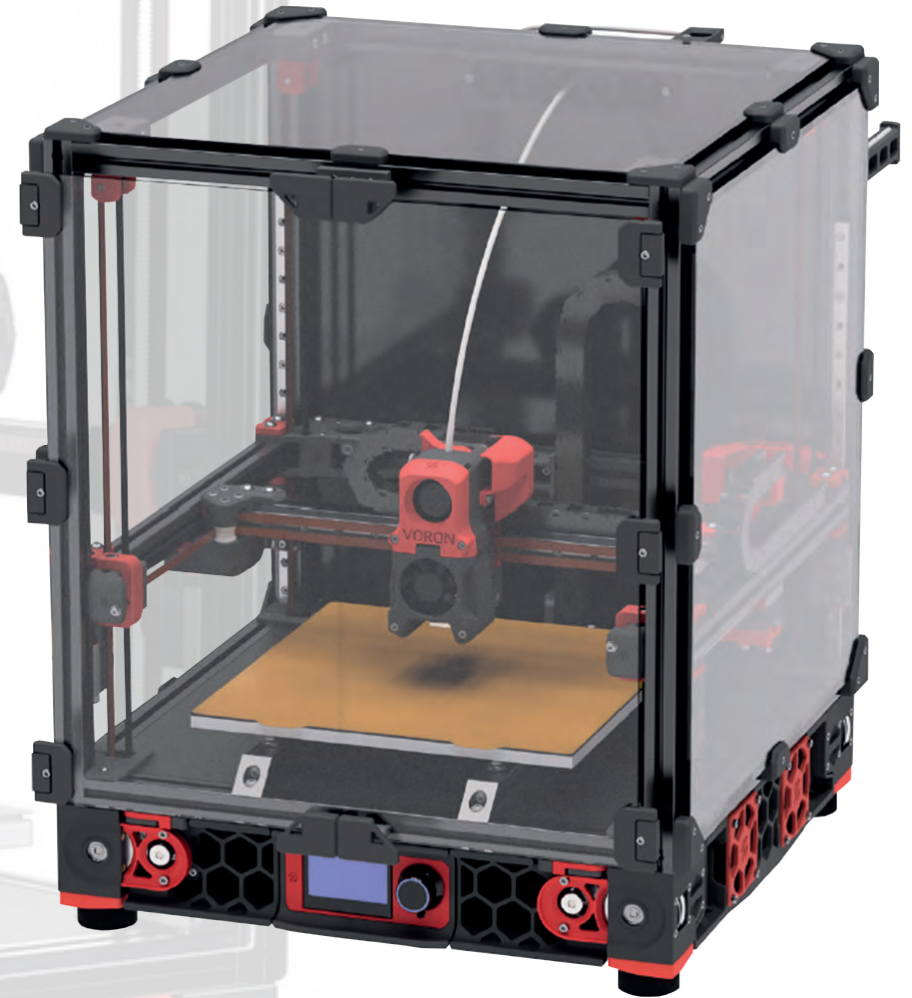




VORON 2.4

KIT 2

- ALUMINIUM CAST HIGH PRECISION GROUND
- HEAT BED
- MAGNETIC SHEET WITH PEI





Before you begin on your journey, a word of caution.

In the comfort of your own home you are about to assemble a robot. This machine can maim, burn, and electrocute you if you are not careful. Please do not become the first VORON fatality. There is no special Reddit flair for that.

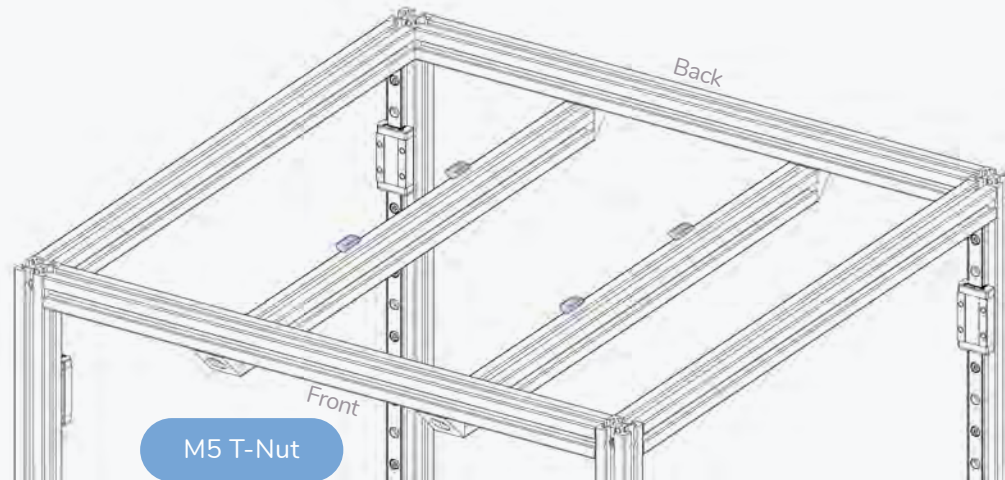
Please, read the entire manual before you start assembly. As you begin wrenching, please check our Discord channels for any tips and questions that may halt your progress.

