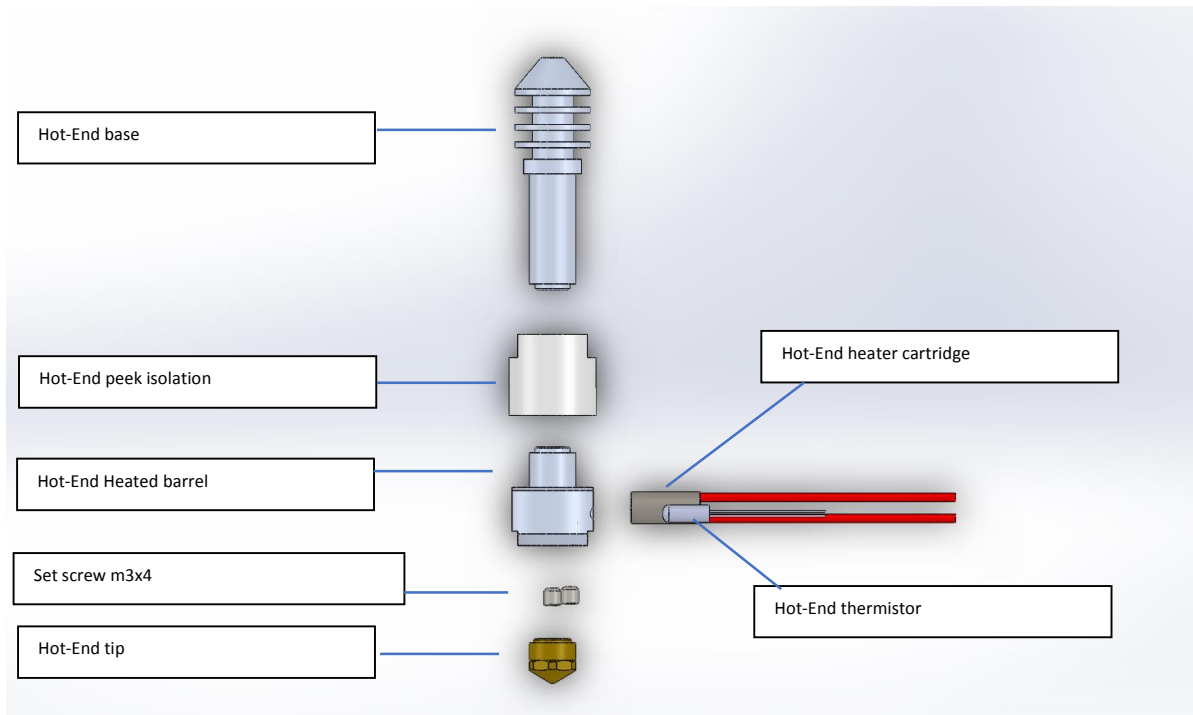
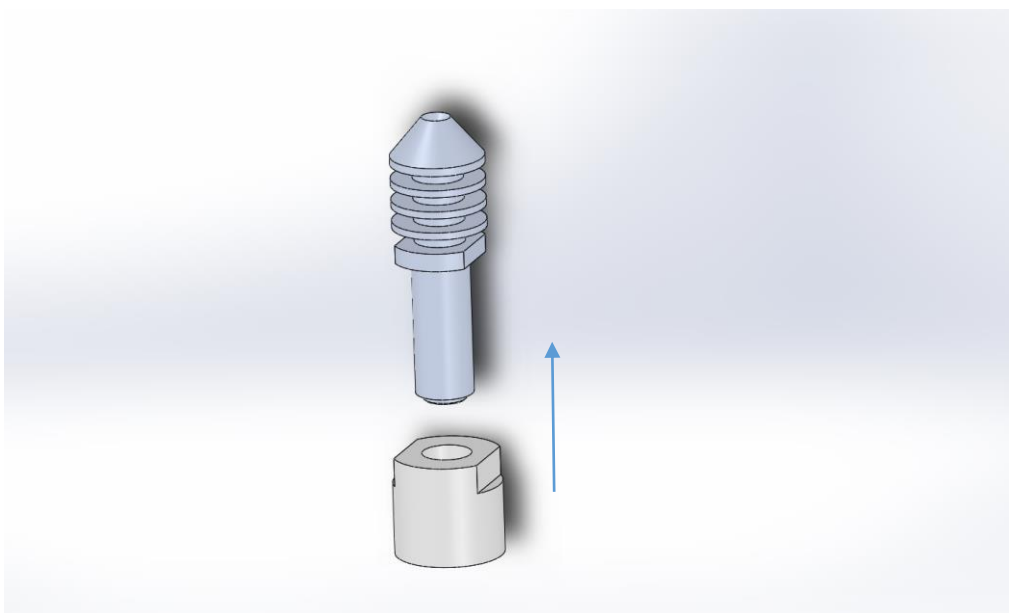


