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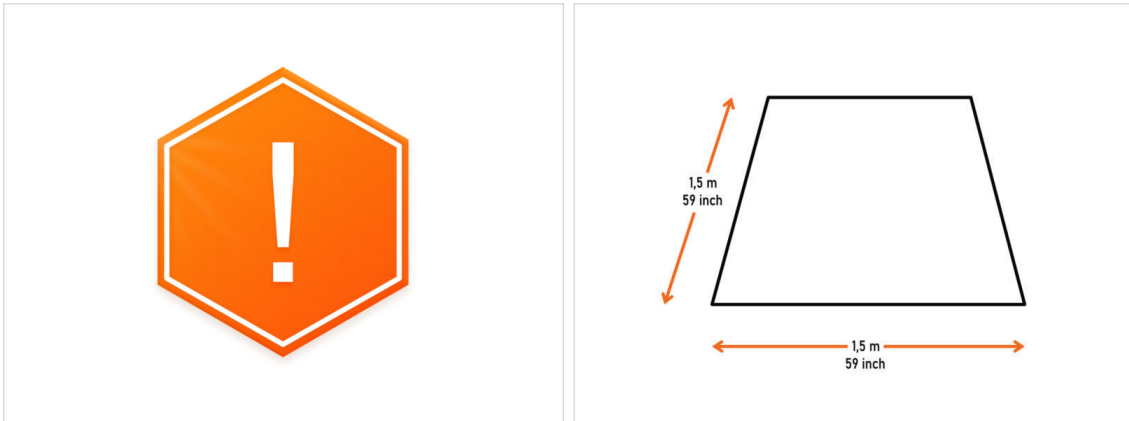
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1. Introduction



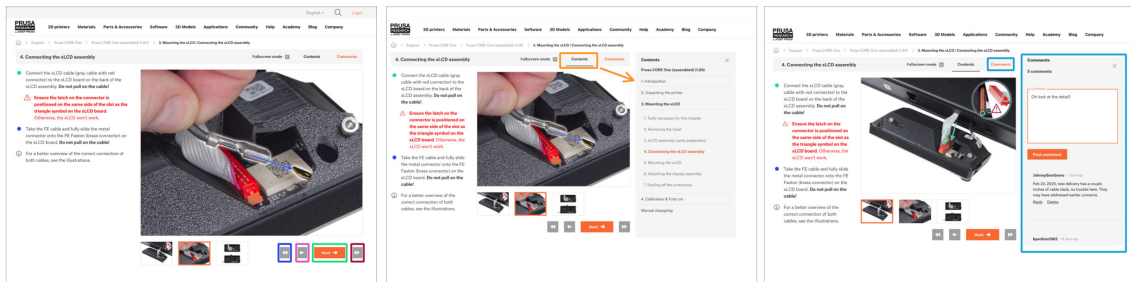
STEP 1 General information



⚠ The package with the printer is heavy! Always ask another person for help with handling.

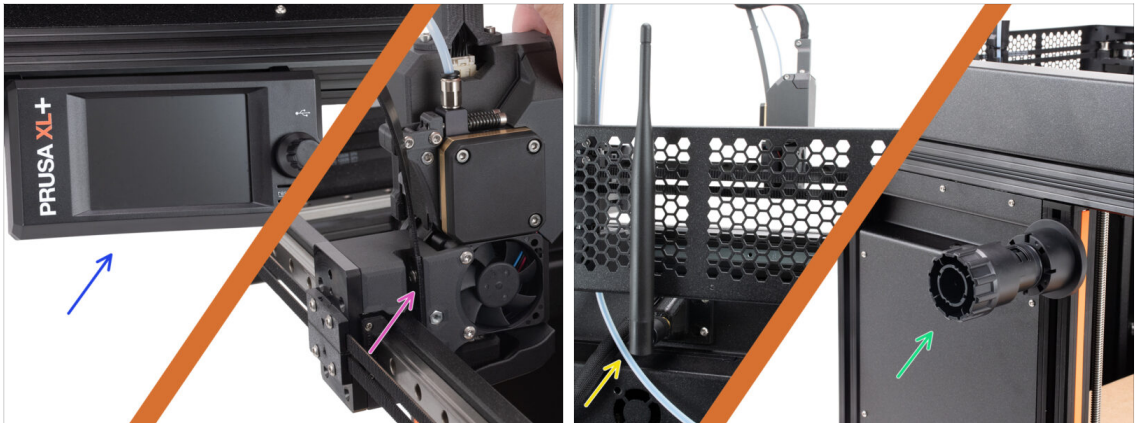
- For the assembly, prepare a clean workbench with a space of at least 1,5 m x 1,5 m (59 in x 59 in).
- We recommend having a bright light above your workbench. Some parts of the printer are dark, and inadequate light could make the assembly more difficult.

STEP 2 How to navigate through the manual



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

STEP 3 What awaits you during the unpacking



❶ Because of transportation, some of the fragile parts must be safely packed separately in the printer package. This manual will take you through the installation of these parts on the printer.

● **These parts will be installed:**

- LCD assembly
- Single tool Nextruder assembly
- Wi-Fi antenna
- Spool holder

STEP 4 Tools in the package



● The package includes:

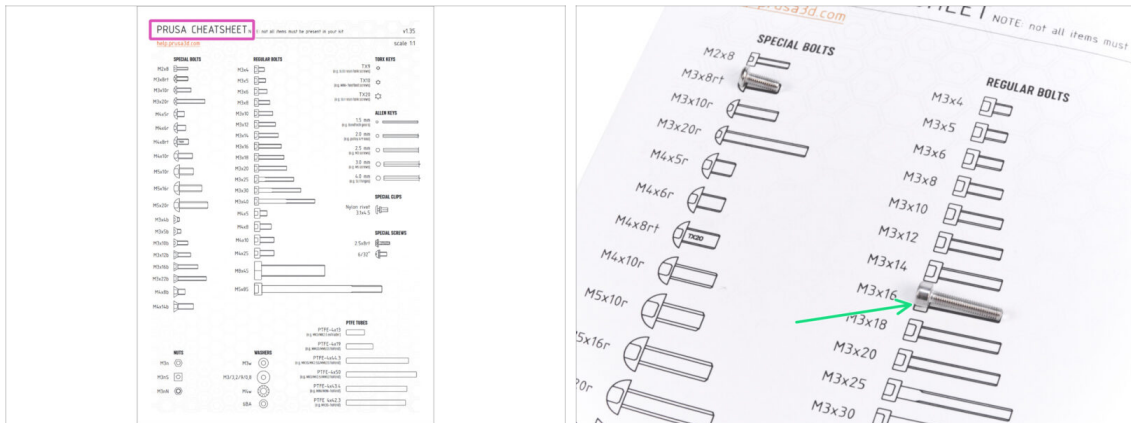
- ① Some of the tools are intended primarily for regular printer maintenance. You won't need them for this manual. At the beginning of the assembly chapter is a list of the necessary tools.
- Torx key TX6, TX8, TX10
- Allen key 2.5 mm, 4.0 mm
- Wrench 13-16
- Universal wrench
- T10 screwdriver
- Philips PH2 screwdriver
- Needle-nose pliers
- The printer's package contains a lubricant, which is intended for maintenance. No need to apply it during the assembly. There is a dedicated online manual Regular printer maintenance.

