

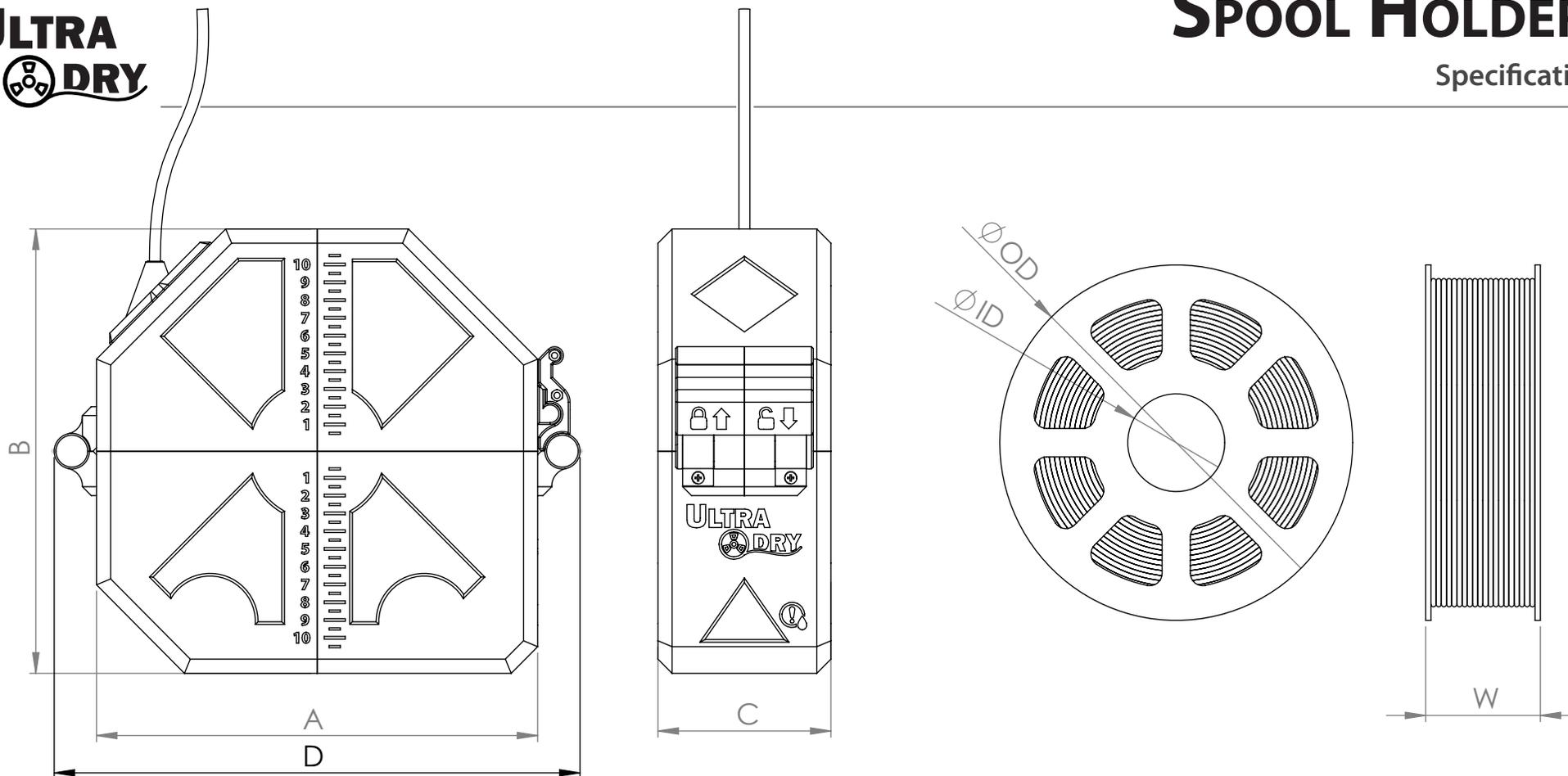
# ULTRA DRY

## Assembly Instructions

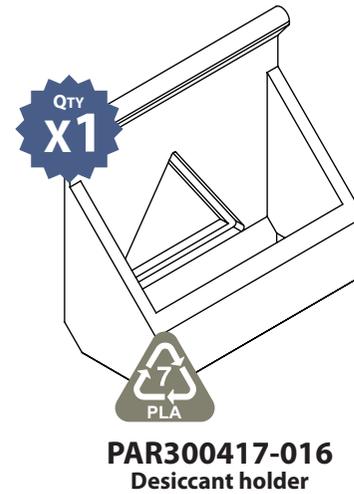
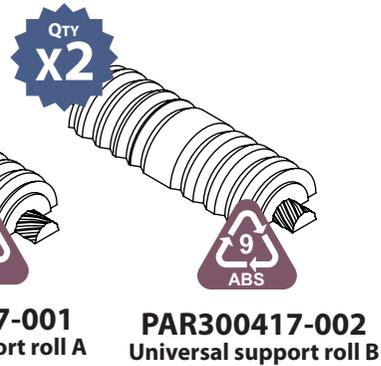
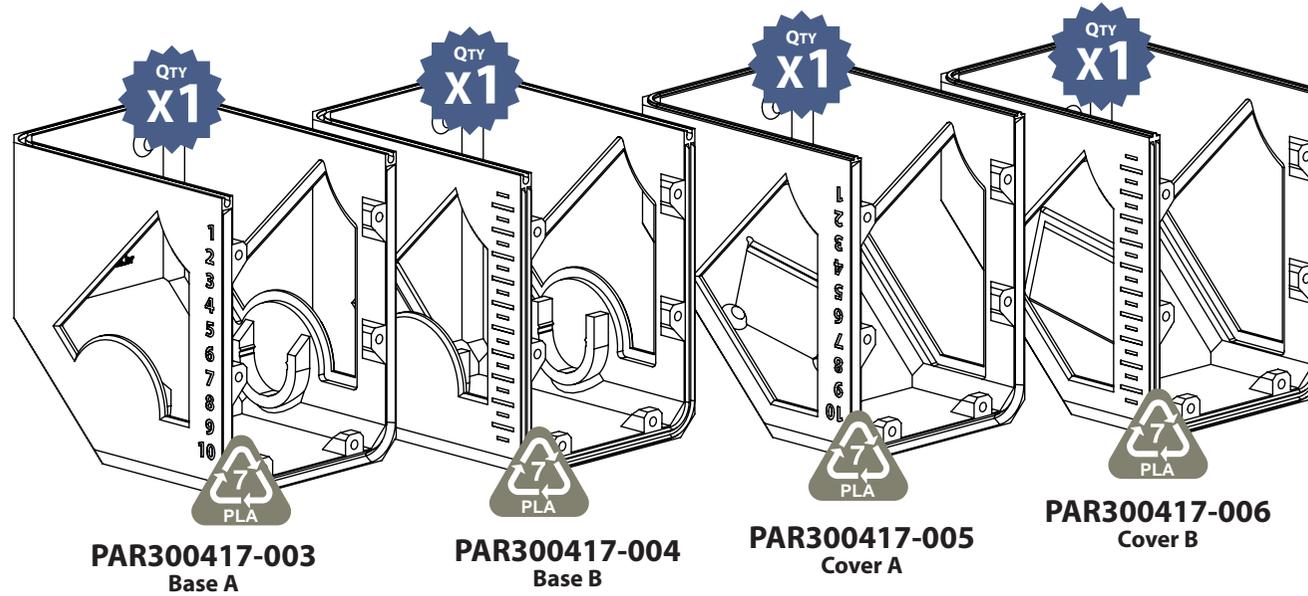


# SPOOL HOLDERS

Specifications

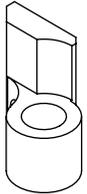


	NARROW version	STANDARD version	WIDE version
Body dimensions (A / B / C / D)	250 / 250 / 68 / 298 mm	250 / 250 / 98 / 298 mm	250 / 250 / 128 / 298 mm
Spool outside diameter (OD)		from 140 mm to 210 mm	
Spool internal diameter (ID)		any	
Spool width (W)	up to 40 mm	up to 70 mm	up to 100 mm
Largest printable part	125 x 125 x 68 mm	125 x 125 x 98 mm	125 x 125 x 128 mm



\* parts displayed in the preferred printing orientation

QTY  
**X2**



**PAR300417-007**  
Hinge and Lock Base A

QTY  
**X2**



**PAR300417-008**  
Hinge and Lock Base B

QTY  
**X2**



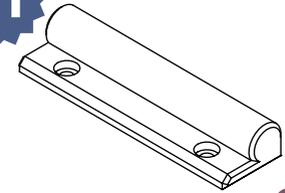
**PAR300417-009**  
Hinge Cover A

QTY  
**X2**



**PAR300417-010**  
Hinge Cover B

QTY  
**X1**



**PAR300417-015**  
Lock Bar

QTY  
**X2**



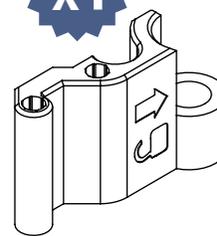
**PAR300417-011**  
Hinge and Lock Pin A

