

Tabla de Contenido

How to replace the CoreXY plastic parts	7
Paso 1 - Introduction	8
Paso 2 - Tools necessary for this manual	9
Paso 3 - Additional tools	10
Paso 4 - Manipulación con la impresora	10
Paso 5 - Protecting the heatbed	11
Paso 6 - Printer unplugging	11
Paso 7 - Removing the Wi-Fi antenna	12
Paso 8 - Optional: Cables disconnecting	12
Paso 9 - Opcional: Separando la parte delantera	13
Paso 10 - Opcional: Separando la parte trasera	13
Paso 11 - Optional: Enclosure removing	14
Paso 12 - Belt releasing	15
Paso 13 - CAUTION: Lubricant Handling	16
Paso 14 - X-carriage cover removing	16
Paso 15 - Single-tool Nextruder	17
Paso 16 - Belt clamps removing	18
Paso 17 - Belts removing	19
Paso 18 - X-axis: parts preparation	19
Paso 19 - X-axis securing	20
Paso 20 - Front left releasing	21
Paso 21 - Front right releasing	22
Paso 22 - Rear right releasing	23
Paso 23 - Rear left releasing	24
Paso 24 - CoreXY cover removing	25
Paso 25 - XL buddy box	25
Paso 26 - Antenna cable disconnecting	26
Paso 27 - Back antenna removing	26
Paso 28 - Nextruder disconnecting	27
Paso 29 - Back cover releasing	28
Paso 30 - Optional: Cable cover cap removing	29
Paso 31 - Back cover removing	29
Paso 32 - Back right cables releasing	30

Paso 33 - Back left cables releasing	30
Paso 34 - Optional: Left XY motor & LED cable disconnecting	31
Paso 35 - Optional: Right XY motor & LED cable disconnecting	32
Paso 36 - Left XY motor & LED cable disconnecting	32
Paso 37 - Right XY motor & LED cable disconnecting	33
Paso 38 - Side antenna removing	33
Paso 39 - CoreXY right metal cover remove	34
Paso 40 - CoreXY-back-right disassembly	34
Paso 41 - CoreXY left metal cover remove	35
Paso 42 - CoreXY-back-left disassembly	35
Paso 43 - CoreXY-tensioner removing	36
Paso 44 - CoreXY-tensioner disassembling	37
Paso 45 - CoreXY-tensioner: parts preparing	37
Paso 46 - Single pulley reassembly	38
Paso 47 - CoreXY-tensioner preparing	38
Paso 48 - CoreXY-tensioner securing	39
Paso 49 - Y-carriage-left-top disassembly	40
Paso 50 - Y-carriage-right-top disassembly	41
Paso 51 - Y-carriage base disassembly	42
Paso 52 - Single pulley reassembly: parts preparation	43
Paso 53 - Single pulley reassembly	43
Paso 54 - X-axis: parts preparation	44
Paso 55 - Y-carriage base assembly	45
Paso 56 - Y-carriage-right-base assembly	46
Paso 57 - Y-carriage-left-base assembly	46
Paso 58 - Y-carriage top assembly	47
Paso 59 - CoreXY-back removing	48
Paso 60 - CoreXY-back-left disassembling	49

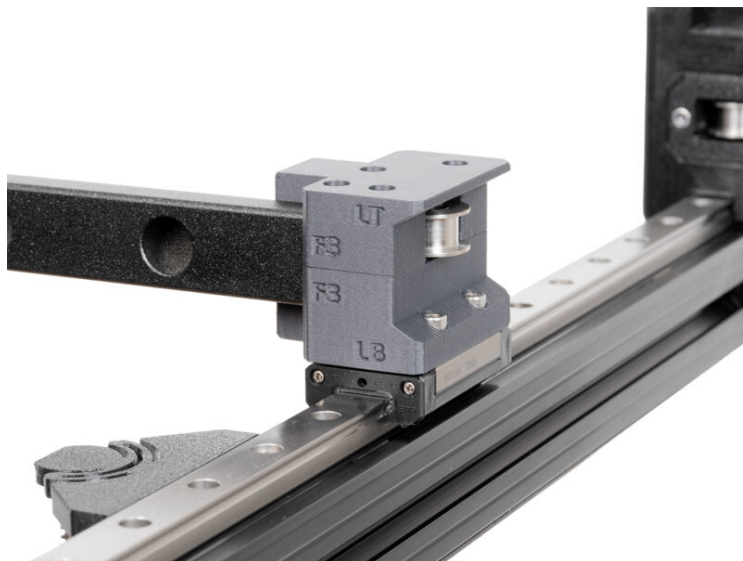
Paso 61 - CoreXY-back-right disassembling	50
Paso 62 - Pulley reassembly: parts preparation	51
Paso 63 - Single pulley reassembly	51
Paso 64 - Double pulley disassembly	52
Paso 65 - Double pulley reassembly	52
Paso 66 - Spacers removing	53
Paso 67 - Back assembly: parts preparation	54
Paso 68 - Back assembly: parts preparation	55
Paso 69 - CoreXY-back-top preparing: part one	56
Paso 70 - CoreXY-back-top preparing: part two	57
Paso 71 - CoreXY-back preparing: part one	58
Paso 72 - CoreXY-back preparing: part two	59
Paso 73 - CoreXY-back-left-top preparing	60
Paso 74 - CoreXY-back-left-top securing	60
Paso 75 - CoreXY-back-right-top preparing	61
Paso 76 - CoreXY-back-right-top securing	61
Paso 77 - CoreXY-back-left securing	62
Paso 78 - CoreXY-back-right securing	63
Paso 79 - XY-motor: parts preparation	63
Paso 80 - Right XY-motor securing	64
Paso 81 - Left XY-motor securing	64
Paso 82 - Tira LED: preparación de las piezas	65
Paso 83 - Left LED strip attaching	66
Paso 84 - Right LED strip attaching	67
Paso 85 - Side antenna preparing	68
Paso 86 - Side antenna securing	68
Paso 87 - CoreXY cover: parts preparation	69
Paso 88 - CoreXY cover left securing	69
Paso 89 - CoreXY cover right securing	70
Paso 90 - Optional: Left XY motor & LED cable	

connecting	70
Paso 91 - Optional: Right XY motor & LED cable connecting	71
Paso 92 - Left XY motor & LED cable connecting	71
Paso 93 - Right XY motor & LED cable connecting	72
Paso 94 - Back cables securing: part preparation	72
Paso 95 - Back left cables securing	73
Paso 96 - Back right cables securing	74
Paso 97 - Cubierta trasera: preparación de las piezas	75
Paso 98 - Back cover attaching	76
Paso 99 - Back cover securing	76
Paso 100 - Antenna cover attaching	77
Paso 101 - Conectando el Nextruder y la Antena	78
Paso 102 - XL buddy box attaching	79
Paso 103 - Single-tool Nextruder	80
Paso 104 - Colocando las correas: información importante	80
Paso 105 - Colocando las correas: preparación de las piezas	81
Paso 106 - Colocando la correa inferior: lado delantero derecho	82
Paso 107 - Lower belt attaching: right rear side	83
Paso 108 - Lower belt attaching: left rear side	83
Paso 109 - Colocando la correa inferior: preparando la correa de la polea del motor	84
Paso 110 - Colocando la correa superior: fijando la correa de la polea del motor	85
Paso 111 - Colocando la correa inferior: lado izquierdo	86
Paso 112 - Colocando la correa inferior: sujeción de la correa	87
Paso 113 - Colocando la correa inferior: fijando la sujeción de la correa	88
Paso 114 - Colocando la correa superior: lado	

delantero izquierdo	89
Paso 115 - Colocando la correa superior: lado	
trasero izquierdo	90
Paso 116 - Colocando la correa superior: lado	
trasero derecho	91
Paso 117 - Colocando la correa inferior: fijando la	
correa de la polea del motor	92
Paso 118 - Colocando la correa superior: lado	
derecho	93
Paso 119 - Colocando la correa superior:	
sujección de la correa	94
Paso 120 - Colocando la correa inferior: fijando la	
sujección de la correa	95
Paso 121 - Belt tensioning	96
Paso 122 - Belt tensioning: video	97
Paso 123 - X-carriage cover: preparación de las	
piezas	97
Paso 124 - X-carriage cover attaching	98
Paso 125 - Cubierta CoreXY: preparación de las	
piezas	98
Paso 126 - CoreXY cover attaching	99
Paso 127 - Opcional: Soportes de fijación:	
preparación de piezas	100
Paso 128 - Opcional: Asegurando la parte trasera	
izquierda	101
Paso 129 - Opcional: Asegurando la parte trasera	
derecha	102
Paso 130 - Asegurando la cubierta CoreXY:	
preparación de las piezas	102
Paso 131 - CoreXY cover securing	103
Paso 132 - Optional: Enclosure preparing	104
Paso 133 - Optional: Enclosure attaching	105
Paso 134 - Opcional: Asegurando el cerramiento:	
preparación de las piezas	106
Paso 135 - Opcional: Asegurando la parte	
delantera	106
Paso 136 - Opcional: Asegurando la parte trasera	
.....	107
Paso 137 - Opcional: Conexión de los cables del	
Cerramiento	108
Paso 138 - Rotando la antena Wi-Fi	109

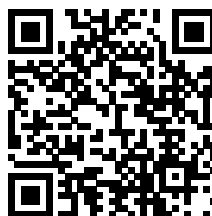
Paso 139 - Printer connecting	109
Paso 140 - Good job	110

How to replace the CoreXY plastic parts

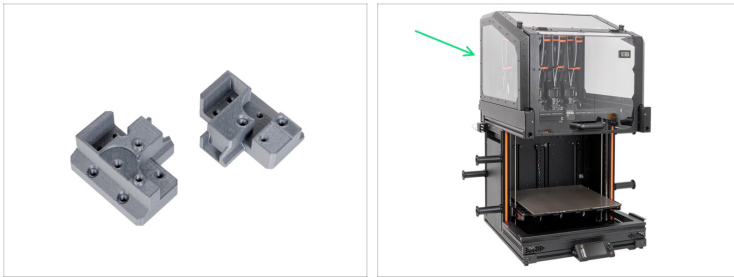


help.prusa3d.com/g265860

Escanea el código
QR para ver la última
versión de este
capítulo.



PASO 1 Introduction



- This guide will take you through the installation of **CoreXY plastic parts** on the **Original Prusa XL**.
- Todas las piezas necesarias están disponibles en nuestra tienda prusa3d.com.
- 📌 Ten en cuenta que debes iniciar sesión para tener acceso a la sección de repuestos.
- Este manual es compatible con el Original Prusa XL Enclosure.
- ⓘ Este manual es compatible con todas las impresoras Original Prusa XL.

PASO 2 Tools necessary for this manual



- **Para el siguiente manual, por favor prepara:**
- Torx T10 screwdriver
- 2.5mm Allen key
- Una caja de cartón para utilizarla como protección de la base calefactable durante la instalación.
Sugerencia: utiliza la caja del Nextruder.
- Llave Allen de 4.0 mm

PASO 3 Additional tools

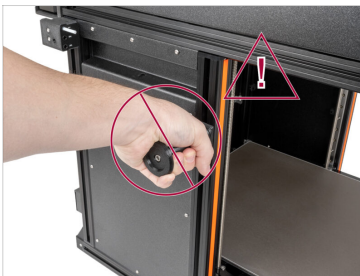


i Herramientas que no están incluidas pero que pueden facilitar el montaje, especialmente al instalar complementos.

Additional tools:

■ Alicates de corte lateral *para cortar bridas y recortes de paneles laterales*

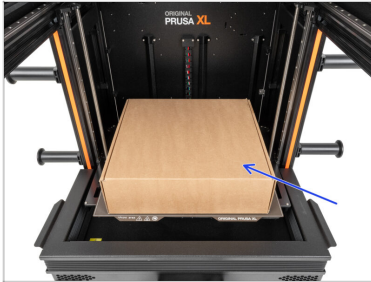
PASO 4 Manipulación con la impresora



⚠ **Nunca manipules la impresora utilizando los porta bobinas o los lados metálicos superiores. Puedes dañar las luces LED ocultas en el interior.**

■ Durante el montaje, manipula la base utilizando las extrusiones.

PASO 5 Protecting the heatbed



i Antes de continuar, te recomendamos que protejas la base calefactable.

■ Asegúrate de que la base calefactable se enfría a temperatura ambiente. Coloca la caja de cartón vacía aproximadamente en la parte delantera central de la base calefactable.

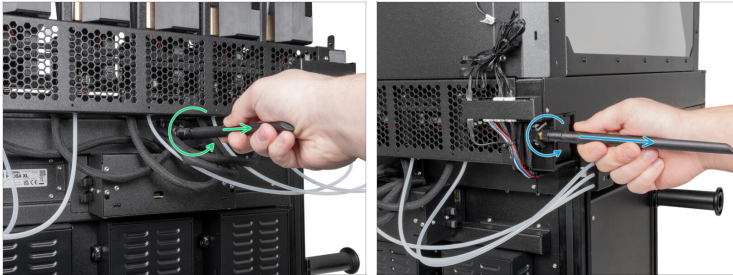
PASO 6 Printer unplugging



■ Apaga el interruptor (símbolo "O").

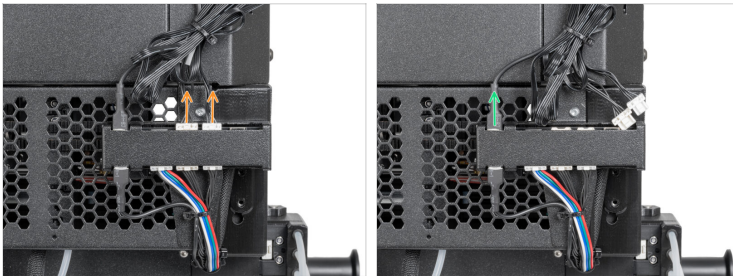
■ Desde la parte posterior de la impresora, desenchufa el cable de la fuente de alimentación.

