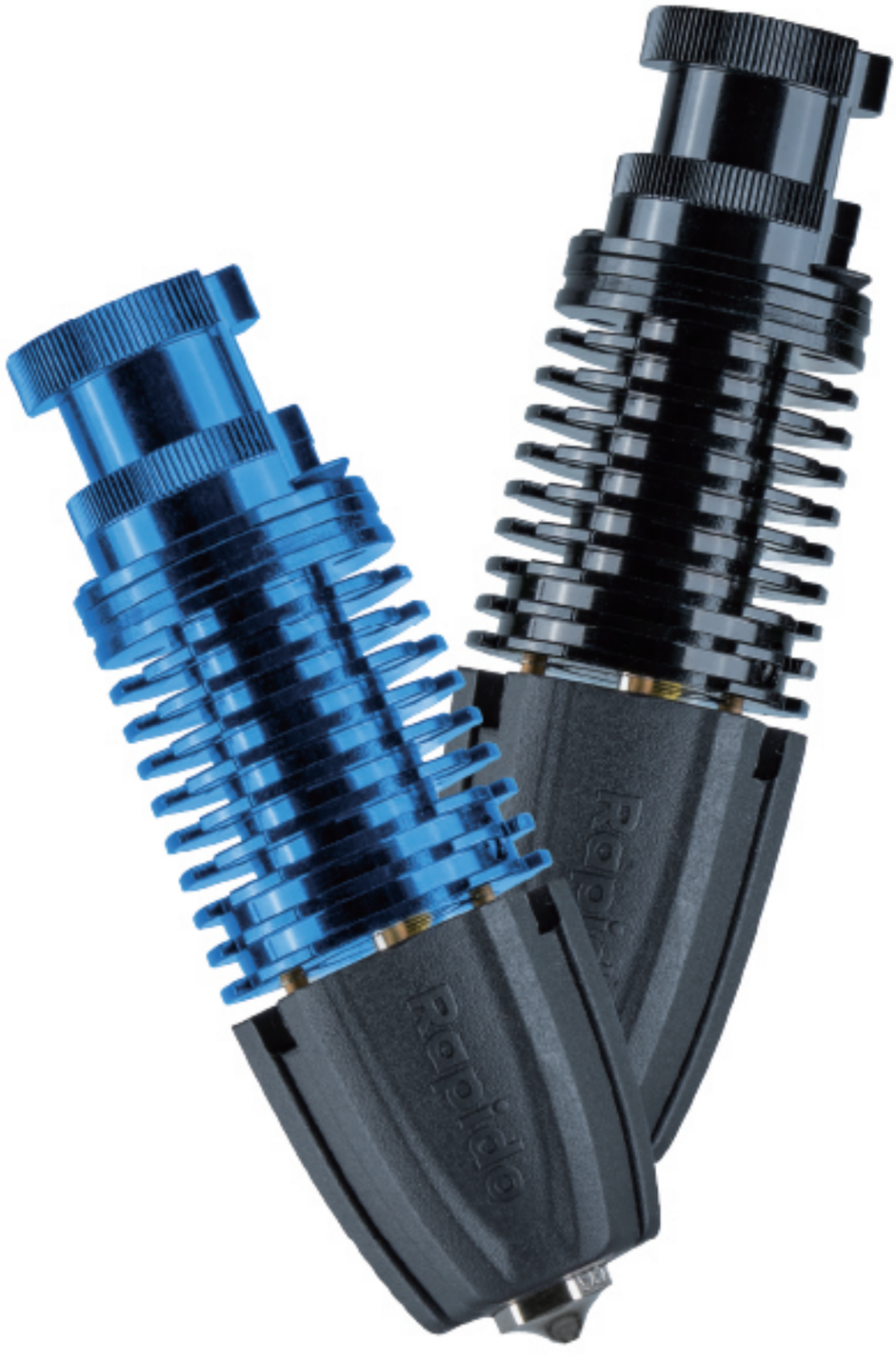
Rapido Hotend Assembly Instruction

Please read and keep this manual carefully before using our products properly

Product Appearance



Thank you for buying Phaetus' Rapido Hotend.

