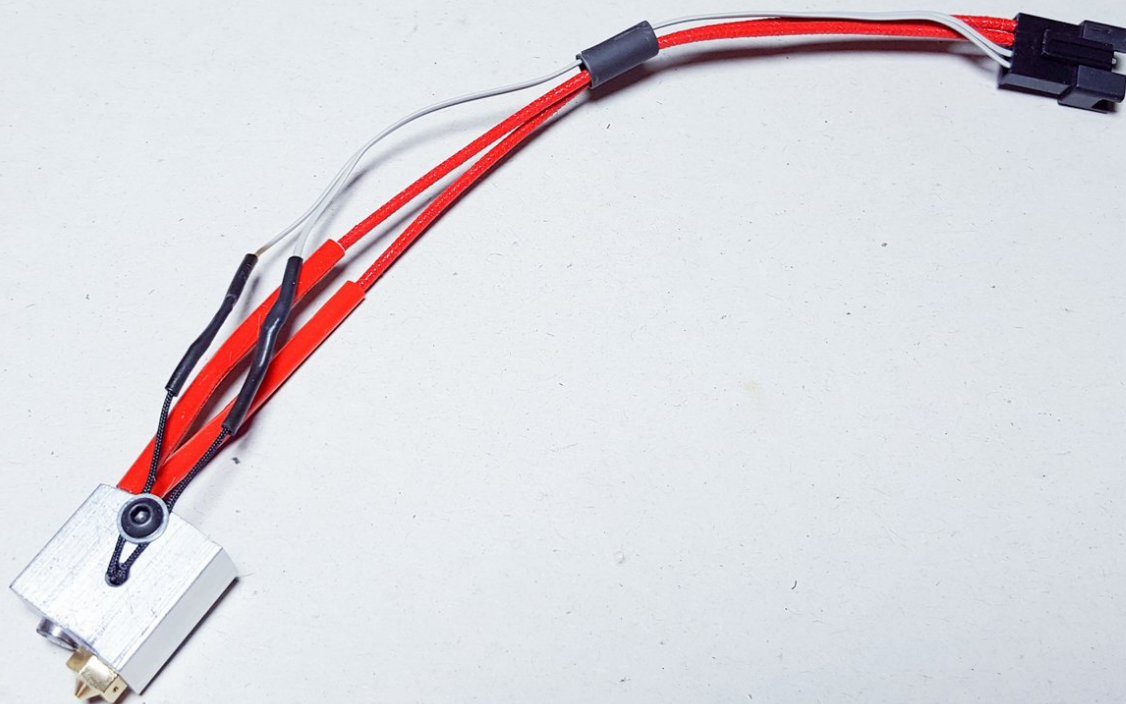


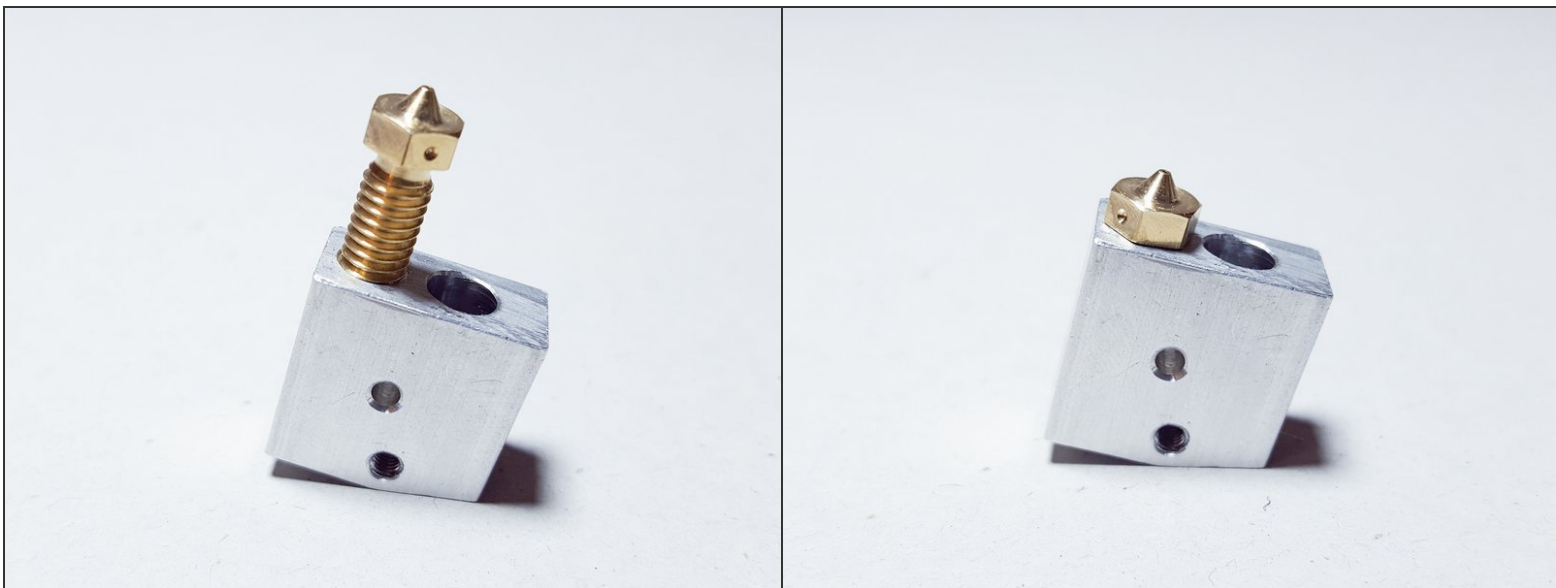


## ↳ Heat Block

In this guide, we will assemble all the parts of the hotend heat block.

