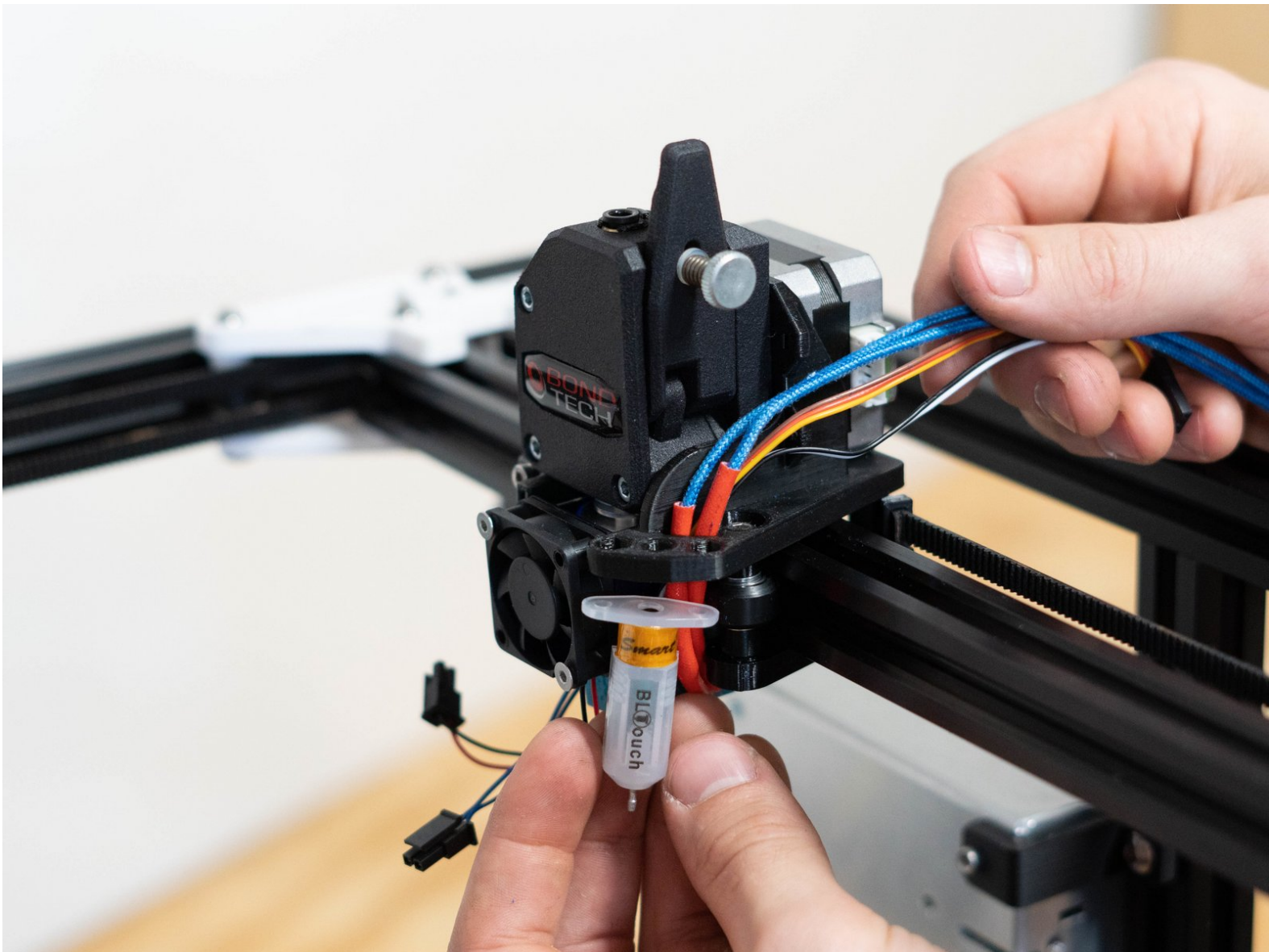




# Section 3.2: Print Carriage Assembly and Bed Positioning

