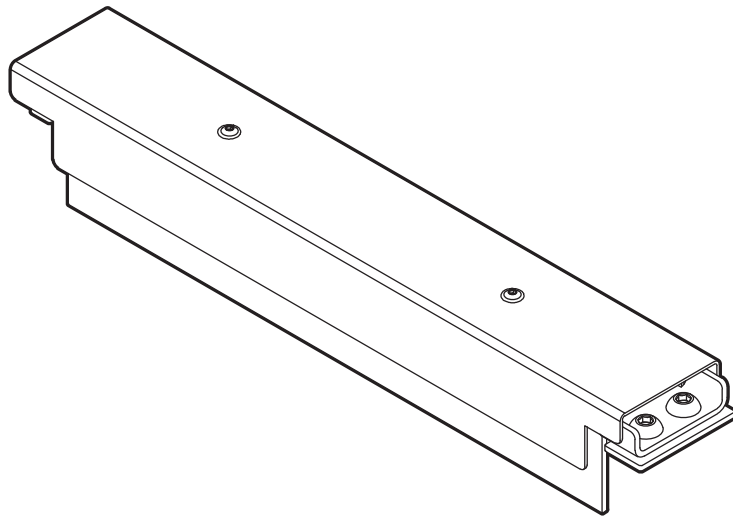




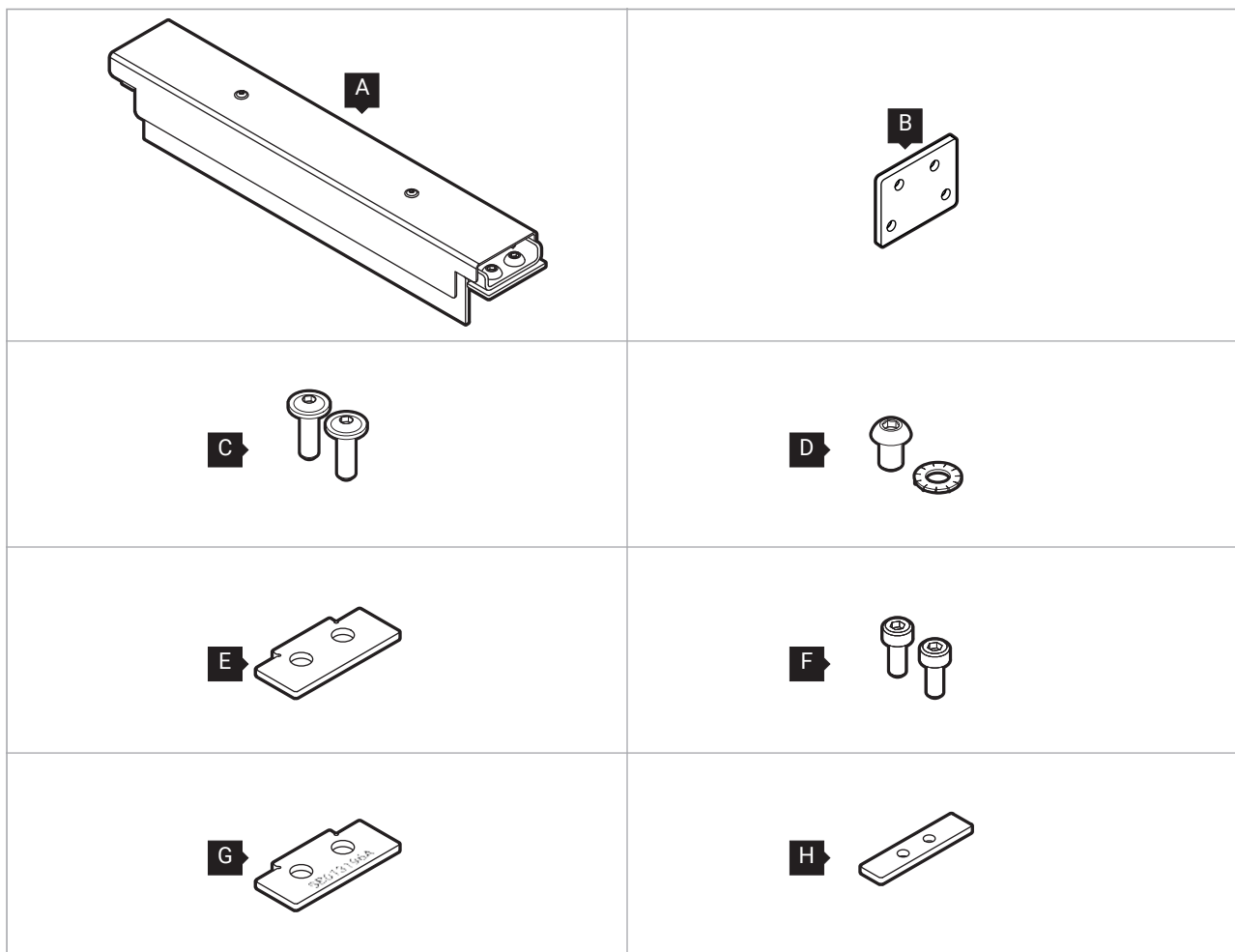
RECOATER BLADE KIT

ASSEMBLY MANUAL





LIST OF ELEMENTS:



* The amount of screws in the kit may be more than the installation assumes. This is a spare.

A	Recoater Blade without cover	1 pc	B	Metal cap	2 pcs
C	M3x8 black screws*	2 pcs	D	M6X10 screws with serrated washer*	2 pcs
E	Linear bearing washer I (SB016251A)	1 pc	F	M3X6 screws with cylindrical head*	10 pcs
G	Linear bearing washer II (SB013196A)	1 pc	H	Levelling slider washer (SB016250A)	1 pc

You will need:

- Allen key 2.0, 2.5, 4.0 mm
- Brush or compressed air
- Box or zip-lock bag for part



1.1 INSTALLING RECOATER BLADE



ATTENTION!

Beware of sharp edges which can cause body cuts and injury.

1. Prepare an appropriately sized box or ziplock bag to store all replaced items.
2. Choose **UNLOCK LID** on the screen.
3. Push on the lid and pull it up using the lid handle. Remember, you only have 10 seconds to open it before the lock activates again.
