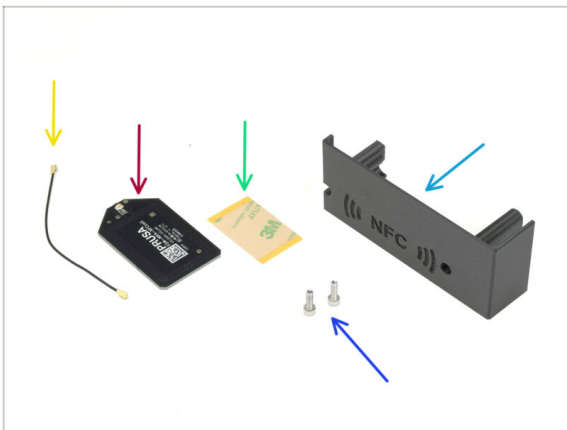
- Move the sensor assembly up, roughly to the middle of the printer's frame, to align the cable properly.
- Once in position, secure the cable underneath the metal profile using a zip-tie. Tighten the zip-tie lightly, allowing for cable adjustments if needed later. Cut off the excess zip-tie.
- Guide the sensor cable through the dedicated opening to the back of the printer.
- À l'arrière de l'imprimante, guidez le câble dans le boîtier de la xBuddy. Laissez-le pendre librement pour le moment.

ÉTAPE 23 Connecting the side filament sensor



- Connect the Side Filament Sensor cable into the connector labeled FILAMENT on top of the xBuddy extension board.
 - i You can use needle-nose pliers to assist you, but be careful not to damage the cables.
- Use two zip-ties to clamp the cable bundle together in the marked area.
 - Secure the cables in the **highest possible position** to ensure they clear the two openings on the sheet metal below.
- ⚠ Do not over-tighten the zip ties or strain the cables too much!

ÉTAPE 24 NFC Antenna: parts preparation



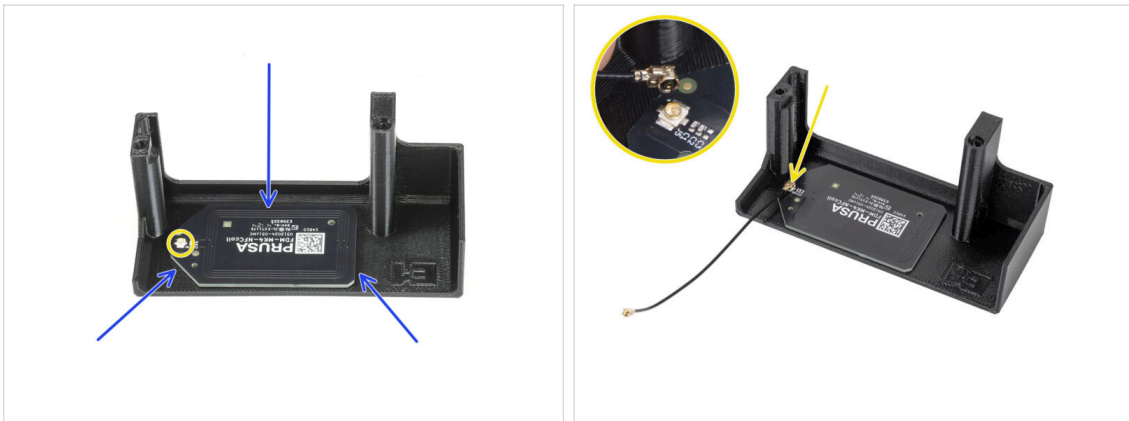
- For the following steps, please prepare:
 - El-box-cover (1x) found in the Printed parts package
 - Vis M3x10 (2x)
 - NFCcoil (1x) found in the Electronics & Chamber parts package
 - Adhesive film 32 x 25 mm (1x) found in the Electronics & Chamber parts package
 - NFC coil cable (1x) found in the Electronics & Chamber parts package

ÉTAPE 25 Applying the adhesive film



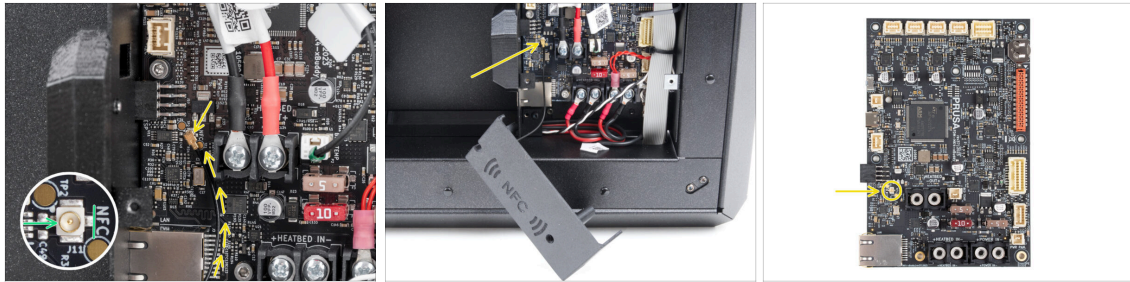
- Peel off the yellow protective film from the adhesive tape.
- Apply the film to the flat side of the NFC coil, ensuring it adheres properly.
- Peel of the remaining protective layer from the NFC coil.

ÉTAPE 26 Installing the NFC Coil



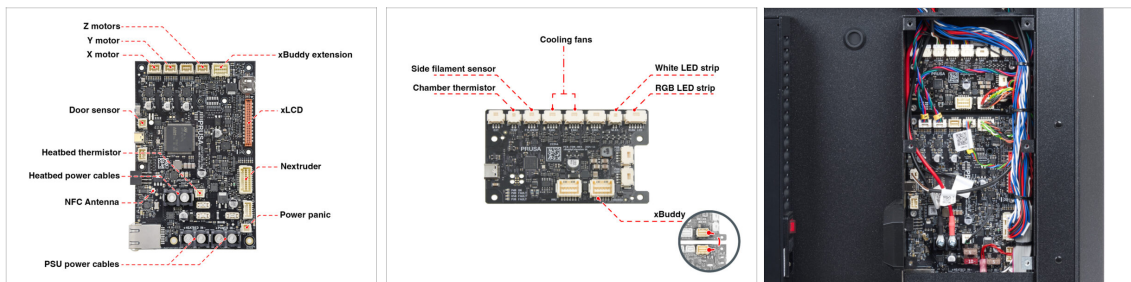
- Stick the NFC coil onto the inner side of the EI-box cover, approximately as shown in the picture.
- ⓘ The small round connector should be positioned closer to the edge of the cover.
- Connect the cable to the board by aligning the connectors and pressing lightly until you feel a click, ensuring a secure connection.
- ⚠ Be careful when connecting the NFC coil cable. Misalignment or excessive pressure can cause irreversible damage.

ÉTAPE 27 Connecting the NFC Coil



- 🟢 Locate the small round connector labeled NFC on the bottom left side of the xBuddy board.
- 🟡 Connect the NFC coil cable to the board by aligning the connectors and pressing lightly until you feel a click.

ÉTAPE 28 Vérification du câblage



- 🟡 Use the pictures as a reference to verify your electronics connections.
- ⚠️ Make sure that all connectors are fully inserted and PSU cables properly tightened. Otherwise, there is a risk of damage to the printer!

ÉTAPE 29 Preparing the electronics cover



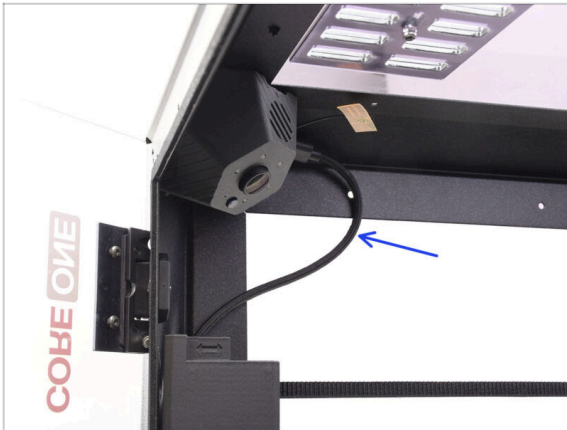
- Push two M3x10 screws through the EI-box-cover.

ÉTAPE 30 Installing the electronics cover



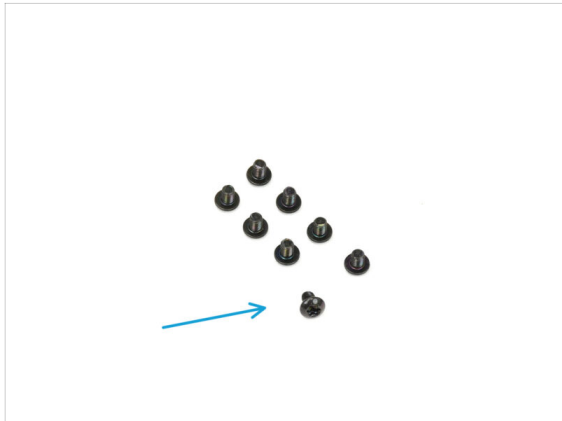
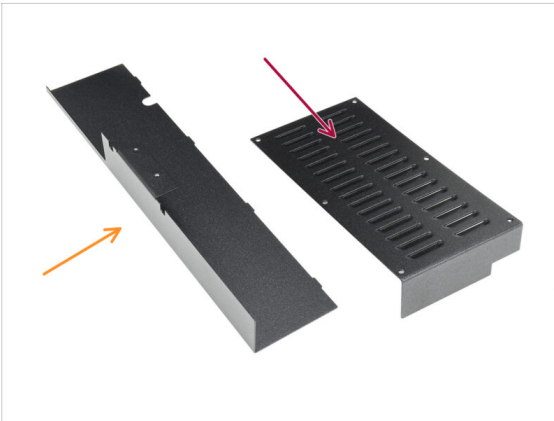
- Ensure the threaded holes on the bottom of the xBuddy box are not obstructed by cables.
- If so, rearrange the cables to allow clear access.
- Align the cover with the opening in the xBuddy box and fix it in place by tightening the screws.
- Route the NFC cable through the space between the Ethernet connector and the PSU power cables.
- ⚠ Avoid running it through the Ethernet connector or the power cables. The cable may be damaged when covering the xBuddy box.**

