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1. Introduzione

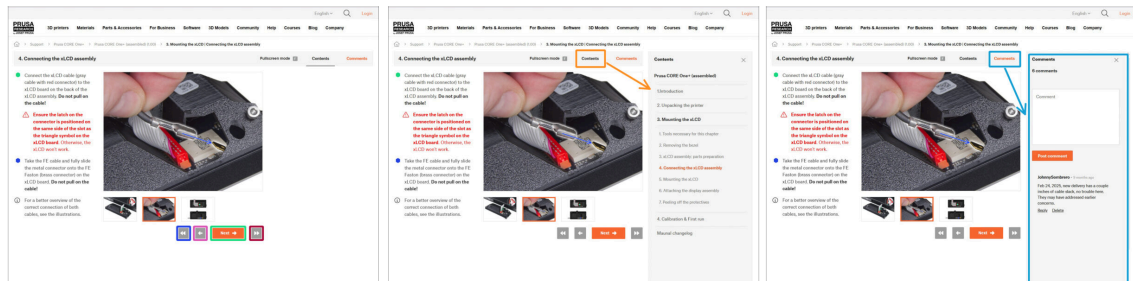


PASSO 1 Preparare il kit



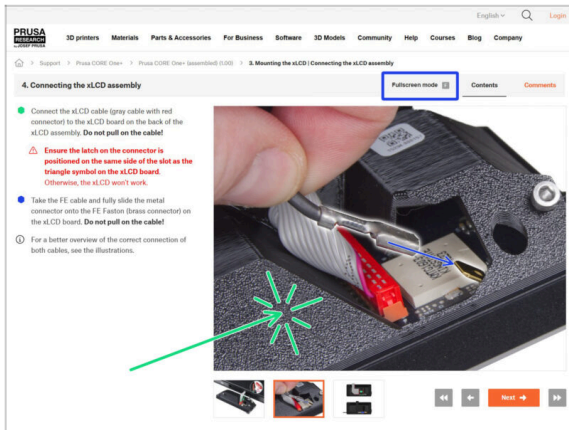
- Ciao, benvenuto nella guida di montaggio e configurazione del kit Prusa CORE One+. Segui questi passaggi per assicurarti che la tua stampante sia pronta per la prima stampa.**
- Prepara il kit ricevuto da Prusa Research.**
- Non è necessario saldare o crimpare i fili.**

PASSO 2 How to navigate through the manual



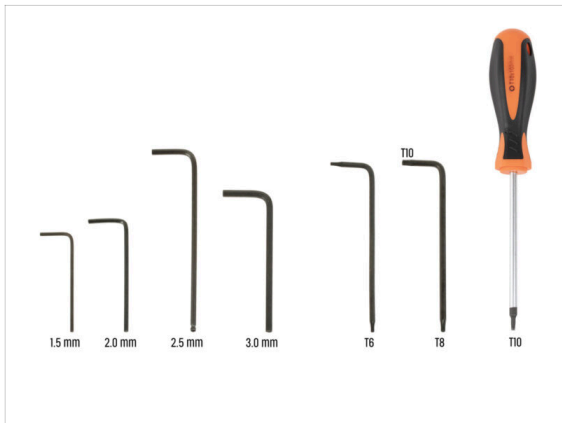
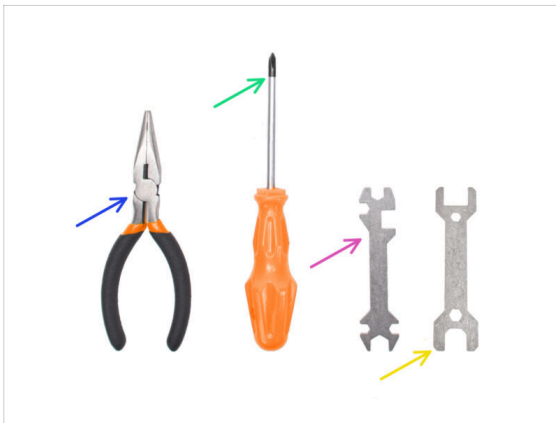
- Use the graphical navigation buttons in the bottom right corner or the arrow keys on your keyboard:**
- Pulsante Play indietro / Tasto freccia su** - Vai al passo precedente.
- Pulsante freccia sinistra / Tasto freccia sinistra** - Passa all'immagine precedente o alla fase precedente se si tratta della prima immagine della fase.
- Pulsante successivo / Tasto freccia destra** - Passa all'immagine successiva o alla fase successiva se si tratta dell'ultima immagine della fase.
- Pulsante Play Avanti / Tasto freccia giù** - Vai al passo successivo.
- 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.

PASSO 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.
- Clicca sull'immagine per aprirla ad alta risoluzione e vederla nel dettaglio.
- Clicca sulla **modalità a schermo intero** o premi il tasto F per massimizzare lo spazio sullo schermo e concentrarti completamente sulle istruzioni.

PASSO 4 All the required tools are included



● La confezione degli strumenti include:

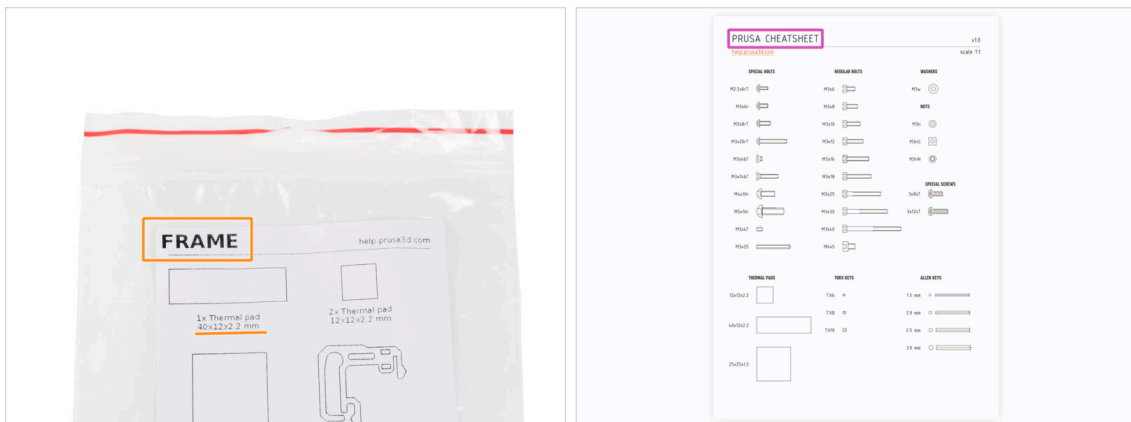
- Gli attrezzi si trovano nel pacchetto *Electronics & fasteners*.
- Pinza a becchi lunghi (1x)
- Cacciavite a stella PH2 (1x)
- Chiave universale (1x)
- Wrench size 13-16 mm (1x)
- Set di chiavi a brugola
- Set di chiavi Torx

PASSO 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):**
- ◆ Panni di carta o un pezzo di stoffa - Per pulire l'olio protettivo dalle barre lisce e dalla guida lineare.
- ◆ Forbici - Per tagliare la busta con i cuscinetti
- ◆ Lubrificante (incluso nel kit) - Per lubrificare l'ingranaggio planetario del Nextruder (testina di stampa).

PASSO 6 Guida alle etichette



- ◆ All the boxes and bags including parts for the build are labeled.
- ◆ Le etichette includono l'elenco dei contenuti e il numero di pezzi.
- ◆ Puoi scaricare il **Cheatsheet** (una scheda riassuntiva) con i disegni dettagliati delle viti dal nostro sito prusa.io/core-one-cheatsheet. Stampala al 100%, non ridimensionarla, altrimenti non funzionerà.
- i Per i veterani PRUSA: I dispositivi di fissaggio sono divisi in sacchetti individuali a seconda del tipo. Non in pacchetti per i singoli capitoli, come avveniva con le stampanti precedenti.
- P Le istruzioni indicheranno la confezione di ogni pezzo, tranne che per gli elementi di fissaggio, che si trovano sempre nella confezione Fasteners.

PASSO 7 Busta di componenti di scorta



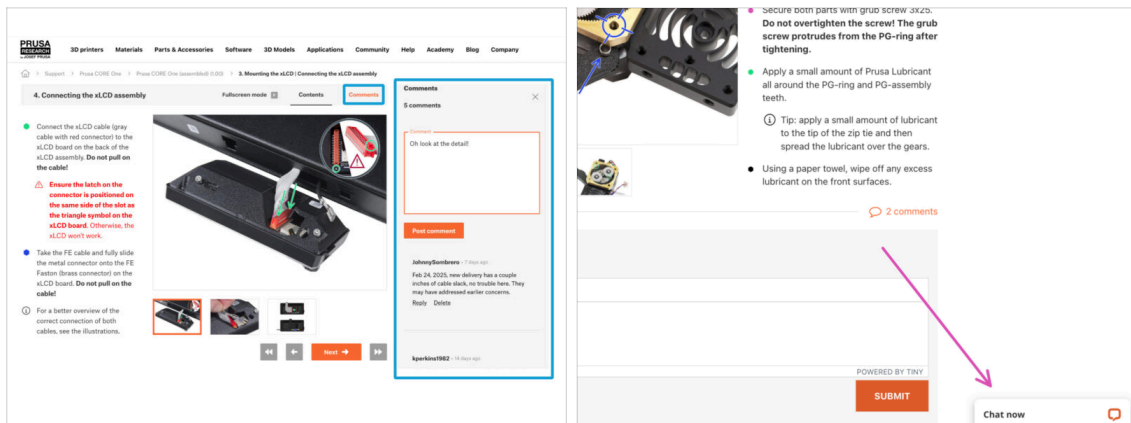
- ◆ Spare fasteners are included in each bag of fasteners. The amount of spare is always included in the total number shown on the bag.
- ◆ Allo stesso modo, alcune parti potrebbero avere un pezzo in più nella stessa busta.

PASSO 8 Printed parts - versioning



- ◆ La maggior parte dei componenti stampati in 3D su Prusa CORE One+ sono segnate con la loro versione.
 - ◆ **Serie E, F e Gx** (ad es. E1) - Queste parti sono stampate da Prusa Research e vengono distribuite con il kit.
 - ◆ **Serie R, S e Tx** (ad es. R1) - Queste parti sono disponibili su [printables.com](https://www.printables.com). Sono identiche a quelle di fabbrica.
 - ◆ I numeri indicano piccole modifiche che di solito riguardano dettagli del design. Un'etichetta diversa nel manuale (ad esempio, una versione diversa mostrata nelle foto) non cambia il montaggio: tutte le versioni sono perfettamente compatibili.
 - ◆ In ogni caso, se una revisione specifica richiede un modo diverso di montare il prodotto, lo scriveremo chiaramente nel manuale e spiegheremo le differenze.
- i 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.

PASSO 9 We are here for you!



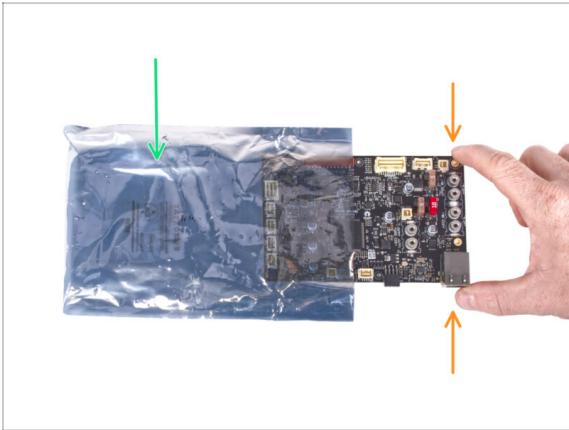
- Lost in the instructions, missing screw or cracked printed part? **Let us know!**
- Puoi contattarci attraverso i seguenti canali:
 - Utilizzando i commenti sotto ogni passo.
 - Utilizzando la nostra chat dal vivo 24 ore su 24, 7 giorni su 7, qui su help.prusa3d.com
 - Scrivendo una mail a info@prusa3d.com

PASSO 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:
 - **Il dado non entra:** usa una vite filettata per l'intera lunghezza (di solito M3x10, M3x18) e avvitala dal lato opposto dell'apertura. Stringendo la vite, il dado verrà tirato dentro. Rimuovi la vite alla fine dell'operazione.
 - **Il dado continua a cadere:** Usa un pezzo di nastro adesivo per fissare temporaneamente il dado in posizione, quando inserisci la vite potrai rimuoverlo. *Usare la colla è sconsigliato in quanto potrebbe raggiungere la filettatura e rendere impossibile stringere correttamente la vite.*
- Ogni volta che consigliamo di utilizzare la "tecnica del tiro della vite", ti verrà ricordato tramite l'avatar di Jo ;)
- ① Parts in the pictures are used as an example.

PASSO 11 Importante: Protezione dell'Elettronica



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

● Di seguito, alcuni **consigli per evitare danni all'elettronica**:

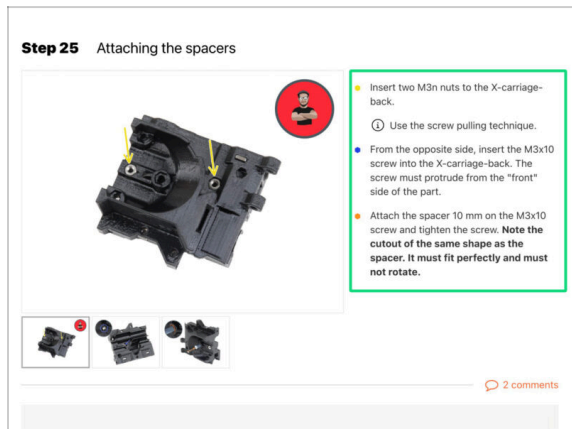
- **Lascia l'elettronica dentro la busta ESD** fino a quando non ti viene chiesto di installarla.
- **Maneggiando la scheda, toccane sempre solo i lati.** Evita di toccare i componenti sulla superficie.
- **Prima di toccare l'elettronica**, serviti di una struttura conduttiva (metallica) nelle vicinanze per eliminare l'eventuale carica statica delle tue mani.
- 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.

PASSO 12 Datti una ricompensa



- ◆ Montare la CORE One+ è un'esperienza gratificante. Dopo aver finito ogni capitolo, concediti una ricompensa. **Nella scatola c'è un sacchetto di orsetti Haribo proprio per questo!**
- ⚠ **Il problema principale secondo la nostra esperienza (MK4S, MK4, MK3S+, MK3S, MK3, MK2S, ...) è il consumo inadeguato di orsetti. Molti di voi non avevano abbastanza orsetti gommosi per tutti i capitoli, alcuni li hanno addirittura mangiati tutti prima di iniziare!**
- ◆ Dopo anni di approfondite ricerche scientifiche, siamo giunti a una soluzione => Al completamento di ciascun capitolo ti verrà comunicata l'esatta quantità di orsetti gommosi da consumare.
- ◆ Mangiare una quantità non corretta rispetto a quella prescritta nel manuale potrebbe causare un improvviso aumento di energia. Consulta un professionista nel negozio di caramelle più vicino.
- ⚠ **Hide the Haribo for now! From our experience, an unattended bag with sweets will suddenly disappear. Confirmed by multiple cases all around the World.**

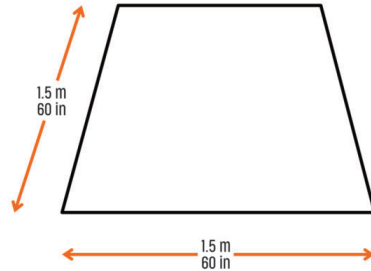
PASSO 13 How to successfully finish the assembly



⚠ Per completare correttamente il montaggio del kit CORE One+, segui tutte queste indicazioni:

- 🟢 **Leggi sempre prima tutte le istruzioni della fase in corso**, ti aiuteranno a capire cosa devi fare. Non tagliare o rifilare se non ti viene detto di farlo!!!
- ⬛ **Non seguire solamente le immagini!** Non è sufficiente. Le istruzioni scritte sono il più breve possibile. **Leggile!**
- ⬛ Leggi i commenti degli altri utenti, sono un'ottima fonte di idee. Anche noi li leggiamo e miglioriamo il manuale e l'intero processo di assemblaggio sulla base di questo feedback.
- ⬛ **Usa una forza ragionevole**, le parti stampate sono resistenti, ma non indistruttibili. Se non entra, rivaluta il tuo approccio.
- ⬛ **Eat the gummy bears as instructed!** Disobedience won't be tolerated :D
- ⬛ **Most importantly: Enjoy the build, and have fun.** Cooperate with your kids, friends or partners.

PASSO 14 Prepara la scrivania



- **Tidy up your desk!** Tidying up decreases the probability of losing small parts.
- **Libera l'area di lavoro.** Assicurati di avere abbastanza spazio. Un bel banco da lavoro libero e piatto ti permetterà di ottenere i risultati sperati.
- **Che ci sia luce!** Assicurati di essere in un ambiente ben illuminato. Una lampada o una torcia in più possono essere utili.
- Prepara qualcosa per contenere i sacchetti di plastica e i materiali di imballaggio rimossi, in modo da poterli riciclare in seguito. Assicurati che non vengano buttate parti importanti.
- Si consiglia uno spazio di lavoro minimo di 1,5 × 1,5 metri (60 × 60 pollici).
- ⚠ **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**

PASSO 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. Gruppo Base

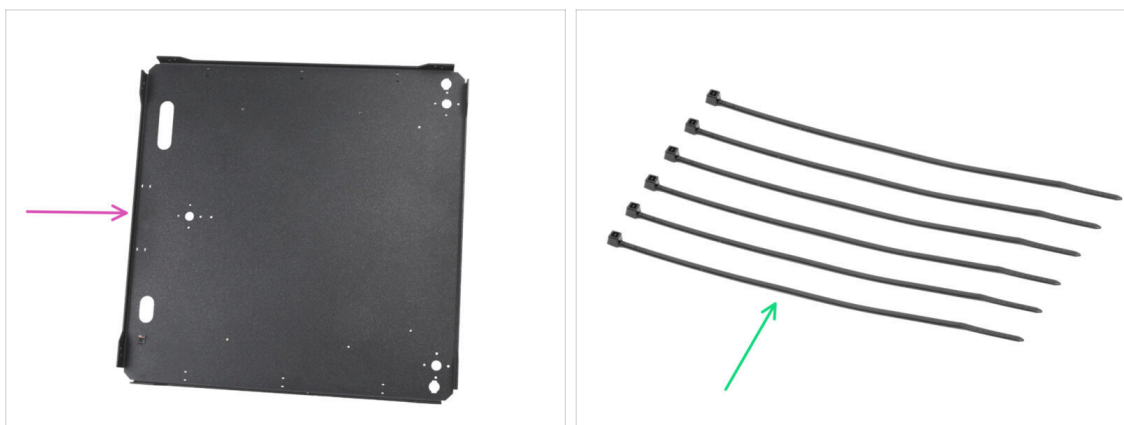


PASSO 1 Tools necessary for this chapter



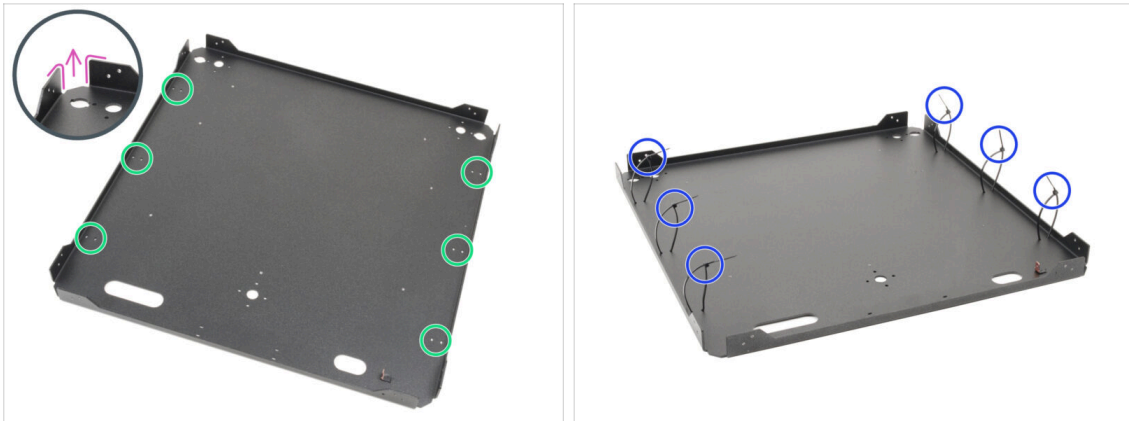
- For this chapter, please prepare:
- Chiave 13-16
- Chiave a brugola da 2.5mm
- T10 torx key / T10 torx screwdriver

PASSO 2 Base assembly: parts preparation



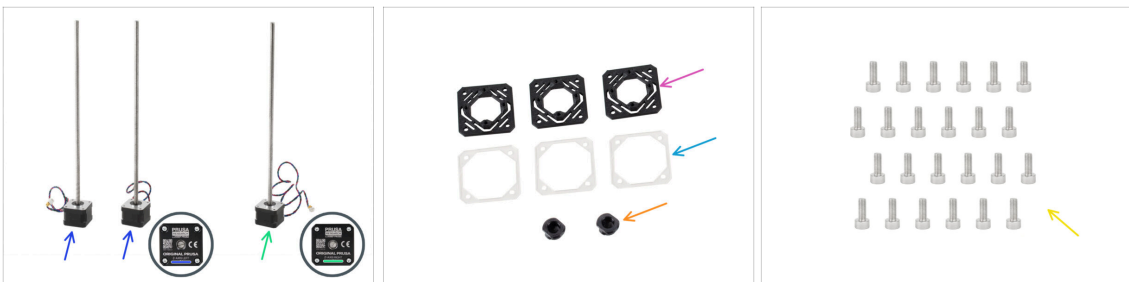
- For the following steps, please prepare:
- Bottom panel (1x) found in the Metal parts 1/3 package
- Zip tie (6x) found in the Electronics & Fasteners package

PASSO 3 Inserting the zip ties



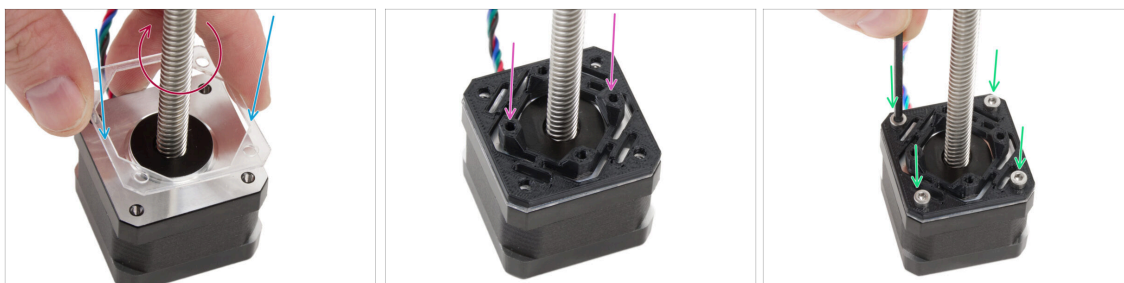
- ✎ Turn the bottom panel so that the bends of the plate are facing upwards.
- ✎ Note the twin holes for the zip ties around the perimeter of the panel.
- ✎ Insert six zip ties through the holes, placing them along both sides and partially tightening them, engaging only the first few teeth.
- ⚠ **Do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

PASSO 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.**
- ℹ 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*
- ✎ Vite M3x8 (24x)

PASSO 5 Installing the motor mounts



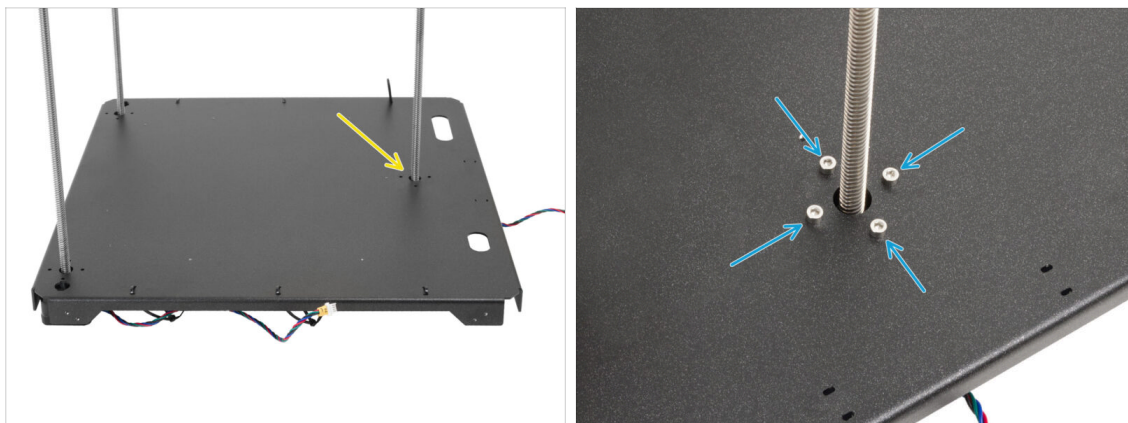
- 🔴 Try to rotate the threaded rods on each Z motor to make sure they are not completely blocked in rotation.
- 🔵 Attach one transparent motor washer pad on each Z motor.
- 🟣 Place one Z-motor-mount on each motor washer. **The protrusions on the part must be facing upwards.**
- ⬛ Align holes with all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

PASSO 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 :).

PASSO 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.

PASSO 8 Installing the front motor right



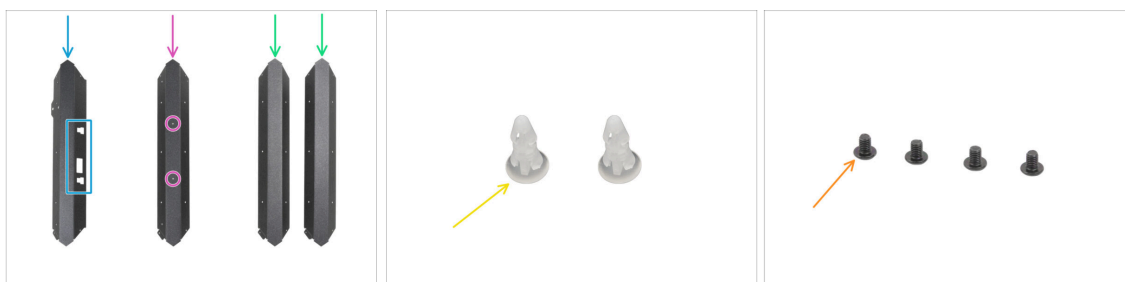
- ✦ First, insert the rod-mount into the opening next to the front right Z motor.
- ✦ Use the 13-16 wrench to rotate the rod mount 90 degrees, locking it into place.
- ✦ Secure the motor using four M3x8 screws. Tighten them completely.
 - ⚠ Make sure the screws stay straight and do not tilt as you tighten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

PASSO 9 Installing the front motor left



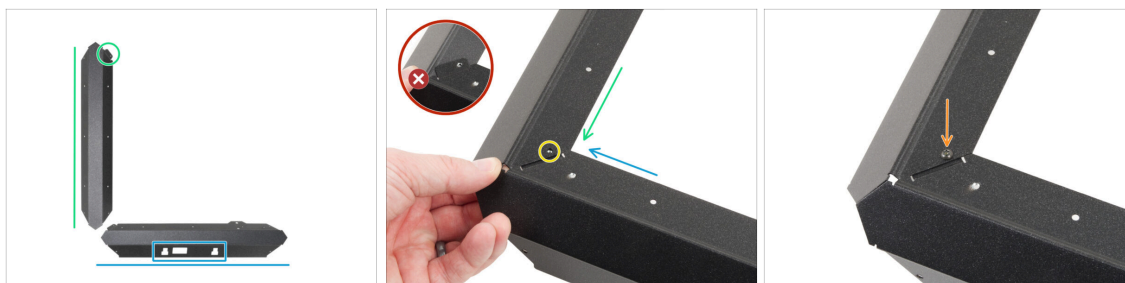
- Let's move to the front left motor (from the front view).
- ⚠ Ensure, the motor cable still points to the rear side.
- Insert the rod-mount into the opening next to the front right Z motor.
- Use the 13-16 wrench to rotate the rod mount 90 degrees, locking it into place.
- Secure the motor using four 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.

PASSO 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
- Vite M3x4rT (4x)

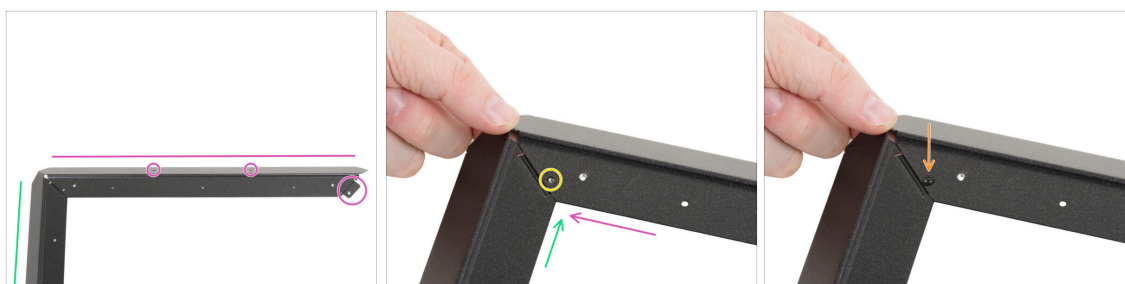
PASSO 11 Assembling the bottom profile: front + left



 Presta molta attenzione quando maneggi le parti in lamiera taglienti per evitare lesioni o danni.

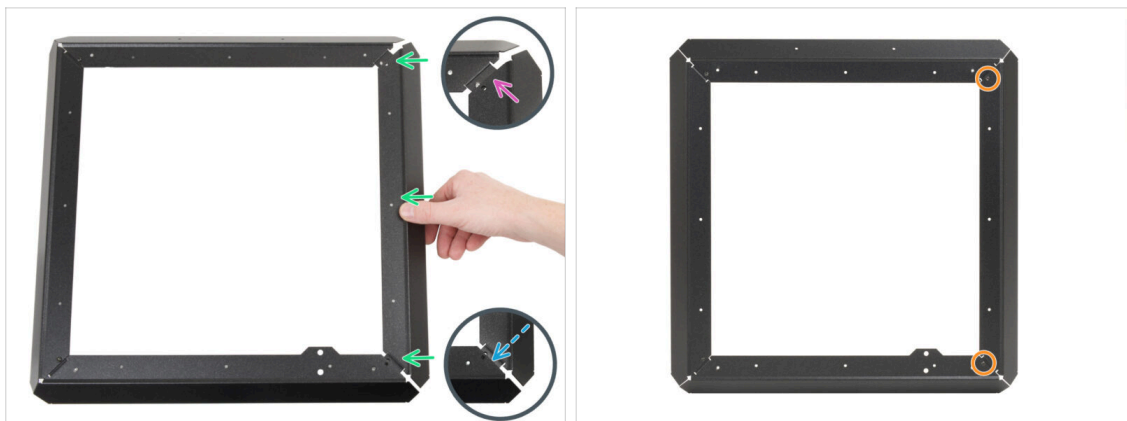
-  Place the front profile according to the picture. The cutouts must be facing you.
-  Place one of the universal profiles on the left side. Orient the part according to the picture. **Use the flange as a guide.**
-  Attach the two profiles together.
-  **The flange of the front plate (blue arrow) must 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.

PASSO 12 Assembling the bottom profile: left + rear



-  In base all'immagine, posiziona il profilo posteriore (con due fori sul lato piatto) sul profilo universale sinistro. Orienta il pezzo secondo l'immagine. **Usa la flangia come riferimento.**
-  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.

PASSO 13 Assembling the bottom profile: right



- Metti il profilo destro universale tra il profilo posteriore e quello anteriore.
Assicurati che:
 - 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.

PASSO 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.

PASSO 15 Anti-vibration feet: parts preparation



● For the following steps, please prepare:

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

PASSO 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.

⚠ Rimuovi con cautela **solo la pellicola protettiva** da ogni piedino antivibrante. Se lo strato adesivo inizia a staccarsi insieme alla pellicola, fermati e prova a staccarla da un altro angolo.

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

PASSO 17 Installing the bottom frame



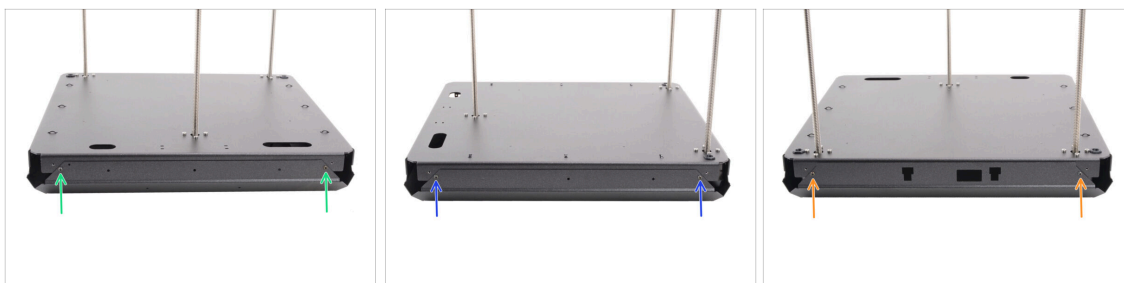
- 🔵 Turn the bottom frame upside down. **The front profile must be facing you.**
- 🟡 Attach the rear side of the bottom panel assembly to the rear side of the bottom frame.
 - 🟠 Ensure that the front side of the bottom panel assembly (with two motors) aligns with the front profile of the bottom frame (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.**

PASSO 18 Mounting the bottom frame: right side



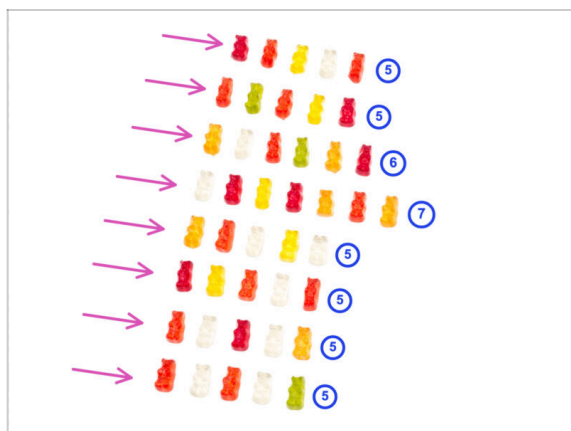
- ⬛ Focus on the front right corner and right side.
- 🟡 Slightly lift one of the corners of the bottom panel assembly.
- 🟢 Align the threaded hole in the bottom panel with the hole in the profile.
- 🟢 Join both parts together with the M3x4rT screw.
- ⬛ Move to the rear corner of the right side.
- 🟣 Align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

PASSO 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.

PASSO 20 È l'ora delle 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.

PASSO 21 Fatto

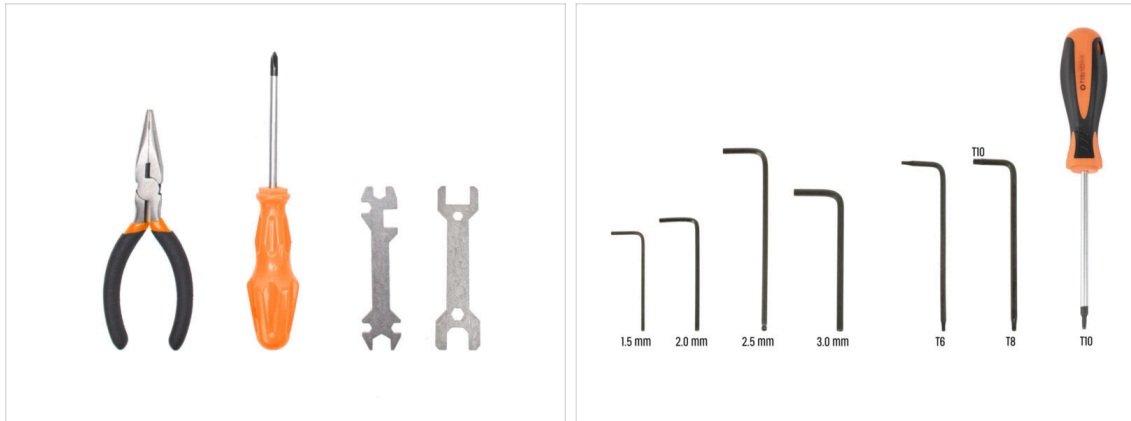


- **Congratulations!** You just assembled the **base assembly**.
- Set the assembly aside for now and let's move to the next chapter.

3. Assemblaggio posteriore

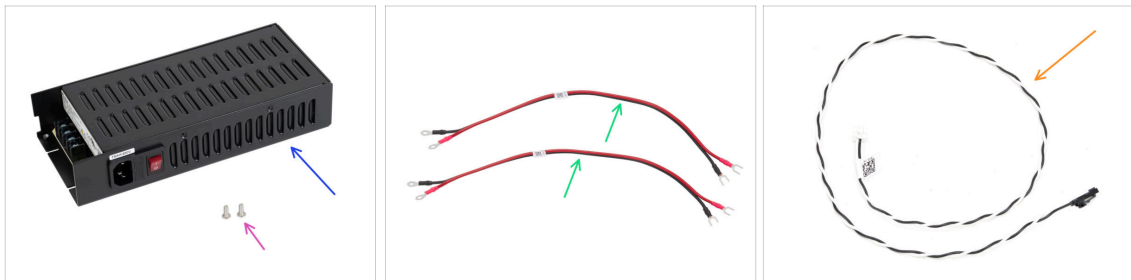


PASSO 1 Tools necessary for this chapter



- **For this chapter, please prepare:**
- Cacciavite a stella PH2
- Pinza a becchi lunghi
- Chiave a brugola da 2.5mm
- T10 torx key / T10 torx screwdriver

PASSO 2 PSU assembly: parts preparation



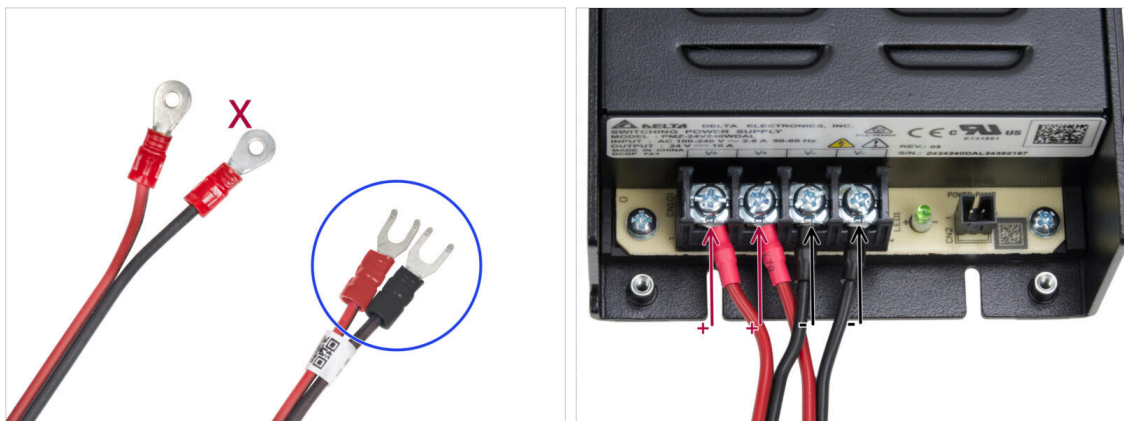
- **For the following steps, please prepare:**
- Delta PSU 240 W 24 V (1x) *power supply*
- M4x6r screw (2x) *from the Fasteners 3/3 package*
- xBuddy power cables (2x) *found in the Electronics package*
- Power panic cable (1x) *found in the Electronics package*

PASSO 3 Preparare l'alimentatore



- 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.

PASSO 4 Informazione sui cavi di alimentazione



- i** 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:**

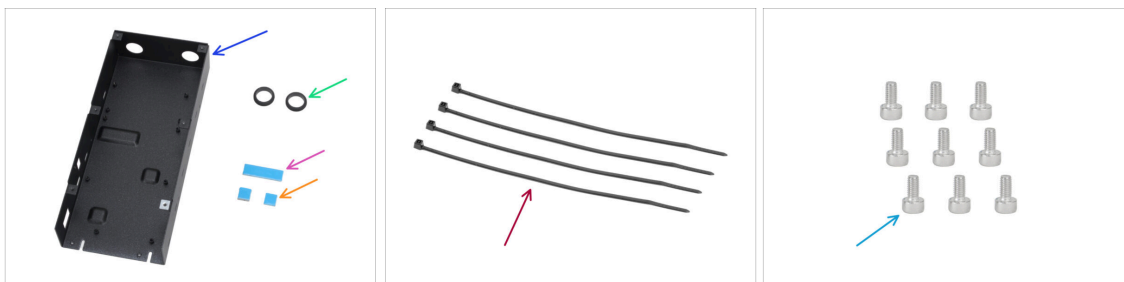
 - Positivo (V+)
 - Positivo (V+)
 - Negativo (V-)
 - Negativo (V-)
- i** The red cable (positive) may have a black stripe on it. Similarly, the black cable (negative) can have a red stripe on it.
- ⚠** **Do not connect any cables yet, wait until you have been prompted.**

PASSO 5 Connettere l'unità di alimentazione



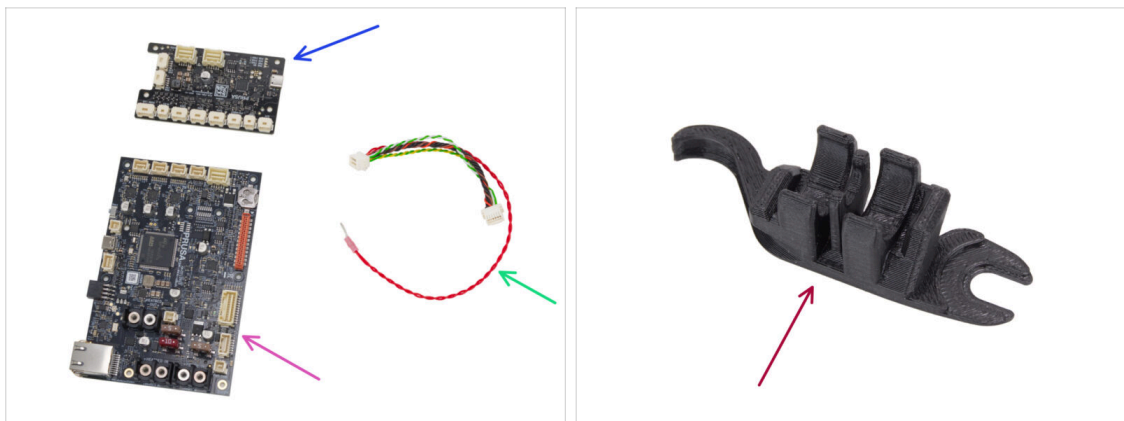
- Take the RED wire and slide the fork connector all the way into the first (positive) terminal from the left on the bottom of the PSU. Make sure the steel washer is above the "fork" connector.
- Tighten the terminal screw firmly.
- Use the same procedure to connect the second red wire to the second 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.

PASSO 6 xBuddy: parts preparation I.



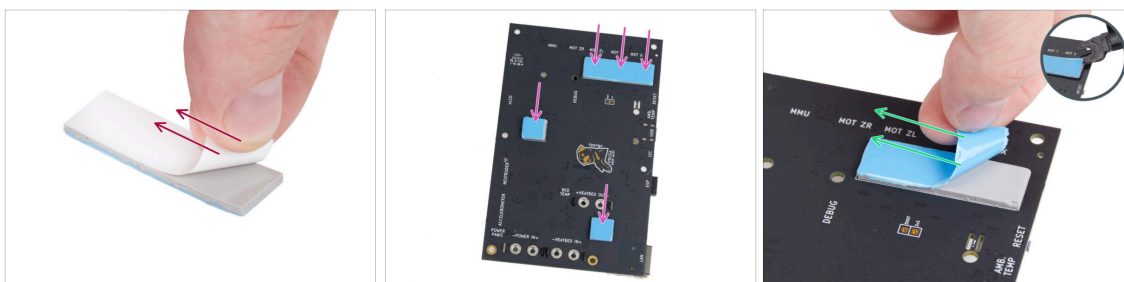
- For the following steps, please prepare:**
- CORE One xBuddy box (1x) found in the Metal parts 3/3 package
- Grommet 19/16 mm (2x) found in the Electronics & Fasteners package
- Thermal pad 40x12x2.2 mm (1x) found in the Electronics & Fasteners package
- Thermal pad 12x12x2.2 mm (2x) found in the Electronics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

PASSO 7 xBuddy: parts preparation II.



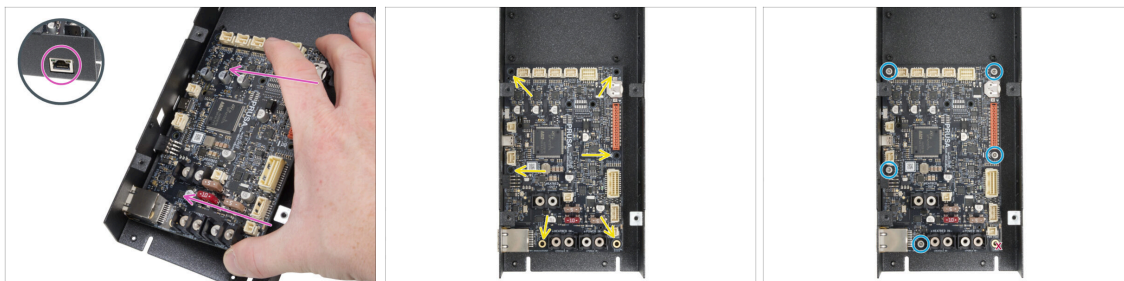
- xBuddy extension board (1x) found in the *Electronics & chamber package*
- xBuddy board (1x) found in the *Electronics package*
- xBuddy extension cable (1x) found in the *Electronics & Fasteners package*
- Assembly-multi-tool (1x) found in the *Printed parts package*

PASSO 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.

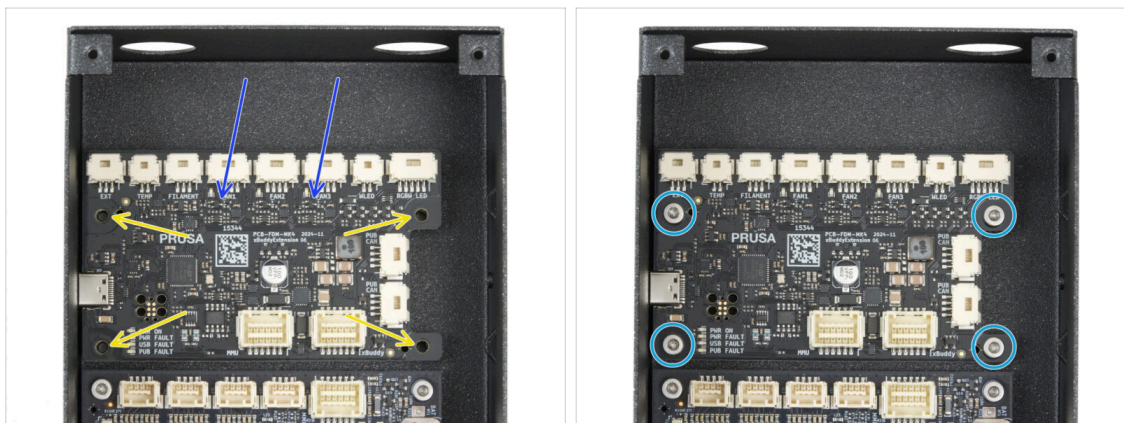
PASSO 9 Installare la xBuddy



⚠ 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.