STEP 5 Labels guide



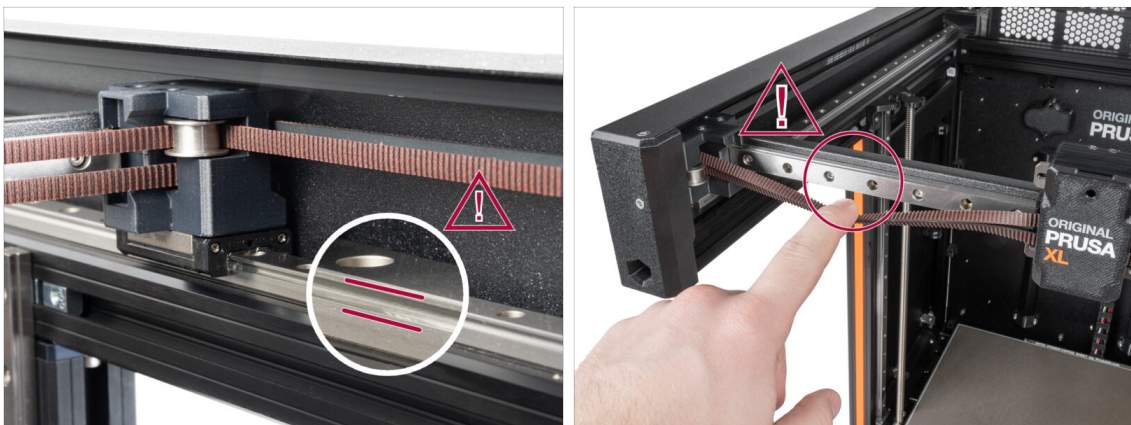
- All the boxes and bags including parts for the build are labeled.
- The LCD Fasteners bag includes an extra spare of each part contained in the bag. The amount of spare parts is written on the label. This number is included in the total number of each type of part.

STEP 6 Cheatsheet



- ◆ Your package contains a letter, on the back of which is a Cheatsheet with drawings of all the necessary fasteners.
- ◆ The fasteners drawings are 1:1 scale, so you can compare the size by placing the fastener on the paper to make sure you are using the correct type.
- ❗ You can download it from our site help.prusa3d.com/cheatsheet. Print it at 100 %, don't rescale it, otherwise, it won't work.

STEP 7 CAUTION: Lubricant Handling



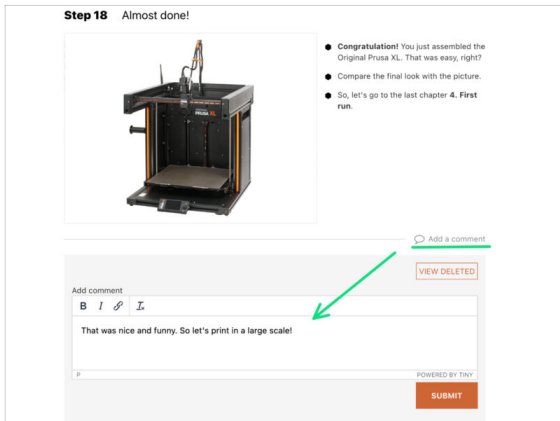
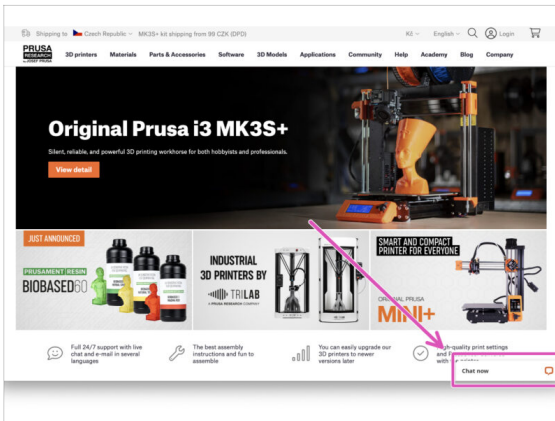
- ⚠ **CAUTION:** Avoid direct skin contact with the lubricant used for the linear rails in this printer. If a contact occurs, wash your hands immediately. Especially before eating, drinking, or touching your face.
- ◆ Lubricant accumulates in the printer's bearings, mainly in the linear rail channels.

STEP 8 View high resolution images



- i** When you browse the guide on help.prusa3d.com, you can view the original images in high resolution for clarity.
- ✿ Hover your cursor over the image and click the Magnifier button ("View original") in the top left corner.

STEP 9 We are here for you!



- Lost in the instructions? Missing screw or cracked printed part? **Let us know!**
- You can contact us using following channels:
 - ✿ Comments under each step.
 - ✿ Our 24/7 live chat at shop.prusa3d.com
 - Writing an email to info@prusa3d.com
- Are you ready to get started on the assembly? Let's move on to chapter 2. Printer unboxing.

2. Printer unboxing

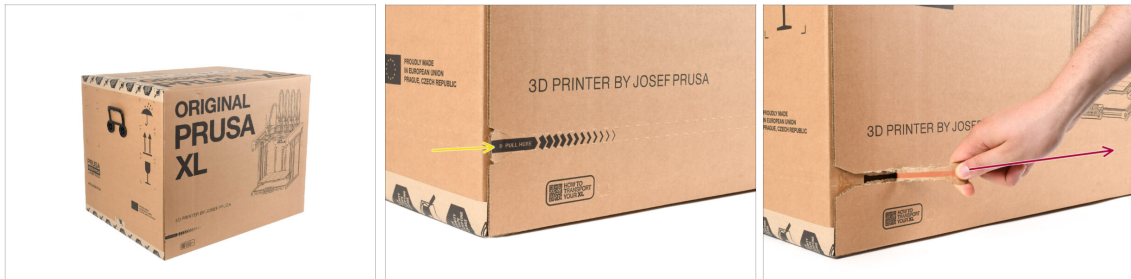


STEP 1 Introduction



- ⚠ **The printer package is heavy!** Ask someone to help you out.
- ⚠ **If any children are helping you with the assembly, always supervise them to avoid injury.**
- ⚠ **Do not discard the packaging!** Please keep the original packaging and protective foam. The printer must be packed in these for any service or warranty shipping to prevent damage.

STEP 2 Opening the package



- Place the package on a stable surface. **Make sure the package is oriented top side up.** See the transportation label.
- The package is equipped with a tear strip that splits the box in two parts.
- Peel off the entire tear strip to split the box.

STEP 3 Opening the package



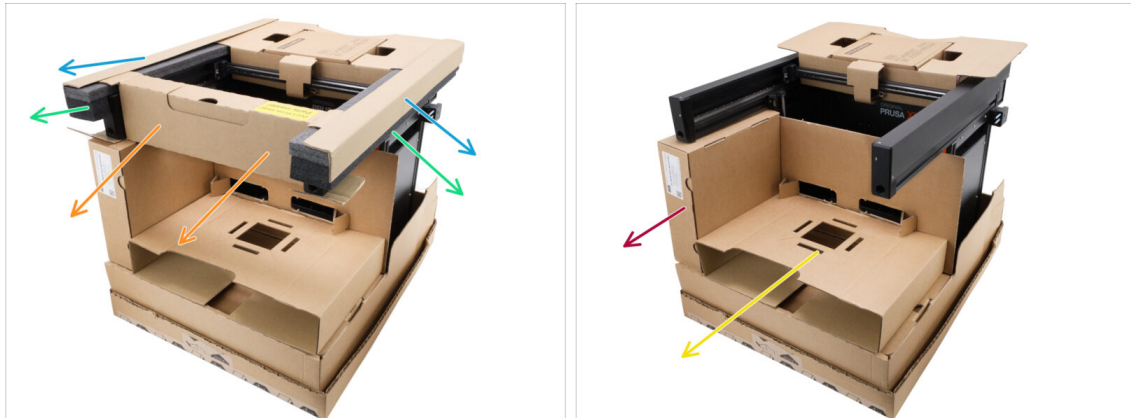
- Remove the top part of the box by lifting it up.

