

Phæetus®



**Dragonfly HIC
Hotend Assembly
Instructions**

Please read and keep this manual
carefully before using our products

Product Appearance

Exclusive Choice for High Configuration



Thank you for buying Phaeetus'
Dragonfly HIC Hotend.

Product Features

**Integrated
welding nozzle**

**Longer nozzle
and heat block**

**Side envelope
surface fixed
structure**

**0.25mm
thin-walled
heat break**

Compatible Filaments

Compatible with all filaments, including: PLA, ABS, PETG, TPU, PP, PC, Nylon, PEEK, PEI and composite materials containing abrasive additives, such as carbon fiber, steel, wood, boron carbide, tungsten and phosphorescent pigment.

Specifications

Product Name: Dragonfly® HIC

Product Size: 26.0mm*21.0mm*57.5mm

Nozzle Diameter: Can be matched
arbitrarily

Color: Blue / Black

Product Net Weight: HIC 70g

Parts & Accessories



Hexagon Bar (1.27/1.50/2.00 each)

H7.0 Open - Ended Wrench *1pcs

M3.0 Flat Head Screw *2pcs

M1.4 Cup Head Screw *2pcs

M3 Semicircle Head Screw *2pcs

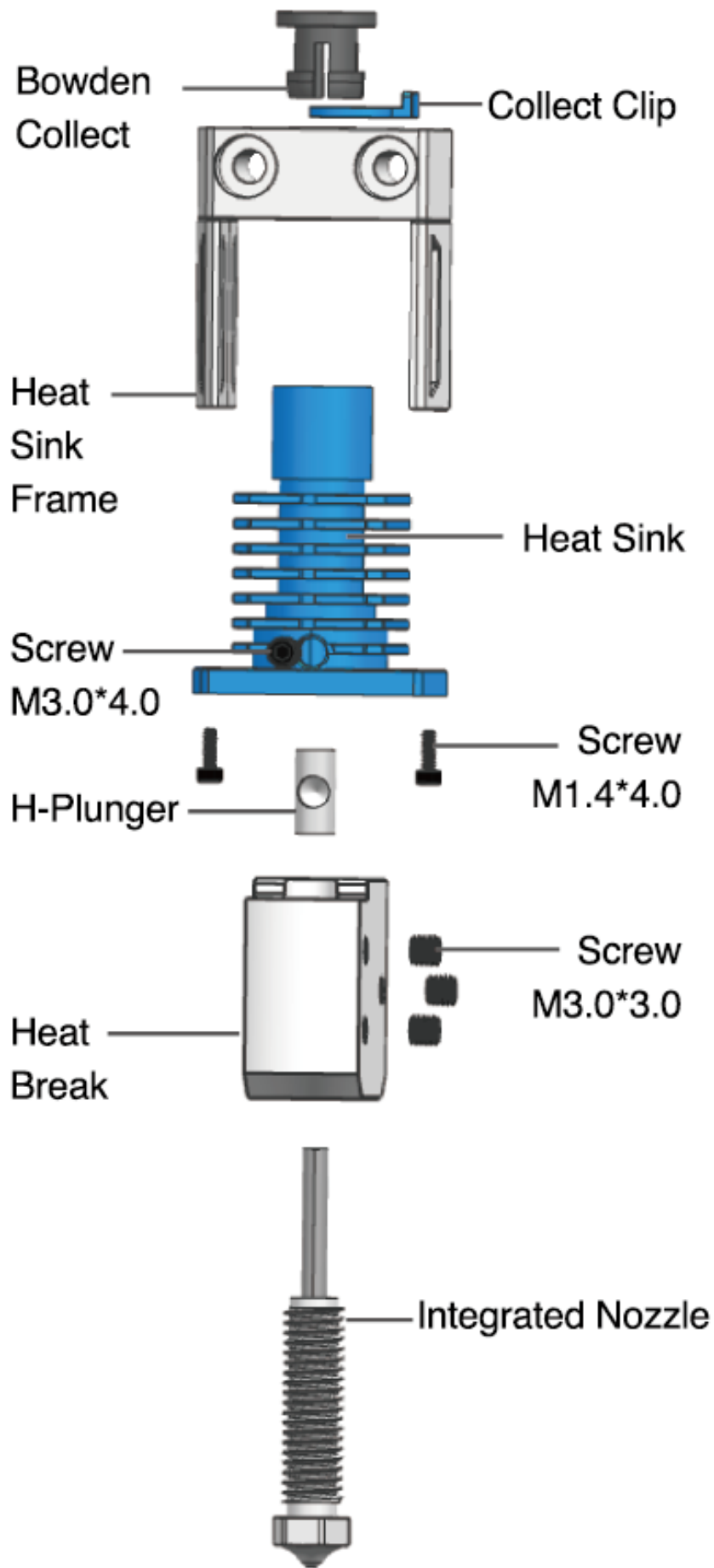
Collect Clip *1pcs

Bowden Collect *1pcs

Brass Tube *1pcs (Compatible with
NTC thermistor)

Black Silicone Sock *1pcs

Product Exploded View



Product Advantage

- Integrated welding nozzle: higher strength, better sealing, free from leakage
- Longer nozzle and heat block: larger melting cavity, suitable for high flow and high speed printing
- Super high flow rate, 67.31mm³/s
- Heat break kit adopts side envelope surface fixed structure: stable and reliable with the possibility of quick replacement