QTY  
**X2**



**PAR300417-012**  
Hinge and Lock Pin B

QTY  
**X1**



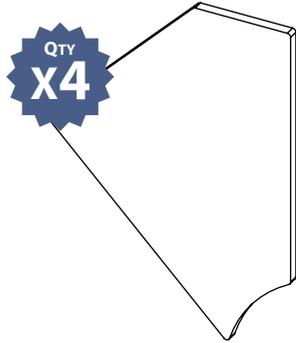
**PAR300417-014**  
Lock Lever B

QTY  
**X1**



**PAR300417-013**  
Lock Lever A

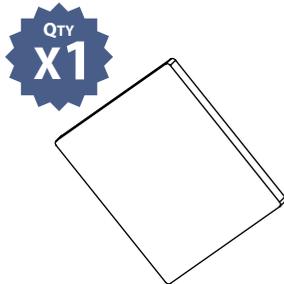
\* parts displayed in the preferred printing orientation



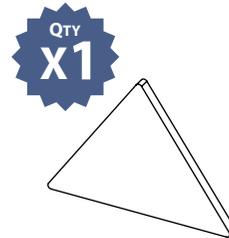
**PAR300417-019**  
Cover - Side Window



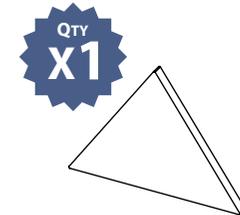
**PAR300417-021**  
Base - Side Window



**PAR300417-020**  
Cover - Front Window

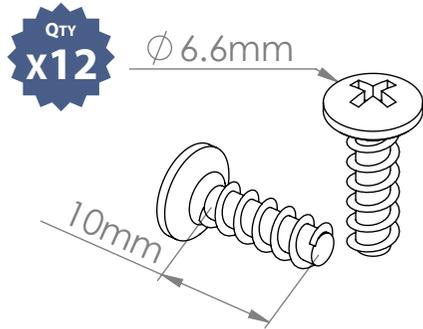


**PAR300417-022**  
Base - Front Window

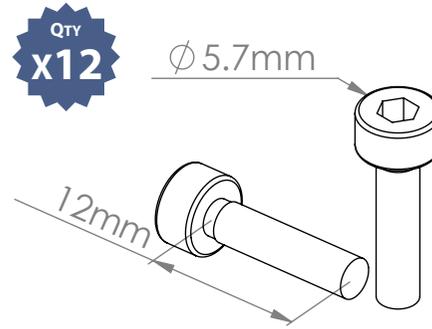


**PAR300417-023**  
Desiccant Window

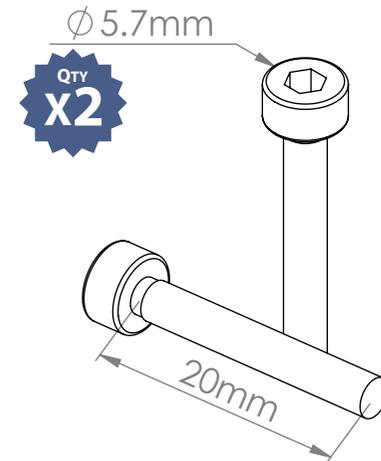
(parts can be hand cut; material up to 3mm thick; keep tolerances within +/-1mm)  
(DWG and STEP files available for CNC programming)



**PAR300417-951**  
M3.5x10mm Phillips, pan head, self-tapper screw



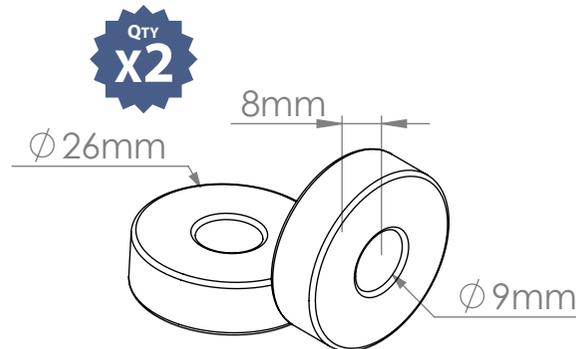
**PAR300417-952**  
M3x12mm hex socket head cap machine black



