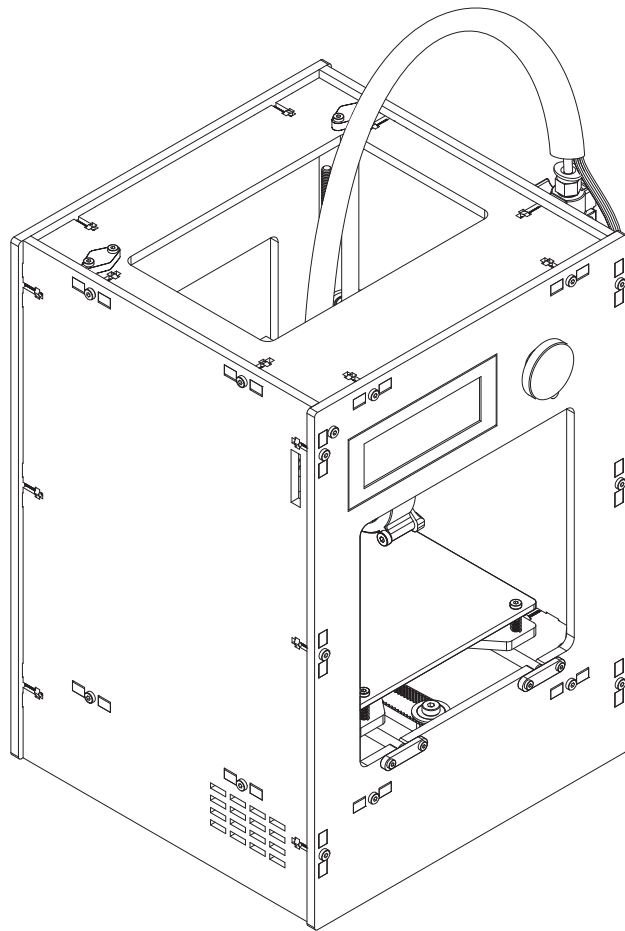


# BLOCKS



**ZERO**

ASSEMBLY GUIDE  
MANUAL DE MONTAGEM



# BLOCKS

**Hi,**

Congratulations, you are now the owner of a brand new Blocks Zero 3D printer! We welcome you on your journey through the fantastic world of 3D printing!

This assembly manual will guide you step-by-step to ensure your 3D printer is up and running in no time! You will find that with each step you complete you will gain valuable insights on how your Blocks Zero 3D printer works.

If you prefer a video version of this assembly manual we've got you covered!

Just go to the Support page on our website at [www.blockstec.com/zero.html](http://www.blockstec.com/zero.html) and watch the whole process!

PS.: Don't forget to subscribe!

Thank you for choosing the Blocks Zero as your new adventure and let's get started!

**Olá,**

Parabéns, tu és agora o proprietário de uma nova impressora 3D Blocks Zero! Damos-te as boas-vindas ao início da tua viagem pelo fantástico mundo da impressão 3D!

Este manual de montagem irá guiar-te passo a passo assegurando-te que a tua impressora estará a funcionar num instante! Durante o processo ganharás profundas noções acerca do funcionamento da tua impressora 3D Blocks Zero.

Se preferires uma versão vídeo deste manual de instruções, estamos contigo!

Acede à nossa página de **Support** no nosso website [www.blockstec.com/zero.html](http://www.blockstec.com/zero.html) e visualiza todo o processo de montagem!

PS.: Não te esqueças de subscrever!

Agradecemos-te a escolha da Blocks Zero na tua nova aventura e, sem mais demora vamos começar!

# How to start?

## Como começar?

The kit is divided in 6 phases and the elements related to each phase are alphabetically ordered. All technical elements, such as screws, nuts, etc, can be found in the toolbox.

O kit está dividido em 6 fases e os elementos de cada uma delas estão denominados alfabeticamente. Os elementos técnicos, como parafusos, porcas, etc, encontram-se na caixa de ferramentas.

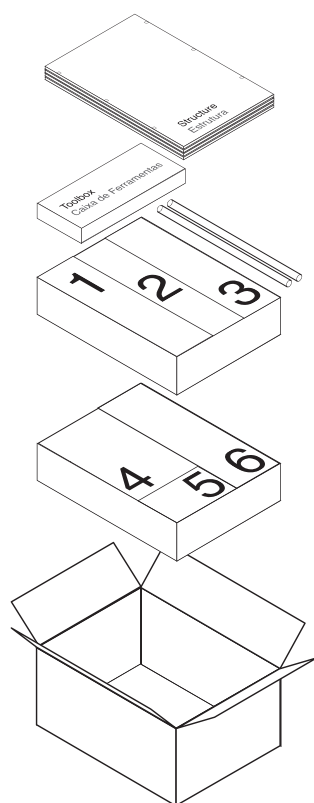
**TOTAL ASSEMBLY TIME: 4 HOURS**

**TEMPO DE MONTAGEM TOTAL: 4 HORAS**

Structure  
Estrutura

Toolbox  
Caixa de Ferramentas

Rods  
Varões estruturais



1 - Assemblies  
Assemblagens

2 - Z Axis + X Axis + Hot end  
Eixo Z + Eixo X + Extrusor

3 - External Assemblies  
Assemblagens Exteriores

4 - Print Table and Support Cart  
Mesa de Impressão e Suporte

5 - Cables  
Cablagem

6 - Power Supply  
Transformador

## INDEX

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 20 min.

**PHASE**

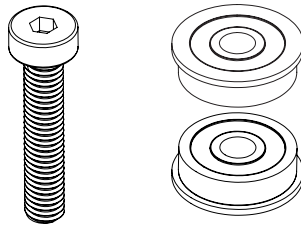
**FASE**

**1**

# A

PHASE 1  
FASE 1

You will need:  
Vais precisar:

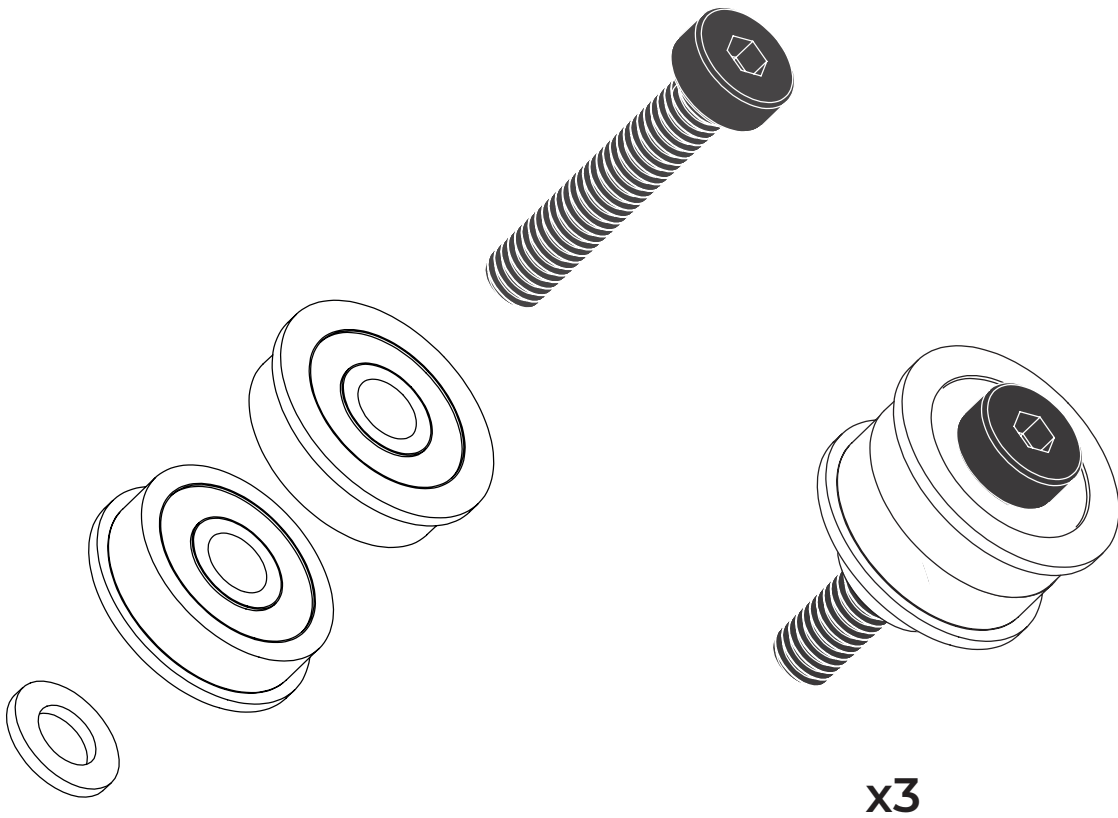


x3

TOOLBOX

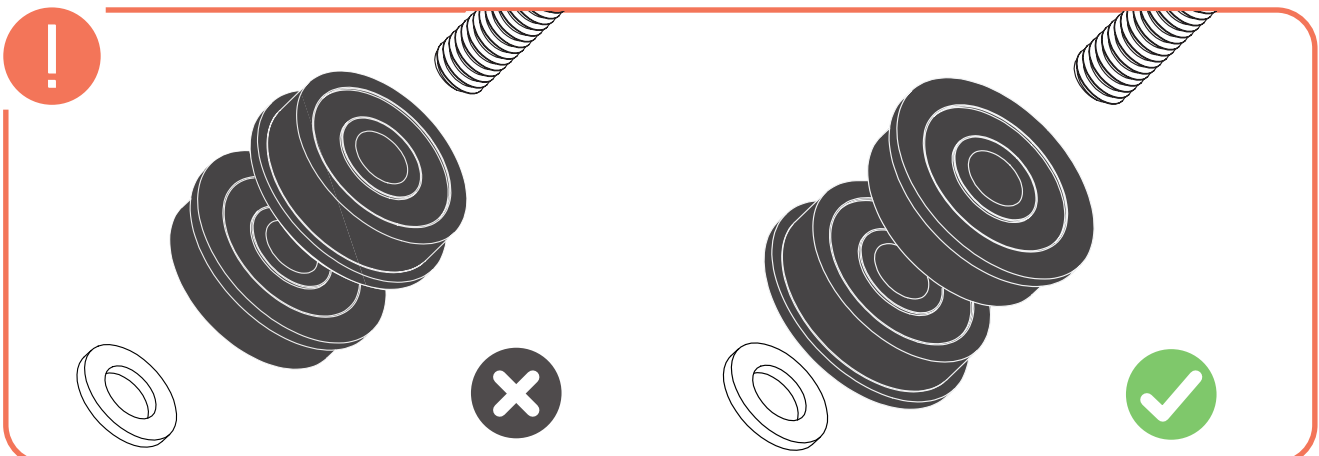


3x Washer  
Anilhas



x3

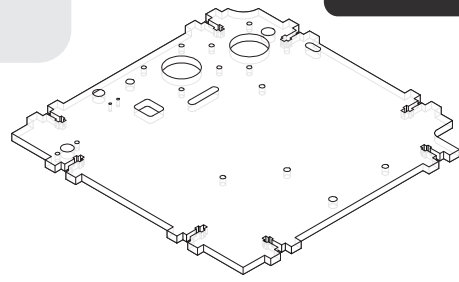
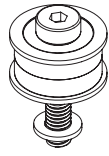
Attention: Flange direction  
Atenção: Direção do componente



# A

PHASE 1  
FASE 1

You will need:  
Vais precisar:



TOOLBOX

3x

Structure 1 Estrutura 1

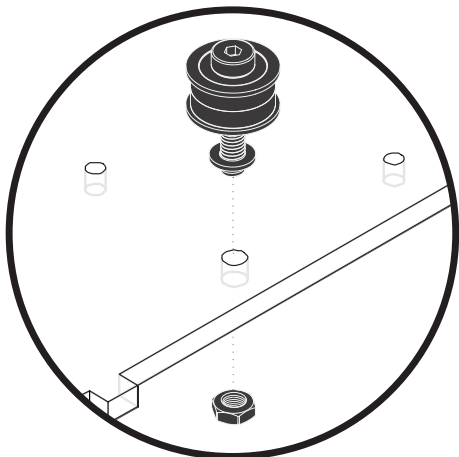
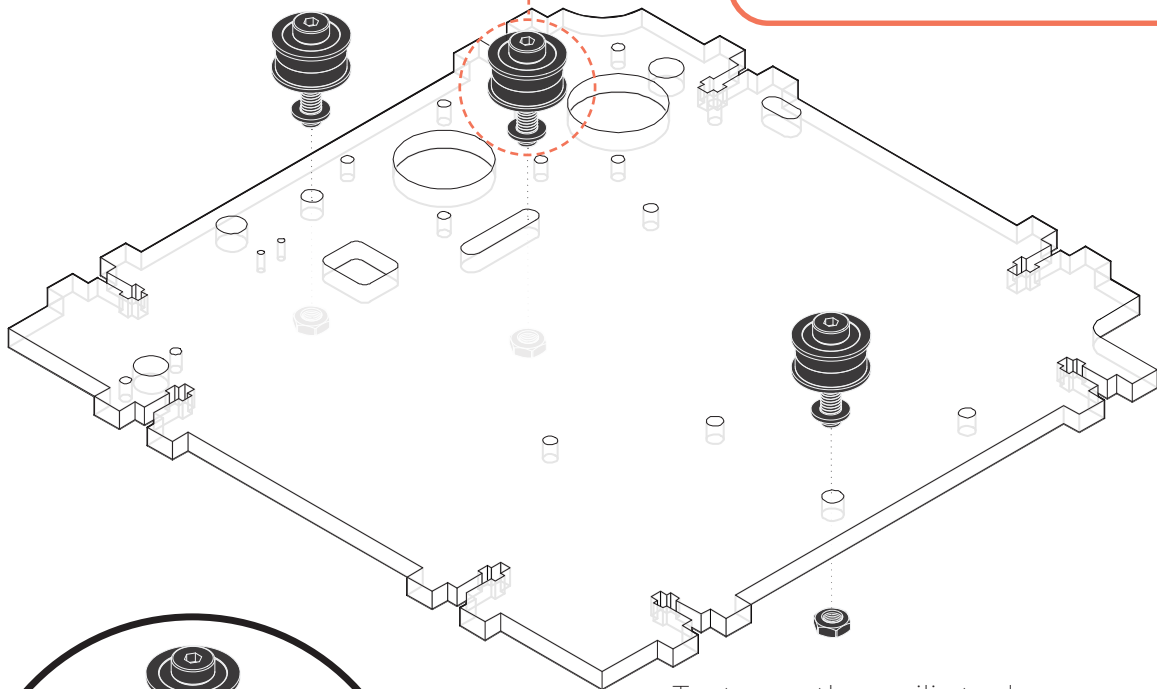
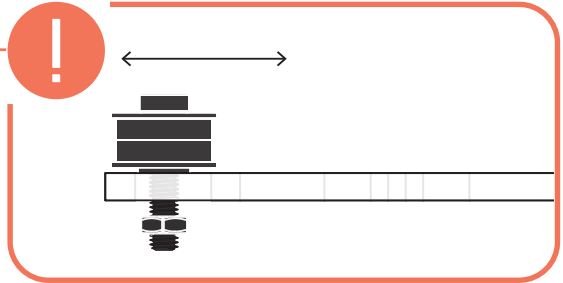


Allen 4

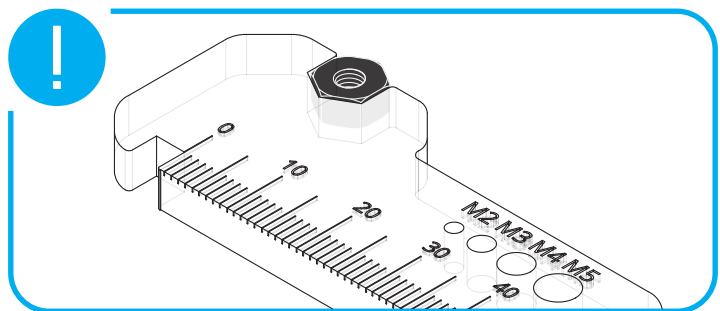


3x M5 Screw Nut  
Porcas M5

Attention: Let it loose  
Atenção: Deixar folgado



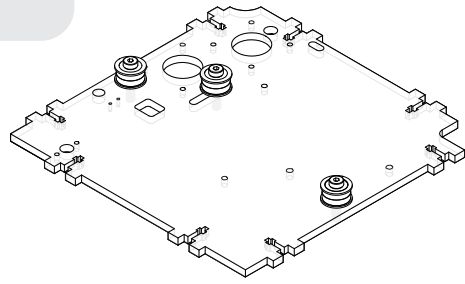
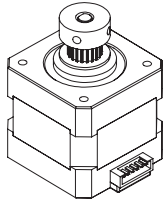
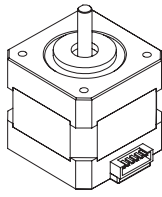
Try to use the acrylic tool  
Experimenta usar a ferramenta acrílica



# B

PHASE 1  
FASE 1

You will need:  
Vais precisar:



TOOLBOX

B.1

B.2

Structure 1 Estrutura 1

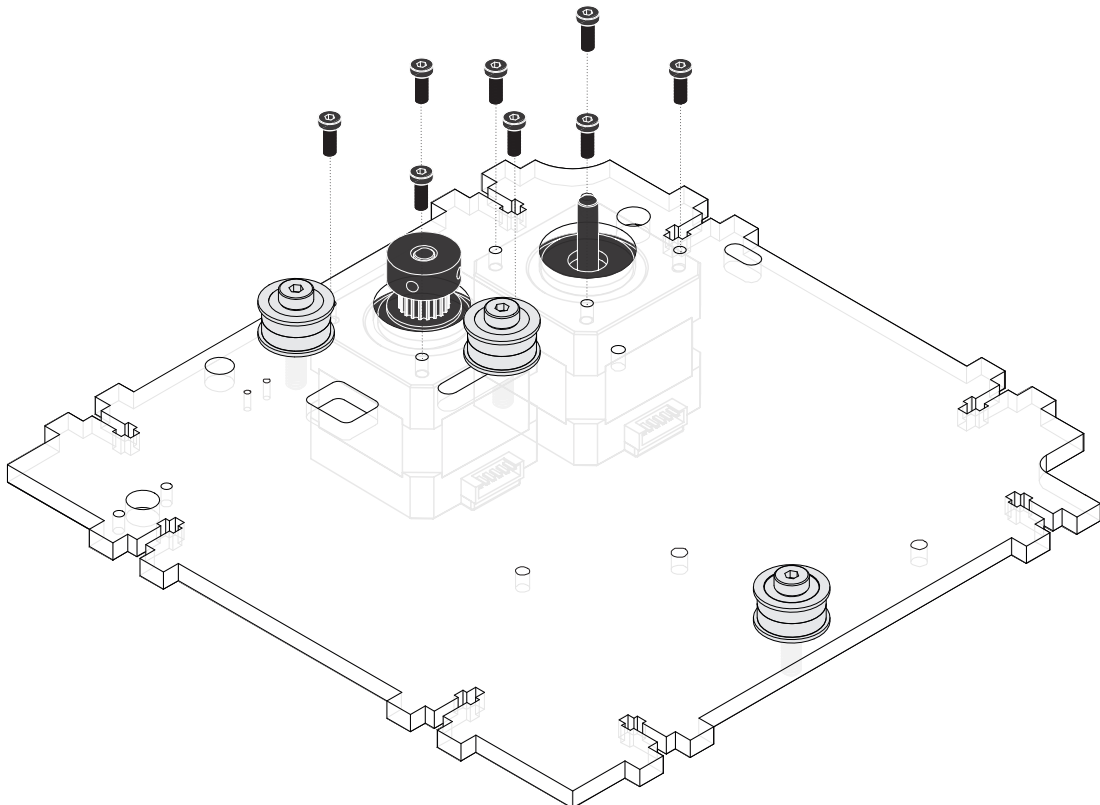
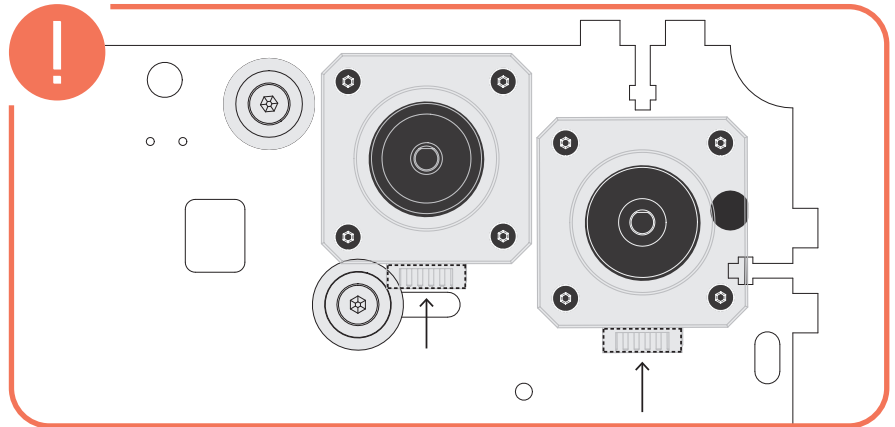


Allen 2



8x M3 8mm

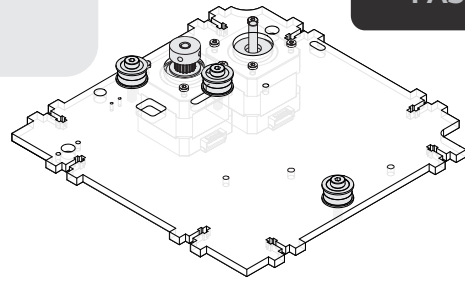
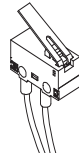
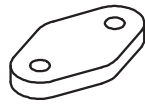
Attention: Direction of the cable plug  
Atenção: Direção da entrada de cabos componente



# B

PHASE 1  
FASE 1

You will need:  
Vais precisar:

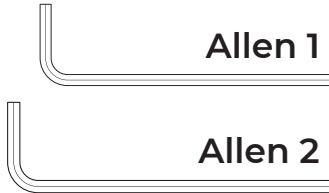


TOOLBOX

B.3

B.4

Structure 1 Estrutura 1



Allen 1

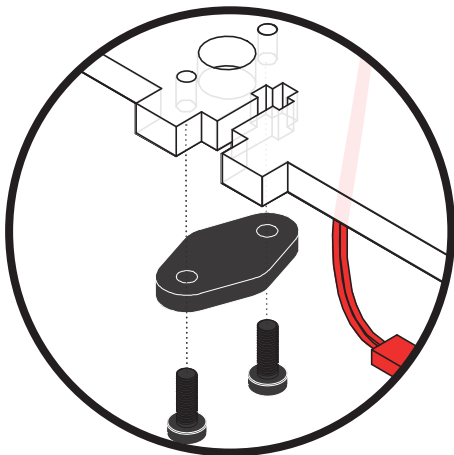
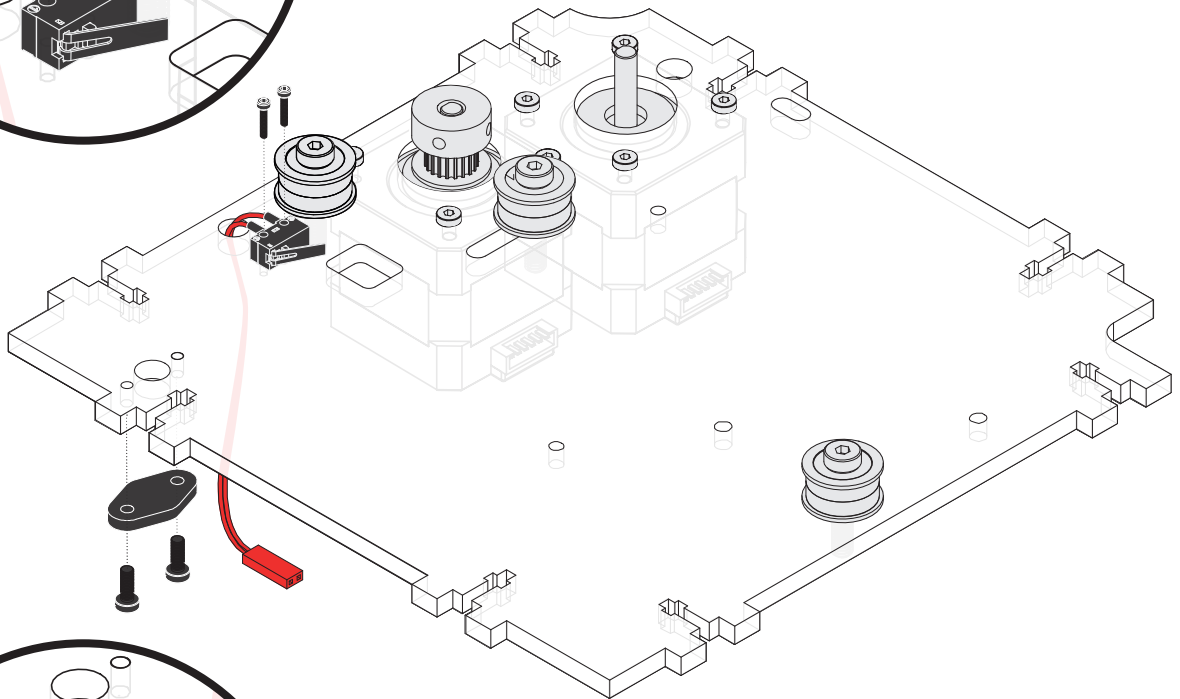
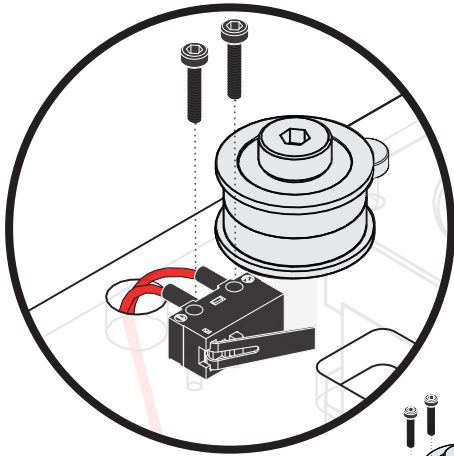
Allen 2



2x M3 8mm



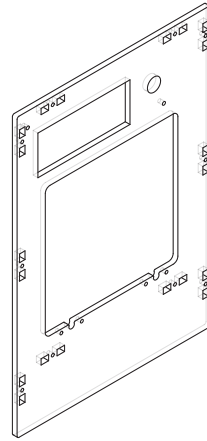
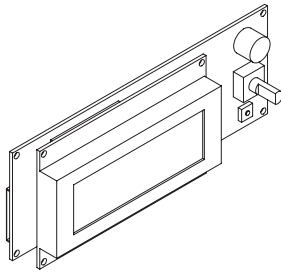
2x M2 8mm



# C

PHASE 1  
FASE 1

You will need:  
Vais precisar:



TOOLBOX

C.1

C.2

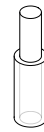
Structure 2 Estrutura 2



Allen 2



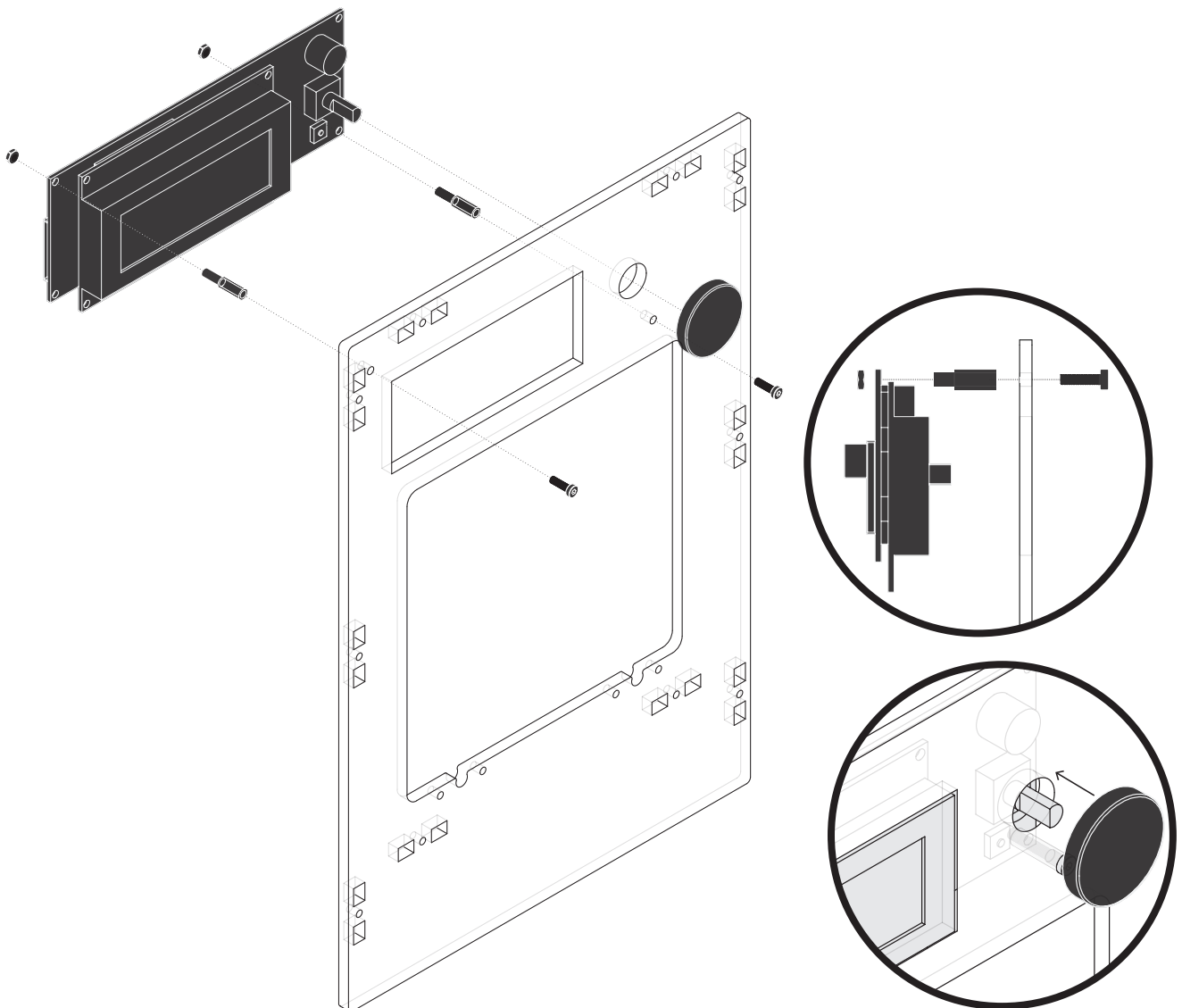
2x M3 10mm



2x Smallest spacer  
Espaçador pequeno



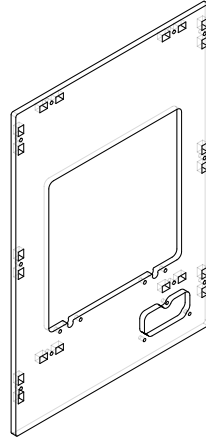
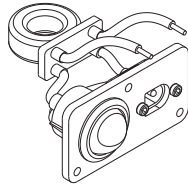
2x M3 Screw Nut  
Porcas M3