- 0.25mm wall thickness heat break: excellent heat insulation, no filament blocking
- Copper alloy / hardened steel material, meet high temperature, wear-resistant material printing
- Brass nozzles / Hardened steel nozzles / Plated copper nozzles support high temperature, wear-resistant filament printing

Supported 3D Printer Models

Dragonfly HIC Hotend is compatible with the following models (including but not limited to) :

HIC	CR-10 CR-10S series CR-10 MINI CR-20 CR-20 Pro Ender 2 / Ender 3 Ender 3 V2 Ender 3 Pro Ender 5 Ender 5 Plus Ender 5 Pro
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Important Note:

1. Please remember to move the Z-axis limit switch up about 8.4mm
2. Please remember to move the air outlet of the cooling fan down about 8.4mm

Phæetus®

欢迎使用

Welcome

Bienvenu

Willkommen

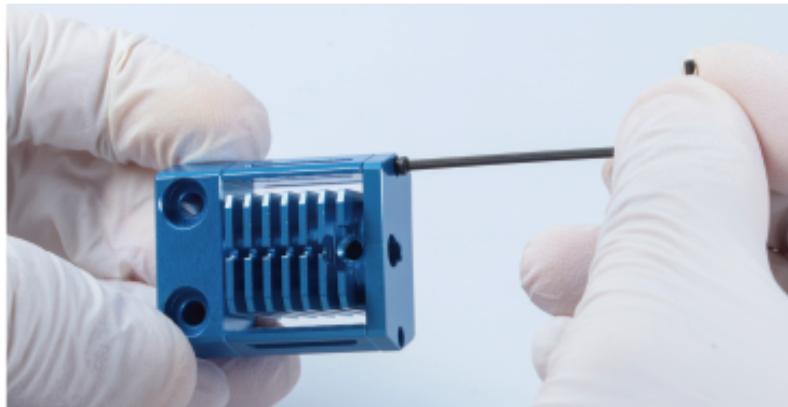
Bienvenida

Välkommen

This user guide helps you get started
using Dragonfly Hotend
And discover all the amazing things it
can do on a 3D printer

Assembly Steps

1. Assemble the heat sink frame and the heat sink together through the cylindrical surface at the top of the heat sink, and lock them up within two M1.4 screws through the two holes at the bottom of the heat sink by using H1.27 hexagonal bar.

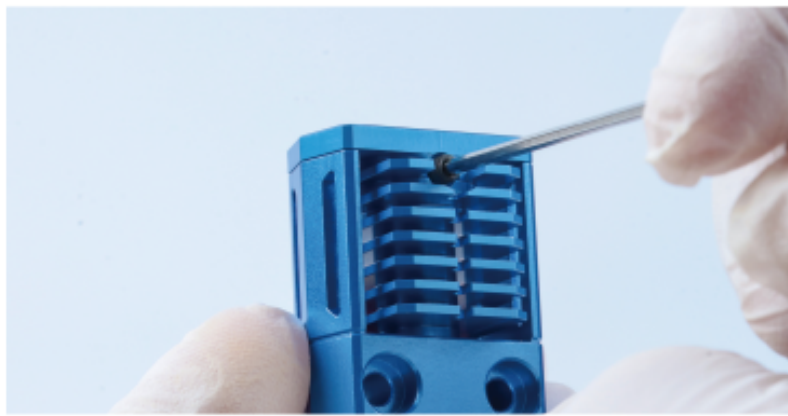


2. Embed the bowden collect into the top of the assembled heat sink, then insert the collect clip in between the bowden collect and the heat sink to fix the bowden collect.