**PAR300417-958**  
M3x20mm hex socket head cap machine black



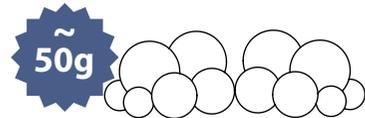
**PAR300417-953**  
Standard M3 nut



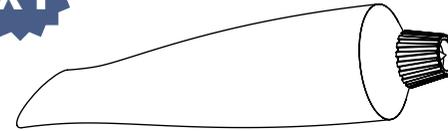
**PAR300417-900**  
Ball bearing 629 2RS



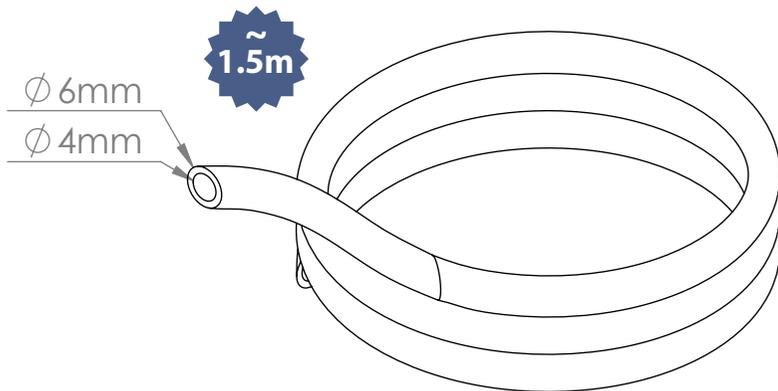
**PAR300417-959**  
3mm O'Ring cord



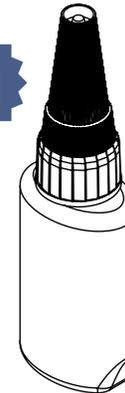
**PAR300417-901**  
Blue Silica (4~8mm balls)