# D

PHASE 1  
FASE 1

You will need:  
Vais precisar:



TOOLBOX

D.1

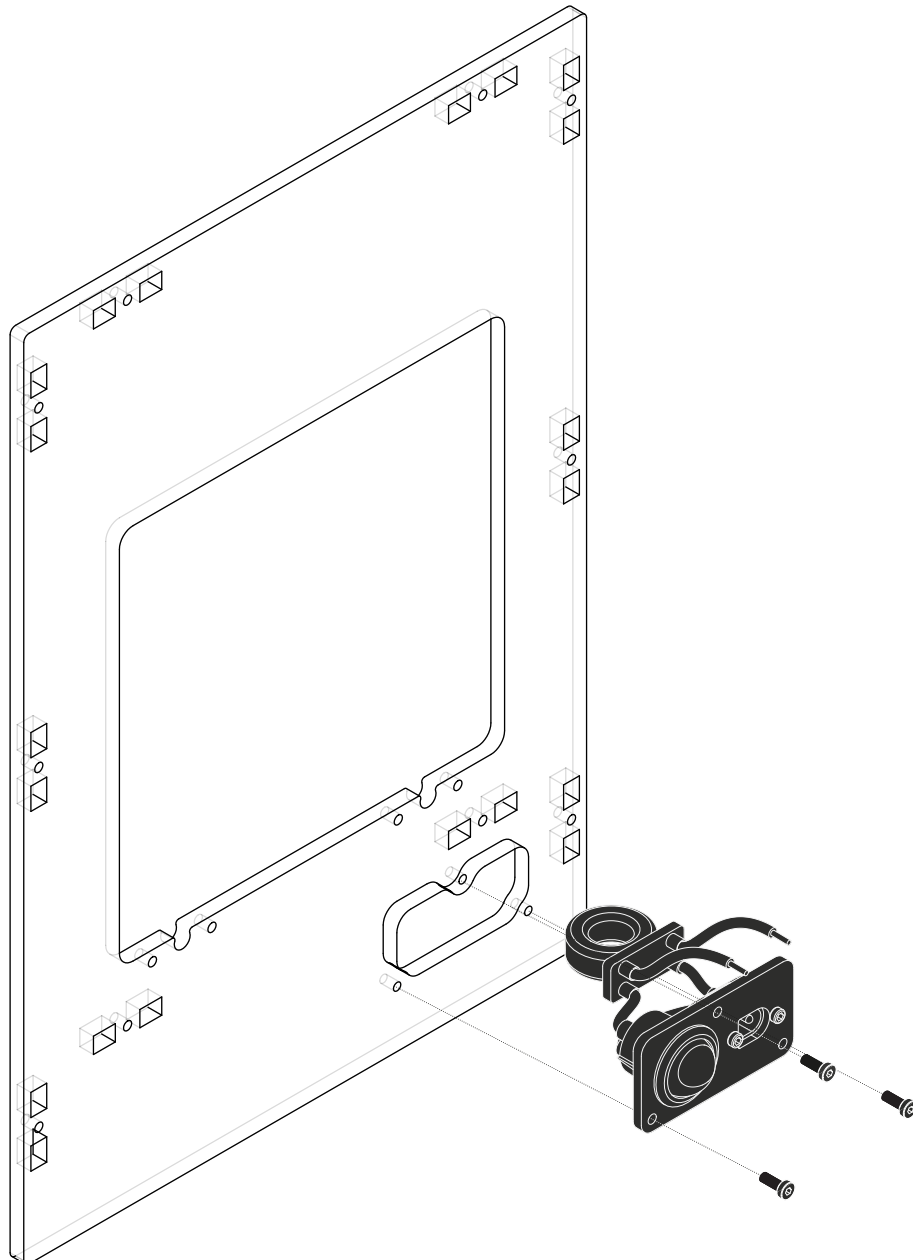
Structure 3 Estrutura 3

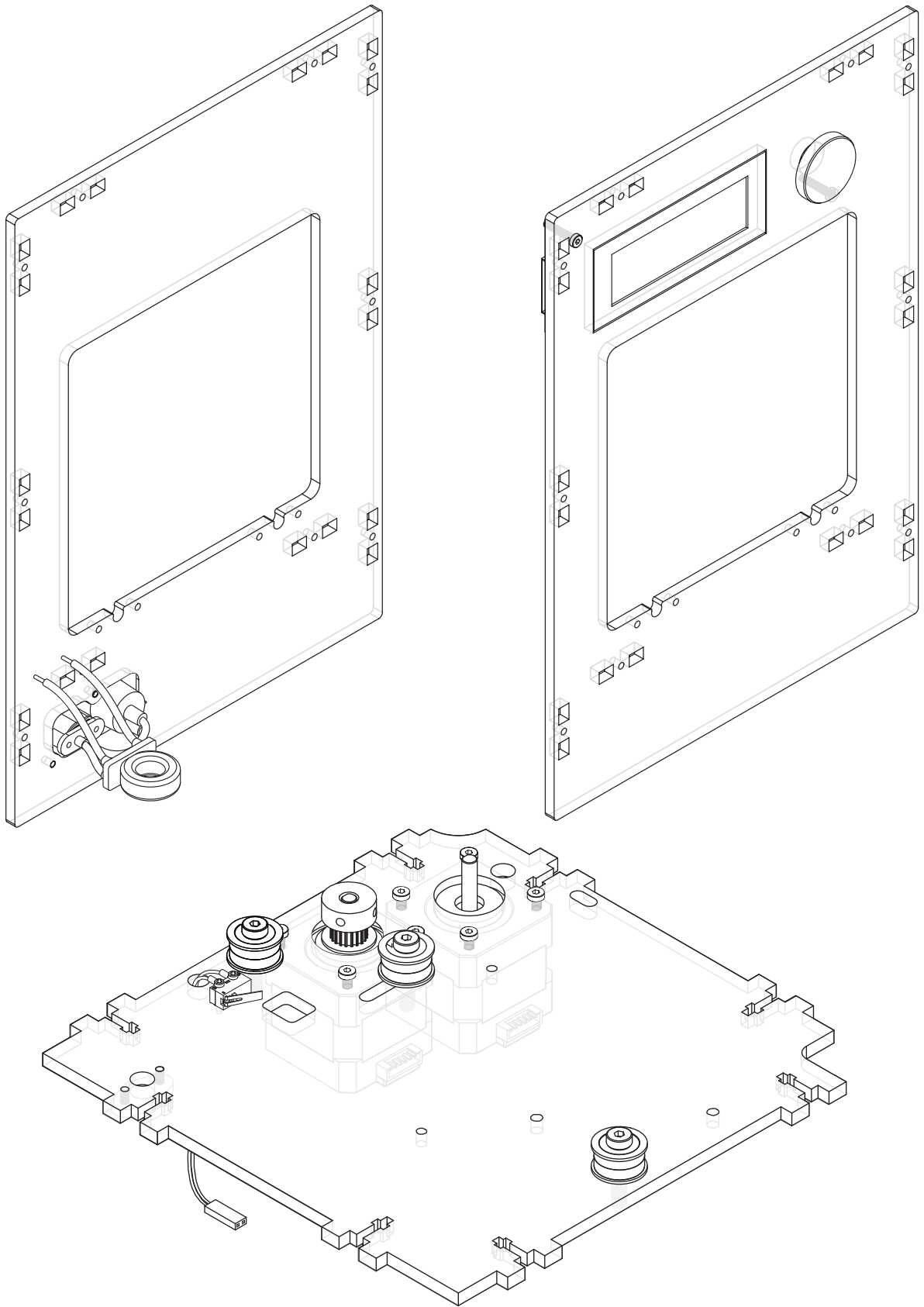


Allen 2



3x M3 8mm





**Phase 1 has been concluded!**  
**A Fase 1 está concluída!**



 35 min.

**PHASE**

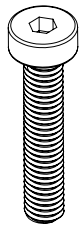
**FASE**

**2**

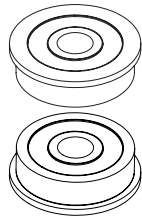
# E

PHASE 2  
FASE 2

You will need:  
Vais precisar:



3x

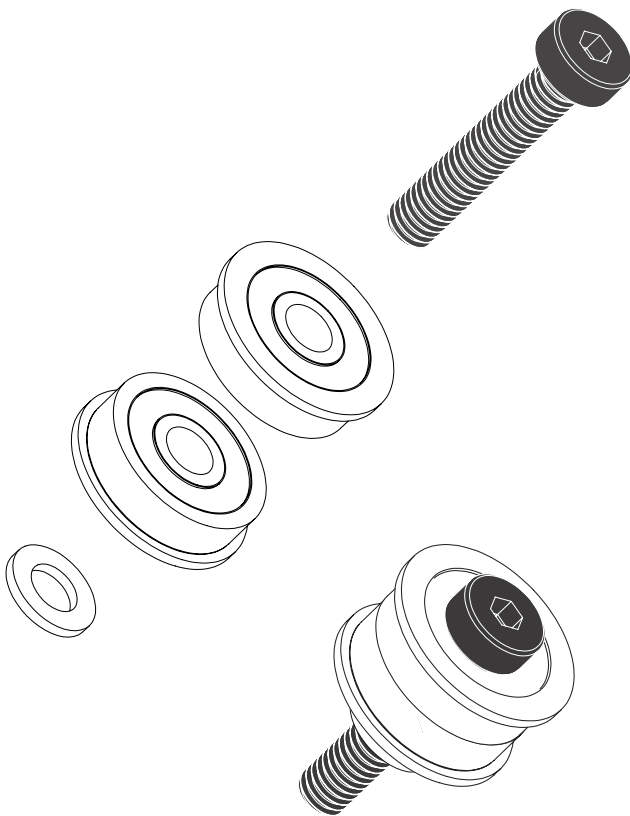


1x

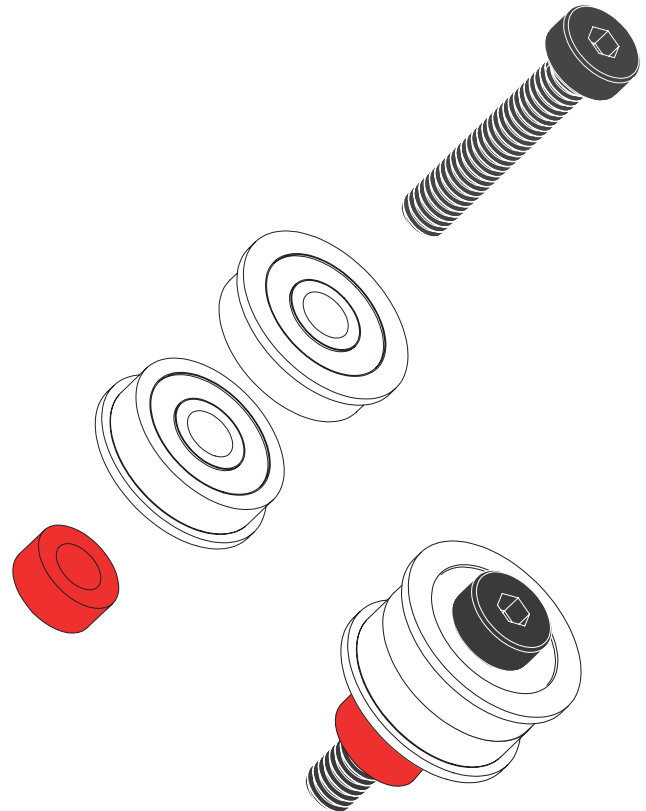
TOOLBOX



2x Washer  
Anilhas

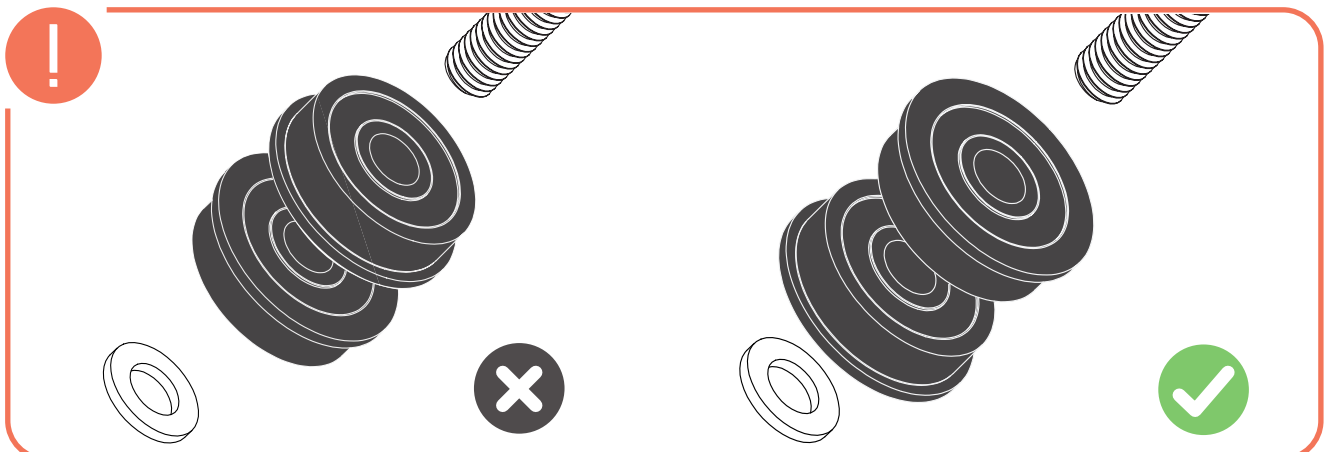


E.1 x2



E.2 x1

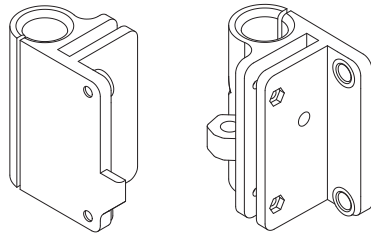
Attention: Flange Direction  
Atenção: Direção do componente



# F

PHASE 2  
FASE 2

You will need:  
Vais precisar:



## TOOLBOX

F.1

F.2



2x M5 Screw Nut  
Porcas M5

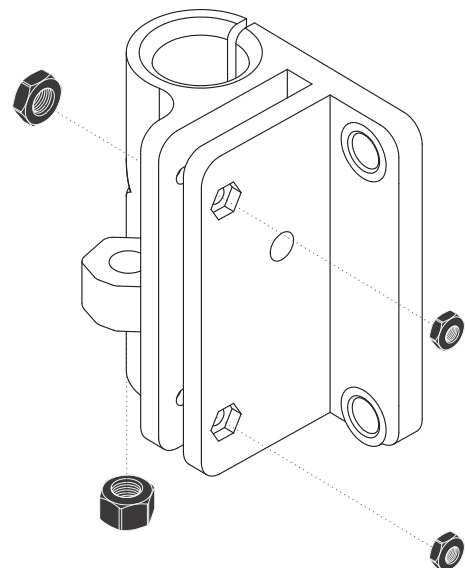
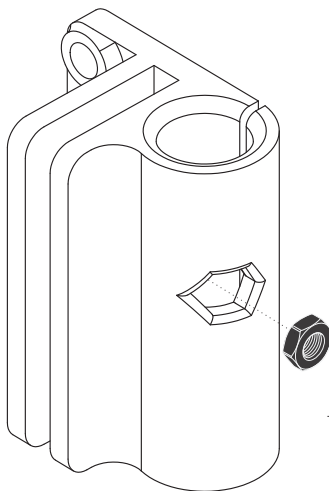
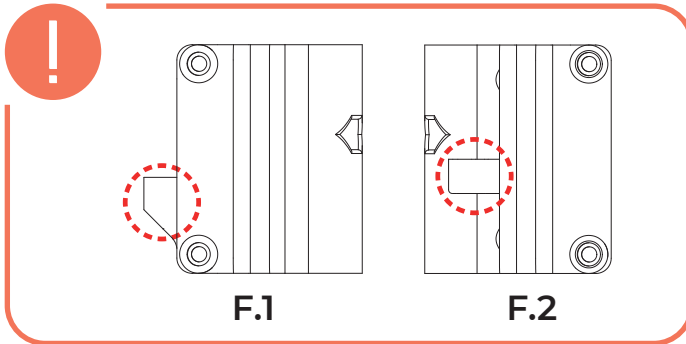


2x M3 Screw Nut  
Porcas M3

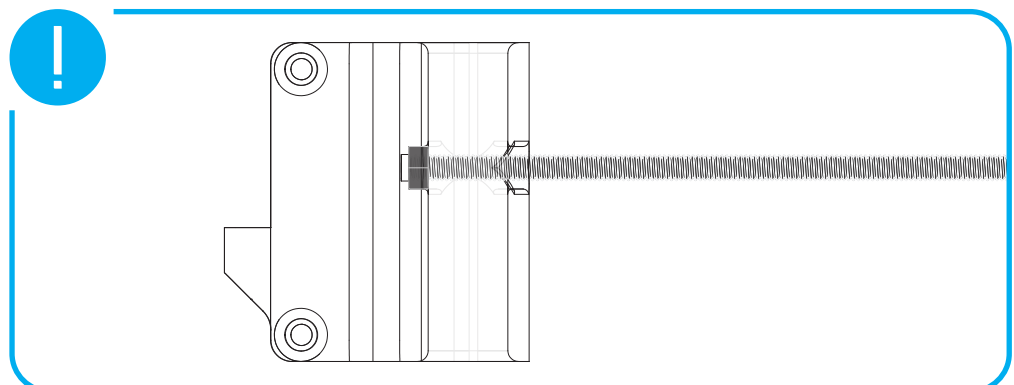


1x M5 Screw Nut Long Profile  
Porca M5 Perfil Longo

Attention: the parts are different  
Atenção: as peças são diferentes



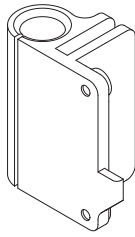
Try using the threaded rod so that screw nut is perfectly aligned  
Experimenta usar o varão roscado para que a porca fique perfeitamente alinhada



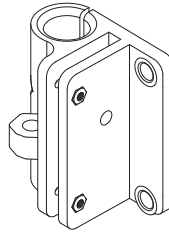
# F

## PHASE 2 FASE 2

You will need:  
Vais precisar:



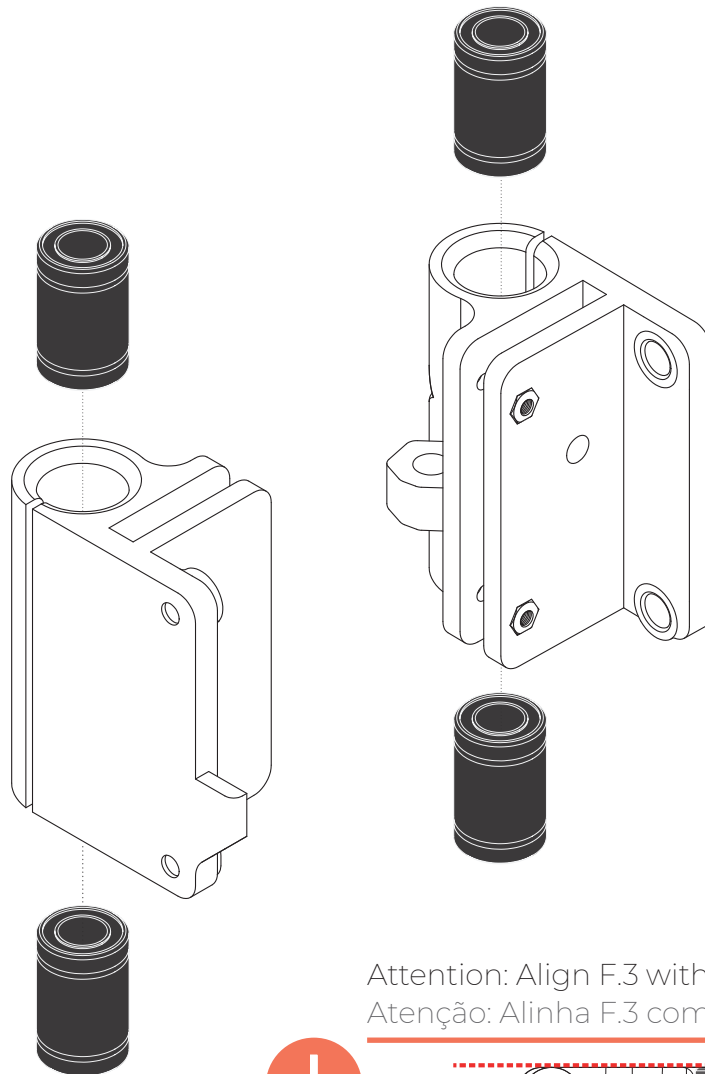
F.1



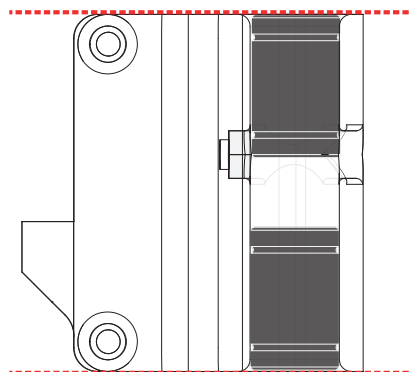
F.2



F.3 x4



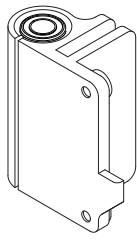
Attention: Align F.3 with the surface  
Atenção: Alinha F.3 com a superfície



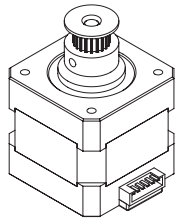
# G

## PHASE 2 FASE 2

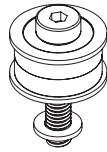
You will need:  
Vais precisar:



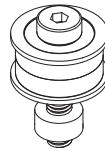
F.1



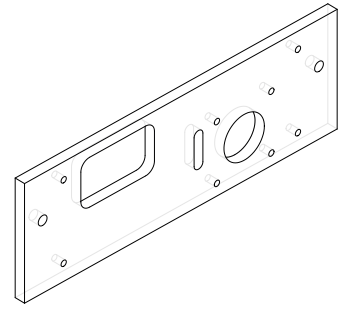
G.1



E.1 x1

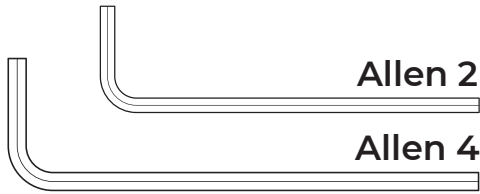


E.2



Structure 4 Estrutura 4

TOOLBOX



Allen 2

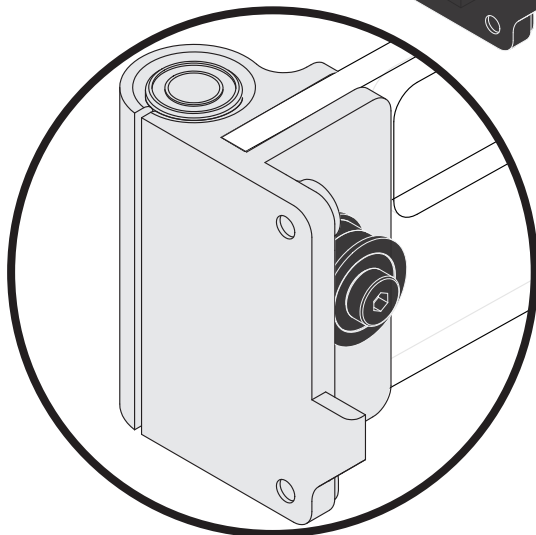
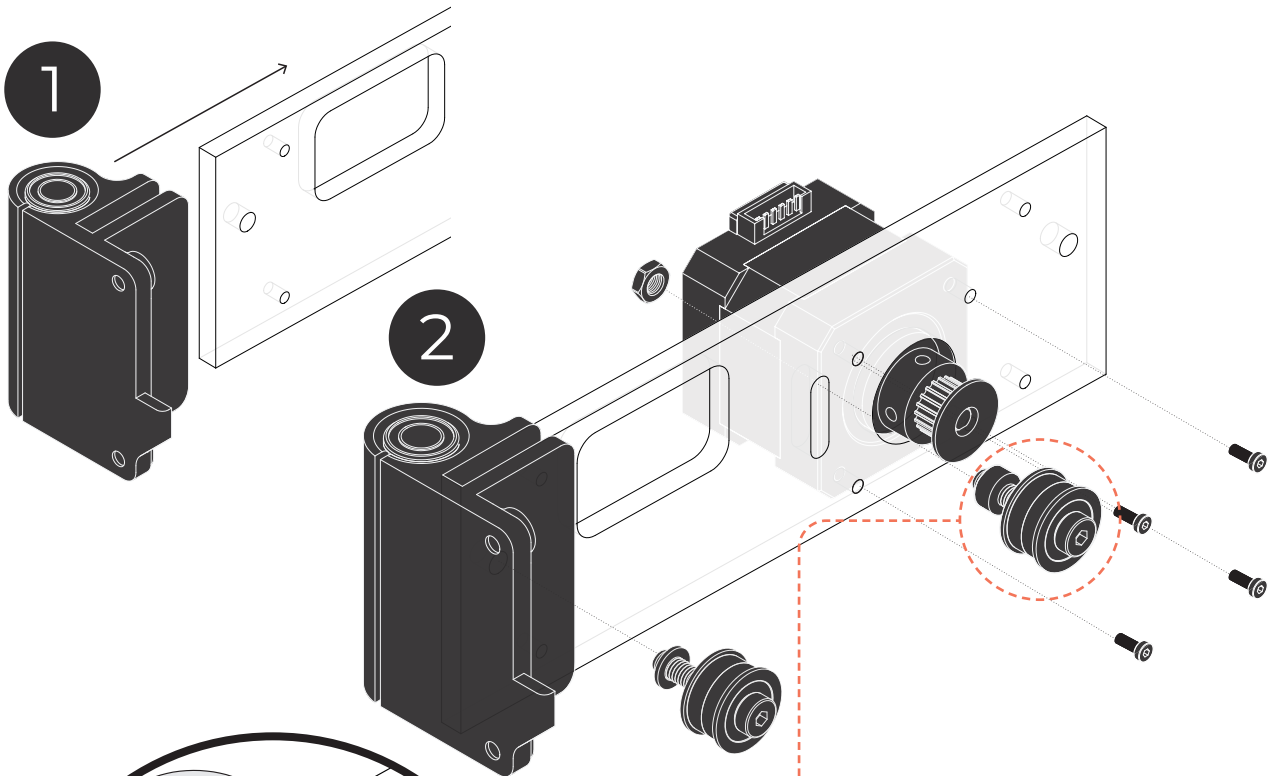
Allen 4



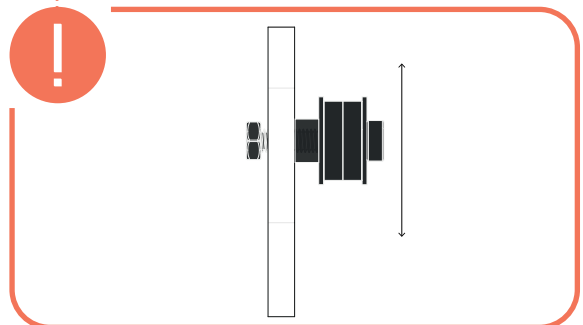
4x M3 8mm



1x M5 Screw Nut  
Porca M5



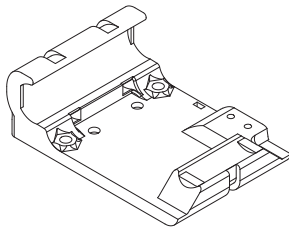
Attention: Let it loose  
Atenção: Deixar folgado



# H

PHASE 2  
FASE 2

You will need:  
Vais precisar:

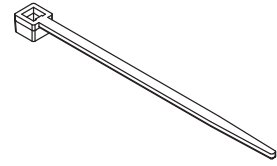


H.1

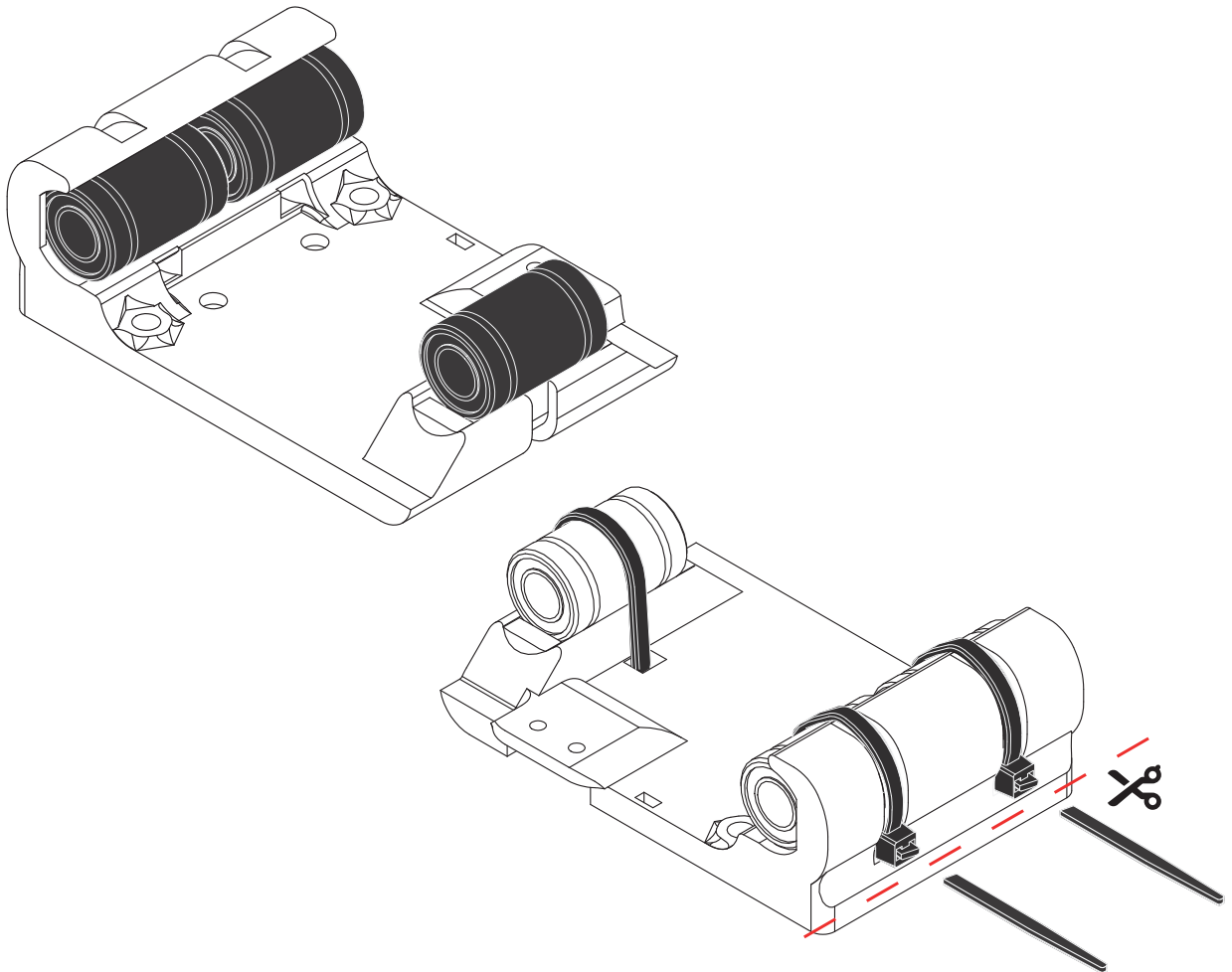


H.2 x3

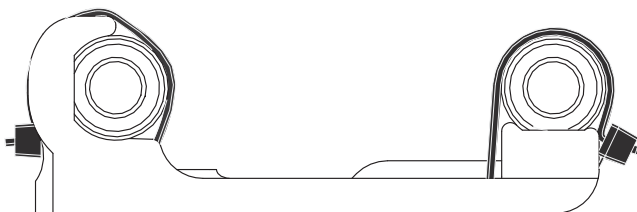
## TOOLBOX



3x Plastic Fastener  
Abraçadeira



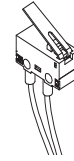
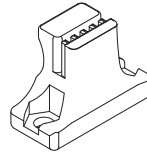
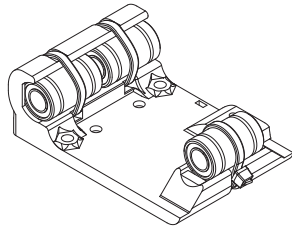
Attention: Last position of the plastic fasteners  
Atenção: Posição final das abraçadeiras



# H

## PHASE 2 FASE 2

You will need:  
Vais precisar:

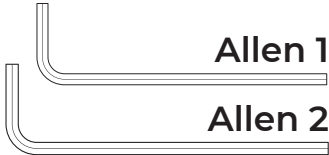


### TOOLBOX

### H.1

### H.3

### H.4



Allen 1

Allen 2



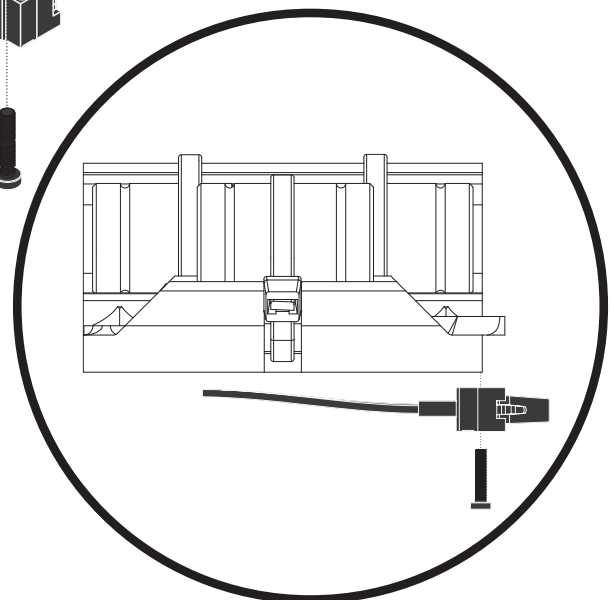
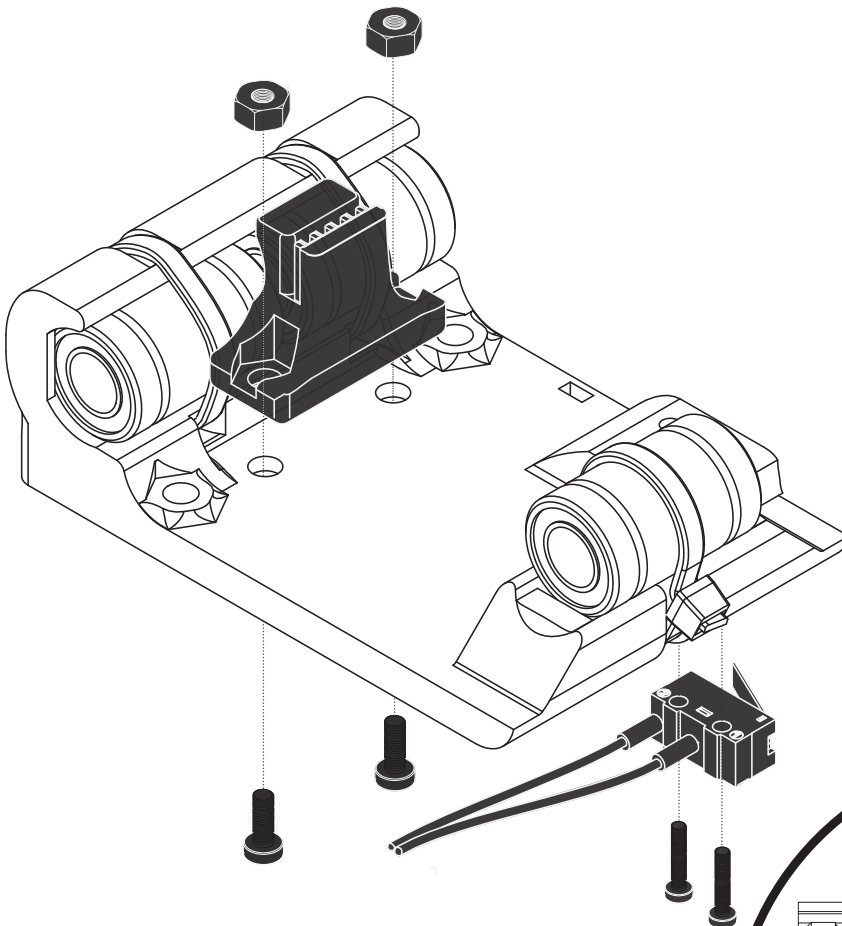
2x M3 8mm



2x M2 8mm



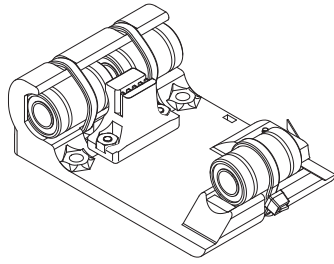
2x M3 Screw Nut  
Porcas M3



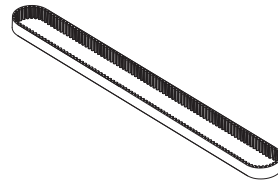
# H

PHASE 2  
FASE 2

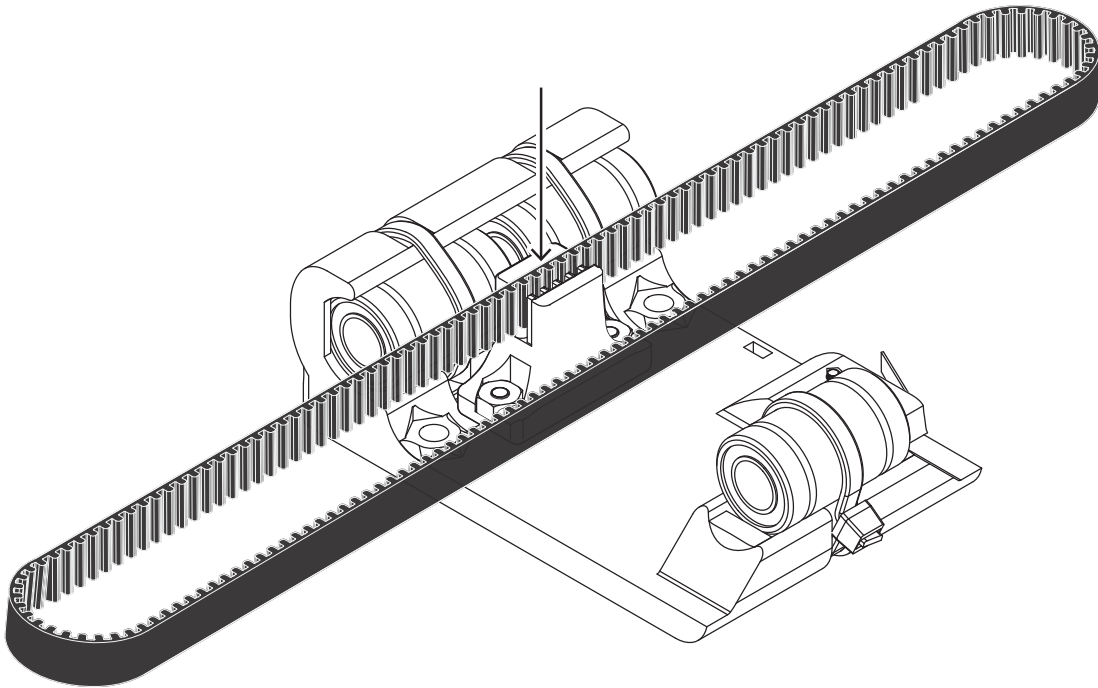
You will need:  
Vais precisar:



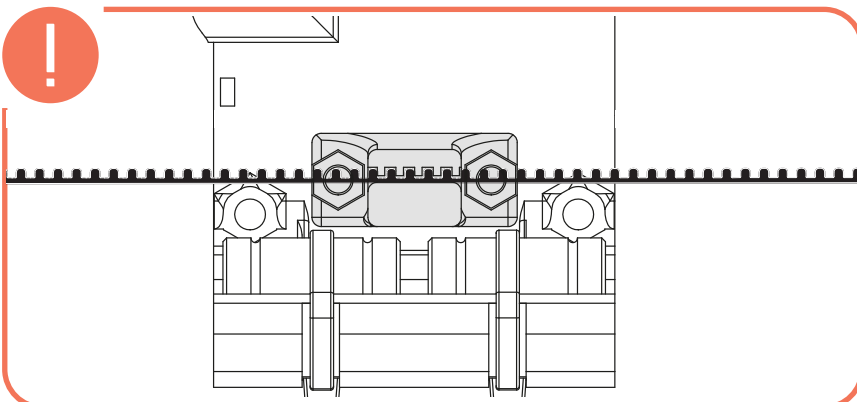
H.1



H.5 x 1

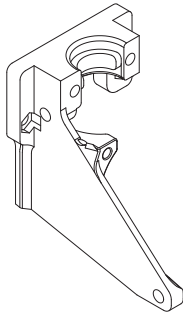


Attention: Position of the belt  
Atenção: Posicionamento da correia



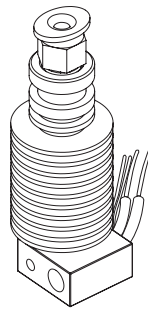


You will need:  
Vais precisar:

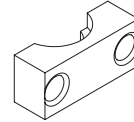


TOOLBOX

I.1



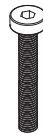
I.2



I.3



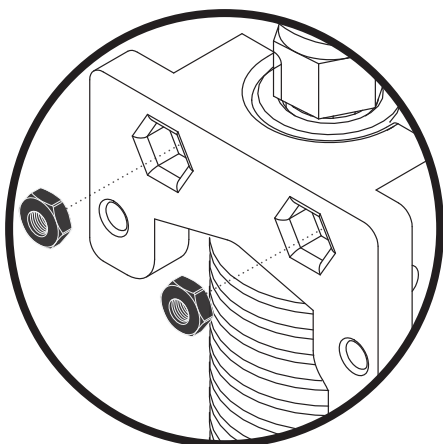
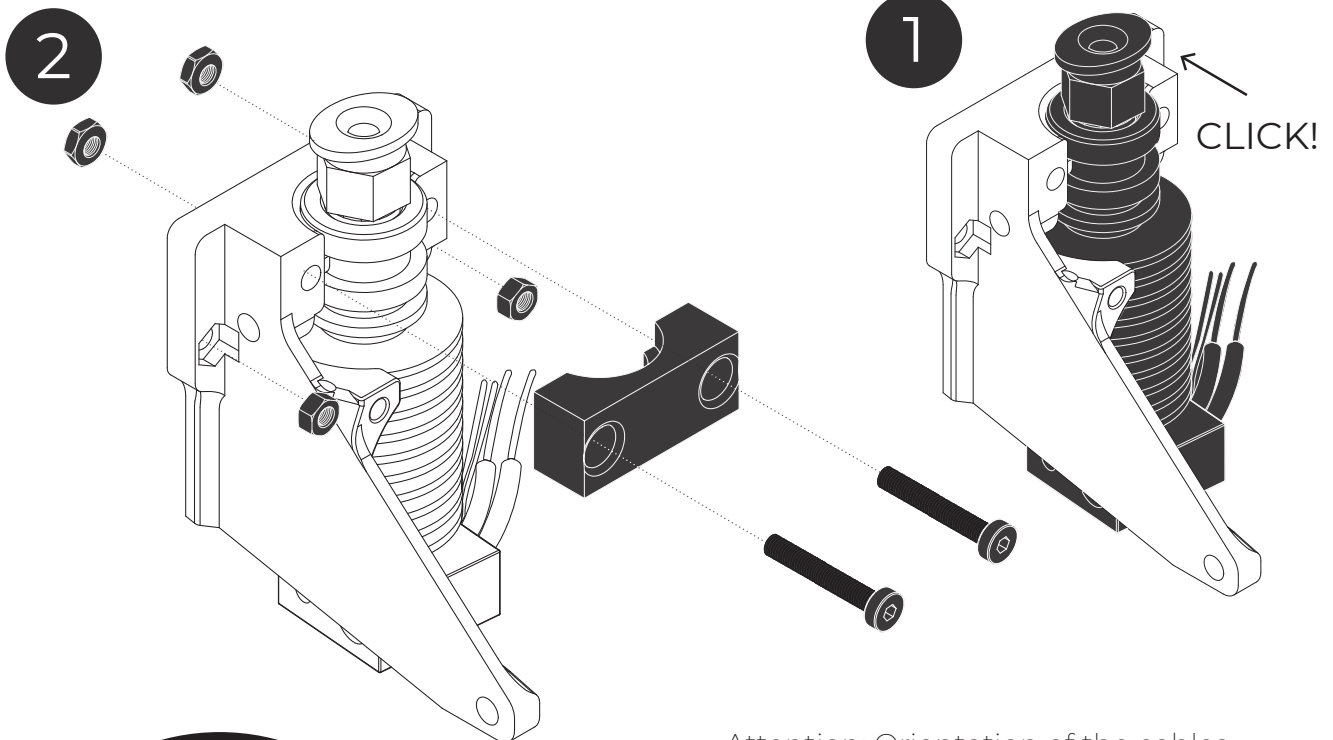
Allen 2



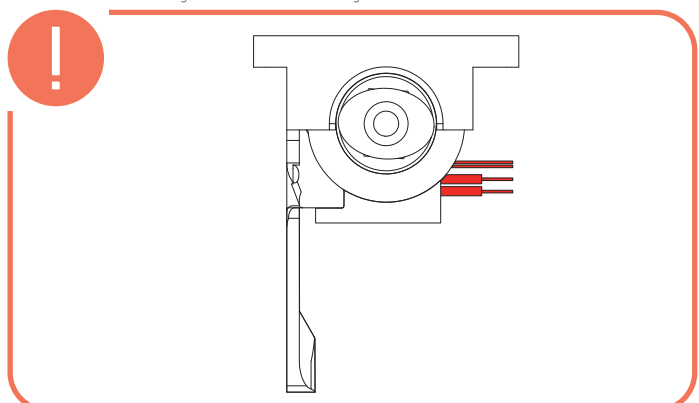
2x M3 20mm



4x M3 Screw Nut  
Porcas M3

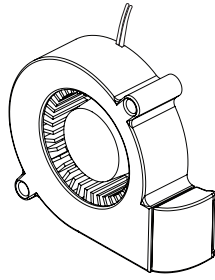


Attention: Orientation of the cables  
Atenção: Orientação dos cabos

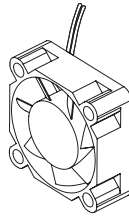


# J

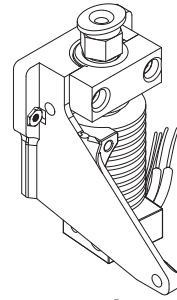
You will need:  
Vais precisar:



J.1

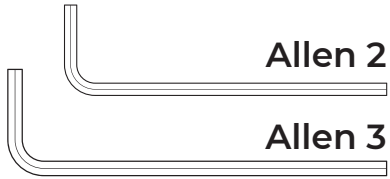


J.2



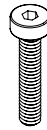
I

## TOOLBOX



Allen 2

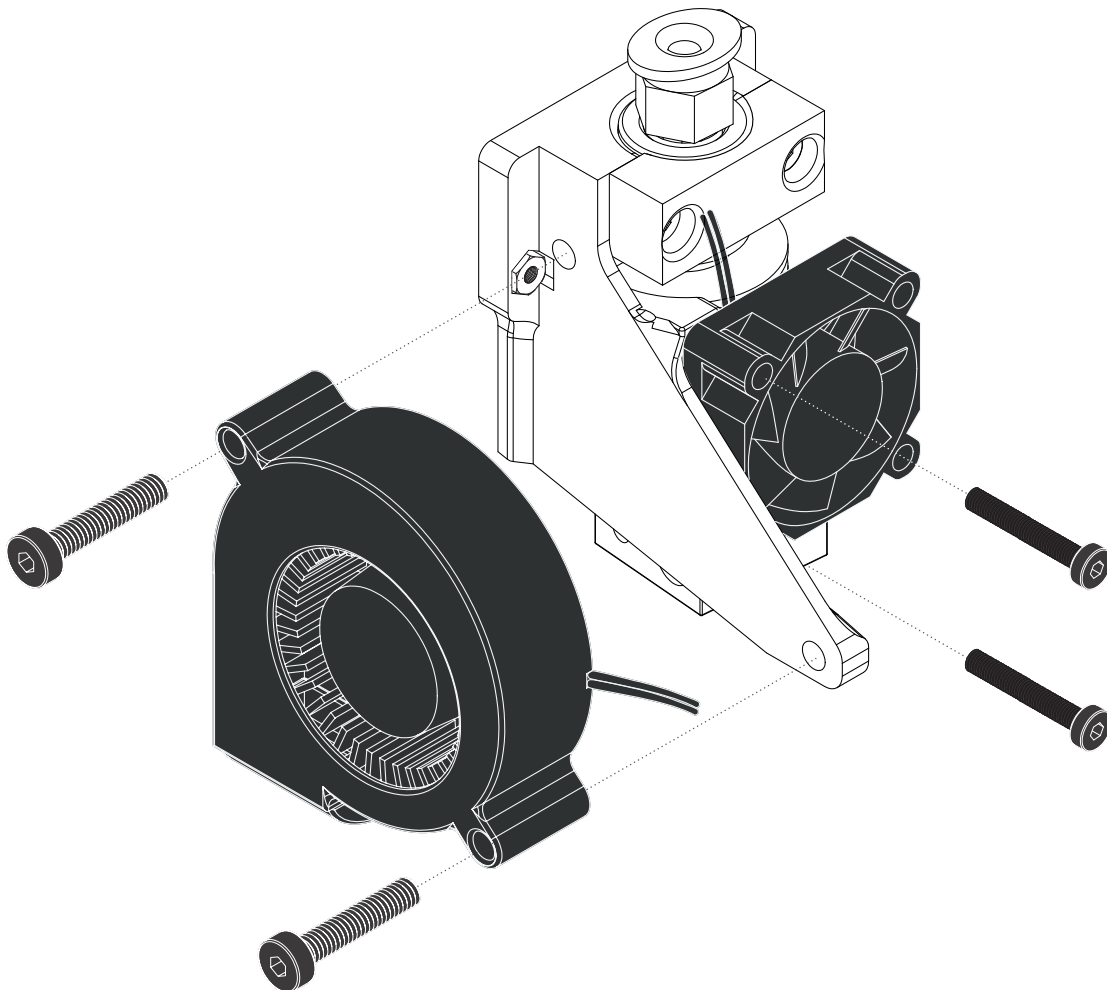
Allen 3



2x M4 20mm



2x M3 16mm

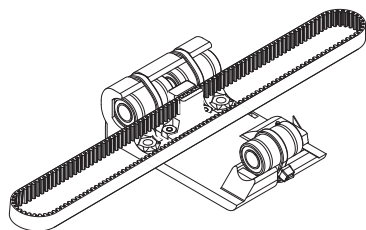


# ELEMENTS ASSEMBLY

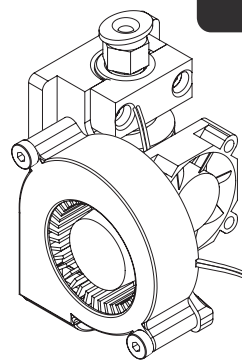
## ELEMENTOS: MONTAGEM

PHASE 2  
FASE 2

You will need:  
Vais precisar:



H



I

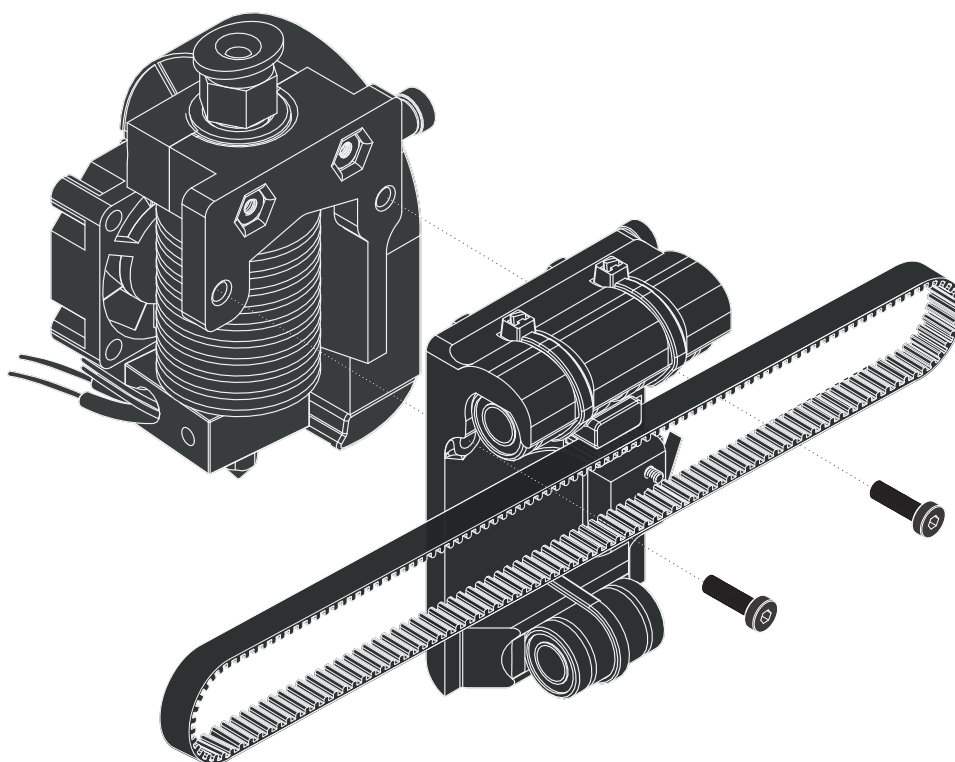
TOOLBOX



Allen 2



2x M3 10mm

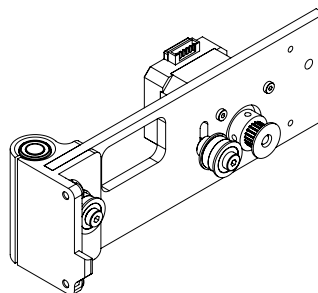
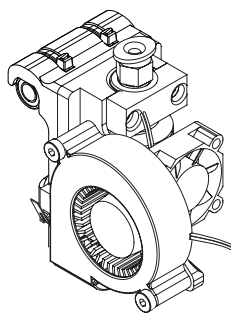


# ELEMENTS ASSEMBLY

## ELEMENTOS: MONTAGEM

PHASE 2  
FASE 2

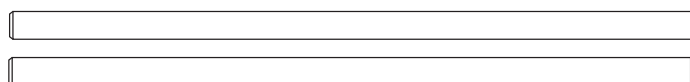
You will need:  
Vais precisar:



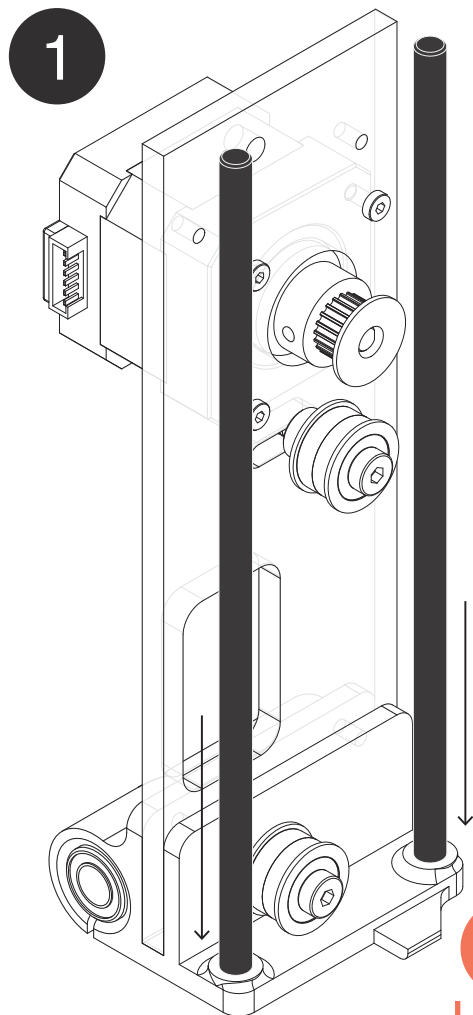
TOOLBOX

I

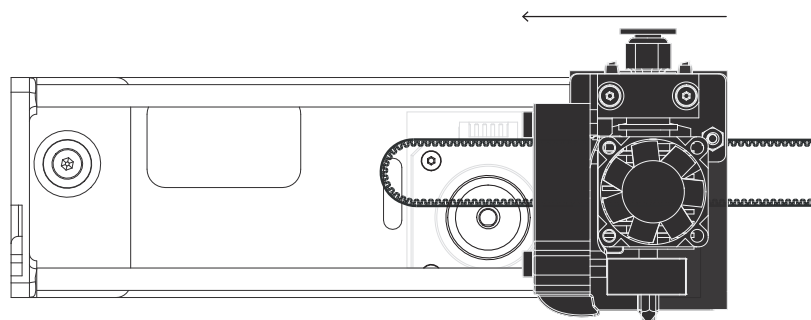
Structure 4 Estrutura 4



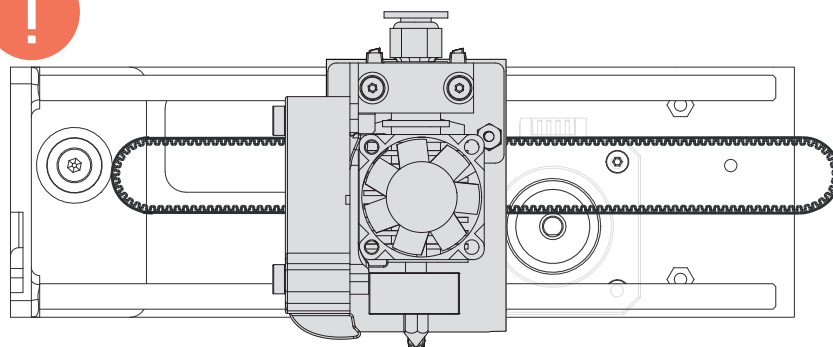
Smallest Rods  
Varões Pequenos



2



Attention: Hold the belt in a way it passes between the rods  
Atenção: Segura a correia de forma a passar no meio dos varões

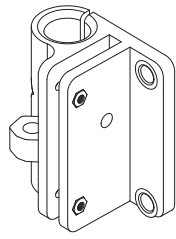


# ELEMENTS ASSEMBLY

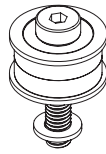
## ELEMENTOS: MONTAGEM

PHASE 2  
FASE 2

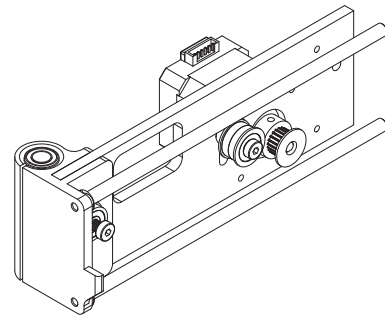
You will need:  
Vais precisar:



F.2

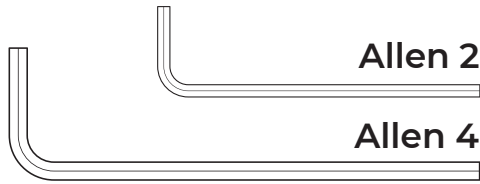


1x E.1



Structure 4 Estrutura 4

TOOLBOX

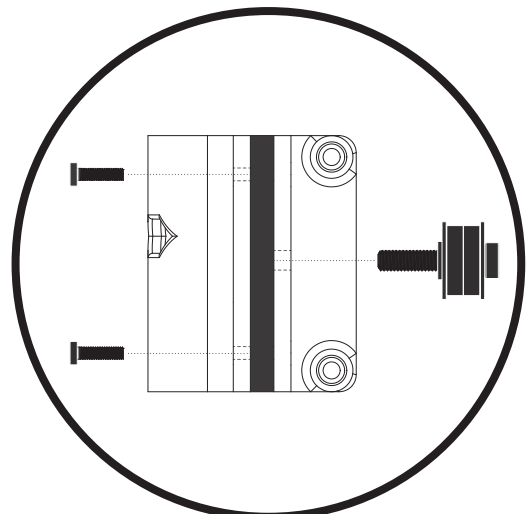
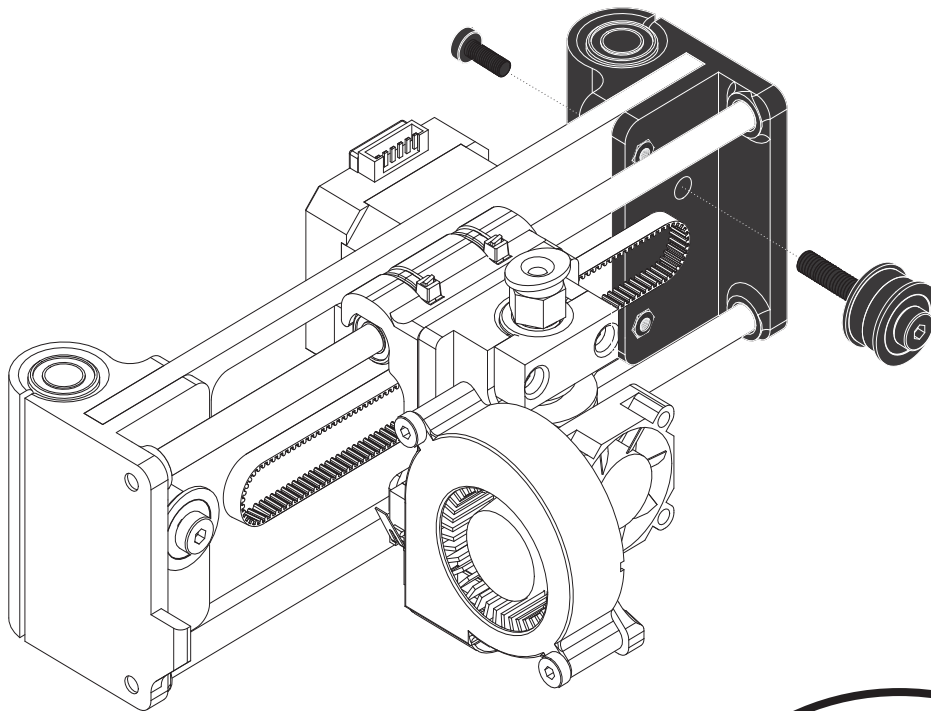


Allen 2

Allen 4



2x M3 10mm



# ELEMENTS ASSEMBLY

## ELEMENTOS: MONTAGEM

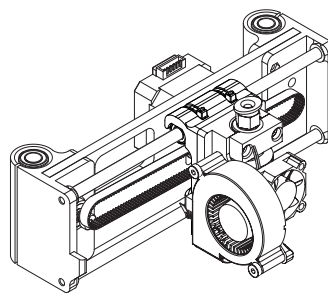
PHASE 2  
FASE 2

You will need:  
Vais precisar:

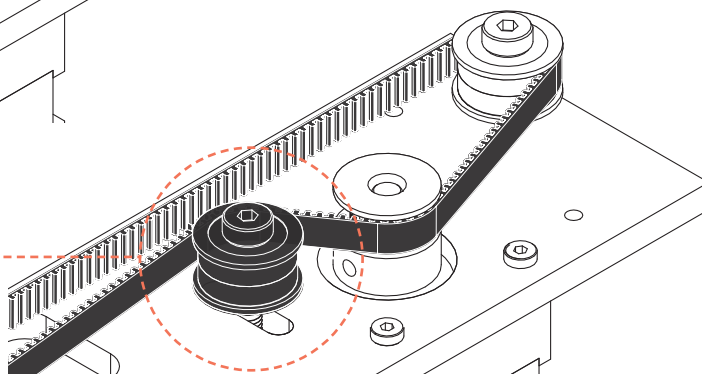
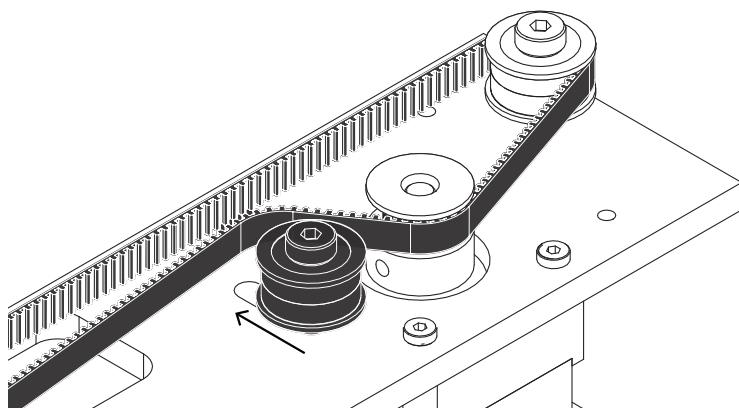
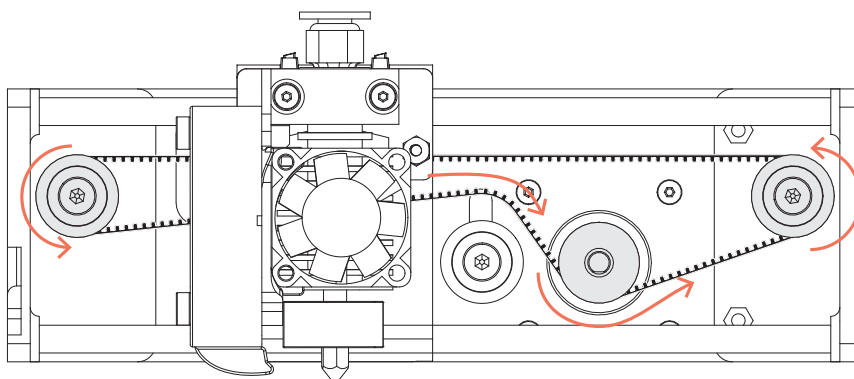
### TOOLBOX



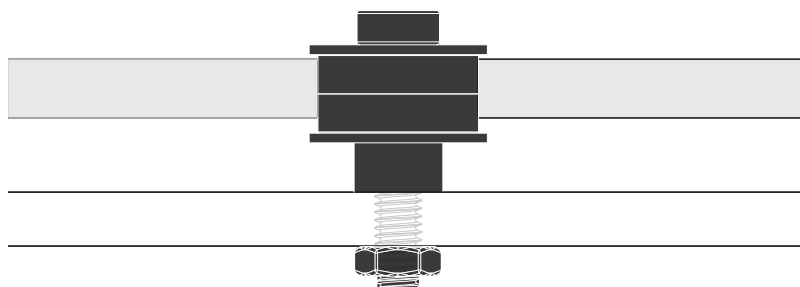
Allen 4



Structure 4 Estrutura 4



Attention: Tighten up the screw when the belt is tensioned  
Atenção: Aperta o parafuso quando a correia estiver tencionada



# LAST ASSEMBLY ÚLTIMA MONTAGEM

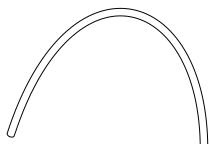
PHASE 2  
FASE 2

You will need:  
Vais precisar:



Threaded rod  
Varão roscado

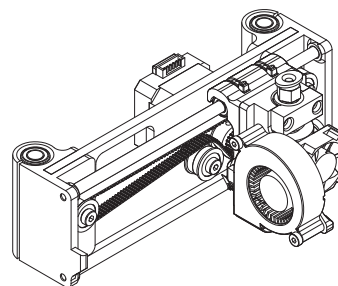
## TOOLBOX



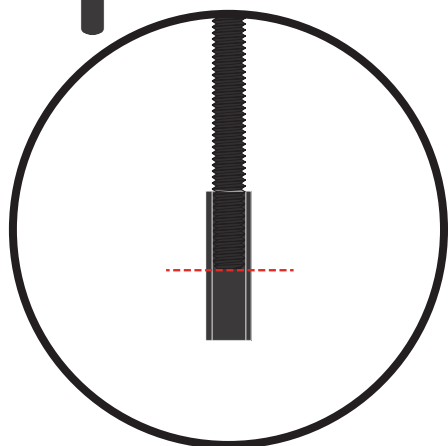
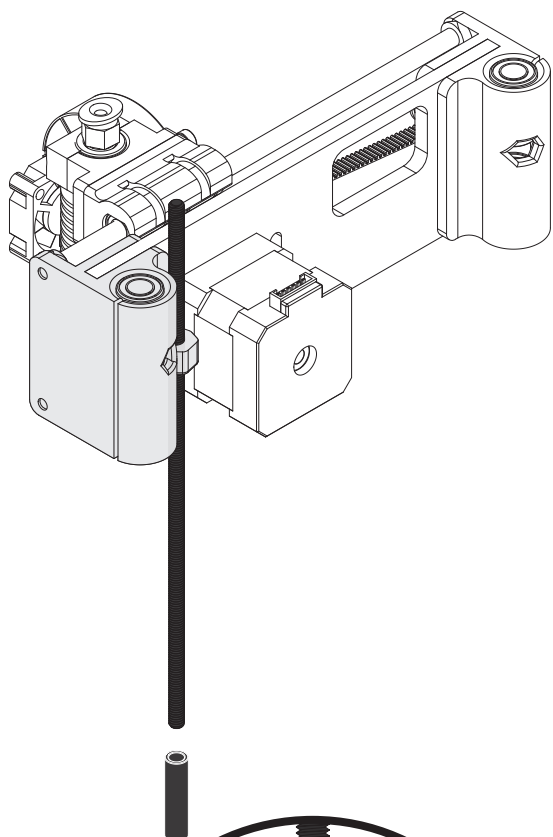
PTFE tube  
Tubo PTFE



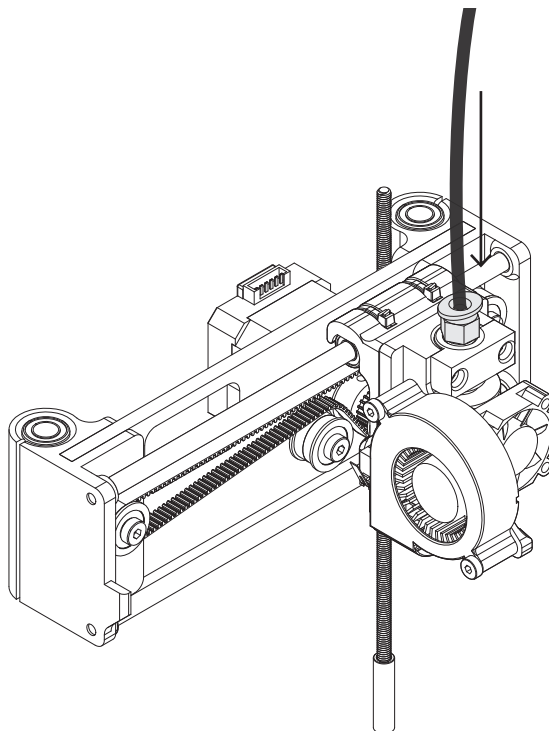
Silicone spacer  
Espaçador de Silicone

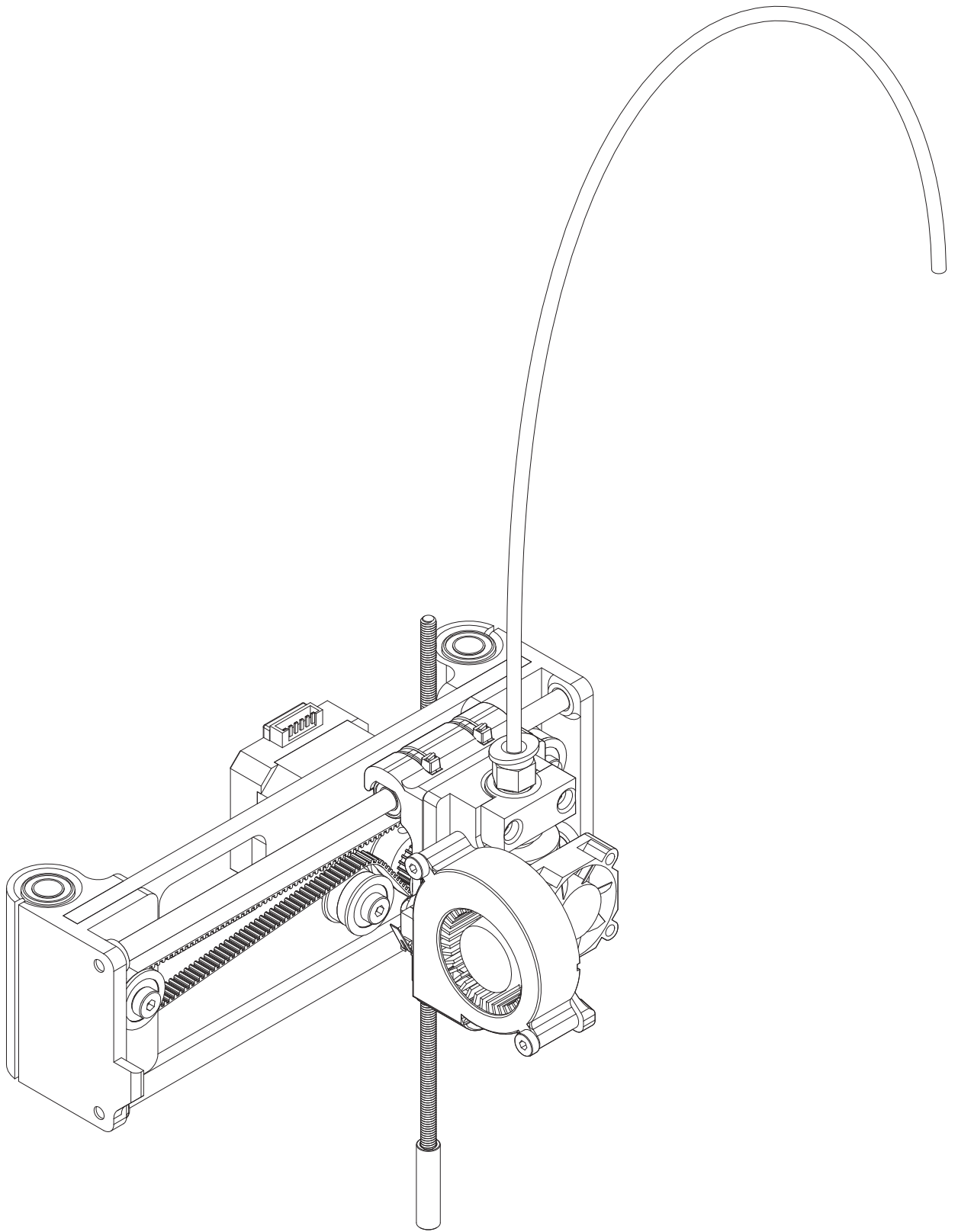


Structure 4 Estrutura 4



Attention: Insert the PTFE tube all the way into the hotend  
Atenção: Insere o tubo de PTFE até ao fim do hotend





**Phase 2 has been concluded!**  
**A Fase 2 está concluída!**



# **STRUCTURE**

## ESTRUTURA

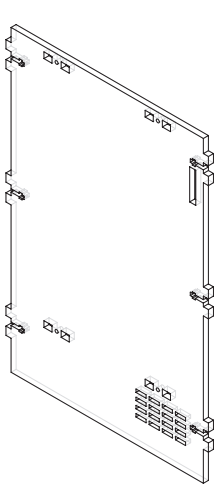
**Part**  
Parte

# **1**

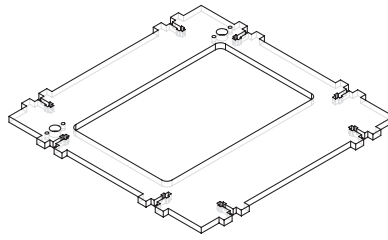
# STRUCTURE PRE-ASSEMBLY

## ESTRUTURA: PRÉ-MONTAGEM

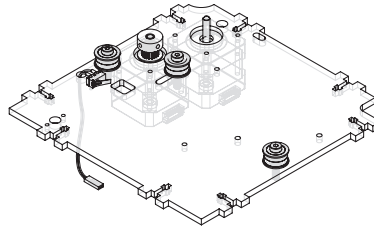
You will need:  
Vais precisar:



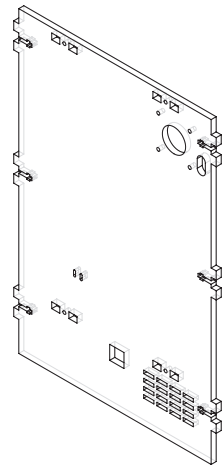
**Structure 5**  
Estrutura 5



**Structure 7**  
Estrutura 7



**Structure 1**  
Estrutura 1

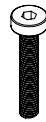


**Structure 6**  
Estrutura 6

**TOOLBOX**



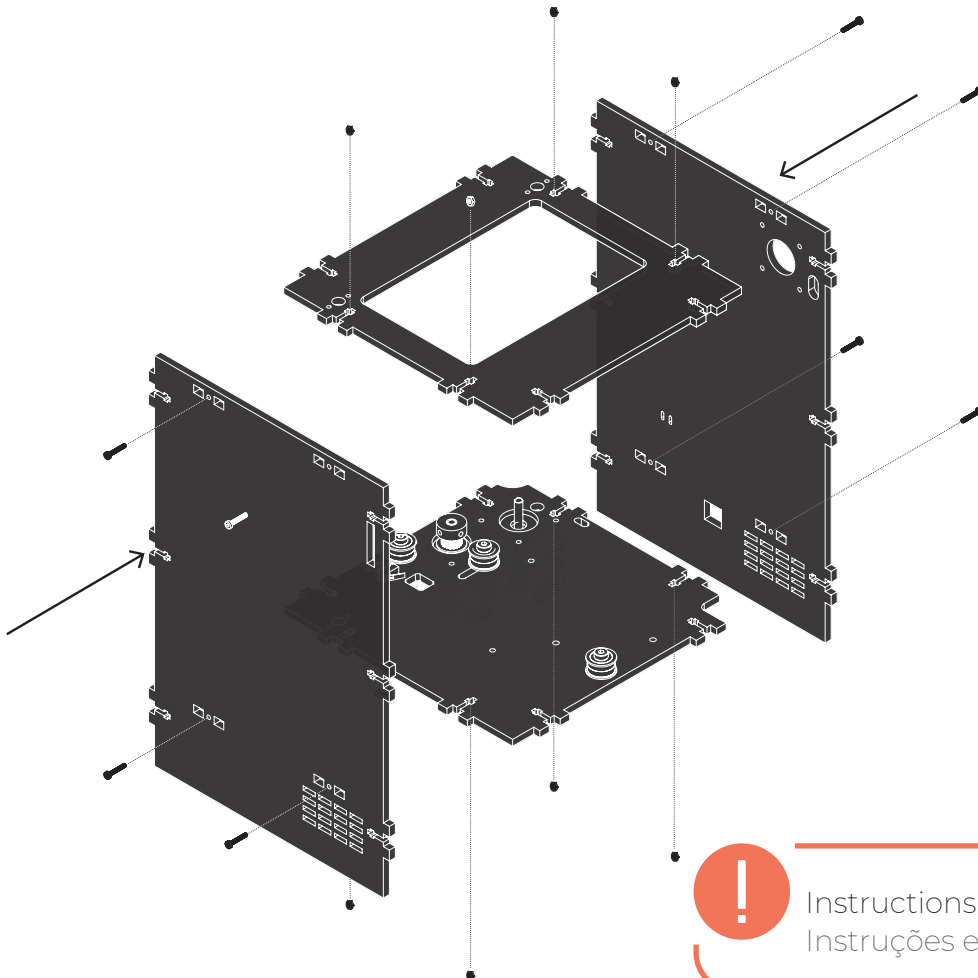
**Allen 2**



**8x M3 16mm**

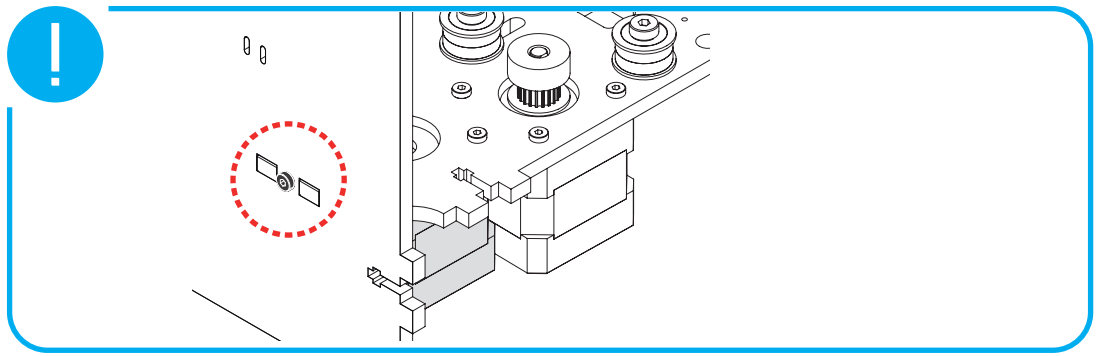


**8x M3 Screw Nut**  
Porcas M3

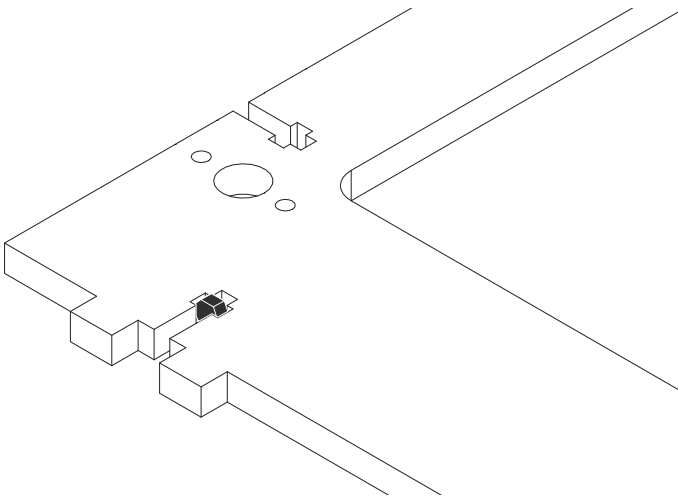


Instructions and tips in the next page  
Instruções e dicas na próxima página

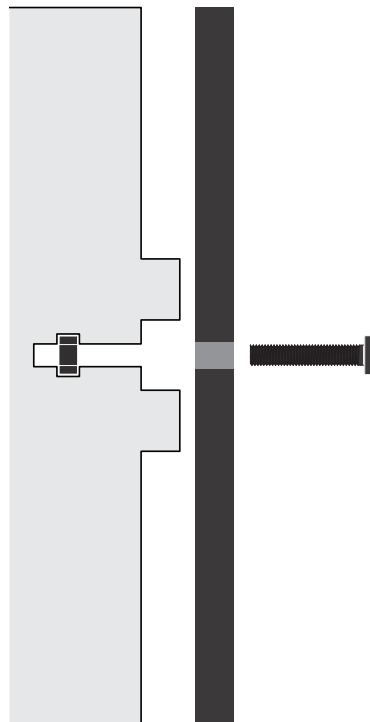
Start the assembly from the motor side to have more stability  
Começa a montagem pelo lado do motor para ganhar estabilidade



- 1 Insert and hold the screw nut in place  
Insere e mantém a porca no sítio



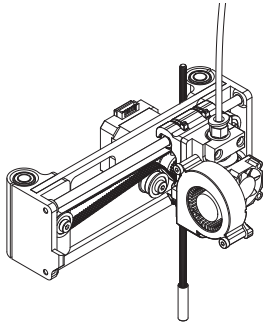
- 2 Insert the screw  
Insere o parafuso



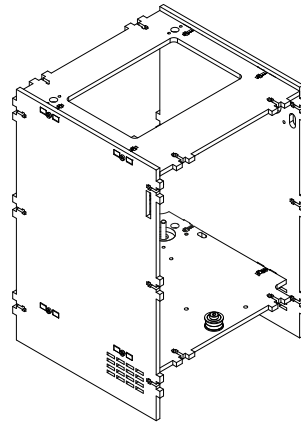
# STRUCTURE PRE-ASSEMBLY

## ESTRUTURA: PRÉ-MONTAGEM

You will need:  
Vais precisar:



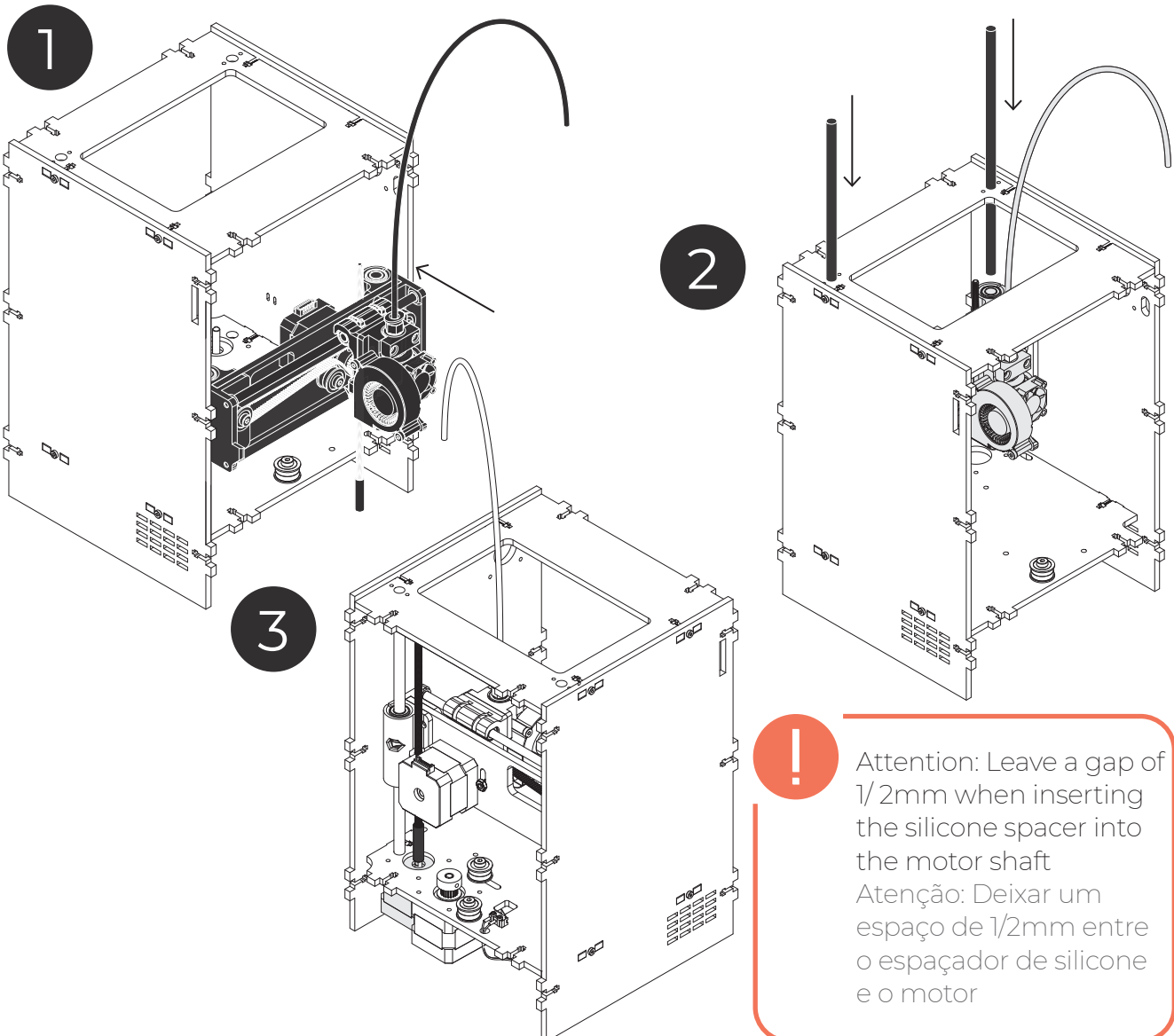
Phase 2 Fase 2



Structure  
Estrutura



2x Largest Rods  
Varões maiores



 90 min.