PASO 7 Removing the Wi-Fi antenna



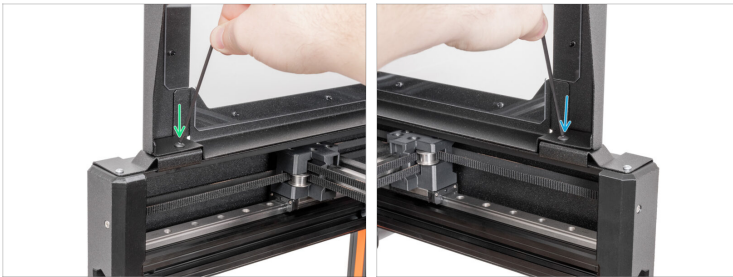
- For the rear version:
 - Desatornilla la antena del conector de la antena.
- For the side version:
 - Desatornilla la antena del conector de la antena.

PASO 8 Optional: Cables disconnecting



- ① The next steps are for users who have an Original Prusa XL Enclosure add-on, otherwise skip to the **Belt releasing**
 - Disconnect the FAN and LED cables from the board by **pressing the safety latch**.
 - Unplug the PE faston from the connection box.

PASO 9 Opcional: Separando la parte delantera



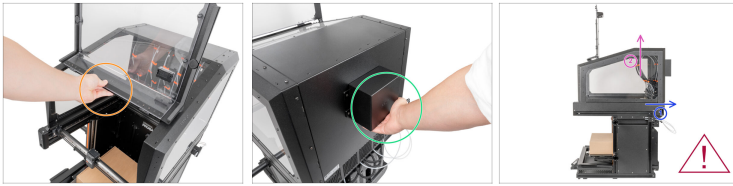
- Desde la parte frontal del cerramiento:
- Open the lid.
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**

PASO 10 Opcional: Separando la parte trasera



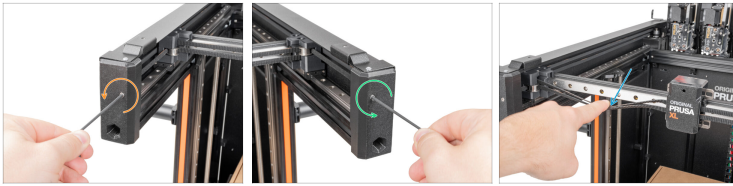
- From the rear side of the printer:
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**
- Remove the M4x8r screw using a 2.5mm Allen key. **Don't throw the parts away!**

PASO 11 Optional: Enclosure removing



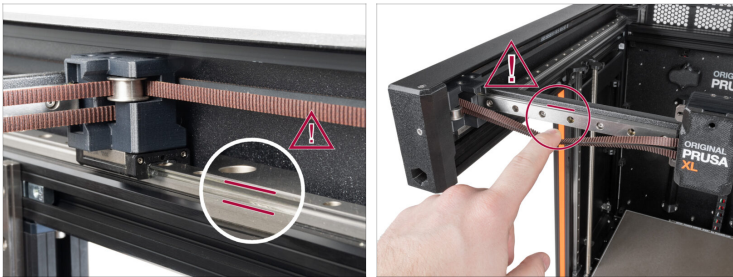
- Sujeta el cerramiento por la parte delantera, donde se encuentra la placa de soporte.
- Sujete el cerramiento por la parte posterior, donde se encuentra la tapa de filtración.
- 1. Push the enclosure to the back of the printer.
- 2. Remove the Enclosure from the printer and place it on a flat surface.

PASO 12 Belt releasing



- On the front side of the printer:
- Using a 2.5mm Allen key, release the M3 screw holding the left CoreXY tensioner. **Do not remove the screw completely.**
- Using a 2.5mm Allen key, release the M3 screw holding the right CoreXY tensioner. **Do not remove the screw completely.**
- Gently tension the belt with your finger. If the belt has a similar degree of looseness as shown in the picture, proceed to the next step.

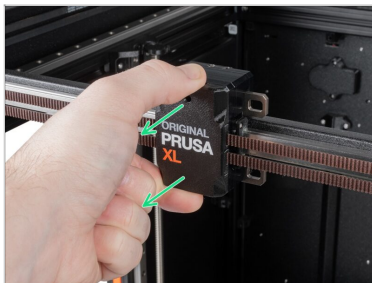
PASO 13 CAUTION: Lubricant Handling



⚠ PRECAUCIÓN: Evita el contacto directo de la piel con el lubricante utilizado para las guías lineales de esta impresora. Si se produce un contacto, lávate las manos inmediatamente. Especialmente antes de comer, beber o tocarte la cara.

- El lubricante se acumula principalmente en los canales de los rieles lineales en los lados lineales.

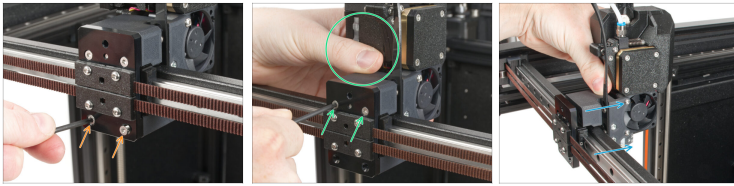
PASO 14 X-carriage cover removing



- Remove the X-carriage cover. **Don't throw the part away!**

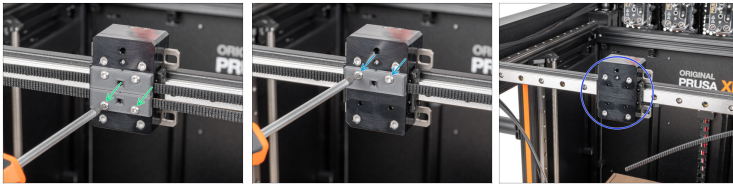
i The cover snaps onto the X-carriage. It is easily removable by hand.

PASO 15 Single-tool Nextruder



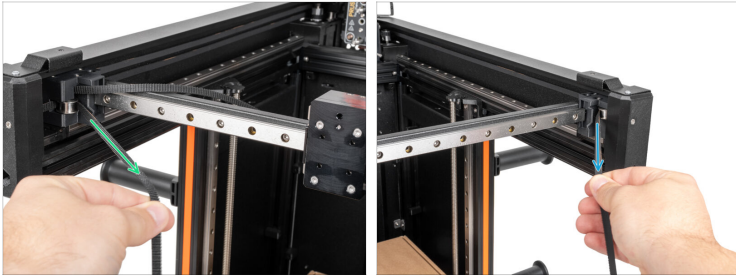
- ① This step is for **single-tool owners only**. Otherwise, ship to the next step.
- 🟠 Remove two M3x12bT screws using a T10 Torx screwdriver. **Don't throw the screws away!**
- 🟢 Hold the extruder and remove the remaining two M3x12bT screws from the top screw holes. **Don't throw the screws away!**
- 🟡 Remove the single-tool Nextruder from the X-carriage. Place the Nextruder on the box covering the heatbed.

PASO 16 Belt clamps removing



- ❶ The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. **The procedure is the same, please continue.**
- Using the T10 Torx screwdriver, remove two M3x12rT screws holding the lower belt-clamp. Remove the belt-clamp. **Do not throw the parts away!**
- Using the T10 Torx screwdriver, remove two M3x12rT screws holding the upper belt-clamp. Remove the belt-clamp. **Do not throw the parts away!**
- With the belt-clamps removed, proceed to the next step.

PASO 17 Belts removing



- Grasp the **bottom belt** on the **left side** of the CoreXY and pull the belt out of the printer.
- Grasp the **upper belt** on the **right side** of the CoreXY and pull the belt out of the printer.
- Throw old belts away!

PASO 18 X-axis: parts preparation



- Para los siguientes pasos, por favor prepara:
- Zip-tie (2x)

PASO 19 X-axis securing



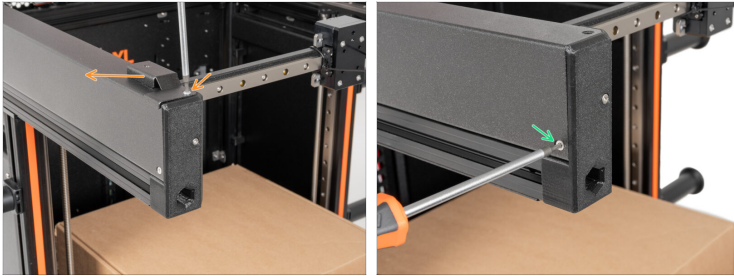
● Single-tool:

- Secure the X-axis with zip-ties to prevent falling from the linear rail during the disassembly in the next steps.

● Multi-tool:

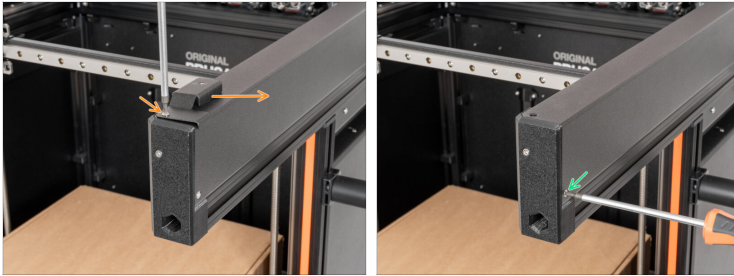
- Secure the X-axis with zip-ties to prevent falling from the linear rail during the disassembly in the next steps.

PASO 20 Front left releasing



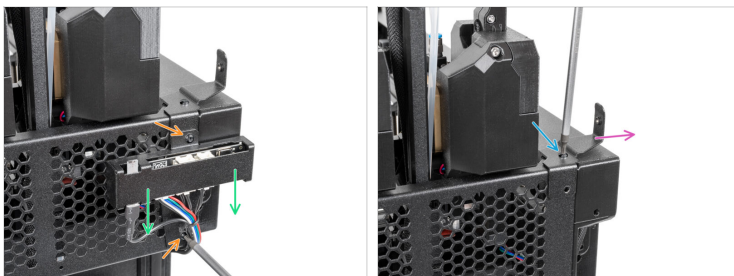
- On the front side of the printer:
- ① If you don't have the Original Prusa XL Enclosure, remove two M3x6bT screws. **Don't throw the parts away!** Continue to the next step.
- Remove the M3x10rT screw and remove the front left bracket. **Don't throw the parts away!**
- Remove the M3x6rT screw. **Don't throw the parts away!**

PASO 21 Front right releasing



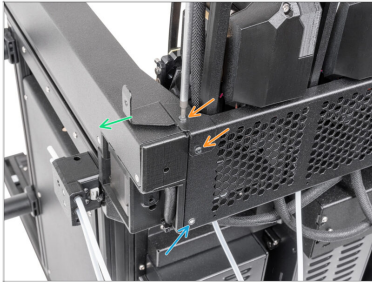
- ① If you don't have the Original Prusa XL Enclosure, remove two M3x6bT screws. Don't throw the parts away! Continue to the next step.
- Remove the M3x10rT screw and remove the front right bracket. Don't throw the parts away!
- Remove the M3x6rT screw. Don't throw the parts away!

PASO 22 Rear right releasing



- On the rear side of the printer:
- ① If you don't have the Original Prusa XL Enclosure, remove three M3x6bT screws. **Don't throw the parts away!** Continue to the next step.
- Remove two M3x10rT screws using a T10 Torx screwdriver. **Don't throw the parts away!**
- Leave the connection box hanging freely on the cables.
- Remove the remaining M3x10rT screw using a T10 Torx screwdriver. **Don't throw the parts away!**
- Retira el soporte fijador trasero izquierdo. **¡No tires las piezas!**

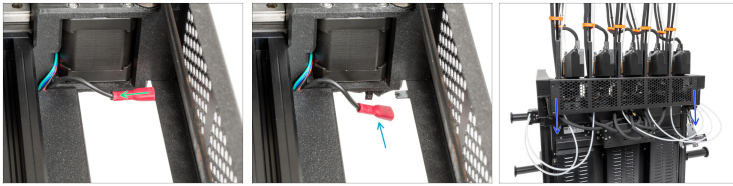
PASO 23 Rear left releasing



i If you don't have the Original Prusa XL Enclosure, remove three M3x6bT screws. **Don't throw the parts away!** Continue to the next step.

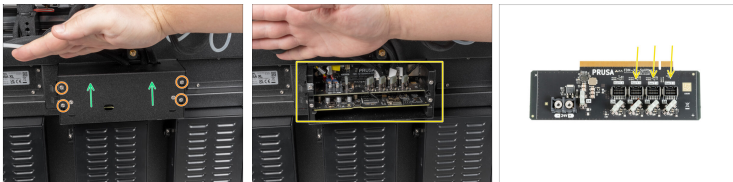
- o** Remove two M3x8bT screws using a T10 Torx screwdriver. **Don't throw the parts away!**
- o** Remove the fixing bracket rear left. **Don't throw the parts away!**
- o** Remove the M3x6bT using a T10 Torx screwdriver. **Don't throw the parts away!**

PASO 24 CoreXY cover removing



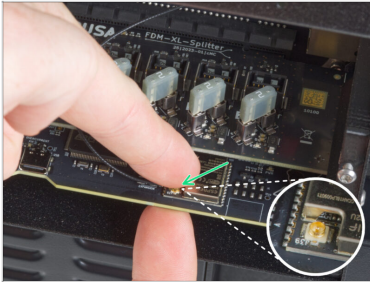
- On the right inner side of the CoreXY cover, unplug the PE connector.
- Leave the PE connector free.
- Gently pull the CoreXY cover from the printer towards you. **Do not throw the part away!**

PASO 25 XL buddy box



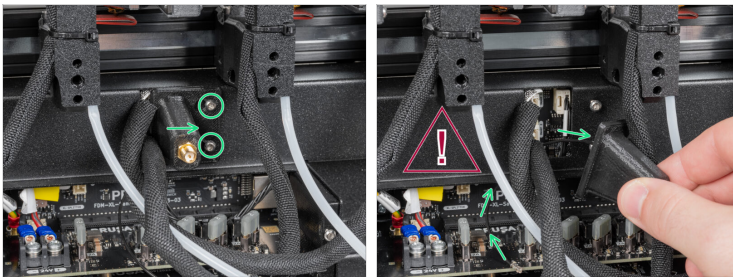
- Afloja (bastan unas pocas vueltas) los cuatro tornillos M3 de la caja XL Buddy.
- Desliza hacia arriba y retira la cubierta XL Buddy.
- i** La siguiente línea es solo para impresoras de cinco cabezales. De lo contrario, pasa al siguiente paso.
- Presionando la pestaña de seguridad, desconecta el DWARF3, DWARF4 y DWARF5 de la placa.