Written By: Leland Crowther

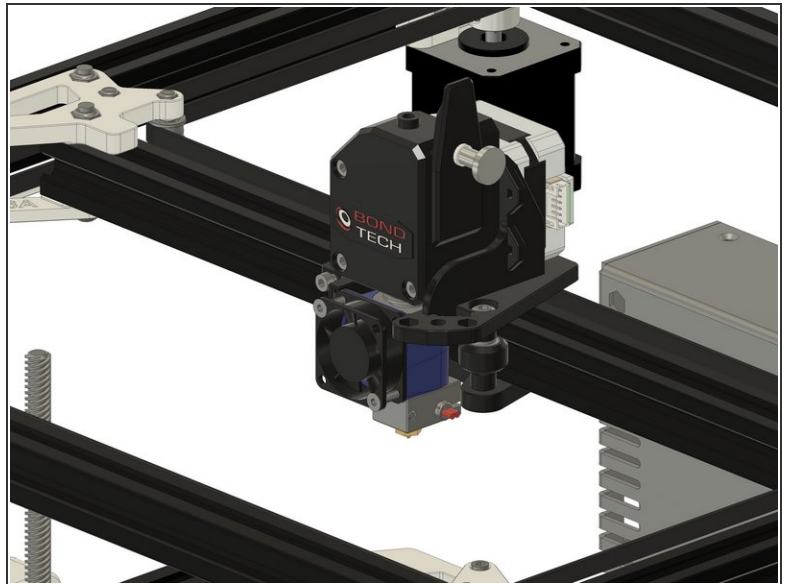
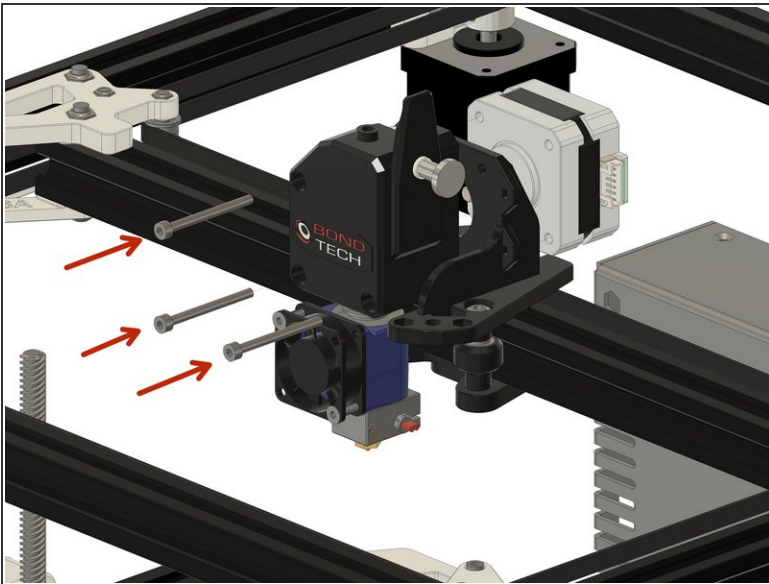


