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# 1. Introduction

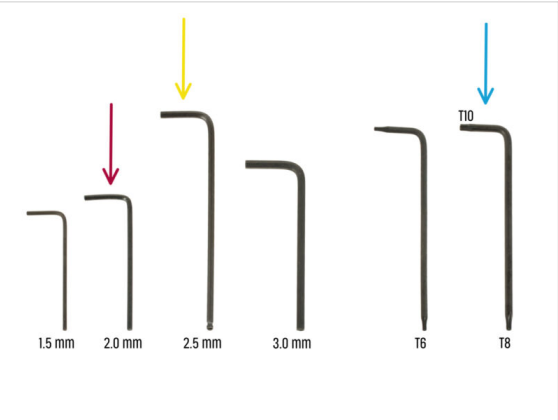
## PASO 1 Preparando el kit de actualización

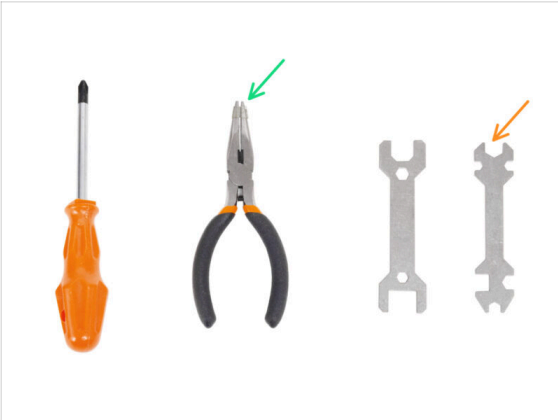
- This manual guides you through upgrading your **Prusa CORE One+ to CORE One+ (Gen 2)**.
- Por favor, prepara el kit de actualización recibido de Prusa Research.

  Todas las herramientas necesarias están incluidas en el kit.

  Las partes imprimibles estan también disponible en Printables.

## PASO 2 Tools Required



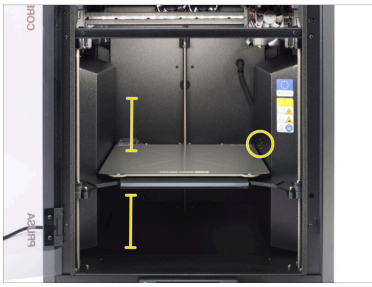
The tools needed for this upgrade are **not included in the kit**. Please use the tools that came with your original CORE One+ printer.

- **Para los siguientes capítulos, por favor prepara estas herramientas:**
- 2.0mm Allen key
- 2.5mm Allen key
- Llave Torx T10 / Destornillador
- Needle-nose pliers
- Unikey con la abertura del tamaño de una tuerca M3.

## PASO 3 Unloading the filament

- Descarga el filamento. Visita el menú **Filamento** y selecciona **Descargar Filamento.**
- Descarga el filamento de la impresora.
- Retira la bobina de filamento de la impresora.

## PASO 4 Moving the Z-axis



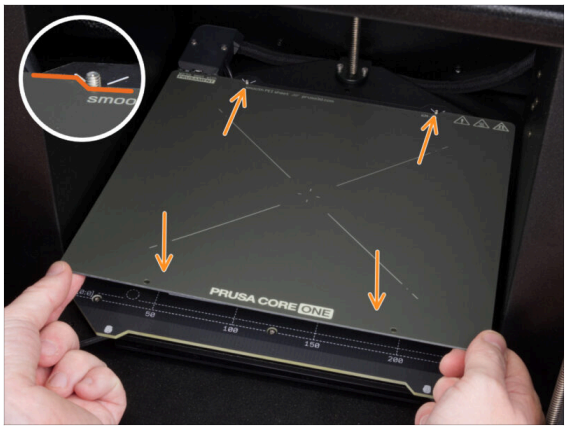
ⓘ Antes de empezar, coloca la base calefactable en una posición accesible.

⚠ Durante este paso, **mantén la puerta de la impresora cerrada** y no metas la mano en su interior.

- En el menú de la impresora, ve a *Control -> Auto Home*.
- After Auto Home, move the heatbed down via *Control -> Move Axis -> Move Z* until the highlighted screws and the underside of the heatbed are accessible (minimum **200 mm**).

  ⓘ De este modo se garantiza que se pueda acceder cómodamente a ambas zonas durante el procedimiento, ya que habrá que manipularlas más adelante en el manual.

## PASO 5 Unplugging the printer

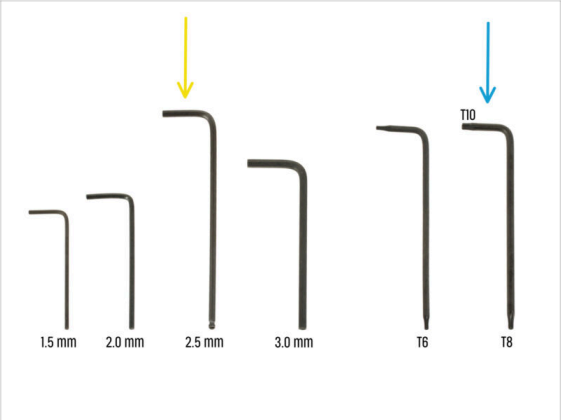


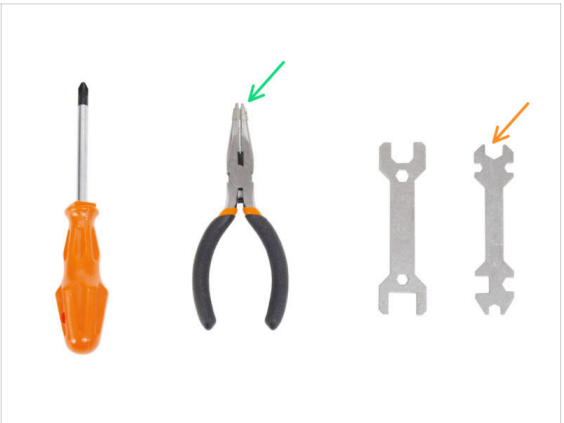

⚠ Antes de comenzar, asegúrate de que la **impresora se haya enfriado** a temperatura ambiente.

- Apaga la impresora mediante el interruptor situado en la parte posterior.
- Desconecta la impresora de la corriente.
- Remove the steel sheet (optional).

# 2. Printer disassembly

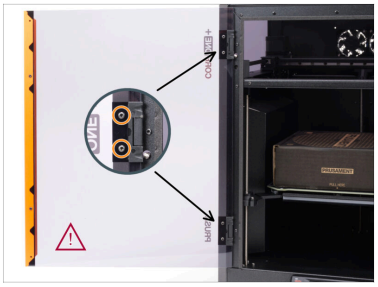
## PASO 1 Tools

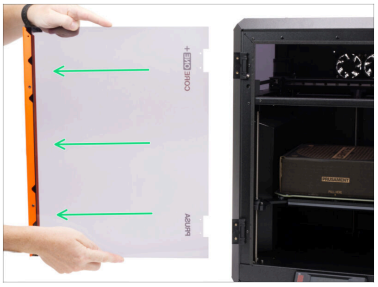


- **Tools necessary for this chapter:**
- 2.5mm Allen key
- T10 key/screwdriver
- Needle-nose pliers
- Universal wrench

## PASO 2 Retirando el panel de la puerta.




We recommend **protecting the heatbed** during handling. An empty Prusament box is an ideal protective layer.

- For easier and safer handling during the upgrade, remove the door. **Proceed carefully** to avoid injury or damage to the door panel.
- Afloja y retira los dos tornillos M3x5rT que fijan el panel de la puerta en ambas bisagras.

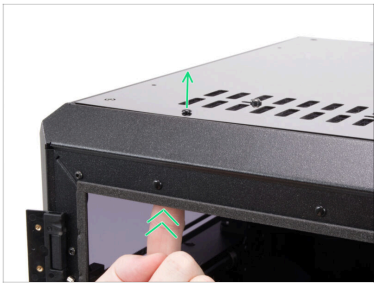
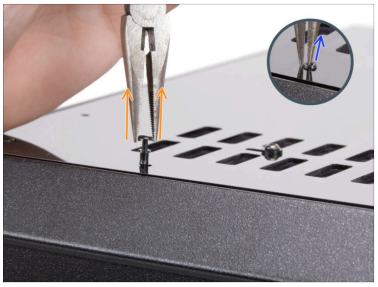
Es imprescindible **sujetar bien el panel de la puerta** mientras se aflojan los tornillos para evitar que se caiga.

Start removing the screws from the lowest.

- Carefully slide the door panel out of the hinges. Leave the hinges open for the remainder of the upgrade.
- Place the door panel and the four screws in a **clean and safe** area to avoid any damage.

Ensure that the shaft that is inside the hinge does not fall out. If the shaft falls out, insert it back in, or set it aside along with the hinge part. We will mount these back on at the end of the assembly.

## PASO 3 Retirando el panel superior

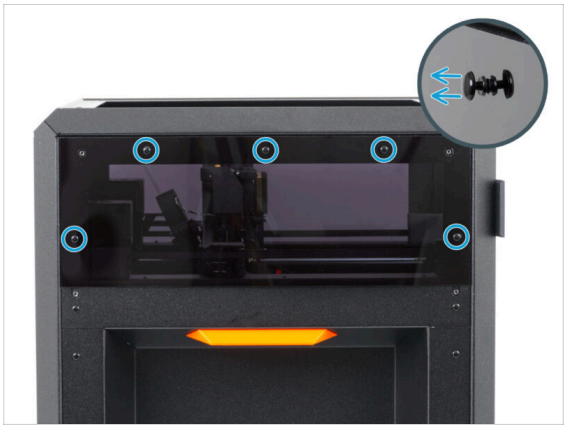
- From the inside, gently push out all the nylon rivets securing the top cover with your finger.
- Using needle-nose pliers, carefully grasp the rivet head with the tip of the pliers and pull it out.

  ⓘ You can also use the previously mentioned **Core-one-snap-rivet-remover.**

⚠ Be careful not to damage the top panel.

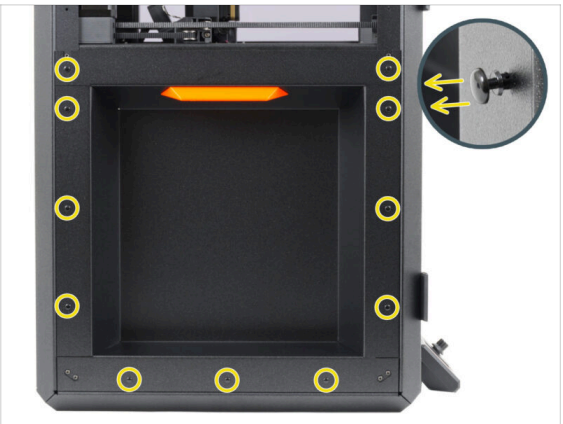
- If the lower part of a rivet remains in the panel, grasp it with pliers and remove it as well.
- Remove the top panel from the printer.

## PASO 4 Removing the left side cover



- Using the same procedure, remove all five nylon rivets securing the left side cover.
- Remove the side cover from the printer.
- Set it aside in a safe, clean place.

## PASO 5 Removing the left metal panel

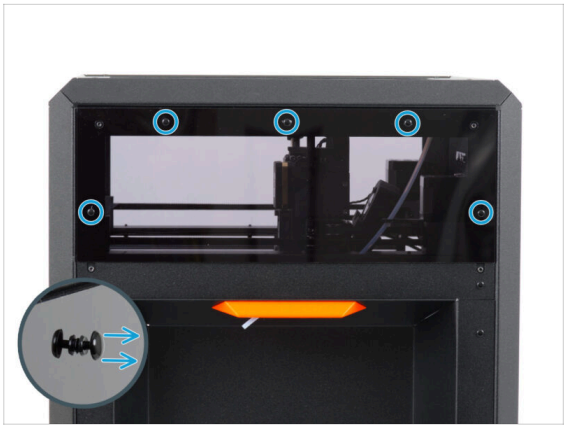


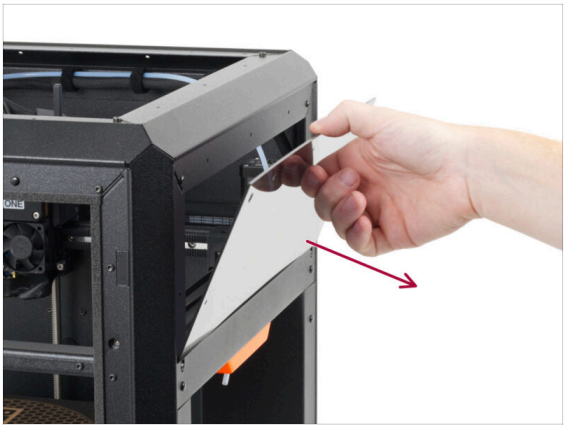
- Remove the eleven nylon rivets securing the left steel panel.

  Start with the bottom rivets. **Support the panel by hand** when removing the last rivets to prevent it from falling.

- Remove the metal panel from the printer.

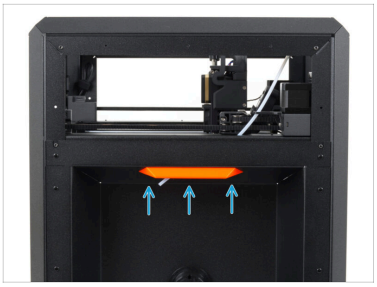
## PASO 6 Removing the right side cover

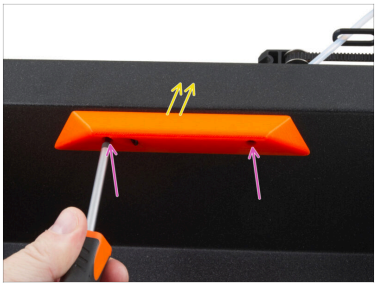




- Using the same procedure, remove all five nylon rivets securing the right side cover.
- Remove the side cover from the printer.
- Set it aside in a safe, clean place.

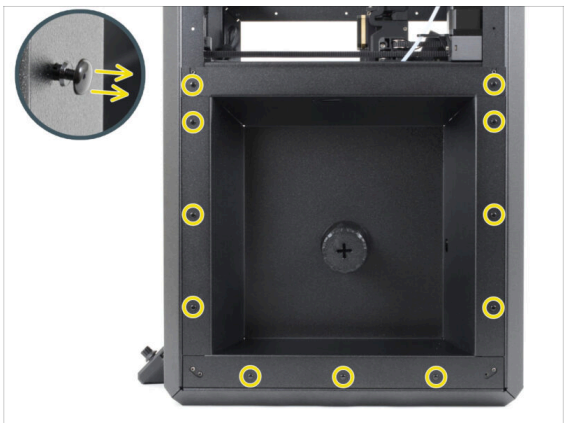
## PASO 7 Removing the right handle





- Move to the opposite side of the printer and focus on the underside of the orange handle.
- Press the black collet on the PTFE tube into the handle to unlock the tube.
- While holding the collet pressed in, pull out the PTFE tube.
- Using the T10 screwdriver release two M3x8rT screws securing the handle and the filament sensor.
- Remove the handle from the printer.

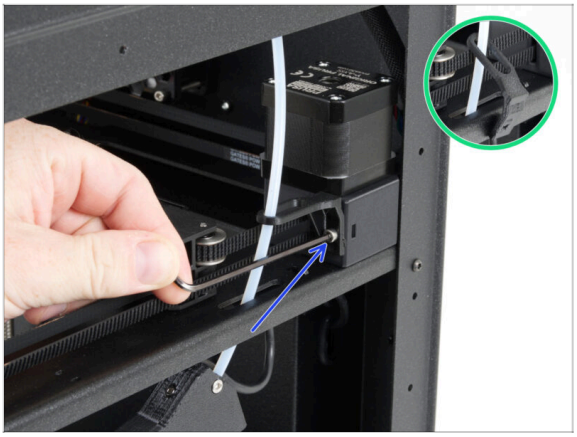
## PASO 8 Removing the right side panel



- Remove the eleven nylon rivets securing the right steel panel.

  Start with the bottom rivets. **Support the panel by hand** when removing the last rivets to prevent it from falling.
- Remove the metal panel from the printer.

## PASO 9 Detaching the Bowden-guide



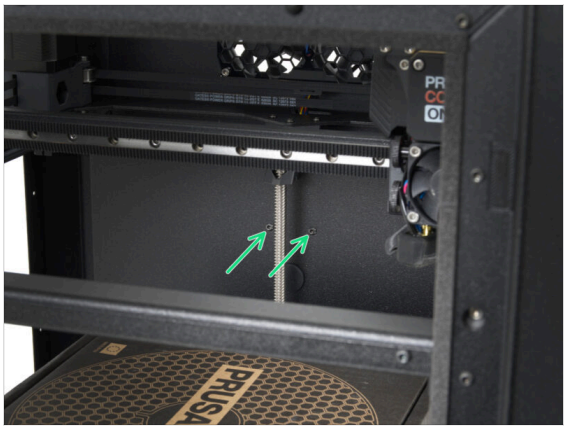
- Remove the M3x10 screw and remove the Bowden guide from the motor mount.

  *Pro tip*: Once the Bowden guide is removed, thread the M3x10 screw back into the motor mount by a few turns. This will keep the nut in place and make reassembly easier.

- Leave the Bowden guide hanging on the PTFE tube.

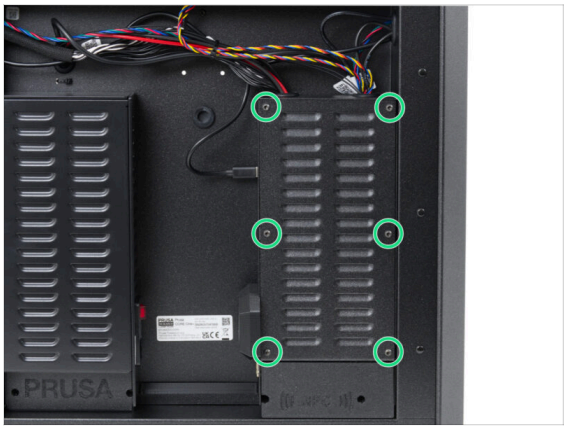
  The Bowden guide does not need to be removed completely. Loosen it to improve access for later steps.

## PASO 10 Uncovering the cables



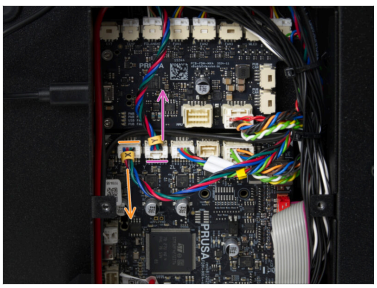
- On the inside of the printer, remove the two M3x4rT screws holding the back cover.
- On the back of the printer, slide the center cover down to unlock it, then remove it.

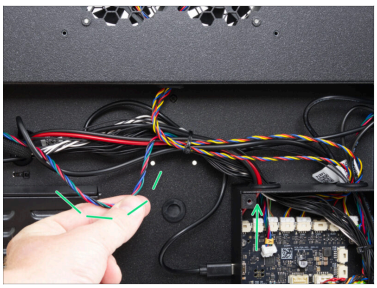
## PASO 11 Uncovering the xBuddy electronics

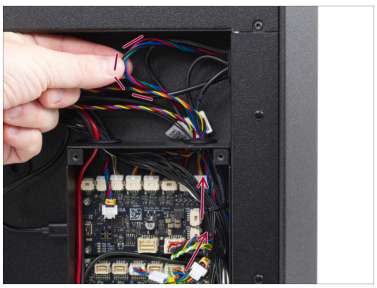


- Unscrew all six M3x4rT screws securing the electronics sheet (xBuddy box cover).
- Slide the xBuddy box cover out of the electronics box and remove it from the printer.

## PASO 12 Disconnecting the motor cables





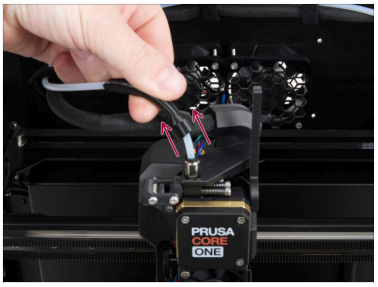


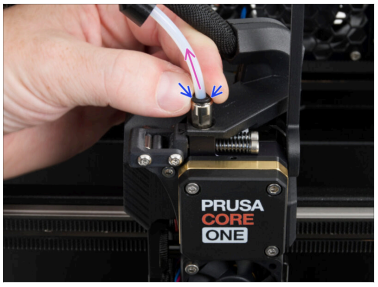
⚠ The connectors have a safety latch that must be pressed when disconnecting.

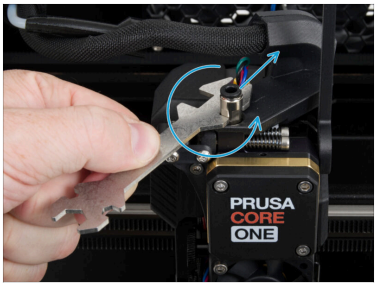
- Disconnect the X motor cable from the first connector on the left.
- Disconnect the Y motor cable from the second connector on the left.
- Gently pull the Y motor cable slightly to create some slack while keeping the connector inside the electronics compartment.
- Gently pull the X motor cable slightly to create some slack while keeping the connector inside the electronics compartment.

⚠ If you feel resistance, **stop pulling**. If the cable cannot be moved at all, cut the zip ties securing the cable bundles. **Be careful not to damage any cables**.

## PASO 13 Unplugging the PTFE tube

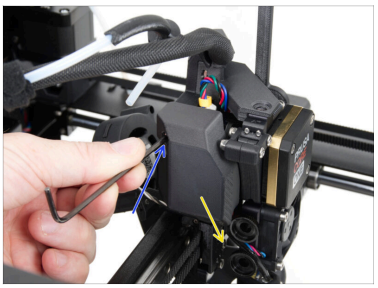


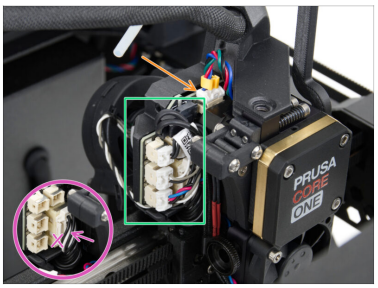





- Move to the inside of the printer.
- Slide the bowden-bend over the fitting in the Nextruder.
- Press the black collet in the fitting down, preferably using two fingers.
- Pull the PTFE tube out of the fitting.
- Using the 8mm cutout on the Universal wrench, remove the M5-4 fitting.

