



Steps for assembly of a Bukito.

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Definitions and conventions.

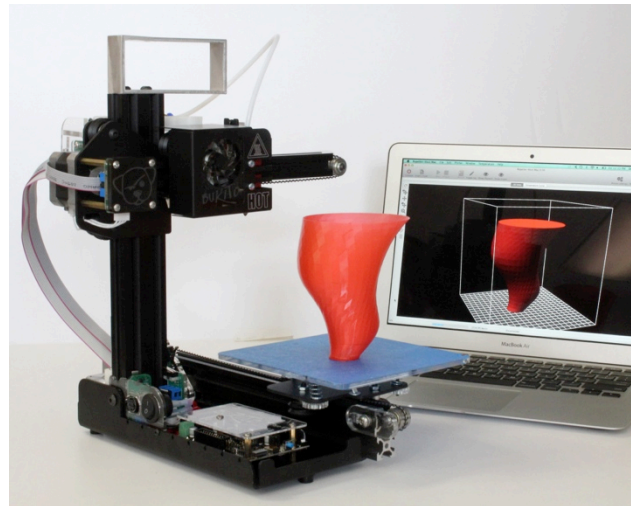
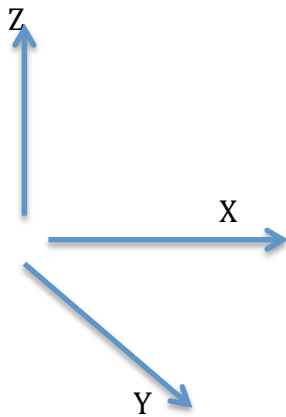
The parts are collected into **kits** (individual plastic bags.) Where possible, we will walk you through all the parts in a kit and highlight the **kit name** in yellow. In some cases we will have you use a few parts from different kits- we will point out where you open a kit for the first time.

The **X axis** runs along the horizontal bar that runs from right to left in this photo. The extruder is carried on the X carriage..

The **Y axis** is the bar that runs underneath the platform (Y direction movement is done by the platform). Or, toward and away from you in this photo.

The **Z axis** is the vertical axis.

The “**front**” of the Bukito is defined here as the end of the Y axis closest from the Azteeg board mount. (Or to put it another way, the Azteeg and other electronics will be in the front, and the power switch will be on the left (See image below of assembled Bukitos– refer back to this if you get lost.) When we say “**left**” or right we mean from the point of view of an observer looking at the machine from the front.



Tools you will need, not included in kit

Phillips-head screwdriver (00 size)

A roll of 3M blue painter's tape ("ScotchBlue") for the platform, if you will be printing in PLA.

Metric allen wrenches (1.5, 2 and 3 mm)

Other items included in kit

We include a piece of nylon filament for cleanout if the nozzle clogs (see www.bukobot.com).

We include a test piece of PLA filament.

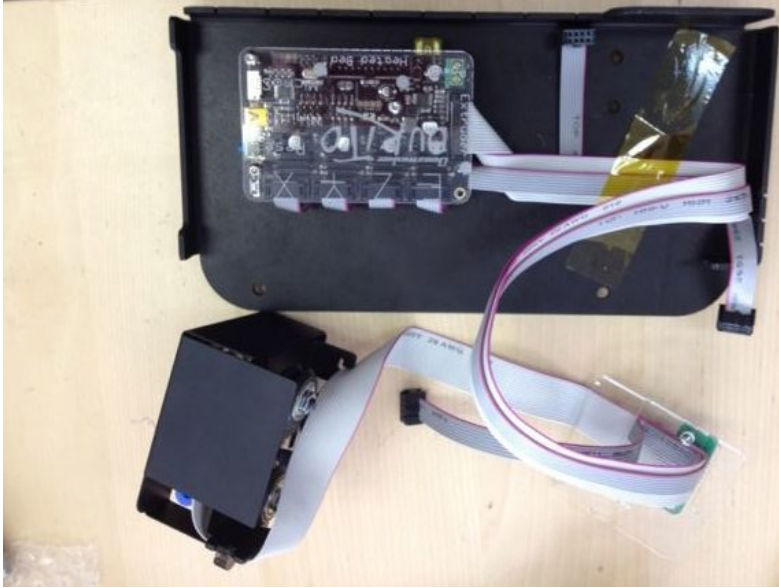
General observations

If you are an experienced assembler of electronics, you may find the following obvious. If not, some notes about assembly in general:

- Many pieces have rectangular and slide nuts. These nuts are designed to lock in the slots in the sides of the aluminum bars. You just need to get them started and they will self-align. The slide nuts should be installed with the protrusion toward the inside of the slot, with the exception of the ones connecting the idlers.
- By and large, it's a bad idea to cinch down nuts on the first pass. We will discuss this as we go.
- Each end stop gets a ribbon cable connection. The other end of these connectors are labeled on the board and also cut to a length that should make them tight connections when allocated correctly. If a ribbon cable has significant slack, it probably isn't the right one! Look at these carefully before beginning.
- Most of the screws are either M3 (3 mm) or M5 (5 mm) size. There are a few small Phillips-head screws.
- Each motor has an end stop; the main board is connected to each end stop with a ribbon cable, and a smaller cable connects each motor to its end stop.
- **IMPORTANT:** In some cases we have shown parts where they *WILL* go to make it clearer how to align them, but the actual connections may be made a few sentences farther down in the instructions. Where this happens we note it. In some cases the prototype parts we used for instructions look a little different or we may switch vendors for minor

parts resulting in cosmetic differences (e.g. color of connectors.) We will note this as we go.

Power switch assembly.

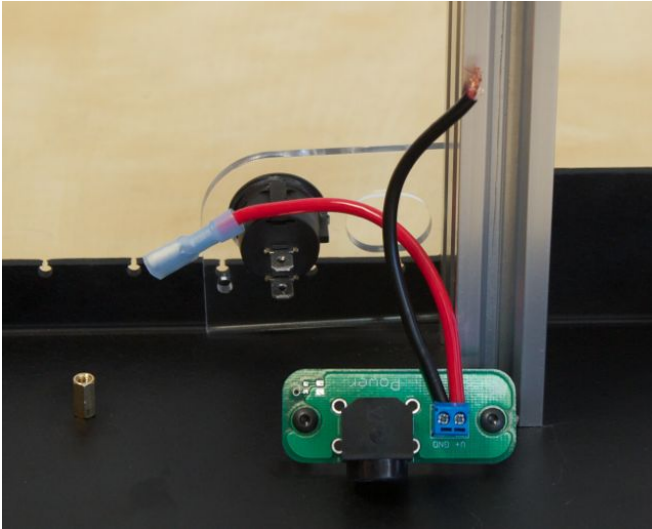


Open the **Power** switch assembly kit.

Gather up the main assembly (baseplate, control board and extruder, with cables) and the two aluminum 11 inch extruded rods.



Attach the acrylic piece with the power switch to the baseplate assembly using the M5 (longer) screw and square nut and then the M3 (shorter) screw. The screw heads should face outward.

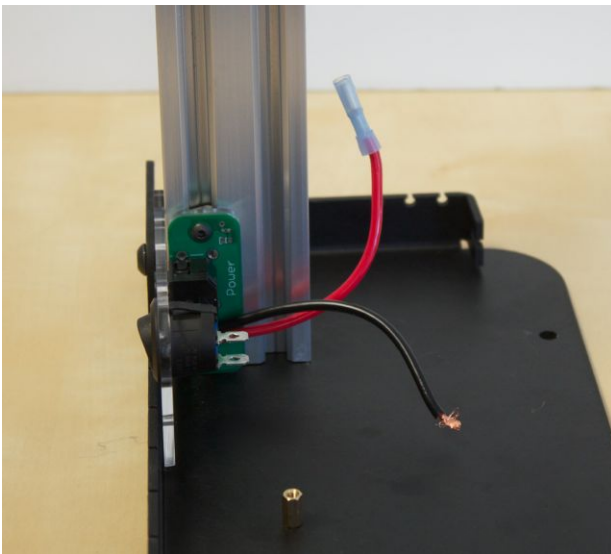


Attach the small acrylic piece to the back of the power connector board (small oval green circuit board) with the two slide nuts and M3 screws. Align the acrylic piece so that the cutouts are over the protruding connections on the board.