PASSO 10 Installing the xBuddy extension



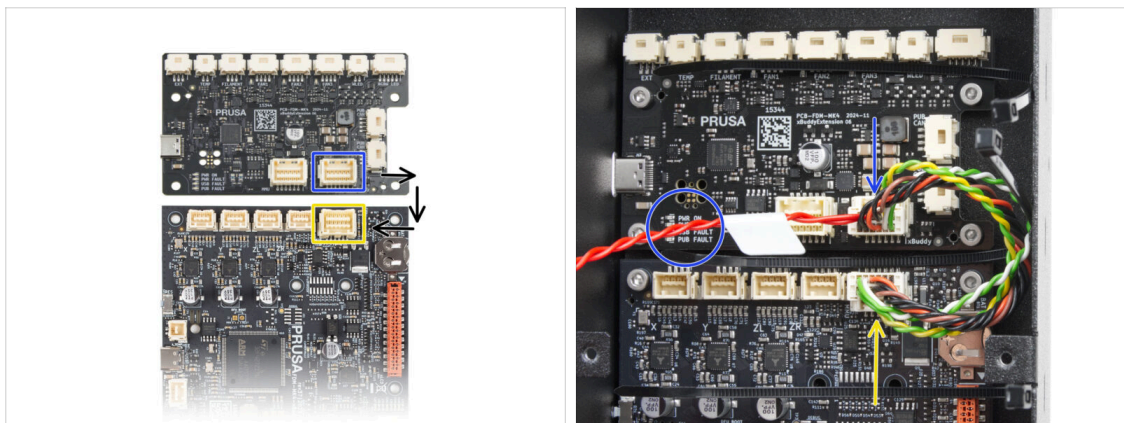
- ✿ Insert the xBuddy extension board to the xBuddy box above the xBuddy board. Notice the part orientation.
- ✿ Before fully attaching it completely, center the holes in the board with the holes (columns) in the xBuddy box.
- ✿ Fix the position of the xBuddy extension board by inserting four M3x6 screws.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

PASSO 11 Installazione delle fascette



- 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.

PASSO 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.

PASSO 13 Inserting grommets: xBuddy box



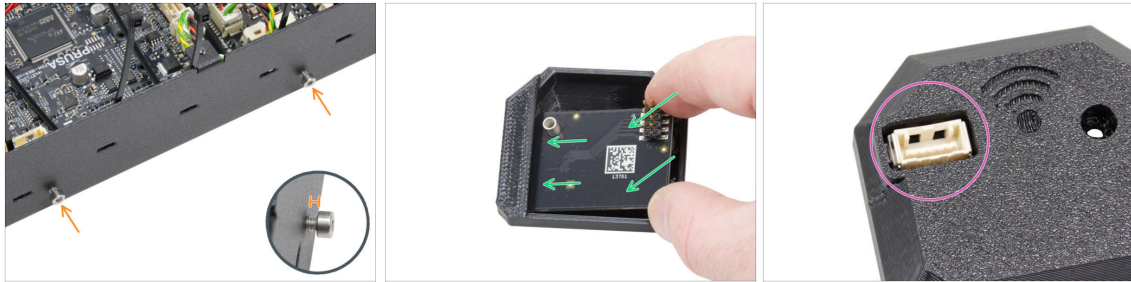
- Insert both grommets into both circle holes in the xBuddy box.
- Gently compress the grommet and fit it into the metal sheet, ensuring the groove locks into place

PASSO 14 Wi-Fi: preparazione dei componenti



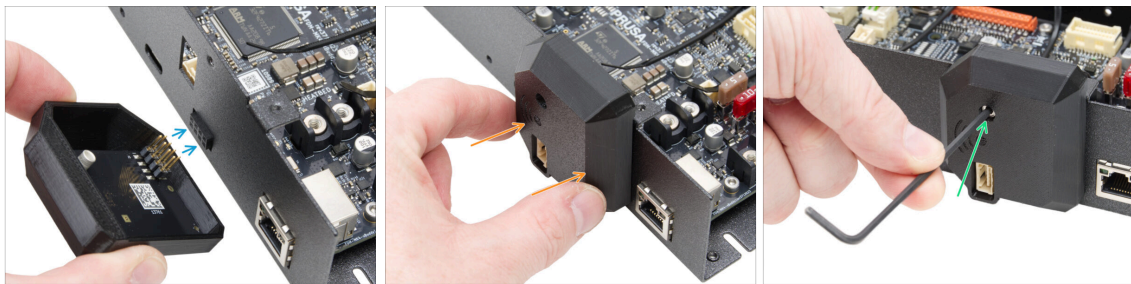
- **For the following steps, please prepare:**
- ESP-WiFi (1x) *found in the Electronics package*
- CORE-One-Wifi-cover (1x) *found in the Printed parts package*
- Vite M3x12 (1x)
- Vite M3x6 (2x)

PASSO 15 Assemblare il Wi-Fi



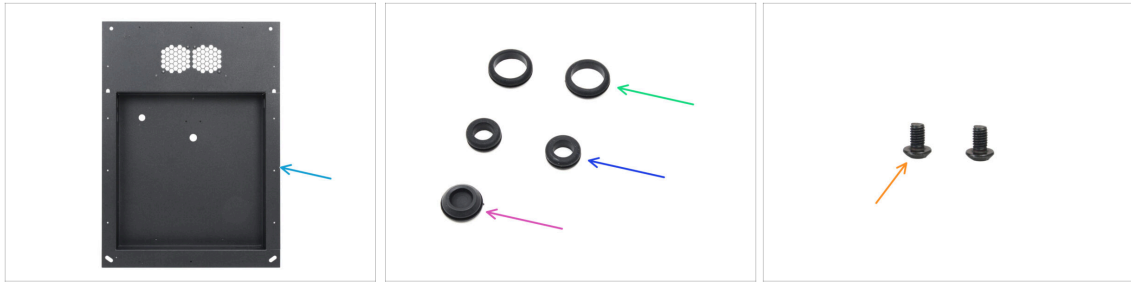
- ✚ Insert two M3x6 screw to the xBuddy box assembly from the right side. **Do not tighten them completely.** Leave at least a 4 mm (0.16 in) gap.
- ✚ Insert the ESP-WiFi module into the WiFi-cover, positioning it just below the bridge on the left side.
- ✚ On the other side, ensure the connector fits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

PASSO 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.

PASSO 17 Back panel: parts preparation



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

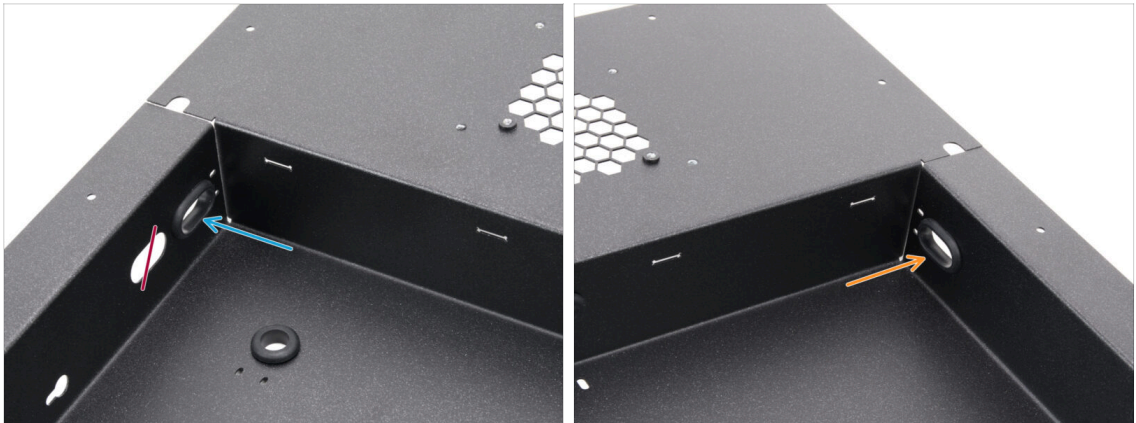
- Back panel (1x) *found in the Metal parts 1/3 package*
- Grommet 19/16 mm (2x) *large one - found in the Electronics & Fasteners package*
- Grommet 13.5/10 mm (2x) *small one - found in the Electronics & Fasteners package*
- Sealing plug 15.5 mm (1x) *found in the Electronics & Fasteners package*
-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

PASSO 18 Installing grommets: back panel top



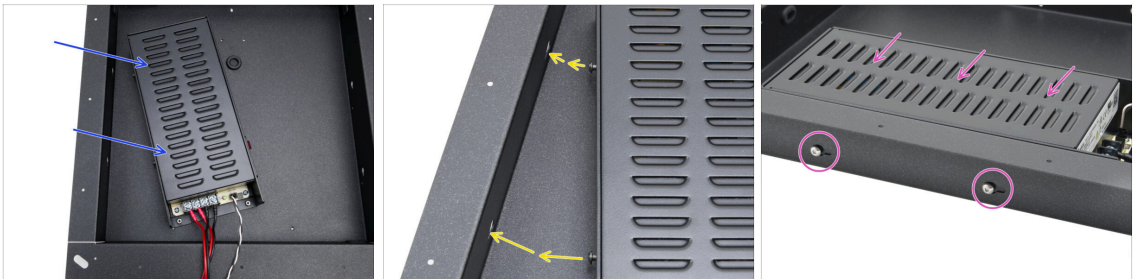
- Position the back panel as shown in the first image. Use the two oval holes as a reference.
- Insert the sealing plug into the center hole.
 - **The sealing plug is not symmetrical.** Insert the side with the smaller diameter facing downward.
- Insert one small grommet to the left circle hole.
- Insert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

PASSO 19 Installing grommets: sides + bottom



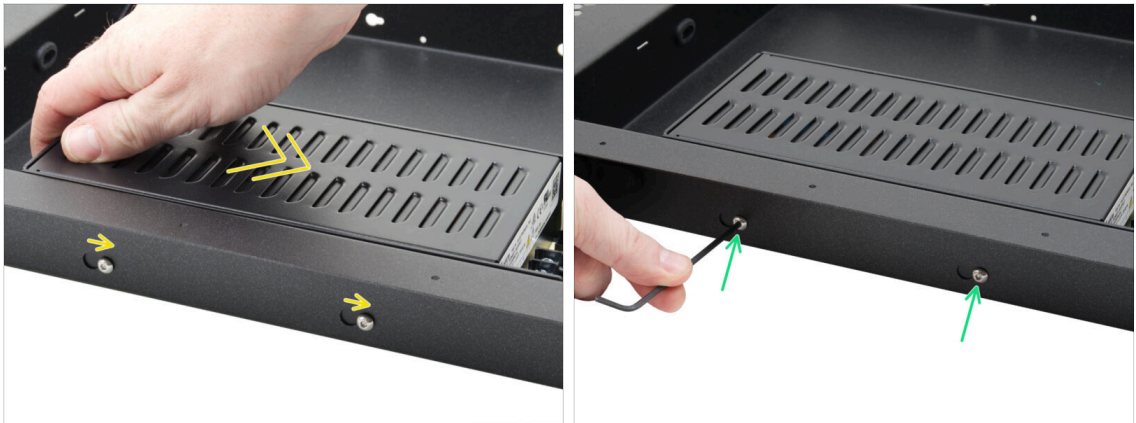
- Focus on the left top side of the back panel and locate two oval holes.
- Insert one large grommet into the oval hole closest to the corner.
- Move to the right top side of the back panel and insert one large grommet to the oval hole.

PASSO 20 Allineamento dell'alimentatore



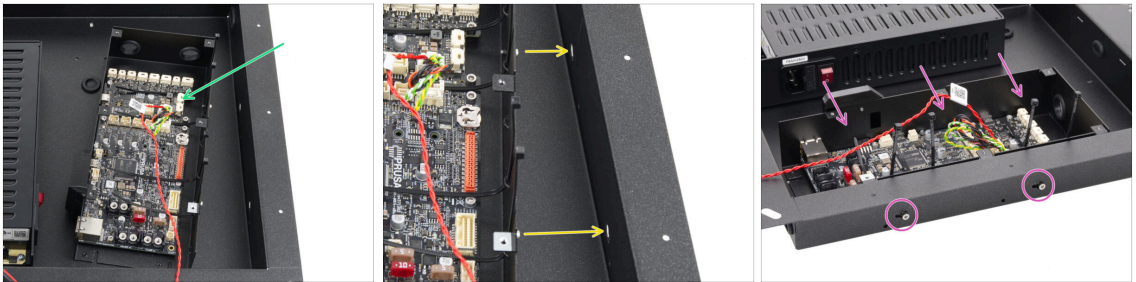
- Carefully insert the PSU into the rear panel pocket.
- Align the screws on the PSU to the holes on the left side of the back panel.
- Slide the PSU so that the screws go through the holes.

PASSO 21 Montaggio dell'alimentatore



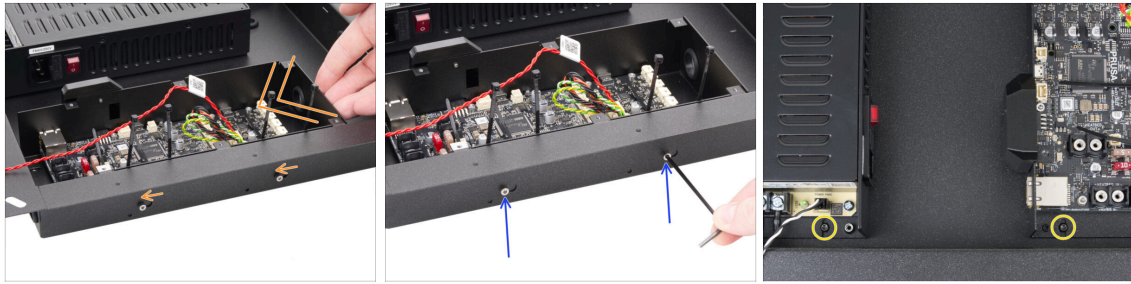
- Gently slide the PSU so that the position of the screws moves to the end position of the keyhole-shaped holes.
- Maintain the PSU position and fully tighten both screws.

PASSO 22 Aligning the xBuddy box assembly



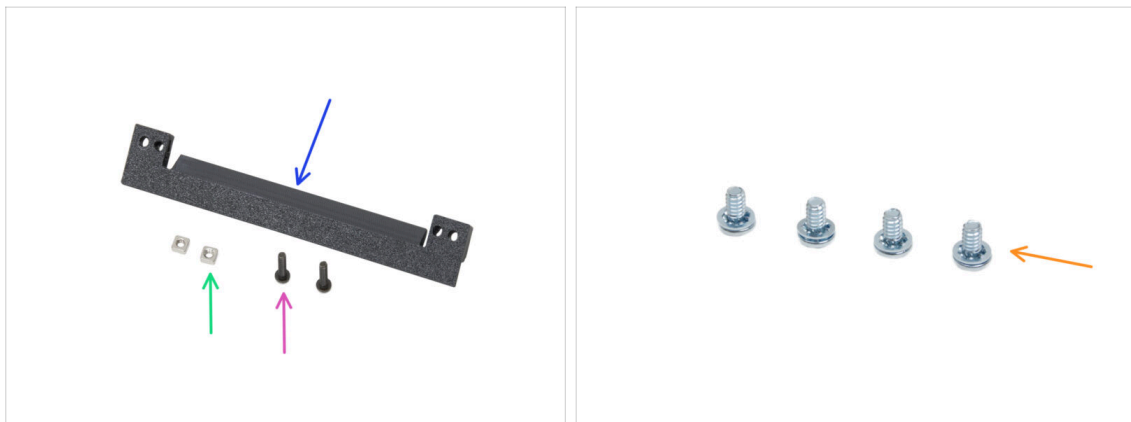
- Carefully insert the xBuddy box assembly into the rear panel pocket.
- Align the screws on the xBuddy box to the holes on the right side of the back panel.
- Slide the xBuddy box so that the screws go through the holes.

PASSO 23 Mounting the xBuddy box



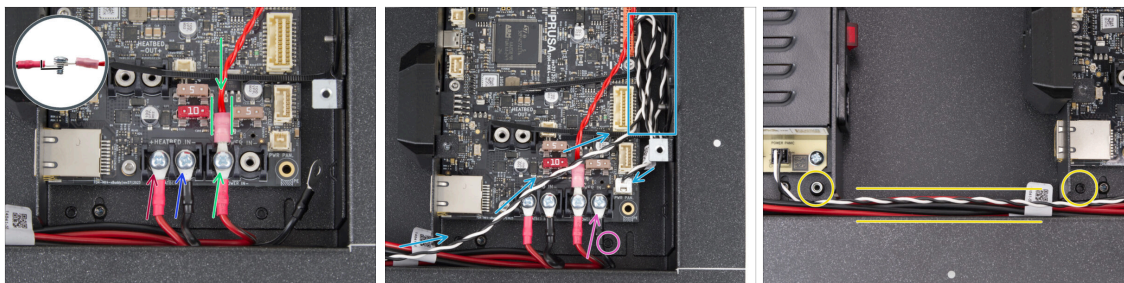
- Gently slide the xBuddy box assembly so that the position of the screws moves to the end position of the keyhole-shaped holes.
- Maintain the xBuddy box position and fully tighten both screws.
- Fix the PSU and xBuddy box assembly to the back panel by tightening two M3x4rT screws.

PASSO 24 Power cables cover: parts preparation



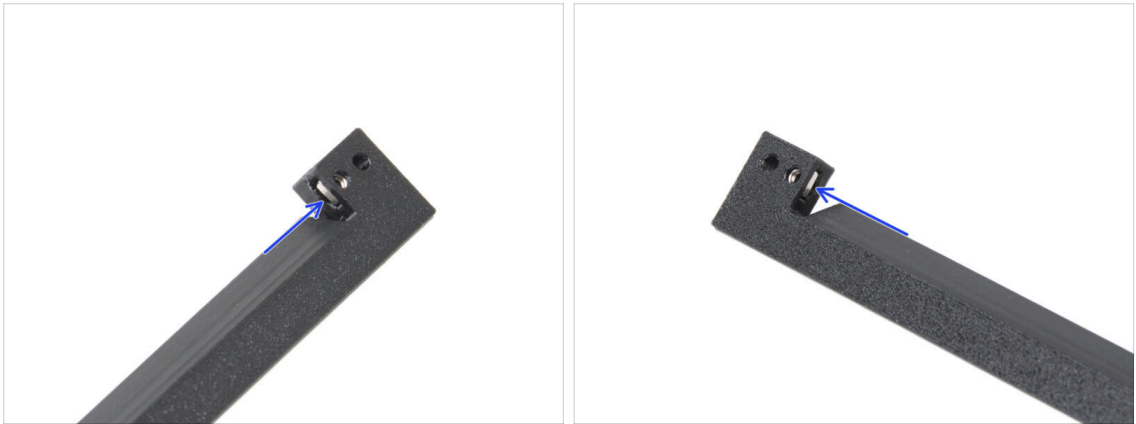
- ⬛ **For the following steps, please prepare:**
- PSU-cable-cover (1x) *found in the Printed parts package*
- Dado M3nS (2x)
- Vite M3x10rt (2x)
- 6-32 Power Terminal Screw (4x)

PASSO 25 Connecting the power cables



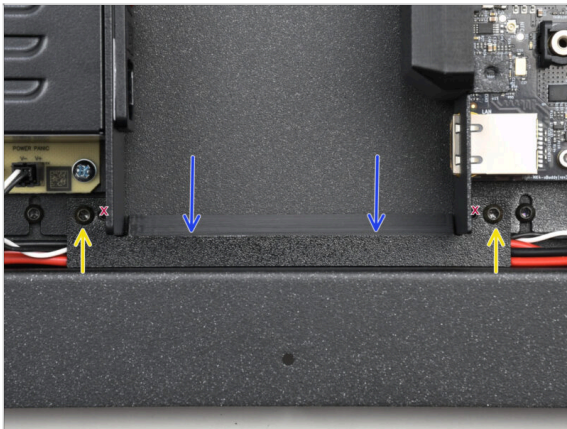
- ◆ Take one red cable leading from the PSU and connect it to the first left terminal slot on the xBuddy board using the 6/32" terminal screw. Tighten it firmly but gently.
 - ⚠ **Note that the "L" shape of the cable connector must always "undercut" the head of the terminal screw.**
- ◆ Connect the black 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.
- (i) **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.

PASSO 26 Preparazione della copertura del cavo dell'alimentatore PSU-cable-cover



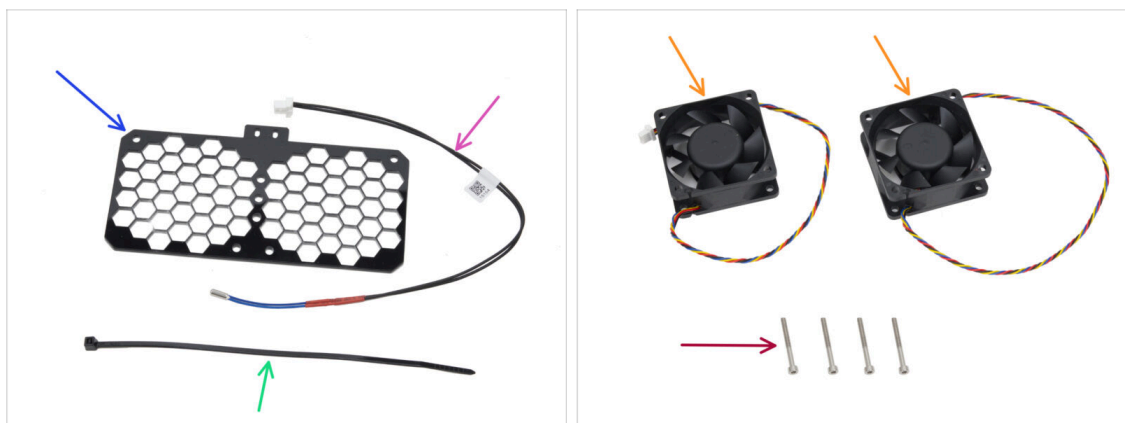
- Insert one M3nS nut into the hole on each end of the PSU-cable-cover.
- Ensure the holes are aligned.

PASSO 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.

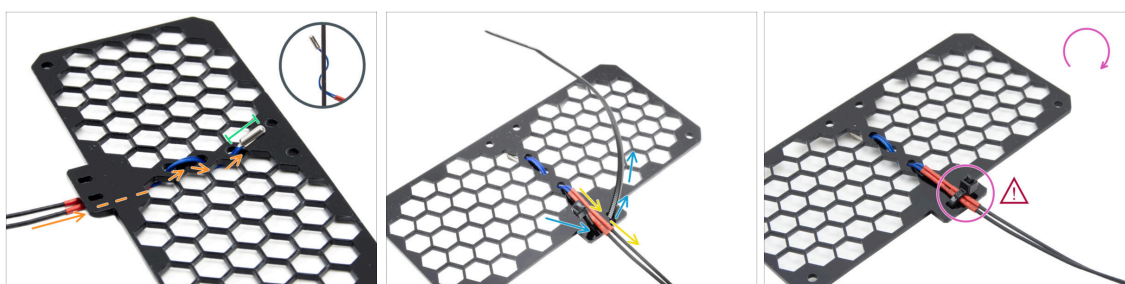
PASSO 28 Chamber fans: parts preparation



● 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
- Fascetta (1x)
- Cooling fan (2x) found in the Electronics & Chamber parts package
- Vite M3x30 (4x)

PASSO 29 Assembling the fan grid



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

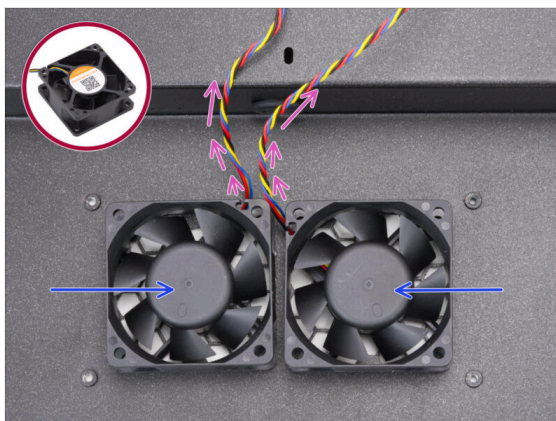
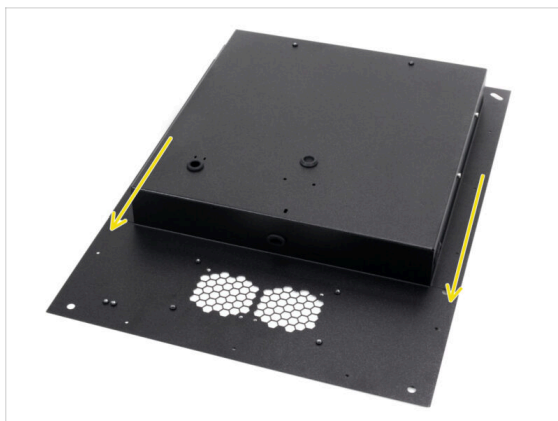
❗ The grid has both sides the same.

- 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.**

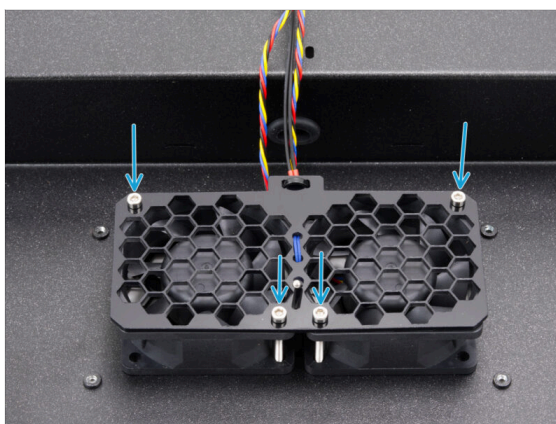
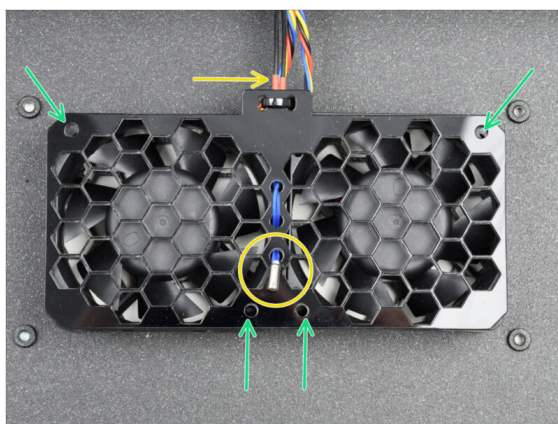
- Put the assembly aside for a while.

PASSO 30 Montaggio delle ventole



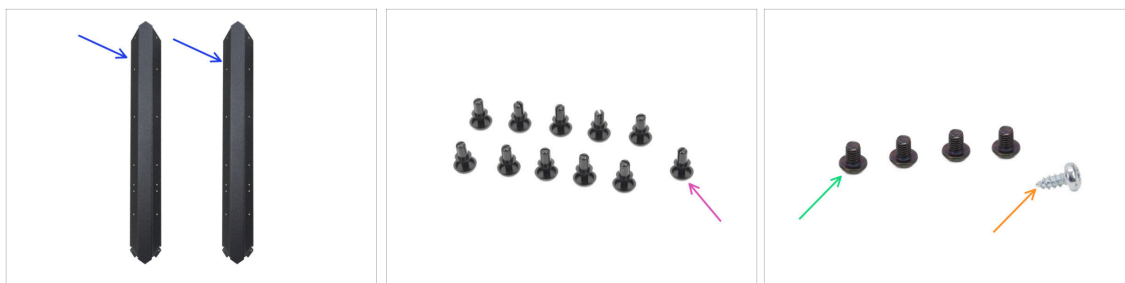
- ✦ Place and orient the back panel according to the picture. The grid cutouts must be facing you.
- ✦ Place both fans to the grid in the back panel.
 - ⚠ **The side of the fan without the sticker must be facing up.**
 - ✦ Orient the fans so that the cables run from the corners in the centre.
 - ⬛ Let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

PASSO 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.**

PASSO 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.

- Rivetto in nylon (11x)
- Vite M3x4rT (4x)
- 2.9x6.5sT self-tapping screw (1x) from the *Electronics and Fasteners Package*

PASSO 33 Installing the rear profiles



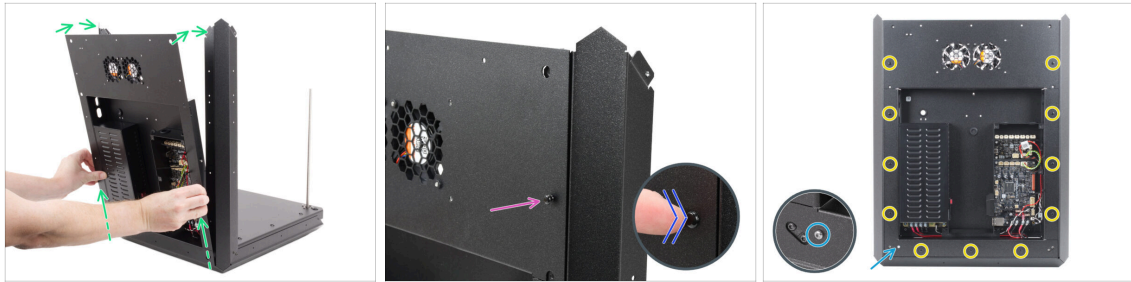
- Take the bottom assembly and turn it so the rear side (with one motor in the center) faces you.



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

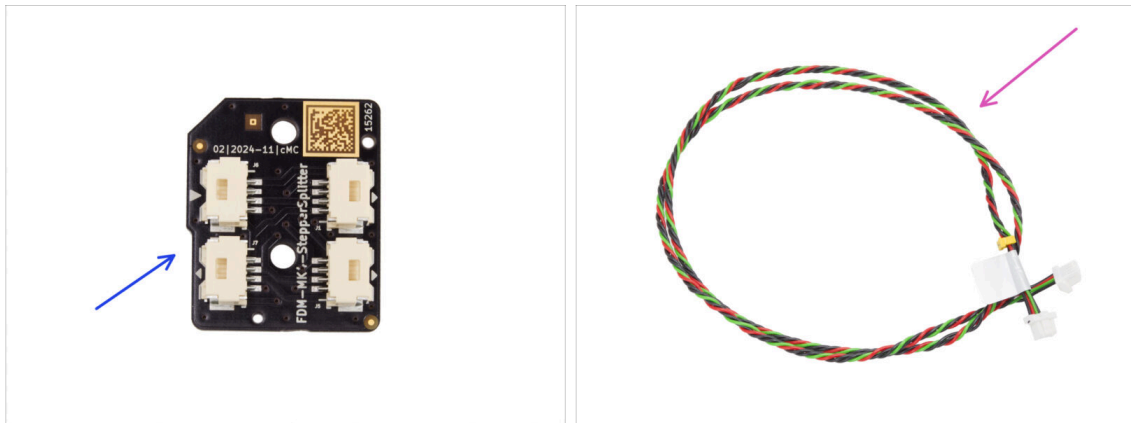
- Attach the rear profile to the right corner, using the **end without flanges**.
- Align the hole on the rear side and secure it with the M3x4rT screw.
- Secure the corner on the other side with a second M3x4rT screw - each corner will be secured with two M3x4rT screws.
- Proceed the same with the second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

PASSO 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.

PASSO 35 Stepper splitter: parts preparation



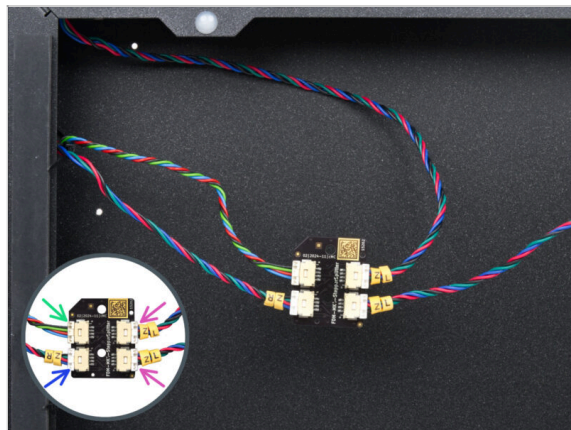
-  **For the following steps, please prepare:**
-  Stepper splitter (1x) *found in the Electronics & Chamber parts package*
-  Stepper splitter cable (1x) *found in the Electronics & Fasteners package*

PASSO 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.**

PASSO 37 Connecting the Stepper splitter



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

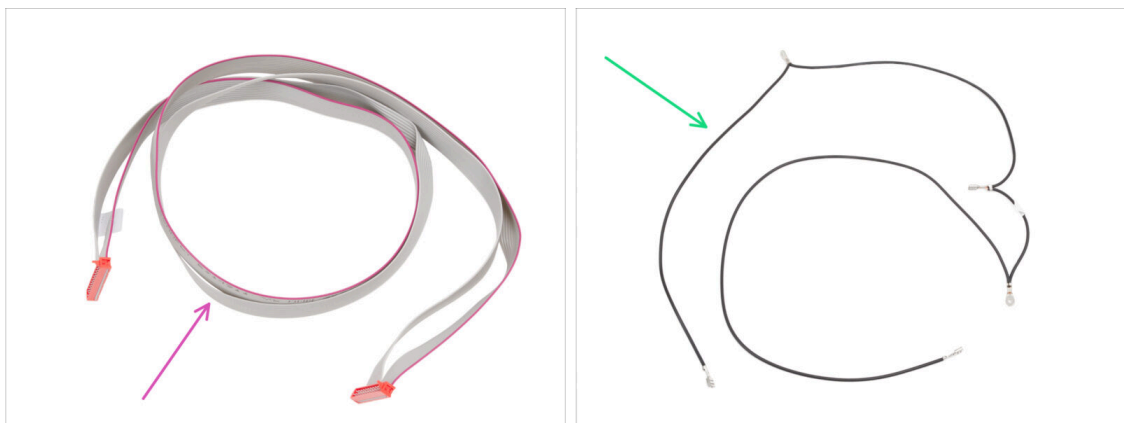
- Cavo sdoppiatore per stepper
- Motore asse Z R
- Motore asse Z L
- Motore asse Z L

PASSO 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.

PASSO 39 LCD cable: parts preparation



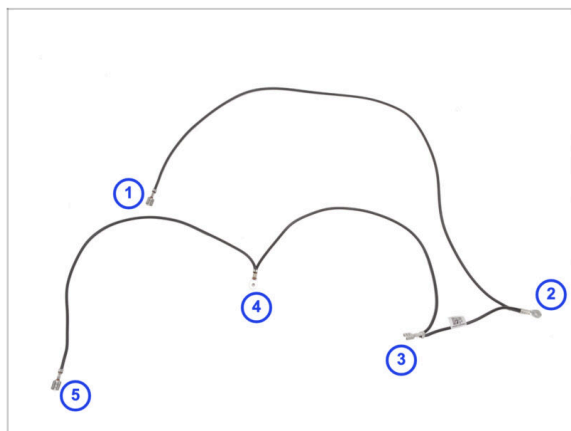
- **For the following steps, please prepare:**
- Cavo xLCD (1x) si trova nella confezione Electronics & Fasteners
- Main FE cable (1x) found in the Electronics & Fasteners package

PASSO 40 Guiding the LCD cable



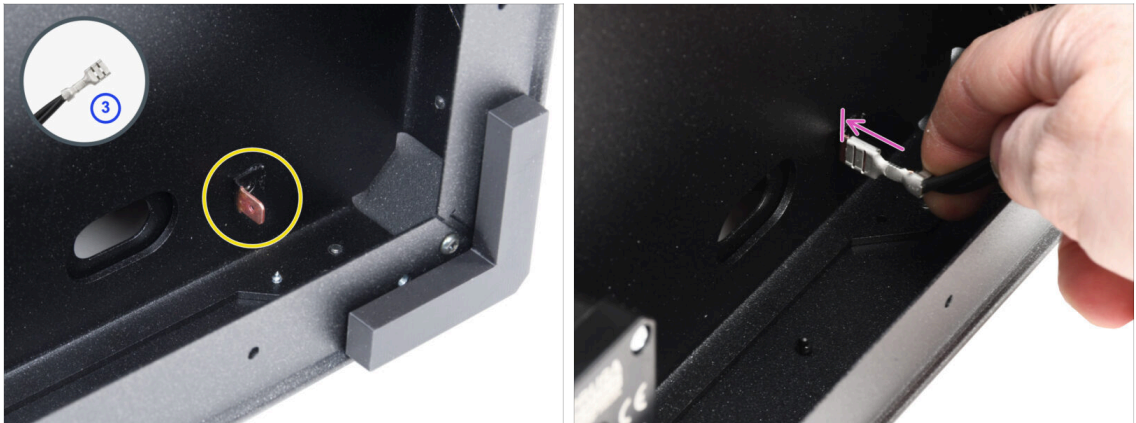
- Guide the Stepper splitter cable through the oval hole to the electronics.
- Prendi l'estremità del cavo del display xLCD con l'etichetta con il codice QR.
- Push a few centimeters of the xLCD cable (the end with the QR code label) through the oval hole in the bottom panel.
- **i** The cable must be 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.

PASSO 41 Main FE cable INFO



- Lay out the Main FE cable as shown in the picture, ensuring each connector is positioned accordingly.
- I connettori sono numerati nella foto solo per riferimento. Questi numeri ti serviranno nei passaggi successivi per collegare tutto nel modo giusto.
- **i** 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.

PASSO 42 Connecting the FE cable (no 3.)



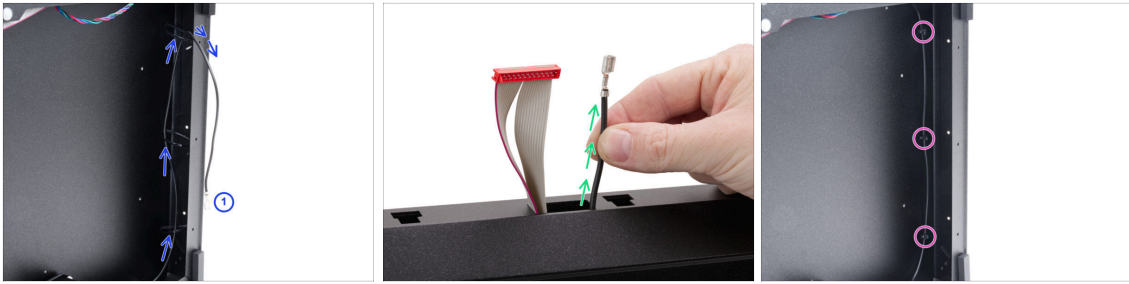
- Prepare the connector number 3.
 - ⓘ That's the female faston connector in the middle of the cable.
- Locate the male Faston connector in the bottom right corner.
- Slide the FE cable connector completely onto the Faston connector.

PASSO 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.

PASSO 44 Guiding the FE cable (no. 1)



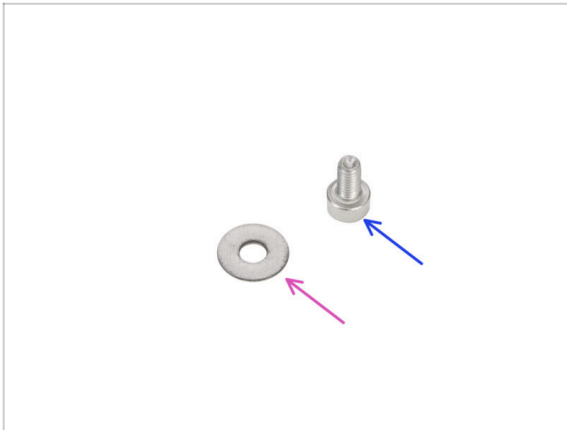
- Take the connector number 1 and guide it through the zip ties on the right side of the frame.
- ❗ That is the long part with just one faston connector at the end.
- Push the connector through the rectangular opening in the front profile. Keep protruding approximately 6 cm (2.36 in).
- Leave the cable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

PASSO 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.

PASSO 46 FE cable - xBuddy: parts preparation



● For the following steps, please prepare:

● Rondella M3w (1x)

● Vite M3x6 (1x)

PASSO 47 Connecting the FE cable: xBuddy

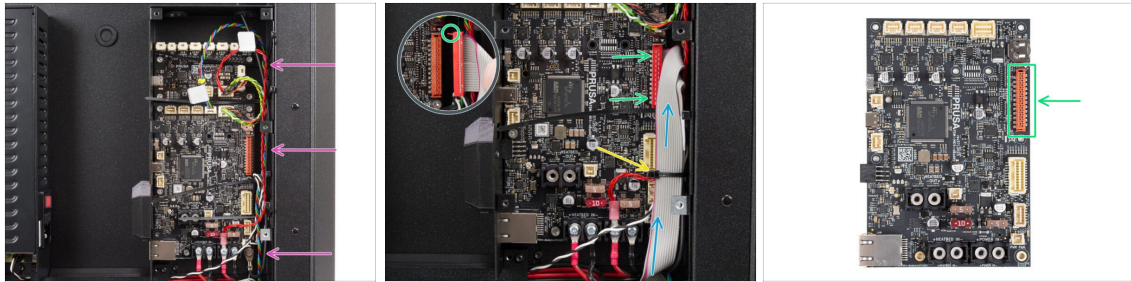


- Take the connector number 4 and connect it to the xBuddy using the M3x6 screw and M3w washer.

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

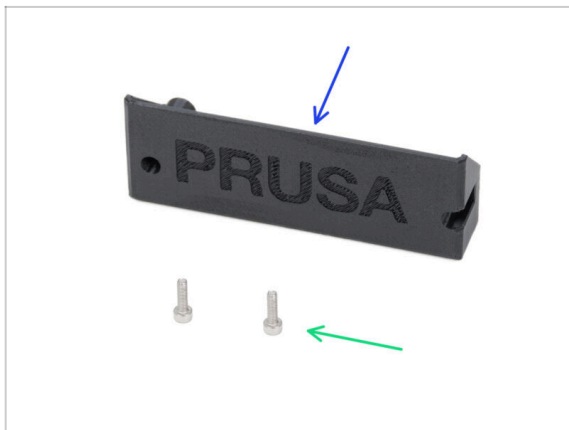
- Guide the FE cable (number 5) alongside the xBuddy box and pass it through the right-side holes out of the box.
- Guide the Stepper splitter cable alongside the xBuddy box and connect it to the second slot from the right in the top row on the xBuddy board (labeled ZR).

PASSO 48 Plugging the xLCD cable



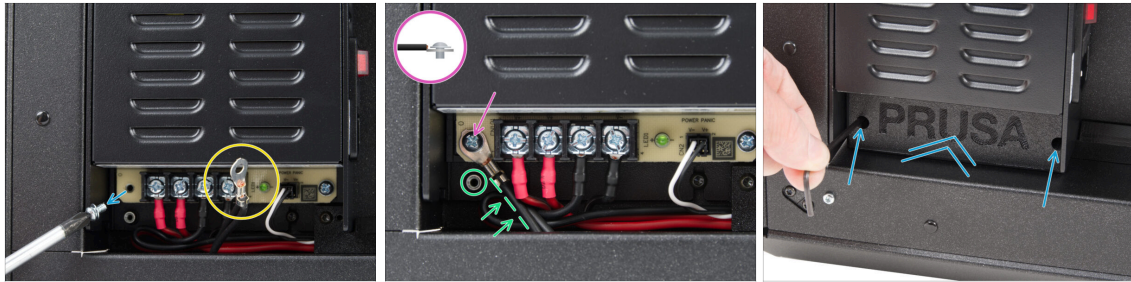
- ◆ Arrange the cables as shown - route all cables along the right side of the xBuddy box.
- ⚠ Make sure all the cables guide through the zip ties in the xBuddy box, not under them.
- ◆ Place the xLCD cable over the other cables and route it upwards.
- ◆ Connect the xLCD to the slot on the right side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

PASSO 49 Copertura dell'alimentatore: preparazione dei componenti



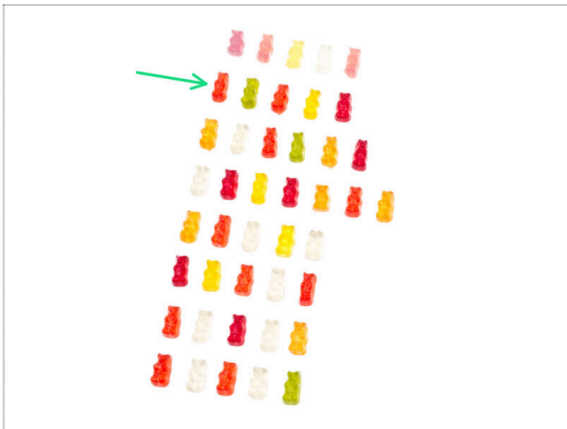
- ◆ For the following steps, please prepare:
- ◆ CORE-One-PSU-cover (1x) found in the Printed parts package
- ◆ Vite M3x10 (2x)

PASSO 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.

PASSO 51 È l'ora delle Haribo!



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

PASSO 52 Fatto

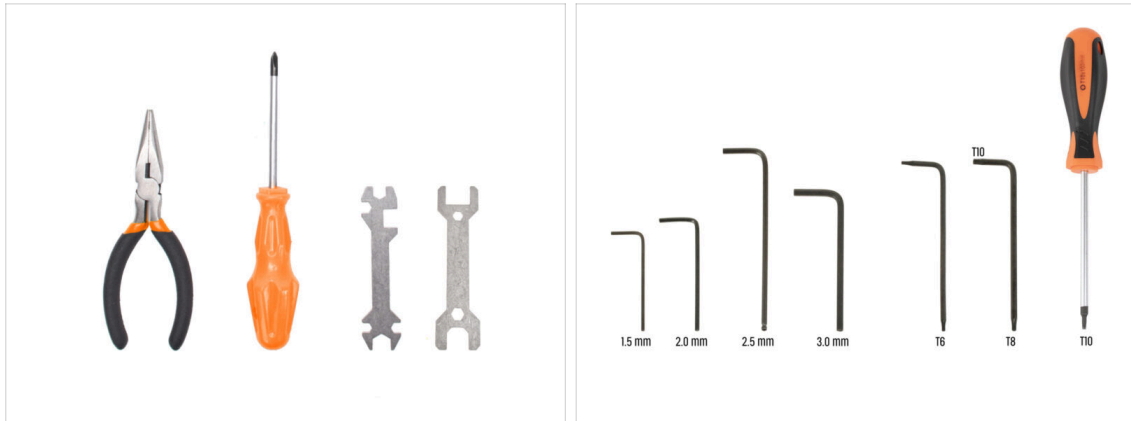


- Congratulations! The back assembly is installed.
- Now continue to the next chapter.