## Step 1 — Prepare Parts



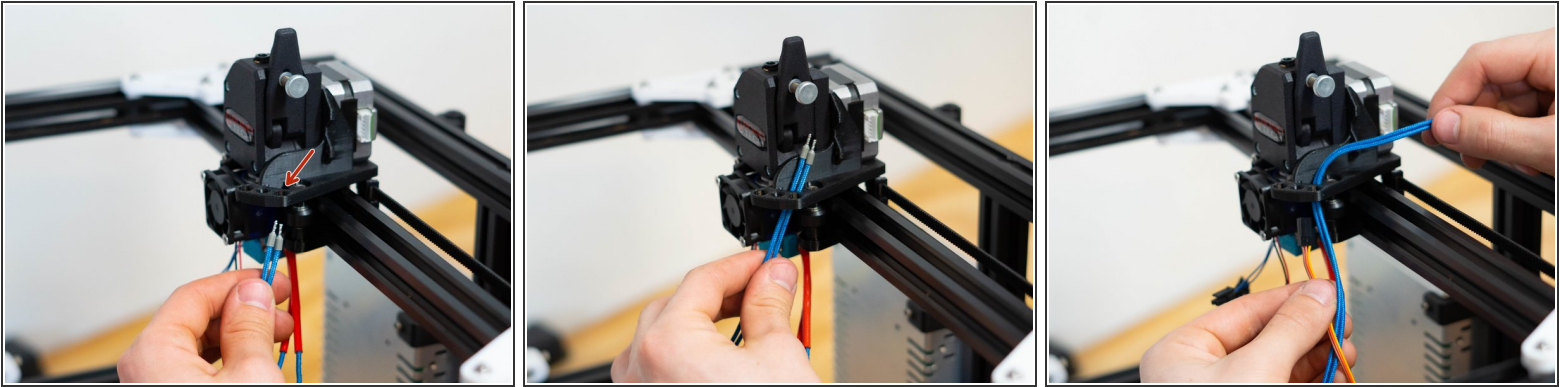
- E3D Hotend (1x)
- BondTech Extruder (1x)
- M3x40 screw included in BondTech extruder kit (3x)

## Step 2 — Mount Extrusion Assembly



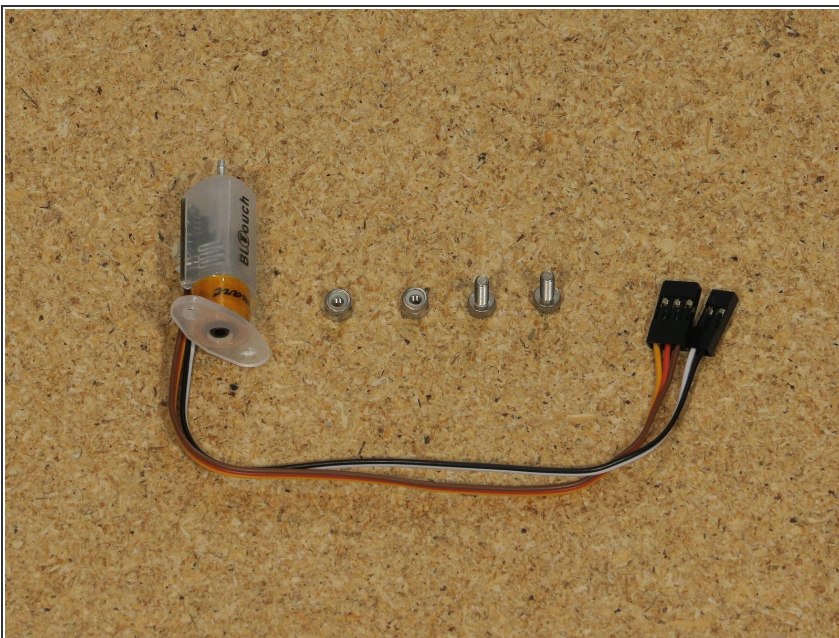
- Mount BondTech and stepper motor using M3x40 screws (supplied with your BondTech BMG)

