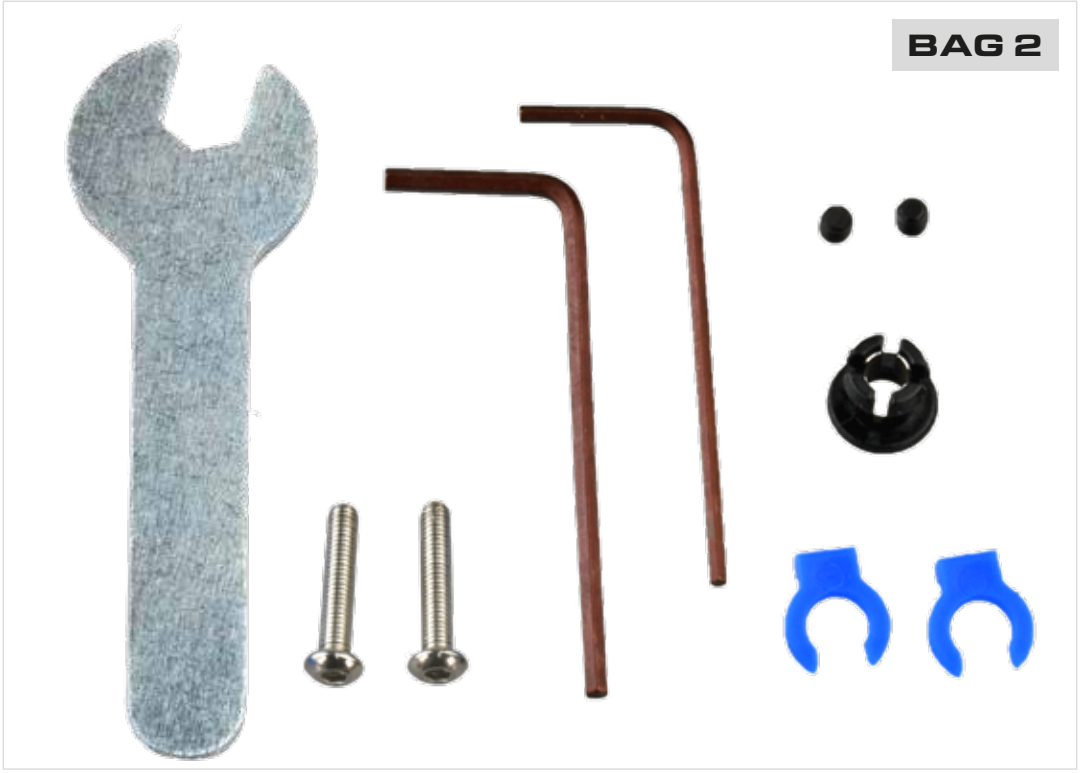
DIRECT DRIVE EXTRUDER
ASSEMBLY INSTRUCTION

Thank you for purchasing the Direct Drive Extruder. When you open the package, you will see the following parts.

BAG 1

M5x20 Half round head hexagon socket stainless steel screw (Anti Falling Glue)	2pcs
M5x30 Half round head hexagon socket stainless steel screw	1pcs
M5 Tightening nut	1pcs
M3x10 Half round head hexagon socket stainless steel screw	2pcs
M3 Nut	2pcs
M3x6 Countersunk head hexagon socket stainless steel screw	3pcs
M5x10x1 Gasket	1pcs
M4 Open – ended Bowden collect	1pcs
2*4 50mm Teflon	1pcs

BAG 2



Bowden Collect	1pcs
Collect Clip	2pcs
H1.5 Hexagon Rod	1pcs
M3x16 Pan head hexagon socket stainless steel screw	2pcs
H7 Open – ended wrench	1pcs
M3x3 Cone head hexagon head screw	2pcs
H2.0 Hexagon Rod	1pcs

BAG 3

Heatblock	1pcs
Brass tube	1pcs
M3x3 Head screw	2pcs
M2 Cup head screw	2pcs
Valve bag	1pcs

Spring wire diameter 0.8, outer diameter 7.6, length 17	1pcs
M3 Hand screw nut	1pcs
Active extrusion wheel	1pcs
Lock screw	1pcs
CBDR4-9-M3*4	1pcs
M3x2 Head screw	1pcs

