

10) Prep sub-assemblies

Utilize OHAI for Hexagon Hot End to build a .5mm Hot End Assembly

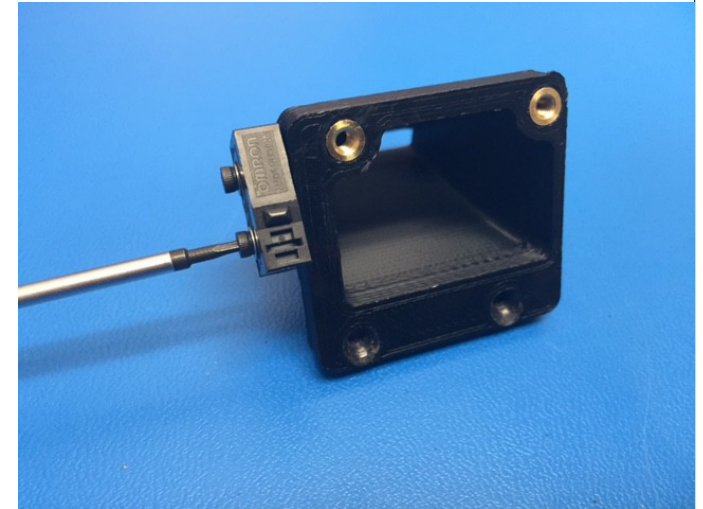
Utilize OHAI for Extruder Body sub-assembly to build a Extruder Body assembly (Herringbone gears will be Green).

20) Attach X end stop switch to the Fan Duct, **RIGHT (PP-GP0212)**. Note the Orientation of the switch, this is critical. Tighten screws to 3 in-lbs (~.35N-m)

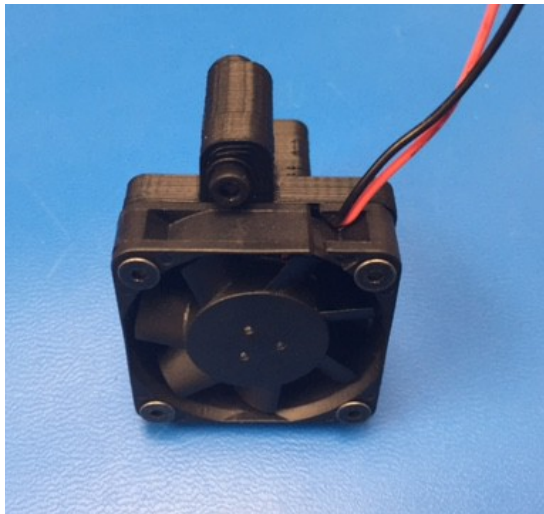
Use:

2x- M2 x 6 SHCS

2x- M2 SS washer

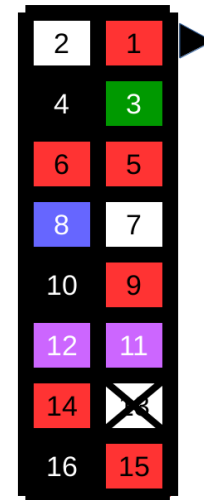


30) Prepare the Hexagon heat sink fan and attach to the Hexagon Hot End Heat Sink fan duct (PP-GP0232) with inserts already installed. Note orientation of fan. Use: 4x- M3x 12 SHCS tighten to 8 in-lbs (~.9N-m)



40) Plugging Order for the devices to be connected to a 16 pin Molex connector

- 1- Red- Motor
- 2- White- Motor
- 3- Green- Motor
- 4- Black- Motor
- 5- Red- Heater Cartridge
- 6- Red- Heater Cartridge
- 7- White- Dual fan
- 8- Blue- Dual Fan
- 9- Red- Heat Sink Fan
- 10- Black- Heat Sink Fan
- 11- Purple- Switch
- 12- Purple- Switch
- 13- Empty
- 14- Red- Ground Wire
- 15- Red- Thermistor
- 16- Black- Thermistor



50) Attach the Hot End Assembly to the Dual fan extruder mount v0.5

Utilize OHAI for Hexagon Hot End .5mm assembly

Use:

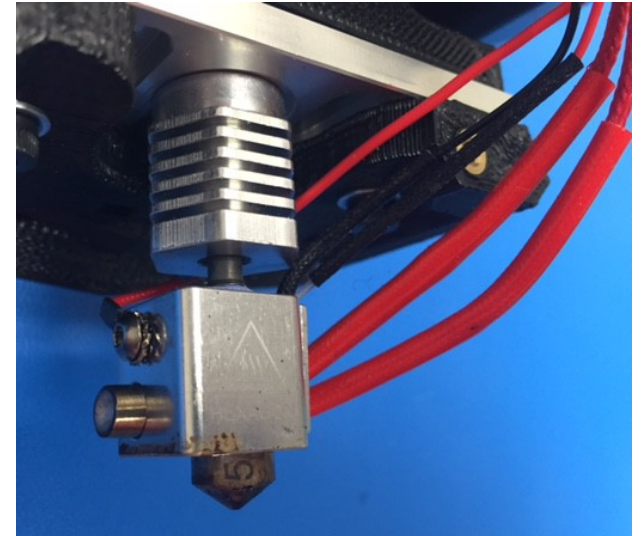
- 1x- Extruder Mount TAZ6 (PP-GP0208)
- 1x- .5mm Hexagon Hot End assembly
- 1x- Extruder body assembly (PP-GP0186)
- 1x- Hot End adapter plate
- 2x- M3x 12 SHCS
- 2x- M3 nut SS

Connect the Heater Cartridge and Thermistor to the 16 pin connector attached to the motor

60) Connect the Hexagon Hot End ground wire (220mm long) to the hot end. Route the ground wire behind the hot end, Plug ground wire into the 16pin connector that is attached to the motor.

Use:

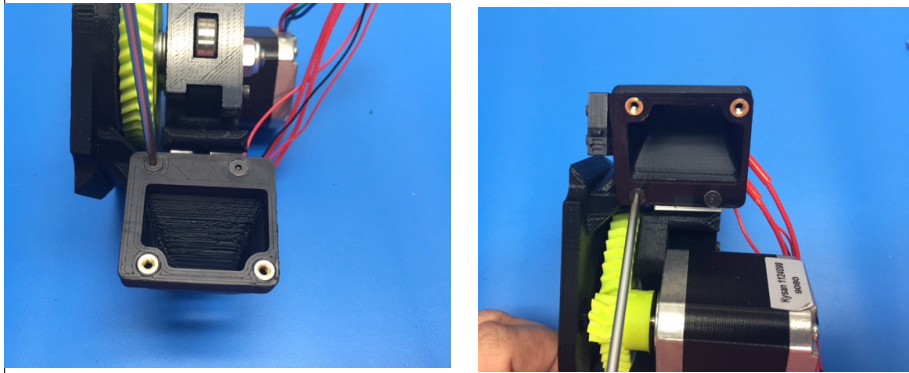
- 1x- 4-40 BHCS SS
- 1x- 4-40 star washer



70) Attach the Left (PP-GP0211) and Right (PP-GP0212) fan ducts to the Extruder Mount TAZ6

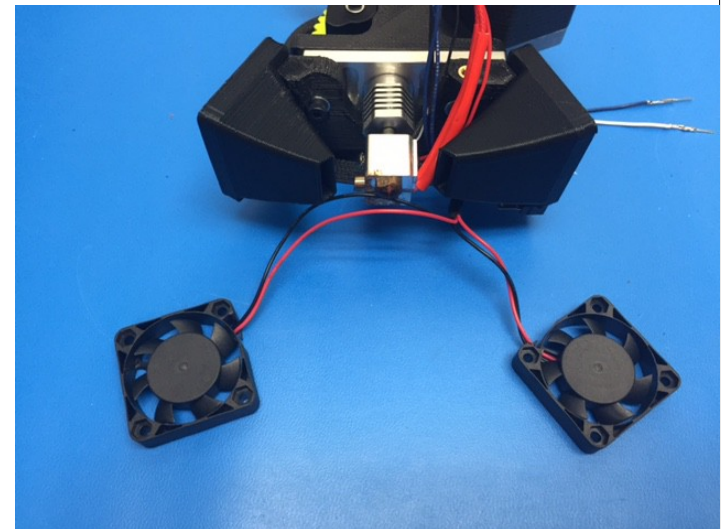
Use:

- 2x- M3 x 12 FHS (for each duct), tighten to 8 in-lbs (~.9 N-m)