### Step 3 — Feed Hotend Wires Through Carriage



- Feed hotend wires through hole

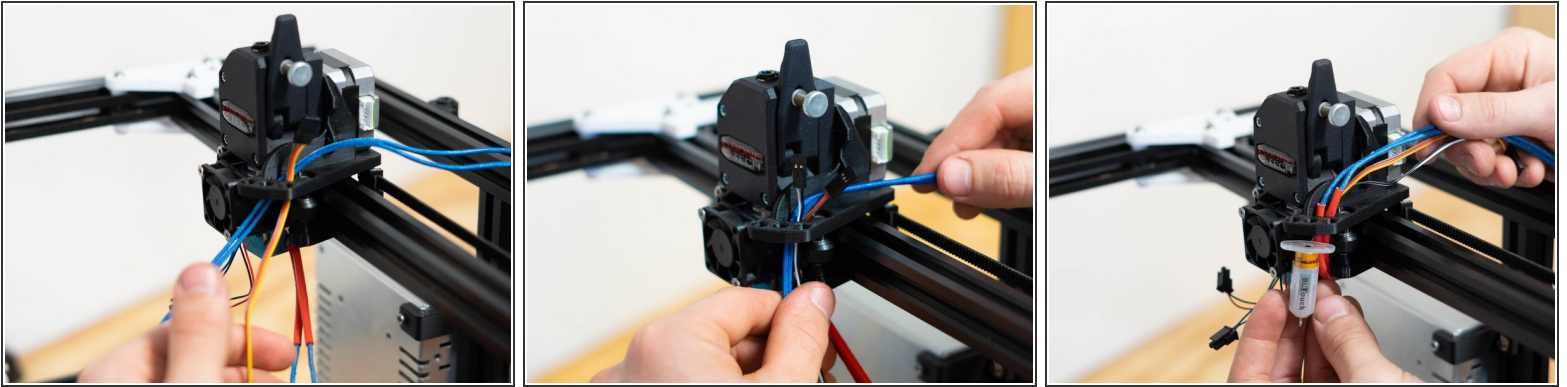
### Step 4 — Prepare Parts




- M3x8 socket head screw (2x)
- M3 Nylock Nut (2x)
- BLTouch probe (1x)

