

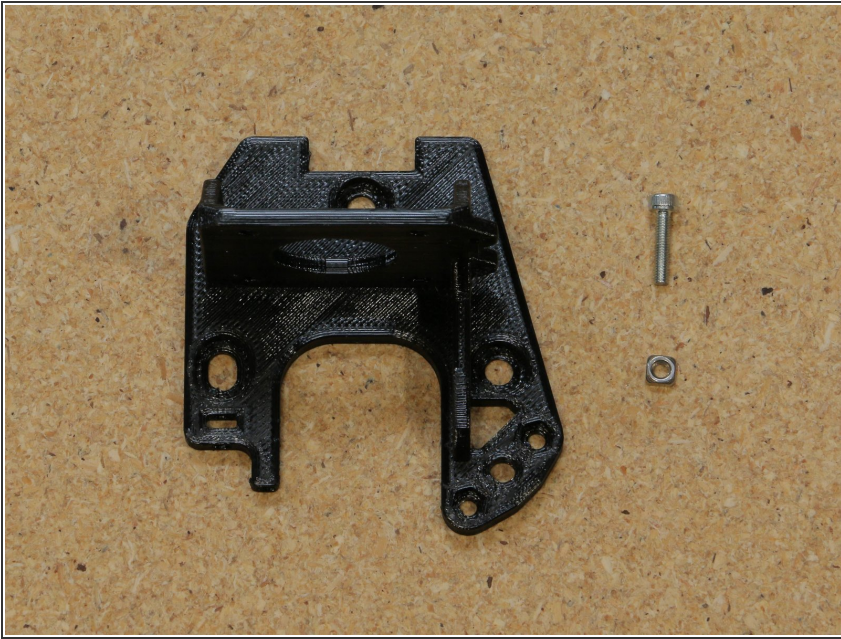


Section 1.6: Print Carriage and Gantry

Written By: Leland Crowther

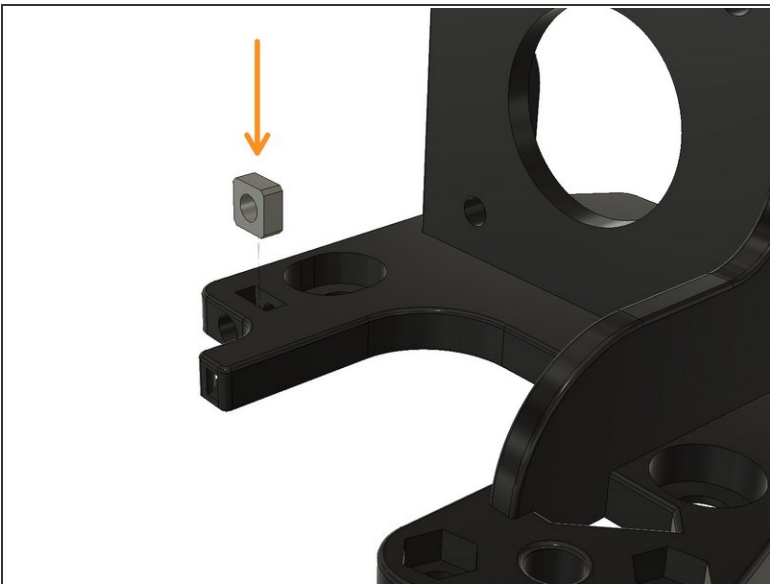


Step 1 — Prepare Parts



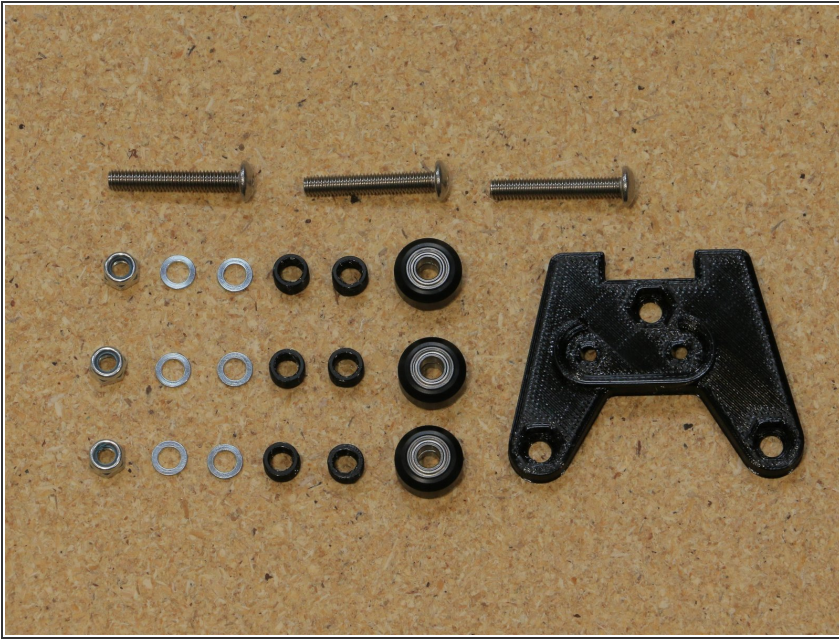
- Print Carriage (top) 13A (1x)
- M3x12 button head cap screw (1x)
- M3 Square Nut (1x)

Step 2 — Prepare Print Carriage to Assemble (Pt 1)