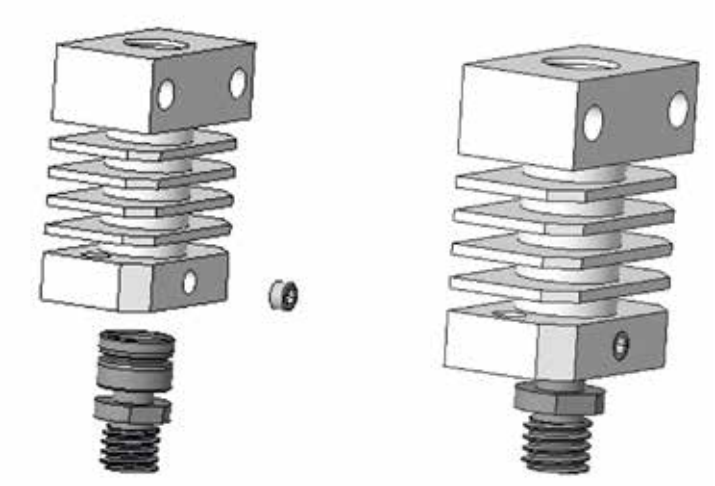
Heatsink	1pcs
Bowden collect	1pcs
Heatbreak	1pcs
Valve bag	1pcs

Lock swing arm	1pcs
Driven extrusion wheel	1pcs
Pin rod	1pcs
Needle roller bearing	2pcs
Tie 2.5*100	5pcs
Nozzle – Plated copper	1pcs
PH2.0 male and female head extension cord, 680mm long, 6 pin 4 lines, black	1pcs
Backboard	1pcs
Adapter1pcs	
Bowden collect	1pcs
Collect clip	1pcs

