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1. Úvod



KROK 1 Příprava stavebnice



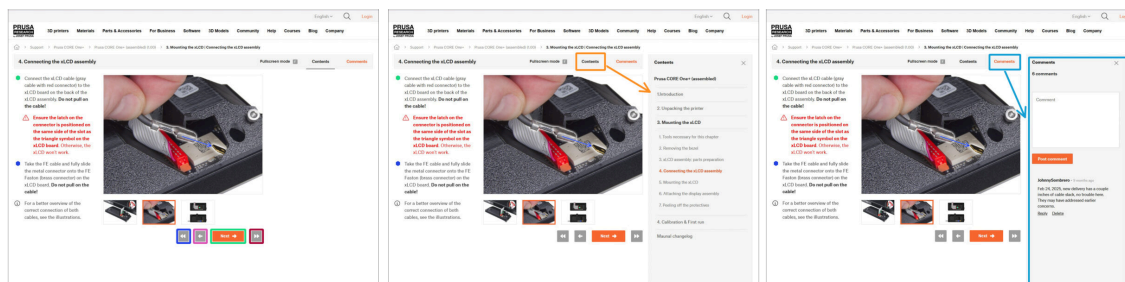
🛡️ Vítejte v návodu na sestavení vaší tiskárny Prusa CORE One+.

Postupujte prosím podle následujících kroků, aby byla vaše tiskárna co nejdřív a bez problémů připravena k prvnímu tisku.

🛡️ Please prepare the kit received from Prusa Research.

📄 No soldering or wire crimping is required.

KROK 2 How to navigate through the manual



🛡️ Use the graphical navigation buttons in the bottom right corner or the arrow keys on your keyboard:

🔵 **Tlačítko „Přetočit zpět“ (Back) / Šipka nahoru** - Vás vrátí na předchozí krok.

🔴 **Tlačítko šipka doleva / klávesa šipka doleva** - Přesune na předchozí obrázek nebo na předchozí krok, pokud se jedná o první obrázek v kroku.

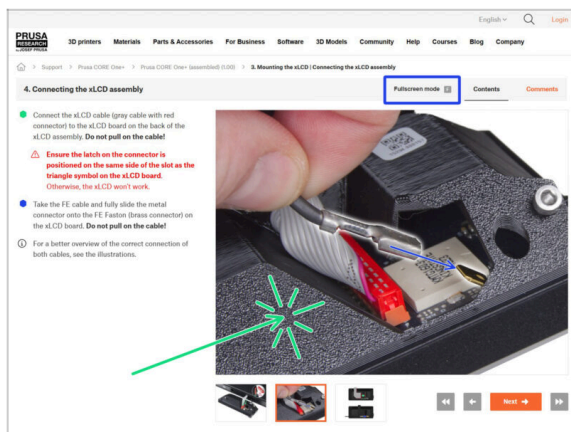
🟢 **Next button / Right arrow key** - Moves to the next image, or to the next step if it's the last image in the step.

🔴 **Tlačítko „Přetočit vpřed“ (Next) / Šipka dolů** - Vás přesune rovnou na další krok.

🟡 **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.

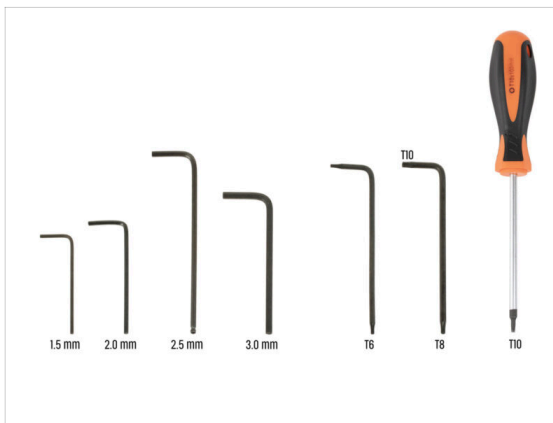
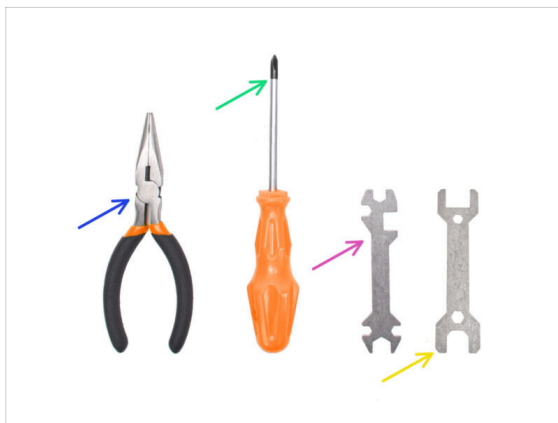
🔵 **Click on Comments** to open the discussion for a specific step and leave your feedback.

KROK 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.
- Kliknutím na **Režim celé obrazovky** nebo stisknutím klávesy F maximalizujete prostor na obrazovce a soustředíte se výhradně na instrukce.

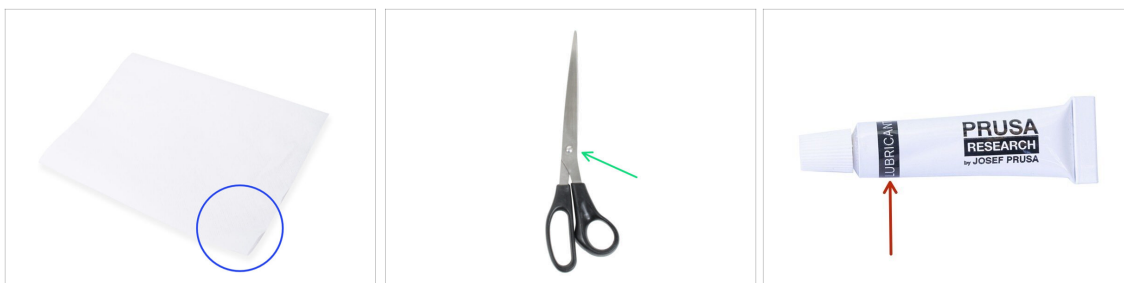
KROK 4 All the required tools are included



■ Balíček nástrojů obsahuje:

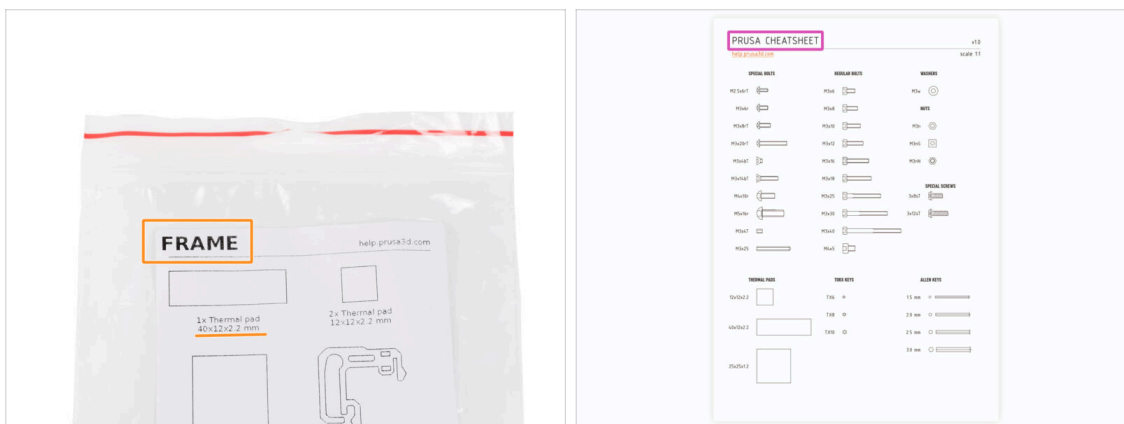
- Tools can be found in *Electronics & fasteners* package.
- Čelistové kleště (1x)
- Křížový šroubovák (PH2) (1x)
- Univerzální klíč (1x)
- Wrench size 13-16 mm (1x)
- Sada inbusových klíčů
- Sada klíčů Torx

KROK 5 Additional utilities for this guide



- ◆ **Some steps in the manual will require commonly available items to help you with assembly (not included in the kit):**
- ◆ Paper towels or a piece of cloth - For wiping preservative oil from the smooth rods and linear rail.
- ◆ Nůžky - na rozstříhnutí pytlíku s ložisky
- ◆ Mazivo (to je součást sady) - K promazání planetové převodovky v Nextruderu (tisková hlava).

KROK 6 Orientace podle štítků



- ◆ All the boxes and bags including parts for the build are labeled.
- ◆ The labels include the list of contents and part count.
- ◆ Můžete si také stáhnout náš **Cheatsheet**, kde najdete obrázky spojovacího materiálu z našich stránek v poměru 1:1 - najdete ho zde: prusa.io/core-one-cheatsheet. Vytiskněte si ho v měřítku 100 % a měřítko rozhodně neměňte, jinak nebude fungovat.
- i Pro PRUSA veterány: Spojovací materiál je rozdělen do jednotlivých sáčků podle typu. Ne do balíčků pro jednotlivé kapitoly, jak tomu bylo u předchozích tiskáren.
- P V pokynech bude vždy uveden balíček, ve kterém každý z potřebných dílů najdete, s výjimkou spojovacího materiálu, který se všechen nachází v balíčku Spojovací materiály.

KROK 7 Záložní materiál



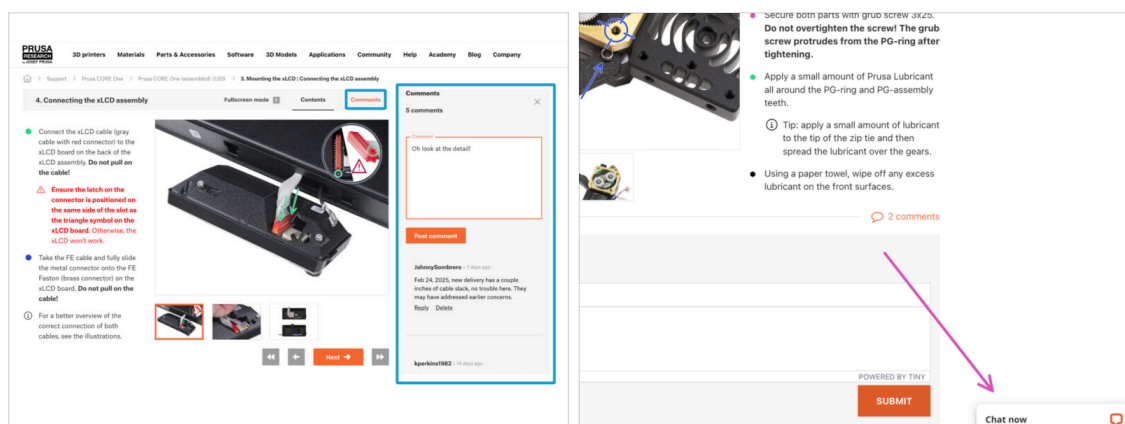
- ◆ Spare fasteners are included in each bag of fasteners. The amount of spare is always included in the total number shown on the bag.
- ◆ Similarly, some parts may include one extra piece in the same bag.

KROK 8 Printed parts - versioning



- ◆ Většina tištěných dílů tiskárny Prusa CORE One+ je označena jejich verzí.
 - ◆ **E, F and Gx series** (e.g. E1) - those parts are printed on Prusa Research farm and are distributed with the kit.
 - ◆ **Řady R, S a Tx** (např. R1) - tyto díly jsou k dispozici ke stažení na [printables.com](https://www.printables.com) a jsou naprosto shodné s dodávanými díly.
 - ◆ Čísla označují drobné změny, které obvykle zahrnují malé úpravy designu. Odlišný štítek v manuálu (např. odlišná verze zobrazená na fotografiích) nemá vliv na sestavu – všechny verze jsou plně kompatibilní.
 - ◆ Pokud však konkrétní revize vyžaduje odlišný postup sestavení, jasně to v manuálu zdůrazníme a vysvětlíme rozdíly.
- ❗ In case you have issues while assembling the printer with the certain printed part, please try to find this label and tell it to our support team.

KROK 9 We are here for you!



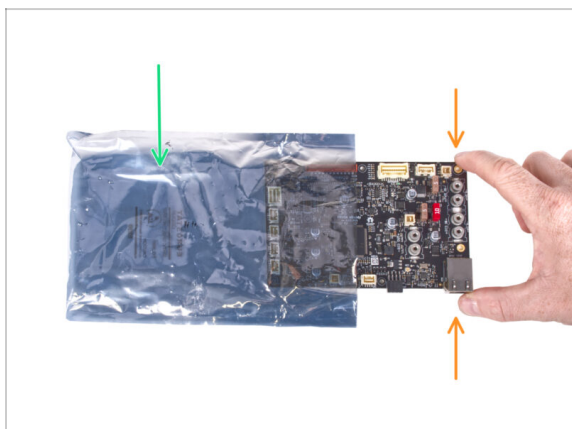
- Lost in the instructions, missing screw or cracked printed part? **Let us know!**
- You can contact us using the following channels:
 - Pomocí komentářů pod jednotlivými kroky.
 - Pomocí naší 24/7 live chat podpory zde help.prusa3d.com
 - Napsáním emailu na info@prusa3d.cz

KROK 10 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.
 - ⬢ **Matice stále vypadává:** Použijte kousek izolepy k dočasné fixaci matice na místě, jakmile vložíte šroub, můžete izolepu odstranit. *Použití lepidla se nedoporučuje, protože se může částečně dostat do závitu a pak nebudete schopni šroub správně dotáhnout.*
- ⬢ Pokaždé, když budeme doporučovat použít "techniku vtahování matek pomocí šroubu", připomene vám ji avatar Pepa ;)
- ⓘ Parts in the pictures are used as an example.

KROK 11 Důležité: Ochrana elektroniky



⚠ WARNING: Make sure to **protect the electronics against electrostatic discharge (ESD)**. Always unpack the electronics right before you need them!

Here are some **tips to prevent damage to the electronics**:

- Keep the electronics inside the ESD bag right until you are asked to install them.
- **Při manipulaci se vždy dotýkejte pouze hran desky.** Vyvarujete se dotyků dílů a komponent na desce.
- **Než se dotknete elektroniky**, použijte v blízkosti jakoukoli vodivou (kovovou) součástku, abyste eliminovali případný statický náboj z rukou.
- 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.

KROK 12 Odměňte se



- ◆ Stavba tiskárny CORE One+ je sice zábava, ale také práce. Takže se po dokončení každé z kapitol nezapomeňte odměnit. **V balení pro tento účel najdete pytlík medvídků Haribo!**
- ⚠ **The biggest issue from our experience** (MK4S, MK4, MK3S+, MK3S, MK3, MK2S, ...) is inadequate bear consumption. Many of you didn't have enough gummy bears for all chapters, some even ate them all before they started!
- ◆ Po letech důkladného vědeckého výzkumu jsme dospěli k řešení => Na konci každé kapitoly se dozvíte konkrétní množství medvědů, které máte zkonzumovat.
- ◆ Z výzkumu také vyplývá, že konzumace množství medvídků v rozporu s doporučením návodu může vést k nepředvídatelnému návalu energie. Před upravením dávky medvídků se tedy radši poraďte s odborníkem v nejbližší cukrárně.
- ⚠ **Haribo prozatím schovejte!** Z našich zkušeností má volně ležící pytlík sladkostí tendenci náhle zmizet. Tento fenomén máme potvrzený velkým počtem případů z celého světa.

KROK 13 How to successfully finish the assembly

Step 25 Attaching the spacers



- Insert two M3n nuts to the X-carriage-back.
- ① Use the screw pulling technique.
- From the opposite side, insert the M3x10 screw into the X-carriage-back. The screw must protrude from the "front" side of the part.
- Attach the spacer 10 mm on the M3x10 screw and tighten the screw. **Note the cutout of the same shape as the spacer. It must fit perfectly and must not rotate.**



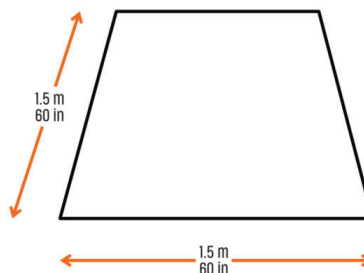
2 comments



Pro úspěšné sestavení stavebnice CORE One+ se prosím řiďte následujícím:

- Always read all the instructions at the current step first, it will help you to understand what you need to do. Don't cut or trim unless you are told to!!!
- Neříďte se pouze obrázky!** To nestačí. Psané instrukce jsou co nejkratší mohou být. Čtěte je.
- Čtěte komentáře od ostatních uživatelů, jsou skvělým zdrojem nápadů. I my je čteme a na základě vaší zpětné vazby pak návod na montáž vylepšujeme.
- Používejte přiměřenou sílu,** tištěné části jsou odolné, ale ne nerozbitné. Pokud do sebe něco nepasuje, zkontrolujte dvakrát váš pracovní postup.
- Eat the gummy bears as instructed!** Disobedience won't be tolerated :D
- A to nejdůležitější: Stavbu si užijte a přejeme vám příjemnou zábavu!** Klidně zkuste přizvat i vaše děti, přátele nebo partnery.

KROK 14 Připravte si pracovní stůl



- **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.
- **Budiž světlo!** Ujistěte se, že se nacházíte na dobře osvětleném místě. Pravděpodobně se vám bude hodit další lampa nebo dokonce baterka.
- Připravte si něco na plastové sáčky a odstraněné obalové materiály, abyste je mohli následně recyklovat. Ujistěte se, že se nevyhazují žádné důležité součásti.
- Doporučujeme pracovní plochu o minimálních rozměrech 1,5 x 1,5 metru.
- ⚠ **It's highly recommended to place a soft pad on your workbench. Some sheet metal parts have sharp edges that could scratch the surface.**
- ⓘ You can use a piece of cardboard as a protective pad.
- OK, we are ready. Let's start! Go to chapter **2. Frame assembly**

KROK 15 Installing the add-ons and upgrades

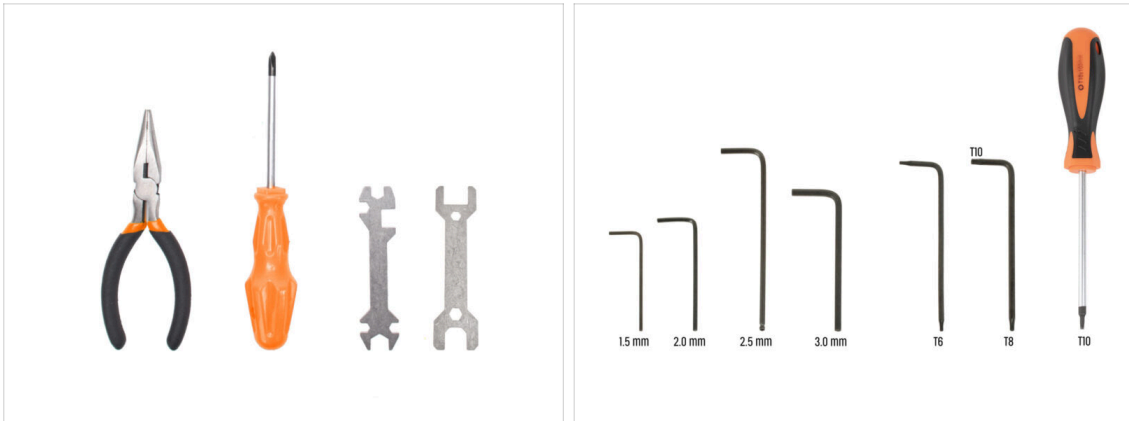


- ◆ This information applies to users planning to install upgrades and add-ons, such as Buddy Camera, an advanced filtration system, and MMU3 in the future.
- ① **Before installing any add-ons and upgrades, it is essential to completely assemble and test your printer.** Once the printer is fully functional, follow the separate MMU3 or add-on assembly manuals to modify the printer for installation.

2. Sestavení rámu

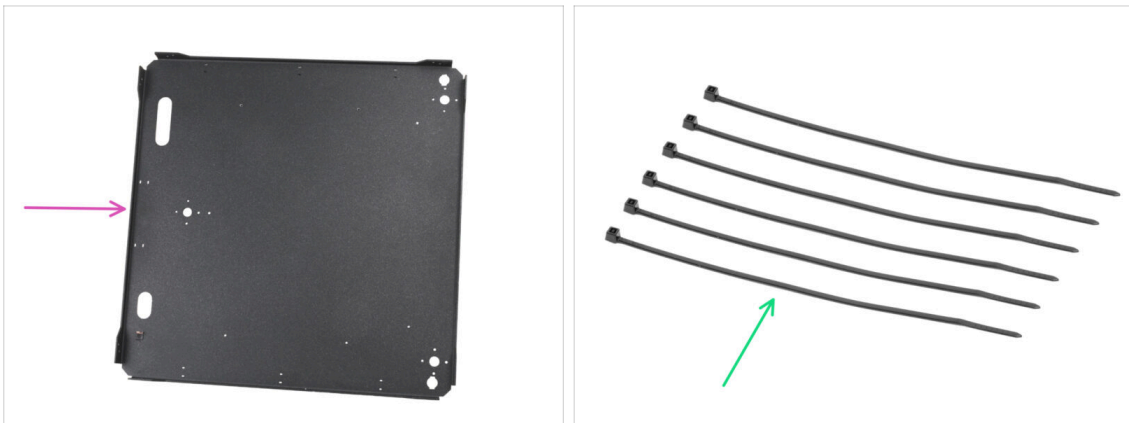


KROK 1 Tools necessary for this chapter



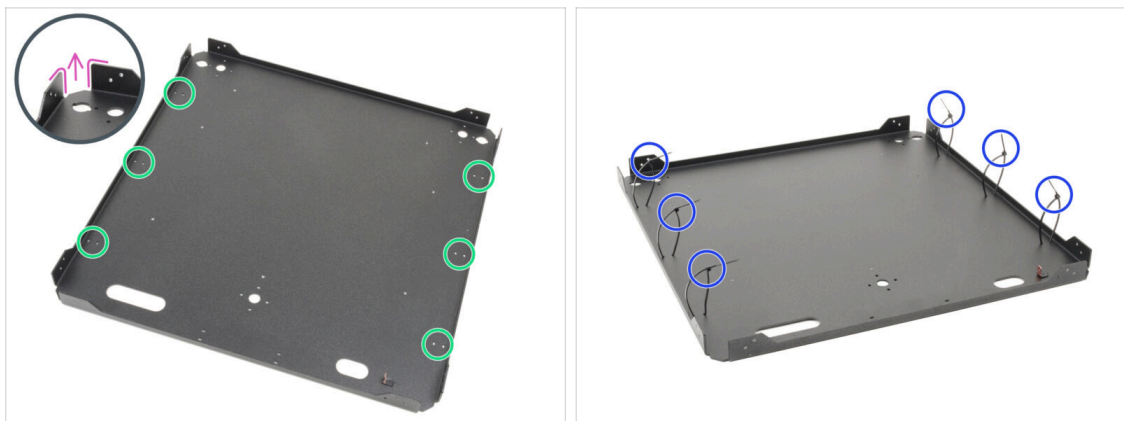
- **For this chapter, please prepare:**
- Klič 13-16
- 2,5mm inbusový klič
- T10 torx key / T10 torx screwdriver

KROK 2 Base assembly: parts preparation



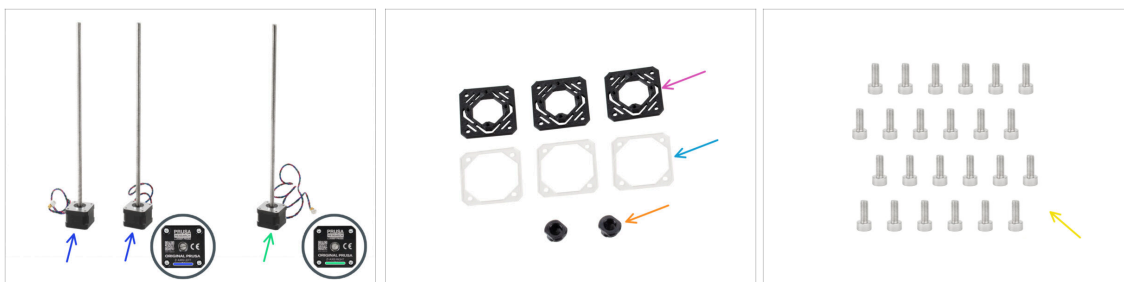
- **For the following steps, please prepare:**
- Bottom panel (1x) *found in the Metal parts 1/3 package*
- Zip tie (6x) *found in the Electronics & Fasteners package*

KROK 3 Inserting the zip ties



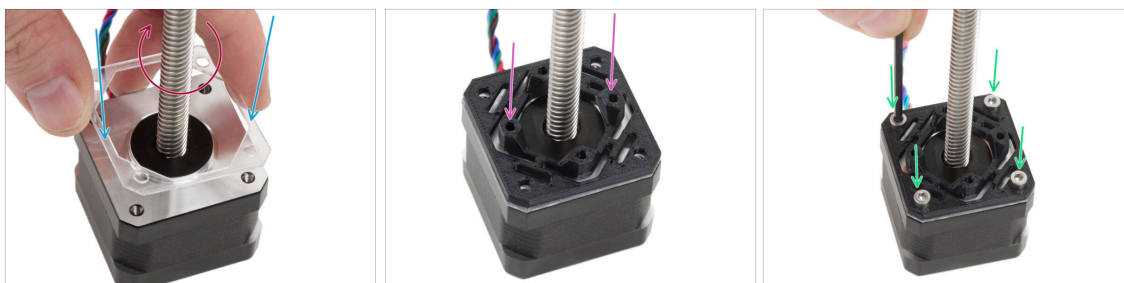
- ✎ Turn the bottom panel so that the bends of the plate are facing upwards.
- 🟢 Note the twin holes for the zip ties around the perimeter of the panel.
- 🟡 Insert six zip ties through the holes, placing them along both sides and partially tightening them, engaging only the first few teeth.
- ⚠️ **Do not fully tighten them yet, as we will route cables through them later.**
- 📌 Note: The orientation of the zip tie heads (inside or outside the metal sheet) doesn't matter.

KROK 4 Base assembly: parts preparation



- ⬛ **For the following steps, please prepare:**
- 🟡 Z-axis left motor (2x) *found in the Motor set box.*
- ⚠️ **One Z-axis left motor is packed separately in the *Electronics & chamber parts* package.**
- 📌 For now, keep the trapezoidal nuts in the motor package.
- 🟢 Z-axis right motor (1x) *found in the Motor set box*
- ✎ Z-motor-mount (3x) *found in the Printed parts package*
- 🟡 Motor washer (3x) *found in the Electronics & Chamber parts package*
- 🟡 Z-rod-mount (2x) *found in the Printed parts package*
- 🟡 Šroub M3x8 (24x)

KROK 5 Installing the motor mounts



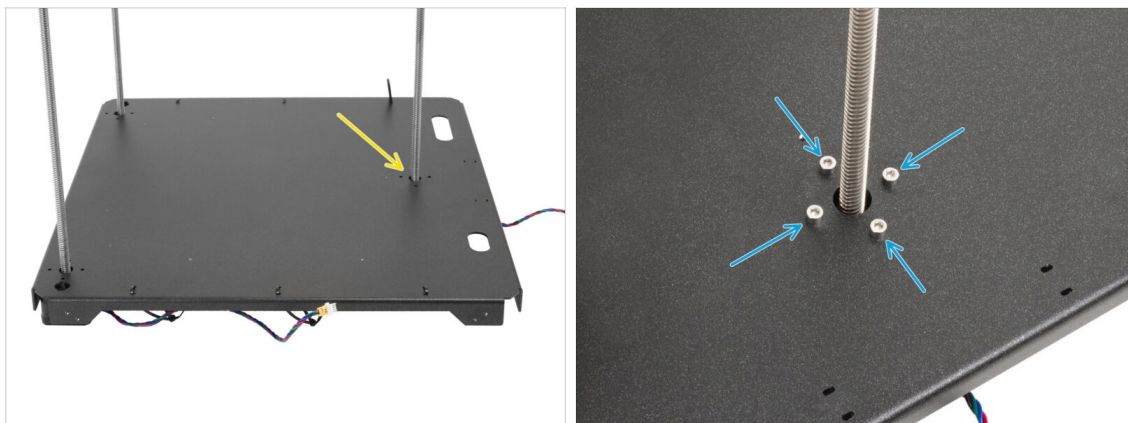
- 🔴 Try to rotate the threaded rods on each Z motor to make sure they are not completely blocked in rotation.
- 🔵 Attach one transparent motor washer pad on each Z motor.
- 🟡 Place one Z-motor-mount on each motor washer. **The protrusions on the part must be facing upwards.**
- ⬛ Align holes with all the parts.
- 🟢 Join all parts together with four M3x8 screws.
- ⬛ Follow the same procedure for all motors.

KROK 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.
- ⚠️ **The motor cable must point outwards (towards you).**
- 🔵 Push both Z-axis motor left through the bottom panel.
- 🔴 **The motor cables must point to the rear motor side.**
- 📄 **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 :).

KROK 7 Securing the rear motor



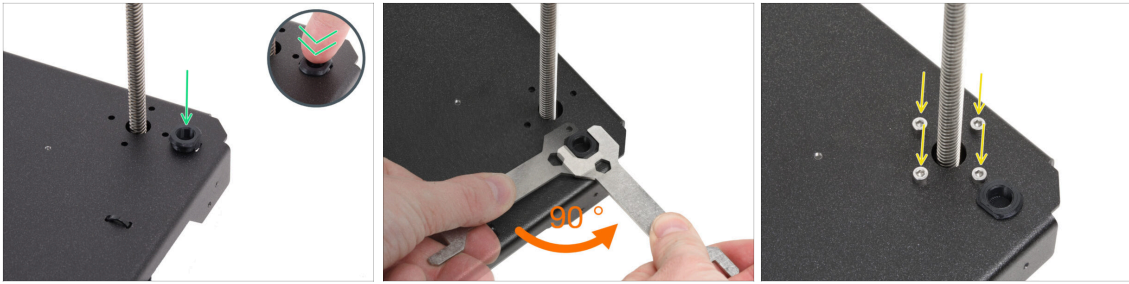
- ✦ Begin securing the motors, starting from the rear motor.
- ✦ Insert and fully tighten four M3x8 screws into the **rear motor**.
 - ⚠ Make sure the screws stay straight and do not tilt as you tighten them.
 - ⚠ Do not overtighten the screws, as they thread directly into the plastic part. For a final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

KROK 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.

KROK 9 Installing the front motor left

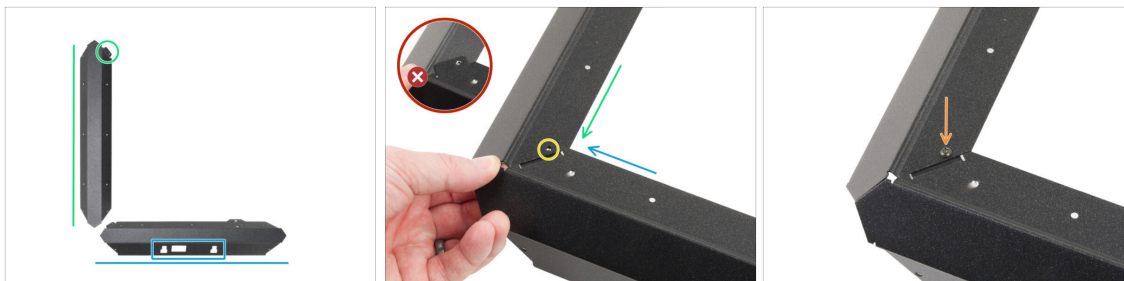


- Let's move to the front left motor (from the front view).
- ⚠ Ensure, the motor cable still points to the rear side.
- Insert the rod-mount into the opening next to the front right Z motor.
- Use the 13-16 wrench to rotate the rod mount 90 degrees, locking it into place.
- Secure the motor using four M3x8 screws. Tighten them completely.
- ⚠ Make sure the screws stay straight and do not tilt as you tighten them.
- Place the whole assembly aside for a while.

KROK 10 Bottom frame: parts preparation

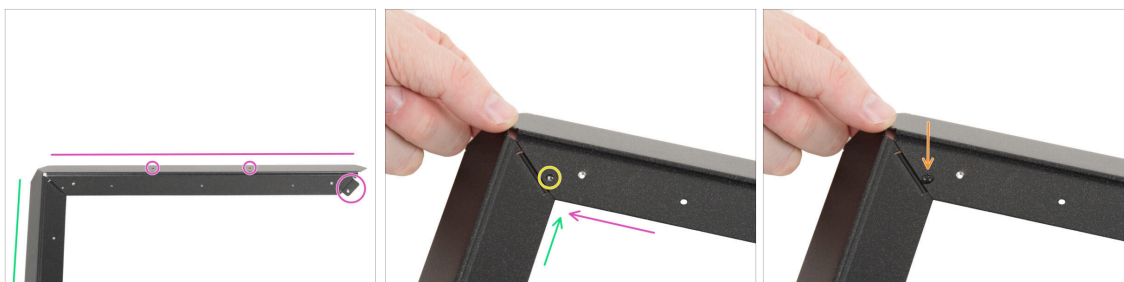


- For the following steps, please prepare:
- ⚠ Be very careful when handling sharp sheet metal parts to avoid injury or damage.
- ⚠ Metal sheet profiles may look identical at first glance, but there are some differences. DOUBLE-CHECK to pick the correct ones.
- Front profile (1x) **notice the cutouts** - found in the Metal parts 1/3 package
- Rear profile (1x) **with two holes on the flat side** - found in the Metal parts 1/3 package
- Universal profile (2x) **no holes on the flat side** - found in the Metal parts 1/3 package
- Spacer pin (2x) found in the Electronics & Fasteners package
- Šroub M3x4rT (4x)

KROK 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.
 - ⚠ 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.
- 🟠 Join both parts together with the M3x4rT screw.

KROK 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.
- 🟠 Join both parts together with the M3x4rT screw.

KROK 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.

KROK 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.

KROK 15 Anti-vibration feet: parts preparation



● For the following steps, please prepare:

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

KROK 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.

⚠ Z každé antivibrační nožičky odstraňte opatrně **pouze ochrannou fólii**. Pokud se spolu s fólií začne odlepovat i lepicí vrstva, přestaňte a pokračujte v odstraňování z jiného rohu.

- Stick one anti-vibration foot in each corner of the frame. Align it with the outer edge of the flat side of the profile.

KROK 17 Installing the bottom frame



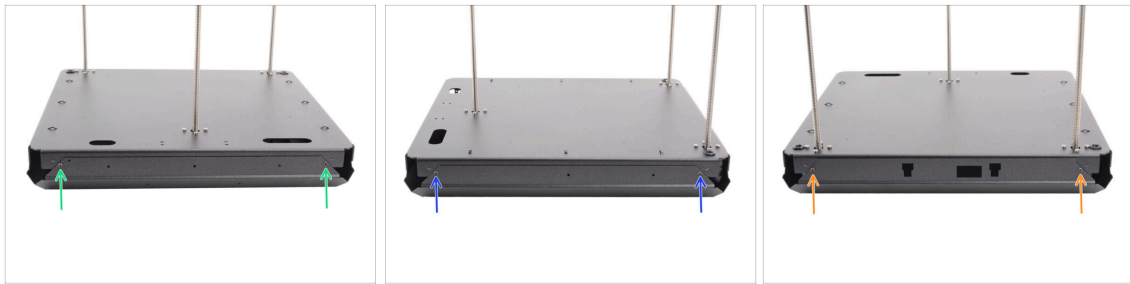
- 🔵 Turn the bottom frame upside down. **The front profile must be facing you.**
- 🟡 Attach the rear side of the bottom panel assembly to the rear side of the bottom frame.
- 🟠 Ensure that the front side of the bottom panel assembly (with two motors) aligns with the front profile of the bottom frame (with cutouts).
- 🟣 Place all the motor cables inside the center area of the bottom frame to prevent pinching.
- 🟢 Slowly and carefully lower the bottom panel assembly into the bottom profile.
 - ⬛ Ensure the assembly fits completely **inside the bottom profile.**
 - ⬛ Make sure no part of the bottom panel assembly extends outside the bottom frame
- ⚠️ **Double-check that no cables are pinched.**

KROK 18 Mounting the bottom frame: right side



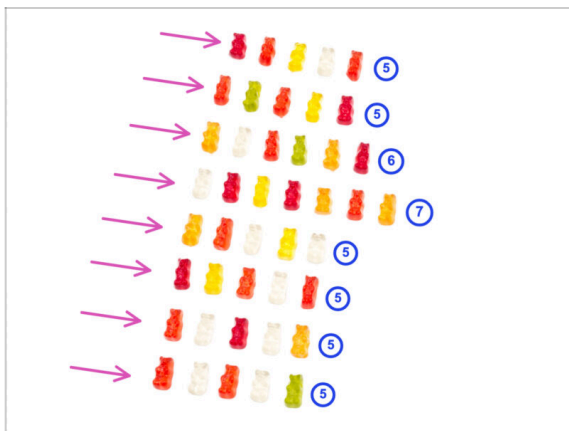
- ⬛ Focus on the front right corner and right side.
- 🟡 Slightly lift one of the corners of the bottom panel assembly.
- 🟢 Align the threaded hole in the bottom panel with the hole in the profile.
- 🟢 Join both parts together with the M3x4rT screw.
- ⬛ Move to the rear corner of the right side.
- 🟣 Align the holes in the base and the profile and secure it with the M3x4rT screw.

KROK 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.
- Turn the assembly with the front profile facing you (profile with cutouts).
- Align holes in the base assembly with the profile and secure them using two M3x4rT screws.

KROK 20 Je čas na 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.
- Eat the first row.

KROK 21 Hotovo



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

3. Kompletace zadního plátu tiskárny

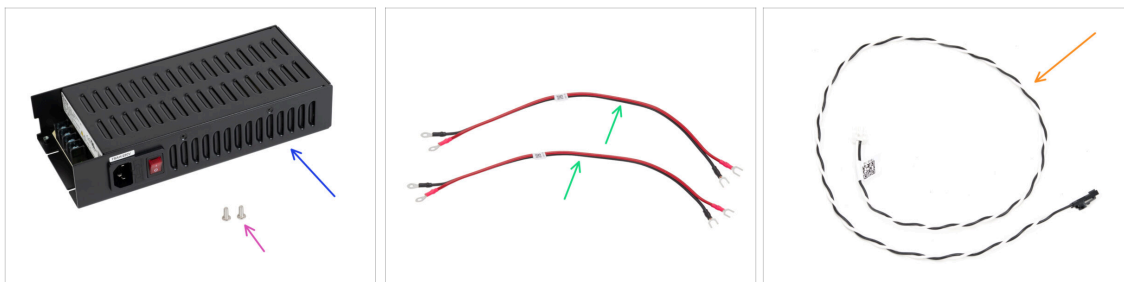


KROK 1 Tools necessary for this chapter



- **For this chapter, please prepare:**
- Křížový šroubovák PH2
- Čelistové kleště
- 2,5mm inbusový klíč
- T10 torx key / T10 torx screwdriver

KROK 2 PSU assembly: parts preparation



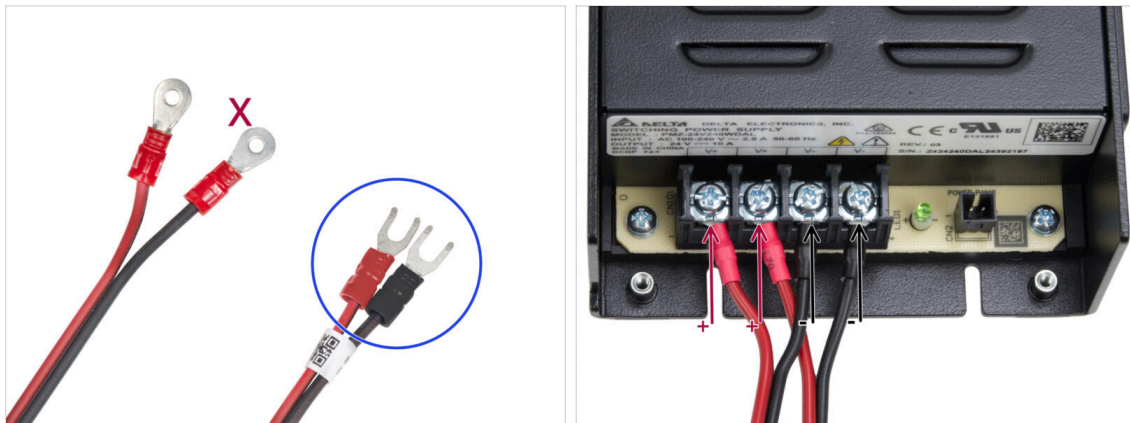
- **For the following steps, please prepare:**
- Delta PSU 240 W 24 V (1x) *power supply*
- M4x6r screw (2x) *from the Fasteners 3/3 package*
- xBuddy power cables (2x) *found in the Electronics package*
- Power panic cable (1x) *found in the Electronics package*

KROK 3 Příprava napájecího zdroje



- Insert two M4x6r screws into the left side of the PSU. **Do not tighten them completely.** Leave at least a 4 mm (0.16 in) gap between the screw head and the PSU.
- Slightly loosen all four power terminal screws on the PSU. **Do not remove them.** 3-4 turns are enough.

KROK 4 Informace o napájecích kabelech



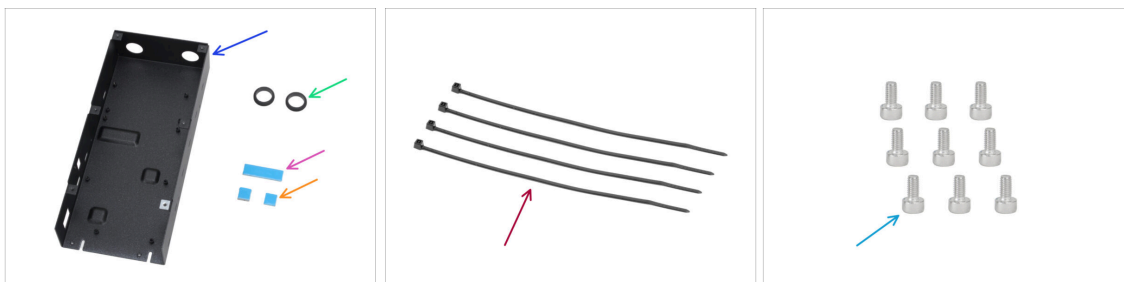
- ❗ In the following steps, we will be connecting the power cables one by one. The terminal screws are installed on the PSU already. Loosen them but **don't remove them completely** so they don't get mixed up with the other type of screws used on the xBuddy board side of the cable. Each of the two power cables has two leads. One has a prevailing **red color = positive / +**. One has a prevailing **black color = negative / -**.
- 🔵 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:**
- 🔴 Kladný (V+)
 - 🔴 Kladný (V+)
 - ⬛ Záporný (V-)
 - ⬛ Záporný (V-)
- ❗ 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.**

KROK 5 Připojení napájecího zdroje



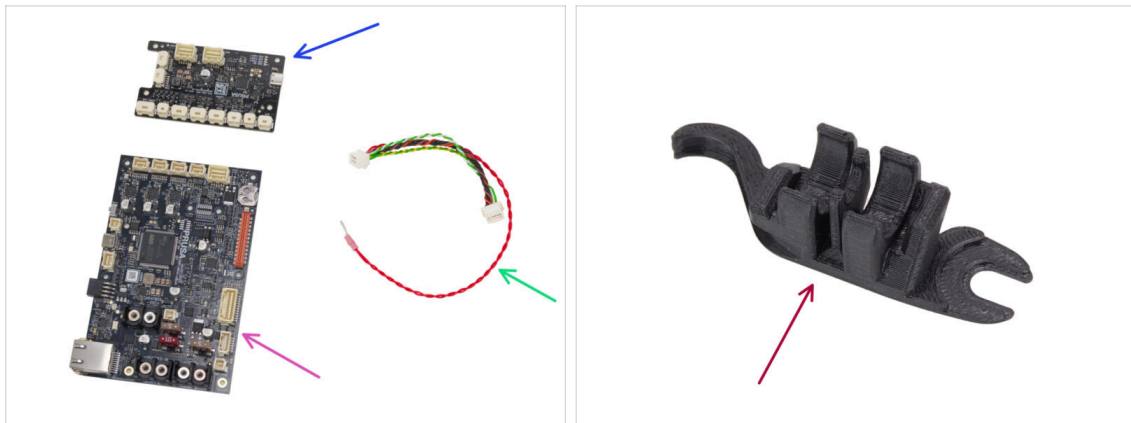
- Take the RED wire and slide the fork connector all the way into the first (positive) terminal from the left on the bottom of the PSU. Make sure the steel washer is above the "fork" connector.
- Tighten the terminal screw firmly.
- Use the same procedure to connect the second red wire to the second terminal slot from the left.
- Connect two black wires to the third and fourth terminal slots using the same procedure.
- Plug the power panic cable to the right most connector.
- Put the assembly aside for a while.

KROK 6 xBuddy: parts preparation I.



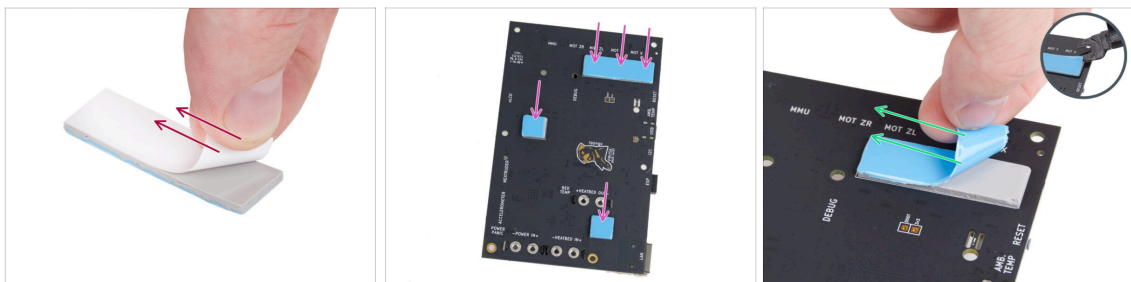
- **For the following steps, please prepare:**
- CORE One xBuddy box (1x) found in the Metal parts 3/3 package
- Grommet 19/16 mm (2x) found in the Electronics & Fasteners package
- Thermal pad 40x12x2.2 mm (1x) found in the Electronics & Fasteners package
- Thermal pad 12x12x2.2 mm (2x) found in the Electronics & Fasteners package
- Stahovací páska (4x)
- Šroub M3x6 (9x)
- **i** The list continues in the next step...

KROK 7 xBuddy: parts preparation II.



