

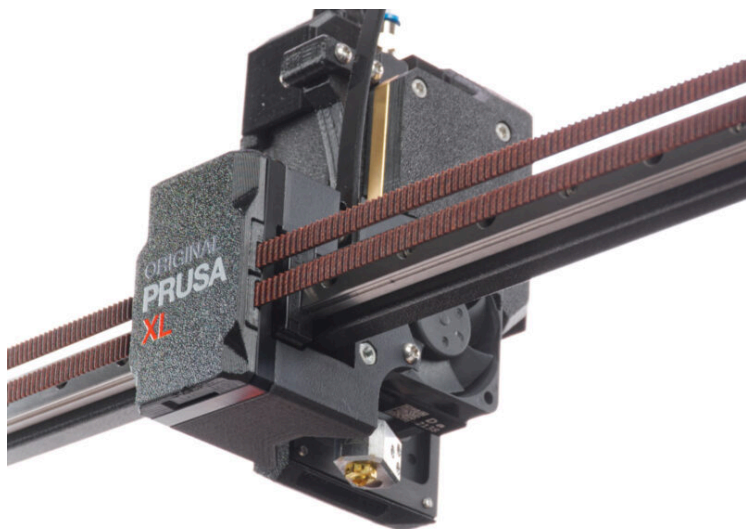
# Table of Contents

## How to install the Nextruder V6 Nozzle Adapter

<b>(XL single-tool)</b> .....	3
Step 1 - Introduction .....	4
Step 2 - Tools necessary for this chapter .....	5
Step 3 - Preparing the printer .....	6
Step 4 - Cleaning the hotend .....	7
Step 5 - Preparing the printer .....	8
Step 6 - Disconnecting the hotend .....	9
Step 7 - Removing the hotend .....	10
Step 8 - Removing the Prusa Nozzle .....	11
Step 9 - Installing the V6 nozzle: parts preparation .....	11
Step 10 - Installing the Nextruder V6 Nozzle Adapter .....	12
Step 11 - Connecting the hotend .....	13
Step 12 - Tightening the nozzle .....	14
Step 13 - Tightening the hotend assembly .....	15
Step 14 - It's done .....	16



# How to install the Nextruder V6 Nozzle Adapter (XL single-tool)

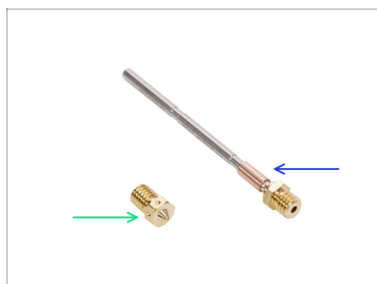


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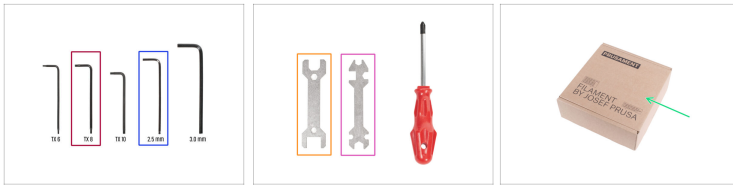


## STEP 1 Introduction



- ◆ This guide will take you through the installation of the **Nextruder V6 Nozzle Adapter** on the **Original Prusa XL**.
- ⓘ For the installation of the **Nextruder V6 Nozzle Adapter** on the **Original Prusa MK4** go to the dedicated guide: [How to install the Nextruder V6 Nozzle Adapter \(MK4\)](#)
- ◆ V6 nozzle is available in our eshop [prusa3d.com](#).
- ⓘ The following instructions are compatible with all V6 nozzle diameters.
- ◆ Nextruder V6 Nozzle Adapter is available in our eshop [prusa3d.com](#).
- ⓘ Note that you have to be logged in to have access to the spare parts section.

## STEP 2 Tools necessary for this chapter



● **For this chapter, please prepare:**

- TX 8 Torx key
- 2.5mm Allen key
- Wrench 13-16
- Universal wrench
- A cardboard box for use as a heatbed protection during the assembly. *Hint: use the Prusament box.*
- Small brass brush *for cleaning the nozzle*

## STEP 3 Preparing the printer



- Manually move the X-axis assembly all the way to the front side of the printer.
- Move the extruder approximately to the center of the X-axis.
- If you have loaded the filament, unload it from the hotend. On the screen, navigate to *Filament* -> *Unload Filament*.
- ⚠ **WARNING: The hotend and heatbed are very HOT. Do not touch these parts!!!**
- Remove the filament from the hotend. It is not necessary to completely remove it from the printer. Just a few centimeters (inches) above the extruder.