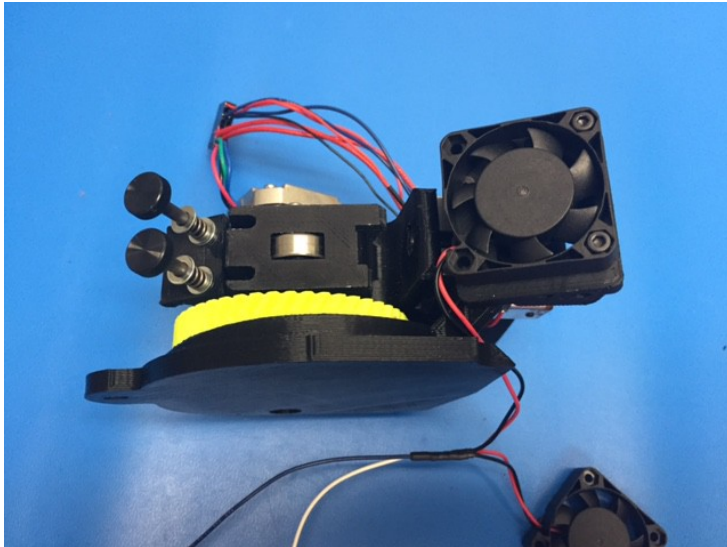
80) Prepare the Hexagon hot end dual fan sub-assembly

Layout the assembly in front of the Extruder with the fan that has the longest wire cut length to the left of the extruder and the shortest to the right side of the extruder.



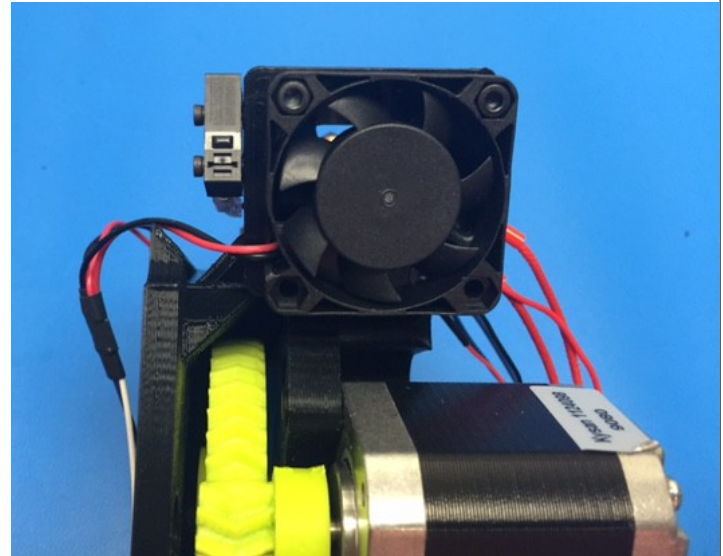
90) Attach the long fan to the Duct, Left. Note Orientation of the wires exiting the fan.

Use: 2x- M3x 12 SHCS; tighten to 8 in-lbs (~.9 N-m)



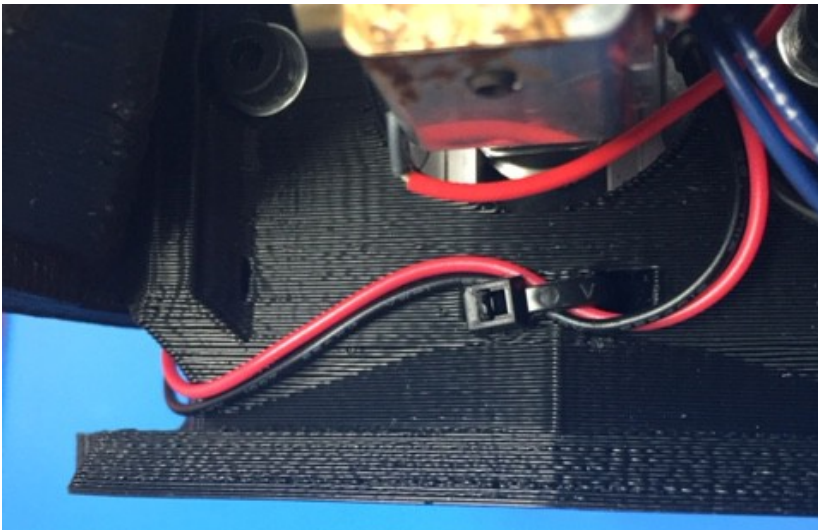
100) Attach the short fan to the Duct, Right. Note Orientation of the wires exiting the fan.