Most of all, good luck!

THE VORON TEAM

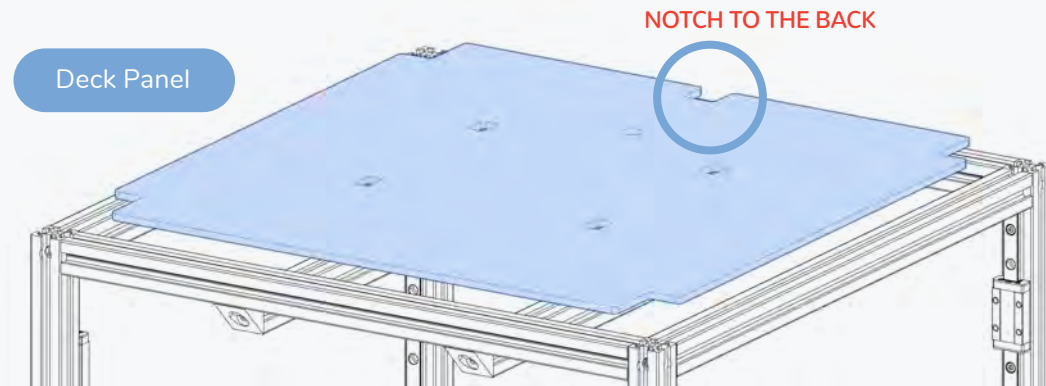
DECK PANEL

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FLIP PRINTER UPSIDE DOWN

It's easier working with gravity than against it. But make sure the rail carriages are secure before doing so.



DECK PANEL

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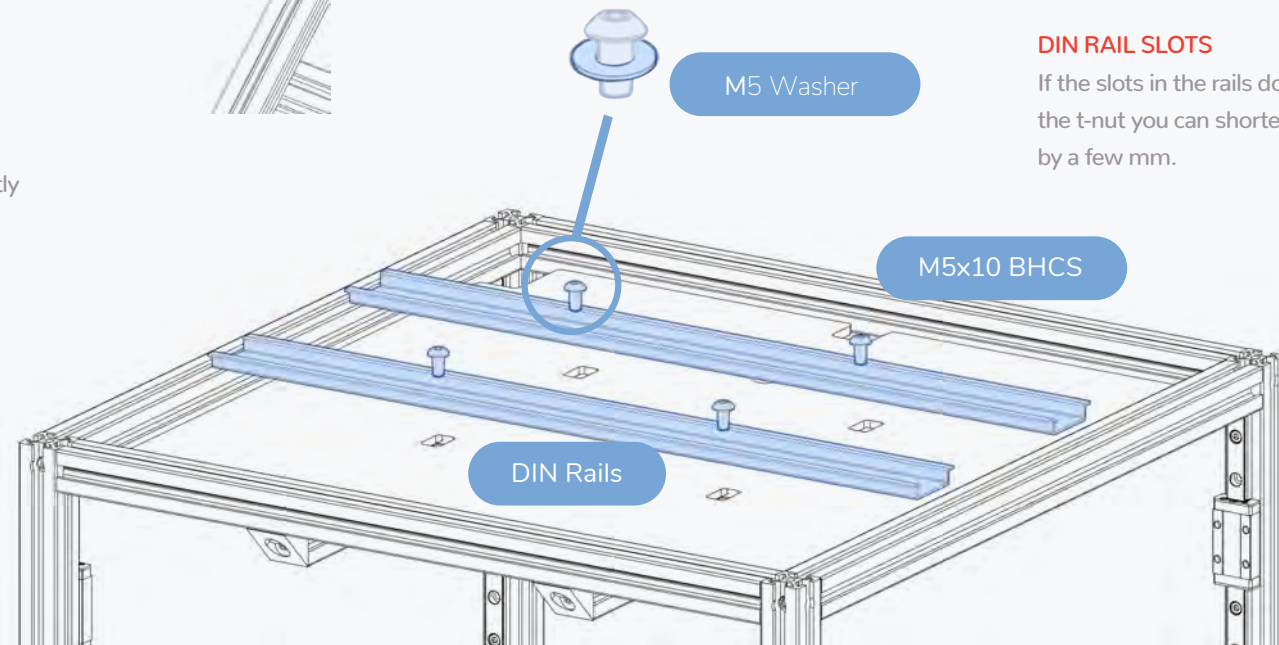


ALIGN T-NUTS WITH HOLES

Position the 4 T-nuts so they are directly below the 4 holes in the deck panel.