ÉTAPE 31 Remarque sur la caméra Buddy3D



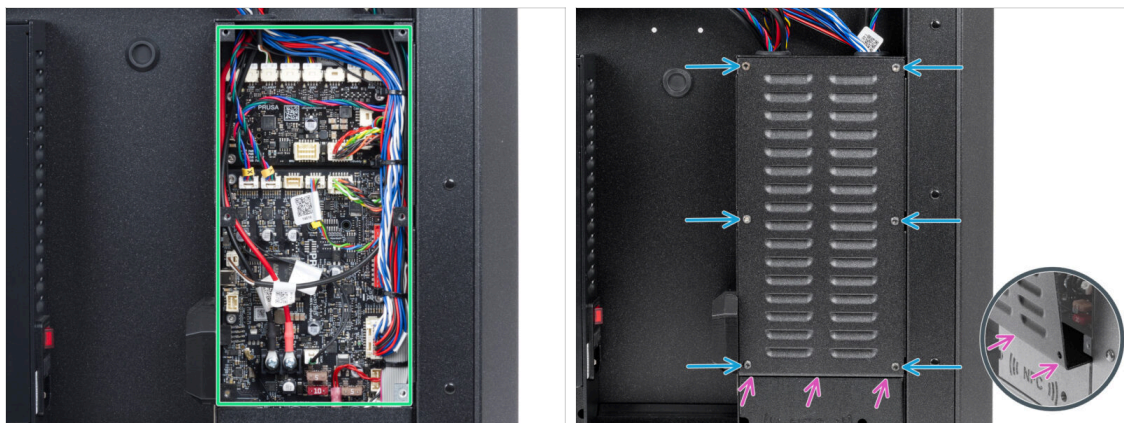
- i** Pour les futurs utilisateurs de la caméra Buddy3D :
- Si vous prévoyez d'utiliser la caméra Buddy3D, le câble USB est déjà installé.
 -  Pour obtenir des informations détaillées sur la façon de monter et de connecter la caméra Buddy3D, reportez-vous à ce guide : **Installation de la Caméra Buddy3D pour la CORE One**

ÉTAPE 32 xBuddy cover: parts preparation



- For the following steps, please prepare:**
- Sheet metal back cover (1x) *found in the Metal parts 2/3 package*
 - Capot de la xBuddy (1x) *qui se trouve dans le paquet des pièces métalliques 3/3*
 - Vis M3x4rT (8x)

ÉTAPE 33 Installing the xBuddy cover



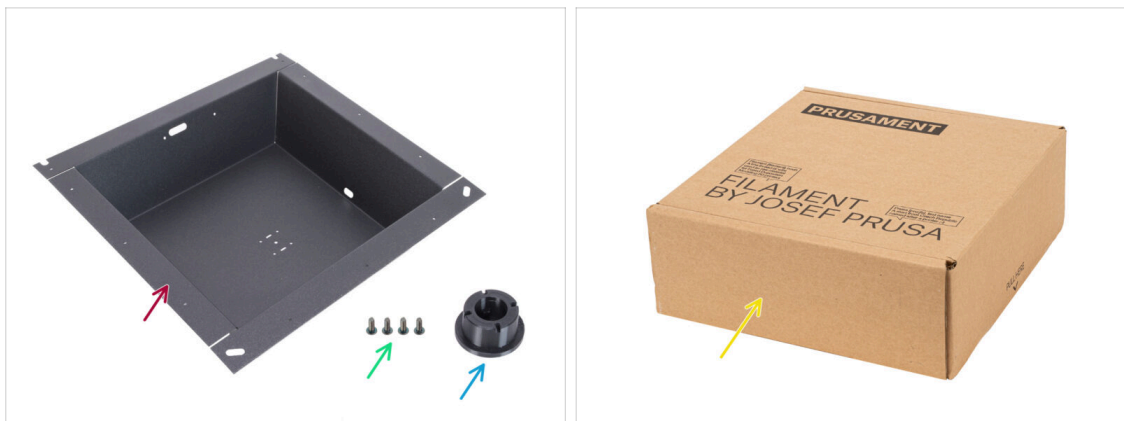
- Agencez les câbles à l'intérieur du boîtier de la xBuddy comme indiqué sur l'image.
- Carefully cover the xBuddy box by first sliding the bent part of the cover into the box.
- ⚠ **Évitez de pincer les câbles. Vérifiez à nouveau la position du câble de l'antenne NFC.**
- Secure the xBuddy box cover using the six M3x4rT screws.

ÉTAPE 34 Installing the rear cover



- Align the rear sheet metal cover so that the cables can run through the "tray".
- Place the rear sheet metal cover into the recess. Push it toward the printer, then move it upward to engage it.
- Il y a quatre languettes qui doivent s'engager dans le châssis de l'imprimante.
- Secure the rear cover in place using two M3x4rT screws from inside the printer.

ÉTAPE 35 Right side: parts preparation



● For the following steps, please prepare:

● Right side sheet metal (1x) found in the Metal parts 2/3 package

⚠ Le bon **côté droit** de la pièce peut être facilement identifié par les ouvertures de vis au milieu.

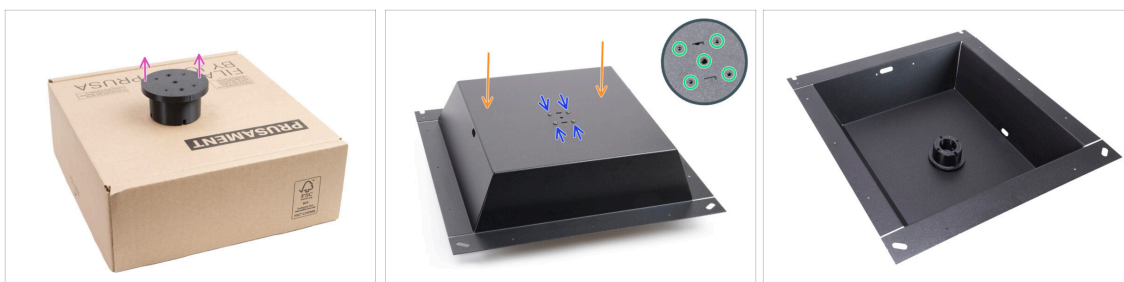
● Vis M3x8rT (4x) qui se trouve dans le paquet Électronique & Visserie

● Puck-universal (1x)

● N'importe quelle boîte en carton (1x)

📌 Astuce : Une boîte de Prusament convient parfaitement.

ÉTAPE 36 Installing the spoolholder puck



● Placez le Puck-universal sur la boîte en carton de manière à ce que les trous de vis soient orientés vers le haut.

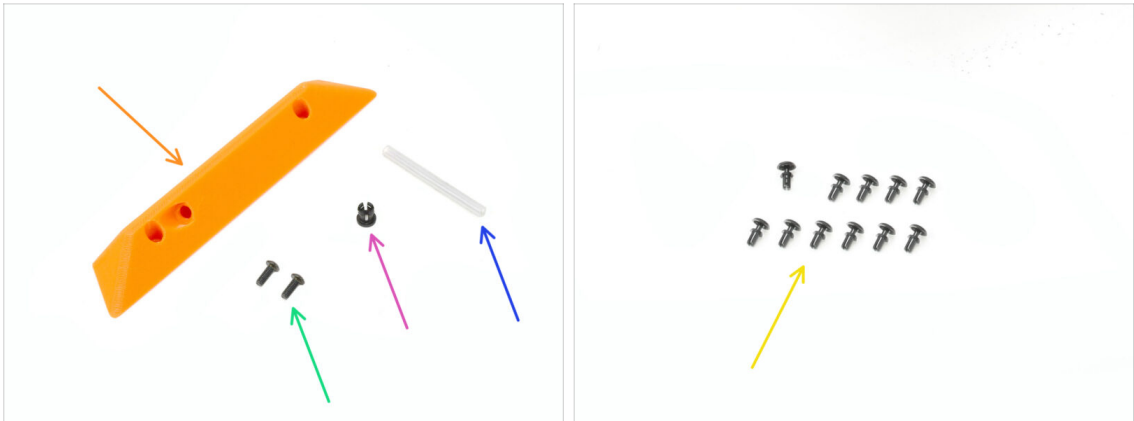
● Placez soigneusement le panneau droit sur le Puck-universal, en le positionnant au centre de la boîte.

● Alignez les trous du Puck-universal avec les trous du panneau de droite.

● Fixez le Puck-universal à l'aide de quatre vis M3x8rT.

ⓘ Les vis peuvent offrir une certaine résistance lors du serrage, car elles créent leur propre filetage à l'intérieur de la pièce.

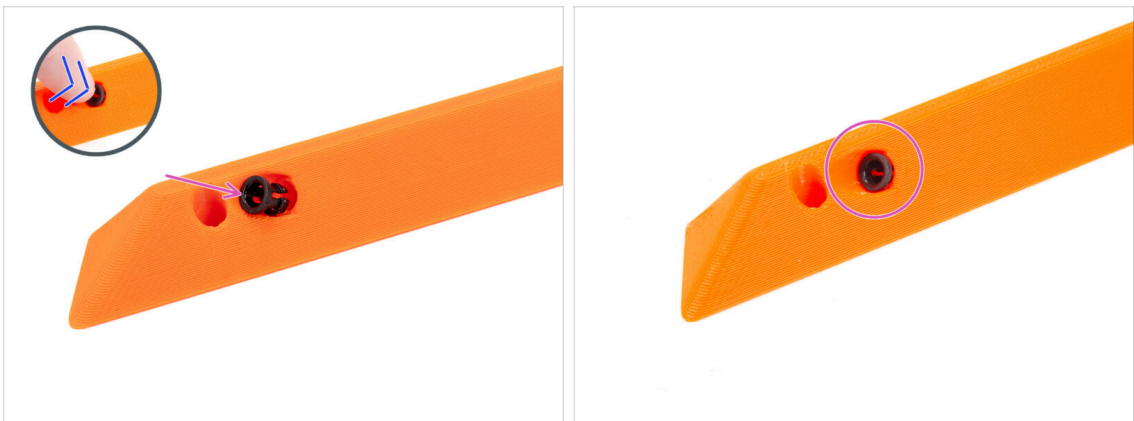
ÉTAPE 37 Right handle: parts preparation