3. Assemble the plunger into the larger hole at the bottom of the heat sink, and screw the flat head screw M3.0*4.0 into the threaded hole on the heat sink with the H1.5 hexagonal bar (no need to locking), so that the plunger won't fall off. Please note that the hole on the plunger should be directly opposite to the threaded hole on the front of the heat sink, which would ensure that the screw can be smoothly screwed in.





4. Screw the nozzle to the heat block with the H7.0 open wrench. Please note that the hexagonal surface of the nozzle should be tightly attached to the bottom surface of the heat block, and the tightening torque of the nozzle is 2.5NM.



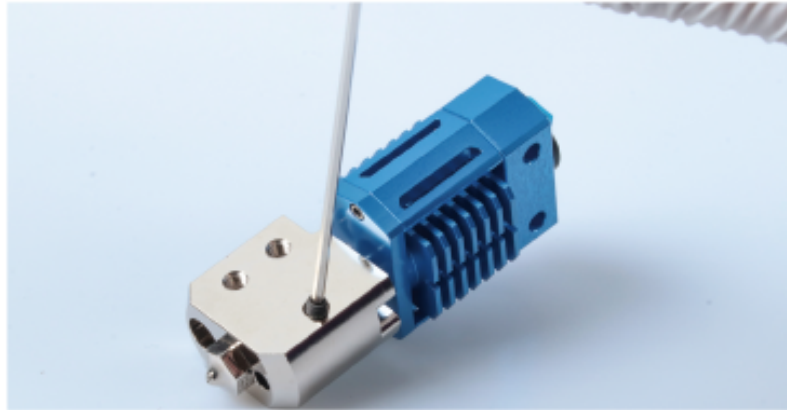
5. Insert the capillary at the end of the nozzle assembly into the eccentric hole at the bottom of the heat sink, and adjust the position so that the arc surface engraved with "Phaetus" on the heat block faces the direction of the threaded hole on the front of the heat sink. Attention should be paid to ensure that the nozzle assembly of the capillary and heat sink are being assembled in place, and axially assembled to the bottom.



6. Use the H1.5 hexagonal bar to lock the flat head screw M3.0*4.0 on the front of the heat sink.



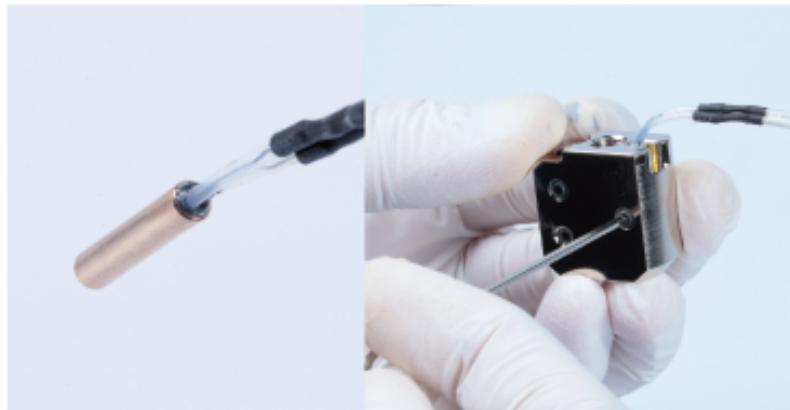
7. On the A side of the heat block, screw 3 flat head screws M3.0*3.0 into the 3 threaded holes respectively with the H1.5 hexagonal bar.



8. Put the silicone sock on the heat block.



9.If you're using glass ball type thermocouple, put the thermocouple into the brass tube which you can find in the accessories kit (the brass tube is shown in the picture below), and then put it into the heat block and lock it with the flat head screws M3.0*3.0. Tie and fix the modified thermocouple wire and the heating rod wire together with the binding belt.



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