- Insert M3 square nuts into carriage top and bottom.
- Insert M3x12 screw into print carriage base.

Step 3 — Prepare Parts



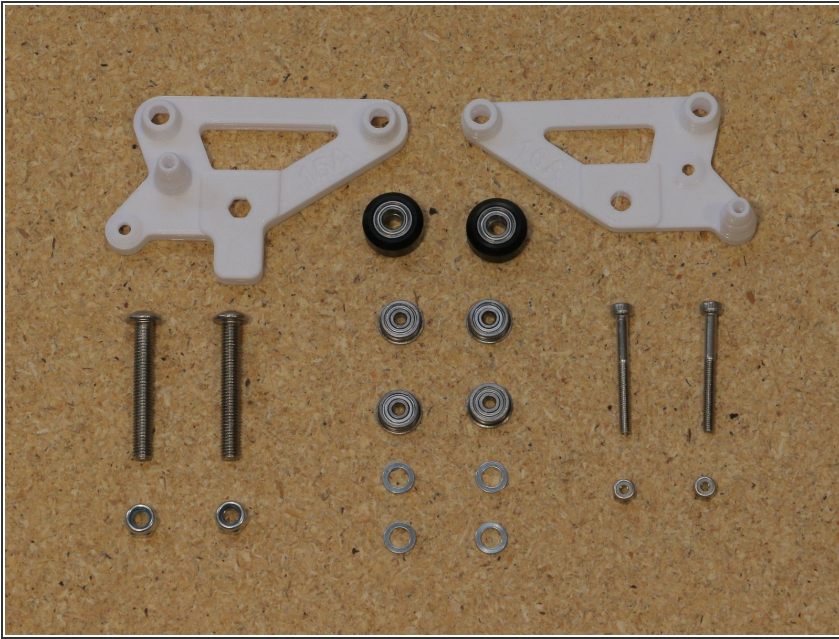
- Print carriage (bottom) 14A (1x)
- Mini V Wheel (3x)
- M5 5.6mm Spacer (6x)
- M5x30 button head cap screw (3x)
- M5 Nylock Nut (3x)
- OpenBuilds precision shim (x6)