Product Features

Specially designed structure made just for high-speed printing

Interchangeable design for different types of nozzles

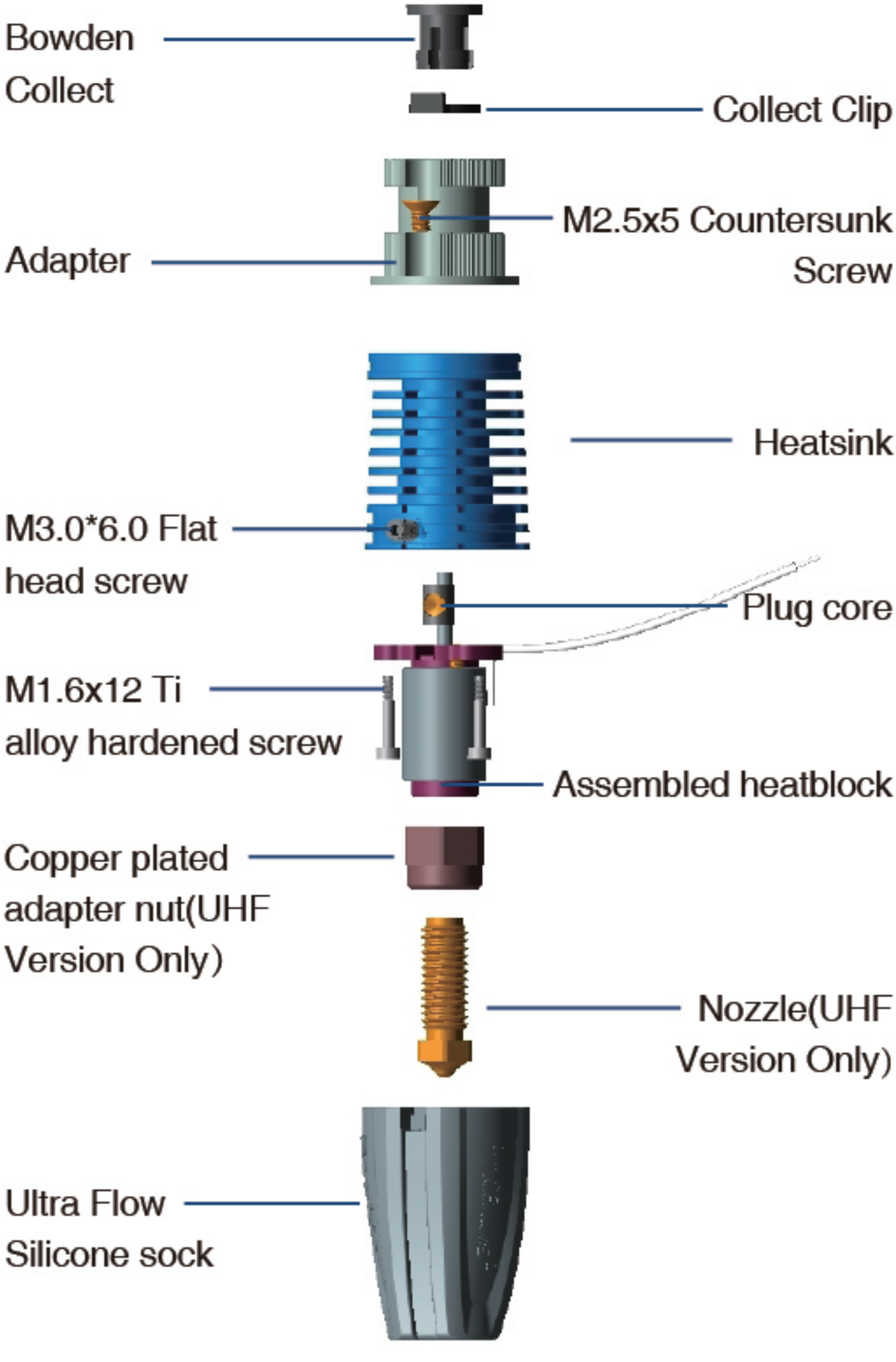
One-handed nozzle change

Suitable for all filament types

Specifications

Product Name: Rapido Hotend
Product Size: φ24.0mm*75.0mm
Default Nozzle: Plated copper 0.4/1.75mm
Volcano Plated copper 0.6/1.75mm
HF:Plated copper 0.4/1.75mm,Hardened steel 0.4/1.75mm
Product Color: Blue/Black
Product Net Weight: HF: 50.50g / UHF: 53.65g
HF: Plated copper 0.4/1.75mm,Hardened steel