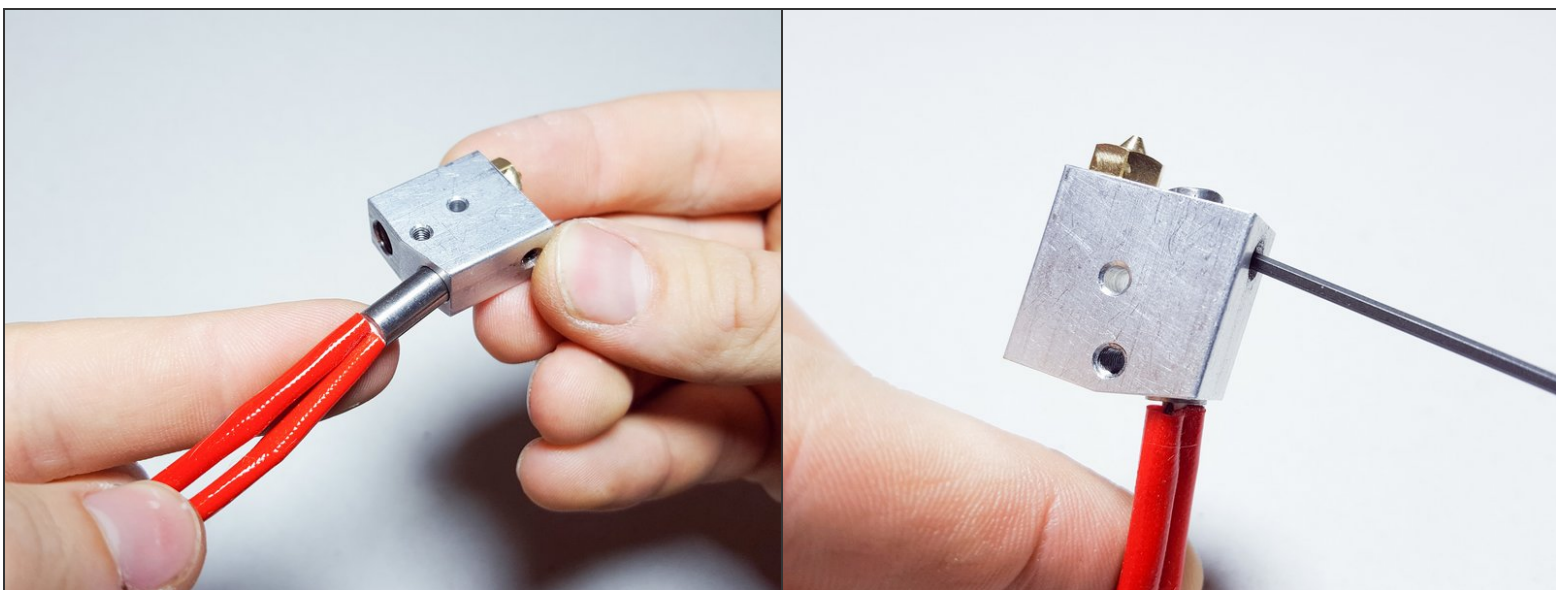


## Step 1 — ↳ Heat Block



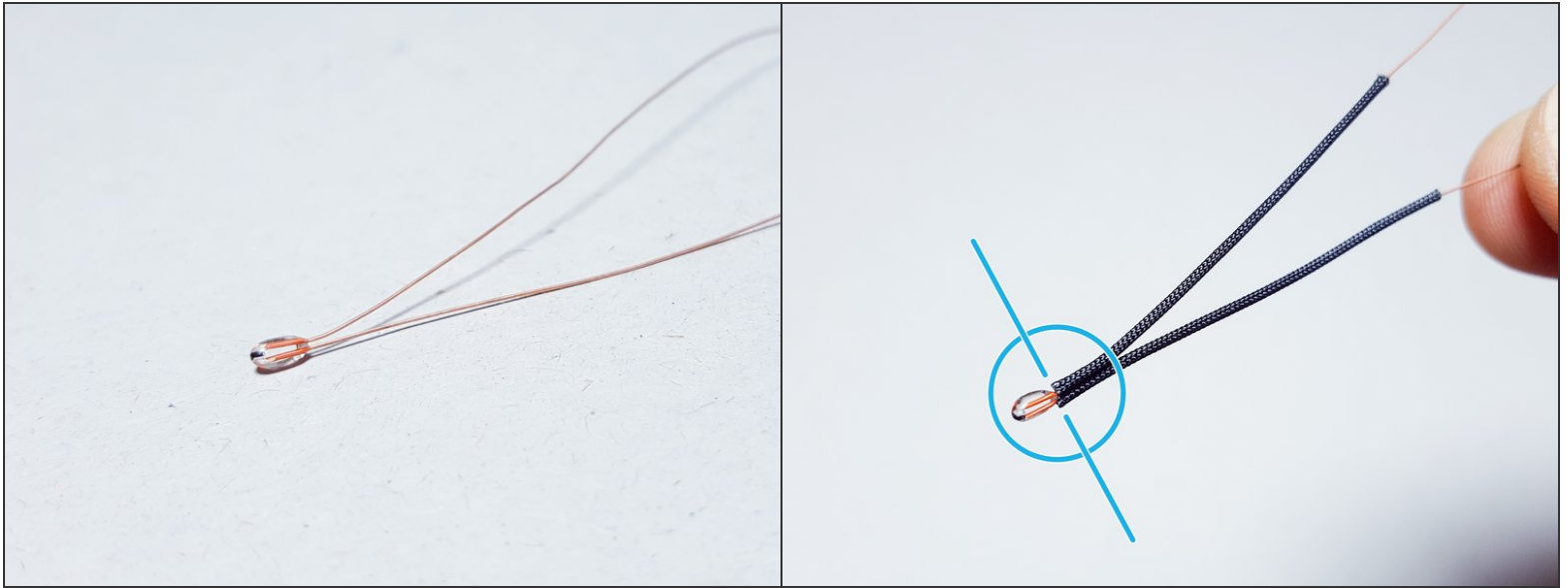
- Do not tighten.


## Step 2



- Secure the heater cartridge with an M3 set screw.