**PAR300417-956**  
Silicone adhesive

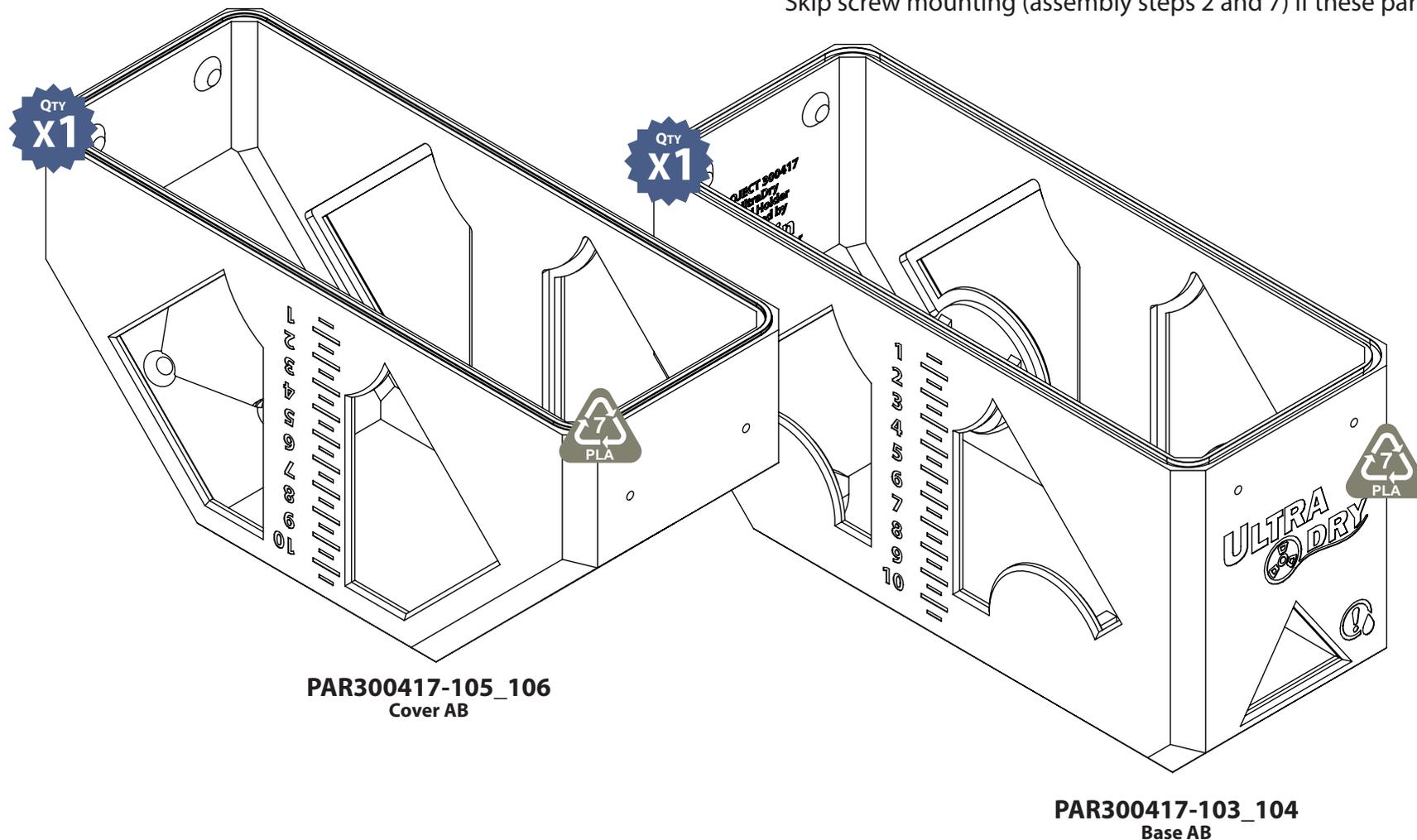


**PAR300417-960**  
Standard 6mm OD / 4mm ID flexible PU pneumatic hose



**PAR300417-957**  
Loctite 401 or similar super-glue

Alternative, single piece, base and cover. These parts require large printer tables (at least 250mm available in X or Y axis).  
Skip screw mounting (assembly steps 2 and 7) if these parts were used.



**PAR300417-105\_106**  
Cover AB

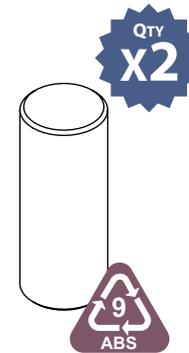
**PAR300417-103\_104**  
Base AB

\* parts displayed in the preferred printing orientation

Alternative, two parts with connecting pin, conic roller.  
Skip assembly steps 13 and 14 if these parts were used.



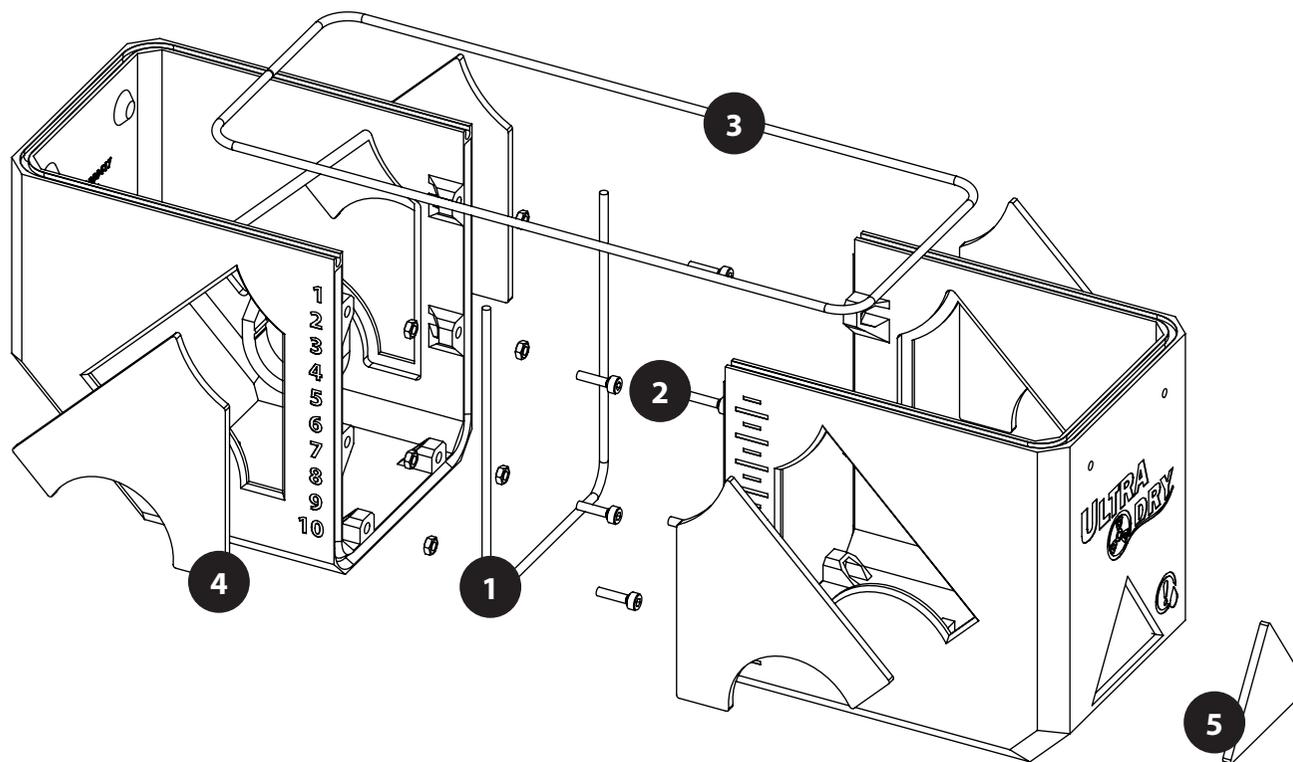
**PAR300417-024**  
Conic support roller BODY