Product Exploded View



Parts & Accessories

Collect Clip x 1pcs
Bowden Collect x 1pcs
1.5 Hexagon Rod x 1pcs
2.5 Hexagon Rod x 1pcs
M2.5*8.0 Hexagon Socket Head Screw x 4pcs
Black Heatblock Extension Cord (810mm) x 1pcs
White Thermistor Extension Cord (910mm) x 1pcs
M2*1.8 Custom Semicircular Head with Gasket Screw x 1pcs
M2.5*5 Custom Countersunk Hexagon Socket Screw x 2pcs
Plated Copper Nut x 1pcs (UHF Version Only)
UHF Silicone Sock x 1pcs (UHF Version Only)
H10.0 Open - Ended Wrench x 1pcs (UHF Version Only)
Phaetus Volcano Plated Copper Nozzle 0.6mm x 1pcs (UHF Version Only)

Product Advantage

· New design of the longer copper heatblock makes a larger molten area and meets the requirement of the high temperature and high speed printing.

· Cylindrical ceramic heating unit, makes heating more fully and evenly.

· Integral frame rigid structure of titanium alloy screws which has lower heat conductivity and realize the function of nozzle changement by one hand.

· Thin wall thickness heatbreak, eliminating the heat creep, realizing an excellent thermal insulation and no filament clog.

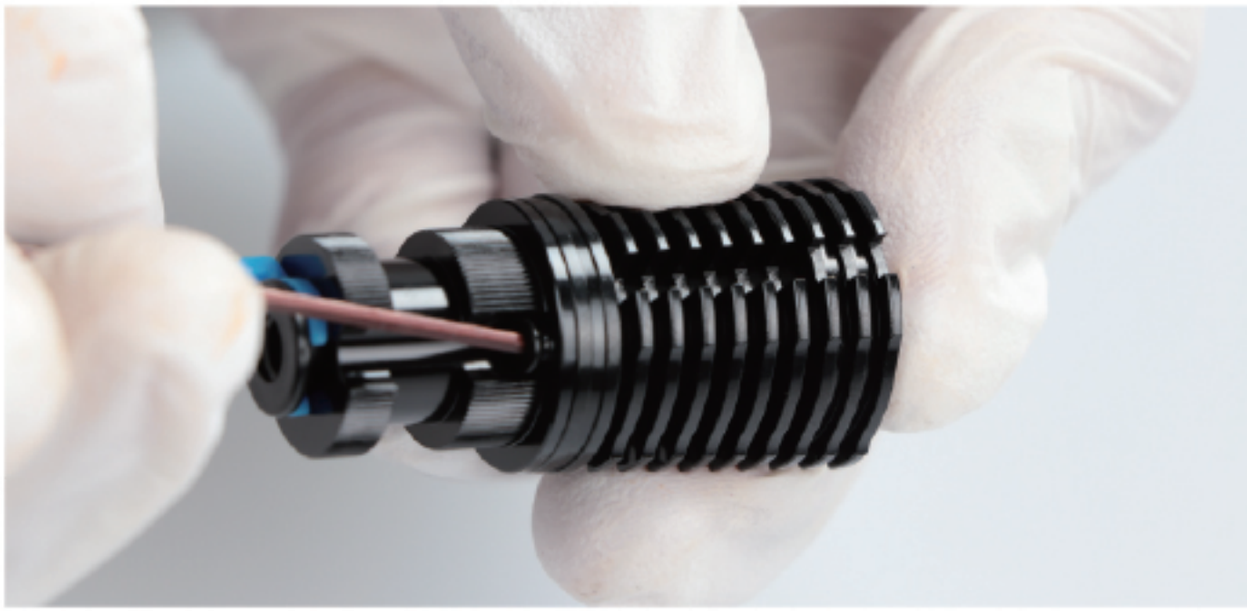
· The universal structure design realizes the fast switching of large flow and super large flow print heads.