Pick up the aluminum bar marked "z axis." (Note: the aluminum bar is shown here attached to the base plate to allow you to anticipate – you should NOT have this bar attached yet. Also, your ribbon

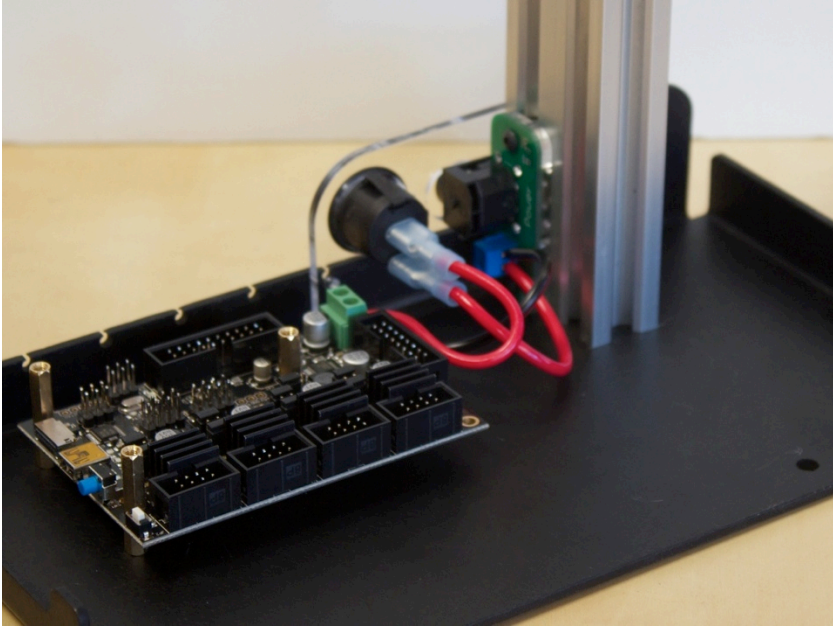
cables will be attached; they are also not shown as attached here in the interest of clarity.)

Slide the nuts into the wider side of the aluminum bar. Slide the green board assembly to near the bottom of the bar.



Note that in this picture the acrylic cover is behind the green board, and the nuts are on the far side slotted into the aluminum bar. It can be a little tricky to handle all the pieces (here, the assembled main electronics board which you will have on your system at delivery is not shown; you should not have attached the z axis to the baseplate just yet.) At the end of this process the Z axis should have the power connector board loosely attached.

Take the power connector board and loosen the small screws in the blue connector box on the green power board with a Phillips head screwdriver just enough so that you can insert the stripped wire ends into the holes at 90 degrees to the small screws. Tighten the small Phillips screws once the wires are in. Be sure there are no stray strands hanging out as this can cause shorts. Twisting the ends a bit before inserting them may help. Red wire goes into the V+ slot and black wire to GND.



Put the rectangular nut on the side of the baseplate into the narrow side of the aluminum bar. Turn the nut sideways so the nut can get into the slot and insert M5 screw into the side of the baseplate (thus attaching the side of the Z axis to the baseplate). Carefully slide down the Z axis over these nuts and attach it to the baseplate. Attach

the bottom of the Z axis with the remaining M5 screws. (You may want to put one screw through the bottom first to help line things up as you lower the Z axis so that you can line up the Z axis without stripping the threads on the aluminum.) Make sure no tape is caught under the Z axis.

Tighten down all sliding nuts and M5 screws but be sure that everything is square first so you don't strip the screw threads.

Take the other **red wire** (not currently attached to anything) and insert it into the **“+” terminal** of the main electronics board (you will need to take off the acrylic cover to do this, which involves taking off three screws with an allen wrench.)

Take the **black wire** from the power plug connector board and attach it to the **“-” terminal** on the main board. Tighten down the small Phillips screws.

Attach the red wire from the main electronics board into the top of the switch.

Attach the red wire from the power plug board into the bottom of the switch.

Reattach the cover of the main electronics board.

Z motor mount.

Open the **Z motor mount** kit.

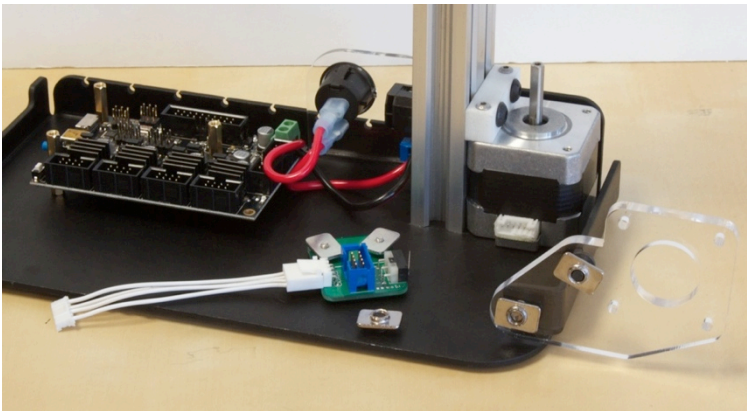
Put in screws from each side into the white block such that the screw tips are closest to the black mark. Put the big black (M5) screws in and out a few times to loosen up the holes a bit. Put the thinner (M3) screws in so they are just flush with the surface of the white block.



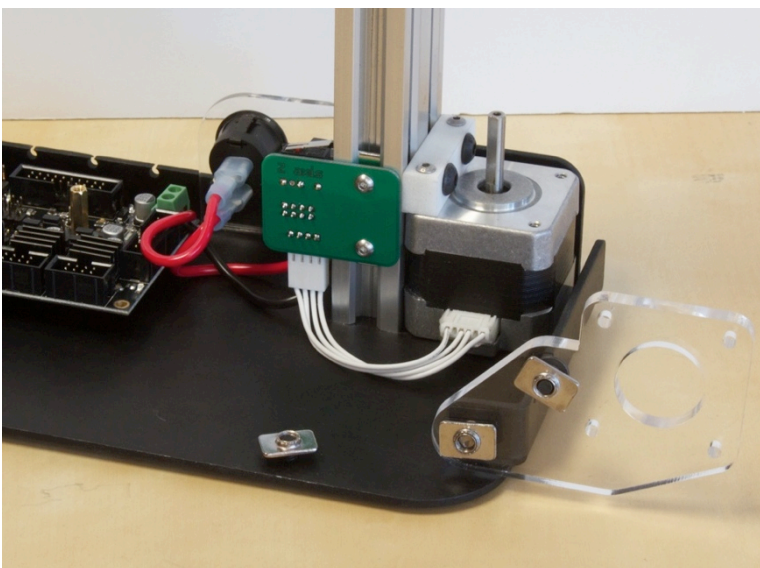
Put the piece on top of one motor such that if the motor connector is toward you, the white piece is on the left with the black line facing out and on top of the motor (the M5 black screw heads should face toward the motor center). The black line will then disappear when it is attached to the aluminum bar. The nuts should be loose so that you can slide them down the Z axis later. Set aside for now.

Z axis kit.

Open the Z axis endstop kit and assemble the screws and acrylic cover such that the acrylic cover cutouts are over the protruding parts of the circuit board. Add the motor cable (thinner cables, not a ribbon cable.) Slide the nuts into the Z (vertical) axis aluminum bar such that the white connector is down. Attach the Z axis insulation displacement connector (ribbon cable- should be appropriate length so that it just fits) into the blue socket. Then press the part until the bottom of the acrylic touches the bottom plate and tighten the screws. **Note: these pictures**



show the Z motor and Y axis clear acrylic support installed. Do not install them just yet - this is just to allow you to anticipate where the part you just put in will be attached later. (It gets hard to see when the other pieces that we are about to put in are installed!)