⚠ Inside, there are cardboard inserts that contain parts necessary for the assembly. Do not throw them out!

i Your printer may differ slightly from the one shown in the photos. This does not affect the guide; the photos are for illustrative purposes only.

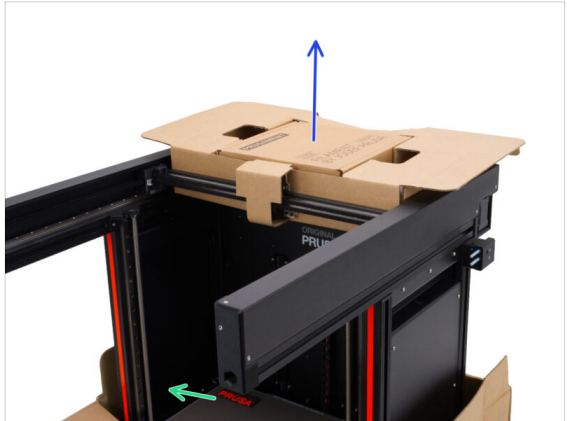
- Remove the Haribo gummy bears from the back of the box and put them aside. We will release them from captivity soon.
- Remove the welcome letter, which also contains the cheatsheet. **Do not dispose of the welcome letter !**

STEP 4 Removing the inserts



- Remove the top hardened cardboard protective fixations.
- Remove the top foam fixations.
- Remove the top front cardboard insert. There are various parts inside; be careful not to lose these when removing the cardboard insert.
- Remove the cardboard insert next to the nexttruder box.
- Remove the nexttruder box.

STEP 5 Removing the inserts



- Lift the two flaps on the side of the front cardboard insert, bend the vertical side down and remove the insert.
- Remove the box with Prusament on top.
- Remove the test print by carefully lifting the corner of the print sheet where the print is located. Slightly bending the print sheet like this will make the print snap out from the surface.

STEP 6 Removing the inserts



- There is a small cut-out in the top cardboard insert that locks it to the printer's frame. Pull it to unhook the insert.
- Unhook the protective cardboard strip that is wrapped around the X-axis.
- Printer parts are stored inside the top cardboard insert! Make sure not to lose them!
- Lift the whole insert and remove it.

STEP 7 Unpacking the printer



- Use the side handles on the printer to lift it up.
- Keep the bottom of the box in place by holding it down while you lift the printer up.
- ⚠ **Do not lift the printer by the top metal profiles!!!** Otherwise, you may warp the printer parts and damage the parts such as the LED lighting inside.
- ⚠ **Do not lift the printer alone;** ask someone to help you lift the printer by the handle on the side of the printer.

STEP 8 Printer is ready for setup

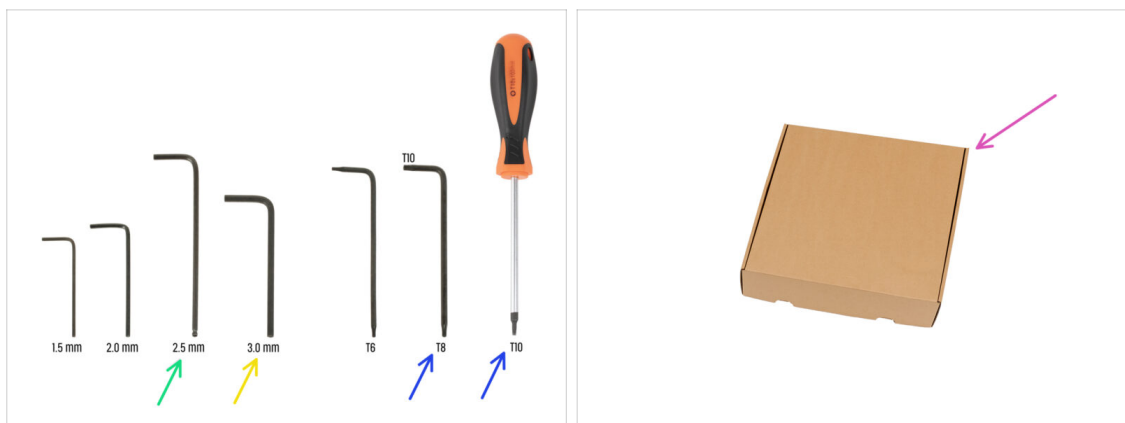


- Good job! The printer is ready for the next step:
- Visit chapter 3. **Printer set up.**

3. Printer set up



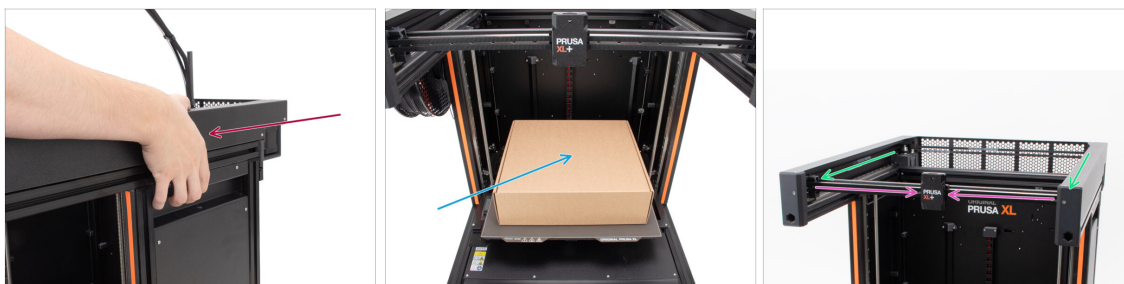
STEP 1 Tools necessary for this chapter



For this chapter, please prepare:

- TX 10 Torx key / T10 screwdriver
- 2.5 mm Allen key
- 3 mm Allen key
- Use a cardboard box as a heatbed protection during the setup. Use one of the Nextruder boxes that you received with your printer.

STEP 2 Preparing the printer



- Reminder: To handle the printer, **always grab the handles on both sides of the printer**. Do not lift the printer by the aluminum extrusions or the metal sheet profiles on top.
- Place the empty cardboard box approximately to the front center part of the heatbed.
- i** In the following steps, we will work with tools and install the extruder above the heatbed. Protect the print surface against any possible damage. An empty Nextruder box can serve this purpose.
- Manually move the X-axis assembly all the way to the front of the printer.
- Move the X-carriage approximately to the center of the X-axis.

STEP 3 Nextruder cable: parts preparation



● For the following steps, please prepare:

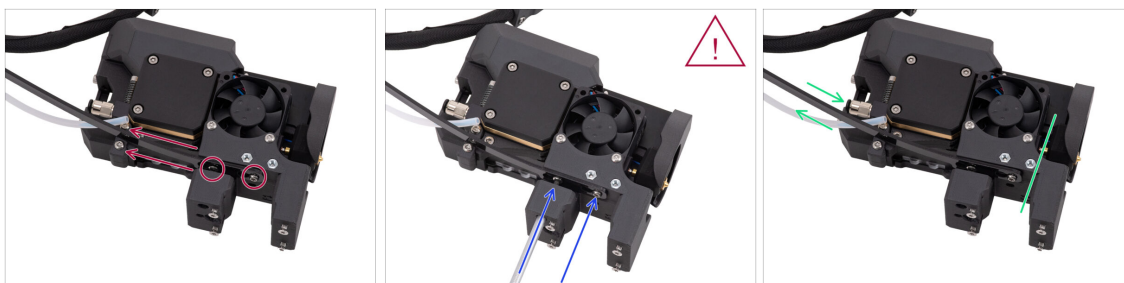
- Nextruder cable bundle (1x)
- Nextruder (1x)

STEP 4 Nextruder cable bundle assembly



- Using the T10 Torx screwdriver, loosen the two highlighted screws on the front side of the Nextruder. Don't unscrew them completely.
- Hook up the keyhole openings in the flexible plate of the cable bundle onto the loosened screw heads.
- Make sure the part of the bundle with the cable and the connector is facing the top of the Nextruder, as seen in the picture.
- ⚠ The cable bundle must be installed exactly the same way as in the picture; with the cable on top and the semi-transparent PTFE tube on the bottom.