OPTIONAL

The M5 washer are to be used if there is space left between the paneling and DIN bars. If this space were to remain, the paneling and DIN bars could move.



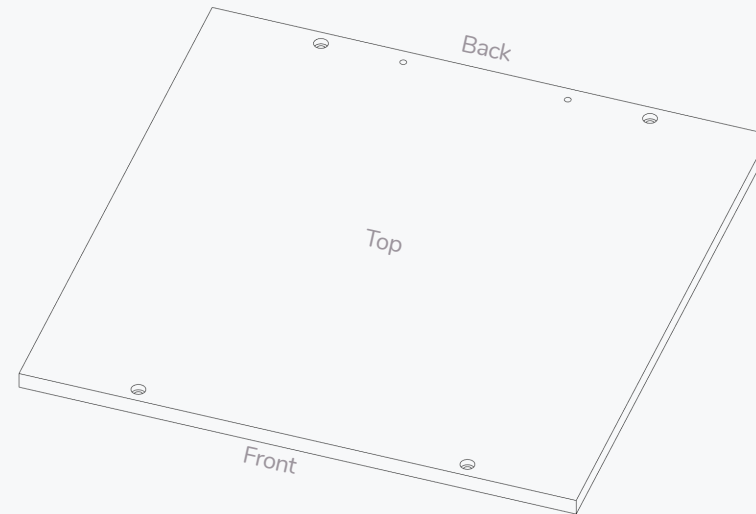
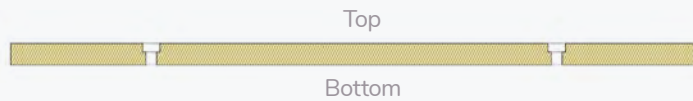
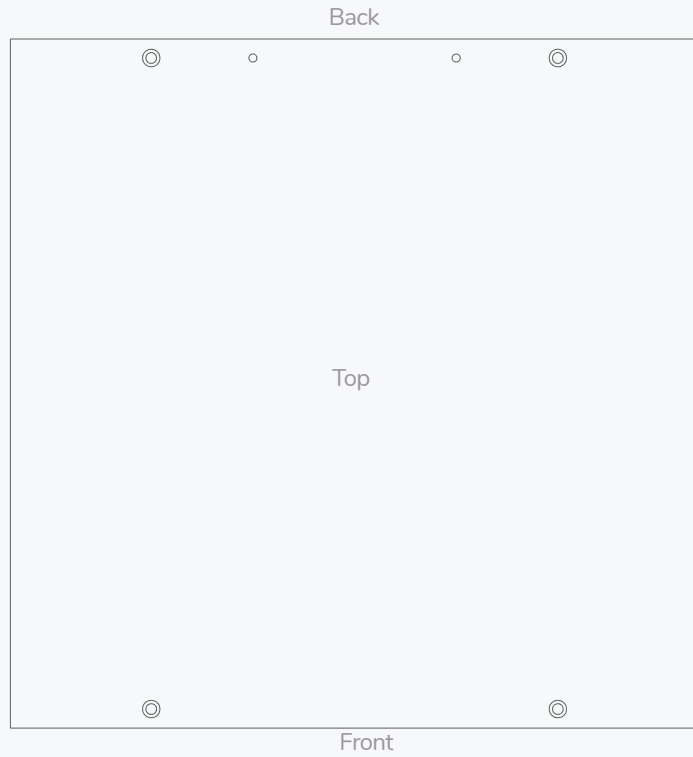
DIN RAIL SLOTS

If the slots in the rails do not line up with the t-nut you can shorten the DIN rails by a few mm.

PRINT BED

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WHICH SIDE IS WHICH?