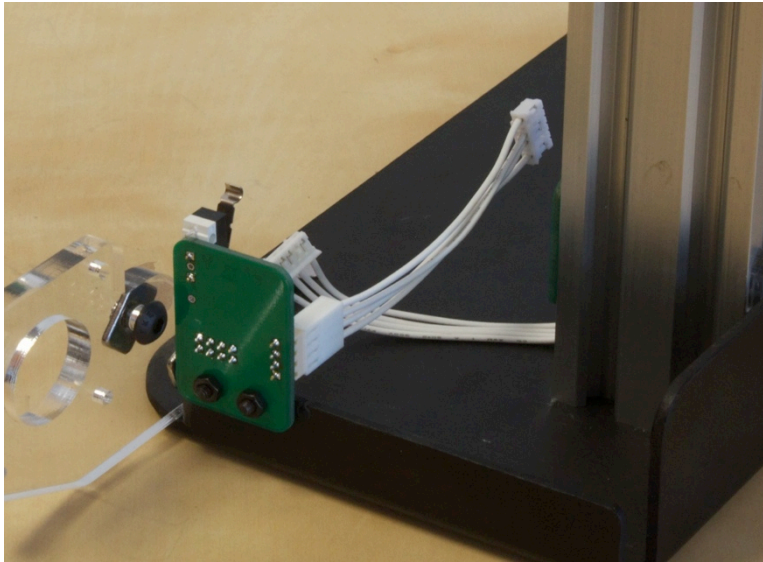
Y axis kit.

Open the **Y axis kit**.

Take the y end stop and attach the motor cable(not a ribbon cable; white here, but black with white connectors in most shipped kits.)Attach it on the outside of the base plate next the acrylic piece with M3 screws. Use the two closest holes to where the acrylic piece will be (see below.)

Note that the board goes OUTSIDE the black metal baseplate, not inside. It's a little tricky to get the nuts on the inside of the board in place- put a washer on the tip of a finger of your non-dominant hand and put it under the hole. Turn the baseplate so that you are screwing the screw in from above and gravity holds that little nut on your finger. Have patience- this is one of the most-fiddly parts of the assembly.

Remove the backing from the acrylic piece. Attach the acrylic piece to the baseplate using the two longest (12mm) M3 screws and two nuts.

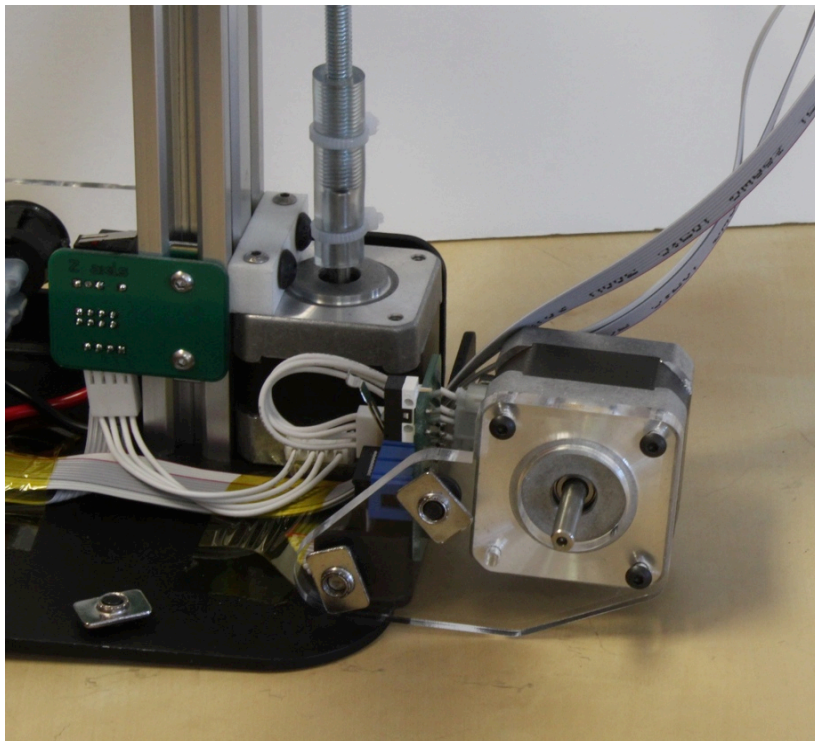
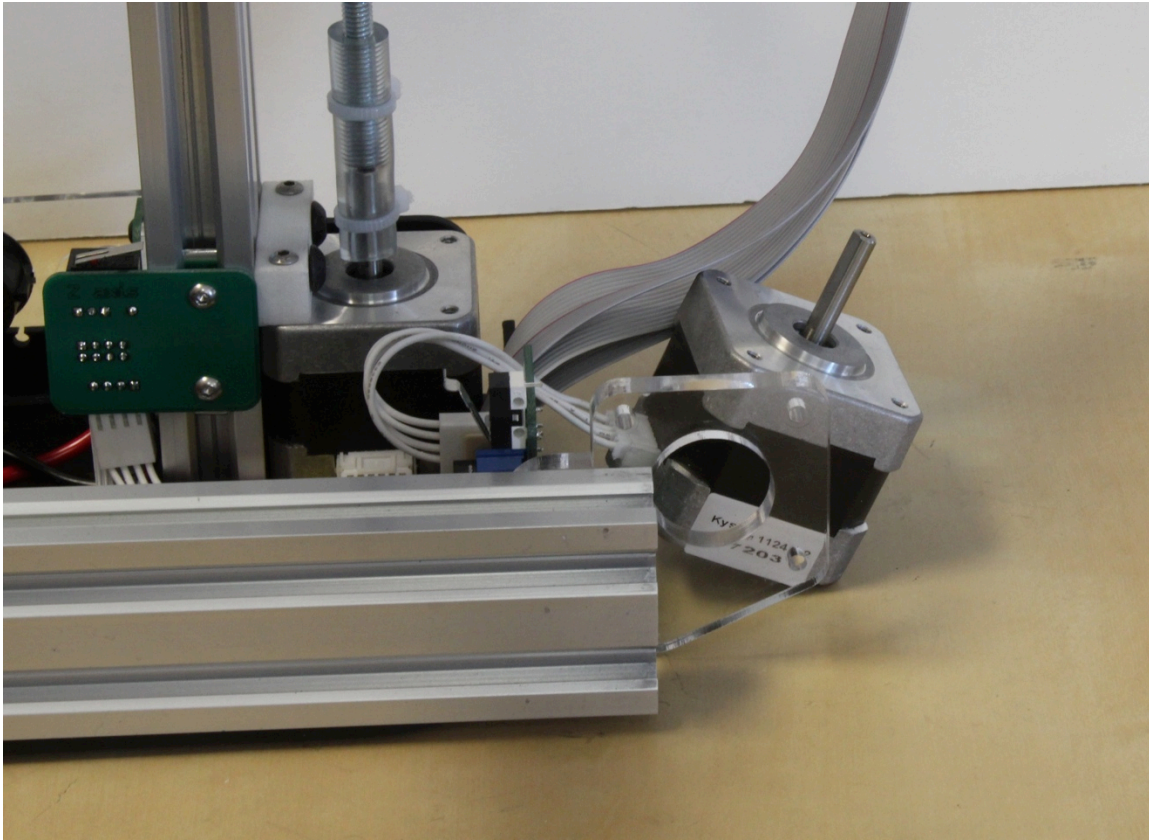


Put the two shorter M5 (10 mm) screws through the holes in the Bukito baseplate and put a rectangular nut loosely on each. The 12 mm will go through the longer hole (through the metal baseplate) and the 10 mm through the upper hole.

Take the other large aluminum bar (which will be the Y axis) and place it over the nuts (two on the bottom of the baseplate and two on the acrylic piece.) Slide until it is just level with the big circular hole on the acrylic piece. Tighten down. Attach the cable from the y motor power board to the y motor.

Take a motor out of the package of motors (NOT the one we worked with before, which is the Z motor.) Attach the ribbon cable and connector for the y motor (trace back to the "y" on the main electronics board) to the y end stop. Then connect the cable from the end stop to the motor.