STEP 5 Nextruder cable bundle assembly



- Pull the flexible line up so that the screws engage into the narrower part of the keyhole openings.
- ⚠ Verify both screws have engaged.
- While the screws sit in the narrower parts of the openings, tighten them up using the T10 Torx screwdriver.
- Verify the flexible part of the cable bundle is held tight to the extruder body.

STEP 6 Nextruder cable bundle assembly



- Insert the semi-transparent PTFE tube into the FESTO fitting on the nextruder.
Push it all the way in.
- Remove two M3x10 screws from the top of the Nextruder. Keep them close by as we will be using them shortly.
- Plug the cable connector to the top of the Nextruder.
- Secure the connector back with the two M3x10 screws we removed earlier.
- Good! Your Nextruder is prepared for the next step.

STEP 7 Installing the Nextruder: parts preparation



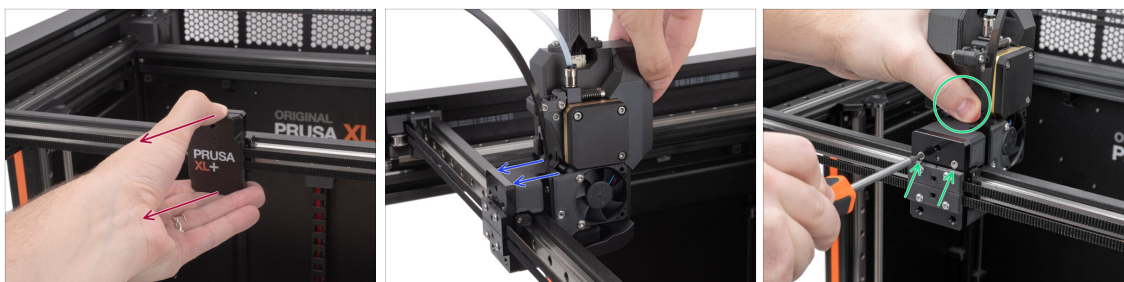
For the following steps, please prepare:

- Nextruder assembly (1x)

i Due to the careful testing of each printer before it is shipped, there may be a small filament residue on the Nextruder nozzle.

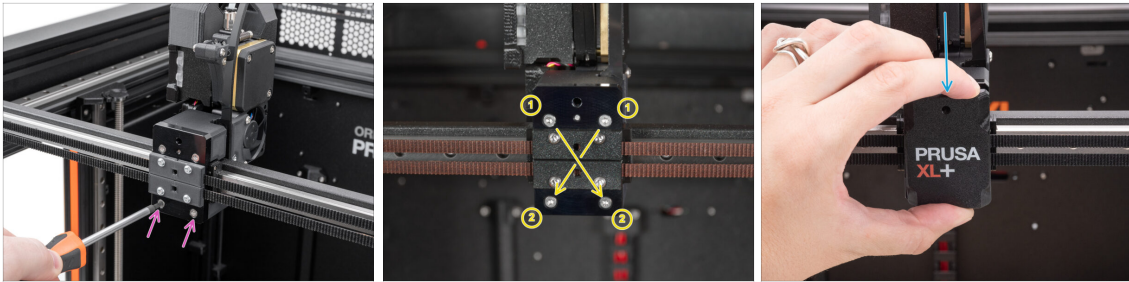
- Remove four M3x12bT (countersunk) screws from the front of the Nextruder body, and set them aside. You will need them in the next step.

STEP 8 Installing the Nextruder



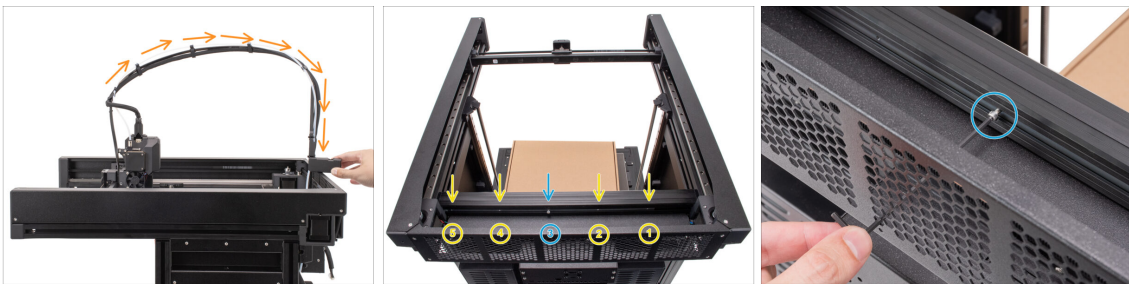
- Remove the x-carriage-cover from the X-carriage.
- From the back of the X-carriage, attach the Nextruder assembly to the X-carriage. See the correct orientation of the Nextruder.
- Hold the Nextruder and secure it by inserting and tightening the two M3x12bT screws we removed earlier into the top screw holes. **Do not fully tighten the screws at this moment!**

STEP 9 Securing the Nextruder



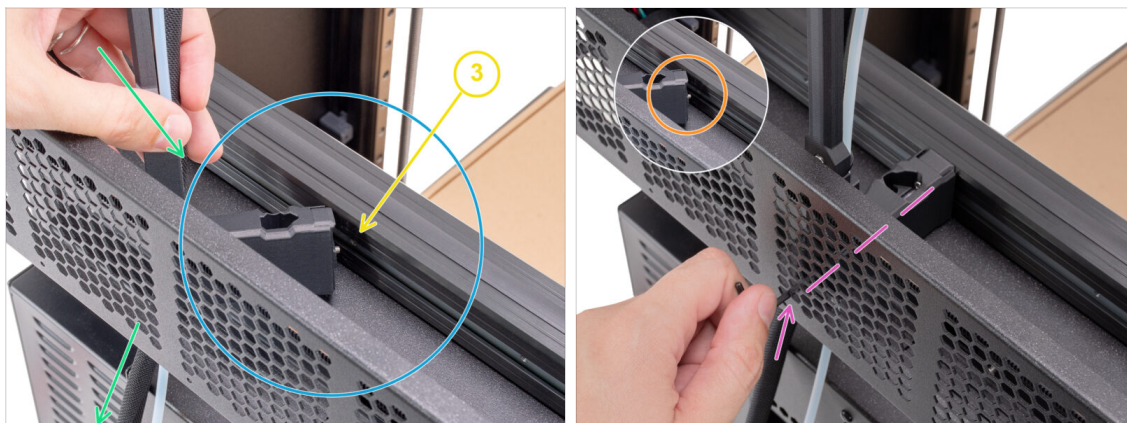
- ✦ Insert and tighten the other two M3x12bT screws to the lower holes in the X-carriage to secure the extruder assembly. **Do not fully tighten the screws at this moment!**
- ✦ After all screws are in place, tighten them in a diagonal sequence.
- ✦ Snap the x-carriage-cover back onto the X-carriage. You must feel a slight "click" to ensure the cover fits on the part.

STEP 10 Guiding the Nextruder cable



- ✦ Carefully rotate the printer 180° so that the PSU (Power Supply Unit) side is facing you.
- ✦ Guide the Nextruder cable bundle with the PTFE tube over the printer to its rear side.
- ✦ Locate the long metal profile with five M3 holes inside the rear aluminum extrusion.
- ⚠ **Maintain the position of the long metal profile for the next step. It must not move! If the metal profile moves, then push it all the way to the left and fix it in position with the screw.**
- ✦ Locate the screw in the long metal profile securing the part during transport. Using the 2.5 mm Allen key, remove the screw from the profile. You will not need it anymore, so keep it as a spare.