## PASO 14 Disconnecting the Nextruder cables - left side





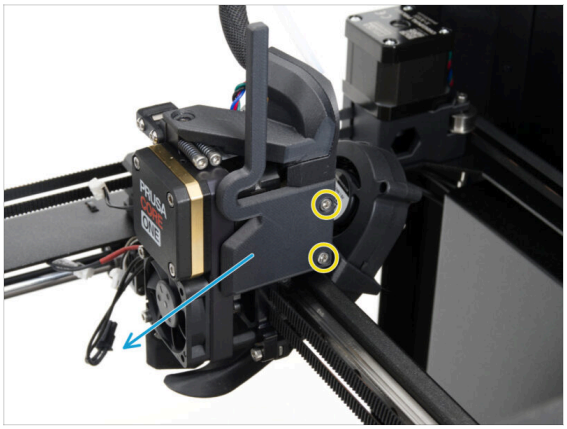

- Con la llave Allen de 2.5mm, retira el tornillo M3x10 que sujeta la tapa lateral.
- Remove the cover.

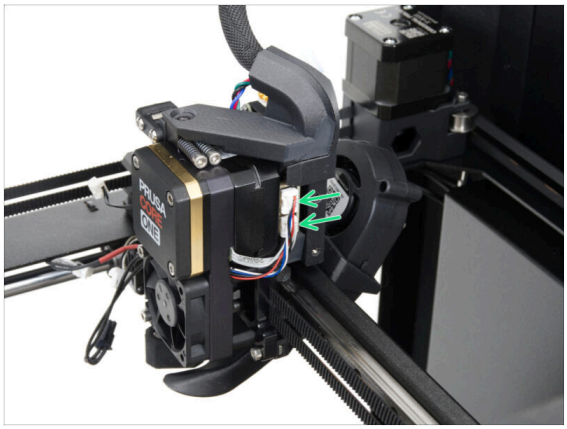
  ⓘ *Pro tip: Keep the screws and nuts with the removed parts whenever possible. This will make reassembly easier.*

⚠ The connectors have a safety latch that **must be pressed when disconnecting**.

- Disconnect all cables on the left side of the Nextruder.
  - Do not disconnect the Nextruder main cable connector.
- Disconnect the extruder motor cable on the top side of the Nextruder.

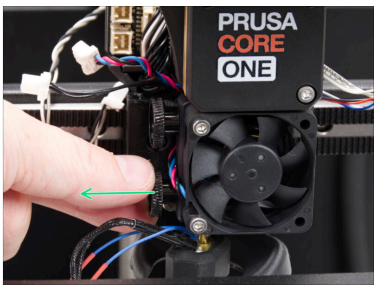
## PASO 15 Disconnecting the Nextruder cables - right side

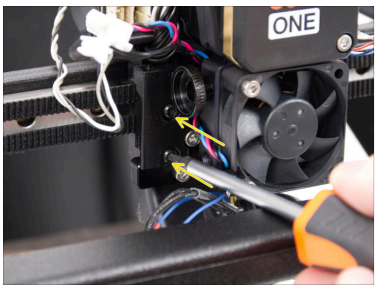


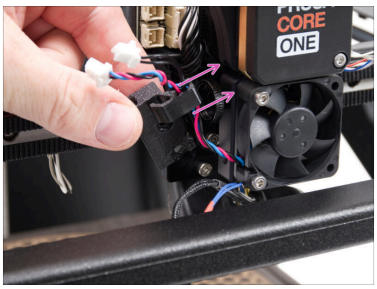




- Using the Allen key, remove two M3x6 screws securing the right cover on the Nextruder.
- Remove the cover.
- ⚠ The connectors have a safety latch that **must be pressed when disconnecting**.
- Disconnect both cables from the right side of the LoveBoard.

## PASO 16 Removing the Cable-clip

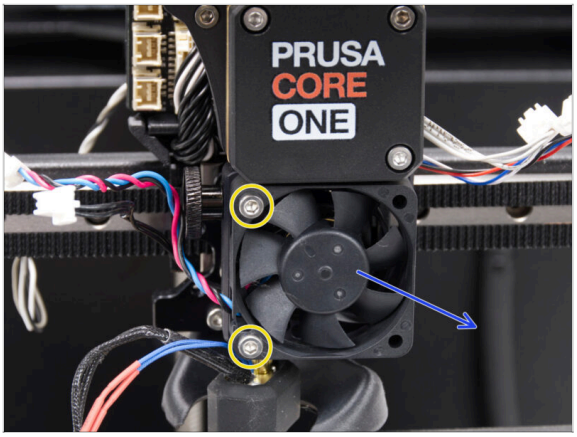


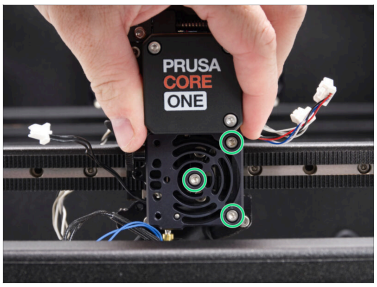

- Remove the lower thumb screw.
  - ⓘ Leave the upper thumb screw in place. It provides access to the screw on the Cable-clip.
- Remove the two M3x4rT screws securing the Cable-clip, then remove the cable clip from the printer.
- Unhook all cables from the cable clip.

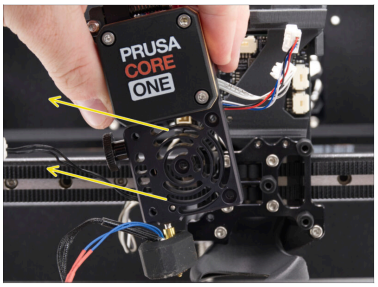
## PASO 17 Detaching the heatsink fan




- Using the Allen key, remove two M3x18 screws securing the heatsink fan.
- Remove the heatsink fan from the printer.

## PASO 18 Removing the Nextruder assembly

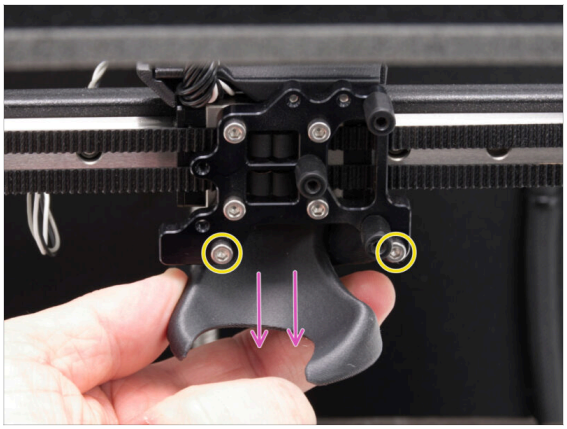


- Remove three M3x10 screws securing the Nextruder assembly to the X-axis.

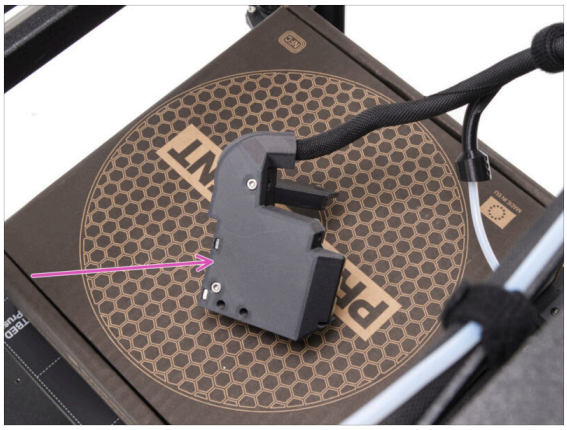
  ⚠ **CAUTION:** While loosening the last screw, **hold the Nextruder to prevent it from falling** and damaging the printer.
- Remove the Nextruder assembly from the printer.
- Set the Nextruder assembly aside in a safe place.

## PASO 19 Desmontando la cubierta del ventilador



- Afloja y retira los dos tornillos M3x10 que fijan la Fan-shroud al soporte del Nextruder.
- Remove the fan shroud assembly with the print fan from the printer.
- Set the print fan assembly aside in a safe place.

## PASO 20 Removing the LoveBoard assembly



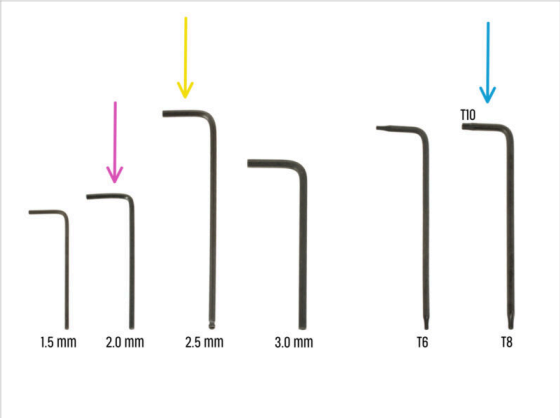
- From the back of the LoveBoard assembly, loosen the two M3x10 screws through the access holes to release the assembly.
  - ⓘ The screws remain inside the assembly.
- Place the LoveBoard assembly on the cardboard box placed on the heatbed.

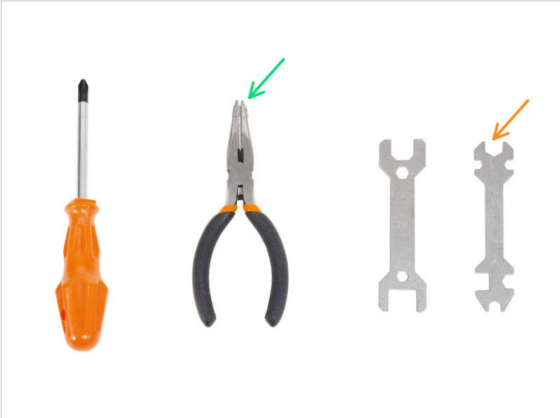
## PASO 21 Chapter completed

- **Congratulations!** You have completed the partial disassembly of the printer and prepared it for the upgrade.
- Proceed to the **next chapter**.

# 3. Belts upgrade

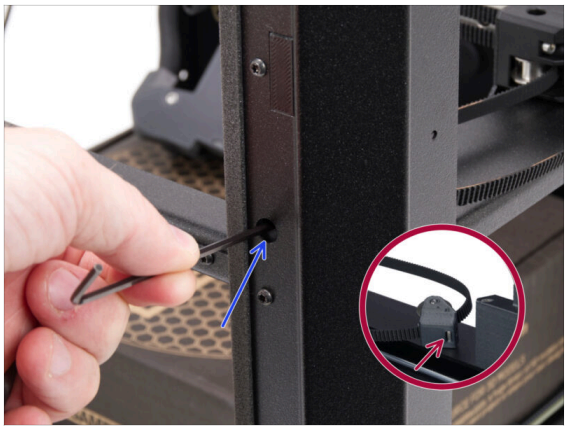
## PASO 1 Tools



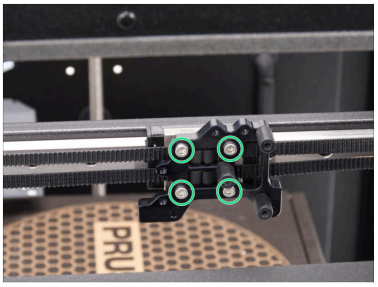
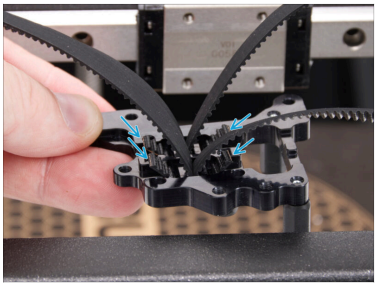
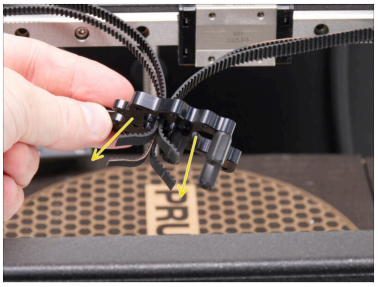
- **Tools necessary for this chapter:**
- 2.0mm Allen key
- 2.5mm Allen key
- T10 key/screwdriver
- Needle-nose pliers
- Universal wrench

## PASO 2 Loosening the belts



- Using a 2.5 mm Allen key, remove the left belt tensioner.
  - Be careful, the tensioner may fall out when loosened.
- Using the same method, loosen the belt tensioner on the right side.
- Ensure the M3nS nuts in the Belt-tensioner-pulleys do not fall out!

## PASO 3 Unlocking the belts

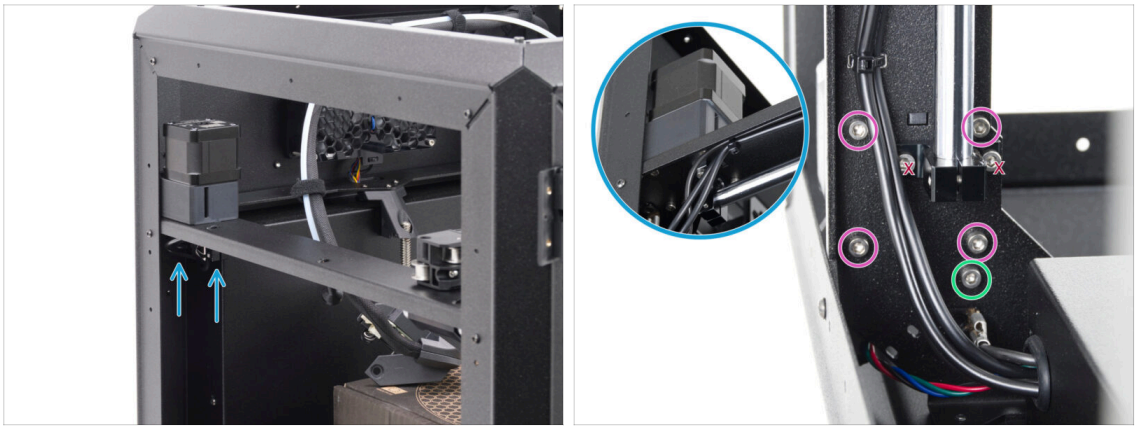
- Remove the four M3x10 screws securing the Nextruder holder.
- From the back of the holder, push all belt ends through the holder.
- Slide the Nextruder holder off the belts.

## PASO 4 Removing the belts

- Remove both belts from the assembly.

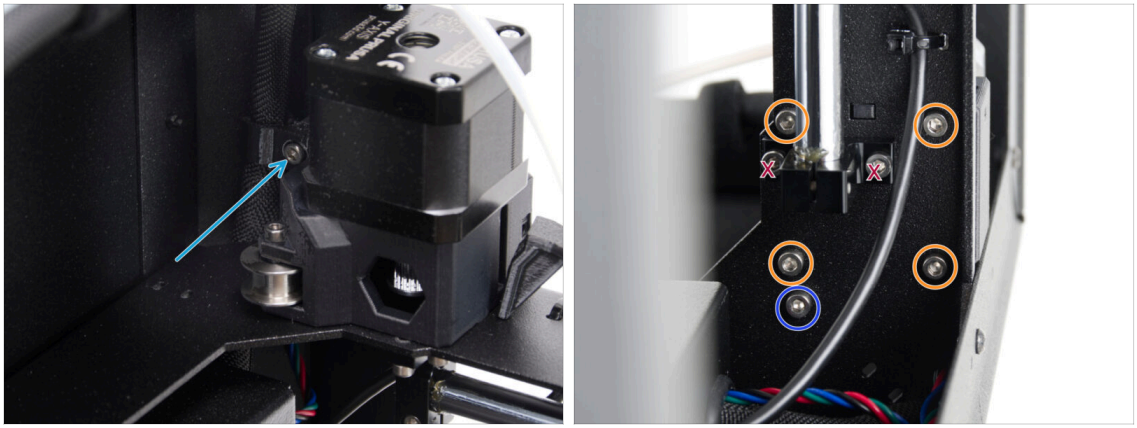
  Caution: The belt tensioner idlers are **still attached to the belts**.

## PASO 5 Releasing the left motor



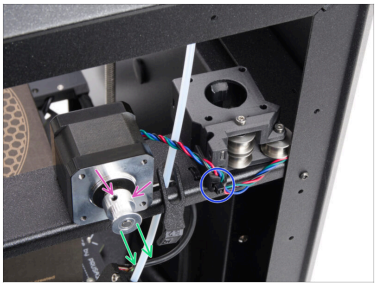
- Move to the underside of the left rear motor.
- Remove the four M3x35 screws securing the motor to the motor holder.
- Remove the M3x6 screw securing the motor holder.
- ⚠ Avoid removing the screws securing the rod holder.

## PASO 6 Releasing the right motor



- Loosen the screw securing the main cable clip and leave it attached to the cable bundle.
  - ⚠ Do not move or reposition the Main-cable-clip on the cable bundle during the upgrade.
- Move to the underside of the right rear motor.
- Remove the four M3x35 screws securing the motor to the motor holder.
- Remove the M3x6 screw securing the motor holder.
- ⚠ Avoid removing the screws securing the rod holder.

## PASO 7 Disassembling the right motor



We recommend **protecting the heatbed during handling.** An empty Prusament box is an ideal protective layer.

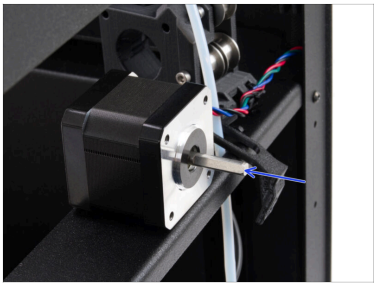
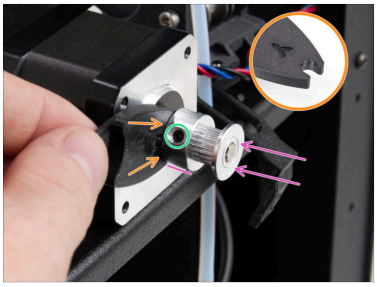
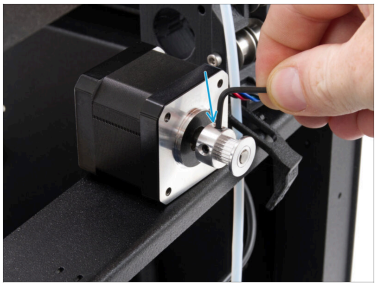
- Focus on the rear-right motor.
- Remove the motor from the motor holder.
- Place the motor on the edge of the printer frame.
- Using a 2.0 mm Allen key, loosen the two set screws securing the pulley.
- Remove the pulley.
- Carefully cut the zip tie securing the motor cable to the motor mount.

This pulley will no longer be used. Set it aside or discard it to **avoid confusing it with the new one**.

## PASO 8 New pulley: parts preparation (right motor)

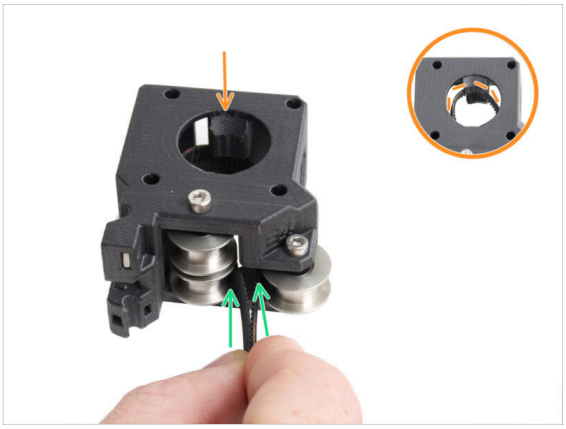
- **Para los siguientes pasos, por favor prepara:**
- T21-1.5GT pulley (1x)
- 1.5GT belt (2x)
- Pulley-offset-tool (1x)

## PASO 9 Installing the new pulley (right motor)

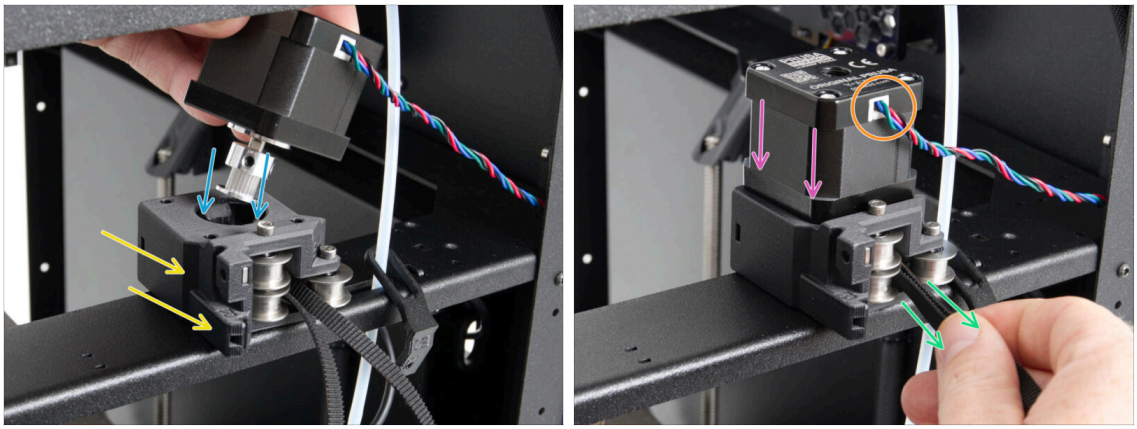
- Rotate the motor shaft so that the flat faces you. **Do not rotate the shaft any further.**
- Slide the new T21-1.5GT pulley onto the end of the shaft, with the set screw side **facing the motor**.
- Insert the Pulley-offset-tool, with the **side marked "Y"**, between the motor and the pulley to set the correct distance.
- Press the pulley against the Pulley-offset-tool and tighten the set screw **against the flat on the motor shaft**.
- Rotate the pulley and tighten the second set screw.

## PASO 10 Inserting the lower belt (right motor)



- Remove the motor mount from the printer.
- Take one of the belts and form a loop with the **teeth facing inward**.
- Push the belt loop into the motor mount **between the two lower idlers**.
- Viewed from the top, the belt loop should follow the circular cutout in the motor mount as closely as possible.