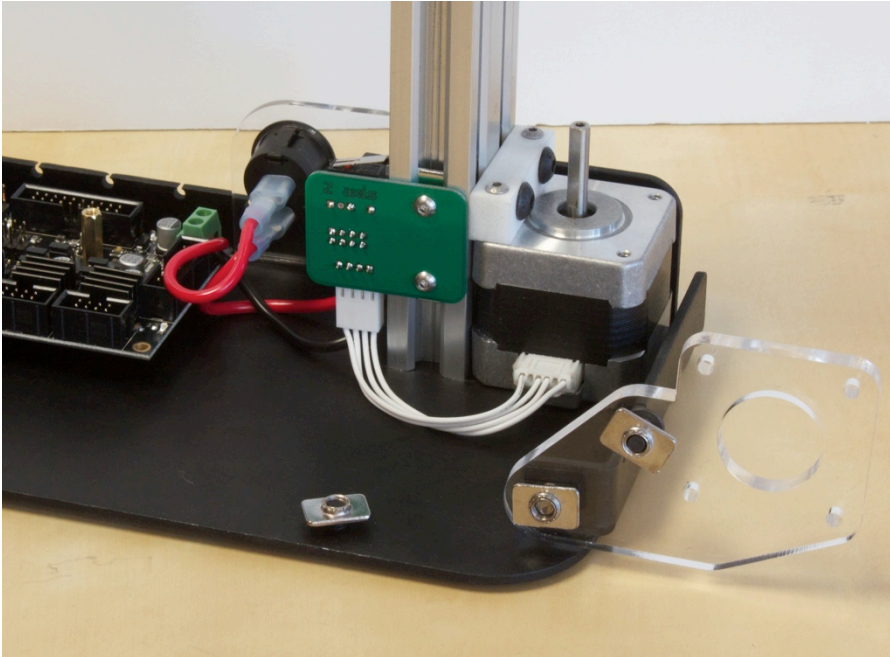
(Note: in this image the z motor and screw is already there to show relative placement for the next two steps.).



The y axis acrylic should be parallel to the y axis aluminum bar. Bottom of the acrylic should be flush with the aluminum bar.

Attach the motor with the three screws provided. We are talking about the motor with the shaft pointed toward us in this picture.

Z motor

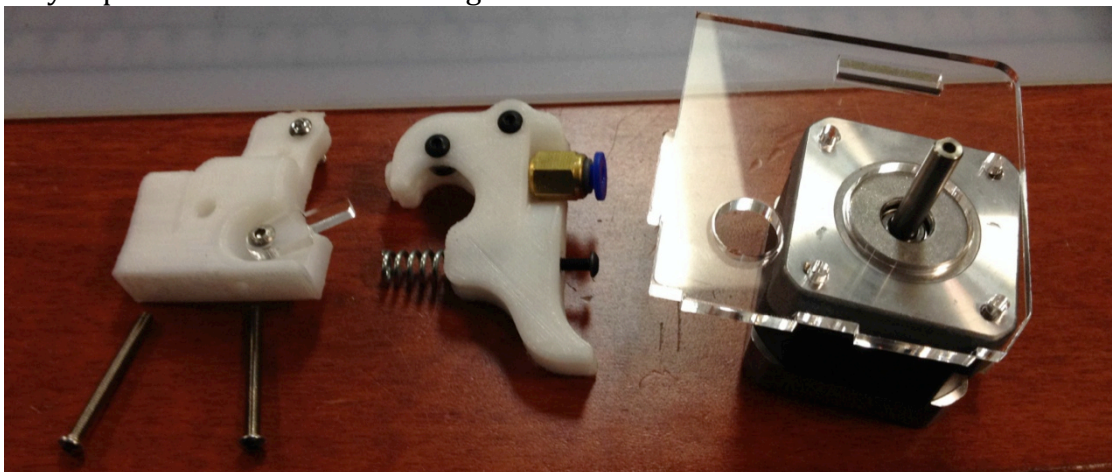


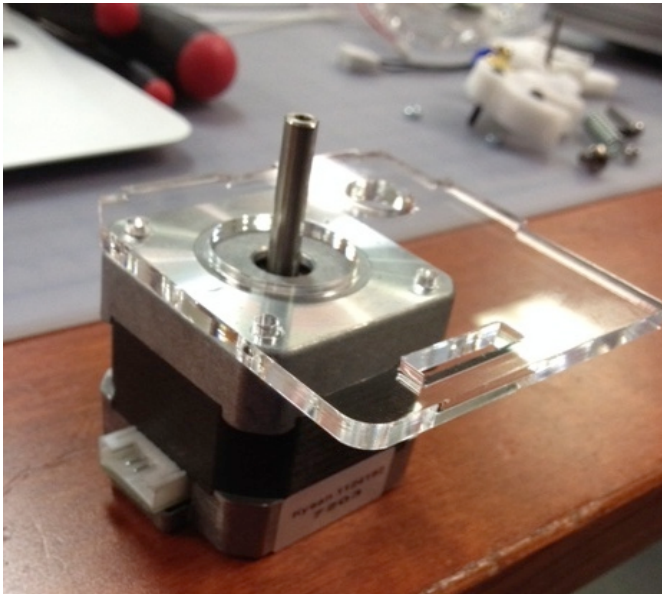
Now attach the z motor by sliding it down the z axis. Attach the connector from the z motor board and tighten the motor down. (Note that you will have the Y axis in place now; this is just to show you more clearly the Z motor connections.) IN

PARTICULAR NOTE WHERE THE Z MOTOR CONNECTION IS PLACED. Otherwise you will have various issues.

Extruder filament drive mechanism

Open the **extruder** drive mechanism kit. Be sure not to lose the small arrow-shaped piece of clear acrylic –the spring (a few steps down) hooks over the narrow part of this small acrylic piece. The next picture shows a semi- exploded view of where the screws go. Note the long thin screws go through and sort of underneath the white acrylic piece without the blue flange.





Take one motor and lay the clear acrylic piece so that shaft pokes through on top with wider end toward the connector. Set the motor and acrylic aside for now but note the orientation, which gets important later. You will be building a three-sided partial box of acrylic around this motor with the white pieces installed on the top of the box.

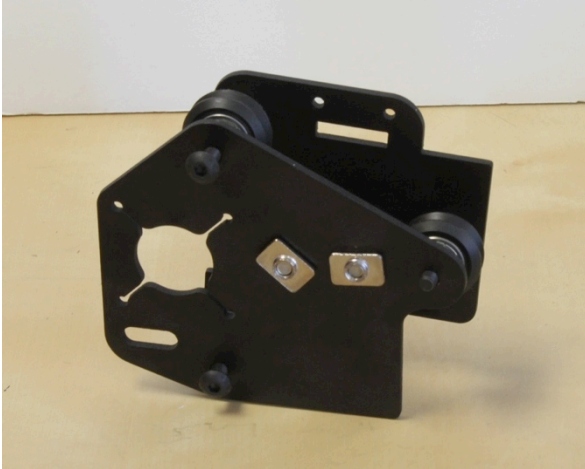


Then, take the white piece shown here. (We will refer to this as "the piece with the blue flange.")

Most of this is assembled for you. Drop in the spring over the screw tip. (Hole is in front of you – screw point is facing toward you in this picture..)

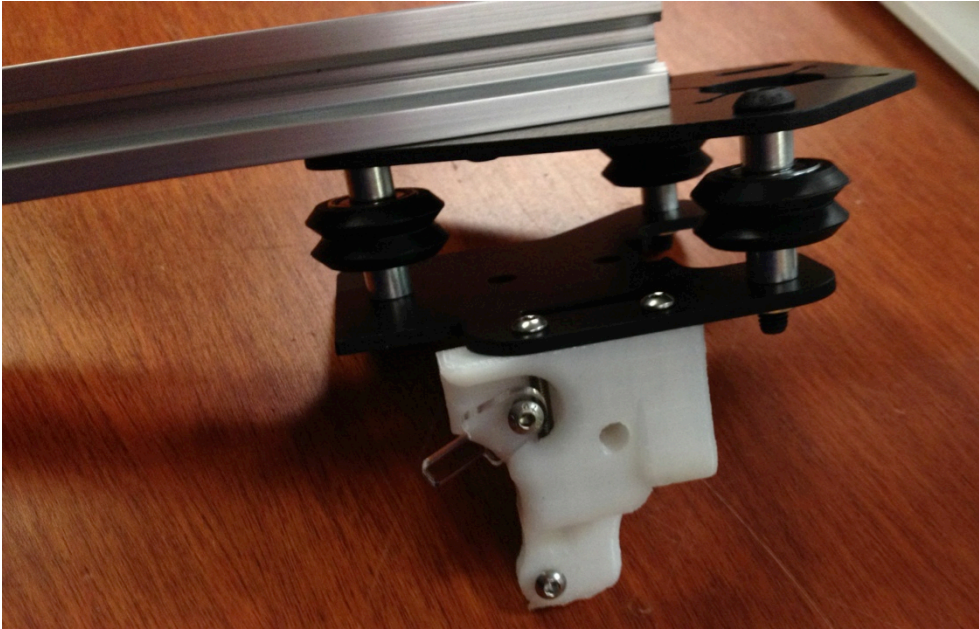
Attaching X axis to extruder drive assembly

Open the **x axis kit** and set aside the X-axis carriage (prebuilt for you as shown.)