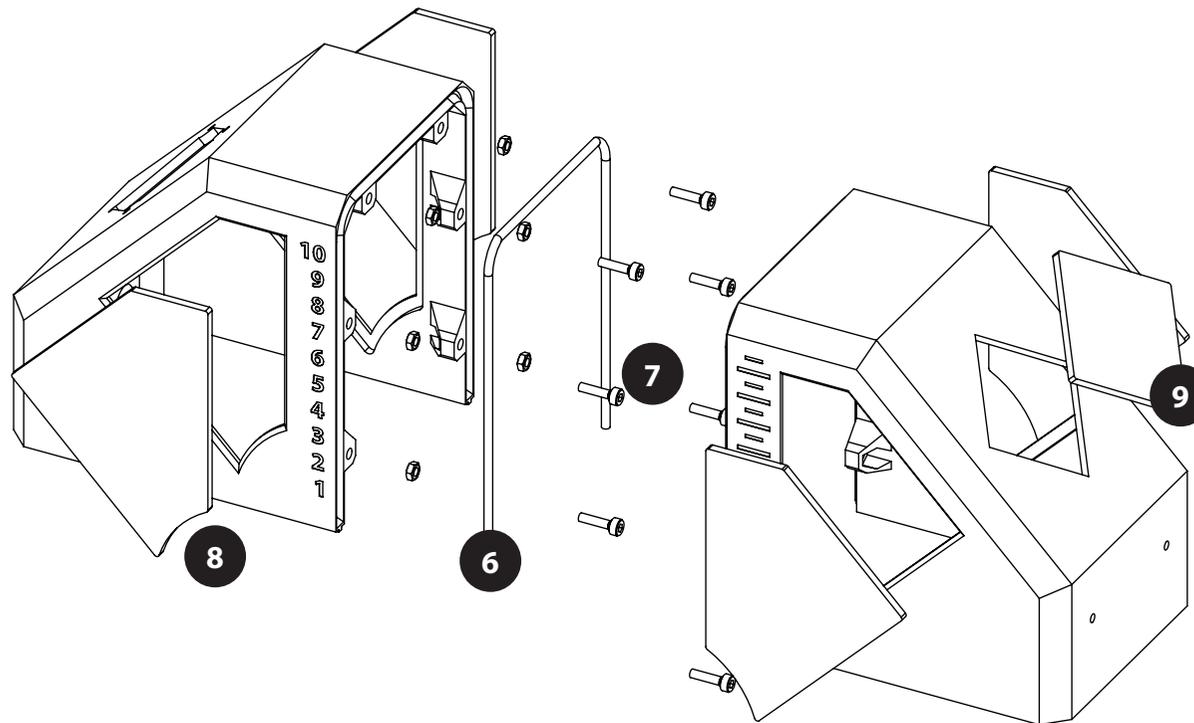
**PAR300417-025**  
Conic support roller PIN