4. Assemblaggio del piano riscaldato



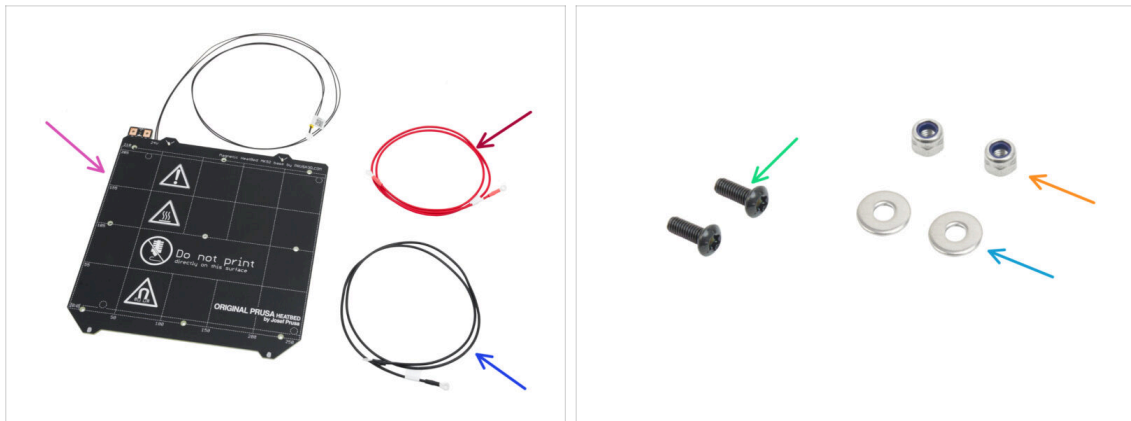
PASSO 1 Attrezzi necessari per questo capitolo



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

- Pinza a becchi lunghi
- Chiave universale
- Chiave 13-16
- Cacciavite a stella PH2
- Chiave a brugola da 2.5mm
- Chiave a brugola da 2.0mm
- Chiave / Cacciavite torx T10

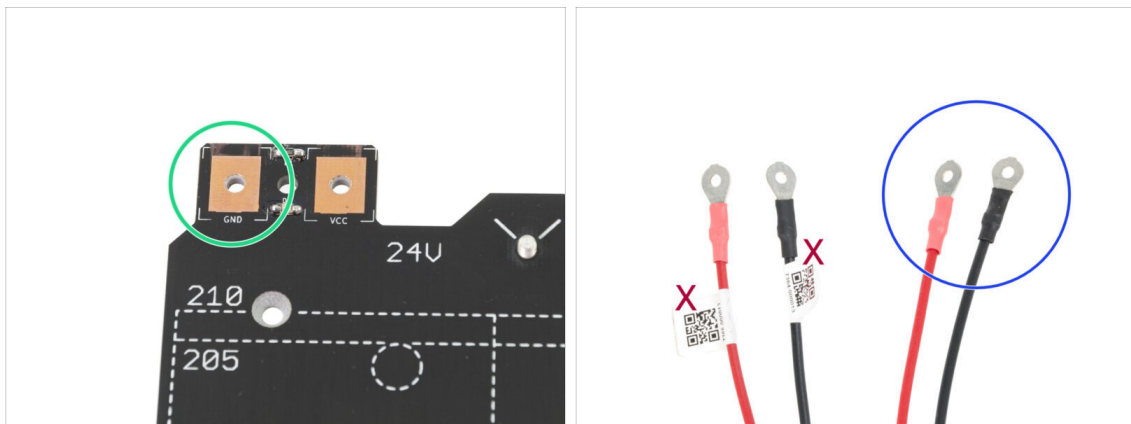
PASSO 2 Piano riscaldato: preparazione componenti



For the following step please prepare:

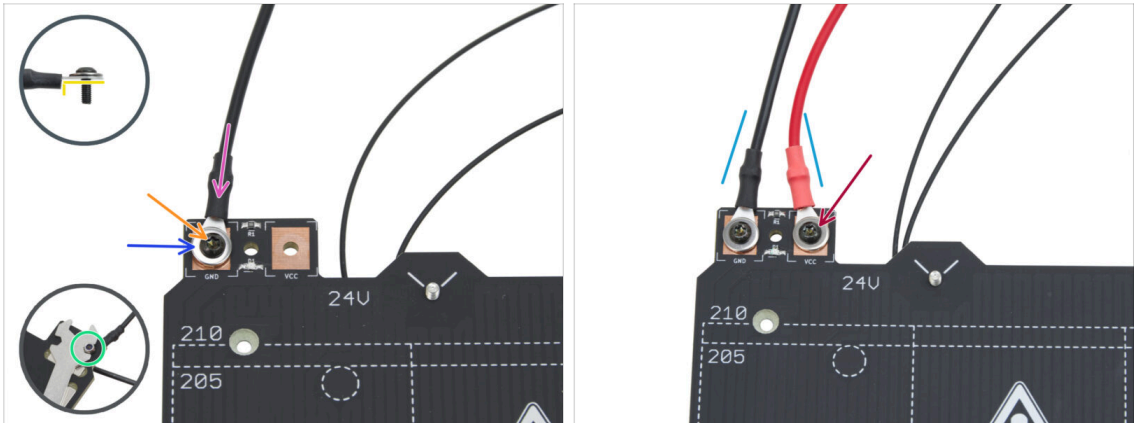
- Heatbed MK52 24V (1x) found in the CoreXY parts + Hinges set package
- Heatbed cable red (1x) found in the Electronics & Fasteners package
- Heatbed cable black (1x) found in the Electronics & Fasteners package
- Vite M3x10rt (2x)
- Dado M3nN (2x)
- Rondella M3w (2x)

PASSO 3 Assemblaggio cavi del piano riscaldato (parte 1)



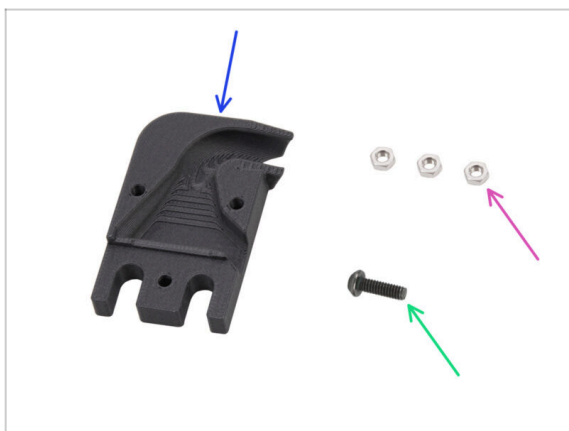
- IT IS IMPORTANT** to connect the power cable correctly. Before you start the assembly have a look at the pins. The one on the left with "GND" sign must be connected to the **BLACK WIRE**.
- Take both Heatbed cables. Note the label on each cable. For the following steps, prepare the ends of the cables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

PASSO 4 Assemblaggio cavi del piano riscaldato (parte 2)



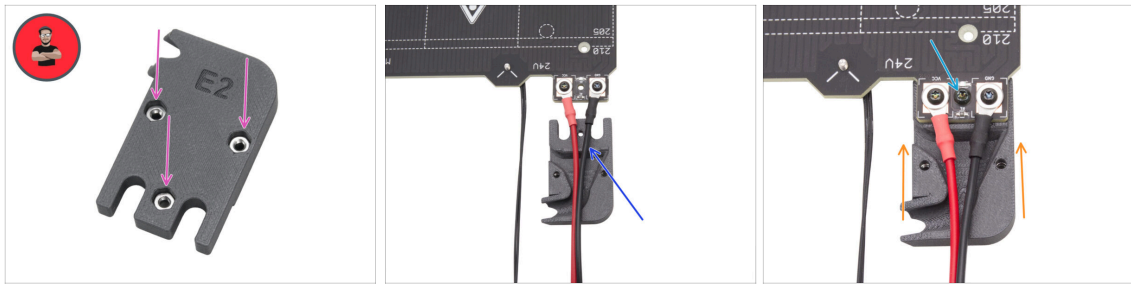
- ✿ Place the black wire above the pin with "GND" sign. **Use the end of the cable that is not labeled with QR code.** The QR code must be at the other end.
- ✿ Note the correct position of the cable terminal lug on the detail.
- ✿ Place the M3w washer above the round cable connector.
- ✿ Push the M3x10rT screw through all parts.
- ✿ Hold the screw and carefully turn the heatbed upside down.
- ✿ Attach the M3nN nut onto the M3x10rT screw and tighten it slightly.
- ✿ Using the same procedure, attach the red cable to the pin labeled "VCC" on the heatbed.
- ✿ Fai passare i cavi dal piano riscaldato leggermente l'uno verso l'altro (a forma di "V"). **Poi stringi bene i dadi da sotto.**

PASSO 5 Bed-cable-cover-bottom: preparazione dei componenti



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

PASSO 6 Applicare la copertura del cavo



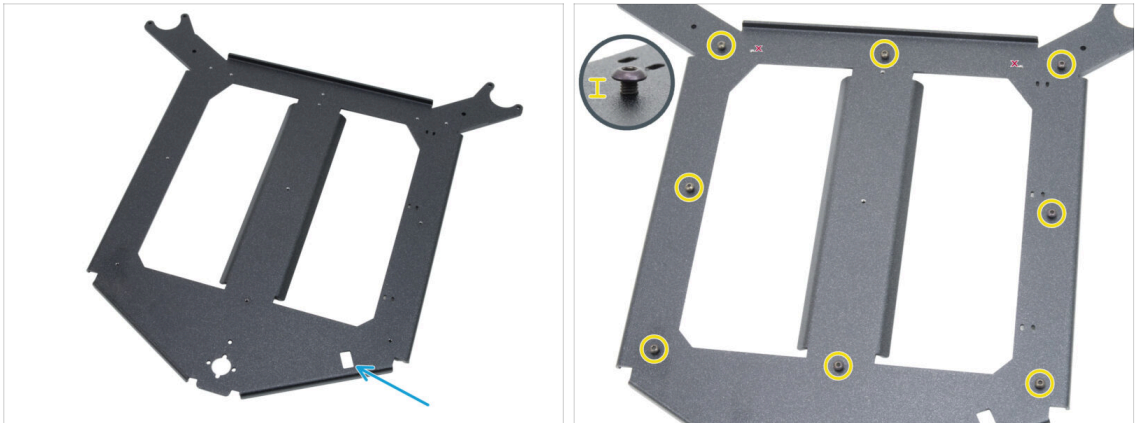
- ✿ Insert three M3n nuts into the Bed-cable-cover-bottom part.
- ❗ Pro tip: Use the screw-pulling technique.
- ⬛ Make sure the nuts are fully inserted and held in place.
- 🔵 Insert the Bed-cable-cover-bottom under the heatbed cables. Note the orientation of the part.
- 🟠 Slide the Bed-cable-cover-bottom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

PASSO 7 Carrello del piano riscaldato: preparazione dei componenti



- ⬛ **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*
- 🟢 Vite M3x4r (8x)
- 🔧 The Fasteners package includes both M3x4r and M3x4rT screws. Make sure you have the correct type prepared.

PASSO 8 Preparare il carrello del piano riscaldato



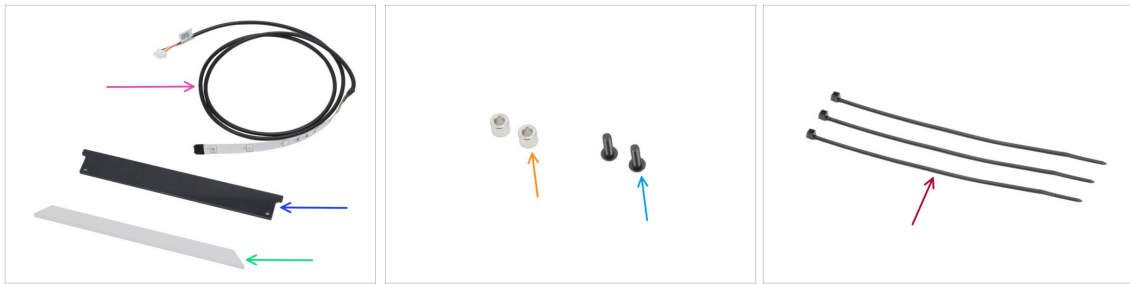
- Place the heatbed carriage in front of you in the same orientation as in the picture.
- Make sure the **rectangular cutout is facing you on the right side**.
- Insert eight M3x4r screws around the heatbed carriage.
- ⚠ **Do not tighten completely, leave a gap of approximately 3 mm (0.12 in).**

PASSO 9 Installazione dei giunti di espansione



- 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.
- Position the key with the expansion joint in its correct orientation as shown in the illustration.
- **Maintain the expansion joint in the correct position** and firmly tighten the M3x4r screw through the expansion joint with a 2.0 mm Allen key.
- ⚠ **Ripeti questa procedura per tutti gli altri giunti di espansione. Assicurati che siano nella posizione corretta!**

PASSO 10 Striscia LED RGB: preparazione dei componenti



For the following steps, please prepare:

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

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

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

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

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

Vite M3x10rt (2x)

Fascetta (3x)

PASSO 11 Installazione della striscia LED



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

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

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

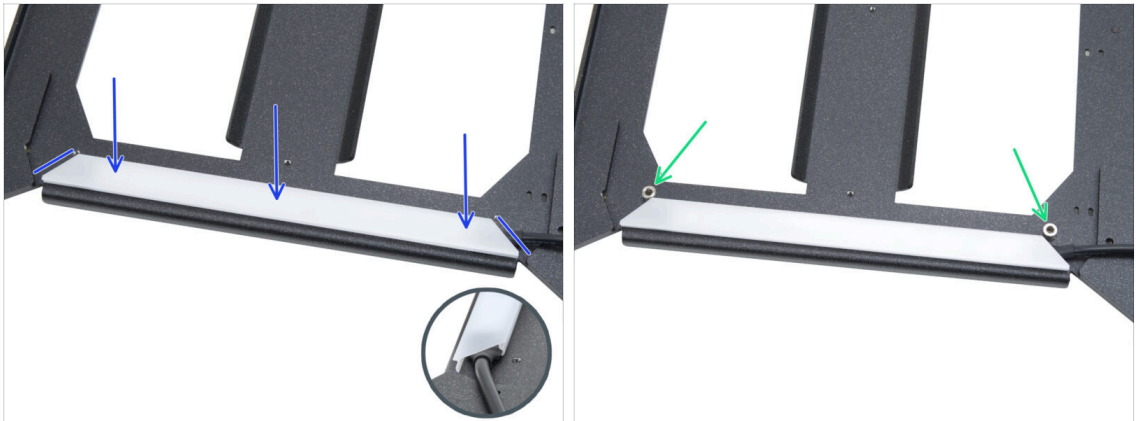
⚠️ **After removing the protective layer, the RGB LED strip is adhesive.**

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

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

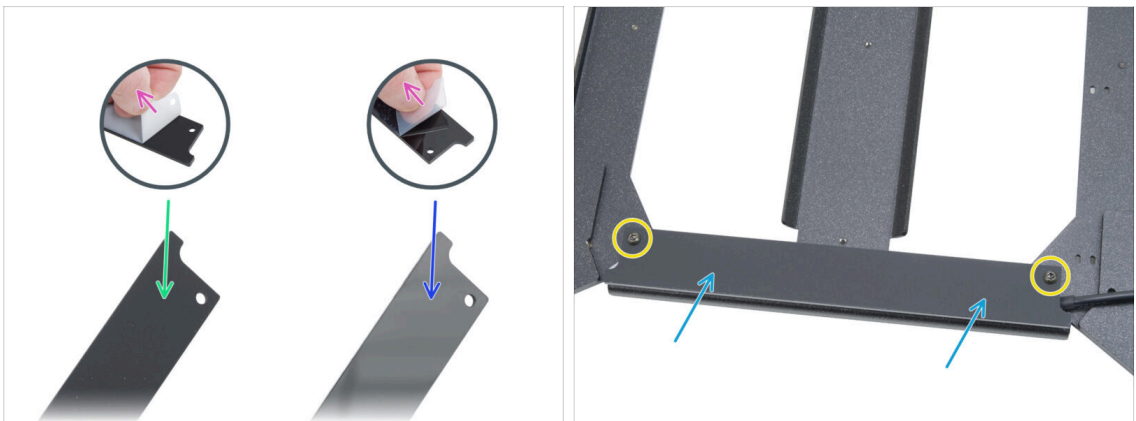
Dopo averla incollata, premi leggermente sulle aree vuote della striscia per garantire l'adesione. **Non toccare i LED e le resistenze!**

PASSO 12 Montaggio del diffusore della striscia LED



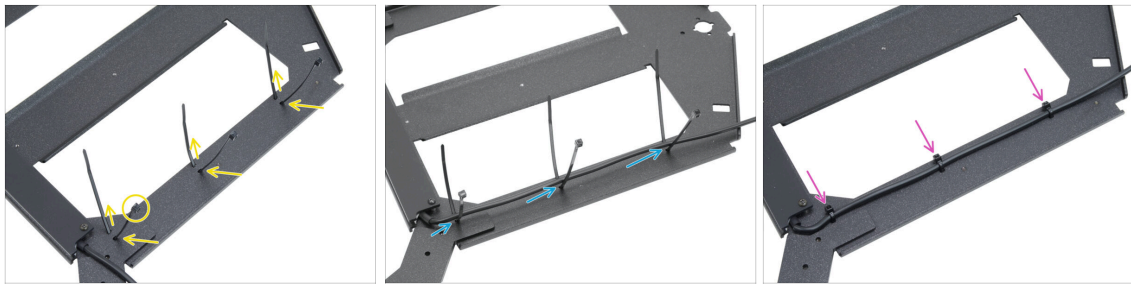
- Place the LED strip diffuser over the RGB LED strip. Note the orientation of the part - according to the beveled edges.
- Place two spacers 3.2/6x5 mm on the holes in the edges of the LED assembly.

PASSO 13 Copertura della striscia LED RGB



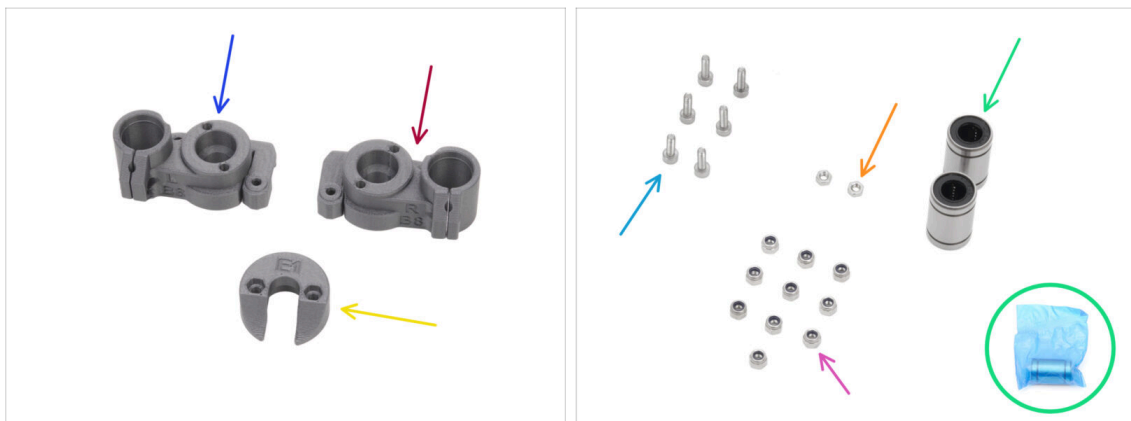
- From both sides of the LED status cover, peel off the protective layers.
- Note that one side of the cover is matte.
- The other side of the cover is glossy.
- Attach the LED strip cover to the assembly, **matte side up**.
- Secure all parts together by inserting and tightening two M3x10rT screws.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

PASSO 14 Orientare il cavo della striscia LED RGB



- ✦ 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.

PASSO 15 Supporti per il piano: preparazione dei componenti



- ✦ **For the following steps, please prepare:**
- ✦ CORE-One-bed-mount-left (1x) *found in the Printed parts package*
- ✦ CORE-One-bed-mount-right (1x) *found in the Printed parts package*
- ✦ CORE-One-bed-spacer-rear (1x) *found in the Printed parts package*
- ✦ LM8UU bearing (2x) *found in the Electronics package*
- ❗ The bearings in the kit are packed in blue bags.
- ✦ Vite M3x10 (6x)
- ✦ Dado M3n (2x)
- ✦ Dado M3nN (10x)

PASSO 16 Montaggio dei supporti del piano



- 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.

PASSO 17 Fissare i supporti per il piano



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

PASSO 18 Supporti per il piano: inserimento dei dadi



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

PASSO 19 Montaggio della parte CORE-One-bed-spacer-rear



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

PASSO 20 Installare il supporto bed-mount-right



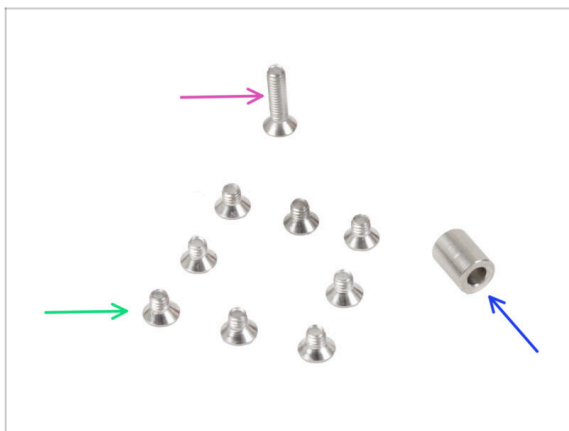
- Turn the heatbed carriage piece with the "forks" facing you and with the **expansion joints facing up**.
- Take the CORE-One-bed-mount-**right** part and slide it **under the right fork** - with the bearing on the right.
- Fix it with two M3x10 screws.

PASSO 21 Installazione del supporto bed-mount-left



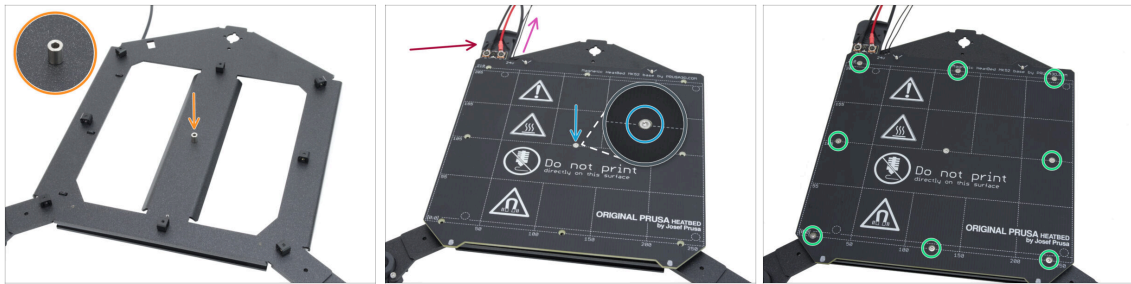
- Take the One-bed-mount-**left** part and slide it **under** the **left** fork - with the bearing on the left.
- Fix it with two M3x10 screws.

PASSO 22 Montaggio del piano riscaldato: preparazione dei componenti



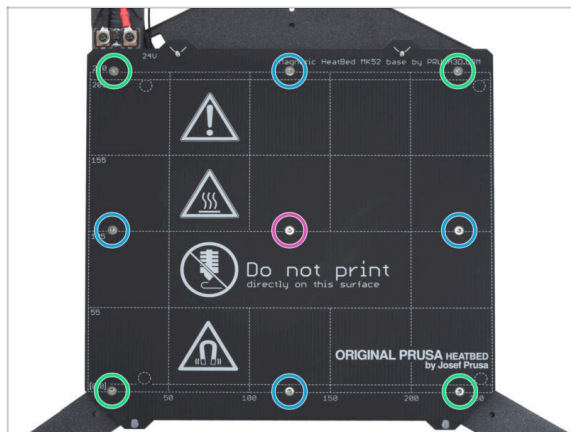
- For the following steps, please prepare:
- M3x12bT countersunk screw (1x)
 - i** Note: The package may label this screw as M3x12cT.
- Spacer 6x3.1x8 mm (1x) *found in the Nextruder assembly package*
- M3x4bT countersunk screw (8x)

PASSO 23 Montare il piano riscaldato



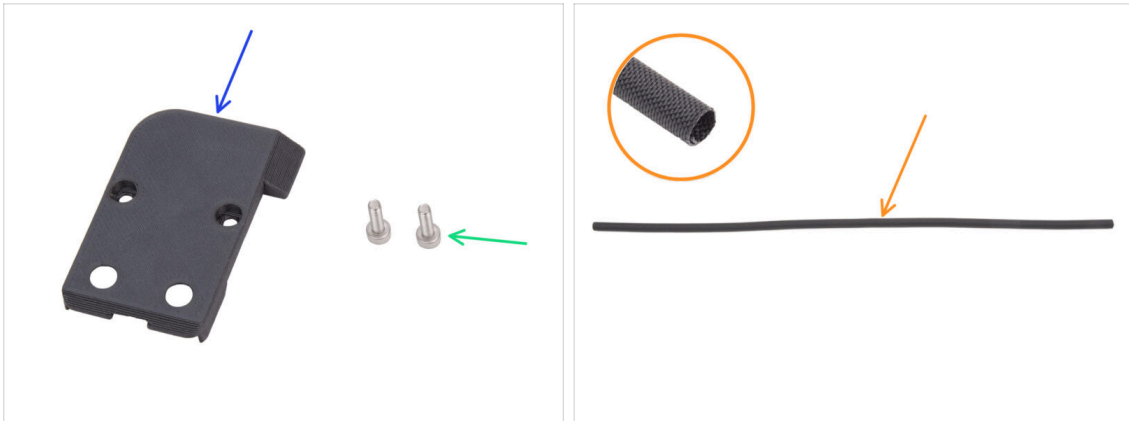
- Place the spacer onto the heatbed carriage on the side with the expansion joints and align it with the hole in the center.
- Put the heatbed on the heatbed carriage and secure it by the M3x12bT. **Do not fully tighten the screw yet.**
 - Make sure the heatbed thermistor cable (the thinnest pair) is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

PASSO 24 Serraggio del piano riscaldato



- ⚠ **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:
 - Vite centrale
 - First four screws (edges)
 - Last four screws (corners)
- ⚠ Tighten the screws gently, but firmly.

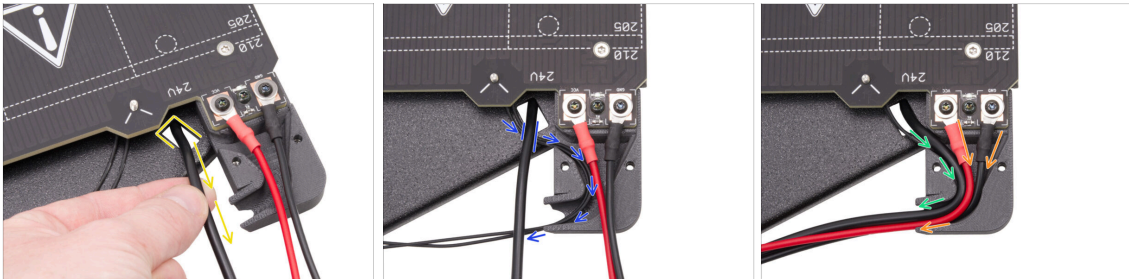
PASSO 25 Copertura dei cavi: preparazione dei componenti



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

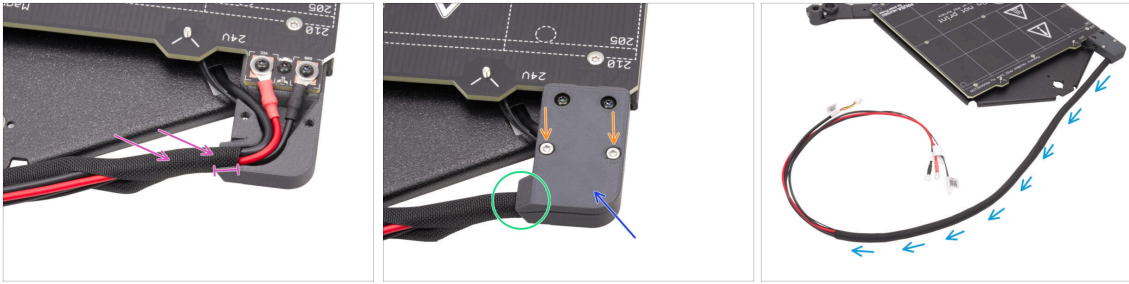
- CORE-One-bed-cable-cover-top (1x) found in the Printed parts package
- Vite M3x10 (2x)
- Guaina in tessuto 520 x 8 mm (1x) si trova nella confezione Electronics & Chamber parts

PASSO 26 Posizionamento dei cavi del piano riscaldato



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

PASSO 27 Coprire i cavi del piano riscaldato



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

PASSO 28 Montaggio del piano riscaldato: preparazione dei componenti



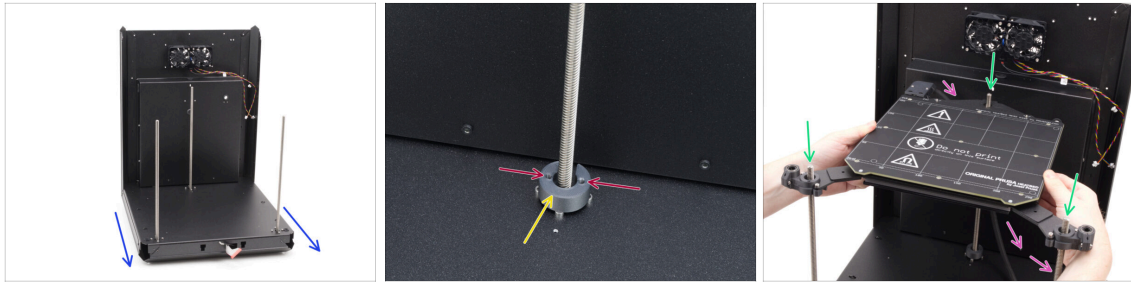
✦ For the following steps, please prepare:

✦ Dado trapezoidale (3x)

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

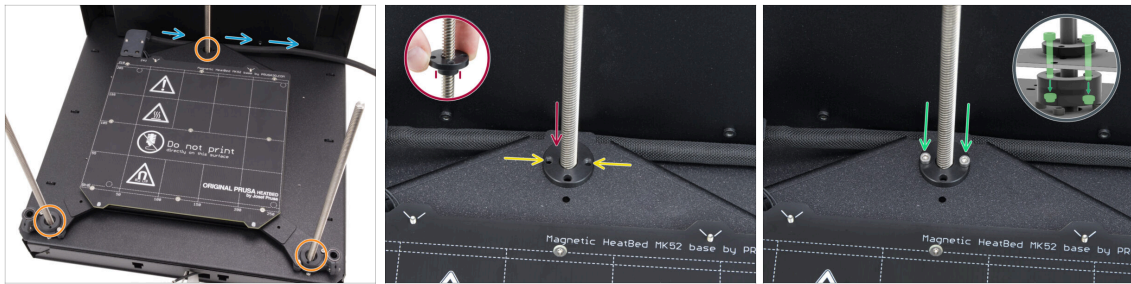
✦ Vite M3x18 (6x)

PASSO 29 Montaggio del gruppo piano riscaldato



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

PASSO 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.
 - ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- ❖ Align the holes in the trapezoidal nut, carriage and bed-spacer-rear.
 - i It doesn't matter which holes you use in the trapezoidal nut.
 - i Suggerimento: puoi infilare una chiave a brugola da 1,5 mm nei fori di tutti i pezzi per allinearli.
- ❖ Fissa il dado trapezoidale, il carrello del piano riscaldato e il distanziale posteriore del piano con due viti M3x18.

PASSO 31 Mounting the heatbed assembly: front motor left



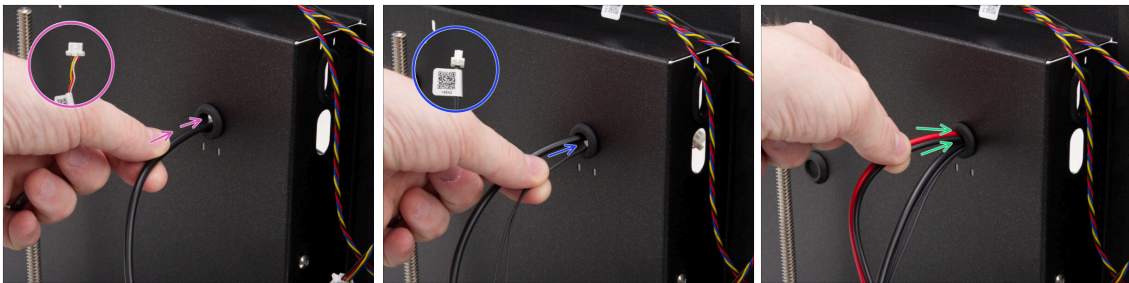
- ❖ Manually thread the trapezoidal nut onto the **left** Z motor. Screw the nut all the way down until it seats into the plastic part.
 - ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- ❖ Align the holes in the trapezoidal nut with those in the plastic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

PASSO 32 Mounting the heatbed assembly: front motor right



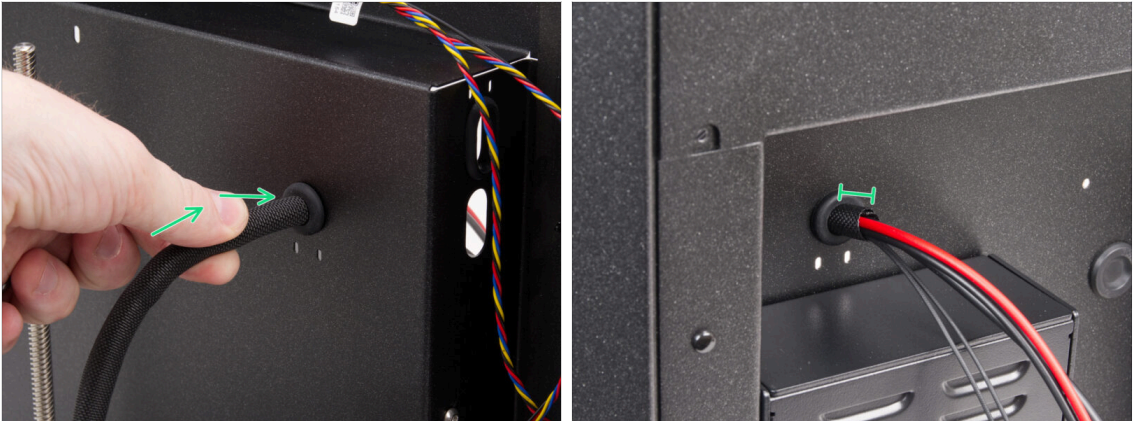
- Manually thread the trapezoidal nut onto the **right** Z motor. Screw the nut all the way down until it seats into the plastic part.
- ⚠ Ensure the correct orientation of the part. **The protruding section must face downwards.**
- Align the holes in the trapezoidal nut with those in the plastic part.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

PASSO 33 Attaching the heatbed cables I.



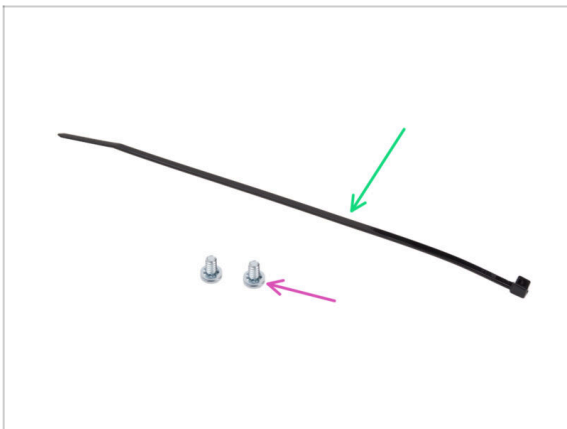
- Locate the grommet hole at the top right of the rear assembly and push the heatbed cables through in the following order:
 - Guide the RGB LED strip cable through the hole first.
 - Route the thermistor cable through the hole.
 - Finally, insert both power cables of the hole.

PASSO 34 Attaching the heatbed cables II.



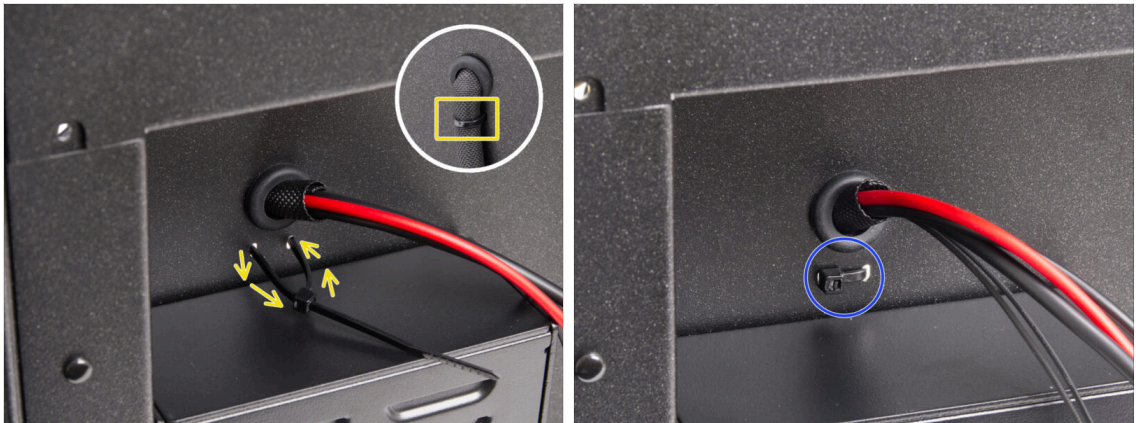
- Push the heatbed cables and the textile sleeve through the grommet hole.
- ⬛ No more than 1 cm (0.39 in) of the textile sleeve should protrude from the back side.

PASSO 35 Securing the heatbed cables: parts preparation



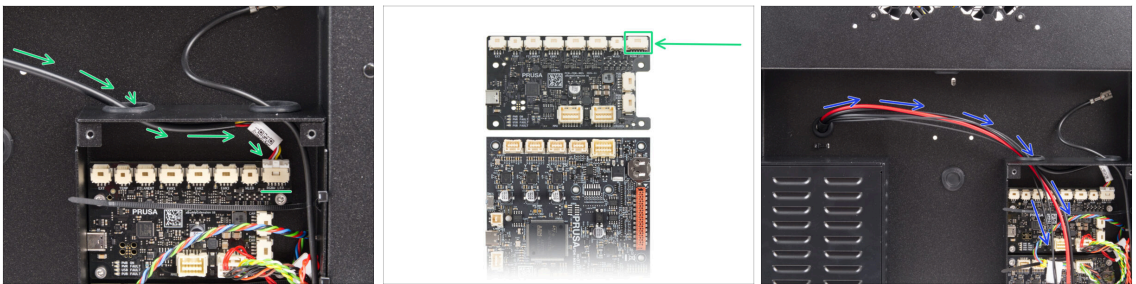
- ⬛ **For the following steps, please prepare:**
- Fascetta (1x)
- Power terminal screw 6-32 (2x)

PASSO 36 Securing the textile sleeve



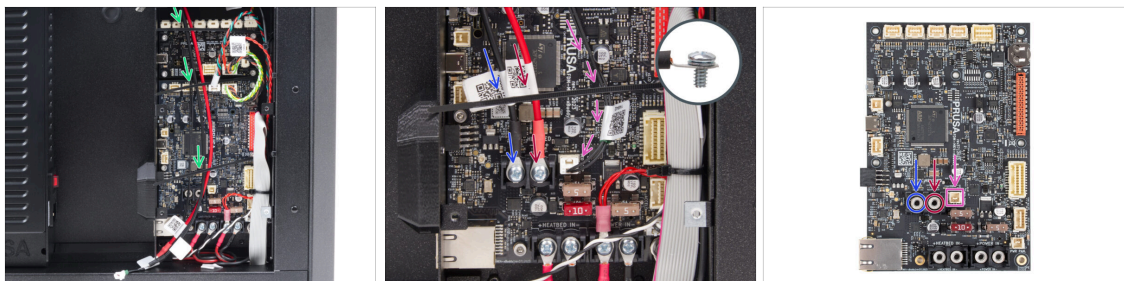
- Guide the zip tie through the two holes under the heatbed cables and make a loop around the heatbed cable bundle (textile sleeve) on the inside.
- Tighten the zip tie firmly and cut off the excess.

PASSO 37 Guiding the heatbed assembly cables



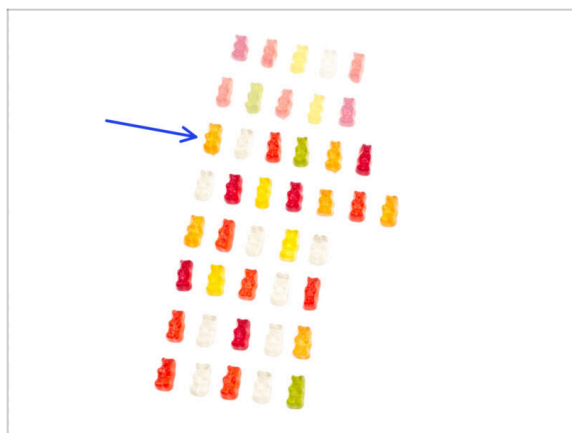
- Route the RGB LED strip cable through the left hole in the xBuddy box and connect it to the xBuddy Extension board labeled 'RGBW LED.'
- Connect it to the first slot from the right on the xBuddy extension board.
- Guide the heatbed power cables along with the thermistor through the left hole. Leave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

PASSO 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.
- Plug the heatbed thermistor connector to the slot next to the power terminals.

PASSO 39 È l'ora delle Haribo!



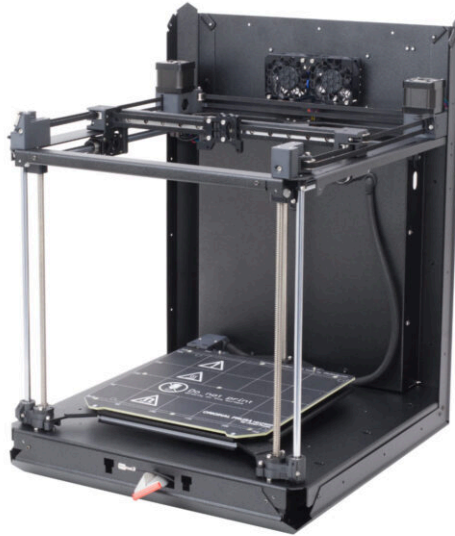
- Time for another quick energy boost!
- Eat the third row.
 - With one extra treat. You deserve it!

PASSO 40 Fatto

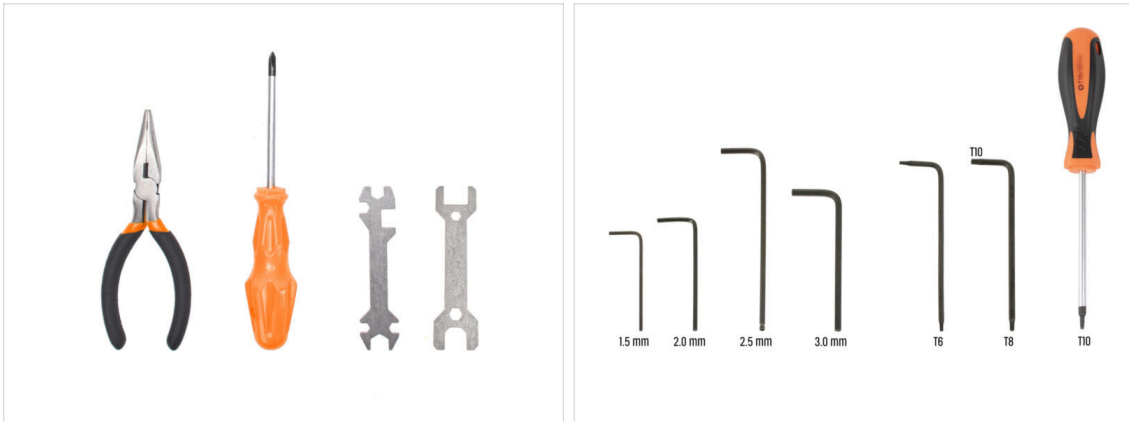


- ◆ Congratulations! You have just assembled and installed the heatbed.
- ◆ Let's go to the next chapter.

5. Gruppo CoreXY

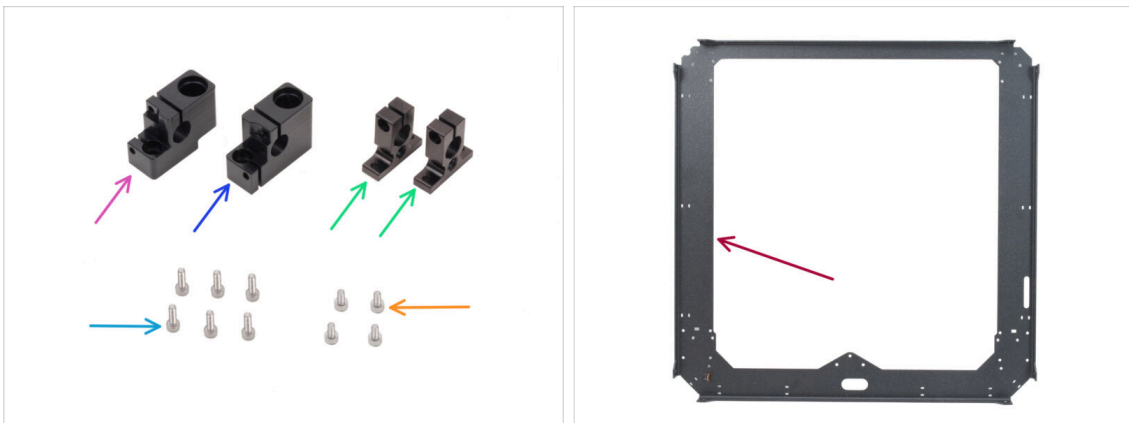


PASSO 1 Tools necessary for this chapter



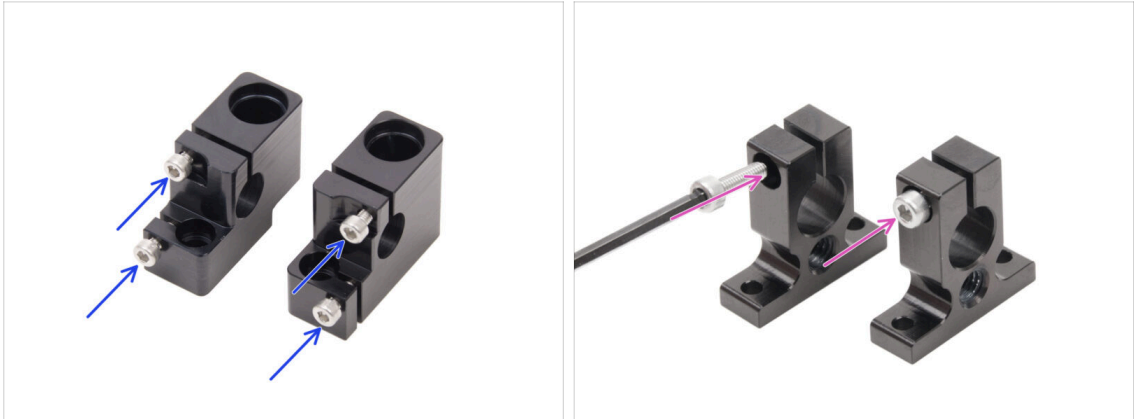
- **For this chapter, please prepare:**
- Pinza a becchi lunghi
- Chiave a brugola da 2.0mm
- Chiave a brugola da 2.5mm
- T10 torx key / T10 torxy screwdriver

PASSO 2 Rod holders: parts preparation



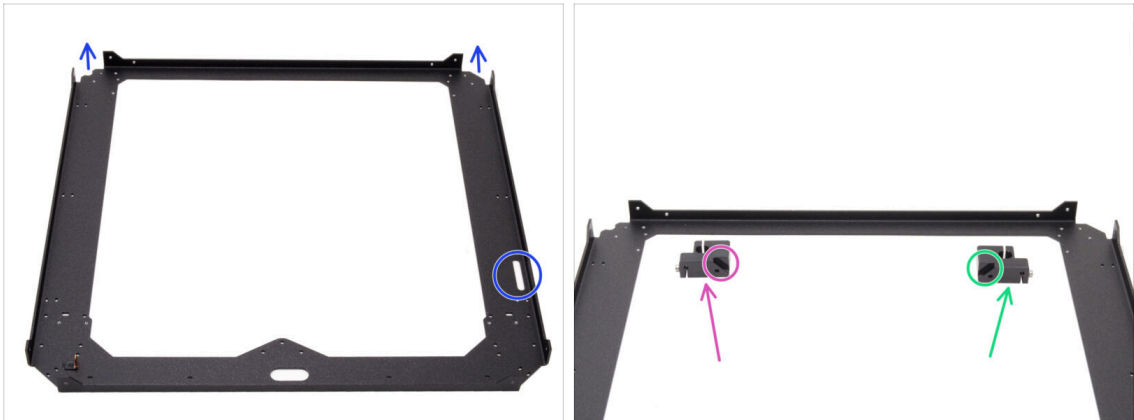
- **For the following steps, please prepare:**
- Rod holder left (1x) *found in the CORE XY parts + hinges + HB set package*
- Supporto barra destro (1x) *nel pacchetto CORE XY parts + hinges + HB set*
- Supporto barra posteriore (2x) *nel pacchetto CORE XY parts + hinges + HB set*
- Vite M3x10 (6x)
- Vite M3x6 (4x)
- CoreXY plate (1x) *found in the Metal parts 1/3 package*

PASSO 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.
- Inserisci una vite M3x10 in ciascun supporto barra posteriore. **Inserisci dalla parte con il foro per la testa della vite.**
- **Non stringere fino in fondo**, per ora bastano pochi giri.