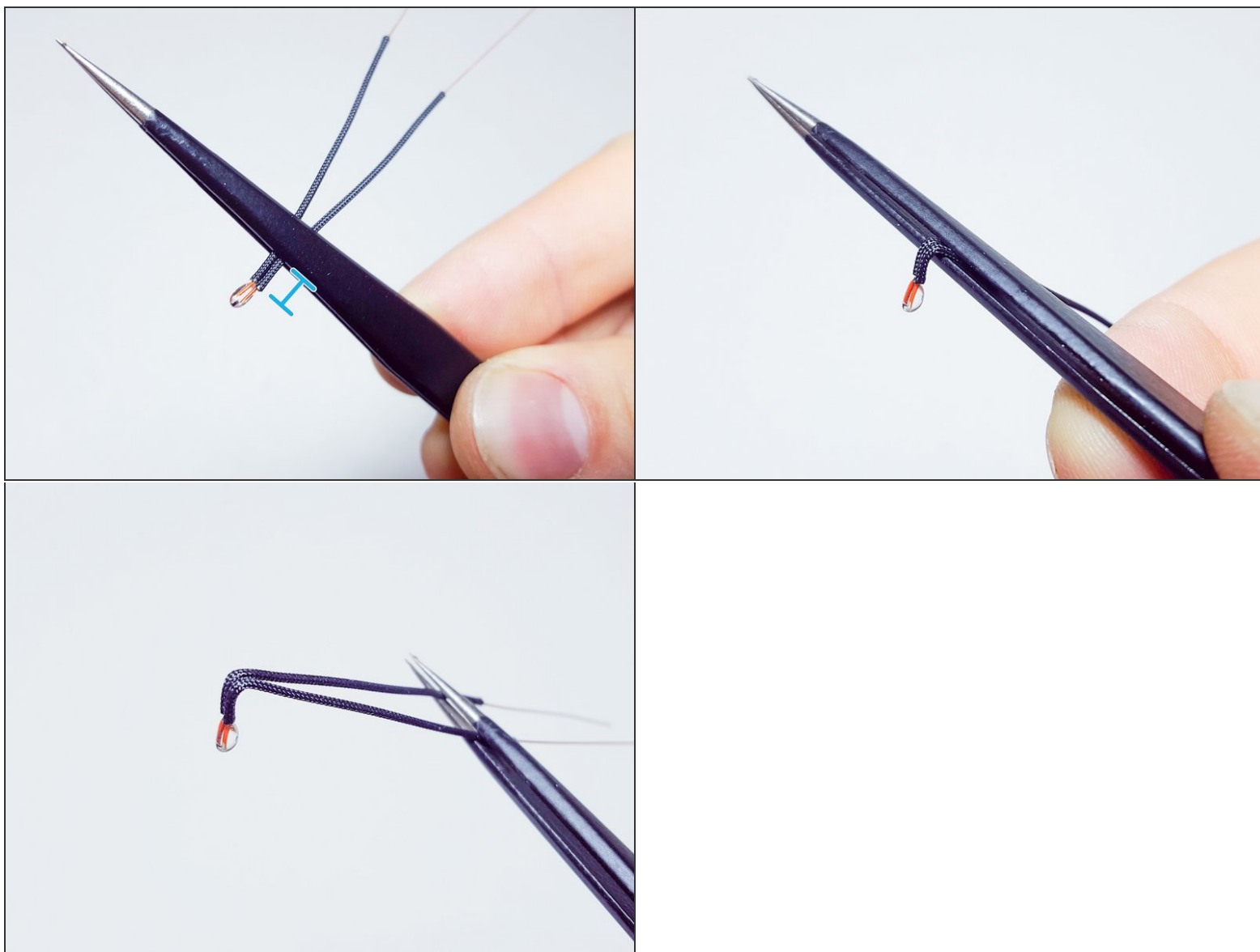
### Step 3



 The thermistor is small and fragile. Be gentle with the legs. The thermistor bead is made of glass - don't crush it!