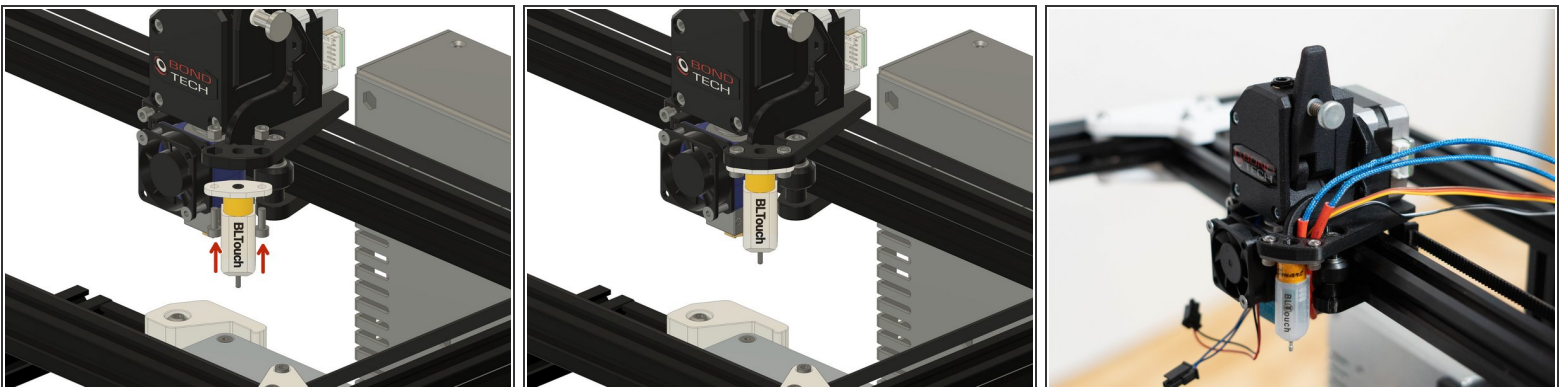



## Step 5 — Feed BLTouch Wires Through Carriage



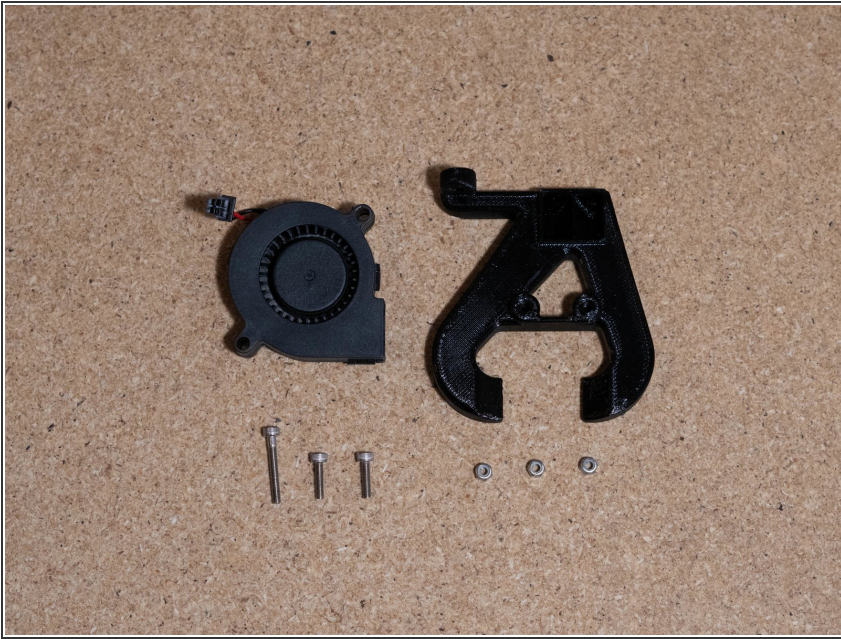
-  Feed BLTouch wires through the same hole as the hotend wires

## Step 6 — Mount BLTouch



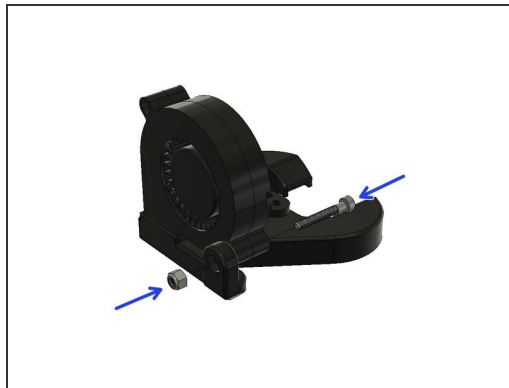
-  Attach BLTouch with M3x8 screws and M3 Nylock nuts