PASSO 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:
 - ⚠ **Assicurati di preparare il pezzo corretto per il lato corretto. Per l'allineamento, usa come riferimento gli smussi su entrambi i pezzi.**
 - **Supporto barra sinistra**
 - **Supporto barra destra**

PASSO 5 Installing the front rod holders



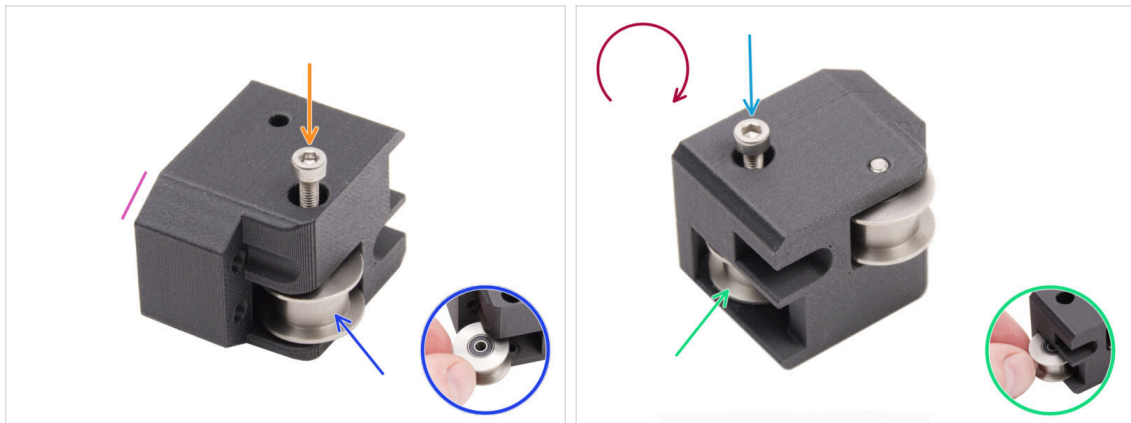
- Place the Rod holder left to the left front corner on the corresponding threaded holes.
- Secure it with two M3x6 screws.
- Posiziona il supporto della barra destra dell'angolo anteriore destro sui fori filettati corrispondenti.
- Fissarlo con due viti M3x6.

PASSO 6 XY carriage: parts preparation



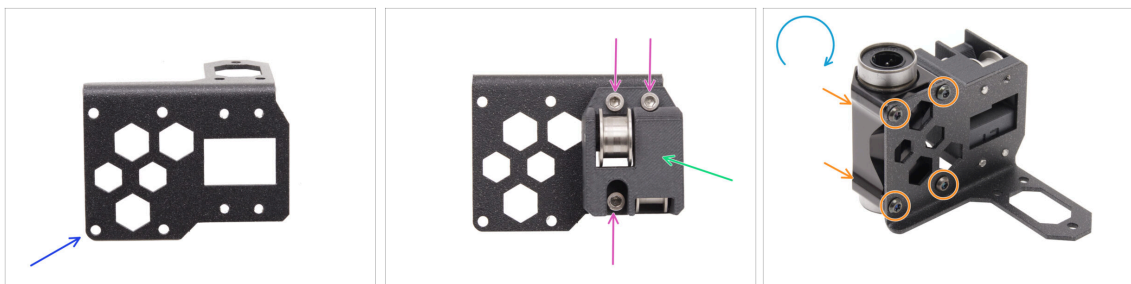
- For the following steps, please prepare:**
- Linear holder left (1x) *found in the Metal parts 1/3 package*
- Supporto destro Guida lineare (1x) *si trova nella confezione Metal parts 1/3*
- Carrello XY (2x) *si trova nella confezione Printed parts*
- LM10LUU linear bearing (2x) *found in the CORE XY parts + hinges + HB set package*
- GT2-20 Idler pulley (4x) *found in the Electronics & Fasteners package*
- M3x8rT black screw (8x)
- Vite M3x18 (10x)

PASSO 7 Montaggio dei carrelli XY



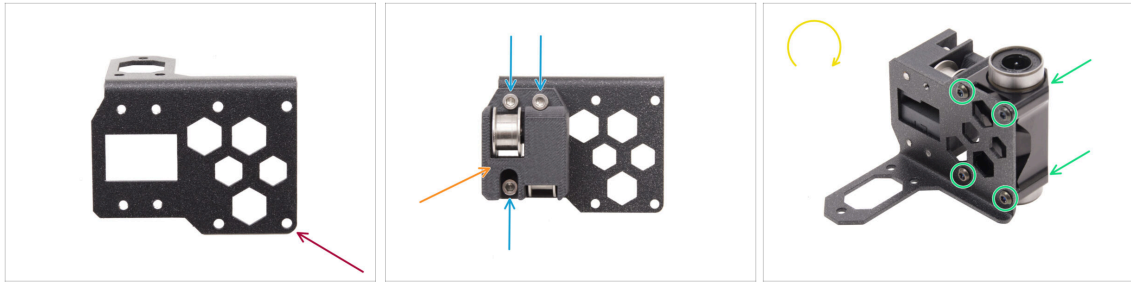
- ◆ Take one of the XY-carriage and orient it as shown. Use the beveled side as a guide.
- ◆ Insert the GT2-20 Idler pulley into the XY-carriage.
- ◆ Inserisci una vite M3x18 attraverso la puleggia e stringila bene.
- ◆ Capovolgere la parte.
- ◆ Insert another GT2-20 Idler pulley into the XY-carriage.
- ◆ Secure it with the M3x18 screw. Tighten it completely down.
- ◆ Repeat the same procedure with the second XY-carriage.

PASSO 8 Assembling the linear holder left



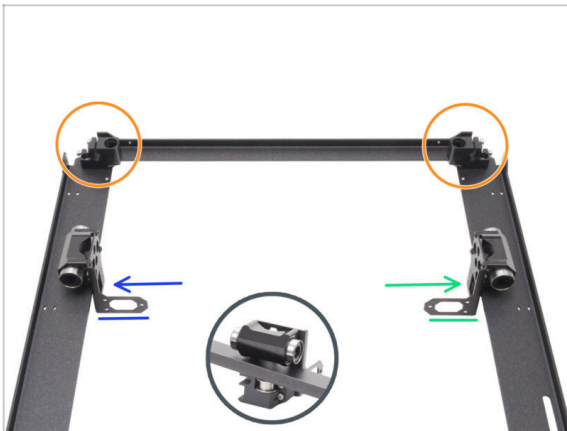
- ◆ Prepare the Linear holder **left** and position it as in the picture.
- ◆ Attach one of the XY-carriages to the Linear holder.
- ◆ Installalo sul supporto lineare con tre viti M3x18.
- ◆ Capovolgi il supporto lineare.
- ◆ From the XY-carriage side, attach the LM10LUU linear bearing to the holder and secure it with four M3x8rT screws.

PASSO 9 Assembling the linear holder right



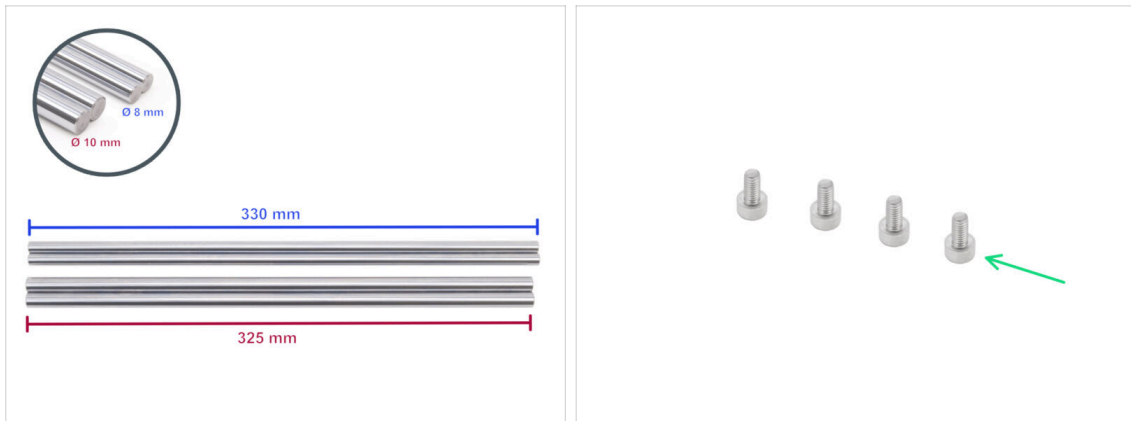
- Prepare the Linear holder **right** and position it as in the picture.
- Attach one of the XY-carriages to the Linear holder.
- Installalo sul supporto lineare con tre viti M3x18.
- Capovolgi il supporto lineare.
- From the XY-carriage side, attach the LM10LUU linear bearing to the holder and secure it with four M3x8rT screws.

PASSO 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.
- **Supporto lineare sinistro**
- **Supporto lineare destro**
- ① The linear holders are now only loosely seated.

PASSO 11 Barre lisce 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.

Barra liscia 330 x 8 mm (2x)

Asta liscia 325 x 10 mm (2x) **necessaria per i seguenti passaggi**

- For the following steps, please prepare:

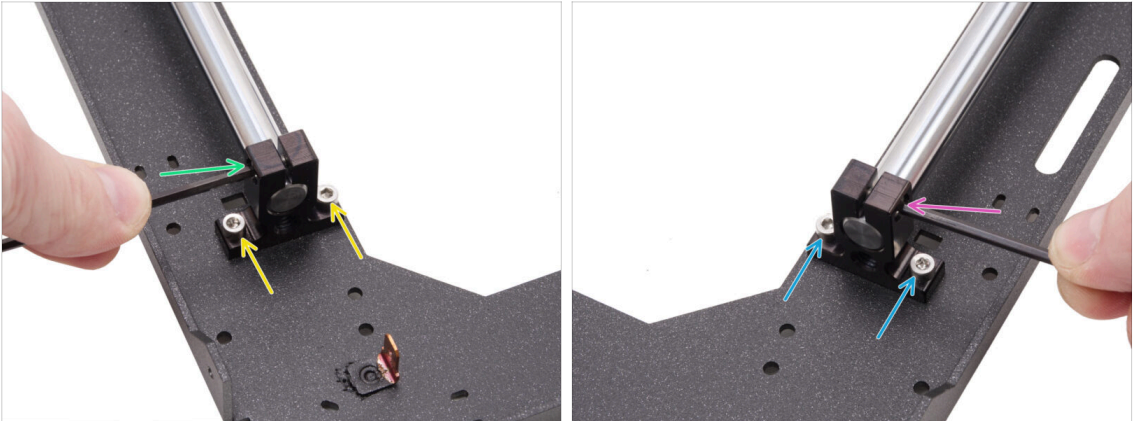
Vite M3x6 (4x)

PASSO 12 Mounting the smooth rods



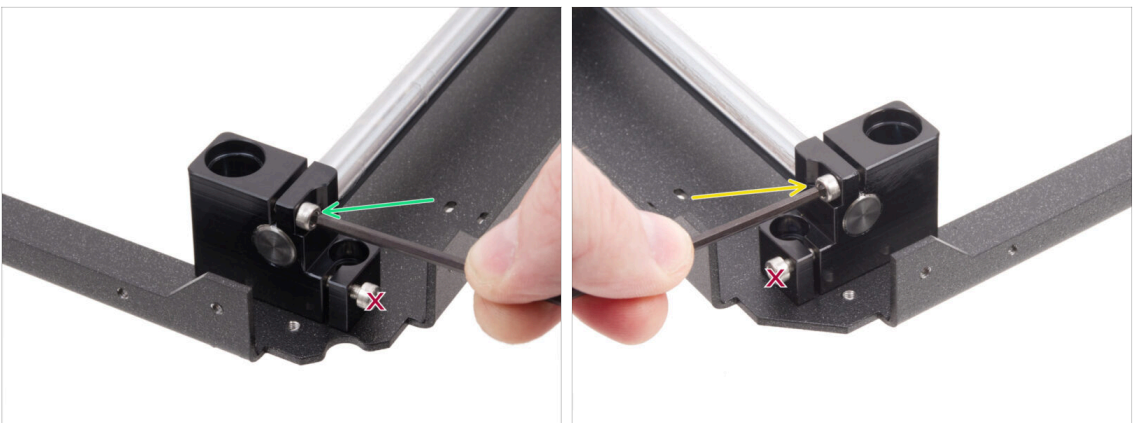
- Slide both rear rod holders onto both 10mm smooth rods.
- Line up the ends of the rods with the holders.
- Spingi entrambe le barre lisce da 10 mm attraverso il cuscinetto LM10LUU fino ai supporti anteriori delle barre.
- Assicurati che le viti dei supporti posteriori delle barre siano rivolte verso l'esterno del telaio.
- Line up the front end of the 10mm smooth rods with the front rod holders.

PASSO 13 Securing the rear rod holders



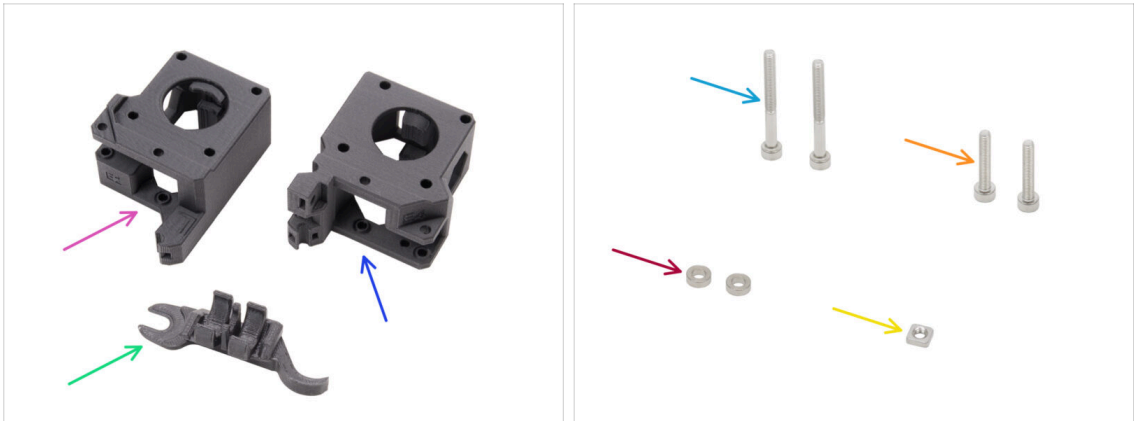
- Line up the left rear rod holder with the threaded holes in the plate.
- Fix it with two M3x6 screws.
- Stringi bene la vite nel supporto della barra.
- Allinea il supporto posteriore destro con i fori filettati della piastra.
- Fix it with two M3x6 screws.
- Firmly tighten the screw in the rod holder.

PASSO 14 Securing the front rod holders



- Concentrati sul supporto anteriore sinistro (attualmente sulla destra) e fissa la barra stringendo la vite nel supporto.
- ⚠ **Do not tighten the bottom screw.**
- Concentrati sul supporto anteriore destro (attualmente sulla sinistra) e fissa la barra stringendo la vite nel supporto.
- ⚠ **Non stringere la vite inferiore.**

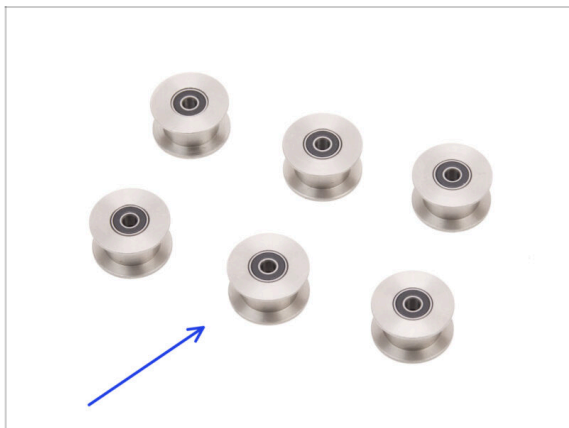
PASSO 15 Motor mounts: parts preparation



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

- XY-motor-mount-left (1x) *found in the Printed parts package*
- XY-motor-mount-right (1x) *si trova nella confezione Printed parts*
- Strumento Assembly-multi-tool (1x) *già usato in precedenza*
- Vite M3x30 (2x)
- Vite M3x18 (2x)
- Spacer 3.2/6x2 (2x) *found in the Electronics & Fasteners package*
- Dado M3nS (1x)
- ① The list continues in the next step...

PASSO 16 Motor mounts: part preparation



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

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



- ✿ Inserisci una puleggia nella posizione inferiore dello strumento Assembly-multi-tool.
- ✿ Insert the spacer 3.2 on the pulley.
- ✿ Inserisci la seconda puleggia nello strumento Assembly-multi-tool.
- ✿ Inserisci l'intero gruppo nel supporto XY-motor-mount-right.
 - Position the part according to the picture. Note the beveled corner.
- ✿ Align holes in both parts and secure it with the M3x30 screw.
 - 🔧 La parte in plastica non ha filettatura pre-tagliata, quindi la vite la creerà man mano che la stringi. È prevista una leggera resistenza.
- ✿ Rimuovi lo strumento Assembly-multi-tool.

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



- ✿ Insert another pulley into the XY-motor-mount-right.
- ✿ Secure it with M3x18 screw.
 - 📘 La parte in plastica non ha filettatura pre-tagliata, quindi la vite la creerà man mano che la stringi. È prevista una leggera resistenza.
- ✿ Inserisci il dado M3nS nel supporto XY-motor-mount-right.

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



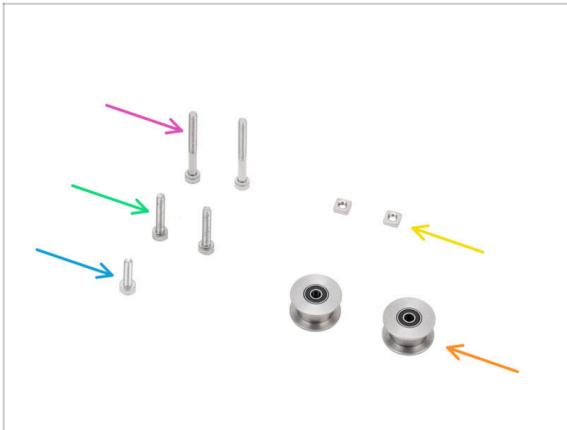
- ✿ Inserisci una puleggia nella posizione inferiore dello strumento Assembly-multi-tool.
- ✿ Insert the spacer 3.2 on the pulley.
- ✿ Inserisci la seconda puleggia nello strumento Assembly-multi-tool.
- ✿ Inserisci l'intero gruppo nel supporto XY-motor-mount-left.
 - ⬛ Position the part according to the picture. Note the bevel next to the screw hole.
- ✿ Align holes in both parts and secure it with the M3x30 screw.
 - ⓘ La parte in plastica non ha filettatura pre-tagliata, quindi la vite la creerà man mano che la stringi. È prevista una leggera resistenza.
- ✿ Rimuovi lo strumento Assembly-multi-tool.

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



- ✿ Insert another pulley into the part.
- ✿ Secure it with M3x18 screw. **Do not overtighten the screw.**
 - ⓘ La parte in plastica non ha filettatura pre-tagliata, quindi la vite la creerà man mano che la stringi. È prevista una leggera resistenza.

PASSO 21 Belt tensioners: parts preparation I.



For the following steps, please prepare:

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

Vite M3x30 (2x)

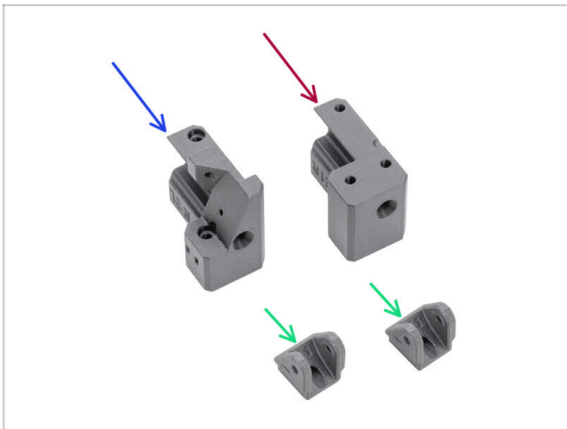
Vite M3x18 (2x)

Vite M3x12 (1x)

Dado M3nS (2x)

i The list continues in the next step...

PASSO 22 Belt tensioners: parts preparation II.



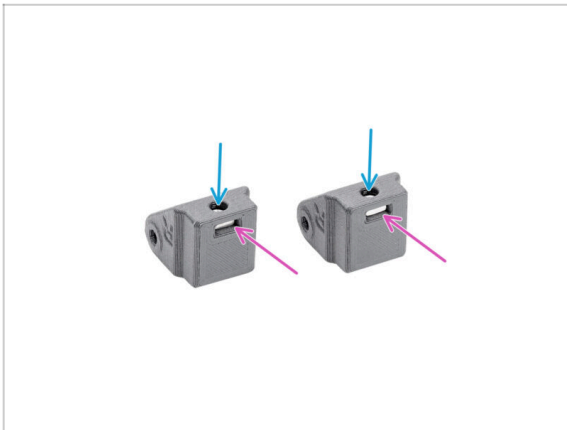
For the following steps, please prepare:

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

Belt-tensioner-right (1x) *si trova nella confezione Printed parts*

Belt-tensioner-pulley (2x) *contenuto nella confezione Printed parts*

PASSO 23 Preparing the tensioner pulleys



- ✦ Insert one M3nS nut into each Belt-tensioner-pulley.
- ✦ Assicurati che i dadi siano inseriti bene nei pezzi. I fori nei dadi e nei pezzi **devono essere allineati**.
- ✦ Tieni entrambe le parti in questa posizione.

PASSO 24 Assembling the belt tensioner left I.



- ✦ Apply a small amount of Prusa lubricant to the tip of both M3x30 screws.
- ✦ Metti il lubrificante in modo uniforme su tutta la filettatura.
- ⓘ Tip: Use the tip of a zip tie to spread the lubricant.
- ✦ Slide the Belt-tensioner-**left** onto the Belt-tensioner-pulley.
- ✦ **Ensure the parts are oriented correctly**, as shown.
- ✦ Insert the M3x30 screw through the Belt-tensioner-left into the Belt-tensioner-pulley. **Do not tighten completely!** 3-4 turns are sufficient.

PASSO 25 Assembling the belt tensioner left II.



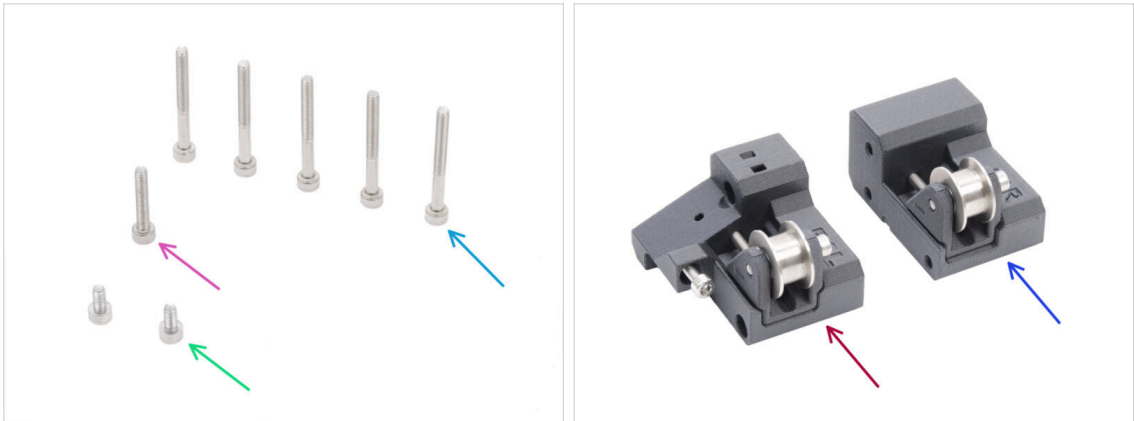
- ◆ Insert the GT2-20 Idler pulley into the Belt-tensioner-pulley.
- ◆ Secure it with the M3x18 screw.
 - i La parte in plastica non ha filettatura pre-tagliata, quindi la vite la creerà man mano che la stringi. È prevista una leggera resistenza.
- ◆ Insert the M3x12 screw into the Belt-tensioner-left. Tighten slightly—five turns are enough. It must not protrude through the other side.
 - i Note: This screw, referred to as the tensioning screw, will later be used to adjust the door sensor.

PASSO 26 Assembling the belt tensioner right



- ◆ Slide the Belt-tensioner-**right** onto the Belt-tensioner-pulley.
 - ◆ **Ensure the parts are oriented correctly**, as shown.
- ◆ Inserisci la vite M3x30 attraverso il tenditore destro della cinghia (Belt-tensioner-right) nel tenditore della puleggia (Belt-tensioner-pulley). **Non stringere completamente!** Sono sufficienti 3-4 giri.
- ◆ Insert the GT2-20 Idler pulley pulley into the Belt-tensioner-pulley-right.
- ◆ Secure it with the M3x18 screw.
 - i La parte in plastica non ha filettatura pre-tagliata, quindi la vite la creerà man mano che la stringi. È prevista una leggera resistenza.

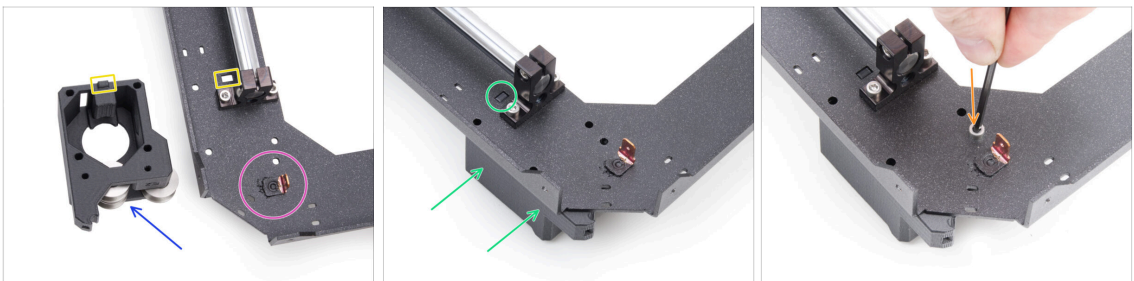
PASSO 27 Installing the belt tensioners: parts preparation



● For the following steps, please prepare:

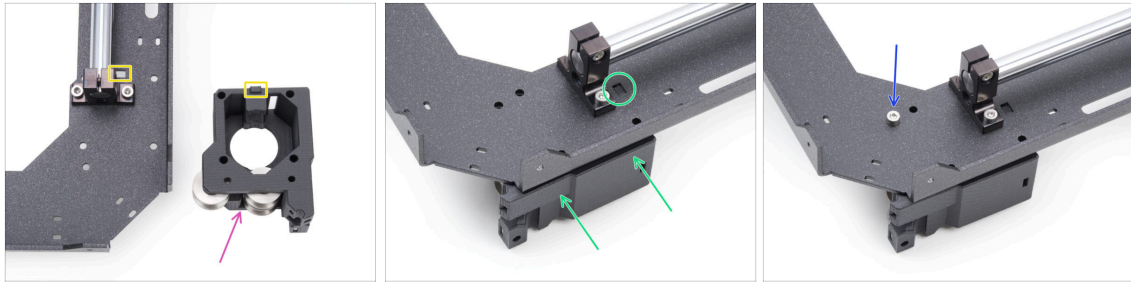
- Vite M3x30 (5x)
- Vite M3x18 (1x)
- Vite M3x6 (2x)
- Belt tensioner left assembly (1x) *you assembled earlier*
- Belt tensioner right assembly (1x) *you assembled earlier*

PASSO 28 Installing the motor mount left



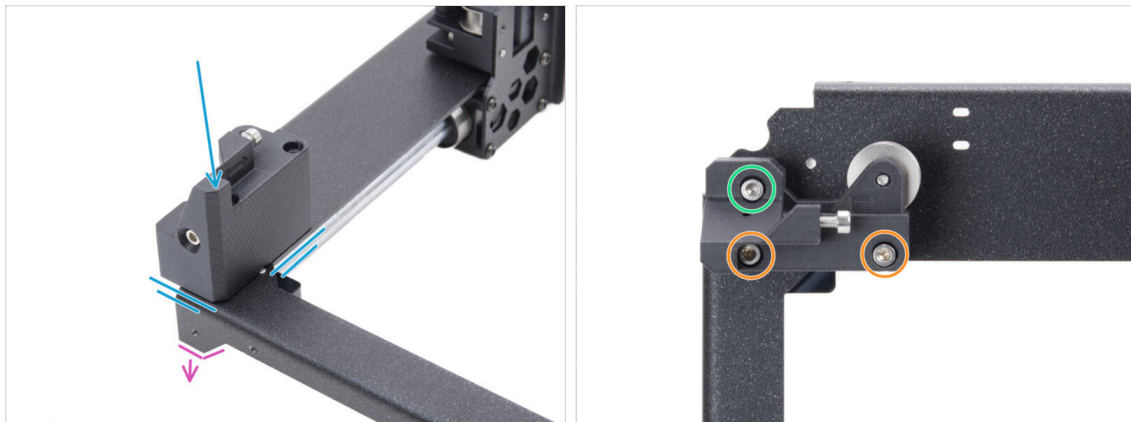
- Locate the corner of the CoreXY plate with the Faston connector on it. It is on the underside of the assembly.
- Position the motor-mount-**left** on the CoreXY plate as shown in the picture.
- Note the rectangular protrusion on the motor-mount-left and the rectangular cutout on the CoreXY plate.
- Fai scorrere il supporto motore sinistro sotto la piastra CoreXY, assicurandoti che la sporgenza rettangolare si inserisca nella fessura.
- Align the holes in both parts and secure them with an M3x6 screw in the designated hole

PASSO 29 Installing the motor mount right



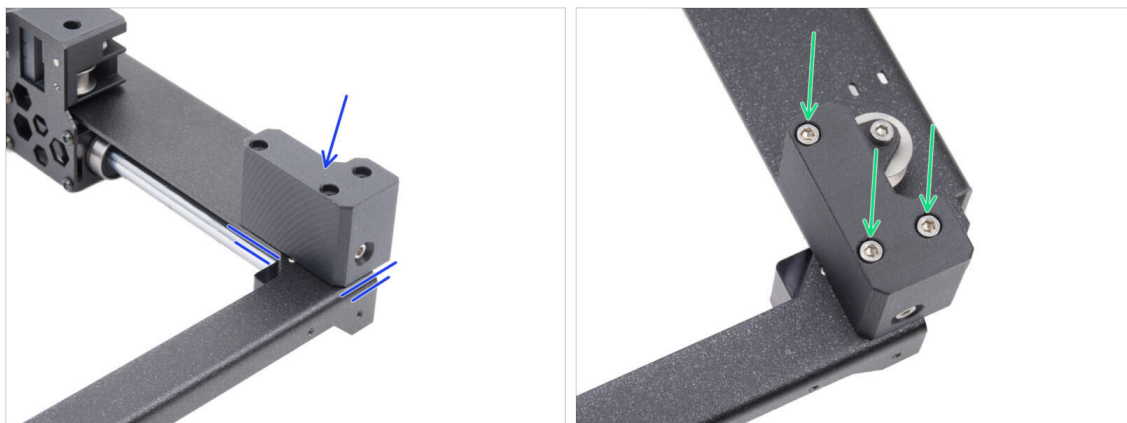
- ✿ Position the motor-mount-**right** on the CoreXY plate as shown in the picture.
- ✿ Fai attenzione alla sporgenza rettangolare sul supporto motore destro e al ritaglio rettangolare sulla piastra CoreXY.
- ✿ Fai scorrere il supporto motore destro sotto la piastra CoreXY, assicurandoti che la sporgenza rettangolare si inserisca nella fessura.
- ✿ Align the holes in both parts and secure them with an M3x6 screw in the designated hole

PASSO 30 Installazione del tenditore belt-tensioner-left



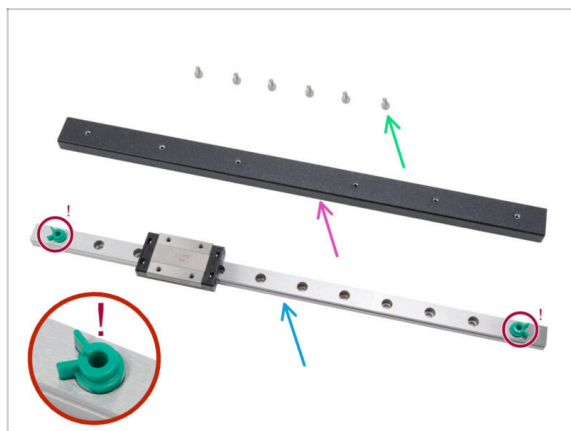
- ✿ Turn the CoreXY assembly upside down so that the bent parts face downward. Focus on the front left corner on the assembly.
- ✿ Place the belt-tensioner-**left** assembly in the front left corner of the CoreXY plate. Align it with the front and inner side edges.
 - ✿ Line up the holes in both parts.
 - ✿ Secure the part with two M3x30 screws.
 - ✿ Insert and tighten one M3x18 screw.

PASSO 31 Installazione del tenditore belt-tensioner-right



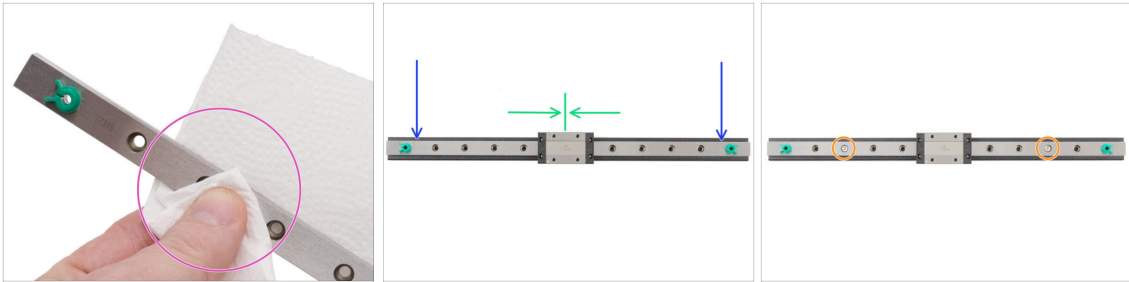
- Place the belt-tensioner-**right** assembly in the front right corner. Align it with the front and inner side edges.
- Line up the holes in both parts.
- Secure the part with three M3x30 screws.

PASSO 32 Linear rail: parts preparation



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

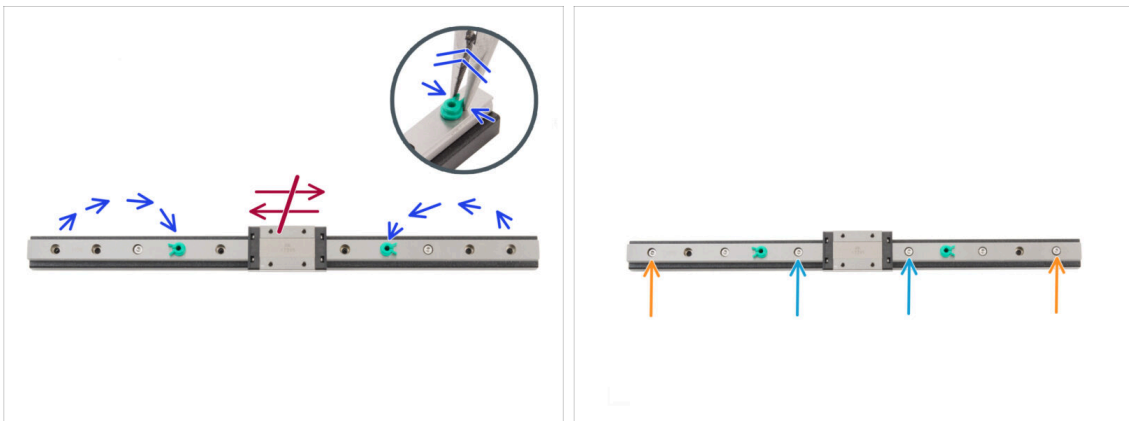
PASSO 33 Attaching the linear rail



⚠ 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.
- 🟢 Move the linear carriage approximately to the center of the rail.

PASSO 34 Securing the linear rail

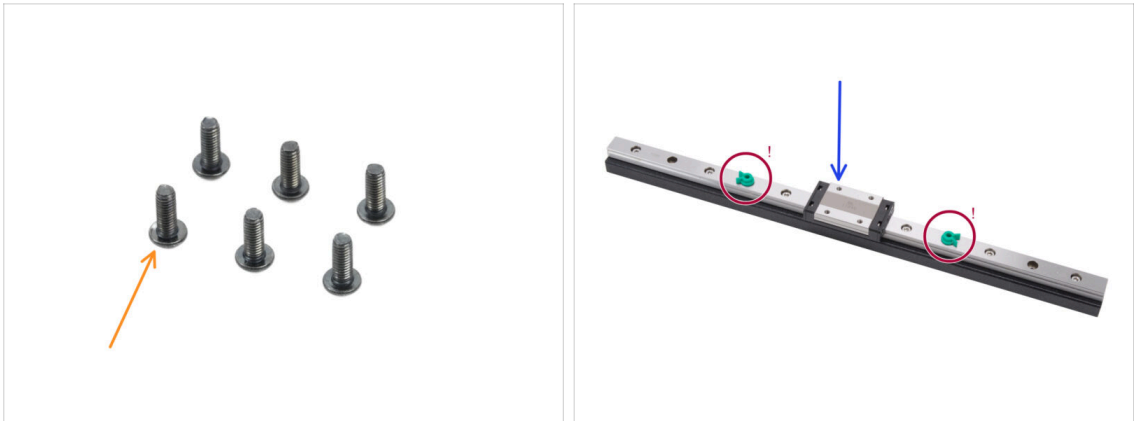


⚠ Do not move the linear carriage in any way in this step.

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

⚠ Do not remove the safety pins from the rail.

PASSO 35 Installing the linear rail: parts preparation



For the following steps, please prepare:

Vite M3x8rT (6x)

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

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

! Do not remove the safety pins.

PASSO 36 Installing the linear rail assembly



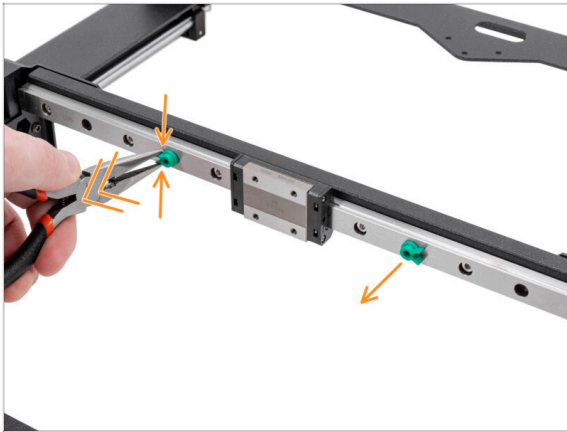
Position the assembly with the motor mounts facing you.

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

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

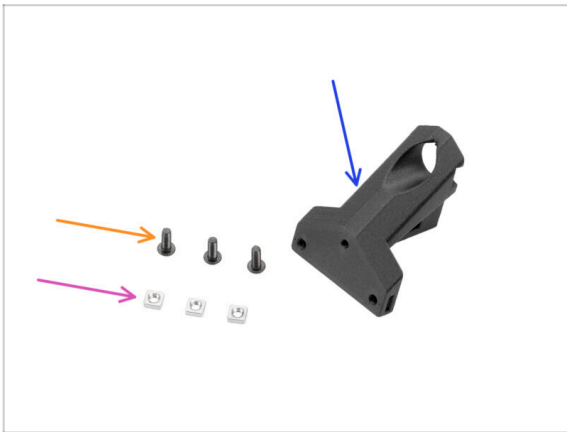
Secure it with three M3x8rT screws from the back side on both the left and right sides.

PASSO 37 Linear rail: removing the safety pins



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

PASSO 38 Finecorsa del piano: preparazione dei componenti



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

PASSO 39 Assemblare il finecorsa del piano



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

PASSO 40 Montare il finecorsa del piano



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

PASSO 41 X&Y motors: parts preparation



- For the following steps, please prepare:
- Y-axis motor (1x) *found in the Motors package*
- X-axis motor (1x) *found in the Motors package*
- i** Note that the motors are marked as X and Y-axes in order to distinguish between them. We will continue to follow this marking.
- Pulley T16-2GT (2x) *found in the Electronics package*
- Assembly-multi-tool (1x) *you already used*

PASSO 42 Installing the X-axis pulley



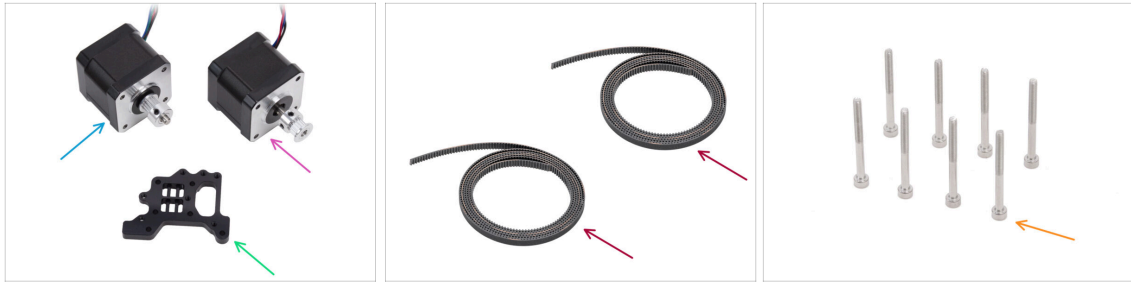
- Prepare the **X-axis** motor.
- Note the flat part on the motor shaft.
- ⚠ Slide the Pulley on, **note the CORRECT orientation.**
- Rotate the motor shaft with the flat part facing you.
- Using the fork on the Assembly-multi-tool set a gap between the pulley and the motor.
- Push the pulley on the tool and firmly tighten the screw against the flat part on the shaft.
- Rotate the pulley and firmly tighten the second grub screw.
- ⚠ **Ricontrolla l'orientamento della puleggia. Il lato dentato della puleggia deve essere sul lato del motore.**

PASSO 43 Installing the Y-axis pulley



- Prepare the **Y-axis** motor.
- Note the flat part on the motor shaft. Rotate the motor shaft with the flat part facing you.
- ⚠ Slide the Pulley on, and **note the CORRECT orientation. The Y-axis pulley orientation is DIFFERENT from the X-axis. Make sure the pulley teeth face away from the motor. Use the wider hook on the assembly tool.**
- Utilizzando l'uncino dello strumento di montaggio (Assembly-multi-tool), metti la parte curva più spessa tra la puleggia e il motore.
- ⚠ **Non provare ad agganciarlo all'albero.** Appoggia semplicemente lo strumento contro il motore e assicurati che la punta del gancio scivoli tra il motore e la puleggia.
- Push the pulley on the tool and firmly tighten the screw against the flat part on the shaft.
- Rotate the pulley and firmly tighten the second grub screw.
- ⚠ **Ricontrolla l'orientamento della puleggia. I denti devono essere rivolti nella direzione opposta al motore.**

PASSO 44 XY belts: parts preparation



● For the following steps, please prepare:

- X-axis motor assembly (1x) *you assembled earlier*
- Y-axis motor assembly (1x) *you assembled earlier*
- Nexttruder holder (1x) *found in the CORE XY parts + hinges + HB set package*
- XY belt (2x) *found in the CORE XY parts + hinges + HB set package*
- Vite M3x35 (8x)

PASSO 45 INFO Cinghie XY



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

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

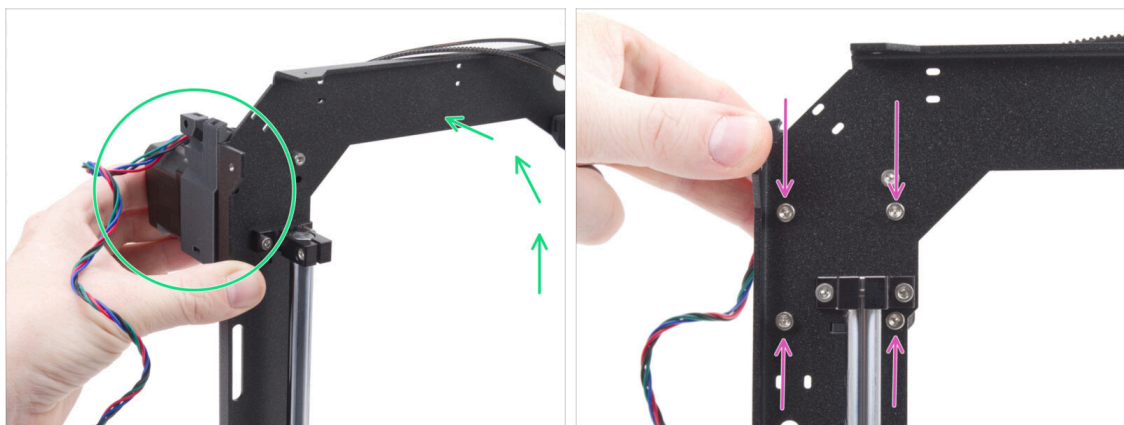
● Let's guide the belts step by step...

PASSO 46 Y belt guiding: Y motor pulley



- From the back of the CoreXY, focus on the motor-mount on the **left** side.
- Create a loop anywhere on the belt so the **belt teeth are pointing inside** the loop.
- Push this loop through the space between the lower pulleys inside the motor mount.
- Push through enough to make the loop follow the top round hole of the motor-mount as closely as possible.
- Insert the **Y** motor into the motor holder, the pulley must be in the middle of the belt loop.
- Insert the Y motor pulley into the motor mount, ensuring the pulley is centered within the belt loop.
Fully attach the motor to the motor-mount with the motor cable facing you.
- Pull lightly on the belt loop to encircle the pulley.

PASSO 47 Securing the Y-axis motor



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

PASSO 48 Y belt guiding: Y motor mount



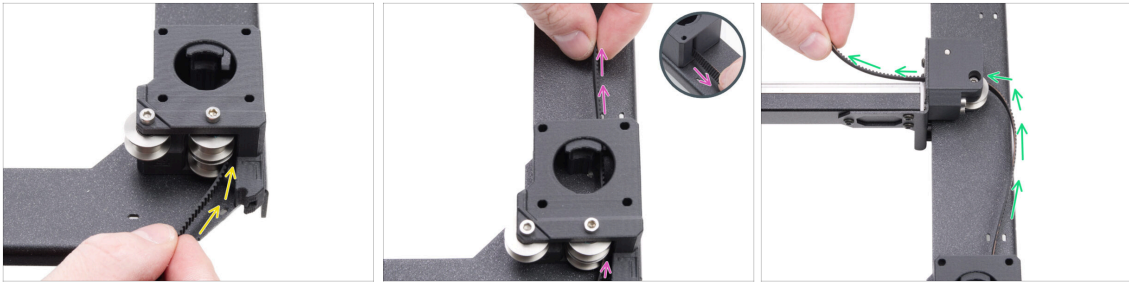
- 🟠 Guide the left end of the belt around the lower left pulley.
- 🟣 Spingi la cinghia attraverso il pezzo e guidala verso la parte anteriore della piastra CoreXY.
- ⚠️ **Don't pull too long so you don't pull the whole belt out.** Remember that the other end is loose. The whole process would then have to be repeated.

PASSO 49 Y belt guiding: belt tensioner



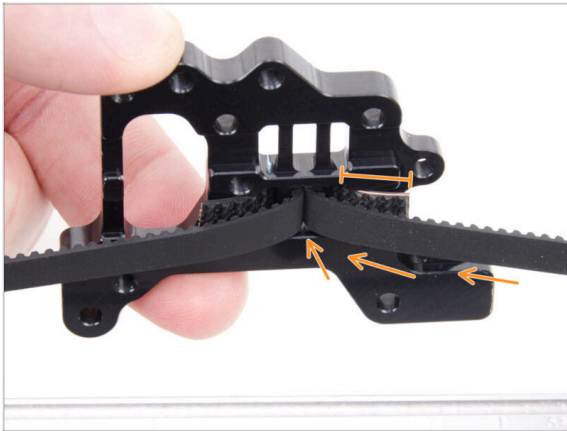
- 🟠 Guida la cinghia intorno alla puleggia del tendicinghia.
- 🟣 Spingi la cinghia intorno alla puleggia anteriore nel gruppo lineare.
- 🟢 Prepare the Nextruder holder in the same orientation as in the picture. Note the holes for securing the belts.
- 🔵 Push the end of the belt through the middle hole into the left hole in the bottom row - leave 4-5 teeth sticking out.
- 📁 The belt is secured on this end. You can leave it free for now.

PASSO 50 Y belt guiding: X motor mount



- Back to the other end of the Y belt.
- Prendi l'altra estremità della cinghia e guidala intorno alla puleggia inferiore del supporto motore X.
- Push it through the motor mount to the front.
- Route the belt around the lower right pulley in the linear rail holder.