**PHASE**

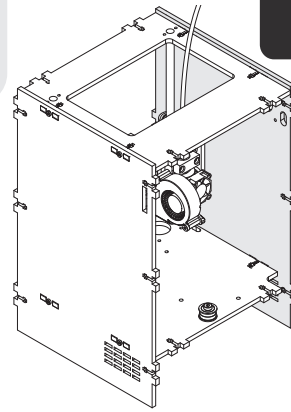
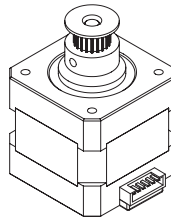
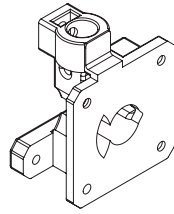
**FASE**

**3**

# K

PHASE 3  
FASE 3

You will need:  
Vais precisar:



TOOLBOX

K.1

K.2

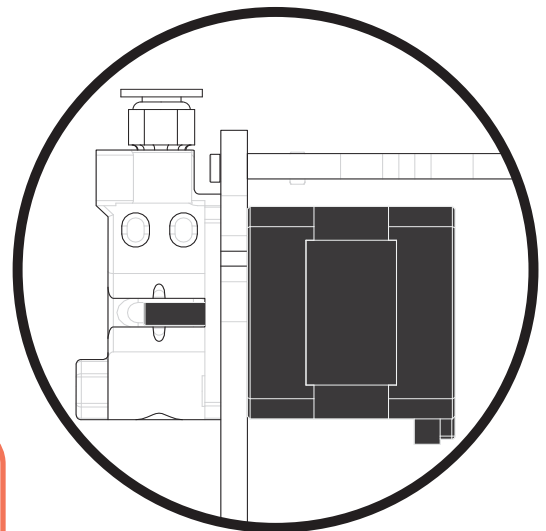
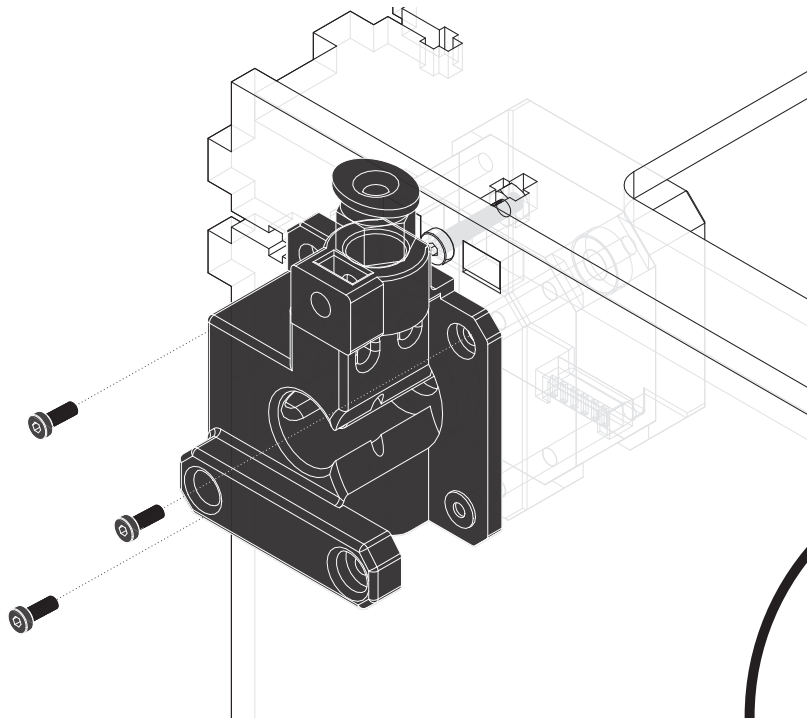
Structure Estrutura



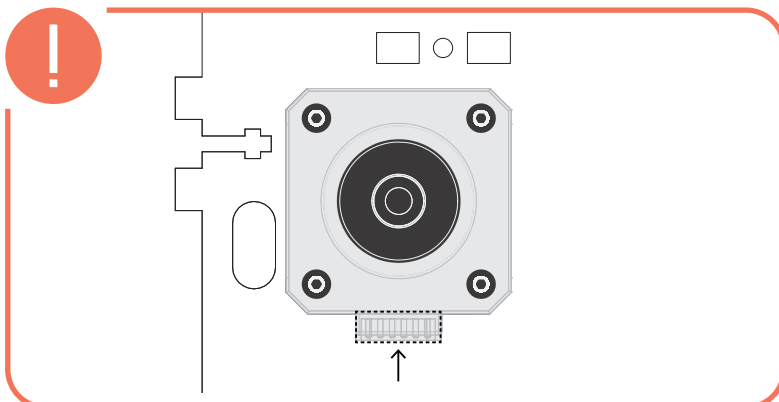
Allen 2



3x M3 10mm



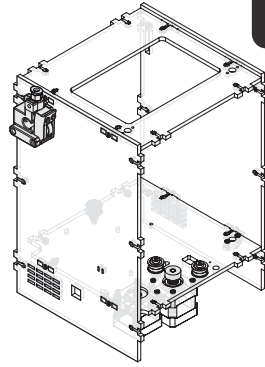
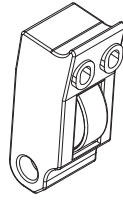
Attention: Direction of the cable plug  
Atenção: Direção da entrada de cabos



# L

PHASE 3  
FASE 3

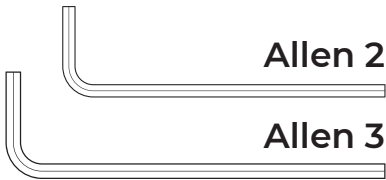
You will need:  
Vais precisar:



## TOOLBOX

L

K



Allen 2

Allen 3



1x M3 30mm



2x M3 50mm

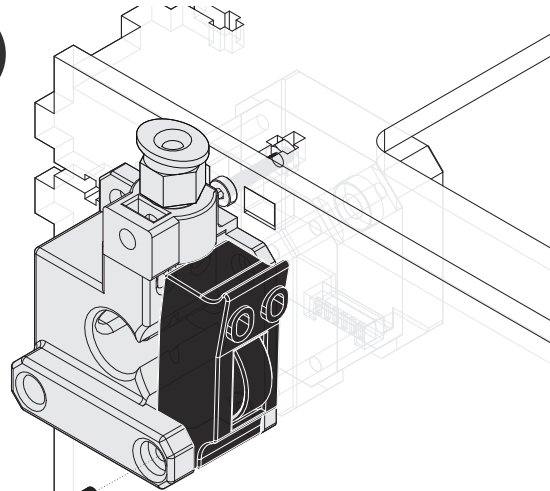


2x Larger Springs  
Molas Maiores

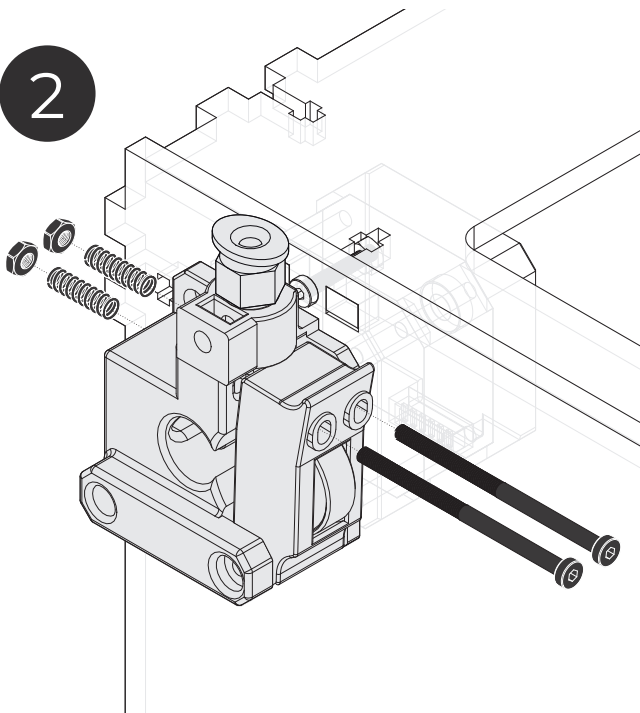


2x M3 Screw Nuts  
Porcas M3

1

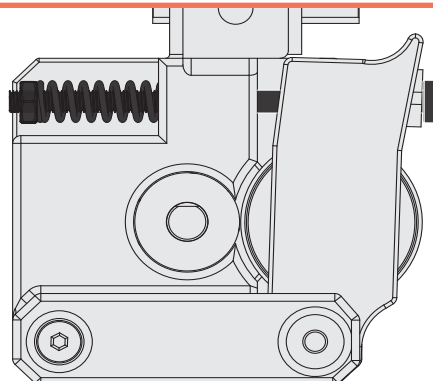


2



Attention: The screw must pass around 2/3 mm beyond the nut.

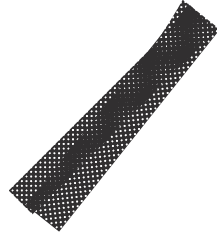
Atenção: O parafuso deve passar cerca de 2/3 mm para além da porca.



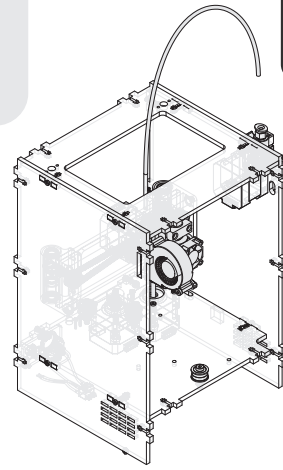
# M

PHASE 3  
FASE 3

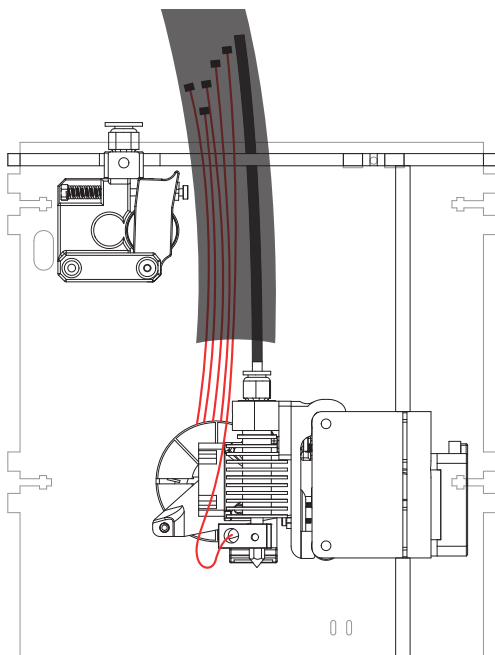
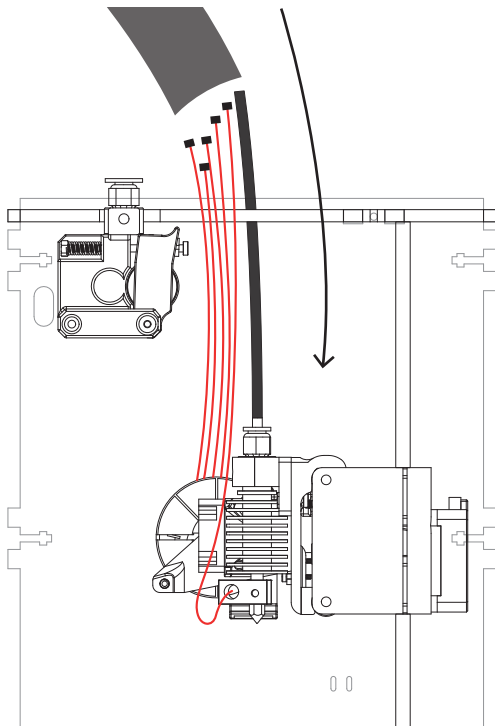
You will need:  
Vais precisar:



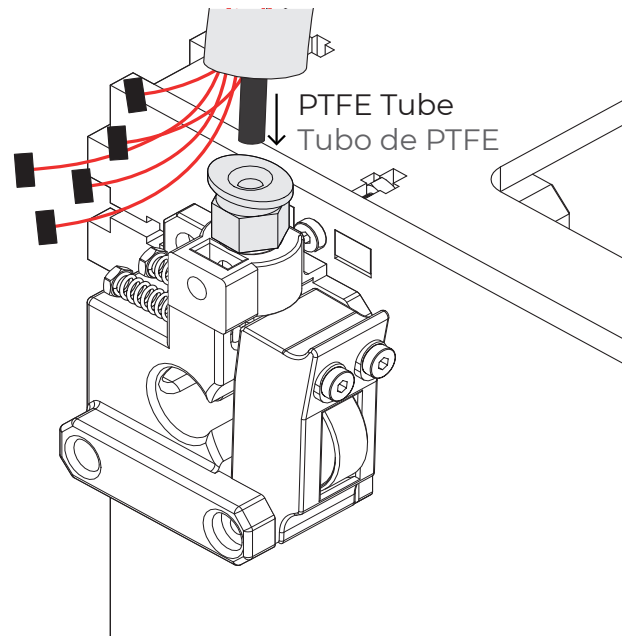
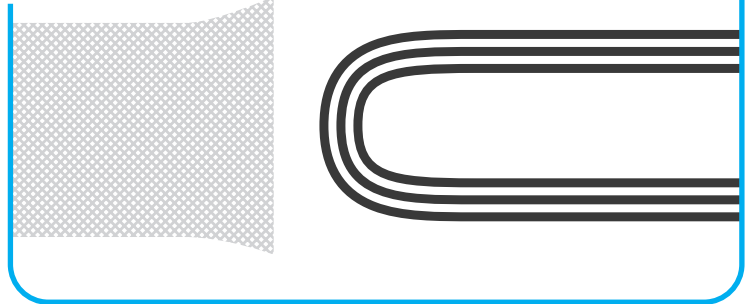
Protective Sleeve Manga



Structure Estrutura



Bend the cables in half for an easy passage  
Dobra os cabos para passar facilmente



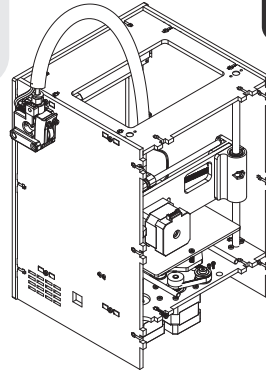
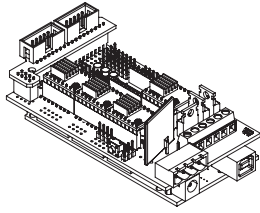
Attention: Insert around 3 cm of PTFE tube inside the extruder.  
Atenção: Insere cerca de 3 cm de tubo PTFE no extrusor.



# N

## PHASE 3 FASE

You will need:  
Vais precisar:

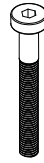


### TOOLBOX

### Structure Estrutura



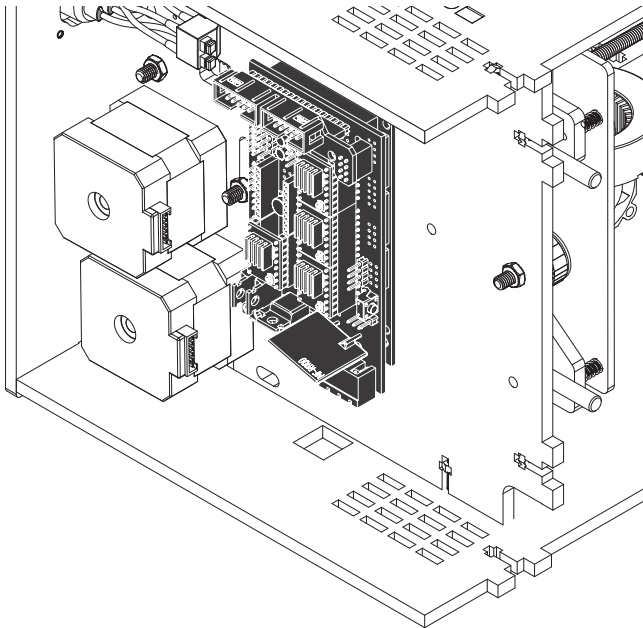
Allen 2



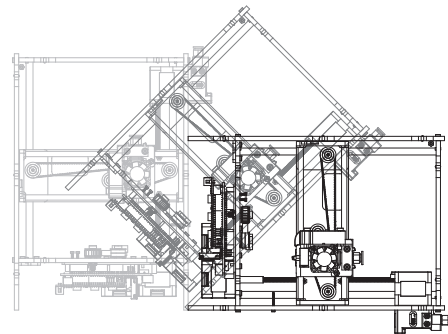
2x M3 30mm



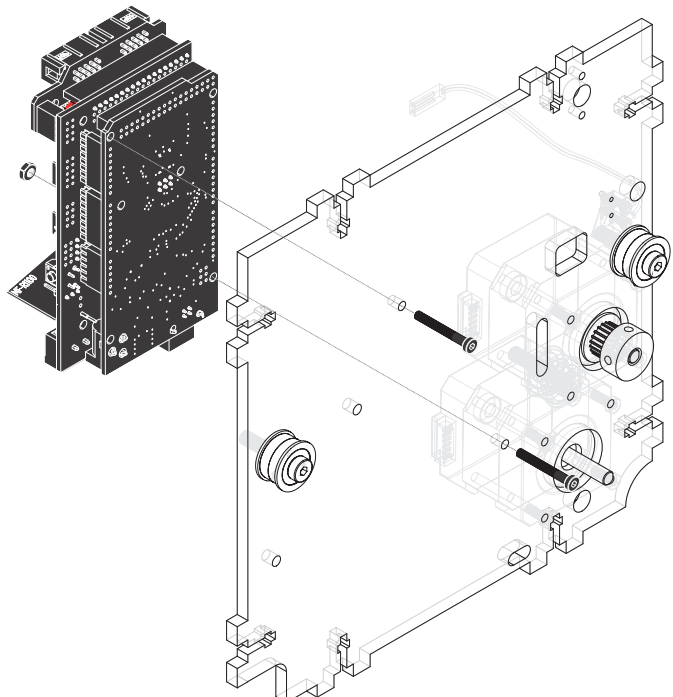
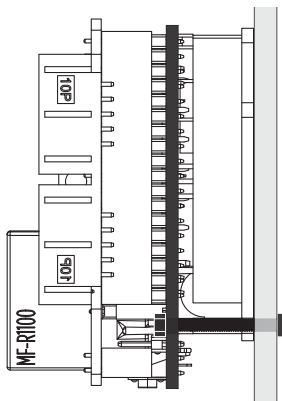
2x M3 Screw Nuts  
Porcas M3



Tip the machine 90 degrees (sideways)  
Vira a máquina a 90 graus (lateral)



Attention: Location of the screw nut  
Atenção: Localização da porca



# **STRUCTURE**

## ESTRUTURA

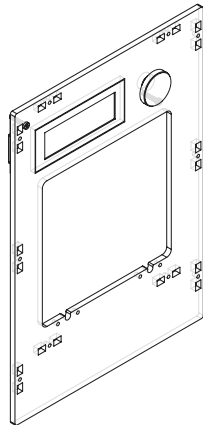
**Part**  
Parte

# **2**

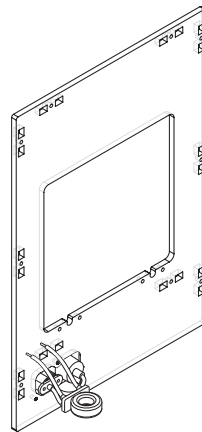
# STRUCTURE ASSEMBLY

## ESTRUTURA: MONTAGEM

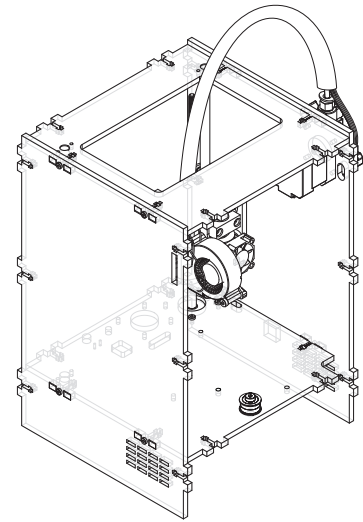
You will need:  
Vais precisar:



**Structure 2**  
**Estrutura 2**



**Structure 3**  
**Estrutura 3**



**Structure**  
**Estrutura**

TOOLBOX



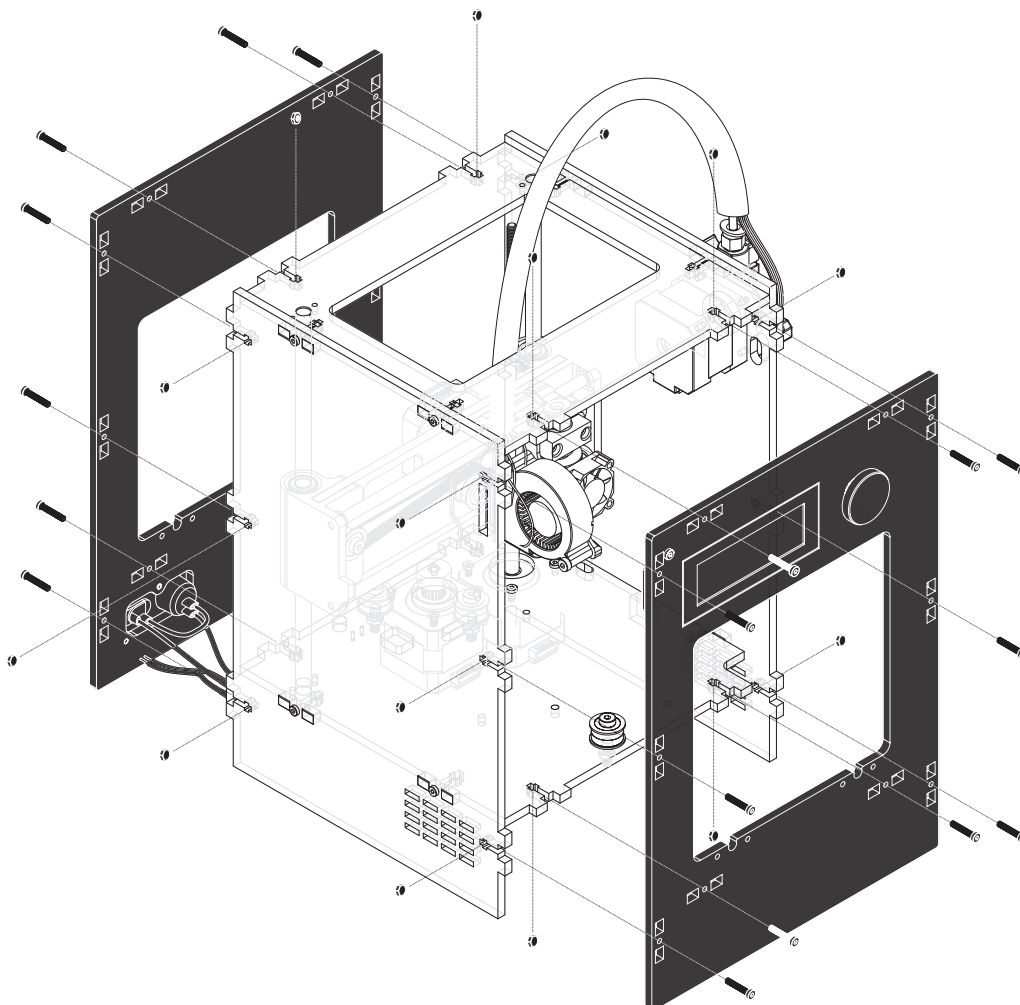
**Allen 2**

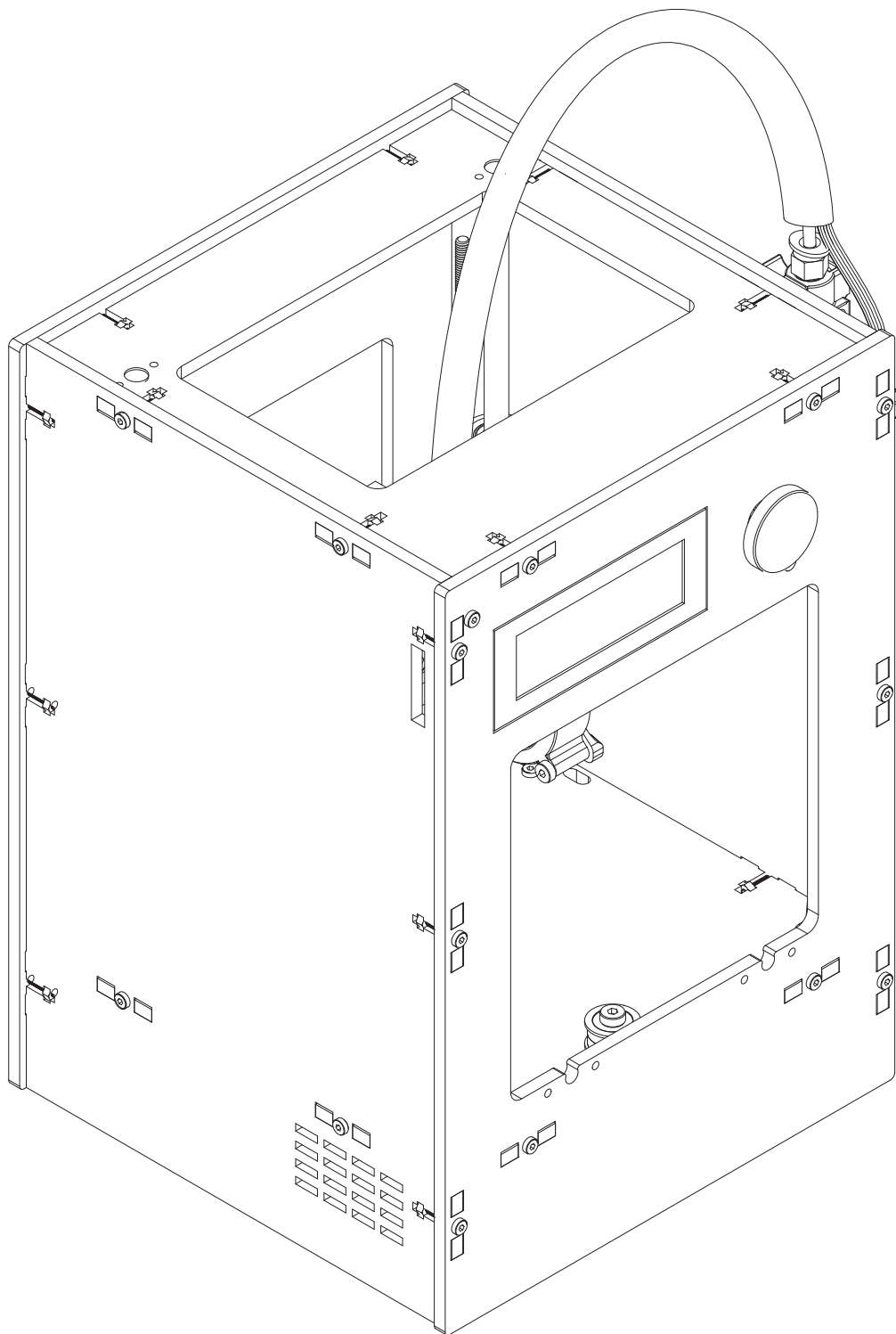


**20x M3 16mm**



**20x M3 Screw Nut**  
**Porcas M3**





**Phase 3 has been concluded!**  
**A Fase 3 está concluída!**

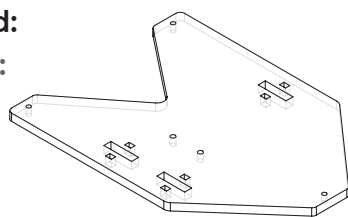
 40 min.

**PHASE**

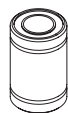
**FASE**

**4**

You will need:  
Vais precisar:

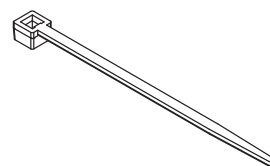


0.1

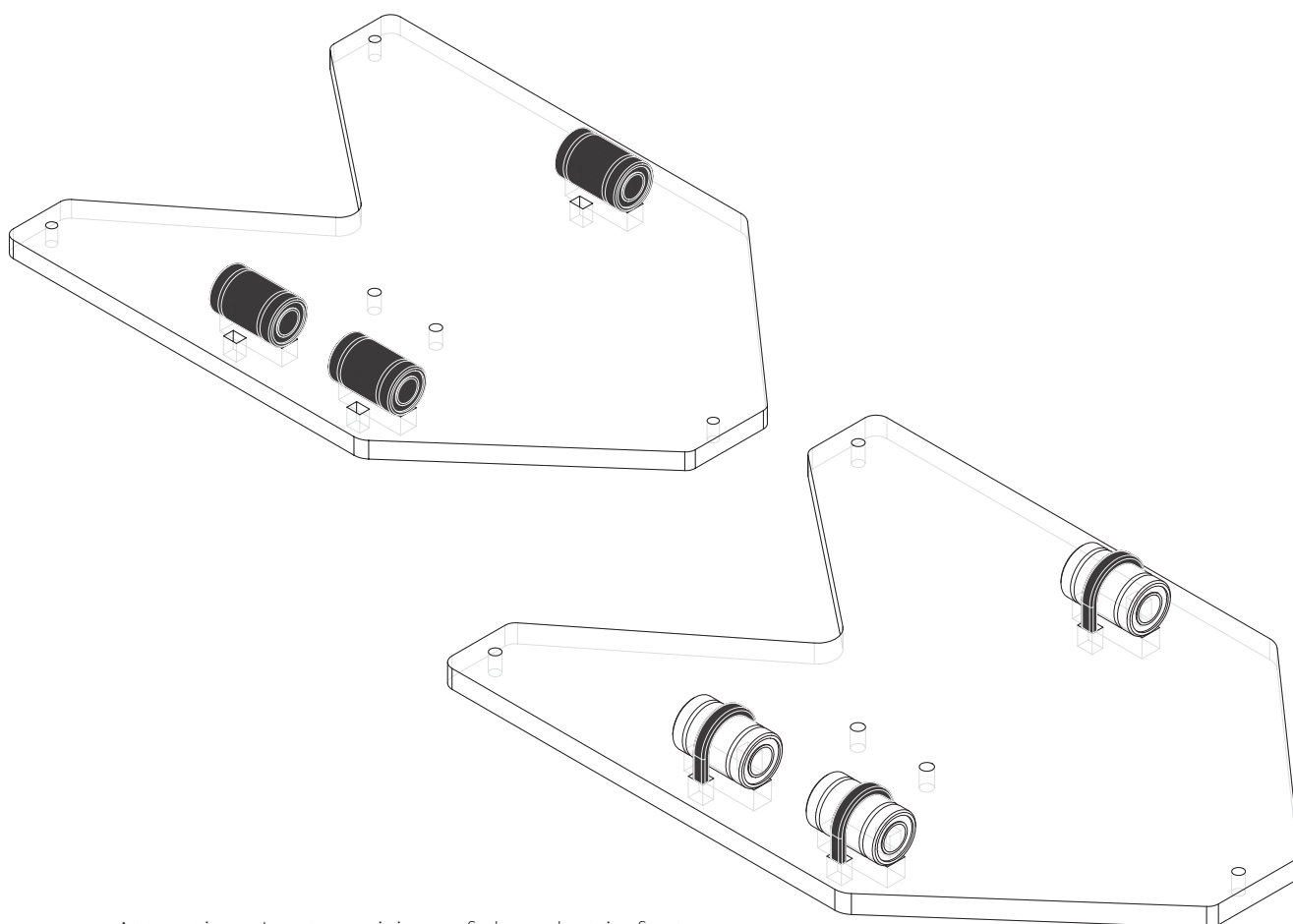


0.2 x3

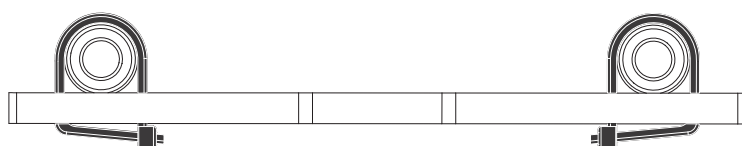
TOOLBOX



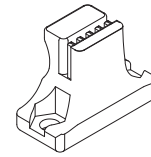
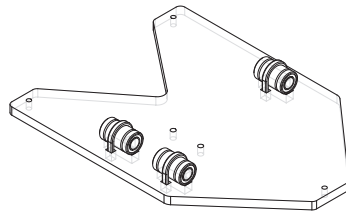
3x Plastic Fastener  
Abraçadeira