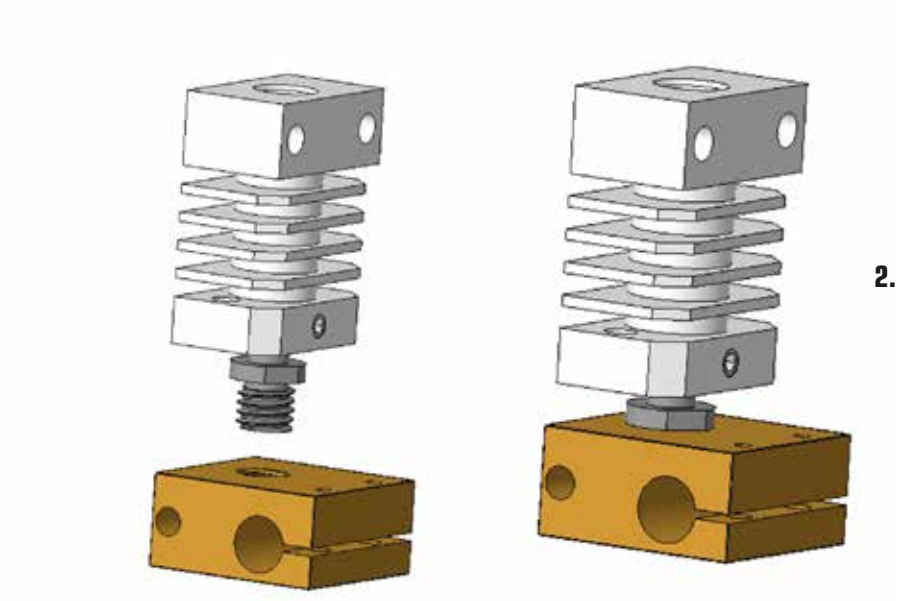
Tools Needed

H2.0 Hexagon rod | H7 Open – ended wrench | H1.5 Hexagon rod

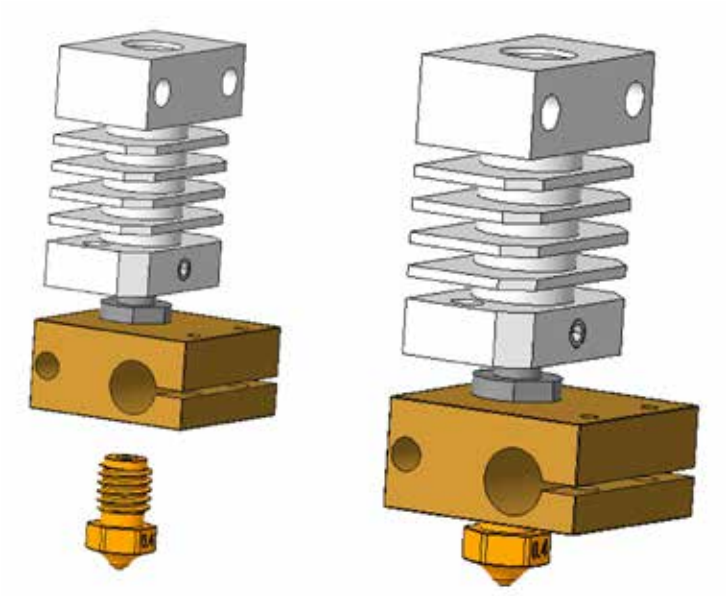
HOTEND ASSEMBLY
Normal Assembly



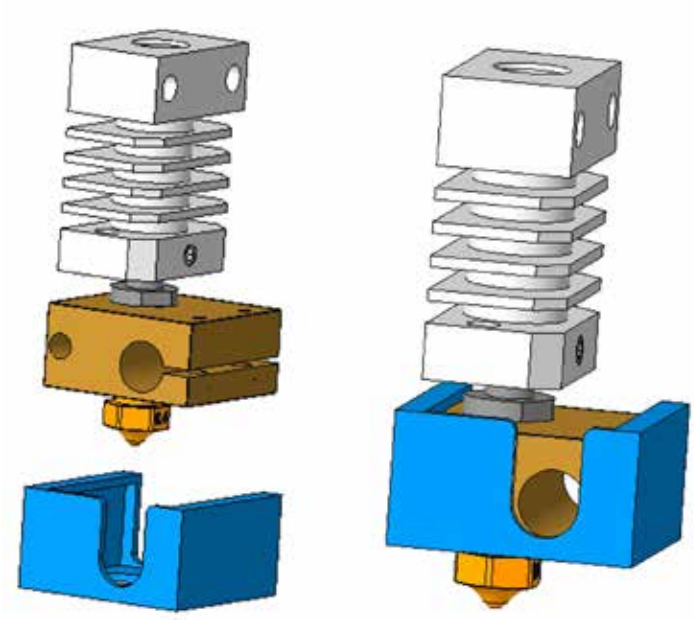
1. Install the heatbreak on the heatsink and lock the head screw.