- Slide the glass-fiber high temperature sleeving onto the legs of the thermistor. Make sure to get the sleeving all the way right up against the glass bead.

## Step 4

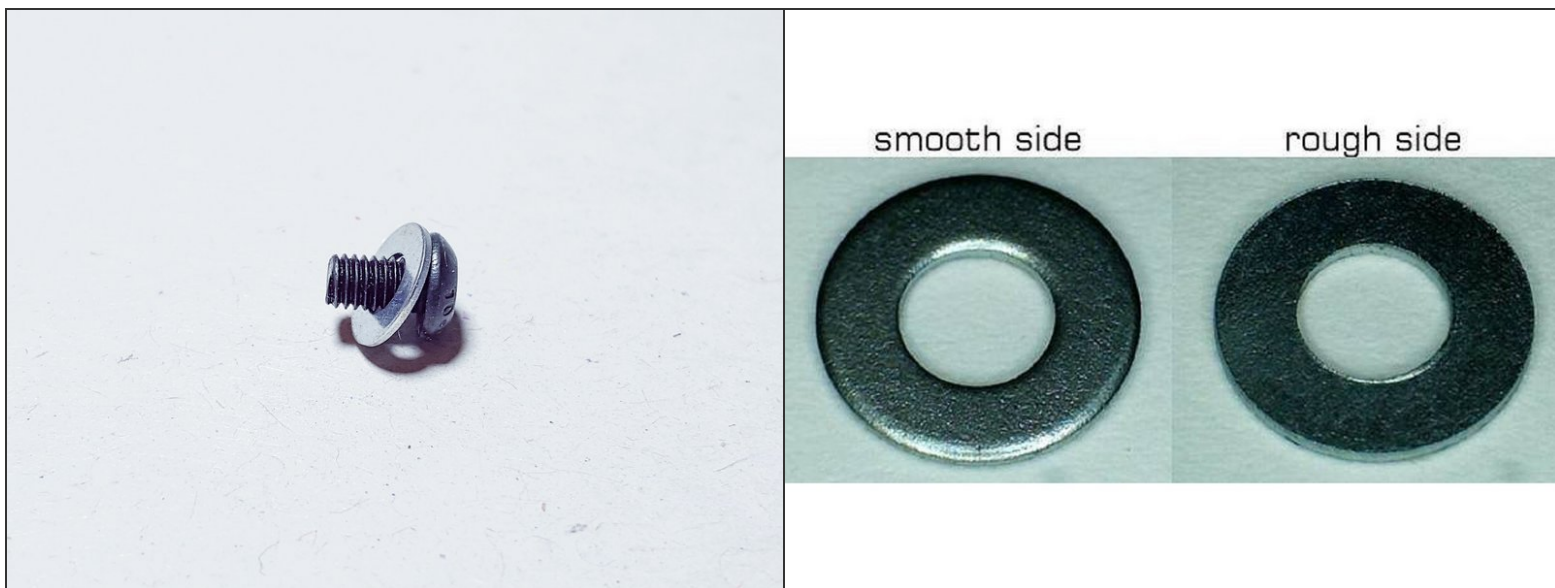


- Bend the thermistor legs 90 degrees about 2-3mm behind the glass bead.

⚠ The legs must be fully insulated next to the bead. Careful about the sleeving - it will want to slide away. Keep it right against the bead.