PASO 26 Antenna cable disconnecting



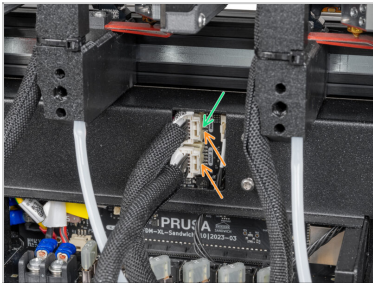
- Localiza y desenchufa el conector Wi-Fi.
- ⓘ If you have the Wi-Fi antenna on the side of the printer, unplug the connector too.

PASO 27 Back antenna removing



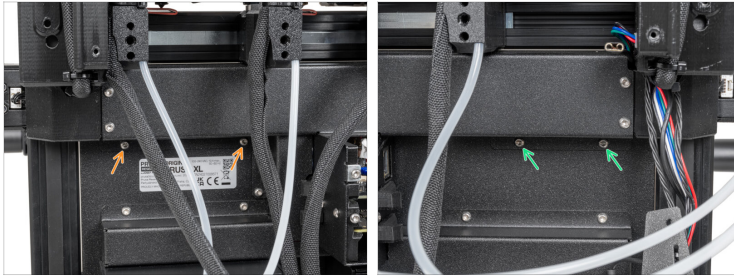
- ⓘ Este paso es solo para la impresora, que tiene una antena Wi-Fi en la parte posterior de la impresora.
- ⚠ **Ten cuidado, no dañes el cable de la antena Wi-Fi.**
- Afloja dos tornillos de la tapa ligeramente. No es necesario retirarlos completamente. Empuja la cubierta hacia la derecha y retírala de la impresora.

PASO 28 Nextruder disconnecting



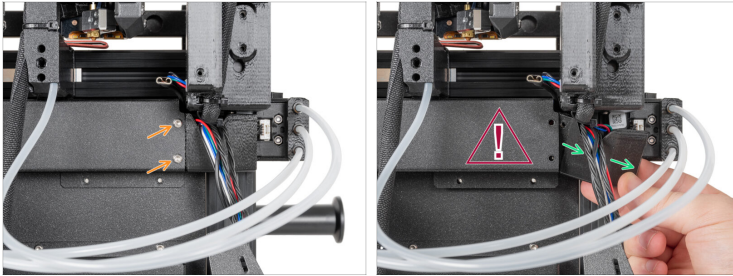
- In case you have a side antenna, loosen two screws on the cover slightly. No need to remove them completely. Push the cover to the right and remove it from the printer.
- En este paso, selecciona la opción adecuada en función de la variante de tu impresora XL:
 - **Un cabezal:** Solo hay un cable. Presionando pestaña de seguridad, retira el cable DWARF1 y continúa con el siguiente paso.
 - **Dos cabezales y cinco cabezales:** Hay dos cables. Presiona la pestaña de seguridad y retira los conectores DWARF1 y DWARF2 de la placa.

PASO 29 Back cover releasing



- ✶ Del lado izquierdo de la parte superior trasera de gestión de cables, retira dos tornillos M3x4rT. **¡No los tires!**
- ✶ Del lado derecho de la parte superior trasera de gestión de cables, retira dos tornillos M3x4rT. **¡No los tires!**

PASO 30 Optional: Cable cover cap removing



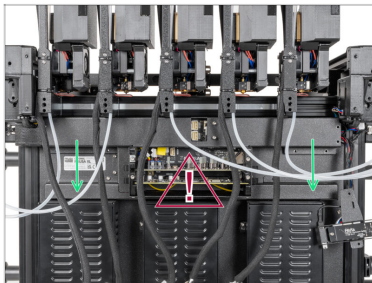
i This step is only for users who have an Original XL Enclosure. Otherwise, continue to the next step.

■ Using a T10 Torx screwdriver, remove two M3x6rT screws.

⚠ **Watch out for cables!**

■ Gently remove cable-cover-cap-right.

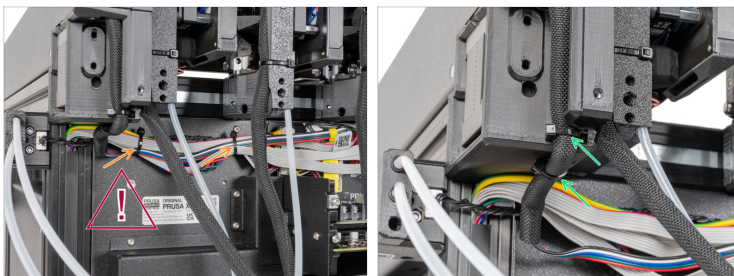
PASO 31 Back cover removing



⚠ **Watch out for cables!**

■ Carefully remove the rear cable management upper from the printer.

PASO 32 Back right cables releasing



¡Cuidado con los cables!

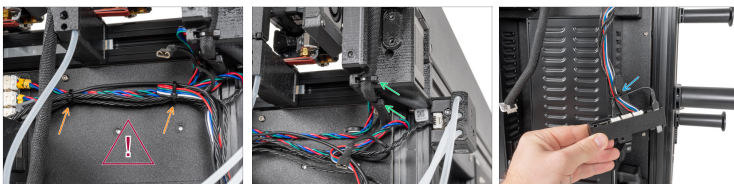


Cut off two zip-ties holding the cables.



Cut off two zip-ties holding the LED cable.

PASO 33 Back left cables releasing



¡Cuidado con los cables!



Cut off two zip-ties holding the cables.



Cut off two zip-ties holding the LED cable.

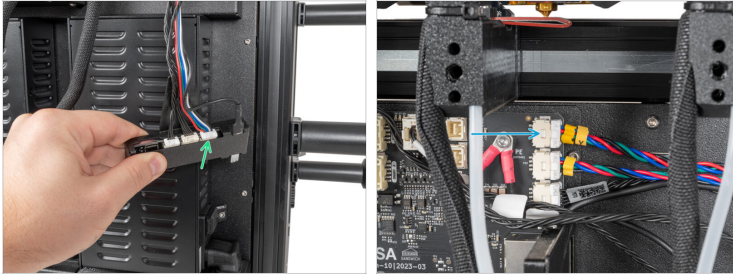


For XL Enclosure owners only. Otherwise, ship to the next step.



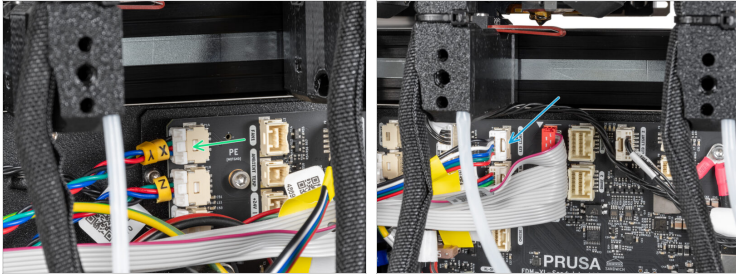
Cut off one zip-tie holding the cables on the XL Enclosure board cover.

PASO 34 Optional: Left XY motor & LED cable disconnecting



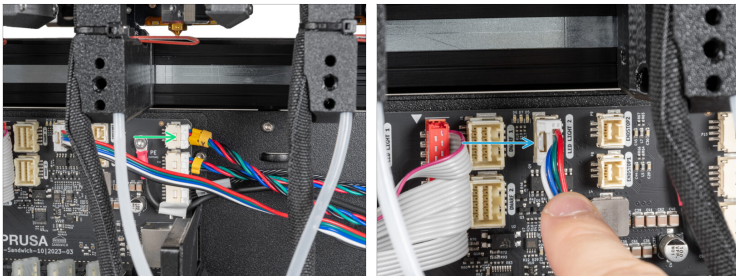
- ① These steps are for Original XL Enclosure owners. Otherwise, continue to the step **Side antenna removing**
- By pressing the safety latch, unplug the LED cable from the connection box.
 - By pressing the safety latch, unplug the XY motor cable.

PASO 35 Optional: Right XY motor & LED cable disconnecting



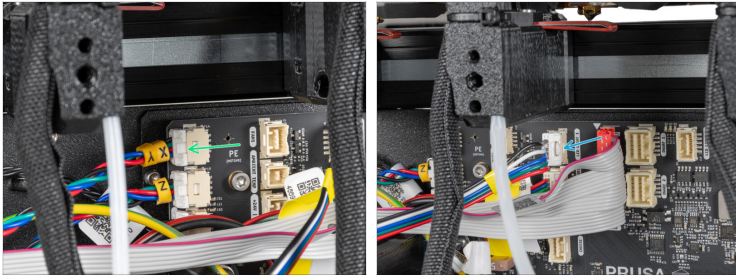
- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable from the connector.

PASO 36 Left XY motor & LED cable disconnecting



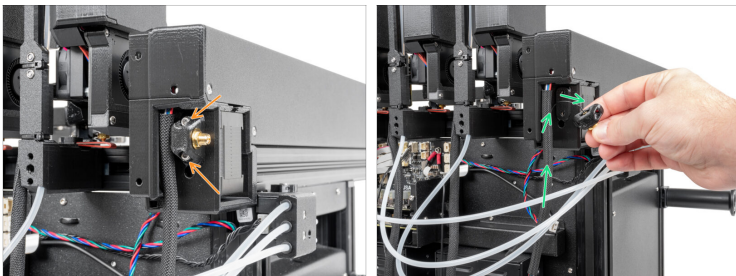
- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

PASO 37 Right XY motor & LED cable disconnecting



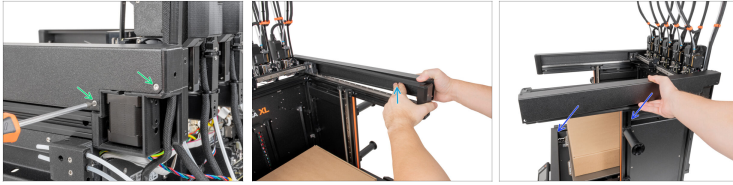
- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

PASO 38 Side antenna removing



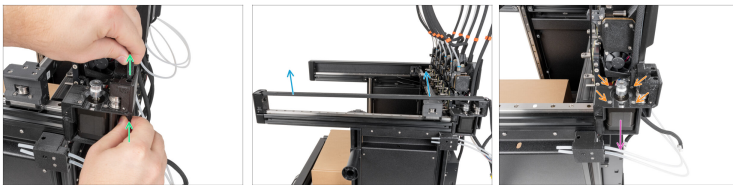
- i** **These steps are for side antenna owners only.** Otherwise, continue to the next step.
- Remove two M3x10 screws using a 2.5 Allen key. **Don't throw the screws away.**
- Gently pull out the antenna cable from the black cotton sleeve. Put the antenna aside.

PASO 39 CoreXY right metal cover remove



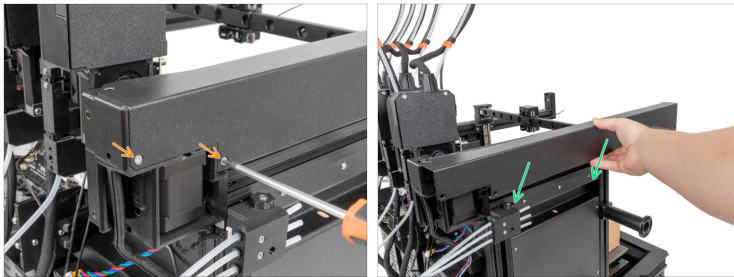
- Desde el lado derecho de la impresora:
- Using the T10 Torx screwdriver, remove two M3x6bT screws. **Don't throw the parts away!**
- Push the cover from the inner side.
- Remove the CoreXY cover. **Don't throw the parts away!**

PASO 40 CoreXY-back-right disassembly



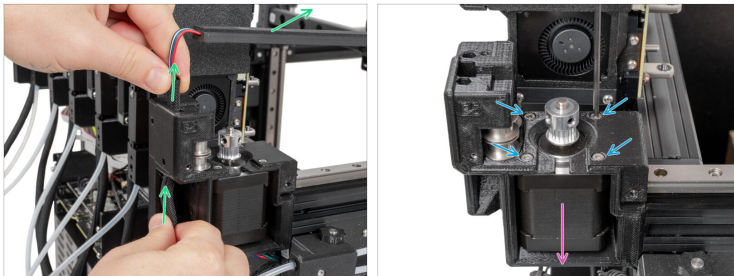
- Gently remove the LED strip cable from the CoreXY back.
- Remove the LED strip panel from the printer. **Don't throw the part away!**
- Using the 2.5mm Allen key, remove four M3x10 screws.
- Remove the XY motor.

PASO 41 CoreXY left metal cover remove



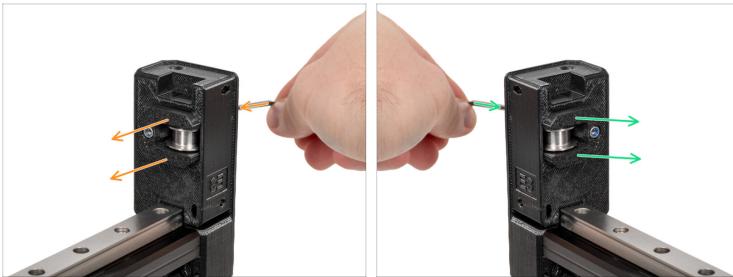
- Desde el lado izquierdo de la impresora:
- Using the T10 Torx screwdriver, remove two M3x6bT screws. **Don't throw the parts away!**
- Push the cover from the inner side and remove the CoreXY cover. **Don't throw the parts away!**

PASO 42 CoreXY-back-left disassembly



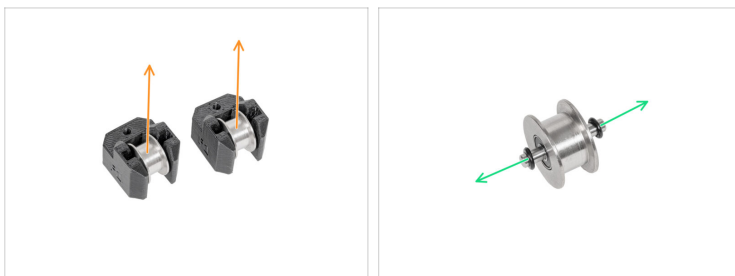
- Gently remove the LED strip cable from the CoreXY back. Remove the LED strip panel from the printer. **Don't throw the part away!**
- Using the 2.5mm Allen key, remove four M3x10 screws.
- Remove the XY motor.