STEP 11 Attaching the Nextruder dock



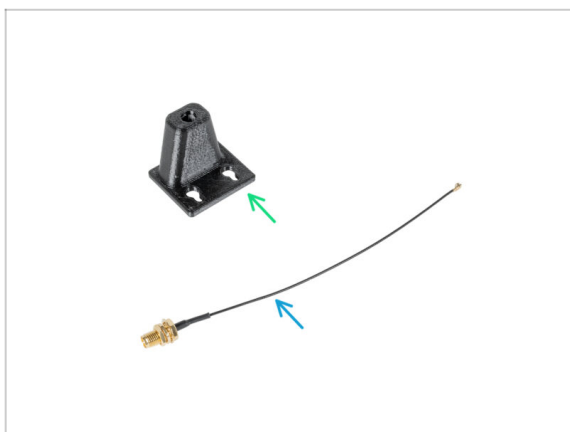
- Insert the dock assembly behind the rear metal sheet. Route the cable and the PTFE tube downward **behind the metal sheet**.
 - Place the XL-dock-cable-router on the bottom metal sheet at position 3 in the metal profile. (Where we removed the screw earlier.)
 - Align the protruding screw from xl-dock-cable-router with the third opening on the metal profile.
 - Push the 2.5 mm Allen key all the way through a hole (bottom left in the pattern) in the rear metal sheet as well as through the plastic part until you reach the middle screw in the xl-dock-cable-router. Tighten it up.
- i** **Tighten the screw firmly.** The dock is designed to be held in place by a press fit.

STEP 12 Guiding the extruder PTFE tube



- Locate the side filament sensor on the side of the printer. Insert the free extruder PTFE tube as far as you can into the top hole of the filament sensor.
- Gently pull the PTFE tube back, this will push out the black collet in the side filament sensor and lock the tube.

STEP 13 Wi-Fi antenna holder: parts preparation

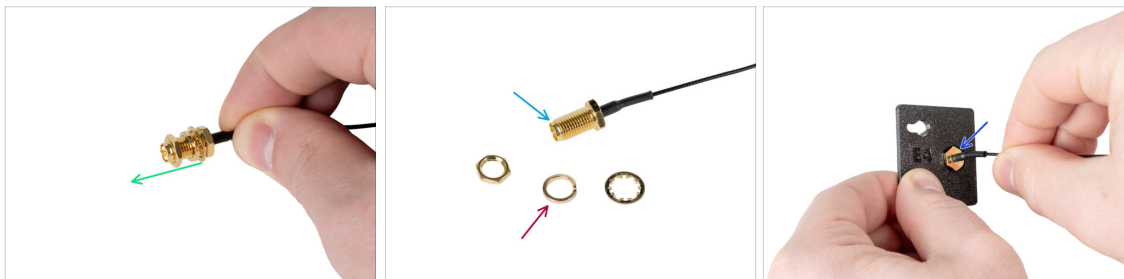


● For the following steps, please prepare:

● Wi-Fi-antenna-holder (1x)

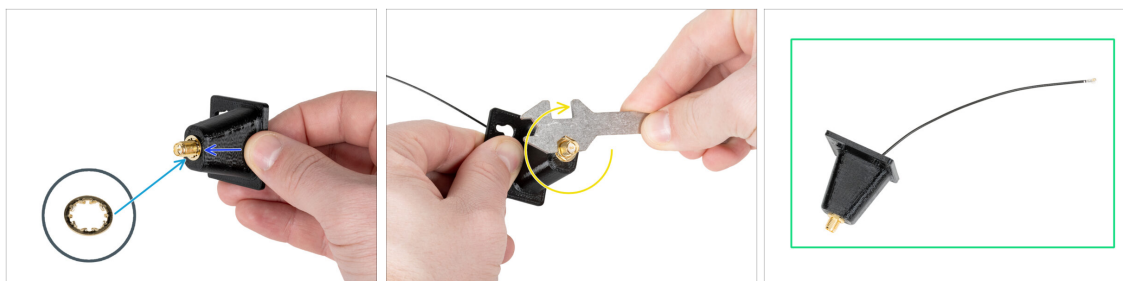
● Antenna cable (1x)

STEP 14 Installing the Wi-Fi antenna: antenna preparing



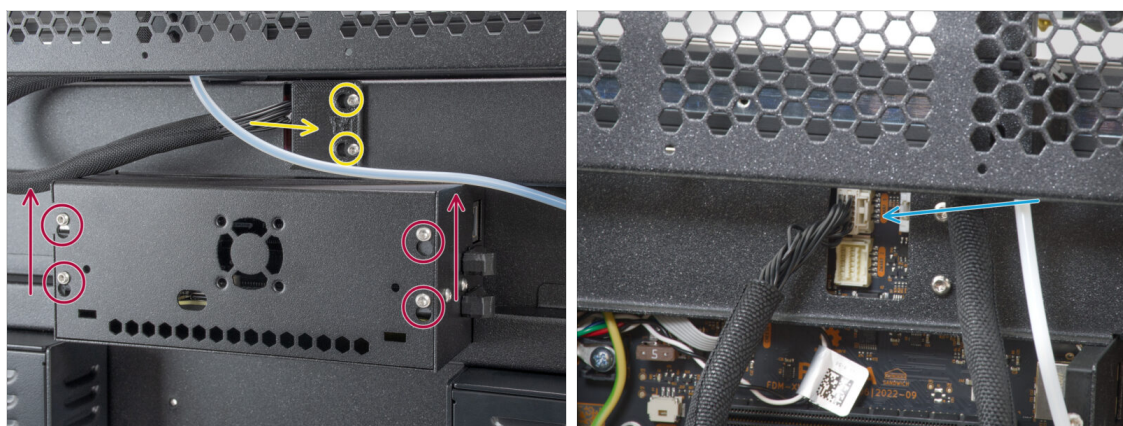
- Remove the nut with the washers from the antenna connector.
- The antenna connector is prepared.
- The latest version of the connector has a thicker washer. We do not need it anymore, and you can dispose of it.
- Insert the antenna connector into the same-shaped hole in the Wi-Fi-antenna-holder .

STEP 15 Installing the Wi-Fi antenna: antenna preparing



- Push the antenna connector through the Wi-Fi-antenna-holder.
- Insert the thinner lock washer back onto the connector.
- Using the universal wrench, tighten the nut on an antenna connector.
- Good job! The Wi-Fi antenna is prepared.

STEP 16 Connecting the extruder cable



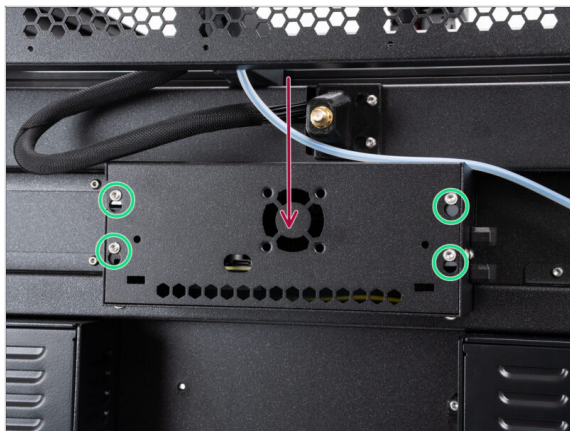
- Locate the xl-rear-cable-management-plug (cover) on the rear of the printer.
- Loosen two screws on the cover slightly. No need to remove them completely. Slide the cover to the right and remove it from the printer.
 - The cover will no longer be needed.
- Loosen four screws securing the electronics cover. Remove the cover.
- Connect the dock cable to the upper slot labeled DWARF 1.