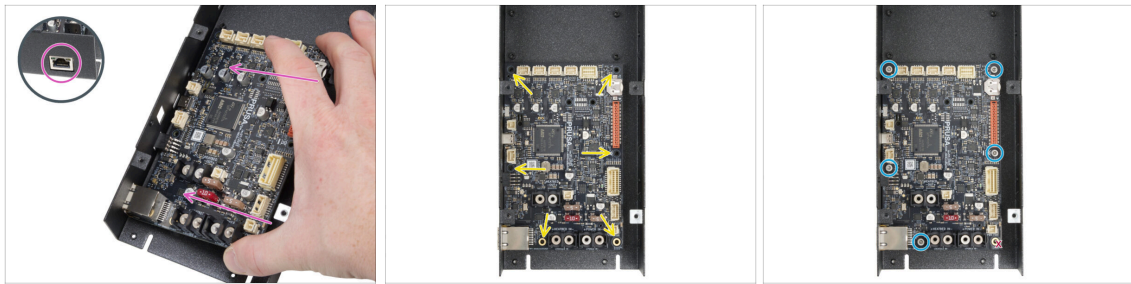
- xBuddy extension board (1x) found in the Electronics & chamber package
- xBuddy board (1x) found in the Electronics package
- xBuddy extension cable (1x) found in the Electronics & Fasteners package
- Assembly-multi-tool (1x) found in the Printed parts package

KROK 8 Applying the thermal pads



- Peel off the white protective layer from all thermal pads.
 - ⚠ **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.
 - ⓘ The surface to which the pads are stuck must be cleaned of grease. This will ensure better adhesion.
- ⚠ **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.
 - ⓘ 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.

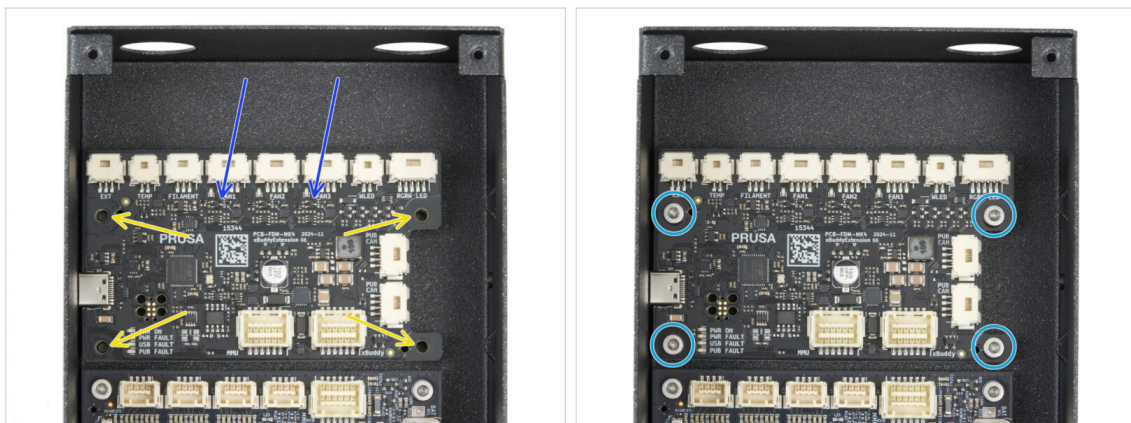
KROK 9 Instalace desky xBuddy



⚠ Always touch the sides of the electronics board while manipulating it. Avoid touching the chips, capacitors and other parts of the electronics.

- ✿ Insert the xBuddy board to the xBuddy box.
 - Make sure the Ethernet connector is properly inserted into the hole in the xBuddy box.
- ✿ **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 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.

KROK 10 Installing the xBuddy extension



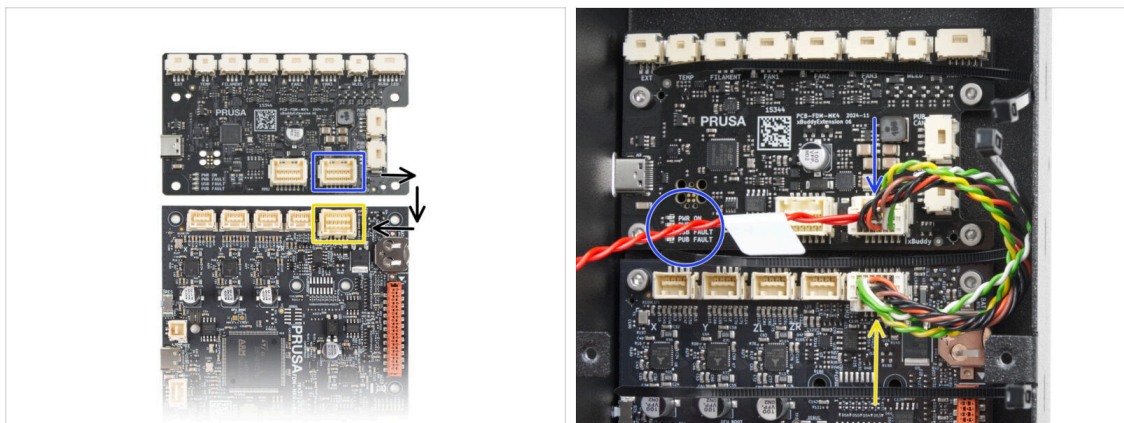
- ✿ Insert the xBuddy extension board to the xBuddy box above the xBuddy board. Notice the part orientation.
- ✿ Before fully attaching it completely, center the holes in the board with the holes (columns) in the xBuddy box.
- ✿ Fix the position of the xBuddy extension board by inserting four M3x6 screws. Tighten them completely.

KROK 11 Montáž stahovacích pásek



- Take a closer look at the xBuddy box. There are six perforations on the metal case.
- ⚠ 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.
- Push the zip tie through the perforation and into the Assembly-multi-tool. It will guide the zip tie into the electronics box.
- ⚠ 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.

KROK 12 Connecting the xBuddy extension board



- Plug the xBuddy extension connector with the free red cable to the xBuddy extension board.
- ⬛ Leave the red cable free for now.
- Plug the other end of the xBuddy extension cable to the xBuddy board.

KROK 13 Inserting grommets: xBuddy box



- Insert both grommets into both circle holes in the xBuddy box.
- Gently compress the grommet and fit it into the metal sheet, ensuring the groove locks into place

KROK 14 Wi-Fi: příprava dílů



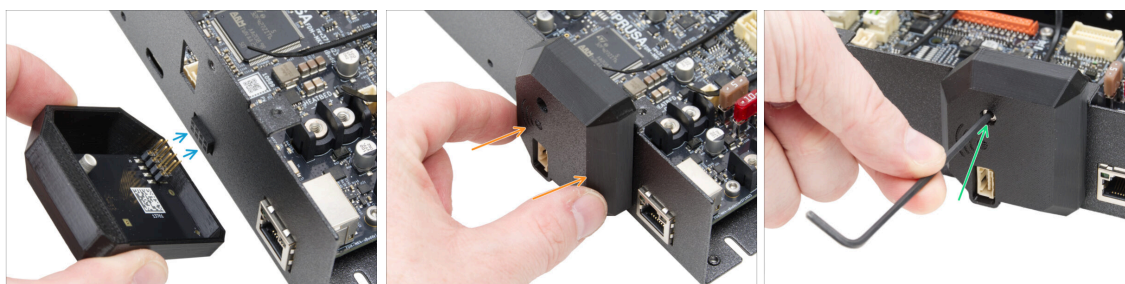
- For the following steps, please prepare:
- ESP-WiFi (1x) found in the Electronics package
- CORE-One-Wifi-cover (1x) found in the Printed parts package
- Šroub M3x12 (1x)
- Šroub M3x6 (2x)

KROK 15 Příprava sestavy s Wi-Fi



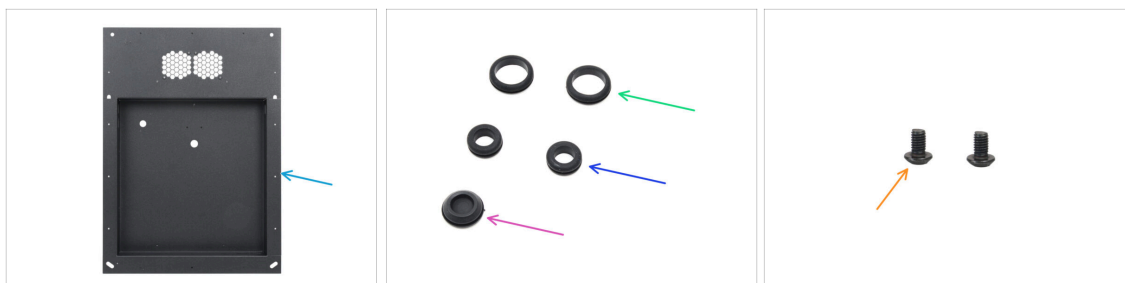
- ✚ Insert two M3x6 screw to the xBuddy box assembly from the right side. **Do not tighten them completely.** Leave at least a 4 mm (0.16 in) gap.
- ✚ Insert the ESP-WiFi module into the WiFi-cover, positioning it just below the bridge on the left side.
- ✚ On the other side, ensure the connector fits correctly into the hole in the cover.

KROK 16 Installing the Wi-Fi assembly



- ⚠ **Be very careful when handling and connecting the ESP module to avoid bending and damaging the pins.**
- ✚ 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.

KROK 17 Back panel: parts preparation



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

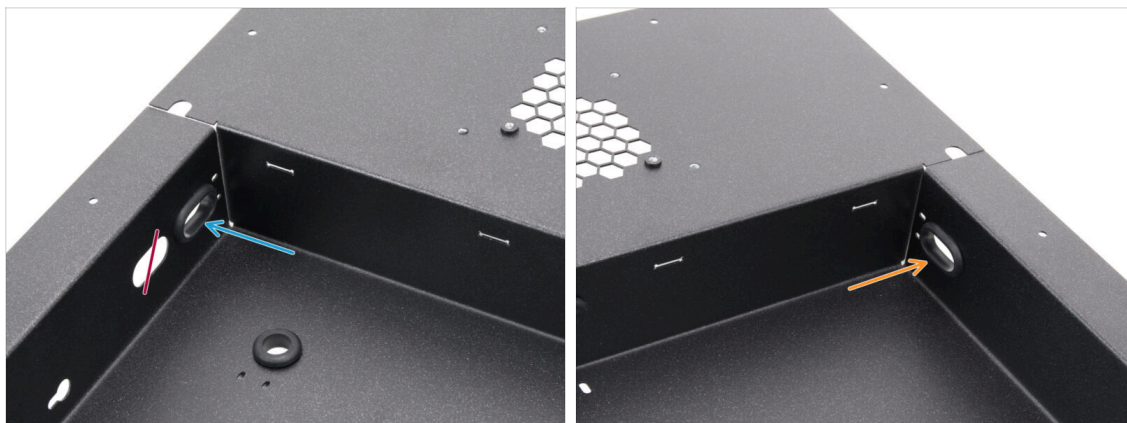
- Back panel (1x) *found in the Metal parts 1/3 package*
- Grommet 19/16 mm (2x) *large one - found in the Electronics & Fasteners package*
- Grommet 13.5/10 mm (2x) *small one - found in the Electronics & Fasteners package*
- Sealing plug 15.5 mm (1x) *found in the Electronics & Fasteners package*
- Šroub M3x4rT (2x)

KROK 18 Installing grommets: back panel top



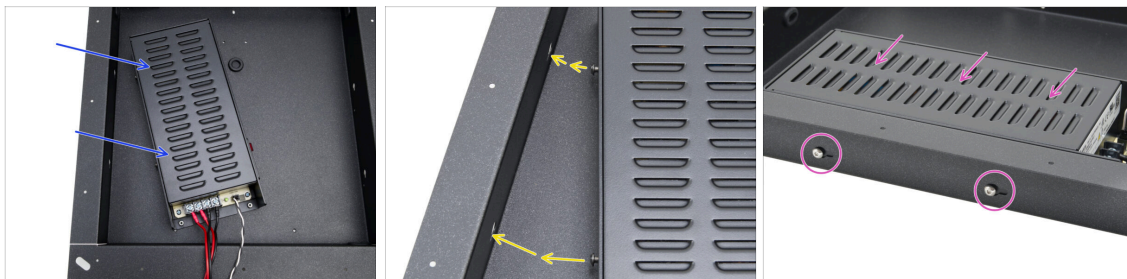
- Position the back panel as shown in the first image. Use the two oval holes as a reference.
- Insert the sealing plug into the center hole.
 - **The sealing plug is not symmetrical.** Insert the side with the smaller diameter facing downward.
- Insert one small grommet to the left circle hole.
- Insert one small grommet into the oval hole.

KROK 19 Installing grommets: sides + bottom



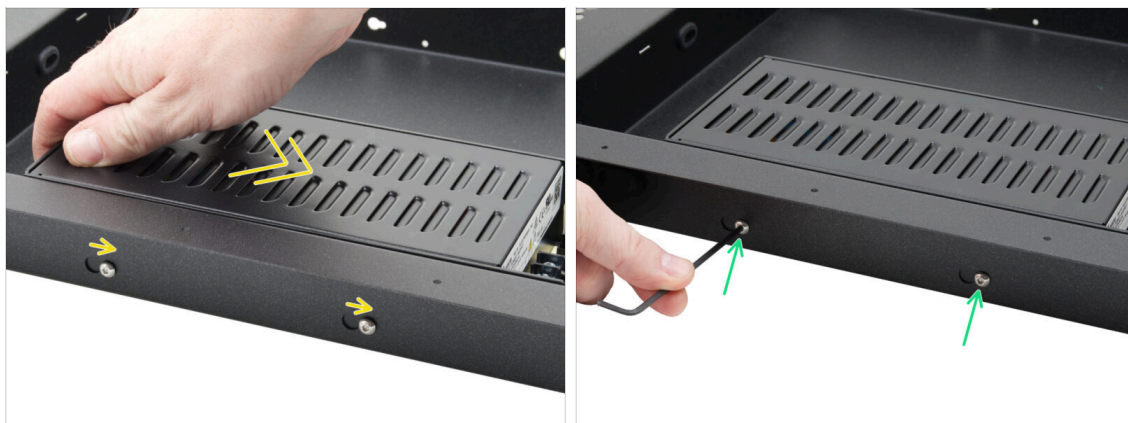
- Focus on the left top side of the back panel and locate two oval holes.
- Insert one large grommet into the oval hole closest to the corner.
- Move to the right top side of the back panel and insert one large grommet to the oval hole.

KROK 20 Zarovnání zdroje napájení



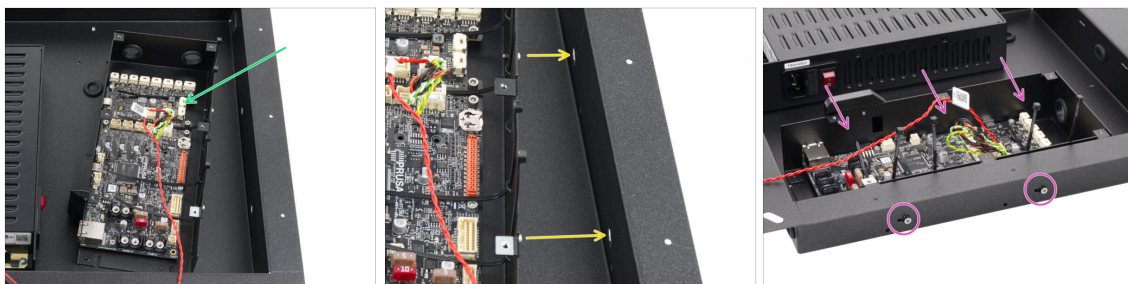
- Carefully insert the PSU into the rear panel pocket.
- Align the screws on the PSU to the holes on the left side of the back panel.
- Slide the PSU so that the screws go through the holes.

KROK 21 Montáž zdroje napájení



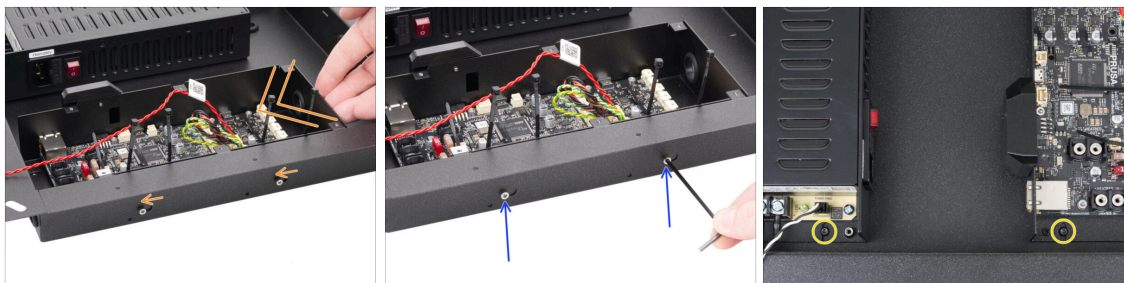
- Gently slide the PSU so that the position of the screws moves to the end position of the keyhole-shaped holes.
- Maintain the PSU position and fully tighten both screws.

KROK 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.

KROK 23 Mounting the xBuddy box



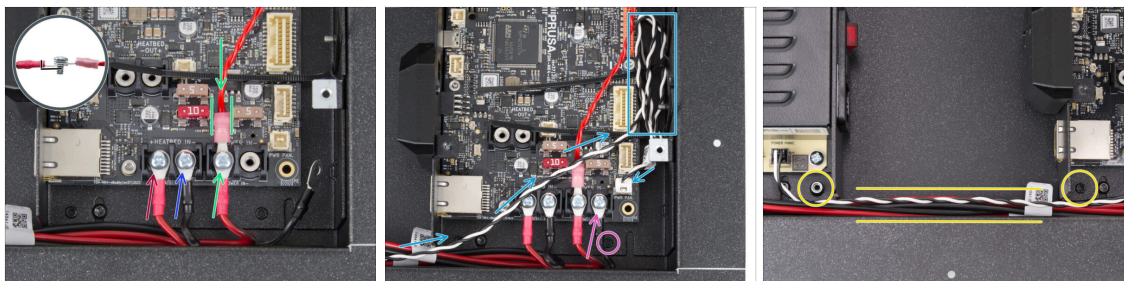
- Gently slide the xBuddy box assembly so that the position of the screws moves to the end position of the keyhole-shaped holes.
- Maintain the xBuddy box position and fully tighten both screws.
- Fix the PSU and xBuddy box assembly to the back panel by tightening two M3x4rT screws.

KROK 24 Power cables cover: parts preparation



- ⬛ **For the following steps, please prepare:**
- PSU-cable-cover (1x) *found in the Printed parts package*
- Matka M3nS (2x)
- Šroub M3x10rT (2x)
- 6-32 Power Terminal Screw (4x)

KROK 25 Connecting the power cables



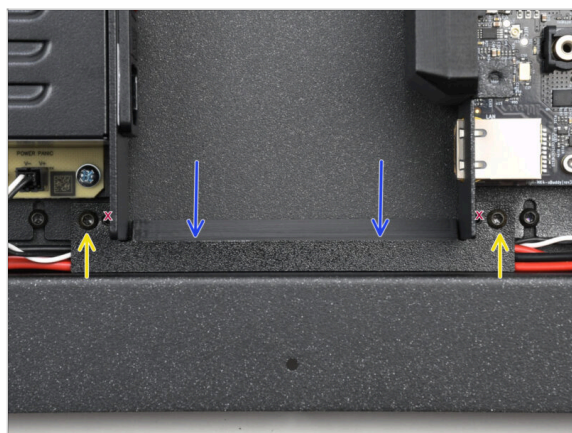
- ◆ Take one red cable leading from the PSU and connect it to the first left terminal slot on the xBuddy board using the 6/32" terminal screw. Tighten it firmly but gently.
 - ⚠ Note that the "L" shape of the cable connector must always "undercut" the head of the terminal screw.
- ◆ Connect the black PSU cable from the same pair as the red one to the second terminal using the 6/32" terminal screw. Tighten the screws firmly.
- ◆ Take the second red cable from the PSU and attach it to the red cable leading from the extension board. **Note the detail.** Secure these two cables with the terminal screw in the third terminal slot.
- ◆ Guide the xBuddy extension cable carefully between the fuses, ensuring it is positioned securely without pressing against them.
- ⓘ **Note that from early 2025, the fuses are different.** Significantly smaller, white, and embedded in the fuse slot in the xBuddy board, so as not to obstruct the cables.
- ◆ Connect the second black PSU cable to the xBuddy, **ensuring it does not obstruct the threaded hole.**
- ◆ Route the power panic cable to the xBuddy box and connect it to the bottom right slot on the xBuddy board. Make several loops from the excess cable above the slot.
- ◆ Arrange the PSU cables as shown, ensuring that no obstructions are around the threaded holes in the PSU and xBuddy box.

KROK 26 Příprava dílu PSU-cable-cover



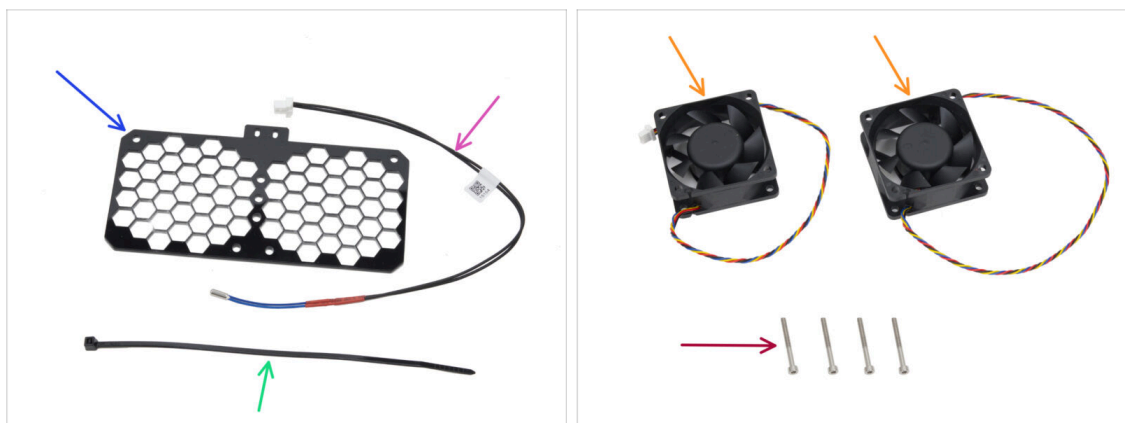
- Insert one M3nS nut into the hole on each end of the PSU-cable-cover.
- Ensure the holes are aligned.

KROK 27 Covering the PSU cables



- Attach the PSU-cable-cover on the PSU cables.
- Secure the cover with two M3x10rT screws in the outermost holes of the part.

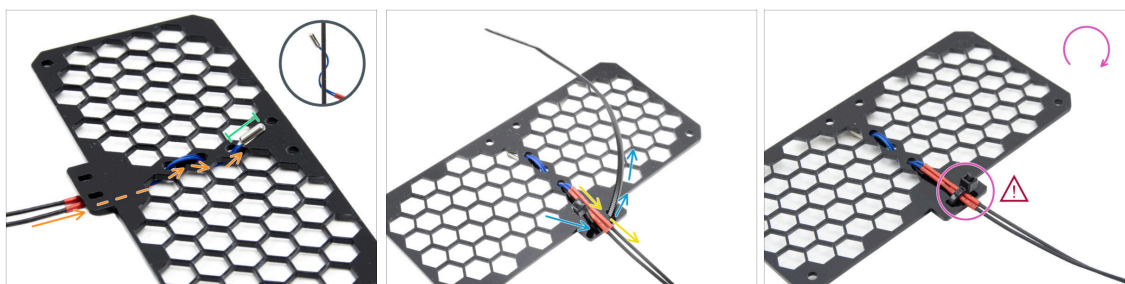
KROK 28 Chamber fans: parts preparation



● 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
- Stahovací páska (1x)
- Cooling fan (2x) found in the Electronics & Chamber parts package
- Šroub M3x30 (4x)

KROK 29 Assembling the fan grid



- Guide the thermistor cable under the grid. Thread it in the direction shown in the picture.

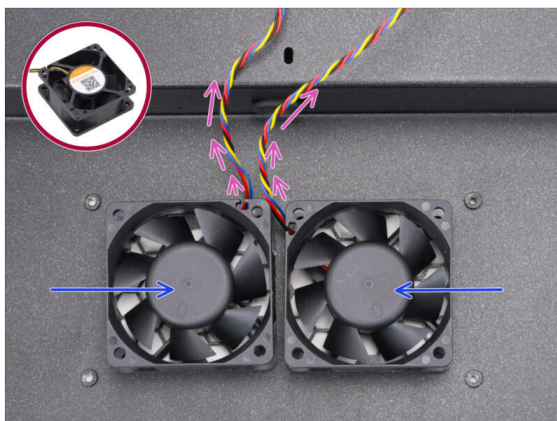
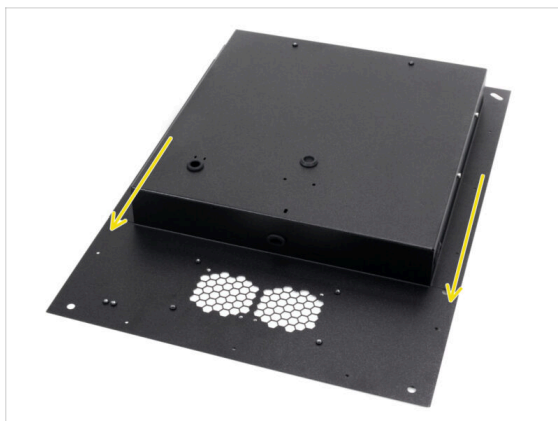
❗ The grid has both sides the same.

- 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.**

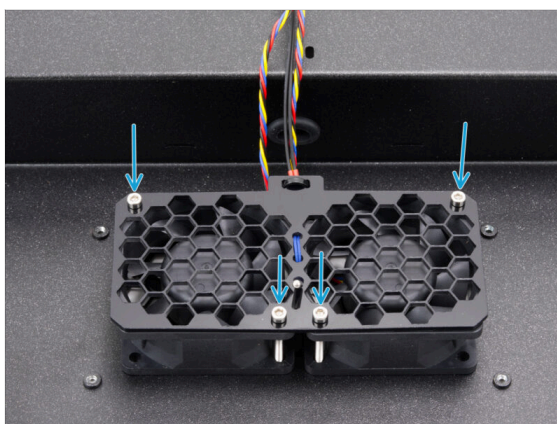
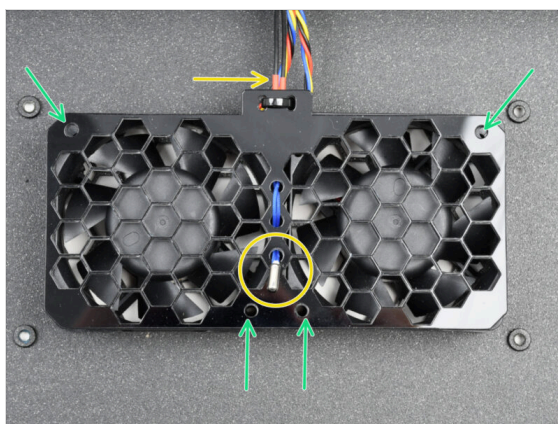
- Put the assembly aside for a while.

KROK 30 Osazení ventilátorů



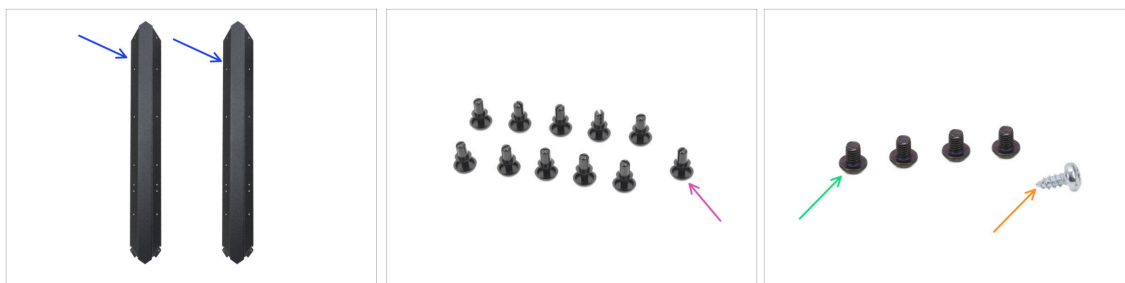
- ✦ Place and orient the back panel according to the picture. The grid cutouts must be facing you.
- ✦ Place both fans to the grid in the back panel.
 - ⚠ **The side of the fan without the sticker must be facing up.**
 - ✦ Orient the fans so that the cables run from the corners in the centre.
 - Let the cables hang freely for now, ensuring they are not pinched during handling.

KROK 31 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.**
- ✦ Align holes in the fans, fan grid and the back panel.
- ✦ Secure the fan assembly to the back panel with four M3x30 screws.
 - ⚠ **Do not overtighten the screws to avoid damaging the grid.**

KROK 32 Rear profiles: parts preparation



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

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

① Take two of the longer ones.

Note that the other two longer ones differ by having cutouts.

- Nylonový nýt (11x)
- Šroub M3x4rT (4x)
- 2.9x6.5sT self-tapping screw (1x) from the Electronics and Fasteners Package

KROK 33 Installing the rear profiles



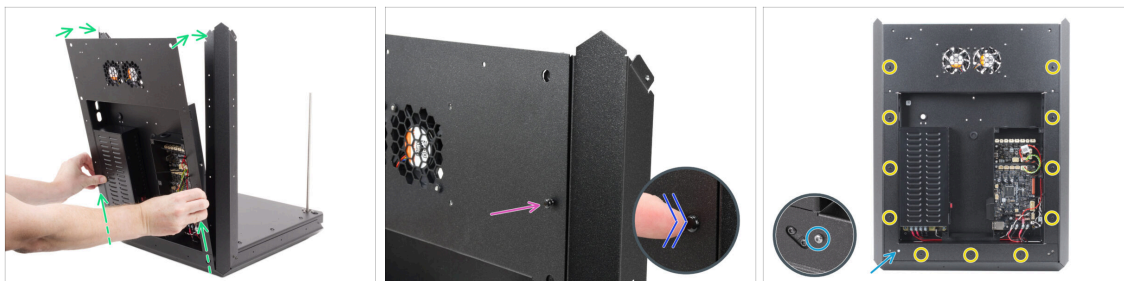
- Take the bottom assembly and turn it so the rear side (with one motor in the center) faces you.



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

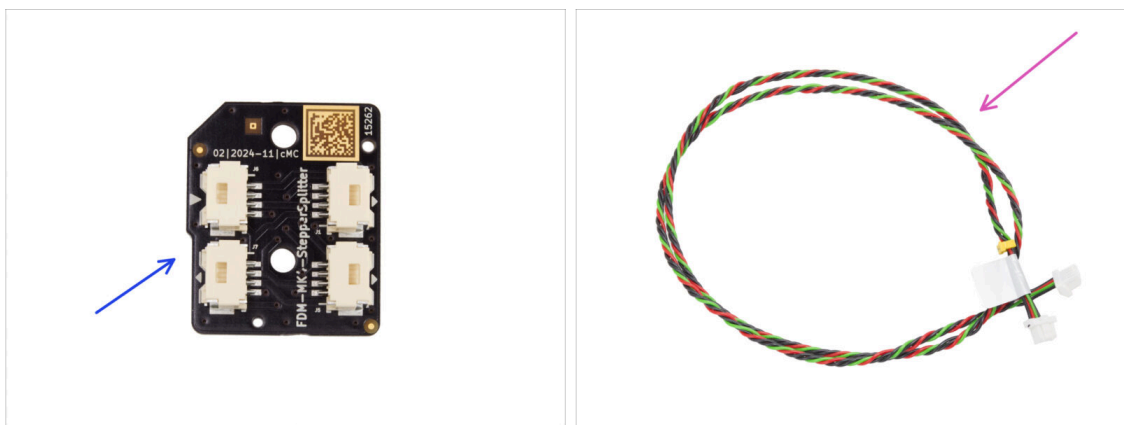
- Attach the rear profile to the right corner, using the **end without flanges**.
- Align the hole on the rear side and secure it with the M3x4rT screw.
- Secure the corner on the other side with a second M3x4rT screw - each corner will be secured with two M3x4rT screws.
- Proceed the same with the second rear profile on the rear left corner.

KROK 34 Mounting the back panel



- ◆ Slightly lift the back assembly and gently place it on the base assembly and rear profiles.
- ◆ Insert one nylon rivet through the rear panel and rear profile on the top right side.
- ◆ Push the rivet head with your finger until it is fully seated.
- ◆ Use this procedure for all eleven nylon rivets around the back panel assembly to secure it in place.
- ◆ Insert and tighten the 2.9x6.5 self-tapping screw into the back panel. **Avoid overtightening** to prevent stripping the self-tapped thread.

KROK 35 Stepper splitter: parts preparation



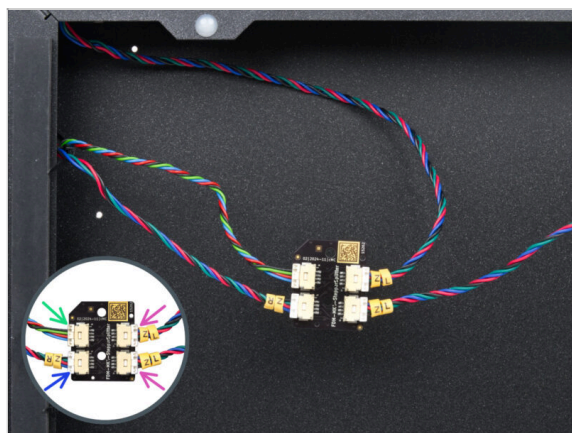
- ◆ **For the following steps, please prepare:**
- ◆ Stepper splitter (1x) *found in the Electronics & Chamber parts package*
- ◆ Stepper splitter cable (1x) *found in the Electronics & Fasteners package*

KROK 36 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.
- ⓘ Tip: Use the foam padding from the sheet metal parts package or an empty cardboard box.
- ✿ 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.**

KROK 37 Connecting the Stepper splitter



- ⬢ **Connect the Z motor cables to the stepper splitter:**

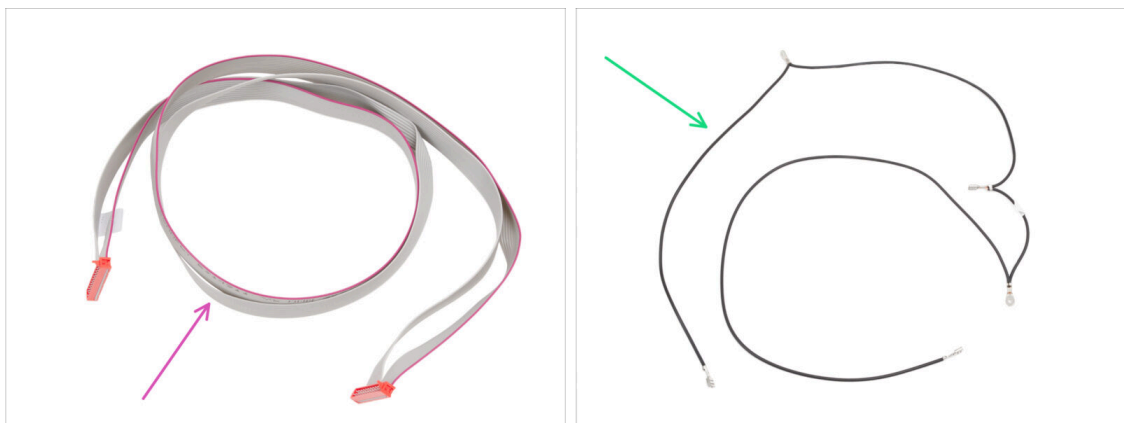
- ✿ kabel Stepper Splitteru
- ✿ Pravý Motor osy Z
- ✿ Levý Motor osy Z
- ✿ Levý Motor osy Z

KROK 38 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.
 - Check the correct orientation of the part by the logo on the board. **The logo is upside down.**
- 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.

KROK 39 LCD cable: parts preparation



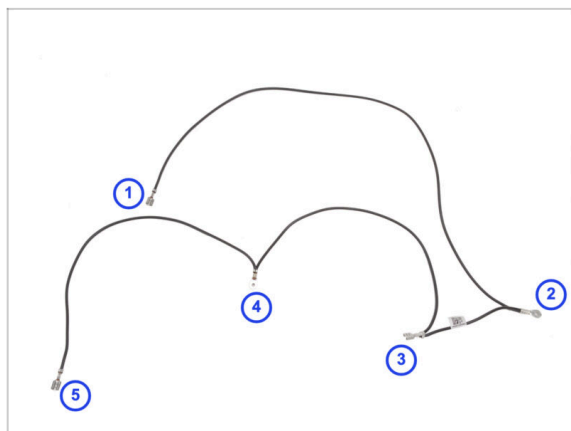
- **For the following steps, please prepare:**
 - xLCD cable (1x) *found in the Electronics & Fasteners package*
 - Main FE cable (1x) *found in the Electronics & Fasteners package*

KROK 40 Guiding the LCD cable



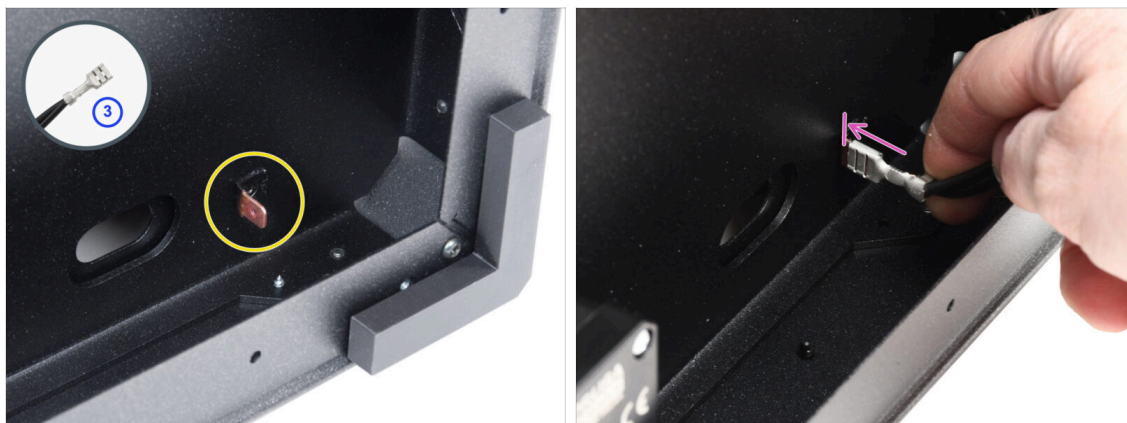
- Guide the Stepper splitter cable through the oval hole to the electronics.
- Take the end of the xLCD cable with the QR code label.
- Push a few centimeters of the xLCD cable (the end with the QR code label) through the oval hole in the bottom panel.
- ❗ The cable must be slightly folded to pass through 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.

KROK 41 Main FE cable INFO



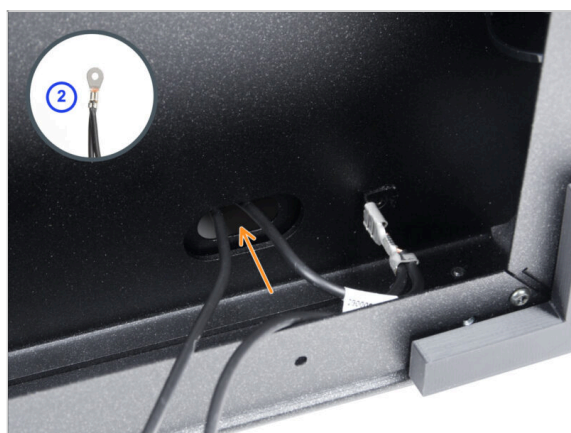
- Lay out the Main FE cable as shown in the picture, ensuring each connector is positioned accordingly.
- The connectors are numbered in the picture for reference only. This numbering will be used in the following steps to help with proper connections.
- ❗ Note: We will always indicate which connector to use in the following steps. However, it's a good idea to remember this overview for easier assembly.

KROK 42 Connecting the FE cable (no 3.)



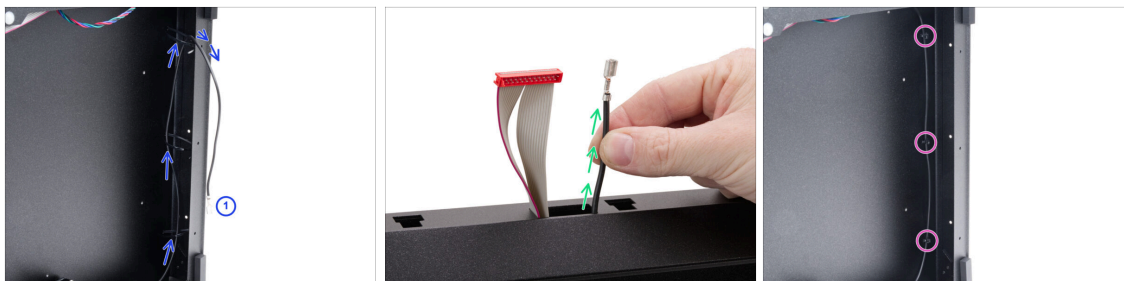
- Prepare the connector number 3.
 - ⓘ That's the female faston connector in the middle of the cable.
- Locate the male Faston connector in the bottom right corner.
- Slide the FE cable connector completely onto the Faston connector.

KROK 43 Guiding the FE cable (no. 2)



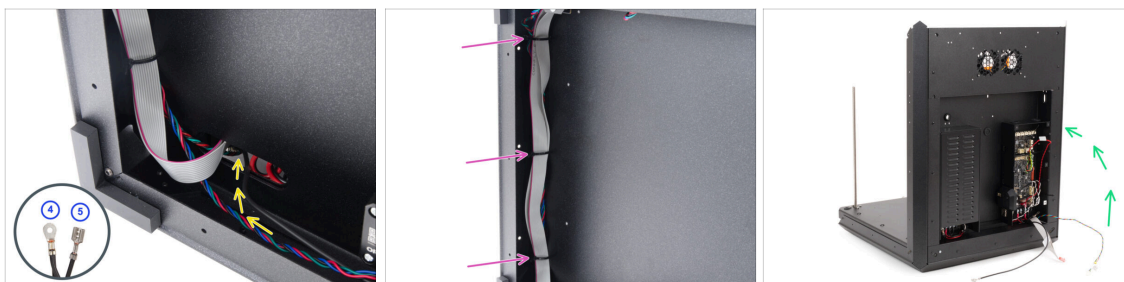
- Take the FE cable connector number 2.
 - ⓘ The round connector nearby.
- Insert the connector loosely into the hole in the bottom panel.

KROK 44 Guiding the FE cable (no. 1)



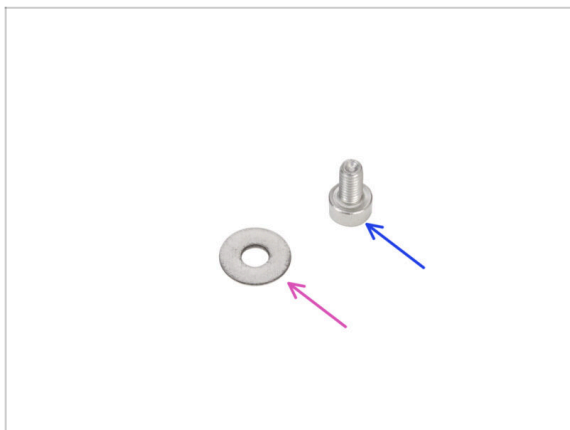
- Take the connector number 1 and guide it through the zip ties on the right side of the frame.
- ❗ That is the long part with just one faston connector at the end.
- Push the connector through the rectangular opening in the front profile. Keep protruding approximately 6 cm (2.36 in).
- Leave the cable hang freely for now.
- Tighten all three zip ties. Cut off the excess.

KROK 45 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.
- Tighten all three zip ties on the left side of the frame. Cut off the excess.
- 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.
- Carefully turn the printer back on its feet. Focus on the back side.

KROK 46 FE cable - xBuddy: parts preparation



● For the following steps, please prepare:

● Podložka M3w (1x)

● Šroub M3x6 (1x)

KROK 47 Connecting the FE cable: xBuddy

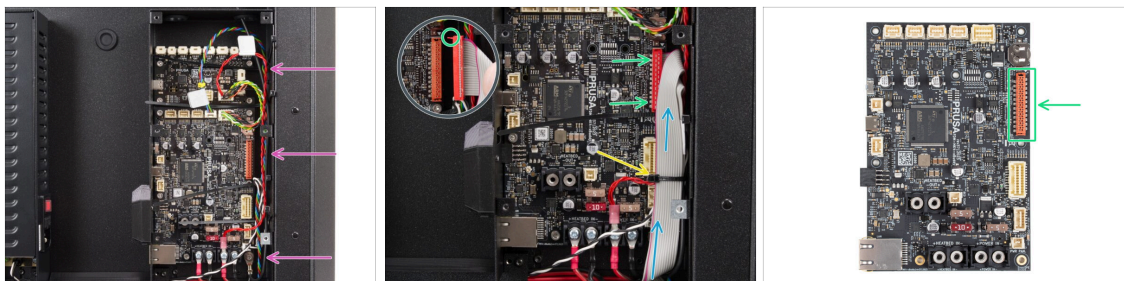


- Take the connector number 4 and connect it to the xBuddy using the M3x6 screw and M3w washer.

⚠ The M3 washer must be between the screw head and the connector.

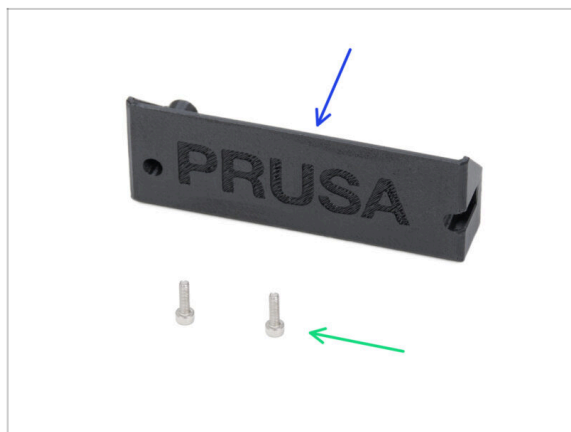
- Guide the FE cable (number 5) alongside the xBuddy box and pass it through the right-side holes out of the box.
- Guide the Stepper splitter cable alongside the xBuddy box and connect it to the second slot from the right in the top row on the xBuddy board (labeled ZR).