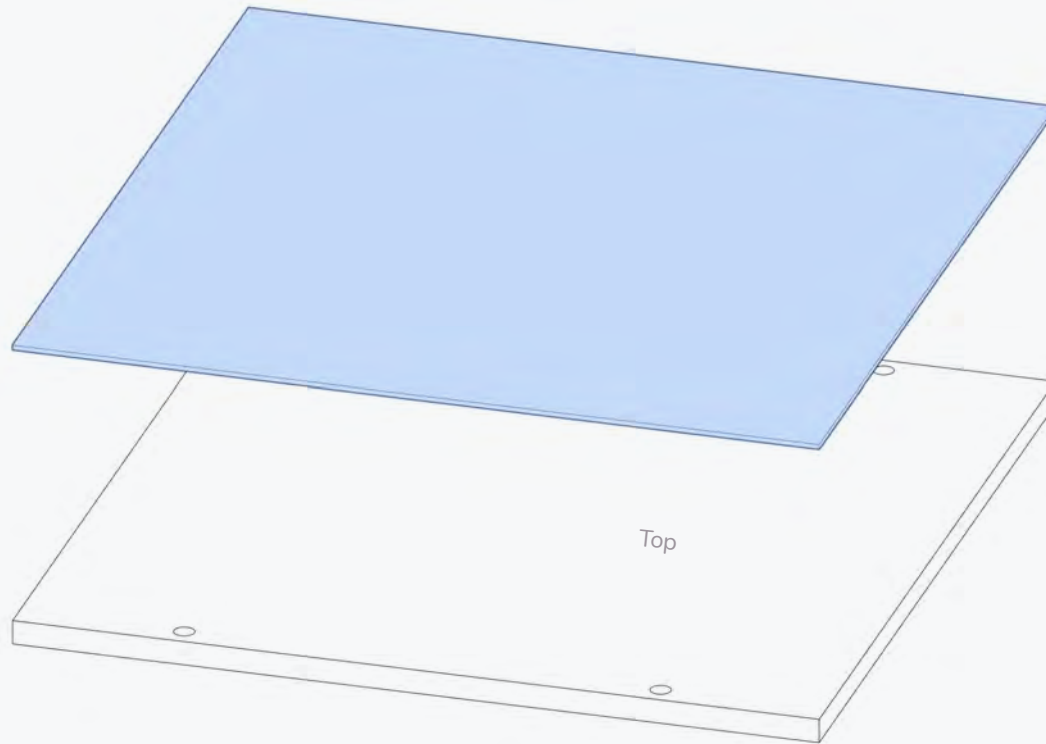
The top of the plate has mounting holes with bores that allow boltheads to sit flush/below the surface.

The plate has additional tapped holes to secure the Protective Earth (PE) connection and a thermal fuse, those are on the back side of the plate.



HEATED BED

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MAGNET APPLICATION

Remove any protective film if present on the aluminium plate.

Clean the plate with isopropyl alcohol or similar cleaner prior to applying the magnet.

Use the edge of a plastic object or a small roller to firmly press the magnet on the plate to get a good bond from the adhesive backing.

If you have never done this before we recommend you watch the linked guide.

Note:

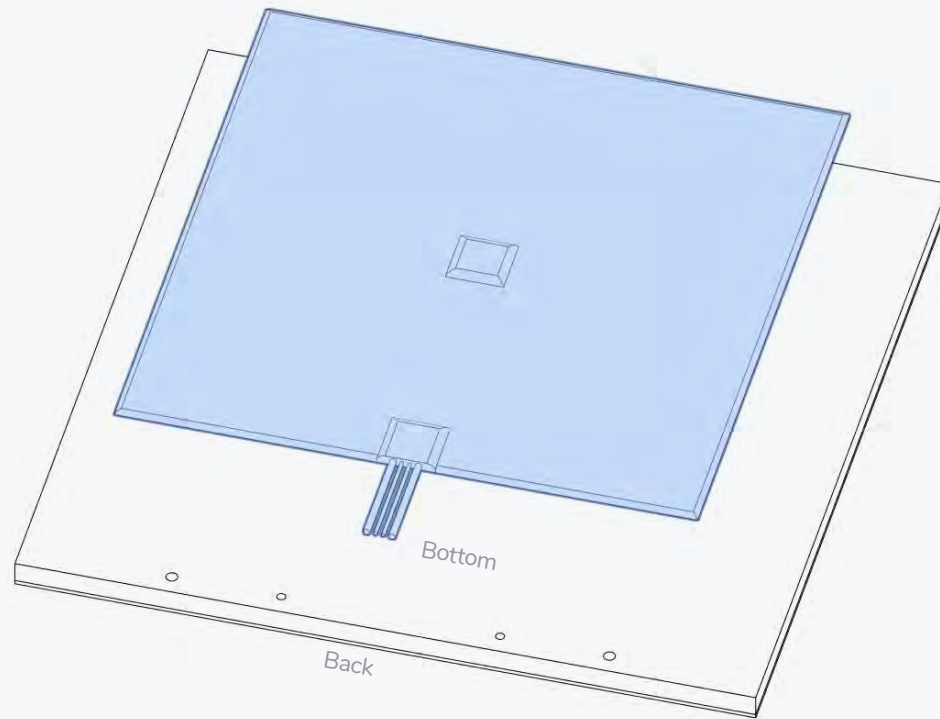
Slots can be made with a cutter to access the mounting holes in the aluminium plate.