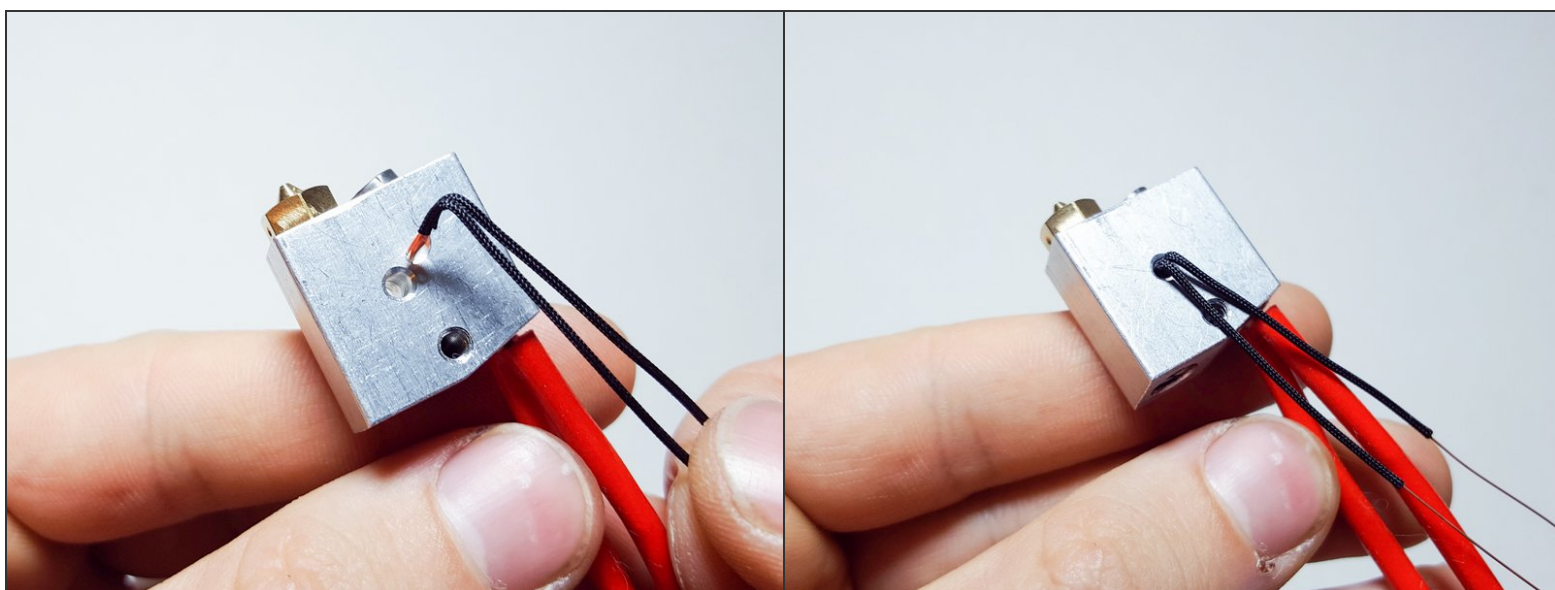


## Step 5

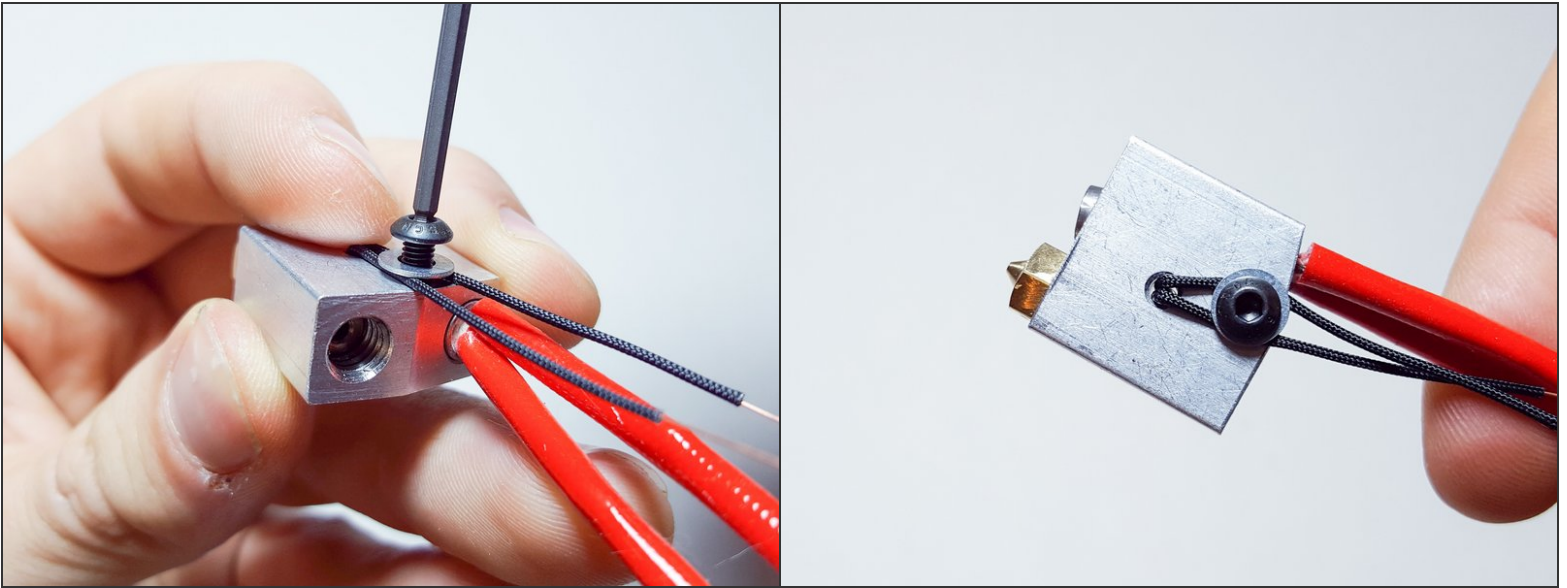


- i** Due to the manufacturing process, washers often have slightly sharper edges on one of their sides.
- Make sure to have the smooth side facing away from the screw head - this way the **smooth** side will be against the sleeving and won't damage the insulation.
  - M5x5 button head screw.