Step 4 — Assemble Print Carriage



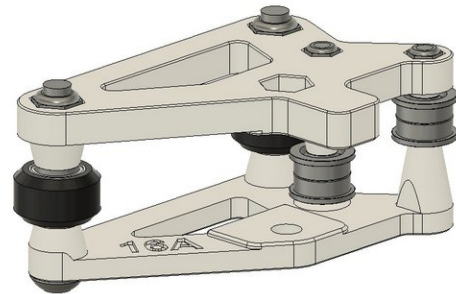
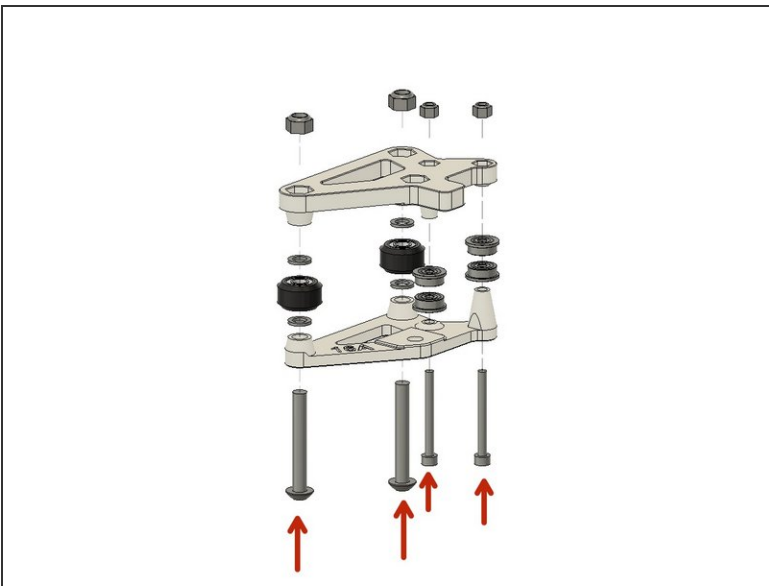
- Assemble carriage

Step 5 — Prepare Parts



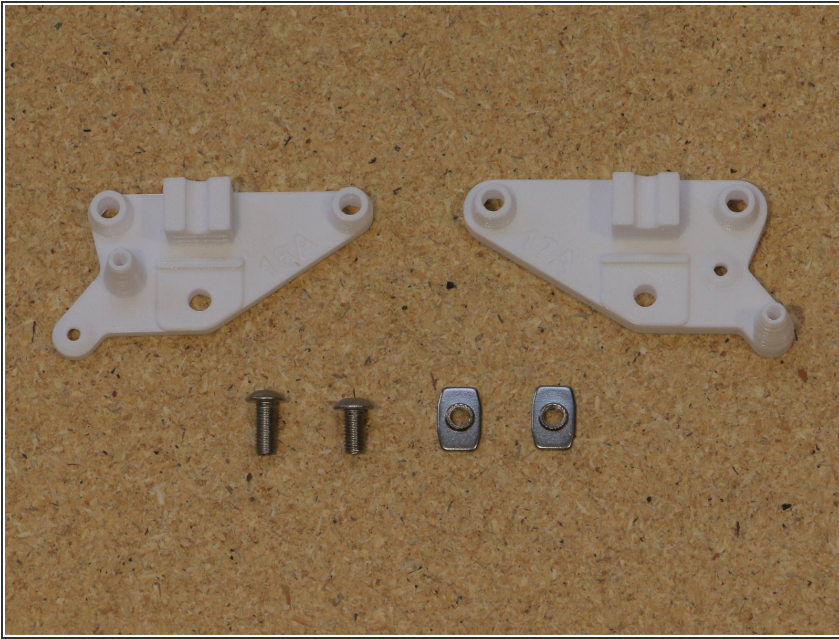
- Y Carriage (top) L 15A (1x)
- Y Carriage (bottom) L 16A (1x)
- Mini V Wheel (2x) OpenBuilds Precision Shim (4x)
- F623ZZ Bearing (4x)
- M5x35 button head cap screw (2x)
- M5 Nylock Nut (2x)
- M3x30 socket head screw (2x)
- M3 Nylock Nut (2x)

Step 6 — Assemble Y Carriage (Left)