## Step 7 — Prepare Parts



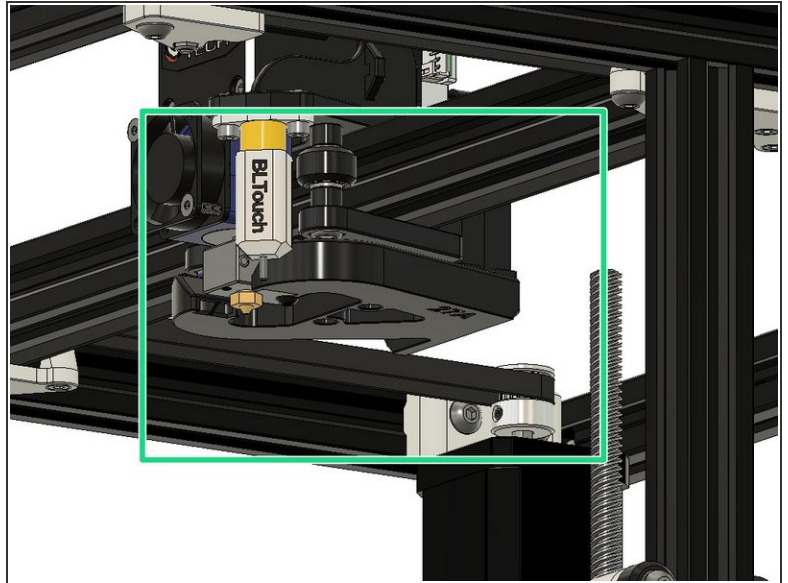
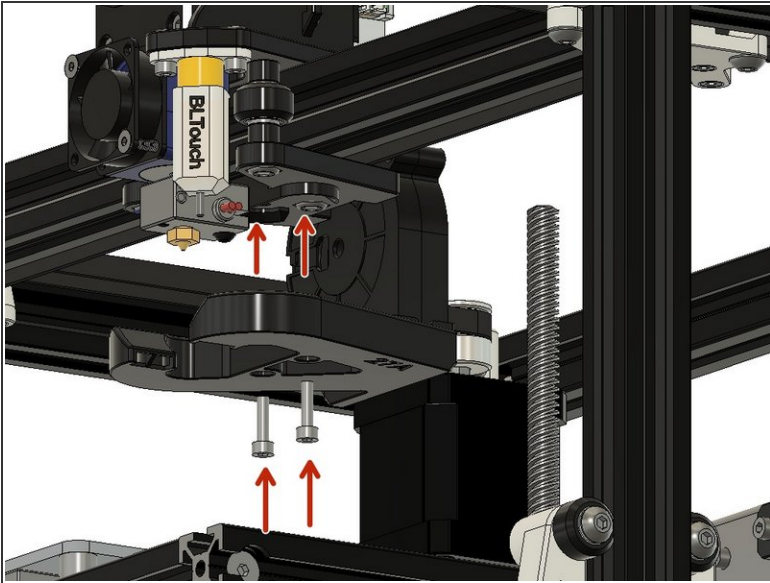
- Part Cooling Fan Shroud 27A (1x)
- 50mm Blower Fan (1x)
- M3x25 socket head screw (1x)
- M3x12 socket head screw (2x)
- M3 Nylock nut (1x)

## Step 8 — Assemble Part Cooling Fan



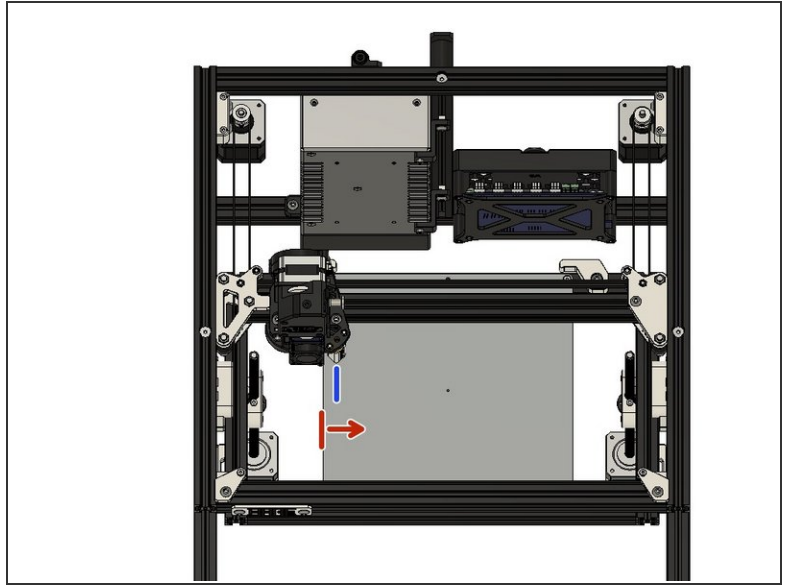
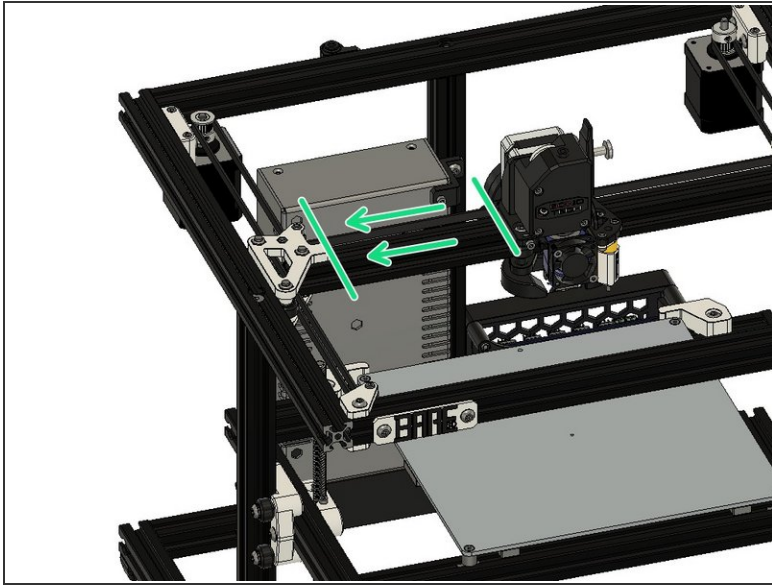
- Press fan into position
- Fasten fan to shroud with M3x25 screw and M3 nylock nut
- Assembled fan with shroud