Attention: Last position of the plastic fasteners  
Atenção: Posição final das abraçadeiras



You will need:  
Vais precisar:



TOOLBOX

O.1

O.3



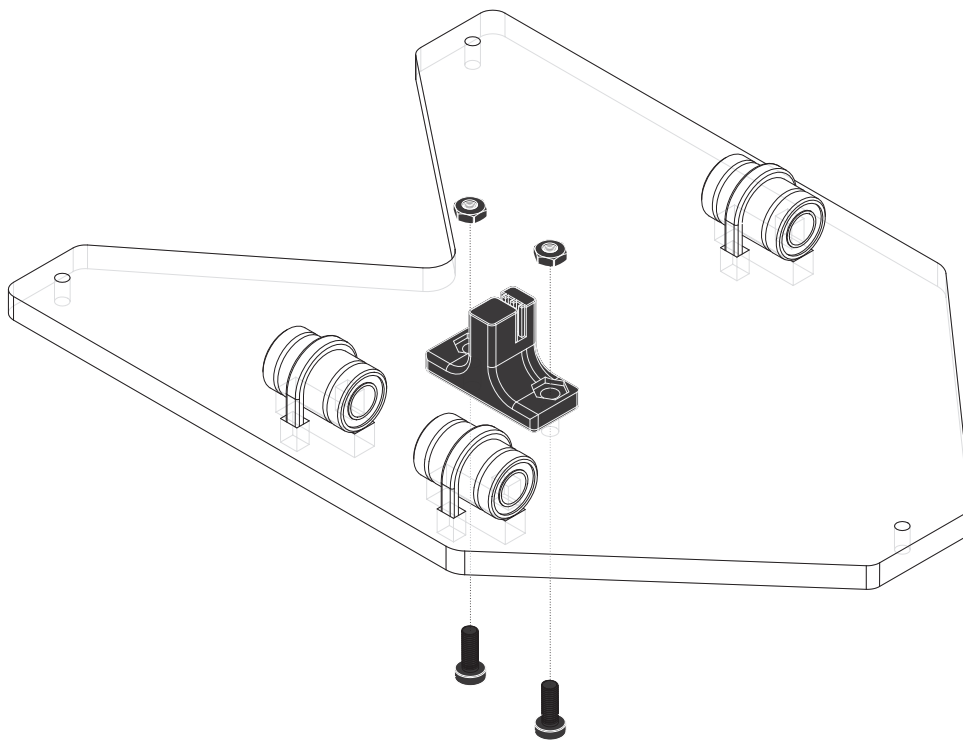
Allen 2



2x M3 10mm



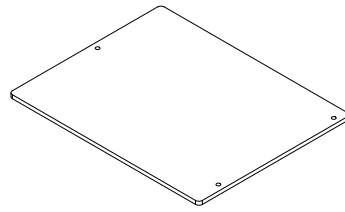
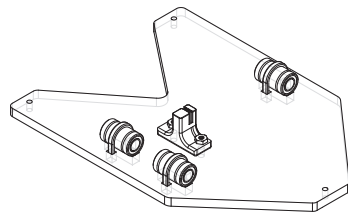
2x M3 Screw Nut  
Porcas M3



Attention: To the orientation of piece O.3  
Atenção: Orientação do componente O.3



You will need:  
Vais precisar:



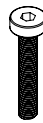
TOOLBOX

0.1

0.4



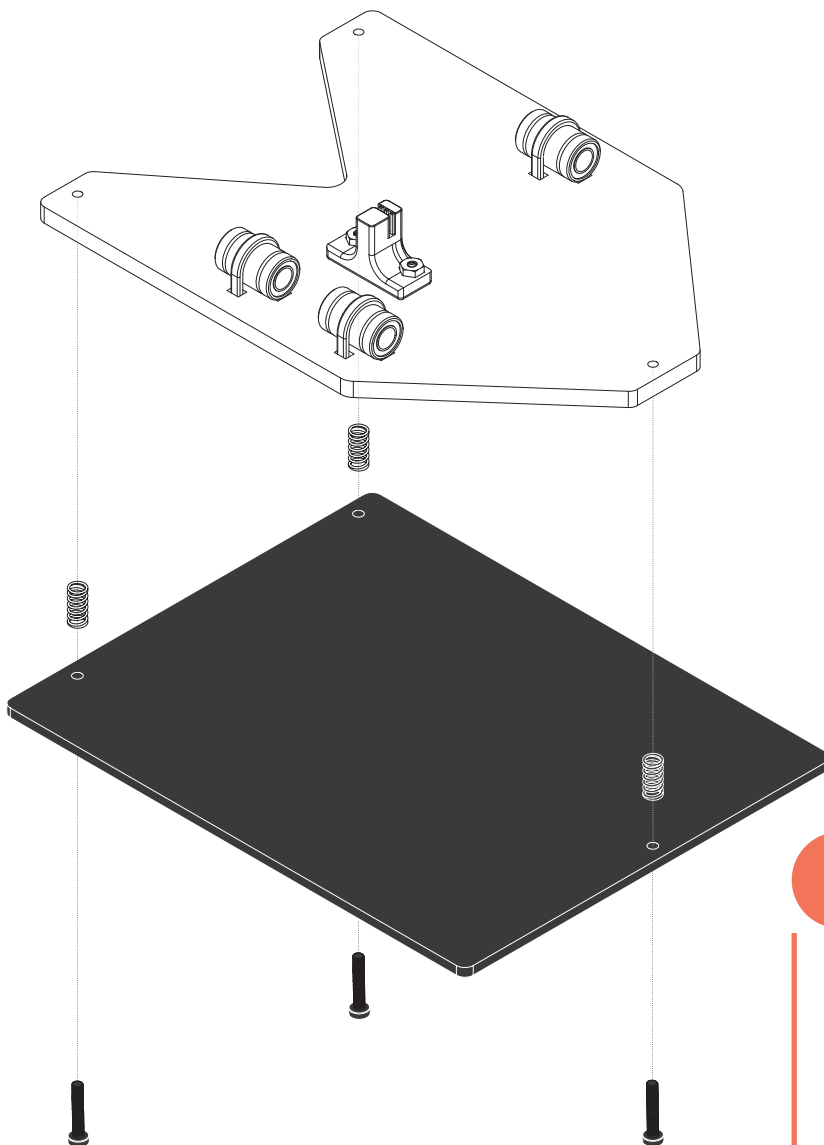
Allen 2



3x M3 16mm

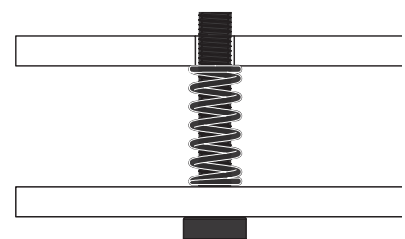


3x Short springs  
Molas curtas



Attention: For a successful calibration later, leave 2mm of the screw out

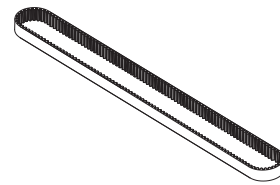
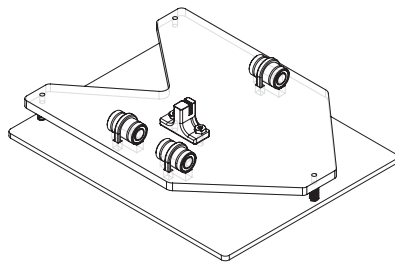
Atenção: Para posteriormente conseguir uma boa calibração, deixa 2mm do parafuso fora



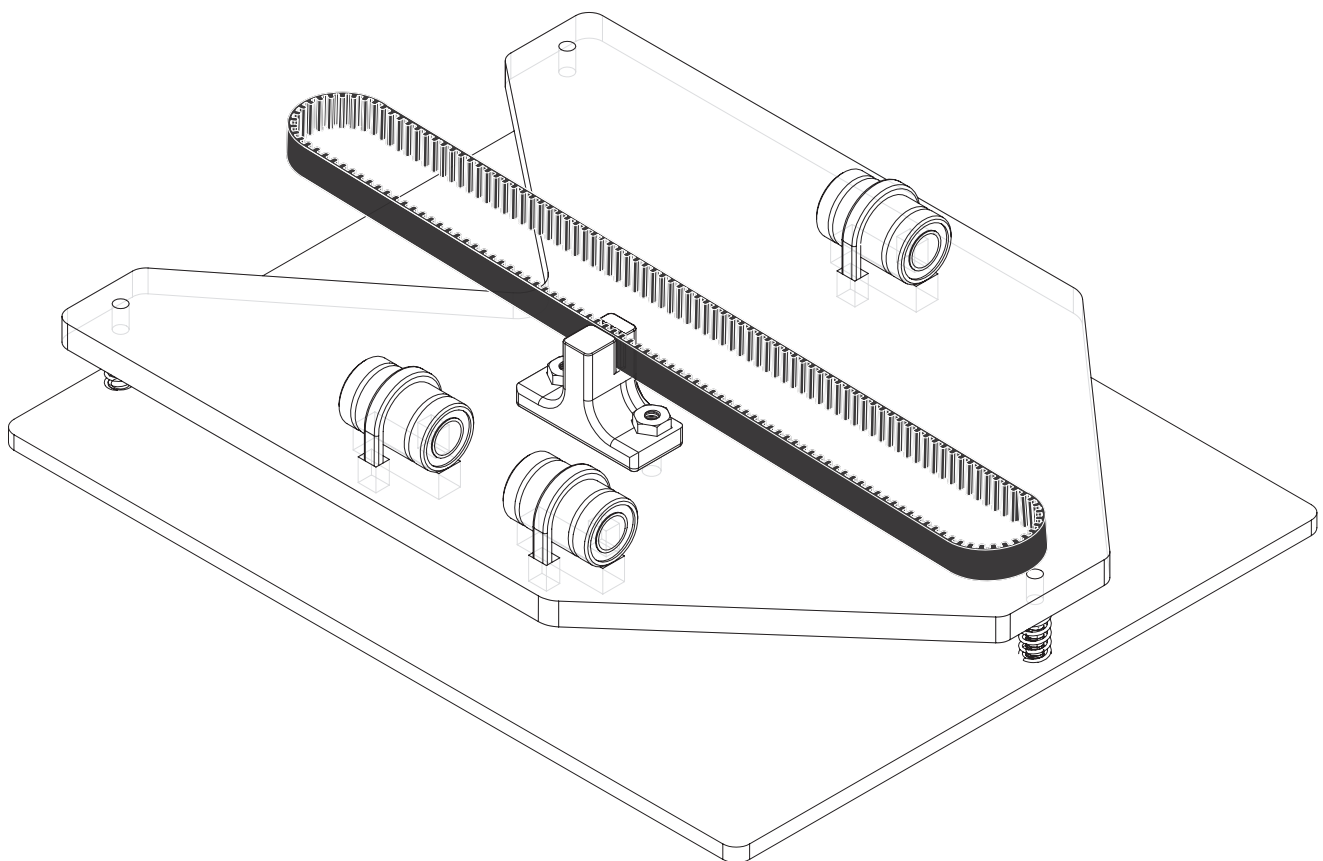




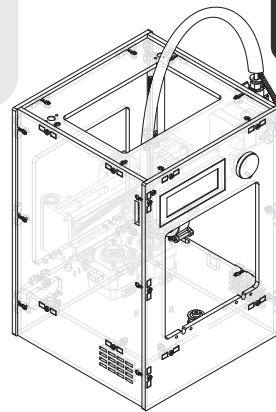
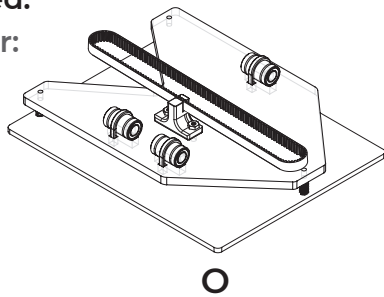
You will need:  
Vais precisar:



Belt  
Correia



You will need:  
Vais precisar:



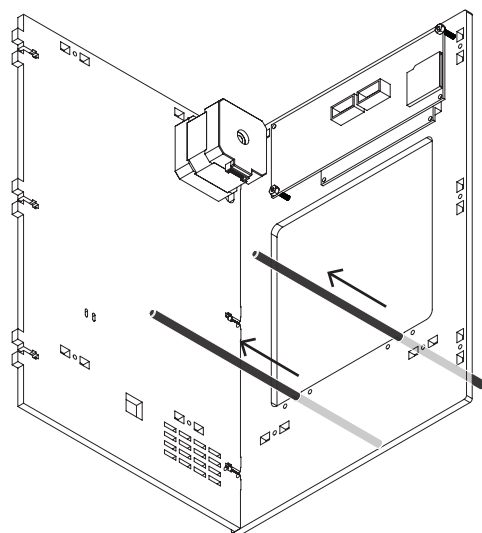
Structure  
Estrutura



2x Medium Rods  
Varões Médios

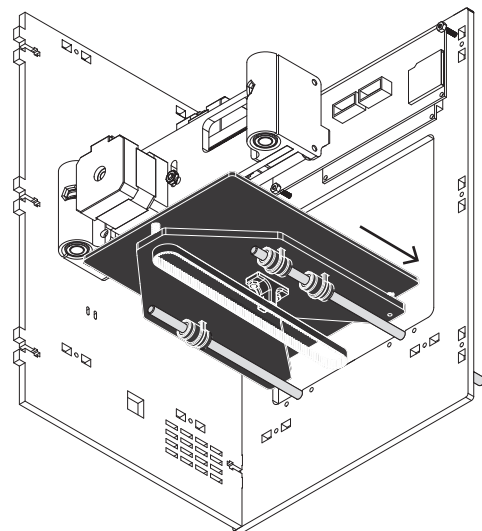
1

Slide the rods through the front rod trails until half way  
Desliza os varões através dos cortes frontais até meio



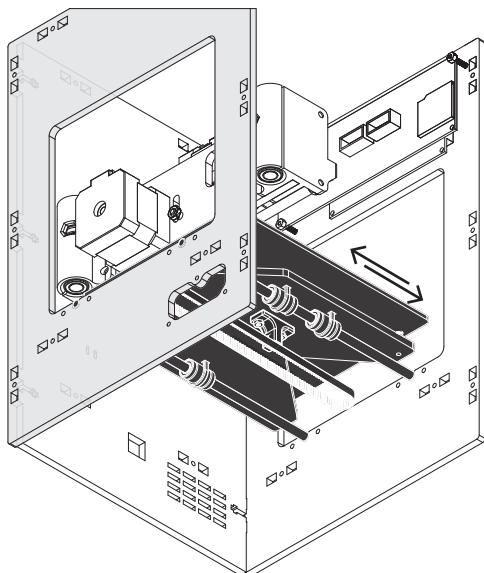
2

Slide the print table through the rods  
Desliza a mesa de impressão através dos varões

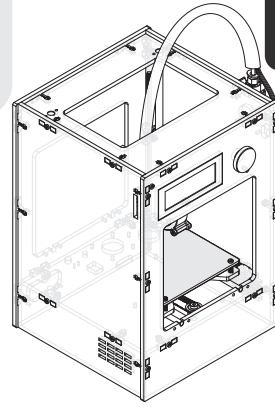


3

Adjust and slide the rods until they fit through the back rail trails  
Ajusta os varões até passarem nos cortes traseiros



Attention: Apply force to the rods, not the print table  
Atenção: Aplicar força nos varões, não na mesa de impressão



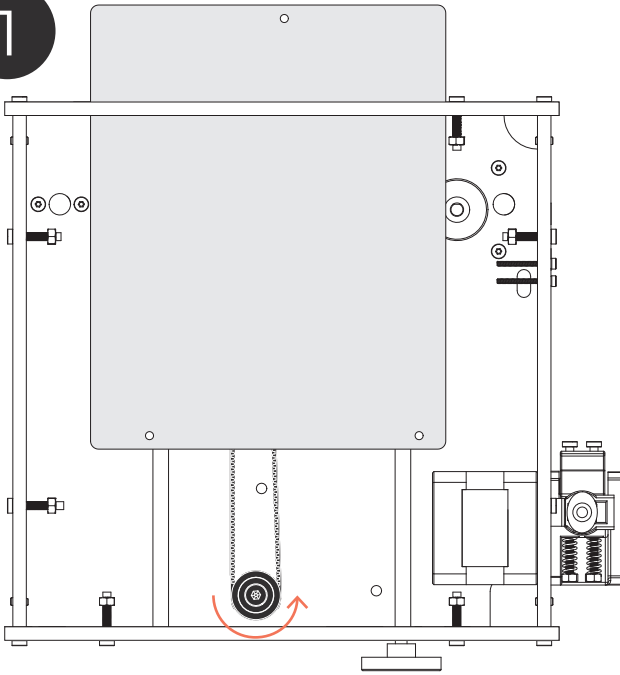
You will need:  
Vais precisar:

**TOOLBOX**

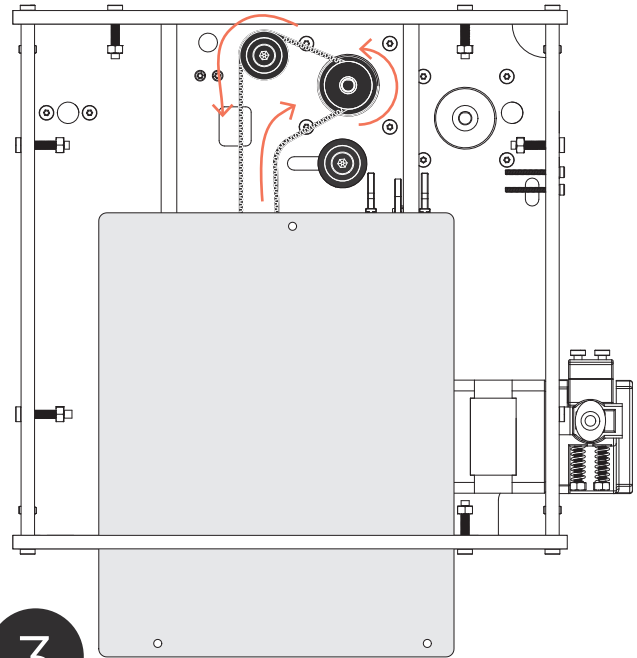


Allen 4

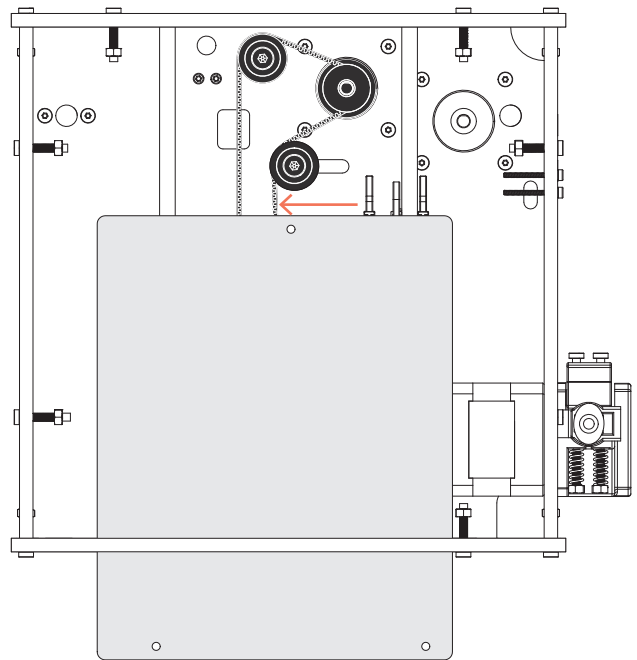
1



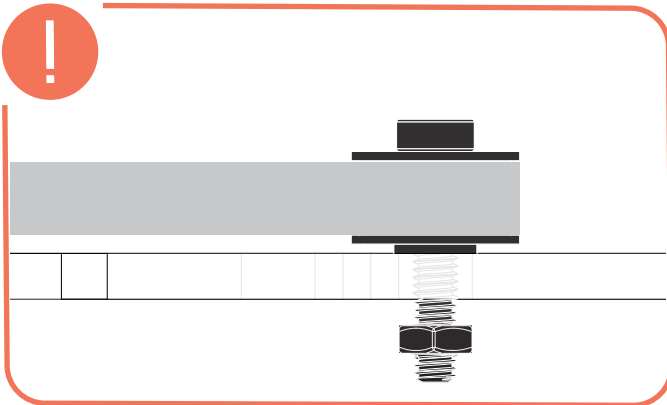
2



3

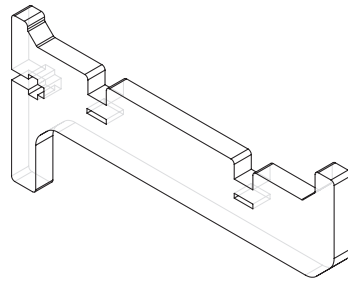
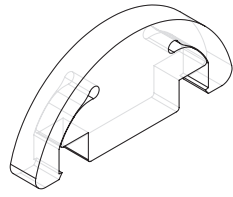


Attention: Tighten up the screw when the belt is tensioned  
Atenção: Aperta o parafuso quando a correia estiver tensionada





You will need:  
Vais precisas:



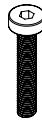
TOOLBOX

2x 0.5

2x 0.6



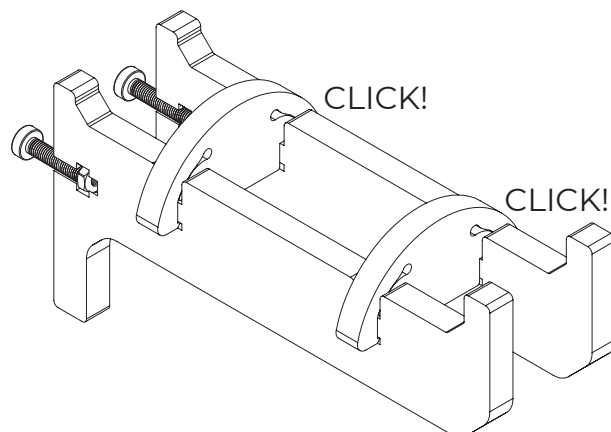
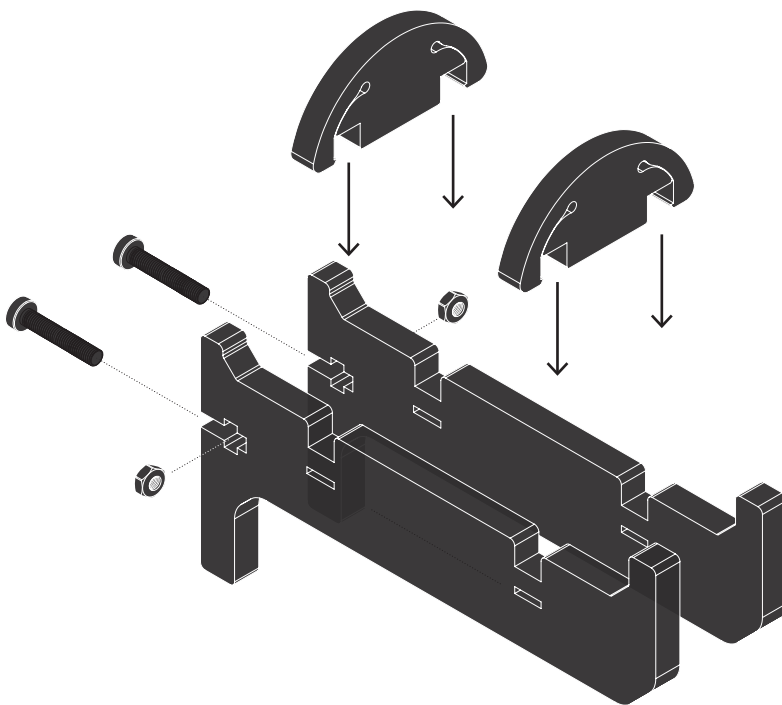
Allen 2

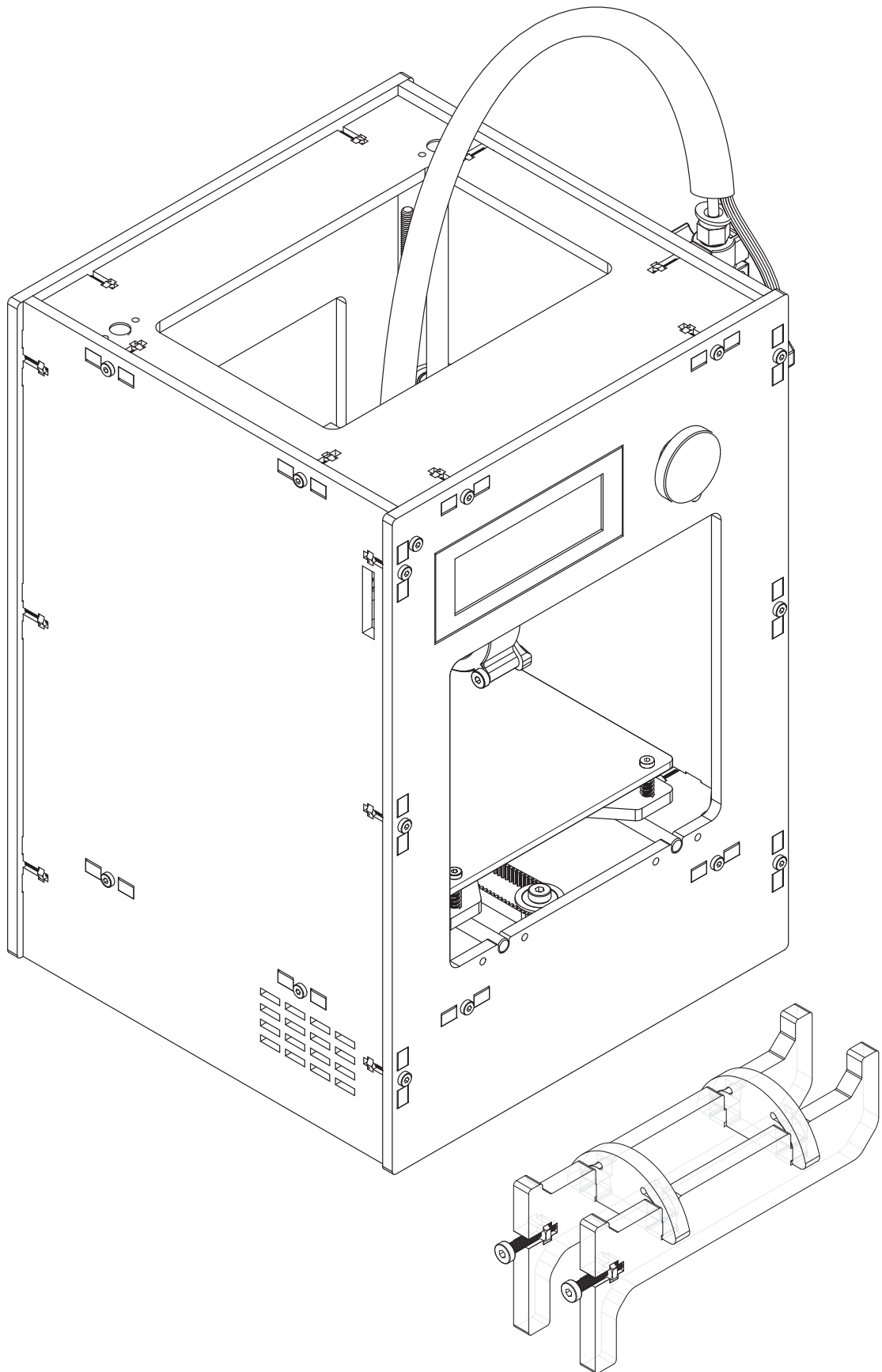


2x M3 16mm



2x M3 Screw Nuts  
Porcas M3





**Phase 4 has been concluded!**  
**A Fase 4 está concluída!**

 40 min.