STEP 17 Installing the Wi-Fi antenna holder



- ✦ Push the antenna cable through the opening in the cable cover (metal sheet) and guide it behind the cover to the electronics box.
- ✦ Attach the antenna-holder on the screws and slide the cover to the left. Tighten the screws.
- ✦ Gently, but firmly, connect the antenna cable with the antenna connector on the XL buddy board.
- ❗ Support the board from below with your finger while attaching the antenna cable to prevent damaging the board.

STEP 18 XL buddy box covering



- ✦ Your text goes here
- ⚠ Be carefull, do not pinch any cables!
- ✦ Put the XL-buddy-box-cover back on the printer. Make sure the screws all sit in the more narrow part of the openings.
- ✦ Tighten the four screws.

STEP 19 Installing the Wi-Fi antenna: parts preparation



● For the following steps, please prepare:

● Wi-Fi antenna (1x)

STEP 20 Installing the Wi-Fi antenna



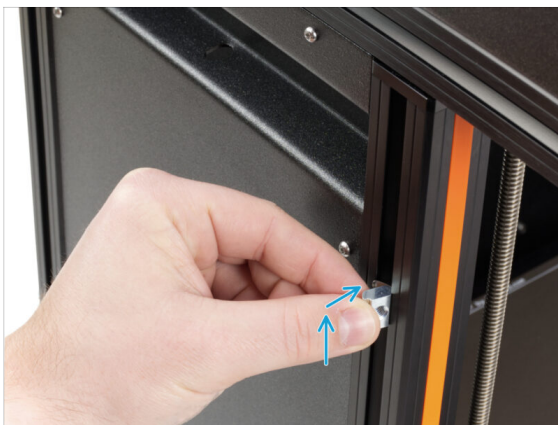
- Locate the Wi-Fi antenna connector in the middle of the printer.
- Screw the Wi-Fi antenna on the antenna connector. The antenna can be rotated around and bent in two directions.
- We recommend pointing the antenna straight upwards.
- Well done! With the Wi-Fi antenna installed, let's move on to the spoolholders in the next step →

STEP 21 Universal spool holder: parts preparation



- For the following steps, please prepare:
- O-ring (1x)
- Puck-universal (1x)
- Spool-holder-static (1x)
- M4nEs nut (1x)
- M4x12 screw (1x)

STEP 22 Adjusting the spool holder nut



- Carefully turn the printer so that the left side is facing you.
- Insert the first M4nEs nut into the front support extrusion (with the orange plastic cover).
- Insert the side with the spring (metal plate) first, then push the nut inside.
- The M4nEs nuts can move freely. Adjust their position as needed and push them slightly inward to move them smoothly. Refer to the image for the recommended placement.

STEP 23 Mounting the puck-universal



- Insert the M4x12 screw into the Puck-universal.
- Align the the Puck-universal with the M4nEs nut.
- ⚠ **Note the tabs** on the part. They must **fit into the groove in the aluminum extrusion**.
- Tighten the screw firmly using a 3.0 mm Allen key.
- ⓘ Once tightened, the position can no longer be adjusted.

STEP 24 Installing the spoolholder



- Put the O-ring onto the Spoolholder-static.
- Push the Spoolholder-static into the Puck-universal dock.
- Lock the Spoolholder-static it in by turning it clockwise.
- Congratulations. You have successfully installed the spoolholder!

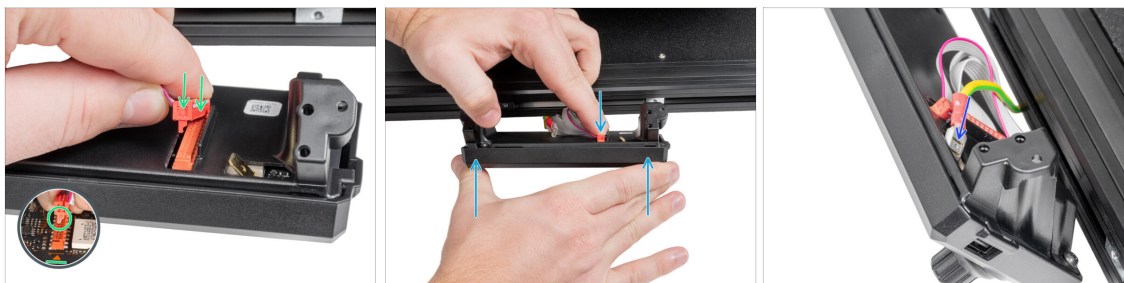
STEP 25 xLCD: parts preparation



● For the following steps, please prepare:

- xLCD assembly (1x)
- M3x10 screw (2x)

STEP 26 Connecting the xLCD cables



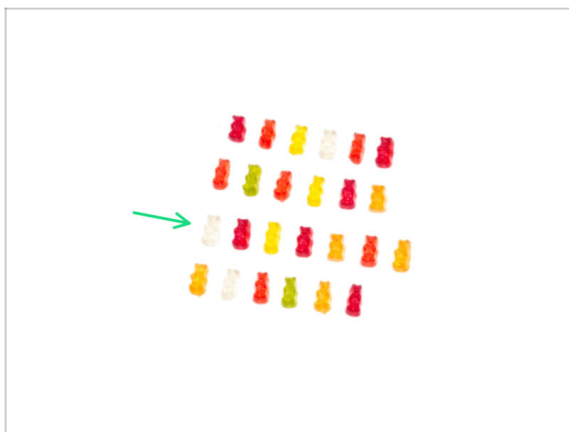
- Connect the xLCD cable to the slot on the xLCD board.
 - ⓘ There is a latch on the xLCD cable connector, which must be facing the triangle symbol on the board. See the picture.
- Push the xLCD cable connector to fully connect to the xLCD. Hold the xLCD cover.
- Push the grounding connector fully into the PE faston.

STEP 27 Mounting the xLCD



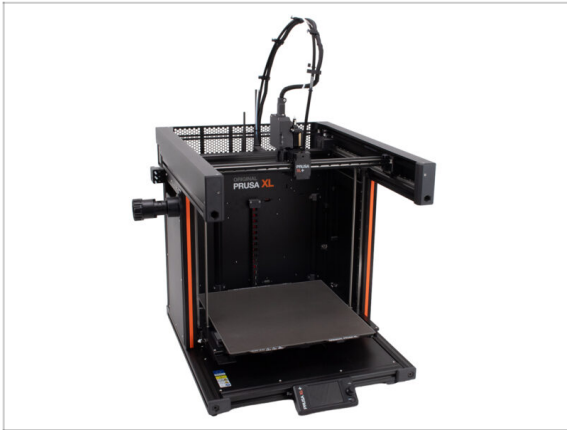
- Align the xLCD assembly with the nuts in the front aluminum extrusion.
- Insert and tighten the M3x10 screw from the right side of the xLCD.
- Insert and tighten the M3x10 screw from the left side of the xLCD.
- The injection-molded xLCD is mounted and ready.

STEP 28 Reward yourself



- Great job! Reward yourself with another row of gummy bears.●Great job! Reward yourself with another row of gummy bears.
- Eat the third row: seven gummy bears.
- Did you know that the bright colors of gummy bears are achieved through the use of food coloring, which adds to their visual appeal?

STEP 29 Almost done!