PASO 43 CoreXY-tensioner removing



- Desde la parte frontal de la impresora:
- Untighten the screw and remove the right CoreXY-tensioner. **Do not remove the screw.**
- Untighten the screw and remove the left CoreXY-tensioner. **Do not remove the screw.**

PASO 44 CoreXY-tensioner disassembling



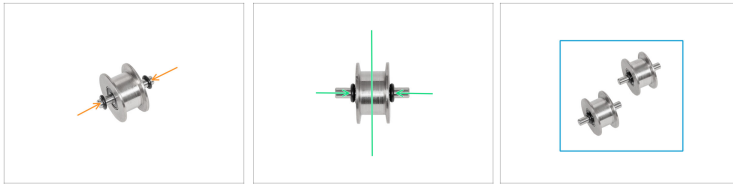
- Remove each single pulley with a pin from the CoreXY-tensioners. **Throw the old plastic parts into the bin.**
- From each single pulley, remove the two O-rings. **Throw the old O-rings into the bin.**
-  Leave the pins in the single pulleys, we'll reassemble them in the next steps.

PASO 45 CoreXY-tensioner: parts preparing



-  **Para los siguientes pasos, por favor prepara:**
-  CoreXY-tensioner (2x)
-  M3nN nut (2x)
-  O-ring (4x)

PASO 46 Single pulley reassembly



-  Place an O-ring on each end of the pin.
-  Push the O-rings towards the centre to keep the pulley in the centre.
-  Prepare both pulleys.

PASO 47 CoreXY-tensioner preparing



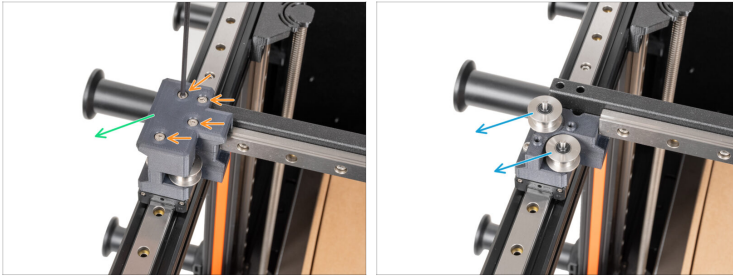
-  Insert one M3nN nut into each CoreXY-tensioner.
-  Insert each prepared single pulley into the CoreXY-tensioners.

PASO 48 CoreXY-tensioner securing



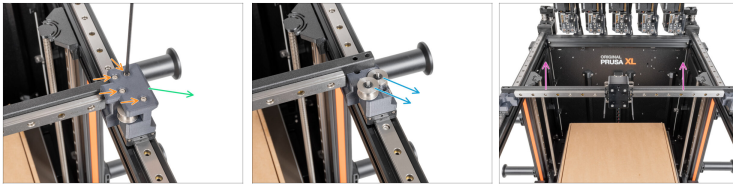
- ✚ Insert the prepared CoreXY-tensioner into the CoreXY-front-left and secure it with the screw. **A few turns are enough for now!**
- ✚ Insert the prepared CoreXY-tensioner into the CoreXY-front-right and secure it with the screw. **A few turns are enough for now!**

PASO 49 Y-carriage-left-top disassembly



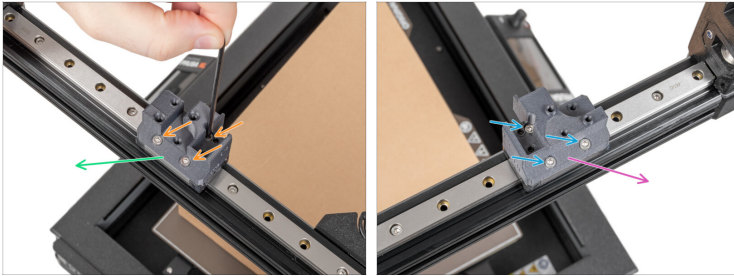
- ✶ Using a 2,5mm Allen key, remove four M3x30 screws. **Don't throw the screws away!**
- ✶ Remove the Y-carriage-left-top. **Throw the old plastic part into the bin.**
- ✶ Remove two single pulleys with the pins from the Y-carriage-left-base. **Put them aside, we'll reassemble them later.**

PASO 50 Y-carriage-right-top disassembly



- ✶ Using a 2,5mm Allen key, remove four M3x30 screws. **Don't throw the screws away!**
- ✶ Remove the Y-carriage-right-top. **Throw the old plastic part into the bin.**
- ✶ Remove two single pulleys with the pins from the Y-carriage-right-base. **Put them aside, we'll reassemble them later.**
- ✶ Remove the X-axis with a **secured tool-changer (x-carriage)**. **Put the part aside.**

PASO 51 Y-carriage base disassembly



- Remove three M3x10 from the Y-carriage-right-base. **Don't throw the screws away!**
- Remove the Y-carriage-right-base. **Throw the old plastic part into the bin.**
- Remove three M3x10 from the Y-carriage-left-base. **Don't throw the screws away!**
- Remove the Y-carriage-left-base. **Throw the old plastic part into the bin.**

PASO 52 Single pulley reassembly: parts preparation

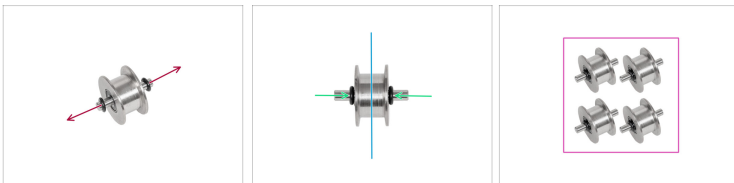


● Para los siguientes pasos, por favor prepara:

● O-ring (8x)

● Assembled Single pulley (4x) *removed in previous steps*

PASO 53 Single pulley reassembly



● Remove the old O-rings from each of the individual belt pulleys. **Throw the old O-rings into the bin.**

● Place a new O-ring on each end of the pin.

● Push the O-rings towards the centre to keep the pulley in the centre.

● Prepare all four single pulleys.

PASO 54 X-axis: parts preparation



❖ **Para los siguientes pasos, por favor prepara:**

🟠 X-axis (1x) *removed in the previous steps*

🟡 M3nN nut (8x)

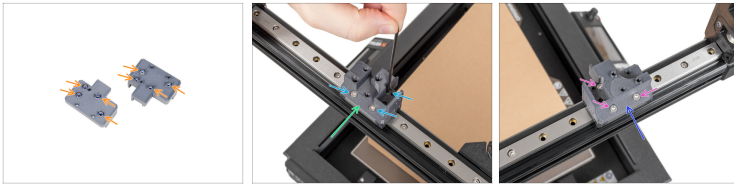
🟢 M3x10 screw (6x) *removed in the previous steps*

⚠ **The printed parts of the Y-carriage are marked with printed letters. Look at the third picture.**

🟢 Y-carriage-right-base (1x) *marked RB*

🟠 Y-carriage-left-base (1x) *marked LB*

PASO 55 Y-carriage base assembly



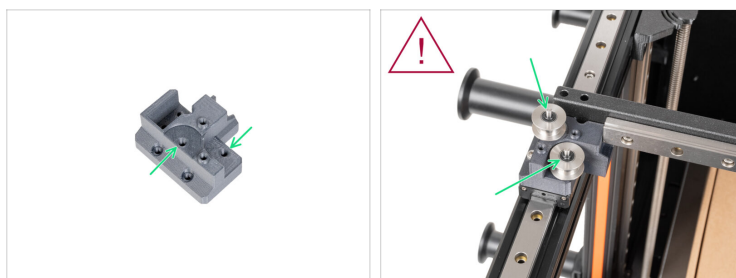
- ✶ Insert M3nN nuts into the Y-carriage bottoms.
- ✶ Place the **Y-carriage-right-base (RB)** onto the linear rail carts.
- ✶ Secure the Y-carriage-right-base (RB) with three M3x10 screws.
- ✶ Place the **Y-carriage-left-base (LB)** onto the linear rail carts.
- ✶ Secure the Y-carriage-left-base (LB) with three M3x10 screws.

PASO 56 Y-carriage-right-base assembly



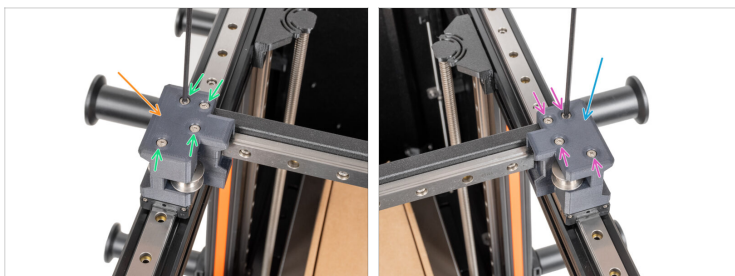
- Insert the X-axis onto Y-carriage bases.
- To ensure that the X-axis is properly seated in the base of the Y-carriage, slide the X-axis back and forth a few times.
- ⚠ Make sure that the individual pulleys are complete with all the necessary parts! **Especialy O-rings!**
- Insert two prepared single pulleys into marked holes in the Y-carriage-right-base. See the picture.

PASO 57 Y-carriage-left-base assembly



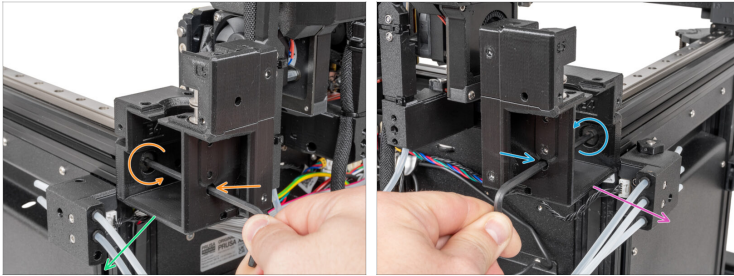
- ⚠ Make sure that the individual pulleys are complete with all the necessary parts! **Especialy O-rings!**
- Insert two prepared single pulleys into the marked holes in the Y-carriage-left-base. See the picture.

PASO 58 Y-carriage top assembly



- Attach the **Y-carriage-left-top (LT)** onto the Y-carriage-left-base.
- Secure the Y-carriage-left-top with four M3x30 screws. **Do not overtighten, make sure the pulleys can rotate freely.**
- Attach the **Y-carriage-right-top (RT)** onto the Y-carriage-right-base.
- Secure the Y-carriage-right-top with four M3x30 screws. **Do not overtighten, make sure the pulleys can rotate freely.**
- Well done! The X-axis parts are replaced, let's continue.

PASO 59 CoreXY-back removing



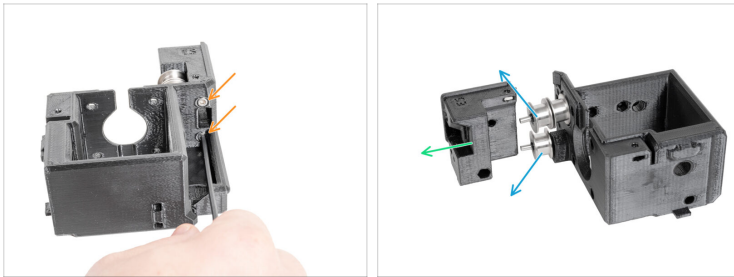
- ✶ Insert the 4mm Allen key through the hole and remove the M8x16 screw.
- ✶ Remove the CoreXY-back-right from the printer.
- ✶ Insert the 4mm Allen key through the hole and remove the M8x16 screw.
- ✶ Remove the CoreXY-back-right from the printer.

PASO 60 CoreXY-back-left disassembling



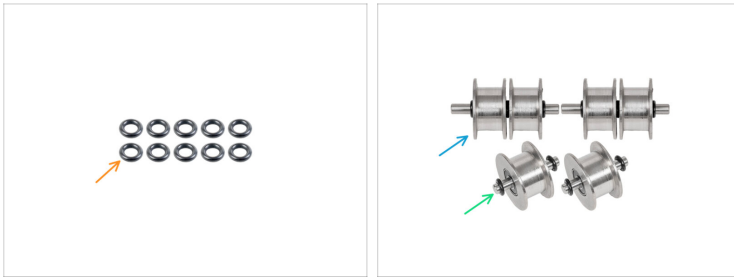
- ✶ Using a 2.5mm Allen key, remove two M3x35 screws.
- ✶ Remove the CoreXY-back-right-top from the CoreXY-back-right. **Don't throw the parts away, we'll need some distance nuts.**
- ✶ Remove the double pulley and the single pulley. **Don't throw the parts away!**
- ① Leave the pins in the pulleys, we'll reassemble them in the next steps.

PASO 61 CoreXY-back-right disassembling



- ✚ Using a 2.5mm Allen key, remove two M3x35 screws.
- ✚ Remove the CoreXY-back-right-top from the CoreXY-back-right. **Don't throw the parts away, we'll need some distance nuts.**
- ✚ Remove the double pulley and the single pulley. **Don't throw the parts away!**
- ⓘ Leave the pins in the pulleys, we'll reassemble them in the next steps.

PASO 62 Pulley reassembly: parts preparation



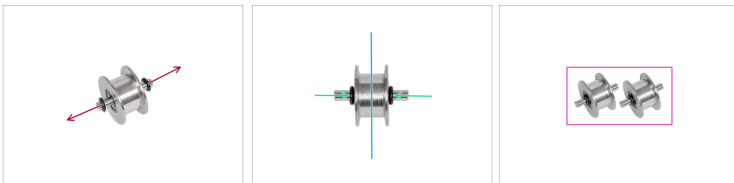
■ Para los siguientes pasos, por favor prepara:

■ O-ring (10x)

■ Assembled Single pulley (2x) *removed in previous steps*

■ Assembled Double pulley (2x) *removed in previous steps*

PASO 63 Single pulley reassembly



■ Remove the old O-rings from each of the individual belt pulleys. **Throw the old O-rings into the bin.**

■ Place a new O-ring on each end of the pin.