4. Clean the print chamber if needed.
5. Go to the **MAINTENANCE** and then the **CONTROL PANEL** tab.
6. Use the steering arrows to position the Recoater in between the Beds.
7. Using a 2 mm allen key, unscrew both screws on the Recoater cover (fig. 1).
8. Gently remove the black cover from the Recoater and put it away for later (fig. 2).

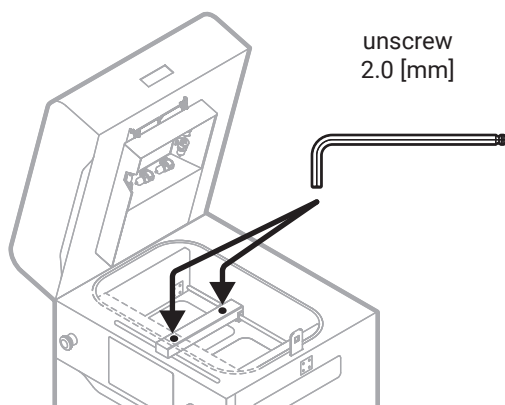


Fig. 1 Set the Recoater and remove the screws from the Recoater cover.

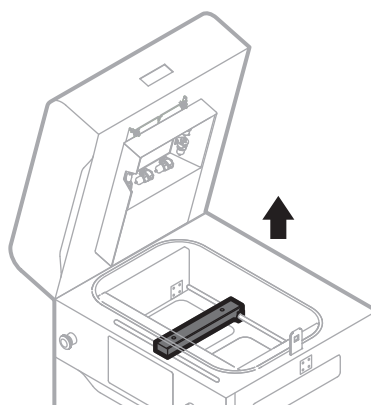


Fig. 2 Remove the black Recoater cover.

9. Using a 2 mm (Recoater cord) or a 2.5 mm (Recoater strip) allen key, unscrew the screws on the Recoater cord mounting plate on the left and right sides (fig. 3).
10. Fit metal caps in the side holes. Use eight M3x6 screws (four per side) and allen key 2.5 mm.
TIP: If you do not have enough space, move the Recoater using the steering arrows on the control panel (**MAINTENANCE/CONTROL PANEL**).

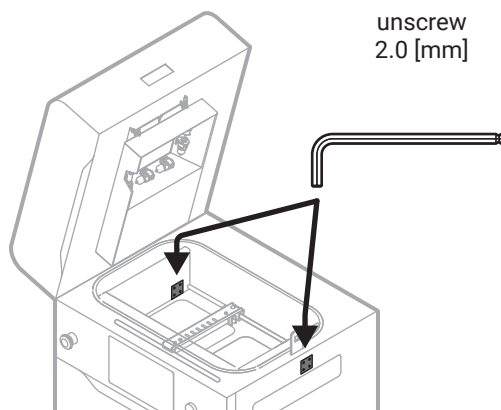


Fig. 3 Unscrew the screw of the Recoater cord plate.