<https://voron.link/rm6tpld>

HEATED BED

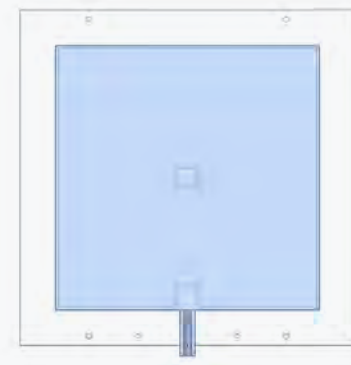
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HEATER APPLICATION

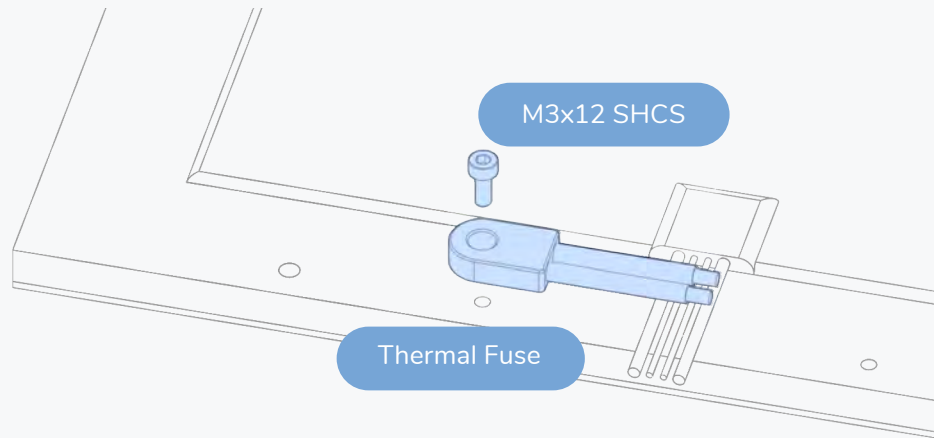
The heater is installed in the same fashion as the magnet.

Centre it on the bottom side of the build plate and make sure to firmly press it on the build plate.



HEATED BED

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THERMAL FUSE

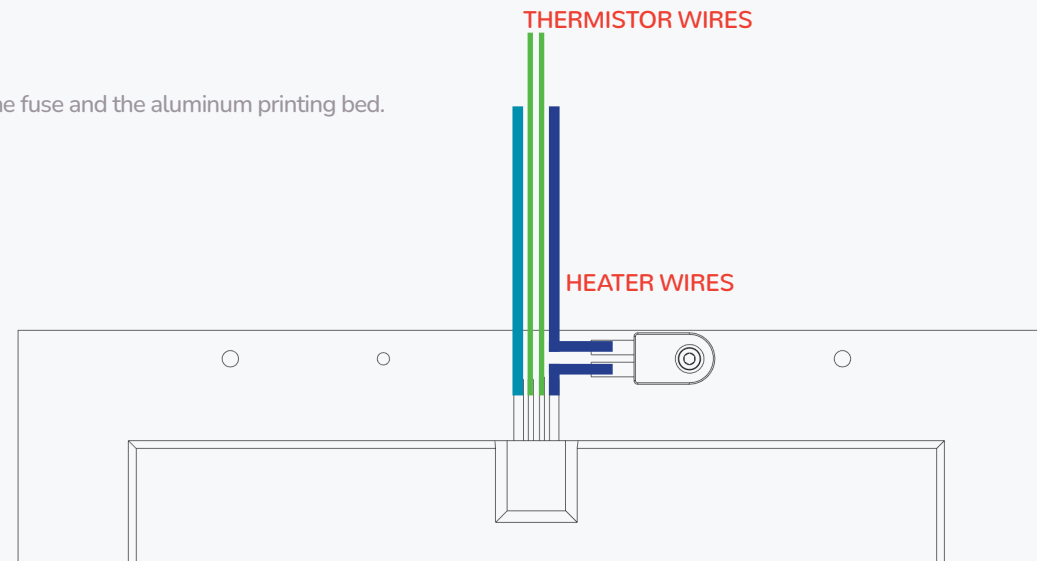
While not required to operate the printer, a thermal fuse attached to the build plate adds an additional layer of protection against potentially dangerous malfunctions.