## Step 6



## Step 7



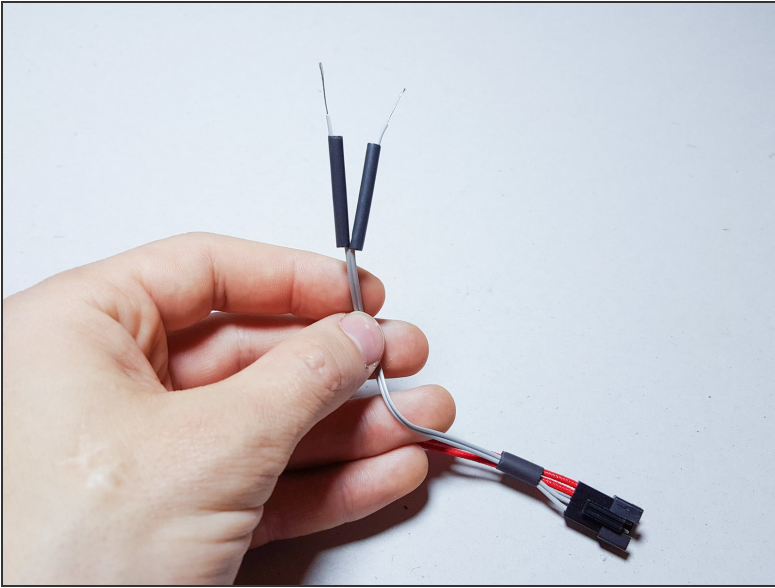
- Secure the thermistor in place with the buttonhead screw.

⚠ Don't overtighten - you don't want to damage the insulation and short-circuit the thermistor.

⚠ Visually check that the sleeving is insulating the legs of the thermistor right down to the bead.

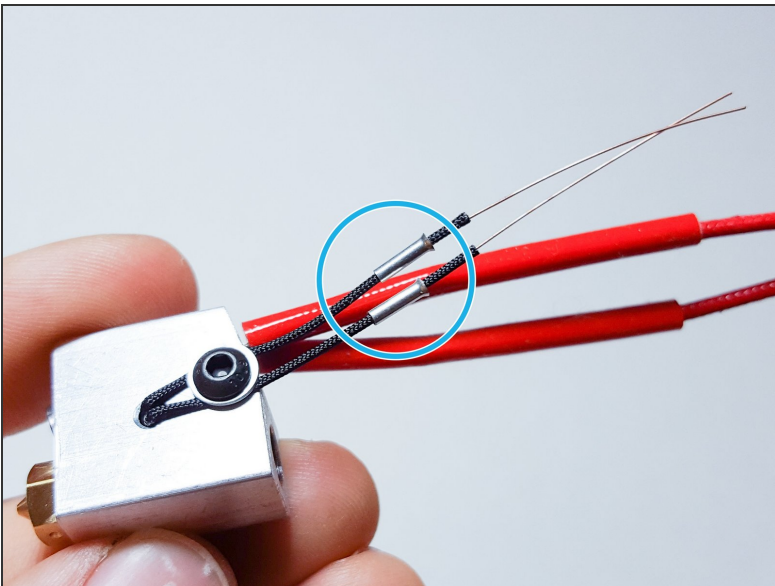
ⓘ If the legs make electrical contact with the block or each other your temperature readings will be incorrect and you risk overheating.

## Step 8



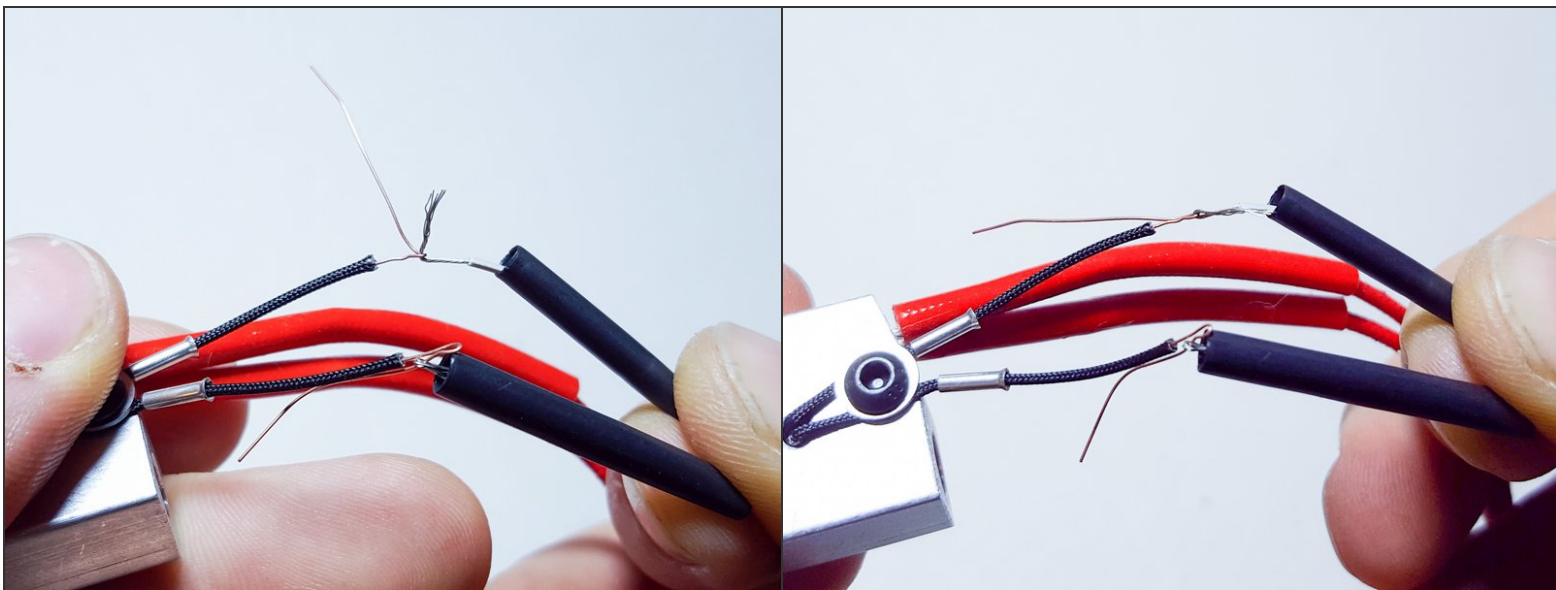
- Split the thin double wire about 5cm and slide heatshrink pieces on both legs.
- Strip about 1.5cm (1/2") of insulation from the wire ends. Use a wire stripper, knife, snips, scissors, fire, teeth, or a combination of these.