- ◆ **Congratulation!** Your Original Prusa XL is ready to be fired up!
- ◆ Compare the final look with the picture.
- ◆ Now, let's go to the last chapter **4. First run.**

4. First run



STEP 1 Before you start with Single-Tool



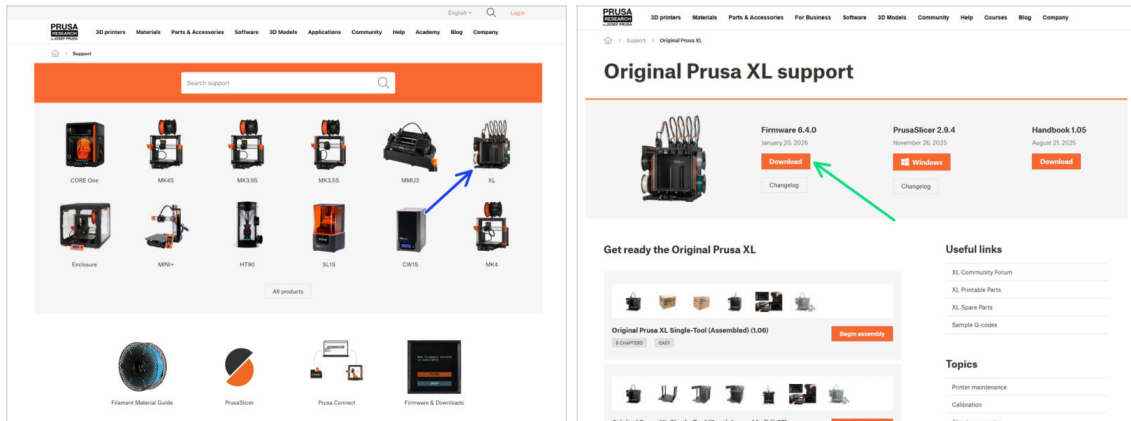
- ⓘ This chapter shows a brief description of the wizard. Please note that the screenshots are illustrative and might differ from those in the firmware.
- ⓘ Make sure you are running **Firmware 6.2.4 or newer**

STEP 2 Preparing the printer



- ⚠ Make sure that the printer is placed in a stable place where no ambient vibrations are transmitted (for example, where other printers are printing).
- 🟡 From the rear side of the printer, plug in the PSU cable.
- 🟢 Turn the power switch ON (symbol "I").

STEP 3 Firmware update



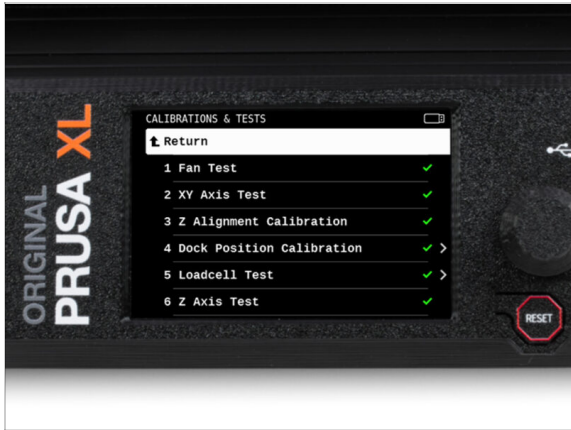
- ❗ All shipped printer packages include a USB drive with the latest firmware. However, it is recommended to check and possibly upgrade the firmware version.
- 🛒 Visit the help.prusa3d.com page.
- 🔵 Navigate to the Prusa XL page.
- 🟢 Save the firmware file (*.bbf*) onto the *bundled USB drive*.
- ❗ Pro tip: To access Prusa XL homepage you can use the URL: prusa.io/XL

STEP 4 Wizard: Network and Prusa Connect setup



- ❗ After the printer starts up, the screen prompts for the printer test and setup wizard.
- 🛒 The initial setup starts with the optional NETWORK SETUP, which also includes PRUSA CONNECT SETUP. Follow the instructions on the screen if you want your printer connected to Wi-Fi and Prusa Connect.

STEP 5 Wizard: Calibration tests



 The wizard will test all important components of the printer. Some parts of the wizard require direct user interaction. Follow the instructions on the screen.

 **WARNING: Do not touch the printer during the wizard unless prompted! Some parts of the printer may be HOT and moving at high speed.**

 The wizard starts with these tests:

- Fan test
- X-axis and Y-axis test
- Z-axis alignment calibration

● These first tests are fully automatic during the first calibration.

 **While testing the axes, make sure that there is nothing in the printer that is obstructing the movement of the axes.**

STEP 6 Wizard - Test Loadcell



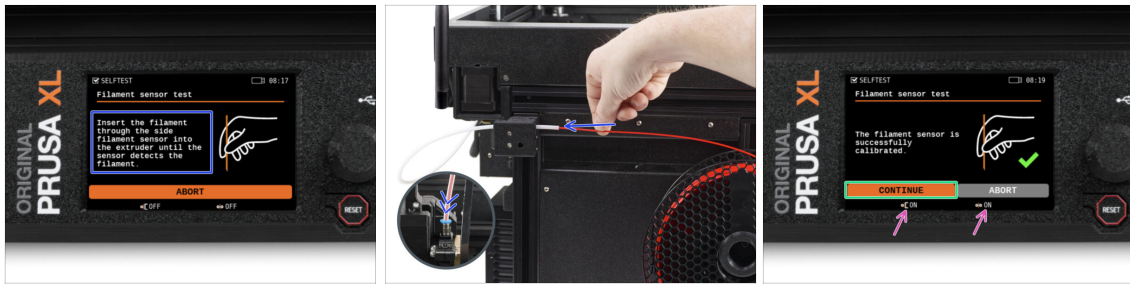
- ◆ The next step of the wizard will prompt you to touch the nozzle to test and calibrate the Loadcell. During this procedure, the parts of the printer are not heated, you can touch the parts of the printer. Click on **Continue**.
- ◆ **Do not touch the nozzle yet.** Wait until the countdown finishes and the printer notifies you with a sound and display prompt.
- ◆ Tap the nozzle gently but firmly. Do not use excessive force. In case the loadcell does not detect your touch, you will be prompted to repeat the step.
- ❗ After this step, proceed to the **Z Axis test** and the **Nozzle heater test**, respectively. These two tests are automatic and require minimal input.

STEP 7 Wizard - Calibrate Filament Sensors part 1



- ◆ During the calibration of the filament sensors, you will be prompted to use at least 130 cm of filament. Use the Prusament shipped with your printer and mount it on the spool holder.
- ◆ When you have prepared the filament, click on **Yes**.
- ◆ Do not insert the filament into the side filament sensor and the tool head. If the side filament sensor is empty, click on **Continue**.

STEP 8 Wizard - Calibrate Filament Sensors part 2



- ◆ Insert the filament into the side filament sensor through the PTFE tube. Push it in until it reaches the filament sensor in the extruder (you will feel a slight resistance).
- ◆ You can check the side filament sensor (left) and extruder filament sensor (right) status on the bottom bar on the screen.
- ◆ At the end of the test, you will be prompted to **remove the filament from the sensor**.
- ◆ The filament sensor is successfully calibrated and tested. Click on **Continue**.

STEP 9 Wizard: Phase stepping



- ◆ **The last step is the phase stepping calibration.** This feature was introduced in firmware version 6.0.0. The calibration is automatic. Follow the instructions on the screen.
- ❗ You can find more information about the phase stepping via the following links:
 - 📌 **PHASE STEPPING GUIDE:** Necessary information about the phase stepping calibration.
 - 📌 **PHASE STEPPING BLOG ARTICLE:** A more in-depth look at the phase stepping feature.
- ❗ The printer will move the first print head to the middle of the heatbed and move the tool diagonally for the X and Y axes at different speeds.
- ◆ After the printer completes the test, the screen will show by how much the motor vibrations were reduced.

STEP 10 It's done



- Manually remove the filament from the printer. And click on *Continue*.
- ⬛ **Well done! The printer is ready to print.** However, follow the instructions in this manual to the end.