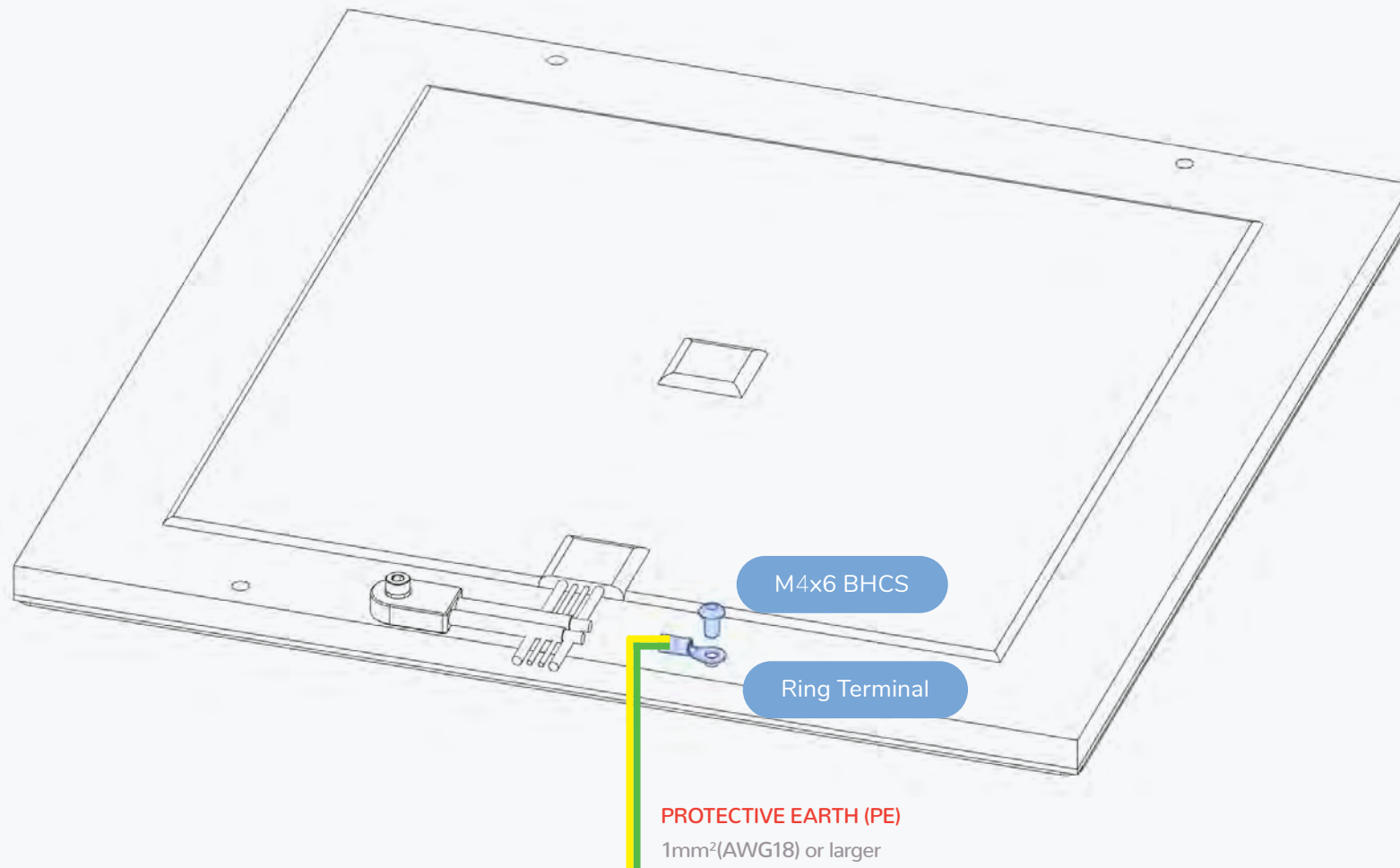
The thermal fuse is wired in-line with the heater wires.

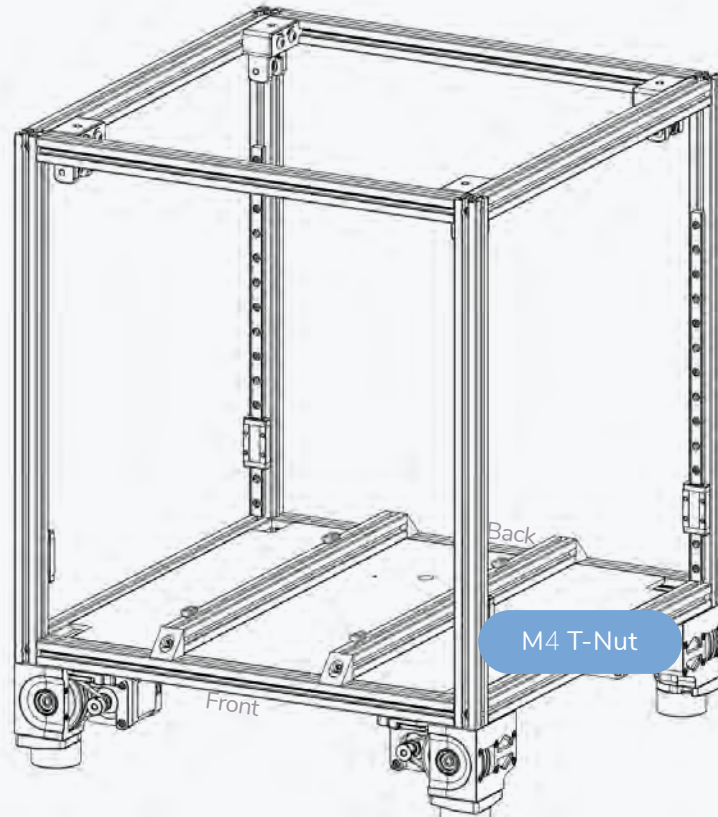
Depending on the tapped holes in the plate you may need to use a shorter bolt.