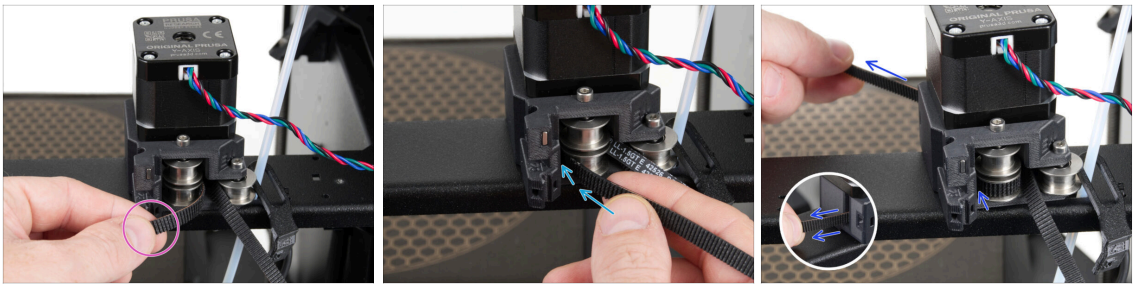
## PASO 11 Securing the lower belt (right motor)



Throughout the process, make sure the **belt does not slip out of the assembly**.

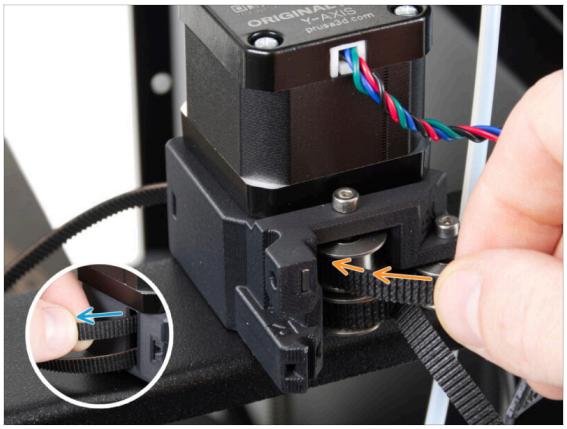
- Place the motor mount onto the printer frame. The side with the two idlers must be facing down and towards you.
- Insert the motor with the pulley into the belt loop inside the motor mount.
- Fully seat the motor against the motor mount.
  - Orient it so that the **motor cable faces outward** (towards you).
- Gently pull both ends of the belts to secure the belt loop around the pulley.

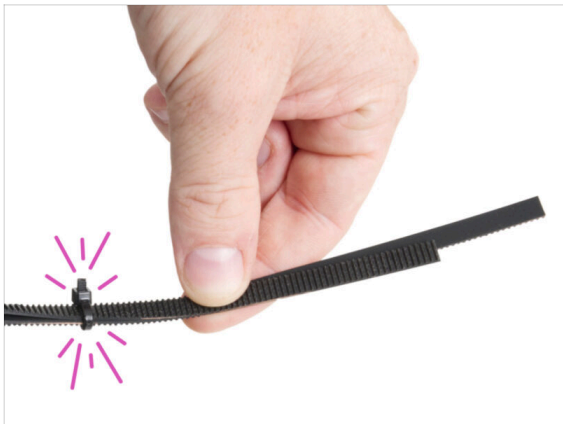
## PASO 12 Guiding the lower belt (right motor)



- Grasp the belt coming from the left idler.
- Route the belt around the idler from the left side and insert it into the motor mount.
- On the opposite side, watch for the belt to come out through the opening and pull it through until approximately 15 cm (6 in) is sticking out.

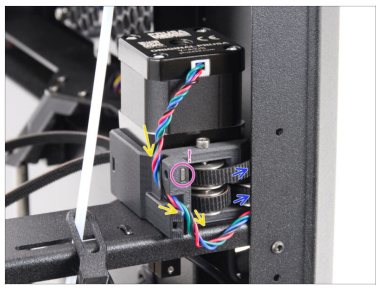
## PASO 13 Guiding the upper belt (right motor)

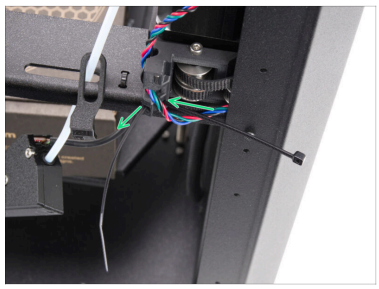


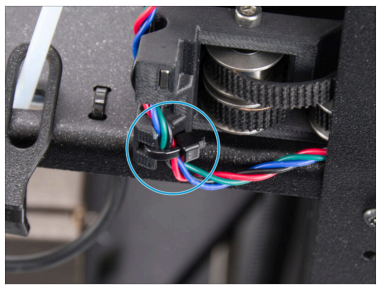



- Take the second new belt.
- Route one end of the belt around the **upper idler** from the left side. Make sure the **teeth face away** from the idler.
- From the opposite side, watch for the belt to come out through the opening.
  - Pull it through until approximately the same length of belt is sticking out - around 15 cm (6 in).
- *Pro tip:* To prevent the belts from being accidentally pulled out, loosely secure their ends together with a zip tie.

## PASO 14 Securing the motor cable (right motor)



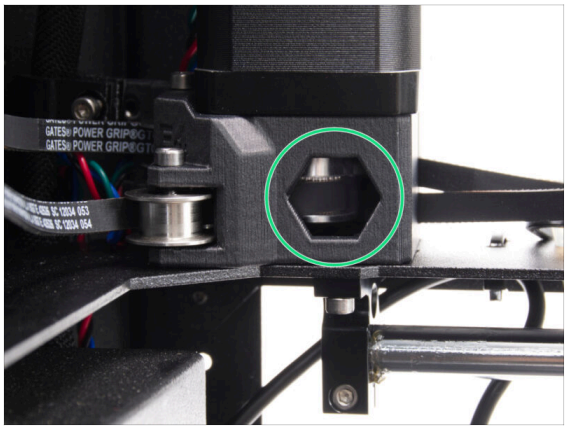




Throughout the process, **make sure the belts do not slip out of the assembly**.

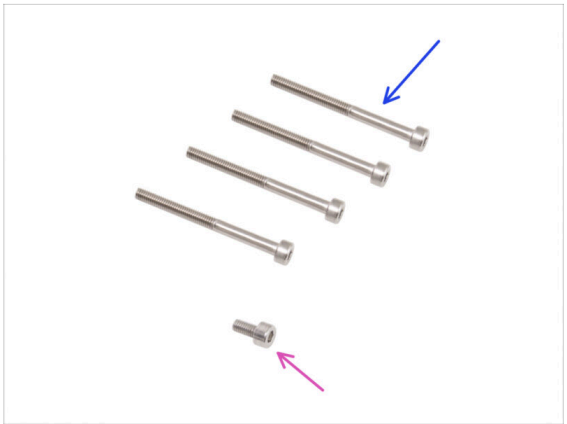
- Move the assembly closer to the rear corner of the printer.
- Route the free ends of the belts toward the rear of the printer. Leave them loose for now.
- Make sure the M3nN nut **is still inserted** in the motor mount and has not fallen out.
  - **If the M3nN nut has fallen out**, reinsert it fully into the part.
- Route the motor cable through the cable channel, as shown in the picture.
- Push the zip tie through the hole in the printed part.
- Carefully secure the cable with the zip tie.

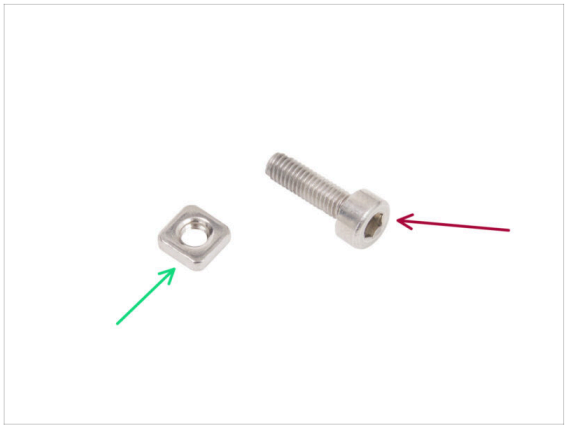
## PASO 15 Fixing the right motor



- Rotate the motor assembly with the motor mount into the correct position. The **belt pulleys must face the rear side** of the printer.
  - The motor mount has a tab on the bottom side that must fit into the rectangular cutout in the frame.
- From the inner side of the printer, check that the lower belt is seated on the pulley throught the hexa hole in the motor-mount.

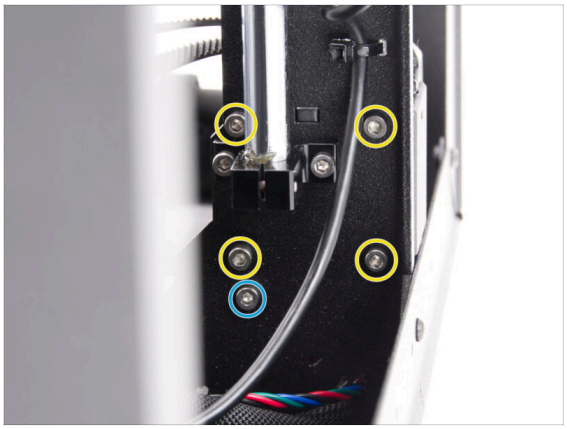
## PASO 16 Right motor screws: parts preparation

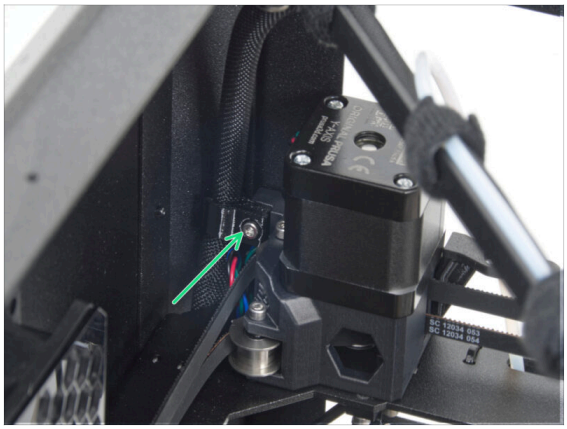




- **For the followings steps, please prepare:**
- M3x35 screw (4x) *you removed earlier*
- M3x6 screw (1x) *you removed earlier*
- M3nS nut (1x) you removed earlier*may have remained inserted from the outer side of the motor mount.*
- Tornillo M3x10 (1x) *que quitaste antes*

## PASO 17 Tightening the right motor

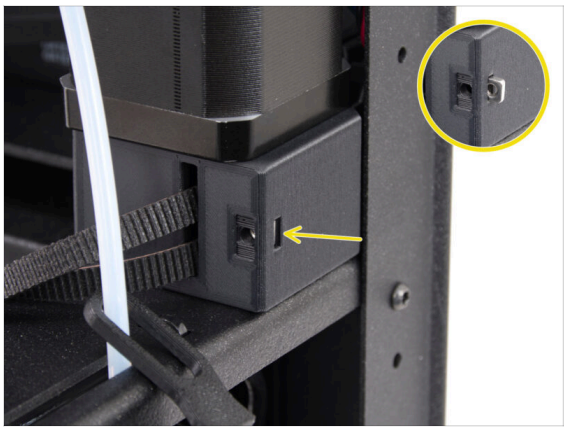


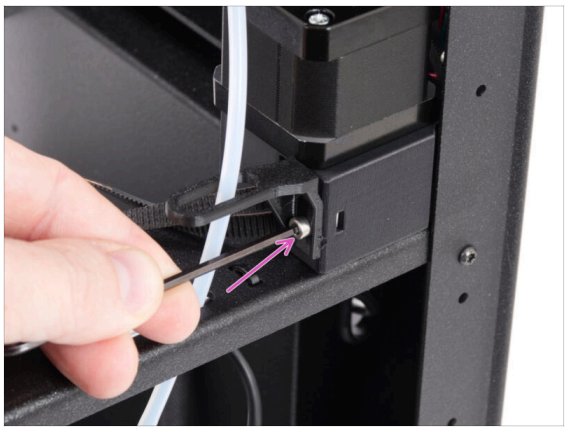


- Secure the entire motor assembly from the bottom side of the frame using four M3x35 screws.
- Finally, secure the motor mount with an M3x6 screw.

  ⚠ **Do not overtighten the M3x6 screw.** The screw is secured directly into a plastic part and excessive tightening can damage the thread.
- From the top side, behind the motor, attach the Main-cable-clip back to the motor mount using the pre-inserted M3x10 screw.

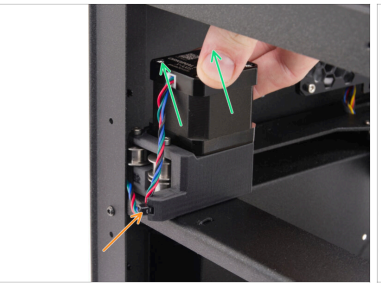
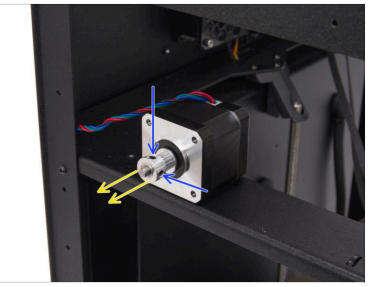
## PASO 18 Securing the Bowden-guide





- From the outer side of the motor mount, insert the M3nN nut if it is not already inserted.
- Attach the Bowden-guide to the motor-mount using the M3x10 screw.

## PASO 19 Disassembling the left motor

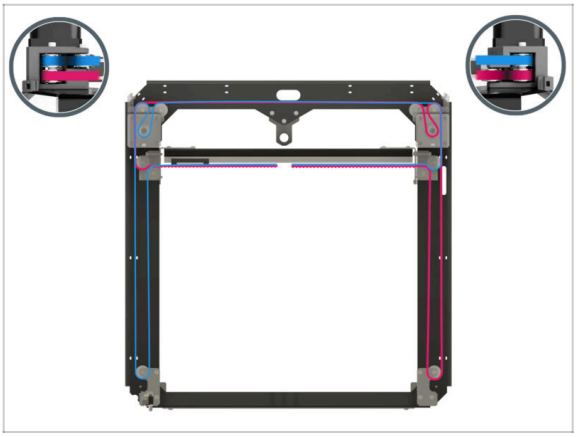
- Focus on the rear-left motor.
- Rotate the motor assembly with the cable facing outward.
- Carefully cut the zip tie. Be careful not to cut the cable.
- Remove the motor from the motor-mount and remove the motor-mount from the printer.
- Place the motor on the printer frame.
- Using a 2.0 mm Allen key, loosen the two set screws securing the pulley.
- Remove the pulley.

This pulley will no longer be used. Set it aside or discard it to **avoid confusing it with the new one**.

## PASO 20 New pulley: parts preparation (left motor)

- **Para los siguientes pasos, por favor prepara:**
- T21-1.5GT pulley (1x)
- Pulley-offset-tool (1x) *you used it before*

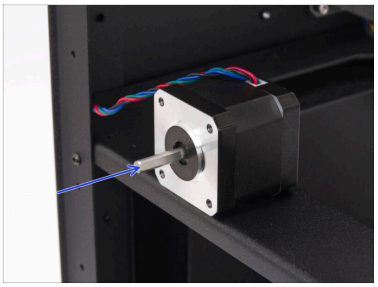
## PASO 21 Belt routing overview

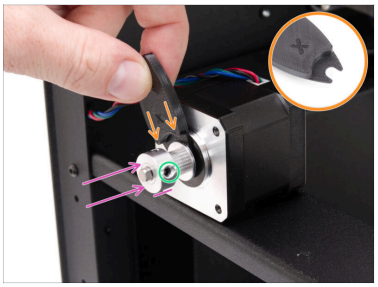


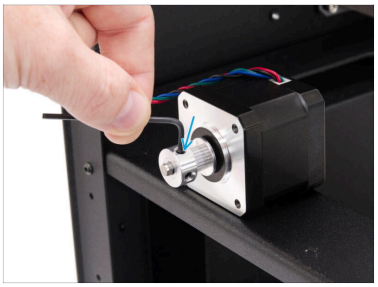
Before routing the belts, familiarize yourself with their path through the CoreXY mechanism.

- The following diagrams show the routing of the upper and lower belts and their orientation within the assembly.
  - Upper belt path
  - Lower belt path
- **Do not perform any actions in this step.**

## PASO 22 Installing the new pulley (left motor)

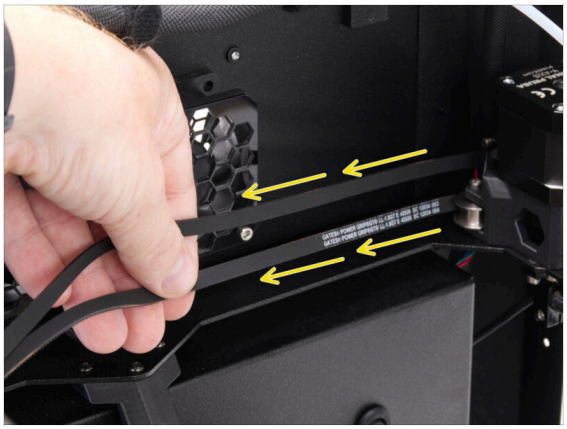


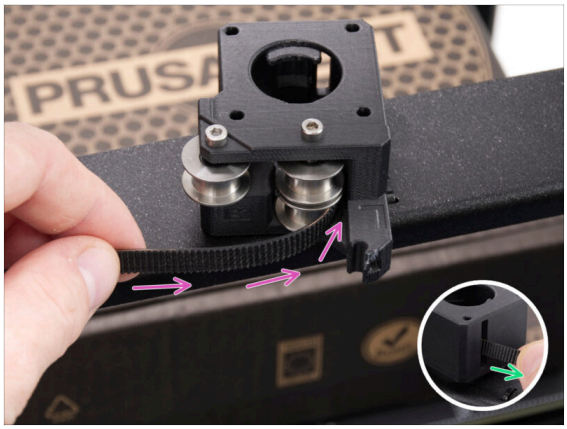




- Rotate the motor shaft so that the flat faces you. **Do not rotate the shaft any further.**
- Slide the new T21-1.5GT pulley onto the shaft, with the set screw side facing **away from the motor**.
- Insert the Pulley-offset-tool, with the side marked "X", between the motor and the pulley to set the correct distance.
- Press the pulley against the Pulley-offset-tool and tighten the set screw **against the flat on the motor shaft**.
- Rotate the pulley and tighten the second set screw.

## PASO 23 Guiding the lower belt (left motor)

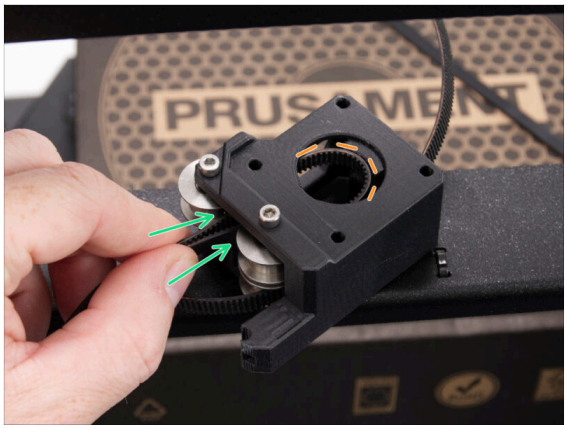




- Route both belts from the right motor towards the rear side of the printer and guide them to the left motor.
- Place the motor-mount onto the printer frame with the side containing one pulley facing downward.
- Route the **lower belt** around the lower idler from the right side.

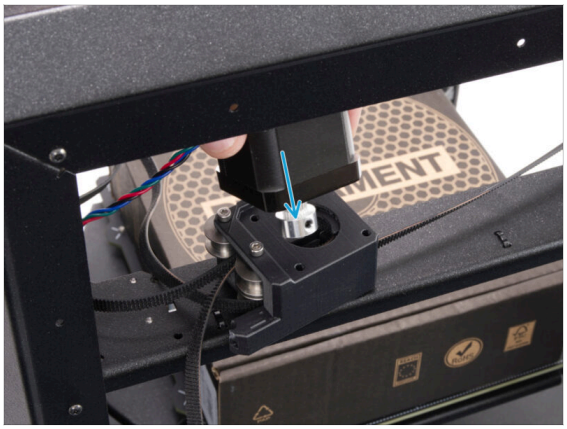
  ⚠ **Make sure you are holding the lower belt** coming from the right motor. **The belt must not be twisted along its path.**
- From the opposite side, pull the belt out approximately 15 cm (6 in).

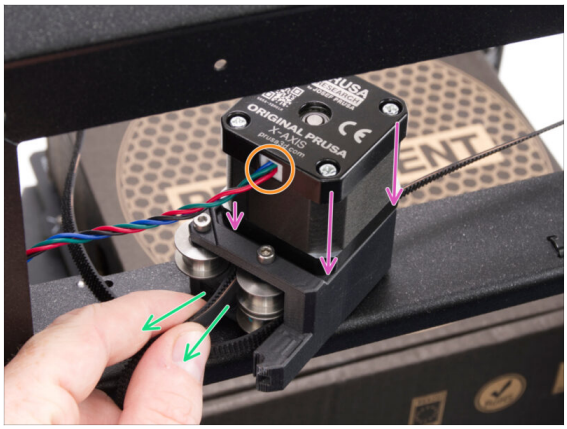
## PASO 24 Inserting the upper belt (left motor)



- Take the **upper belt** and form a loop with the **teeth facing inward**.
- Push the belt loop into the motor mount **between the two upper pulleys**.
- Viewed from the top, the belt loop should follow the circular cutout in the motor mount as closely as possible.