## Step 9



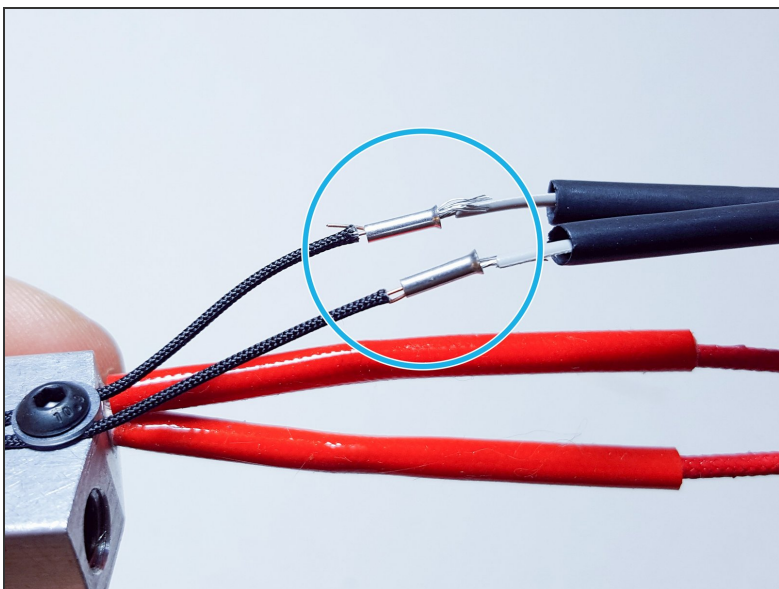
- Slide on two ferrules onto the thermistor legs.

## Step 10



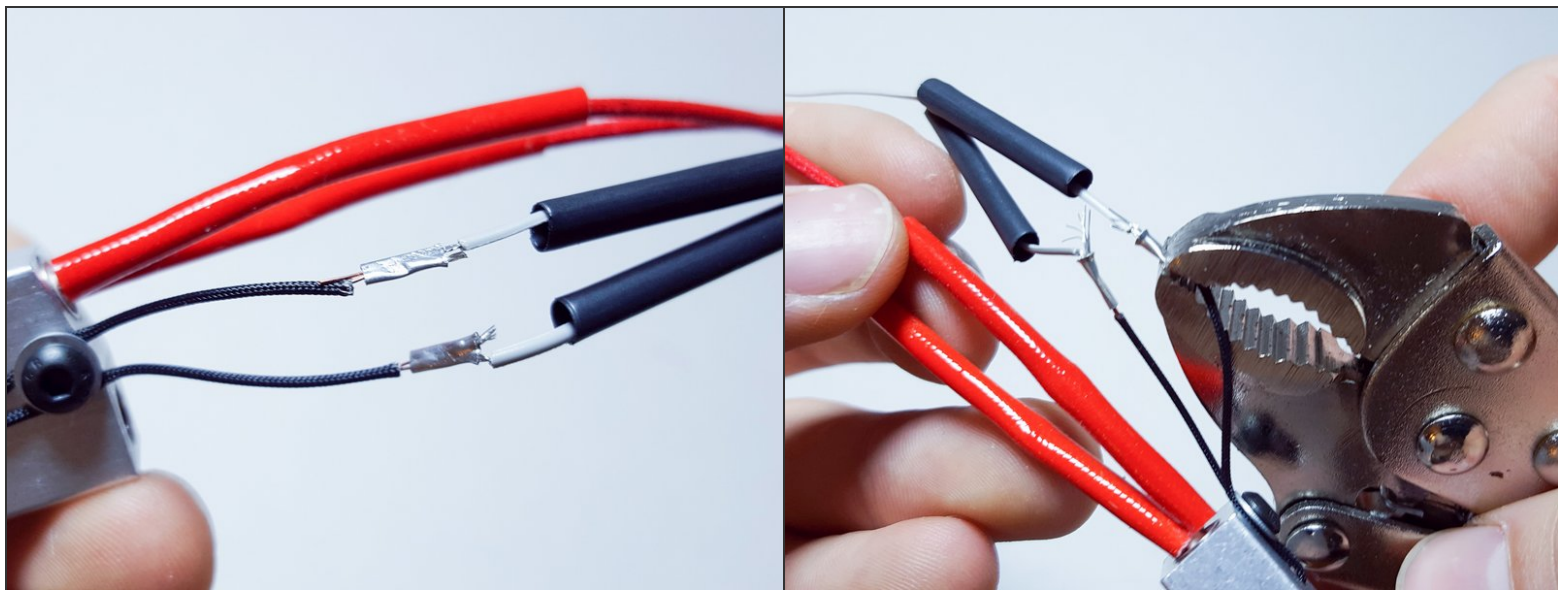
- It does not matter which wire is which. The thermistor does not care about plus and minus.