KROK 48 Plugging the xLCD cable



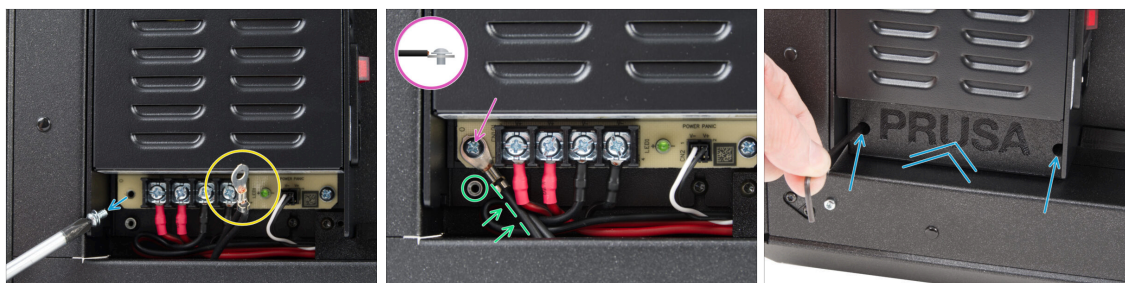
- ◆ Arrange the cables as shown - route all cables along the right side of the xBuddy box.
- ⚠ Make sure all the cables guide through the zip ties in the xBuddy box, not under them.
- ◆ Place the xLCD cable over the other cables and route it upwards.
- ◆ Connect the xLCD to the slot on the right side 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!**

KROK 49 Kryt zdroje napájení (PSU-cover): příprava dílů



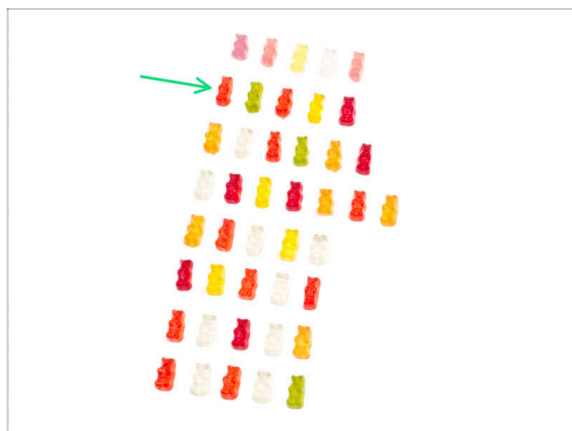
- ◆ For the following steps, please prepare:
- ◆ CORE-One-PSU-cover (1x) found in the Printed parts package
- ◆ Šroub M3x10 (2x)

KROK 50 Connecting the FE cable: PSU



- Remove the screw from the PSU board. **Do not discard it!**
- Ensure the FE connector (number 2) is routed into the PSU compartment.
- Insert the removed screw through the FE cable connector and screw it back to the PSU board.
- Note the correct orientation of the connector.
- Rotate the connector counter-clockwise, positioning it so it doesn't block the threaded hole underneath.
- Attach the PSU-cover over the PSU connectors and secure with two M3x10 screws.

KROK 51 Je čas na Haribo!



- Time to recharge for the next chapter!
- Eat the second row.
- No cheating**—eat only the number shown!

KROK 52 Hotovo



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

4. Sestavení vyhřívané podložky



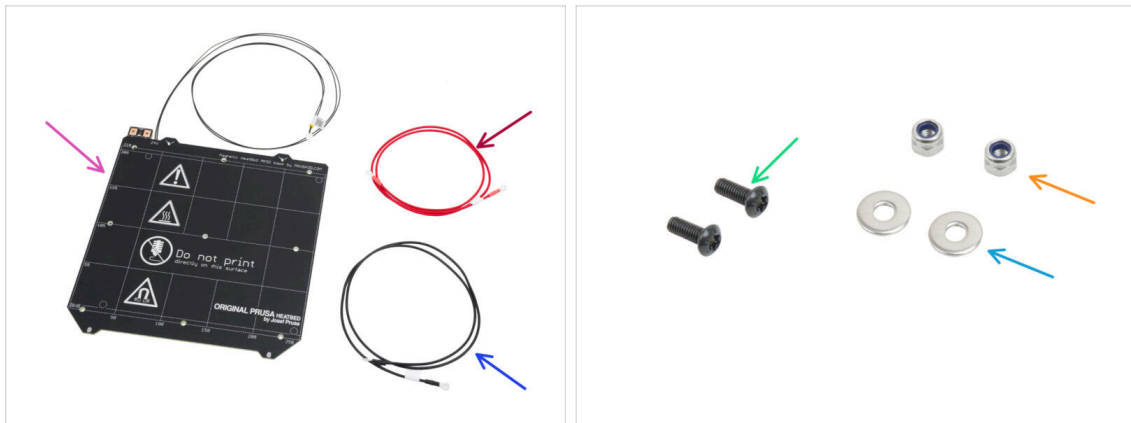
KROK 1 Náradí potřebné k této kapitole



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

- Čelistové kleště
- Univerzální klíč
- Klíč 13-16
- Křížový šroubovák PH2
- 2,5mm inbusový klíč
- 2,0mm inbusový klíč
- Klíč T10 torx / Šroubovák T10 torx

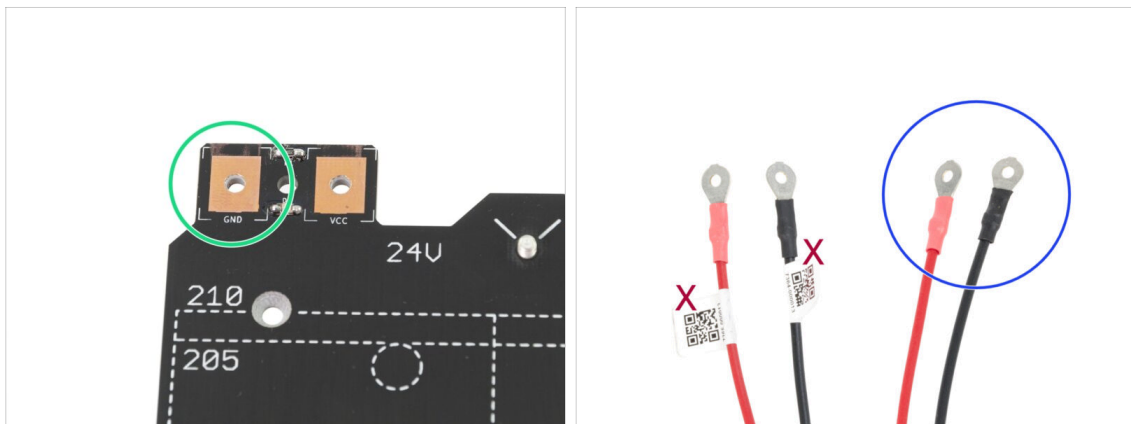
KROK 2 Vyhřívaná podložka: příprava dílů



For the following step please prepare:

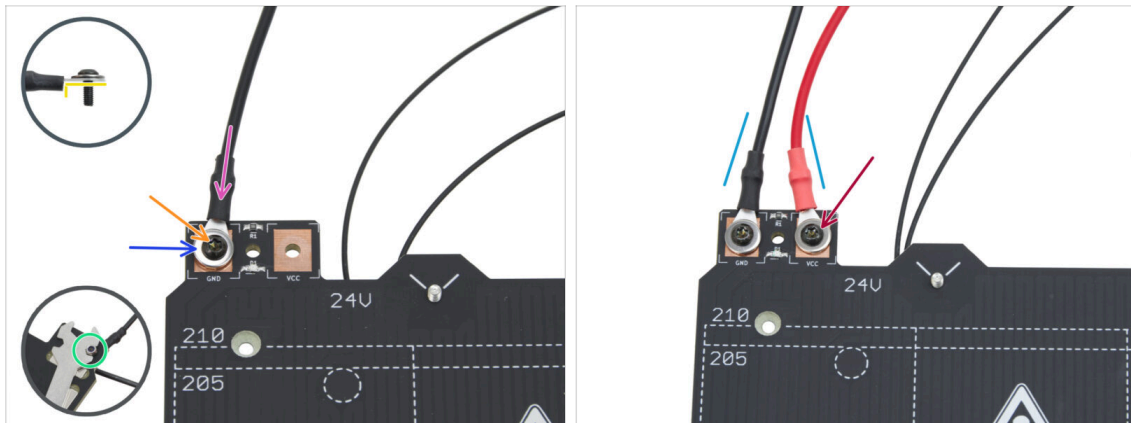
- Heatbed MK52 24V (1x) found in the CoreXY parts + Hinges set package
- Heatbed cable red (1x) found in the Electronics & Fasteners package
- Heatbed cable black (1x) found in the Electronics & Fasteners package
- Šroub M3x10rT (2x)
- Matka M3nN (2x)
- Podložka M3w (2x)

KROK 3 Napojení kabelu heatbedu (1. část)



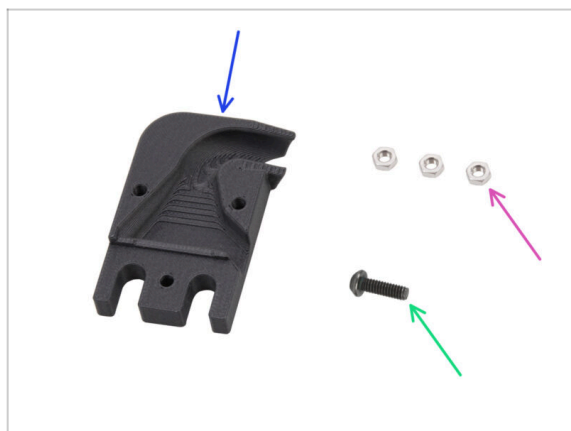
- IT IS IMPORTANT** to connect the power cable correctly. Before you start the assembly have a look at the pins. The one on the left with "GND" sign must be connected to the **BLACK WIRE**.
- Take both Heatbed cables. Note the label on each cable. For the following steps, prepare the ends of the cables **without the label**.

KROK 4 Napojení kabelu heatbedu (2. část)



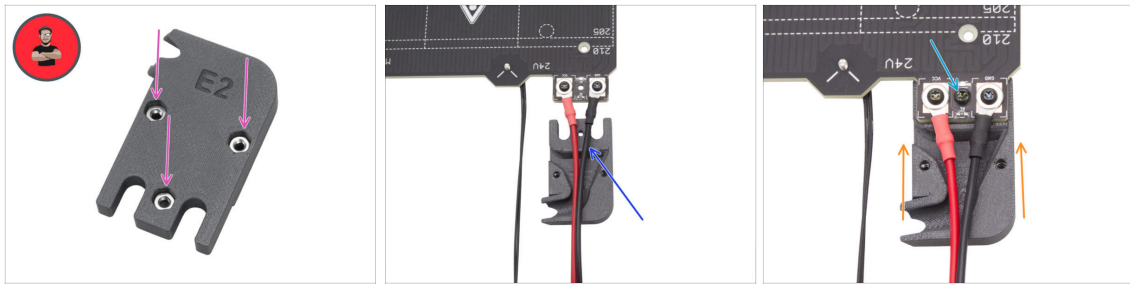
- ✿ Place the black wire above the pin with "GND" sign. **Use the end of the cable that is not labeled with QR code.** The QR code must be at the other end.
- ✿ Note the correct position of the cable terminal lug on the detail.
- ✿ Place the M3w washer above the round cable connector.
- ✿ Push the M3x10rT screw through all parts.
- ✿ Podržte šroub a opatrně otočte vyhřívanou podložku vzhůru nohama.
- ✿ Na šroub M3x10rT nasadte matku M3nN a částečně ji utáhněte.
- ✿ Stejným postupem připojte červený kabel k pinu označenému „VCC“ na vyhřívané podložce.
- ✿ Kabely od vyhřívané podložky vedte mírně k sobě (do tvaru písmene „V“). **Poté zesponu pevně utáhněte matice.**

KROK 5 Bed-cable-cover-bottom: příprava dílů



- ✿ **For the following steps, please prepare:**
- ✿ Bed-cable-cover-bottom (1x)
- ✿ Matka M3n (3x)
- ✿ Šroub M3x10rT (1x)

KROK 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.
- ✦ Zasuňte kryt Bed-cable-cover-bottom pod kabelový spoj vyhřívané podložky.
- ✦ Zarovnejte otvor ve vyhřívané podložce s krytem kabelu a zajistěte jej šroubem M3x10rT.

KROK 7 Heatbed carriage: parts preparation



- ⬛ **For the following steps, please prepare:**
- ✦ Heatbed carriage (1x) *found in the Metal parts 1/3 package*
- ✦ Expansion joint (8x) *found in the Electronics package*
- ✦ Šroub M3x4r (8x)
- 🔩 Balení fasteners obsahuje šrouby M3x4r i M3x4rT. Ujistěte se, že máte připraven správný typ.

KROK 8 Preparing the heatbed carriage



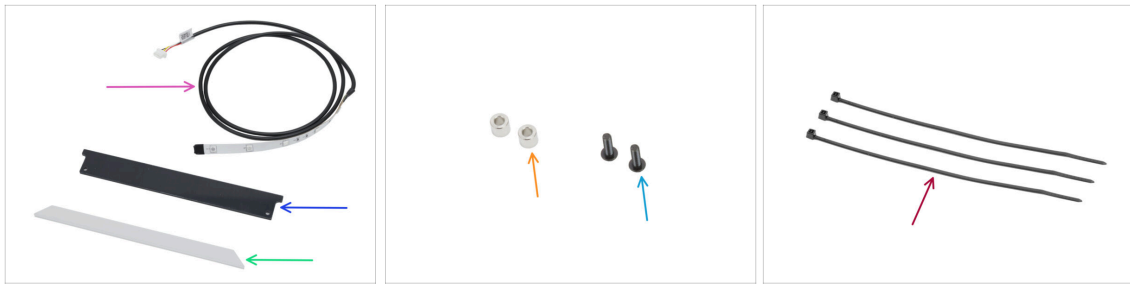
- Place the heatbed carriage in front of you in the same orientation as in the picture.
- Make sure the **rectangular cutout is facing you on the right side**.
- Insert eight M3x4r screws around the heatbed carriage.
- ⚠ **Do not tighten completely, leave a gap of approximately 3 mm (0.12 in).**

KROK 9 Installing the expansion joints



- Attach one expansion joint to any M3x4r 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.
- Umístěte klíč na dilatační podložku ve správné orientaci, jak je znázorněno na obrázku.
- **Udržujte dilatační podložku ve správné poloze** a pevně utáhněte šroub M3x4r přes dilatační podložku 2,0mm inbusovým klíčem.
- ⚠ **Tento postup opakujte u všech ostatních dilatačních podložek. Dodržujte správnou pozici!**

KROK 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

Difuzér LED pásku (1x) naleznete v balíčku *CoreXY + Hinges* set

Podložka 3,2/6x5 mm (2x) naleznete v balíčku *Electronics & Fasteners*

Šroub M3x10rT (2x)

Stahovací páska (3x)

KROK 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.

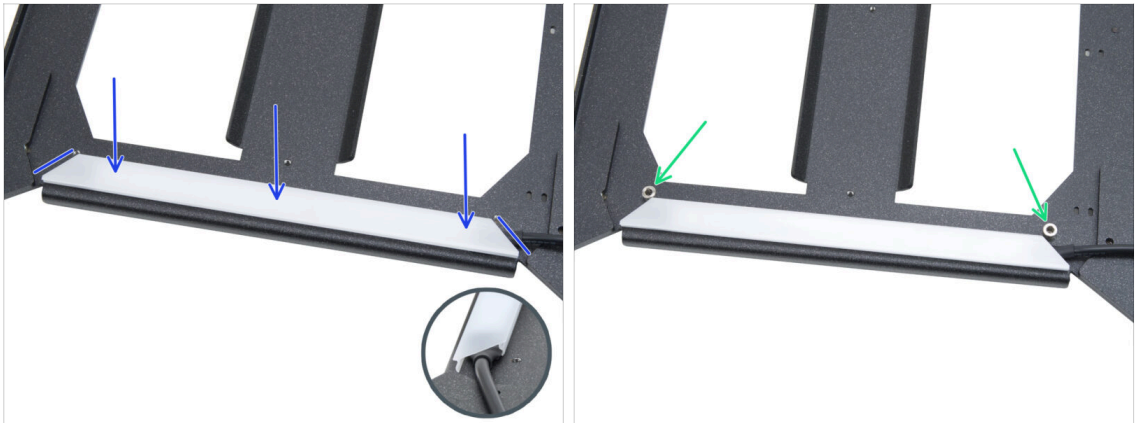
⚠️ After removing the protective layer, the RGB LED strip is adhesive.

RGB LED pásek rovnoměrně přilepte na přední stranu heatbed carriage, přibližně 3 mm od ohnutého okraje.
Zarovnejte prostřední LED diodu se šroubem na carriage.

Kabel RGB LED pásku **musí směřovat doprava**.

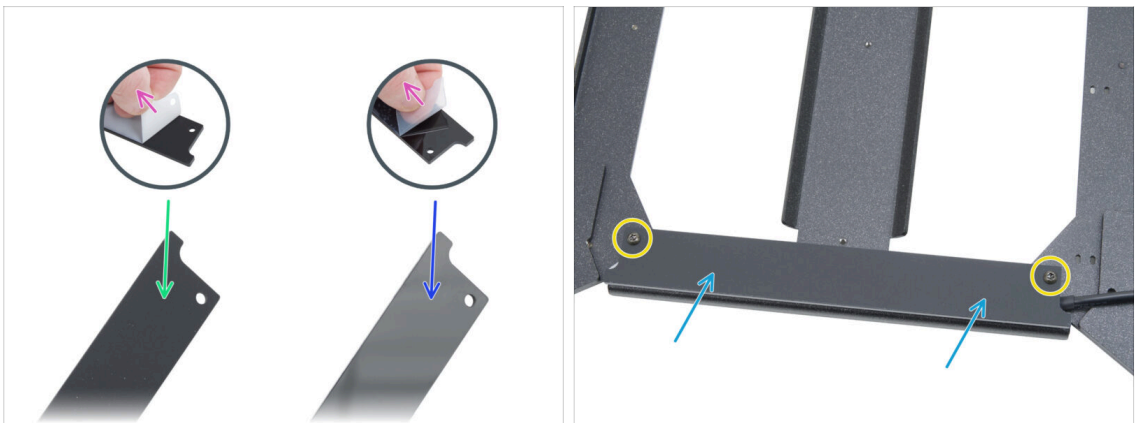
Po nalepení lehce zatlačte na prázdná místa pásku, abyste zajistili přilnavost.
Nedotýkejte se LED diod a rezistorů!

KROK 12 Attaching the LED strip diffuser



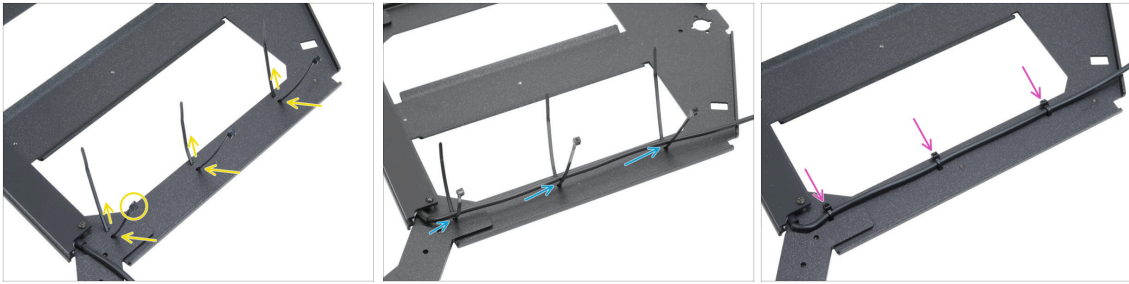
- Place the LED strip diffuser over the RGB LED strip. Note the orientation of the part - according to the beveled edges.
- Place two spacers 3.2/6x5 mm on the holes in the edges of the LED assembly.

KROK 13 Covering the RGB LED strip



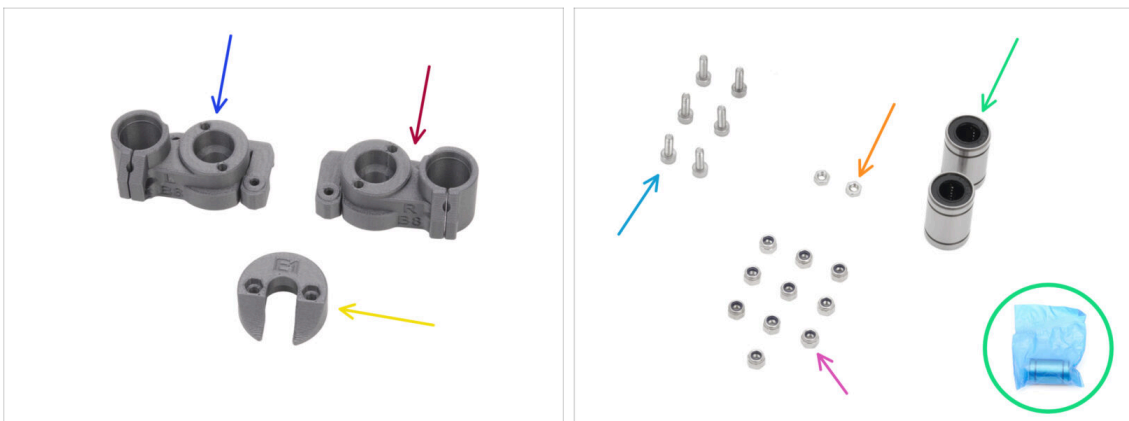
- From both sides of the LED status cover, peel off the protective layers.
- Note that one side of the cover is matte.
- The other side of the cover is glossy.
- Attach the LED strip cover to the assembly, **matte side up**.
- Zajistěte všechny díly dohromady vložení a utažením dvou šroubů M3x10rT. **Šrouby příliš neutahujte**, mohlo by dojít k prasknutí krytu.

KROK 14 Guiding the RGB LED strip cable



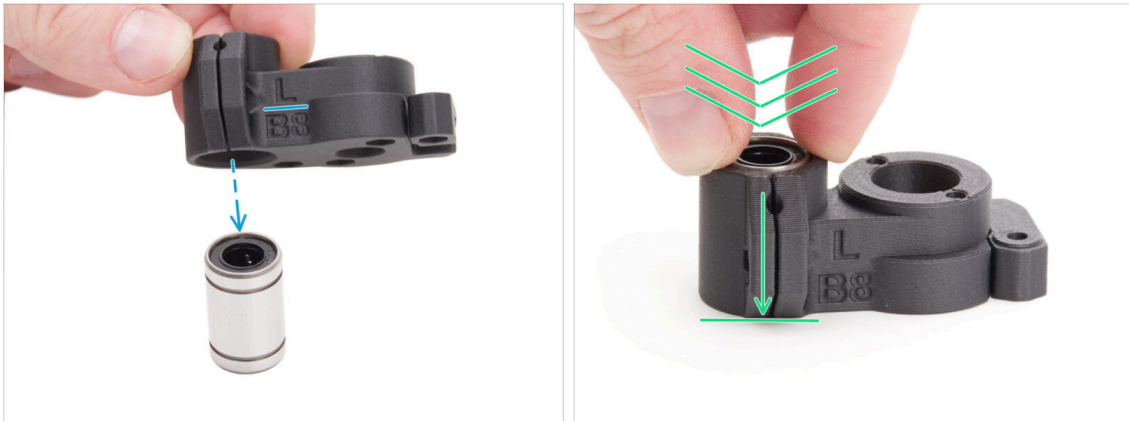
- ✦ Thread the three zip ties along the **RIGHT SIDE** of the heatbed carriage. Make sure the zip tie heads are facing outward.
- ✦ Guide the RGB LED strip cable through all zip ties.
- ✦ Then tighten all three zip ties. Cut off excess zip ties.

KROK 15 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*
- ✦ Ložiska LM8UU (2x) *naleznete v balíčku Electronics*
- ⓘ Ložiska jsou zabalena v modrých sáčcích.
- ✦ Šroub M3x10 (6x)
- ✦ Matka M3n (2x)
- ✦ Matka M3nN (10x)

KROK 16 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.

KROK 17 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.
- Udržujte ložisko v dané poloze a zajistěte jej vložím a utažením jednoho šroubu M3x10.
- ⚠ Ujistěte se, že je horní povrch ložiska v jedné rovině s horním povrchem plastového dílu.
- Stejně postupujte i při montáži CORE-One-bed-mount-right.

KROK 18 Bed mounts: inserting the nuts



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

KROK 19 Montáž dílu CORE-One-bed-spacer-rear



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

KROK 20 Montáž dílu bed-mount-right



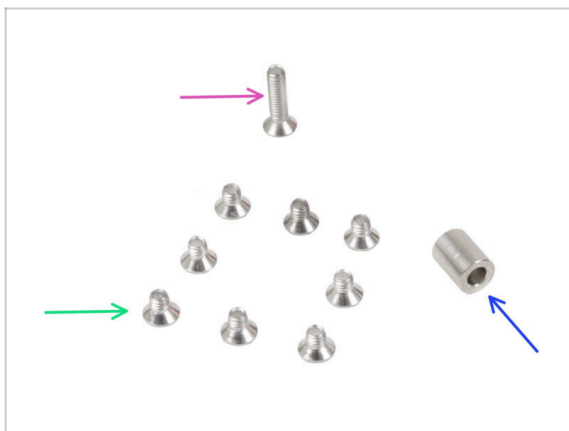
- Turn the heatbed carriage piece with the "forks" facing you and with the **expansion joints facing up**.
- Take the CORE-One-bed-mount-**right** part and slide it **under the right fork** - with the bearing on the right.
- Fix it with two M3x10 screws.

KROK 21 Montáž dílu 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.

KROK 22 Mounting the heatbed: parts preparation



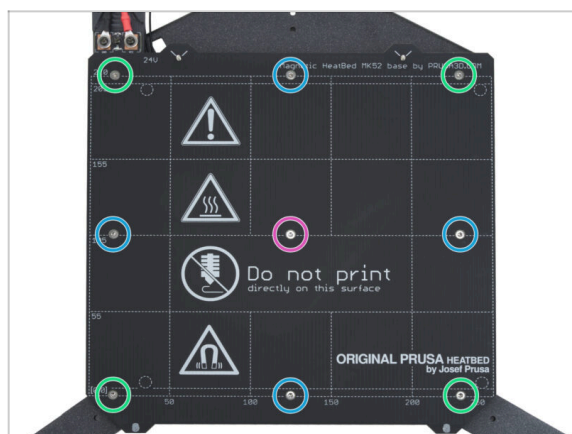
- For the following steps, please prepare:
- M3x12bT countersunk screw (1x)
 - i** Note: The package may label this screw as M3x12cT.
- Distanční vložka 6x3,1x8 mm (1x)
naleznete v balíčku Nextruder assembly
- Šroub se zápusťnou hlavou M3x4bT (8x)

KROK 23 Montáž vyhřívané podložky



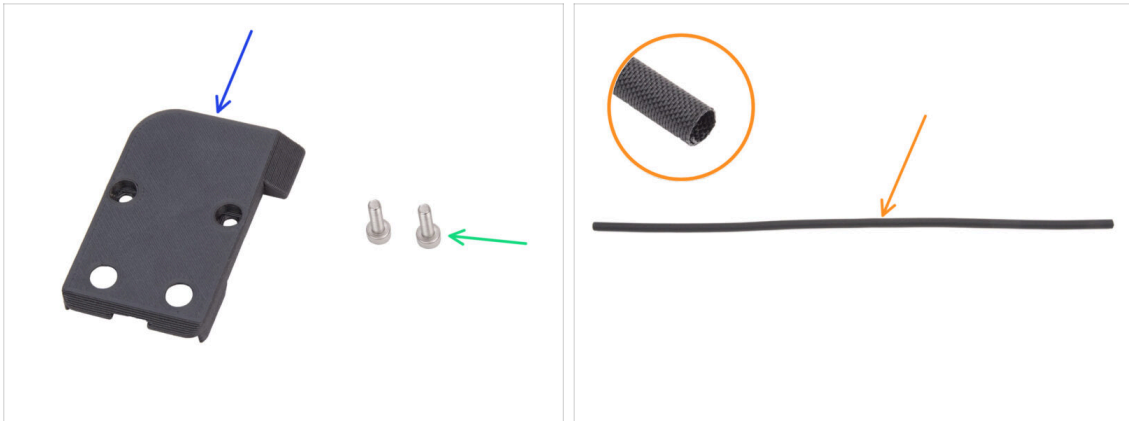
- ❖ Place the spacer onto the heatbed carriage on the side with the expansion joints and align it with the hole in the center.
- ❖ Put the heatbed on the heatbed carriage and secure it by the M3x12bT. **Do not fully tighten the screw yet.**
 - ❖ Make sure the heatbed thermistor cable (the thinnest pair) is routed alongside the heatbed power cables. Do not route it around or across any expansion joints.
- ⚠ **Zajistěte správnou orientaci dílu.** Jako vodičko použijte kabely vyhřívané podložky.
- ❖ Teď vložte šrouby M3x4bT i do zbývajících otvorů. **Ještě je neutahujte úplně !**

KROK 24 Utažení vyhřívané podložky



- ⚠ **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:
 - ❖ Středový šroub
 - ❖ První čtyři šrouby (na stranách)
 - ❖ Poslední čtyři šrouby (v rozích)
- ⚠ Šrouby utáhněte pevně, ale opatrně.

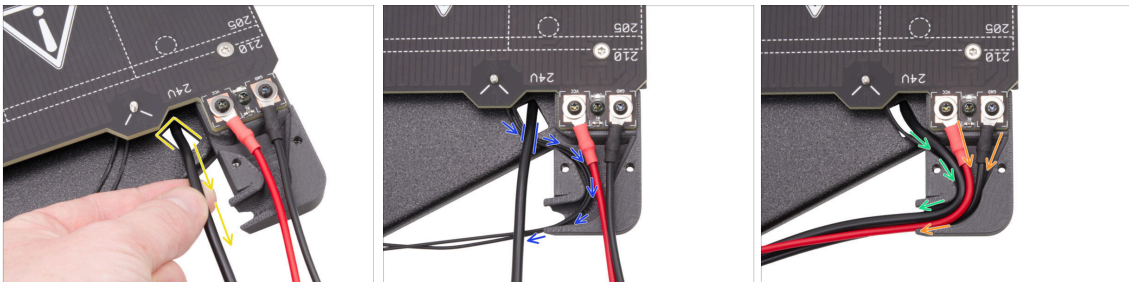
KROK 25 Covering the cables: parts preparation



■ For the following steps, please prepare:

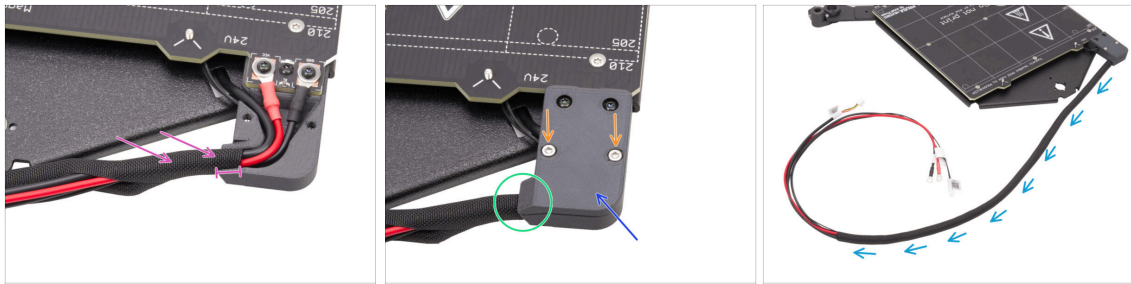
- CORE-One-bed-cable-cover-top (1x) found in the Printed parts package
- Šroub M3x10 (2x)
- Textilní rukáv 520 x 8 mm (1x) naleznete v balíčku Electronics & Chamber parts

KROK 26 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.
- Proveďte napájecí kabely vyhřívané podložky kabelovým kanálem.

KROK 27 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.**
- ✦ Zajistěte horní kryt dvěma šrouby M3x10.
- ✦ Zbytek textilního rukávu omotejte kolem svazku kabelů.

KROK 28 Mounting the heatbed: parts preparation



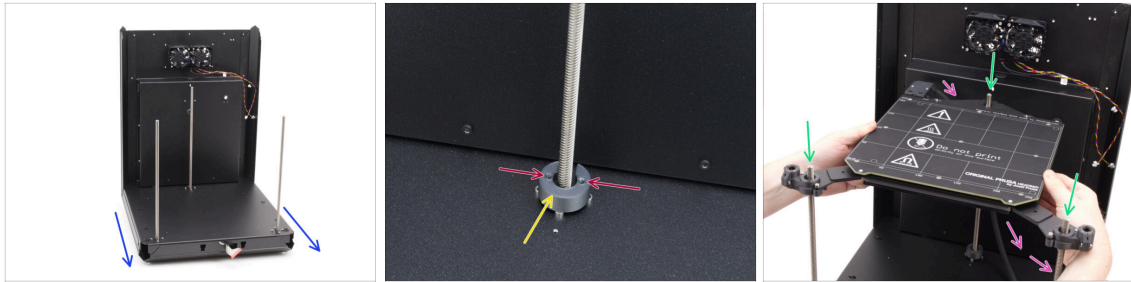
✦ **For the following steps, please prepare:**

✦ Trapézová matka (3x)

① Two trapezoidal nuts are included in the motors set package, and one nut can be found in the Electronics & Chamber parts package.

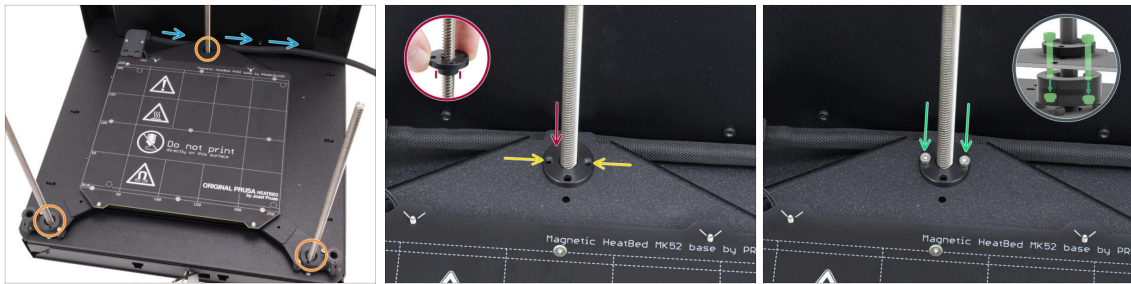
✦ Šroub M3x18 (6x)

KROK 29 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.
- Velmi opatrně nasadte sestavu vyhřívané podložky na závitové tyče motorů Z a poté ji opatrně položte na základnu.
 - ⚠ Nezapomeňte, že na zadním motoru je podložka. Vyhněte se podložce u kabelu vyhřívané podložky.
- Kabel vyhřívané podložky musí vést **pod vyhřívanou podložkou** a **za zadním motorem..**

KROK 30 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.

⚠ **Zajistěte správnou orientaci dílu. Vyčnívající část musí směřovat dolů.**
- ❖ Vyrovnajte otvory v trapézové matici, carriage a dílu bed-spacer-rear.

i Na použitém otvoru v trapézové matici nezáleží.

i Tip: 1,5mm inbusový klíč můžete prostrčit skrze otvory ve všech dílech, abyste je vyrovnali.
- ❖ Připevněte k sobě trapézovou matici, carriage vyhřívané podložky a díl bed-spacer-rear dvěma šrouby M3x18.

KROK 31 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.

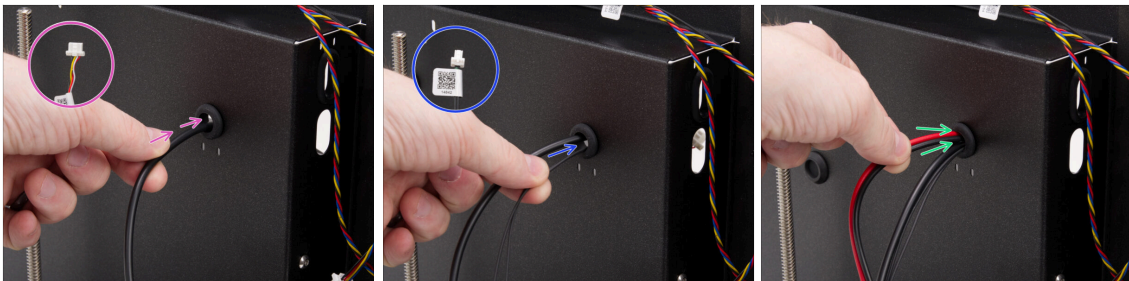
⚠ **Ensure the correct orientation of the part. The protruding section must face downwards.**
- ❖ Align the holes in the trapezoidal nut with those in the plastic part. Either pair of holes can be used.
- ❖ Všechny díly zajistěte pomocí dvou M3x18 šroubků.

KROK 32 Mounting the heatbed assembly: front motor right



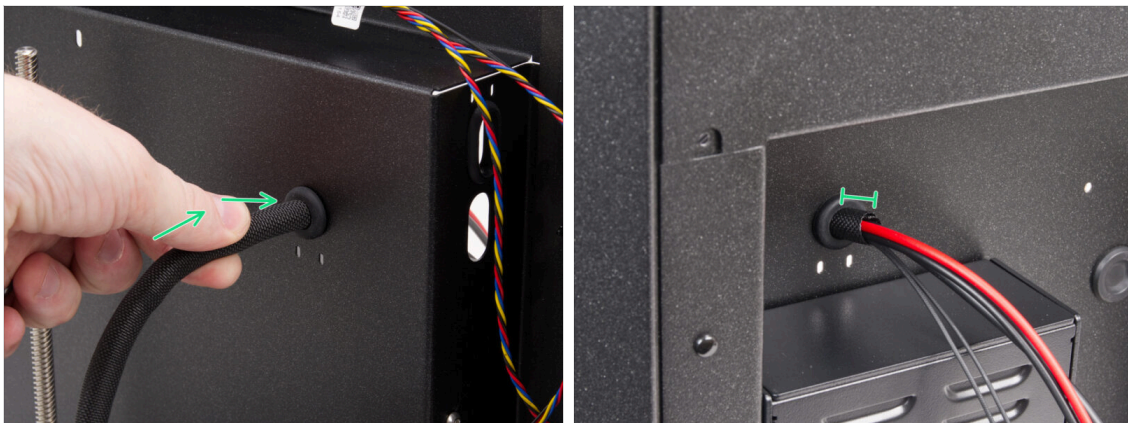
- Manually thread the trapezoidal nut onto the **right** Z motor. Screw the nut all the way down until it seats into the plastic part.
- ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- Align the holes in the trapezoidal nut with those in the plastic part.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

KROK 33 Attaching the heatbed cables I.



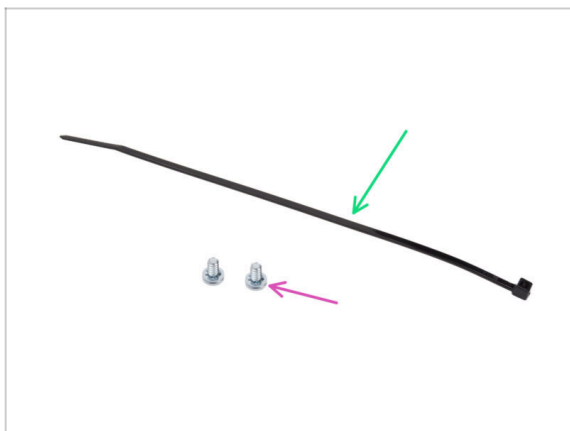
- Locate the grommet hole at the top right of the rear assembly and push the heatbed cables through in the following order:
 - Guide the RGB LED strip cable through the hole first.
 - Route the thermistor cable through the hole.
 - Nakonec zasuňte oba kabely napájení do otvoru.

KROK 34 Attaching the heatbed cables II.



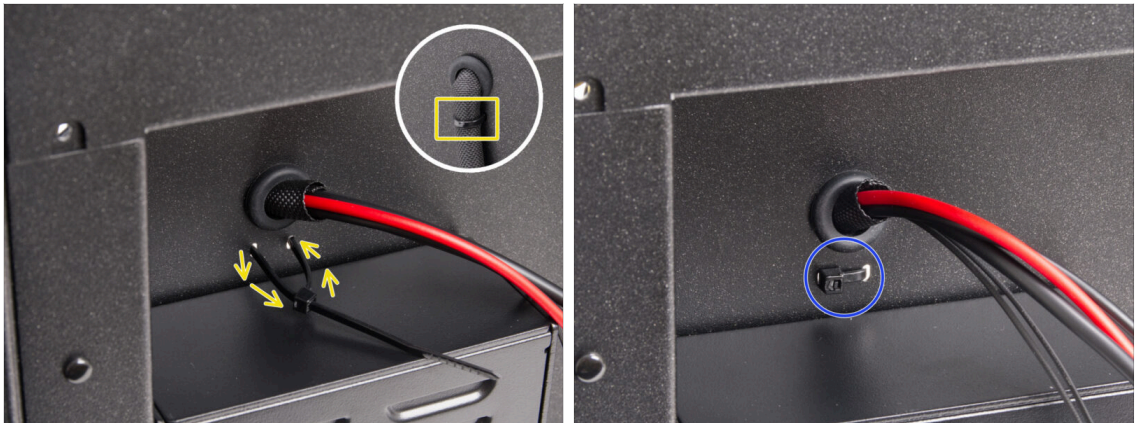
- Push the heatbed cables and the textile sleeve through the grommet hole.
- ⬛ No more than 1 cm (0.39 in) of the textile sleeve should protrude from the back side.

KROK 35 Securing the heatbed cables: parts preparation



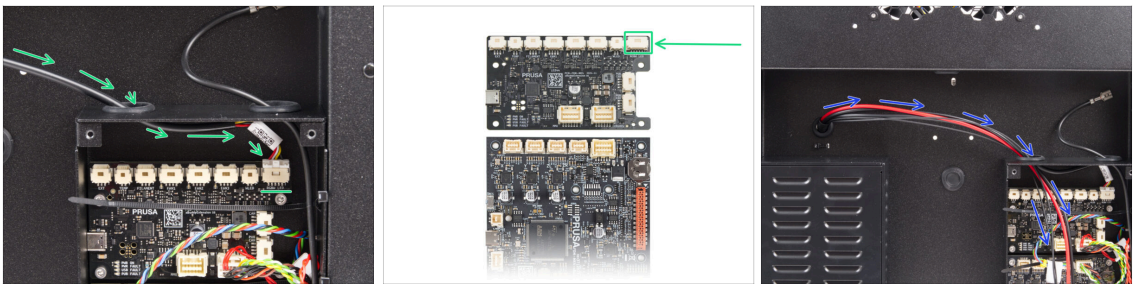
- ⬛ **For the following steps, please prepare:**
- Stahovací páska (1x)
- Power terminal screw 6-32 (2x)

KROK 36 Securing the textile sleeve



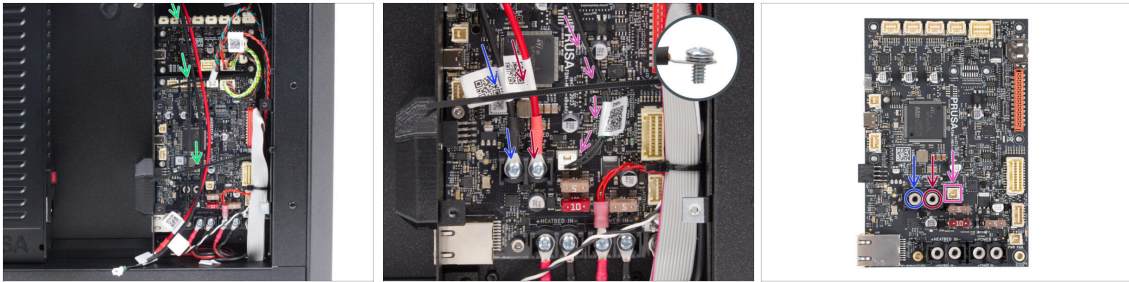
- Guide the zip tie through the two holes under the heatbed cables and make a loop around the heatbed cable bundle (textile sleeve) on the inside.
- Tighten the zip tie firmly and cut off the excess.

KROK 37 Guiding the heatbed assembly cables



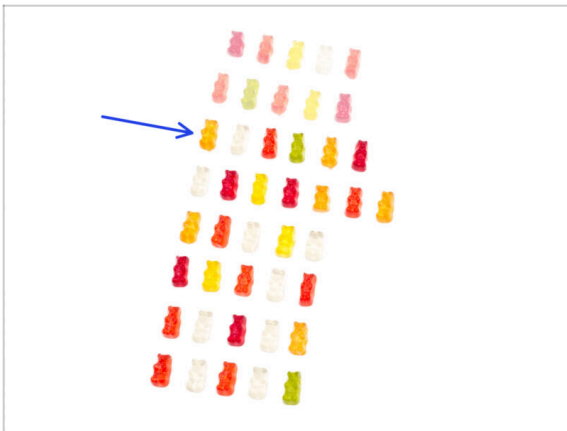
- Route the RGB LED strip cable through the left hole in the xBuddy box and connect it to the xBuddy Extension board labeled 'RGBW LED.'
- Connect it to the first slot from the right on the xBuddy extension board.
- Guide the heatbed power cables along with the thermistor through the left hole. Leave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

KROK 38 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 slot on the xBuddy board. Tighten firmly.
- Using the 6/32" terminal screw to connect the **red** power cable to the **right** terminal slot. Tighten firmly.
- Zapojte konektor termistoru vyhřívané podložky do slotu vedle napájecích svorek.

KROK 39 Je čas na Haribo!



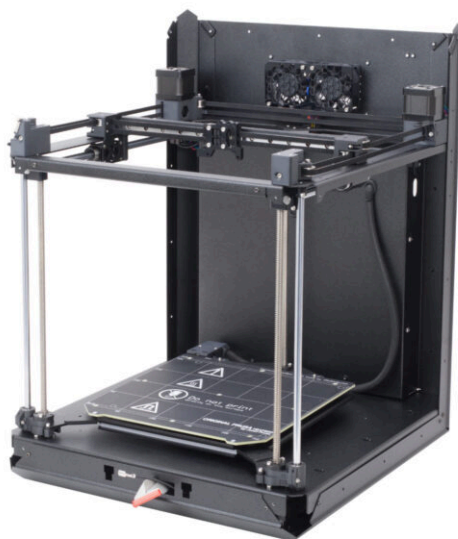
- Time for another quick energy boost!
- Eat the third row.
 - With one extra treat. You deserve it!