■ Push the O-rings towards the centre to keep the pulley in the centre.

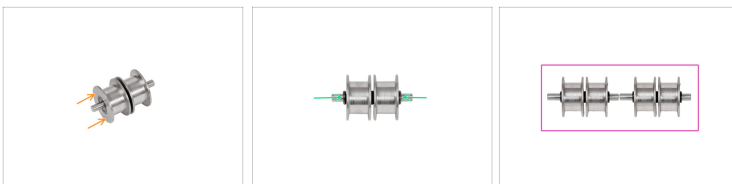
■ Prepare both single pulleys.

PASO 64 Double pulley disassembly



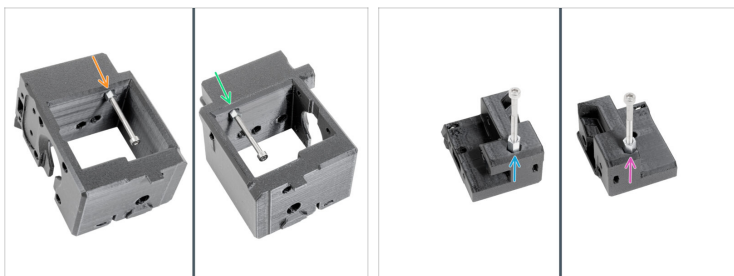
- From each side of the pin, remove the O-ring. **Throw the old O-rings into the bin.**
- Remove the pulley. **Put it aside.**
- Remove the remaining O-Ring. **Throw the old O-ring into the bin.**
- Attach a **new** O-Ring on the pin. See the picture.

PASO 65 Double pulley reassembly



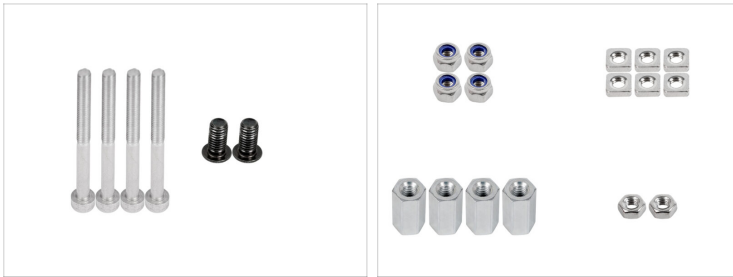
- Attach the removed pulley back onto the pin. See the picture.
- Attach on each side one **new** O-ring. See the picture.
- Prepare both double pulleys.
- Good job. Single and double pulleys are prepared. Let's continue.

PASO 66 Spacers removing



- i** *Hint: You can use an M3x35 to remove the M3x10 spacer nut.*
- Remove one M3x10 spacer nut from CoreXY-back-left. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
 - Remove one M3x10 spacer nut from CoreXY-back-right. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
 - Remove one M3x10 spacer nut from CoreXY-back-left-top. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
 - Remove one M3x10 spacer nut from CoreXY-back-right-top. See the pictures. **Keep the nuts for later, we'll use them again in the next steps.**
 - Throw your old CoreXY-backs & tops in the bin, we don't need them anymore.

PASO 67 Back assembly: parts preparation



■ **Para los siguientes pasos, por favor prepara:**

■ M3x35 screw (2x) *removed in previous steps*

■ M8x16 screw (2x) *removed in previous steps*

■ M3nN nut (4x)

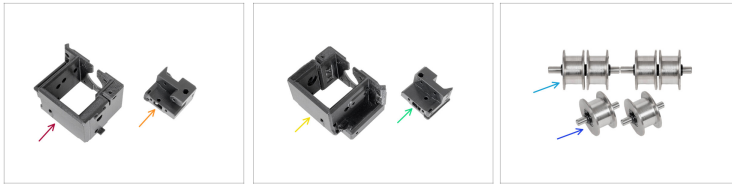
■ M3nS nut (6x)

■ M3x10 spacer nut (4x) *removed in previous steps*

■ M3n nut (2x) *for side antenna owners only*

ⓘ The list continue in the next step.

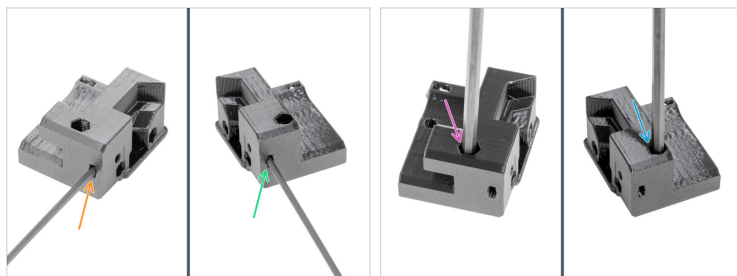
PASO 68 Back assembly: parts preparation



■ **Para los siguientes pasos, por favor prepara:**

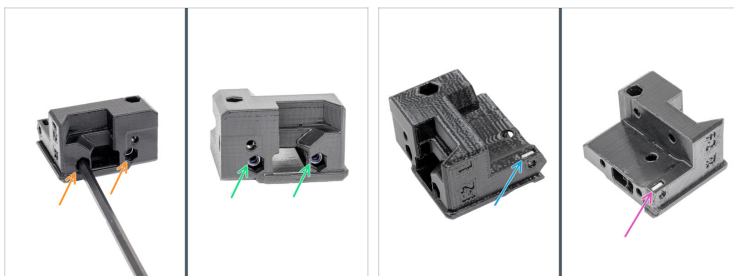
- CoreXY-back-left (1x)
- CoreXY-back-left-top (1x)
- CoreXY-back-right (1x)
- CoreXY-back-right-top (1x)
- Reassembled double pulley (2x)
- Reassembled single pulley (2x)

PASO 69 CoreXY-back-top preparing: part one



- ✚ Insert one M3nS nut into the CoreXY-back-left-top. Push it with a 2.5 mm Allen key. See the first picture.
- ✚ Insert one M3nS nut into the CoreXY-back-right-top. Push it with a 2.5 mm Allen key. See the first picture.
- ✚ Insert one M3x10 spacer nut into the CoreXY-back-left-top. Push it with a 4.0 mm Allen key. See the second picture.
- ✚ Insert one M3x10 spacer nut into the CoreXY-back-right-top. Push it with a 4.0 mm Allen key. See the second picture.

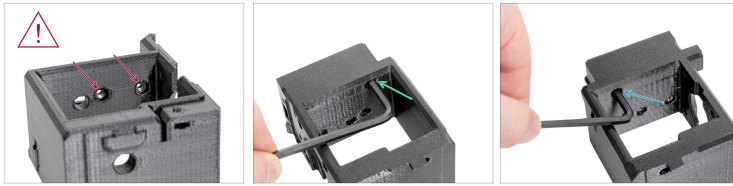
PASO 70 CoreXY-back-top preparing: part two



- ✚ Insert two M3nN nut into the CoreXY-back-right-top. Push it with a 4.0 mm Allen key. See the first picture.
- ✚ Insert two M3nN nut into the CoreXY-back-left-top. Push it with a 4.0 mm Allen key. See the first picture.
- ✚ Insert one M3nS nut into the CoreXY-back-left-top. Push it with a 2.5 mm Allen key. See the second picture.
- ✚ Insert one M3nS nut into the CoreXY-back-right-top. Push it with a 2.5 mm Allen key. See the second picture.

⚠ Double-check that you have inserted all the nuts as described in steps 68 and 69 (nice). You don't want to find out later that you missed a nut. Trust me on this.

PASO 71 CoreXY-back preparing: part one



- **Only if you have an antenna on the left:** Insert two M3n into the inside of the CoreXY-back-left. See the picture
- Insert one M3x10 spacer nut into the CoreXY-back-left. Push it with a 4.0 mm Allen key. See the second picture.
- Insert one M3x10 spacer nut into the CoreXY-back-right. Push it with a 4.0 mm Allen key. See the third picture.

PASO 72 CoreXY-back preparing: part two



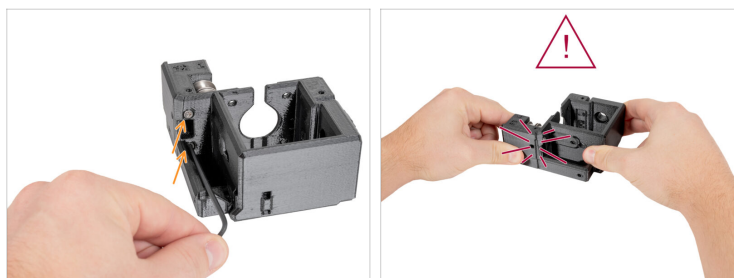
- ✚ Insert one M3nS nut into the CoreXY-back-right. Push it with a 2.5 mm Allen key. See the first picture.
- ✚ Insert one M3nS nut into the CoreXY-back-left. Push it with a 2.5 mm Allen key. See the second picture.
- ⚠ Double-check that you have inserted all the nuts as described in steps 70 and 71. You don't want to find out later that you missed a nut. Trust me on this.

PASO 73 CoreXY-back-left-top preparing



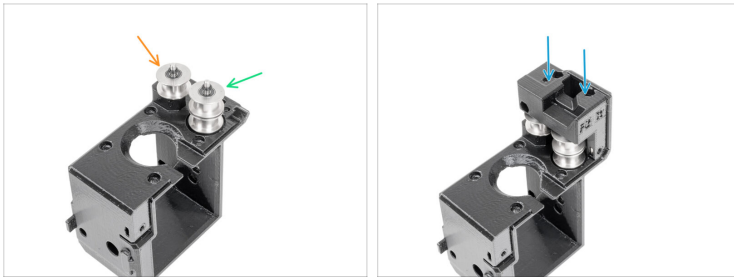
- ✚ Insert the prepared double pulley into the CoreXY-back-left. See the picture.
- ✚ Insert the prepared single pulley into the CoreXY-back-left. See the picture.
- ✚ Attach the CoreXY-back-left-top onto the pulleys and the CoreXY-back-left. See the picture.

PASO 74 CoreXY-back-left-top securing



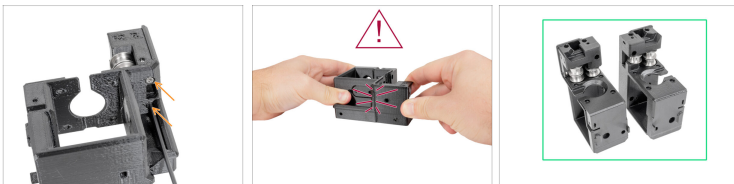
- ✚ Insert and tighten two M3x35 screws.
- ⚠ The parts must be tightened together. Check that the parts do not move. Tighten the M3x35 screws if necessary.

PASO 75 CoreXY-back-right-top preparing



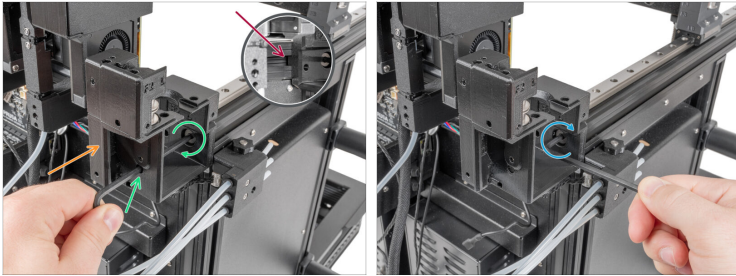
- ✚ Insert the prepared single pulley into the CoreXY-back-right. See the picture.
- ✚ Insert the prepared double pulley into the CoreXY-back-right. See the picture.
- ✚ Attach the CoreXY-back-right-top onto the pulleys and the CoreXY-back-right.

PASO 76 CoreXY-back-right-top securing



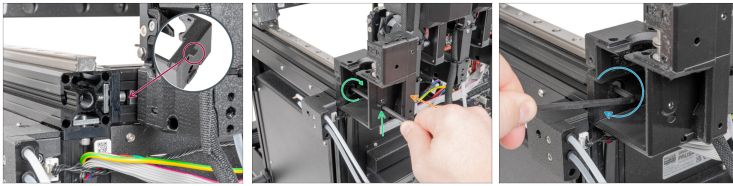
- ✚ Insert and tighten two M3x35 screws.
- ⚠ The parts must be tightened together. Check that the parts do not move. Tighten the M3x35 screws if necessary.
- ✚ Well done. Both CoreXY-backs are ready to be attached to the printer.

PASO 77 CoreXY-back-left securing



- Both CoreXY-backs have a printed piece that fits inside the extrusion. See picture.
- Attach the CoreXY-back-left to the printer.
- Secure the CoreXY-back-right with an M8x16 screw using a 4.0 mm Allen key.
- Tighten the screw with the shorter side of the 4.0 mm Allen key.

PASO 78 CoreXY-back-right securing



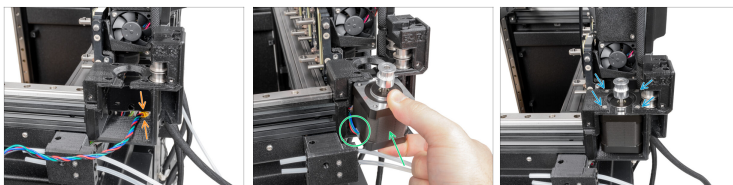
- The right CoreXY-back-right has a printed piece that fits into the extrusion between the screw and the tch-insert. See picture.
- Attach the CoreXY-back-right to the printer.
- Secure the CoreXY-back-right with an M8x16 screw using a 4.0 mm Allen key.
- Tighten the screw with the shorter side of the 4.0 mm Allen key.