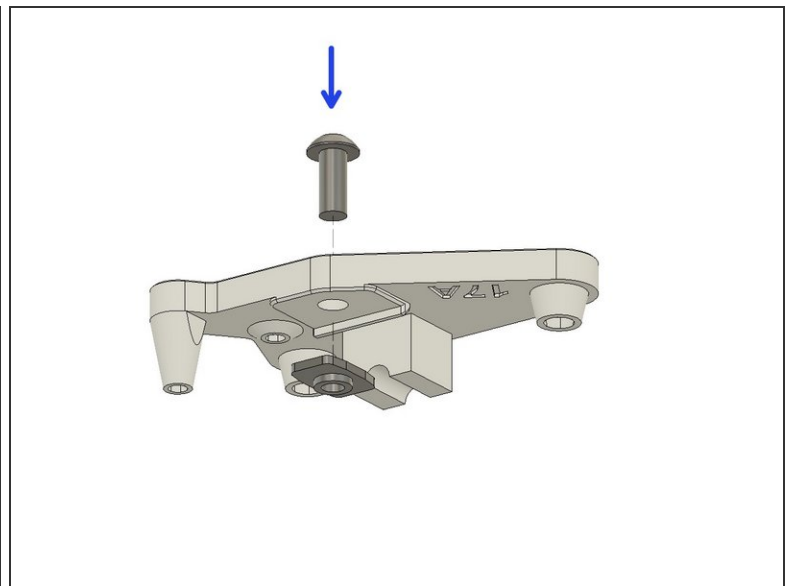
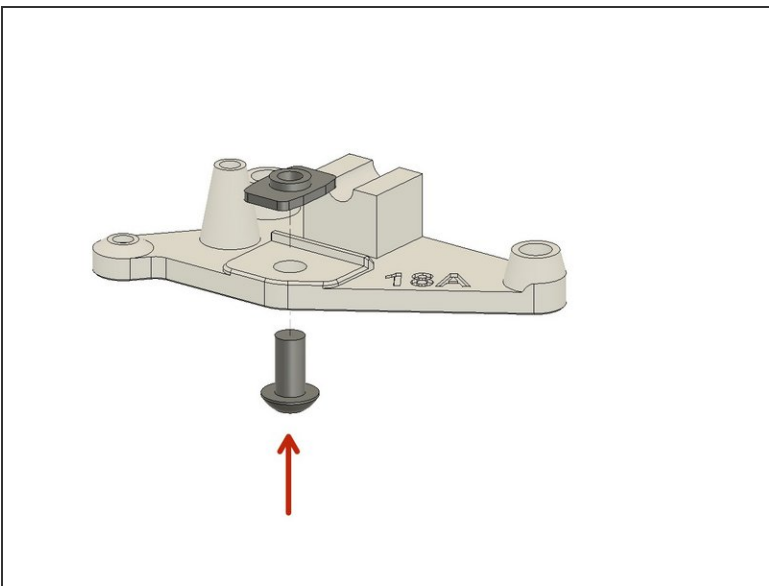
- Assemble carriage