KROK 40 Hotovo



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

5. Sestava CoreXY



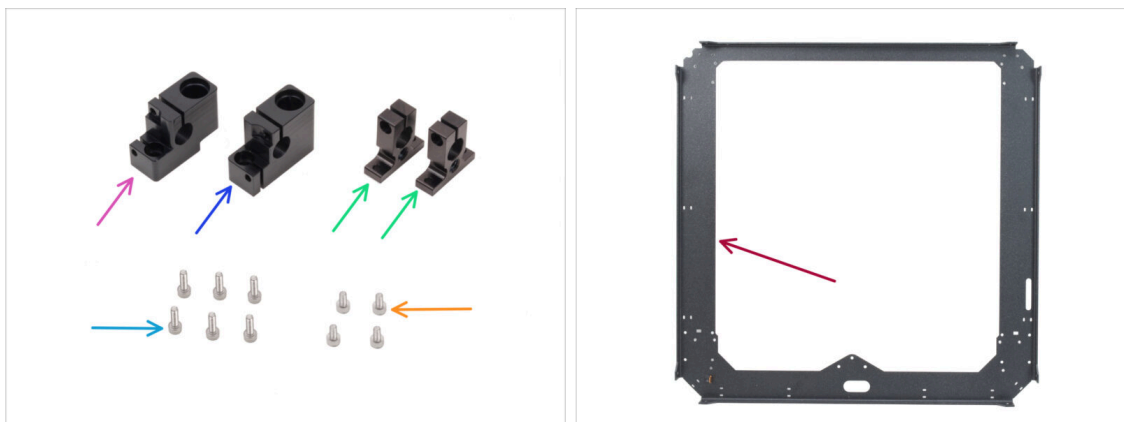
KROK 1 Tools necessary for this chapter



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

- Čelistové kleště
- 2,0mm inbusový klíč
- 2,5mm inbusový klíč
- T10 torx key / T10 torxy screwdriver

KROK 2 Rod holders: parts preparation



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

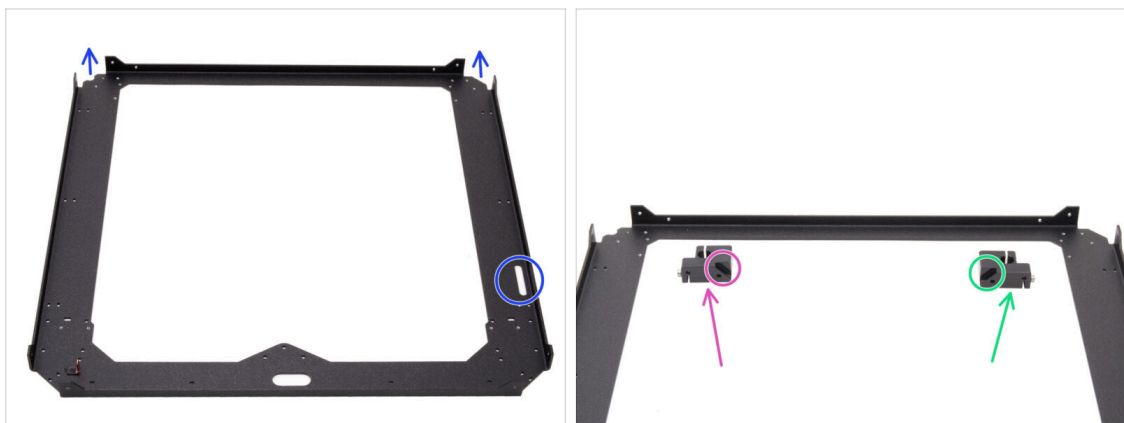
- Levý držák tyče (1x) *naleznete v balíčku CORE XY parts + hinges + HB set package*
- Rod holder right (1x) *found in the CORE XY parts + hinges + HB set package*
- Rod holder rear (2x) *found in the CORE XY parts + hinges + HB set package*
- Šroub M3x10 (6x)
- Šroub M3x6 (4x)
- základní plát sestavy CoreXY (1x) *naleznete v balení Metal parts 1/3*

KROK 3 Assembling the rod holders



- Insert two M3x10 screws into the Rod holder left and two into the Rod holder right.
 - **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.

KROK 4 Preparing the front rod holders



- Place the CoreXY plate as shown - the **bent parts of the plate must point upwards**.
- 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.**
 - Držák tyče (levý)
 - Držák tyče (pravý)

KROK 5 Installing the front rod holders



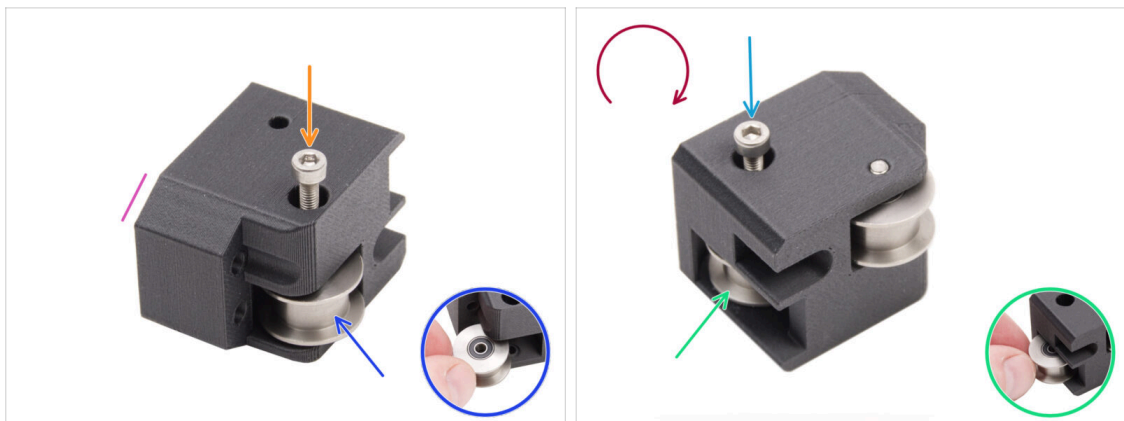
- 🟢 Place the Rod holder left to the left front corner on the corresponding threaded holes.
- 🟠 Secure it with two M3x6 screws.
- 🟡 Place the Rod holder right to the right front corner on the corresponding threaded holes.
- 🟣 Secure it with two M3x6 screws.

KROK 6 XY carriage: parts preparation



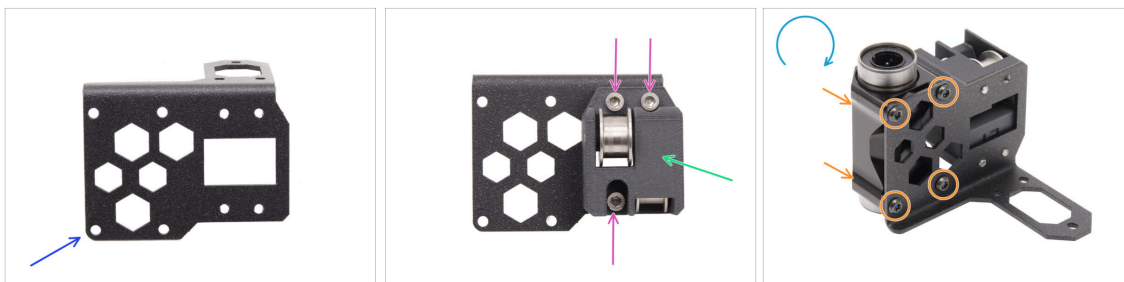
- ⬛ **For the following steps, please prepare:**
- 🟡 Linear holder left (1x) *found in the Metal parts 1/3 package*
 - 🔴 Linear holder right (1x) *found in the Metal parts 1/3 package*
 - 🟢 XY-carriage (2x) *found in the Printed parts package*
 - 🟣 LM10LUU linear bearing (2x) *found in the CORE XY parts + hinges + HB set package*
 - 🟠 Řemenice idleru GT2-20 (4x) *naleznete v balíčku Electronics & Fasteners*
 - 🟠 Šroub M3x8T - černý (8x)
 - 🟡 Šroub M3x18 (10x)

KROK 7 Montáž dílu XY-carriage



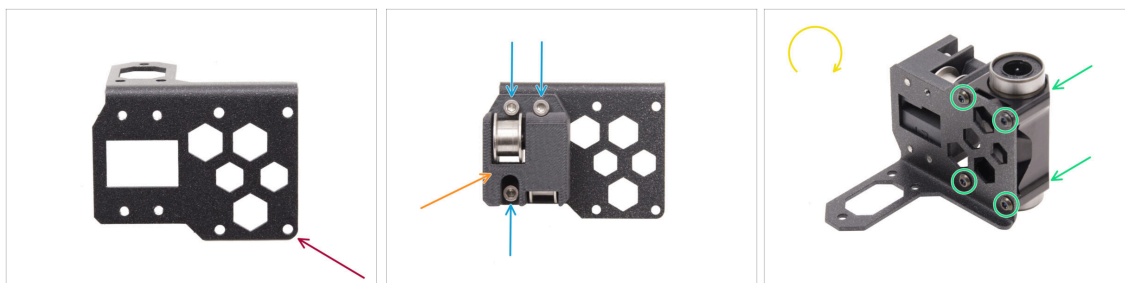
- ✿ Take one of the XY-carriage and orient it as shown. Use the beveled side as a guide.
- ✿ Insert the GT2-20 Idler pulley into the XY-carriage.
- ✿ Push one M3x18 screw through the pulley and tighten it completely down.
- ✿ Turn the part upside down.
- ✿ Insert another GT2-20 Idler pulley into the XY-carriage.
- ✿ Zajistěte jej šroubem M3x18. Úplně jej utáhněte.
- ✿ **Opakujte stejný postup pro druhý XY-carriage.**

KROK 8 Assembling the linear holder left



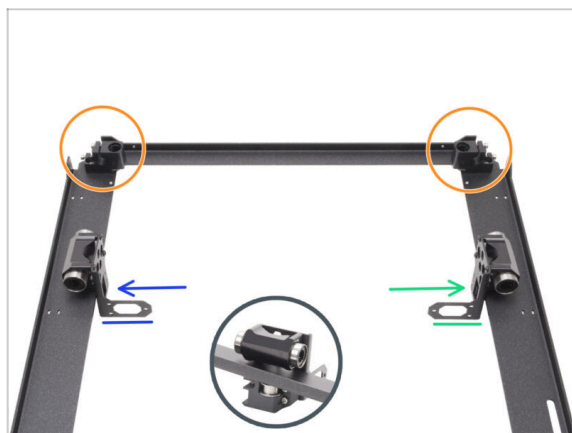
- ✿ Prepare the Linear holder **left** and position it as in the picture.
- ✿ Attach one of the XY-carriages to the Linear holder.
- ✿ Carriage k držáku připevněte třemi šrouby M3x18.
- ✿ Turn the Linear holder upside down.
- ✿ From the XY-carriage side, attach the LM10LUU linear bearing to the holder and secure it with four M3x8rT screws.

KROK 9 Assembling the linear holder right



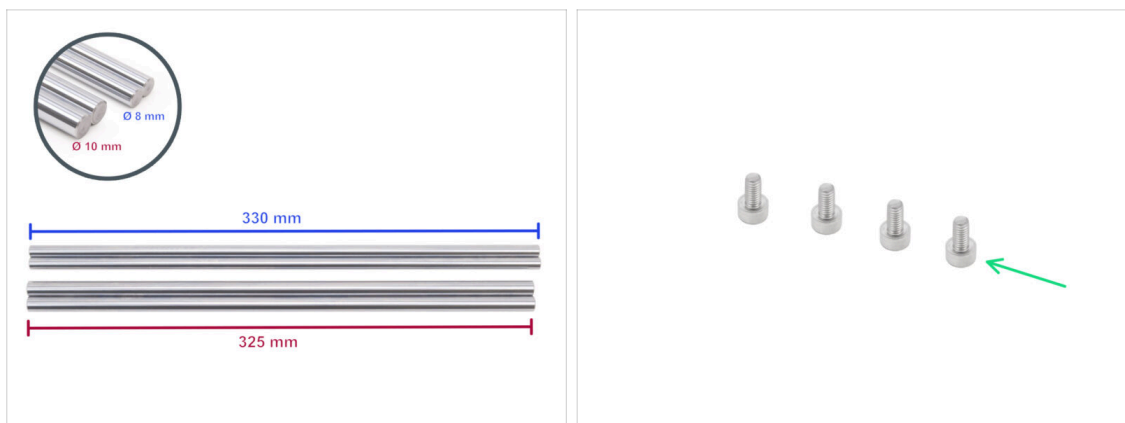
- Prepare the Linear holder **right** and position it as in the picture.
- Attach one of the XY-carriages to the Linear holder.
- Carriage k držáku připevněte třemi šrouby M3x18.
- Turn the Linear holder upside down.
- From the XY-carriage side, attach the LM10LUU linear bearing to the holder and secure it with four M3x8rT screws.

KROK 10 Attaching the linear holder assemblies



- Position the CoreXY plate as shown in the picture, ensuring the front rod holders are facing up.
- Slightly lift the CoreXY plate and from the plate's inner side loosely attach the Linear holder of the assemblies.
- **Držák lineárního vedení (levý)**
- **Držák lineárního vedení (pravý)**
- ① The linear holders are now only loosely seated.

KROK 11 Hlazené tyče INFO



- There are two different types of smooth rods in the package. Compare carefully with the picture and prepare the correct ones required.

i Smooth rods are included in the Rods box.

Smooth rod 330 x 8 mm (2x)

Smooth rod 325 x 10 mm (2x) **required for the following steps**

- For the following steps, please prepare:**

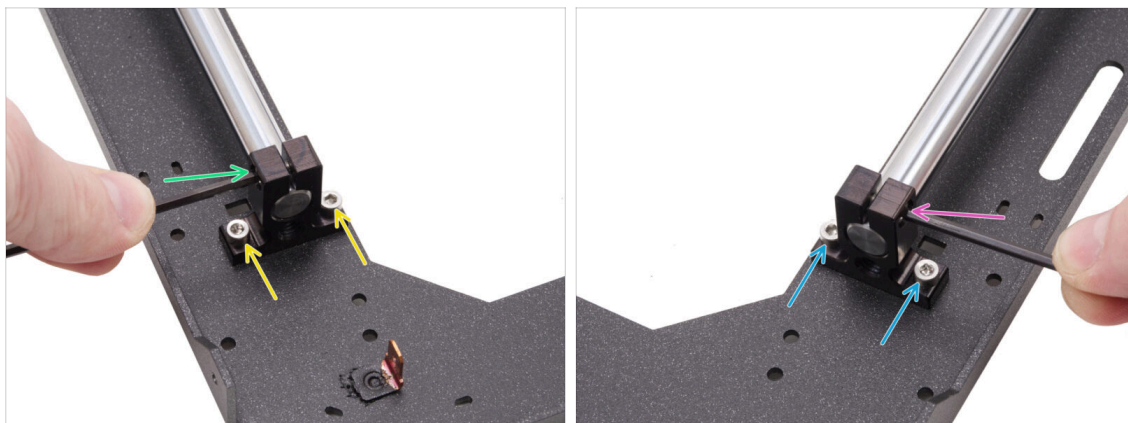
Šroub M3x6 (4x)

KROK 12 Mounting the smooth rods



- Slide both rear rod holders onto both 10mm smooth rods.
- 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.

KROK 13 Securing the rear rod holders



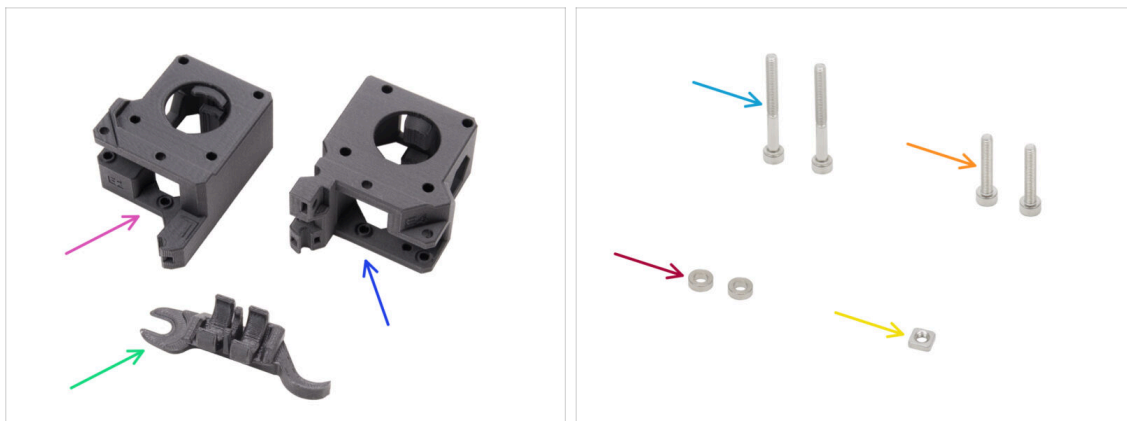
- Line up the left rear rod holder with the threaded holes in the plate.
- Fix it with two M3x6 screws.
- Firmly tighten the screw in the rod holder.
- Line up the right rear rod holder with the threaded holes in the plate.
- Fix it with two M3x6 screws.
- Pevně utáhněte šroub v horní části držáku tyče.

KROK 14 Securing the front rod holders



- Zaměřte se na levý přední držák (nyní vpravo) a zajistěte tyč utažením šroubu v držáku.
- ⚠ **Do not tighten the bottom screw.**
- Zaměřte se na pravý přední držák (nyní vlevo) a zajistěte tyč utažením šroubu v držáku.
- ⚠ **Do not tighten the bottom screw.**

KROK 15 Motor mounts: parts preparation

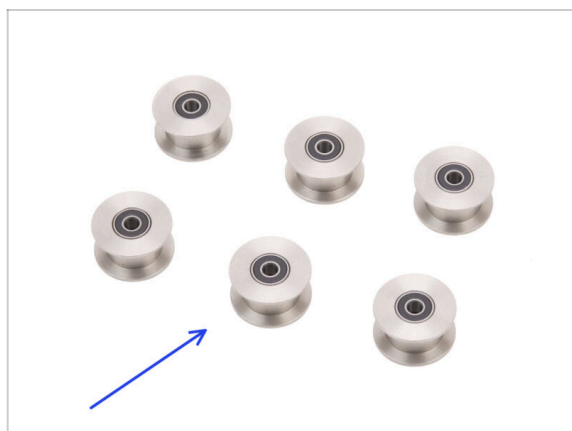


● **For the following steps, please prepare:**

- 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*
- Šroub M3x30 (2x)
- Šroub M3x18 (2x)
- podložka 3.2/6x2 (2x) *naleznete v balíčku Electronics & Fasteners*
- Matka M3nS (1x)

❗ The list continues in the next step...

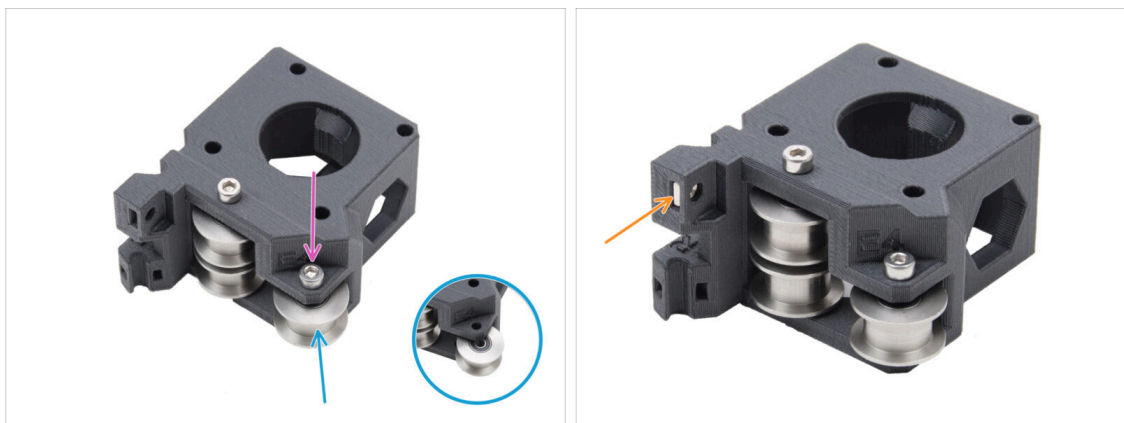
KROK 16 Motor mounts: part preparation



- GT2-20 Idler pulley (6x) *found in the Electronics & Fasteners package*

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

- ✦ Vložte jednu řemeničku do spodní pozice dílu Assembly-multi-tool.
- ✦ Insert the spacer 3.2 on the pulley.
- ✦ Vložte druhou řemeničku do dílu Assembly-multi-tool.
- ✦ Insert the whole assembly into the XY-motor-mount-right.
 - ⬛ Position the part according to the picture. Note the beveled corner.
- ✦ Zarovnejte otvory v obou dílech a zajistěte je šroubem M3x30.
 - 🔩 Plastová část nemá předřezaný závit, takže šroub jej vytvoří při utahování. Očekávejte proto mírný odpor.
- ✦ Odejměte Assembly-multi-tool.

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

- ✦ Insert another pulley into the XY-motor-mount-right.
- ✦ Secure it with M3x18 screw.
 - 🔩 (i) Plastová část nemá předřezaný závit, takže šroub jej vytvoří při utahování. Očekávejte proto mírný odpor.
- ✦ Insert the M3nS nut into the XY-motor-mount-right.

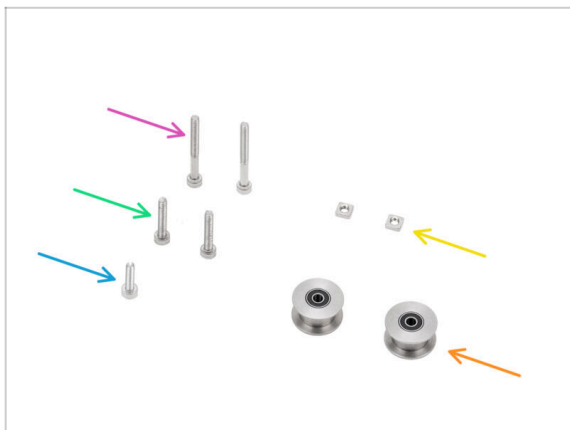
KROK 19 Assembling the XY-motor-mount-left I.

- ✿ Vložte jednu řemeničku do spodní pozice dílu Assembly-multi-tool.
- ✿ Insert the spacer 3.2 on the pulley.
- ✿ Vložte druhou řemeničku do dílu Assembly-multi-tool.
- ✿ 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.
- ✿ Zarovnejte otvory v obou dílech a zajistěte je šroubem M3x30.
 - ⓘ Plastová část nemá předřezaný závit, takže šroub jej vytvoří při utahování. Očekávejte proto mírný odpor.
- ✿ Odejměte Assembly-multi-tool.

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

- ✿ Insert another pulley into the part.
- ✿ Secure it with M3x18 screw. **Do not overtighten the screw.**
 - ⓘ Plastová část nemá předřezaný závit, takže šroub jej vytvoří při utahování. Očekávejte mírný odpor.

KROK 21 Belt tensioners: parts preparation I.



For the following steps, please prepare:

GT2-20 Idler pulley (2x) *found in the Electronics package*

Šroub M3x30 (2x)

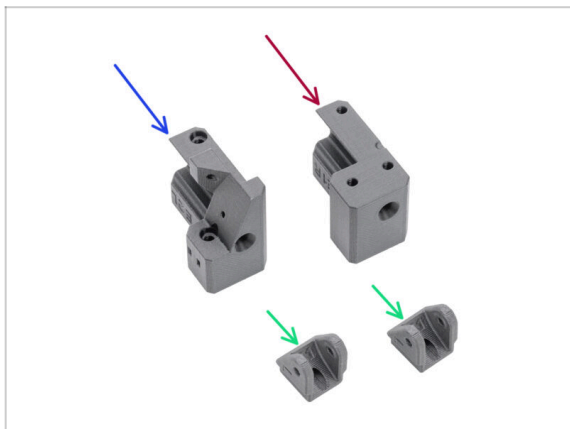
Šroub M3x18 (2x)

Šroub M3x12 (1x)

Matka M3nS (2x)

i Seznam pokračuje v dalším kroku...

KROK 22 Belt tensioners: parts preparation II.



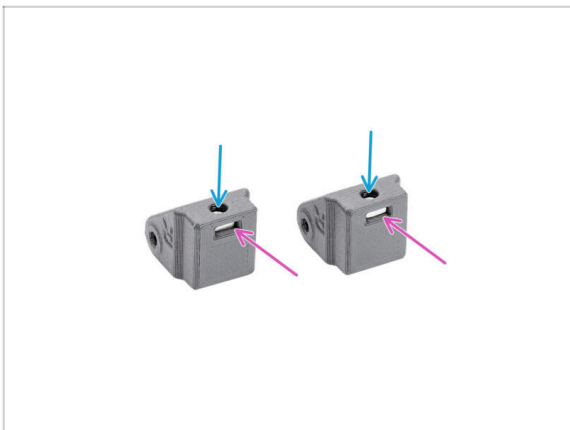
For the following steps, please prepare:

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*

KROK 23 Příprava dílů tensioner pulley



- ✦ Insert one M3nS nut into each Belt-tensioner-pulley.
- ✦ Ujistěte se, že jsou matky správně zasunuty do dílů. Otvory v matkách a dílech **musí být zarovnány**.
- ✦ Ponechte oba díly v této poloze.

KROK 24 Assembling the belt tensioner left I.



- ✦ Naneste malé množství maziva Prusa Lubricant na špičku obou šroubů M3x30.
- ✦ Naneste mazivo rovnoměrně po celém závitu.
- ⓘ Tip: K nanesení maziva použijte špičku stahovací pásky.
- ✦ Slide the Belt-tensioner-**left** onto the Belt-tensioner-pulley.
- ✦ **Ensure the parts are oriented correctly**, as shown.
- ✦ Vložte šroub M3x30 skrz díl Belt-tensioner-left do dílu Belt-tensioner-pulley. **Nedotahujte jej úplně!** Postačí 3-4 otáčky.

KROK 25 Assembling the belt tensioner left II.



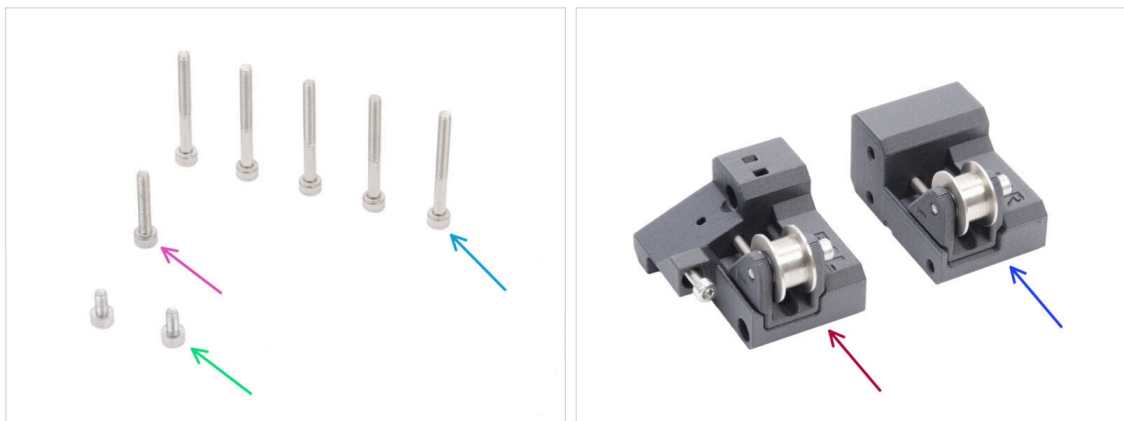
- Insert the GT2-20 Idler pulley into the Belt-tensioner-pulley.
- Secure it with the M3x18 screw.
 - ⓘ Plastová část nemá předřezaný závit, takže šroub jej vytvoří při utahování. Očekávejte proto mírný odpor.
- Insert the M3x12 screw into the Belt-tensioner-left. Tighten slightly—five turns are enough. 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.

KROK 26 Assembling the belt tensioner right



- Slide the Belt-tensioner-**right** onto the 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.
 - ⓘ Plastová část nemá předřezaný závit, takže šroub jej vytvoří při utahování. Očekávejte proto mírný odpor.

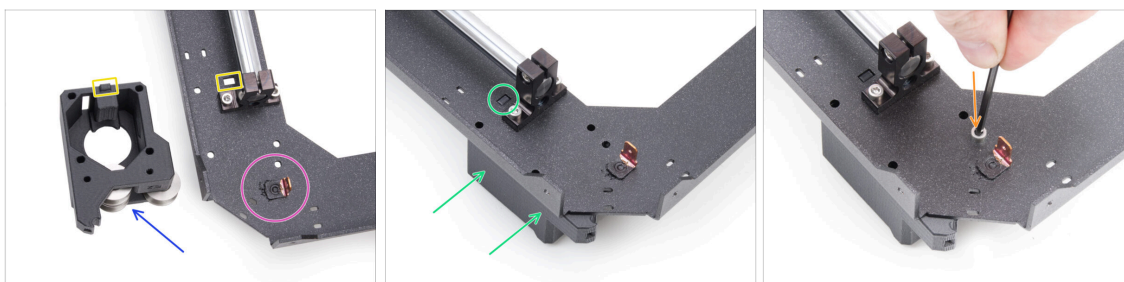
KROK 27 Installing the belt tensioners: parts preparation



● For the following steps, please prepare:

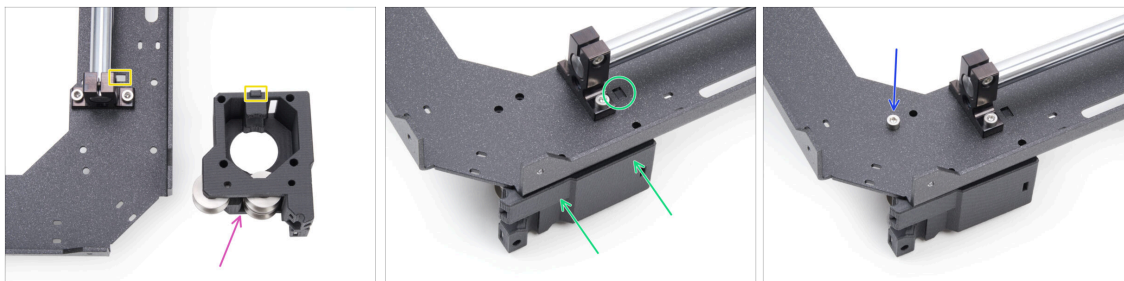
- Šroub M3x30 (5x)
- Šroub M3x18 (1x)
- Šroub M3x6 (2x)
- Sestava Belt tensioner left (1x) *kterou jste odmontovali dříve*
- Sestava Belt tensioner right (1x) *kterou jste odmontovali dříve*

KROK 28 Installing the motor mount left



- Locate the corner of the CoreXY plate with the Faston connector on it. It is on the underside of the assembly.
- 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.
- Zasuňte levý držák motoru (díl motor-mount-left) pod desku CoreXY, aby obdélníkový výstupek zapadl do výřezu.
- Vyrovnajte otvory v obou dílech a zajistěte je šroubem M3x6 v určeném otvoru.

KROK 29 Installing the motor mount right



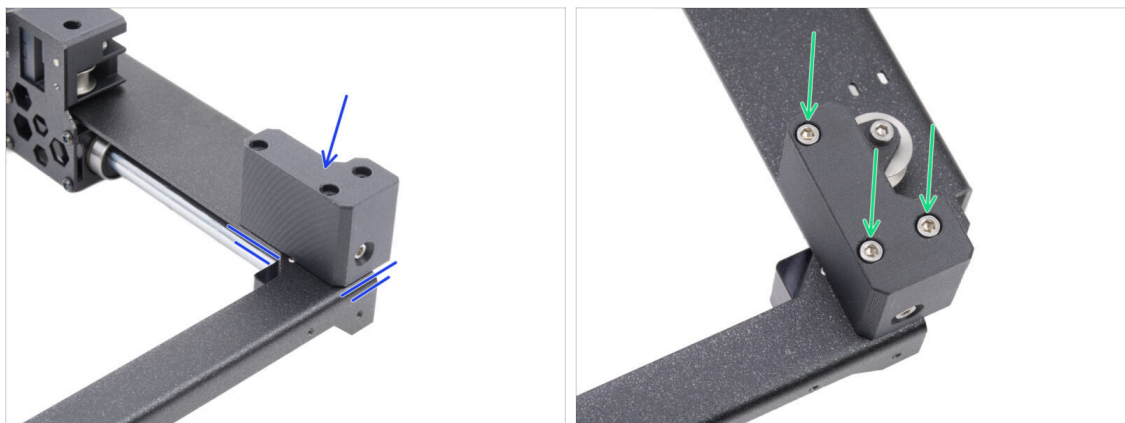
- ◆ Position the motor-mount-**right** on the CoreXY plate as shown in the picture.
- ◆ Všimněte si obdélníkového výčnělku na pravém držáku motoru (motor-mount-right) a obdélníkového výřezu na plátu CoreXY.
- ◆ Zasuňte pravý držák motoru (díl motor-mount-right) pod desku CoreXY, aby obdélníkový výstupek zapadl do výřezu.
- ◆ Align the holes in both parts and secure them with an M3x6 screw in the designated hole

KROK 30 Osazení levého napínáku řemenu



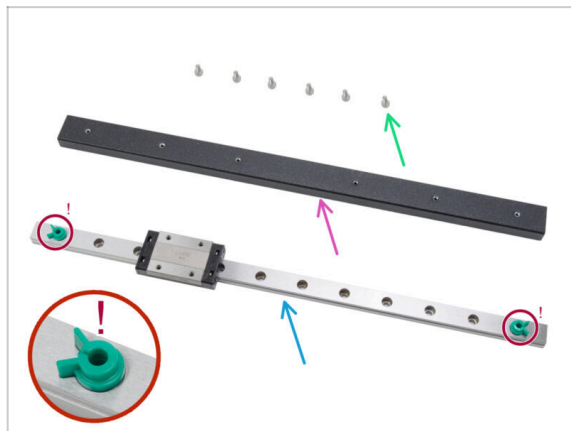
- ◆ Turn the CoreXY assembly upside down so that the bent parts face downward. Focus on the front left corner on the assembly.
- ◆ Place the belt-tensioner-**left** assembly in the front left corner of the CoreXY plate. Align it with the front and inner side edges.
- ◆ Line up the holes in both parts.
- ◆ Secure the part with two M3x30 screws.
- ◆ Vložte jeden šroub M3x18 a utáhněte jej.

KROK 31 Osazení pravého napínáku řemenu



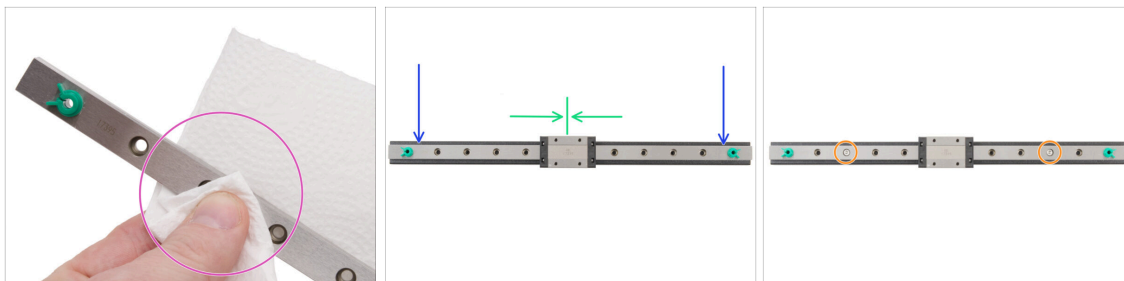
- Place the belt-tensioner-**right** assembly in the front right corner. Align it with the front and inner side edges.
- Line up the holes in both parts.
- Secure the part with three M3x30 screws.

KROK 32 Linear rail: parts preparation



- For the following steps, please prepare:
 - Šroub M3x6 (6x)
 - Linear rail beam (1x) *found in the Metal parts 3/3 package*
 - Linear rail (1x) *found in the Electronics & Chamber parts package*
- ⚠ **V žádném případě neodstraňujte zelené bezpečnostní kolíčky zabraňující vysunutí.. Počkejte na výzvu v pokynech.**
- Papírové utěrky nebo hadřík - k otření ochranného oleje z hladkých tyčí a lineárního vedení.

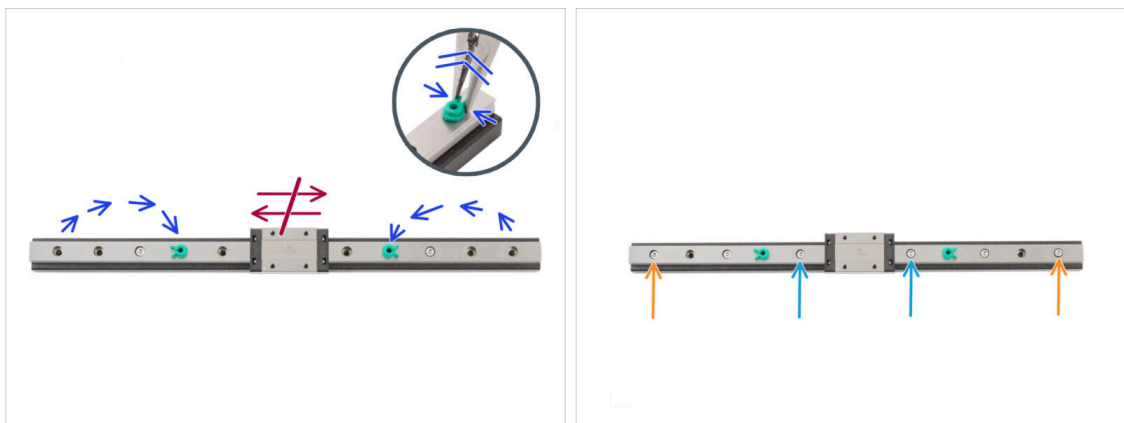
KROK 33 Attaching the linear rail



⚠ 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.
- 🟢 Place 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.
- 🟢 Carriage lineárního vedení přesuňte přibližně do středu kolejnice lineárního vedení.

KROK 34 Securing the linear rail

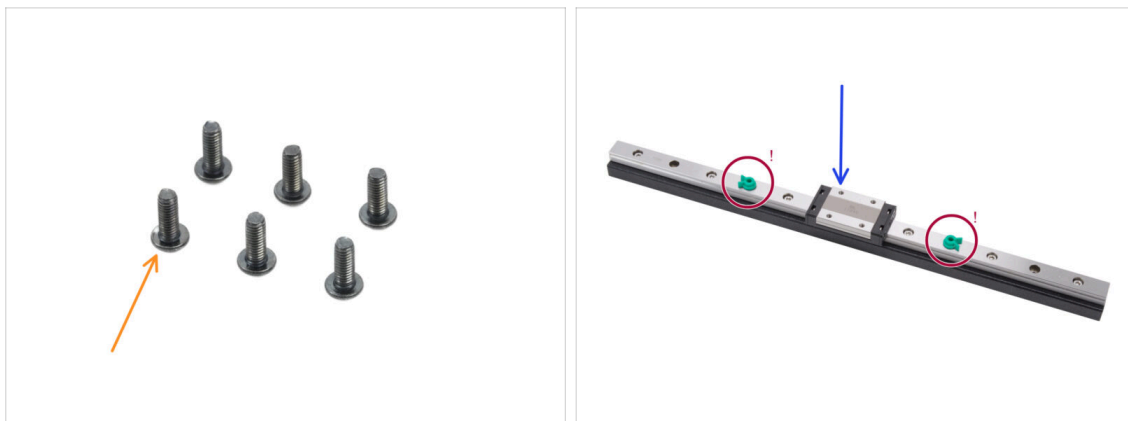


⚠ Do not move the linear carriage in any way in this step.

- 🟢 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.**
- 🟠 Do prvních otvorů v liště vložte dva šrouby M3x6. **Jen mírně je utáhněte.**

⚠ Bezpečnostní zarážky z kolejnice ještě neodstraňujte!

KROK 35 Installing the linear rail: parts preparation



● Pro následující kroky si prosím připravte:

● Šroub 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*

⚠ **Neodstraňujte bezpečnostní kolíčky.**

KROK 36 Installing the linear rail assembly



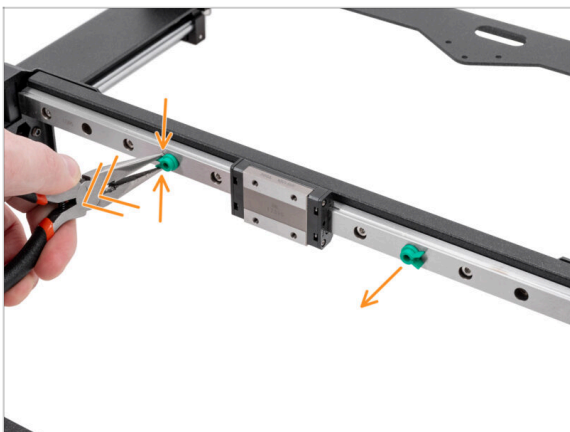
● Sestavu si umístěte tak, aby motory směřovaly k vám.

● 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.

● Secure it with three M3x8rT screws from the back side on both the left and right sides.

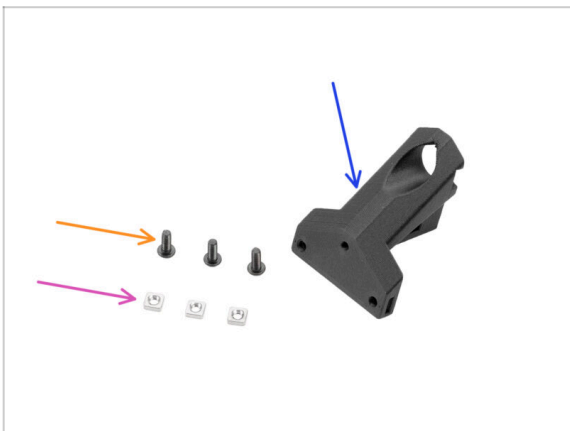
KROK 37 Linear rail: removing the safety pins



🟡 Jemně stiskněte oba pojistné kolíky čelistovými kleštěmi a vytáhněte je z lineárního vedení.

📌 You can discard the safety pins as they are no longer needed.

KROK 38 Bed-stop (zarážka podložky): příprava dílů



⬛ Pro následující kroky si prosím připravte:

🟡 Bed-stop-rear (1x) found in the Printed parts package

🟣 Matka M3nS (3x)

🟡 Šroub M3x8rT (3x)

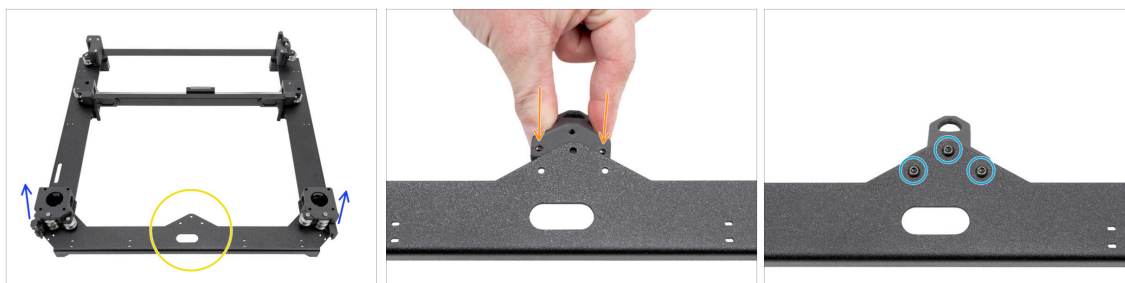
KROK 39 Sestavení zarážky podložky (bed-stop)



🟣 Do dorazu podložky (bed-stop) vložte dvě matky M3nS z jedné strany.

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

KROK 40 Osazení zarážky podložky (bed-stop)



- Umístěte sestavu CoreXY podle obrázku tak, aby držáky motoru směřovaly nahoru.
- Focus on the triangle protrusion on the metal part.
- Insert the bed-stop-rear **under** the protrusion at the back of the CoreXY plate.
- Align all three holes in both parts.
- Oba díly zajistěte dohromady třemi šrouby M3x8rT.
- ⓘ Horní šroub je zašroubován do plastu bez předřezaného závitu. Při utahování se závit vyřízne. Očekávejte mírný odpor.

KROK 41 X&Y motors: parts preparation



- Pro následující kroky si prosím připravte:
- Y-axis motor (1x) *found in the Motors package*
- X-axis motor (1x) *found in the Motors package*
- ⓘ Note that the motors are marked as X and Y-axes in order to distinguish between them. We will continue to follow this marking.
- Řemenička T16-2GT (2x) *naleznete v balíčku Electronics*
- Assembly-multi-tool (1x) *který jste už použili*

KROK 42 Installing the X-axis pulley



● Připravte si motor **osy X**.

● Note the flat part on the motor shaft.

⚠ Slide the Pulley on, **note the CORRECT orientation**.

● Rotate the motor shaft with the flat part facing you.

● K nastavení správného odstupu mezi řemeničkou a motorem použijte "vidličku" vašeho Assembly-multi-toolu.

● Řemeničku zatlačte až k multi-toolu a pevně utáhněte stavěcí šroub řemeničky - ujistěte se, že sedí na ploché straně hřídele.

● Otočte řemeničku a utáhněte pevně druhý stavěcí šroub.

⚠ Překontrolujte správnou orientaci řemeničky. **Ozubená strana řemeničky musí být na straně motoru.**

KROK 43 Installing the Y-axis pulley

- Připravte si motor **osy Y**.
- Note the flat part on the motor shaft. Rotate the motor shaft with the flat part facing you.
- ⚠ **Nasadte řemeničku - dejte si pozor na SPRÁVNOU orientaci. Orientace řemeničky osy Y se LIŠÍ od osy X. Ujistěte se, že zuby řemeničky směřují od motoru. Použijte širší hák na montážním nástroji.**
- Pomocí "háku" na Assembly-multi-toolu umístěte silnější zakřivenou část mezi řemeničku a motor.
- ⚠ **Nepokoušejte se jej zachytit kolem hřídele.. Nástroj pouze opřete o motor a ujistěte se, že hrot háku klouže mezi motorem a řemeničkou.**
- Řemeničku zatlačte až k multi-toolu a pevně utáhněte stavěcí šroub řemeničky - ujistěte se, že sedí na ploché straně hřídele.
- Otočte řemeničku a utáhněte pevně druhý stavěcí šroub.
- ⚠ **Překontrolujte správnou orientaci řemeničky. Ozubená strana musí směřovat od motoru.**

KROK 44 XY belts: parts preparation



● Pro následující kroky si prosím připravte:

- X-axis motor assembly (1x) *you assembled earlier*
- Y-axis motor assembly (1x) *you assembled earlier*
- Nexttruder holder (1x) *found in the CORE XY parts + hinges + HB set package*
- řemen XY (2x) *naleznete v balíčku dílů CORE XY parts + hinges + HB set*
- Šroub M3x35 (8x)

KROK 45 Řemeny osy XY INFO



ⓘ Další kroky se týkají instalace a vedení řemene na sestavě Core XY. Než začnete, podívejte se na obrázek pro přehled a lepší pochopení dráhy jednotlivých řemenů.

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

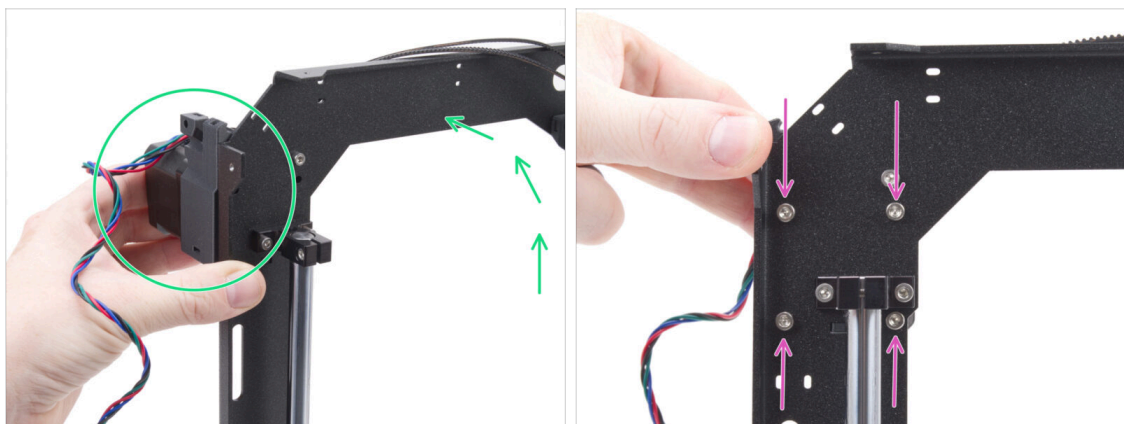
● Let's guide the belts step by step...