For the following steps, prepare:

- Side Handle (1x) *found in the Printed parts package*
- Vis M3x8rT (2x)
- Collet (1x) *found in the Electronics & Fasteners package*
- PTFE Tube 4 x 2.5 x 45 mm (1x) *found in the CoreXY parts + Hinges set package (together with hinges parts)*
- Rivets en nylon (11x)

ÉTAPE 38 Installation du collet



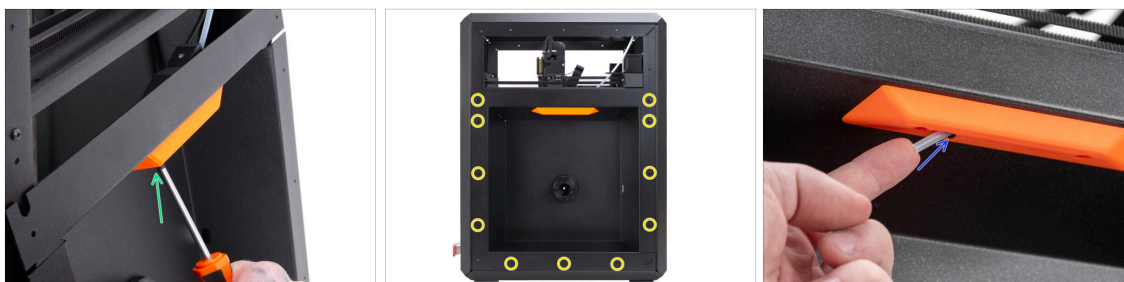
- Insert the collet into the handle.
- Push it all the way in.

ÉTAPE 39 Montage de la poignée



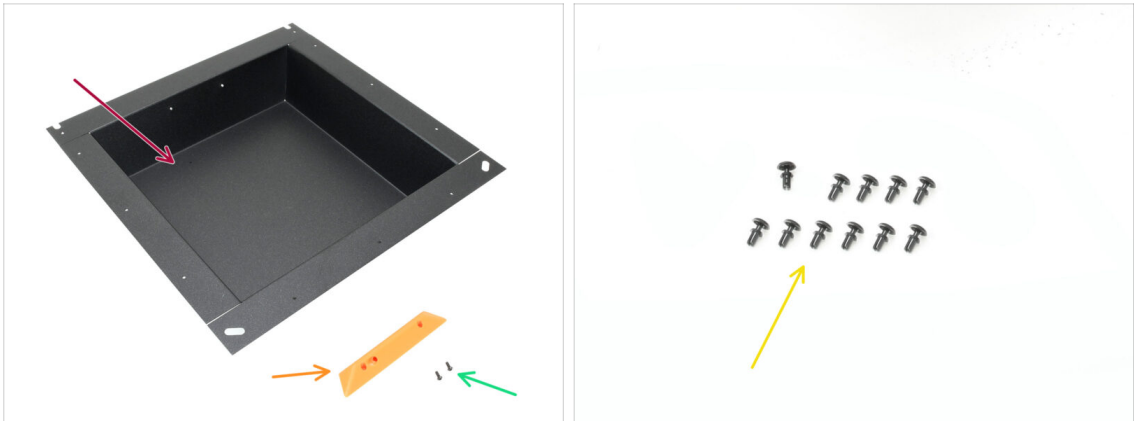
- ✿ Place the right-side metal sheet assembly on the right side of the printer. Ensure the U-shaped cutouts are facing upwards.
- ✿ Attach the right handle to the right metal sheet.
- ✿ Poussez une vis M3x8rT à travers le trou arrière de la poignée et la tôle.
- ✿ Attach the side filament sensor assembly on the screw.
- ⚠ **Do not pull the side sensor assembly too far; bring the right side metal sheet as close as possible.**
- ✿ Tighten the screw just slightly—the nut must remain free to move.
- ✿ Align the side filament sensor with the front screw hole in the metal sheet and the handle.

ÉTAPE 40 Fixing the right side



- ✿ Using the second M3x8rT screw, secure the right handle and the side filament sensor to the right metal sheet.
- ✿ Secure the side sheet metal to the printer using the 11 Nylon rivets.
- ✿ Insérez le tube court en PTFE 4 x 2,5 x 45 dans le collet. Poussez-le à fond.
- ⓘ Part of the PTFE tube will remain protruding from the handle.

ÉTAPE 41 Left side: parts preparation



● **For the following steps, prepare:**

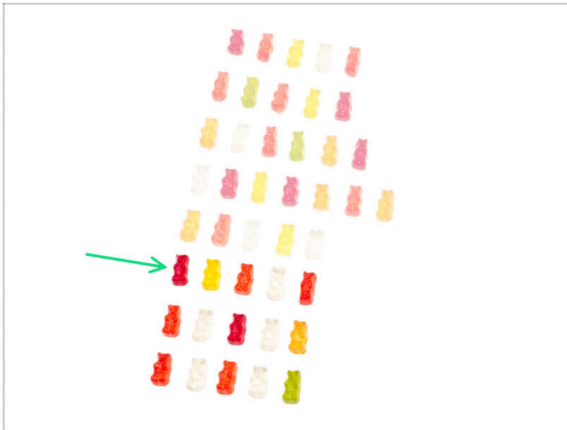
- Left side sheet metal (1x) found in the Metal parts 2/3 package
- Poignée latérale (1x) qui se trouve dans le paquet des pièces imprimées
- Vis M3x5rT (2x)
- Rivet en nylon (11x)

ÉTAPE 42 Installing the left side



- Align the handle with the threaded openings in the sheet metal.
- Attach the handle using the two M3x5rT screws.
- Fixez la tôle latérale à l'imprimante à l'aide de 11 rivets en nylon.

ÉTAPE 43 C'est l'heure des Haribo



- Well done—fuel up for the next challenge!
- Eat the sixth row.
- Si proche ! Mais **ne touchez pas à ces derniers bonbons !**

ÉTAPE 44 Fini

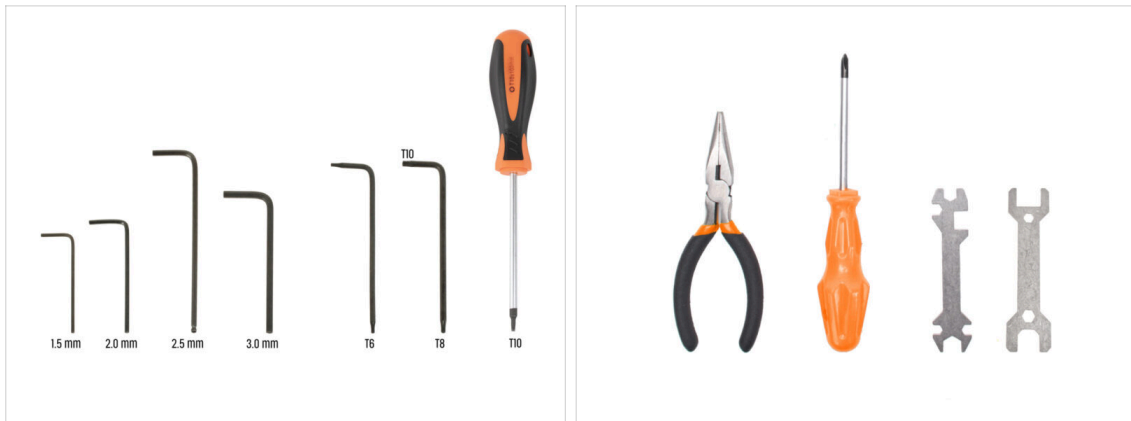


- Congratulations! You've successfully assembled the entire body.
- Let's move to the next chapter.

8. Trim, Door & xLCD



ÉTAPE 1 Tools necessary for this chapter



● **For the following steps, prepare:**

- Clé Allen de 2,5 mm
- Clé Torx T10
- Pince à bec fin

ÉTAPE 2 Top cover: parts preparation



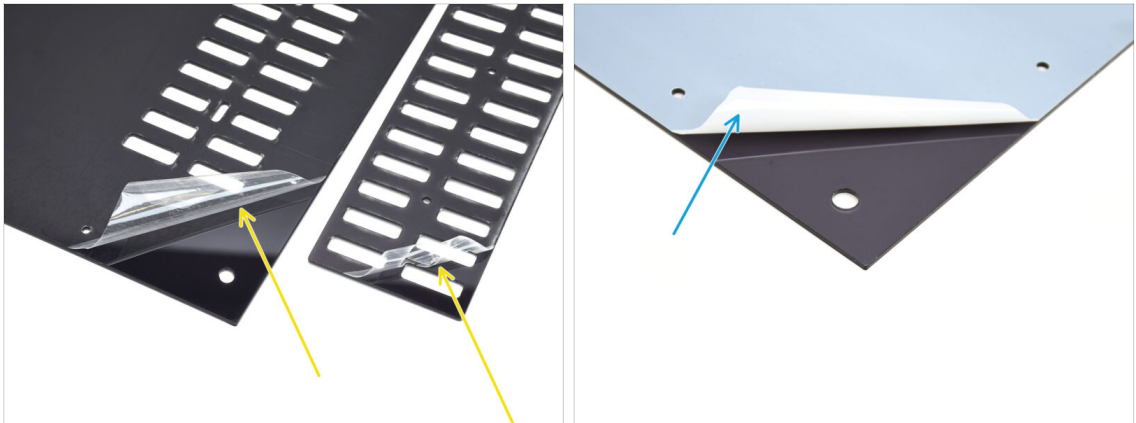
● **For the following steps, prepare:**

- Top cover (1x) *found in the Plexi set package*
- Vent cover (1x) *found in the Plexi set package*
- Écrou M3nN (3x)
- Insulating insert (3x) *found in the Electronics & Fasteners package*

i Cette pièce peut être disponible en gris ou en noir. Cependant, la forme est identique et cela n'affecte pas la procédure.