## STEP 4 Cleaning the hotend



**⚠ WARNING: The hotend and heated are very HOT. Do not touch these parts!!!**

**i** For the following steps, it is necessary to have the heaterblock and the hotend clean from the remains of the filament. Otherwise, it can be difficult to release the nozzle.

**⚠** If you have a Prusa hotend sock on the hotend, remove it.

🟡 On the printer screen, go to *Control* -> *Temperature* and set the nozzle temperature to 250°C.

⬛ Wait at least 5 minutes. The remains of the filament must be warmed up slightly so that they can be removed more easily.

🟠 Using the brass brush, carefully clean the heaterblock and the hotend from the filament residue. **Avoid contact of the brush with the hotend cables, as this could cause a short circuit.**

🟢 When the heaterblock and the hotend are perfectly clean, cool down the printer. On the screen, navigate to *Preheat* -> *Cooldown*.

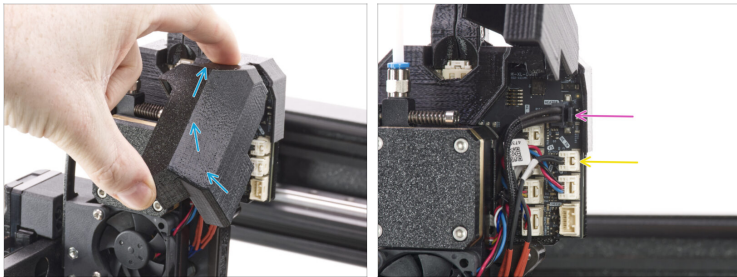
**⚠ Wait until the hot parts are cooled down to ambient temperature. It takes approximately 10 minutes.**

## STEP 5 Preparing the printer



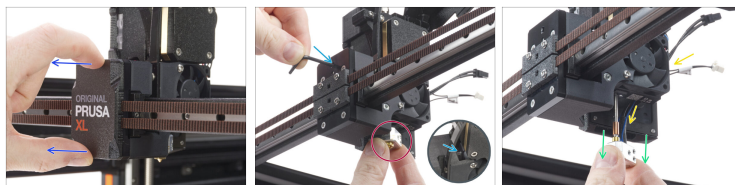
- (i)** Before you proceed, it is recommended to protect the heatbed.
- Make sure the heatbed is cooled down to ambient temperature. Place the empty cardboard box approximately to the front center part of the heatbed.
- From the rear side of the printer, turn the power switch OFF (symbol "O").
- Unplug the PSU cable.

## STEP 6 Disconnecting the hotend



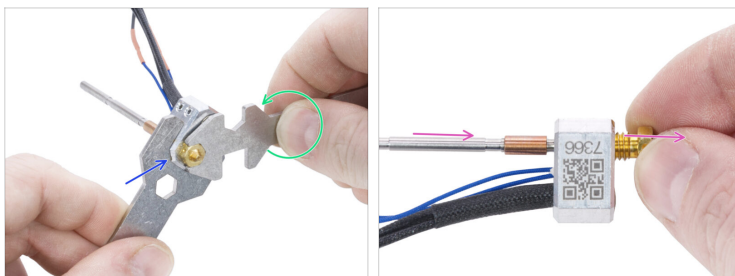
- ◆ Open the dwarf-cover-door to access the electronics board.
- ◆ Disconnect the hotend thermistor cable.
- ⚠ **Each connector has a safety latch. It is necessary to press the latch before disconnecting. Otherwise, the connector may get damaged.**
- ◆ Disconnect the hotend heater cable.
- ◆ Leave both cables free for now.

## STEP 7 Removing the hotend



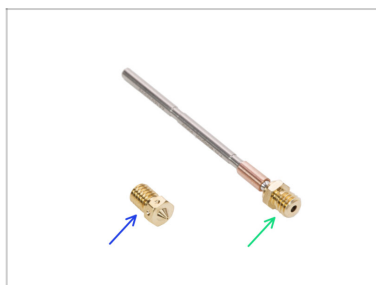
- ◆ Remove the x-carriage-cover from the X-carriage.
- ◆ Hold the hotend with your right hand.
- ◆ Using your left hand, insert the Torx TX 8 key all the way through the X-carriage until it reaches the grub screw in the extruder. Loosen the screw. **Do not remove the screw**, a few turns are enough!
- ◆ Carefully pull the hotend assembly out of the extruder.
- ◆ At the same time push the hotend cables behind the fan out of the extruder.