KROK 46 Y belt guiding: Y motor pulley



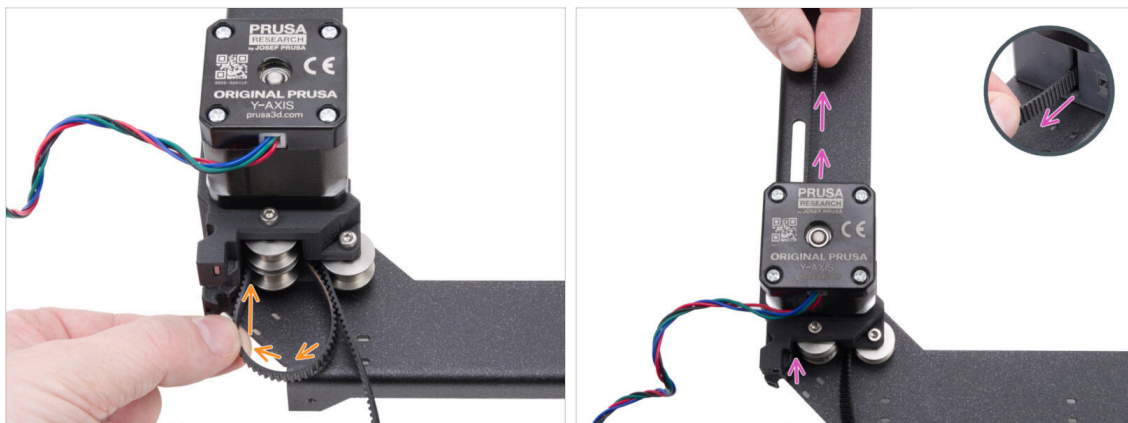
- Ze zadní strany CoreXY se teď soustředíte na držák motoru na **levé** straně.
- Create a loop anywhere on the belt so the **belt teeth are pointing inside** the loop.
- Push this loop through the space between the lower pulleys inside the motor mount.
- Push through enough to make the loop follow the top round hole of the motor-mount as closely as possible.
- Vložte motor osy Y do držáku motoru a ujistěte se, že je řemenička vycentrována ve smyčce řemene.
- Vložte řemenici motoru osy Y do držáku motoru a ujistěte se, že je vycentrována ve smyčce řemene.
Pak motor napevno přimontujte k držáku motoru tak, aby kabel motoru směřoval k vám.
- Lehce zatáhněte za smyčku řemene, aby obepínala řemeničku.

KROK 47 Securing the Y-axis motor



- Pevně uchopte sestavu motoru osy Y a umístěte sestavu CoreXY do svislé polohy.
Neupustěte 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.**
- Place the CoreXY assembly back into the horizontal position.

KROK 48 Y belt guiding: Y motor mount



- ✚ Levý konec řemene vedte kolem levé spodní řemenice.
- ✚ 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.

KROK 49 Y belt guiding: belt tensioner



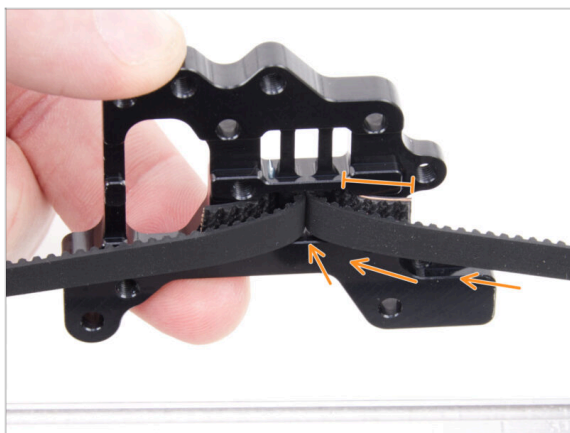
- ✚ Řemen vedte kolem řemenice v napínáku řemene.
- ✚ Push the belt around the front pulley in the linear assembly.
- ✚ Prepare the Nextruder holder in the same orientation as in the picture. Note the holes for securing the belts.
- ✚ Push the end of the belt through the middle hole into the left hole in the bottom row - leave 4-5 teeth sticking out.
- ⓘ Na tomto konci je řemen zajištěn. Prozatím jej můžete nechat volný.

KROK 50 Y belt guiding: X motor mount



- Vraťme se zpět na druhý konec řemene osy Y.
- 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.
- Route the belt around the lower right pulley in the linear rail holder.

KROK 51 Y belt guiding: securing the belt



- Zasuňte konec řemene prostředním otvorem do pravého otvoru ve spodní řadě držáku Nextruderu - nechte 4-5 zubů vyčnívat.

i If it is difficult to reach the Nextruder holder with the belt, try loosening the belt tensioner screw on the front of the assembly.



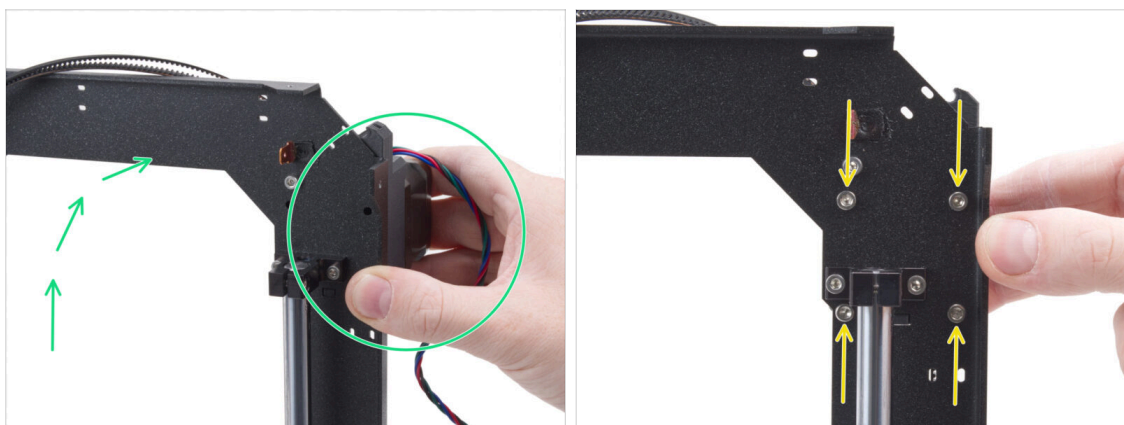
Don't forget to adjust it back after securing the belt.

KROK 52 X belt guiding: X motor pulley



- Ze zadní strany CoreXY se teď soustředíte na držák motoru na **pravé** straně.
- 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.
- Push through enough to make the loop follow the top round hole of the motor-mount as closely as possible.
- Vložte řemenici motoru osy **X** do držáku motoru a ujistěte se, že je vycentrována ve smyčce řemene.
- Ujistěte se, že kabel motoru směřuje k vám (dozadu).
- Lehce zatáhněte za smyčku řemene, aby obepínala řemeničku.

KROK 53 Securing the X-axis motor



- Pevně uchopte sestavu motoru osy X a umístěte sestavu CoreXY do svislé polohy. **Neupustěte 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.**
- Place the CoreXY assembly back into the horizontal position.

KROK 54 Y belt guiding: X motor mount



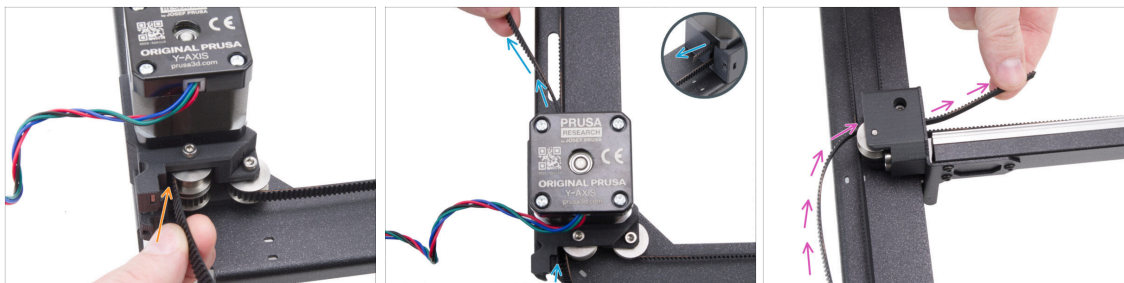
- Pravý konec řemene vedte kolem pravé horní řemenice.
- Push the belt through the part and guide it to the front of the CoreXY plate.
- ⚠ **Don't pull too long so you don't pull the whole belt out.** Remember that the other end is loose. The whole process would then have to be repeated.

KROK 55 X belt guiding: belt tensioner



- Řemen vedte kolem řemenice v napínáku řemene.
- 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.
- ⓘ The belt is secured on this end. You can leave it free for now.

KROK 56 X belt guiding: Y motor mount



- Ted' zpátky k druhému konci řemene osy X.
- 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.
- Route the belt around the upper front pulley in the linear rail holder.

KROK 57 X belt guiding: securing the belt



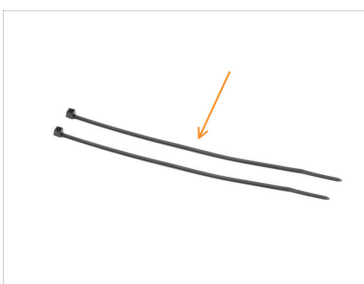
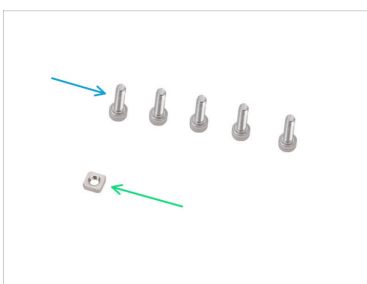
- Zasuňte konec řemene prostředním otvorem do levého otvoru v horní řadě držáku Nextruderu - nechte 4-5 zubů vyčnívat.

KROK 58 Checking the belt guidance



Před pokračováním přezkontrolujte vedení řemene podle obrázku.

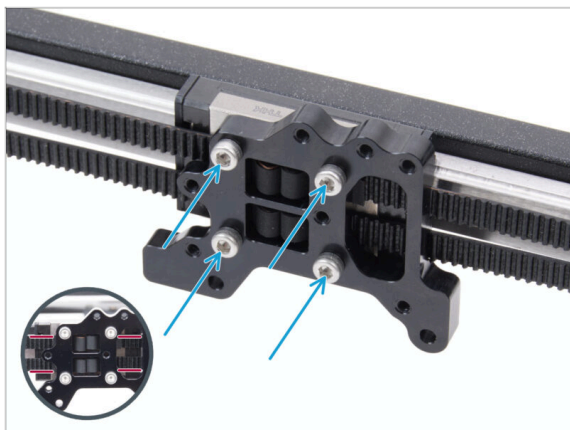
KROK 59 Bowden guide: parts preparation



● Pro následující kroky si prosím připravte:

- Bowden-guide (1x) *found in the Printed parts package*
- Šroub M3x10 (5x)
- Matka M3nS (1x)
- Stahovací páska (2x)

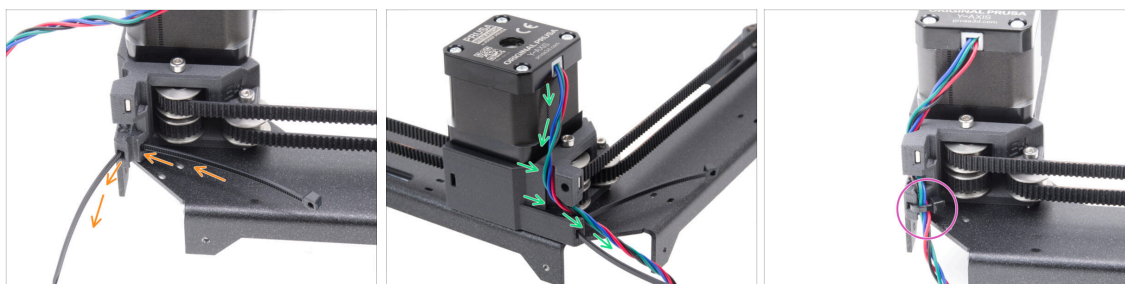
KROK 60 Securing the Nextruder holder



- Přichyťte držák Nextruderu ke carriage lineárního vedení a zajistěte jej pomocí čtyř šroubů M3x10.

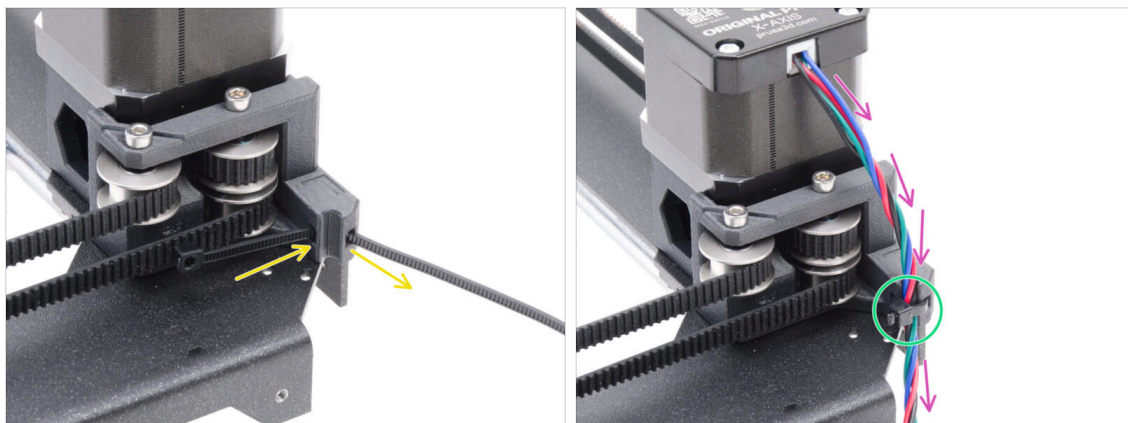
⚠ CAUTION: Ensure no belt obstructs the screw. Avoid screwing through the belt!

KROK 61 Securing the Y motor cable



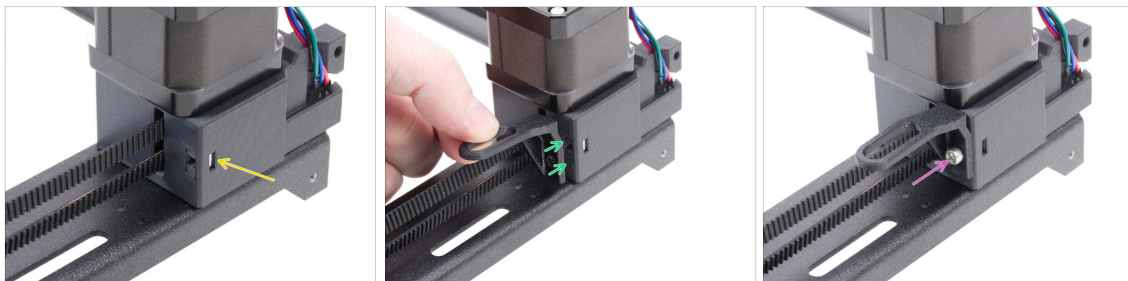
- Protáhněte stahovací pásku skrz díl motor-mount-right.
- Route the Y motor cable through the cable channel in the motor-mount-right and over the zip tie.
- Secure the cable with a zip tie and trim the excess.

KROK 62 Securing the X motor cable



- ✦ Protáhněte stahovací pásku skrz díl motor-mount-left.
- ✦ Route the X motor cable through the cable guide in the motor-mount-left and over the zip tie.
- ✦ Secure the cable with a zip tie and trim the excess.

KROK 63 Installing the bowden guide



- ✦ Vložte matku M3nS do dílu motor-mount-right.
- ✦ Attach the bowden-guide to the motor-mount-right.
- ⚠ Note the correct orientation of the part.
- ✦ Fix the bowden-guide in place using the M3x10 screw.

KROK 64 White LED strip: parts preparation



● Pro následující kroky si prosím připravte:

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

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

ⓘ The part is inserted in a foam cutout and may not be immediately visible at first glance.

● Šroub M3x4rT (2x)

KROK 65 Sticking the White LED strip



● Opatrně odstraňte ochrannou (papírovou) fólii z Bílého LED pásu.

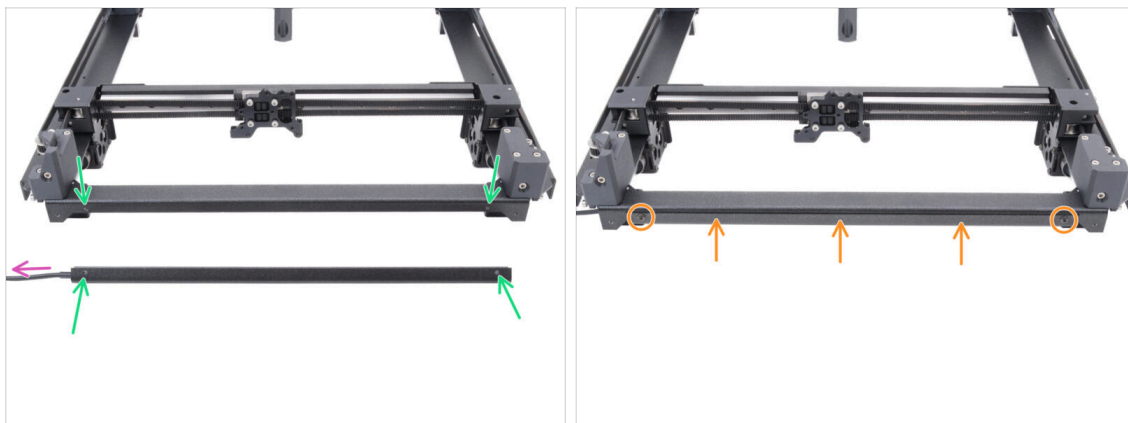
⚠ After removing the protective layer, the LED strip is adhesive.

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

⚠ Note the rectangular cutout on the strut, orient the strip cable to the same side.

● Teď přilepte bílý LED pásek na nosník. Opatrně, rovnoměrně a tak, aby byl kabel LED pásu na konci nosníku s obdélníkovým výřezem.

● Po nalepení lehce zatlačte na prázdná místa pásu, abyste zajistili přilnavost. **Nedotýkejte se LED diod a rezistorů!**

KROK 66 Installing the white LED assembly

- Vezměte sestavu bílé LED a připevněte ji na přední stranu sestavy CoreXY. Zarovnejte otvory obou dílů.
- **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.

KROK 67 Door sensor & White LED strip: parts preparation

- **Pro následující kroky si prosím připravte:**
- Door sensor (1x) *found in Electronics and fasteners package*
- M2.5x10 screw (1x) *silver*
- Stahovací páska (4x)

KROK 68 Inserting the zip ties



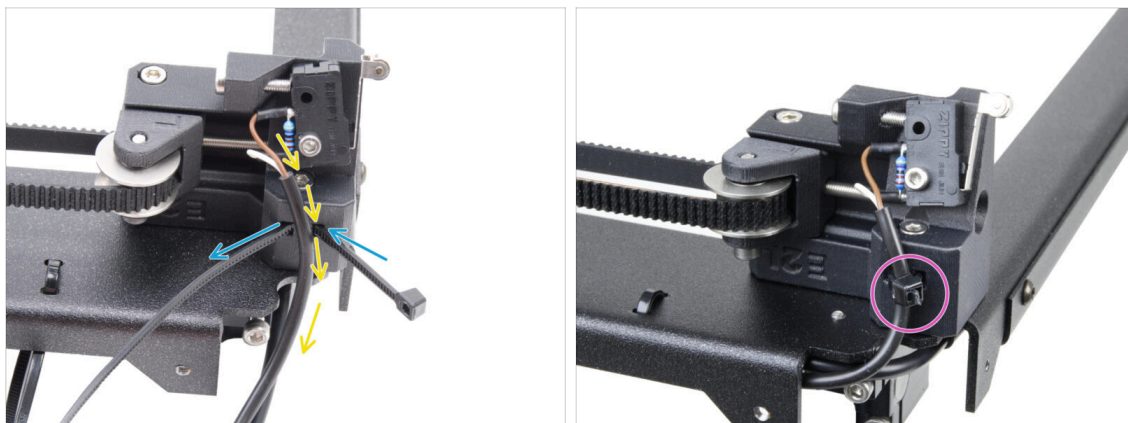
- 🔵 Otočte sestavu CoreXY vzhůru nohama a opřete ji o motory.
- 🟡 Position it with the white LED strip cable facing toward you.
- 🟠 Thread three zip ties through the CoreXY plate, ensuring the zip tie heads point inward. **Make sure that the zip ties do not catch the belts from the other side.**
- 🟢 Partially tighten the zip ties—just enough to catch the first few teeth.
- ⚠️ **Ještě je plně nedotahujte, protože jimi budeme později vést kabely.**
- ⬛ Celou sestavu si otočte zase zpátky, tak aby motory směřovaly nahoru.

KROK 69 Installing the door sensor



- 🟡 Umístěte senzor dvířek na levý napínák řemene. Páčka senzoru musí směřovat dopředu.
- 🟡 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.
- 🔵 From the rear of the belt tensioner, tighten the M3x12 screw so that it touches the door sensor.

KROK 70 Securing the door sensor cable



- ◆ Stahovací pásku prostrčte otvorem v levém napínáku řemene.
- ◆ Guide the door sensor cable through the zip tie.
- ◆ Tighten the zip tie to secure the door sensor cable. Cut off the excess.

KROK 71 Guiding the cables: LED and door sensor



- ◆ Připravte si kartonovou krabici. Můžete použít jakoukoli krabici ze sady. *Krabice použitá na obrázku je pouze ilustrační.*
- ◆ 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.**
- ◆ Ved'te kabel bílého LED pásu a kabel senzoru dvířek skrz stahovací pásky.
- ◆ Utáhněte všechny stahovací pásky a zajistěte kabely. Odřízněte přebytečné části pásek.
- ⓘ **If you plan on adding the Buddy camera, do not tighten the zip ties all the way.** As you will be adding another USB-C cable to the zip ties soon.
- ◆ **Cables must be slightly taut and straight.** Excess slack or bends may cause collisions with the Y-axis and lead to damage.

KROK 72 Poznámka k Buddy3D kameře



- ◆ Pouze pro budoucí uživatele kamery Buddy3D. **Pokud instalaci kamery neplánujete, tento krok přeskočte.**

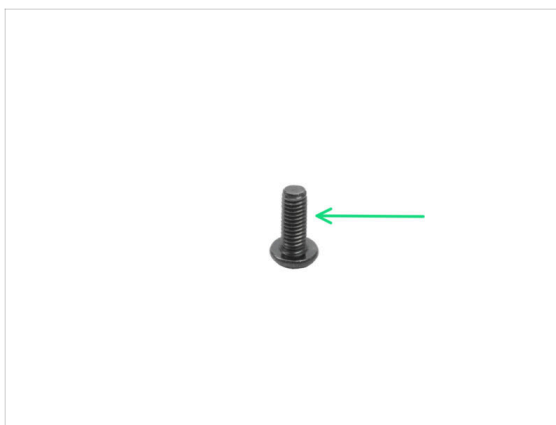
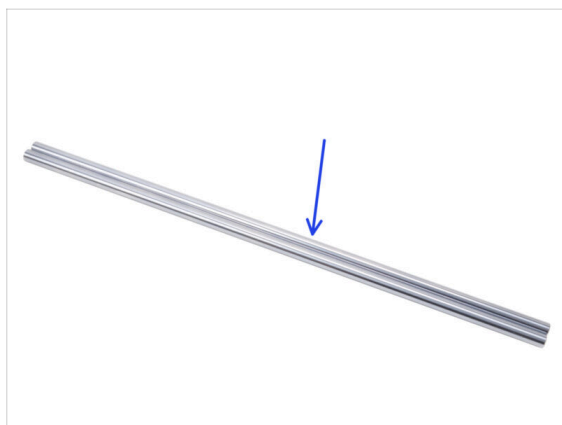
⚠ **Disclaimer:** Typically, the printer must be fully assembled and tested before any add-ons can be installed. Choosing to install the Buddy3D Camera USB cable now will save you time later on.



For detailed information on cable placement, refer to the separate guide **Buddy3D Camera for CORE One Installation**

- ◆ The above-mentioned guide on how to install the Buddy3D Camera shows the printer in a further stage of assembly.
- ◆ V tuto chvíli použijte návod, abyste zkontrolovali, že jsou kabely nainstalovány správně a utáhněte stahovací pásky.
- ⓘ Dáme vám vědět později, kdy se k tomuto návodu vrátit a dokončit instalaci kamery Buddy.

KROK 73 Smooth rods: parts preparation



- ◆ **Pro následující kroky si prosím připravte:**
- ◆ Smooth rod 330 x 8 mm (2x) *found in the Rods box*
- ◆ Šroub M3x8rT (1x)

KROK 74 Installing the CoreXY assembly



- Obě hladké tyče opatrně zasuňte do ložisek na sestavě vyhřívané podložky, skrz a dále do držáků tyčí v základní sestavě.

⚠ 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.

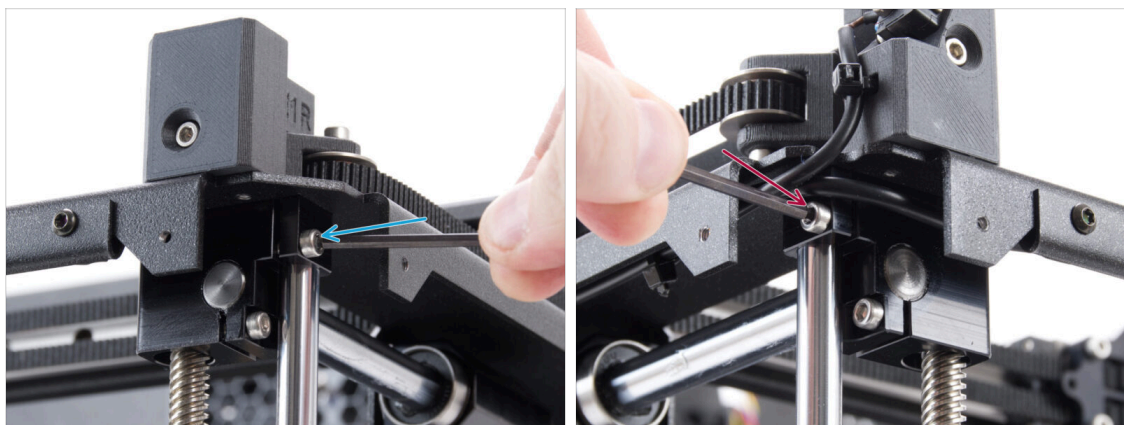
⚠ Ujistěte se, že nejsou kabely skřípnuté.

- Zkontrolujte, zda jsou obě hladké tyče správně usazeny v držácích tyčí.

- 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.

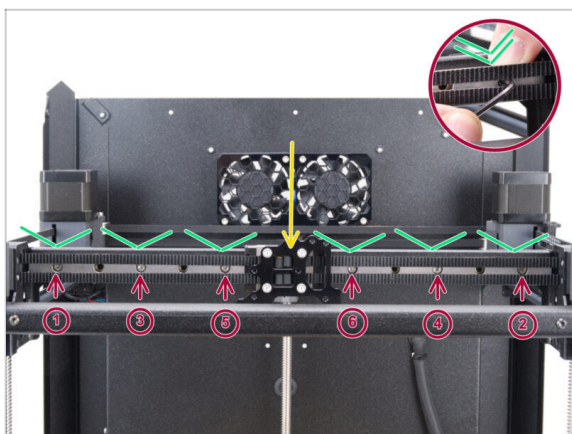
KROK 75 Securing the smooth rods



⚠ Zkontrolujte, že jsou obě hlazené tyče správně usazeny v držácích.

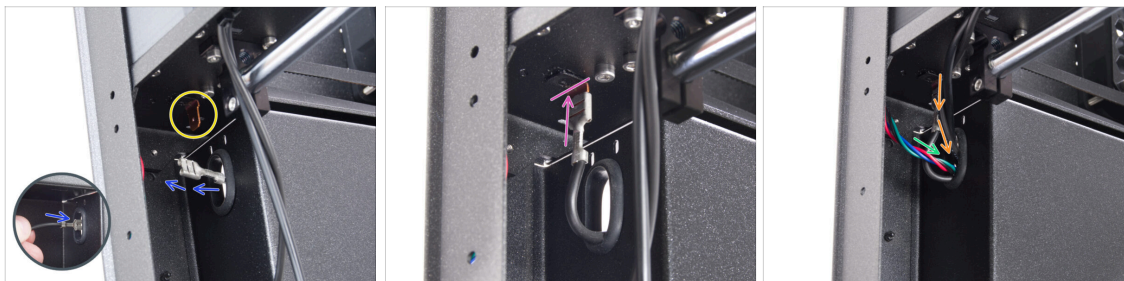
- Firmly tighten the right M3x10 screw to secure the smooth rod.
- Firmly tighten the left M3x10 screw to secure the smooth rod.

KROK 76 Aligning the linear rail



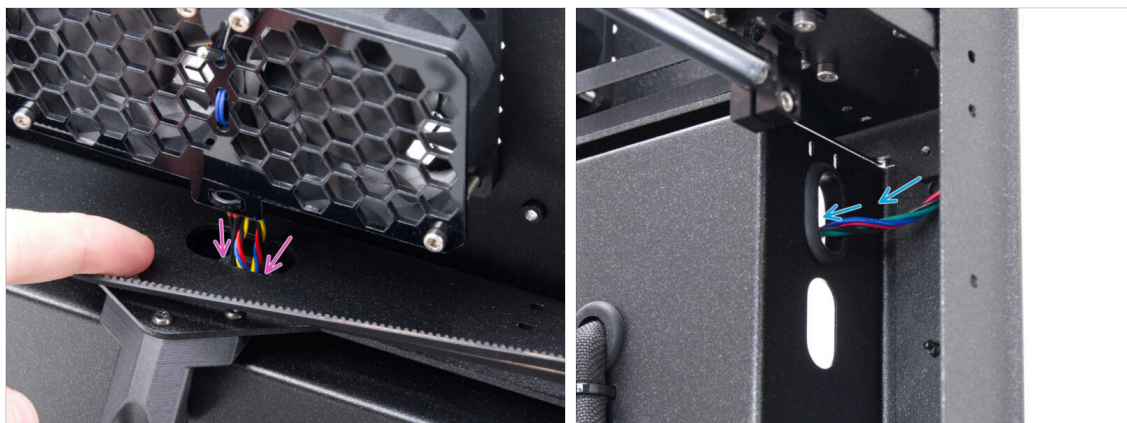
- ✦ Přesuněte si carriage lineárního vedení na střed.
- ⚠ **Firmly tighten all screws in the order shown in the picture.**
- ✦ Push the linear rail down while tightening.

KROK 77 Guiding the corexy cables



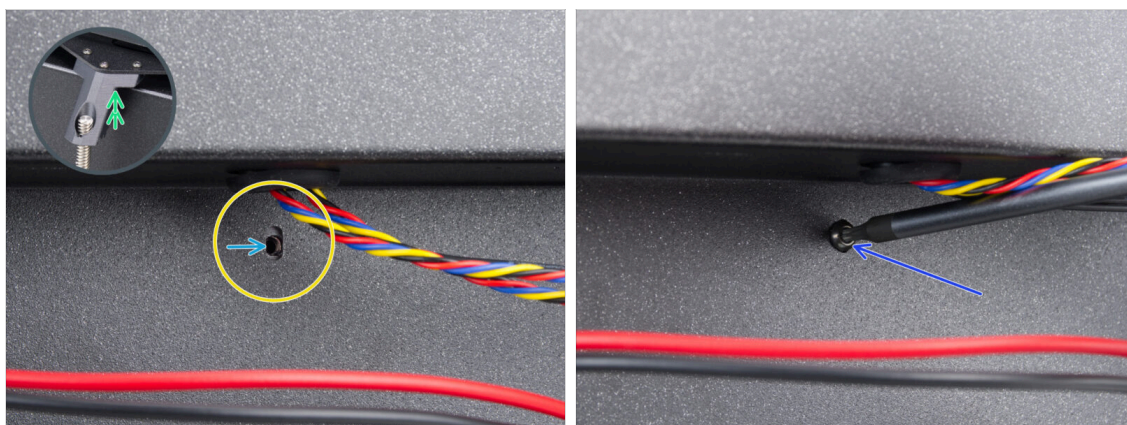
- ✦ Ze zadní strany tiskárny prostrčte konektor FE oválným otvorem.
- ✦ Locate the FE cable connector (number 5) in the rear left corner - under the CoreXY assembly.
- ✦ Plug the FE connector onto the Faston on the underside of the CoreXY plate.
- ✦ On the same side, push the X motor cable through the oval hole in the back panel.
- ✦ Protáhněte kabely bílého LED pásku a senzoru dvířek oválným otvorem v zadním panelu.

KROK 78 Guiding the cooling fan cables



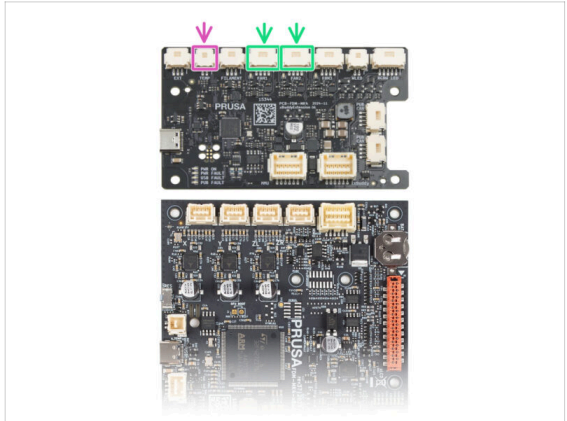
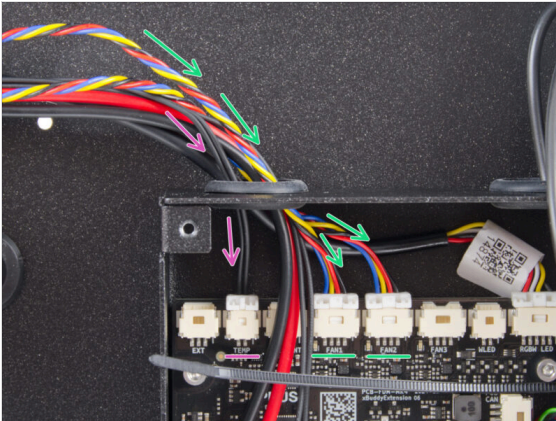
- ✿ Protáhněte kabely ventilátoru chlazení a termistoru oválným otvorem v zadním panelu.
- 🔵 On the right back corner, locate the Y motor cable and push it through the upper oval hole in the back panel.

KROK 79 Zajištění zarážky podložky (bed-stop)



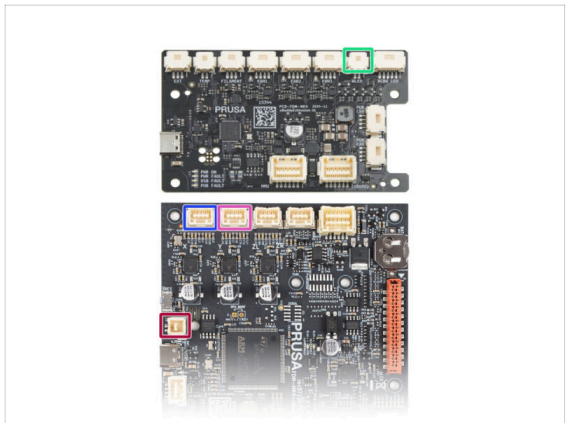
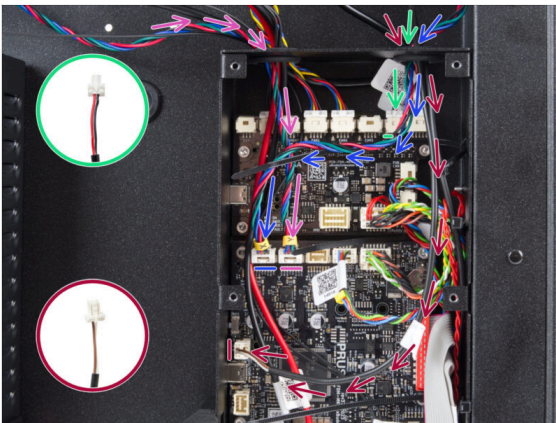
- 🟡 Na zadní straně najdete oválný otvor pro šroub pod chladicími ventilátory.
- 🔵 The oval hole must be flush with the hole in the bed-stop part on the opposite side.
- 🟢 To compensate, slightly raise the rear of the CoreXY assembly - just a few millimeters.
- 🟡 After aligning the holes, secure them with an M3x8rT screw.

KROK 80 Connecting the cooling fans cables



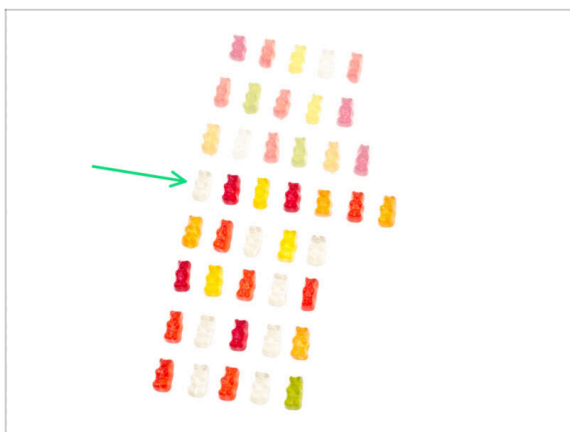
- Protáhněte kabely chladicího ventilátoru levým otvorem v krabici xBuddy a zapojte je do čtvrtého a pátého slotu na rozšiřující desce xBuddy označených jako FAN 1 a FAN 2.
- ❗ The connection order does not matter, both cables are the same.
- Guide the chamber thermistor cable together with the cooling fan cables.
- Connect it to the second slot from the left on the xBuddy extension board labeled TEMP.

KROK 81 Connecting the corexy cables



- Ved'te kabel motoru osy X pravým otvorem v krabici xBuddy. Připojte jej do prvního slotu zleva na desce xBuddy.
- 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.

KROK 82 Je čas na Haribo!



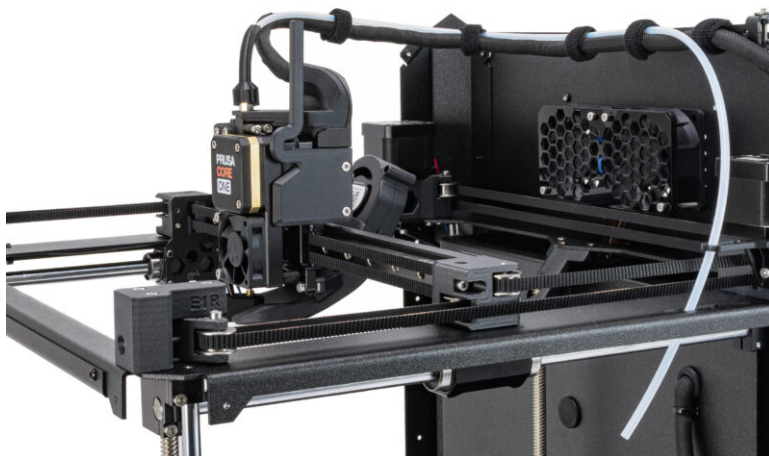
- Myslím, že je zase čas na svačinu.
- You deserve to eat the whole bag, but keep... Eat just the fourth row.

KROK 83 Hotovo

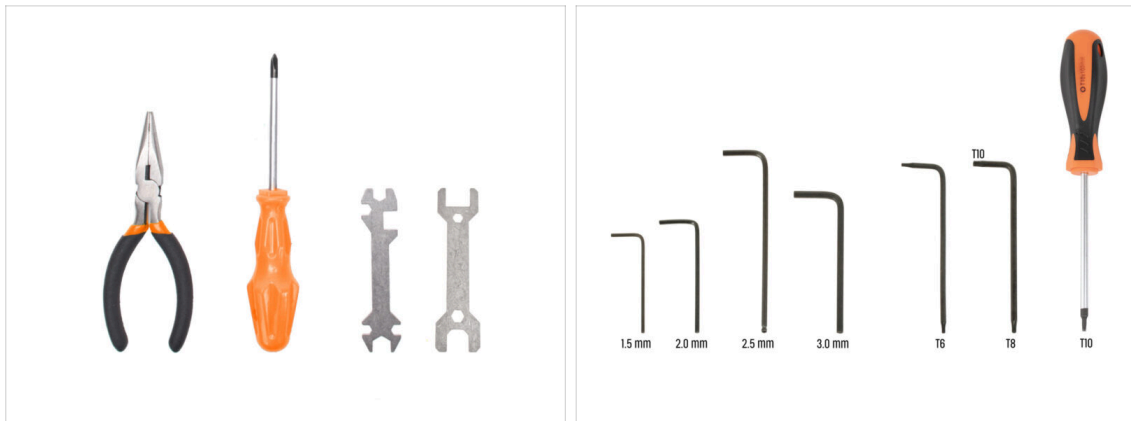


- Gratulujeme! Právě jste sestavili a nainstalovali sestavu CoreXY.
- Let's go to the next chapter.

6. Montáž Nextruderu



KROK 1 Tool necessary for this chapter



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

- Univerzální klíč
- 1,5mm inbusový klíč
- 2,5mm inbusový klíč
- T6 Torx klíč
- Klíč T10 torx / Šroubovák T10 torx

KROK 2 Nextruder idler assembly: parts preparation



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

- Idler-lever-a (1x) *found in the Electronics package*
- 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*
- Šroub M3x6 (1x)
- Váleček 13,2x3,8x0,35 (1x) *naleznete v balíčku Electronics*

KROK 3 Assembling the extruder idler

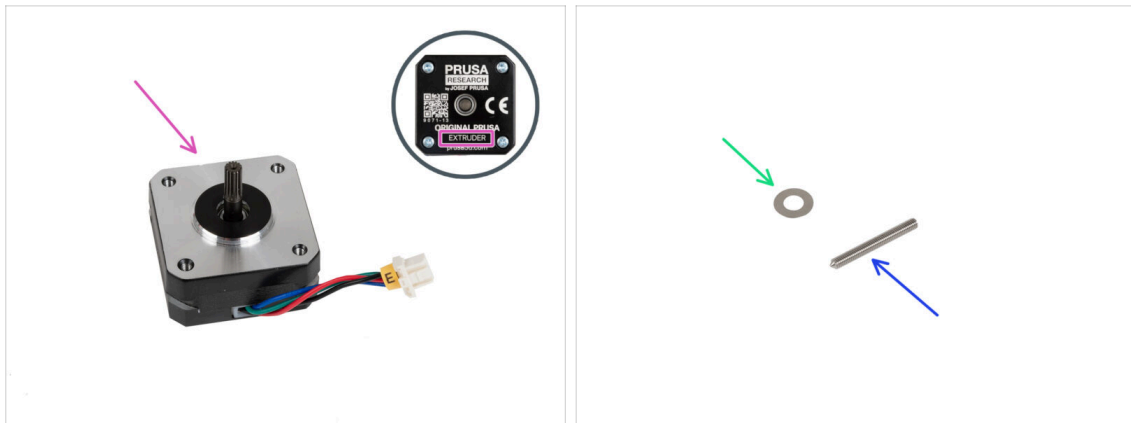


- Place both bearings into the Idler-lever-a.
- Insert the pin 2.9x8.5 into each bearing 693 2RS, as seen in the picture.
- Close it up with the Idler-lever-b part and secure it with the M3x6 screw. **Do not overtighten the screw.** Both bearings must be able to rotate without significant resistance.
- 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.

KROK 4 Assembling the extruder: parts preparation I.



- **For the following steps, please prepare:**
- PG-assembly (1x) *found in the Electronics package*
- 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) *naleznete v balíčku Electronics*
- ① Seznam pokračuje v dalším kroku...

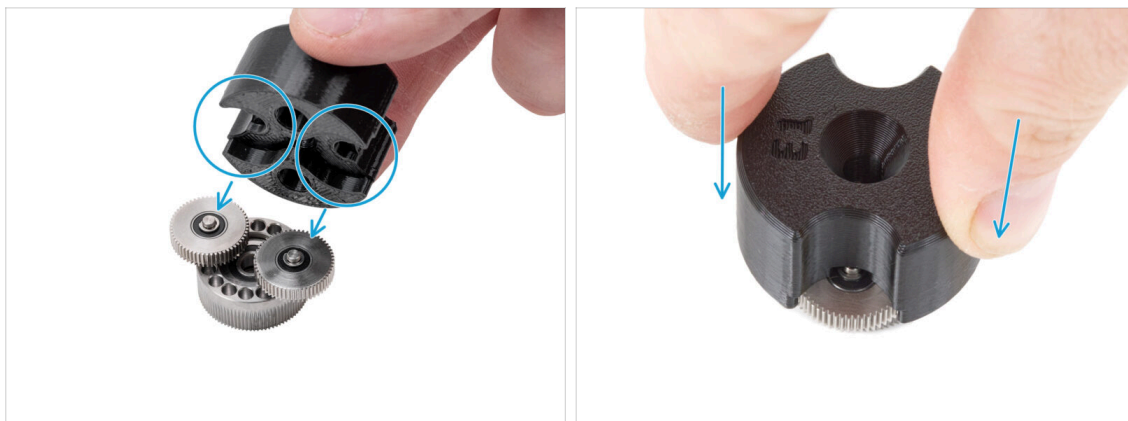
KROK 5 Assembling the extruder: parts preparation II.

- ◆ Extruder motor (1x) *found in the Motors package*
- ◆ Spacer 5x10x0.1 mm (1x) *found in the Electronics package*
- ◆ Socket set screw M3x25 (1x) *found in the Electronics & Fasteners package*

KROK 6 Sestavení extruderu

- ◆ Place the 5x10x0.1 spacer over the shaft on the extruder motor.
 - ◆ Place the heatsink on the extruder motor. Note the orientation of both parts.
 - ◆ 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.
- ⚠ **Než přejdete k dalšímu kroku, ujistěte se, že je na motoru extruderu umístěna distanční podložka 5x10x0,1.**

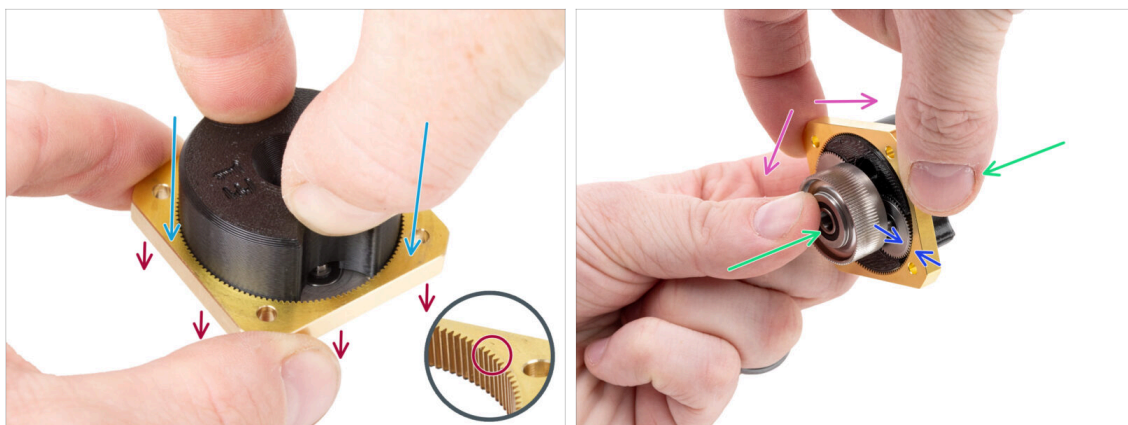
KROK 7 Sestavení převodovky



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

- After watching the video, follow the steps in this guide.
- Attach the PG-assembly-adapter on the PG-assembly. Note the pockets for the gears in the adapter.