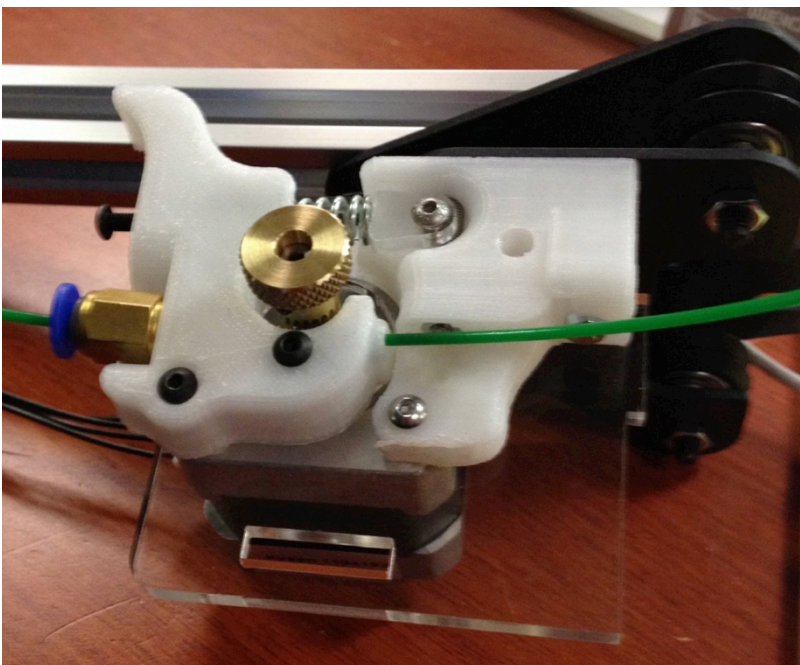


Take the white acrylic piece without the blue flange and attach it to the x axis and carriage using the long screws provided.

Then attach the motor and acrylic mount to the X-carriage assembly.



Take the knurled knob and arrange so that teeth of drive gears are in line where filament will be inserted (through blue flange.) Loosen small black adjustment screw on side and line up with flat part of the shaft. Tighten down. Finally attach the white piece with the blue flange. Compress the spring as you tighten down the piece



to anticipate that you will be running filament through from left to right of this picture. Put filament in to check drive gear alignment. **Pull on the filament; if the gear turns it is set correctly. If not adjust the height of the filament drive gear.**

As shown here the gear top is above the motor shaft by 10 mm or so. To tighten it down align the small black screw on the side of the gear so that it is on the flat side of the

drive shaft. It is about right if the allen wrench (1.5mm) you are using to tighten it rests along the top of the white plastic piece as you tighten the screw. Be sure it is very tight so that there is no slop during operation.



Now straighten out wires and arrange things so that you can get at the wire clamp panel (acrylic piece and board on a ribbon cable, already attached to the main electronics board.)

Attach that panel to the extruder drive mechanism. It will become the left side of a



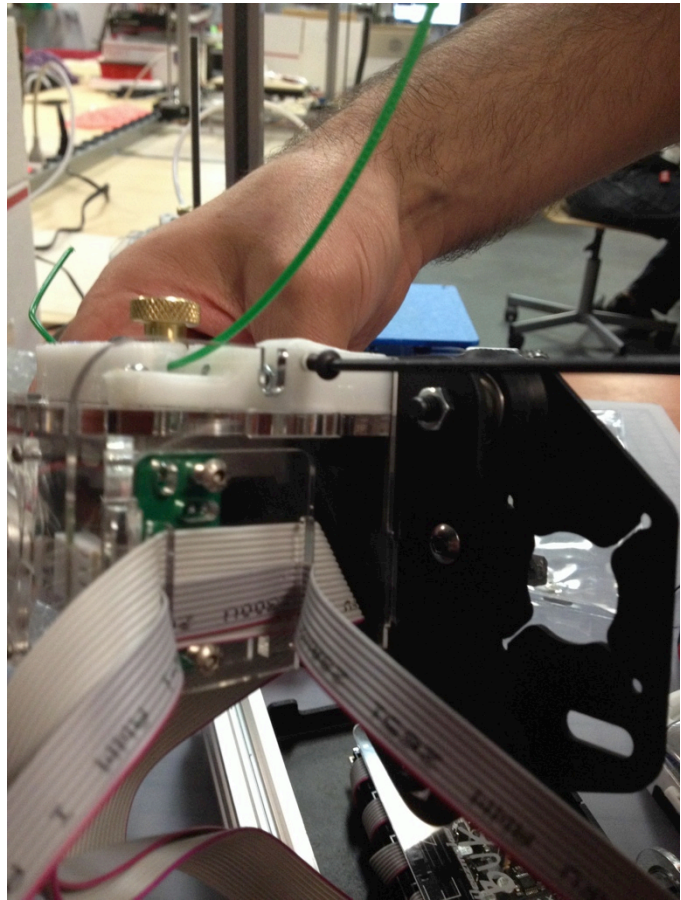
3-sided partial acrylic box around the extruder drive motor assembly.

Plug motor into circuit board on assembly.

Add the fan – attach acrylic piece and press fit into place (far end first).

The fan will be the back of the three-sided acrylic box around the extruder drive mechanism left, front, and top sides. The filament drive gear will be on top. Use tabs/slots and M3 screws to assemble.

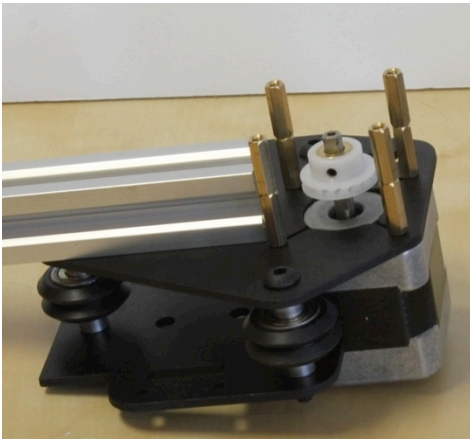
Note there is one critical screw that holds the box together on the side of the box (upper center of picture, being screwed in with black round allen wrench). If you have another person around, this part is easier if done with three hands- two to hold together the three-sided acrylic box and be sure all the tabs are snug, and another to screw in the one screw. Be sure to tuck the ribbon cable nearest the X carriage out of the way and to make sure that all the wires for the fan are clear of the fan blades.



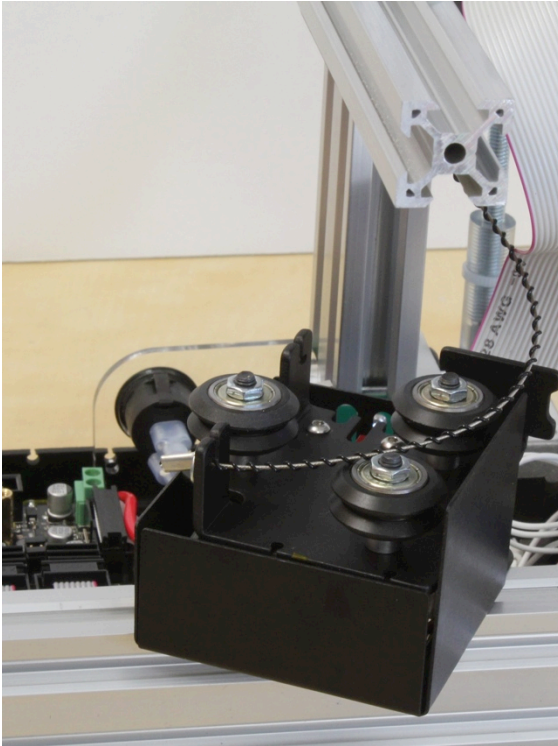
X motor attachment

Take the rest of the parts **the x axis kit** (other than the carriage which you have used already.) The cutout for the motor shaft is the front, and the beam will stick out to the right. The oblong hole should be on the bottom and front.