2. Insert the heatblock into the heatbreak.

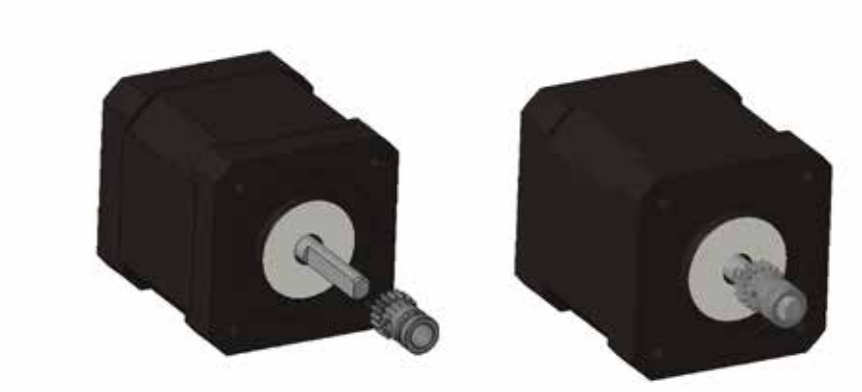


3. Screw the nozzle into the heatblock.

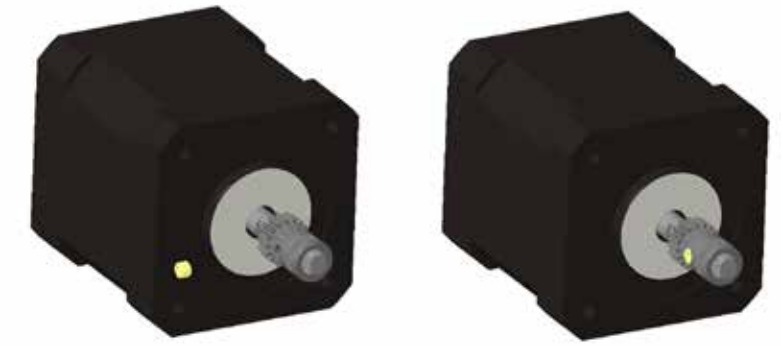


4. Install the silicone sock. (Before this step, you could install heating rods and thermistors first).

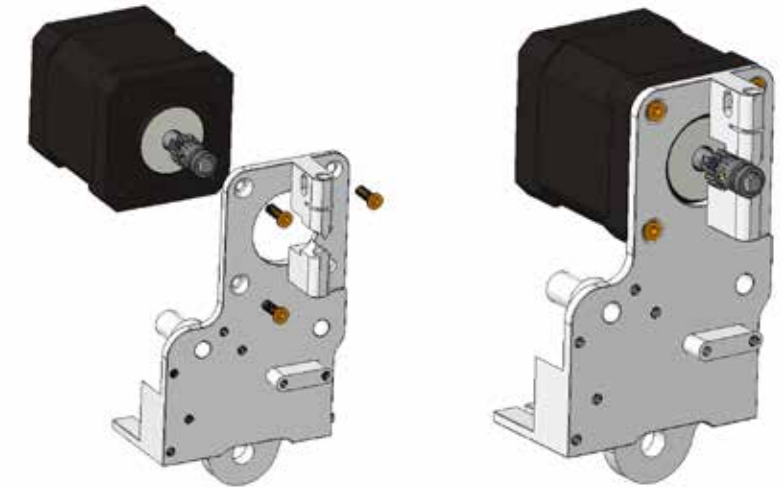
INTEGRAL ASSEMBLY
Normal Assembly



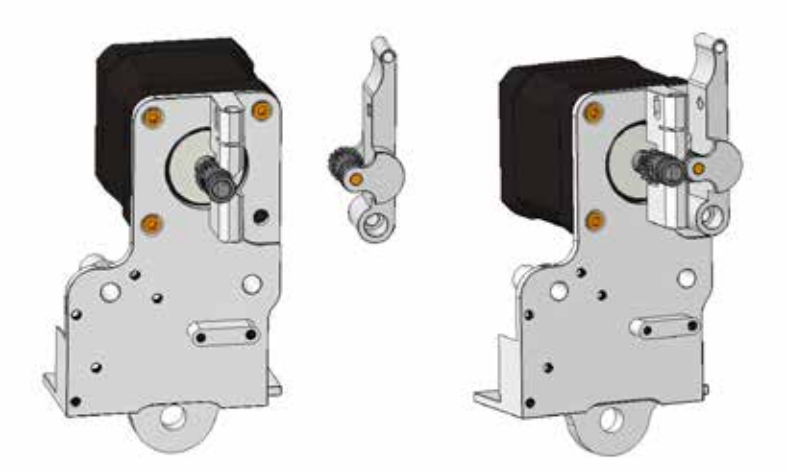
1. Install the extrusion wheel on the shaft of the stepping motor (self-provided) of 42, and the threaded hole faces the plane of the motor screw.



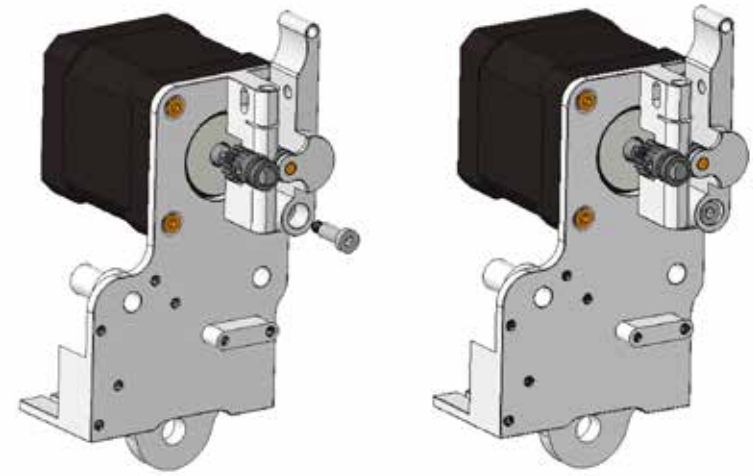
2. Lock the head screw of M3*2 and prefix the extrusion wheel.