11. Using a 4 mm allen key unscrew the two screws holding the Recoater to the bearing (fig. 4).
12. Take out the Recoater with the cord (and optionally metal spacer if it is).
13. Stow everything in the box/ziplock bag along with the screws.

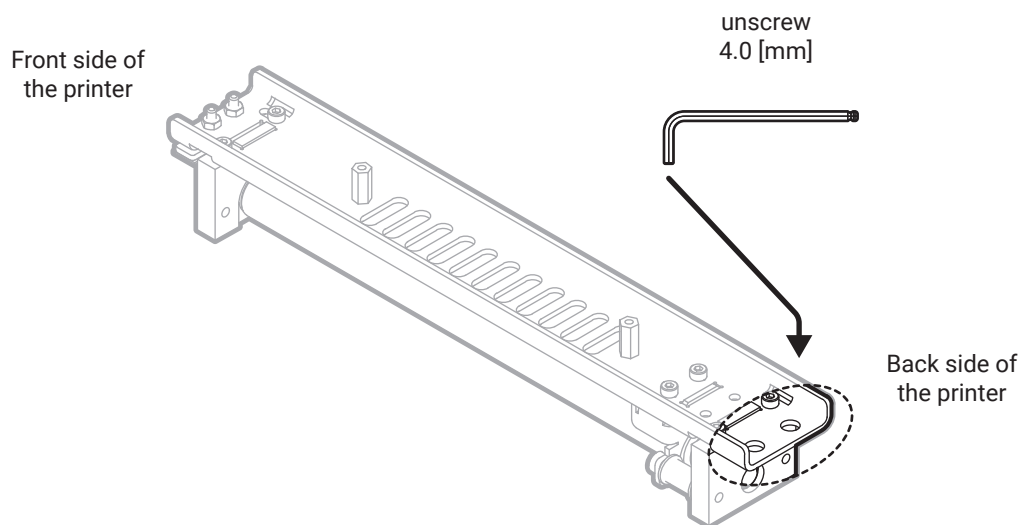


Fig. 4 Unscrew and remove the Recoater with roller and cord.

14. Place the Linear bearing washer I (without the number stamped) on the bearing.
15. Remove from the box: the Recoater blade and two M6x10 screws with the serrated washers.
16. Position the Recoater blade correctly on the bearing and screw it together using a 4 mm allen key (fig. 5).

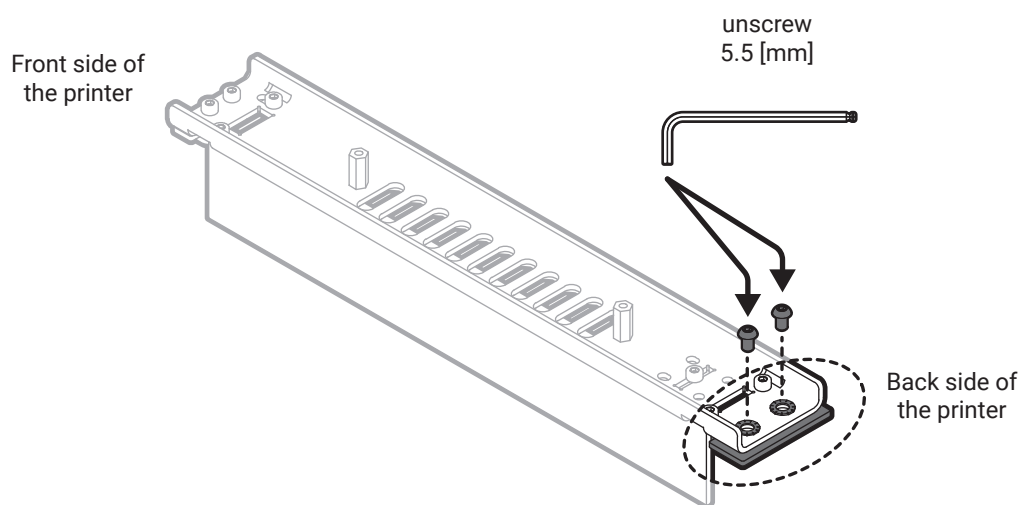


Fig. 5 Screw the Recoater blade with the Linear bearing washer I onto the bearing.