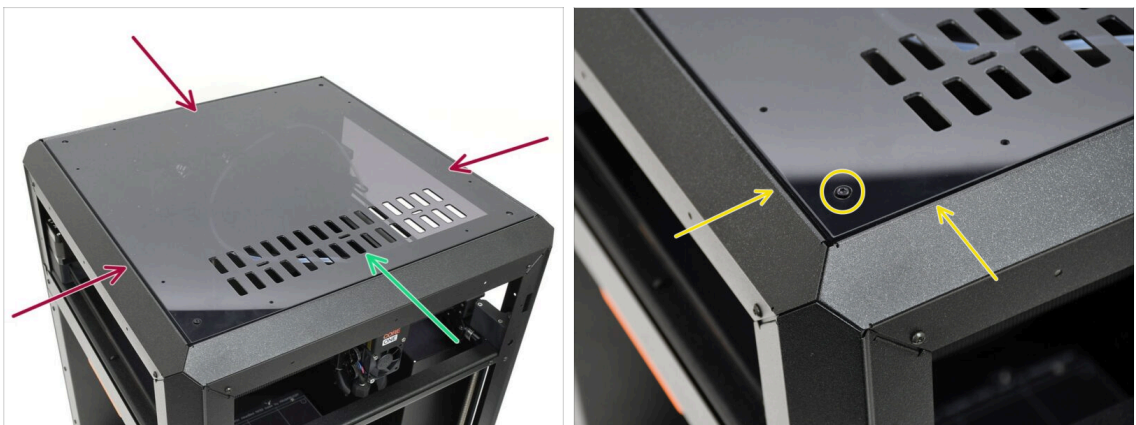
- Vis M3x12rT (3x)
- Rivet nylon (4x)
- Upg-vent-block

ÉTAPE 3 Retrait du film



- First, remove the protection foil from both the plastic sheets.
- Flip the parts around and remove the protective foil from the other sides.

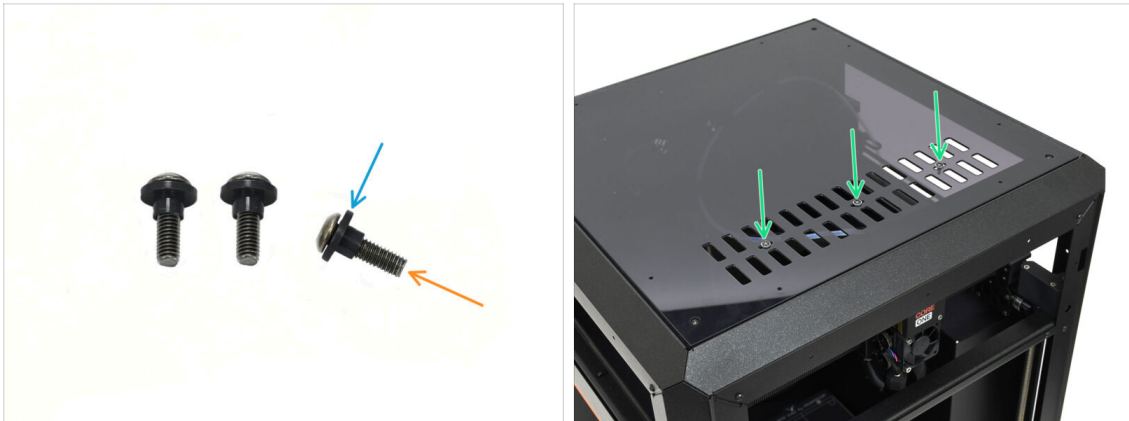
ÉTAPE 4 Test-fitting the top cover



- Lay down the top cover onto the printer.
- La partie avec les ouvertures d'aération doit être orientée vers l'avant de l'imprimante.
- If oriented correctly, the cover will align with the recess, and the bolt heads in the corners will fit into the cutouts.
- i** If the bolt openings don't align, flip the cover.

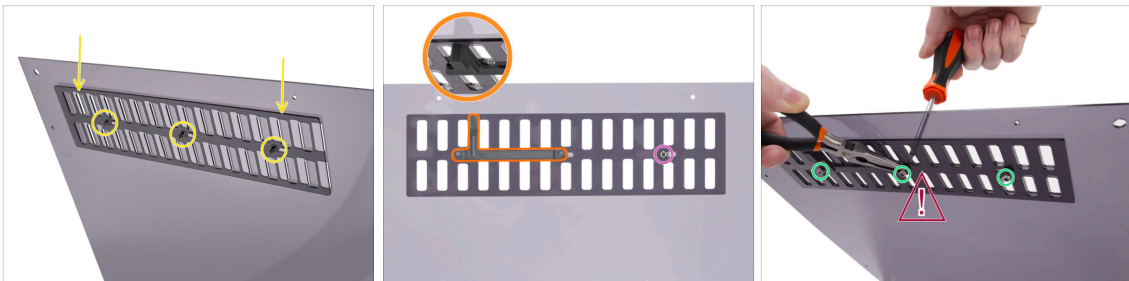
Spoiler alert: The cover isn't symmetrical!

ÉTAPE 5 Assembling the top cover I.



- 🟠 Run all three M3x12rT screws through the insulating inserts.
- 🟠 Assurez-vous que la partie à bride de l'insert est orientée vers la tête de vis.
- 🟢 Insert the screws with the inserts through the three slot openings in the vent.

ÉTAPE 6 Assembling the top cover II.



- 🟡 Align the vent cover with the screw ends on the bottom.
 - 🟡 Serrez à la main l'écrou M3nN le plus à droite sur la vis M3x12rT pour fixer le capot en place.
 - 🟠 Fixez l'Upg-vent-block au capot de la ventilation. Assurez-vous qu'il est correctement positionné.
 - 🟢 Fixez l'Upg-vent-block sur le capot de la ventilation avec des écrous M3nN. Utilisez la pince à bec fin pour maintenir les écrous pendant que vous serrez les vis.
- ⚠️ The screw must be tight enough just to remove the slack. It must remain loose, or the ventilation cover won't open and close properly.

ÉTAPE 7 Test de la ventilation



Try moving one of the three screws with your hand.

Les ouvertures d'aération doivent s'ouvrir et se fermer en douceur et sans effort.

If movement is difficult, loosen the screw that is restricting it.

ÉTAPE 8 Installing the top cover

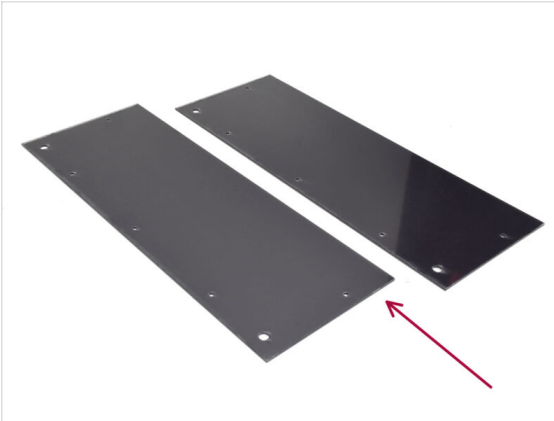


Alignez le capot avec l'encoche sur l'imprimante, en veillant à ce que l'orifice de ventilation soit orienté vers l'avant.

Fixez le capot au cadre à l'aide de quatre rivets en nylon dans les ouvertures marquées.

There are eight openings, but four rivets should be sufficient.

ÉTAPE 9 Side covers: parts preparation

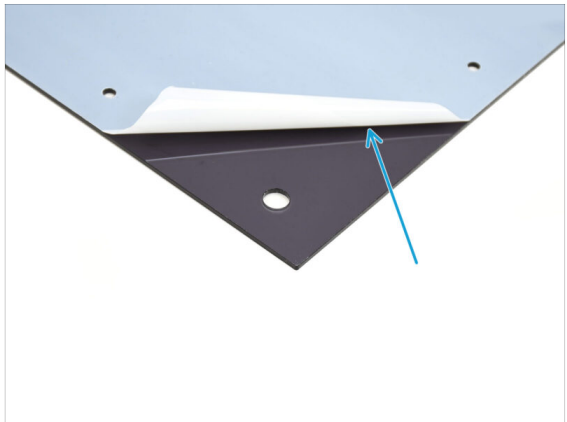


● For the following steps, prepare:

● Capot latéral (2x) qui se trouve dans le paquet des Plexi

● Rivet en nylon (10x)

ÉTAPE 10 Retrait du film



● Remove the protective foil from both the side covers.

● Retirez le film protecteur des autres côtés des deux capots latéraux.

ÉTAPE 11 Covering the left side



- ✎ Align the cover with the recess on the left side of the printer.
- ✎ Les vis saillantes de l'imprimante doivent s'aligner avec les ouvertures plus grandes du capot.
- ✎ Secure the cover to the frame using five nylon rivets in the marked openings.

ÉTAPE 12 Covering the right side



- ✎ Align the other cover with the recess on the right side of the printer.
- ✎ Fixez le capot au cadre à l'aide de cinq rivets en nylon dans les ouvertures marquées.

ÉTAPE 13 xLCD : préparation des pièces : préparation des pièces



- **For the following steps, prepare:**
- xLCD (1x) *qui se trouve dans le paquet Électronique*
- xLCD Front Cover (1x) *found in the Printed parts package*
- xLCD Display-mount (1x) *found in the Printed parts package*
- Knob (1x) *found in the Printed parts package*
- Vis 3x8sT (4x)
- Faston connector (1x) *found in the Electronics package*

ÉTAPE 14 Assembling the xLCD I.



- Nous vous recommandons de placer le capot avant face vers le bas sur le bord d'une boîte en carton ou sur un bureau pour créer de l'espace pour le bouton de l'encodeur.
- Retirez le film protecteur du xLCD.
- Insert the xLCD into the front cover.

ÉTAPE 15 Assembling the xLCD II.