## PASO 25 Securing the upper belt (left motor)

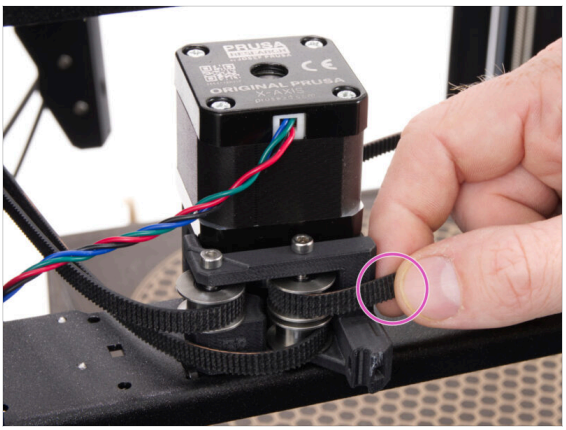


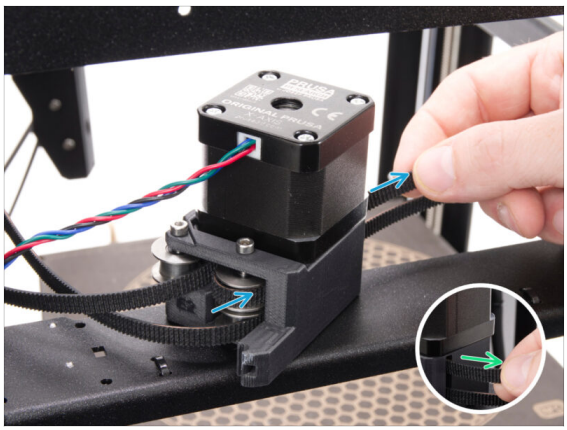



Throughout the process, make sure the **belt does not slip out of the assembly**.

- Insert the motor with the pulley into the belt loop inside the motor mount.
- Fully seat the motor against the motor mount.
  - Orient it so that the motor cable faces backward (towards the pulleys).
- Gently pull both ends of the belts to secure the belt loop around the pulley.

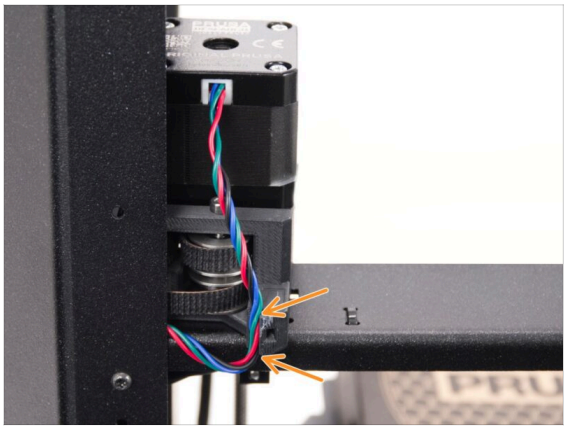
## PASO 26 Guiding the upper belt (left motor)

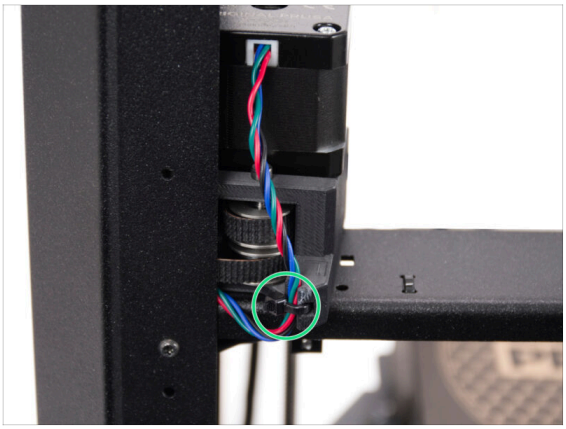




- Grasp the right belt coming from the upper pulley.
- Route the belt around the upper right pulley **from the right side** and insert it into the motor mount.
- On the opposite side, watch for the belt to come out through the opening and pull it through until approximately 15 cm (6 in) is sticking out.

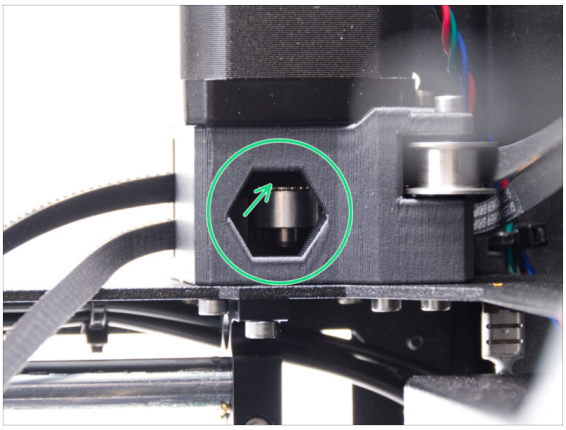
## PASO 27 Securing the motor cable (left motor)





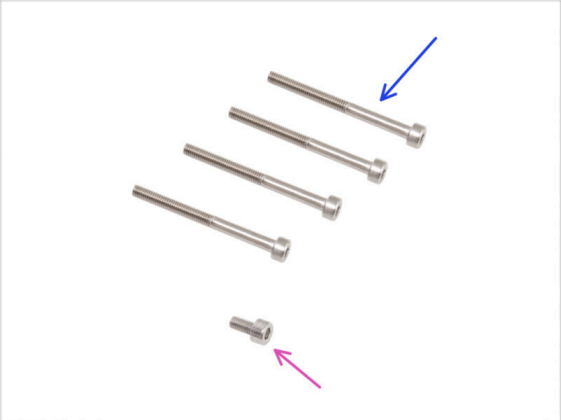
- Move the assembly closer to the rear corner of the printer.
- Route the motor cable through the cable channel, as shown in the picture.
- Push the zip tie through the hole in the printed part. And carefully secure the cable with the zip tie.

## PASO 28 Fixing the left motor



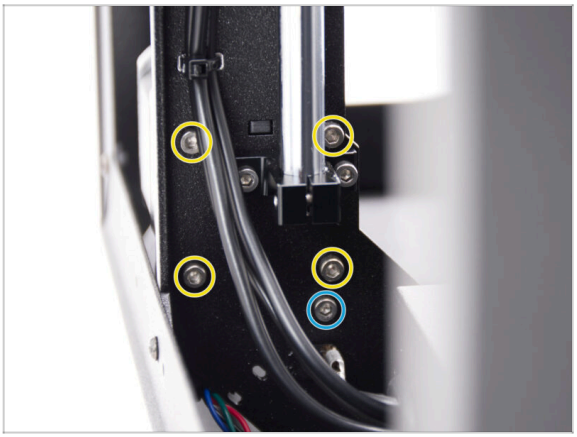
- Rotate the motor assembly with the motor mount into the correct position. The **belt idlers must face the rear side** of the printer.
  - The motor mount has a tab on the bottom side that must fit into the rectangular cutout in the frame.
- From the inner side of the printer, check that the upper belt is seated on the idler throught the hexa hole in the motor-mount.

## PASO 29 Belt tensioner pulleys: parts preparation



- **Para los siguientes pasos, por favor prepara:**
- M3x35 screw (4x) *you removed earlier*
- M3x6 screw (1x) *you removed earlier*
- Belt tensioner assembly (2x) *you removed earlier*

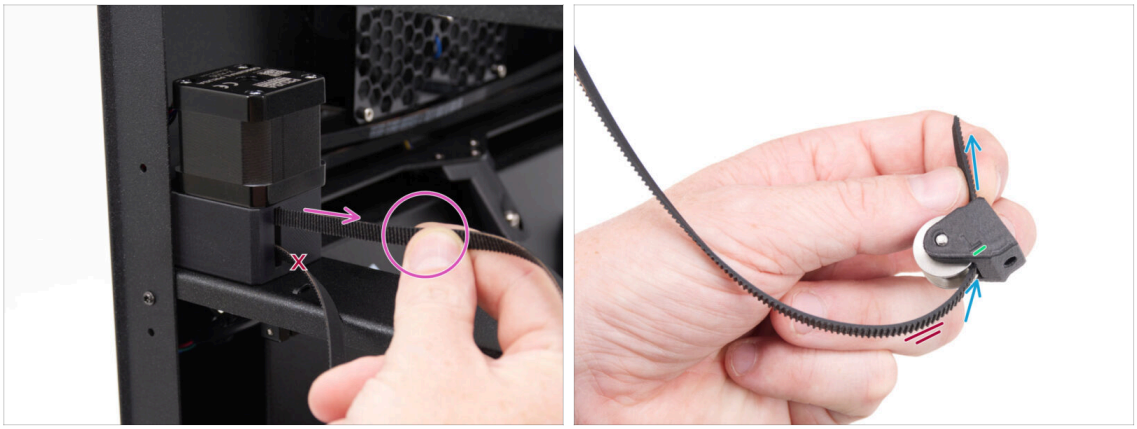
## PASO 30 Tightening the left motor



- Secure the entire motor assembly from the bottom side of the frame using four M3x35 screws.
- Finally, secure the motor mount with an M3x6 screw.

⚠ **Do not overtighten the M3x6 screw.** The screw is secured directly into a plastic part and excessive tightening can damage the thread.

## PASO 31 Guiding the upper belt (left side)



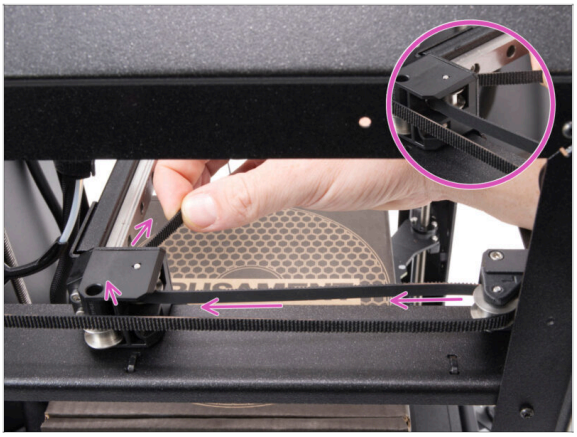
- Take the **upper** belt coming from the left motor.
- **Route the belt around the idler so that:**
  - The "L" (left) mark on the idler faces upward
  - The toothed side of the belt does not contact the idler

⚠ The belt must not be twisted along its path.

## PASO 32 Attaching the left belt tensioner

- Insert the idler with the belt wrapped around it into the "rails" of the left tensioner.
- From the opposite side, tighten the pre-inserted screw until the idler assembly starts to move.
- Stop tightening when the sliding part is flush with the stationary part.

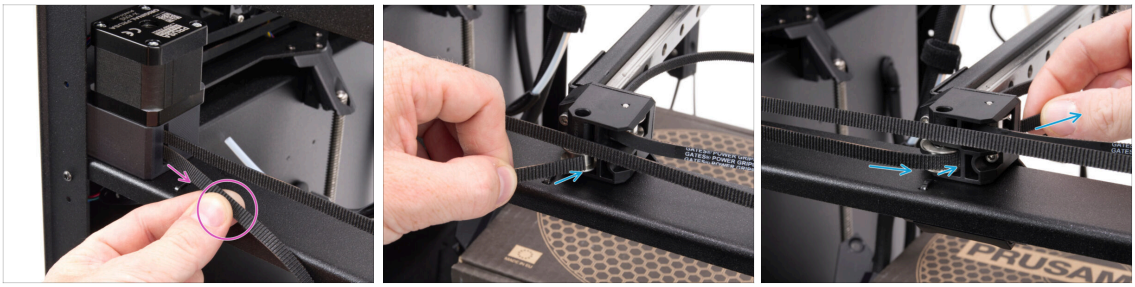
## PASO 33 Guiding the upper belt (gantry - left)



- Route the free end of the belt coming from the idler around the upper idler on the XY gantry.

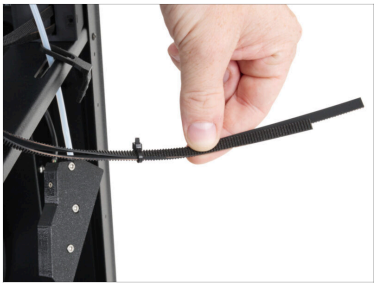
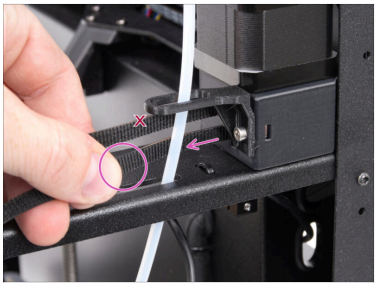
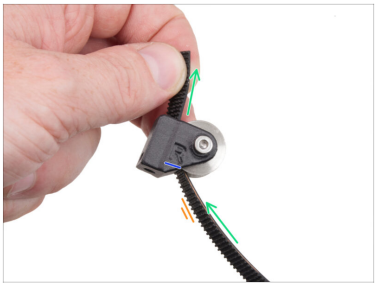
ⓘ The XY gantry idlers may differ visually between printer versions. The procedure is identical for both 3D-printed and injection-molded parts.

## PASO 34 Guiding the lower belt (gantry - left)



- Take the lower belt coming from the left motor.
- Route it towards the XY gantry and around the lower idler.
  - From the opposite side, pull the belt through until at least 8 cm (3 in) is sticking out.

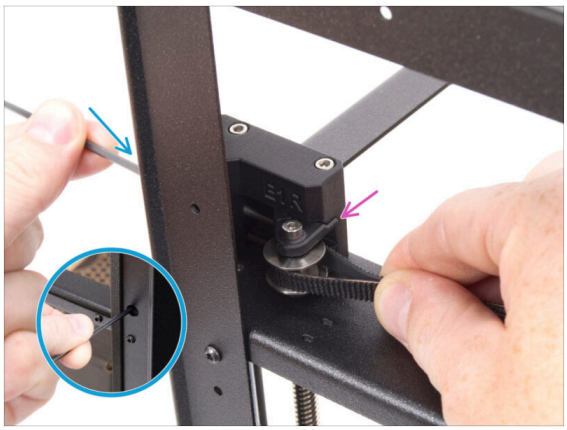
## PASO 35 Guiding the lower belt

- Move to the right motor.
- Remove the zip tie securing the two free belt ends on the right side of the printer, if you used one.
- Take the **lower** belt coming from the right motor.
- **Route the belt around the idler so that:**
  - The "R" (right) mark on the idler faces upward
  - The toothed side of the belt does not contact the idler

⚠ The belt must not be twisted along its path.

## PASO 36 Attaching the right belt tensioner



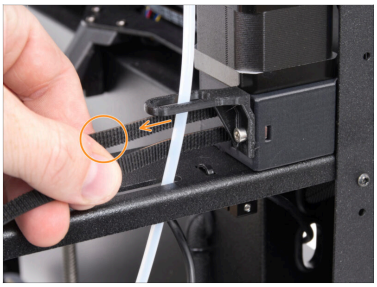
- Insert the idler with the belt wrapped around it into the "rails" of the right tensioner.
- From the opposite side, tighten the pre-inserted screw until the idler assembly starts to move.
- Stop tightening when the sliding part is flush with the stationary part.

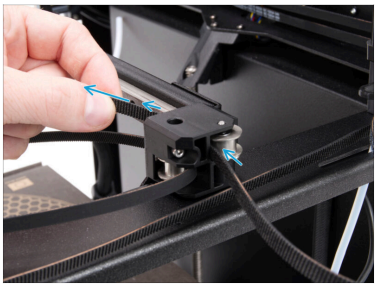
## PASO 37 Guiding the lower belt (gantry - right)

- Route the free end of the belt coming from the idler around the lower idler on the XY gantry.
  - From the opposite side, pull the belt through until at least 8 cm (3 in) is sticking out.

ⓘ The XY gantry idlers may differ visually between printer versions. The procedure is identical for both 3D-printed and injection-molded parts.

## PASO 38 Guiding the upper belt (gantry - right)

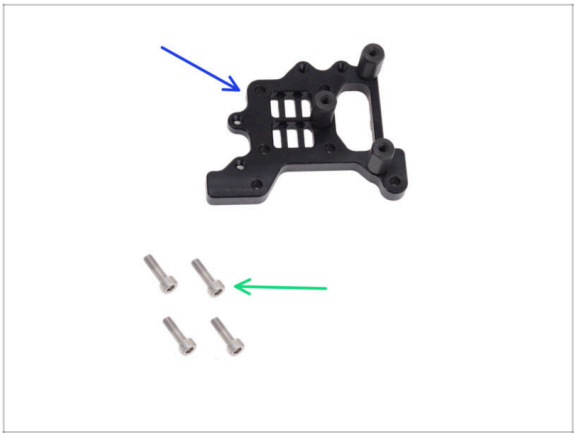




- Take the upper belt coming from the right motor.
- Route the belt around the upper idler on the XY gantry.
  - From the opposite side, pull the belt through until at least 8 cm (3 in) is sticking out.

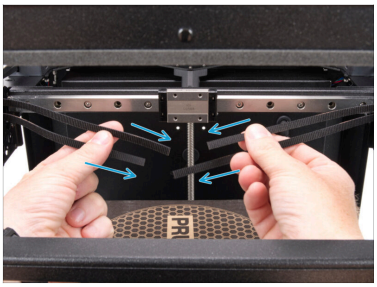
If you are assembling the Prusa INDX along with the GEN 2 upgrade, **return to the Prusa INDX GEN 2 article now**.

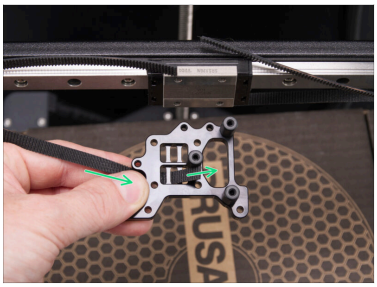
## PASO 39 Nextruder holder: parts preparation

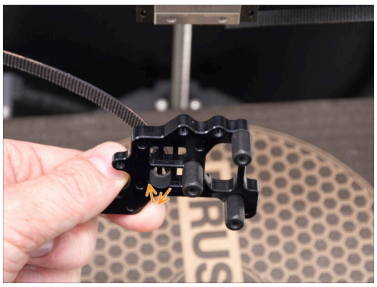


- **For the follwing steps, pelase prepare:**
- Nextruder holder assembly (1x) *you removed earlier*
- Tornillo M3x10 (4x) *que quitaste antes*

## PASO 40 Securing the belts I.

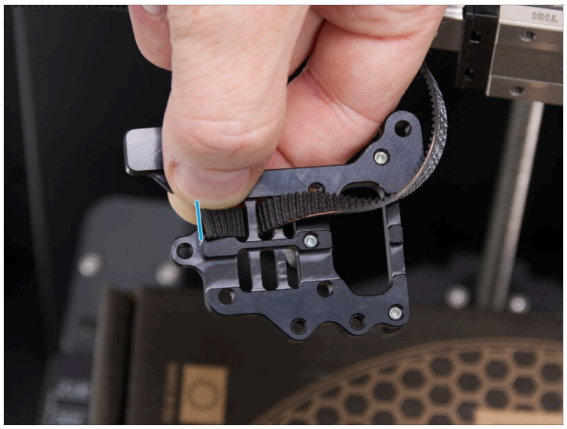
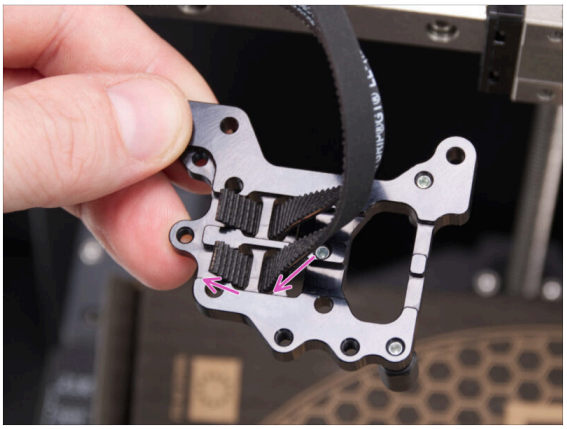






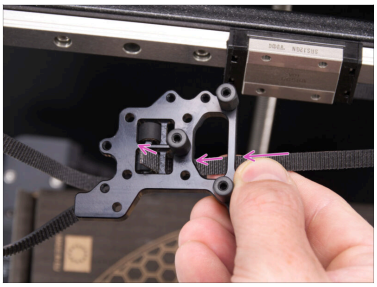
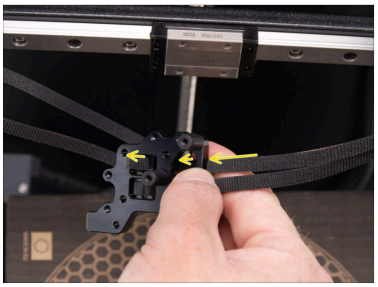
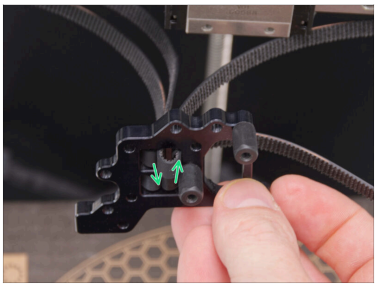
- Gently pull all belt ends towards the center of the printer.
- Keep the Nextruder holder in the same orientation as shown in the picture.
- Route the **lower left** belt through the center opening of the Nextruder holder from the rear side to the front.
  - Pull the belt out so that approximately 15 mm protrudes.
- From the front side of the Nextruder holder, route the belt back through the left opening towards the rear.

## PASO 41 Securing the belts II.

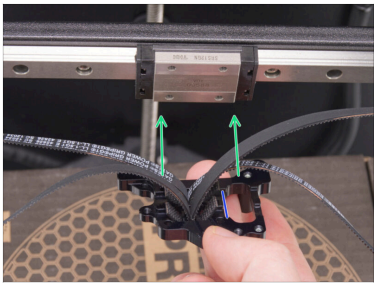
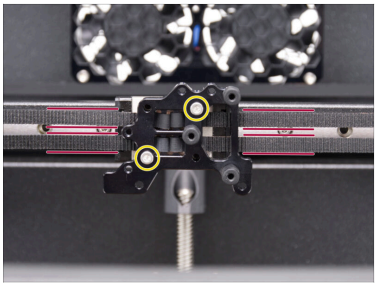
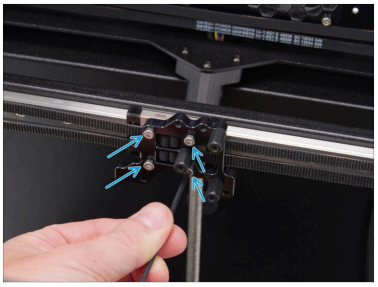
- From the rear side, place the belt end against the Nextruder holder.
  - Adjust the belt length so that the belt end is **flush with the edge** of the Nextruder holder.
- Repeat the same procedure for the **upper left** belt.