PASO 79 XY-motor: parts preparation



- Para los siguientes pasos, por favor prepara:
- ⚠ **Look how are GT2-16 pulleys oriented on each motor. See the pictures.**
- XY-motor right (1x) *removed in previous steps*
- XY-motor left(1x) *removed in previous steps*
- M3x8 screw (8x) *removed in previous steps*

PASO 80 Right XY-motor securing



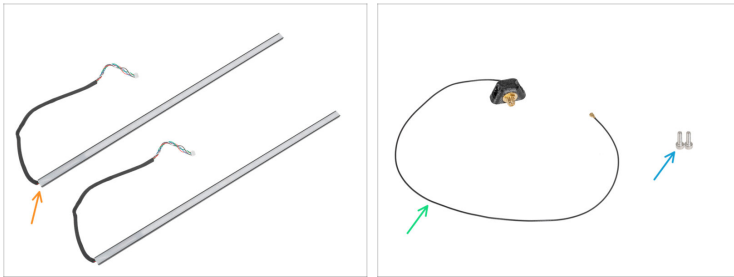
- ✚ Insert the cable through the CoreXY-back-right and under the fifth tool-head (if installed). See the picture.
- ✚ Insert the motor into the CoreXY-back-right. **The motor cable has to be oriented to the left.** See the picture.
- ✚ Insert and secure four M3x8 using a 2.5mm Allen key.

PASO 81 Left XY-motor securing



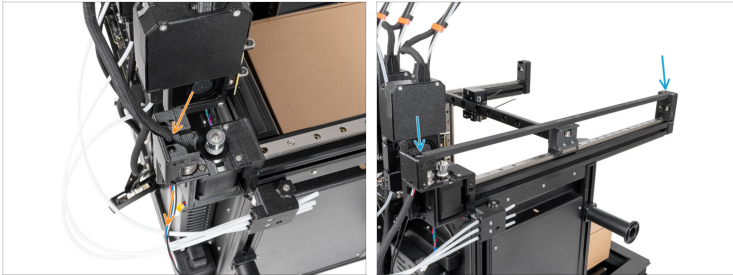
- ✚ Insert the cable through the CoreXY-back-left.
- ✚ Insert the motor into the CoreXY-back-left. The motor cable has to be oriented to the right. See the picture.
- ✚ Insert and secure four M3x8 using a 2.5mm Allen key.

PASO 82 Tira LED: preparación de las piezas



- **Para los siguientes pasos, por favor prepara:**
- LED strip (2x) *removed in previous steps*
- For side antenna owners only:
- Side antenna assembly (1x) *removed in previous steps*
- M3x10 screw (2x) *removed in previous steps*

PASO 83 Left LED strip attaching



- ✚ Insert the power cable of the LED strip through the hole in the CoreXY back.
- ⓘ The LED strip panel must face down with the white diffuser facing downwards.
- ✚ Attach the back side of the LED strip panel onto the CoreXY-back-left and CoreXY-front-left.

PASO 84 Right LED strip attaching



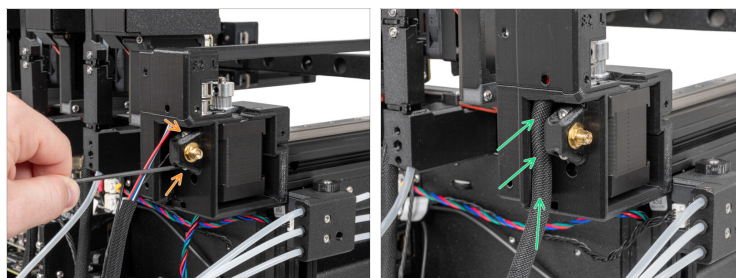
- ✦ Insert the power cable of the LED strip through the hole in the CoreXY-back-right.
- ① The LED strip panel must face down with the white diffuser facing downwards.
- ✦ Attach the back side of the LED strip panel onto the CoreXY-back-right and CoreXY-front-right.

PASO 85 Side antenna preparing



- i** These steps are for **side antenna owners only**. Otherwise, ship to the step Core XY cover: parts preparation
- On the back side, where was your antenna used to be:
- Insert the end of the antenna cable into the black textile sleeve.
- Push the antenna cable through the sleeve.
- At the top, pull the antenna cable out of the sleeve a little. See the picture.

PASO 86 Side antenna securing



- Attach and secure the side antenna with two M3x10 screws using a 2.5 mm Allen key.
- Lift the textile sleeve and push it into the CoreXY back-left. See the picture.

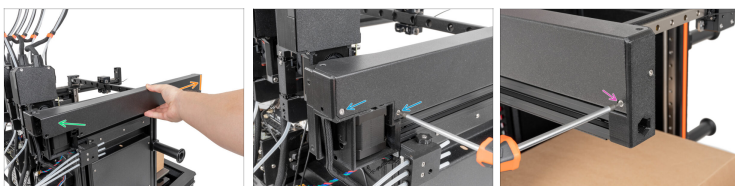
PASO 87 CoreXY cover: parts preparation



■ Para los siguientes pasos, por favor prepara:

- CoreXY cover left (1x) *removed in previous steps*
- CoreXY cover right (1x) *removed in previous steps*
- M3x6bT screw (6x) *removed in previous steps*

PASO 88 CoreXY cover left securing



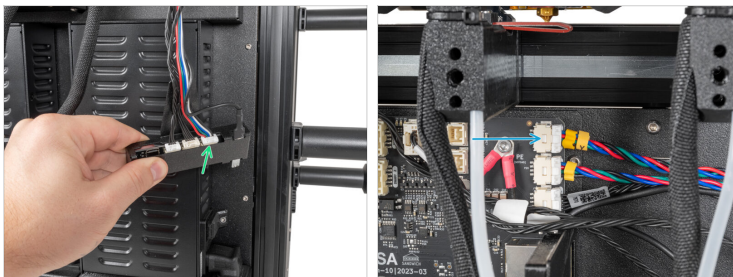
- Insert the front (straight) part of the Cover CoreXY left into the CoreXY-front-left and slide the cover into place.
- Push the rear side of the Cover CoreXY left panel into the CoreXY-back-left.
- Insert two M3x6bT into the holes and tighten them using a T10 Torx screwdriver.
- Insert one M3x6bT into the hole and tighten it using a T10 Torx screwdriver.

PASO 89 CoreXY cover right securing



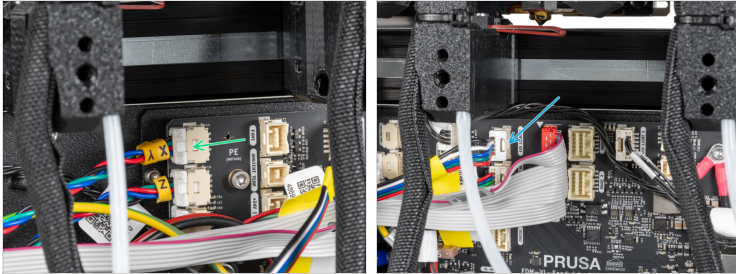
- 🟠 Attach the Cover CoreXY right onto the printer.
- 🟢 Push the rear side of the Cover CoreXY right into the CoreXY-back-right.
- 🟡 Insert two M3x6bT into the holes and tighten them using a T10 Torx screwdriver.
- 🟣 Insert one M3x6bT into the hole and tighten it using a T10 Torx screwdriver.

PASO 90 Optional: Left XY motor & LED cable connecting



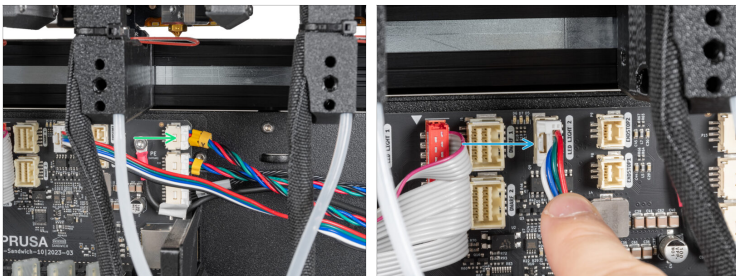
- 📘 These steps are for Original XL Enclosure owners. Otherwise, continue to the step **Left XY motor & LED cable disconnecting**
- 🟢 Connect the LED cable to the connection box.
- 🟡 Connect the XY motor cable.

PASO 91 Optional: Right XY motor & LED cable connecting



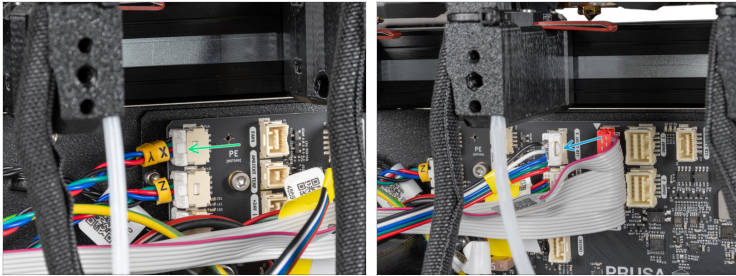
- Connect the XY motor cable.
- Connect the LED cable to the LED Light 1 connector.

PASO 92 Left XY motor & LED cable connecting



- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

PASO 93 Right XY motor & LED cable connecting



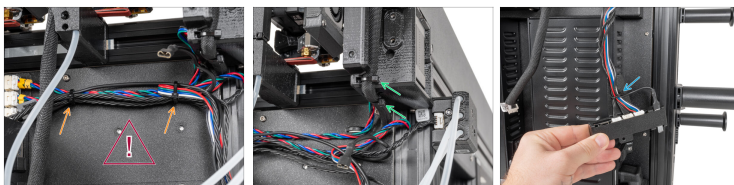
- By pressing the safety latch, unplug the XY motor cable.
- By pressing the safety latch, unplug the LED cable.

PASO 94 Back cables securing: part preparation



- Para los siguientes pasos, por favor prepara:
- Zip-tie (9x)

PASO 95 Back left cables securing



ATTENTION: Do not overtighten the zip ties! Otherwise, you risk damaging the cables.



Insert the zip-tie through the metal cut-out and secure all cables. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.



From the bottom side of the CoreXY-back-left, insert two zip-ties around the LED strip cable. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.



For XL Enclosure owners only. Otherwise, ship to the next step.



Fija los cables con cuidado a la cubierta de la placa de XL enclosure. **No aprietes demasiado la brida.** Corta el extremo de la brida.

PASO 96 Back right cables securing



ATTENTION: Do not overtighten the zip ties! Otherwise, you risk damaging the cables.

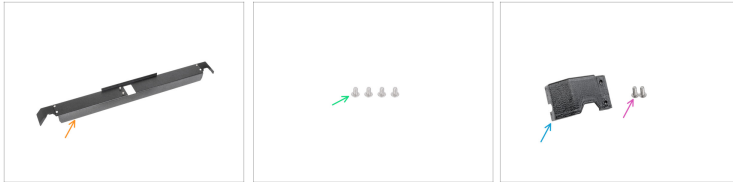


Insert the zip-tie through the metal cut-out and secure all cables. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.



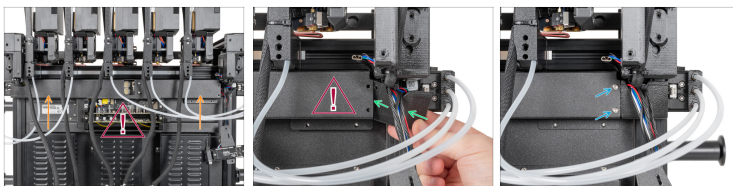
From the bottom side of the CoreXY-back-left, insert two zip-ties around the LED strip cable. **Do not overtighten the zip-tie.** Cut the ends of the zip-ties.

PASO 97 Cubierta trasera: preparación de las piezas



- **Para los siguientes pasos, por favor prepara:**
- Rear-cable-management-upper (1x) *que retiraste en los pasos anteriores*
- Tornillos M3x4rT screws (4x) *que retiraste en los pasos anteriores*
- **For XL Enclosure owners only.** Otherwise, skip to the next step.
- Cable-cover-cap-right (1x) *removed in previous steps*
- M3x8rT screw (2x) *removed in previous steps*

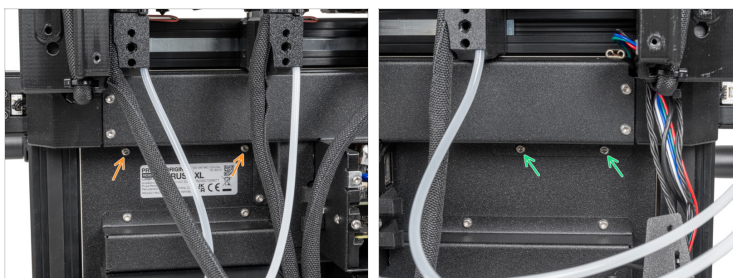
PASO 98 Back cover attaching



Watch out for cables!

- Carefully attach the rear cable management upper to the printer.
- **This step is only for users who have an Original XL Enclosure.** Otherwise, continue to the next step.
- Gently insert the cable-cover-cap-right.
- Insert and secure two M3x8rT screws using a T10 Torx screwdriver.

PASO 99 Back cover securing



- On the left side of the rear cable management upper, insert and secure two M3x4rT screws.
- On the right side of the rear cable management upper, insert and secure two M3x4rT screws.

PASO 100 Antenna cover attaching



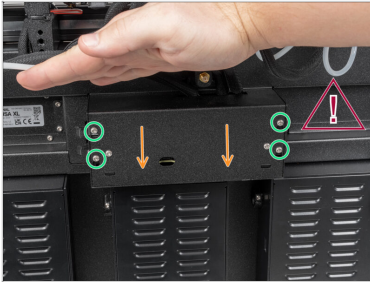
- En este paso, selecciona la opción adecuada en función de la variante de tu impresora XL:
 - Single-tool: There is only one cable. Connect the first dock (from the right side) cable to the upper slot labeled DWARF 1.
 - Dual-Head & Five-Head: Connect the second dock (from the right side) cable to the lower slot labeled DWARF 2.
- ① The next step is only for the printer, which has a **Wi-Fi antenna on the back** of the printer. Otherwise, ship to the following one.
- ⚠ **Ten cuidado, no dañes el cable de la antena Wi-Fi.**
 - Pasa el cable de la antena por la abertura de la cubierta de cables (chapa metálica) y guíalo por detrás de la cubierta hasta la caja de la electrónica.
 - Coloca el antenna-holder en los tornillos y empuja la cubierta hacia la izquierda. Aprieta los tornillos.