Step 7 — Prepare Parts



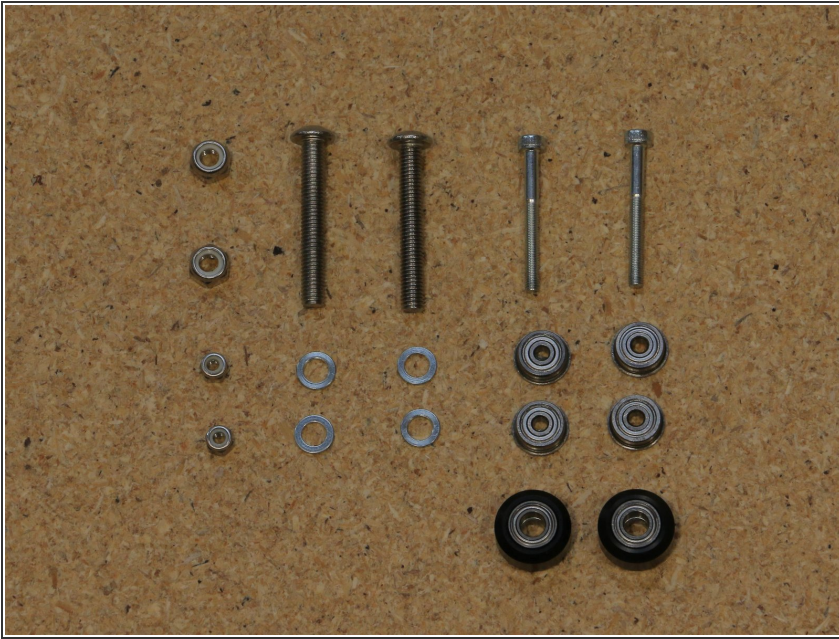
- Y Carriage (top) R 17A (1x)
- Y Carriage (bottom) R 18A (1x)
- M5x12 button head cap screw (1x)
- M5x10 button head cap screw (1x)
- M5 T Nut (2x)

Step 8 — Prepare Y Carriage (Right)



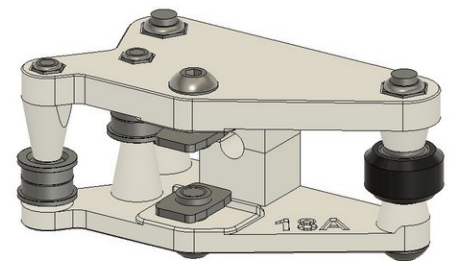
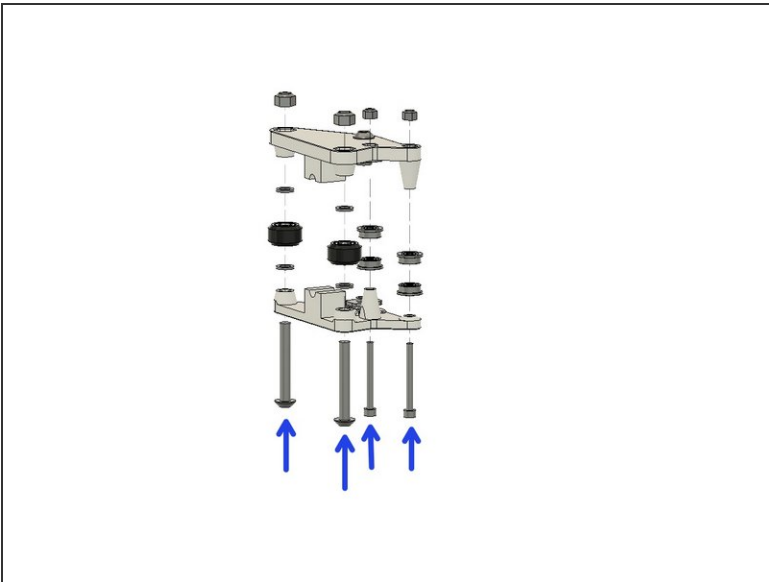
- Partially thread M5x10 into M5 T nut.
- Partially thread M5x12 into M5 T nut.

Step 9 — Prepare Parts



- Y Carriage (top) with hardware (1x)
- Y Carriage (bottom) with hardware (1x)
- Mini V Wheel (2x) OpenBuilds Precision Shim (4x)
- Belt Pulley (4x)
- M5x35 button head cap screw (2x)
- M5 Nylock Nut (2x)
- M3x30 socket head screw (2x)
- M3 Nylock Nut (2x)

Step 10 — Assemble Y Carriage (Right)