PASSO 51 Y belt guiding: securing the belt



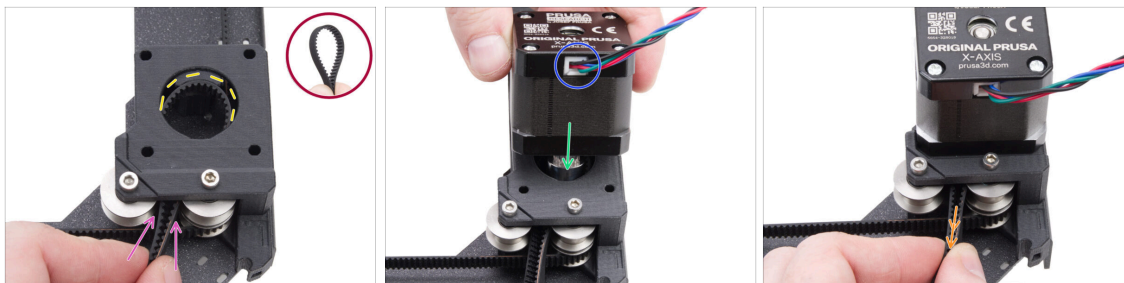
- Push the end of the belt through the middle hole to the right hole in the bottom row of the Nextruder holder - leave 4-5 teeth sticking out.

i Se è difficile raggiungere il supporto Nextruder con la cinghia, prova allentando la vite del tendicinghia sulla parte anteriore del gruppo.



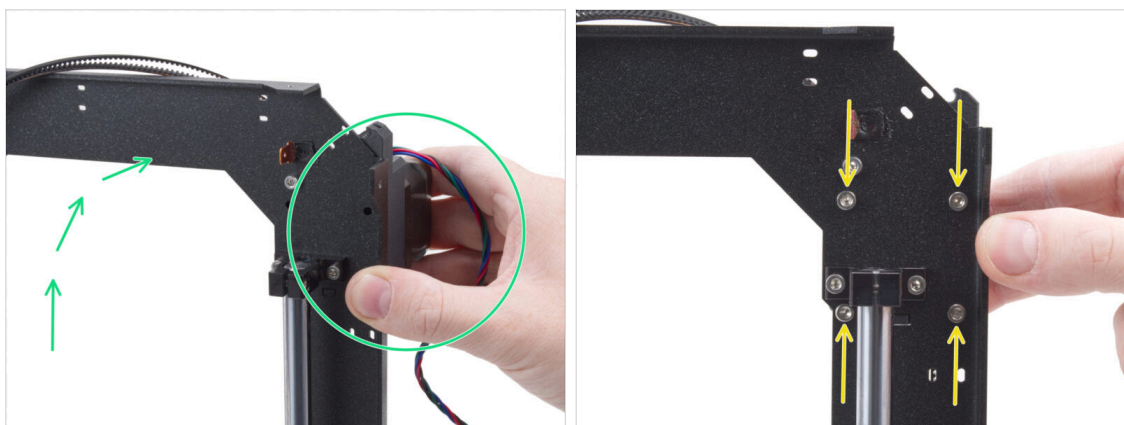
Non dimenticare di regolarlo dopo aver fissato la cinghia.

PASSO 52 X belt guiding: X motor pulley



- From the back of the CoreXY, focus on the motor-mount on the **right** side.
- Crea un occhiello in un punto qualsiasi della seconda cinghia in modo che i denti della cinghia siano rivolti verso l'interno.
- Fai passare questo occhiello attraverso lo spazio tra le pulegge superiori all'interno del supporto motore.
- Push through enough to make the loop follow the top round hole of the motor-mount as closely as possible.
- Insert the **X** motor pulley into the motor mount, ensuring the pulley is centered within the belt loop.
- Ensure the motor cable is facing you (rear).
- Pull lightly on the belt loop to encircle the pulley.

PASSO 53 Securing the X-axis motor



- Firmly grasp the X-axis motor assembly and position the CoreXY assembly vertically. **Do not drop the motor!**
- ⚠ Fai attenzione a non estrarre l'intera cinghia dal motore.
- Continua a tenere il motore con una mano. Con l'altra mano, fissalo con quattro viti M3x35 sul lato inferiore del telaio. **Stringerle bene.**
- Place the CoreXY assembly back into the horizontal position.

PASSO 54 Y belt guiding: X motor mount



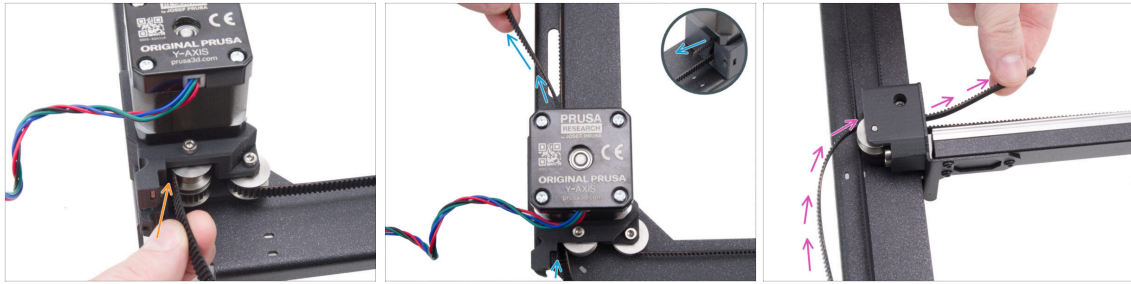
- Guide the right end of the belt around the upper right pulley.
- Spingi la cinghia attraverso il pezzo e guidala verso la parte anteriore della piastra CoreXY.
- ⚠ **Non tirare troppo a lungo per evitare di tirare fuori tutta la cinghia.** Ricorda che l'altra estremità è allentata. A quel punto bisognerà ripetere l'intero processo.

PASSO 55 X belt guiding: belt tensioner



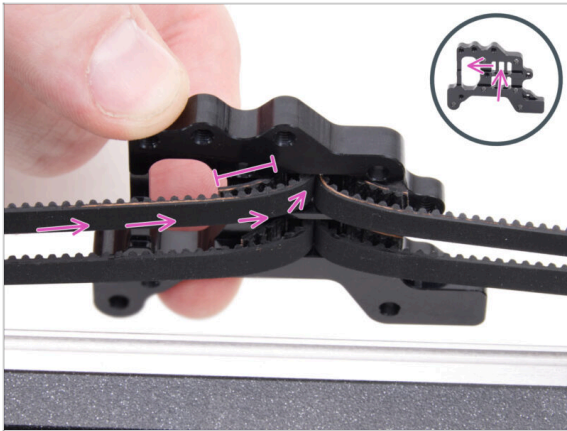
- Guida la cinghia intorno alla puleggia del tendicinghia.
- Spingi la cinghia intorno alla puleggia anteriore superiore nel gruppo lineare.
- Fai passare l'estremità della cinghia attraverso il foro centrale verso il foro destro, lasciando fuoriuscire 4-5 denti.
- ⓘ The belt is secured on this end. You can leave it free for now.

PASSO 56 X belt guiding: Y motor mount



- Back to the other end of the X belt.
- Prendi l'altra estremità della cinghia e guidala intorno alla puleggia superiore del supporto motore Y.
- Spingi la cinghia attraverso il supporto del motore.
- Route the belt around the upper front pulley in the linear rail holder.

PASSO 57 X belt guiding: securing the belt



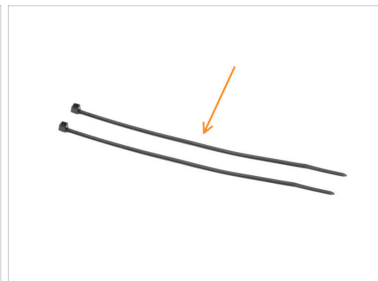
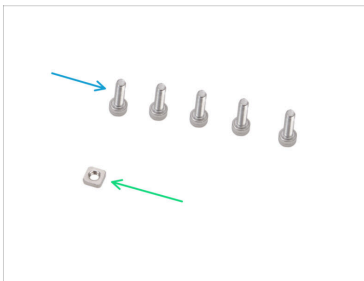
- Push the end of the belt through the middle hole to the left hole in the upper row of the Nextruder holder - leave 4-5 teeth sticking out.

PASSO 58 Checking the belt guidance



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

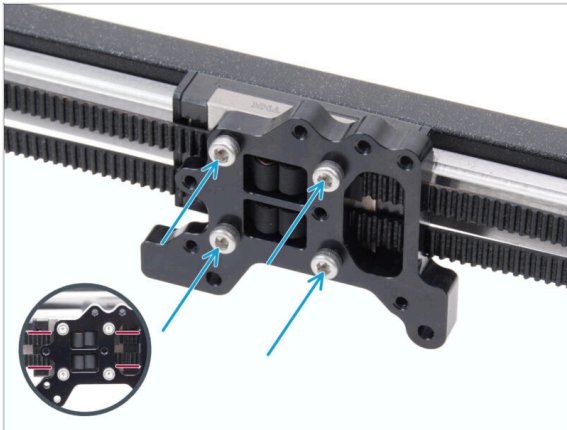
PASSO 59 Bowden guide: parts preparation



● For the following steps, please prepare:

- Bowden-guide (1x) *si trova nella confezione Printed parts*
- Vite M3x10 (5x)
- Dado M3nS (1x)
- Fascetta (2x)

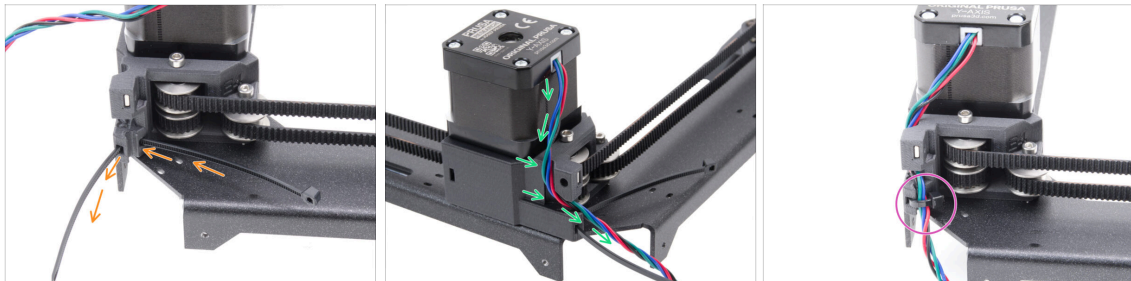
PASSO 60 Securing the Nextruder holder



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

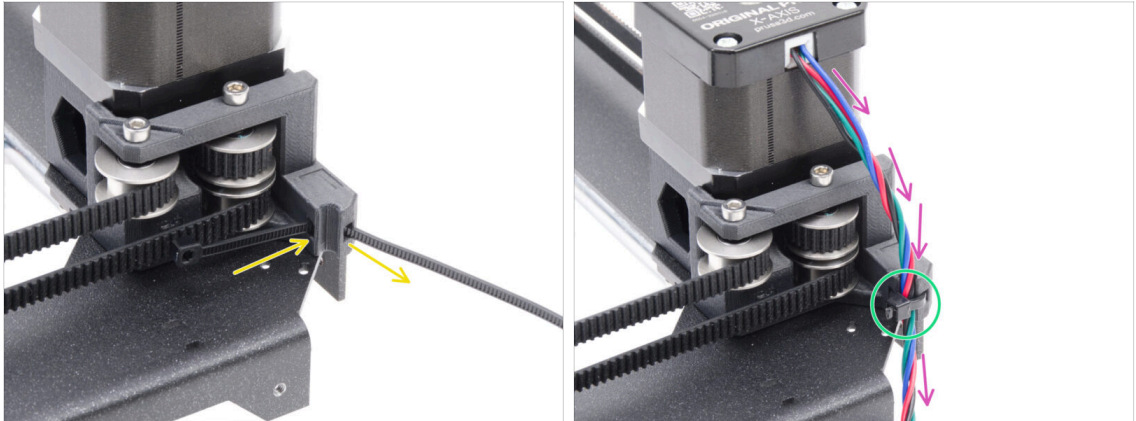
⚠ ATTENZIONE: assicurati che la cinghia non ostruisca la vite. Non avvitare attraverso la cinghia!

PASSO 61 Securing the Y motor cable



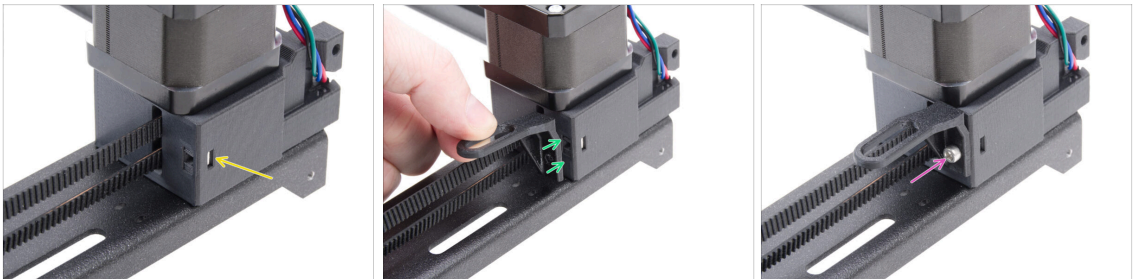
- Push the zip tie through the motor-mount-right.
- Fai passare il cavo del motore Y attraverso il canale del supporto motore destro e sopra la fascetta.
- Fissa il cavo con una fascetta e taglia la parte in eccesso.

PASSO 62 Securing the X motor cable



- ✚ Push the zip tie through the motor-mount-left.
- ✚ Fai passare il cavo del motore X attraverso la guida del cavo nel supporto motor-mount-left e sopra la fascetta.
- ✚ Fissa il cavo con una fascetta e taglia la parte in eccesso.

PASSO 63 Installing the bowden guide



- ✚ Insert the M3nS nut into the motor-mount-right.
- ✚ Monta la guida bowden al supporto destro del motore (motor-mount-right).
- ⚠ **Nota il corretto orientamento del pezzo.**
- ✚ Fix the bowden-guide in place using the M3x10 screw.

PASSO 64 White LED strip: parts preparation



● For the following steps, please prepare:

● Striscia LED bianca (1x) si trova nella confezione Electronics & Fasteners

● Montante CoreXY (1x) si trova nella confezione Metal parts 1/3

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

● Vite M3x4rT (2x)

PASSO 65 Sticking the White LED strip



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

⚠ Dopo aver rimosso lo strato protettivo, la striscia LED è adesiva.

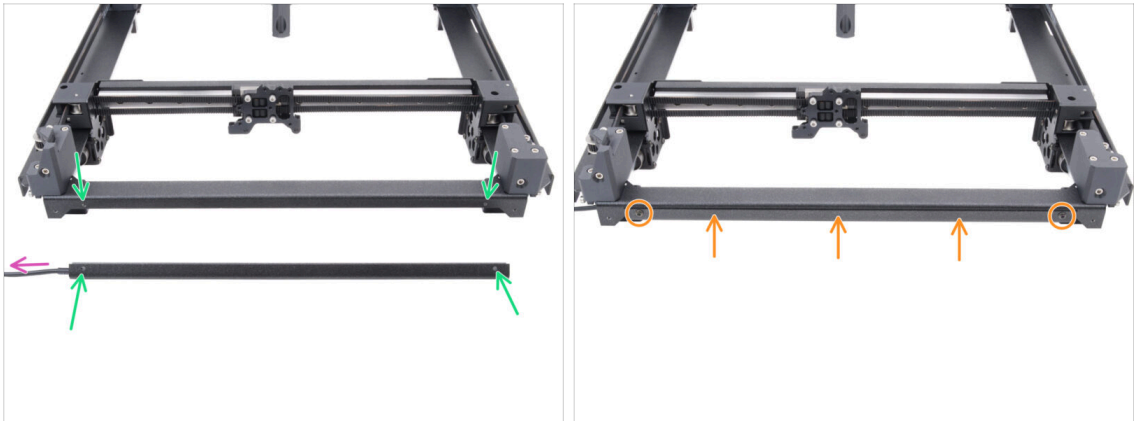
● Posiziona la striscia LED bianca vicino al montante CoreXY per verificare l'allineamento, ma **non fissarla ancora**.

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

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

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

PASSO 66 Installing the white LED assembly



- Take the white LED assembly and attach it to the front of the CoreXY assembly. Align the holes of both parts.
- **Il cavo della striscia LED bianca deve essere rivolto verso sinistra.**
- Monta il gruppo LED alla piastra CoreXY e fissalo con due viti M3x4rT.

PASSO 67 Door sensor & White LED strip: parts preparation



- **For the following steps, please prepare:**
- Sensore sportello (1x) *si trova nella confezione Electronics & Fasteners*
- Vite M2.5x10 (1x) *argentata*
- Fascetta (4x)

PASSO 68 Inserting the zip ties



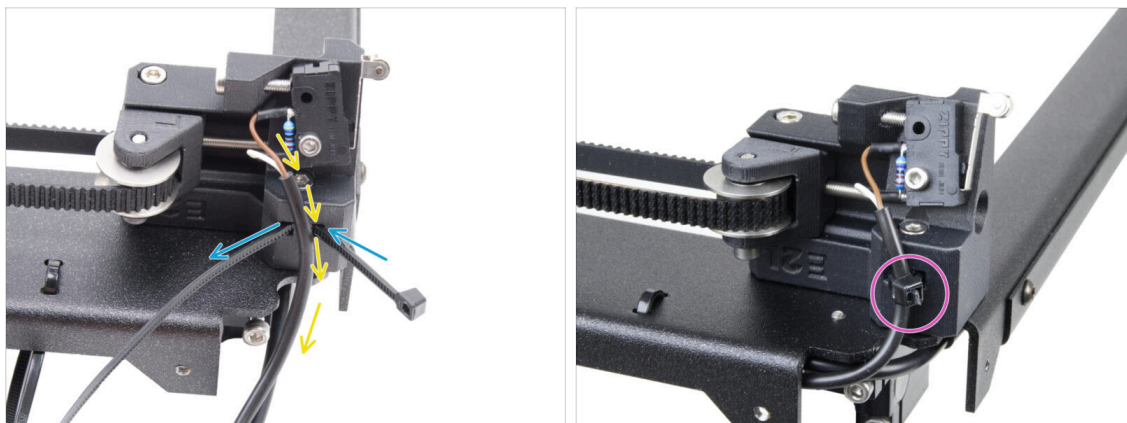
- ◆ Flip the CoreXY assembly upside down and rest it on the motors.
- ◆ Posizionalo con il cavo della striscia LED bianca rivolto verso di te.
- ◆ Fai passare tre fascette attraverso la piastra CoreXY, assicurandoti che le teste delle fascette siano rivolte verso l'interno. **Assicurati che le fascette non si aggancino alle cinghie dall'altro lato.**
- ◆ Partially tighten the zip ties—just enough to catch the first few teeth.
- ⚠ **Do not fully secure them yet, as we will route cables through them later.**
- ◆ Flip the assembly back with the motors facing upwards.

PASSO 69 Installing the door sensor



- ◆ Place the door sensor on the left belt tensioner. The lever of the door sensor must face forward.
- ◆ Secure the door sensor with the M2.5x10 screw.
- ◆ Stringi bene il bullone e poi allentalo di 1/4 di giro. Il sensore deve poter muoversi.
- ◆ From the rear of the belt tensioner, tighten the M3x12 screw so that it touches the door sensor.

PASSO 70 Securing the door sensor cable



- ◆ Push the zip tie through the hole in the left belt tensioner.
- ◆ Guide the door sensor cable through the zip tie.
- ◆ Stringi la fascetta per fissare il cavo del sensore dello sportello. Taglia la parte in eccesso.

PASSO 71 Guiding the cables: LED and door sensor



- ◆ Prepare a cardboard box. You can use any box from the kit. *The box used in the picture is for illustrative purposes only.*
- ◆ Flip the CoreXY assembly upside down, positioning the smooth rods on top.
- ◆ Solleva leggermente e sorreggi la parte anteriore del gruppo CoreXY usando la scatola di cartone.
- ⚠ **Be careful not to damage the door sensor.**
- ◆ Route the white LED strip cable and the door sensor cable through the zip ties.
- ◆ Tighten all the zip ties to secure the cables. Cut off the excess zip ties.
- ⓘ **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.

PASSO 72 Note sulla Fotocamera Buddy3D



- For future Buddy3D Camera users only. **Skip this step if you are not planning to install the Buddy3D Camera.**

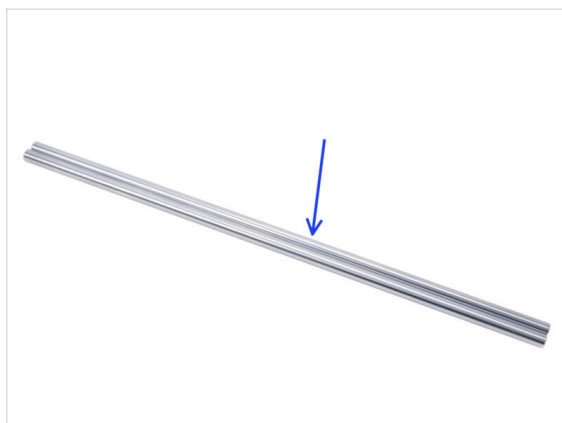
⚠ Disclaimer: Typically, the printer must be fully assembled and tested before any add-ons can be installed. Choosing to install the Buddy3D Camera USB cable now will save you time later on.



Per maggiori dettagli su come posizionare i cavi, dai un'occhiata alla guida dedicata **Installazione fotocamera Buddy3D per CORE One**

- The above-mentioned guide on how to install the Buddy3D Camera shows the printer in a further stage of assembly.
- For now, use the guide to make sure that the cable is installed correctly and tighten the zipties.
- i** We will let you know later on when to return to the guide and finish the Buddy camera installation.

PASSO 73 Smooth rods: parts preparation



- For the following steps, please prepare:**
- Smooth rod 330 x 8 mm (2x) *found in the Rods box*
- Vite M3x8rt (1x)

PASSO 74 Installing the CoreXY assembly



- Carefully insert both smooth rods through the heatbed assembly bearings and into the rod mount part in the base assembly.

⚠ **It is a requirement to insert the smooth rod in the axis with the bearing very slowly to prevent the balls from shooting out of the bearing.**

- Appendi temporaneamente i cavi delle ventole di raffreddamento sul pannello posteriore. **Deve esserci uno spazio tra i cavi e la tasca del pannello posteriore.**
- Exercise extreme caution when placing the assembly on the smooth rods and back panel assembly.

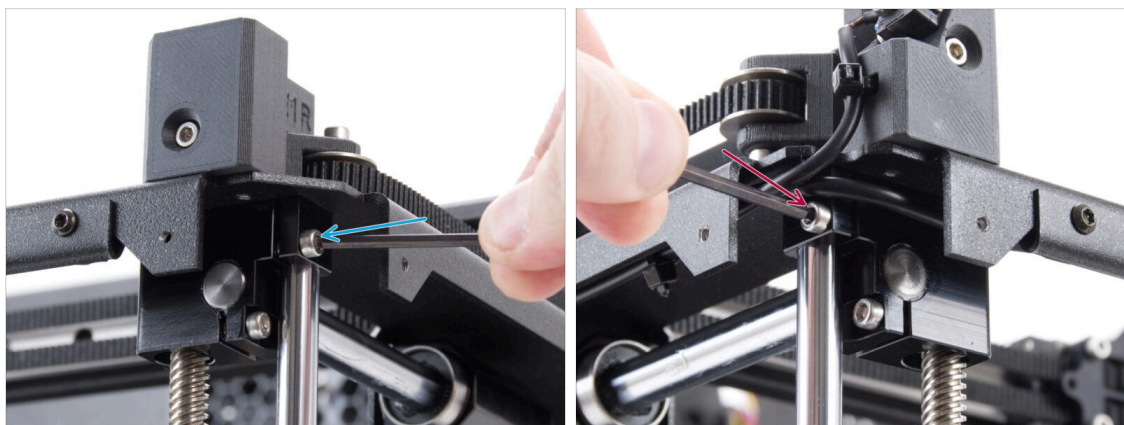
⚠ **Ensure that no cables are pinched.**

- Ensure both smooth rods are properly seated in the rod holders.

- The threaded rod of the rear Z motor must pass through the bed-stop-rear part.

⚠ **WARNING: When handling the printer, DO NOT lift it by the CoreXY assembly. Always lift it by the base of the entire assembly.**

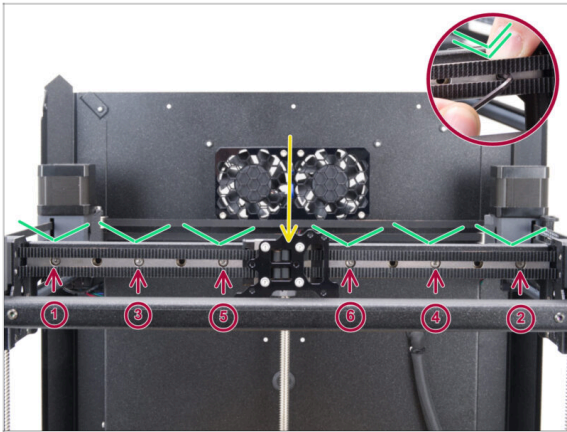
PASSO 75 Securing the smooth rods



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

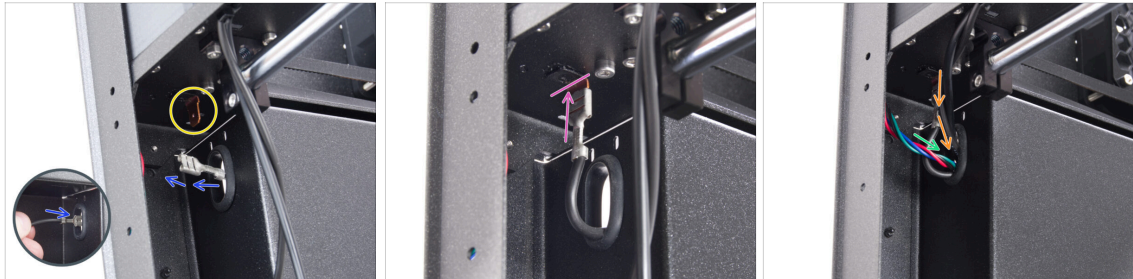
- Firmly tighten the right M3x10 screw to secure the smooth rod.
- Stringi con forza la vite M3x10 sinistra per fissare la barra liscia.

PASSO 76 Aligning the linear rail



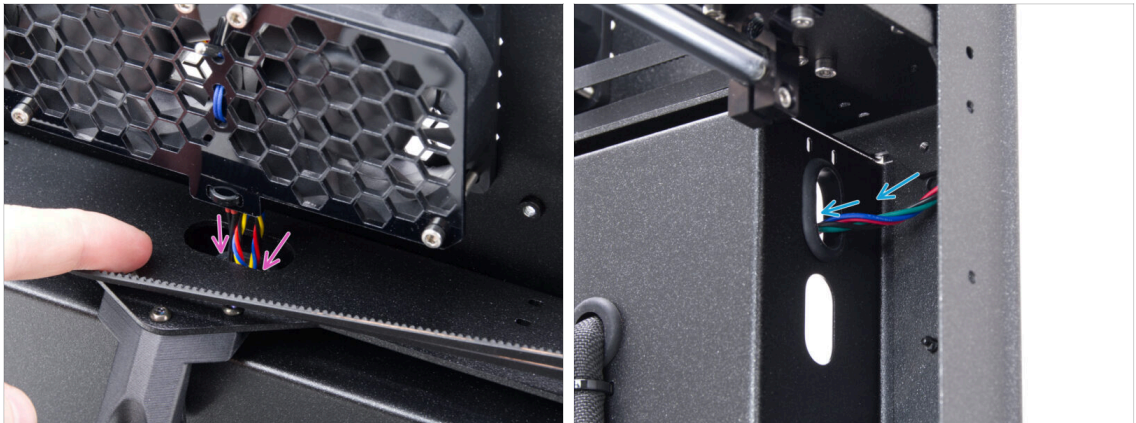
- Move the linear rail carriage to the center.
- ⚠ Stringi saldamente tutte le viti nell'ordine mostrato nell'immagine.
- Spingi la guida lineare verso il basso mentre la stringi.

PASSO 77 Guiding the corexy cables



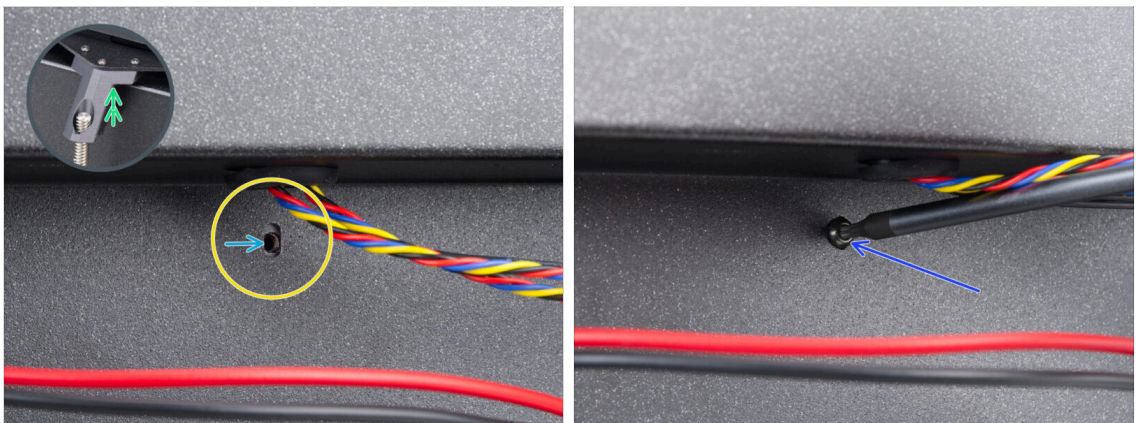
- From the back of the printer, push the FE connector through the oval hole.
- Trova il connettore del cavo FE (numero 5) nell'angolo posteriore sinistro, sotto il gruppo CoreXY.
- Inserisci il connettore FE sul faston presente sul lato inferiore della piastra CoreXY.
- On the same side, push the X motor cable through the oval hole in the back panel.
- Push the White LED strip and Door sensor cables through the oval hole in the back panel.

PASSO 78 Guiding the cooling fan cables



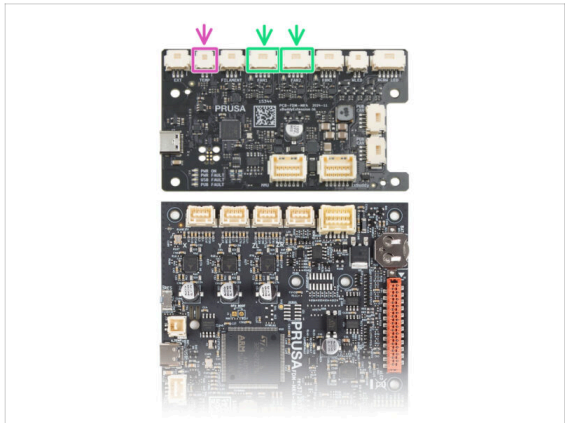
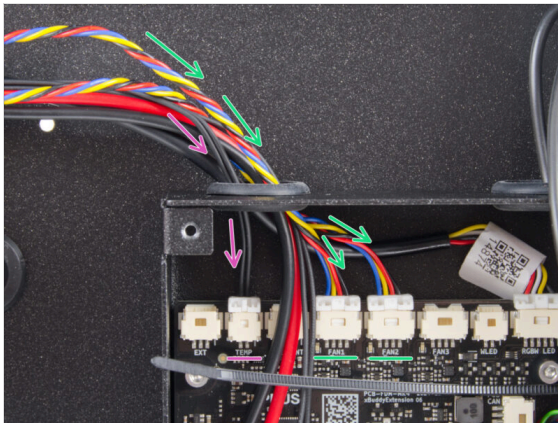
- Push the cooling fan and thermistor cables through the oval hole in the back panel.
- Nell'angolo posteriore destro, individua il cavo del motore Y e spingilo attraverso il foro ovale superiore presente nel pannello posteriore.

PASSO 79 Fissare il finecorsa del piano



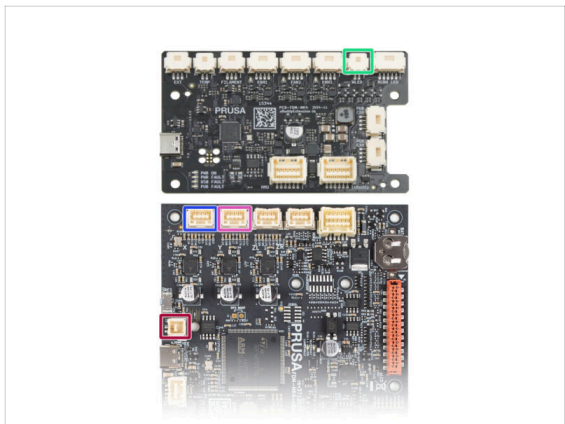
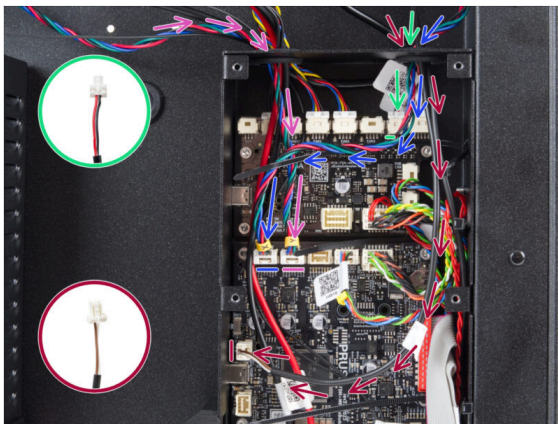
- From the back side, locate the oval screw hole under the cooling fans.
- Il foro ovale deve essere a filo con il foro nel finecorsa del piano sul lato opposto.
- Per compensare, alza leggermente la parte posteriore del gruppo CoreXY, solo di qualche millimetro.
- After aligning the holes, secure them with an M3x8rT screw.

PASSO 80 Connecting the cooling fans cables



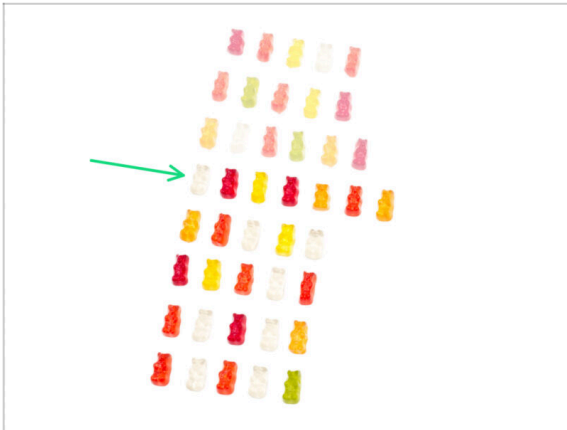
- Route the cooling fan cables through the left hole in the xBuddy box and plug them into the fourth and fifth slots on the xBuddy extension board labeled FAN 1 and FAN 2.
- ❗ L'ordine di collegamento non ha importanza, entrambi i cavi sono uguali.
- Fai passare il cavo del termistore della camera insieme ai cavi della ventola di raffreddamento.
- Connect it to the second slot from the left on the xBuddy extension board labeled TEMP.

PASSO 81 Connecting the corexy cables



- Guide the X motor cable through the right hole in the xBuddy box. Connect it to the first slot from the left on the xBuddy board.
- Fai passare il cavo del sensore dello sportello attraverso il foro destro della scatola xBuddy. Collegalo allo slot inferiore sul lato sinistro della scheda xBuddy.
- Fai passare il cavo della striscia LED bianca attraverso il foro destro nella scatola xBuddy. Collegalo al secondo slot da destra sulla scheda di estensione xBuddy.
- 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.

PASSO 82 È l'ora delle Haribo!



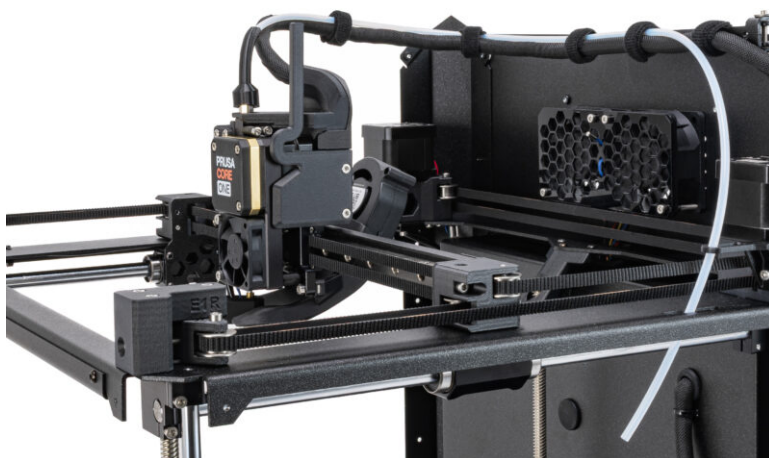
- Think it's snack o'clock again.
- Ti meriti di mangiare tutto il sacchetto, ma trattieniti... Mangia solo la quarta fila.

PASSO 83 Fatto

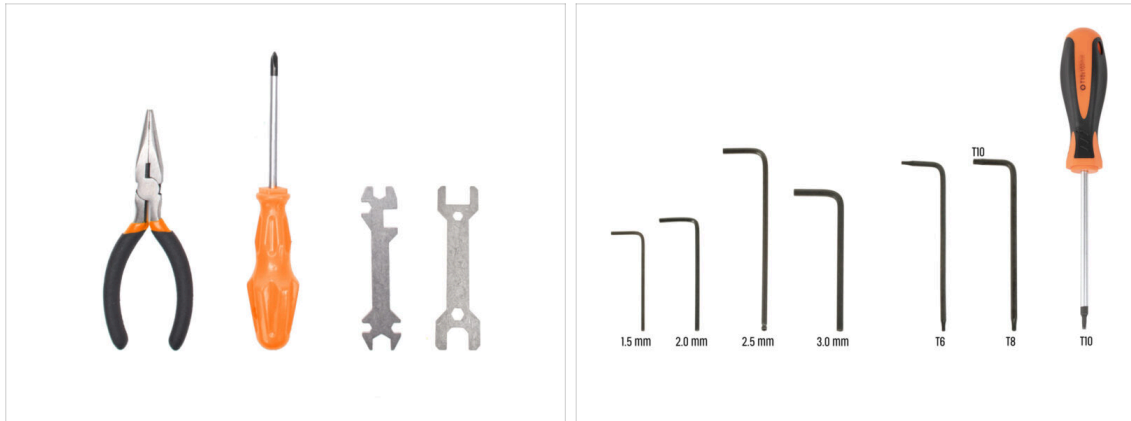


- Congratulations! You have just assembled and installed the CoreXY assembly.
- Andiamo al prossimo capitolo.

6. Gruppo Nextruder



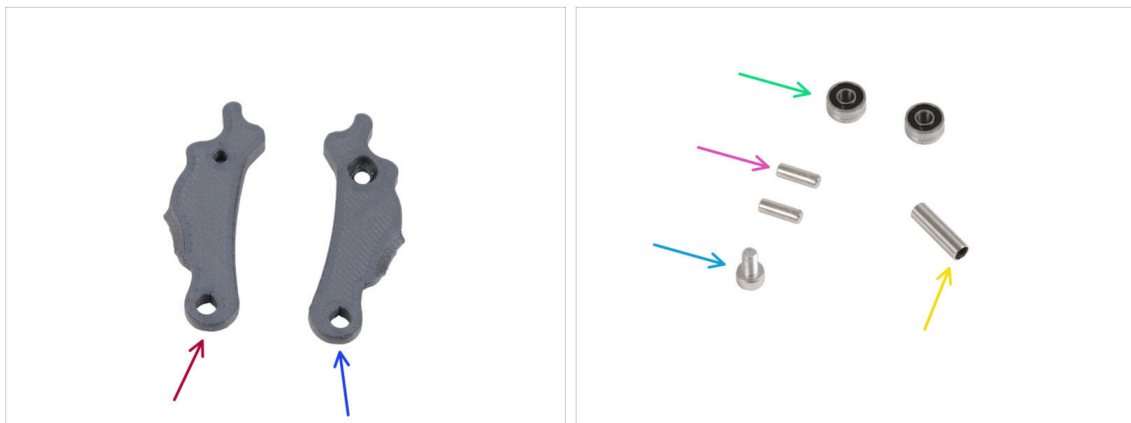
PASSO 1 Tool necessary for this chapter



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

- Chiave universale
- Chiave a brugola da 1.5mm
- Chiave a brugola da 2.5mm
- Chiave Torx T6
- T10 torx key / T10 torx screwdriver

PASSO 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) *si trova nella confezione Electronics*
- Bearing 693 2RS (2x) *found in the Electronics package*
- Pin 2.9x8.5 (2x) *found in the Electronics package*
- Vite M3x6 (1x)
- Tubular spacer 13.2x3.8x0.35 (1x) *found in the Electronics package*

PASSO 3 Assemblare l'Extruder-idler



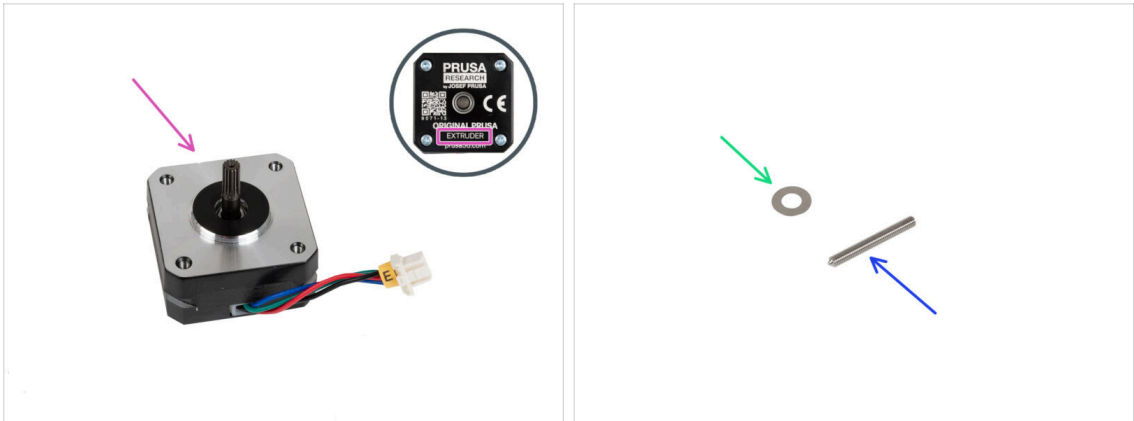
- Place both bearings into the Idler-lever-a.
- Insert the pin 2.9x8.5 into each bearing 693 2RS, as seen in the picture.
- Chiudilo con la leva del tenditore Idler-lever-b e fissalo con la vite M3x6. **Non stringere troppo la vite.** Entrambi i cuscinetti devono essere in grado di ruotare senza incontrare una resistenza significativa.
- 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.

PASSO 4 Assembling the extruder: parts preparation I.



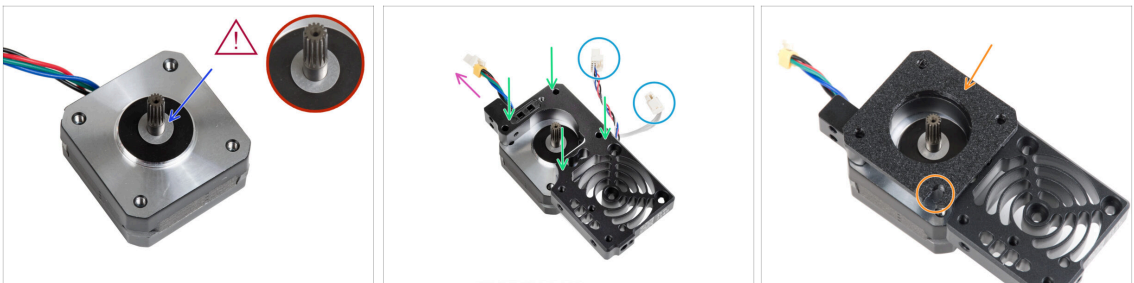
- **For the following steps, please prepare:**
- PG-assembly (1x) *found in the Electronics package*
- Gruppo Dissipatore (1x) *si trova nella confezione Electronics*
- Main-plate (1x) *found in the Electronics package*
- PG-ring (1x) *found in the Electronics package*
- PG-assembly-adaptor (1x) *found in the Electronics package*
- ① The list continues in the next step...

PASSO 5 Assembling the extruder: parts preparation II.



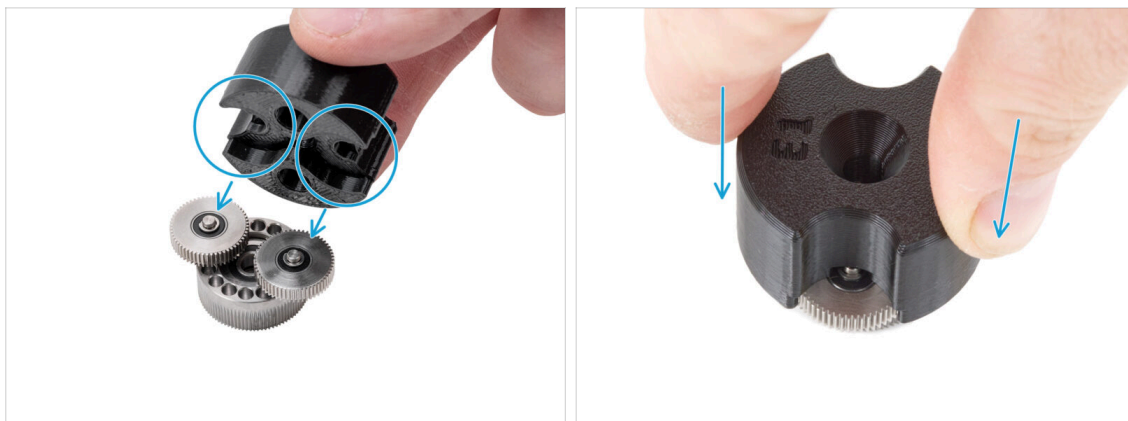
- ◆ Extruder motor (1x) *found in the Motors package*
- ◆ Spacer 5x10x0.1 mm (1x) *found in the Electronics package*
- ◆ Vite senza testa M3x25 (1x) *contenuta nella confezione di Electronics & Fasteners*

PASSO 6 Assemblare l'estrusore



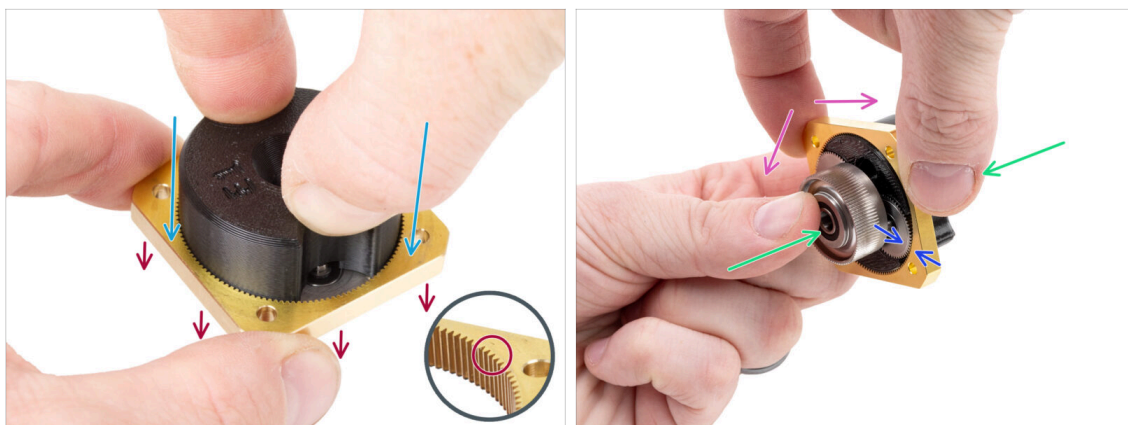
- ◆ Place the 5x10x0.1 spacer over the shaft on the extruder motor.
 - ◆ Place the heatsink on the extruder motor. Note the orientation of both parts.
 - ◆ The motor cable must be facing "up".
 - ◆ The heatsink cables must be on the right side.
 - ◆ Place the main-plate on the heatsink. Note the orientation of the part. Use the cutout as a guide.
- ⚠ **Before proceeding to the next step, make sure that the 5x10x0.1 spacer is placed on the extruder motor.**

PASSO 7 Assemblaggio del riduttore



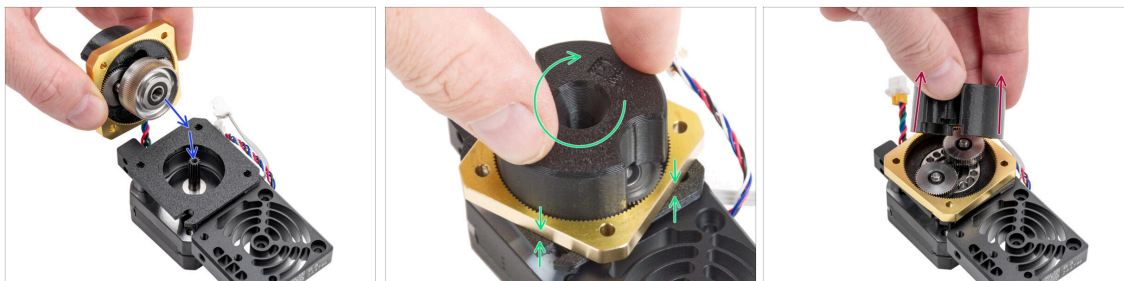
- i** The following instructions need to be done correctly and carefully. Achieve better understanding and successful assembly by watching the video alongside the guide: prusa.io/PG-assembly
- After watching the video, follow the steps in this guide.
 - Attach the PG-assembly-adapter on the PG-assembly. Note the pockets for the gears in the adapter.