## PASO 42 Securing the belts III.

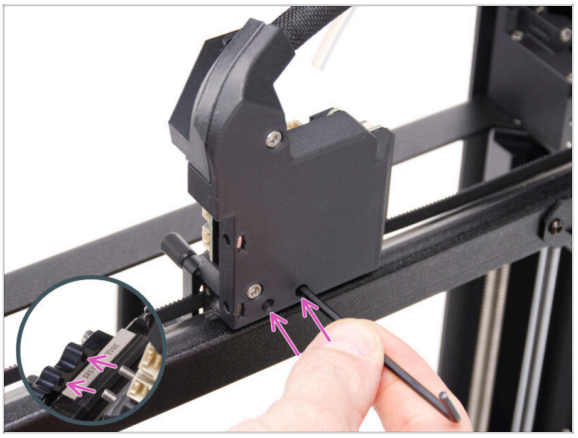
- From the rear side, route the **lower belt coming from the right** side through the center opening of the Nextruder holder.
  - Pull out approximately 15 mm of the belt.
- Route the upper right belt through the rear side of the Nextruder holder.
- Bend both right-side belts and route them back through the right opening of the Nextruder holder.

## PASO 43 Attaching the Nextruder holder

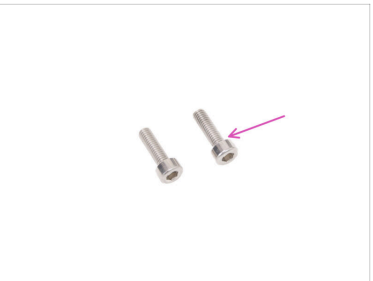
- Align the right-side belts with the edge of the Nextruder holder and adjust their length if needed.
- Align the Nextruder holder with the X-carriage. The Nextruder holder is attached from the belt side.
- Attach the Nextruder holder to the X-carriage and lightly secure it using one upper and one lower M3x10 screw.
- Check that all belts run straight and are not twisted.
- Insert the remaining two M3x10 screws and tighten all four screws firmly.

## PASO 44 Installing the LoveBoard assembly



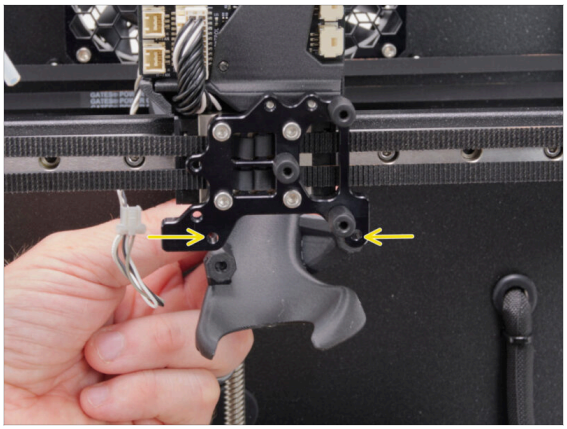
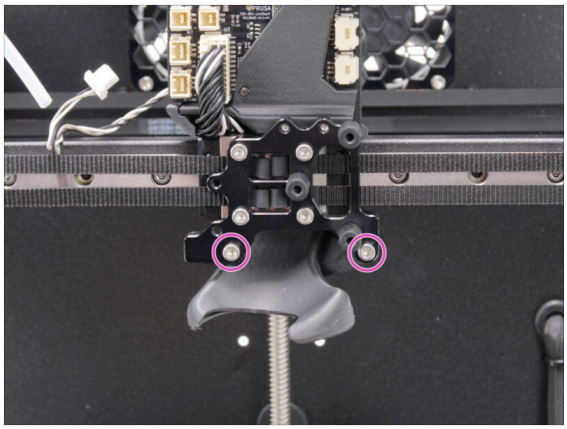
- Look at the rear side of the Nextruder holder.
- Attach the LoveBoard assembly to the rear side of the Nextruder holder while it is resting on the box.
  - The LoveBoard assembly has two pre-inserted screws. Align them with the holes in the Nextruder holder and tighten them using a 2.5 mm Allen key.

## PASO 45 Fan shroud assembly: parts preparation



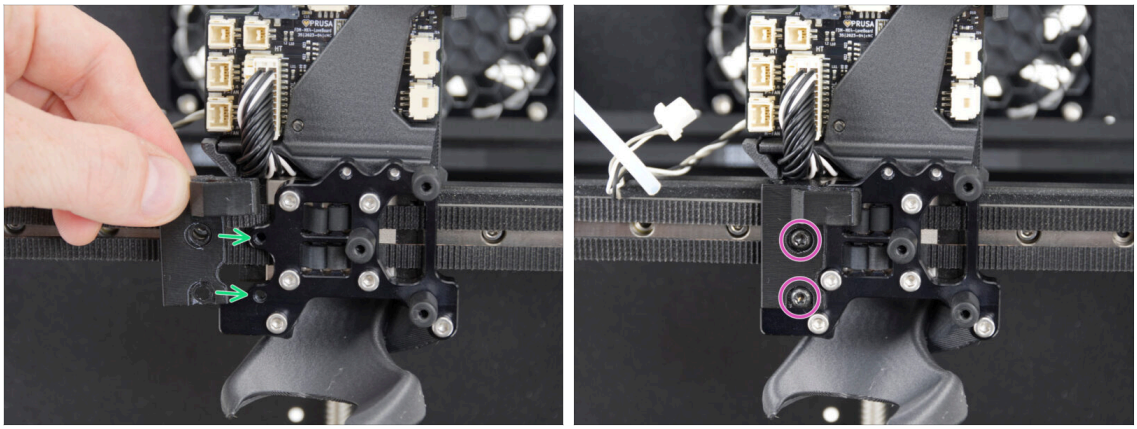
- **Para los siguientes pasos, por favor prepara:**
- Fan shroud assembly (1x) *you removed earlier*
- Tornillo M3x10 (2x) *que quitaste antes*
- Cable-clip (1x) *you removed earlier*
- M3x4rT screw (2x) *you removed earlier*

## PASO 46 Attaching the fan shroud assembly

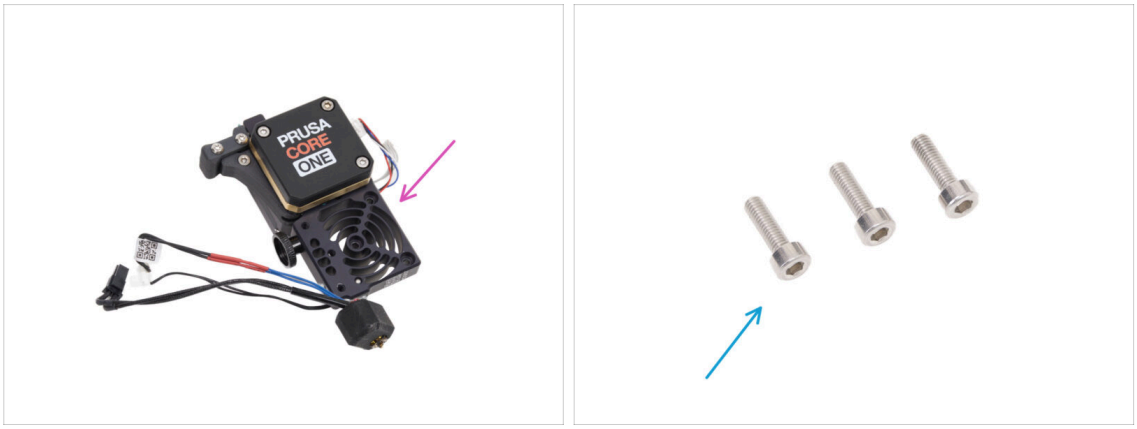
- From the rear side of the Nextruder holder, place the fan shroud assembly and align it with the holes.
- Secure the assembly using two M3x10 screws.

## PASO 47 Installing the Cable-clip



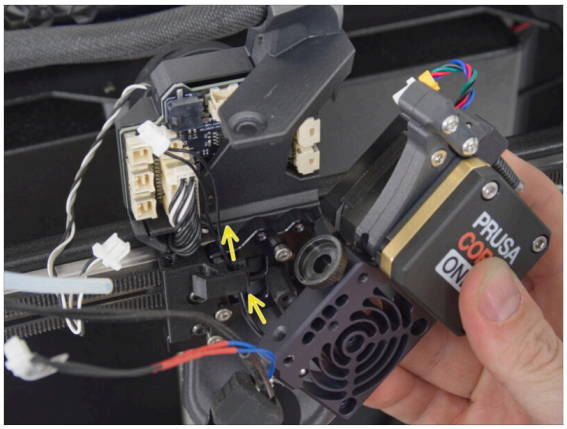
- From the front side of the Nextruder holder, place the Cable-clip in the orientation shown in the picture and align it with the holes.
- Secure the Cable-clip using two M3x4rT screws and tighten them using a T10 key.

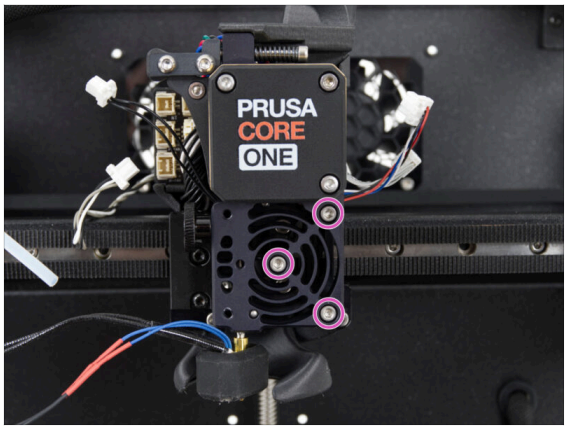
## PASO 48 Montaje nextruder: preparación de las piezas




- **Para los siguientes pasos, por favor prepara:**
- Nextruder assembly (1x) *you removed earlier*
- M3x10 screw (3x) *you removed earlier*

## PASO 49 Attaching the Nextruder assembly

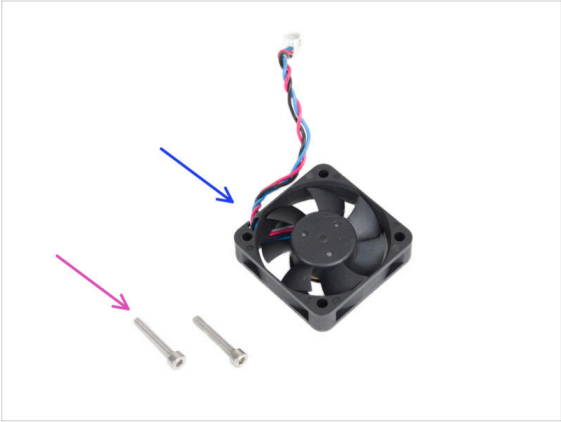





- Take the Nextruder assembly and position it against the Nextruder holder.
- Hook the NTC thermistor cable coming from the rear side of the heatsink into the right side of the Cable-clip.
- Place the Nextruder onto the Nextruder holder spacers, align it, and secure it using three M3x10 screws.

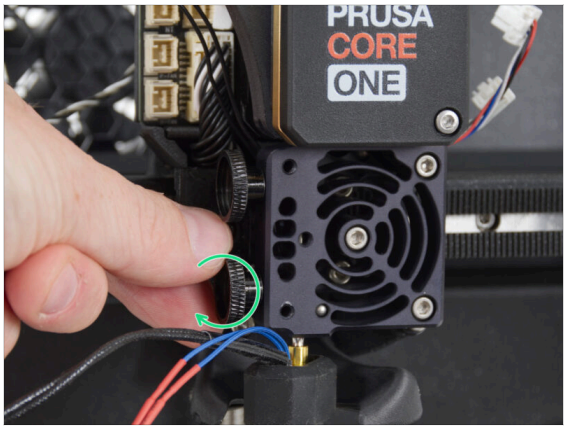
  ⚠ **Do not overtighten the screws.** The spacers are made of plastic and can be damaged by excessive tightening.

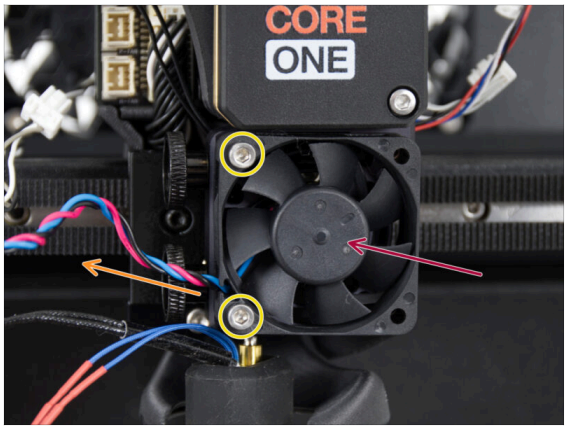
## PASO 50 Heatsink fan: parts preparation



- **For the following steps, pelase prepare:**
- Heatsink fan (1x) *you removed earlier*
- M3x20 screw (2x) *you removed earlier*
- Thumbs screw (1x) *you removed earlier*

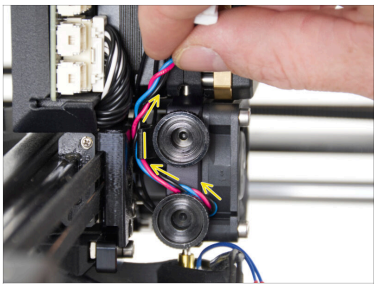
## PASO 51 Mounting the heatsink fan

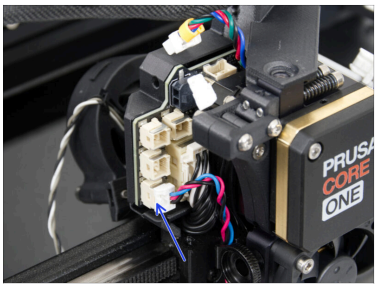


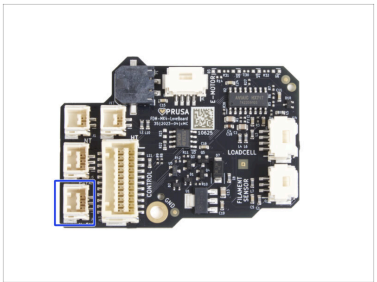




- Screw the thumb screw back into the side of the Nextruder heatsink and tighten it firmly by hand.
- Attach the Nextruder heatsink fan using two M3x20 screws.
  - The fan must face outward with the side **without the sticker facing out**.
  - The heatsink cable must exit from the **lower-left corner**.

## PASO 52 Connecting the heatsink fan

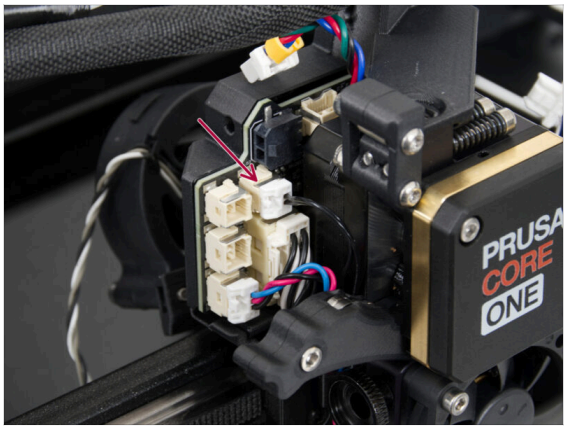


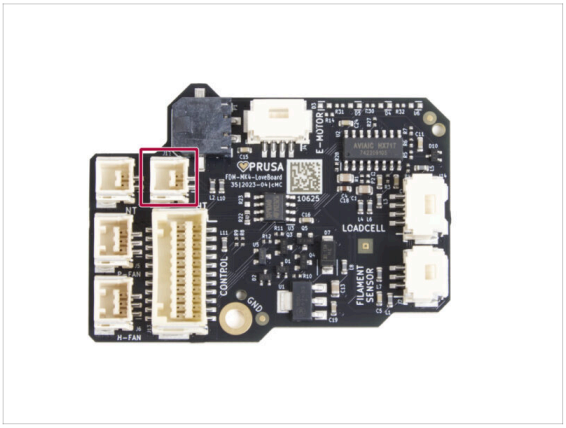


- Route the heatsink fan cable above the lower thumb screw through the Cable-clip.
- Connect it to the lowest connector on the LoveBoard.

## PASO 53 Conectando el termistor NTC

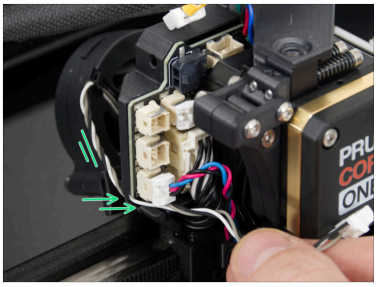


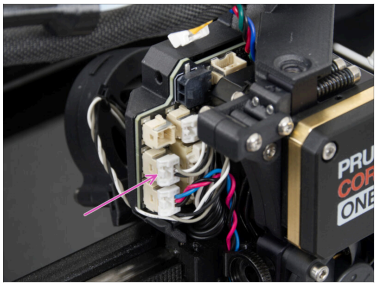



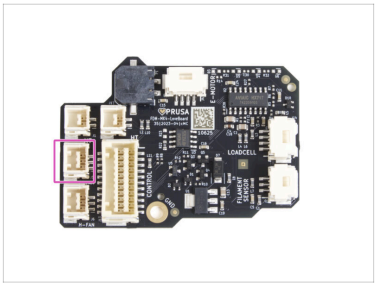

- Connect the heatsink thermistor to the upper right connector.

ⓘ For better access, you can release the tensioning mechanism of the idler.

## PASO 54 Conectando el ventilador de capa

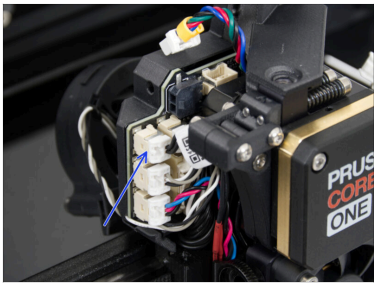


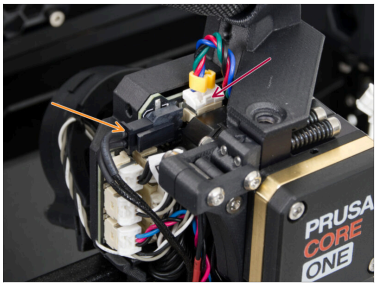


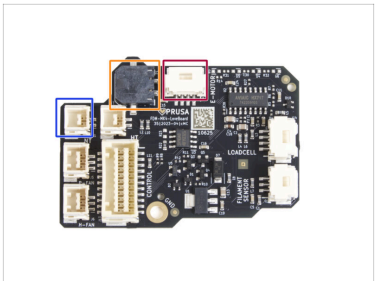


- Guide the print fan cable through the cable channel.
  - The cable should **not be stretched too tightly**.
- Plug the print fan cable to the middle conenctor in the left row on the LoveBoard.

## PASO 55 Connecting the hotend cables and motor

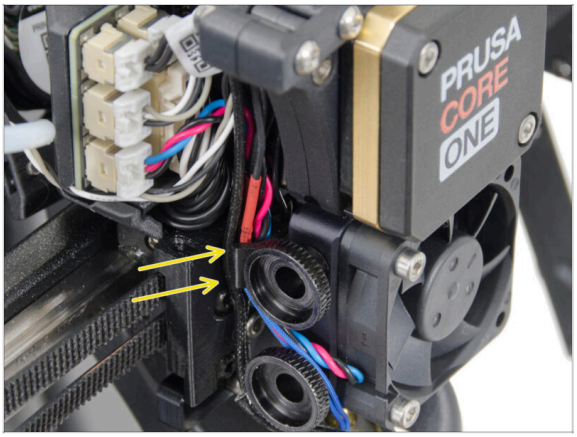


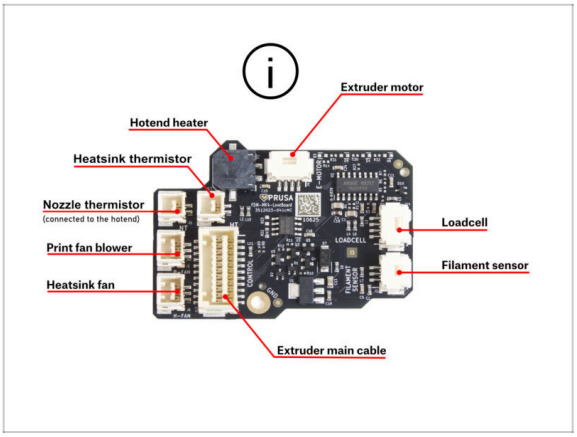
- Connect the nozzle thermistor cable to the top connector in the left row.
- Connect the hotend heater cable to the black connector at the top.
- Connect the extruder motor cable (E) to the topmost connector.

## PASO 56 Guiando los cables del fusor



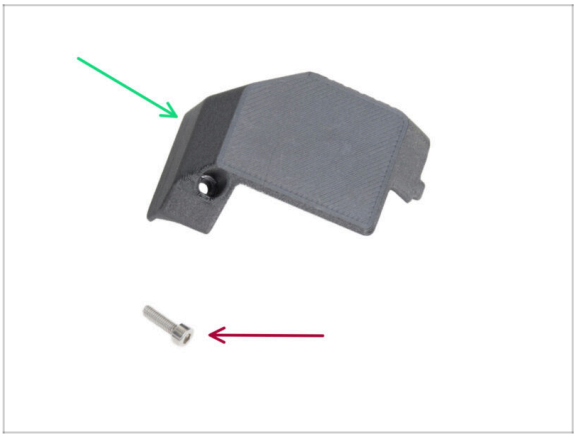

- Hook both hotend cables into the Cable-clip.
  - Hook the thermistor cable first, followed by the heater cable.

## PASO 57 Wiring check



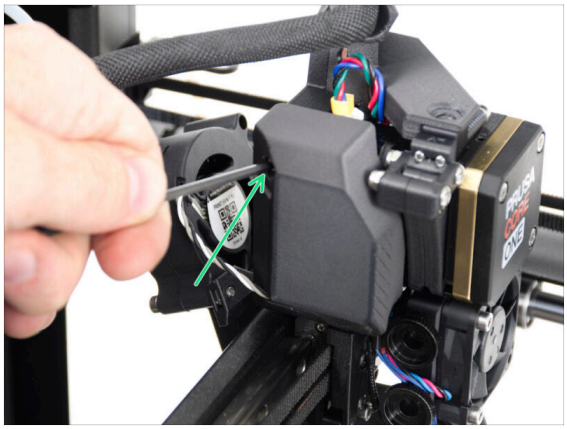

Before closing the Nextruder electronics, perform a final inspection according to the wiring diagram.