Mount the x motor onto the rest of the X axis using the standoffs in the kit; be sure the connector faces down (away from the extruder drive assembly we made in the previous sections).



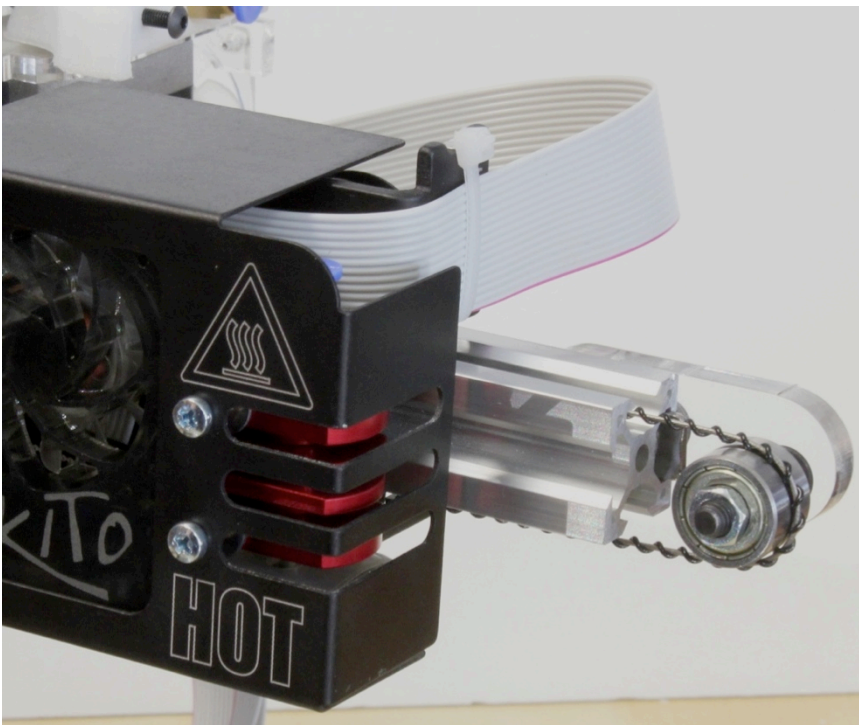
Align the syncromesh pulley (white plastic part) with slot of the extruded aluminum rod. Once it is aligned, rotate the pulley so that the small screw on the side (dark spot on side in image) is on the flat part of the motor shaft so that it can be tightened down. Use a 1.5mm allen wrench. Be sure it is solidly tightened or you will get a lot of backlash when printing if the pulley is loose.



Take the shorter of the two pieces of synchronesh cable and be sure there is a washer on either end. Put the cable in the slot of the top of the x carriage aluminum bar.

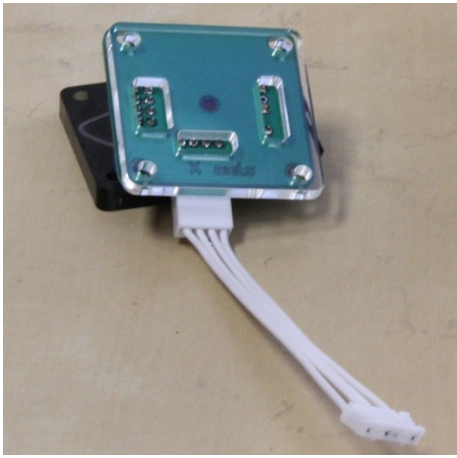
Take the extruder carriage and slide it onto the x axis by sliding the wheels onto the top and bottom slots on the x axis aluminum bar. Be careful to place the wheels over the synchronesh before sliding fully onto the beam. Then hook the synchronesh into the tabs on the bottom of the X carriage. You may have to angle it a bit to get it in. Get the top one that does not have a matching bottom wheel in first and then maneuver the top and bottom pair into place. Be sure the ribbon cable to the extruder is tucked between the extruder motor and the x motor mount. If it's too hard to handle the

synchronesh at the same time as you are getting on the carriage, you can also slip the synchronesh on under the wheels if you lay the washer and tab flat into the slot first.

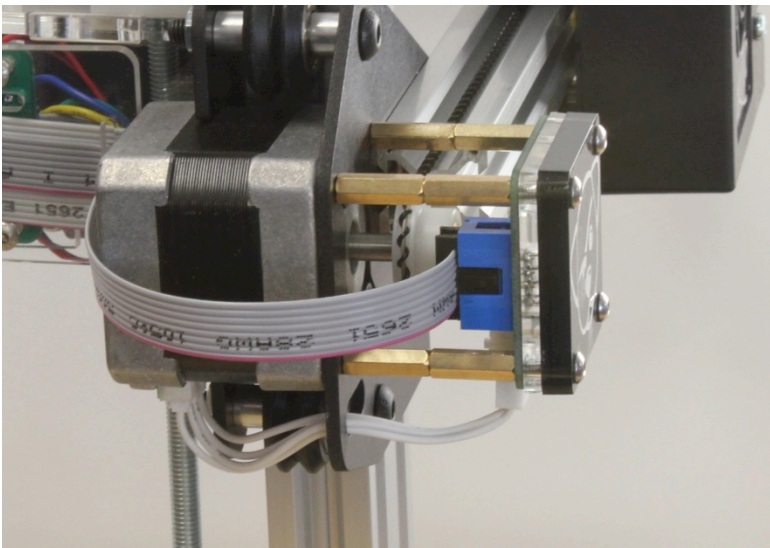


Next take the synchronesh idler (piece of acrylic with a roller) and attach it to the back of the end of the x axis. Adjust the tension of the synchronesh by pulling the idler away from the end of the x axis. Adjust the synchronesh to be tight enough so that it takes some force to tighten down the idler into position. Be sure the synchronesh isn't binding or dragging

anywhere. It should be tight enough that it does not lift off the idler or pulley on the other end – about the same tension as a steel-string guitar string.

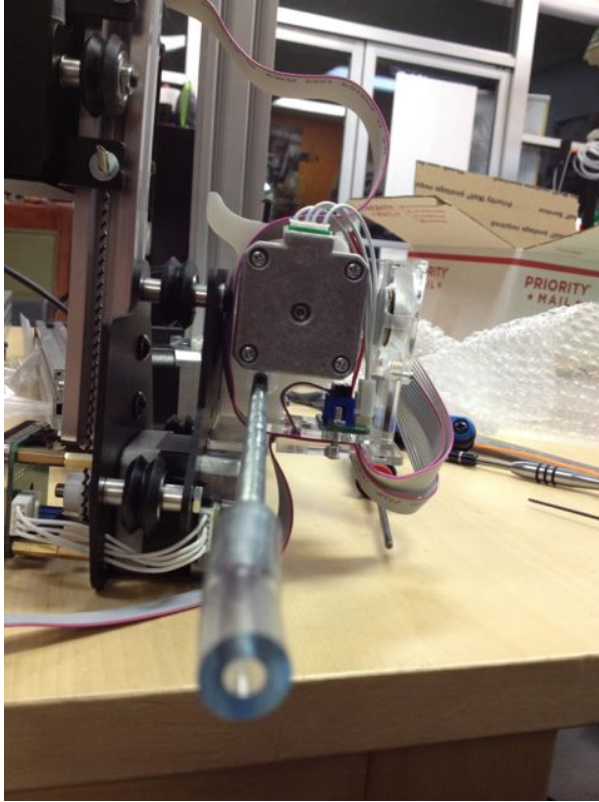


Take the x end stop kit and put the acrylic cover over the circuit board, aligning so that the protruding parts of the board are in the cutouts. Attach the part with the Bukito logo to the other side (facing away from you in this photo.) Be sure to take the brown paper backing off the Bukito logo acrylic piece.