**PHASE**

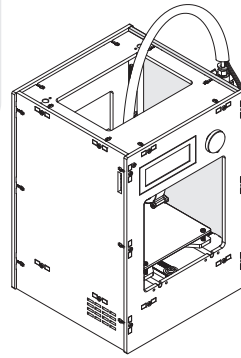
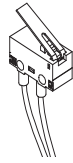
**FASE**

**5**

# CABLES CABLAGEM

PHASE 5  
FASE 5

You will need:  
Vais precisar:



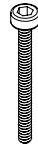
TOOLBOX

P.1-Z

Structure 6 Estrutura 6



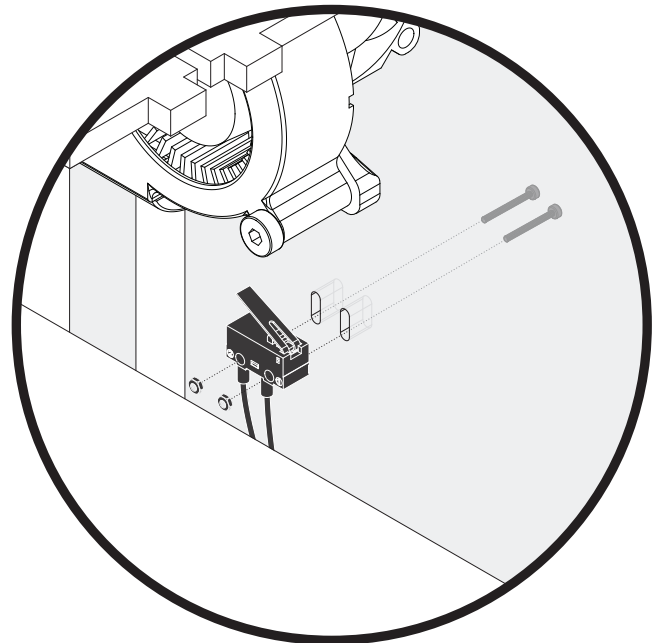
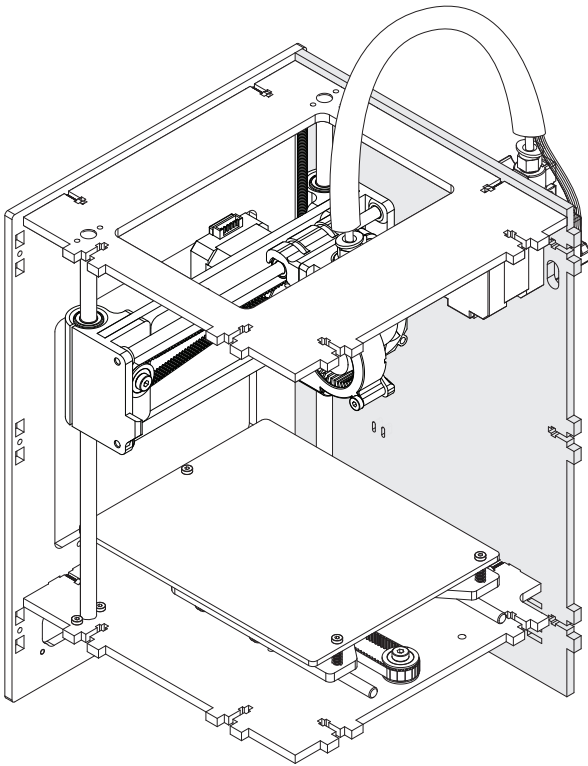
Allen 1



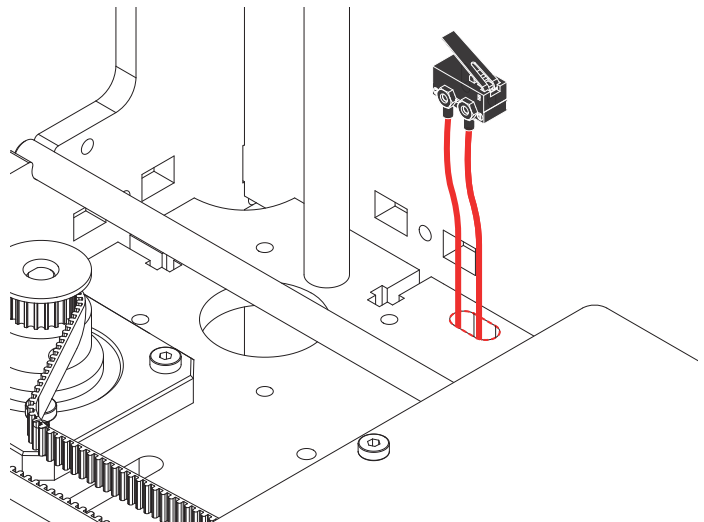
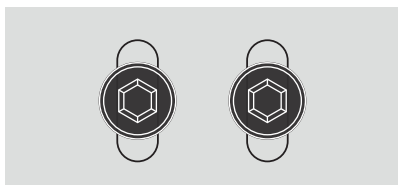
2x M2 12mm



2x M2 Screw Nuts  
Porcas M2



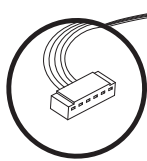
Attention: Align screw centrally  
Atenção: Alinhar centralmente



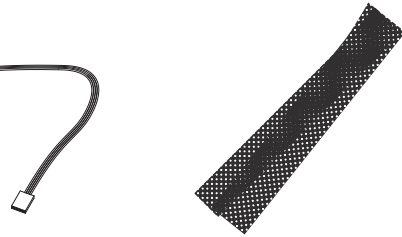
# CABLES CABLAGEM

PHASE 5  
FASE

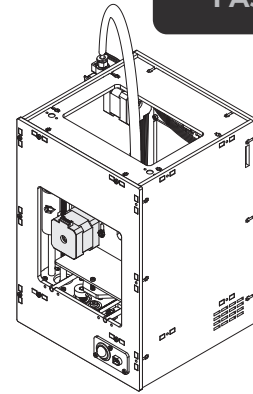
You will need:  
Vais precisar:



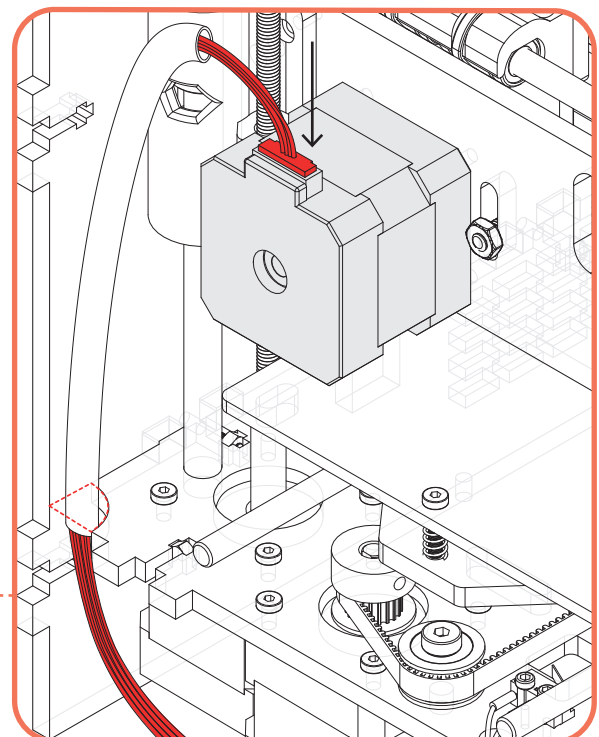
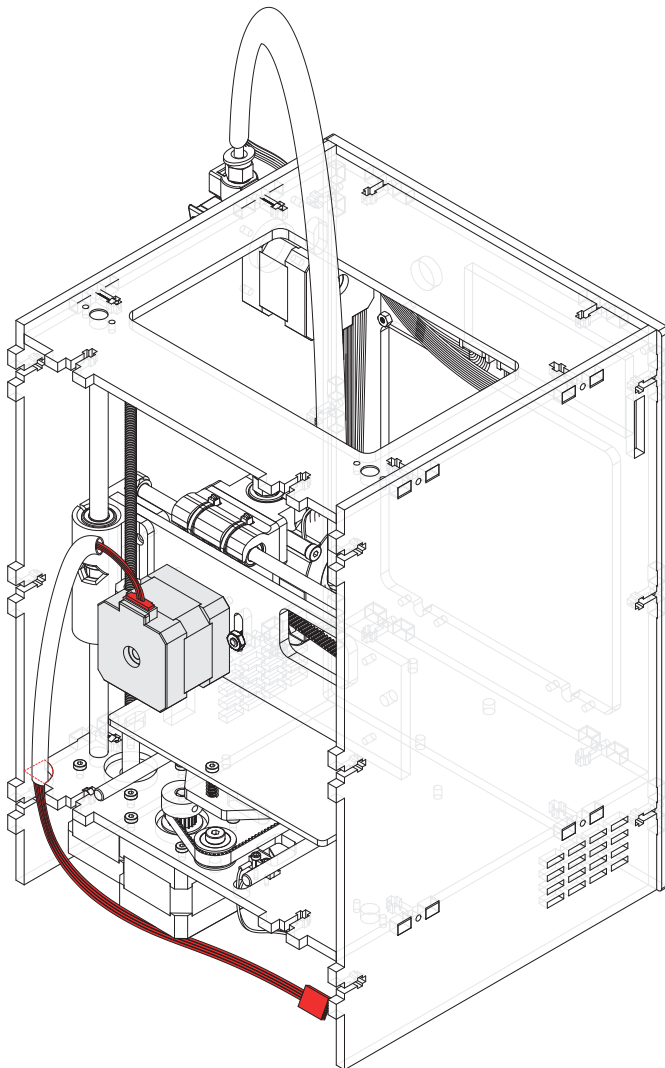
P.2-X



Protective Sleeve Manga



Structure Estrutura

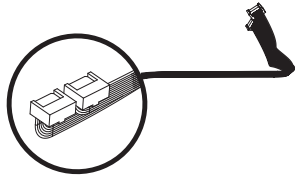




# CABLES CABLAGEM

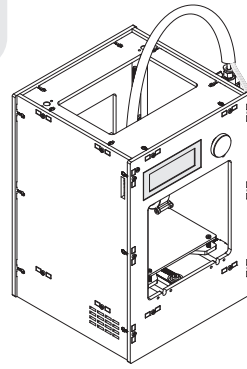
PHASE 5  
FASE 5

You will need:  
Vais precisar:

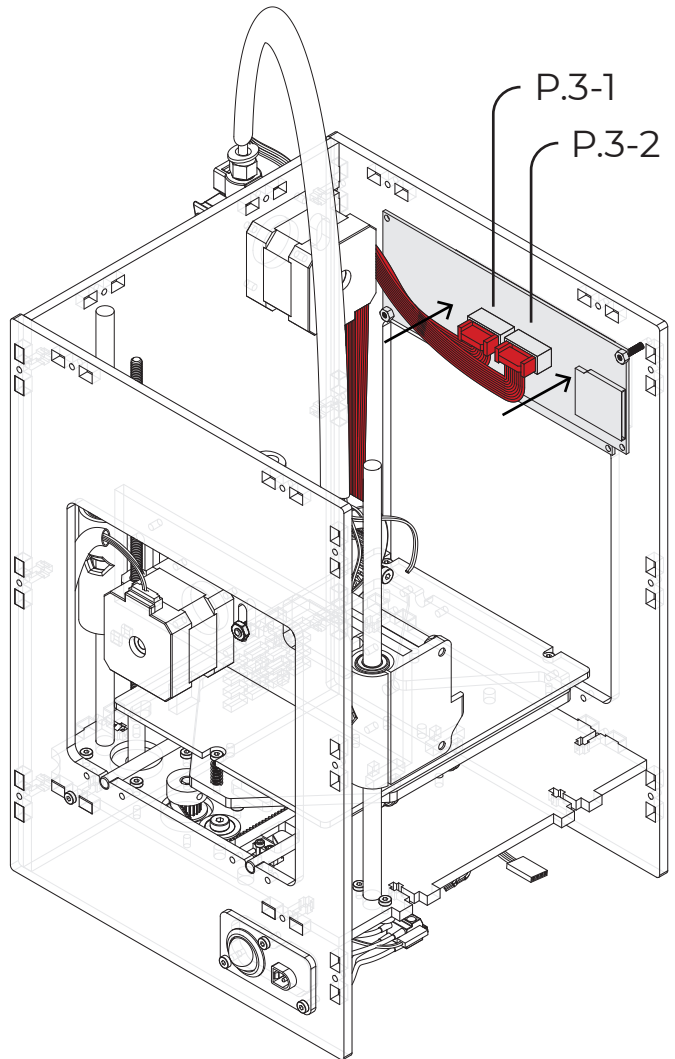
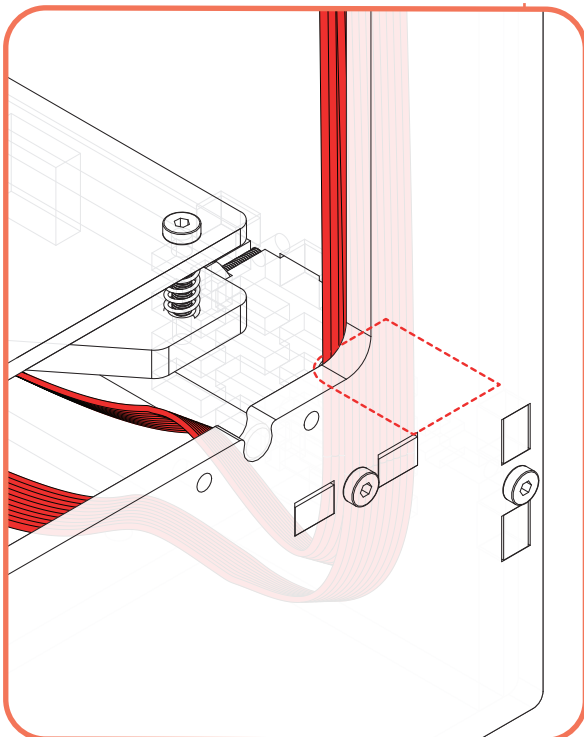
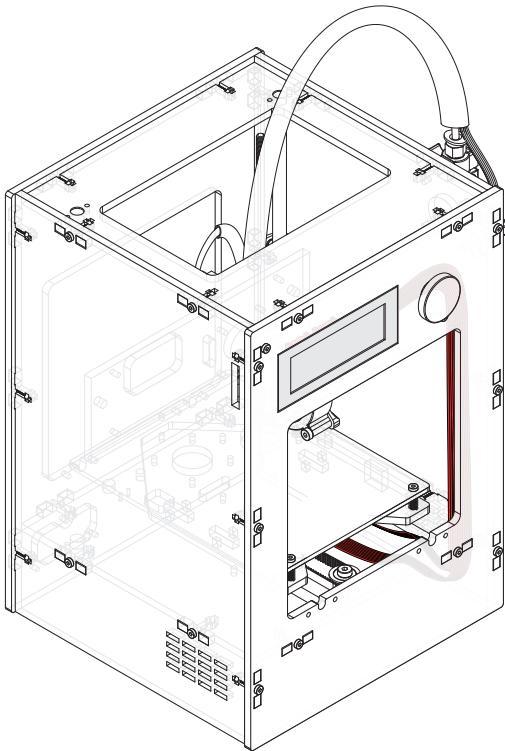


P.3-1

P.3-2



Structure Estrutura



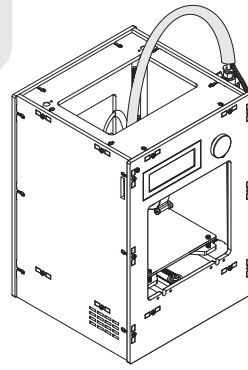
P.3-1

P.3-2

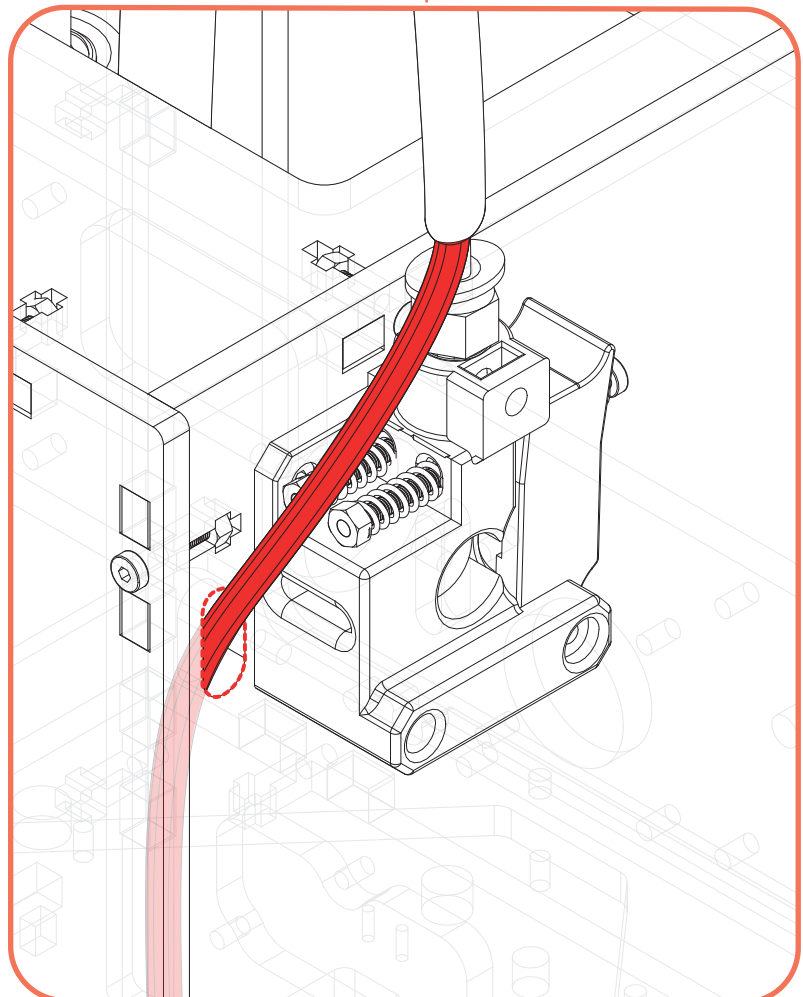
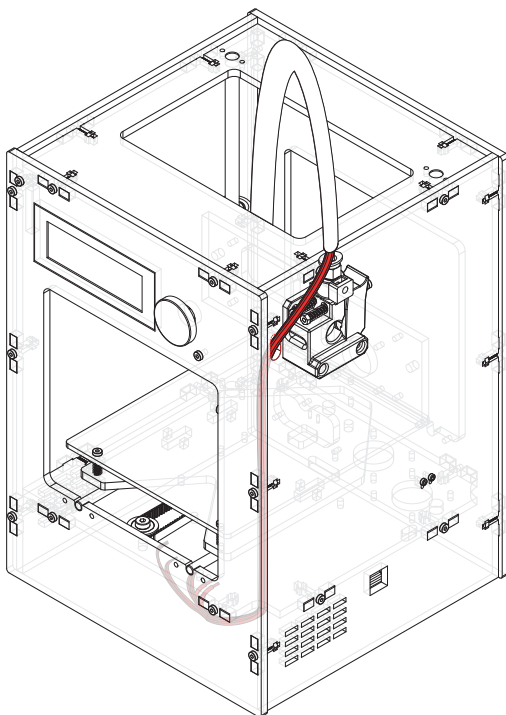
# CABLES CABLAGEM

PHASE 5  
FASE

You will need:  
Vais precisar:



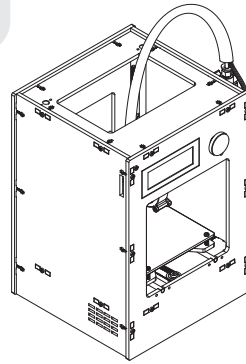
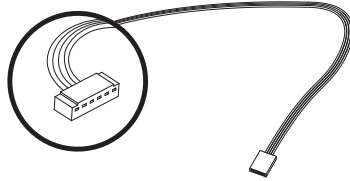
Structure Estrutura



# CABLES CABLAGEM

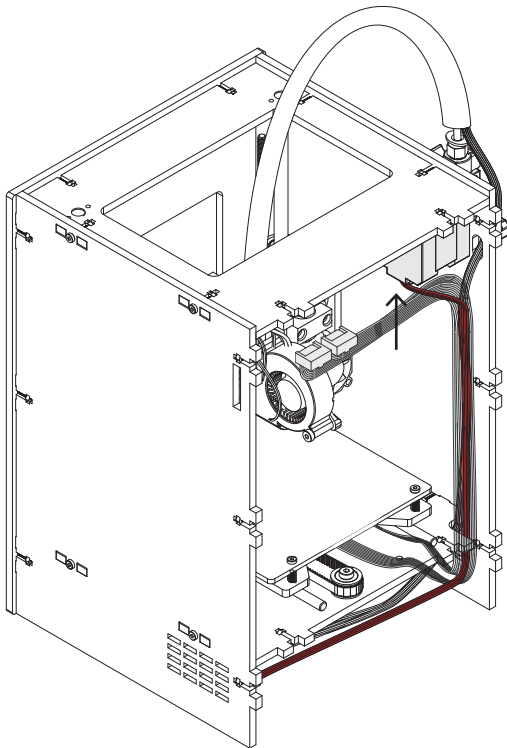
PHASE 5  
FASE

You will need:  
Vais precisar:

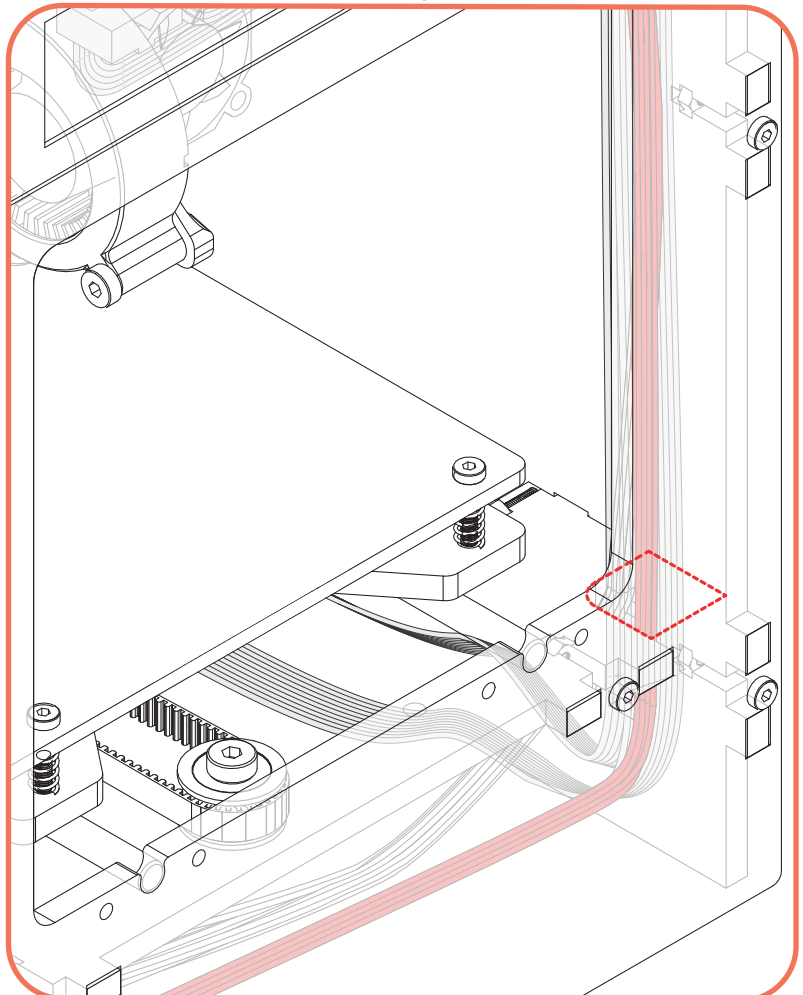


P.4-E0

Structure Estrutura



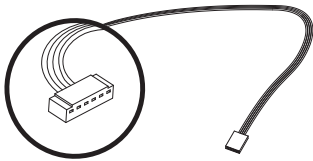
Use plastic fasteners  
to keep the cables organized  
Use abraçadeiras para manter  
os cabos organizados



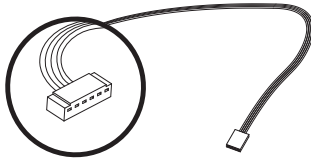
# CABLES CABLAGEM

PHASE  
FASE **5**

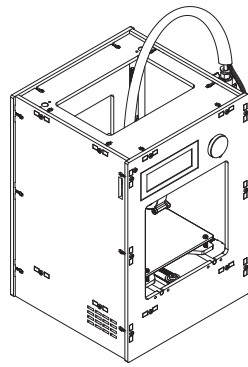
You will need:  
Vais precisar:



P.5-Z

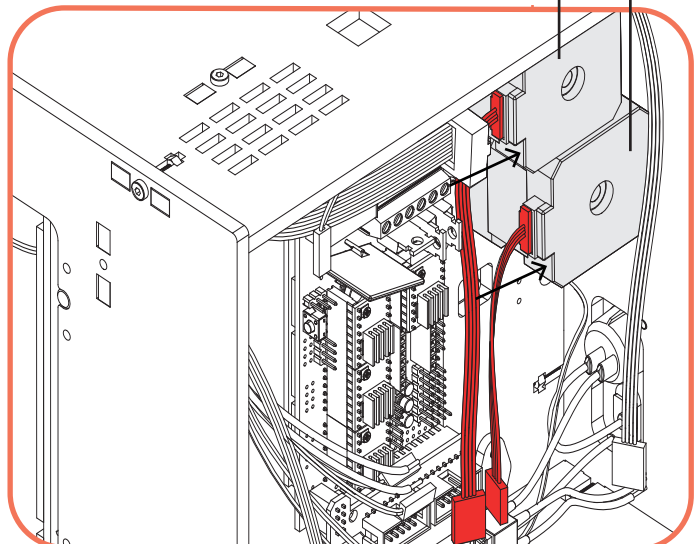
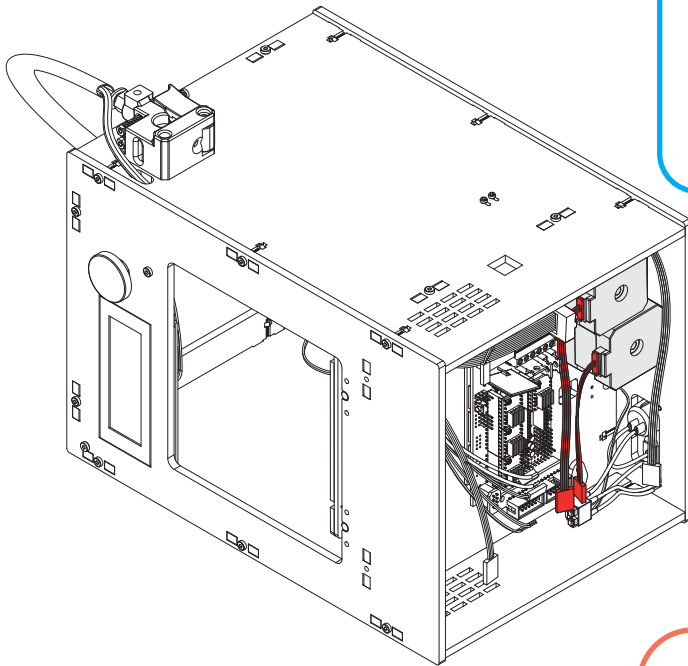
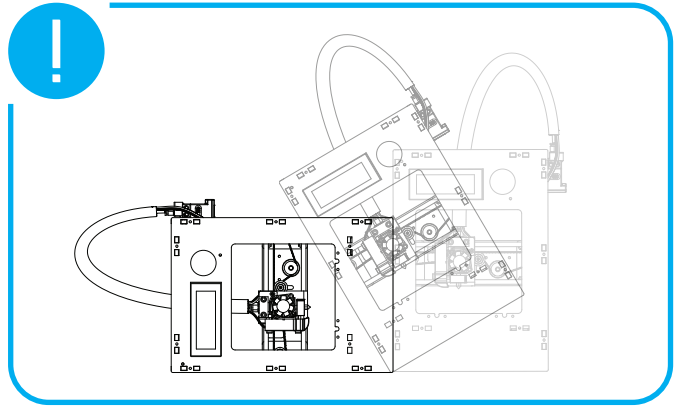


P.6-Y



Structure Estrutura

Tip the machine 90 degrees (sideways)  
Vira a máquina a 90 graus (lateral)



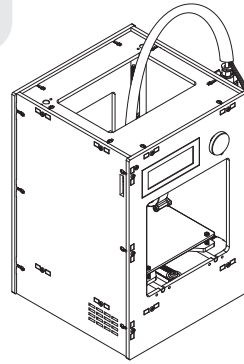
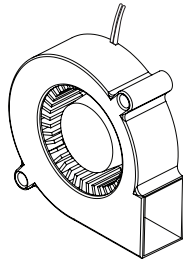
P.5-Z

P.6-Y

# CABLES CABLAGEM

PHASE  
FASE **5**

You will need:  
Vais precisar:



TOOLBOX

P.7

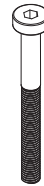
Structure Estrutura



Allen 3



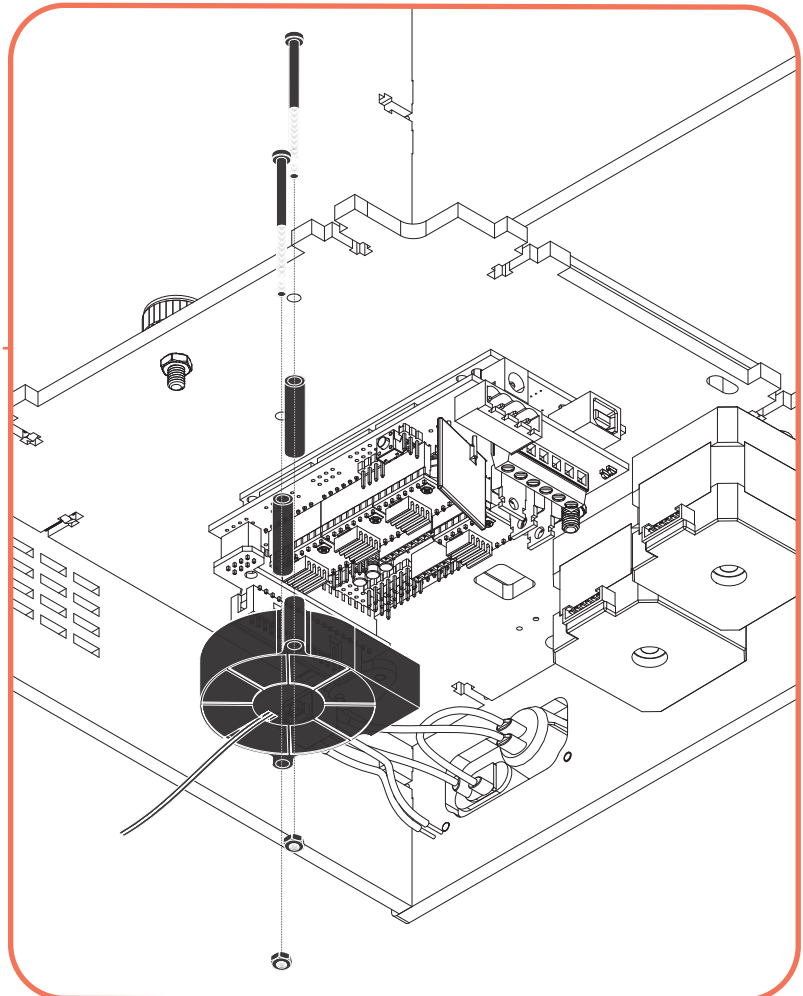
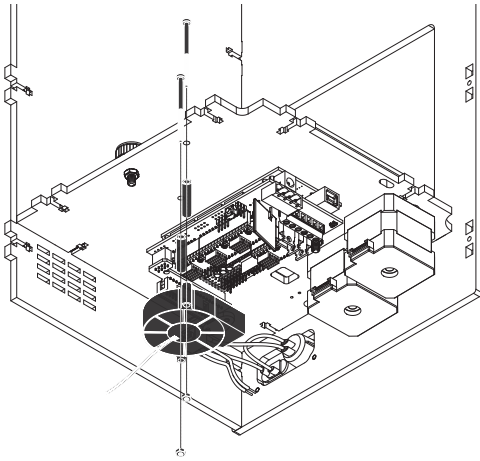
2x Silicone Spacer  
Espaçador Silicone



2x M3 50mm



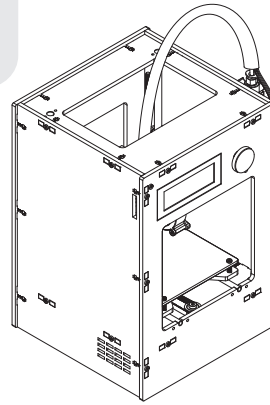
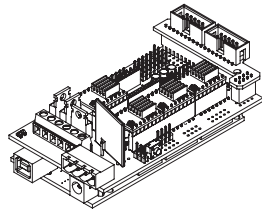
2x M3 Screw Nuts  
Porcas M3



# CABLES CABLAGEM

PHASE  
FASE **5**

You will need:  
Vais precisar:

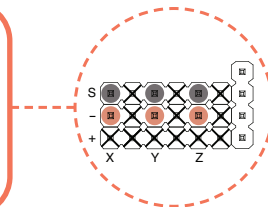


N

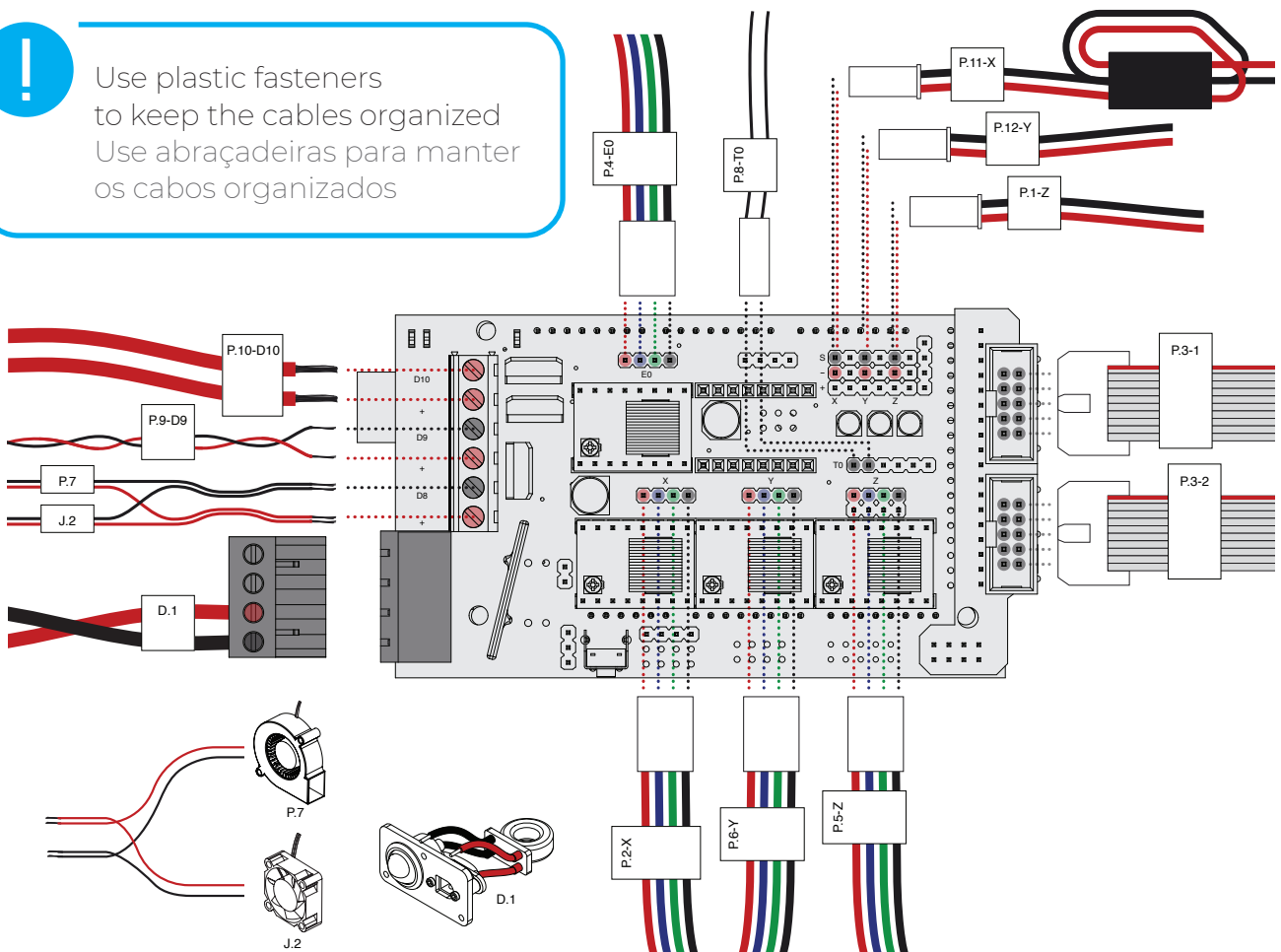
Please check page 66 of the TIPS section, before making the connection of the cables.  
Por favor, consulta a página 66 da secção DICAS, antes de iniciar as ligações da cablagem.