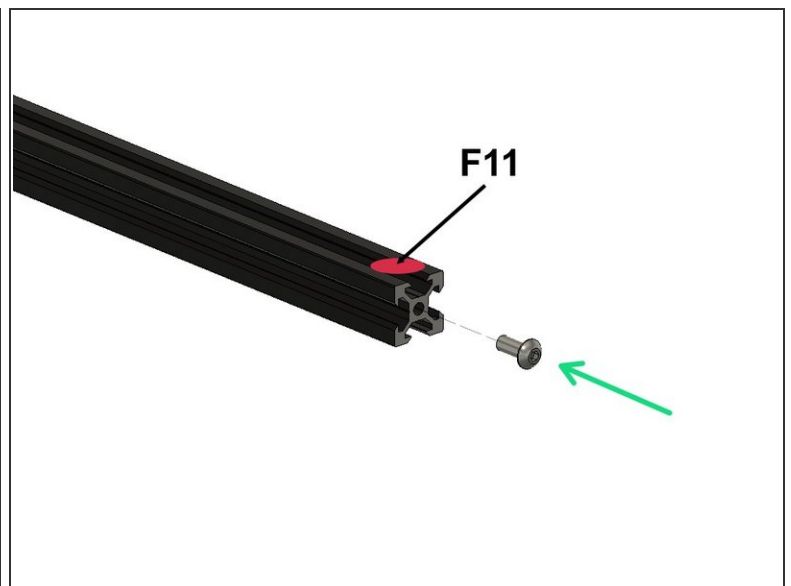
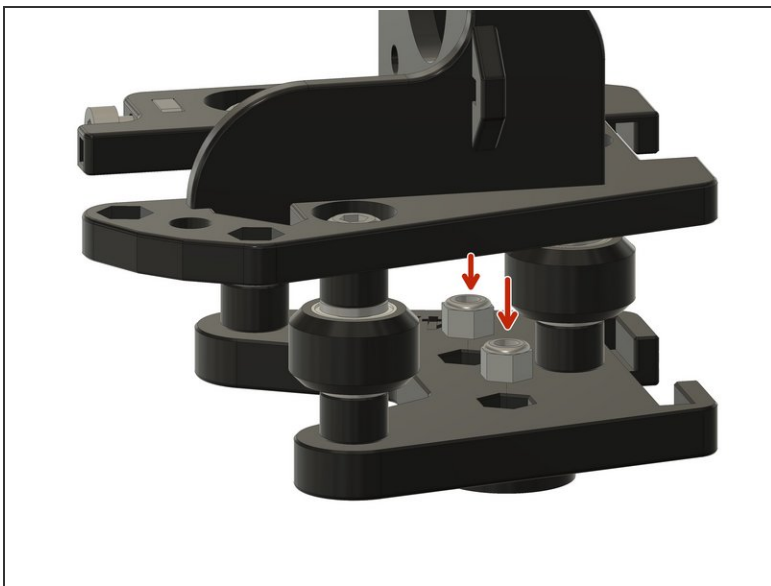
- Assemble carriage

Step 11 — Prepare Parts



- F11 (1x)
- M5x10 button head cap screw (1x)
- M3 Nylock Nut (2x)