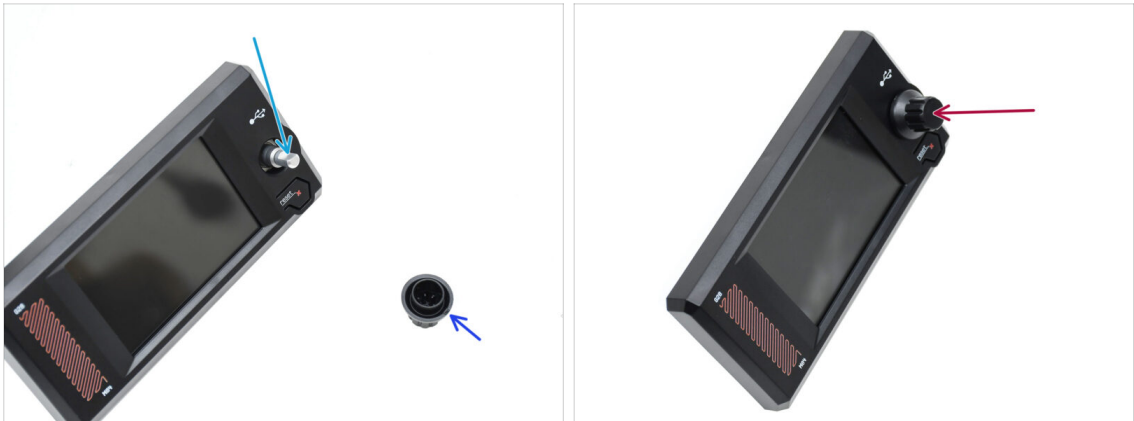
- Cover the assembly with the rear part.
 - Si vous avez une ancienne version du capot arrière imprimé, il doit s'accrocher au xLCD lui-même dans le coin. Avec la version actuelle, la partie arrière peut être simplement posée.
 - Fix the parts together using **JUST THREE** 3x8sT screws in the marked openings.
 - ⚠ N'insérez pas la vis dans la quatrième ouverture à côté du long connecteur pour le connecteur xLCD, visible à travers la découpe. Laissez-la vide pour le moment.

ÉTAPE 16 Installing the FE Faston connector



- Let's move on to the fourth screw opening—this is where we will attach the grounding faston connector.
 - À l'aide d'une pince à bec fin, manœuvrez soigneusement le connecteur Faston de mise à la terre sur l'ouverture de la vis, en vous assurant que les trous sont alignés.
 - Secure the connector in place using one 3x8sT screw, making sure it stays lined up as indicated.
 - ⚠ To prevent damaging some of the surrounding electronic components, be careful and make sure the connector doesn't spin, while tightening it.

ÉTAPE 17 Installing the LCD knob



- There is a flat part on the encoder shaft. Rotate the encoder so that the flat part is facing up.
- Il y a une petite marque de moulage sur le bouton moulé par injection, qui peut servir de marque d'orientation.
- Attach the knob onto the shaft, making sure the mark on the knob is facing up.

ÉTAPE 18 xLCD bezel: parts preparation



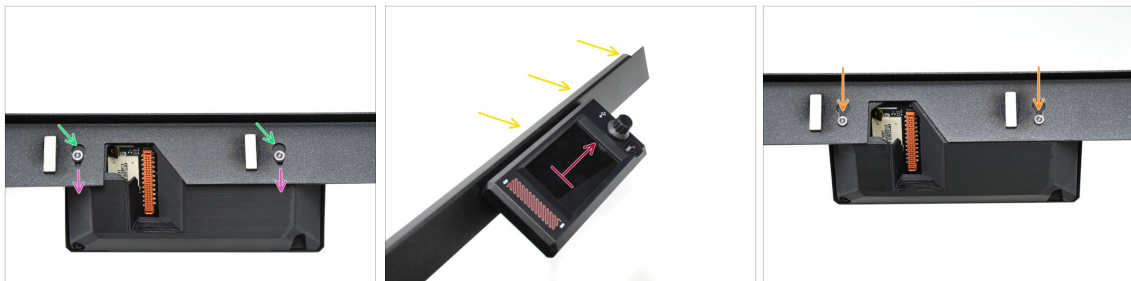
- For the following steps, prepare:**
- xLCD (1x) *qui se trouve dans le paquet Électronique*
- Écrou M3nS (2x)
- Vis M3x6 (2x)
- Bezel (1x) *found in the Metal parts 2/3 package*

ÉTAPE 19 Mounting the xLCD I.



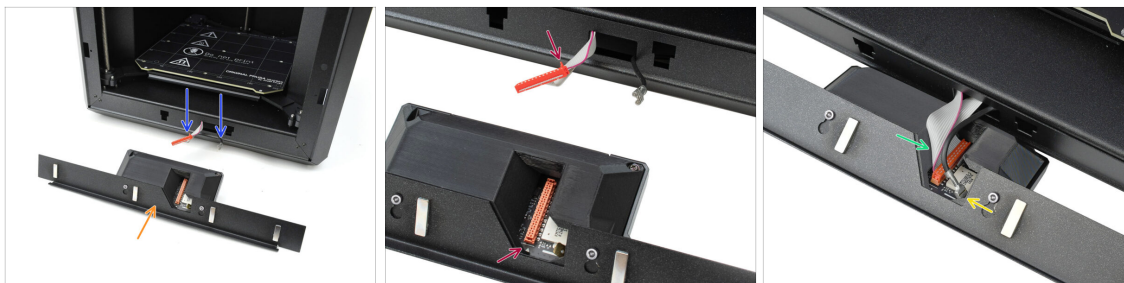
- Insert the two M3nS nuts into the dedicated openings on the back of the xLCD assembly,
 - Enfoncez les écrous à fond jusqu'à ce que les filetages soient alignés avec les ouvertures des vis.
- Attach two M3x6 screws into the openings. Do not screw them all the way in.
 - Leave a gap under the screw heads.

ÉTAPE 20 Mounting the xLCD II.



- Hook up the xLCD assembly onto the Bezel.
 - Insérez les têtes de vis dans les ouvertures en trou de serrure.
 - Slide the xLCD assembly so that the screw heads engage into the narrower parts of the keyholes.
- If assembled correctly, the LCD should be pointing up...
 - ...While the bent lip on the Bezel is on top.
- Push the screws all the way into the narrow part of the keyhole on both sides. Then, tighten the screws.

ÉTAPE 21 Installing the xLCD assembly



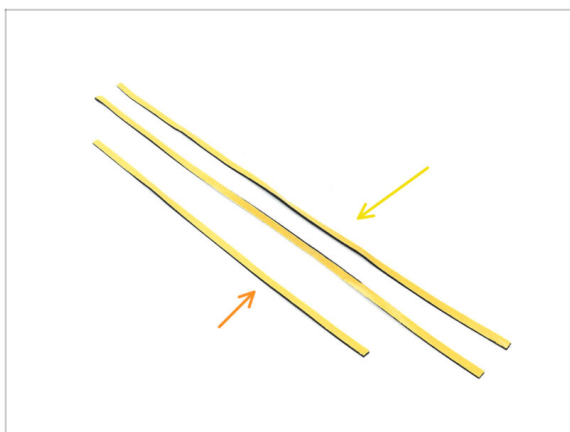
- ✦ Put the xLCD assembly in front of the printer, as pictured.
- ✦ Retirez les câbles appropriés de l'avant de l'imprimante pour faciliter leur connexion.
- ✦ There is a small red tab on the main connector. This tab must be oriented towards the triangle symbol on the PCB.
- ✦ Connect the main connector into the xLCD.
- ✦ Connect the grounding faston connector.

ÉTAPE 22 Securing the xLCD assembly



- ✦ Gently lift the xLCD assembly into the upward position.
 ⚠ Procédez avec précaution pour vous assurer qu'aucun câble ne soit pincé ou déconnecté.
- ✦ Hook the tiny tab on the left side of the bezel behind the left vertical profile of the printer.
- ✦ Gently lift the bottom part of the xLCD assembly to allow for smoother tab engagement and extra wiggle room.
 - ✦ Hook the tab on the right side into the printer's right profile.

ÉTAPE 23 Door seal: parts preparation



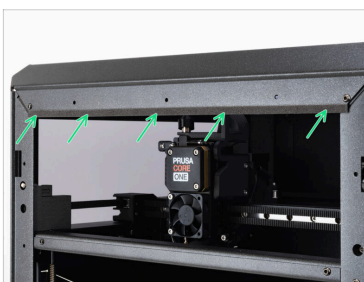
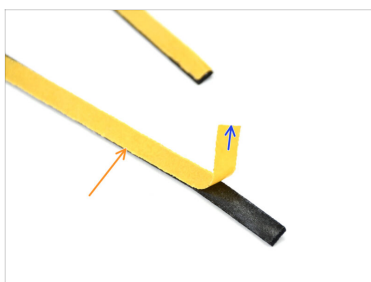
For the following steps, prepare:

Joint de porte latéral, le plus long (2x) qui se trouve dans le paquet Électronique & Visserie

Top door seal, a shorter one (1x) found in the Electronics & Fasteners package

i The color of the protective layer may vary.

ÉTAPE 24 Attaching the top seal



Take the **SHORTER** seal.

Décollez le début du film protecteur. Il n'est pas encore nécessaire de le retirer complètement.

i No need to remove it entirely yet. For easier installation, you can peel it off gradually as you go.

Start applying the seal along the top edge of the printer's frame.

Begin offset from the corner by a distance equal to the seal thickness.

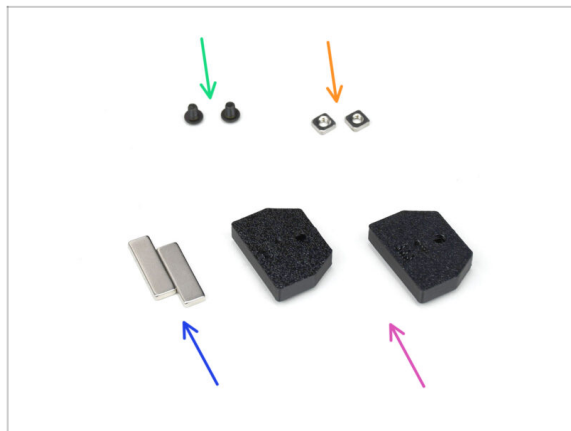
Apply the seal along the top edge, leaving the end offset from the corner, just like on the other side.

ÉTAPE 25 Attaching the side seals



- Apply the longer door seal, starting from the end of the seal on top.
- Travaillez de haut en bas.
- ① With needle-nose pliers, trim the excess.
- Using the same technique, apply the remaining long seal along the left edge of the printer's frame.