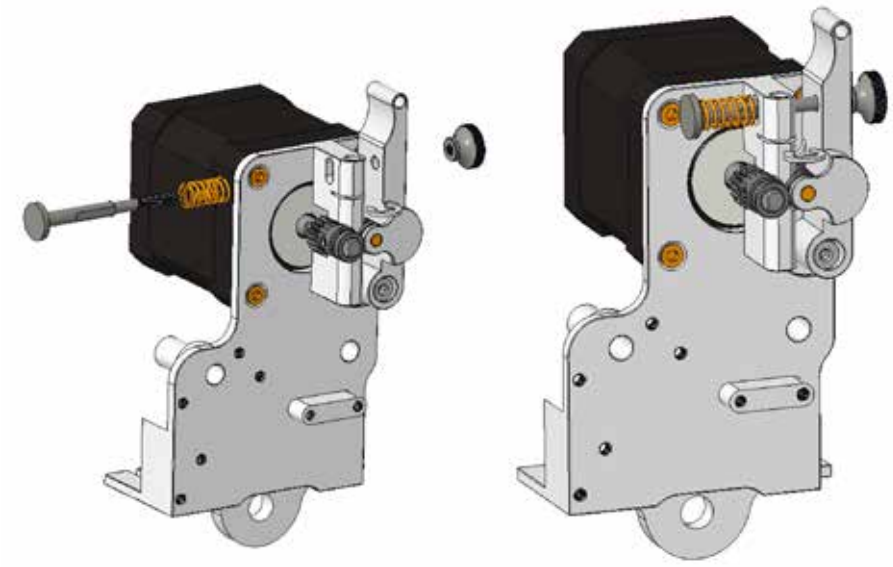
3. Lock the motor into the backplane through three countersunk screws.



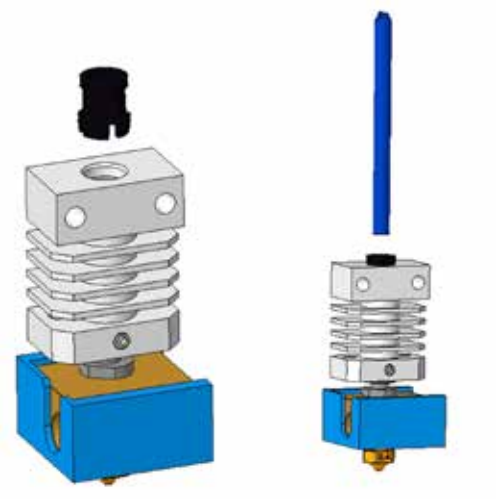
4. Align the countersunk holes on the swing arm with the four holes of the motor.



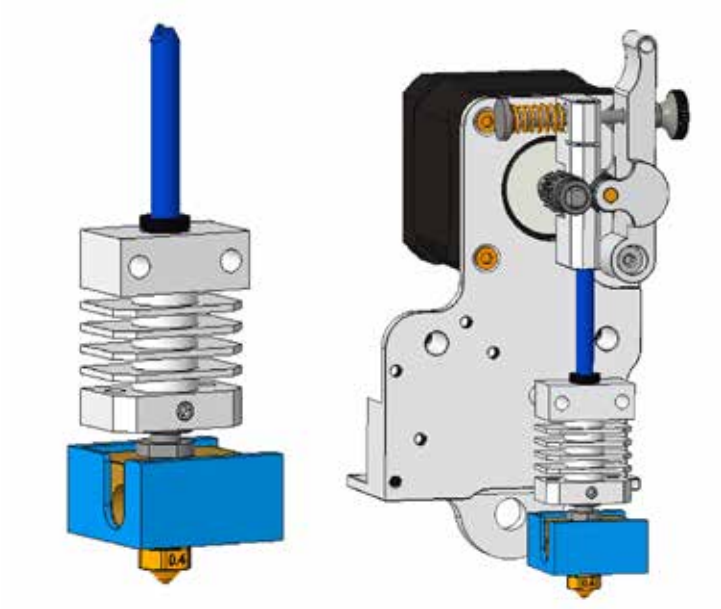
5. Lock step screws. Adjust the relative position of the active extrusion wheel on the motor and the driven extrusion wheel on the swing arm to make the front and rear positions consistent, then lock the head screw of the active extrusion wheel on the motor (M3*2).