## Step 9 — Mount Part Cooling Fan to Print Carriage



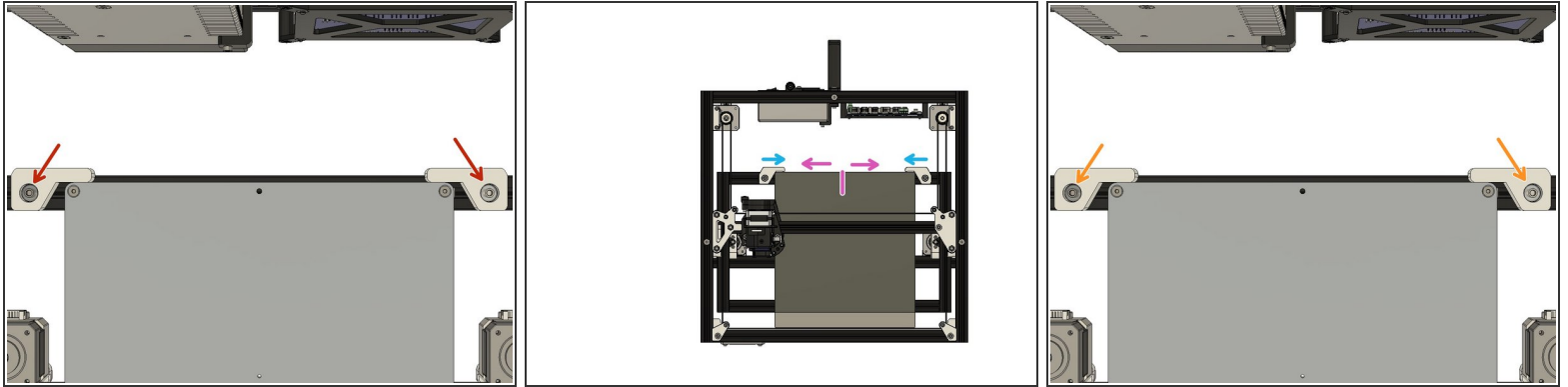
- Mount cooling fan assembly with M3x12 screws
- ⓘ Screws thread into nylock nuts embedded in the print carriage
- Correctly mounted cooling fan assembly

## Step 10 — Position Bed



- Move carriage left up against hard stop
- Shift bed left or right so that the side of the bed (red) lines up with BLTouch probe (blue) when carriage is against hardstop. Once lined up tighten bed in place
- ⓘ Probe tip should be above edge of heated bed

## Step 11 — Position FlexPlate Aligners



- Make sure screws are loose enough that the aligners can be shifted
- Center FlexPlate in relation to bed
- Slide aligners inward until up against FlexPlate
- Tighten aligner mounting screws