

# macewen3D

## V6 Clone Kit

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Before USE: Be sure to heat block to 230C, and tighten nozzle against the tube; when HOT. You should have a small gap between heater block, and hexagonal shape on the nozzle. About 1/2 a thread thickness. About the thickness of your fingernail.



This tightening of nozzle when hot is important. It helps prevent plastic leaking out from heater block. If you tighten nozzle when cold, then heat block, the seal between threaded tube and brass nozzle will spread apart. Tightening must occur when block is hot. Please heat block before when loosening nozzle for replacement. Plastic will work as a glue, unless it is heated. Be careful. It's HOT! :)

WIRING: You may reuse your existing heater and thermistor from your printer, if you use care, and are able to do so without damaging it. White pair is thermistor circuit. Red pair of wires is the heater cartridge. Polarity will not matter. Soldering wires, and using shrink tubing is recommended. I generally cut old wiring 4 inches from old hotend, and leave 6 inches of new wire on V6. Crimp butt splices work as well. Use polyamid tape to protect wires from shorting, particularly important with Volcano block. Apply polyamid tape to bottom of heatsink, wires, and top of heater block to protect wires.