· Interchangeable design of different types of nozzles to meet the requirements of high temperature and fiber filaments printing.

Normal Assembly Steps

1. Insert the bowden collect into the top of the adapter, insert the collect clip between the bowen collect and the adapter to secure the bowden collect.

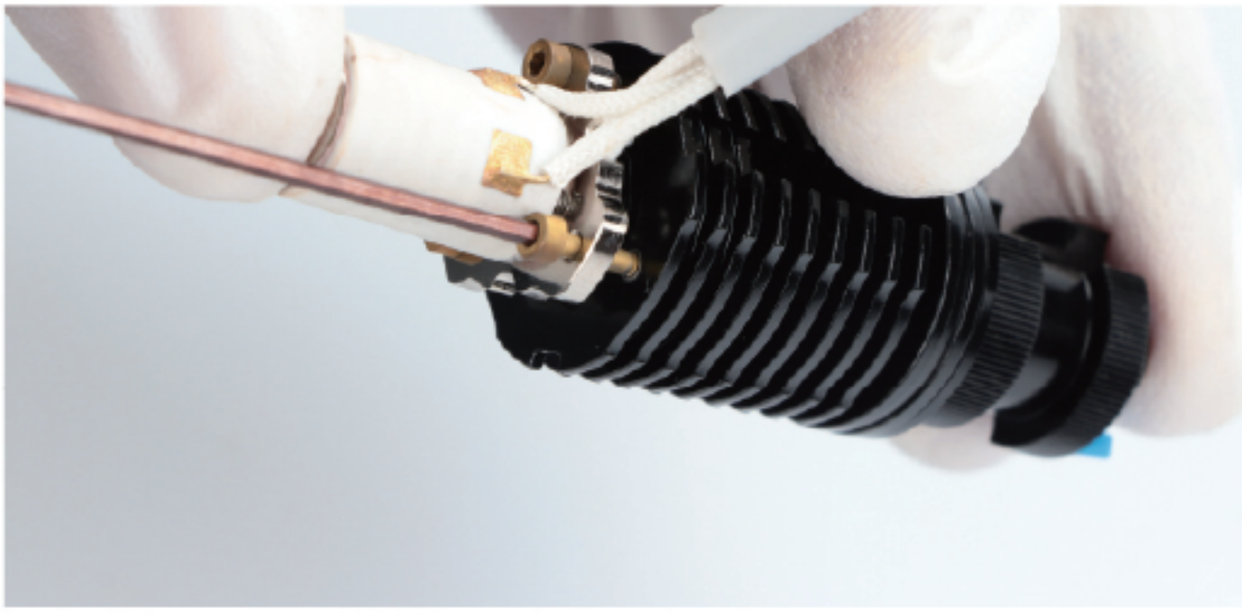
2. Install the adapter on the heatsink using the M2.5*5 screws.



3. Insert the plug core into the large hole at the bottom of the heatsink, and gently hold the heatsink with a M3*6 head screw (the groove faces the central hole).