17. Assess the gap between the Recoater blade and the print chamber. The correct value should be between 0.8 and 1.8 mm (fig. 6).

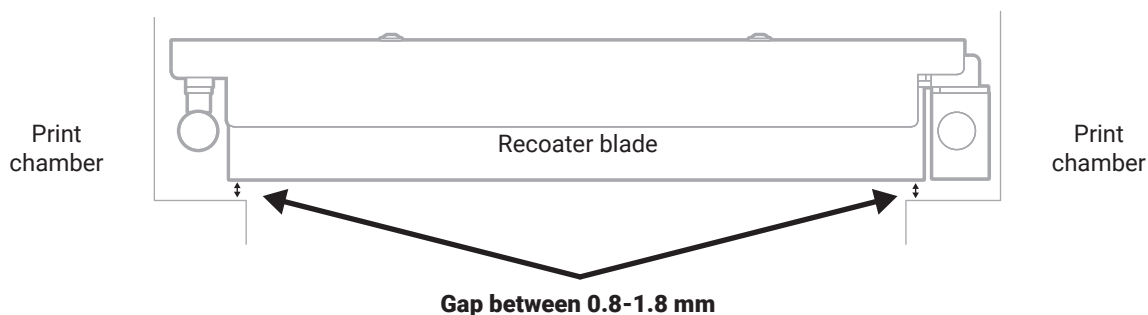


Fig. 6 Correct distance between the Recoater blade and the print chamber.

18. If the gap is insufficient (less than 0.8 mm), use additional washers (Linear bearing washer II and Levelling slider washer).
19. Unscrew the Recoater blade and use washers.
 - a. Levelling slider washer - Using the 2.5 mm allen key unscrew the Levelling slider (left side of the Recoater blade). Replace the metal washer (1mm) with the additional one from the set (2mm) and screw everything together (fig. 7).

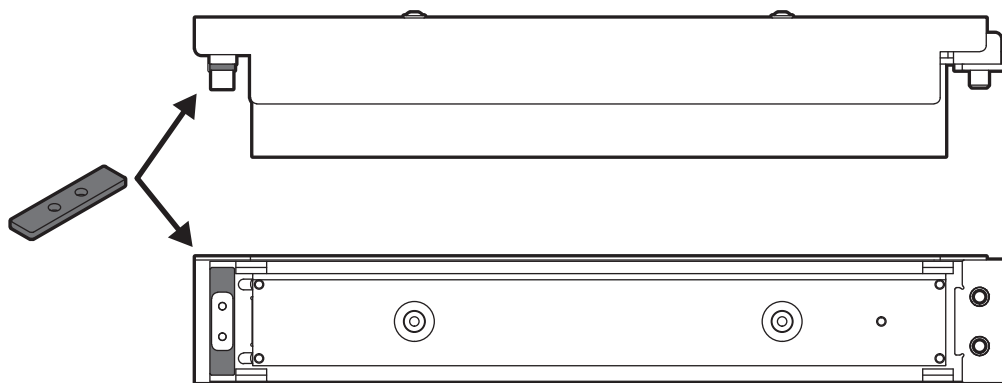


Fig. 7 Place of replacing the metal washers for the levelling slider (front and bottom view of Recoater blade).

- b. Linear bearing washer II - Place an additional washer (with a stamped number) between the Linear bearing washer and the Recoater Blade (right side). Fasten everything with two M6x10 screws with the serrated washers (fig. 8).

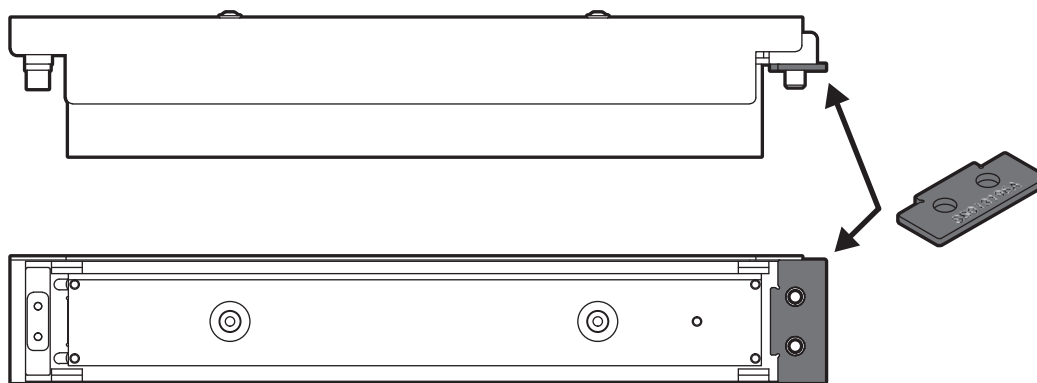


Fig. 8 Linear bearing washer II installation location (front and bottom view of Recoater blade).