PASO 101 Conectando el Nextruder y la Antena



- Locate and connect the Wi-Fi cable to the Wi-Fi connector.
- ① Those steps are only for printers with more than 2 Nextruders. **Otherwise go to the next step.**
- Conecta el tercer, cuarto y quinto (desde la derecha) Nextruder al splitter:
 - Third Nextruder.
 - Fourth Nextruder.
 - Fifth Nextruder.
- El XL-splitter con los Nextruders conectados debe parecerse a esto.

PASO 102 XL buddy box attaching



¡Ten cuidado de no atrapar los cables!



Vuelva a colocar la XL-buddy-box-cover en la impresora.

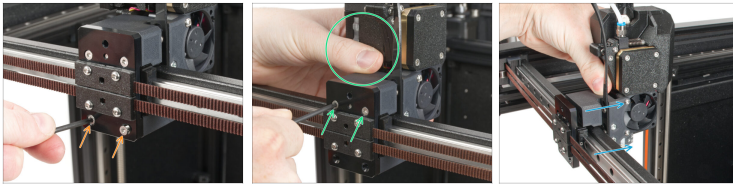


Comprueba los cables Nextruders, tienen que estar dentro del recorte en la cubierta.



Con una llave T10 aprieta los cuatro tornillos.

PASO 103 Single-tool Nextruder



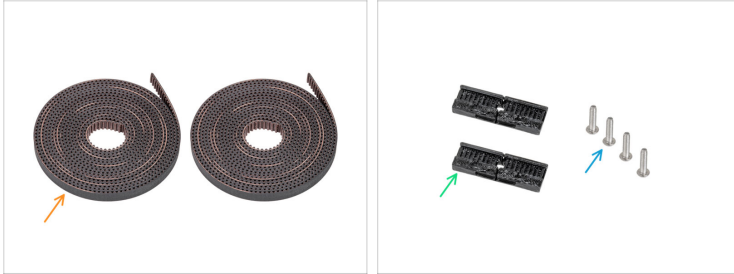
-  This step is for **single-tool owners only**. Otherwise, ship to the next step.
-  Remove two M3x12bT screws using a T10 Torx screwdriver. **Don't throw the screws away!**
-  Hold the extruder and remove the remaining two M3x12bT screws from the top screw holes. **Don't throw the screws away!**
-  Remove the single-tool Nextruder from the X-carriage. Place the Nextruder on the box covering the heatbed.

PASO 104 Colocando las correas: información importante



-  It is important to attach the belts correctly to the printer. Do not rush.
-  Always Compare pictures with your printer.
-  Make sure, that no belt is twisted.

PASO 105 Colocando las correas: preparación de las piezas



i The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. **The procedure is the same, please continue.**

■ Para los siguientes pasos, por favor prepara:

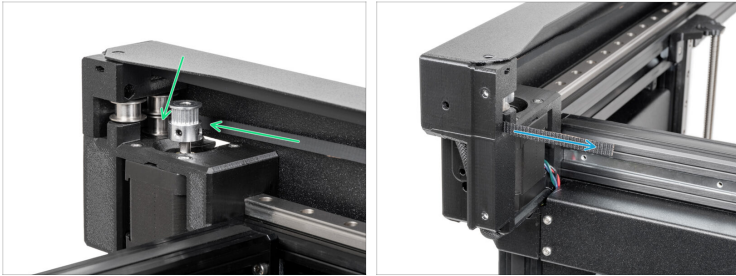
- New XY belts (2x)
- XL-belt-clamp (2x) *removed in previous steps*
- M3x12rT screws (4x) *removed in previous steps*

PASO 106 Colocando la correa inferior: lado delantero derecho



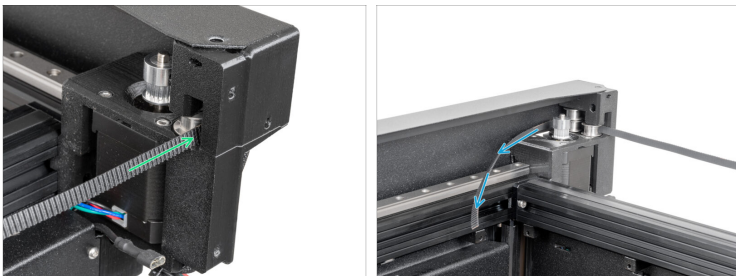
- Desde la parte frontal de la impresora:
- Take one of the belts.
- Insert the one end of the belt into the front lower section of the Y-carriage-right-base.
- The belt has to be facing toward the printer with the teeth showing (not the smooth side of the belt).
- ① Comprueba dos veces que los dientes están orientados hacia la máquina.
- On the inner side of the Y-carriage-right-base pull the the belt.
- ⚠ Don't pull the belt too much, it can fall out from the Y-carriage-right-base and the whole process of the belt attaching has to be repeated from the start.

PASO 107 Lower belt attaching: right rear side



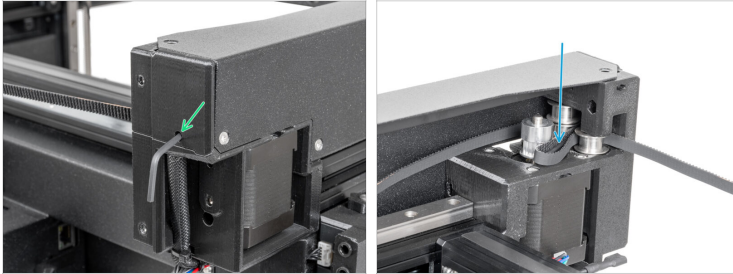
- Pull the belt some more and insert it behind the lower pulley.
- Pull the belt, which is now inserted through the lower pulley.

PASO 108 Lower belt attaching: left rear side



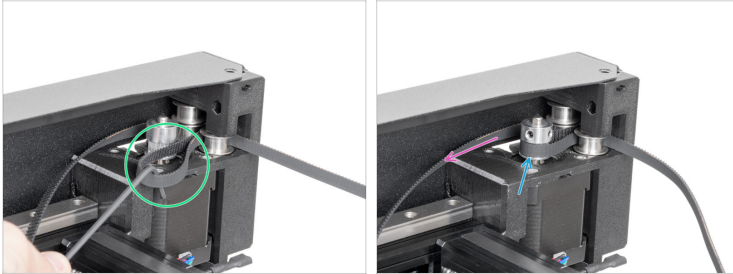
- Pull the belt some more and insert it behind the lower pulleys.
- Pull the belt, which is now inserted through the lower pulleys.

PASO 109 Colocando la correa inferior: preparando la correa de la polea del motor



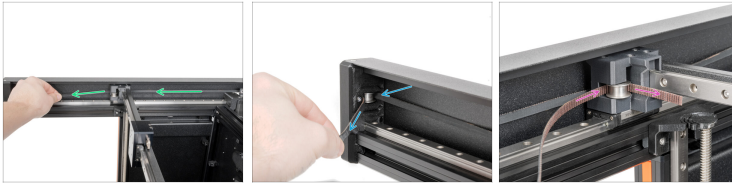
- From the rear side of the printer:
- Insert the 2.5 mm Allen key through the hole to create a loop on the belt.
- When the loop is created, you can remove the Allen key. **Do not pull the belt!**

PASO 110 Colocando la correa superior: fijando la correa de la polea del motor



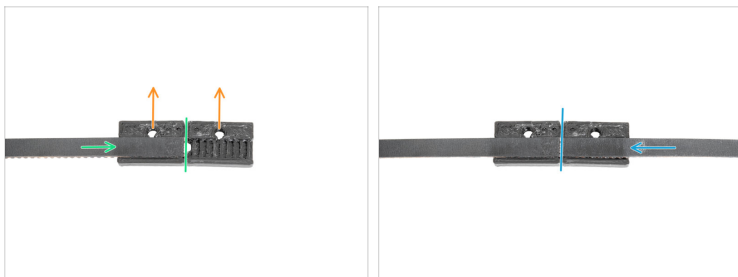
- Desde la parte frontal de la impresora:
- Using a shorter side of the 2.5 mm Allen key, pull gently the belt to create larger loop.
- Attach the loop on the motor pulley.
- Pull the belt to secure its position on the pulley.

PASO 111 Colocando la correa inferior: lado izquierdo



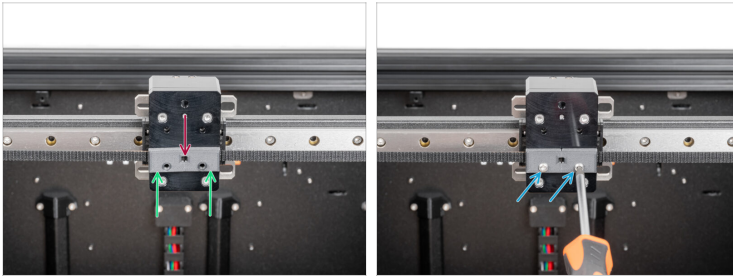
- i** When you pull on the belt you will feel more resistance from the XY motor, that's perfectly fine.
- Pull the belt some more and guide it behind the Y-carriage-left-base.
- Wrap the belt around the pulley on the front left side.
- Wrap the belt around the pulley in the Y-carriage-left-base.

PASO 112 Colocando la correa inferior: sujeción de la correa



- i** The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. The procedure is the same, please continue.
- i** This image has been taken outside the printer on a white background for better visibility and definition. Follow this step on your printer.
- Prepare one belt-clamp facing with the holes for the screws facing up.
- Attach the left end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- Attach the right end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- i** The belt-clamp with the belts will be turned by 180° and attached to the X-carriage.

PASO 113 Colocando la correa inferior: fijando la sujeción de la correa



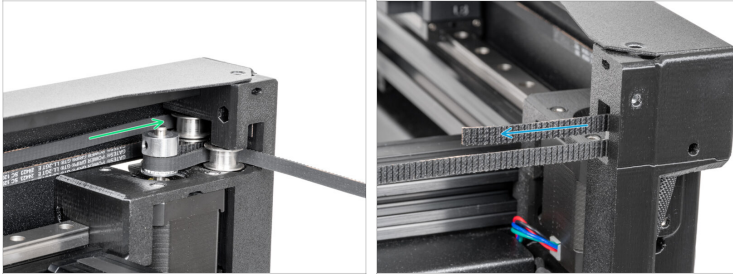
- Turn the prepared belt-clamp by 180° and attach the belt-clamp with the belts on the X-carriage.
- Check the belts if they are in their position. If not repair the position by the previous step.
- Insert two M3x12rT screws and secure them using a T10 Torx screwdriver.
- ¡Bien hecho! Uno de las correas está atornillada. Probemos con la segunda.

PASO 114 Colocando la correa superior: lado delantero izquierdo



- Desde la parte frontal de la impresora:
- Take the second belt.
- Insert the one end of the belt into the front upper section of the Y-carriage-left-base.
- The belt has to be facing toward the printer with the teeth showing (not the smooth side of the belt).
 - ① Comprueba dos veces que los dientes están orientados hacia la máquina.
- On the inner side of the Y-carriage-left-base pull the the belt.
- ① Don't pull the belt too much, it can fall out from the Y-carriage-left-base and the whole process of the belt attaching has to be repeated from the start.

PASO 115 Colocando la correa superior: lado trasero izquierdo



- Pull the belt more and insert it behind the upper pulley.
- Pull the belt, which is now inserted through the upper belt pulley.

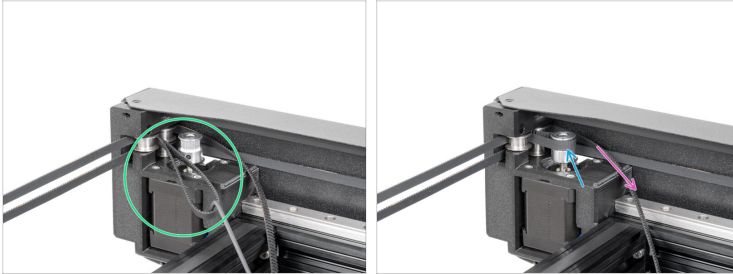
PASO 116 Colocando la correa superior: lado trasero derecho



i *Hint: For the simplest possible assembly, remove the fifth Nextruder **(for Five-head users only)** and place it on top of the box on the heating heatbed.*

- Pull the belt more and insert it behind the upper pulleys.
- Pull the belt, which is now inserted through the upper pulleys.
- From the rear side of the printer:
 - Insert the 2.5 mm Allen key through the hole to create a loop on the belt.
 - When the loop is created, you can remove the Allen key. Do not pull the belt!
- Continúa en el siguiente paso.

PASO 117 Colocando la correa inferior: fijando la correa de la polea del motor



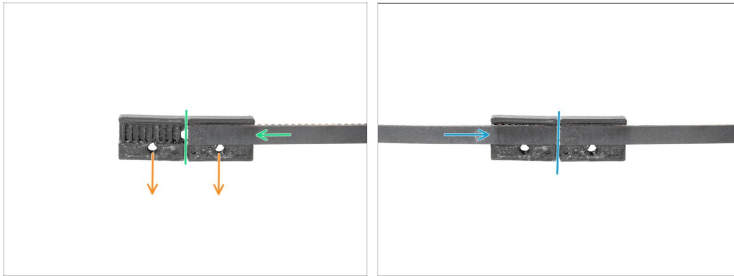
- Desde la parte frontal de la impresora:
- Using a shorter side of the 2.5 mm Allen key, pull gently the belt to create larger loop.
- Attach the loop on the motor pulley.
- Pull the belt to secure its position on the pulley.

PASO 118 Colocando la correa superior: lado derecho



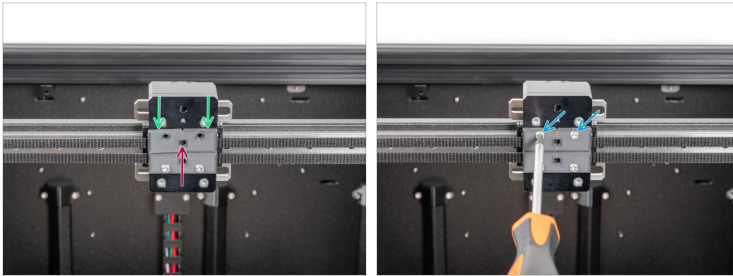
- i When you pull on the belt you will feel more resistance from the XY motor, that's perfectly fine.
- Pull more the belt and stretch the belt behind the Y-carriage-right-base.
- Pull the belt around the pulley on the right front side.
- Pull the belt around the pulley in the Y-carriage-right-base.