## STEP 8 Removing the Prusa Nozzle



- ◆ Using the 13mm cutout in Universal wrench X grasp the heaterblock.
- ◆ Using the 7mm cutout in the Universal wrench Y grasp the nozzle and loosen it.
- ◆ Manually release and remove the nozzle with nub from the hotend assembly.

## STEP 9 Installing the V6 nozzle: parts preparation



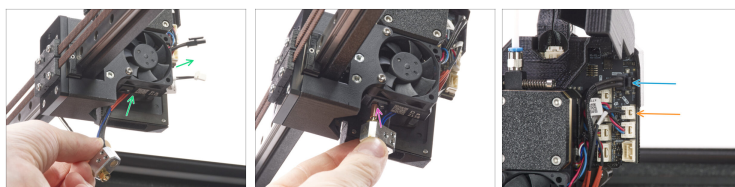
- ◆ **For the following steps, please prepare:**
- ◆ Nextruder V6 Nozzle Adapter (1x)
- ◆ V6 Nozzle (1x)

## STEP 10 Installing the Nextruder V6 Nozzle Adapter



- From the side with cables, screw the Nextruder V6 Nozzle Adapter to the heaterblock.
- Hold the heaterblock in your hand and tighten the Nextruder V6 Nozzle Adapter by the universal wrench.
- From the opposite side of the heaterblock, screw in the V6 nozzle. **Do not tighten it completely.** Leave a 2 - 3 mm gap between the nozzle and heaterblock.
- ⓘ The final tightening of the nozzle will proceed later. Please continue to the next step.

## STEP 11 Connecting the hotend



- ◆ Push the hotend cable behind the heatsink fan up to the electronics.
- ◆ Locate the hole in the heatsink from the bottom of the extruder and insert the hotend nub into the heatsink.
- ⚠ **Do not tighten the grub screw to secure the hotend yet! Wait for the instruction.**
- ◆ Connect the hotend heater to the upper slot on the electronics board.
- ◆ Connect the hotend thermistor to the lower slot on the electronics board.
- ◆ Keep the hotend assembly hanging on cables. **Avoid to pulling on the hotend.**

## STEP 12 Tightening the nozzle



- ⚠ In the following steps, we will need to heat up the nozzle. **Avoid touching the HOT parts on the hotend.**
- ⚠ **Remove the cardboard box from the heated!**
- ⬛ Plug the power cord to the printer and turn it ON.
- 🟡 On the printer screen, go to *Control* -> *Temperature* -> *Nozzle Temperature* and using the knob set **250°C**.
- ⚠ **WARNING: From now, the hotend and heated are very HOT. Do not touch these parts!!!**
- 🟡 Grasp the heaterblock with the wrench 13-16. **Avoid pulling on the hotend!**
- 🟢 Tighten the nozzle using the universal wrench. **Do not overtighten it, you can damage the thread.** Use the sufficient force. The prescribed tightening torque is 1.5 Nm.
- ⚠ **NOTE: Avoid bending the hotend assembly while tightening!** After that, there will be a gap of approximately 1 mm between the nozzle and the heater block.

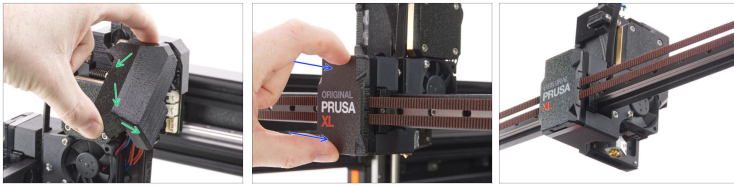
## STEP 13 Tightening the hotend assembly



- ❖ Cool down the printer. Go to *Preheat* -> *COOLDOWN*.
  - ❖ **Wait until both temperatures drop below 35°C.** It may take about 10 minutes. See the status bar at the bottom of the screen.
  - ❖ **Make sure, the hotend is cooled down.** Push the hotend assembly all the way in.
  - ❖ Rotate the heaterblock as in the picture. There must be approximately 35° - 40° angle to avoid damaging the hotend cables.
  - ❖ Maintain the position and using the TX 8 Torx key carefully tighten the grub screw to secure the hotend.
- ⚠ **Do not use extra force while tightening, it may damage the hotend tube.**

## How to install the Nextruder V6 Nozzle Adapter (XL single-tool)

### STEP 14 It's done



- ◆ Close the dwarf-cover-door.
- ◆ Snap the x-carriage-cover back onto the X-carriage. You must feel a slight "click" to ensure the cover fits on the part.
- ◆ **That's it, good job!** You just successfully installed the V6 nozzle on your Original Prusa XL.



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