20. Using a 2 mm Allen key and two M3x8 screws, fasten the black cover onto the Recoater (fig. 9).

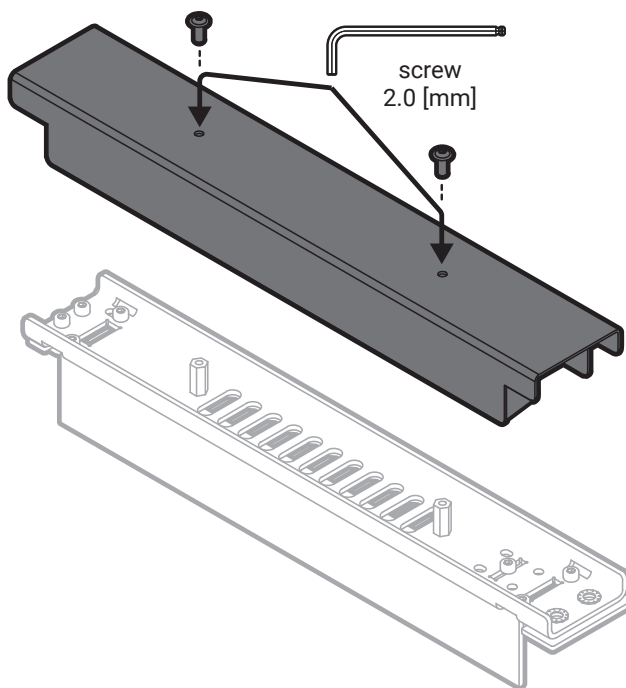


Fig. 9 Installing the Recoater blade black cover.

1.2 SOFTWARE ACTIVATION ON THE PRINTER

1. On the screen under **SETTINGS**, select the **MORE OPTIONS** tab and then **RECOATER SETTINGS** (fig. 10).
2. Press the **CHANGE** button and the next window will appear.
3. Select the **RECOATER DRIVE TYPE** line and press the **CHANGE** button (fig. 10).
4. Select the **RECOATER WITH BLADE** checkbox (fig. 11).
5. Read the message carefully then click on **GOT IT** and **SAVE**.
6. Now you can print using the Recoater blade.

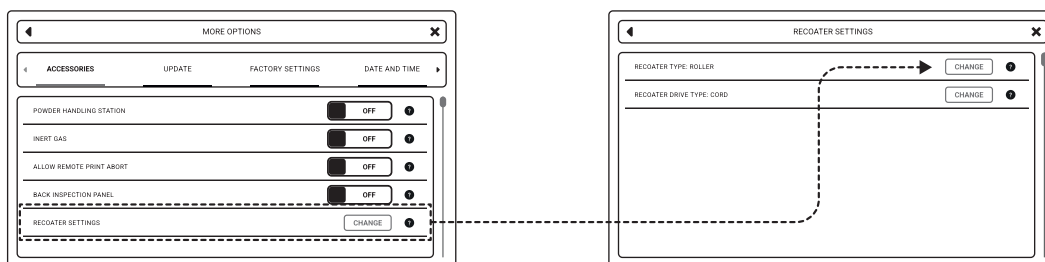


Fig. 10 Recoater blade activation I.

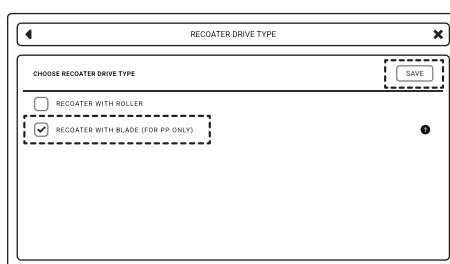
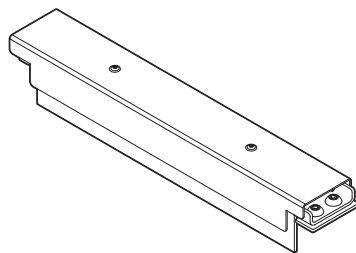


Fig. 11 Recoater blade activation II.



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