ÉTAPE 26 Magnet holders: parts preparation



● For the following steps, prepare:

- Vis M3x5rT (2x)
- Écrou M3nS (2x)
- 20x6x2 Magnet (2x) *found in the Electronics & Fasteners package*
- ⚠ **Keep the magnets apart at a sufficient distance. They can break each other!**
- Magnet Holder (2x) *found in the Printed parts package*

ÉTAPE 27 Assembling the magnet holders



- ✚ Insert the M3nS nuts into the corresponding openings in the magnet holders.
- ✚ Enfoncez les écrous à fond, jusqu'à ce que le filetage s'aligne avec l'ouverture de la vis.
- ✚ Insert the magnets into the corresponding pockets in the holders. Push them all the way in.
- ⓘ The orientation of the magnets does not matter.

ÉTAPE 28 Installing the magnet holders



- ✚ From the inside of the printer, insert the magnet holder assembly into the corresponding bottom opening in the right-side metal profile.
- ⚠ Assurez-vous que la poche rectangulaire saillante s'insère dans la découpe.
- ✚ Secure the assembly in place using the M3x5rT screw.
- ✚ Using the same technique, install the other magnet holder into the top opening on the right side.

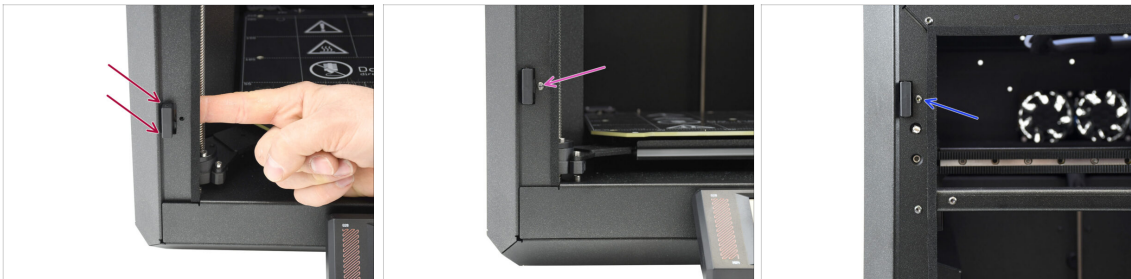
ÉTAPE 29 Charnières : préparation des pièces



For the following steps, prepare:

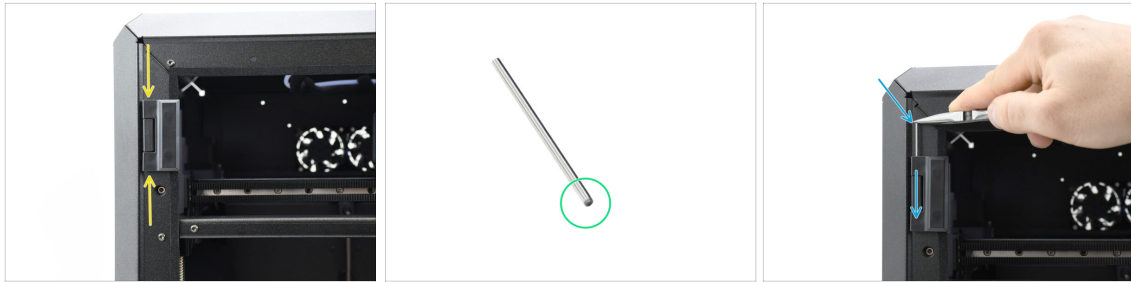
- Door-hinge-in (2x) *qui se trouve dans le paquet des Pièces du CoreXY + du Jeu de charnières*
- Door-hinge-out (2x) *found in the CoreXY + Hinges set package*
- Hinge Pin 2 x 40 mm (2x) *found in the Electronics & Fasteners package*
- Vis M3x5rT (2x)

ÉTAPE 30 Installing the door-hinge-in parts



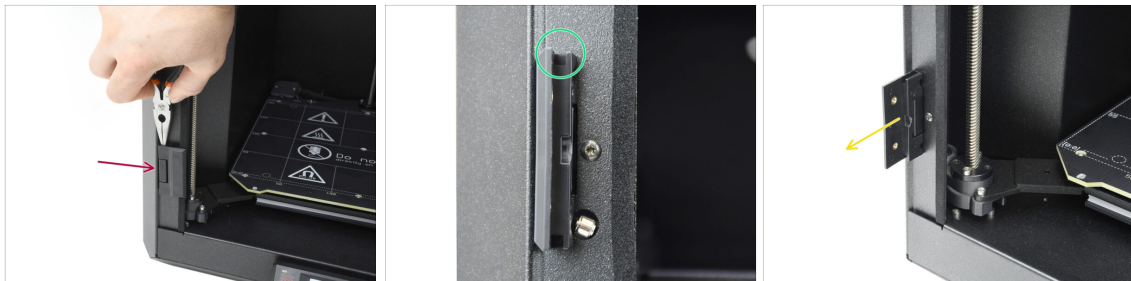
- From the inside of the printer, insert the door-hinge-in into the bottom rectangular opening in the left-side profile. The protruding part should pass through to the front.
- Fixez la door-hinge-in en place à l'aide de la vis M3x5rT.
- Using the same technique, install the other door-hinge-in into the opening on top.

ÉTAPE 31 Installing the door-hinge-out I.



- ✦ Align the door-hinge-out with the door-hinge-in.
- ✦ L'extrémité chanfreinée de l'axe de charnière doit être insérée en premier pour faciliter l'assemblage.
- ✦ Insert the pin from the top of the door-hinge-out, guiding it through the door-hinge-in until it is fully inserted.
- ❗ Use the tip of needle-nose pliers to press the pin in securely.

ÉTAPE 32 Installing the door-hinge-out II.

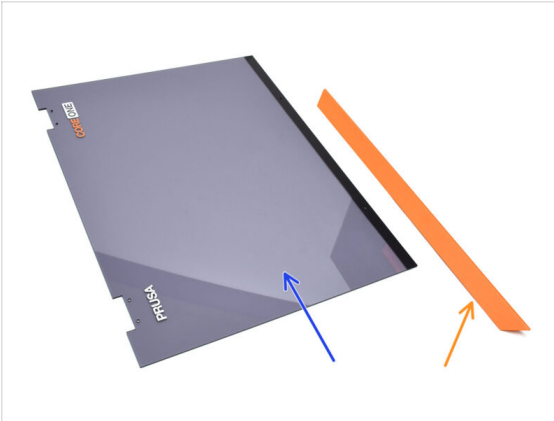


- ✦ Using the same technique, install the bottom door-hinge-out to complete the hinge assembly.
- ✦ Regardez dans les rainures des pièces door-hinge-out et vérifiez que les broches sont complètement insérées.

Aucune partie de l'axe ne doit être visible au-dessus de la surface inférieure de la rainure.

- ✦ Open up both the hinges.

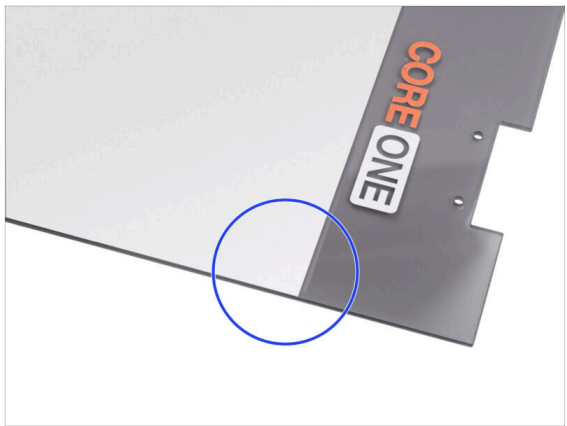
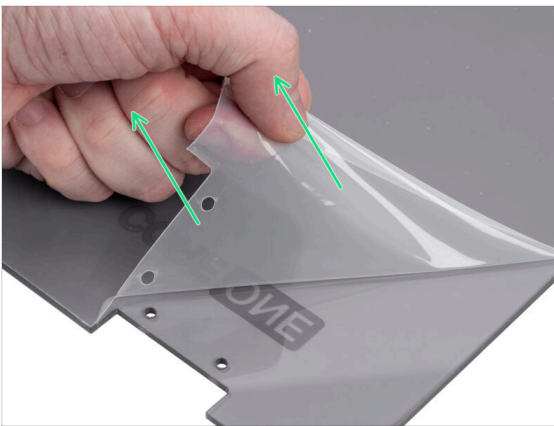
ÉTAPE 33 Door panel: parts preparation



For the following steps, prepare:

- Door (1x) found in the Plexi set package
 - ❶ Le panneau de porte est pré-marqué **CORE ONE**. Ne vous inquiétez pas, **c'est voulu** ! Vous appliquerez l'autocollant + de mise à niveau à la dernière étape.
- Door handle (1x) found in the Metal parts 2/3 package
- Vis M3x5rT (4x)

ÉTAPE 34 Door panel: removing the protective film



- **The door panel has protective film on both sides.** One covers the entire surface, the other just the center area.
- Peel off the film covering the entire door; it's lightly transparent.
- You can remove the center protective film (white) now or after mounting the panel to protect the surface during handling.
 - ❶ This protective film does not interfere with the installation of the hinges or handle.

ÉTAPE 35 Installing the door panel



- Align the door with the hinges. The cutouts on the door should fit into the grooves on top and bottom of the leaves.
- Make sure the door is oriented so that the signs on the door are pointing outward.
- Slide the door all the way into both the hinges.
- Fix the door to the hinges using four M3x5rT screws. Start with the top one. Then, do the bottom.

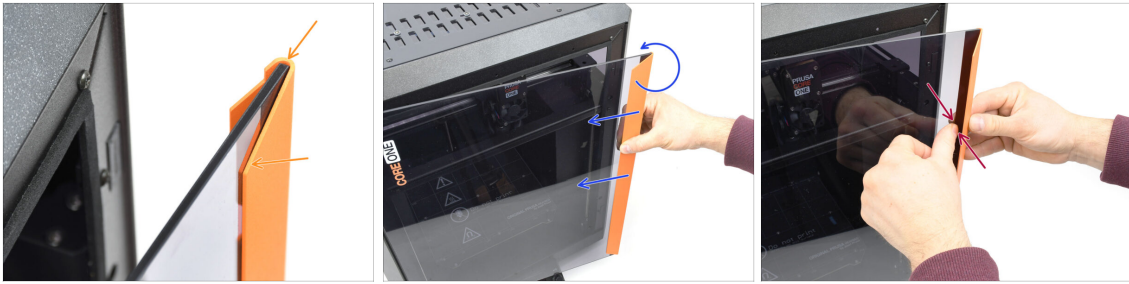
ÉTAPE 36 Assembling the door handle



- Let's move onto the handle. Remove the protective foil from both the adhesive strips on the inside.
- The part with the adhesive strip will go onto the back of the door. But do not attach the handle yet!