## PASO 58 Print-head-cover-left: parts preparation



- **Para los siguientes pasos, por favor prepara:**
- Printhead-cover-left (1x) *you removed earlier*
- M3x10 screw (1x) *you removed earlier*

## PASO 59 Covering the electronics - left side

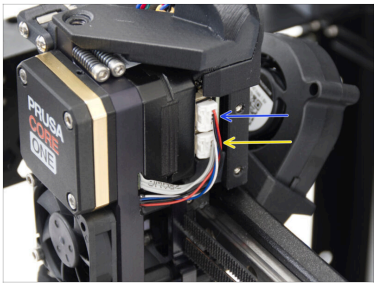


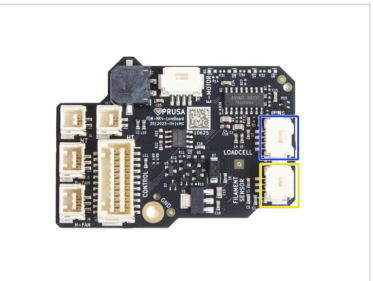

- Place the Printhead-cover-left onto the left side of the Nextruder.
  - Insert the tab into the opening first.
  - Then secure the top of the cover using an M3x10 screw.

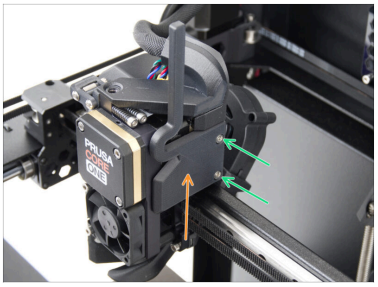
## PASO 60 Print-head-cover-right: parts preparation

- **Para los siguientes pasos, por favor prepara:**
- Printhead-cover-right-lever (1x) *you removed earlier*
- M3x6 screw (2x) *you removed earlier*
- Fitting M4-5 (1x) *you removed earlier*

## PASO 61 Connecting the loadcell and FS





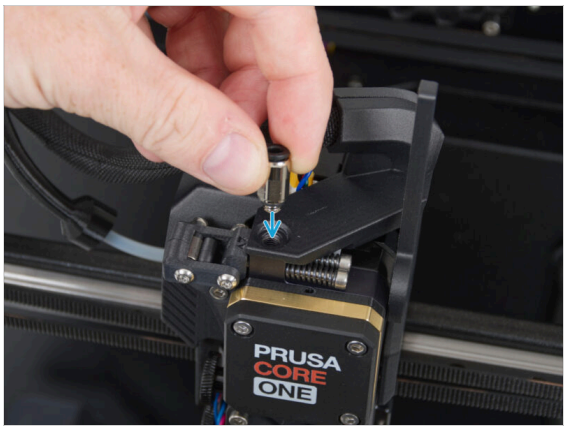


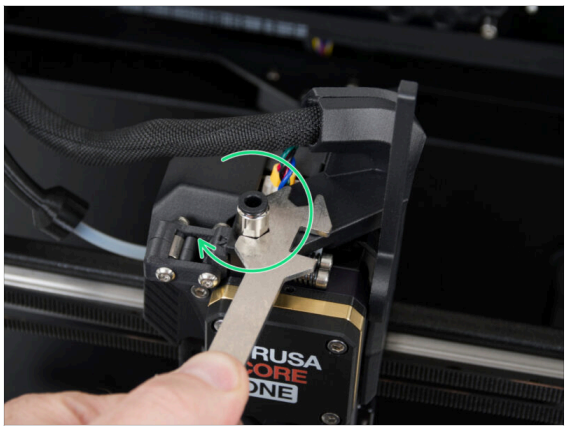

- Plug the Loadcell cable to the upper connector on the right side of the Nextruder.
- Plug the filaments sensor cable to the lower connector,

  ⓘ The connectors are keyed and cannot be mixed up.
- Coloca la Printhead-cover-right-lever en el lado derecho del Nextruder.

  ⚠ ¡No apriete los cables!
- Secure the cover with two M3x6 screw.

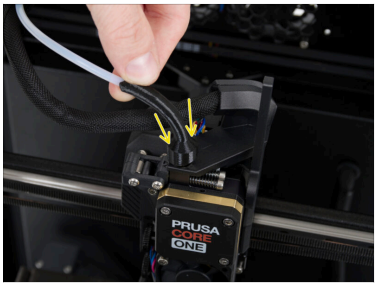
## PASO 62 Installing the fitting

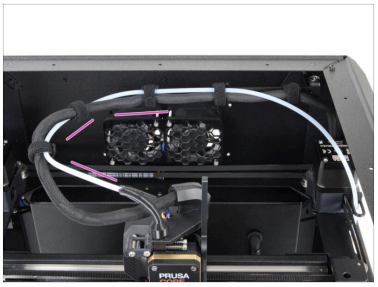




- Insert the fitting M4-5 to the heatsink.
- Using the universal wrench, thighten the fitting firmly.

## PASO 63 Conectando los tubos de Teflón





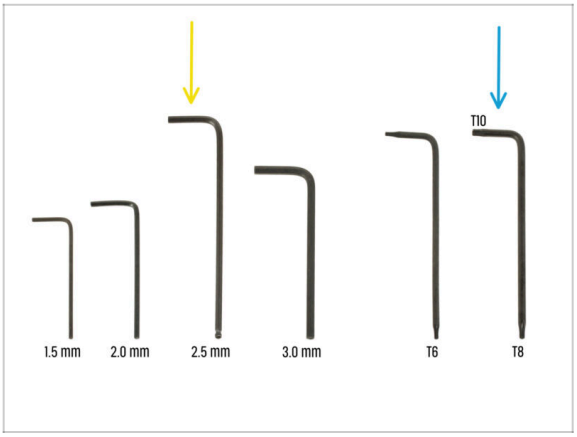
- Push the free end of the removed PTFE tube into the fitting. Push it all the way down.
- Slide the Bowden-bend down to cover the fitting.
- After connecting the cables, verify the routing against the reference image. Make sure the PTFE tube is **not twisted** and it's routed correctly.

## PASO 64 Almost there...

- **Congratulations!** You have successfully replaced the belts.
- Continue to the **next chapter.**

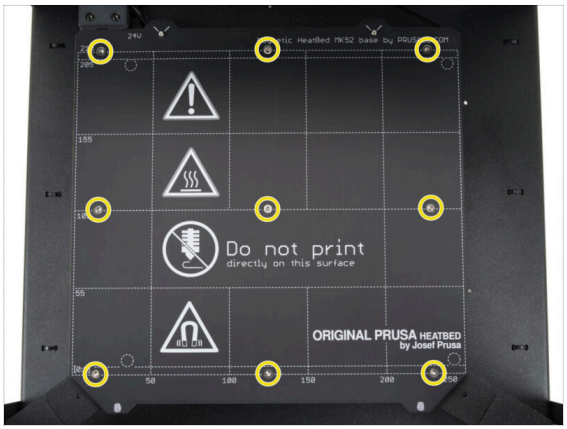
# 4. Heatbed upgrade

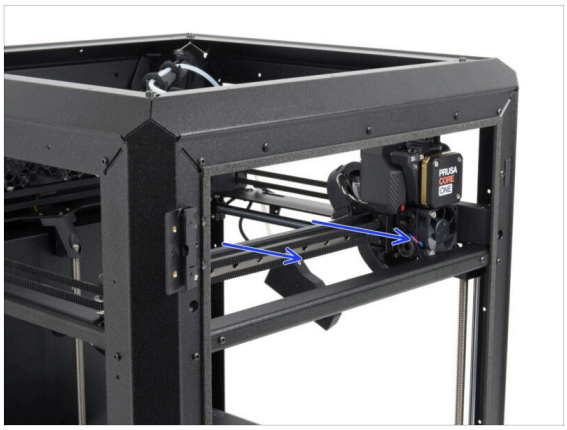
## PASO 1 Tools




- **Tools necessary for this chapter:**
- 2.5mm Allen key
- T10 key/screwdriver

## PASO 2 Loosening the heatbed



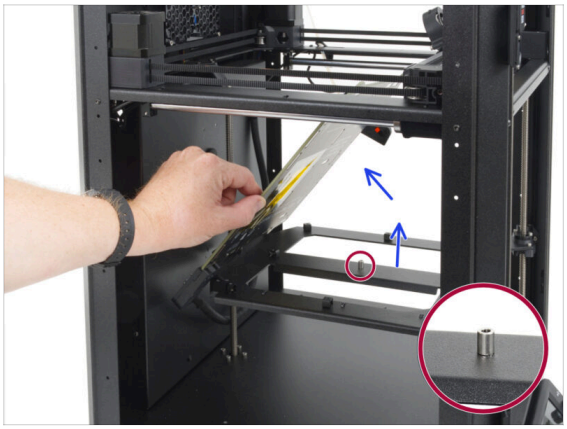



- Using a T10 screwdriver, loosen and remove all nine countersunk screws securing the heatbed.

  ⓘ Keep these screws at hand; we will use them to secure the headbed later.

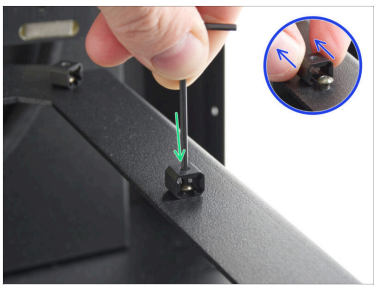
- Move the Nextruder all the way to the front.

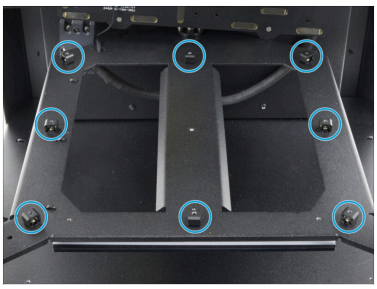
## PASO 3 Opening the heatbed



- Lift the heatbed away from the Z-carriage.
- Remove the heatbed spacer under the heatbed and discard it to avoid mixing it up with the new one.
- Lean the heatbed against the back of the printer.
- Move the Nextruder towards the heatbed and use the print fan to keep it from tilting down.

## PASO 4 Removing old expansion joints

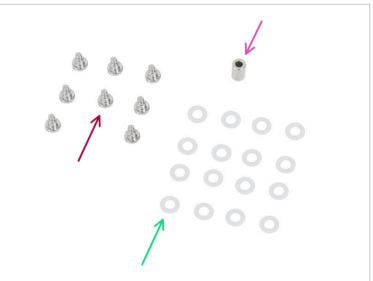




- Using a 2.0 mm Allen key, slightly loosen the M3x4r screw securing the expansion joint on the Z-carriage.
- Slide the expansion joint off the screw.

  ⓘ Keep the expansion joints. One of them will be reused for the nozzle wiper assembly.
- Remove the M3x4r screw.
- Procede del mismo modo con el resto de las juntas de expansión.

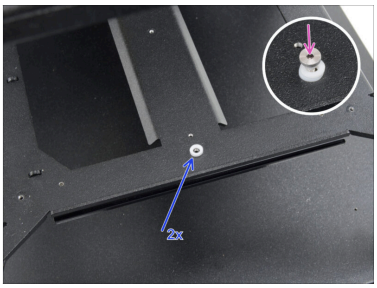
## PASO 5 New expansion joints: parts preparation

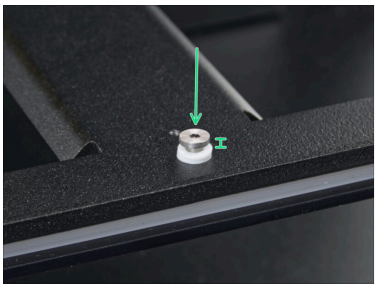
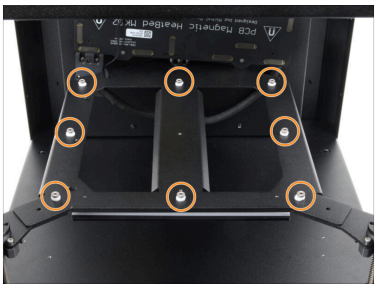


- **Para los siguientes pasos, por favor prepara:**
- New expansion joint (8x)
- Expansion joint screw (8x)
- Arandela M3 PTFE (16x)
- Heatbed spacer 10 mm (1x)

Do not confuse the new heatbed spacer with the old one. They look similar, but the **new spacer is longer**.

## PASO 6 Installing the expansion joint screws

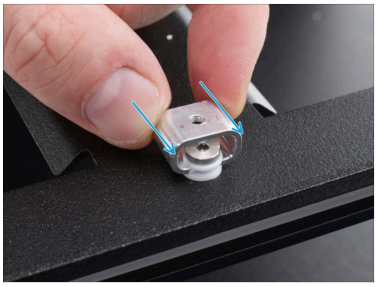
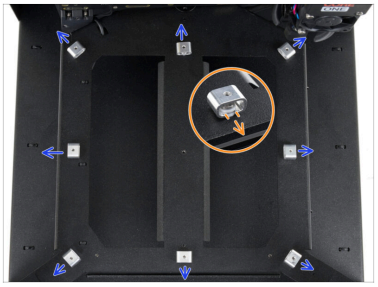


- Place the **two** PTFE washers on top of each other in the front threaded hole of the Z-carriage.
- Insert the expansion joint screw through the washers into the threaded hole.
- Tighten the screw fully, but do not overtighten.

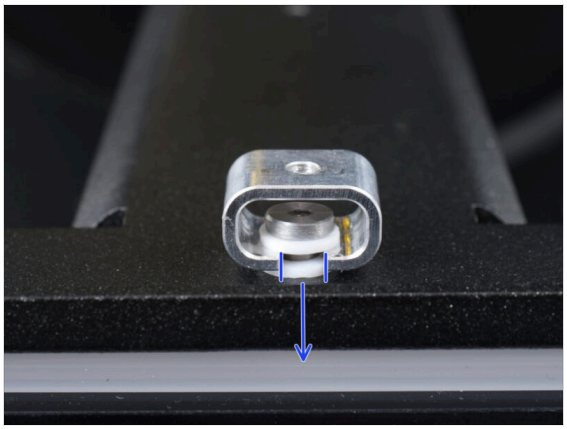
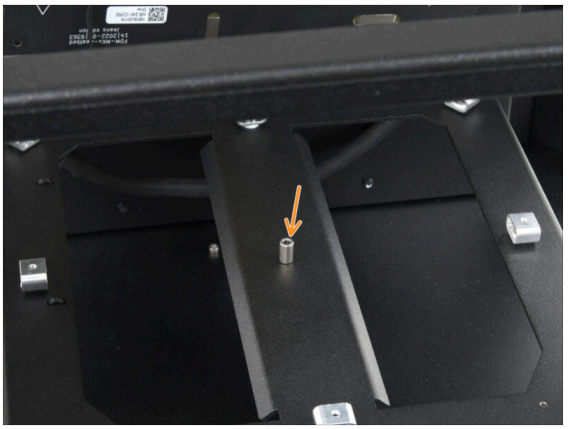
  Es normal que quede un pequeño espacio entre las arandelas y la cabeza del tornillo, debido a la sección sin rosca del tornillo.
- Proceed the same for the rest of the threaded holes.

## PASO 7 Installing the new expansion joints

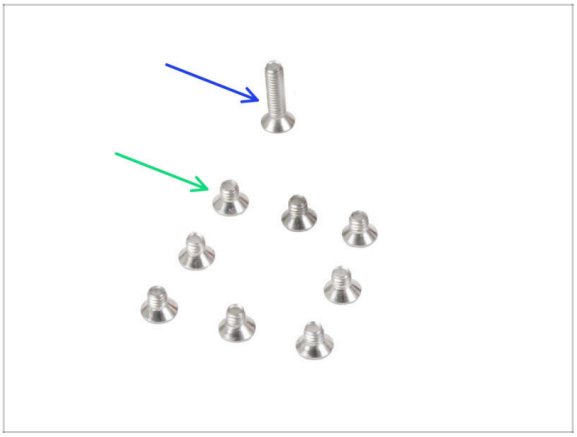
- Slide the new expansion joint with the groove on the underside onto the screw **between** the PTFE washers.
- Orient the expansion joint with the **groove facing away from the Z-carriage**.
- Repeat this process for all remaining expansion joints.
- The final position will be adjusted in the following steps.

## PASO 8 Inserting the heatbed spacer

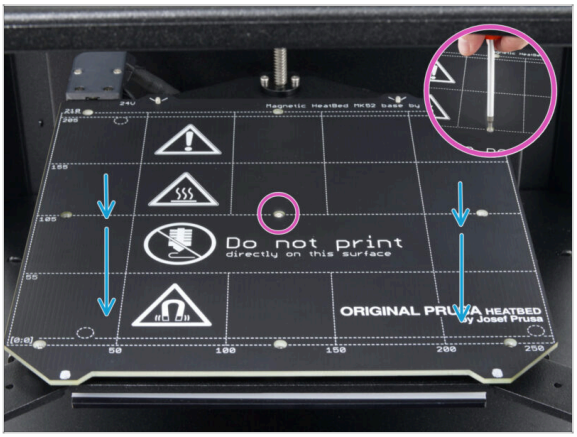
- Double-check that all expansion joints are oriented correctly and that the grooves are facing outward.
- Place the **new** 10 mm heatbed spacer on the threaded hole in the center of the Z-carriage.
- If you are assembling the Prusa INDX along with the GEN 2 upgrade, return to the article: **Assembling the Prusa INDX Core One with the Gen 2 upgrade**.

## PASO 9 Heatbed screws: parts preparation



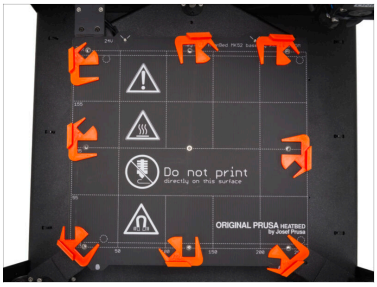
- **Para los siguientes pasos, por favor prepara:**
- M3x14cT countersunk screw (1x)
  - ⓘ Some iterations of the upgrade might call this screw M3x14bT.
- M3x4cT countersunk screw (8x) *removed earlier*

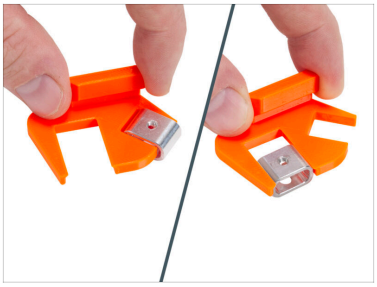
## PASO 10 Securing the heatbed




- Place the heatbed on the expansion joints and align the mounting holes.
- Insert the M3x14cT countersunk screw through the heatbed spacer into the center hole and tighten it lightly.

## PASO 11 Expansion joint aligner





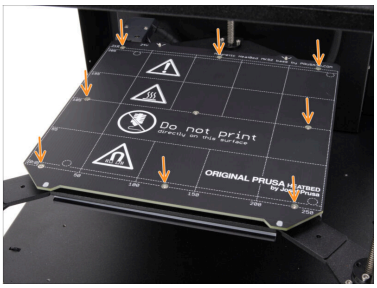
- Prepare the **Expansion-joint-aligner** for the following steps.

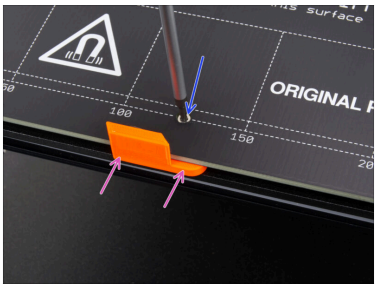
ⓘ Your package includes the **black version**. The orange version is shown in this guide for better visibility.

- In the following steps, you will precisely align each expansion joint.
- For reference, see the second image showing the simplified aligner orientation for a single expansion joint.
- The third image shows the alignment tool being slid onto the expansion joint for reference.

  ⓘ The expansion joint is shown outside the printer for clarity. During alignment, it is installed under the heatbed.

## PASO 12 Aligning the front side expansion joint



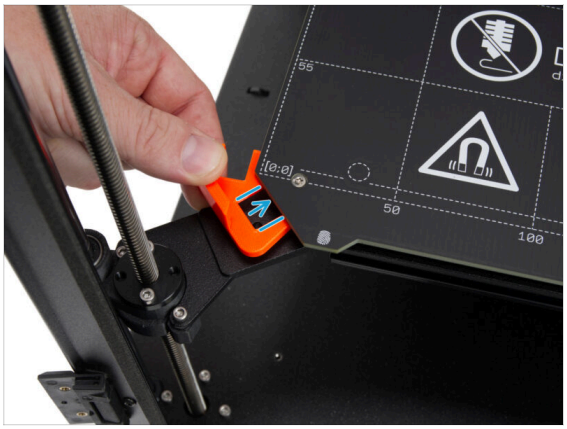


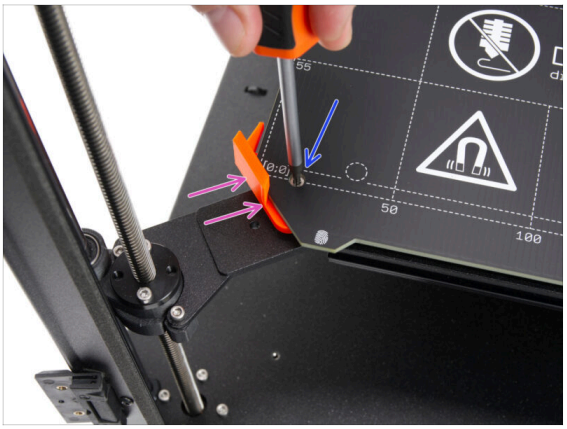

- Inserta los tornillos M3x4cT en **los ocho orificios** que hay alrededor de la base calefactable. Aprieta cada tornillo **solo una vuelta**.
- Empieza por alinear la **junta de expansión central en la parte frontal**.

  ⓘ Use the symbols on the heatbed as a reference.