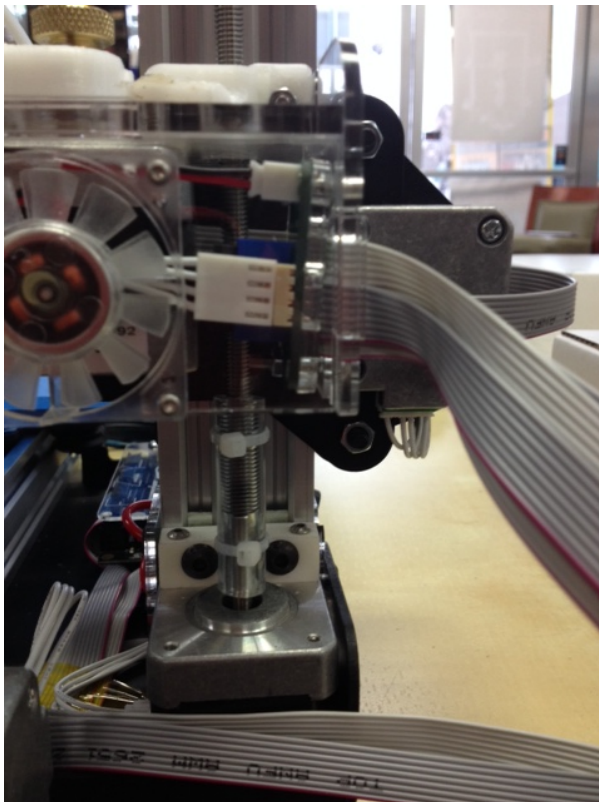
Plug in end stop ribbon cable (should trace to “x” on main board); the motor cable goes through oblong hole black metal plate (near center of image below) Plug in motor cable (ribbon cable) into blue connector. White cable connector will be facing down (be sure the Bukito logo is right-side up before you screw it into the standoffs!)

Z Screw



Put z screw into white plastic of extruder screw assembly. (You are looking up from what will be the bottom of the screw.) Screw into plastic piece until it starts to come out other side.

Slide x carriage onto front of z axis and extruder assembly onto back and be sure that all wheels and z screw align. You might want a friend to help you hold pieces as you do this part.



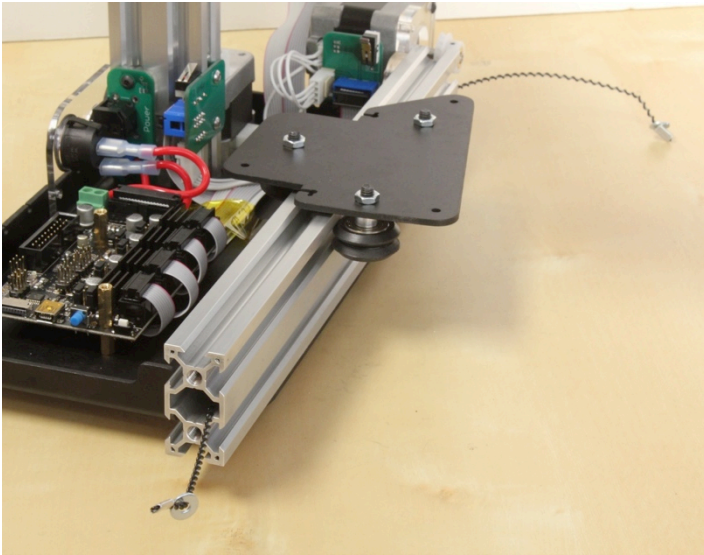
Squeeze plastic tube onto z axis and push down. Squeeze while pushing down so that tube will widen a bit while being forced along.

Put a cable tie on the plastic tube just above the z motor mount white piece and another near the top of the screw cover. Make these as tight as possible to prevent shafts from turning in tube. Be sure to clip off the rest of the cable tie as short as possible (see picture) because otherwise it will bind when the z screw starts to turn.

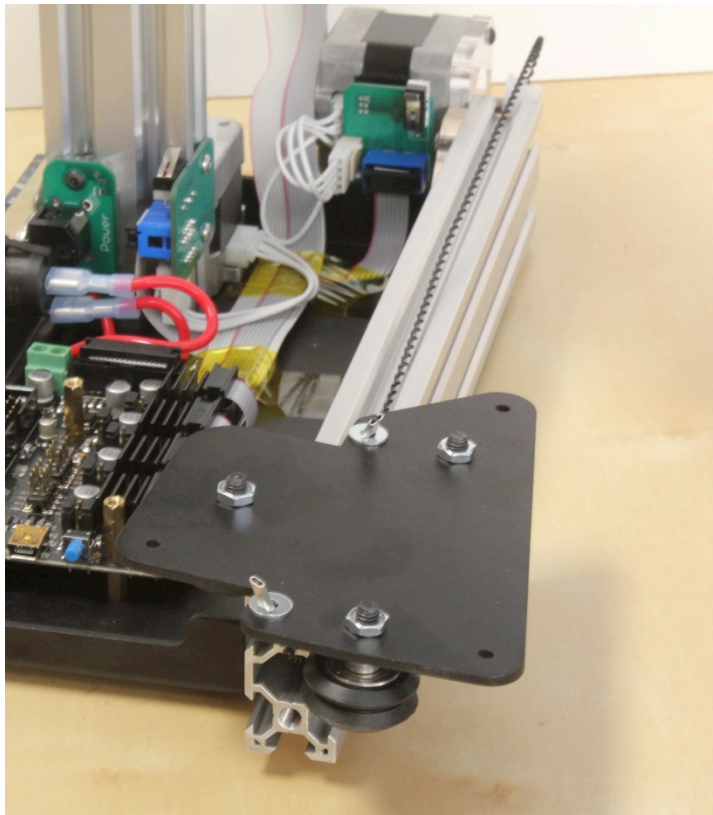
Y platform

Slide the y platform carriage onto the y carriage aluminum bar.

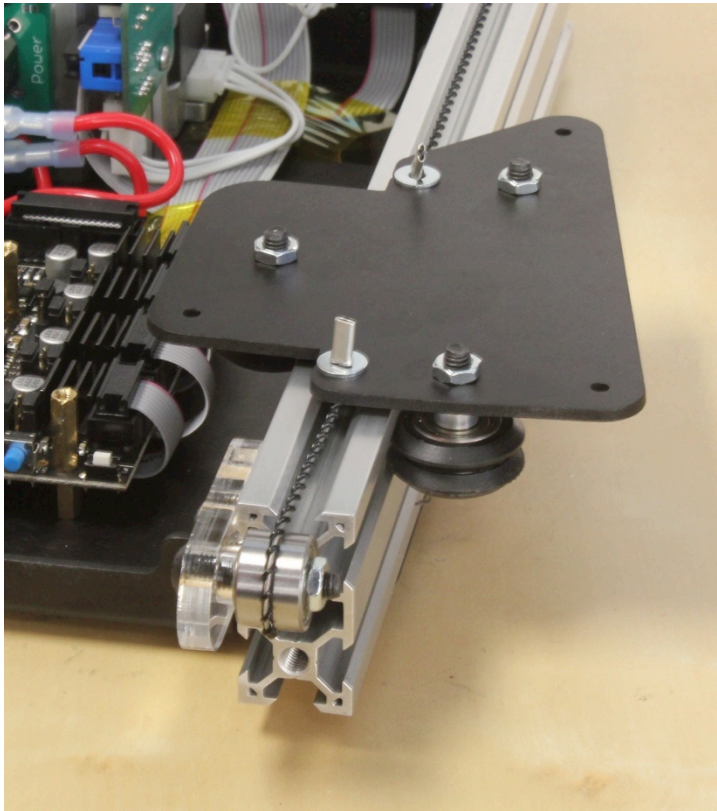
Run the remaining piece of synchomesh through the channel in the MIDDLE of the aluminum rail. Be sure that you have a washer on either end.



Put the synchomesh pulley on the y axis motor and adjust the same way you did for the x axis. Again, be sure it is solidly attached so there is no slop when printing. Remember that the small screw goes on the flat side of the motor shaft.