OPTIONAL:

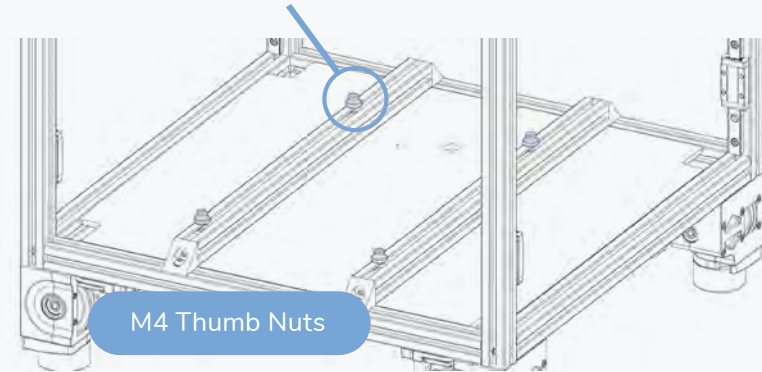
You can put thermal paste between the fuse and the aluminum printing bed.





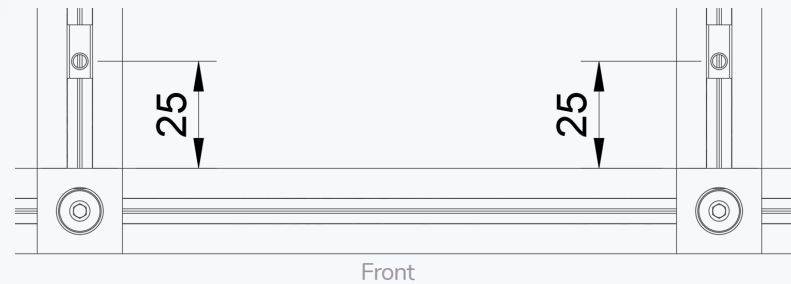


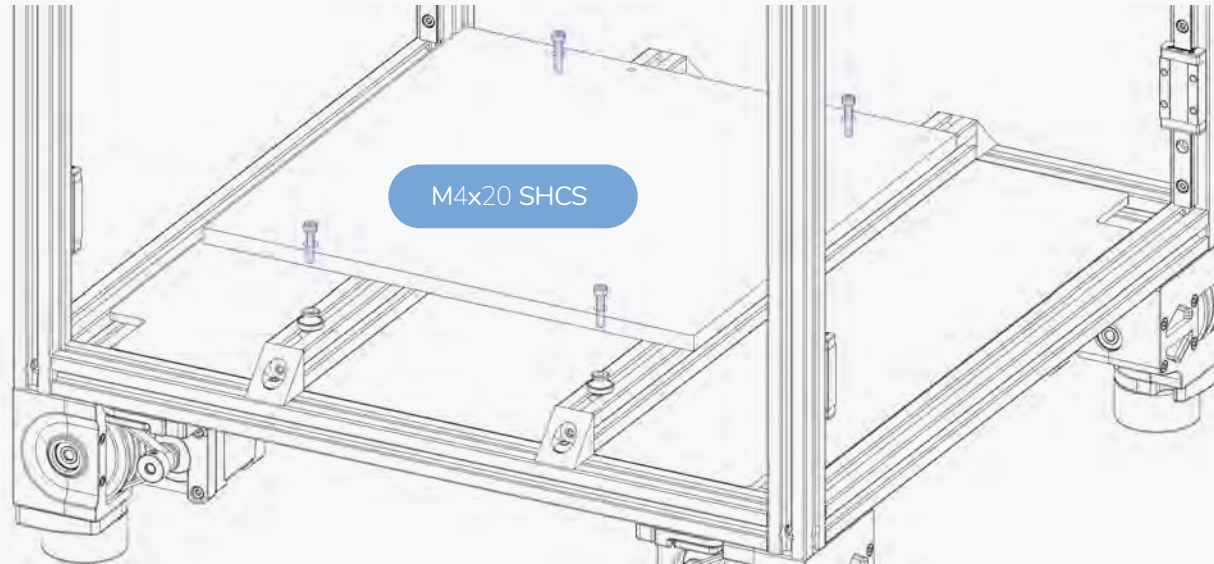
If the profiles do not already arrive smooth on the inside, drill through them from the $\varnothing 4$ mm drill bit.



M4 NUT FOR A M3 BOLT?

We use the thumb nuts as spacers. You can replace them with different heat resistant spacers of the same length.