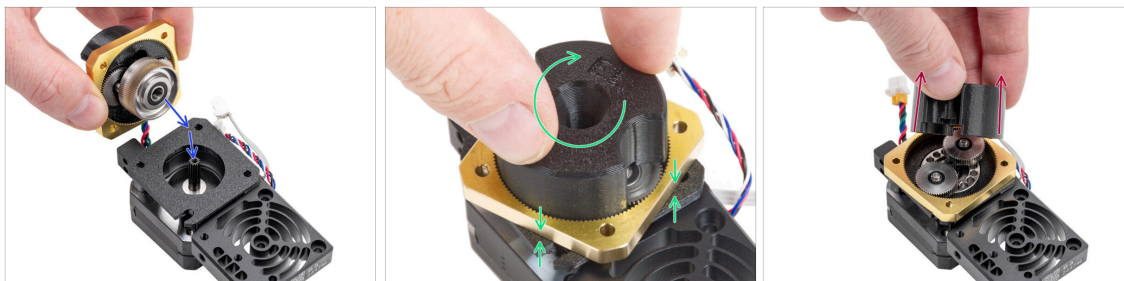
KROK 8 Sestavení dílu PG-ring



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

- Slide the PG-ring onto the adapter.
- 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.
- Zastavte, když jsou povrchy ozubených kol v jedné rovině s povrchem dílu PG-ring.

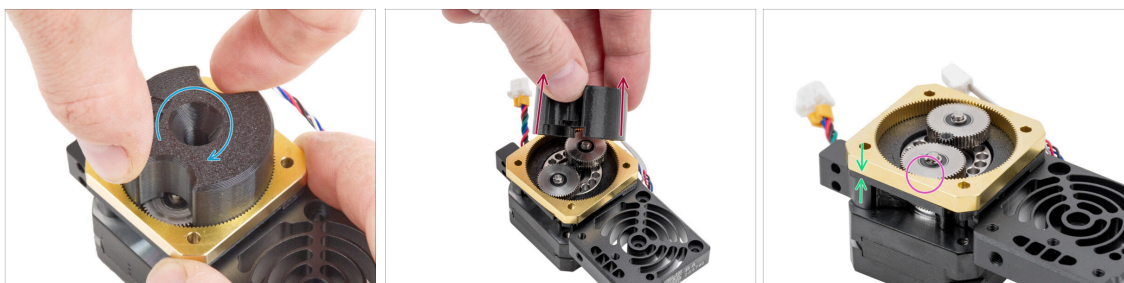
KROK 9 Montáž PG-assembly



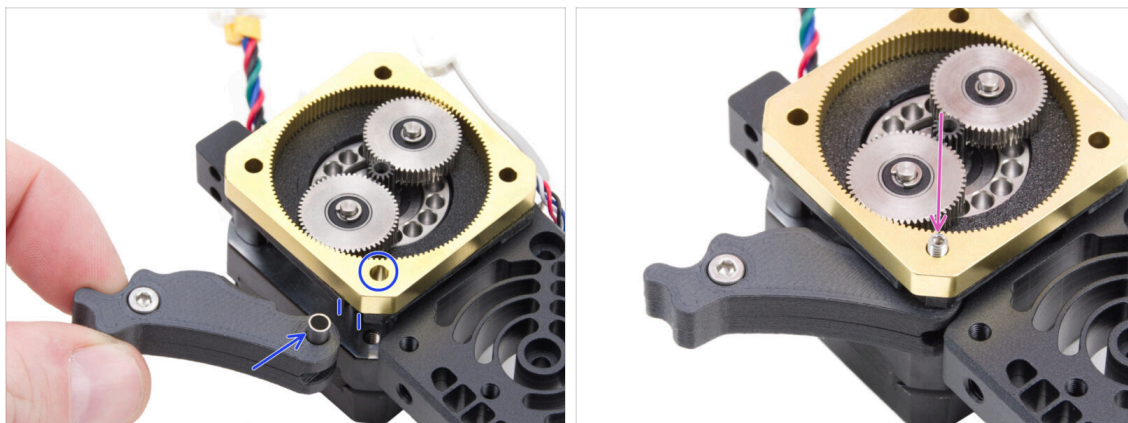
⚠ **Proceed very carefully in this step.**

- Maintain the position of the PG-assembly and attach it on to extruder motor shaft.
- 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.**
- Odstraňte PG-assembly-adapter.

KROK 10 Kontrola PG-assembly



- Attach the PG-assembly-adapter back on the PG-assembly again to verify that all parts are properly seated.
- Rotate with the PG-assembly-adapter. **The PG assembly must be easy to rotate without having to exert much 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.

KROK 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.
- Secure both parts with the socket set screw 3x25. **Do not overtighten the screw! The screw protrudes from the PG-ring after tightening.**

KROK 12 Gear lubrication: parts preparation

- **For the following steps, please prepare:**
- Front Case (1x) *found in the Printed parts package*
 - ⓘ Logo na předním krytu Nextruderu zůstane **PRUSA CORE ONE**.
- Šroub M3x25 (3x)
- Lubricant (1x) *found in the Electronics & Fasteners package*
- Několik papírových utěrek k otření maziva a mastnoty.

KROK 13 Mazání převodovky



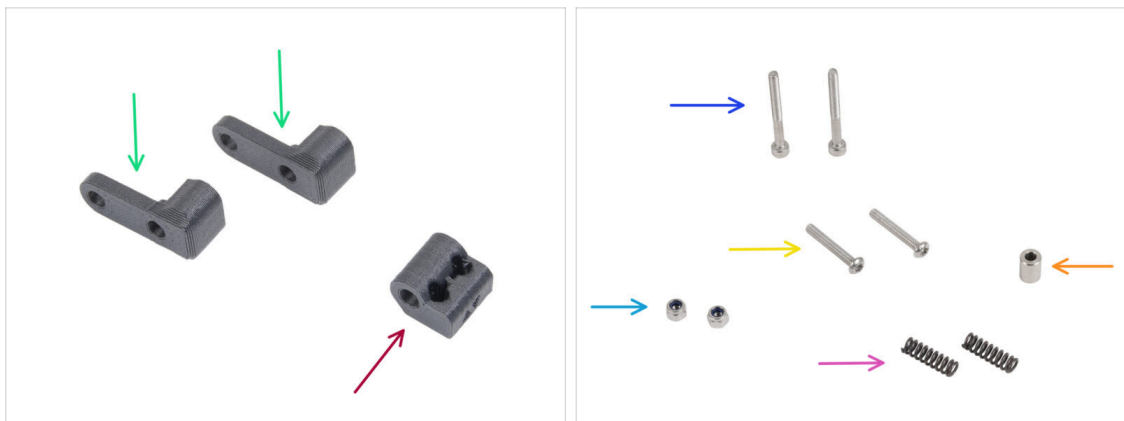
- Remove the cap from the lube. Use the spike on the opposite side of the cap to pierce a hole in the lube tube opening.
- Naneste malé množství maziva na špičku stahovací pásky a poté jej rozetřete po ozubených kolech.
- Apply a small amount of Prusa Lubricant **all around** the PG-ring and PG-assembly teeth.
- Close the lubricant; it is no longer needed for the assembly.

KROK 14 Covering the planetary gear



- Using the paper towel, wipe off the lubricant residue from the face surface of the PG-ring.
- Place the front case onto the gearbox and secure it with three M3x25 screws. **Do not tighten them completely** at this moment.
- ① The screws on the front case will be completely tightened during the self-test in the final chapter.

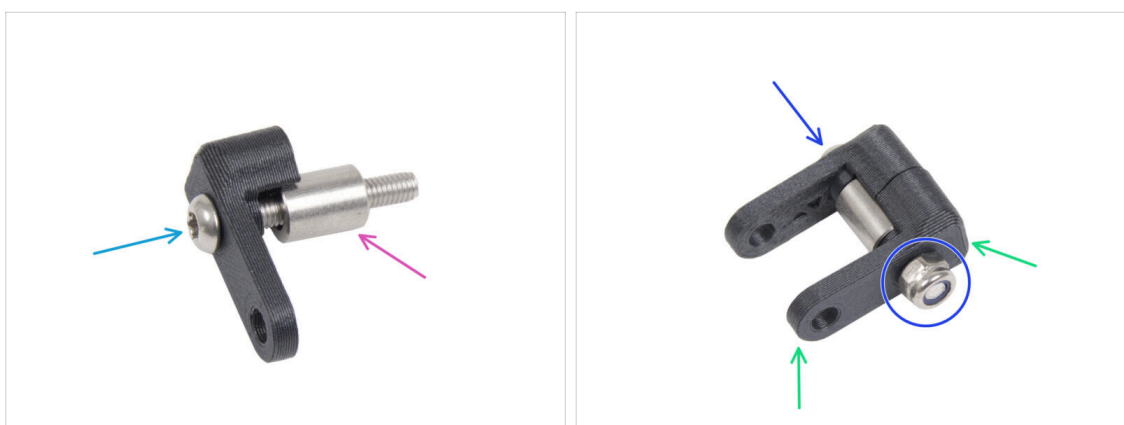
KROK 15 Assembling the Idler-swivel: parts preparation



● For the following steps, please prepare:

- Idler-swivel (2x) found in the *Electronics package*
- Idler-nut (1x) found in the *Electronics package*
- Šroub M3x30 (2x)
- Šroub M3x20rT (2x)
- Matka M3nN (2x)
- Pružina 15x5 (2x) *naleznete v balíčku Electronics*
- Podložka 6x3,1x8 (1x) *naleznete v balíčku Electronics*

KROK 16 Sestavení přítlačné záklopky Idleru (Idler-swivel)



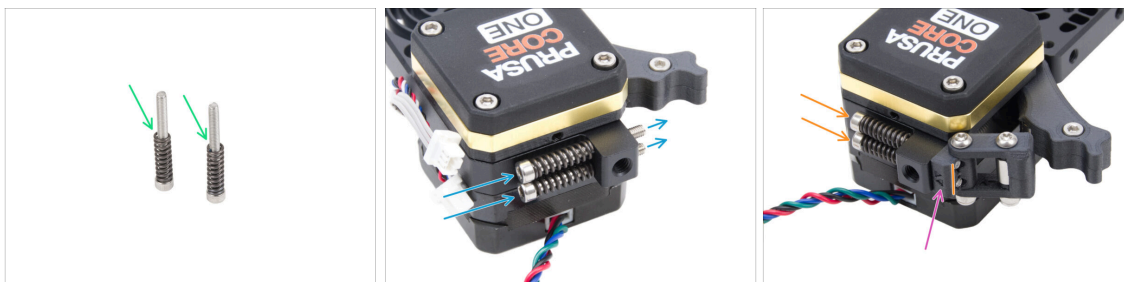
- Push the M3x20rT screw all the way through one of the idler-swivel.
- Slide the spacer onto the screw.
- Place the second idler-swivel from the opposite side on the screw.
- From the other side, attach the M3nN nut onto the screw. Hold the nut using the universal wrench and tighten the screw. **Tighten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

KROK 17 Montáž dílu Idler-nut



- ✚ Insert the Idler-nut into the Idler-swivel assembly. Make sure that both parts are oriented correctly according to the picture.
- ✚ Secure both parts together by inserting the M3x20rT screw from the same side, like the first screw.
- ✚ 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.

KROK 18 Mounting the Idler-swivel assembly



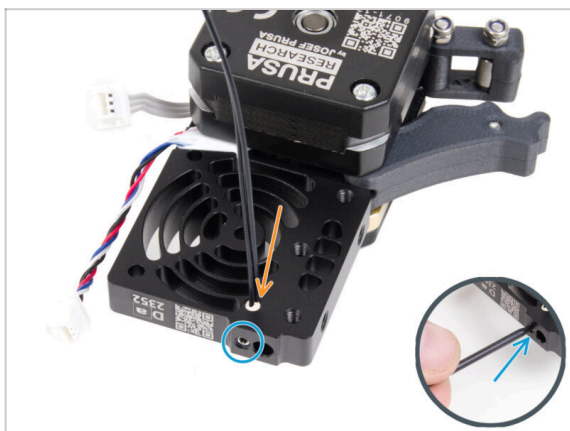
- ✚ Attach the spring 15x5 on both M3x30 screws.
- ✚ Push the two screws with the springs through the holes in the protrusion on the heatsink. There are no threads inside.
- ✚ Na šrouby připevněte sestavu Idler-swivel. Podívejte se na správnou orientaci dílu Idler-nut. Strana se dvěma tečkami musí být viditelná. Viz obrázek.
- ✚ Tighten both screws. **Stop tightening as soon as the screw tips reach the front face of the idler nut.**

KROK 19 NTC thermistor: parts preparation



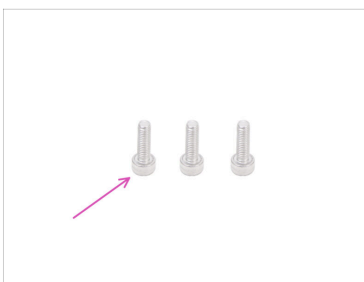
- For the following steps, please prepare:
- NTC thermistor 90 mm (1x) found in the *Electronics* package
- M3x4T grub screw (1x)

KROK 20 Assembling the NTC thermistor



- On the **extruder motor side**, insert the NTC thermistor into the hole in the heatsink.
- Secure it with the M3x4T grub screw. Screw it all the way in. **Tighten gently, but firmly** using two fingers and the short side of the T6 Torx key. Applying more force may cause permanent damage to the thread.

KROK 21 Mounting the Nextruder: parts preparation



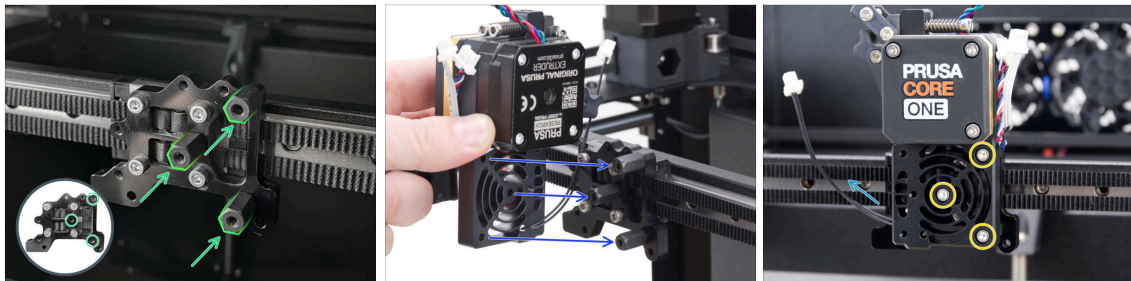
- For the following steps, please prepare:
- Nextruder spacer (3x) found in the *Electronics & Fasteners* package
- Šroub M3x10 (3x)
- Cardboard box (1x) used as temporary heatbed protection
- ⓘ Hint: You can use any cardboard box from the kit package.

KROK 22 Ochrana vyhřívané podložky



- Place an empty cardboard box on the heatbed, ensuring it covers as much of the surface as possible.
- i** This will protect the heatbed from falling parts.

KROK 23 Montáž Nextruderu



- Screw three Nextruder spacers to the Nextruder holder. Tighten the spacers firmly.
- Place the Nextruder assembly on the spacers.
- 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.

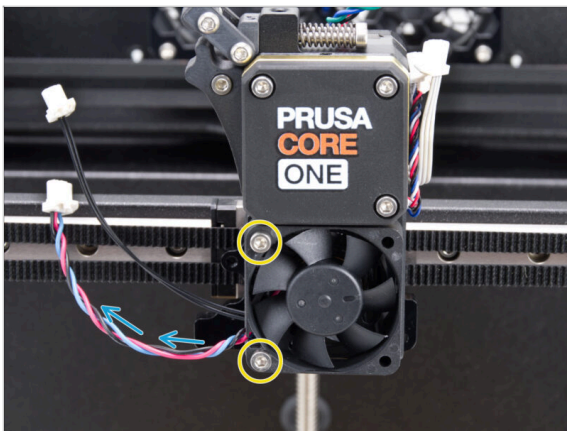
KROK 24 Ventilátor hotendu: příprava dílů



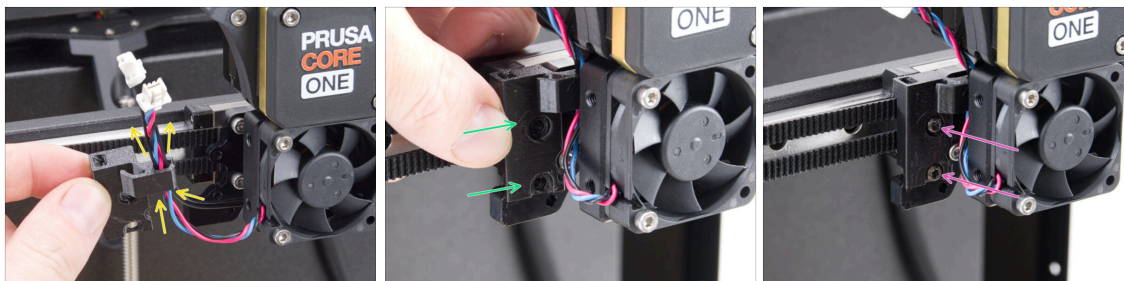
For the following steps, please prepare:

- Hotend fan (1x) found in the Electronics package
- Hotend-cable-clip (1x) found in the Printed parts package
- Šroub M3x4rT (2x)
- Šroub M3x18 (2x)

KROK 25 Montáž ventilátoru hotendu



- 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.

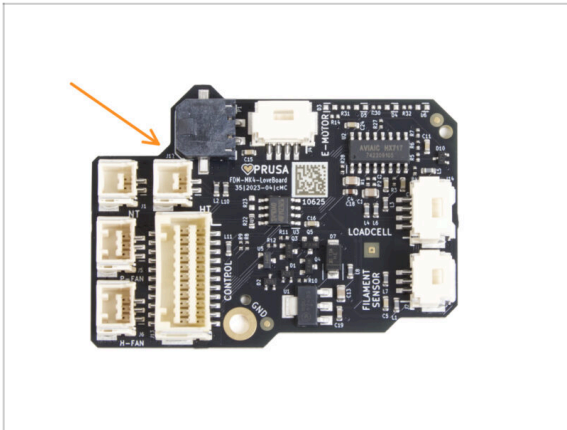
KROK 26 Vedení kabelu ventilátoru hotendu.

- ✦ 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.

KROK 27 LoveBoard: parts preparation I.

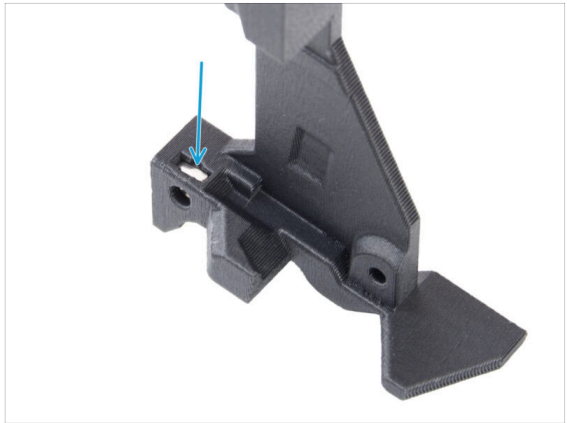
- ✦ **For the following steps, please prepare:**
 - ✦ Printhead-cover (1x) *found in the Printed parts package*
 - ✦ Loveboard-mount (1x) *found in the Printed parts package*
 - ✦ Main cable (1x) *found in the Electronics & Fasteners package*
- ⓘ Note: Cable color may vary depending on the batch. This does not affect the procedure.
- ✦ Šroub M3x10 (4x)
- ✦ Šroub M3x8rT (1x)
- ✦ Matka M3nS (5x)
- ⓘ Seznam pokračuje v dalším kroku...

KROK 28 LoveBoard: parts preparation II.



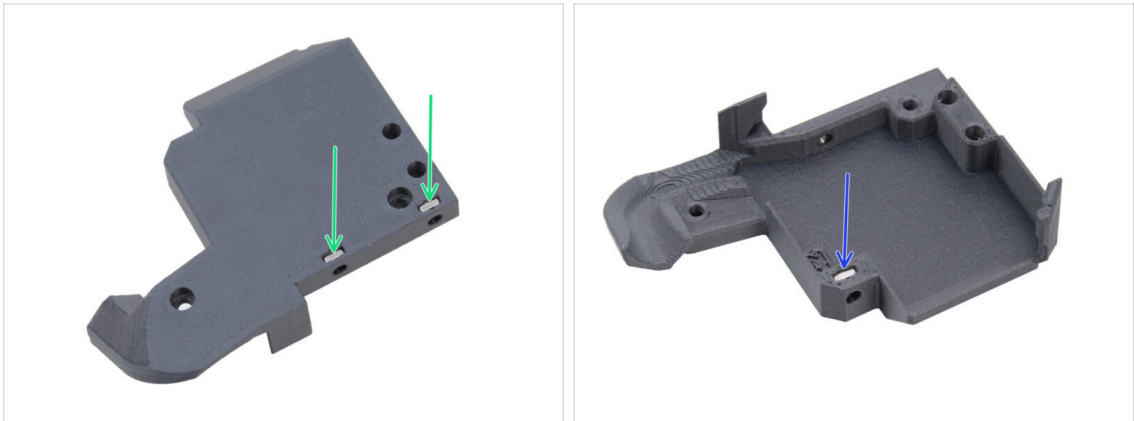
- For the following steps, please prepare:
- LoveBoard (1x) found in the Electronics package

KROK 29 Sestavení Loveboard-mount



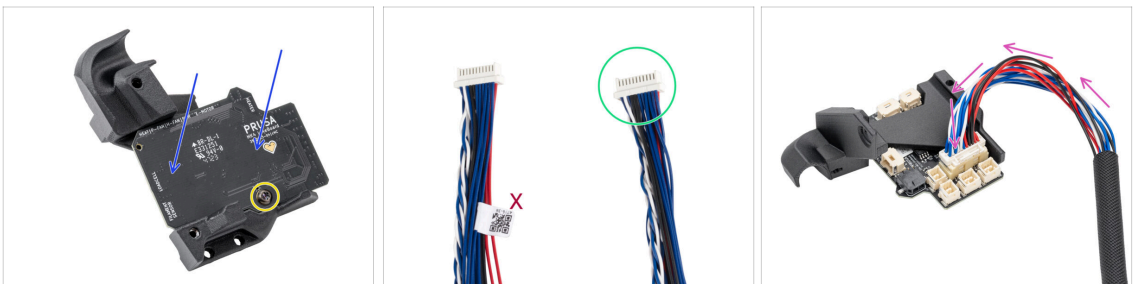
- Locate the U-shaped cable channel on the Loveboard-mount and insert an M3nS nut into the nearby hole.
- Use a 2.5mm Allen key to push the nut all the way in.
- On the opposite side of the part, insert an M3nS nut and push it into place.

KROK 30 Sestavení Printhead-cover (krytu tiskové hlavy)



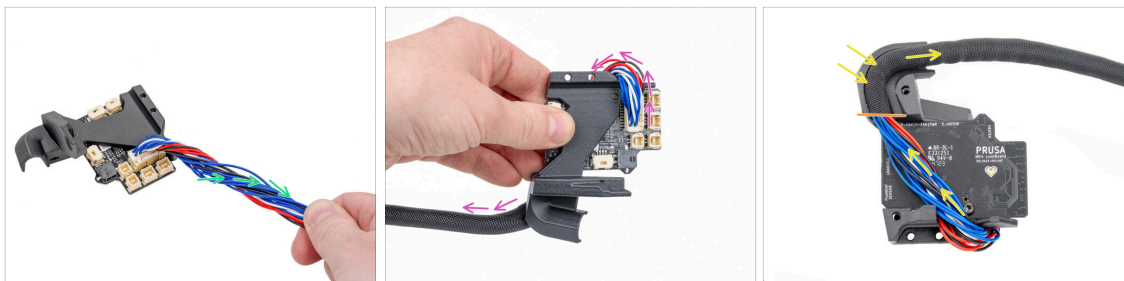
- 🟢 From the back of the printhead-cover, insert two M3nS nuts into the part.
- 🟡 From the other side of the printhead-cover, insert one M3nS nut into the part.

KROK 31 Sestavení desky 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.

KROK 32 Vedení hlavního kabelu



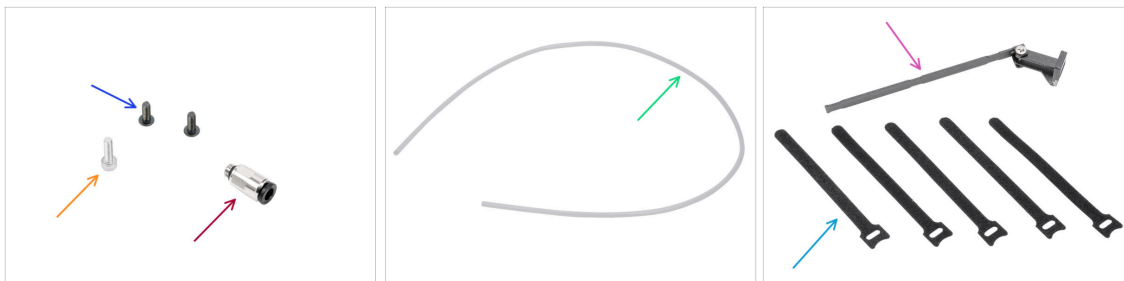
- ✦ Twist the main cable half a turn.
- ✦ Fold the main cable over the LoveBoard to its opposite side.
- ✦ Turn the LoveBoard assembly upside down.
- ✦ Guide the main cable over the LoveBoard through the cable channel in the Loveboard-mount.
- ✦ Konec textilního rukávu musí být zarovnan s okrajem plastového dílu.

KROK 33 Zakrytí desky 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.
- ✦ Zkontrolujte, zda mezi díly není velká mezera nebo skřípnutý textilní rukáv.

KROK 34 Swingarm: parts preparation I.



For the following steps, please prepare:

- Šroub M3x8rT (2x)
- Šroub 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*
- Sestava swingarmu (1x) *naleznete v balení Metal parts 3/3*
- páska na kabely (5x) *naleznete v balíčku Electronics & Fasteners*
- i Baleno dohromady, musí být rozděleno.
- i Seznam pokračuje v dalším kroku...

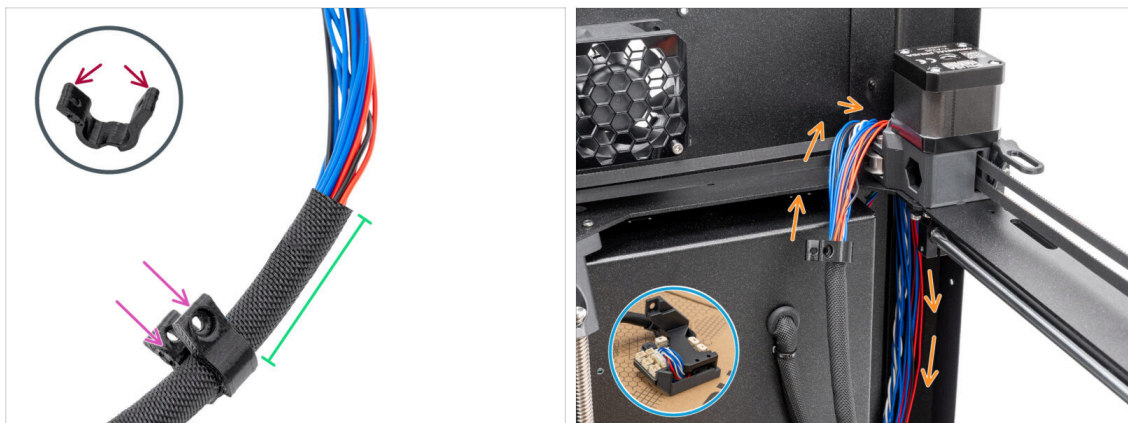
KROK 35 Swingarm: parts preparation II.



For the following steps, please prepare:

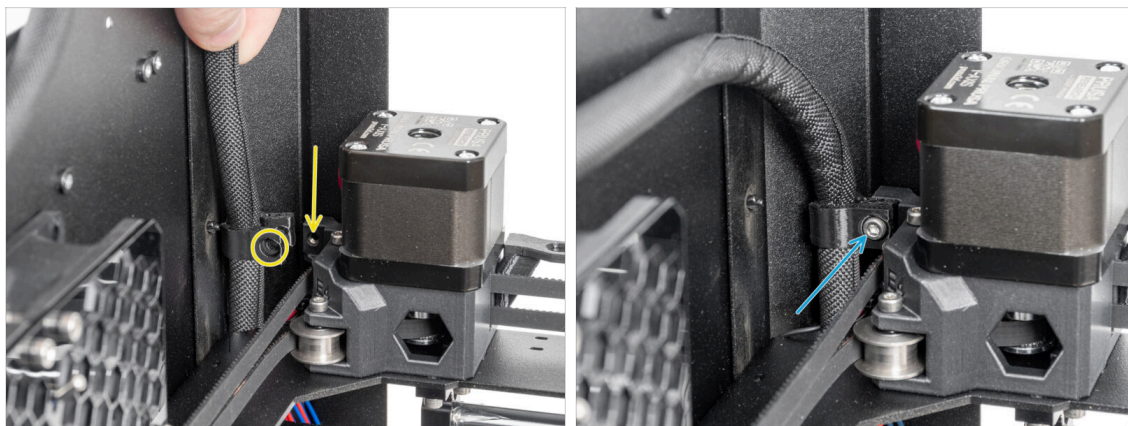
- Bowden-bend (1x) *found in the Printed parts package*
- Main-cable-clip (1x) *found in the Printed parts package*

KROK 36 Vedení hlavního kabelu



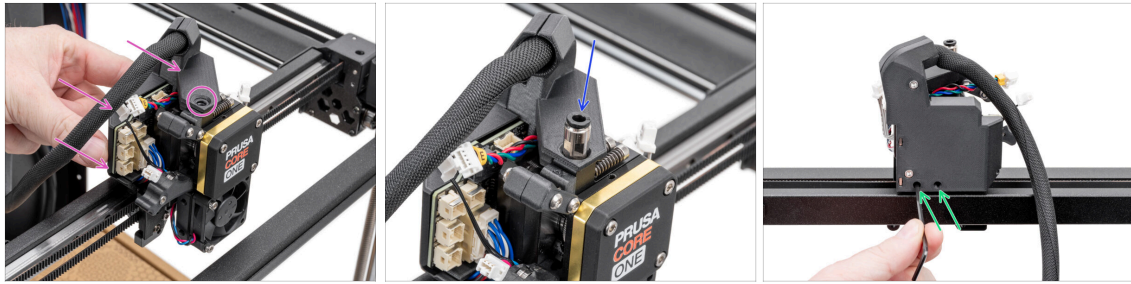
- Carefully open the Main-cable-clip. Be careful not to crack the part.
- Insert the main cable into the Main-cable-clip.
- Umístěte svorku Main-cable-clip přibližně 5 - 15 cm od konce textilního rukávu a svorku zavřete.
- Place the LoveBoard assembly on the cardboard box on the heatbed.
- Push the main cable behind the CoreXY assembly in the right rear corner.

KROK 37 Mounting the main cable



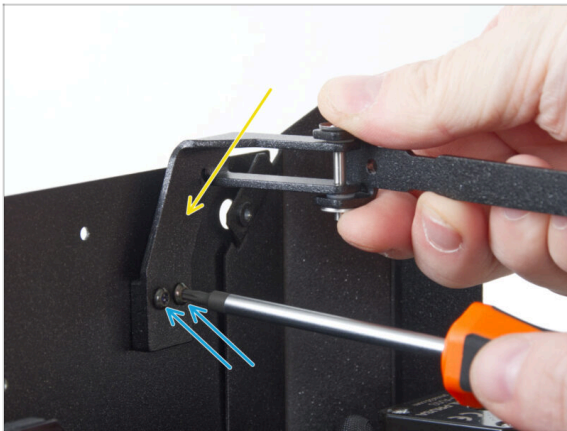
- In the right corner of the printer on the Y motor assembly, locate the hole in the plastic part and align it with the main-cable-clip.
- Fix the main-cable-clip with the cable to the hole using the M3x10 screw.

KROK 38 Attaching the LoveBoard assembly



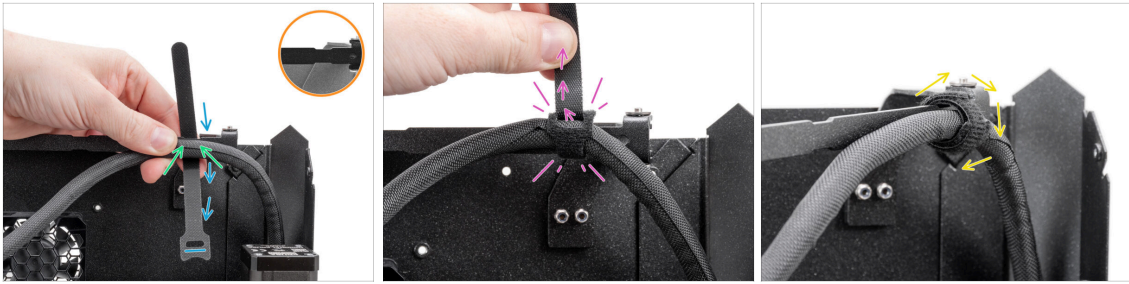
- ◆ From the back of the Nextruder, attach the LoveBoard assembly to the Nextruder.
- ◆ Align the hole in the Loveboard-mount with the threaded hole in the top of the heatsink (Nextruder).
- ◆ Insert and tighten the fitting M5-4 to the heatsink. Use the universal wrench.
- ◆ From the back of the Nextruder,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

KROK 39 Osazení swingarmu



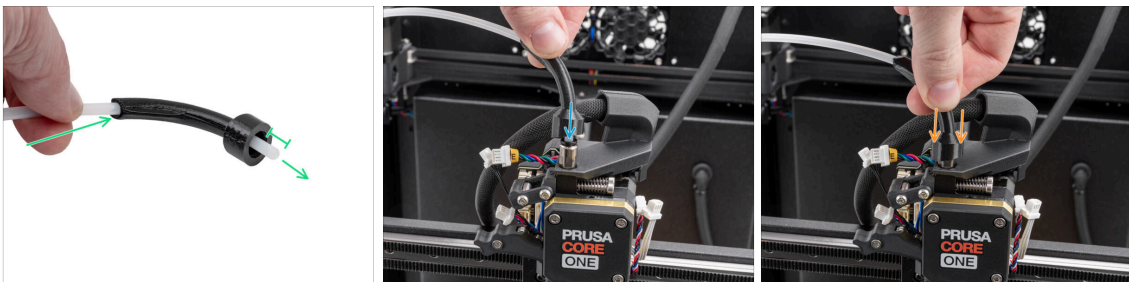
- ◆ Attach the swingarm assembly to the pair of threaded holes on the back panel near the top right corner.
- ◆ Secure it with two M3x8rT screws.
- ⚠ Do not overtighten the screws, as this may strip the threads.

KROK 40 Attaching the main cable



- 🟠 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.
- ⬛ Utáhněte stahovací pásku co nejvíce je to možné.
- 🟡 Omotejte stahovací pásku kolem kabelu.

KROK 41 Inserting the PTFE tube



- 🟢 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.

KROK 42 Securing the PTFE tube



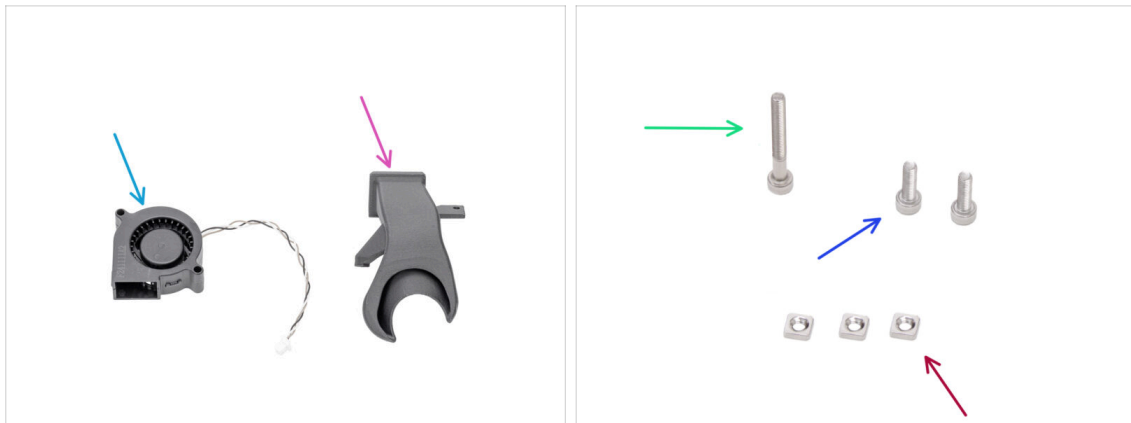
- ◆ Route the PTFE tube in parallel with the main cable, ensuring the PTFE tube stays above the main cable.
- ◆ Secure the PTFE tube and main-cable to the swingarm using two cable ties to the remaining cutouts.
- ⚠ Do not pass the PTFE tube through the first cable tie on the swingarm.
- ◆ Push the free end of the PTFE tube through the Bowden guide and CoreXY plate downward. Leave the end hanging freely.
- ◆ Spojte PTFE trubičku a hlavní kabel zbývajících dvěma kabelovými páskami, přičemž mezi nimi ponechte vzdálenost 10 cm.

KROK 43 Kontrola pohyblivosti



- ◆ 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.
 - ◆ Hlavní kabel nevytváří příliš velký oblouk.
 - ◆ Pokud je kabel příliš napnutý nebo tvoří velký oblouk, mírně povolte šroub na hlavní kabelové sponě a kabel vytáhněte o několik milimetrů nahoru nebo dolů. Poté šroub utáhněte a proveďte další zkoušku.

KROK 44 Print fan: parts preparation



For the following steps, please prepare:

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

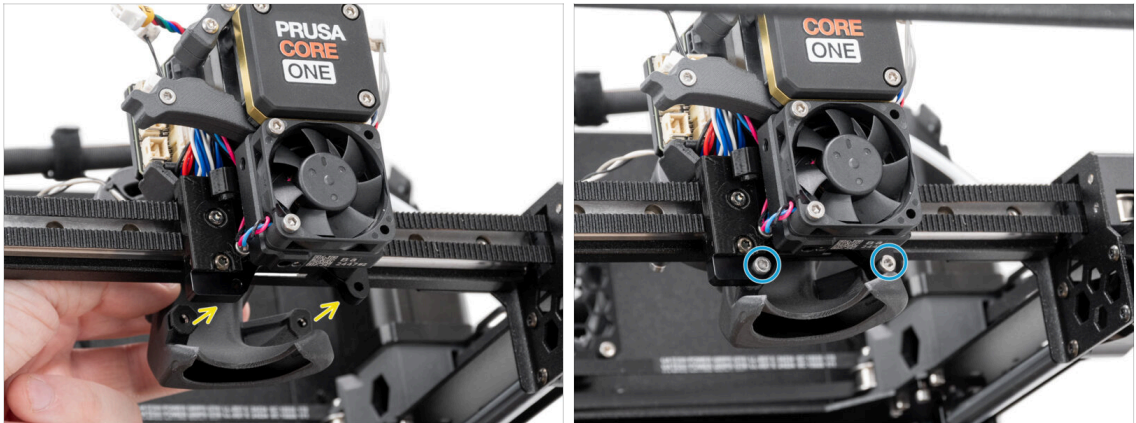
KROK 45 Sestavení dílu fan-shroud



- 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.

⚠ Šrouby příliš neutahujte, aby nedošlo k poškození krytu ventilátoru.

KROK 46 Installing the print fan assembly



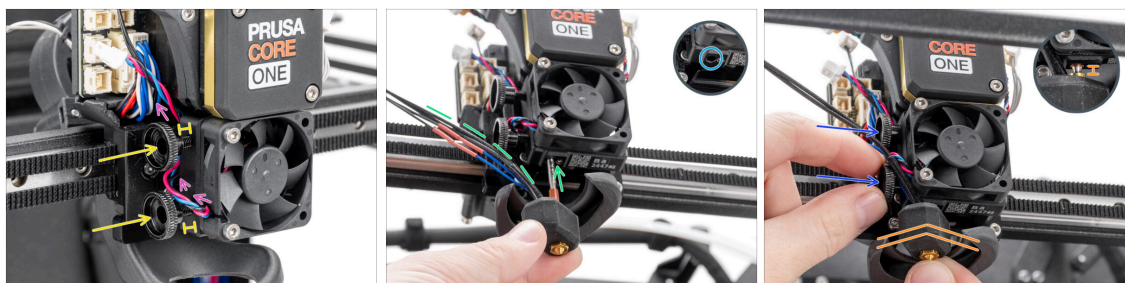
- Attach the print fan assembly to the back of the Nextruder.
- Align the holes in the Nextruder bracket with the holes in the fan-shroud.
- Secure the fan-shroud to the Nextruder holder using two M3x10 screws.

KROK 47 Hotend: Příprava dílů



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

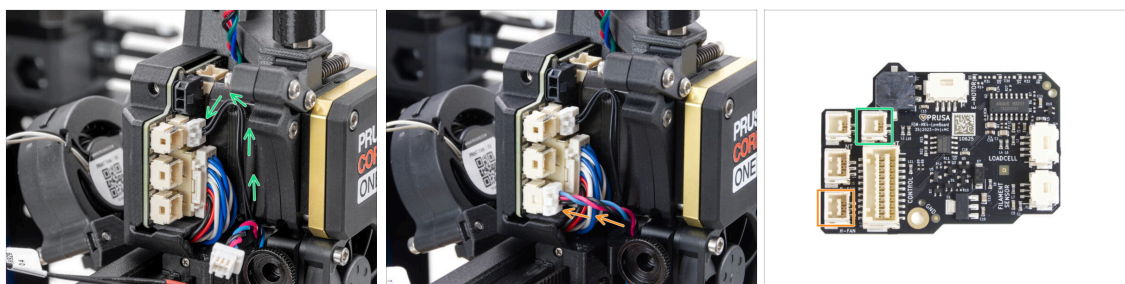
KROK 48 Instalace hotendu



- ✿ 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.
- ✿ Kabely nasměrujte doleva podle fotografie.
- ✿ Zasuňte sestavu hotendu až na doraz do chladiče. Mezi chladičem a mosaznou částí trysky by měla být přibližně 2mm mezera.
- ✿ Zatlačte sestavu hotendu dovnitř a **pevně utáhněte spodní stavěcí šroub a horní stavěcí šroub.**

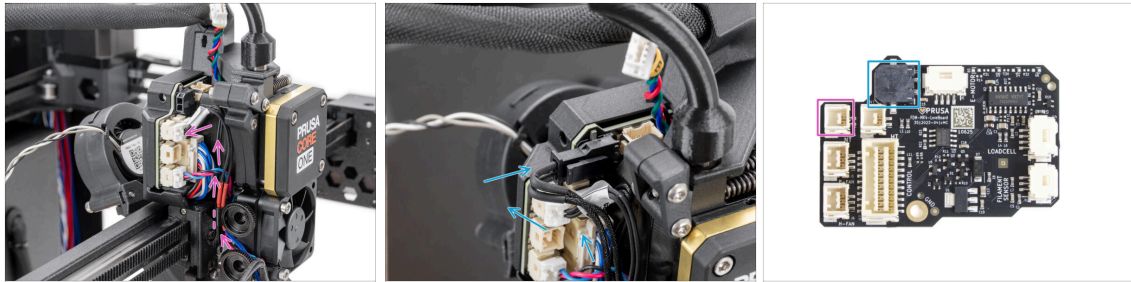
⚠ **Vyvarujte se přiskřípnutí jakéhokoli kabelu mezi šrouby a chladičem!**

KROK 49 Connecting the heatsink cables



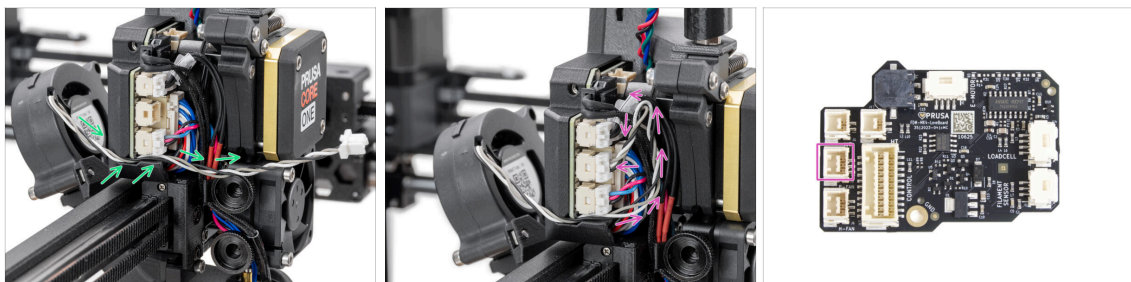
- ✿ Plug the NTC thermistor cable into the connector above the main cable on the LoveBoard.
- ✿ Zapojte kabel ventilátoru hotendu do spodního konektoru v levé řadě desky LoveBoard.

KROK 50 Connecting the hotend cables



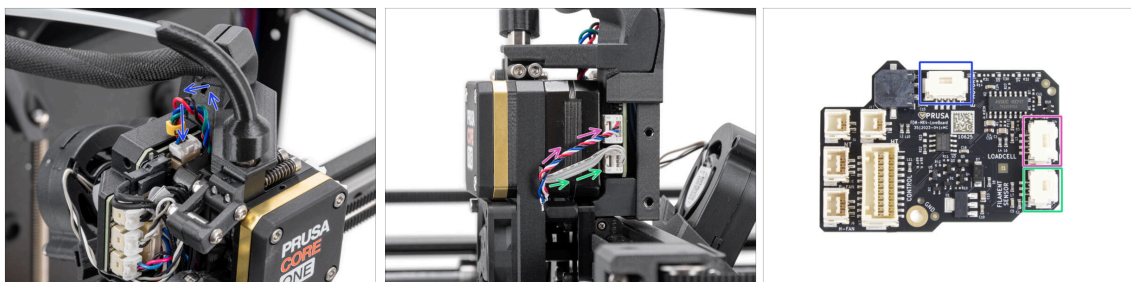
- ◆ Guide the hotend thermistor through the cable-clip on the Nextruder and connect it to the LoveBoard.
- ◆ Guide the hotend heater through the cable-clip on the Nextruder and connect it to the LoveBoard.