STEP 11 Quick guide for your first prints

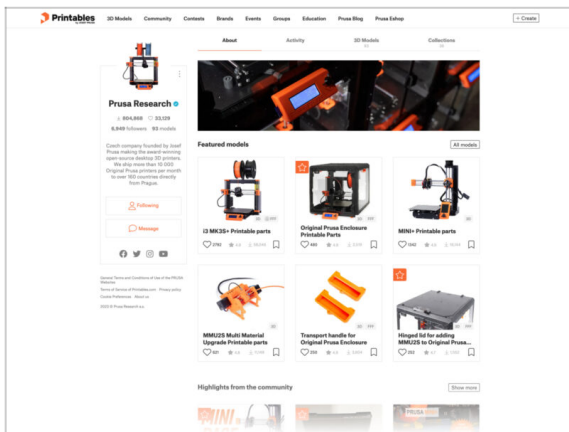


Now, please read the **3D Printing Handbook**, which is tailor-made for your printer and **follow the instructions to set up the printer properly**. The latest version is always available at **this link**.



*Read the chapters **Disclaimer** and **Safety instructions**.*

STEP 12 Printable 3D models



- ◆ **Congratulations! You should be ready to print by now ;-)**
- ◆ You can start by printing some of our test objects bundled on the included USB stick - you can check them out in this collection.

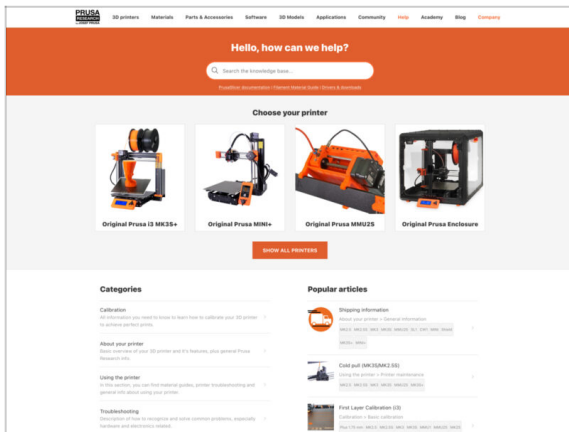
STEP 13 Give us feedback



- ◆ We know you're eager to start printing, but we'd really appreciate it if you could take 3-4 minutes to **share your thoughts** on this manual: how clear it was, how easy it was to follow, and any ideas to improve it.
- ① This feedback is a little different from the usual comments you might leave on individual steps.
- ◆ **Share your feedback here.**
- ◆ Thank you for helping us make our manuals even better!

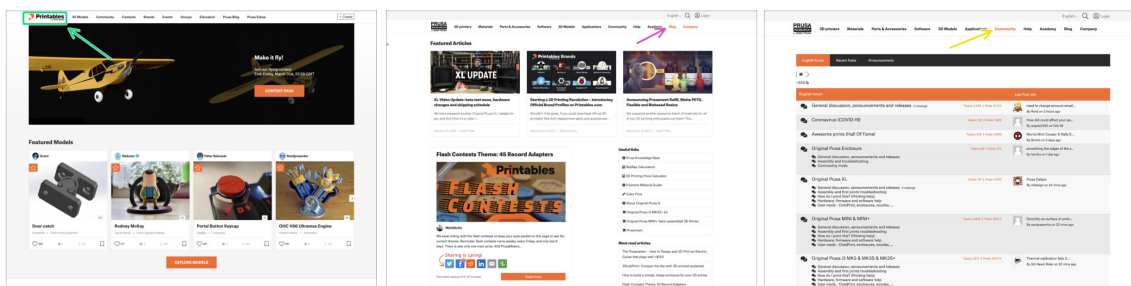
4. First run

STEP 14 Prusa knowledge base

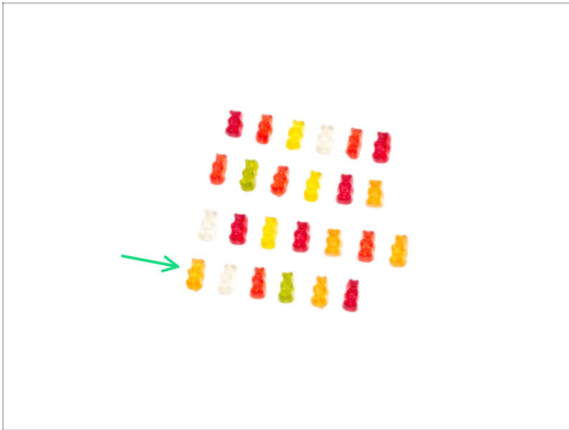


- If you encounter any problems at all, don't forget you can always check out our knowledge base at help.prusa3d.com
- We're adding new topics every day!

STEP 15 Join Printables!

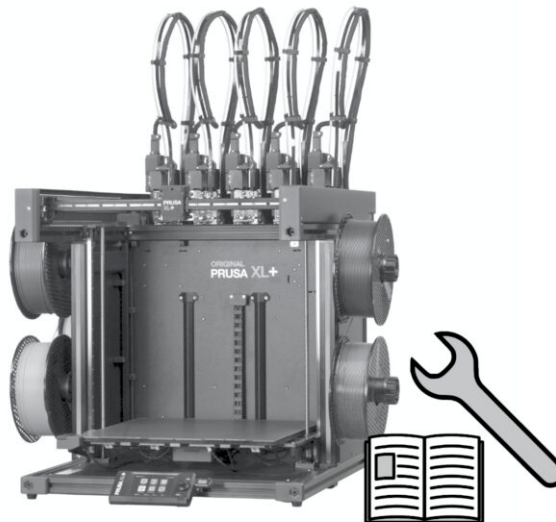


- Don't forget to join the biggest Prusa community! Download the latest models in STL or G-code tailored for your printer. Register at [Printables.com](https://printables.com)
- Looking for inspiration on new projects? Check our blog for weekly updates.
- If you need help with the build, check out our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

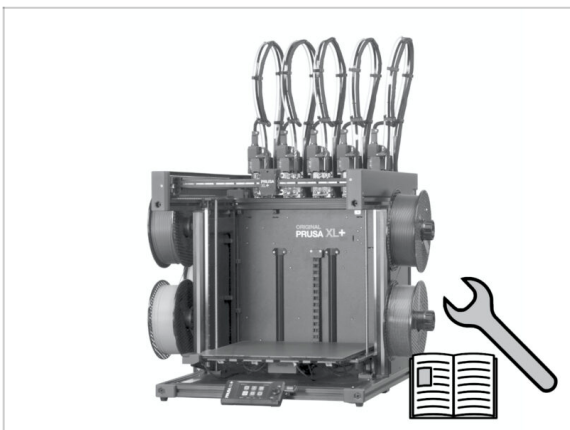
STEP 16 Haribo time!

- ◆ **Congratulations! You did it.** The printer should already be up and running, and you can enjoy the last row of gummy bears: six gummy bears.
- ⓘ **Disclaimer:** You have a lot of gummy bears left. **Do not eat all the leftover gummy bears all at once by yourself now!** As much as it sounds like fun, trust us... You do not want to **bear** the consequences.
 - ◆ We recommend re-sealing the bag and placing it near the printer while making sure to protect the Haribo from heat and moisture. You can have a few anytime your printer is heating up, or you are eagerly waiting for your project to finish printing.
- ⓘ Did you know that gummy bears have a long shelf life? Typically lasting for up to two years if stored properly in a cool and dry place. But don't test that with our gummy bears.

Manual changelog



STEP 1 Version history



- **Versions of the Prusa XL+ (assembled) manual:**
- 08/2026 - Initial version 1.00

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[illegible]

[illegible]

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