⚠ Wait for the upcoming step! We have to align the handle first!

ÉTAPE 37 Securing the door handle



- Align the handle so that the front chamfered part is flat to the door. The top of the handle must be flush with the door.
- While pushing the handle against the door to keep it aligned, slowly rotate it counterclockwise until the adhesive strips bond to the door.
- Push the door and handle together firmly in the adhesive strip areas to ensure a secure attachment.

ÉTAPE 38 Pose de l'autocollant : Préparation des pièces : Préparation des pièces



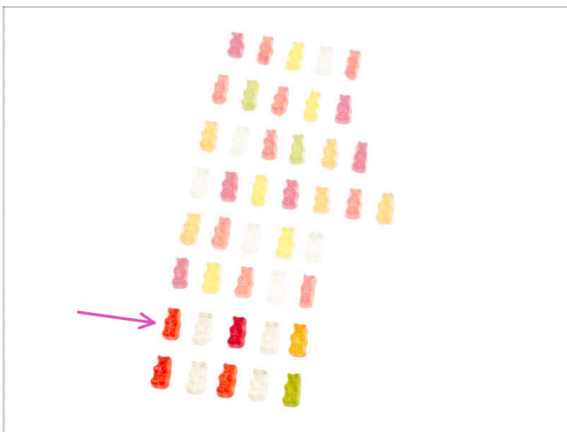
- Pour l'étape suivante, préparez :
 - Autocollant du plexi de la CORE One+
- i L'autocollant du plexi de la CORE One+ se trouve dans la boîte de mise à niveau vers la CORE One+.

ÉTAPE 39 Pose de l'autocollant



- ◆ Retirez l'autocollant de la base bleue.
- ◆ Alignez l'autocollant avec le **ONE** et appliquez une pression douce mais ferme sur l'autocollant.
- ◆ Décollez délicatement la couche transparente et assurez-vous que le + ne se décolle pas.

ÉTAPE 40 C'est l'heure des Haribo



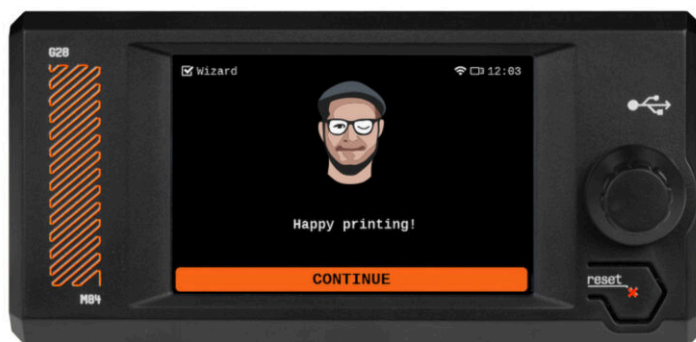
- ◆ Hard work deserves sweet results!
- ◆ Eat the seventh row.
- ⚠ But don't eat the rest yet.

ÉTAPE 41 Fini



- Félicitations ! Vous avez assemblé avec succès votre Prusa CORE One+.
- Let's move to the final chapter.

9. Calibration & First run



ÉTAPE 1 Tension de la courroie



- i** This chapter will guide you through calibrating and preparing the printer for its first run.
- Calibrate the belt tension. See the following article for more info:
 - **Adjusting belt tension (CORE One)**
- !** Don't forget to come back here after adjusting the belts.

ÉTAPE 2 Installation du support de bobine : Préparation des pièces : Préparation des pièces



- **Pour l'étape suivante, préparez :**
 - Joint torique
 - Spoolholder-static
- i** Le Spoolholder-static et le joint torique se trouvent dans le même sachet.

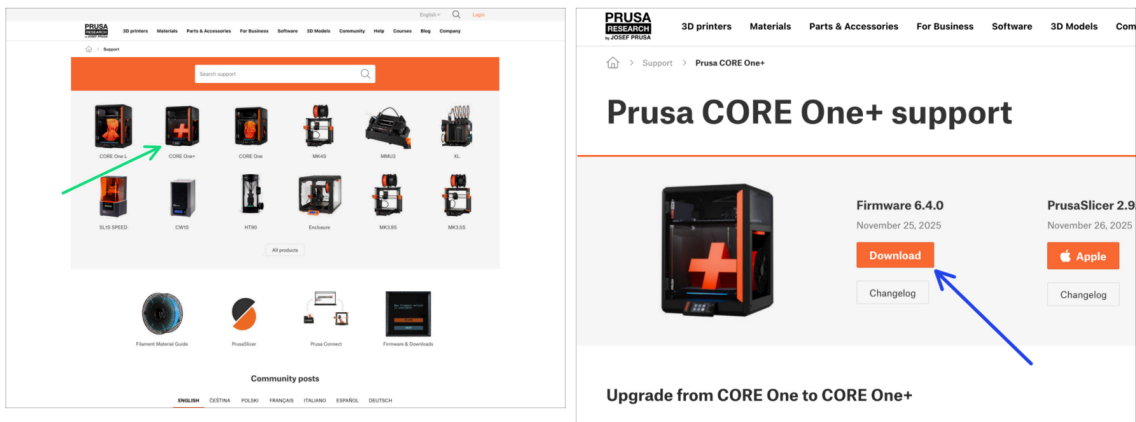
ÉTAPE 3 Fixation de la plaque d'impression et du support de bobine



⚠ **Make sure there is nothing on the heatbed.** The heatbed must be clean. Any dirt can damage the surface of both the heatbed and the print sheet.

- 🟡 **Attach the sheet by first aligning the rear cutout with the locking pins on the back of the heated bed.** Hold the sheet by the front two corners and slowly lay it down onto the heated bed - **watch your fingers!**
 - ⬛ Keep the **print sheet** clean for optimum performance.
 - ⬛ #1 cause of prints detaching from the print surface is a greasy print sheet. **Use IPA (Isopropyl alcohol) to degrease it** if you have touched its surface before.
- 🟢 Placez le joint torique sur le Spoolholder-static.
- 🟡 Insérez le Spoolholder-static dans le dock Puck-universal et verrouillez-le en le tournant dans le sens des aiguilles d'une montre.

ÉTAPE 4 Téléchargement du firmware



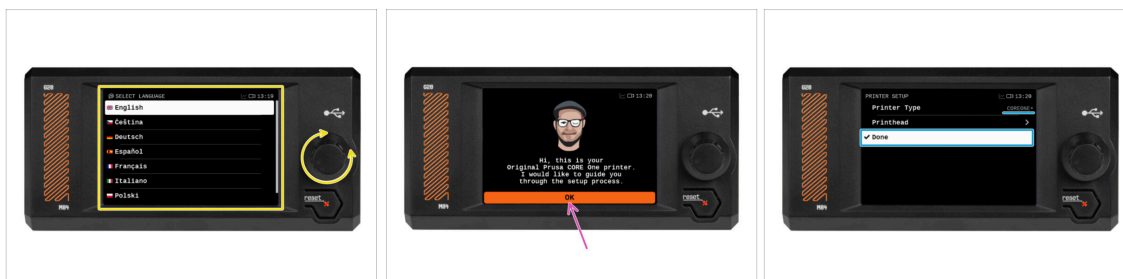
- ⬛ We will have to upgrade the firmware.
 - 📄 La CORE One+ nécessite une version de firmware **6.4.0 ou plus récente**.
- 🟢 Visitez la **page de support de la Core One+ sur help.prusa3d.com**.
- 🟢 Download the latest firmware file (.bbf).
Save the file onto a USB drive.

ÉTAPE 5 Allumage de l'imprimante



- ✿ Insert the USB drive included in your kit into your printer.
 - ❗ The included USB drive contains the latest firmware file.
- ✿ Connect the power cable and plug the printer into a wall outlet.
- ✿ Turn the printer on using the switch on the back.
- ❗ The printer will now detect if a new firmware file is available on the USB drive.
- ✿ If the "New firmware available" screen appears, hit **FLASH** by pressing the rotary knob to upgrade to the latest firmware.
 - ✿ If no such message appears, the printer is running the latest firmware already. Proceed to the next step.

ÉTAPE 6 Setting up the printer: Intro



- ✿ The printer displays on the screen a prompt to select your language. Use the control knob or touchscreen to set your preference.
- ✿ After selecting your language, the printer will display the welcome screen. Hit **OK** to continue through the setup process.
- ✿ The next screen will prompt you to select your printer model **COREONE**. Hit **Done** to continue.

ÉTAPE 7 Setting up the printer: Network setup



- The Network Setup screen will ask you to connect to a Wi-Fi network using our official Prusa mobile app.
- ① Read more on prusa.io/app.
- If you select **No**, the printer will show alternative ways to connect to Wi-Fi. This step is optional and can be done later.
- ① You can skip this screen and set up the network connection later.