PASSO 8 Assemblare l'anello 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.
 - Stop when the surfaces of the gears are approximately flush with the surface of the PG ring.

PASSO 9 Assemblare il gruppo PG-assembly



 **Proceed very carefully in this step.**

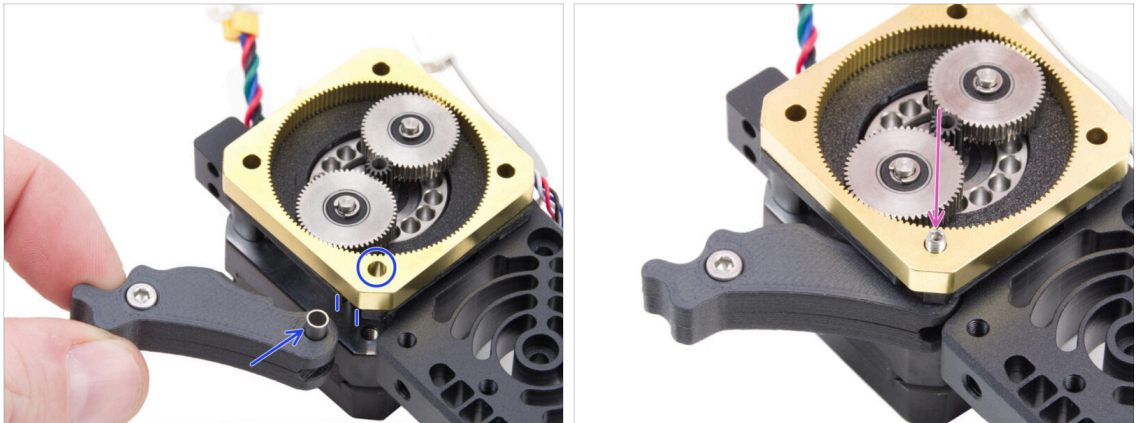
-  Maintain the position of the PG-assembly and attach it on to extruder motor shaft.
-  Very gently and freely rotate with the whole PG assembly (PG-assembly-adapter, PG-assembly and PG-ring) until it drops down so that there is no gap between the assembly and the main-plate. **Do not push on the assembly.**
-  Rimuovi il PG-assembly-adapter.

PASSO 10 Controllo del gruppo 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.

PASSO 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.**

PASSO 12 Gear lubrication: parts preparation



- **For the following steps, please prepare:**
- Front Case (1x) *found in the Printed parts package*
 - ① Il logo sulla parte frontale del Nextruder rimarrà **PRUSA CORE ONE**.
- Vite M3x25 (3x)
- Lubricant (1x) *found in the Electronics & Fasteners package*
- Several paper towels to wipe grease from your hands.

PASSO 13 Lubrificazione degli ingranaggi



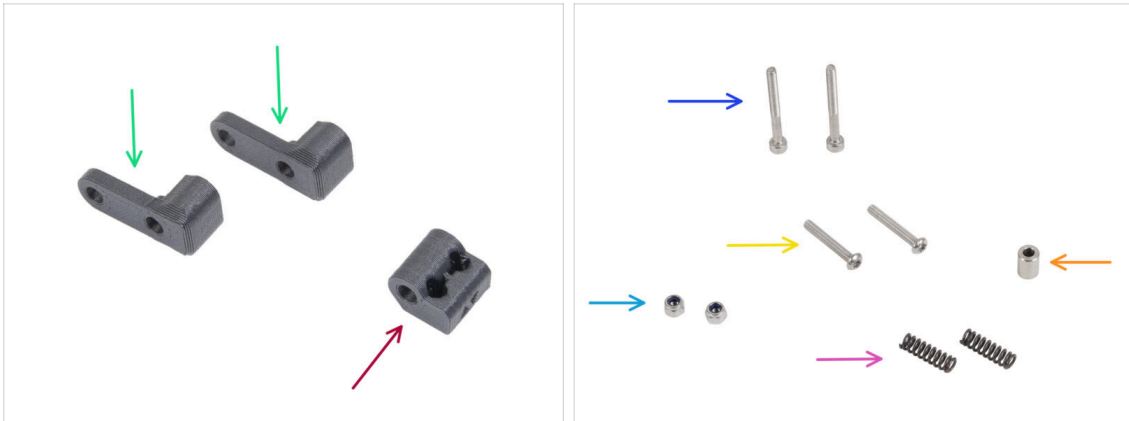
- Remove the cap from the lube. Use the spike on the opposite side of the cap to pierce a hole in the lube tube opening.
- Squeeze a small amount of lubricant onto the tip of the zip tie, then spread it over the gears.
- Apply a small amount of Prusa Lubricant **all around** the PG-ring and PG-assembly teeth.
- Close the lubricant; it is no longer needed for the assembly.

PASSO 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.
- ⓘ The screws on the front case will be completely tightened during the self-test in the final chapter.

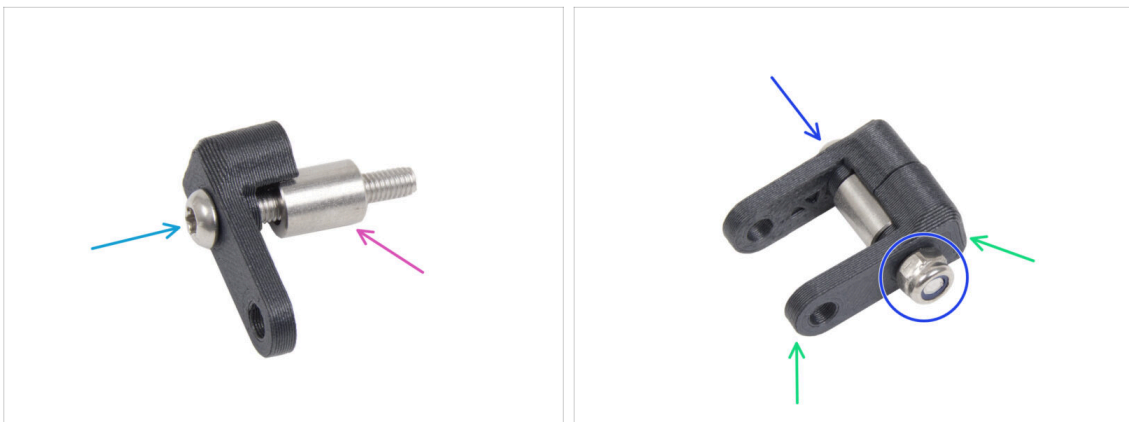
PASSO 15 Assembling the Idler-swivel: parts preparation



For the following steps, please prepare:

- Idler-swivel (2x) *si trova nella confezione Electronics*
- Idler-nut (1x) *found in the Electronics package*
- Vite M3x30 (2x)
- Vite M3x20rT (2x)
- Dado M3nN (2x)
- Spring 15x5 (2x) *found in the Electronics package*
- Spacer 6x3.1x8 (1x) *found in the Electronics package*

PASSO 16 Assemblare l'Idler-swivel



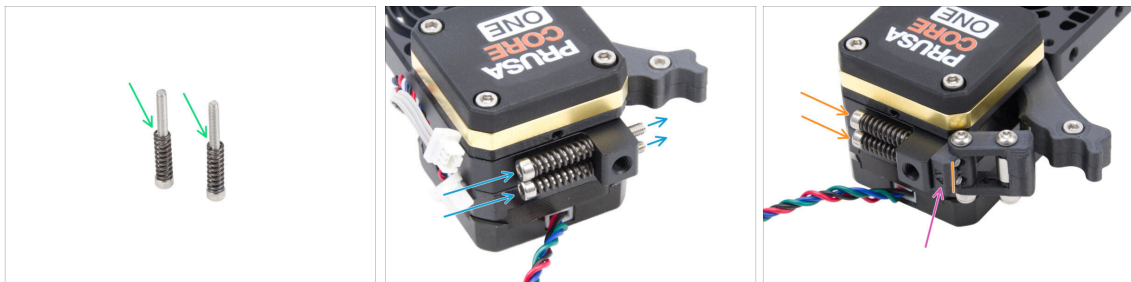
- Push the M3x20rT screw all the way through one of the idler-swivel.
- Fai scorrere il distanziatore sulla vite.
- Place the second idler-swivel from the opposite side on the screw.
- From the other side, attach the M3nN nut onto the screw. Hold the nut using the universal wrench and tighten the screw.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

PASSO 17 Assemblare il dado del tenditore (Idler-nut)



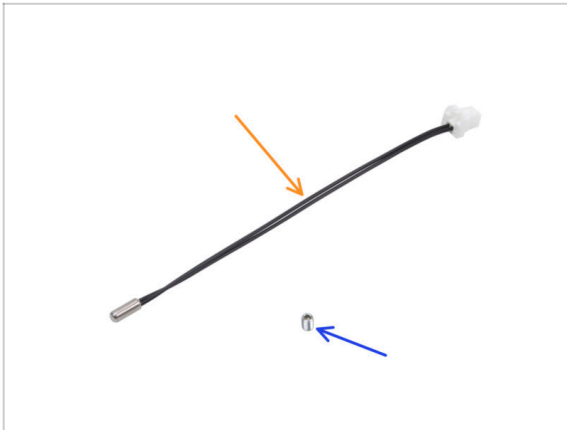
- Insert the Idler-nut into the Idler-swivel assembly. Make sure that both parts are oriented correctly according to the picture.
- Fissa le due parti insieme inserendo la vite M3x20rT dallo stesso lato, come la prima vite.
- Secure the screw with M3nN nut. **Do not overtighten the nut.** It must be possible to move with the Idler-swivel on the Idler-nut.

PASSO 18 Mounting the Idler-swivel assembly



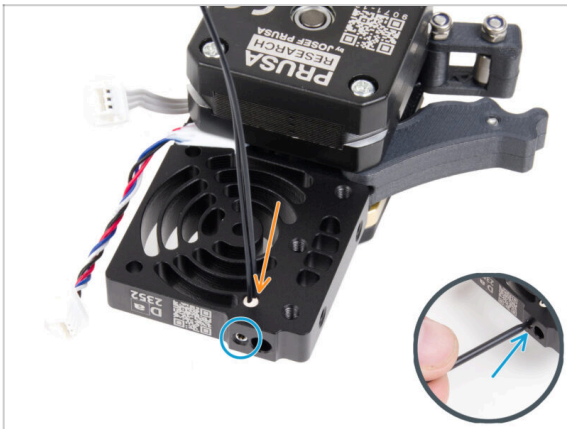
- Attach the spring 15x5 on both M3x30 screws.
- Spingi le due viti con le molle attraverso i fori della sporgenza del dissipatore. Non ci sono filettature all'interno.
- Attach the Idler-swivel assembly on the screws. See the correct orientation of the Idler-nut. The side with version marking must be visible. See the picture.
- Tighten both screws. **Stop tightening as soon as the screw tips reach the front face of the idler nut.**

PASSO 19 NTC thermistor: parts preparation



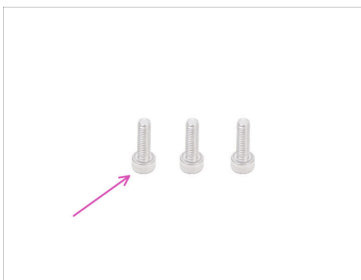
- For the following steps, please prepare:
- Termistore NTC 90 mm (1x) si trova nella confezione Electronics
- M3x4T grub screw (1x)

PASSO 20 Assembling the NTC thermistor



- On the **extruder motor side**, insert the NTC thermistor into the hole in the heatsink.
- Fissalo con la vite M3x4T. Avvitala fino in fondo. **Stringi delicatamente, ma con decisione**, usando due dita e il lato corto della chiave Torx T6. L'applicazione di una forza maggiore potrebbe causare danni permanenti alla filettatura.

PASSO 21 Mounting the Nextruder: parts preparation



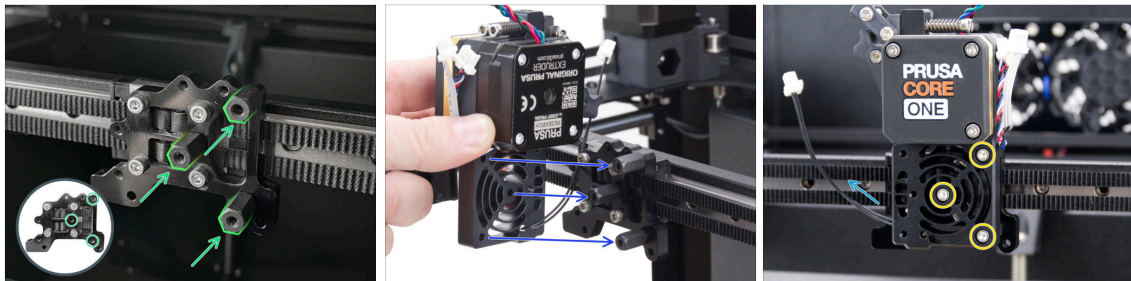
- For the following steps, please prepare:
- Distanziatore Nextruder (3x) si trova nella confezione Electronics & Fasteners
- Vite M3x10 (3x)
- Cardboard box (1x) used as temporary heatbed protection
- Hint: You can use any cardboard box from the kit package.

PASSO 22 Proteggere il piano riscaldato



- Place an empty cardboard box on the heatbed, ensuring it covers as much of the surface as possible.
- i** Questo proteggerà il piano riscaldato da eventuali cadute di pezzi.

PASSO 23 Montare il Nextruder



- Screw three Nextruder spacers to the Nextruder holder. Tighten the spacers firmly.
- Posiziona il gruppo Nextruder sui distanziatori.
- 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.

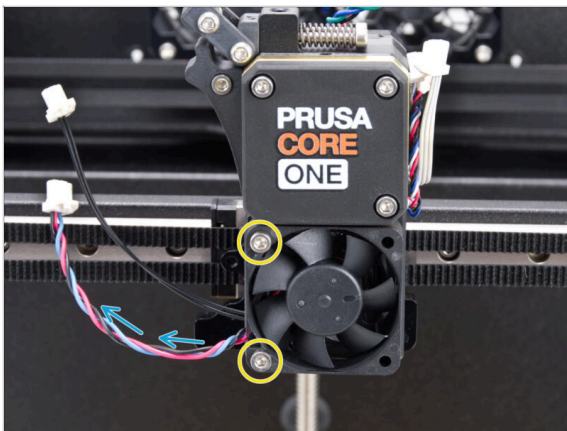
PASSO 24 Ventola Hotend: preparazione dei componenti



For the following steps, please prepare:

- Ventola dell'Hotend (1x) *si trova nella confezione Electronics*
- Hotend-cable-clip (1x) *found in the Printed parts package*
- Vite M3x4rT (2x)
- Vite M3x18 (2x)

PASSO 25 Installare la ventola dell'Hotend

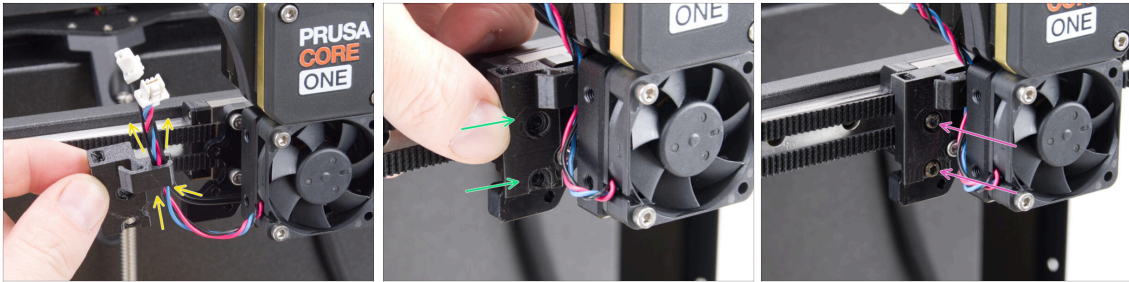


- Attach the hotend fan onto the heatsink with two M3x18 screws on the left side. **Tighten the screw gently, but firmly, otherwise the plastic housing may crack.**

⚠ C'è un adesivo sulla ventola dell'hotend, l'adesivo deve trovarsi sul lato posteriore della ventola, non visibile.

- The cable must be pointing towards the lower-left corner.

PASSO 26 Guidare i cavi della ventola dell'Hotend



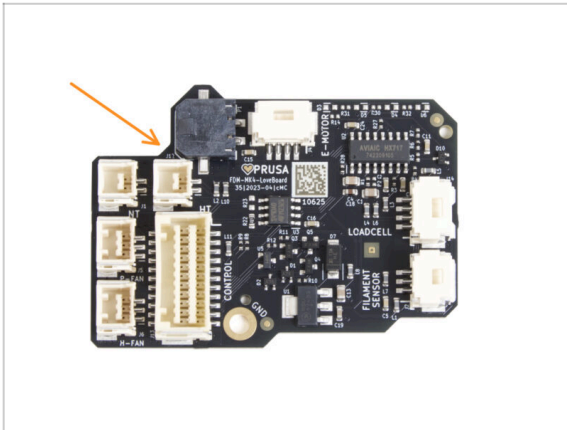
- ✦ Take the Hotend-cable-clip in the same position as shown and guide the **heatsink fan cable** together with the **NTC thermistor cable** through the right cable hook.
- ✦ Attacca la clip del cavo Hotend al supporto Nextruder.
- ✦ Secure it using two M3x4rT screws.

PASSO 27 LoveBoard: parts preparation I.



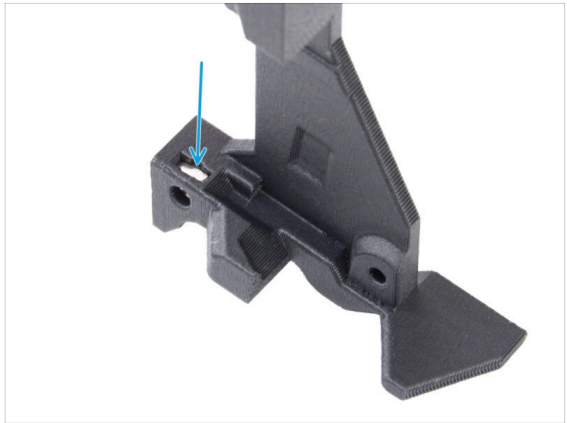
- ✦ **For the following steps, please prepare:**
- ✦ Printhead-cover (1x) *si trova nella confezione Printed parts*
- ✦ Loveboard-mount (1x) *found in the Printed parts package*
- ✦ Main cable (1x) *found in the Electronics & Fasteners package*
- ⓘ Note: Cable color may vary depending on the batch. This does not affect the procedure.
- ✦ Vite M3x10 (4x)
- ✦ Vite M3x8rt (1x)
- ✦ Dado M3nS (5x)
- ⓘ The list continues in the next step...

PASSO 28 LoveBoard: parts preparation II.



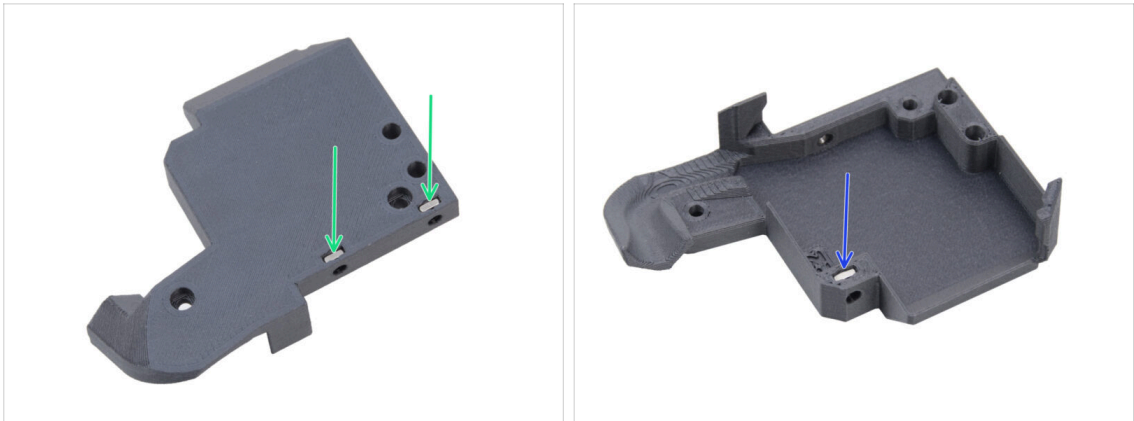
- For the following steps, please prepare:
- LoveBoard (1x) si trova nella confezione Electronics

PASSO 29 Assemblare il supporto Loveboard



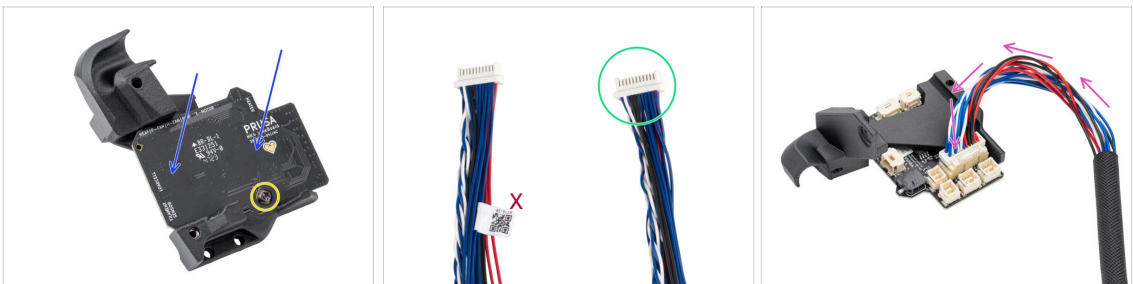
- Locate the U-shaped cable channel on the Loveboard-mount and insert an M3nS nut into the nearby hole.
- Usa la Chiave a brugola da 2.5mm per spingere il dado fino in fondo.
- On the opposite side of the part, insert an M3nS nut and push it into place.

PASSO 30 Montaggio della copertura Printhead-cover



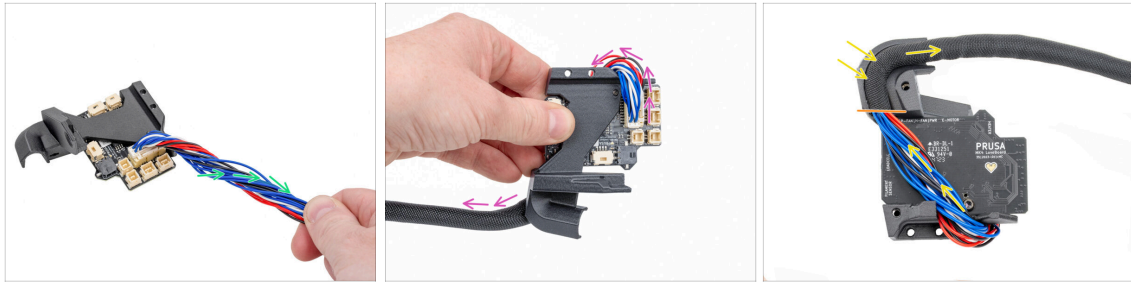
- From the back of the printhead-cover, insert two M3nS nuts into the part.
- Dall'altro lato della copertura printhead-cover, inserisci un dado M3nS nella parte.

PASSO 31 Assemblare la LoveBoard



- Place the LoveBoard to the Loveboard-mount. Note the correct orientation - the connectors must be facing downwards.
- Allinea i fori con entrambe le parti e fissa la scheda con la vite M3x8rT. **Non stringerla troppo** per non danneggiare il pezzo.
- 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.

PASSO 32 Guidare il cavo principale



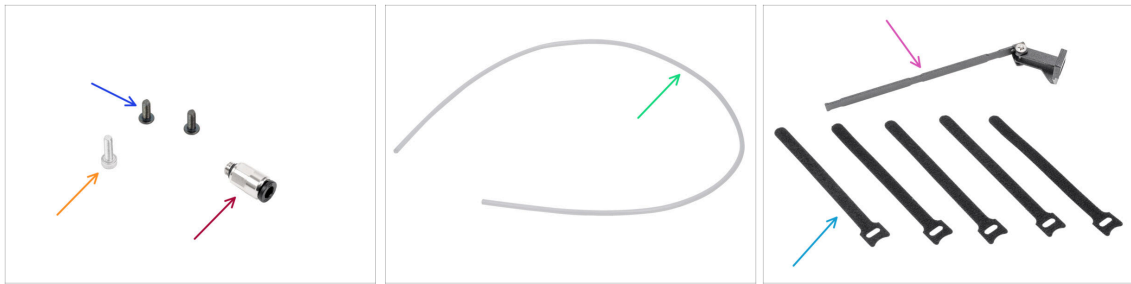
- ✦ Twist the main cable half a turn.
- ✦ Piega il cavo principale sopra la LoveBoard verso il lato opposto.
- ⬛ Turn the LoveBoard assembly upside down.
- ✦ Guide the main cable over the LoveBoard through the cable channel in the Loveboard-mount.
- ✦ The end of the textile sleeve must align with the edge of the plastic part.

PASSO 33 Coprire la LoveBoard



- ✦ Insert two M3x10 screws into the Loveboard-holder.
 - ⚠ **Assicurati di inserire le viti dal lato corretto. Usa il logo LoveBoard sulla scheda come riferimento.**
- ✦ Cover the LoveBoard with the Printhead-cover.
 - ⚠ **Avoid pinching any wires in the main cable.**
- ✦ Fix both parts together using two M3x10 screws.
- ✦ Check that there is no large gap or pinched textile sleeve between the parts.

PASSO 34 Swingarm: parts preparation I.



● For the following steps, please prepare:

- Viti M3x8rT (2x)
- Vite M3x10 (1x)
- Fitting M5-4 (1x) *found in the Electronics & Fasteners package*
- PTFE tube 710 x 4 x 2.5 (1x) *found in the CoreXY parts + Hinges set package*
- Swingarm assembly (1x) *found in the Metal parts 3/3 package*
- Cable tie (5x) *found in the Electronics & Fasteners package*
- ① Packed in a stack and must be separated.
- ① The list continues in the next step...

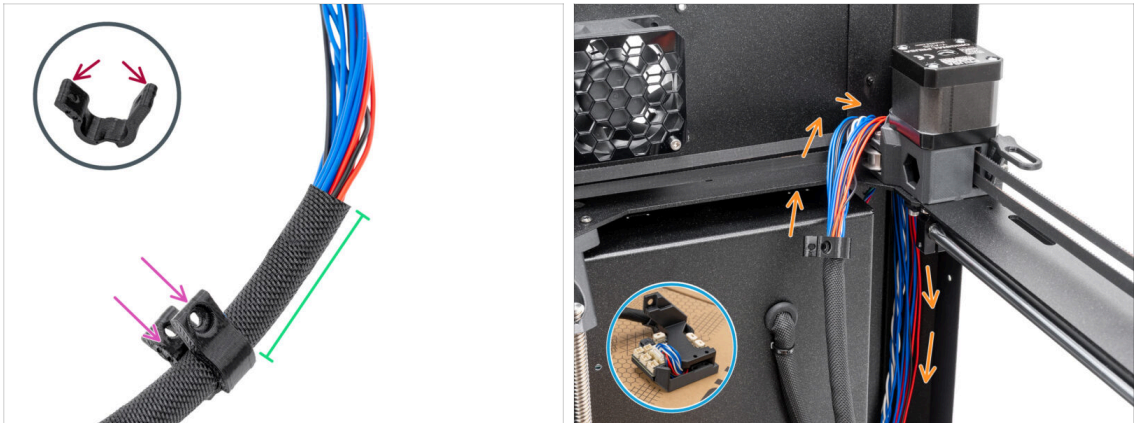
PASSO 35 Swingarm: parts preparation II.



● For the following steps, please prepare:

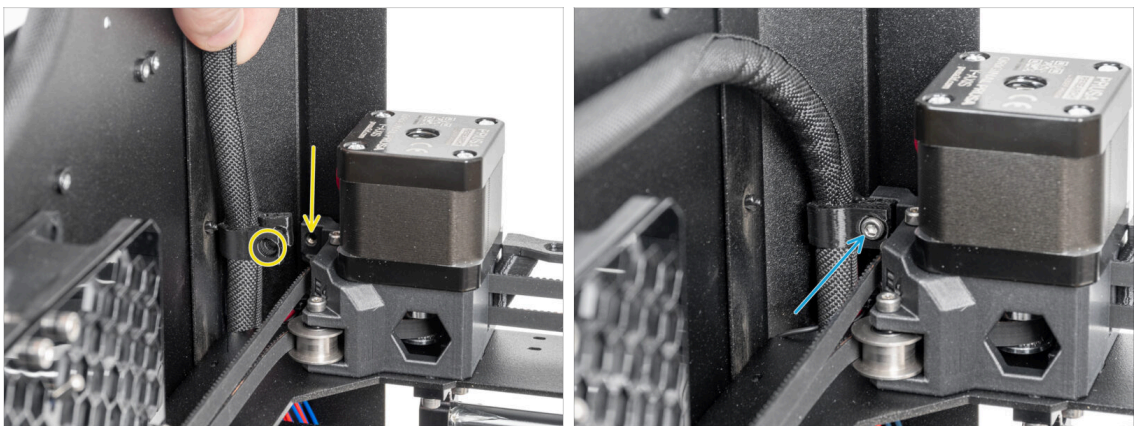
- Raccordo Bowden-bend (1x) *si trova nella confezione Printed parts*
- Main-cable-clip (1x) *found in the Printed parts package*

PASSO 36 Guidare il cavo principale



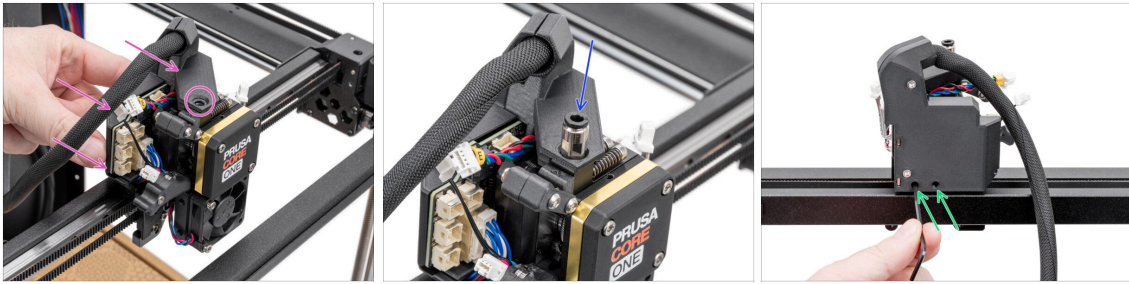
- Carefully open the Main-cable-clip. Be careful not to crack the part.
- Inserisci il cavo principale nella clip principale (Main-cable-clip).
- Posiziona la clip del cavo principale a circa 5 - 15 cm dall'estremità della guaina in tessuto e chiudi la clip.
- Place the LoveBoard assembly on the cardboard box on the heatbed.
- Push the main cable behind the CoreXY assembly in the right rear corner.

PASSO 37 Mounting the main cable



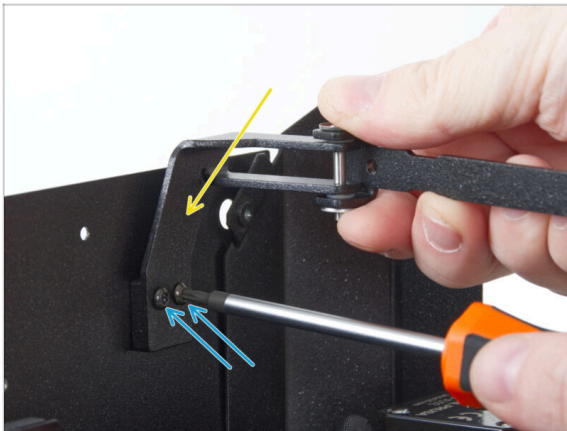
- In the right corner of the printer on the Y motor assembly, locate the hole in the plastic part and align it with the main-cable-clip.
- Fissa il cavo e la clip main-cable-clip sul foro utilizzando la vite M3x10.

PASSO 38 Attaching the LoveBoard assembly



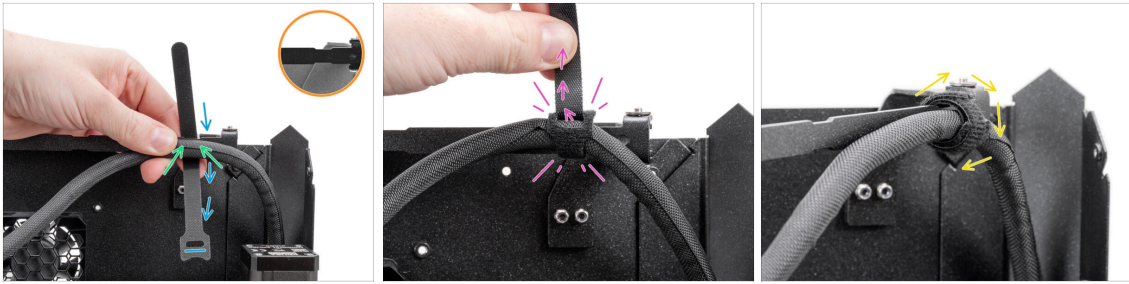
- ◆ From the back of the Nextruder, attach the LoveBoard assembly to the Nextruder.
- ◆ Allinea il foro del supporto Loveboard con il foro filettato nella parte superiore del dissipatore (Nextruder).
- ◆ Insert and tighten the fitting M5-4 to the heatsink. Use the universal wrench.
- ◆ From the back of the Nextruder, tighten the two M3x10 screws to secure the LoveBoard assembly.

PASSO 39 Montaggio del braccio oscillante



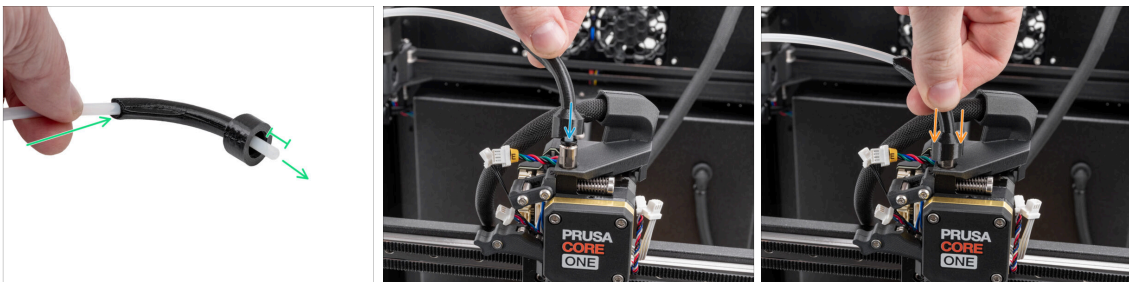
- ◆ Attach the swingarm assembly to the pair of threaded holes on the back panel near the top right corner.
- ◆ Fissalo con due viti M3x8rT.
- ⚠ Do not overtighten the screws, as this may strip the threads.

PASSO 40 Attaching the main cable



- Notice the cutouts on the swingarm.
- Posiziona il cavo principale sul primo intaglio del braccio oscillante.
- Place one cable tie behind the first cutout on the swingarm, ensuring the correct orientation of the zip strip.
- Thread the cable tie through its eyelet, wrapping it around the swingarm and main cable.
- Tighten the cable tie as much as possible.
- Wrap the cable tie around.

PASSO 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.
- Inserisci il tubo in PTFE nel raccordo M5-4 sul Nextruder. Spingilo fino in fondo.
- Slide bowden-bend down to cover the fitting M5-4.

PASSO 42 Securing the PTFE tube



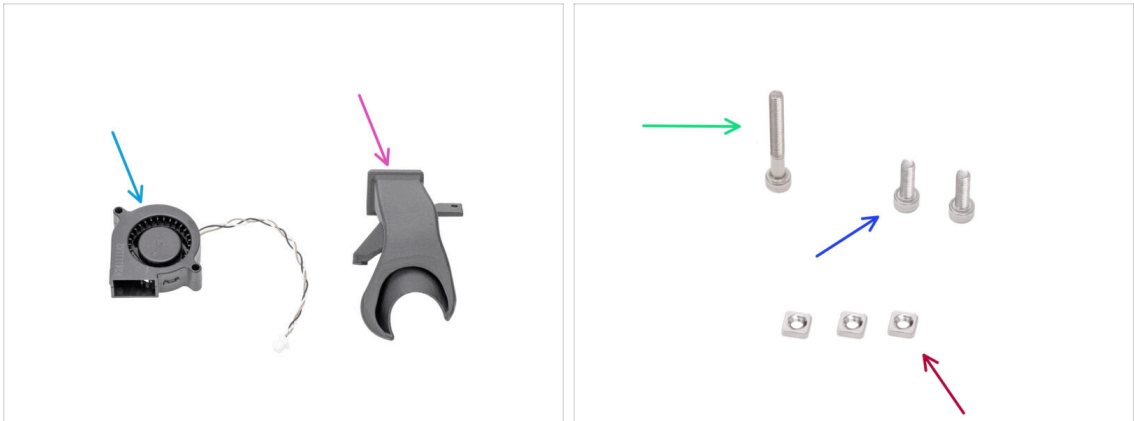
- ◆ Route the PTFE tube in parallel with the main cable, ensuring the PTFE tube stays above the main cable.
- ◆ Fissa il tubo in PTFE e il cavo principale al braccio oscillante utilizzando due fermacavi nei restanti fori.
- ⚠ **Do not pass the PTFE tube through the first cable tie on the swingarm.**
- ◆ Push the free end of the PTFE tube through the Bowden guide and CoreXY plate downward. Leave the end hanging freely.
- ◆ Merge the PTFE tube and main-cable with the remaining two cable ties, leaving a 10 cm (3.94 in) distance between them.

PASSO 43 Controllo del movimento



- ◆ Manually move the XY axes to their end positions several times and ensure that:
 - ◆ Il cavo principale non sia troppo teso e che non tiri indietro il Nextruder.
 - ◆ Il cavo principale non forma un arco eccessivamente ampio.
 - ◆ Se il cavo è troppo teso o forma un arco troppo ampio, allentare leggermente la vite sul fermacavo principale e tirare il cavo verso l'alto o verso il basso di alcuni millimetri. Quindi, serrare la vite e riprovare.

PASSO 44 Print fan: parts preparation



● For the following steps, please prepare:

- Ventola di stampa (1x) si trova nella confezione Electronics
- Fan-shroud (1x) found in the Printed parts package
- Vite M3x25 (1x)
- Vite M3x10 (2x)
- Dado M3nS (3x)

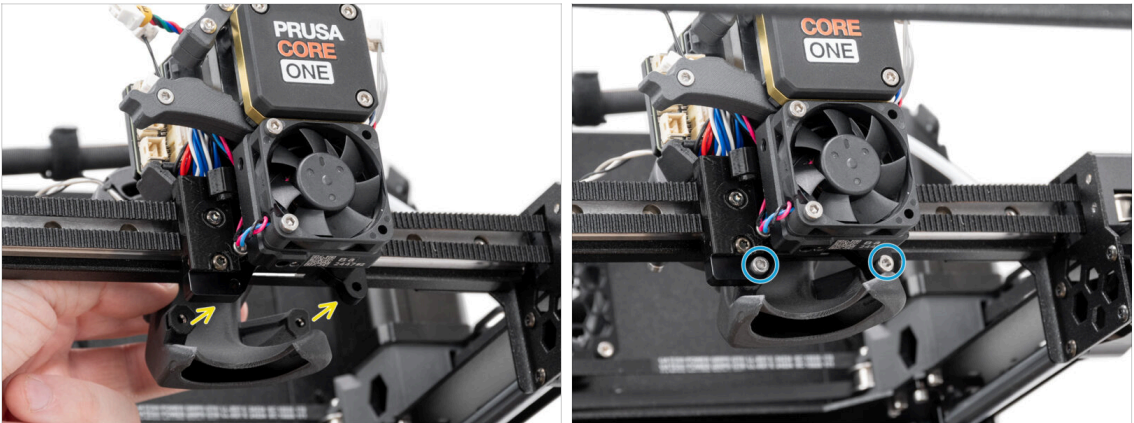
PASSO 45 Montaggio del coprimentello



- Insert two M3nS nuts from one side into the fan-shroud.
- Dall'altro lato, inserisci un dado M3nS nel coprimentello.
- Insert the print fan into the fan-shroud as shown. See the correct orientation of the parts.
- Secure both parts together with one M3x25 screw.

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

PASSO 46 Installing the print fan assembly



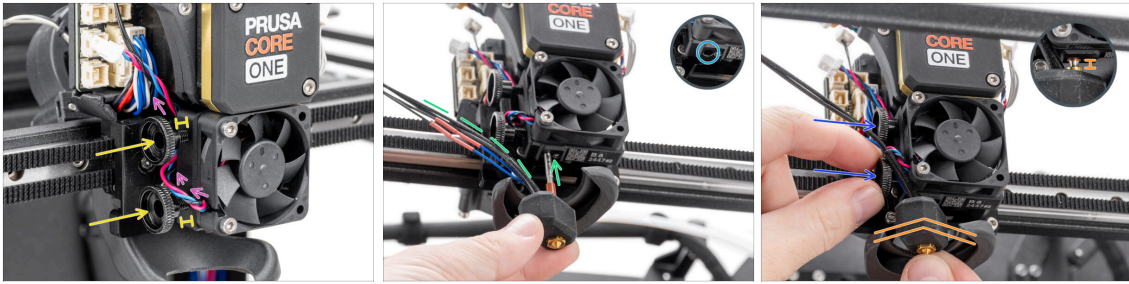
- Attach the print fan assembly to the back of the Nextruder.
- Allinea i fori della staffa Nextruder con i fori del copriventola.
- Secure the fan-shroud to the Nextruder holder using two M3x10 screws.

PASSO 47 Hotend: preparazione dei componenti



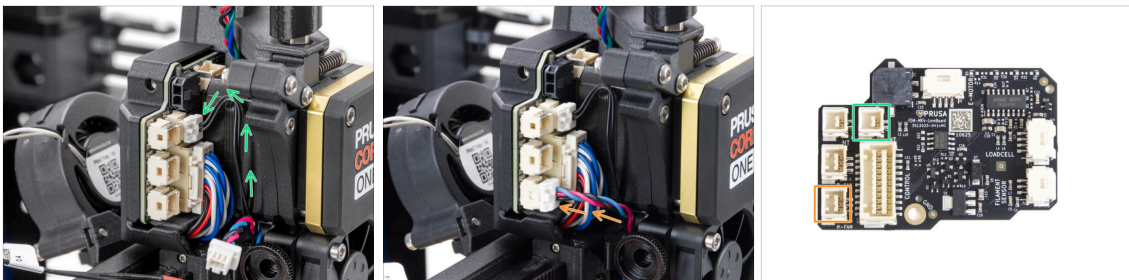
- **For the following steps, please prepare:**
- Vite a testa zigrinata (2x) *nella confezione Electronics*
- Prusa Hotend assembly (1x) *found in the Electronics package*

PASSO 48 Installare l'hotend



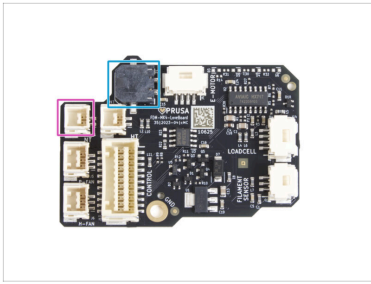
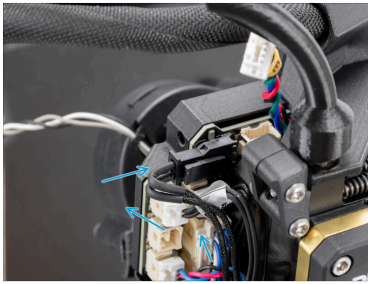
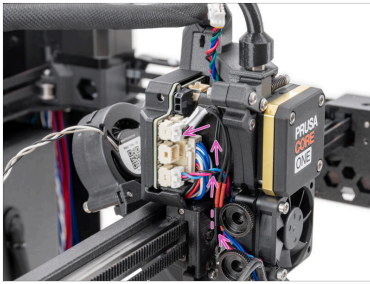
- ✿ Route the heatsink fan cable above the first threaded hole in the heatsink.
- ✿ Inserisci due viti a testa zigrinata nel dissipatore. **Non stringerle a fondo.** Due giri sono sufficienti per ora.
- ✿ Look closely at the underside of the heatsink and find the hole for the hotend assembly.
- ✿ Insert the hotend assembly tube in the hole and slide the whole thing into the heatsink.
- ✿ Point the cables to the left according to the photo.
- ✿ Push the hotend assembly all the way into the heatsink. There should be approximately a 2 mm (0.08 in) gap between the heatsink and the brass part of the nozzle.
- ✿ While pushing the hotend assembly in, **firmly tighten both thumb screws.**
- ⚠ **Avoid pinching any cable between the screws and the heatsink!**

PASSO 49 Connecting the heatsink cables



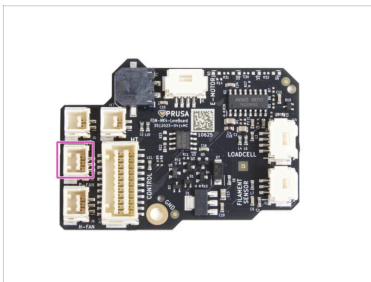
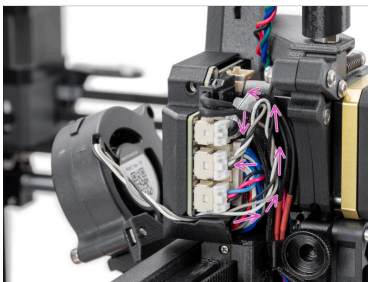
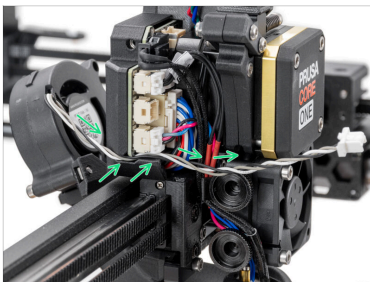
- ✿ Plug the NTC thermistor cable into the connector above the main cable on the LoveBoard.
- ✿ Inserisci il cavo della ventola dell'Hotend nel connettore inferiore della fila sinistra della LoveBoard.

PASSO 50 Connecting the hotend cables



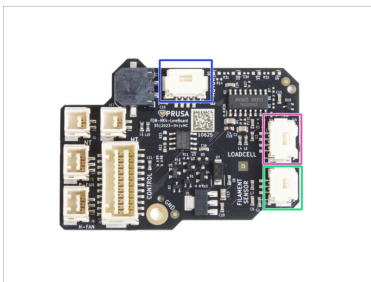
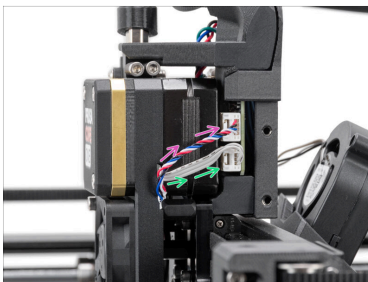
- ◆ Guide the hotend thermistor through the cable-clip on the Nextruder and connect it to the LoveBoard.
- ◆ Fai passare il riscaldatore dell'hotend attraverso la clip del Nextruder e collegalo alla LoveBoard.