- Slide the straight fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

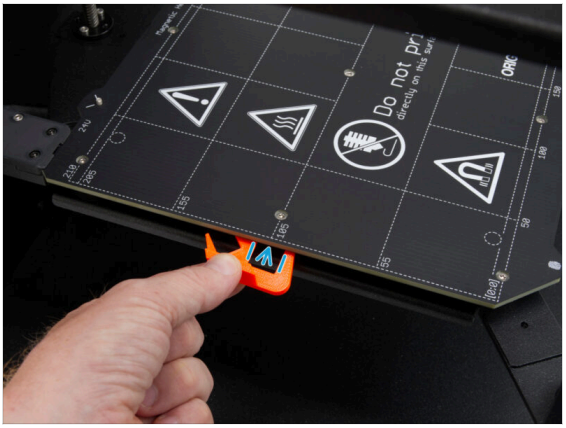
## PASO 13 Aligning the front left expansion joint

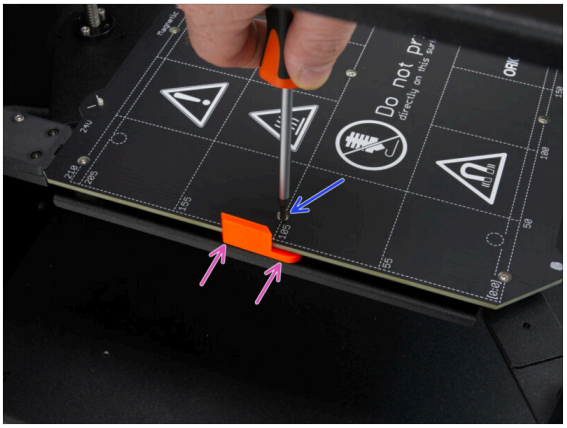




- Move to the **left corner**.
- Slide the straight fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

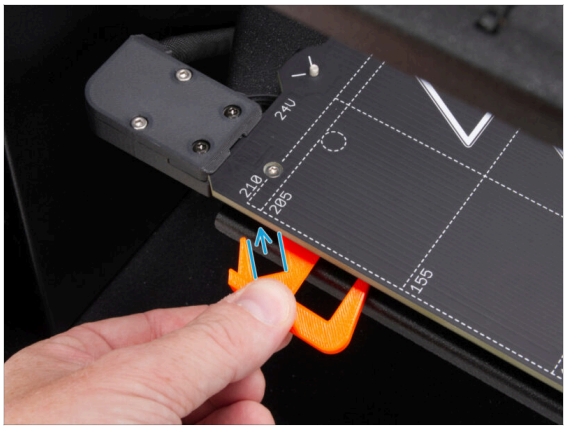
## PASO 14 Aligning the left side expansion joint

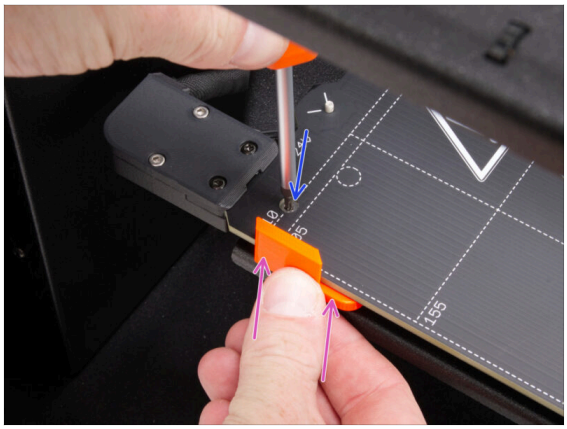




- Move to the **left side** of the heatbed.
- Slide the straight fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

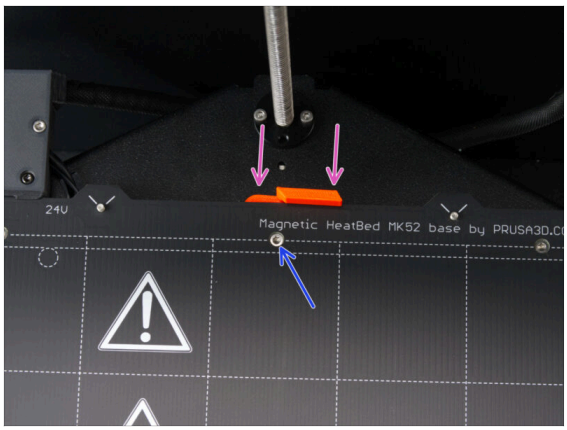
## PASO 15 Aligning the rear left expansion joint




- Pasa a la **esquina trasera izquierda**.
- Slide the **angled** fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

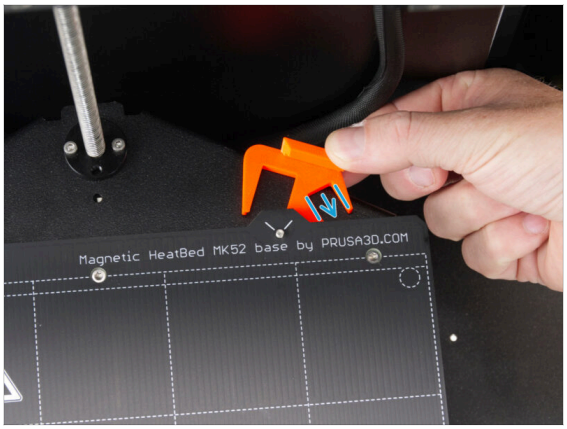
## PASO 16 Aligning the middle rear expansion joint

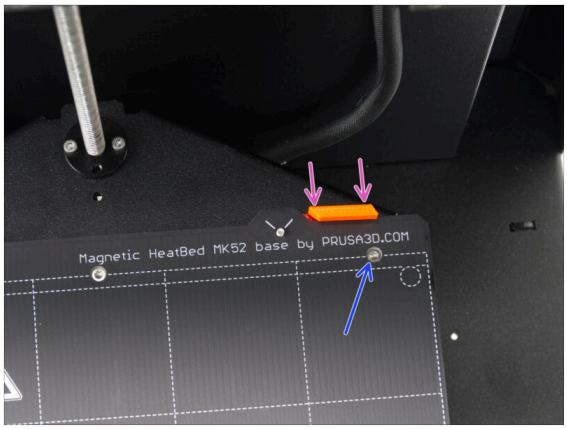



- Continue with the **middle rear** expansion joint.
- Slide the straight fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

## PASO 17 Disconnecting the Nextruder cables - left side

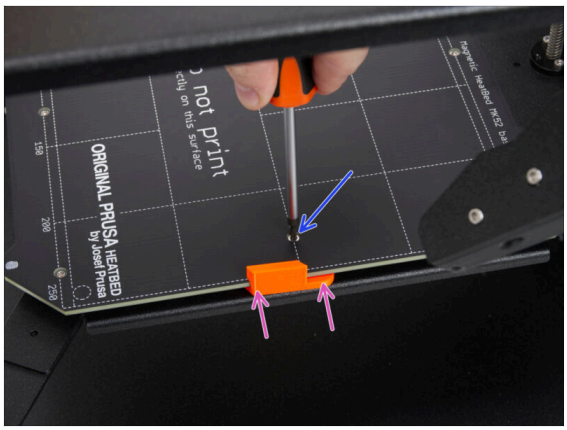
## PASO 18 Aligning the rear right expansion joint




- Continue with the **rear right corner**.
- Slide the **angled** fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

## PASO 19 Aligning the right side expansion joint




- Desplázate hacia el **lado derecho** de la base calefactable.
- Slide the straight fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

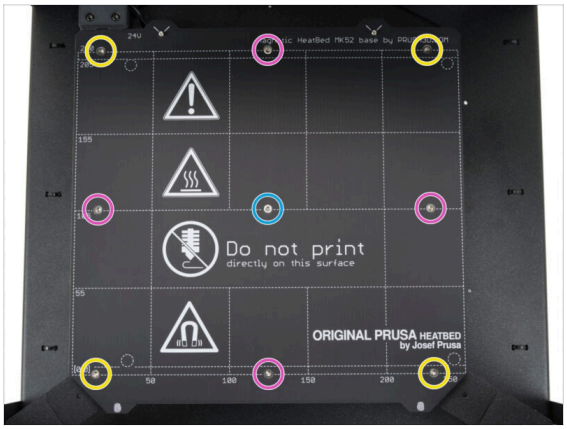
## PASO 20 Aligning the front right expansion joint

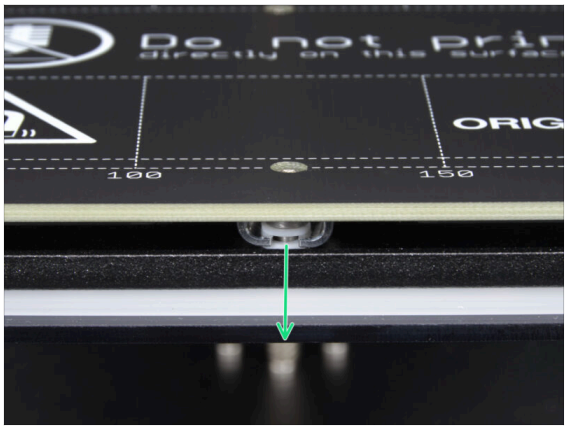
- Continue with the **front right corner**.

  ⓘ **If you are converting your printer to the Prusa INDX version**, move the offset sensor out of the way to align this expansion joint, then place it back.

- Slide the straight fork onto the expansion joint and push the Expansion-joint-aligner against the heatbed. This will align the expansion joint.
- Push the aligner firmly against the edge of the heatbed.
- Tighten the screw, but just lightly.

## PASO 21 Fixing the heatbed



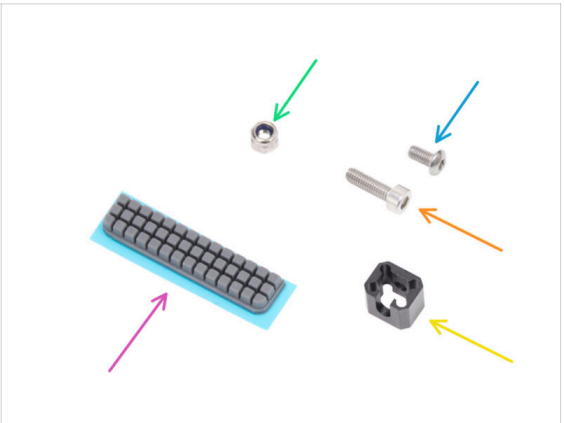




**IMPORTANTE:** La base calefactable debe apretarse en un orden específico. Repite la secuencia varias veces, asegurando el apriete final después de al menos dos rondas.

- After all screws are in place, tighten them in the following sequence:
  - Center screw
  - First fours screw (edges)
  - Últimos cuatro tornillos (esquinas)
- Aprieta los tornillos suavemente, pero con firmeza.
- Double-check that the expansion joint has not rotated and that the groove is facing outwards from the printer.

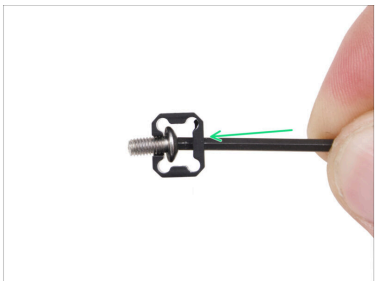
If you are assembling the Prusa INDX along with the GEN 2 upgrade, **return to the Prusa INDX GEN 2 article now**.

## PASO 22 Nozzle wiper assembly: parts preparation



- **Para los siguientes pasos, por favor prepara:**
- Nozzle-wiper-holder (1x)
- Nozzle wiper (1x)
- M3n nut (1x)
- M3x6r screw (1x)
- M3x10 screw (1x)
- Expansion joint (1x) *you removed earlier*

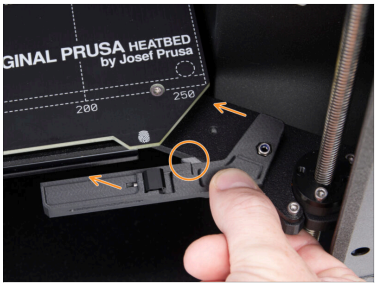
## PASO 23 Assembling the nozzle wiper

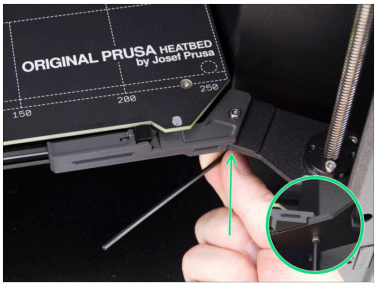


- Insert the M3x6r screw into the expansion joint with the screw head first.
- Insert a 2.0 mm Allen key through the threaded hole to reach the screw.
- Attach the expansion joint to the Nozzle-wiper-holder and tighten the screw. Do not overtighten it.

  ⚠ **Do not overtighten the screw.** Tighten it gradually, backing the screw off slightly if you feel increased resistance. This helps prevent the expansion joint from splitting.

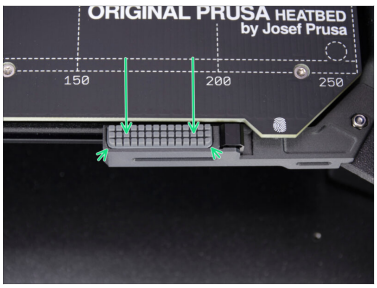
## PASO 24 Mounting the nozzle wiper

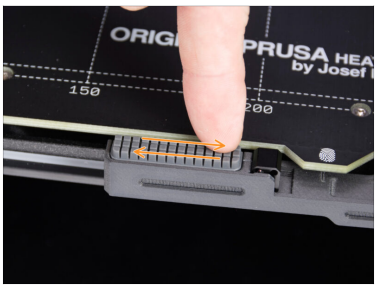





- Insert the M3nN nut into the hexagonal opening.
- Place the Nozzle-wiper-holder onto the right side of the Z-carriage.
- Slide the Nozzle-wiper-holder along the Z-carriage onto the heatbed assembly.
  - Notice the small tab on the holder. It must hook behind the sheet metal edge underneath the heatbed.
- Push the assembly firmly against the heatbed and secure it from the underside of the Z-carriage using the M3x10 screw.

## PASO 25 Sticking the wiper pad



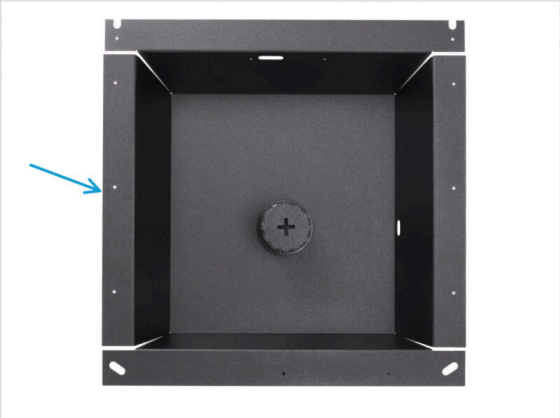


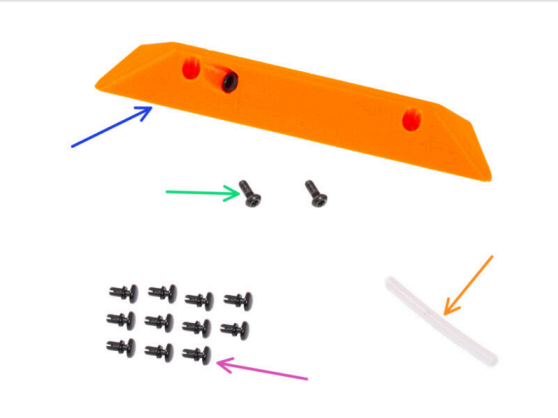

- Peel off the protective layer from the nozzle wiper pad.

  ⓘ **The pad is adhesive** underneath the protective layer. Avoid touching the adhesive surface.
- Insert the nozzle wiper pad into the matching recess in the nozzle wiper assembly.

  Note that the pad has **rounded corners** on one side. Match them to the shape of the recess.
- Run your finger over the entire surface of the nozzle wiper pad several times to ensure it is evenly adhered and fully seated.

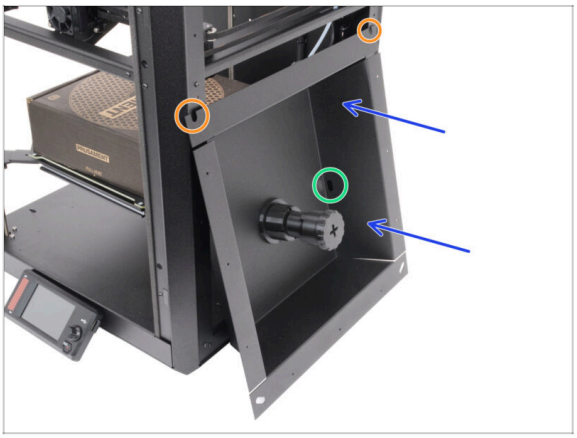
## PASO 26 Right metal sheet: parts preparation





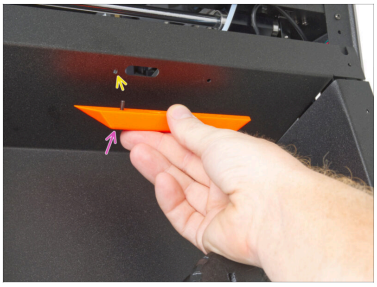
- **Para los siguientes pasos, por favor prepara:**
- Right side sheet metal (1x) *you removed earlier*
- Side-handle (1x) *you removed earlier*
- Tornillo M3x8rT (2x) *que quitaste antes*
- PTFE tube 4 x 2.5 x 45 mm (1x) *you removed earlier*
- Nylon rivet (11x) *you removed earlier*

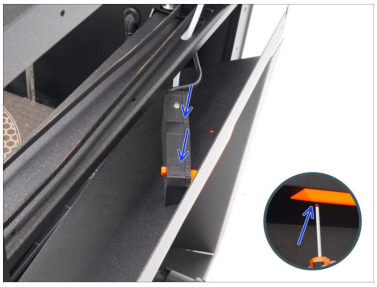
## PASO 27 Preparing the right metal sheet



- Carefully lean the right side sheet against the printer.
  - The U-shaped cutouts must face upward.
  - The oval opening must be on the right side of the sheet.

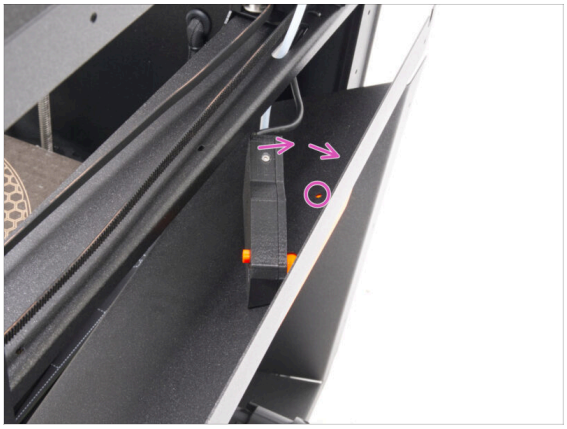
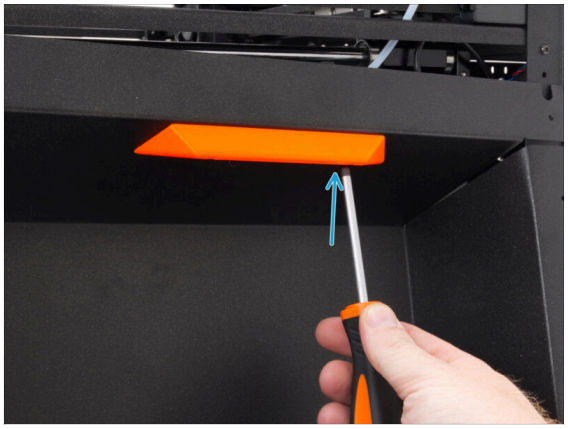
## PASO 28 Attaching the handle and FS





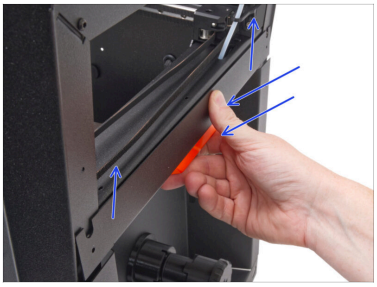
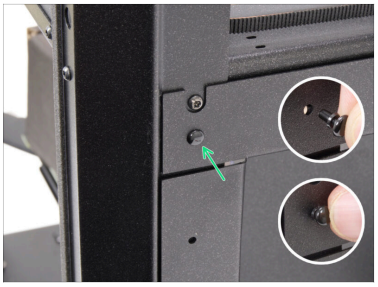
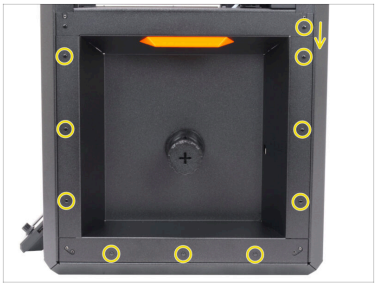
- Insert an M3x8rT screw through the left hole in the side handle.
- Place the side handle against the opening in the side panel and align it.
- Push the screw through the panel.
- From the opposite side, align the side filament sensor with the screw.
- Place the filament sensor onto the screw and tighten it.

## PASO 29 Securing the side filament sensor

- Align the side filament sensor with the second mounting hole.
- Secure it using an M3x8rT screw inserted through the side handle.

## PASO 30 Mounting the right metal sheet

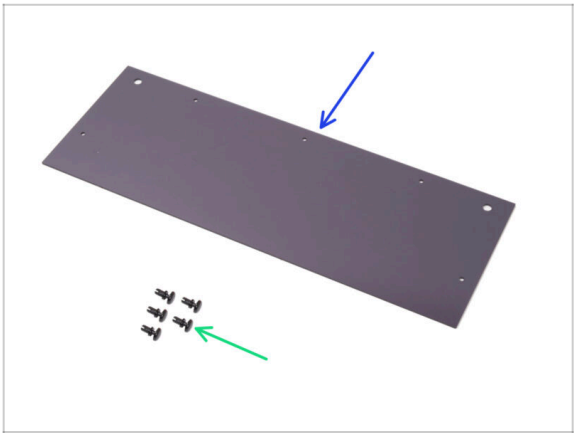




- Gently press the metal sheet against the printer frame while sliding it upward.
- Seat it in place and secure it with a nylon rivet in the upper-left corner.
  - Align the holes.
  - Insert the nylon rivet into the hole and press it in lightly.
  - Then press it in firmly until fully seated.
- Using the same method, continue with the remaining ten holes. Start from the top.