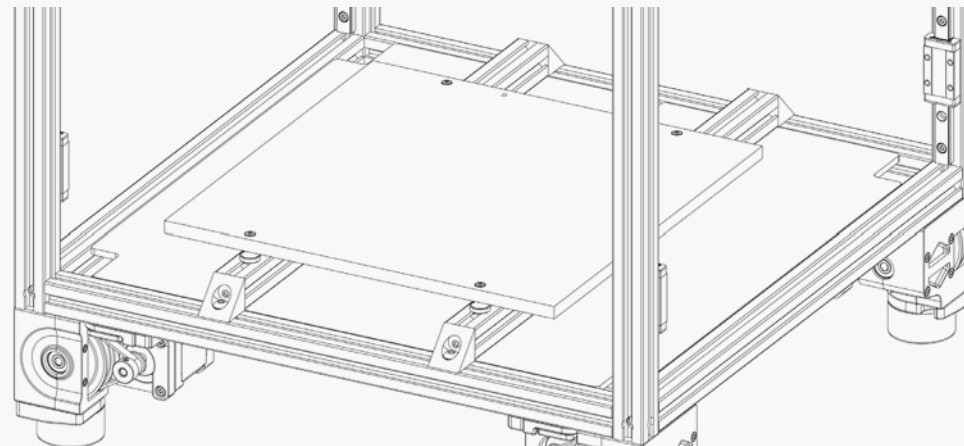


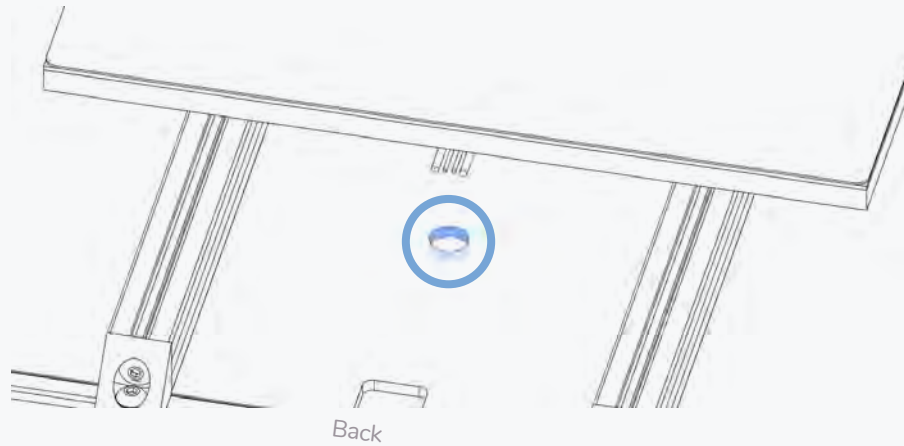
BED AND SPACER THICKNESS

Depending on the combination of bed and spacer thickness you may need to use longer bolts to secure the bed.

DON'T TIGHTEN

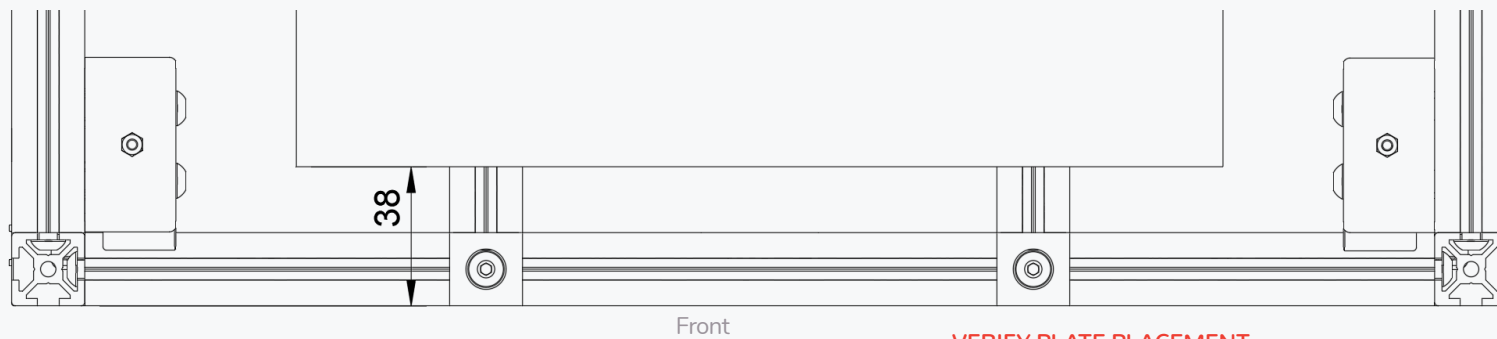
Only tighten one bolt fully.
Leave the remaining bolts slightly loose.
This will allow for thermal expansion without putting additional stress on the plate.





WIRE PASSTHROUGH

Feed the bed related wires through the opening in the deck plate.



VERIFY PLATE PLACEMENT

The front edge of the print plate should sit 38mm behind the front edge of the frame.