## Voron Design

Voron 0 Assembly Guide: 04. Full Frame Assembly

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## TOOLS:

- Hex keys or drivers (1)
- Flat, level surface on which to work (1)


## PARTS:

- M3x10 BHCS $\times 12$ (1)
- M2 Hex Nut $\times 10$ (1)
- M2x6 SHCS/BHCS/FHCS $\times 10$ (1)
- M3 Hex Nut × 39 (1)


## Step 1 - Bottom and Rear Extrusions



- You should square joints on a flat surface, now, but final squaring will be done after the frame is fully assembled.
- Note in the illustration the version of drilled extrusion being used for the bottom piece. You will need two of these, one in this step, and one in the next step.
- The vertical extrusion is drilled with 7.5 mm spaced holes at both ends.
- NOTE: Steps 1-3 will be done twice, once for each side of the printer.


## Step 2 - Top Extrusion



- Install the top extrusion similarly as the bottom.
- As before, the printed M2 nut holders are sensitive to elephant foot. Be prepared to have to trim them slightly with a hobby knife and/or take care inserting them so they don't snap.


## Step 3 - Attach the Y Linear Rails



## Step 4 - Attach Z Assembly



- Attach the $Z$ assembly as shown, and note the nut insertion indicator.


## Step 5 - Insert Rear Bottom Panel



- Insert the bottom panel, now, before installing both side frame assemblies.


## Step 6 - Attach Second Side Frame



- Make sure all panels are slotted correctly, and attach second side frame, as shown..


## Step 7 - Front Beams



- The beams used in this step are drilled through on both sides on one end, and only on side at the other end. There are only two such beams in the set.
- Install front beams in the familiar blind joint fashion as elsewhere in this guide.
- NOTE: The term "beam" will be used synonymously with the term "extrusion", and in some cases will include a linear rail. So a beam is single extrusion, or an extrusion and linear rail combination.


## Step 8 - Bottom Front Beam



- Install the end screws for the blind joint, and slide into position. Tighten loosely, as final tightening will be done in the frame alignment section.


## Step 9



- Voron 0 Assembly Guide: 05. Frame Alignment