KROK 51 Connecting the print fan cable



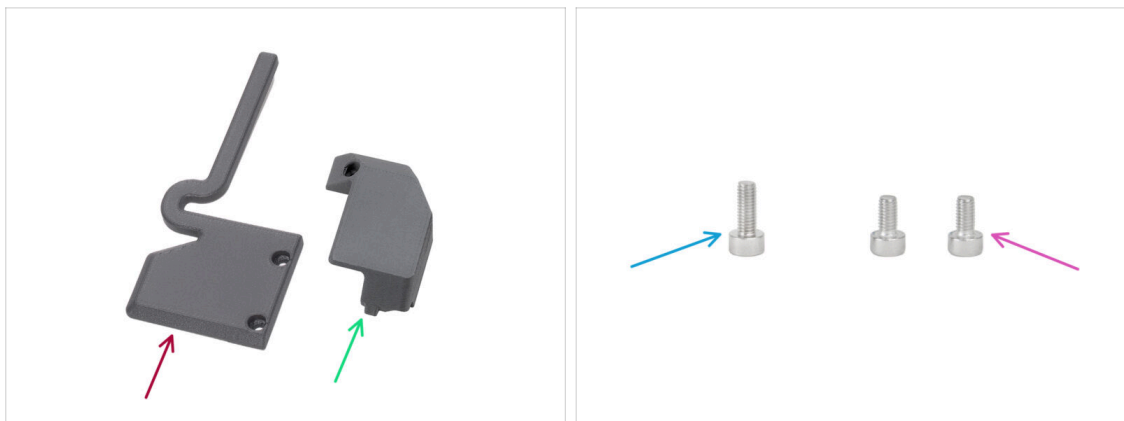
- ◆ Guide the print fan cable through the channel in the plastic cover.
- ◆ Create a loop with the print fan cable in the cable area and plug it into the middle connector in the LoveBoard.

KROK 52 Zapojte kabel motoru označený 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.

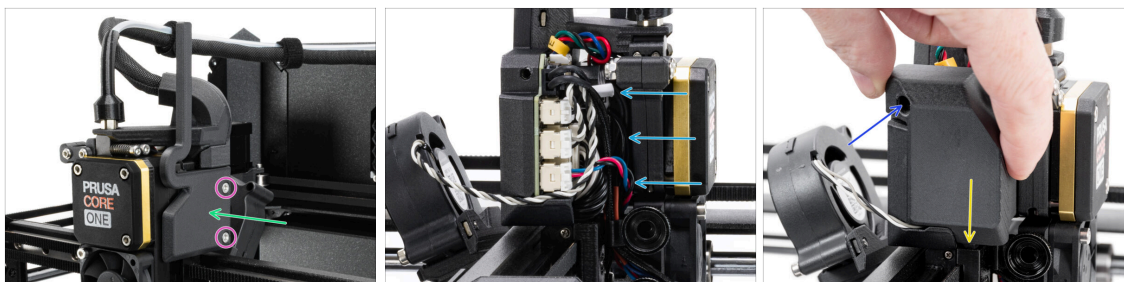
KROK 53 LoveBoard covers: parts preparation



For the following steps, please prepare:

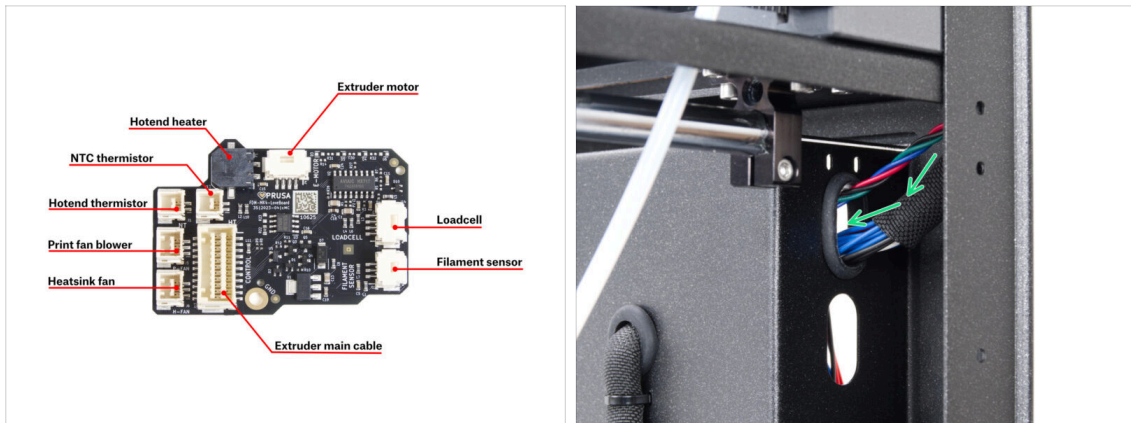
- Print-head-cover-right-lever(1x)
- Print-head-cover-right (1x) *found in the Printed parts package*
- Šroub M3x10 (1x)
- Šroub M3x6 (2x)

KROK 54 Zakrytí desky LoveBoard



- Umístěte díl Print-head-cover-right-lever na pravou stranu Nextruderu.
- ⚠ 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.
- Přichyťte díl Print-head-cover-left na levé straně Nextruderu.
- **Všimněte si výstupku na spodní straně krytu - výstupek musí zapadnout do protějšku na Nextruderu.**
- Zajistěte kryt jedním šroubem M3x10.

KROK 55 LoveBoard: kontrola zapojení



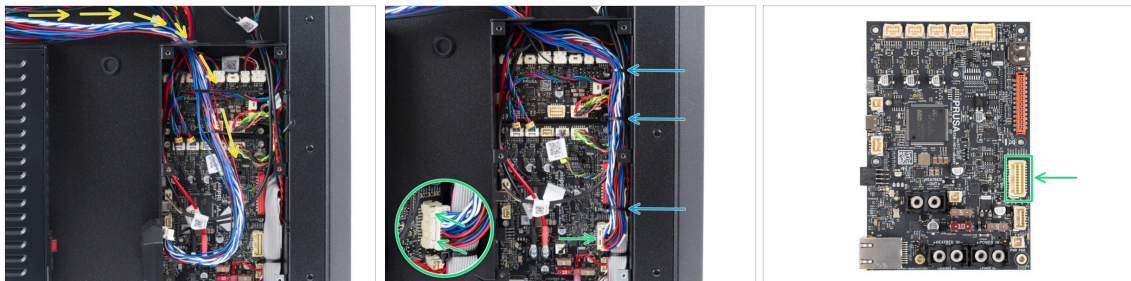
⚠ Before covering the electronics, check the connection of all cables.

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.

KROK 56 Guiding the main cable



⬛ Rotate the printer so that the backside faces you.

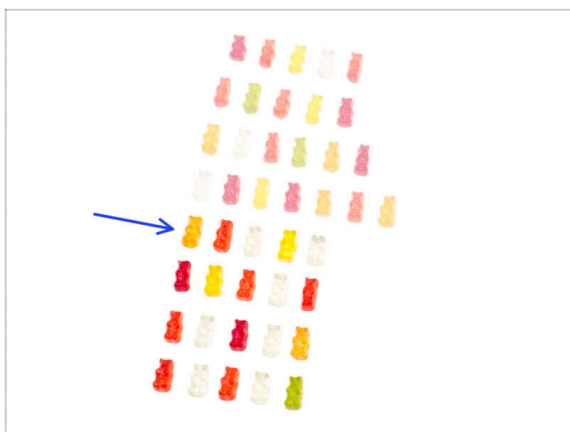
➡ Ved'te hlavní kabel levým otvorem do krabičky xBuddy.

➡ 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.

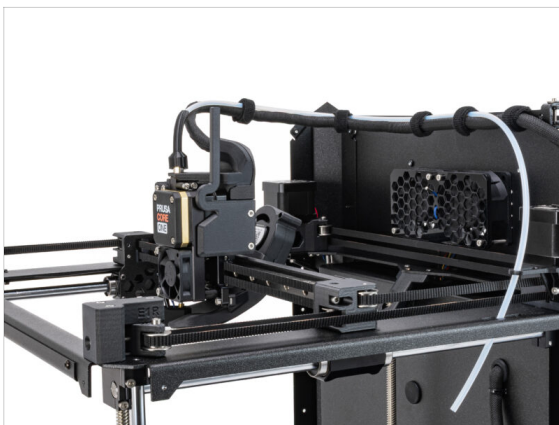
➡ Zajistěte kabely již dříve provlečenými stahovacími páskami v xBuddy boxu. Přebytké části pásek opatrně odstříhněte, **vyhněte se přestřihnutí kabelů..**

KROK 57 Je čas na Haribo!



- ⬛ Power up and push forward!
- ⬛ Eat the fifth row.
- ⬛ Nejste už přecpaní?

KROK 58 Hotovo

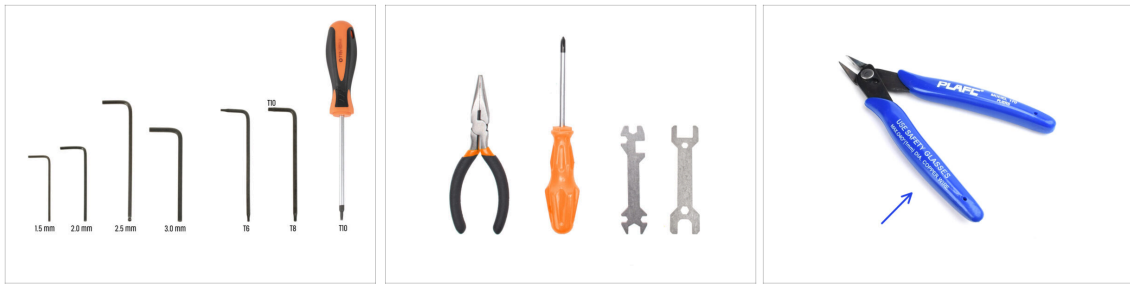


- ⬛ Congratulations! You just successfully assembled the Nextruder.
- ⬛ Let's move to the next chapter.

7. Bodywork & Electronics



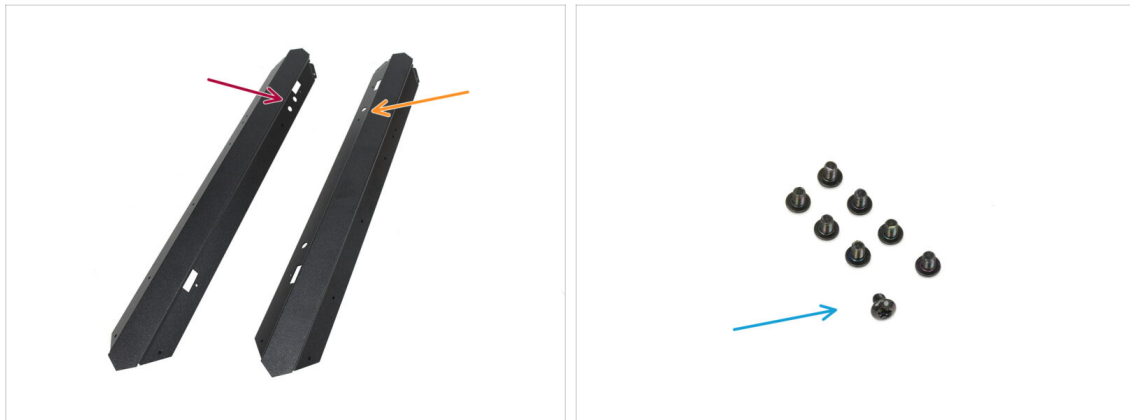
KROK 1 Tools necessary for this chapter



● For the following steps, please prepare:

- 2,5mm inbusový klíč
- 1,5mm inbusový klíč
- Klíč Torx T10
- Čelistové kleště
- Vyštipovací kleště (volitelné)

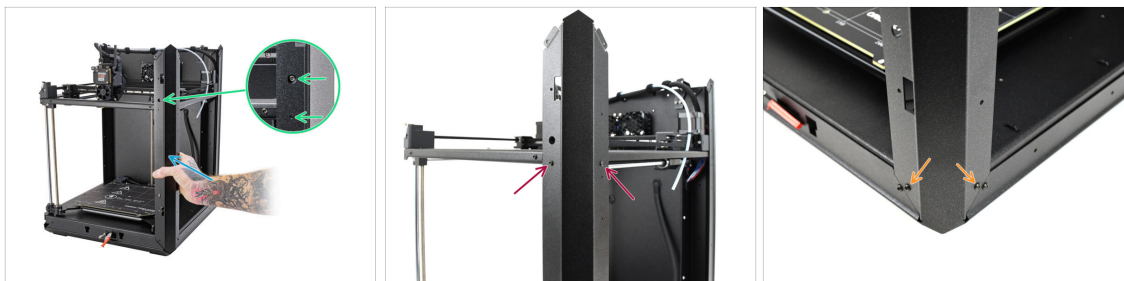
KROK 2 Front profiles: parts preparation



● For the following steps, please prepare:

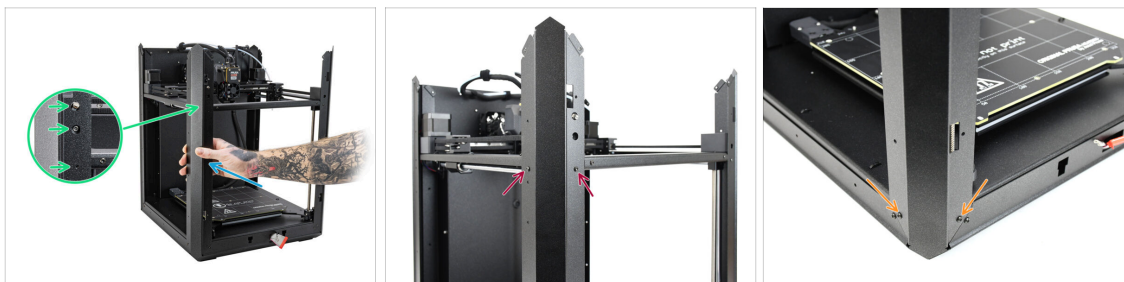
- Front Left Profile (1x) *found in the Metal parts 1/3 package*
 - ① The one with the two circular openings on top.
- Přední pravý profil (1x) *naleznete v balení Metal parts 1/3*
 - ① The one with one circular opening on top.
- Šroub M3x4rT (8x)

KROK 3 Installing the front right profile



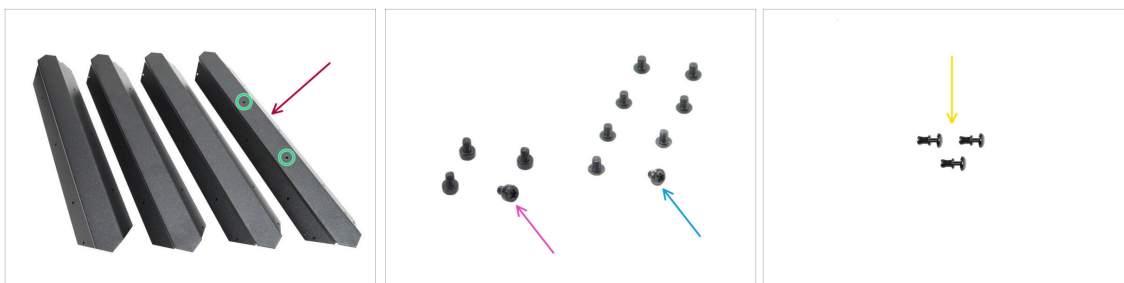
- Attach the Front Right Profile to the printer.
 - i Ensure you are using the correct profile—it should have **one large round opening** for the belt tensioning screw.
- Align the profile so that the calibration screw opening and the smaller bolt opening line up with the thread.
- Připevněte profil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

KROK 4 Instalace předních levých profilů



- 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!**
- Připevněte profil k sestavě CoreXY pomocí dvou šroubů M3x4rT.
- Fix the profile at the bottom using the two M3x4rT screws.

KROK 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.
- Šroub M3x4rT (8x)
- Šroub M3x4 (4x) *s odlišným typem hlavičky*
- Nylonový nýt (3x)

KROK 6 Assembling the top profiles I.



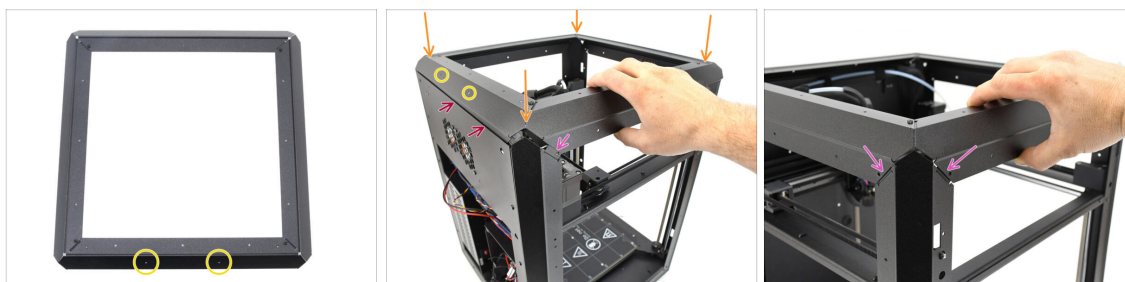
- ⚠ Be very careful when handling sharp sheet metal parts to avoid injury or damage.
- According to the picture, place the top profile with two holes on the flat side.
- Orient the part according to the picture. **Use the flange as a guide.**
- Na levou stranu umístěte libovolný jiný z horních profilů. Orientujte díl podle obrázku. **Použijte přírubu jako vodítko.**
- 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.

KROK 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.

KROK 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.
- ✦ Na bočních a předních stranách musí profily dosedat na výstupky se závitovými otvory.

KROK 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.

KROK 10 CoreXY fixing screws: parts preparation



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

KROK 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.

KROK 12 Side sensor base: parts preparation



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

KROK 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.

i Díl s magnetem by měl být umístěn vedle kuličky.

Všimněte si, že kulička bude přitahována k magnetu - ujistěte se, že zůstane pevně na místě.

- ✚ Připevněte páku na místo pomocí podložky M3w a šroubu M3x10. Zatím ho utáhněte jen o několik otáček - stačí, aby držel na místě.

⚠ Šroub nedotahujte úplně. Jinak se páčka nebude pohybovat a senzor nebude fungovat!

KROK 14 Test páčky



- ✚ Verify the lever is able to move freely.
- ✚ Pokud se páčka nepohybuje volně nebo se vůbec nepohybuje, povolte šroub o čtvrt otáčky a znovu vyzkoušejte pohyb.

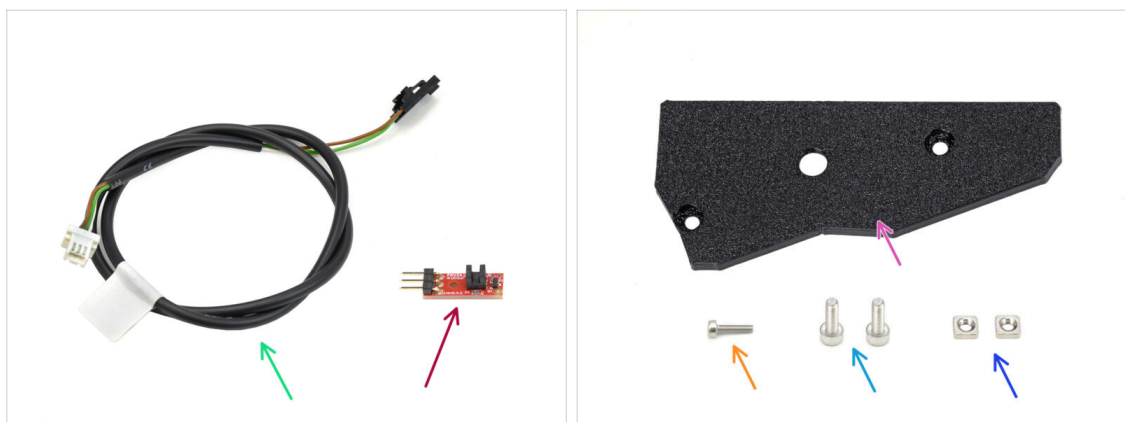
⚠ Šroub nesmí být zcela utažen, jinak se páčka nebude moci volně pohybovat.

KROK 15 Sestavení přepínače



- 🔵 Vložte druhý magnet o rozměrech 10x6x2 do dílu filament-sensor-switch.
- 🟡 Namontujte díl filament-sensor-switch do filament-sensor-body.
- 🟠 Přesuňte díl filament-sensor-switch do levé koncové polohy tak, aby magnety směřovaly k sobě.
- 🟢 Zkontrolujte, že se **magnety odpuzují** - měly by se odtlačovat od sebe.
- 🔴 **Pokud se přitahují** - tedy posouvají k sobě: vyjměte magnet z přepínače senzoru filamentu a otočte jeho polaritu. Poté vše znovu zkontrolujte.
- 📌 *Pro tip: K odstranění magnetu z dílu filament-sensor-switch použijte jeden z tenkých šestihranných klíčů nebo klíčů Torx.*

KROK 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*
- 🟡 Plastový díl Side Filament Sensor Cover (1x) *naleznete v balení Printed parts*
- 🟠 Šroub M2x8 (1x)
- 🔵 Šroub M3x10 (2x)
- 🟢 Matka M3nS (2x)

KROK 17 Connecting the IR sensor



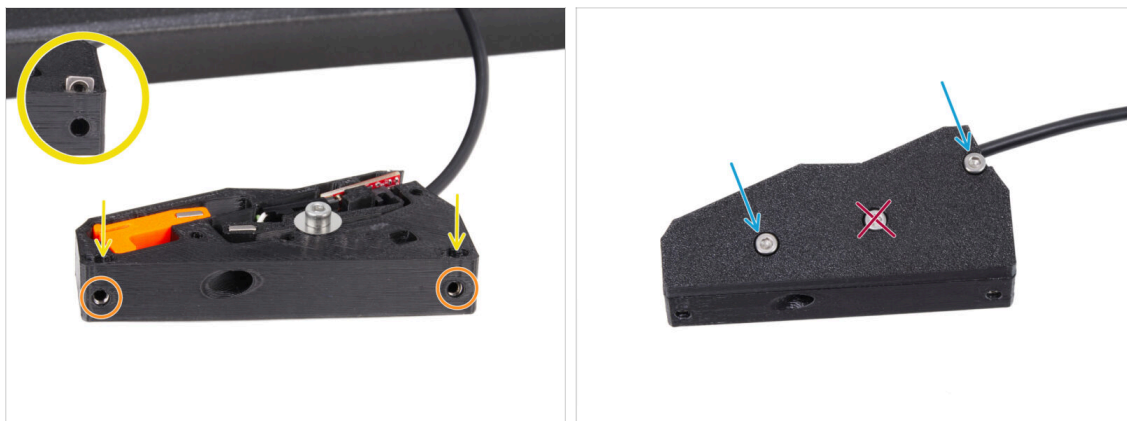
- 🟢 Plug the cable into the IR filament sensor.
- ⚠️ Ensure the connector is oriented correctly before plugging it in!
- 🟡 On CORE One, the brown cable must connect to the +5V pin.
- 🔵 Bílý kabel se připojuje ke kolíku GND.

KROK 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.
- 🟡 Ujistěte se, že se konektor ani kabely nedotýkají páčky, protože by to mohlo zabránit správné funkci snímače.
- 🔵 Using the 1.5mm Allen key, fix the sensor in place with the M2x8 screw.

KROK 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.
 - ✦ Zajistěte plastový kryt na místo pomocí dvou šroubů M3x8 (boční otvory na šrouby).
- ⚠ **Šroub uprostřed nedotahujte! Jinak by senzor přestal fungovat.**

KROK 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*
- ✦ Stahovací páska (3x)

KROK 21 Installing the side filament sensor



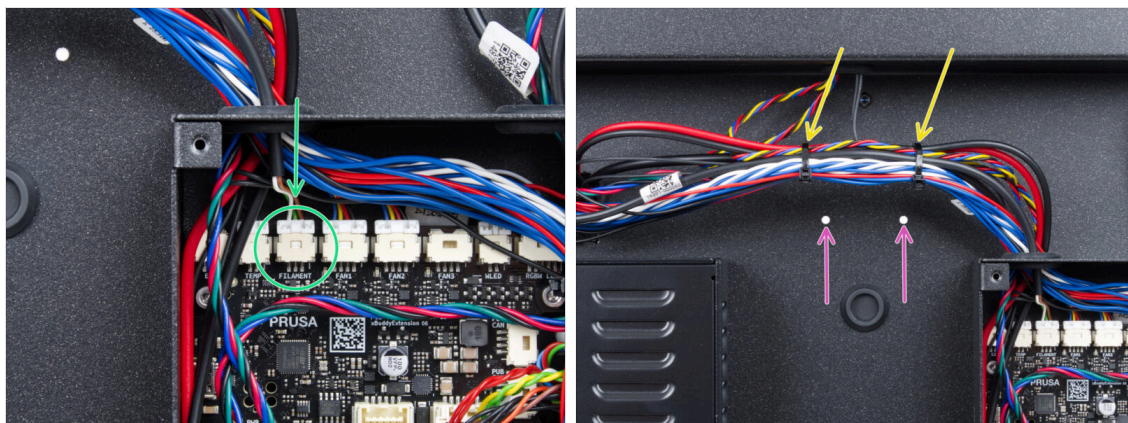
- 🟠 Install one zip-tie into the marked openings. We will use it to attach a cable underneath the metal profile.
 - 🟡 Vložte objímku do označeného otvoru na sestavě senzoru.
 - 🟢 Attach the sensor assembly onto the PTFE tube in the printer.
- ⚠️ Dbejte na to, abyste trubičku zasunuli až na doraz!

KROK 22 Guide the filament sensor cable



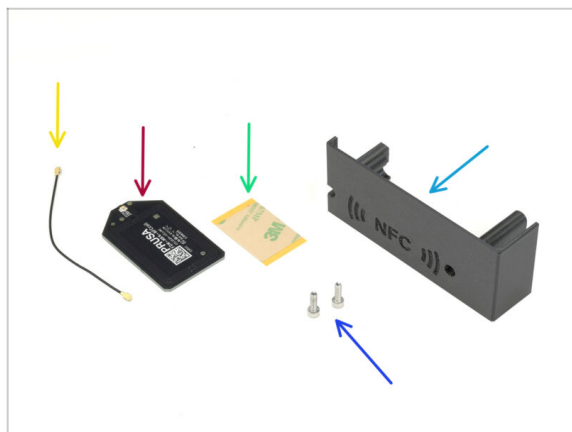
- 🟠 Move the sensor assembly up, roughly to the middle of the printer's frame, to align the cable properly.
- 🟢 Once in position, secure the cable underneath the metal profile using a zip-tie. Tighten the zip-tie lightly, allowing for cable adjustments if needed later. Cut off the excess zip-tie.
- 🟡 Guide the sensor cable through the dedicated opening to the back of the printer.
- 🟠 Na zadní straně tiskárny ved'te kabel do krabičky xBuddy. Zatím ho nechte volně viset.

KROK 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.
 - Zajistěte kabely v **co nejvyšší možné poloze** tak, aby nepřekážely dvěma otvorům na kovovém plátu pod nimi.
- ⚠ Do not over-tighten the zip ties or strain the cables too much!

KROK 24 NFC Antenna: parts preparation



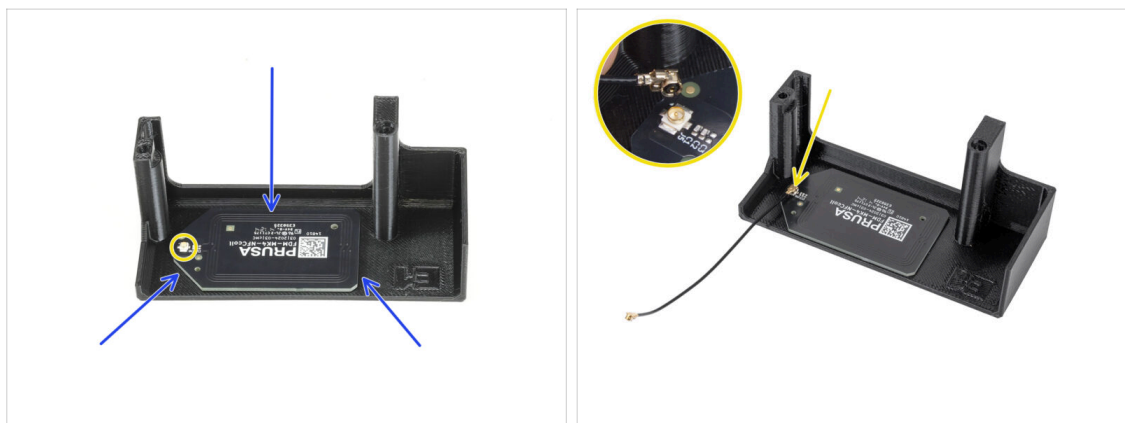
- For the following steps, please prepare:
 - El-box-cover (1x) found in the Printed parts package
 - Šroub M3x10 (2x)
 - NFC cívka (1x) naleznete v balíčku Electronics & Chamber parts
 - Adhesive film 32 x 25 mm (1x) found in the Electronics & Chamber parts package
 - NFC coil cable (1x) found in the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

KROK 25 Applying the adhesive film



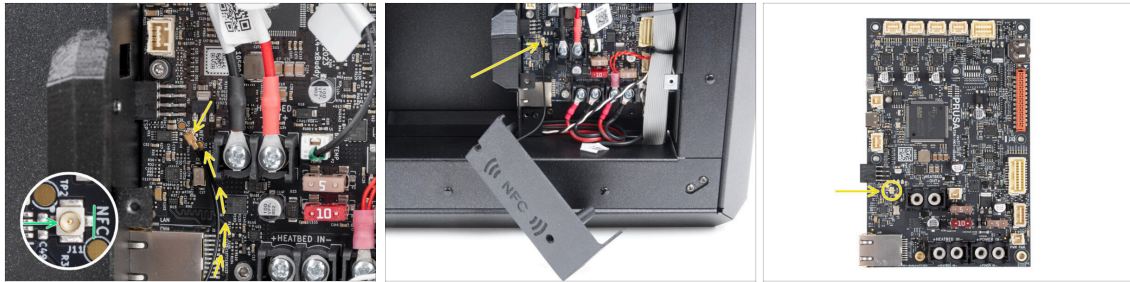
- ✦ Peel off the yellow protective film from the adhesive tape.
- ✦ Apply the film to the flat side of the NFC coil, ensuring it adheres properly.
- ✦ Peel of the remaining protective layer from the NFC coil.

KROK 26 Installing the NFC Coil



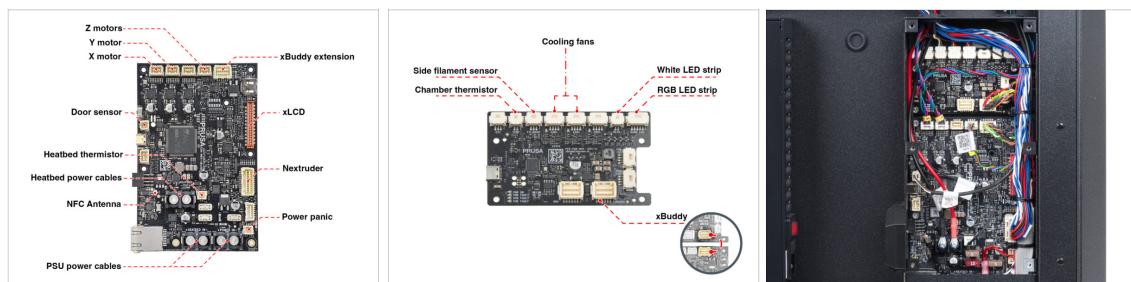
- ✦ Stick the NFC coil onto the inner side of the EI-box cover, approximately as shown in the picture.
- ⓘ The small round connector should be positioned closer to the edge of the cover.
- ✦ Connect the cable to the board by aligning the connectors and pressing lightly until you feel a click, ensuring a secure connection.
- ⚠ **Při připojování kabelu NFC cívky buďte opatrní. Nesprávné zarovnání nebo nadměrný tlak mohou způsobit nevratné poškození.**

KROK 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.

KROK 28 Kontrola zapojení



- 🟡 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!

KROK 29 Preparing the electronics cover



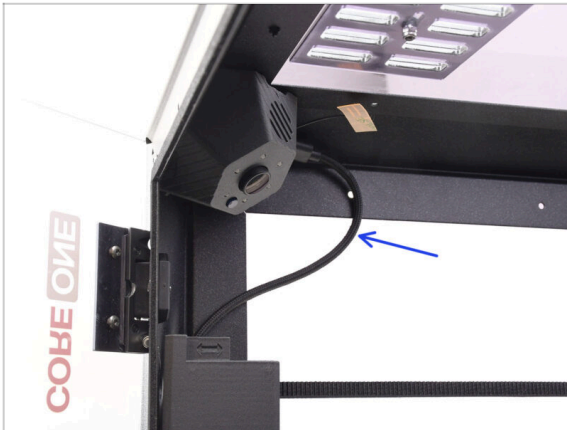
- Push two M3x10 screws through the EI-box-cover.

KROK 30 Installing the electronics cover



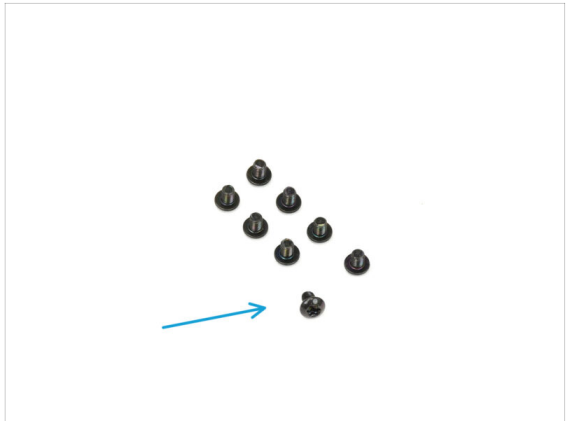
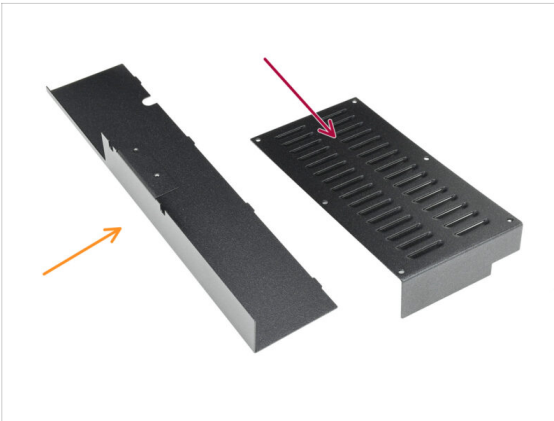
- Ensure the threaded holes on the bottom of the xBuddy box are not obstructed by cables.
- If so, rearrange the cables to allow clear access.
- Align the cover with the opening in the xBuddy box and fix it in place by tightening the screws.
- Route the NFC cable through the space between the Ethernet 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.**

KROK 31 Poznámka ke kameře Buddy3D



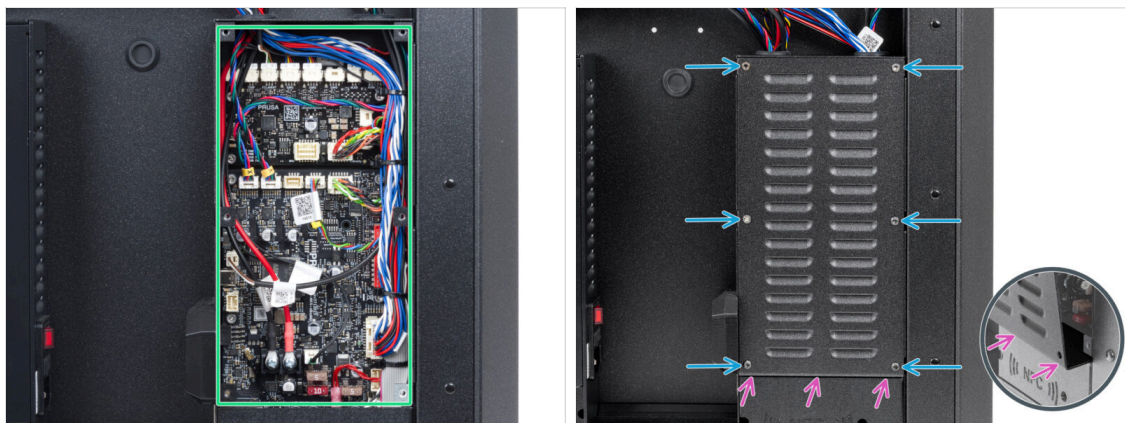
- i** Pro budoucí uživatele kamery Buddy3D:
- Pokud plánujete používat kameru Buddy3D, máte již nainstalovaný kabel USB.
 -  Pro detailní informace o montáži a připojení kamery Buddy3D se vraťte k tomuto návodu: **Instalace kamery Buddy3D pro CORE One**

KROK 32 xBuddy cover: parts preparation



- For the following steps, please prepare:**
- Sheet metal back cover (1x) found in the Metal parts 2/3 package
 - xBuddy cover (1x) found in the Metal parts 3/3 package
 - Šroub M3x4rT (8x)

KROK 33 Installing the xBuddy cover



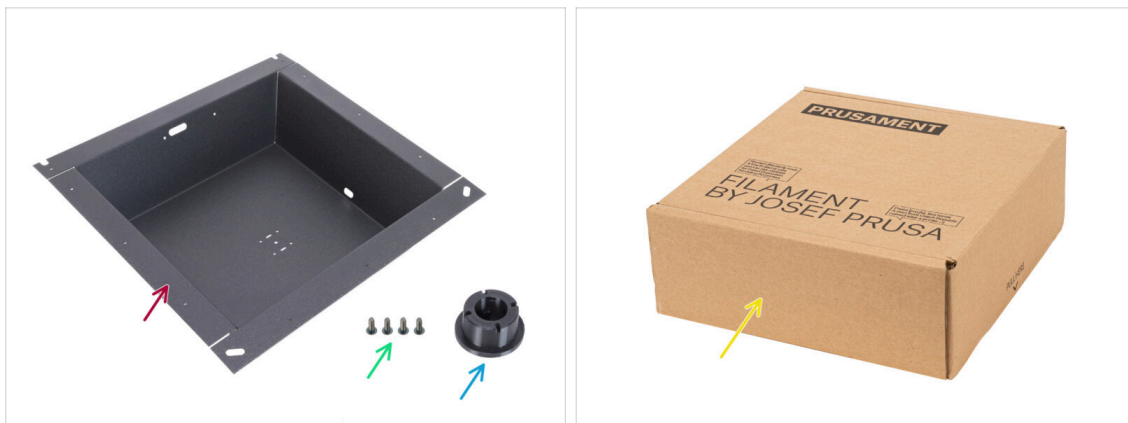
- 🟢 Uspořádejte vedení kabelů v xBuddy boxu podle obrázku.
- 🟡 Carefully cover the xBuddy box by first sliding the bent part of the cover into the box.
- ⚠️ **Avoid pinching the cables. Double-check the NFC coil cable position.**
- 🔵 Secure the xBuddy box cover using the six M3x4rT screws.

KROK 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.
- 🟡 There are four tabs that should engage into the printer's chassis.
- 🟢 Secure the rear cover in place using two M3x4rT screws from inside the printer.

KROK 35 Right side: parts preparation



● For the following steps, please prepare:

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

⚠ The correct **right-side** piece can be easily identified by the screw openings in the middle.

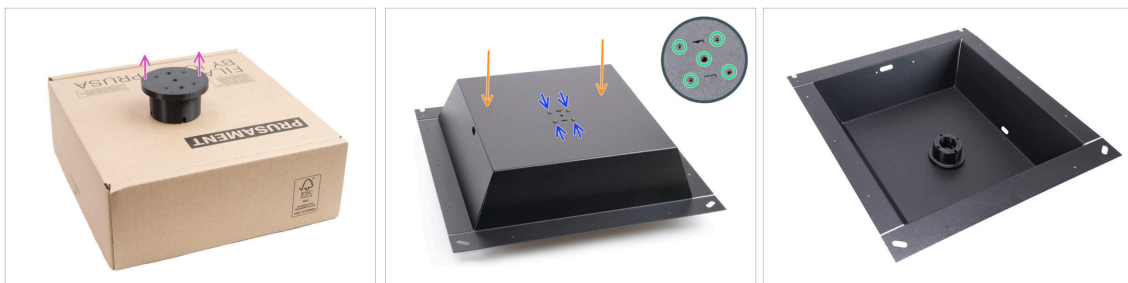
● Šrouby M3x8rT (4x) naleznete v balíčku Electronics & Fasteners

● Puk-univerzální (1x)

● Jakákoli kartonová krabice (1x)

📌 Tip: Dobře se hodí krabice od Prusamentu.

KROK 36 Instalace puku pro držák cívky



● Umístěte díl Puck-universal na kartonovou krabici tak, aby otvory pro šrouby směřovaly nahoru.

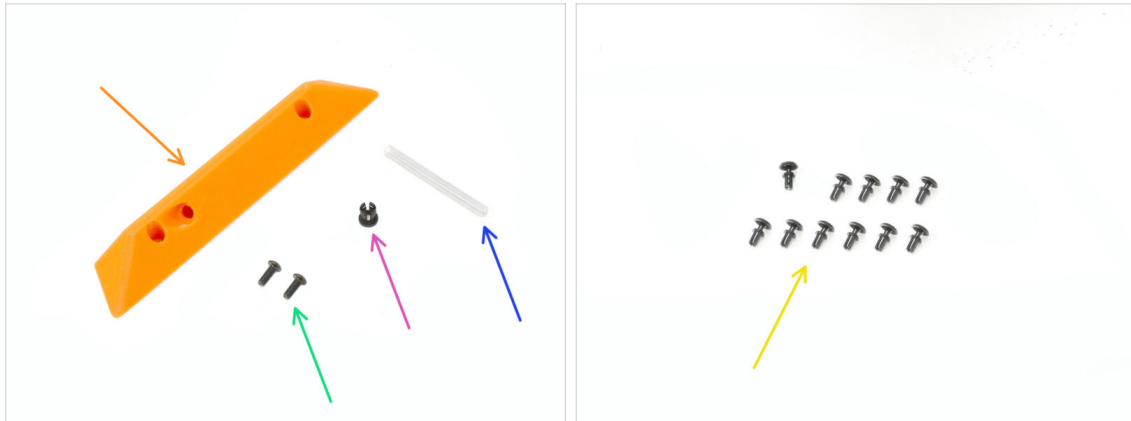
● Opatrně umístěte pravý panel na díl Puck-universal, umístěte jej do středu krabice.

● Zarovnejte otvory v dílu Puck-universal s otvory v pravém panelu.

● Upevněte díl Puck-universal pomocí čtyř šroubů M3x8rT.

ⓘ Při utahování mohou šrouby klást odpor, protože si uvnitř dílu prořezávají vlastní závit.

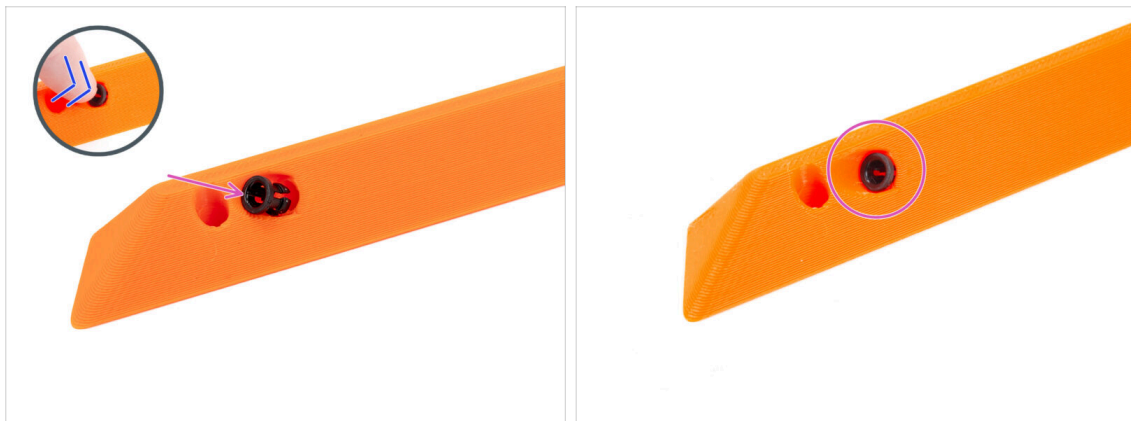
KROK 37 Right handle: parts preparation



For the following steps, prepare:

- Side Handle (1x) *found in the Printed parts package*
- Šroub 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)*
- Nylonový nýt (11x)

KROK 38 Montáž objímky



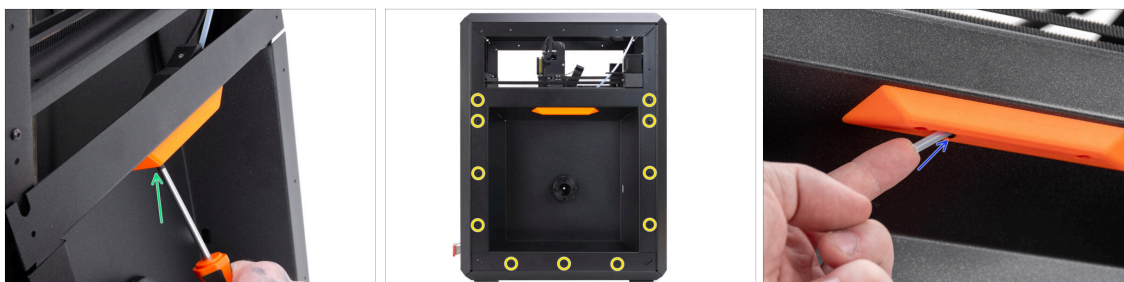
- Insert the collet into the handle.
- Push it all the way in.

KROK 39 Montáž úchytu



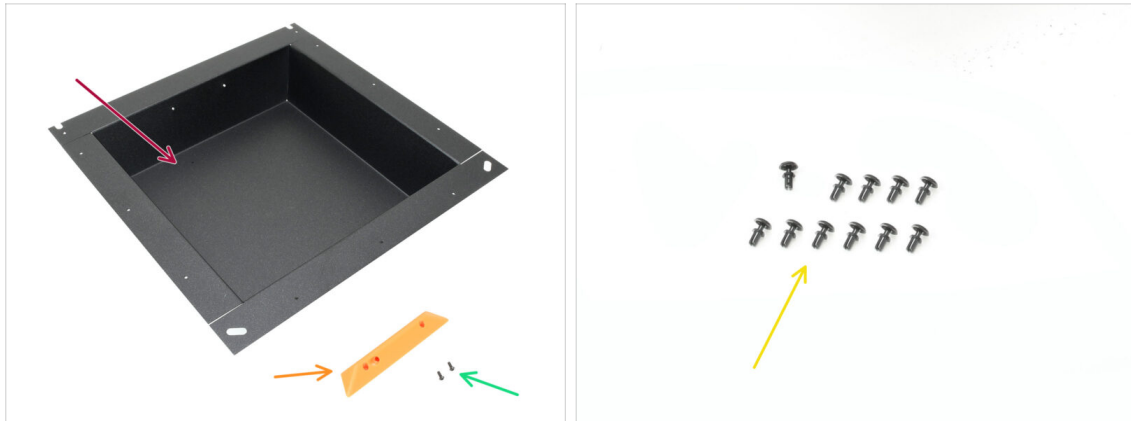
- ✦ Place the right-side metal sheet assembly on the right side of the printer. Ensure the U-shaped cutouts are facing upwards.
- ✦ Attach the right handle to the right metal sheet.
- ✦ Prostrčte jeden šroub M3x8rT zadním otvorem v rukojeti a plechem.
- ✦ Attach the side filament sensor assembly on the 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.

KROK 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.
- ✦ Vložte krátkou teflonovou PTFE trubičku 4 x 2,5 x 45 do kleštiny. Zatlačte ji až na doraz.
- ⓘ Part of the PTFE tube will remain protruding from the handle.