PASSO 51 Connecting the print fan cable



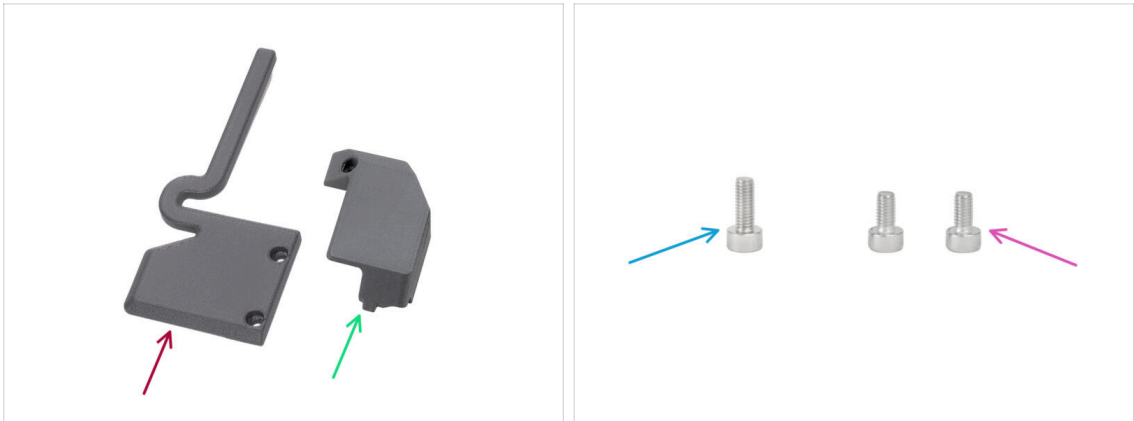
- ◆ Guide the print fan cable through the channel in the plastic cover.
- ◆ Crea un anello con il cavo della ventola di stampa nella zona dei cavi e collegalo al connettore centrale della LoveBoard.

PASSO 52 Collega il cavo del motore E



- ◆ Plug the Nextruder motor (labeled E) to the top-facing connector.
- ◆ Collega il cavo della cella di carico (cavo inferiore) al connettore superiore sul lato destro di Nextruder.
- ◆ Plug the filament sensor (upper cable) to the lower connector.

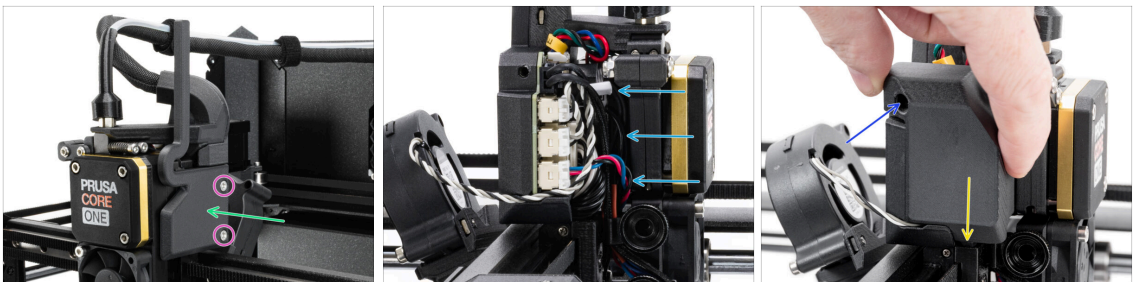
PASSO 53 LoveBoard covers: parts preparation



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

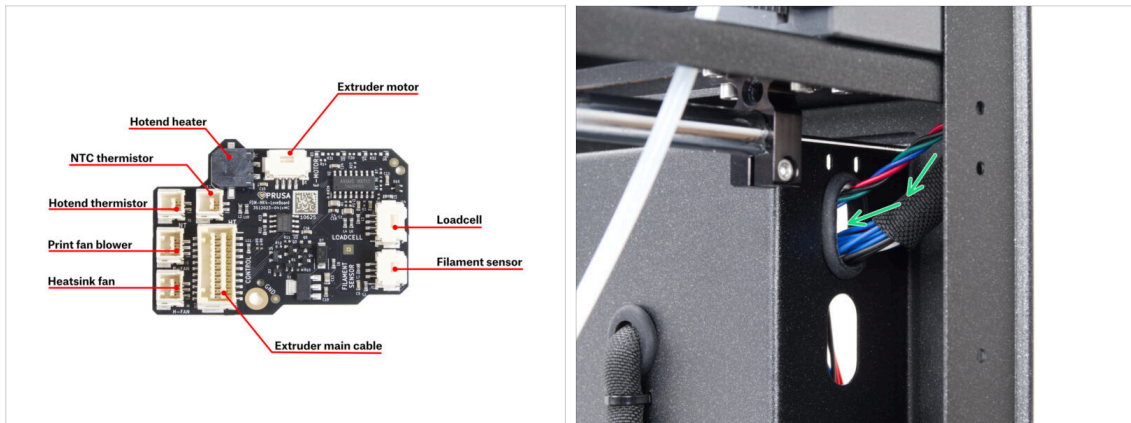
- Printhead-cover-right-lever(1x)
- Print-head-cover-right (1x) *found in the Printed parts package*
- Vite M3x10 (1x)
- Vite M3x6 (2x)

PASSO 54 Coprire la LoveBoard



- Posiziona la copertura con leva Printhead-cover-right-lever sul lato destro del Nextruder.
- ⚠ **Attento a non schiacciare i cavi!**
- Secure the cover with two M3x6 screws.
- Squeeze the wiring harness as far inward to the LoveBoard as possible so that it does not protrude out and interfere with the fitting of the cover.
- Attach the Print-head-cover-left on the left side of the Nextruder.
- **Note the protrusion on the underside of the cover - the protrusion must fit into the counterpart on the Nextruder.**
- Secure the cover with one M3x10 screw.

PASSO 55 LoveBoard: Controllo del cablaggio



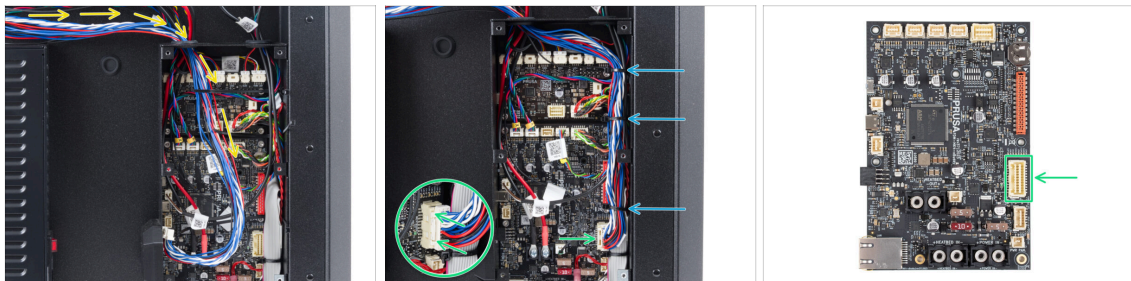
⚠ Before covering the electronics, check the connection of all cables.

i Clicca sull'immagine per aprirla nell'anteprima ad alta risoluzione.

➤ 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.

PASSO 56 Guiding the main cable



⬛ Rotate the printer so that the backside faces you.

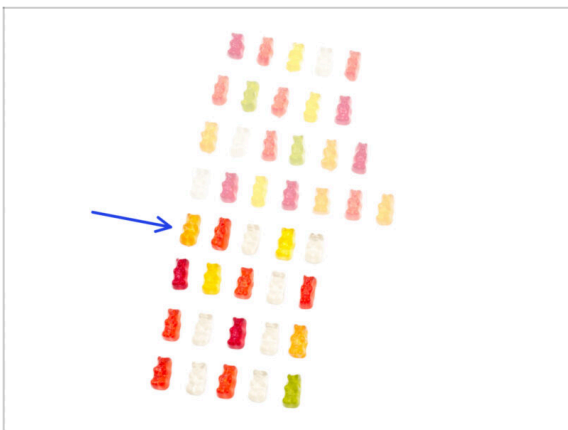
➤ Fai passare il cavo principale attraverso il foro sinistro nella scatola xBuddy.

➤ 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.

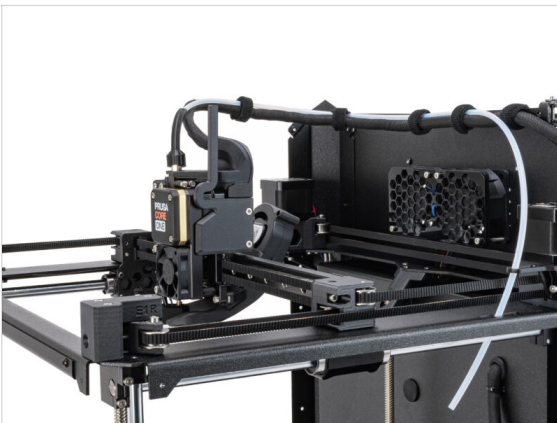
➤ Secure the cables with the pre-threaded zip ties in the xBuddy box. Carefully cut the excess, **avoiding cutting the cables**.

PASSO 57 È l'ora delle Haribo!



- Power up and push forward!
- Mangia la quinta fila.
- Non sei ancora sazio?

PASSO 58 Fatto

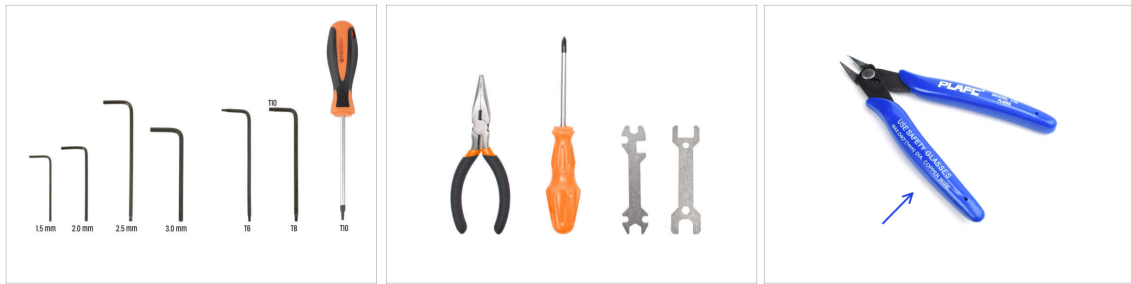


- Congratulations! You just successfully assembled the Nextruder.
- Passiamo al prossimo capitolo.

7. Bodywork & Electronics



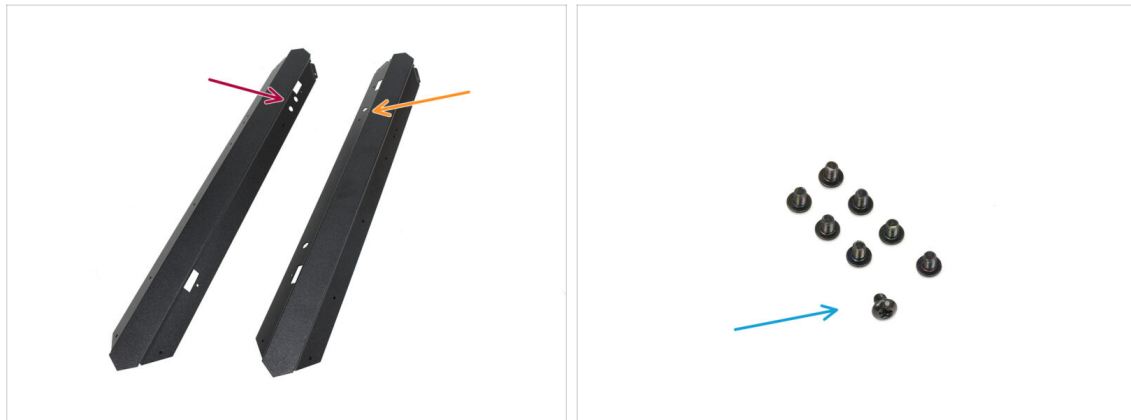
PASSO 1 Tools necessary for this chapter



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

- Chiave a brugola da 2.5mm
- Chiave a brugola da 1.5mm
- Chiave Torx T10
- Pinza a becchi lunghi
- Tronchesi (opzionale)

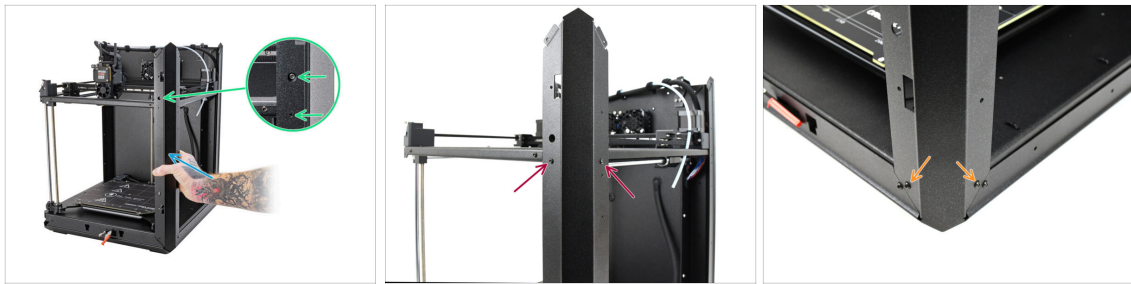
PASSO 2 Front profiles: parts preparation



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

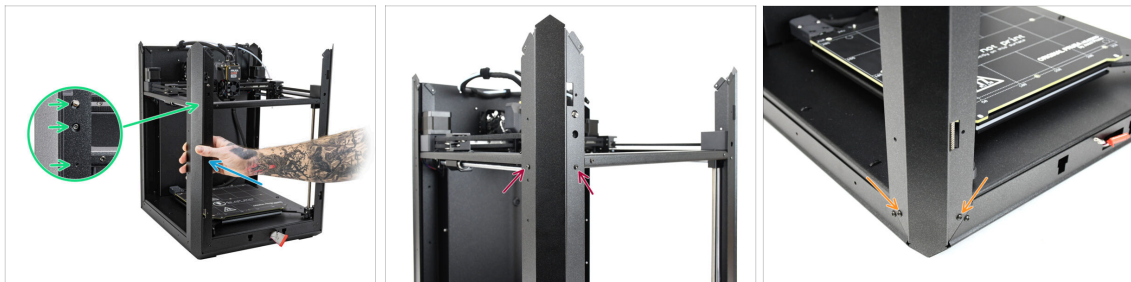
- Front Left Profile (1x) *found in the Metal parts 1/3 package*
 - ① The one with the two circular openings on top.
- Profilo anteriore destro (1x) *si trova nella confezione Metal parts 1/3*
 - ① The one with one circular opening on top.
- Vite M3x4rT (8x)

PASSO 3 Installing the front right profile



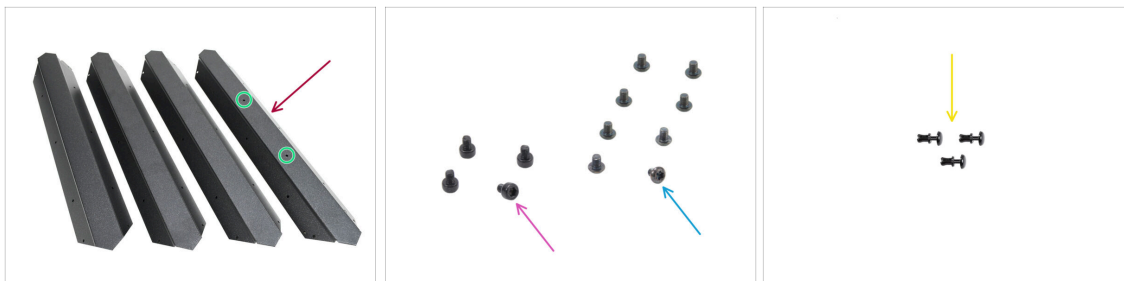
- Attach the Front Right Profile to the printer.
 - ❗ Ensure you are using the correct profile—it should have **one large round opening** for the belt tensioning screw.
- Align the profile so that the calibration screw opening and the smaller bolt opening line up with the thread.
- Fissa il profilo al gruppo CoreXY con due viti M3x4rT.
- Fix the profile at the bottom using the two M3x4rT screws.

PASSO 4 Installazione del profilo anteriore sinistro



- Attach the Front Left Profile to the printer.
 - ❗ 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!**
- Fissa il profilo al gruppo CoreXY con due viti M3x4rT.
- Fix the profile at the bottom using the two M3x4rT screws.

PASSO 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.
- Vite M3x4rT (8x)
- Vite M3x4 (4x) *con il diverso tipo di testa*
- Rivetto in nylon (3x)

PASSO 6 Assembling the top profiles I.



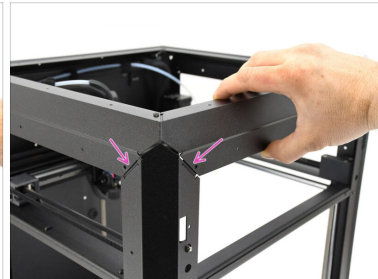
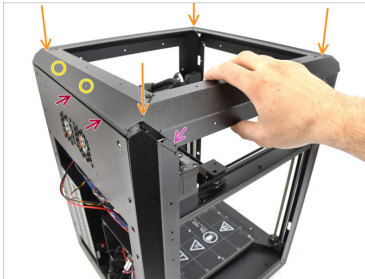
- ⚠ Be very careful when handling sharp sheet metal parts to avoid injury or damage.
- According to the picture, place the top profile with two holes on the flat side.
- Orient the part according to the picture. **Use the flange as a guide.**
- Posiziona un altro dei profili superiori sul lato sinistro. Orienta il pezzo come indicato nell'immagine. **Usa la flangia come riferimento.**
- 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.

PASSO 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.

PASSO 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.
- Sui lati e sulla parte anteriore, i profili devono poggiare sulle linguette con aperture filettate.

PASSO 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.

PASSO 10 CoreXY fixing screws: parts preparation



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

PASSO 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.

PASSO 12 Side sensor base: parts preparation



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

PASSO 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 La parte con il magnete deve essere posizionata accanto alla pallina.

Nota che la pallina sarà attratta dal magnete - assicurati che rimanga saldamente al suo posto.

- Fissa la leva con la rondella M3w e la vite M3x10. Per ora avvitala solo un po', quanto basta per tenerla in posizione.

⚠ Non stringere completamente la vite. In caso contrario, la leva non si muoverà e il sensore non funzionerà!

PASSO 14 Testare la leva



- Verify the lever is able to move freely.
- Se la leva non si muove bene o non si muove per niente, allenta la vite di un quarto di giro e prova di nuovo a muoverla.

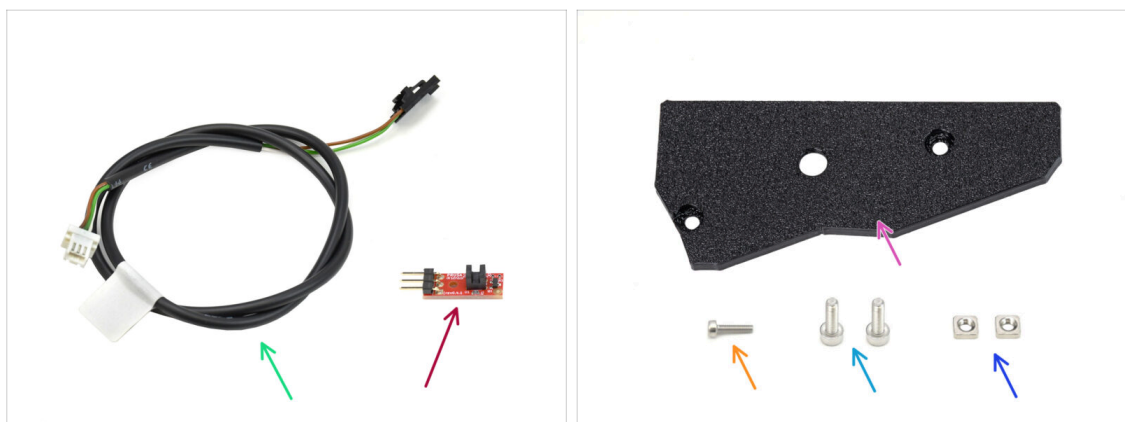
⚠ La vite non deve essere avvitata fino in fondo, altrimenti la leva non si muoverà liberamente.

PASSO 15 Assemblare l'interruttore



- Inserisci il secondo magnete 10x6x2 nel filament-sensor-switch.
- Installa l'interruttore filament-sensor-switch nel corpo filament-sensor-body.
- Sposta l'interruttore filament-sensor-switch alla posizione finale sinistra in modo che i magneti siano uno di fronte all'altro.
- Make sure **the magnets repel** - they should push away from one another.
- **Se si attraggono**, cioè si avvicinano: toglie il magnete dall'interruttore del sensore del filamento e cambia la sua polarità. Poi controlla di nuovo.
- ❗ *Pro tip: usa una delle chiavi esagonali sottili o delle chiavi Torx per togliere il magnete dall'interruttore del sensore del filamento.*

PASSO 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*
- Copertura del sensore laterale del filamento (1x) *si trova nella confezione Printed parts*
- Vite M2x8 (1x)
- Vite M3x10 (2x)
- Dado M3nS (2x)

PASSO 17 Connecting the IR sensor



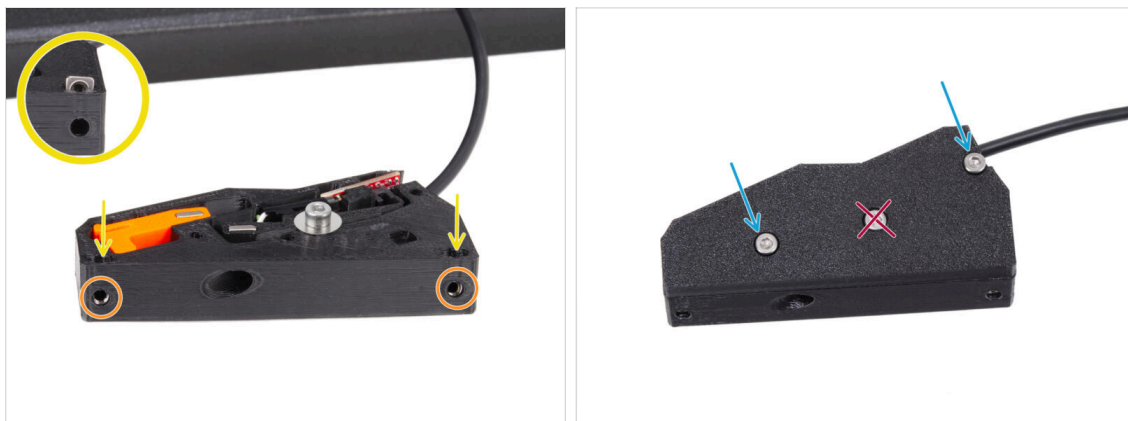
- 🟢 Plug the cable into the IR filament sensor.
- ⚠️ Ensure the connector is oriented correctly before plugging it in!
- 🟠 On CORE One, the brown cable must connect to the +5V pin.
- 🟡 Il cavo bianco si collega al pin GND.

PASSO 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.
- 🟠 Assicurati che né il connettore né i cavi tocchino la leva, perché questo potrebbe impedire il corretto funzionamento del sensore.
- 🟡 Using the 1.5mm Allen key, fix the sensor in place with the M2x8 screw.

PASSO 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.
- ✚ Fissa la copertura in posizione utilizzando due viti M3x8 sui lati.

⚠ **Non stringere la vite al centro! In caso contrario, il sensore smetterebbe di funzionare.**

PASSO 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*
- ✚ Fascetta (3x)

PASSO 21 Installing the side filament sensor



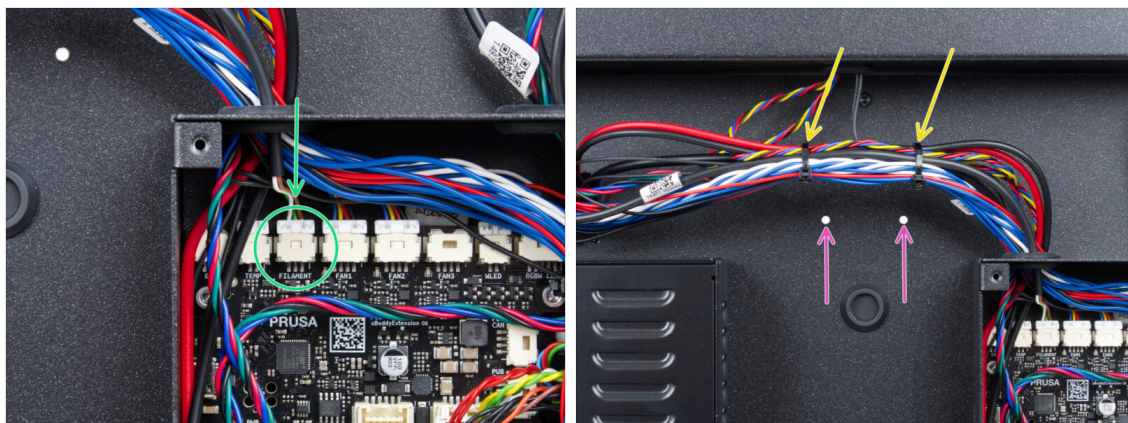
- 🟠 Install one zip-tie into the marked openings. We will use it to attach a cable underneath the metal profile.
 - 🟡 Insert the collet into the marked opening on the sensor assembly.
 - 🟢 Attach the sensor assembly onto the PTFE tube in the printer.
- ⚠️ **Assicurati di spingere il tubo fino in fondo!**

PASSO 22 Guide the filament sensor cable



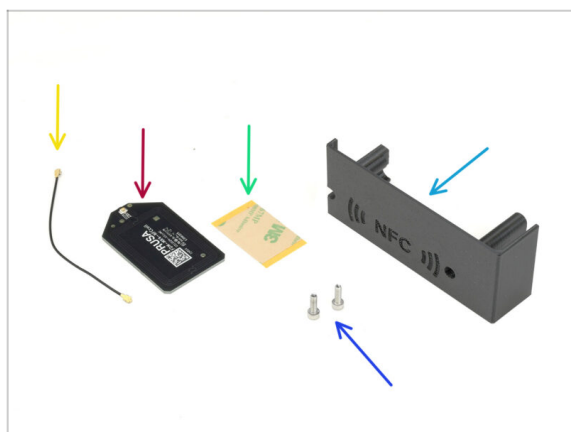
- 🟠 Move the sensor assembly up, roughly to the middle of the printer's frame, to align the cable properly.
- 🟢 Once in position, secure the cable underneath the metal profile using a zip-tie. Tighten the zip-tie lightly, allowing for cable adjustments if needed later. Cut off the excess zip-tie.
- 🟡 Guide the sensor cable through the dedicated opening to the back of the printer.
- 🟠 Sul retro della stampante, guida il cavo nella scatola di xBuddy. Per il momento lasciala appesa in modo lasco.

PASSO 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.
 - Fissa i cavi nella **posizione più alta possibile** per assicurarti che lascino libere le due aperture sulla piastra sottostante.
- ⚠ Do not over-tighten the zip ties or strain the cables too much!

PASSO 24 NFC Antenna: parts preparation



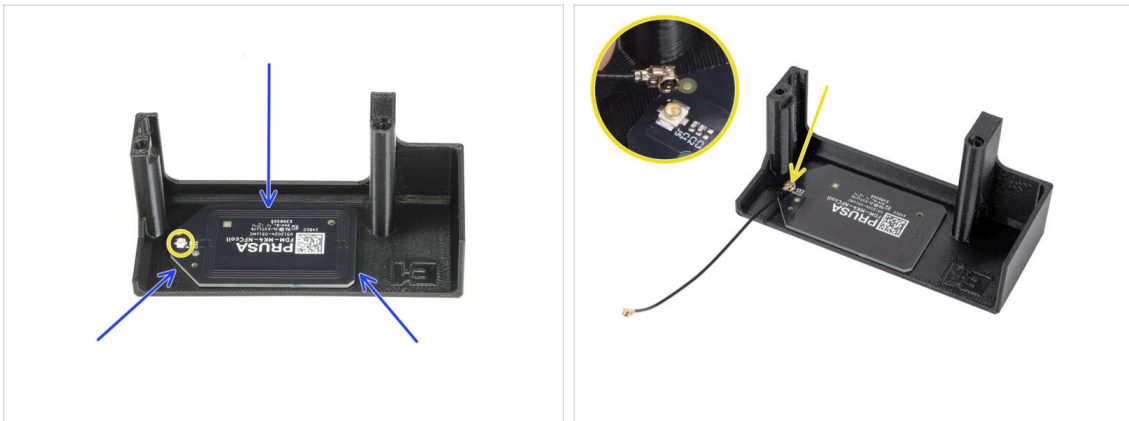
- For the following steps, please prepare:
 - El-box-cover (1x) found in the Printed parts package
 - Vite M3x10 (2x)
 - NFCcoil (1x) found in the Electronics & Chamber parts package
 - Adhesive film 32 x 25 mm (1x) found in the Electronics & Chamber parts package
 - NFC coil cable (1x) found in the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

PASSO 25 Applying the adhesive film



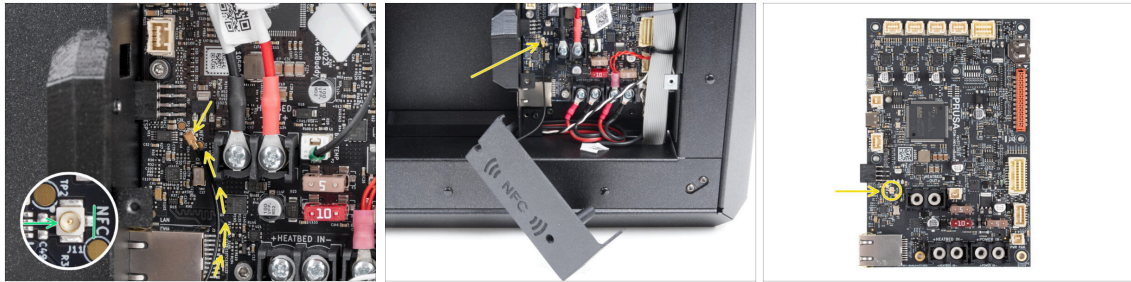
- Peel off the yellow protective film from the adhesive tape.
- Apply the film to the flat side of the NFC coil, ensuring it adheres properly.
- Stacca lo strato protettivo rimanente dalla bobina NFC.

PASSO 26 Installing the NFC Coil



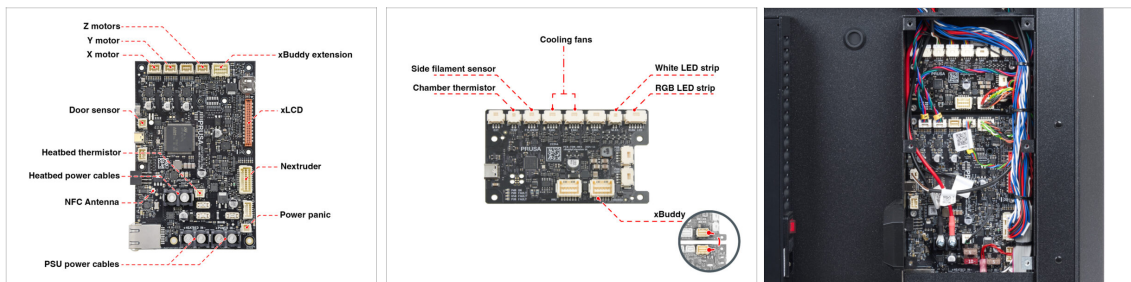
- Stick the NFC coil onto the inner side of the EI-box cover, approximately as shown in the picture.
- ⓘ The small round connector should be positioned closer to the edge of the cover.
- Collega il cavo alla scheda allineando i connettori e premendo leggermente fino ad avvertire un clic, in modo da garantire una connessione sicura.
- ⚠ Be careful when connecting the NFC coil cable. Misalignment or excessive pressure can cause irreversible damage.

PASSO 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.

PASSO 28 Controllo del cablaggio



- 🟡 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!**

PASSO 29 Preparing the electronics cover



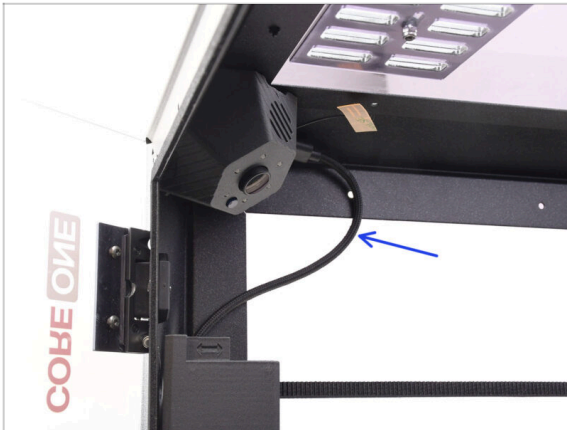
- Push two M3x10 screws through the EI-box-cover.

PASSO 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.
- Allinea la copertura con l'apertura della scatola xBuddy e fissala in posizione stringendo le viti.
- 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.**

PASSO 31 Note sulla Fotocamera Buddy3D



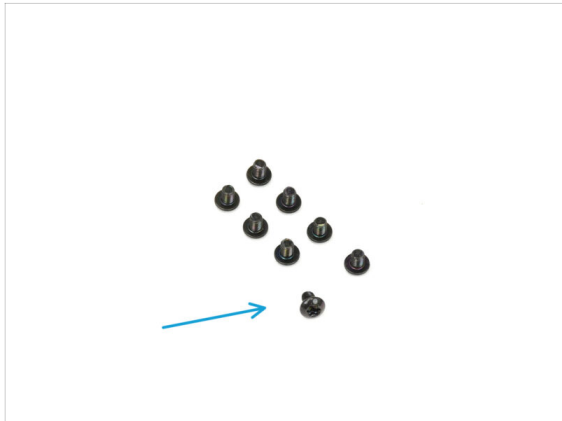
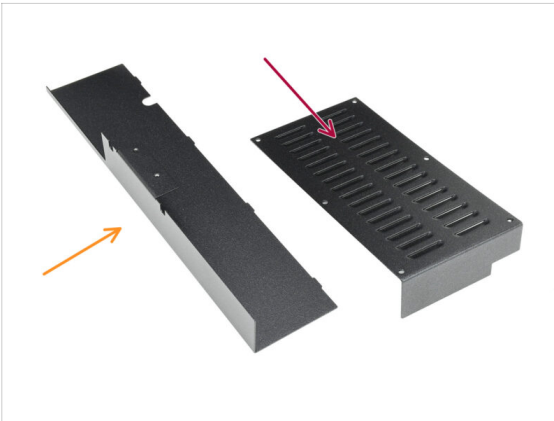
i For future Buddy3D Camera users:

Se prevedi di utilizzare la fotocamera Buddy3D, il cavo USB è già installato.



Per sapere come montare e collegare la fotocamera Buddy3D, dai un'occhiata a questa guida: **Installazione fotocamera Buddy3D per CORE One**

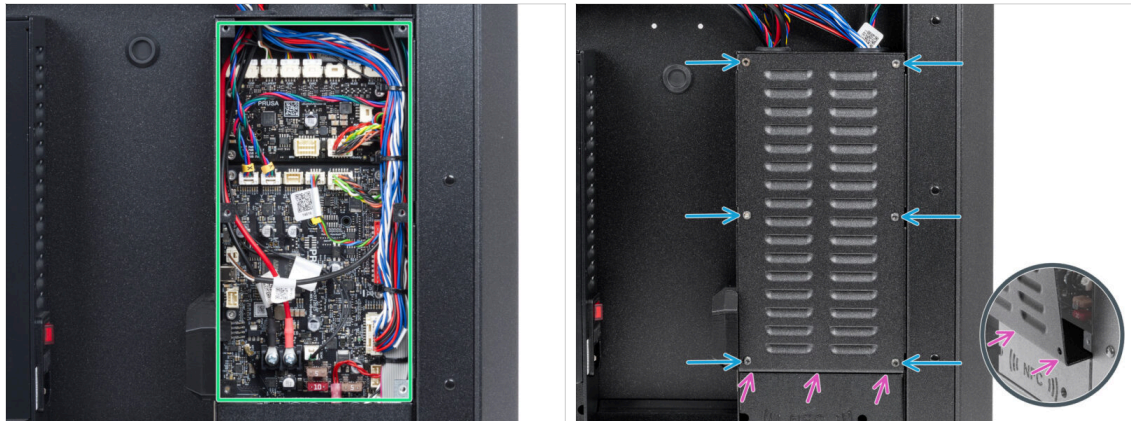
PASSO 32 xBuddy cover: parts preparation



For the following steps, please prepare:

- Sheet metal back cover (1x) *found in the Metal parts 2/3 package*
- Copertura xBuddy (1x) *si trova nella confezione Metal parts 3/3*
- Vite M3x4rT (8x)

PASSO 33 Installing the xBuddy cover



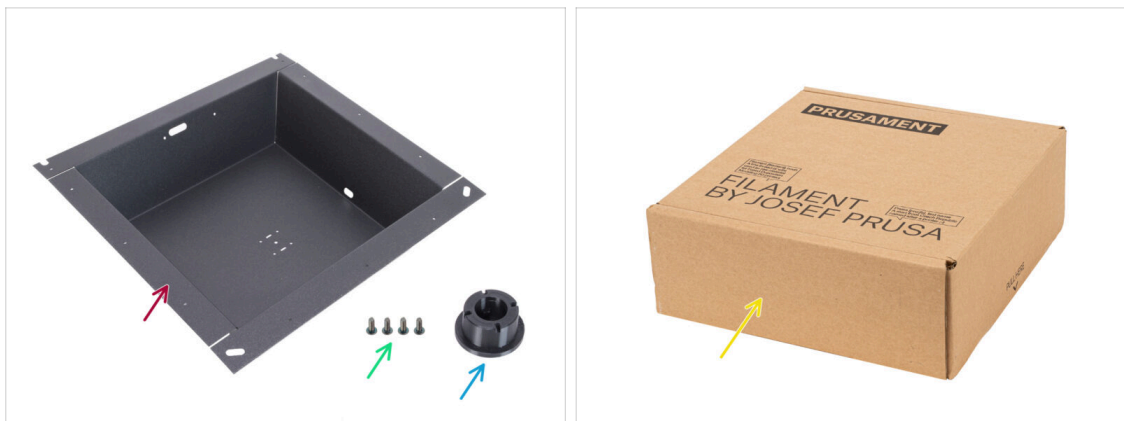
- Arrange the cables inside the xBuddy box as shown in the picture.
- Carefully cover the xBuddy box by first sliding the bent part of the cover into the box.
- ⚠ **Evita di schiacciare i cavi. Controlla due volte la posizione del cavo della bobina NFC.**
- Secure the xBuddy box cover using the six M3x4rT screws.

PASSO 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.
- Ci sono quattro linguette che dovrebbero agganciarsi al telaio della stampante.
- Secure the rear cover in place using two M3x4rT screws from inside the printer.

PASSO 35 Right side: parts preparation



● For the following steps, please prepare:

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

⚠ Il pezzo corretto del **lato destro** può essere facilmente identificato grazie alle aperture per le viti al centro.

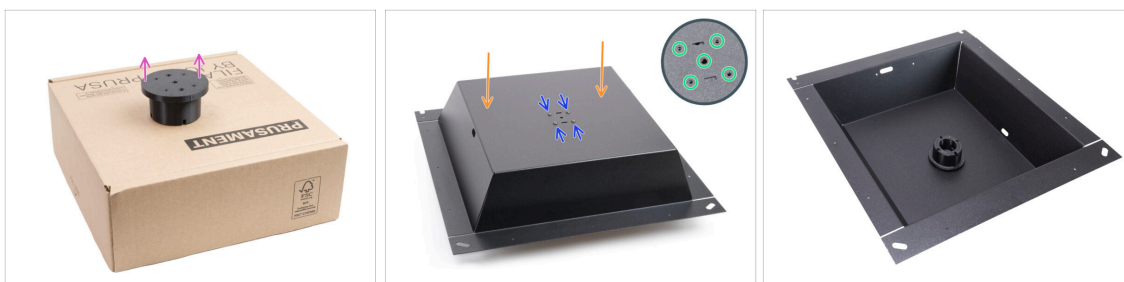
● Vite M3x8rT (4x) si trovano nella confezione Electronics & Fasteners.

● Puck-universal (1x)

● Una scatola di cartone (1x)

📌 Sugerimento: una scatola Prusament va benissimo.

PASSO 36 Installare il cilindro del supporto bobina



● Posiziona il cilindro Puck-universal sulla scatola di cartone in modo che i fori per le viti siano rivolti verso l'alto.

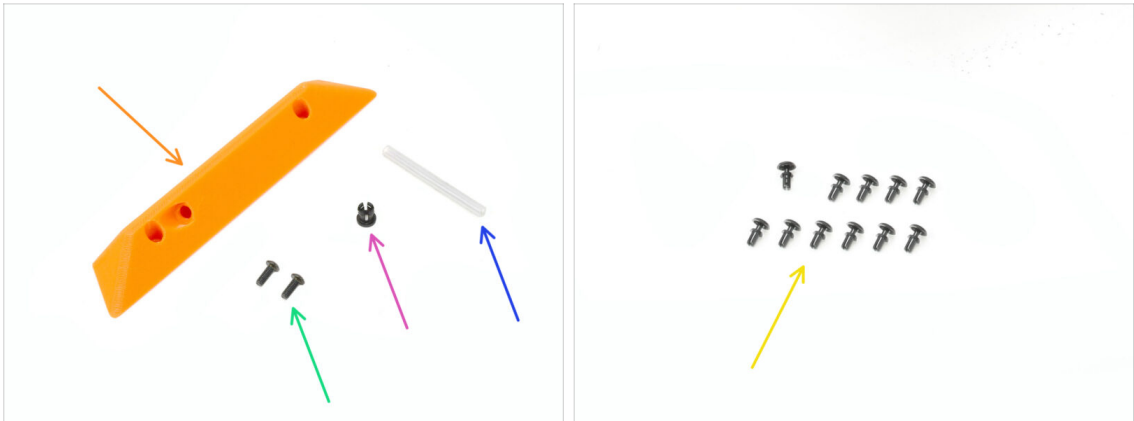
● Posiziona con cura il pannello destro sul Puck-universal, posizionandolo al centro della scatola.

● Allinea i fori del Puck-universal con quelli del pannello destro.

● Fissa il Puck-universal con quattro viti M3x8rT.

ⓘ Le viti possono opporre resistenza durante il serraggio, poiché incidono la propria filettatura all'interno del componente.

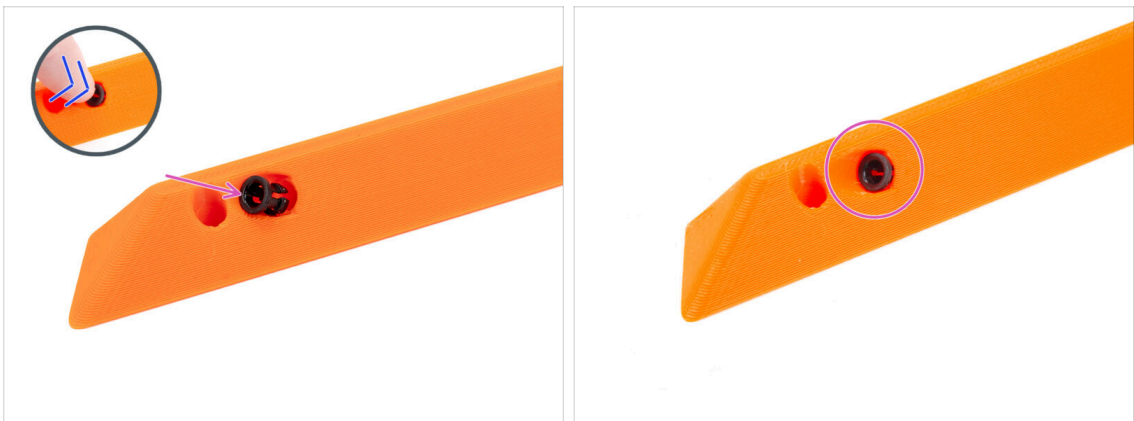
PASSO 37 Right handle: parts preparation



For the following steps, prepare:

- Side Handle (1x) *found in the Printed parts package*
- Viti 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)*
- Rivetto in nylon (11x)

PASSO 38 Installazione del colletto



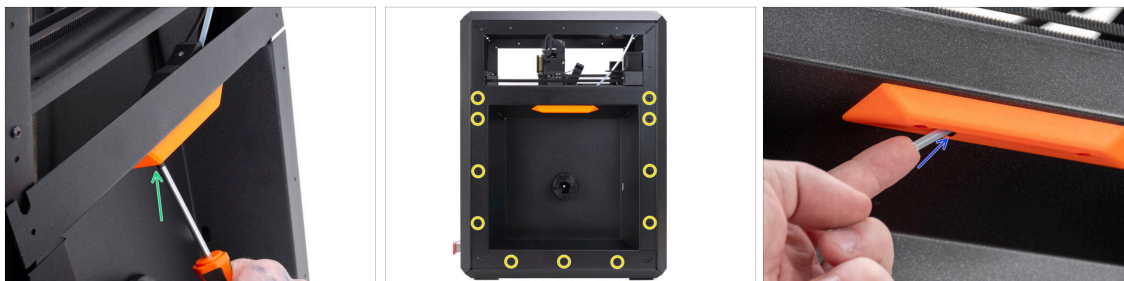
- Insert the collet into the handle.
- Push it all the way in.

PASSO 39 Montare la maniglia



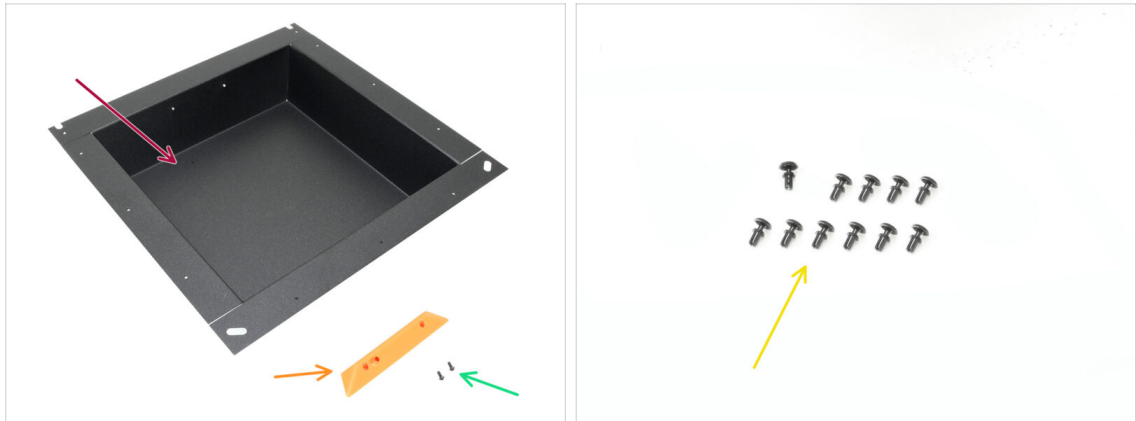
- ✦ Place the right-side metal sheet assembly on the right side of the printer. Ensure the U-shaped cutouts are facing upwards.
- ✦ Attach the right handle to the right metal sheet.
- ✦ Spingi una vite M3x8rT attraverso il foro posteriore della maniglia e la piastra metallica.
- ✦ Attach the side filament 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.

PASSO 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.
- ✦ Inserisci il tubo corto in PTFE 4 x 2,5 x 45 nella pinza. Spingilo fino in fondo.
- ⓘ Part of the PTFE tube will remain protruding from the handle.

PASSO 41 Left side: parts preparation



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

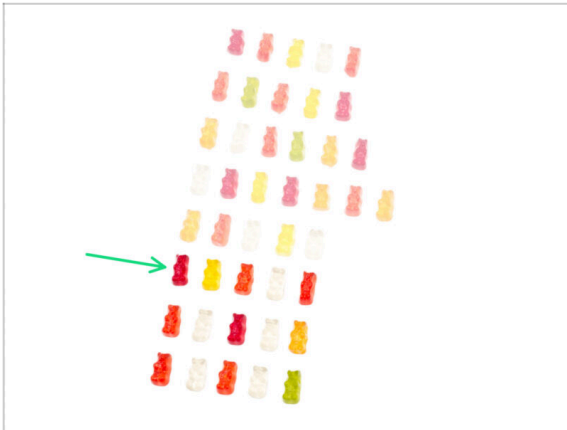
- Left side sheet metal (1x) *found in the Metal parts 2/3 package*
- Maniglia (1x) *si trova nella confezione Printed parts*
- Vite M3x5rT (2x)
- Rivetto in nylon (11x)

PASSO 42 Installing the left side



- Align the handle with the threaded openings in the sheet metal.
- Attach the handle using the two M3x5rT screws.
- Fissa la piastra laterale alla stampante con 11 rivetti di nylon.