\* parts displayed in the preferred printing orientation

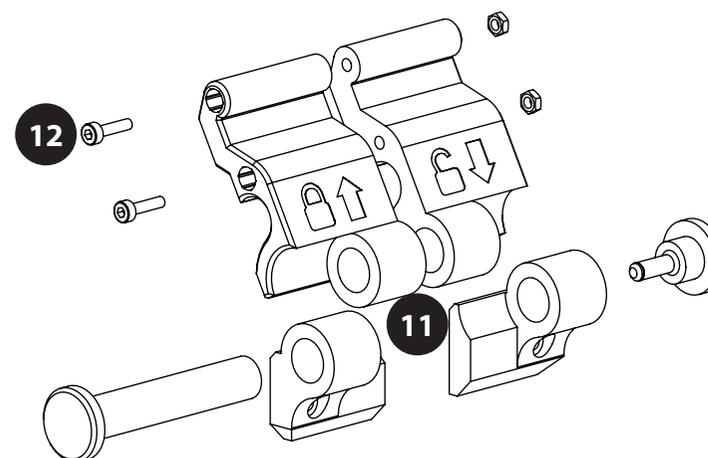
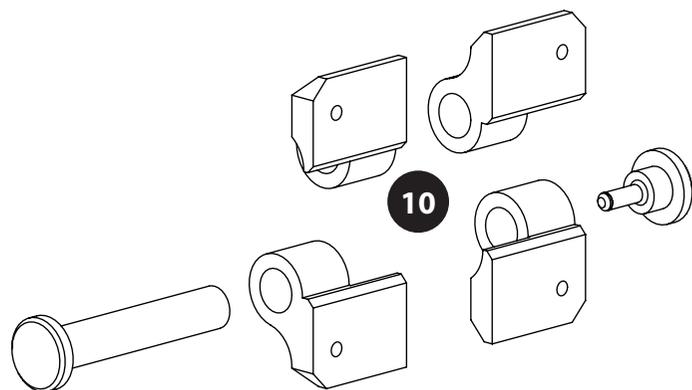
- 1 Place an O'Ring cord along the recessed contour of part **PAR300417-003 - Base A**.  
Align and temporarily tape together parts **PAR300417-003 - Base A** and **PAR300417-004 - Base B**.
- 2 Install the **PAR300417-952 - M3x12mm screw** and the **PAR300417-953 - M3 nut** on all 6 mounting pillars. Tight well.
- 3 Insert an O'Ring cord along the entire top recessed track contour. Press it firmly inside.
- 4 Apply a small amount of **PAR300417-956 - Silicone adhesive** around **PAR300417-021 - Base - Side Window** and place it on the internal recessed frame. Repeat the process for all 4 windows.
- 5 Apply a small amount of **PAR300417-956 - Silicone adhesive** around **PAR300417-022 - Base - Front Window** and also install it in.



- 6 Place an O'Ring cord along the recessed contour of part **PAR300417-005 - Cover A**.  
Align and temporarily tape together parts **PAR300417-005 - Cover A** and **PAR300417-006 - Cover B**.
- 7 Install the **PAR300417-952 - M3x12mm screw** and the **PAR300417-953 - M3 nut** on all 6 mounting pillars. Tight well.
- 8 Apply a small amount of **PAR300417-956 - Silicone adhesive** around **PAR300417-019 - Cover - Side Window** and place it on the internal recessed frame. Repeat the process for all 4 windows.
- 9 Apply a small amount of **PAR300417-956 - Silicone adhesive** around **PAR300417-020 - Cover - Front Window** and also install it in.



