

ZGE Short head Assembly



Check both part fit and deblur if needed with a needle file, exacto, etc.

Use a drill bit to clean the filament pathway. For 1.75 use 2mm drill bit, for 2.85 use a 3mm drill bit to clean from print errors.



Insert the bearing and lock it with a screw + washer. (washer optional)



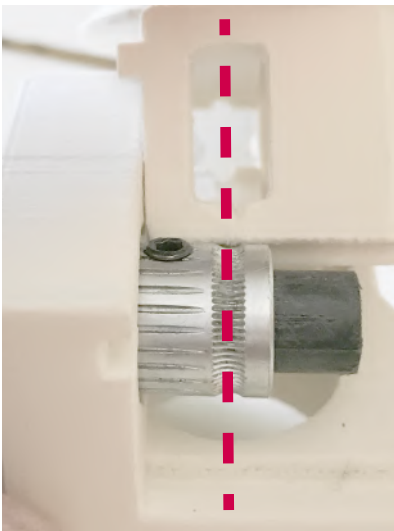
Insert the ZGESlider-Ujoint-System and ensure it goes through the bearing. If can't pass, use an exacto and deblur it. I prefer to do that with a big metal file to make the round area even. An exacto also works, but don't clean too much, just enough so it pass through in/out with a moderate amount of force.



Insert the spacer and the bondtech main drivegear.



Very important step. The screw must go in, but DONT over screw it. More force won't do any good. Just enough so it doesn't hit any wall of the printed part.



Very important step. Double, Triple, Quadruple Check, that the bondtech main drive gear teeth are align on the center, the printed part has a visual mark that shows where the center is. If the washer isn't enough, use two.

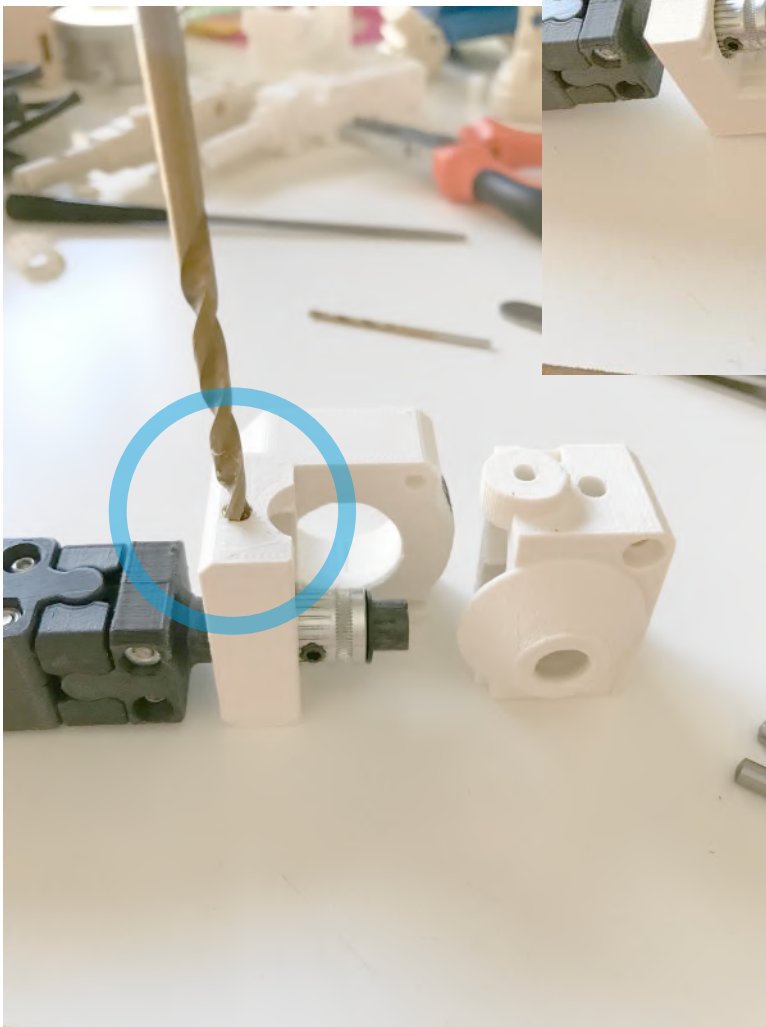
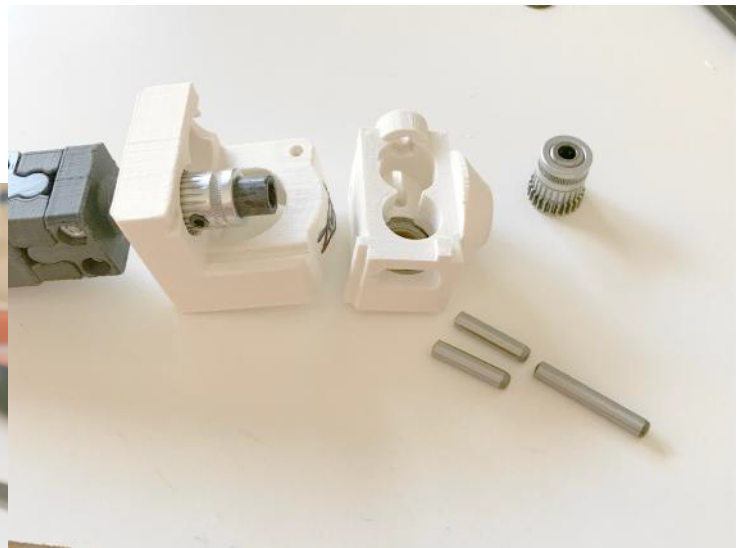
TRICK Print many size washers 0.2-0.3-0.4 It only takes a few minutes and you can use PLA for this without any issue (for the washers). I highly doubt any 2.85 user will need this, but on 1.75mm I had 3 different positions due different bondtech version bough along the time.