## Assembly instructions for Hot-end v4

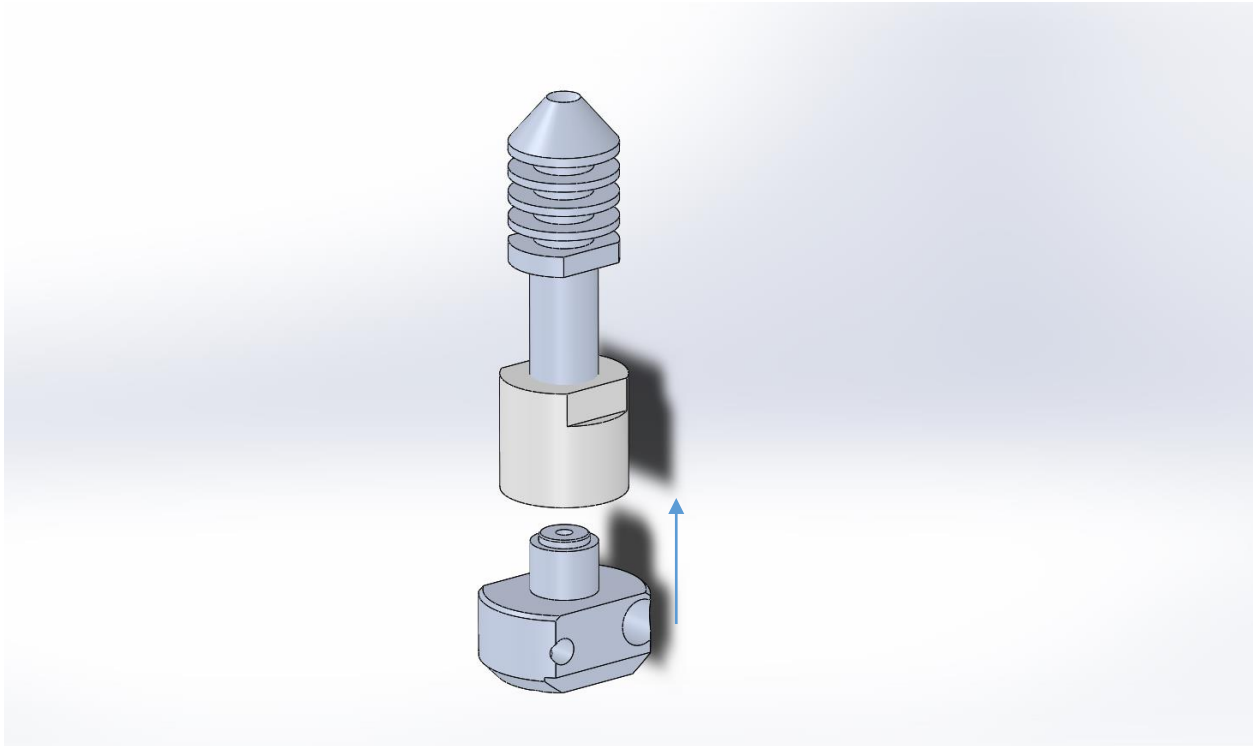
Date: 26 - october - 2013



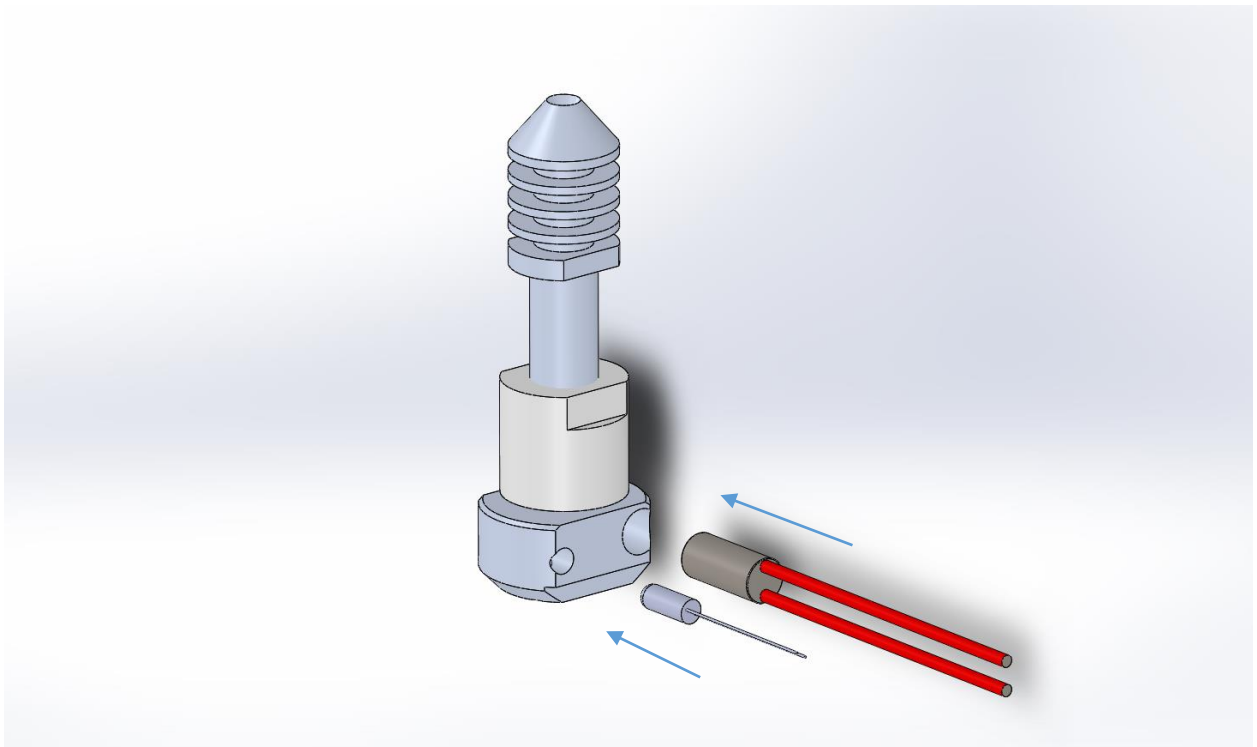
1. Screw the *Hot-End peek isolation* onto the *Hot-End base* first gently by hand. It should screw on without much effort. Fix the two parts together with a 12mm wrench on the peek part and 10mm wrench on the top part. Screw it hand tight. When attached to each other look if there is no significantly noticeably edge from