## PASO 31 Insertar el tubo de PTFE

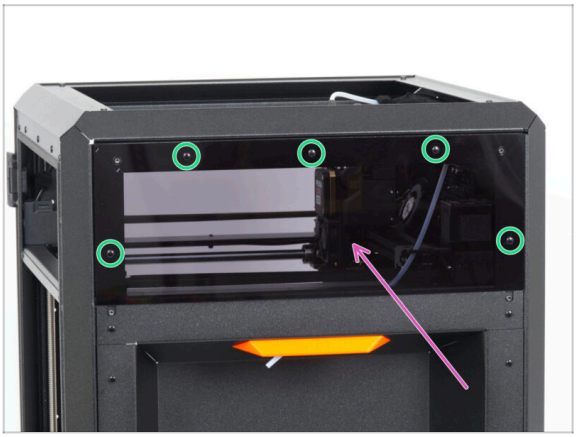
- Locate the black collet inside the side handle.
- Fully insert the PTFE tube into the side handle.

## PASO 32 Right side panel: parts preparation



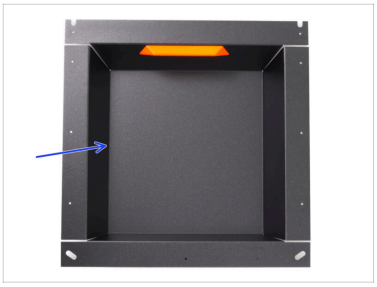
- **Para los siguientes pasos, por favor prepara:**
- Side panel (1x) *you removed earlier*
- Nylon rivet (5x) *you removed earlier*

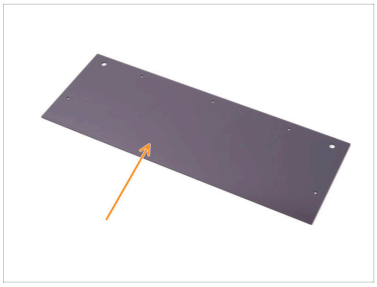
## PASO 33 Installing the right side panel

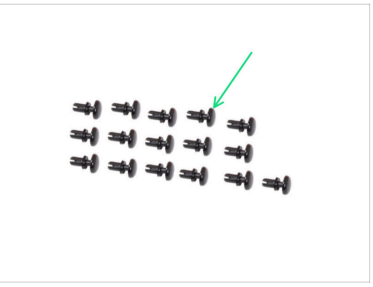


- Place the side panel on the right side of the printer above the metal sheet.
- Secure it using five nylon rivets.

## PASO 34 Lateral izquierdo: preparación de las piezas

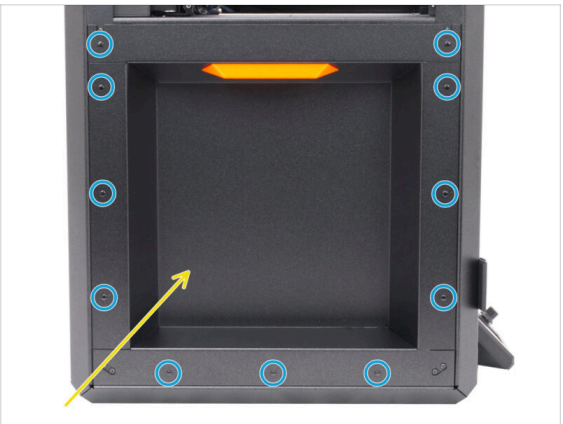


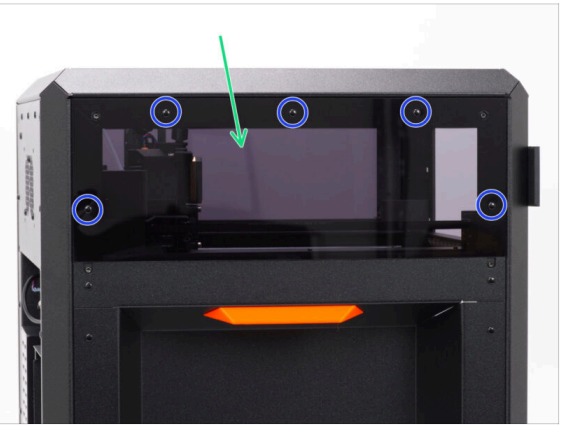




- **Para los siguientes pasos, por favor prepara:**
- Left side metal sheet (1x) *you removed earlier*
- Side panel (1x) *you removed earlier*
- Nylon rivet (16x) *you removed earlier*

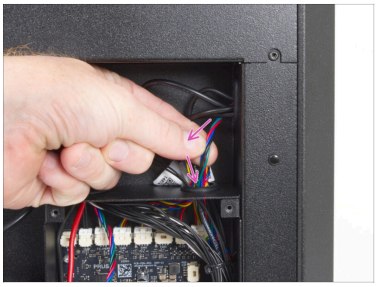
## PASO 35 Installing the left side panels

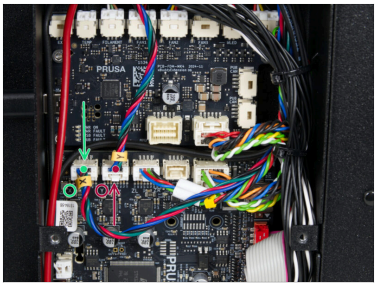




- Insert the left side metal sheet into the printer frame from the left side.
- Secure it using eleven nylon rivets.
- Place the side panel over the side metal sheet.
- Secure it using five nylon rivets.

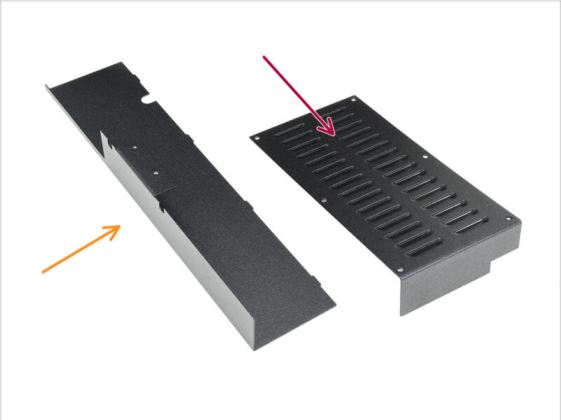
## PASO 36 Conexión de los cables de los motores

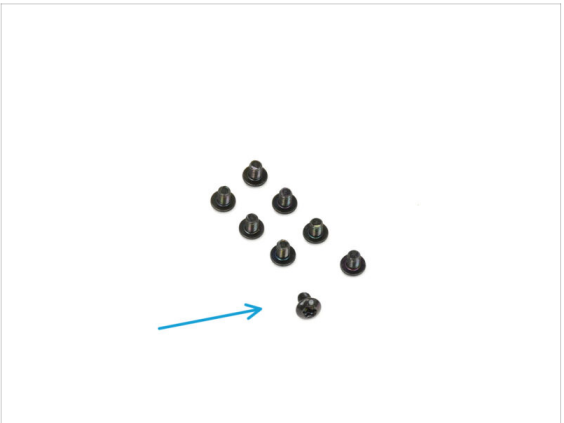




- Ve a la parte trasera de la impresora.
- Gently pull the right rear motor cable back towards the electronics. **Stop pulling if you feel resistance**.
- Gently pull the left rear motor cable back towards the electronics. **Stop pulling if you feel resistance**.
- Connect the **left** motor cable (X motor) to the left connector. It is labeled X on the board.
- Connect the **right** motor cable (Y motor) to the right connector. It is labeled Y on the board.

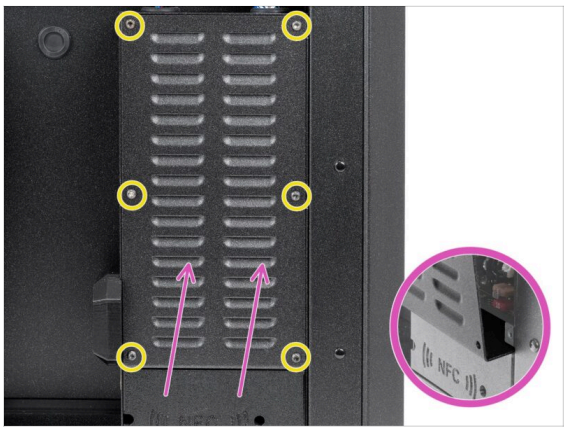
## PASO 37 Cubierta xBuddy: preparación de piezas





- **Para los siguientes pasos, por favor prepara:**
  - Cubierta trasera chapa metálica (1x) *que se encuentra en el paquete Metal parts 2/3*
  - Cubierta xBuddy (1x) *que se encuentra en el paquete de Metal parts 3/3*
  - M3x4rT screw (8x)

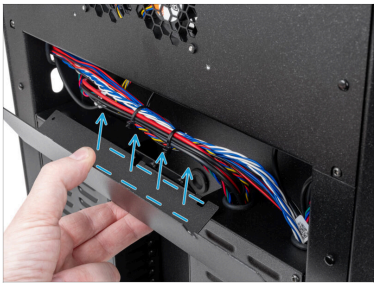
## PASO 38 Covering the xBuddy board

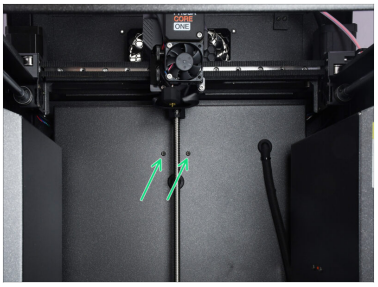


- Cubre con cuidado la caja xBuddy deslizando primero la parte doblada de la cubierta dentro de la caja.
  - Avoid pinching the cables, and make sure the cover is inserted perpendicular to the xBuddyboard.
- Fija la tapa de la caja xBuddy con los seis tornillos M3x4rT.
- Wrap two zipties around the cable bundle on the top to keep the cables tidy and secured.

  Carefully cut the excess; avoid cutting the cables.

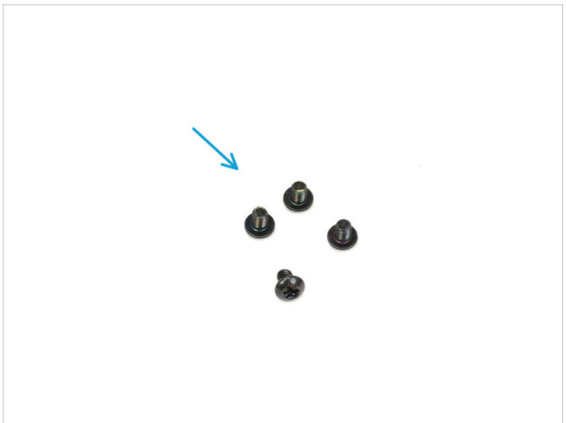
## PASO 39 Covering the cables





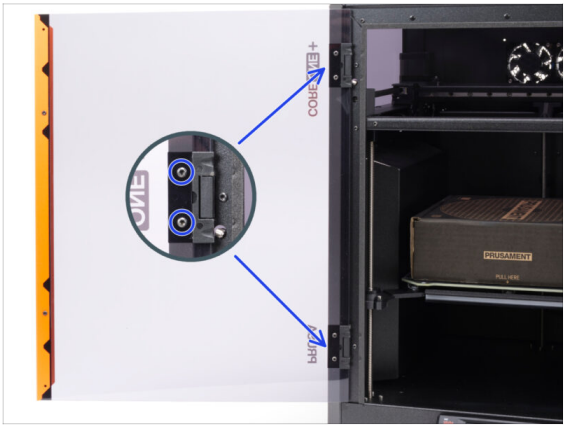
- Align the rear sheet metal cover so that the cables can run through the platform.
- Push the rear cable cover toward the printer, then move it upward.
- Ensure that the cable cover slides into the four openings in the printer rear cover.
- From the inside of the printer, secure the rear cover in place using two M3x4rT screws from inside the printer.

## PASO 40 Panel de la puerta: preparación de las piezas



- **Para los siguientes pasos, por favor prepara:**
- Door panel (1x) *you removed earlier*
- M3x5rT screw (4x) *you removed earlier*

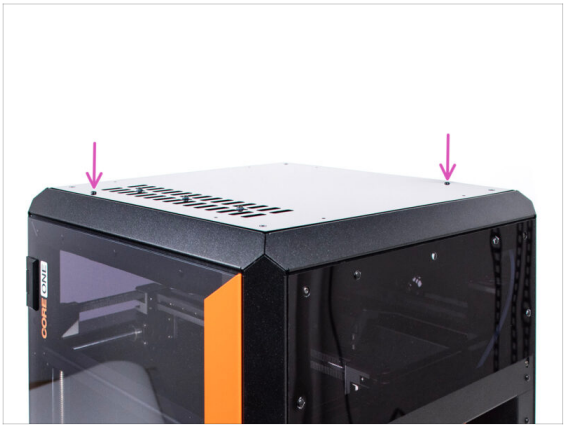
## PASO 41 Instalando el panel de la puerta




⚠ **Make sure the door panel is oriented correctly**, with the PRUSA CORE One+ logo readable from the outside of the printer when the door is closed.

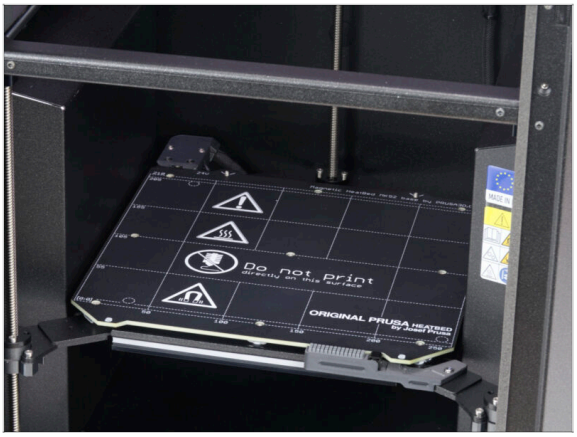
- Slide the cutouts in the door panel back onto the hinges.
- Secure the door panel by installing two M3x5rT screws into each hinge.
  - **Do not overtighten the screws**, as this may damage the door panel.

## PASO 42 Instalando la tapa superior



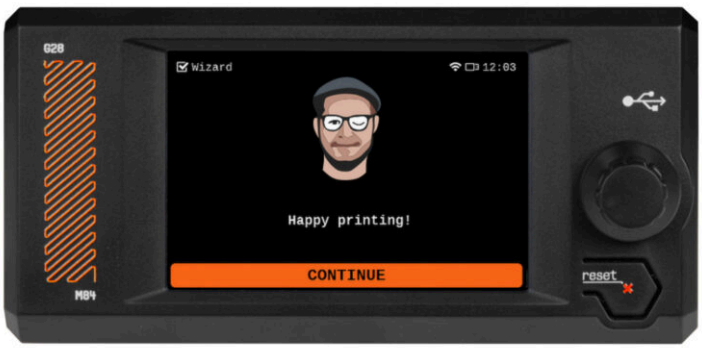
- Alinea la tapa con el marco metálico de la esquina derecha.
- Alinea también la tapa con el hueco de la parte delantera
- Fija la cubierta en su sitio utilizando dos remaches de nylon en las aberturas marcadas.

## PASO 43 Done

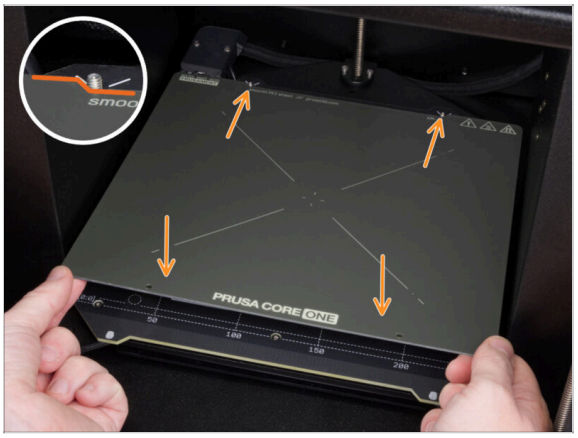



- **Congratulations!** You have just completed the heatbed upgrade.
- Now, proceed to the **final chapter**.

# 5. Preflight check



## PASO 1 Print Sheet

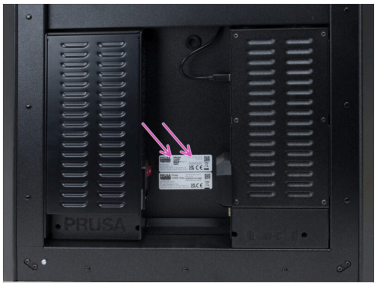



- Reinstala la lámina de impresión.

⚠ **Asegúrate de que no haya nada sobre la base calefactable.** La base calefactable debe estar limpia. Cualquier suciedad puede dañar la superficie tanto de la base calefactable como de la lámina de impresión.

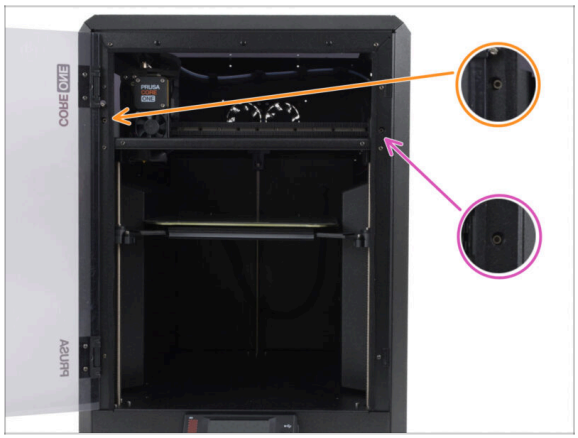
- **Fija la lámina alineando primero el recorte trasero con los pasadores de bloqueo de la parte trasera de la base calefactada.** Sujeta la lámina por las dos esquinas delanteras y colócala lentamente sobre la base calefactable - **¡cuidado con los dedos!**
  - Keep the print sheet clean for optimum performance.
  - La causa Nº1 de que las impresiones se despeguen de la superficie de impresión es una lámina de impresión grasienta. Utiliza IPA (alcohol isopropílico) para desengrasarla si has tocado antes su superficie.

## PASO 2 Attaching the stickers




- **Para los siguientes pasos, prepara:**
- CORE One+ sticker
- GEN 2 SN sticker
- Peel the CORE ONE+ sticker off the base and place it on the CORE ONE+ logo on the door.
- Make sure to align the sticker with the outline of the "ONE". Apply pressure and then remove.
- Place the GEN 2 SN sticker above the original SN sticker on the back of the printer.

## PASO 3 Belt tensioning




Este capítulo le guiará a través de la calibración y preparación de la impresora para su primer uso. Empezando por tensar las correas:

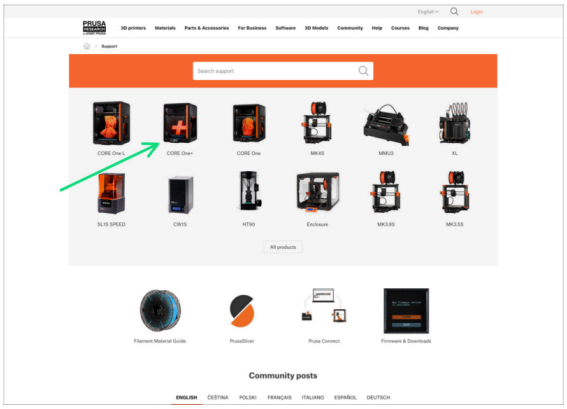
- El tornillo izquierdo ajusta la correa superior.
- El tornillo derecho ajusta la correa inferior.

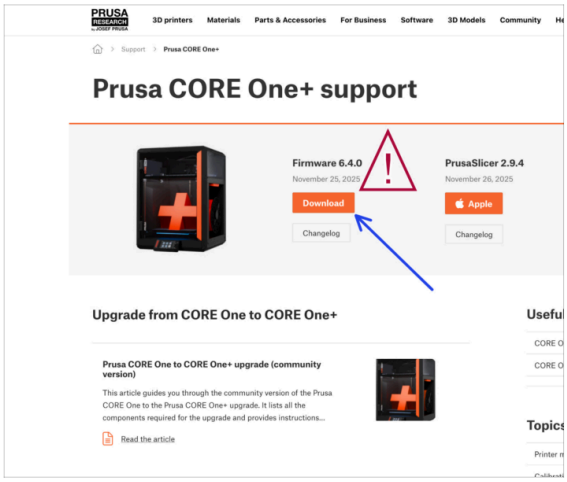
**ADVERTENCIA: Un procedimiento incorrecto puede provocar daños en las piezas de plástico o el agarrotamiento de los tornillos. Antes de ajustar la tensión de la correa, lee el artículo dedicado a este tema:**

- **Ajustando la tensión de la correa (CORE One)**

No olvides volver aquí después de ajustar las correas.

## PASO 4 Firmware Download




- Tendremos que actualizar el firmware.

  ⓘ La CORE One+ requiere la versión de firmware 6.4.0 o posterior.
- Visita la página de ayuda de la Core One+ en Help.Prusa3D.com.
- Descarga el archivo de firmware (.bbf) más reciente.
  Guarda el archivo en una unidad USB.

## PASO 5 Firmware Flash

- Inserta la unidad USB con el archivo de firmware en la impresora.
- Conecta el cable de alimentación.
- Enciende la impresora mediante el interruptor situado en la parte posterior.
- Una vez que aparezca en la pantalla "Nuevo firmware disponible", selecciona la opción **FLASH**.

## PASO 6 Changing the printer edition

After completing the CORE One+ (Gen 2) upgrade, **change the printer edition to CORE One+ (Gen 2)**.

This is required because the Gen 2 uses belts and pulleys with a different tooth pitch.

- Go to ***Settings*** → ***Hardware*** → ***Edition*** → ***Hardware*** → ***Edition*** and select **CORE One+ Gen2**.
- The printer will ask you to confirm the edition change. Select ***Yes***.

## PASO 7 Selftest

- Después de terminar la actualización, te recomendamos visitar el menú de ***Control > Calibración y Tests*** y ejecuta el Selftest desde el principio.

## PASO 8 Finish

Congratulations! Your upgraded CORE One+ (Gen 2) is ready to roll!

**Happy printing!**

# Manual changelog

## PASO 1 Version history

- **Version of the Prusa CORE One+ (Gen 2) upgrade manual:**
- 08/2026 - Initial version 1.00

**Notes:**

**Notes:**

**Notes:**

**Notes:**