PASO 119 Colocando la correa superior: sujeción de la correa



- i** The color of the belt-clamps may be different depending on if you have an Original Prusa XL Enclosure. The procedure is the same, please continue.
- i** This image has been taken outside the printer on a white background for better visibility and definition. Follow this step on your printer.
- Prepare one belt-clamp facing with the holes for the screws facing down.
- Attach the right end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- Attach the left end of the belt to the belt-clamp. The end of the belt must be on half of the belt-clamp.
- i** The belt-clamp with the belts will be turned by 180° and attached to the X-carriage.

PASO 120 Colocando la correa inferior: fijando la sujeción de la correa



- Turn the prepared belt-clamp by 180° and attach the belt-clamp with the belts on the X-carriage.
- Check the belts if they are in their position. If not repair the position by the previous step.
- Insert two M3x12rT screws and secure them using a T10 Torx screwdriver.
- Well done! Both of the belts are fastened.

PASO 121 Belt tensioning



- On the front side of the printer:
- Using a 2.5mm Allen key, slightly tighten the M3 screw holding the left CoreXY tensioner.
- Using a 2.5mm Allen key, slightly tighten the M3 screw holding the right CoreXY tensioner.
- No tenses completamente la correa, procede con el siguiente paso, donde hay un video sobre el ajuste de la tensión de las correas.

PASO 122 Belt tensioning: video

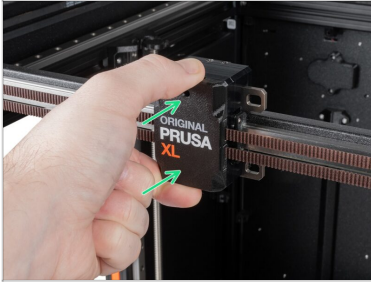
- En la Original Prusa XL, ajustar la correa a la tensión óptima es fundamental para conseguir una buena calidad en las impresiones. Una correa floja puede provocar desplazamientos de capas, imágenes fantasma u otras anomalías en la impresión, como obtener una forma irregular en lugar de un círculo perfecto. Una correa demasiado tensa puede provocar un movimiento irregular en los ejes X e Y.
- Tenemos nuestro propio afinador de correas. La aplicación determina la tensión de la correa midiendo la frecuencia de la vibración generada al tocarla. Sigue las instrucciones del vídeo a continuación para ajustar la correa.

PASO 123 X-carriage cover: preparación de las piezas



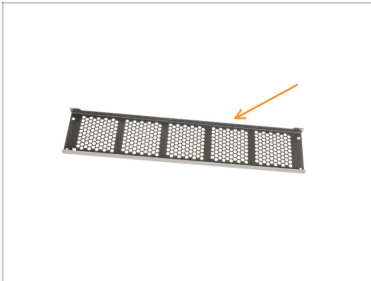
- **Para los siguientes pasos, por favor prepara:**
- X-carriage-cover (1x)

PASO 124 X-carriage cover attaching



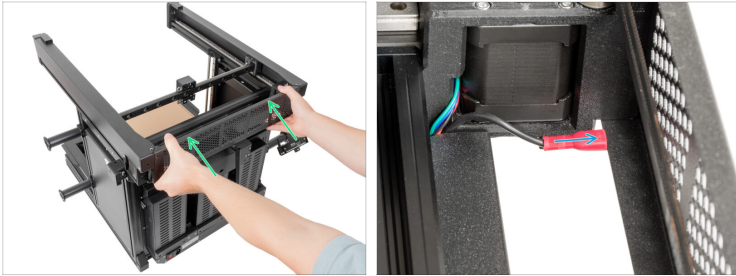
- Attach the X-carriage cover.

PASO 125 Cubierta CoreXY: preparación de las piezas



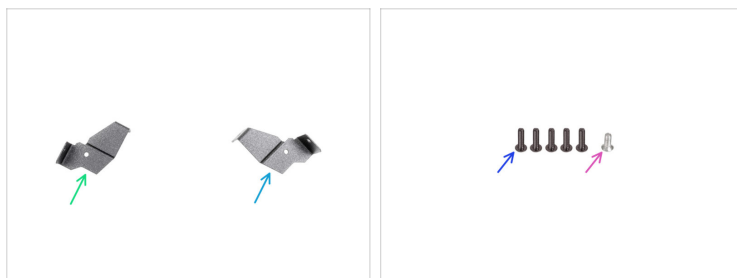
- Para los siguientes pasos, por favor prepara:
- CoreXY cover (1x)

PASO 126 CoreXY cover attaching



- Gently attach the CoreXY cover on the back of the CoreXY.
- On the inner side of the CoreXY cover, connect the PE connector.

PASO 127 Opcional: Soportes de fijación: preparación de piezas

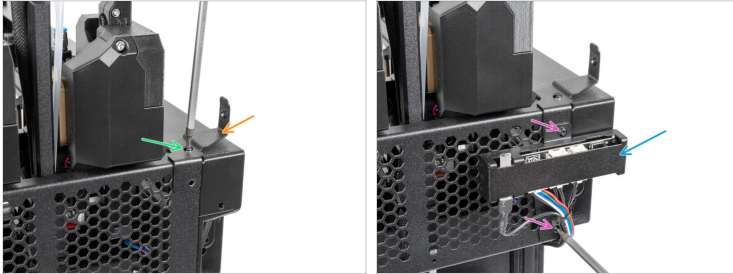


i The next steps are for users who have an Original Prusa XL Enclosure add-on, otherwise skip to the **CoreXY securing: parts preparation**

■ Para los siguientes pasos, por favor prepara:

- Soporte de fijación trasero izquierdo (1x)
- Soporte de fijación trasero derecho (1x)
- M3x10rT screw (5x)
- M3x6bT (1x)

PASO 128 Opcional: Asegurando la parte trasera izquierda



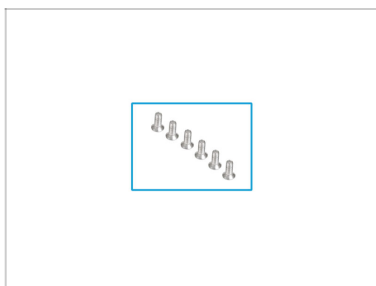
- Gira la impresora de modo que la parte trasera quede frente a ti.
- Fija el soporte de fijación trasero izquierdo.
- Fija el soporte de fijación trasero izquierdo con el tornillo M3x10rT.
- Gently attach the XL enclosure board assembly.
Don't pinch any cable!
- Fija el conjunto de la placa XL enclosure con dos tornillos M3x10rT.

PASO 129 Opcional: Asegurando la parte trasera derecha



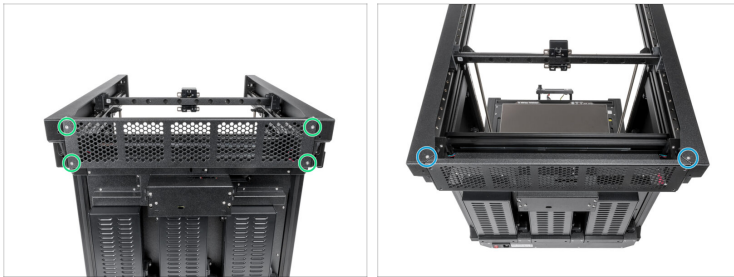
- Fija el soporte de fijación trasero izquierdo.
- Secure the fixing bracket rear left with two M3x10rT screws.
- Secure the M3x6bT screw using a T10 Torx screwdriver.

PASO 130 Asegurando la cubierta CoreXY: preparación de las piezas



- **Para los siguientes pasos, por favor prepara:**
- M3x6bT screws (6x) *removed in previous steps*

PASO 131 CoreXY cover securing



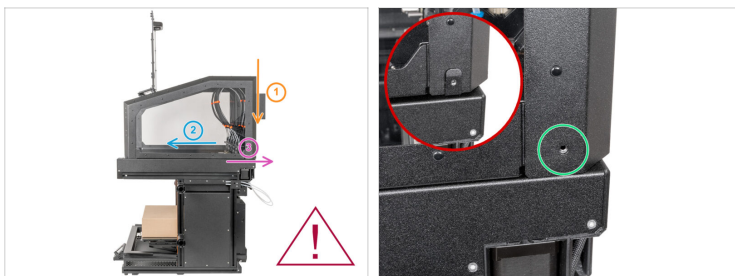
-  Insert four M3x6bT screws and tighten them using a T10 Torx screwdriver.
-  Insert two M3x6bT screws and tighten them using a T10 Torx screwdriver.
-  If you have an Original Prusa XL Enclosure, please proceed to the next step. Otherwise proceed to the **Installing the Wi-Fi antenna**.

PASO 132 Optional: Enclosure preparing



- En el Cerramiento ensamblado, abre la tapa.
- Sujeta el cerramiento por la parte delantera, donde se encuentra la placa de soporte.
- Sujete el cerramiento por la parte posterior, donde se encuentra la tapa de filtración.

PASO 133 Optional: Enclosure attaching



⚠ Para este paso, llama a alguien para que te ayude a colocar el cerramiento a la impresora.

⚠ **No pellizques ningún cable del Cerramiento.**
¡Cuidado con los cables!

● Fija con cuidado el cerramiento a la impresora en tres pasos:

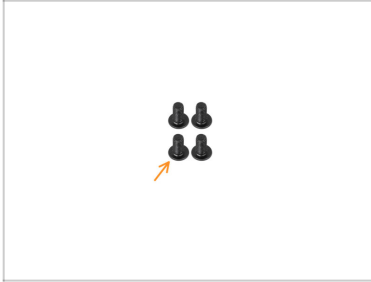
● 1. Coloca el cerramiento en la impresora.

● 2. Empuja el cerramiento hacia la parte delantera de la impresora.

● 3. Empuja el cerramiento hacia la parte posterior de la impresora.

● Alinea los agujeros para los tornillos.

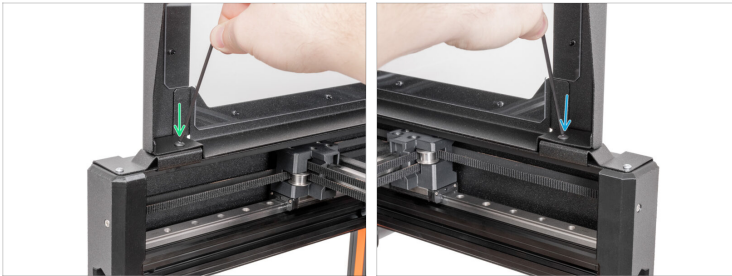
PASO 134 Opcional: Asegurando el cerramiento: preparación de las piezas



● Para los siguientes pasos, por favor prepara:

● M4x8r screw (4x)

PASO 135 Opcional: Asegurando la parte delantera



● Desde la parte frontal del cerramiento:

● Fija la esquina inferior izquierda con un tornillo M4x8r al fixing-bracket-front-left utilizando una llave Allen de 2.5 mm.

● Fija la esquina inferior derecha con un tornillo M4x8r al fixing-bracket-front-right utilizando una llave Allen de 2.5 mm.



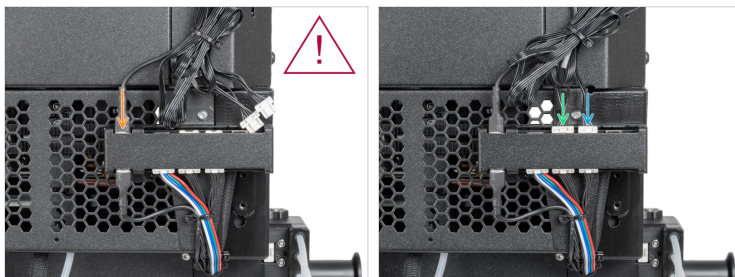
Cierra la tapa. Esto evita que la tapa se cierre por gravedad durante la manipulación.

PASO 136 Opcional: Asegurando la parte trasera



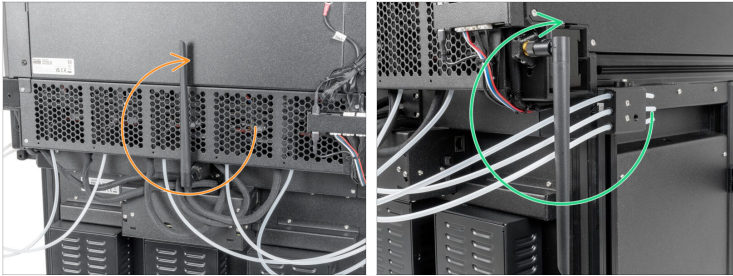
- From the rear side of the printer:
- Fija la esquina inferior izquierda con un tornillo M4x8r al fixing-bracket-back-right utilizando una llave Allen de 2.5mm.
- Fija la esquina inferior izquierda con un tornillo M4x8r al fixing-bracket-back-left utilizando una llave Allen de 2.5 mm.

PASO 137 Opcional: Conexión de los cables del Cerramiento



- 🟡 Attach the PE faston to the connection box.
- ⚠️ **Asegura completamente el cable PE a la XL Enclosure board cover.**
- 🟢 Coje el cable del LED (5 hilos) y conecta el extremo del cable al conector izquierdo del divisor del FDM XL Enclosure.
- 🟠 Coje el cable del ventilador (4 hilos) y conecta el extremo del cable al conector derecho del divisor del FDM XL Enclosure.

PASO 138 Rotando la antena Wi-Fi



- Wi-Fi antenna on the back of the printer:
 - Turn the back antenna upwards.
- Wi-Fi antenna on the side of the printer:
 - Turn the side antenna upwards.

PASO 139 Printer connecting



- Enciende el interruptor (símbolo "I").
- From the rear side of the printer, plug the PSU cable.

PASO 140 Good job



Well done, the printer is ready.

[illegible]

[illegible]

[illegible]