the inside between the peek and aluminum part. An internal edge can cause hot-end jams because the filament can stick behind it. If there is an edge. Carefully post drill the inside with a 2mm drill. Until there is no edge visible.



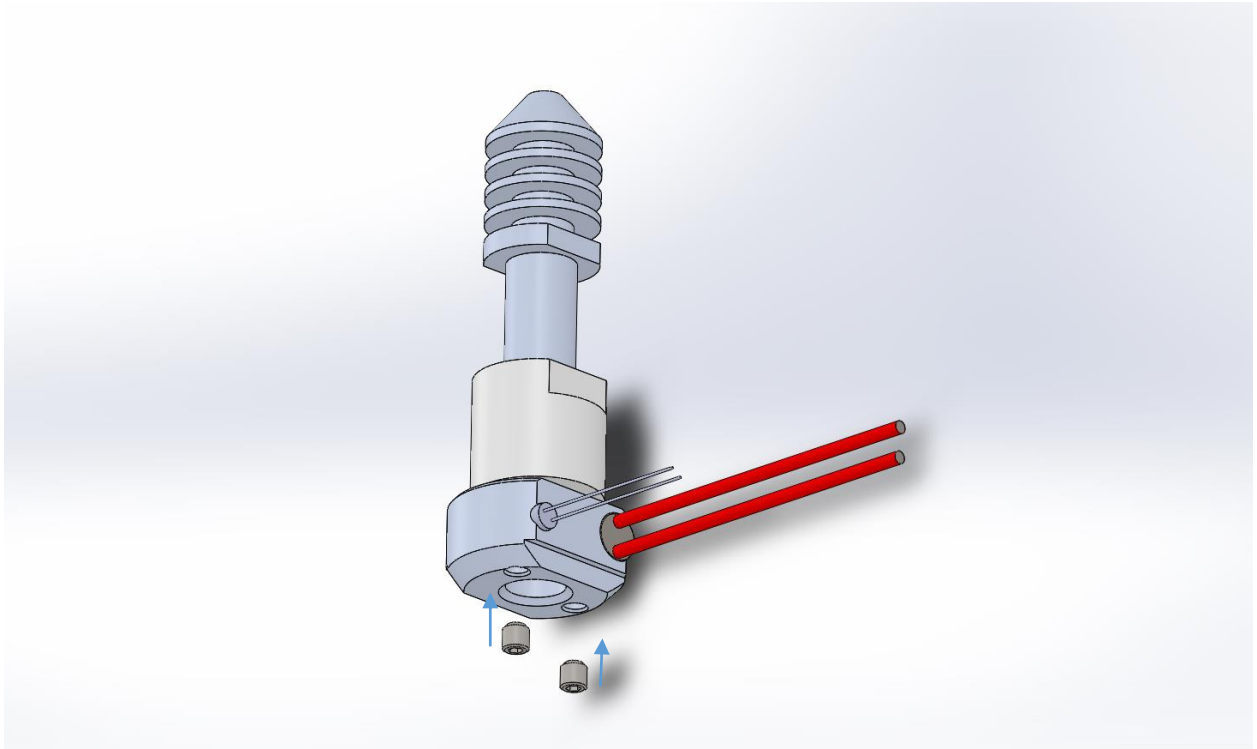
2. Screw the *Hot-End Heated barrel* onto the *Hot-End peek isolation* with a 12mm wrench. Use the bottom edge of the heated barrel to fixate the 12mm wrench. Again hand tight. Don't overdo it.