Use: 2x- M3x 12 SHCS; tighten to 8 in-lbs (~.9 N-m)



110) Route the long fan wire along the back of the mount, secure in place with a Ty wrap as shown, proper routing is critical

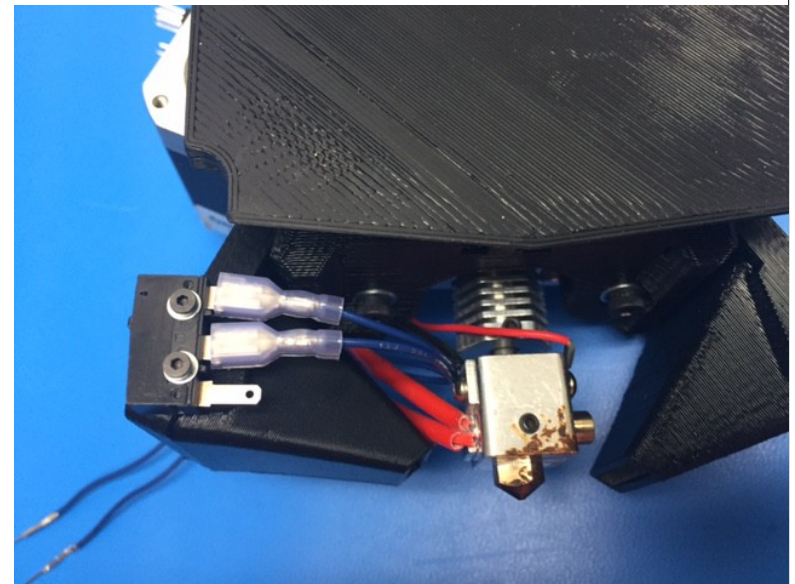
Connect the Heater Cartridge and Thermistor to the 16 pin connector attached to the motor



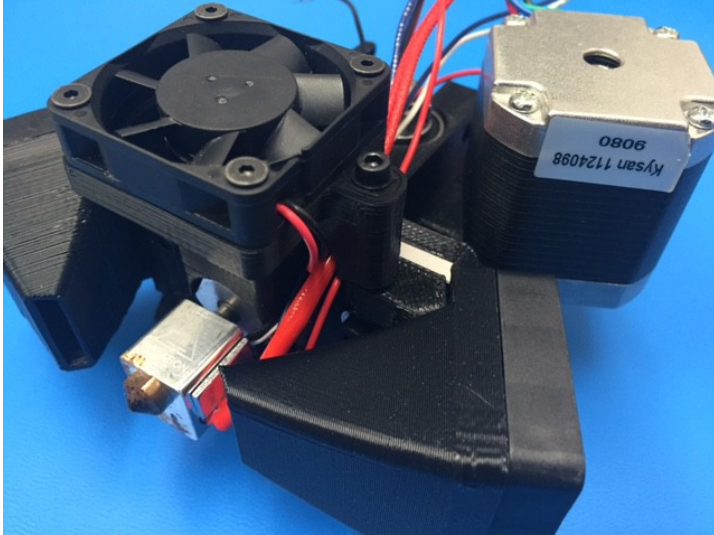
120) Connect Switch to the 16 pin connector, connect to the switch terminals shown; route wires as shown

Use:

2x- 190mm Blue wire with terminals and Faston PIDGN connector



130) Attach Heat Sink Fan Duct to assembly
Route wires into the duct channel as shown, secure duct to assembly
Use:
1x- M3x 25 SHCS; 1x- M3 washer; ; tighten to 8 in-lbs (~.9 N-m)



140) Attach Heat Sink fan to 16 position connector
Wrap 3/4" panduit (110mm length) around wires starting at the bottom of the connector and completing as far down the wire bundle as possible
Secure the panduit to the wire bundle with one Ty Wrap; Position the Ty Wrap approximately where shown



150) Apply the Connect Up label onto the Pin 1 side of the connector nearest the pins extending from the connector