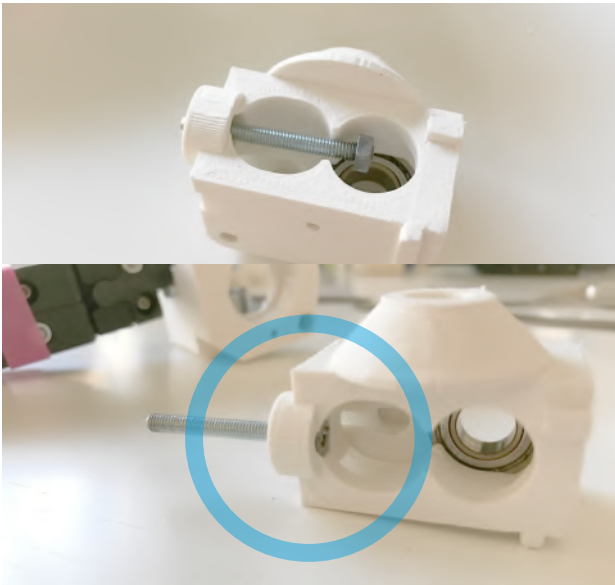
Very important step. Use a 5mm Drill Bit and Clean the path. Check that the drill doesn't go too much further in, just enough to clean the inside that you printed from errors, and also, from the plastic that might have bend a bit near the screw area. If your print has too many errors inside, REMEMBER to do this after you finish, because by then this will have 2 bearings holding all together and will be much easier to drill it.



Insert the other bearing, insert the printed lock and close the loop with a screw-washer.



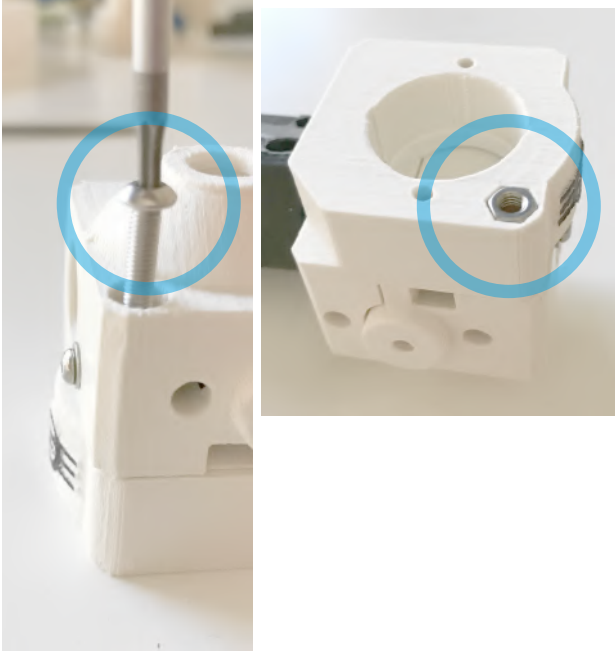
Check the 4mm holes that are on a side, use a 4mm drill bit to clean it gently. Check with your tiny 4mm pins if they pass smoothly. Try to make them pass as smooth as possible, but don't over do it.



Insert the M3 + Nut or the Nut screw, or the version you use. I used a Nut smashed on a head-less screw (Gudo made it for me). And to fix it a did heat a Needle File to heat the plastic around and seal it with the printed part.



Insert the mirror drivegear with the pin and close the Short ZGE



Nut. Screw... Now to the spring...
And Install the Lock with the screw.