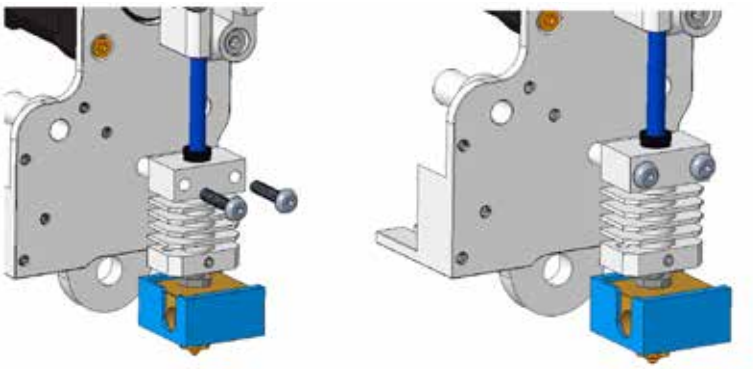
6. Install adjusting screws, respectively through the spring, backplane and swing arm, and then fix the hand screw nut.



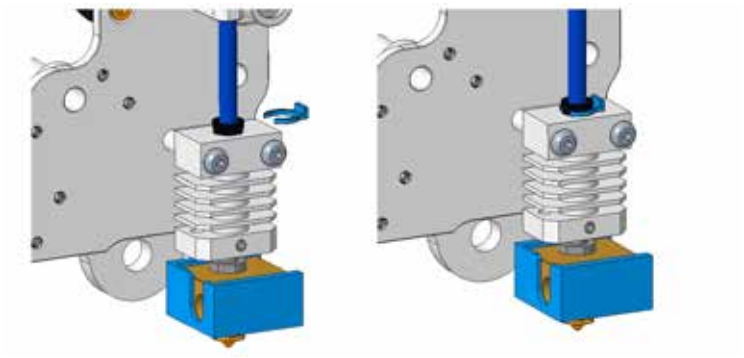
7. Install bowden collect on the hotend and the Teflon tube.



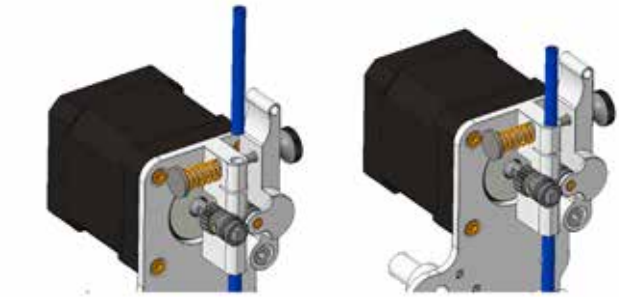
8. Insert the hotend with Teflon tube into the backplane.



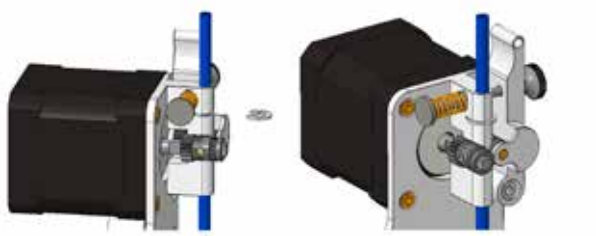
9. Install two M3*16 screws to secure the hotend to the backplane.



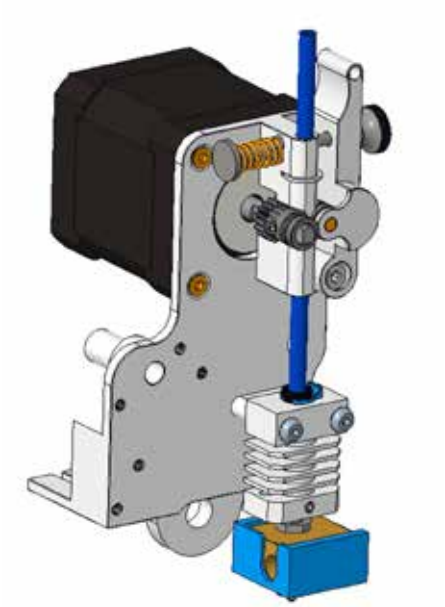
10. Adjust the direction of the Teflon tube so that the cut at the place of the extrusion wheel is consistent with the backplane.



11. Insert Teflon tube into the upper end of the backplane (self-provided).



12. Insert the E-type spring into the cut on the backplane to fix the Teflon tube.



13. After installation the component should be the same with the picture.

14. The breakdown diagram of the whole product.