KROK 41 Left side: parts preparation



For the following steps, prepare:

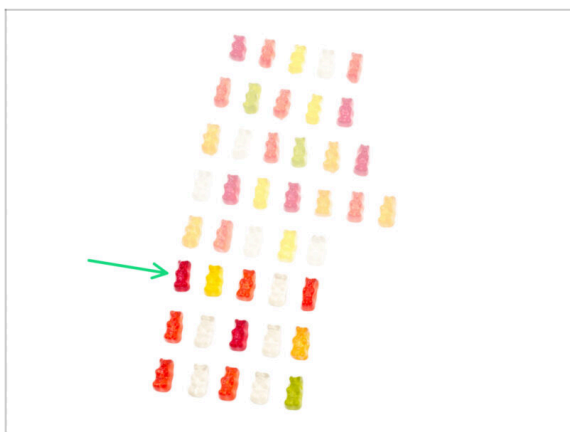
- Left side sheet metal (1x) *found in the Metal parts 2/3 package*
- Boční úchyt (1x) *naleznete v balíčku Printed parts*
- Šroub M3x5rT (2x)
- Nylonový nýt (11x)

KROK 42 Installing the left side



- Align the handle with the threaded openings in the sheet metal.
- Attach the handle using the two M3x5rT screws.
- Připevněte boční plech k tiskárně pomocí 11 nylonových nýtů.

KROK 43 Je čas na Haribo



- Well done—fuel up for the next challenge!
- Eat the sixth row.
- Tak blízko! Ale ruce pryč od těch posledních medvídků!

KROK 44 Hotovo

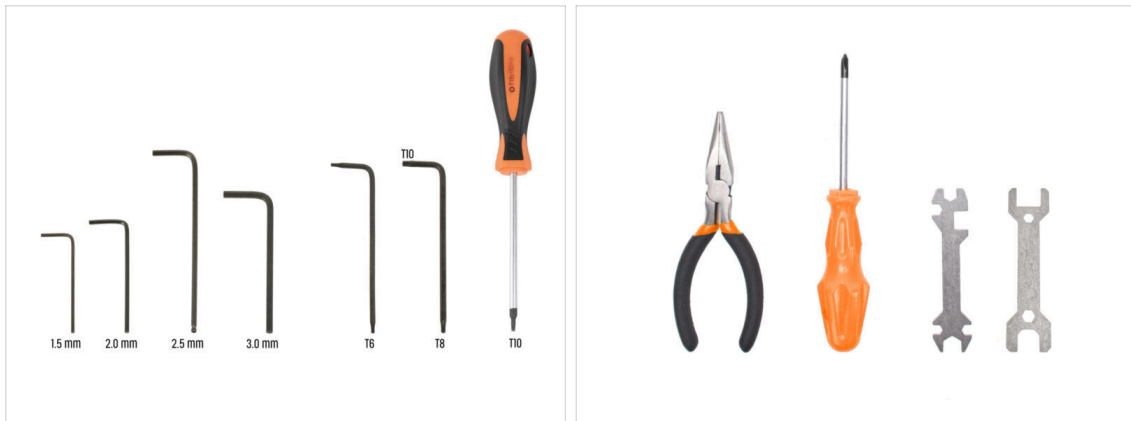


- Congratulations! You've successfully assembled the entire body.
- Let's move to the next chapter.

8. Trim, Door & xLCD



KROK 1 Tools necessary for this chapter



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

- 2,5mm inbusový klíč
- Klíč Torx T10
- Čelistové kleště

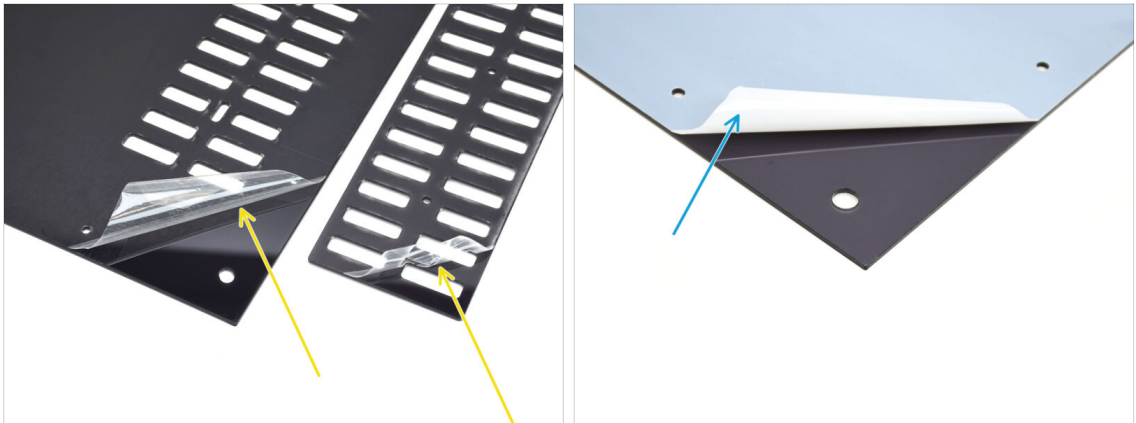
KROK 2 Top cover: parts preparation



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

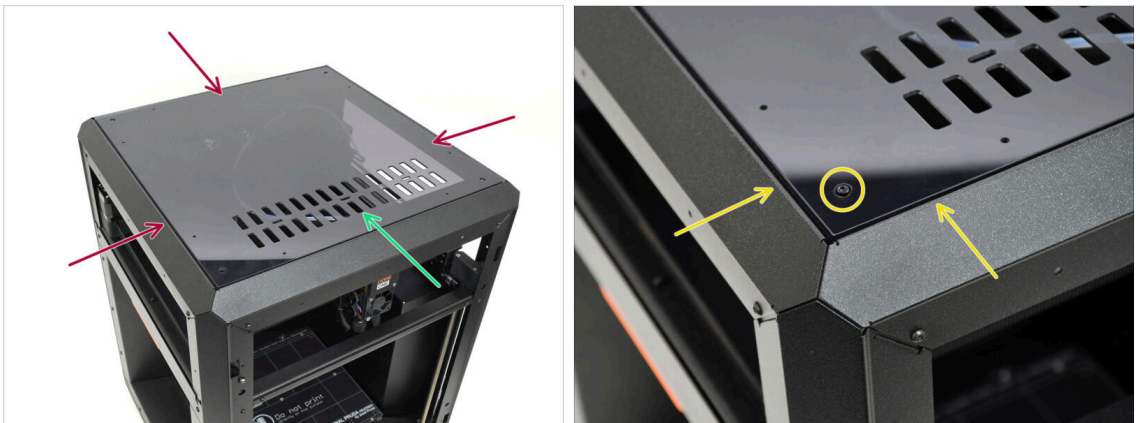
- Top cover (1x) *found in the Plexi set package*
- Vent cover (1x) *found in the Plexi set package*
- Matka M3nN (3x)
- Insulating insert (3x) *found in the Electronics & Fasteners package*
- **i** Tento díl může být buďto šedý nebo černý. Tvar je nicméně identický a proces stavby to nijak neovlivní.
- Šroub M3x12rT (3x)
- Nylonový nýt (4x)
- Upg-vent-block

KROK 3 Odstranění ochranné fólie



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

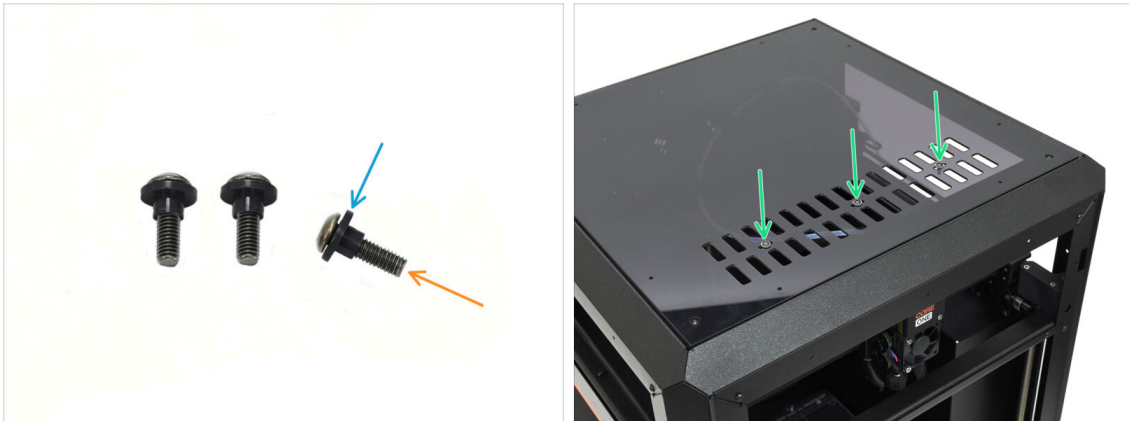
KROK 4 Test-fitting the top cover



- Lay down the top cover onto the printer.
- The part with the vent openings should be oriented towards the front of the printer.
- 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.

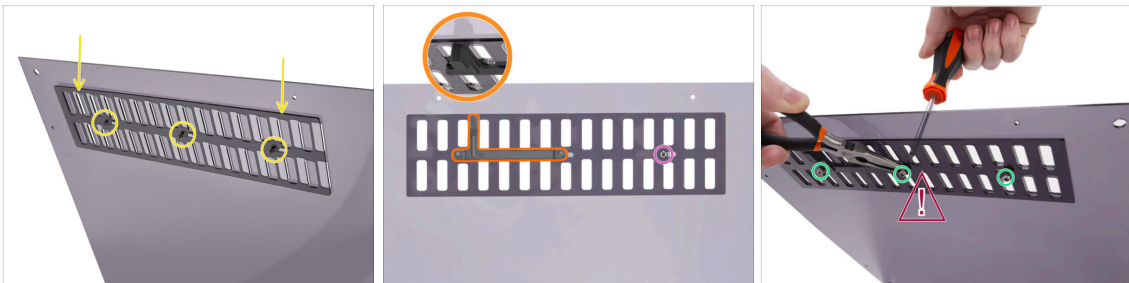
Spoiler alert: The cover isn't symmetrical!

KROK 5 Assembling the top cover I.



- ✚ Prostrčte všechny tři šrouby M3x12rT izolačními vložkami.
- 🔵 Make sure the flanged part of the insert is oriented toward the screw head.
- 🟢 Insert the screws with the inserts through the three slot openings in the vent.

KROK 6 Assembling the top cover II.



- 🟡 Align the vent cover with the screw ends on the bottom.
- 🟣 Ručně utáhněte matici M3nN zcela vpravo na šroub M3x12rT, abyste kryt upevnili na místě.
- ✚ Připojte díl Upg-vent-block ke krytu ventilační mřížky. Ujistěte se, že je umístěn správně.
- 🟢 Zajistěte díl Upg-vent-blok na krytu ventilace pomocí matek M3nN. Při utahování šroubů přidržujte matky čelistovými kleštěmi.

⚠ 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.

KROK 7 Testování ventilace



- ◆ Try moving one of the three screws with your hand.
- ⓘ The vent openings must open and close smoothly without effort.
- ⚠ If movement is difficult, loosen the screw that is restricting it.

KROK 8 Installing the top cover



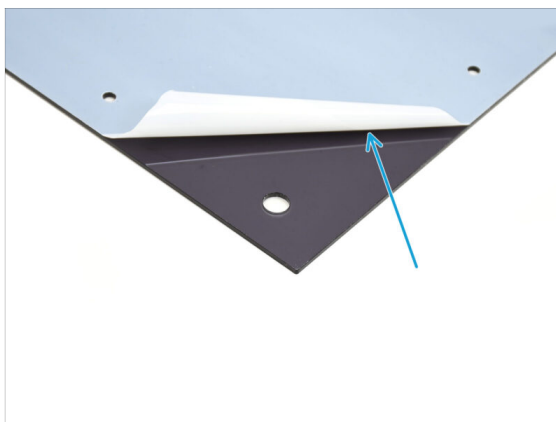
- ◆ Zarovnejte kryt s výřezem v tiskárně a ujistěte se, že větrací otvor směřuje dopředu.
- ◆ Secure the cover to the frame using four nylon rivets in the marked openings.
- ⓘ There are eight openings, but four rivets should be sufficient.

KROK 9 Side covers: parts preparation



- For the following steps, prepare:
- Side Cover (2x) *found in the Plexi set package*
- Nylonový nýt (10x)

KROK 10 Odstranění ochranné fólie



- Remove the protective foil from both the side covers.
- Remove the protective foil from the other sides of both the side covers.

KROK 11 Covering the left side



- Align the cover with the recess on the left side of the printer.
- The protruding screws on the printer must align with the larger openings in the cover.
- Secure the cover to the frame using five nylon rivets in the marked openings.

KROK 12 Covering the right side



- Align the other cover with the recess on the right side of the printer.
- Secure the cover to the frame using five nylon rivets in the marked openings.

KROK 13 Sestava xLCD: Příprava dílů



- For the following steps, prepare:**
- ✦ xLCD (1x) found in the *Electronics package*
 - ✦ 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*
 - ✦ Šroub 3x8sT (4x)
 - ✦ Faston connector (1x) found in the *Electronics package*

KROK 14 Assembling the xLCD I.



- ✦ Doporučujeme položit přední kryt lícem dolů na okraj lepenkové krabice nebo stolu, aby vznikl prostor pro ovladačí tlačítko.
- ✦ Remove the protective foil from the xLCD.
- ✦ Insert the xLCD into the front cover.

KROK 15 Assembling the xLCD II.



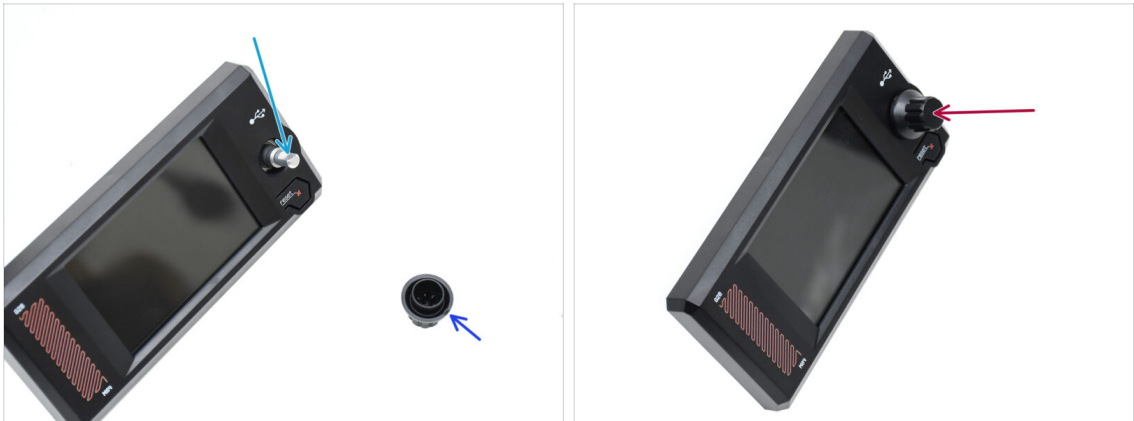
- Cover the assembly with the rear part.
 - Pokud máte starší verzi tištěného zadního krytu, je nutné díl nejprve zachytit na roh xLCD. Novější verzi můžete jednoduše nasadit přímo.
- Fix the parts together using **JUST THREE** 3x8sT screws in the marked openings.
 - ⚠ Nevkládejte šroub do čtvrtého otvoru vedle dlouhého otvoru pro konektor xLCD, který je viditelný přes výřez. Nechte jej prozatím prázdný.

KROK 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.
- Using needle-nose pliers, carefully maneuver the grounding faston connector over the screw opening, ensuring the holes line up.
- 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.

KROK 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.
- There is a small gate scar on the injection-molded knob, which can serve as an orientation mark.
- Attach the knob onto the shaft, making sure the mark on the knob is facing up.

KROK 18 xLCD bezel: parts preparation



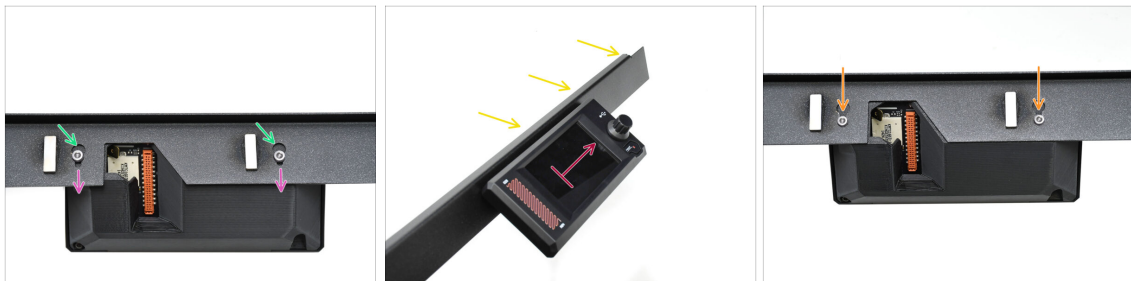
- **For the following steps, prepare:**
- xLCD (1x) *found in the Electronics package*
- Matka M3nS (2x)
- Šroub M3x6 (2x)
- Bezel (1x) *found in the Metal parts 2/3 package*

KROK 19 Mounting the xLCD I.



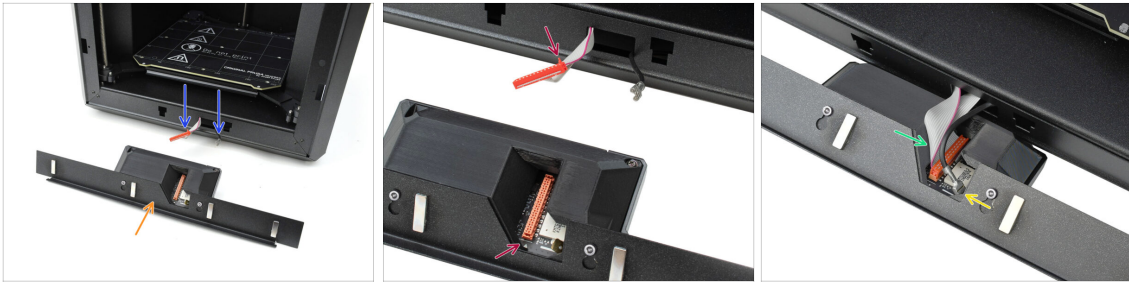
- Insert the two M3nS nuts into the dedicated openings on the back of the xLCD assembly,
- Push the nuts all the way in until the threads line up with the screw openings.
- Attach two M3x6 screws into the openings. Do not screw them all the way in.
- Leave a gap under the screw heads.

KROK 20 Mounting the xLCD II.



- Hook up the xLCD assembly onto the Bezel.
- Insert the screw heads into the keyhole openings.
- 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.

KROK 21 Installing the xLCD assembly



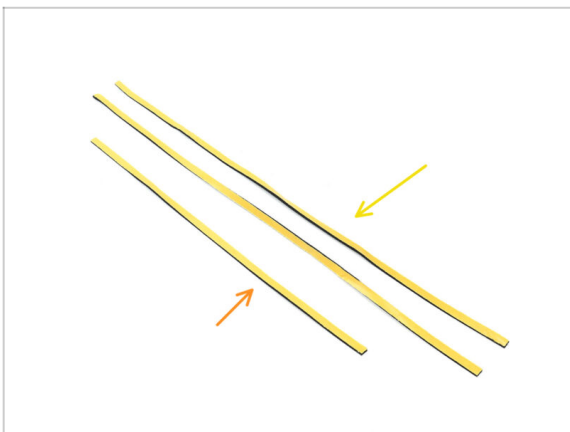
- Put the xLCD assembly in front of the printer, as pictured.
- Pull the appropriate cables out from the front of the printer to make connecting them easier.
- There is a small red tab on the main connector. This tab must be oriented towards the triangle symbol on the PCB.
- Connect the main connector into the xLCD.
- Connect the grounding faston connector.

KROK 22 Securing the xLCD assembly



- Gently lift the xLCD assembly into the upward position.
⚠ Proceed carefully to ensure none of the cables get pinched or disconnected.
- 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.

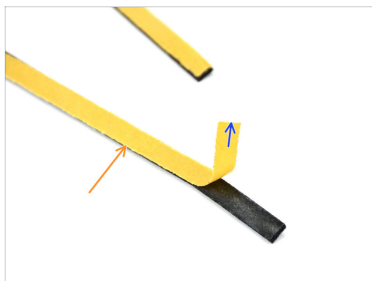
KROK 23 Door seal: parts preparation



For the following steps, prepare:

- Side door seal, a longer one (2x) found in the *Electronics & Fasteners* package
- Top door seal, a shorter one (1x) found in the *Electronics & Fasteners* package
- i The color of the protective layer may vary.

KROK 24 Připevnění horního těsnění



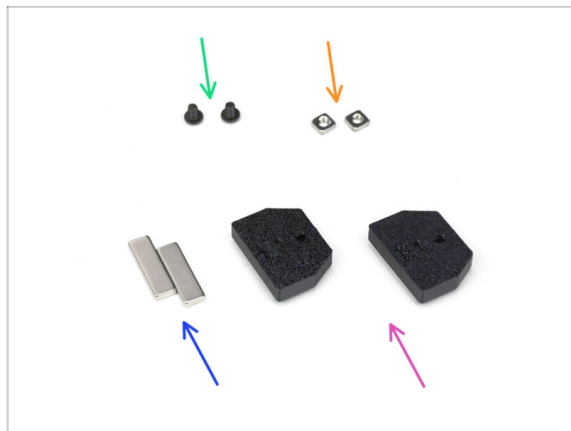
- Take the **SHORTER** seal.
- Peel off the start of the protective foil. No need to remove it entirely yet.
 - i No need to remove it entirely yet. For easier installation, you can peel it off gradually as you go.
- Start applying the seal along the top edge of the printer's frame.
 - Begin offset from 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.

KROK 25 Attaching the side seals



- Apply the longer door seal, starting from the end of the seal on top.
- Work your way from the top down.
- 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.

KROK 26 Magnet holders: parts preparation



● For the following steps, prepare:

- Šroub M3x5rT (2x)
- Matka 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*

KROK 27 Assembling the magnet holders



- ✚ Insert the M3nS nuts into the corresponding openings in the magnet holders.
- ✚ Push the nuts all the way in, until the thread aligns with the screw opening.
- ✚ Insert the magnets into the corresponding pockets in the holders. Push them all the way in.
- ⓘ The orientation of the magnets does not matter.

KROK 28 Installing the magnet holders



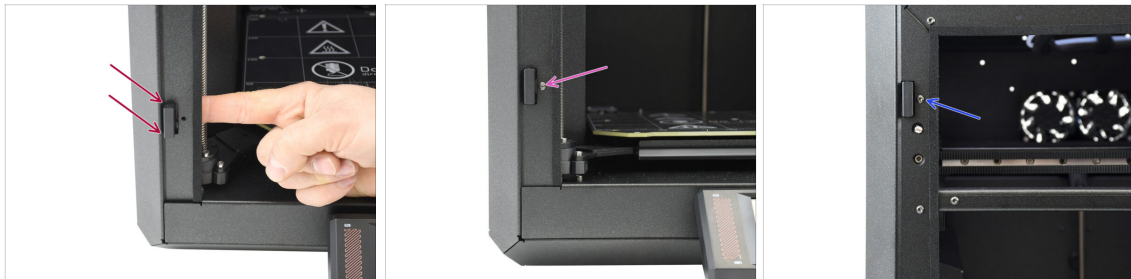
- ✚ From the inside of the printer, insert the magnet holder assembly into the corresponding bottom opening in the right-side metal profile.
- ⚠ Ensure the protruding rectangular pocket fits into the cutout.
- ✚ Secure the assembly in place using the M3x5rT screw.
- ✚ Using the same technique, install the other magnet holder into the top opening on the right side.

KROK 29 Panty dvířek: příprava dílů



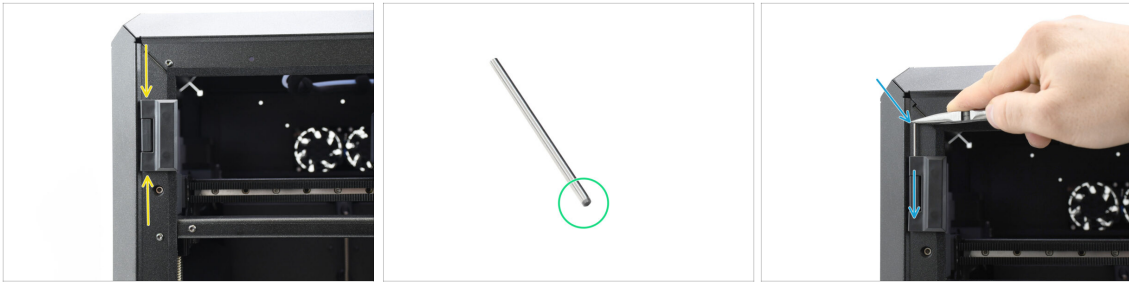
- For the following steps, prepare:
- Door-hinge-in (2x) found in the CoreXY + Hinges set package
 - Door-hinge-out (2x) found in the CoreXY + Hinges set package
 - Hinge Pin 2 x 40 mm (2x) found in the Electronics & Fasteners package
 - Šroub M3x5rT (2x)

KROK 30 Installing the door-hinge-in parts



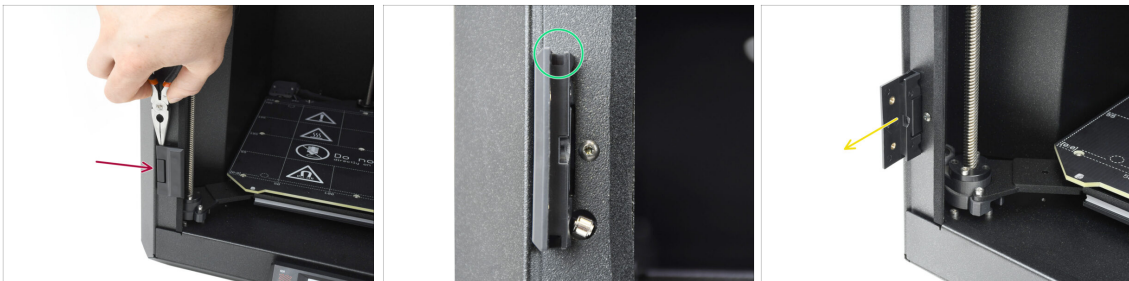
- From the inside of the printer, insert the door-hinge-in into the bottom rectangular opening in the left-side profile. The protruding part should pass through to the front.
- Fix the door-hinge-in in place using the M3x5rT screw.
- Using the same technique, install the other door-hinge-in into the opening on top.

KROK 31 Installing the door-hinge-out I.



- ✦ Align the door-hinge-out with the door-hinge-in.
- ✦ The chamfered end of the hinge pin should be inserted first to make assembly easier.
- ✦ 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.

KROK 32 Installing the door-hinge-out II.

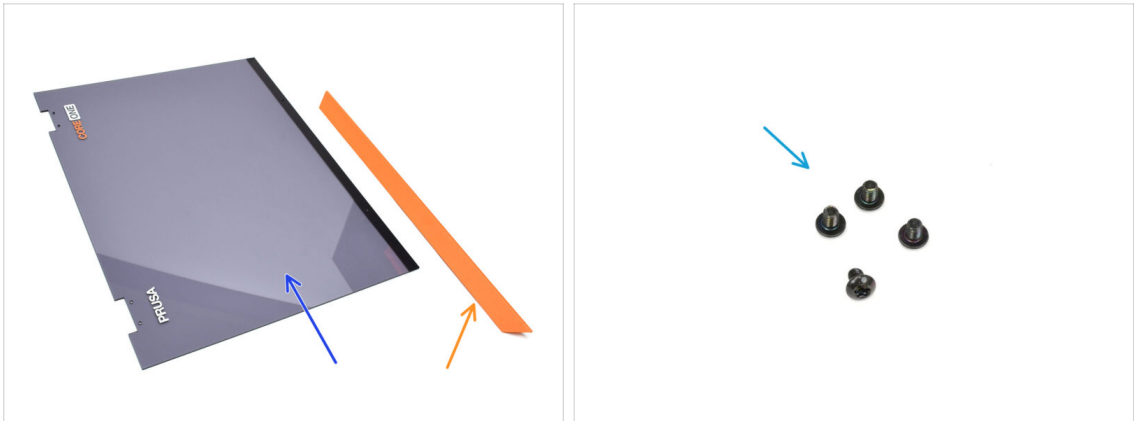


- ✦ Using the same technique, install the bottom door-hinge-out to complete the hinge assembly.
- ✦ Look into the grooves on the door-hinge-out parts and verify that the pins are fully inserted.

No part of the pin should be visible above the bottom surface in the groove.

- ✦ Open up both the hinges.

KROK 33 Door panel: parts preparation



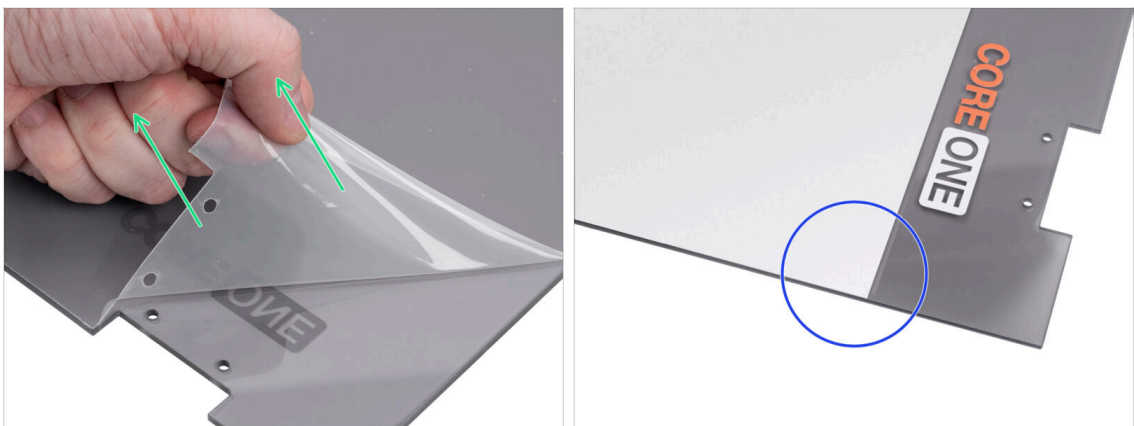
■ **For the following steps, prepare:**

- Door (1x) *found in the Plexi set package*

❗ Dvířka jsou předem označena jako **CORE ONE**. Nebojte se, **je to tak správně!** Samolpeku upgradu na + nalepíte v posledním kroku.

- Door handle (1x) *found in the Metal parts 2/3 package*
- Šroub M3x5rT (4x)

KROK 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.

❗ This protective film does not interfere with the installation of the hinges or handle.

KROK 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.

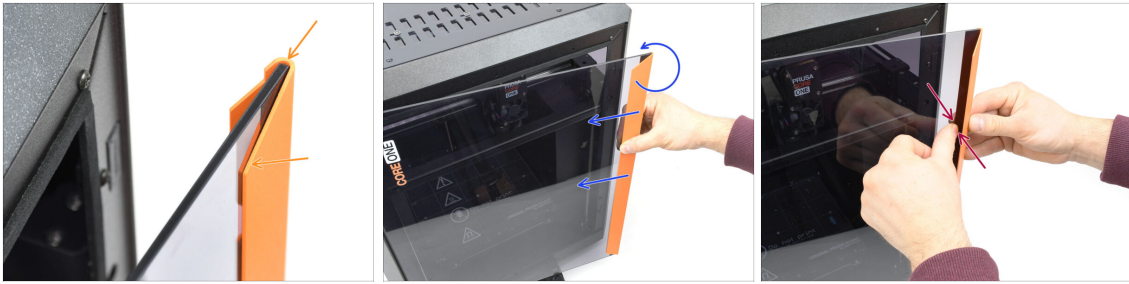
KROK 36 Assembling the door handle



- 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!

KROK 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.

KROK 38 Nalepení samolepky: příprava dílů



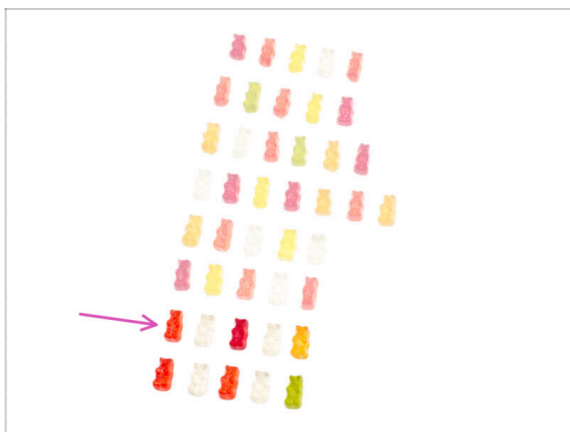
- ✦ Pro následující krok si připravte:
 - ✦ Samolepka CORE One+ na plexisklo dvířek
 - ⓘ Samolepka CORE One+ na plexisklo dvířek se nachází v krabici CORE One+ Upgrade

KROK 39 Přilepení samolepky



- ◆ Sloupněte samolepku z modrého podkladu.
- ◆ Zarovnejte samolepku s nápisem **ONE** a jemně, ovšem pevně ji přitlačte.
- ◆ Opatrně odlepte průhlednou vrstvu a ujistěte se, že + drží na místě.

KROK 40 Je čas na Haribo



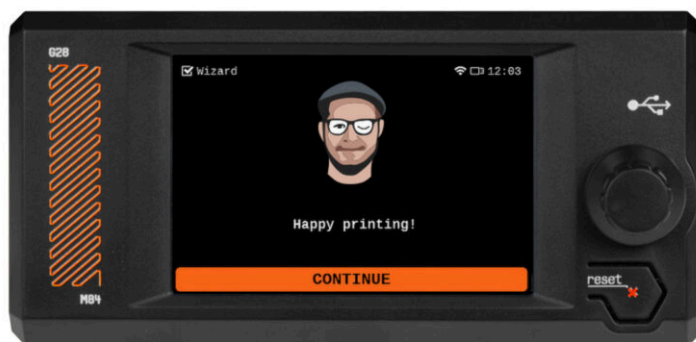
- ◆ Hard work deserves sweet results!
- ◆ Eat the seventh row.
- ⚠ But don't eat the rest yet.

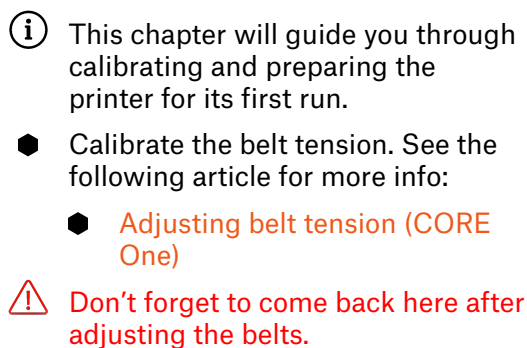
KROK 41 Hotovo



- Gratulujeme! Úspěšně jste sestavili vaši tiskárnu Prusa CORE One+.
- Let's move to the final chapter.

9. Calibration & First run





- For the next step, prepare:
 - O-kroužek
 - Spoolholder-static
- Držák cívký a O-kroužek jsou v jednom pytlíku.

KROK 3 Umístění tiskového plátu a držáku cívky filamentu

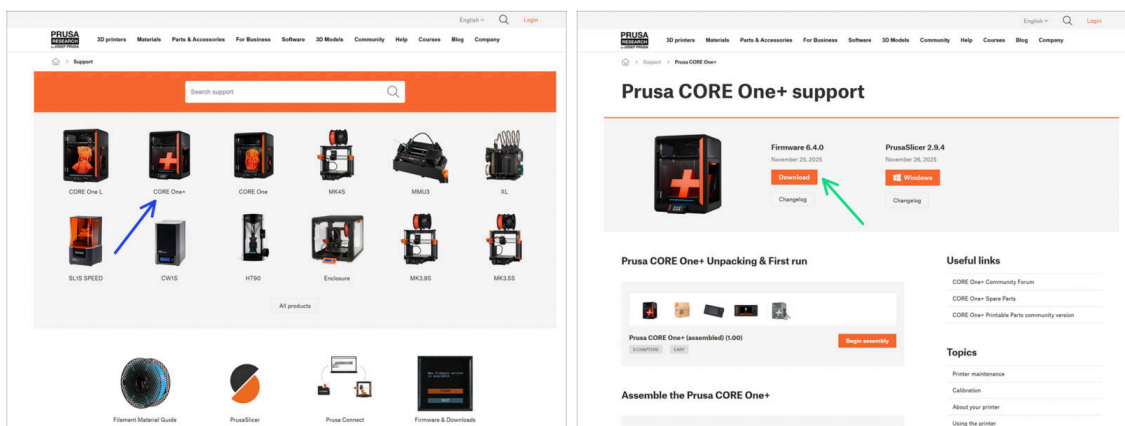


⚠ Ujistěte se, že na heatbedu nic není. Podložka musí být čistá. Jakékoli nečistoty mohou poškodit povrch heatbedu i tiskového plátu.

- ➊ **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!**

 - ➋ Keep the **print sheet** clean for optimum performance.
 - ➌ Nejčastějším důvodem odlepení výtisku od podložky je mastný nebo jinak špinavý tiskový plát. **Použijte IPA (Isopropylalkohol) pro jeho odmaštění**, pokud jste byli jen dotkli povrchu.
- ➍ Umístěte o-kroužek na díl Spoolholder-static.
- ➎ Zatlačte díl Spoolholder-static do doku dílu Puck-universal a uzamkněte ho otočením po směru hodinových ručiček.

KROK 4 Aktualizace firmwaru



i Všechny tiskárny dorazí s USB diskem, na kterém je nejnovější firmware. Doporučujeme však jednou za několik týdnů zkontrolovat a případně firmware zaktualizovat.

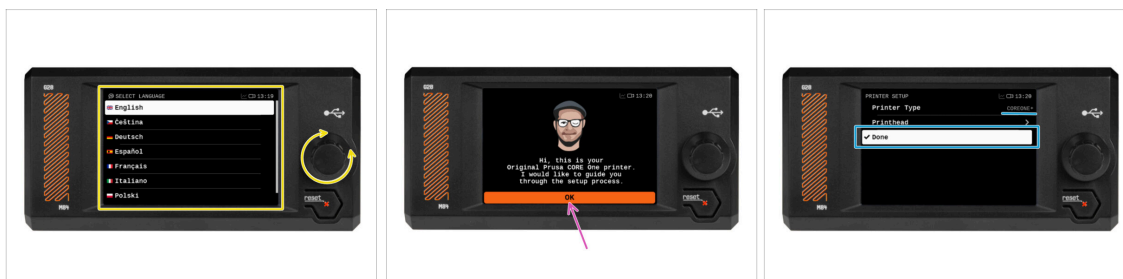
- ➋ Visit the help.prusa3d.com page.
- ➌ Přejděte na stránku Prusa CORE One+.
- ➍ Stáhněte nejnovější verzi firmwaru.
- ➎ Save the firmware file (*.bbf*) onto the *bundled USB drive*.

KROK 5 Zapnutí tiskárny



- ✿ 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.

KROK 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.
- ✿ Na další obrazovce se zobrazí výzva k výběru modelu tiskárny COREONE+. Pro pokračování klikněte na **Hotovo**.

KROK 7 Setting up the printer: Network setup



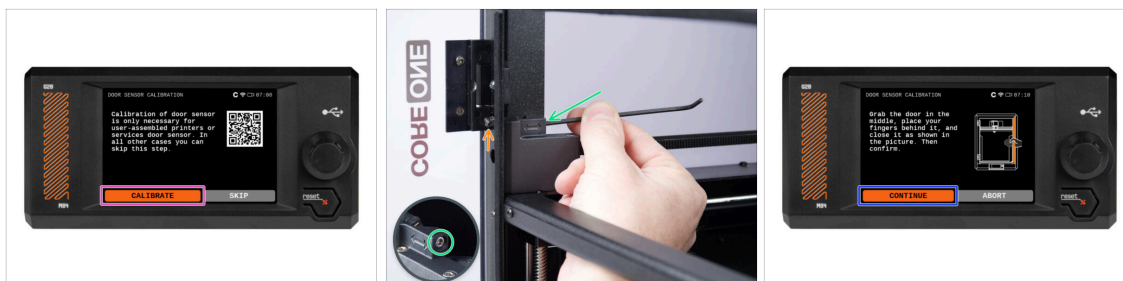
- The Network Setup screen will ask you to connect to a Wi-Fi network using our official Prusa mobile app.
- ① Read more on prusa.io/app.
- If you select **No**, the printer will show alternative ways to connect to Wi-Fi. This step is optional and can be done later.
- ① You can skip this screen and set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

KROK 8 Průvodce: Úvod



- 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!**

KROK 9 Wizard: Door Sensor Calibration



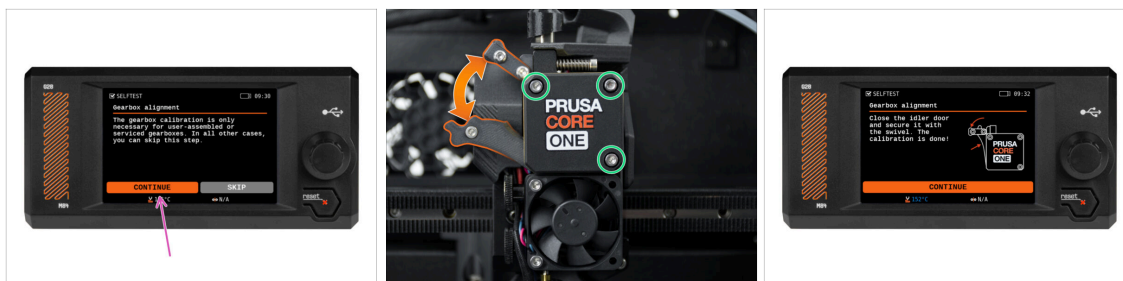
- ✿ The first part that requires your interaction is the door sensor calibration. To begin, hit **Calibrate** and follow the on-screen instructions.
- ✿ You'll be prompted to gradually tighten the sensor tension screw from its default loose position - usually in half-turn steps, possibly several times 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.

KROK 10 Průvodce: Test Loadcell senzoru



- ✿ 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**.

KROK 11 Průvodce: zarovnání převodovky



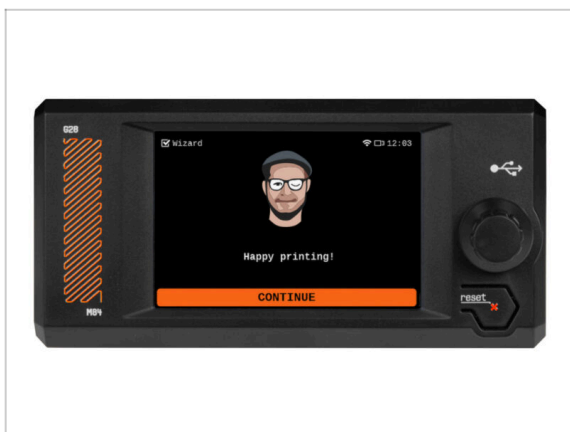
- ✦ Once you get to the Gearbox Alignment part, select **Continue** and follow the on-screen instructions.
- ✦ Make sure the idler lock (swivel) is unlocked from the idler door.
- ✦ Loosen the three screws on the front of the gearbox by 1.5 turns.
- ❗ The printer will go through the automatic gearbox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

KROK 12 Wizard: Filament Sensor Calibration



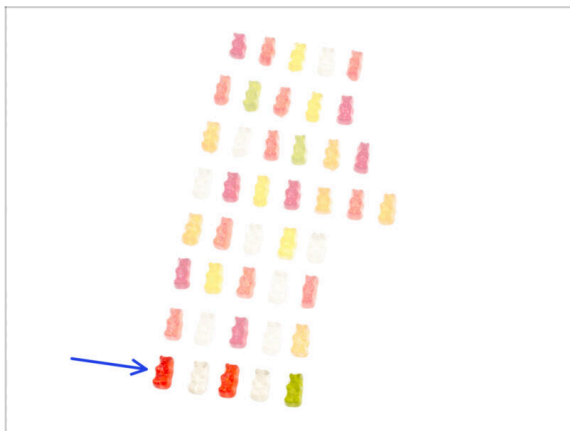
- ✦ Zkontrolujte ruční spínač na senzoru filamentu. **Ujistěte se, že je v poloze ON (zapnutý).**
- ✦ Pro kalibraci senzoru filamentu je nutné použít krátký kousek filamentu. Připravte si ho a následně zvolte **Pokračovat**.
- ❗ There should be no filament inside the extruder before the calibration process 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.

KROK 13 Průvodce dokončen



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

KROK 14 Je čas na Haribo!



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

KROK 15 Příručka 3D tiskaře



- 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.

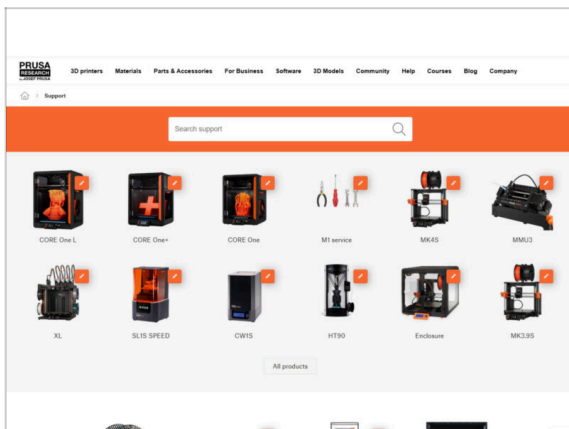


The latest version is always available at help.prusa3d.com.



Read the Disclaimer and Safety instructions chapters.

KROK 16 Centrum Nápořvědy

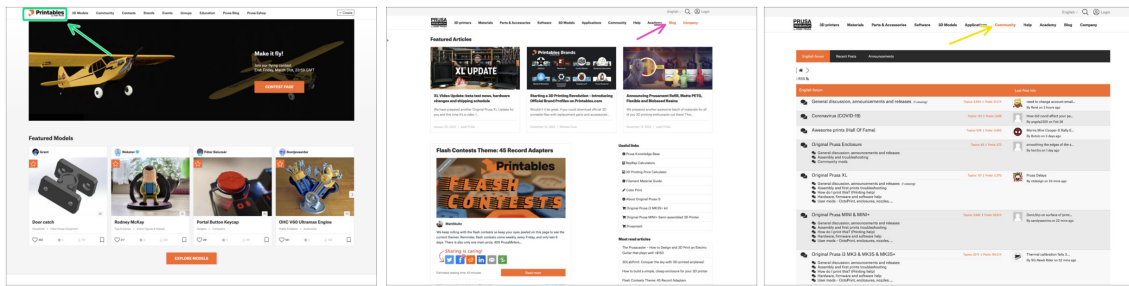


If you encounter any problems at all, don't forget you can always check out our knowledge base at help.prusa3d.com



We're adding new topics every day!

KROK 17 Přidejte se na 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.

Seznam změn v manuálu



KROK 1 Historie verzí



- ◆ **Verze manuálu pro stavebnici Prusa CORE One+:**
- ◆ 11/2025 - Úvodní verze 1.00

[illegible]

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

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.