Step 12 — Prepare to Assemble Gantry



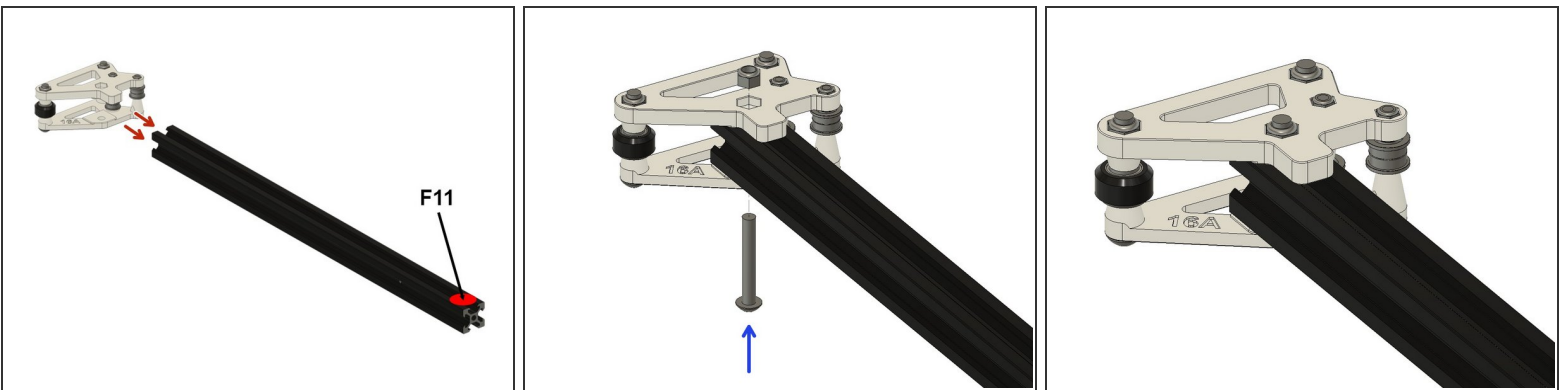
- Insert M3 Nuts into Print Carriage (bottom) for later mounting of part cooling fan.
- Insert M5x10 screws into F11. These will be used for pre-loading the carriage later.

Step 13 — Prepare Parts



- Y Carriage Assembly (left) (1x)
- Y Carriage Assembly (Right) (1x)
- Print Carriage Assembly (1x)
- F11 with hardware (1x)
- M5x35 button head cap screw
- M5 Nylock nut

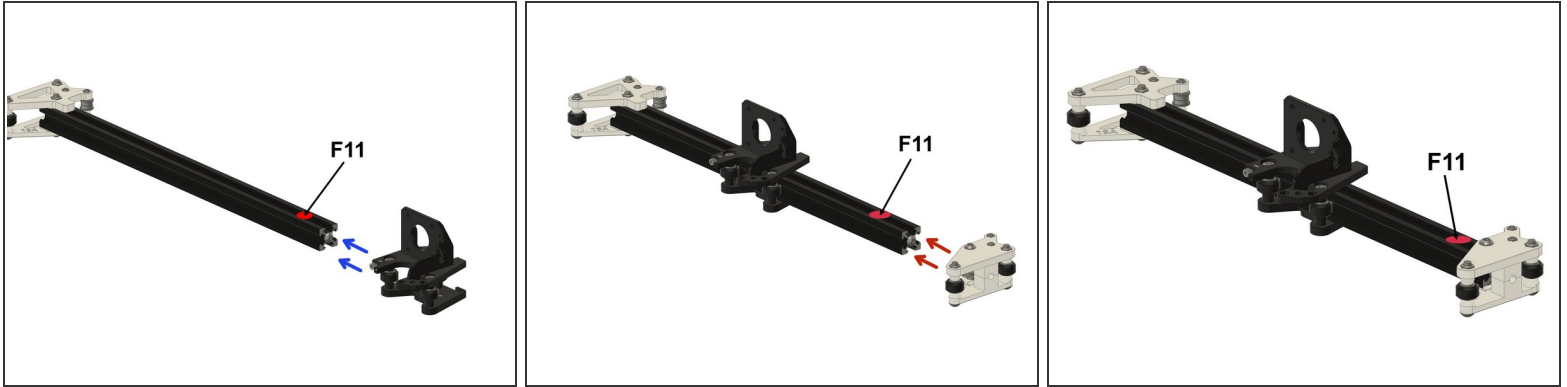
Step 14 — Assemble Gantry



- Slide Y Carriage Assembly (left) on to extrusion F11
- Fasten Carriage to through hole in F11 with M5x35 screw and nylock nut

⚠ F11 sticker should be on top face at other end of F11

Step 15 — Finish Gantry



- Roll on print carriage

⚠ Pay attention to orientation of carriages on F11. Sticker should be on top face

- Slide Y Carriage Assembly (Right) on to F11 and tighten screws lightly