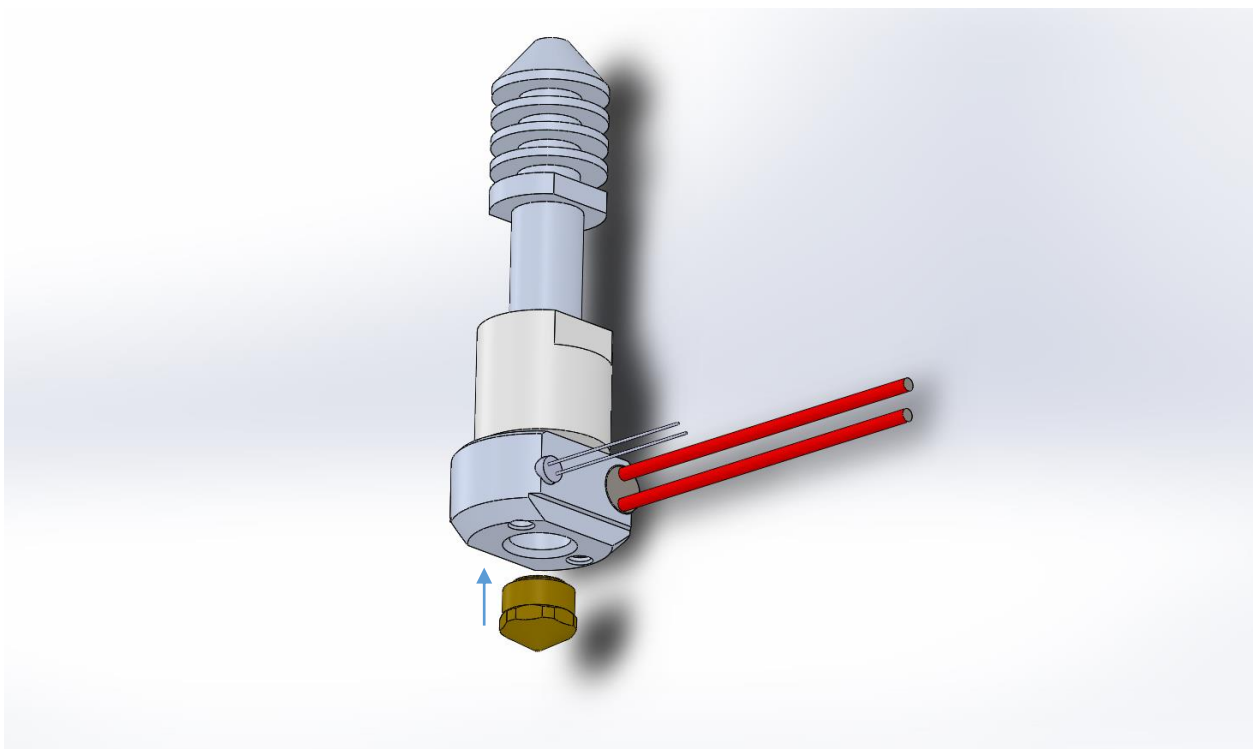
3. Insert both *Hot-End thermistor* and *Hot-End heater cartridge* in their correct holes.



4. Tighten both *set screws*  $m3 \times 4$  so that the *thermistor* and the *heater cartridge* are secure. Carefully fix it, because over tightening could deform the *thermistor* and/or *heater cartridge*



5. Finally, screw the *Hot-End tip* onto the heater barrel. Fix the *Hot-End tip* with a 8mm wrench.



6. The end result should look like this.