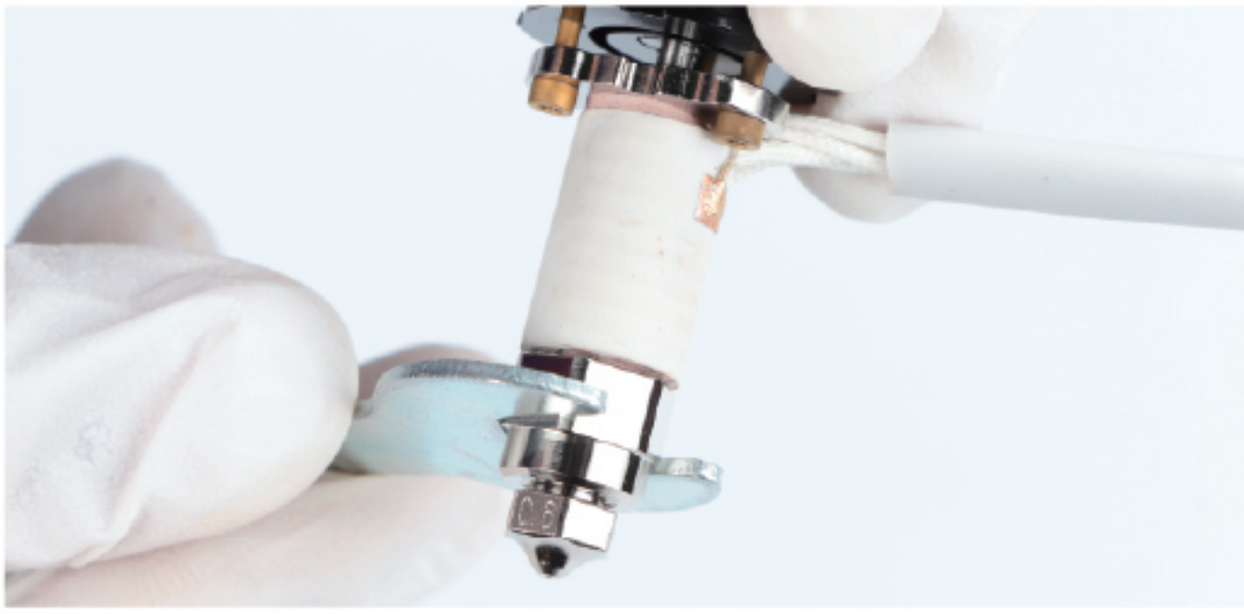
4. Insert the capillary tube on the heatblock to the central hole at the bottom of the heatsink, and the three holes on the heatblock should be aligned with the three supporting tubes on the heatsink.

5. Align the three supporting tubes at the bottom of the assembled heatsink with the three round holes on the heatblock (the direction of the wire on the heatblock should be staggered with the position of the head screw on the heatsink), and screw the titanium alloy screws of M1.6*12. (The gap between the heatblock and the heatsink is about 2.5mm).



6. Tighten the M3*6 screw on the heatsink, and push the groove of the plug core against the capillary.

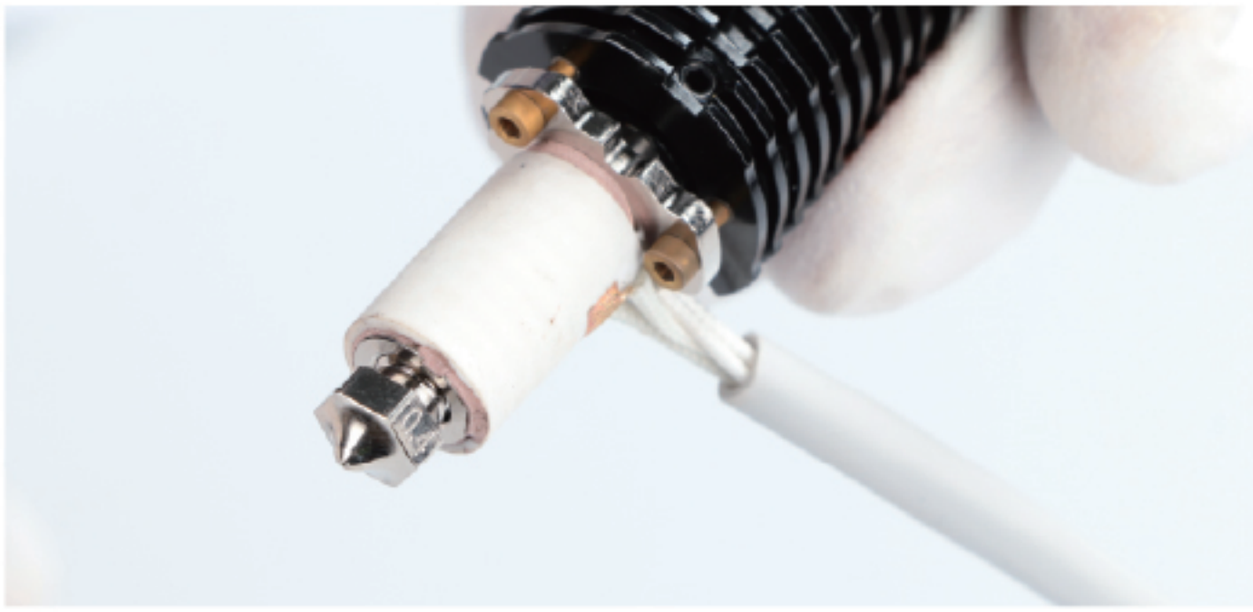
7. Install the nozzle in a hot - tightening manner.