Be careful to properly connect the cables or you may damage the equipment.  
Tem cuidado em ligar corretamente os cabos, ou podes danificar o equipamento.



Use plastic fasteners to keep the cables organized.  
Use abraçadeiras para manter os cabos organizados



 05 min.

**PHASE**

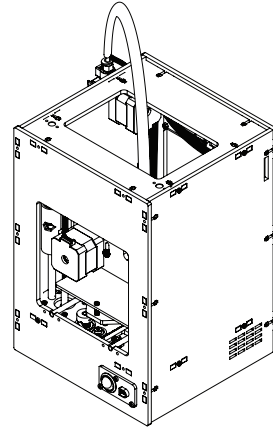
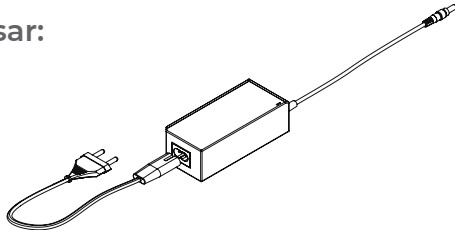
**FASE**

**6**

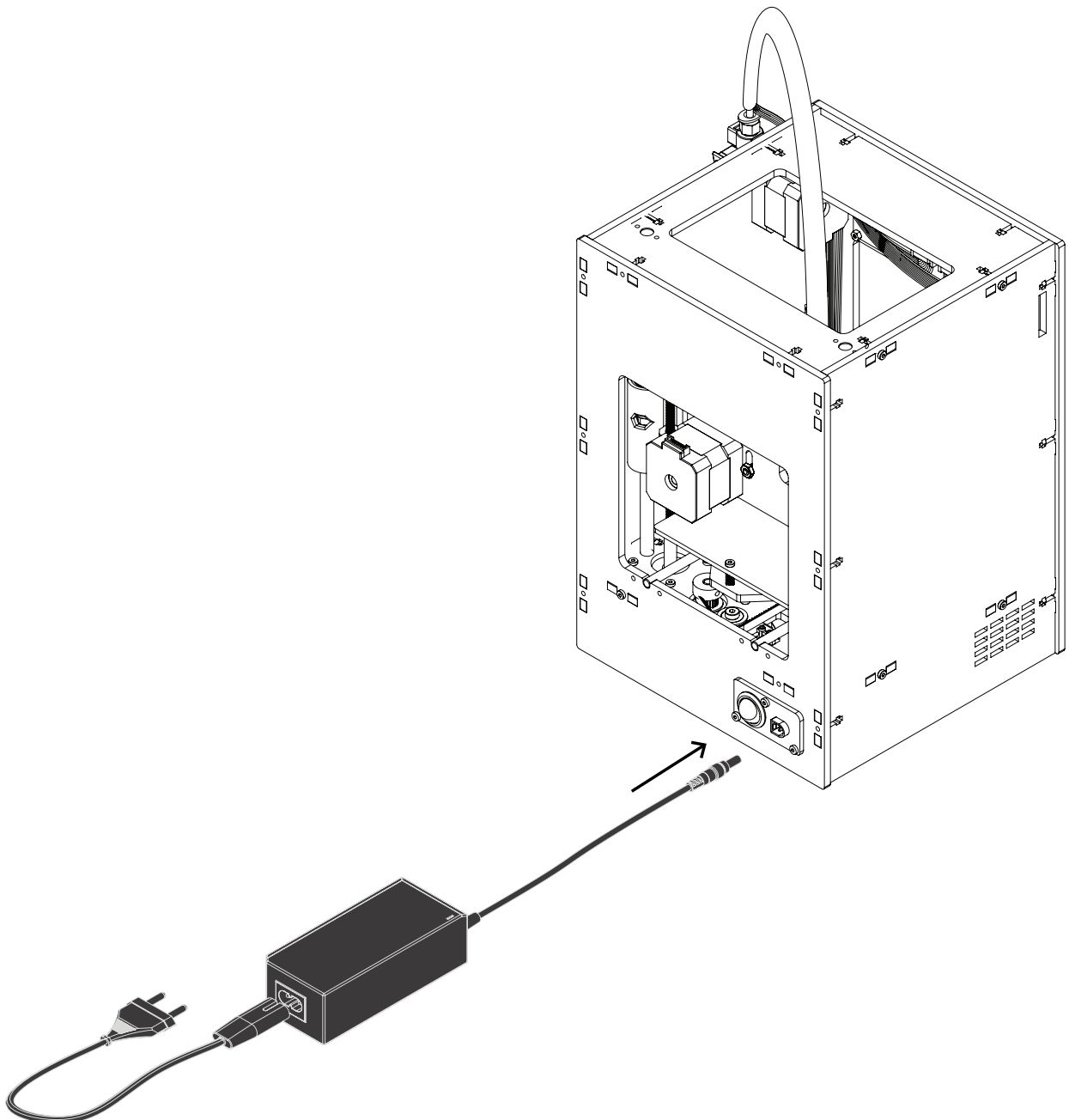


Q

You will need:  
Vais precisar:



Estrutura Estrutura





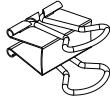
# LAST ASSEMBLY

## ÚLTIMA MONTAGEM

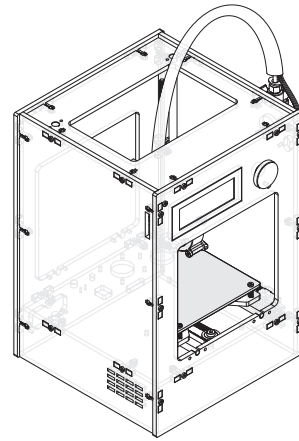
You will need:

Vais precisar:

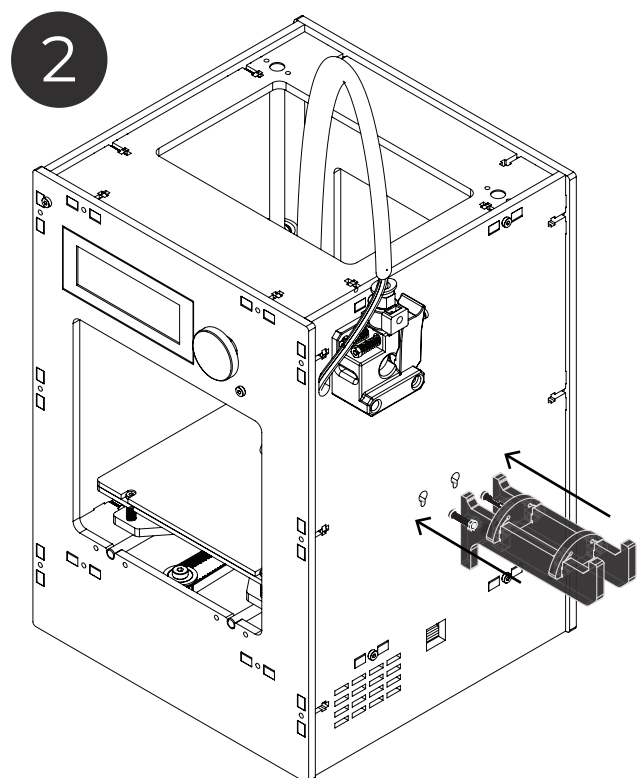
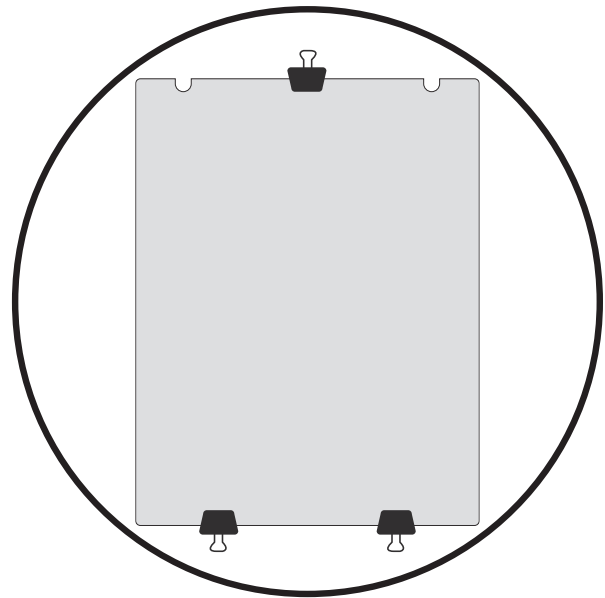
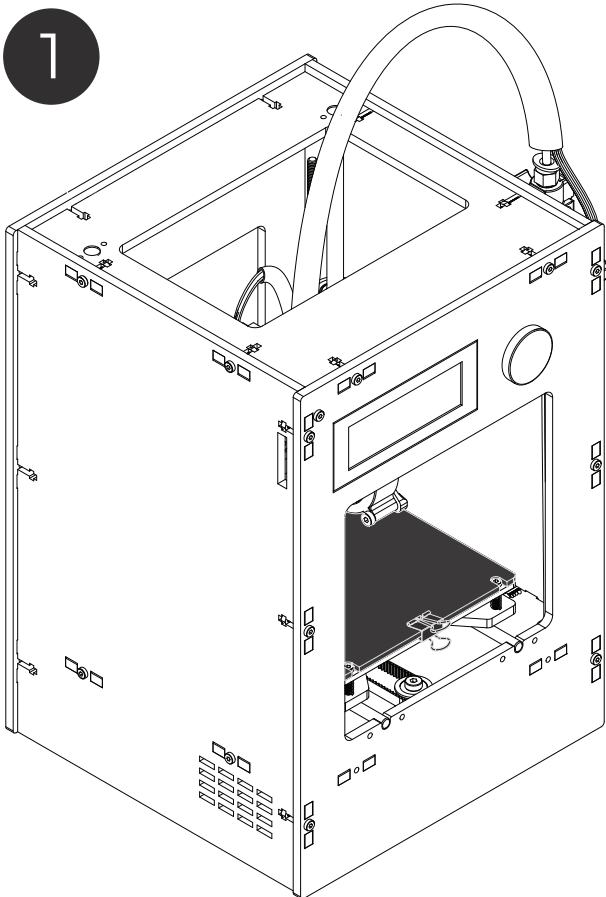
**TOOLBOX**



**3x** Metal Paper Clip  
Grampo



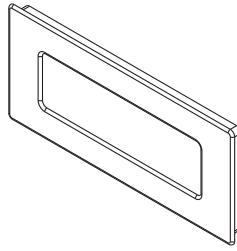
**Estrutura Estrutura**



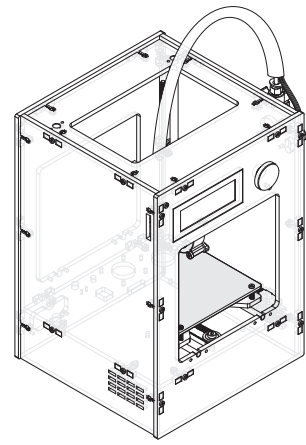
# LAST ASSEMBLY

## ÚLTIMA MONTAGEM

You will need:  
Vais precisar:



LCD Frame  
Tampa Lcd



Estrutura Estrutura

### TOOLBOX



Allen 2



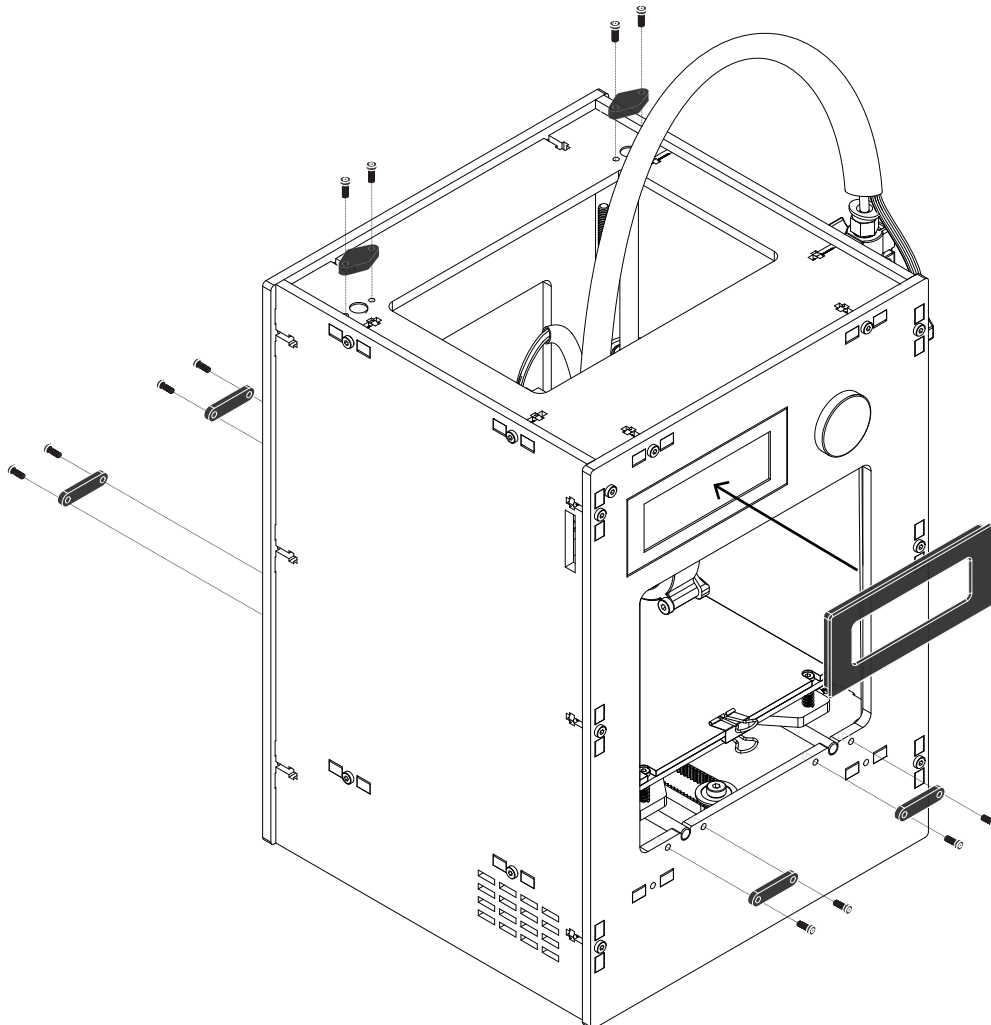
12x M3 8mm



2x Z Rod Covers  
Tampa Varões



4x Y Rod Covers  
Tampa Varões



**TIPS**

**DICAS**

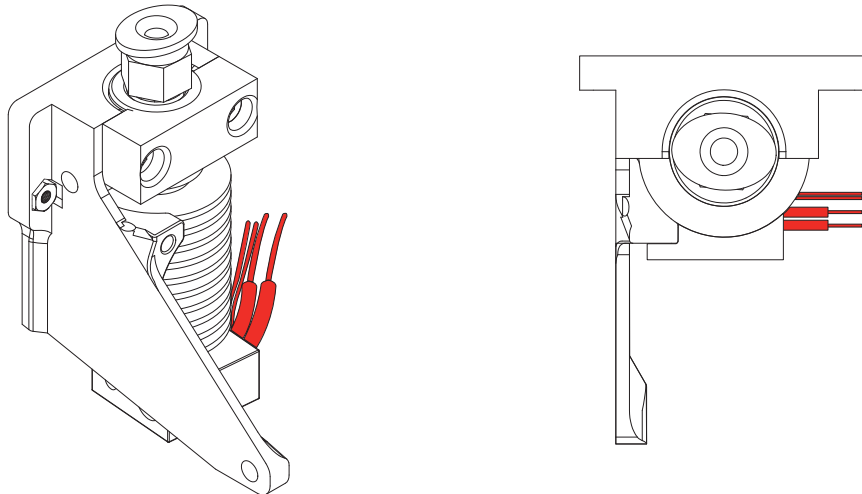
## TIPS DICAS

### Phase 2 - Step I (page 21)

Pay special attention to the orientation of the hot end cables as the image on page 21 shows.

### Fase 2 - Etapa I (página 21)

Presta especial atenção à orientação dos cabos do hot end como mostra a imagem da página 21.



### Phase 2 - Step Last Assembly (page 27)

When inserting the PTFE tube into the hot end this has to enter approximately 5 centimeters.

### Phase 3 - Step M (page 36)

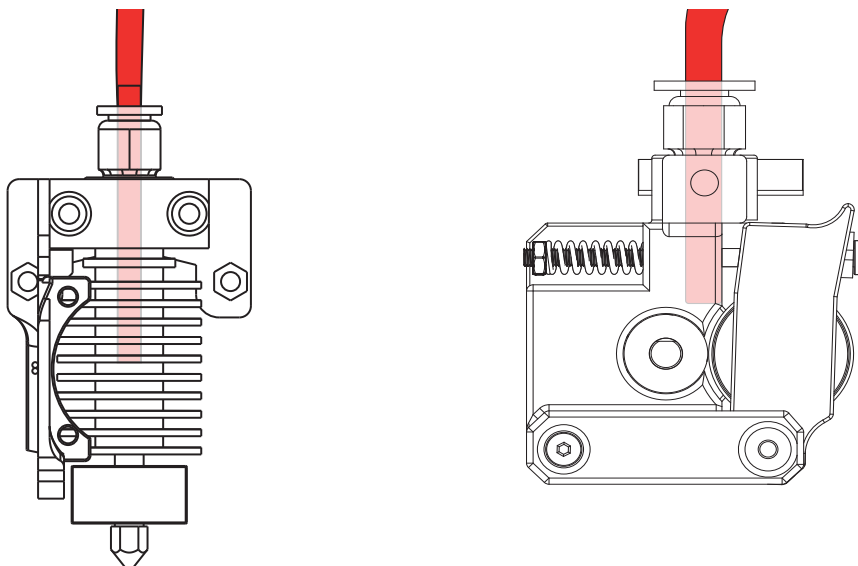
When inserting the PTFE tube into the extruder it has to enter approximately 3 centimeters.

### Fase 2 - Etapa Última montagem (página 27)

Ao inserir o tubo de PTFE no hot end, este terá que entrar aproximadamente 5 centímetros.

### Fase 3 - Etapa M (página 36)

Ao inserir o tubo de PTFE no extrusor, este deve entrar aproximadamente 3 centímetros.



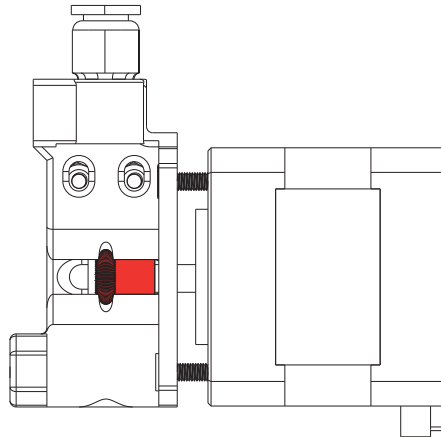
## TIPS DICAS

### Phase 3 - Step K (page 34)

Make sure that the pinion teeth are perfectly aligned with the extruder holes where the filament passes.

### Fase 3 - Etapa K (página 34)

Confirma que os dentes do pinhão estão perfeitamente alinhados com os furos do extrusor onde passa o filamento.

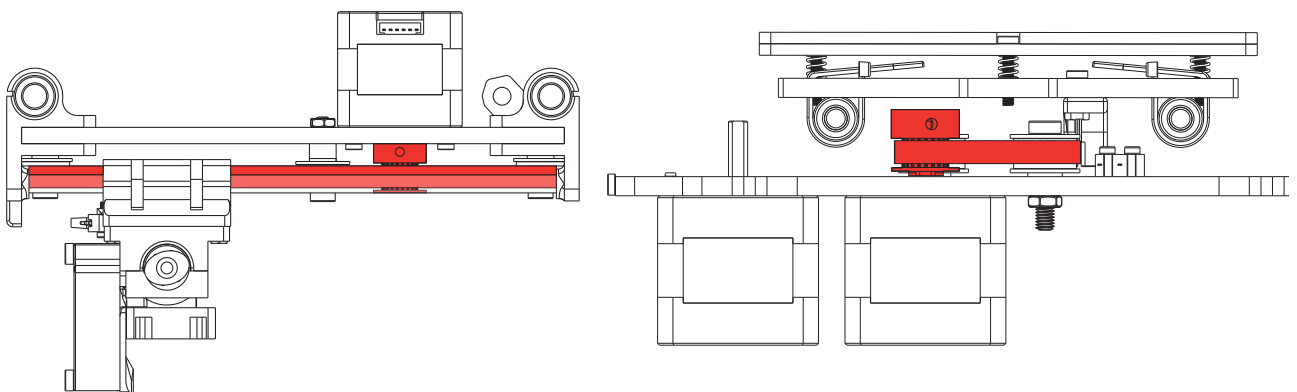


### Phase 2 and 4 - Belt tensioning process (page 26 and page 47)

Make sure that both the X motor pinion and the Y motor pinion is perfectly aligned with the movement of the belt.

### Fase 2 e 4 - Processo de tensionamento da correia (página 26 e página 47)

Confere que tanto o pinhão do motor do X como do motor Y, estão perfeitamente alinhados com o movimento da correia.



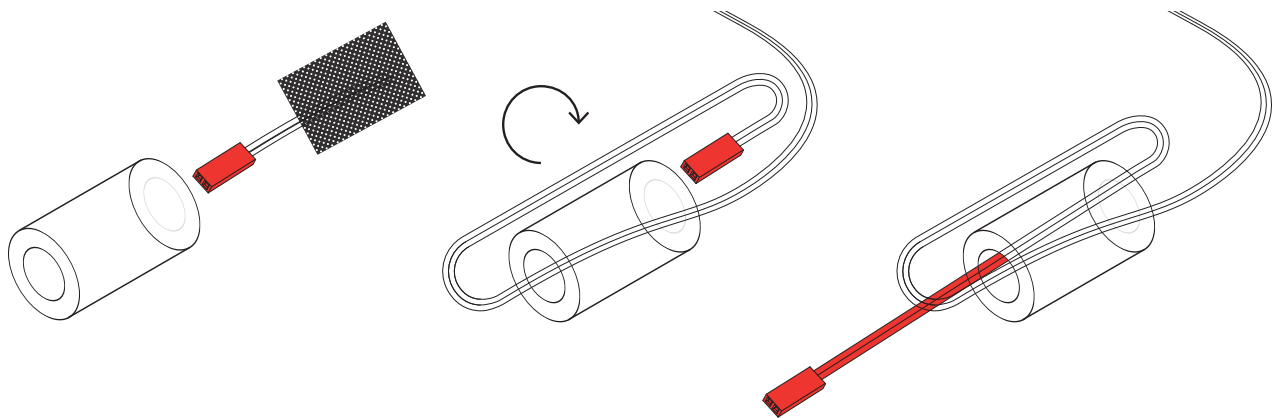
## TIPS DICAS

### Phase 5 - Passing P.11-X cable through ferrite (page 58)

After passing the cable P.11-X through the sleeve, take the ferrite component from the toolbox, and make a loop through it with the cable about 5 cm from the end of the component.

### Fase 5 - Passar o cabo P.11-X através de ferrite (página 58)

Depois de passar o cabo P.11-X pela manga, retira o ferrite da caixa de ferramentas, e faz uma laçada com o cabo através deste, a cerca de 5 cm do fim do componente.



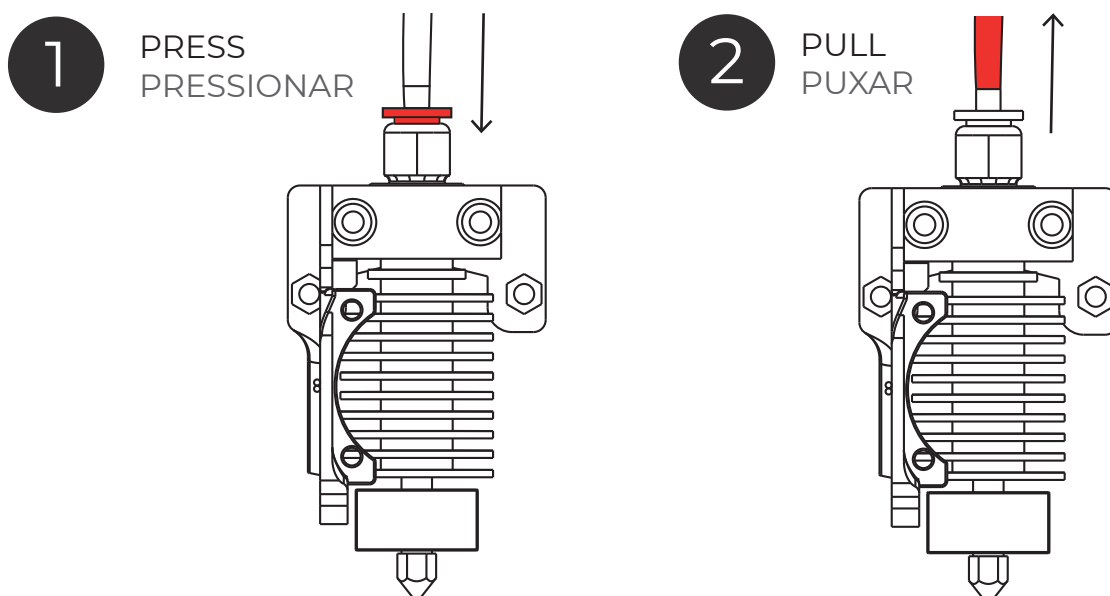
### How to disconnect the PTFE tube

To disengage the PTFE tube from the hotend or the extruder, you have to press the black plastic ring and then pull the tube. Otherwise you will permanently damage the PTFE tube.

### Como desconectar o tubo de PTFE

Para desengatar o tubo de PTFE do hotend ou do extrusor, pressiona o anel de plástico preto e puxa o tubo.

De outra forma o tubo de PTFE, poderá ficar permanentemente danificado.



# BLOCKS

## **Congratulations!**

Now that your printer is assembled, follow the step-by-step instalation guide and your printer will be up and running in no time!

## **Parabéns!**

Agora que a tua máquina está montada, segue o guia de instalação passo a passo e a tua impressora vai estar pronta a imprimir em menos de nada!