ÉTAPE 8 Assistant : Introduction



- ① The printer will prompt you to run self-tests and calibrations for all important components. The entire process takes a few minutes, with some parts requiring direct user interaction.
- Hit **YES** to begin the self-test and follow the instructions on screen.
- ⚠ During the self-test, **keep the door closed** until you are prompted. Opening the door will interrupt the process.
- There are **HOT** and moving parts inside during the self-test.
- The printer will begin by testing all the fans. **Be aware—it can get quite noisy for a while!**

ÉTAPE 9 Wizard: Door Sensor Calibration



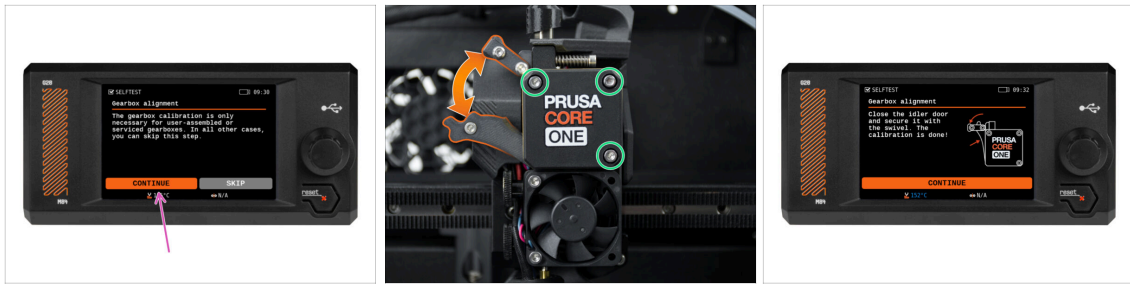
- ✿ The first part that requires your interaction is the door sensor calibration. To begin, hit **Calibrate** and follow the on-screen instructions.
- ✿ You'll be prompted to gradually tighten the sensor tension screw from its default loose position - usually in half-turn steps, possibly several times during calibration.
 - ✿ After each adjustment, observe the door sensor switch emerging from the front profile hole.
- ✿ Repeat the procedure until the door sensor is correctly adjusted - meaning it switches at a hand-gap distance. Then hit **Continue**.
- ❗ Once the sensor is properly calibrated, you should hear an audible click from the door sensor area when opening and closing the door.

ÉTAPE 10 Assistant : Test du capteur de force



- ✿ The next step of the wizard will prompt you to touch the nozzle to test and calibrate the Loadcell. During this procedure, the **parts of the printer are not heated up** so that you can touch them. Hit **Continue**.
- ❗ Loadcell calibration requires the door to be open, as you must interact directly inside the printer.
 - ✿ Do not touch the nozzle yet, wait until prompted by the **Tap nozzle NOW** message.
 - ✿ Tap the nozzle from below. In case the Loadcell does not detect the touch, you will be prompted to repeat the step. Otherwise, you will see **Loadcell test passed OK** when it succeeds.
 - ✿ To allow the printer to continue with the Wizard, **close the door**.

ÉTAPE 11 Assistant : Alignement du réducteur



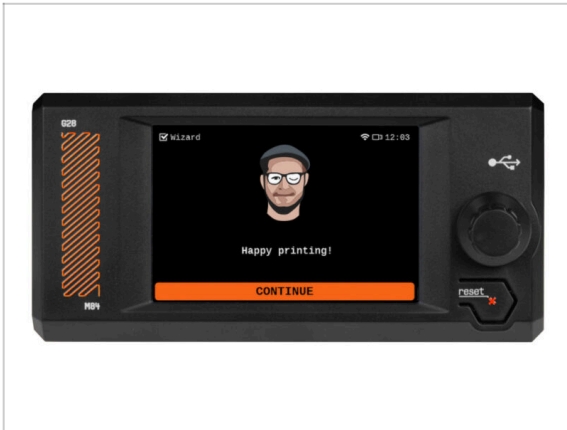
- ✦ Once you get to the Gearbox Alignment part, select **Continue** and follow the on-screen instructions.
- 🔧 Make sure the idler lock (swivel) is unlocked from the idler door.
- 🟢 Loosen the three screws on the front of the gearbox by 1.5 turns.
- 📌 The printer will go through the automatic gearbox alignment. This process can't be seen from the outside.
- ⬛ Once prompted, tighten the three screws in the pattern indicated on the screen.

ÉTAPE 12 Wizard: Filament Sensor Calibration



- 🔧 Vérifiez le commutateur manuel du capteur de filament. **Assurez-vous qu'il est activé.**
- ✦ During the filament sensor calibration, you will need to use a short piece of filament. Prepare the filament and select **Continue**.
- 📌 There should be no filament inside the extruder before the calibration process starts.
- 🔵 Place a spool of filament onto the spool holder on the right side of the printer.
- 🟡 When prompted, begin inserting the filament into the PTFE tube located beneath the right handle.
- ⬛ Remove the filament after the calibration finishes.

ÉTAPE 13 Assistant terminé



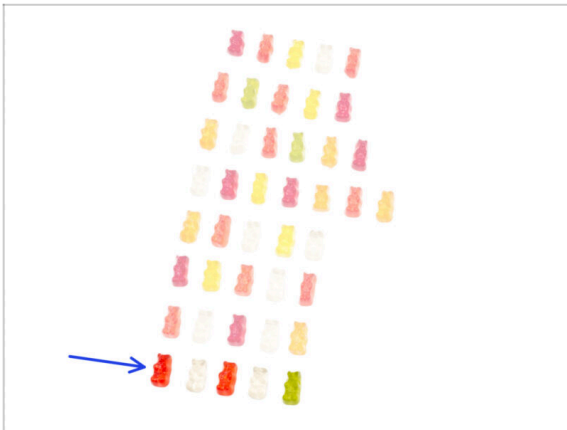
- ◆ Congratulations! The Wizard is complete. Now it's time to test some prints.

ÉTAPE 14 Setting the printer up



- ◆ Pour activer l'ouverture automatique de la grille supérieure, rendez-vous dans les **Réglages -> Matériel -> Contrôle de ventilation de la chambre** et réglez le sur **Auto**.

ÉTAPE 15 C'est l'heure des Haribo



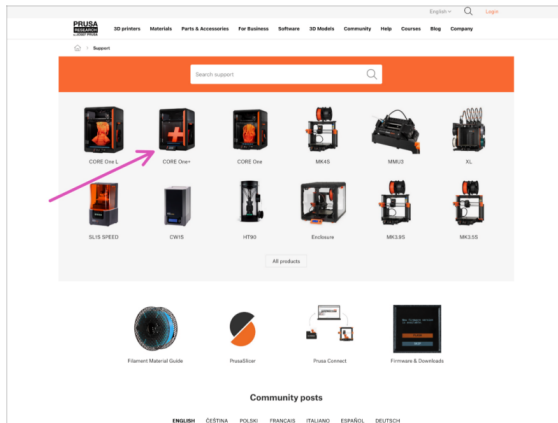
- 🛡️ Victory tastes like gummy bears!
- 🔵 Enjoy the rest. You've earned this.

ÉTAPE 16 Manuel



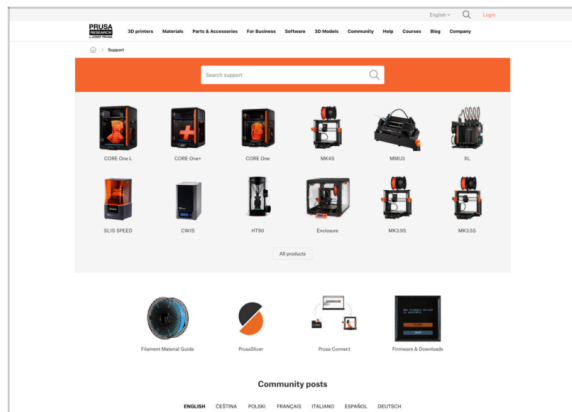
- 🛡️ Read the **3D Printing Handbook** dedicated to your printer and follow the instructions to set up the printer and prepare it for your first print.
- 📌 The latest version is always available at help.prusa3d.com.
- ⚠️ Read the **Disclaimer and Safety instructions** chapters.

ÉTAPE 17 Mise à jour du firmware



- ❗ Toutes les imprimantes sont livrées avec une clé USB contenant le dernier firmware. Il est toutefois recommandé de vérifier et éventuellement de mettre à jour la version du firmware toutes les quelques semaines.
- 🔗 Visit the help.prusa3d.com page.
- 🔗 Accédez à la page Prusa CORE One+.
- 🔗 Save the firmware file (.bbf) onto the bundled USB drive.
- 🔗 Branchez la clé USB à l'imprimante. Ensuite, lorsque vous y êtes invité, sélectionnez l'option FLASH sur l'écran.

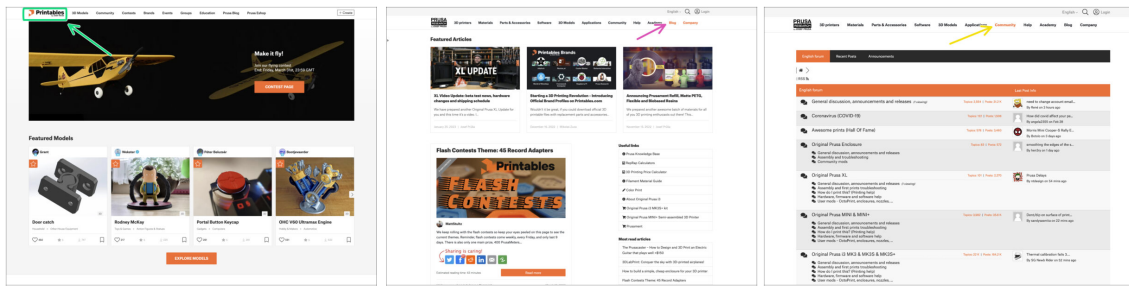
ÉTAPE 18 Base de connaissances Prusa



If you encounter any problems at all, don't forget you can always check out our knowledge base at help.prusa3d.com

- 🔗 We're adding new topics every day!

ÉTAPE 19 Rejoignez Printables !



- Don't forget to join the biggest Prusa community! Download the latest models in STL or G-code tailored for your printer. Register at [Printables.com](https://www.printables.com)
- Looking for inspiration on new projects? Check our blog for weekly updates.
- If you need help with the build, check out our forum with a great community :-)
- All Prusa services share one user account.

Journal des modifications



ÉTAPE 1 Historique des versions



- **Versions du manuel du kit de conversion de la Prusa CORE One+ :**
- 11/2025 - Version initiale 1.00

[illegible]

This image shows a full page of blank, lined paper. It features approximately 20 evenly spaced horizontal grey lines across the entire width of the page, providing a guide for handwriting or typing. The background is a clean, solid white color.

This image shows a full page of blank, lined paper. It features approximately 20 evenly spaced horizontal grey lines across the entire width of the page, providing a guide for handwriting or typing. The background is a clean, off-white color.

This image shows a full page of blank, lined paper. It features approximately 20 evenly spaced horizontal grey lines across the entire width of the page, providing a guide for writing. The background is a clean, solid white color. There are no margins, text, or other markings present.