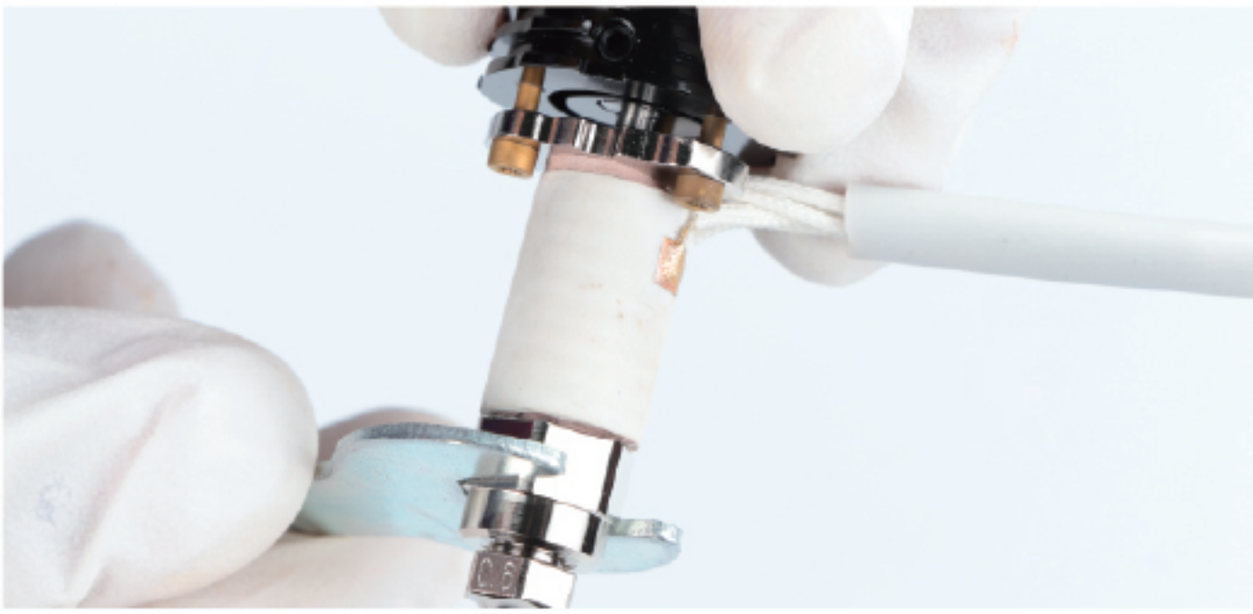
8. Last step, install the silicone sock on the heatblock.

Ultra Flow Assembly Steps

1. Install the copper plated adapter nut on the Φ 0.8 / Φ1.2 copper plated nozzle.



2. Install the nozzle on the heatblock in hot - tightening way.



3. Screw the copper plated adapter nut with the H10 open - ended wrench, and stick the hexagon side of the nut to the bottom of the heatblock (The two sides should be fit tightly where the red arrow points below).

Hot – Tightening

1. Hot - tightening is the last mechanical step before the Rapido High Flow Hotend is ready! Hot - tightening is critical for sealing the nozzle and the heatbreak to ensure that molten filaments do not leak out of the hotend during use.

2. Using the printer's control software (or LCD screen) to set the hotend’s temperature to 285°C. Wait one minute after its temperature reaches 285°C to equalize the temperature of all components.

3. Gently tighten the nozzle while fixing the heatblock with a wrench, and finally tighten the nozzle with a smaller 7.0mm wrench. This will keep the nozzle close to the heatbreak and ensure that the hotend does not leak.

4. The tightening torque of the hot nozzle is about 2.5NM, which is about the pressure applied by one finger on the small wrench.

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