PASSO 43 È l'ora delle Haribo!



- Well done—fuel up for the next challenge!
- Eat the sixth row.
- Ci siamo quasi! **Ma giù le mani da quelle ultime caramelle!**

PASSO 44 Fatto

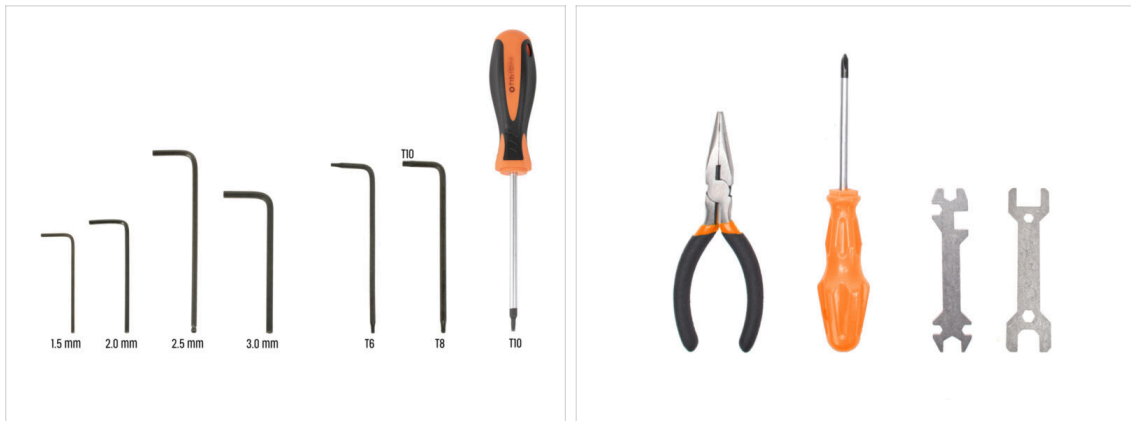


- Congratulations! You've successfully assembled the entire body.
- Let's move to the next chapter.

8. Trim, Door & xLCD



PASSO 1 Tools necessary for this chapter



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

- Chiave a brugola da 2.5mm
- Chiave Torx T10
- Pinza a becchi lunghi

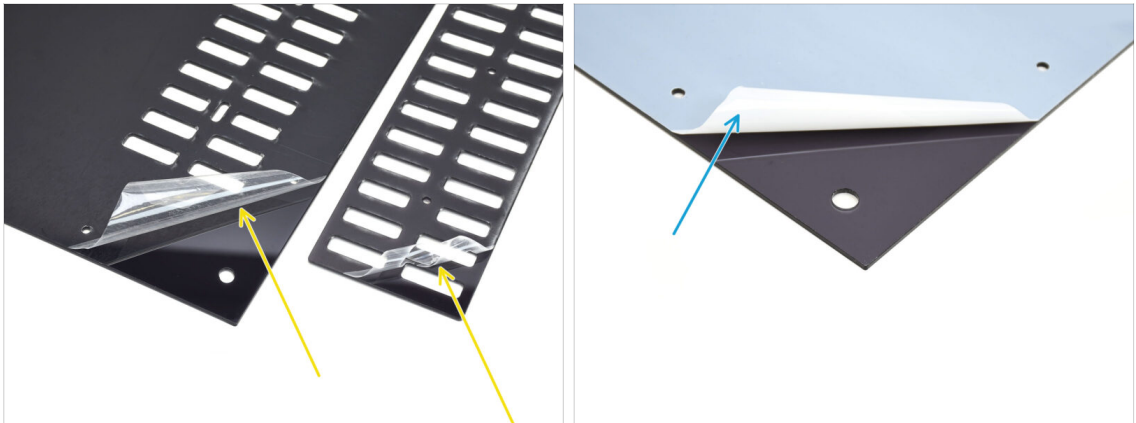
PASSO 2 Top cover: parts preparation



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

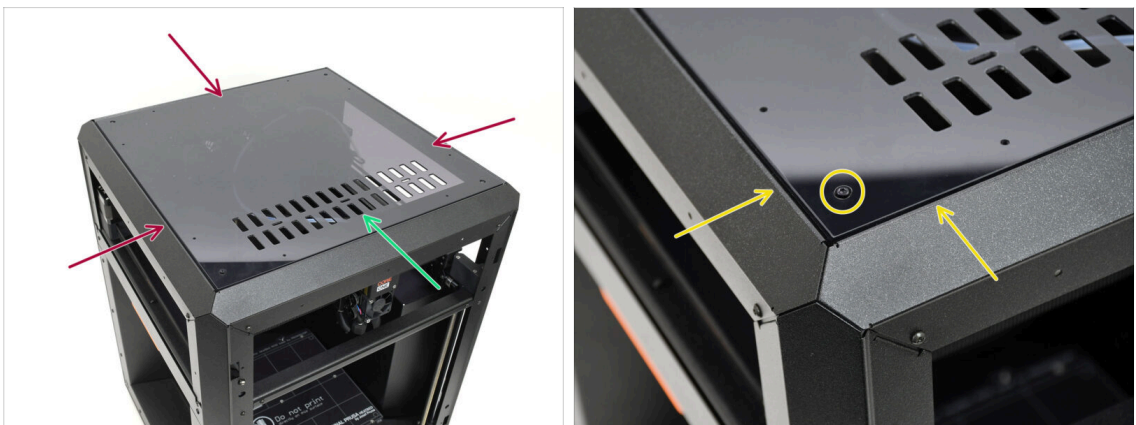
- Top cover (1x) *found in the Plexi set package*
- Coperchio della presa d'aria (1x) *si trova nella confezione Plexi set*
- Dado M3nN (3x)
- Insulating insert (3x) *found in the Electronics & Fasteners package*
- ⓘ This part may come in either gray or black. However, the shape is identical, and it does not affect the procedure.
- Vite M3x12rT (3x)
- Rivetto in nylon (4x)
- Upg-vent-block

PASSO 3 Rimuovere la pellicola



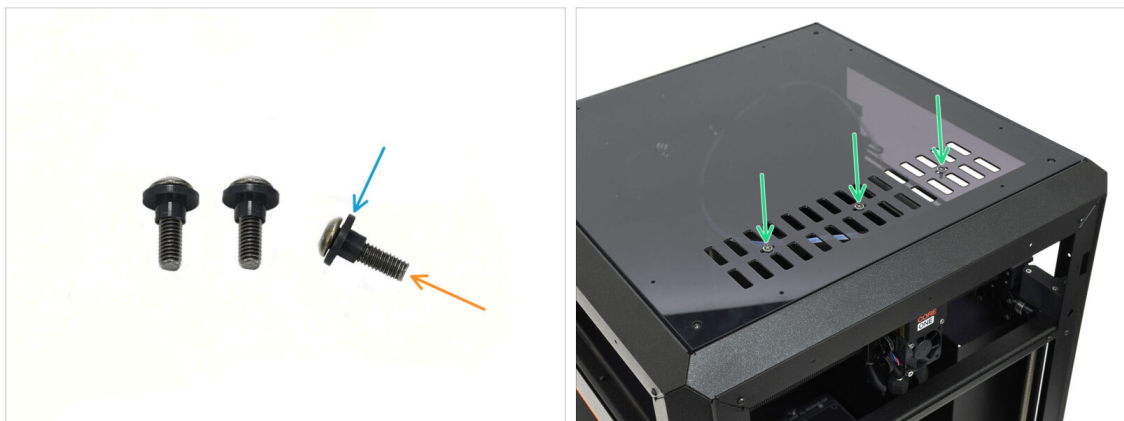
- First, remove the protection foil from both the plastic sheets.
- Flip the parts around and remove the protective foil from the other sides.

PASSO 4 Test-fitting the top cover

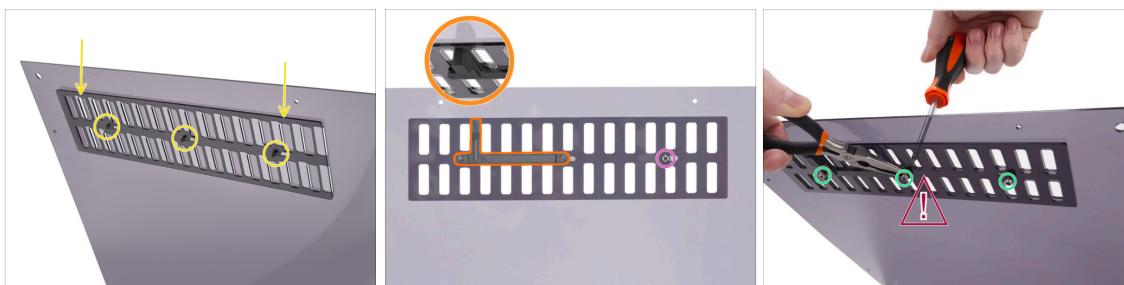


- Lay down the top cover onto the printer.
- The part with the vent openings should be oriented towards the front of the printer.
- Se orientato correttamente, il coperchio si allineerà con l'incavo e le teste dei bulloni negli angoli si inseriranno nelle aperture.
- i** If the bolt openings don't align, flip the cover.

Spoiler alert: The cover isn't symmetrical!

PASSO 5 Assembling the top cover I.

- ✶ Fai passare tutte e tre le viti M3x12rT attraverso gli inserti isolanti.
- ✷ Make sure the flanged part of the insert is oriented toward the screw head.
- ✸ Inserisci le viti con gli inserti attraverso le tre aperture della presa d'aria.

PASSO 6 Assembling the top cover II.

- ✶ Align the vent cover with the screw ends on the bottom.
 - ✷ Stringi a mano il dado M3nN più a destra sulla vite M3x12rT per fissare il coperchio.
 - ✶ Monta la parte Upg-vent-block alla copertura della ventilazione. Assicurati che sia posizionata nel modo corretto.
 - ✸ Fissa la parte Upg-vent-block sulla copertura della griglia di ventilazione con i dadi M3nN. Usa le pinze a becchi lunghi per tenere i dadi mentre stringi le viti.
- ⚠ 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.

PASSO 7 Testare la ventilazione



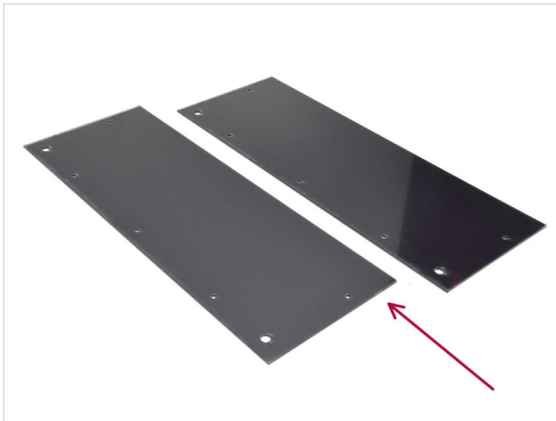
- ◆ Try moving one of the three screws with your hand.
- ① The vent openings must open and close smoothly without effort.
- ⚠ If movement is difficult, loosen the screw that is restricting it.

PASSO 8 Installing the top cover



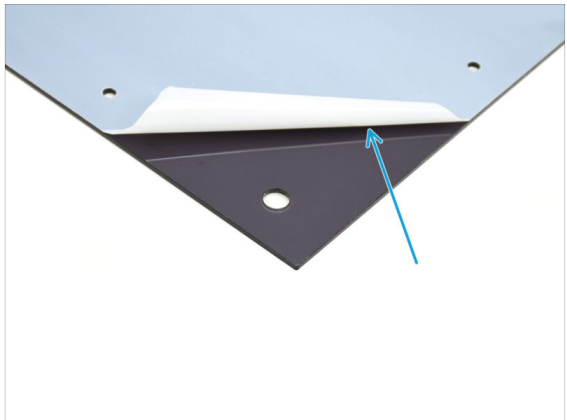
- ◆ Allinea la copertura con l'incavo sulla stampante, assicurandoti che la presa d'aria sia rivolta in avanti.
- ◆ Secure the cover to the frame using four nylon rivets in the marked openings.
- ① There are eight openings, but four rivets should be sufficient.

PASSO 9 Side covers: parts preparation



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

PASSO 10 Rimuovere la pellicola



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

PASSO 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.

PASSO 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.

PASSO 13 xLCD: preparazione componenti



- 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*
 - ✖ Vite 3x8sT (4x)
 - ✖ Faston connector (1x) found in the *Electronics package*

PASSO 14 Assembling the xLCD I.



- ✖ We recommend placing the front cover face down on a cardboard box edge or desk to create space for the encoder knob.
- ✖ Remove the protective foil from the xLCD.
- ✖ Insert the xLCD into the front cover.

PASSO 15 Assembling the xLCD II.



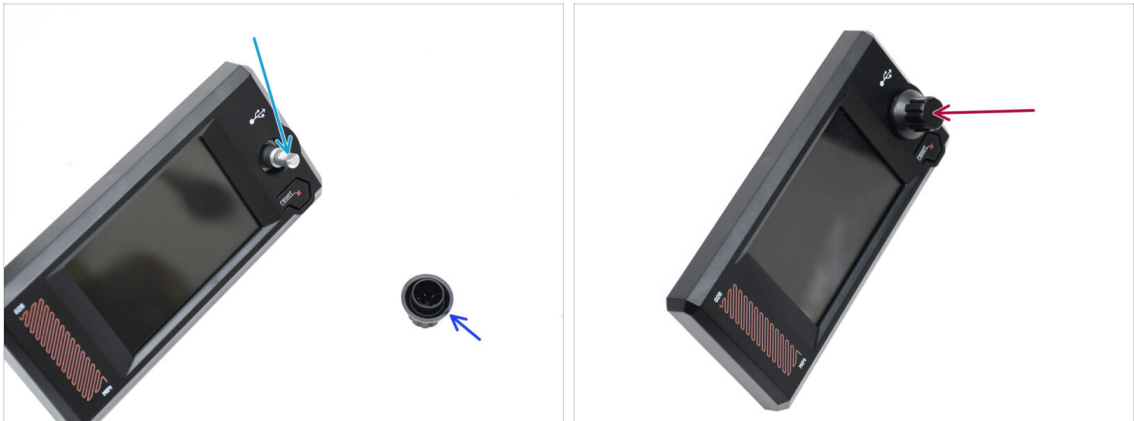
- Cover the assembly with the rear part.
 - If you have an older version of the printed rear cover, it must hook by the xLCD itself in the corner. With the up-to-date version, the rear part can be simply laid down.
- Fix the parts together using **JUST THREE** 3x8sT screws in the marked openings.
 - ⚠ Do not insert the screw into the fourth opening next to the long slot for the xLCD connector, visible through the cutout. Leave it empty for now.

PASSO 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.
- Utilizzando pinze a becchi lunghi, manovra con attenzione il connettore di messa a terra sull'apertura della vite, assicurandoti che i fori siano allineati.
- 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.

PASSO 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.
- Sulla manopola stampata a iniezione è presente una piccola incisione, che può servire come segno di orientamento.
- Attach the knob onto the shaft, making sure the mark on the knob is facing up.

PASSO 18 xLCD bezel: parts preparation



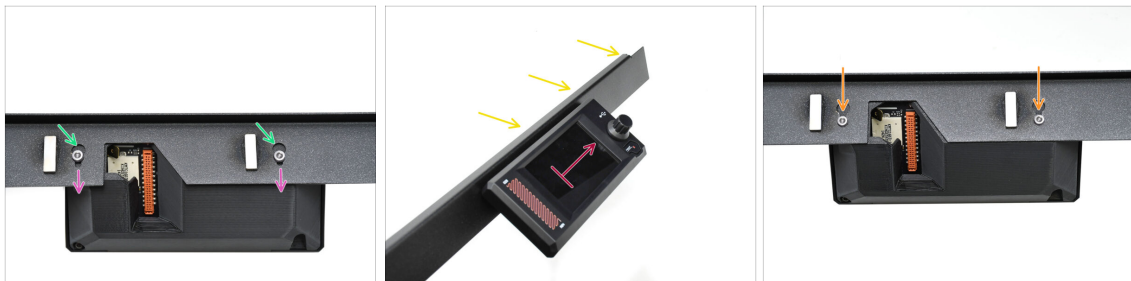
- **For the following steps, prepare:**
- xLCD (1x) *assemblato nei passi precedenti*
- Dado M3nS (2x)
- Vite M3x6 (2x)
- Bezel (1x) *found in the Metal parts 2/3 package*

PASSO 19 Mounting the xLCD I.



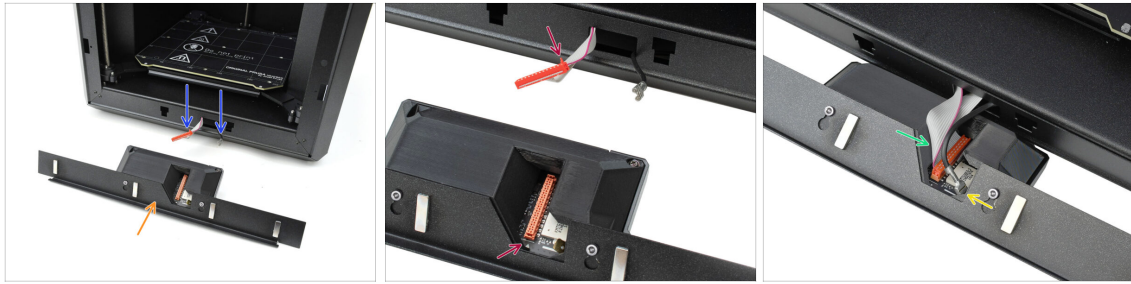
- Insert the two M3nS nuts into the dedicated openings on the back of the xLCD assembly,
- Spingi i dadi fino in fondo finché le filettature non si allineano con le aperture delle viti.
- Attach two M3x6 screws into the openings. Do not screw them all the way in.
- Leave a gap under the screw heads.

PASSO 20 Mounting the xLCD II.



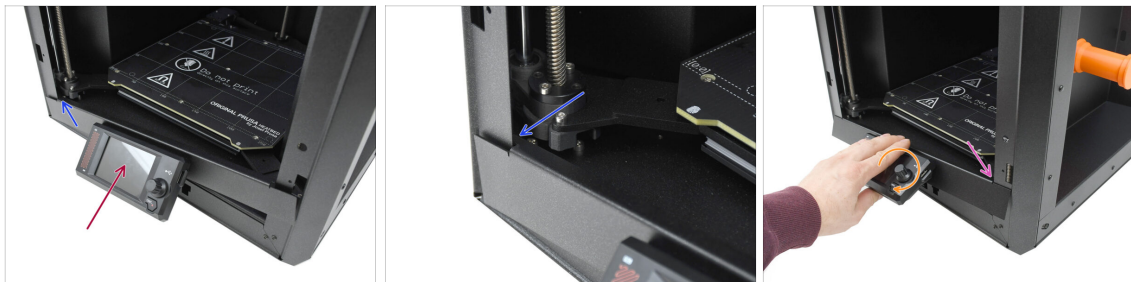
- Hook up the xLCD assembly onto the Bezel.
- Inserisci le teste delle viti nei buchi a serratura.
- Slide the xLCD assembly so that the screw heads engage into the narrower parts of the keyholes.
- If assembled correctly, the LCD should be pointing up...
- ...While the bent lip on the Bezel is on top.
- Push the screws all the way into the narrow part of the keyhole on both sides. Then, tighten the screws.

PASSO 21 Installing the xLCD assembly



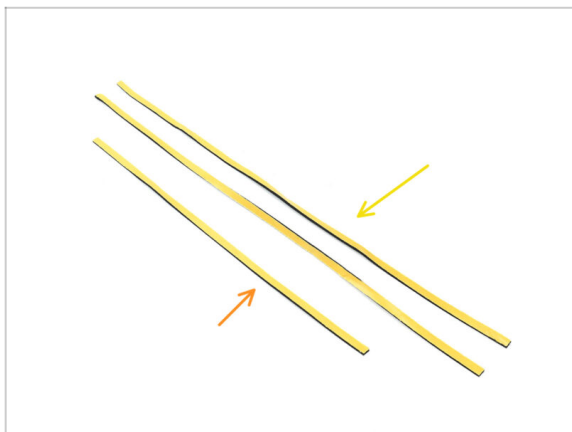
- Put the xLCD assembly in front of the printer, as pictured.
- Estrai i cavi corrispondenti dalla parte anteriore della stampante per facilitarne il collegamento.
- There is a small red tab on the main connector. This tab must be oriented towards the triangle symbol on the PCB.
- Connect the main connector into the xLCD.
- Connect the grounding faston connector.

PASSO 22 Securing the xLCD assembly



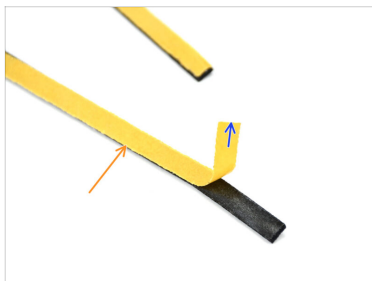
- Gently lift the xLCD assembly into the upward position.
- ⚠ Procedi con attenzione per assicurarti che nessuno dei cavi venga schiacciato o scollegato.**
- Hook the tiny tab on the left side of the bezel behind the left vertical profile of the printer.
- Gently lift the bottom part of the xLCD assembly to allow for smoother tab engagement and extra wiggle room.
- Hook the tab on the right side into the printer's right profile.

PASSO 23 Door seal: parts preparation



- **For the following steps, prepare:**
- Guarnizione laterale sportello, una più lunga (2x) si trova nella confezione *Electronics & Fasteners*
- Top door seal, a shorter one (1x) found in the *Electronics & Fasteners* package
- ⓘ The color of the protective layer may vary.

PASSO 24 Attaching the top seal



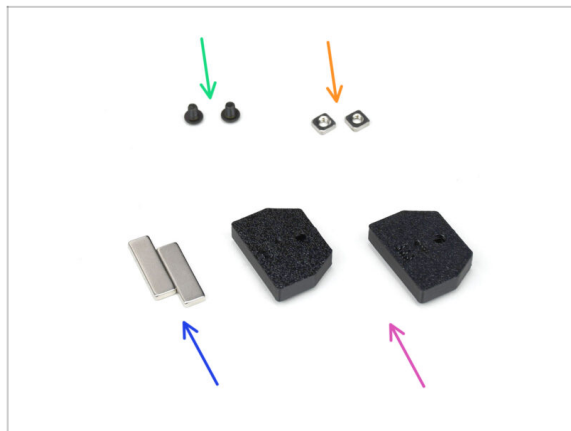
- Take the **SHORTER** seal.
- Stacca la parte iniziale della pellicola protettiva. Non è necessario rimuoverla completamente.
- ⓘ No need to remove it entirely yet. For easier installation, you can peel it off gradually as you go.
- Start applying the seal along the top edge of the printer's frame.
- 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.

PASSO 25 Attaching the side seals



- Apply the longer door seal, starting from the end of the seal on top.
- Lavora dall'alto verso il basso.
- 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.

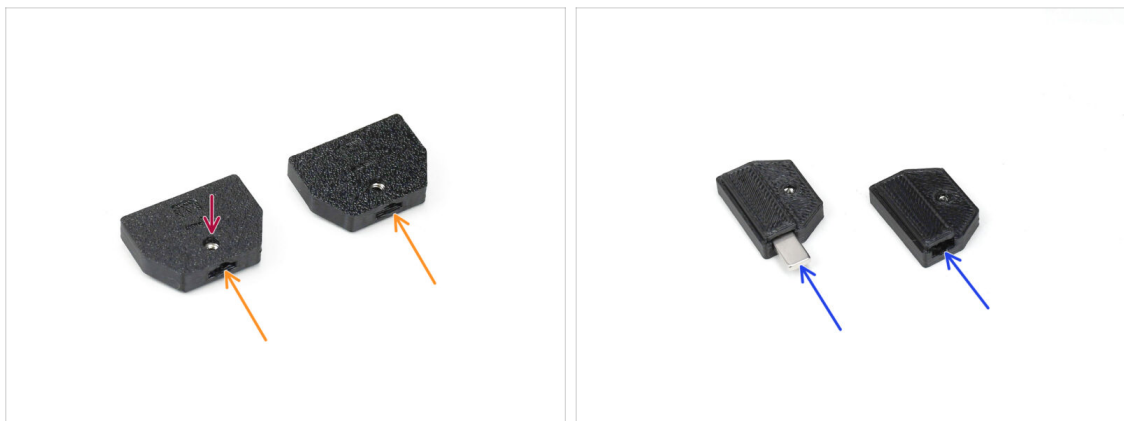
PASSO 26 Magnet holders: parts preparation



● For the following steps, prepare:

- Vite M3x5rT (2x)
- Dado 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*

PASSO 27 Assembling the magnet holders



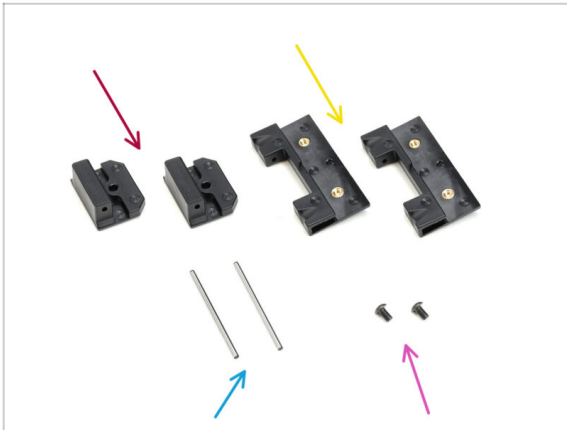
- ✚ Insert the M3nS nuts into the corresponding openings in the magnet holders.
- ✚ Spingi i dadi fino in fondo, finché la filettatura non si allinea con l'apertura per la vite.
- ✚ Insert the magnets into the corresponding pockets in the holders. Push them all the way in.
- ⓘ The orientation of the magnets does not matter.

PASSO 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.
- ⚠ Assicurati che la parte rettangolare sporgente si inserisca nel ritaglio.
- ✚ 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.

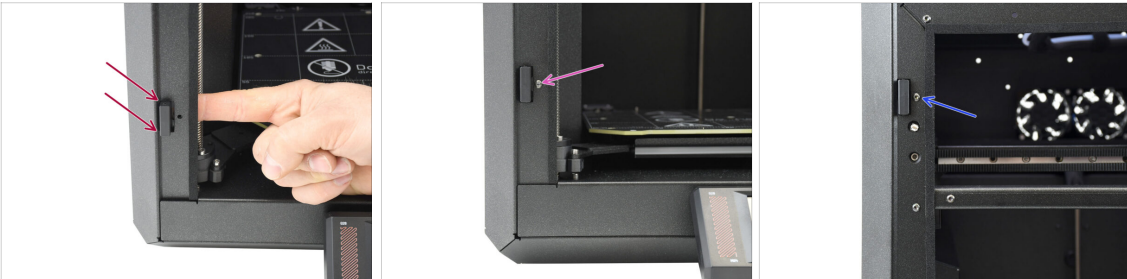
PASSO 29 Cerniere: preparazione dei componenti



For the following steps, prepare:

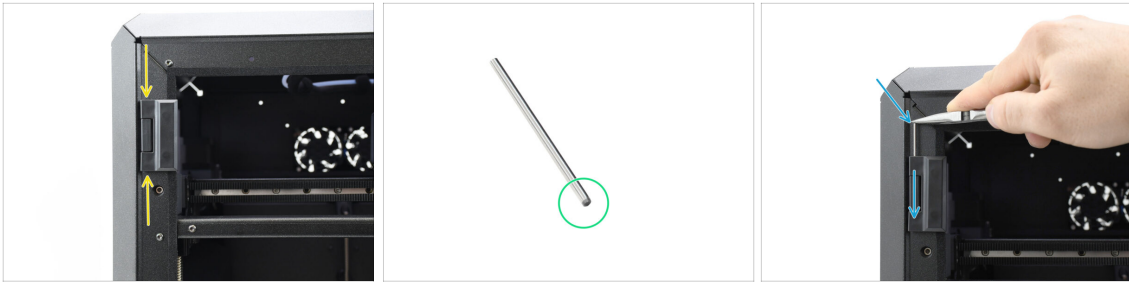
- Door-hinge-in (2x) *si trova nella confezione CoreXY + Hinges set*
- Door-hinge-out (2x) *found in the CoreXY + Hinges set package*
- Hinge Pin 2 x 40 mm (2x) *found in the Electronics & Fasteners package*
- Vite M3x5rT (2x)

PASSO 30 Installing the door-hinge-in parts



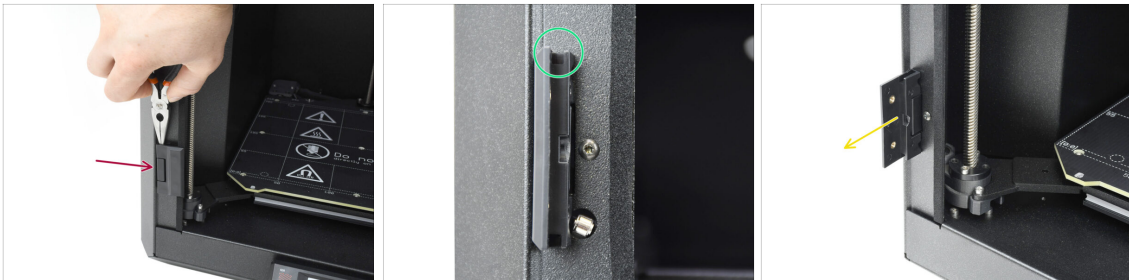
- From the inside of the printer, insert the door-hinge-in into the bottom rectangular opening in the left-side profile. The protruding part should pass through to the front.
- Fissa in posizione la parte door-hinge-in utilizzando la vite M3x5rT.
- Using the same technique, install the other door-hinge-in into the opening on top.

PASSO 31 Installing the door-hinge-out I.



- ✦ Align the door-hinge-out with the door-hinge-in.
- ✦ Il perno deve essere inserito dall'estremità smussata per facilitarne l'assemblaggio.
- ✦ 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.

PASSO 32 Installing the door-hinge-out II.

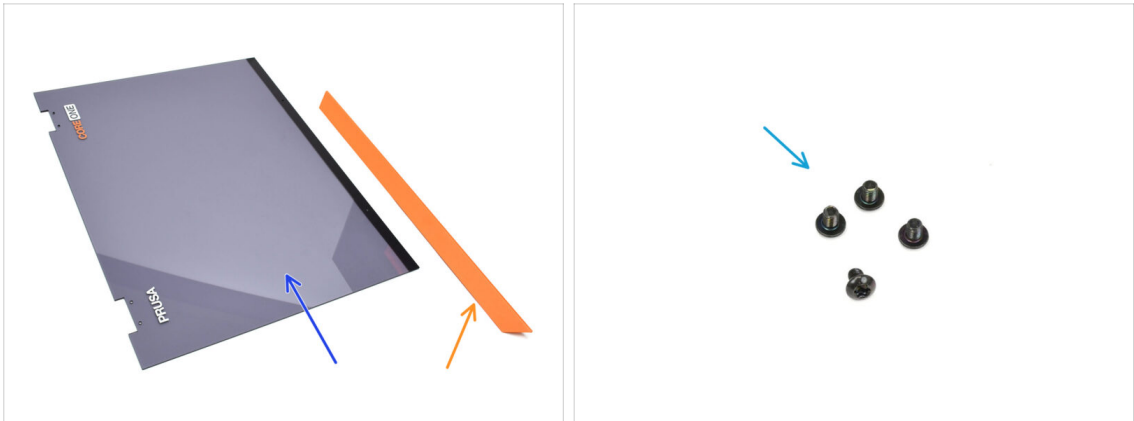


- ✦ Using the same technique, install the bottom door-hinge-out to complete the hinge assembly.
- ✦ Guarda nelle scanalature degli sportelli e verifica che i perni siano completamente inseriti.

Nessuna parte del perno deve essere visibile al di sopra della superficie inferiore della scanalatura.

- ✦ Open up both the hinges.

PASSO 33 Door panel: parts preparation



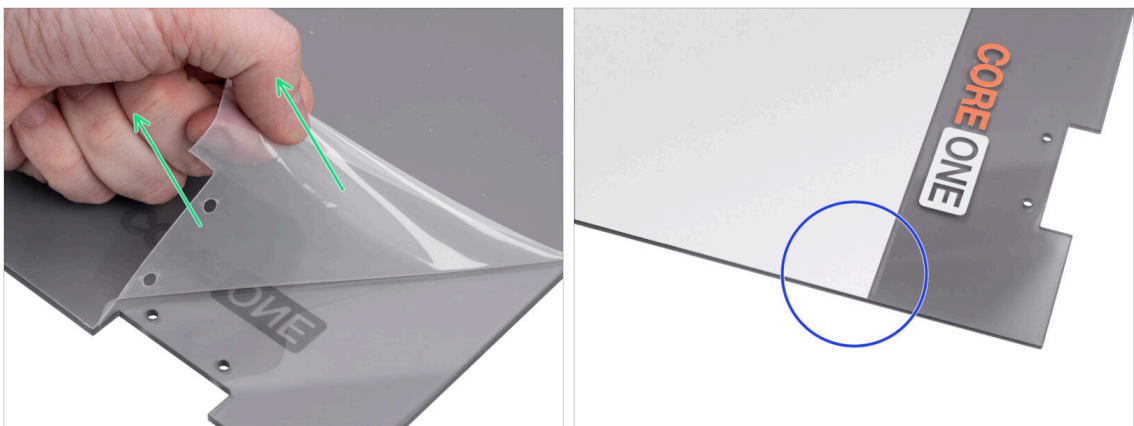
■ **For the following steps, prepare:**

- Sportello (1x) *nella confezione Plexi set*

① Il pannello dello sportello ha già la scritta **CORE ONE**. Non preoccuparti, è **normale!** Alla fine dovrai applicare l'adesivo + dell'aggiornamento.

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

PASSO 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.

- Stacca la pellicola che ricopre lo sportello; è leggermente trasparente.

- You can remove the center protective film (white) now or after mounting the panel to protect the surface during handling.

① This protective film does not interfere with the installation of the hinges or handle.

PASSO 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.
- Assicurati che lo sportello sia orientato in modo che i segni sullo sportello siano rivolti verso l'esterno.
- 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.

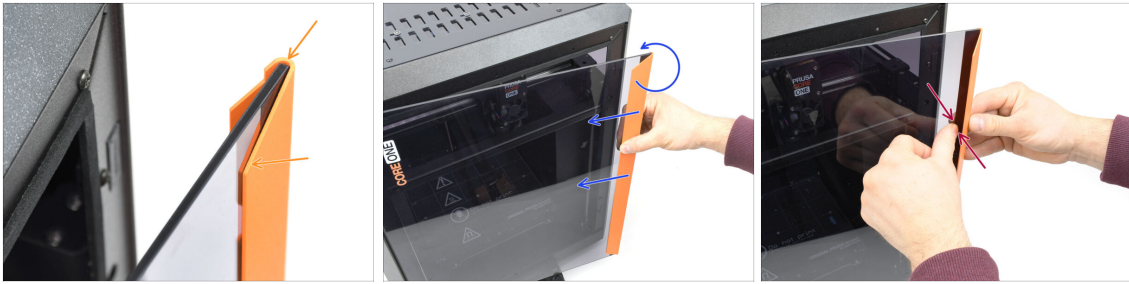
PASSO 36 Assembling the door handle



- Let's move onto the handle. Remove the protective foil from both the adhesive strips on the inside.
- La parte con la striscia adesiva andrà applicata sul retro dello sportello. Ma non attaccare ancora la maniglia!

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

PASSO 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.
- Mentre spingi la maniglia contro lo sportello per mantenerla allineata, ruotala lentamente in senso antiorario fino a quando le strisce adesive si incollano allo sportello.
- Push the door and handle together firmly in the adhesive strip areas to ensure a secure attachment.

PASSO 38 Applicare l'adesivo: preparazione dei componenti



- Per il seguente passo prepara:
 - Adesivo del plexiglass CORE One+
- i L'adesivo del plexiglass CORE One+ è nella scatola CORE One+ Upgrade

PASSO 39 Come attaccare l'adesivo



- Togli l'adesivo dalla base blu.
- Metti l'adesivo in linea con il **ONE** e premi con delicatezza ma con decisione sull'adesivo.
- Togli con attenzione lo strato trasparente e assicurati che il + non si stacchi.

PASSO 40 È l'ora delle Haribo!



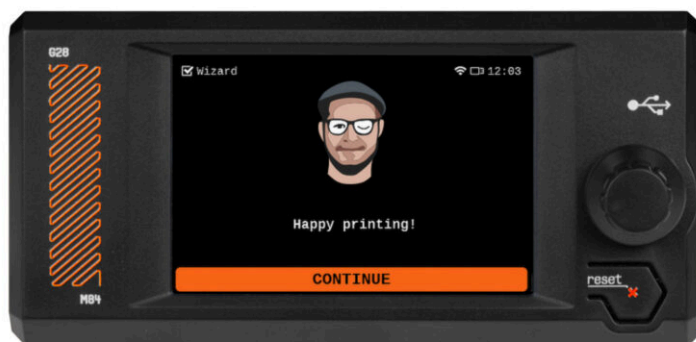
- Hard work deserves sweet results!
- Mangia la settima fila.
- ⚠ But don't eat the rest yet.

PASSO 41 Fatto



- Congratulazioni! Hai montato correttamente la tua Prusa CORE One+.
- Passiamo al capitolo finale.

9. Calibration & First run



PASSO 1 Tensionamento della cinghia



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

PASSO 2 Montaggio del porta bobina: preparazione dei componenti



- ⬢ For the next step, prepare:
 - ⬢ O-ring
 - ⬢ Spoolholder-static
- ❗ Il porta bobina e l'O-ring sono nella stessa busta.

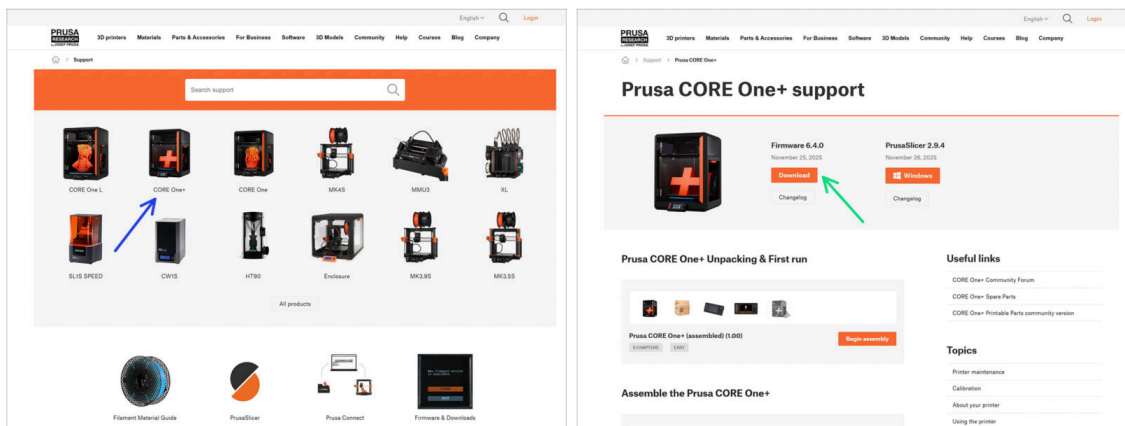
PASSO 3 Montaggio della piastra di stampa e del porta bobina



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

- 🟡 **Attach the sheet by first aligning the rear cutout with the locking pins on the back of the heated bed.** Hold the sheet by the front two corners and slowly lay it down onto the heated bed - **watch your fingers!**
 - ⬛ Keep the **print sheet** clean for optimum performance.
 - ⬛ #1 cause of prints detaching from the print surface is a greasy print sheet. **Use IPA (Isopropyl alcohol) to degrease it** if you have touched its surface before.
- 🟡 Put the O-ring onto the Spoolholder-static.
- 🟡 Spingi il porta bobina nel dock e fissalo ruotandolo in senso orario.

PASSO 4 Aggiornamento Firmware



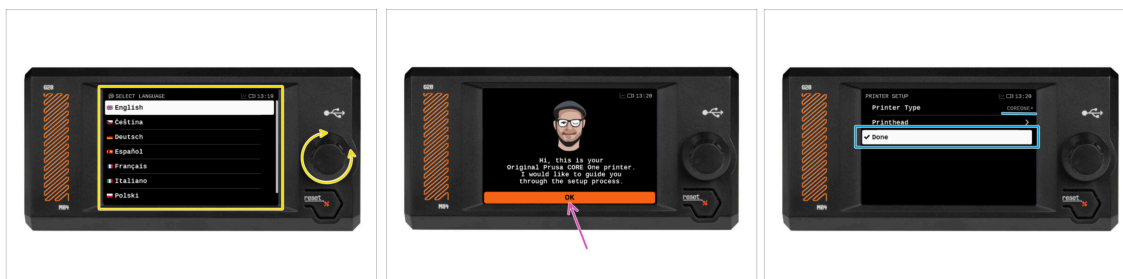
- 📄 **All printers come with a USB drive containing the latest firmware.** However, it is recommended to check and possibly upgrade the firmware version every few weeks.
 - ⬛ Visit the help.prusa3d.com page.
 - 🟡 Navigate to the Prusa CORE One+ page.
 - 🟢 Download the latest firmware version.
 - ⬛ Save the firmware file (*.bbf*) onto the *bundled USB drive*.

PASSO 5 Accendere la stampante



- ✿ 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.

PASSO 6 Setting up the printer: Intro



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

PASSO 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.

PASSO 8 Configurazione guidata: Introduzione



- 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!**

PASSO 9 Wizard: Door Sensor Calibration



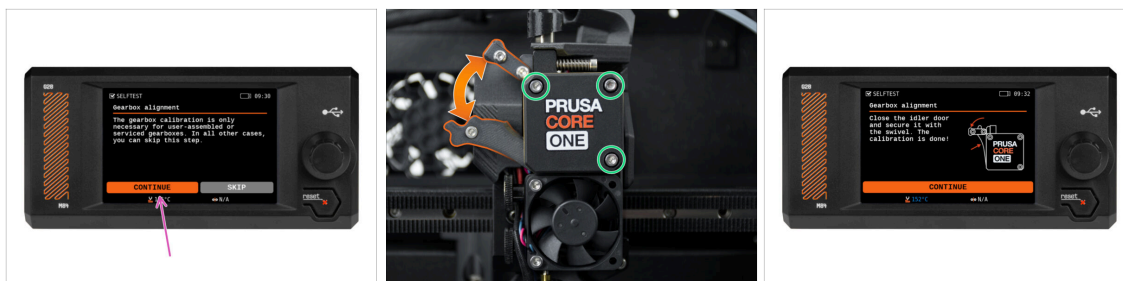
- ✿ The first part that requires your interaction is the door sensor calibration. To begin, hit **Calibrate** and follow the on-screen instructions.
- ✿ You'll be prompted to gradually tighten the sensor tension screw from its default loose position - usually in half-turn steps, possibly several times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

PASSO 10 Configurazione guidata - Test della cella di carico



- ✿ 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**.

PASSO 11 Configurazione guidata: Allineamento degli ingranaggi



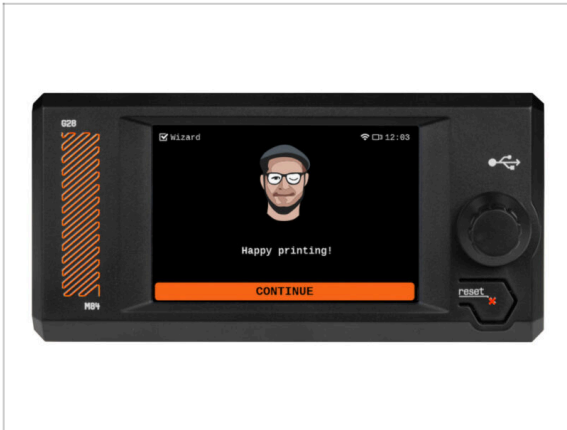
- ✿ Once you get to the Gearbox Alignment part, select **Continue** and follow the on-screen instructions.
- 🔧 Make sure the idler lock (swivel) is unlocked from the idler door.
- 🟢 Loosen the three screws on the front of the gearbox by 1.5 turns.
- 📌 The printer will go through the automatic gearbox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

PASSO 12 Wizard: Filament Sensor Calibration



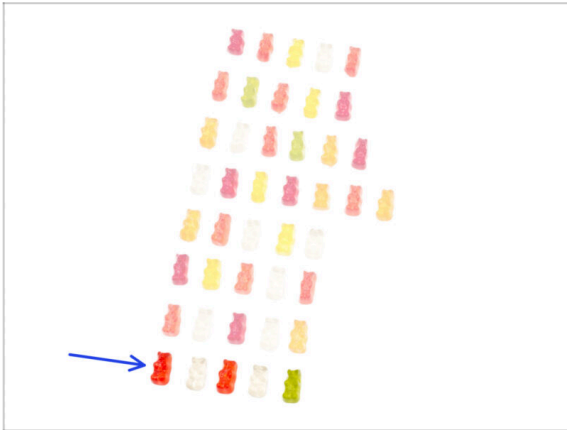
- 🔧 Controlla l'interruttore manuale sul sensore del filamento. **Assicurati che sia su ON.**
- ✿ During the filament sensor calibration, you will need to use a short piece of filament. Prepare the filament and select **Continue**.
- 📌 There should be no filament inside the extruder before the calibration process starts.
- 🔵 Place a spool of filament onto the spool holder on the right side of the printer.
- 🟡 When prompted, begin inserting the filament into the PTFE tube located beneath the right handle.
- ⬛ Remove the filament after the calibration finishes.

PASSO 13 Configurazione guidata completata



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

PASSO 14 È l'ora delle Haribo!



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

PASSO 15 Manuale



- 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.

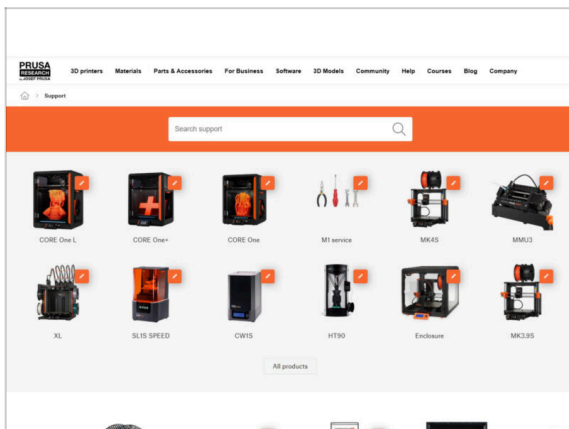


The latest version is always available at help.prusa3d.com.



Read the Disclaimer and Safety instructions chapters.

PASSO 16 Nozioni base Prusa

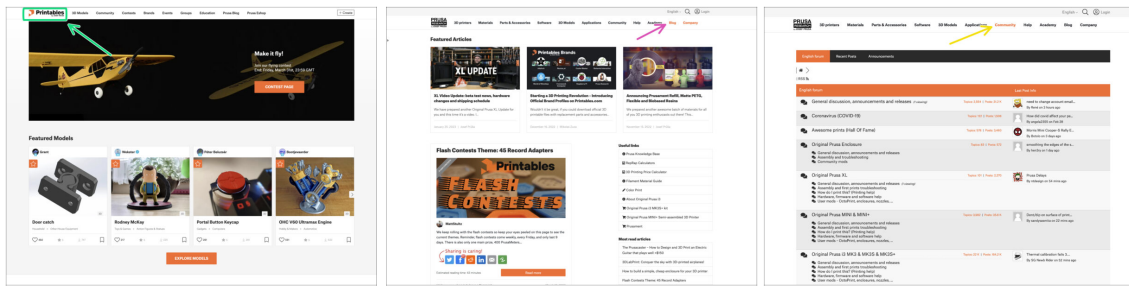


If you encounter any problems at all, don't forget you can always check out our knowledge base at help.prusa3d.com



We're adding new topics every day!

PASSO 17 Unisciti a 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 :-)
- i All Prusa services share one user account.

Registro modifiche del manuale



PASSO 1 Storico versioni



- **Versioni del manuale del kit Prusa CORE One+:**

- 11/2025 - Versione iniziale 1.00

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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.

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