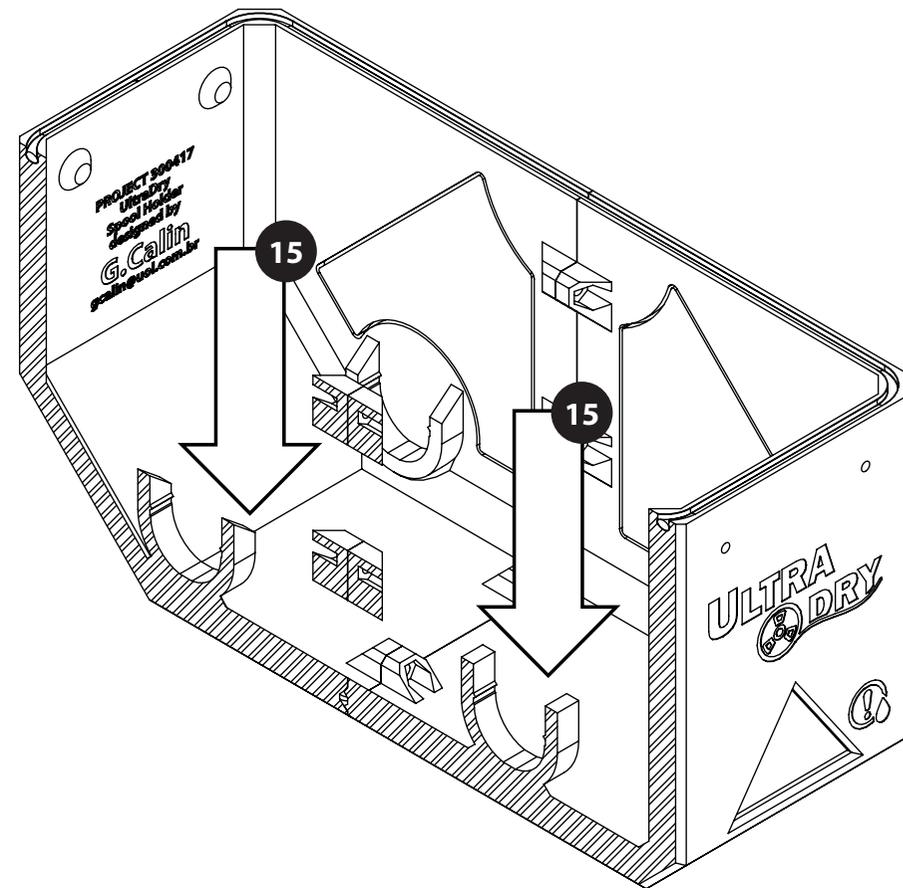
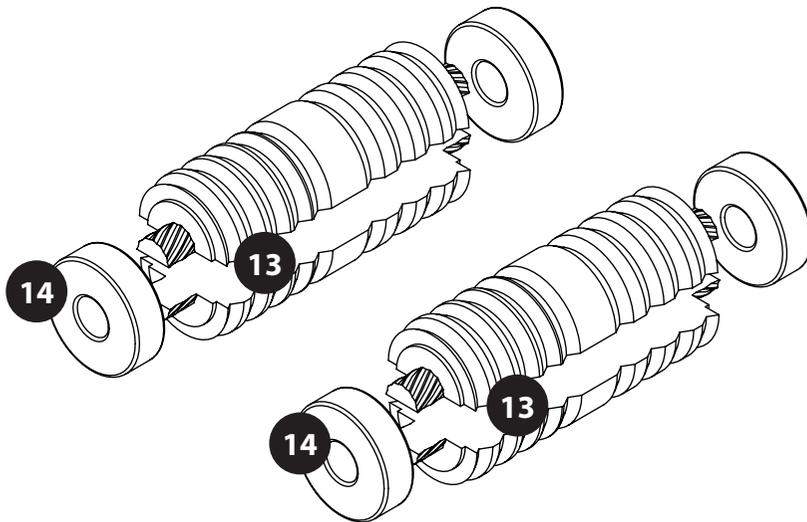
- 10 Align **PAR300417-009 - Hinge Cover A**, **PAR300417-010 - Hinge Cover B**, **PAR300417-007 - Hinge Lock/Base A** and **PAR300417-008 - Hinge Lock/Base B**, locking all parts together with **PAR300417-012 - Hinge/Lock Pin B** and **PAR300417-011 - Hinge/Lock Pin A**. Apply a small amount of Loctite 401 on **PAR300417-011** during assembly.
- 11 Align **PAR300417-013 - Lock Lever A**, **PAR300417-014 - Lock Lever B**, **PAR300417-007 - Hinge Lock/Base A** and **PAR300417-008 - Hinge Lock/Base B**, locking all parts together with **PAR300417-012 - Hinge/Lock Pin B** and **PAR300417-011 - Hinge/Lock Pin A**. Apply a small amount of Loctite 401 on **PAR300417-011** during assembly.
- 12 Install **PAR300417-958 - M3x20mm screws** and the **PAR300417-953 - M3 nuts** on the lock lever to finish the assembly.



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- 13 Align **PAR300417-001 - Universal support roll A** and **PAR300417-002 - Universal support roll B**. Glue parts together using a small amount of Loctite 401. Note the proper parts alignment.
- 14 Install the **PAR300417-900 - Ball bearing 629 2RS**. It is a tight fit. If necessary sand the axle to adjust the interference.
- 15 Snap both Universal support roll assemblies into place. They should “click” into the support bed.



- 20 Apply a small amount of **PAR300417-956 - Silicone adhesive** around **PAR300417-023 - Desiccant Window** and place it on the internal recessed frame.
- 21 Fill **PAR300417-016 - Desiccant holder** with **PAR300417-901 - Blue Silica** and close it with **PAR300417-917 - Desiccant cover**.
- 22 Place the Desiccant holder inside the spool holder base, near the front window.
- 23 Install the **PAR300417-960 - 6mm PU hose** into the hose holder.
- 24 Place the spool filament (1.75 or 2.85mm filament) inside; guide the filament through the hose, close the spool holder and lock it.