## Step 11



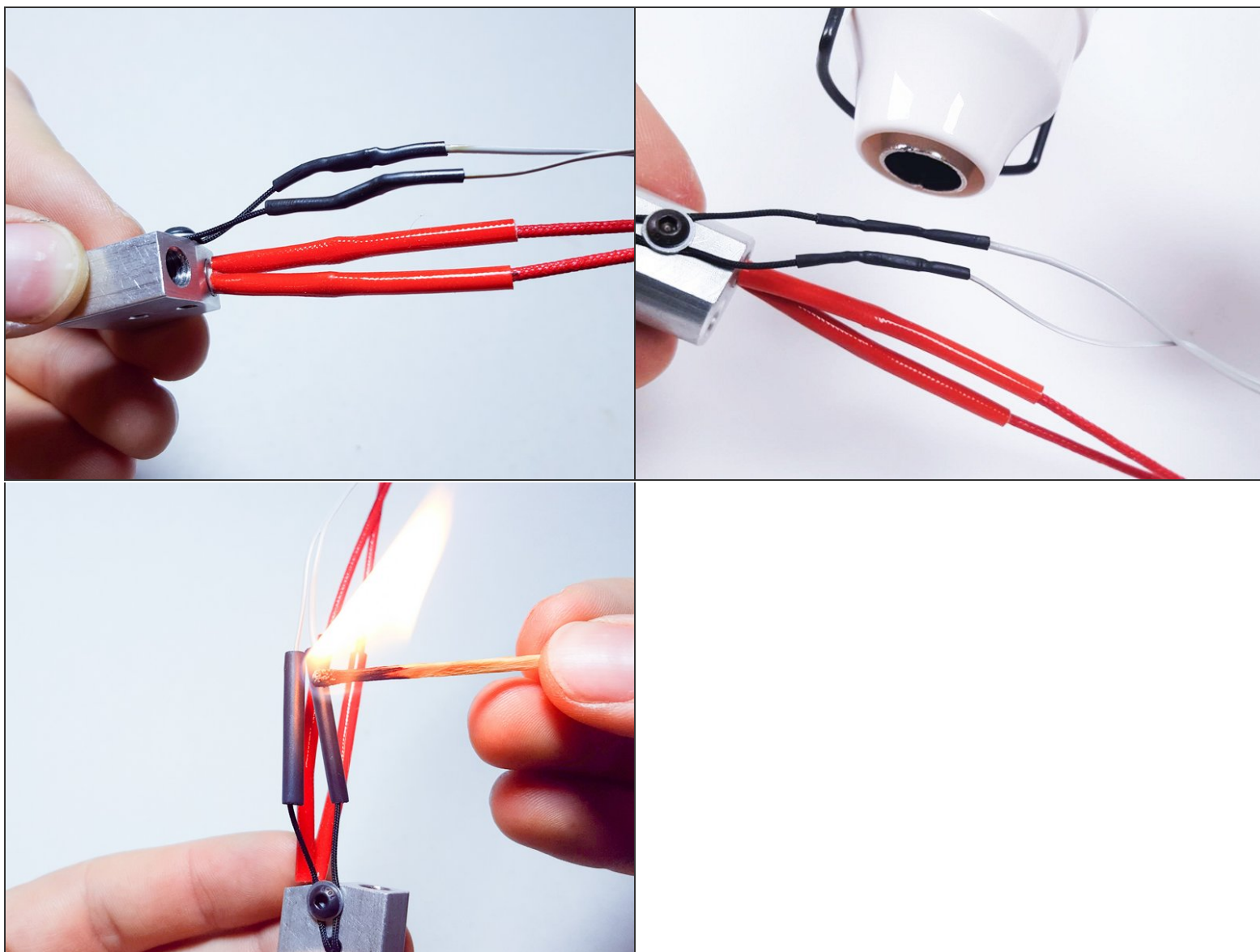


## Step 12



- Crimp the ferrules by firmly crushing them with a pair of vise grips/ pliers.
- You can use a fancy ferrule crimping tool if you have one, but it's not needed.

## Step 13



- Slide the heatshrink down over the now crushed ferrules and shrink into place with a heat source such as a soldering iron, hot air gun or a flame.

## Step 14 — Looking good!