Hook the synchomesh on the back side of the Y carriage then slide onto rail. Hook front end before sliding all the way.

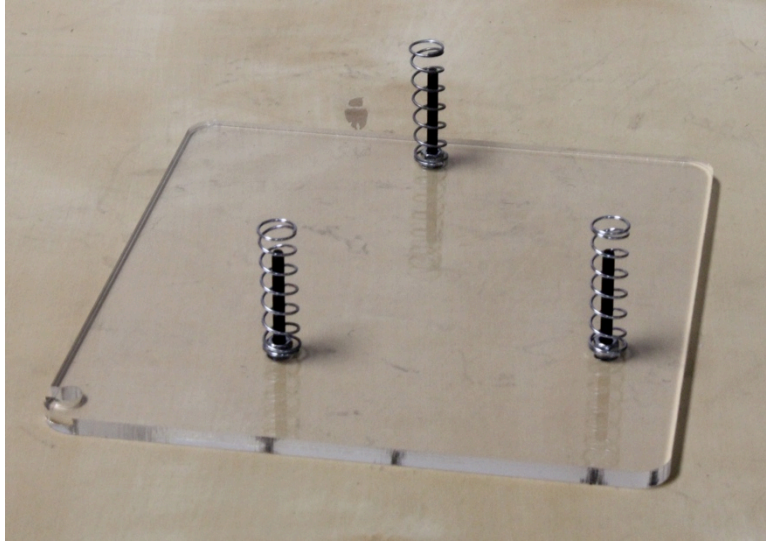


Attach ends of synchronesh to bottom of platform. Attach and adjust idler as you did on the x carriage; put it on the inside of the y axis as shown. The synchronesh should be taut, again like a steel guitar string.

Attaching the platform

Open the [platform attachment kit](#)

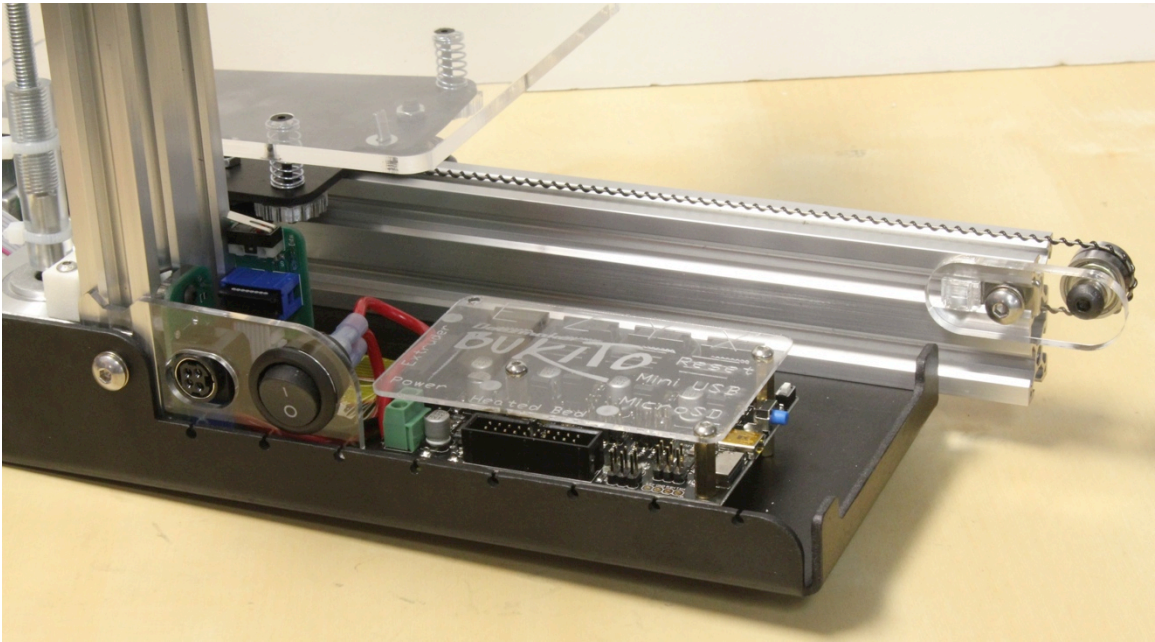
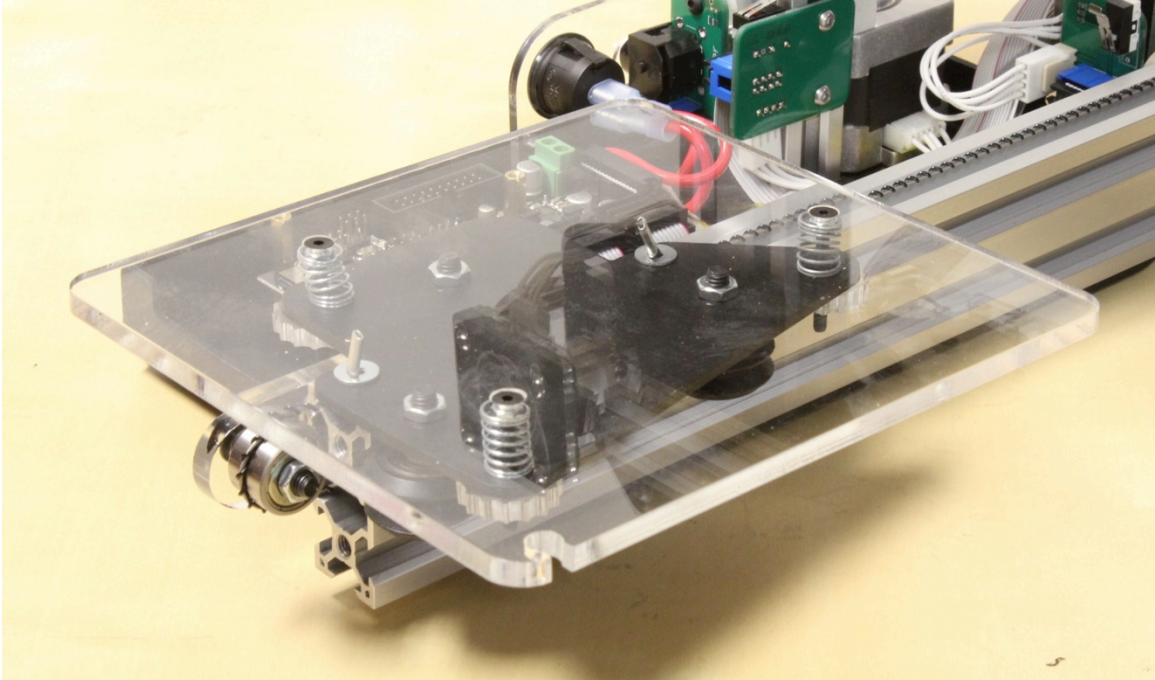
Take the platform (shown here as clear acrylic, but production kits will be made of garolite-LE, a tan linen-phenolic composite.) Put the three long screws, then nuts, and then springs on as shown. Be sure the nuts are on tight so that the screws do not wiggle around.



Take the flower-shaped adjuster wheels and small nuts and drop a washer into the indentation in each gear. Press into place.

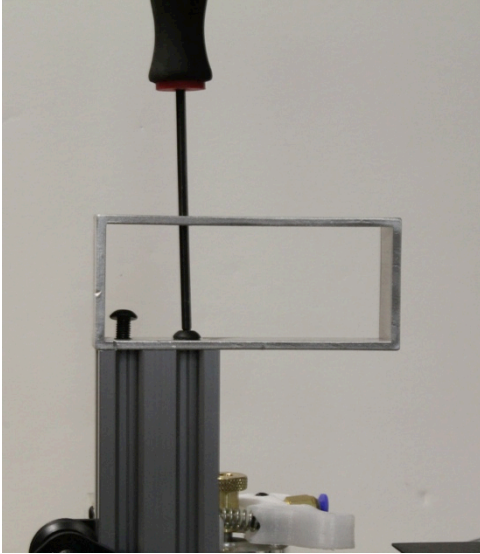


Take the platform and connect it to the carriage as shown. Hold the platform down with one hand and tighten the screws (using the “flowers”) as much as you can. You will back it off later to adjust it.



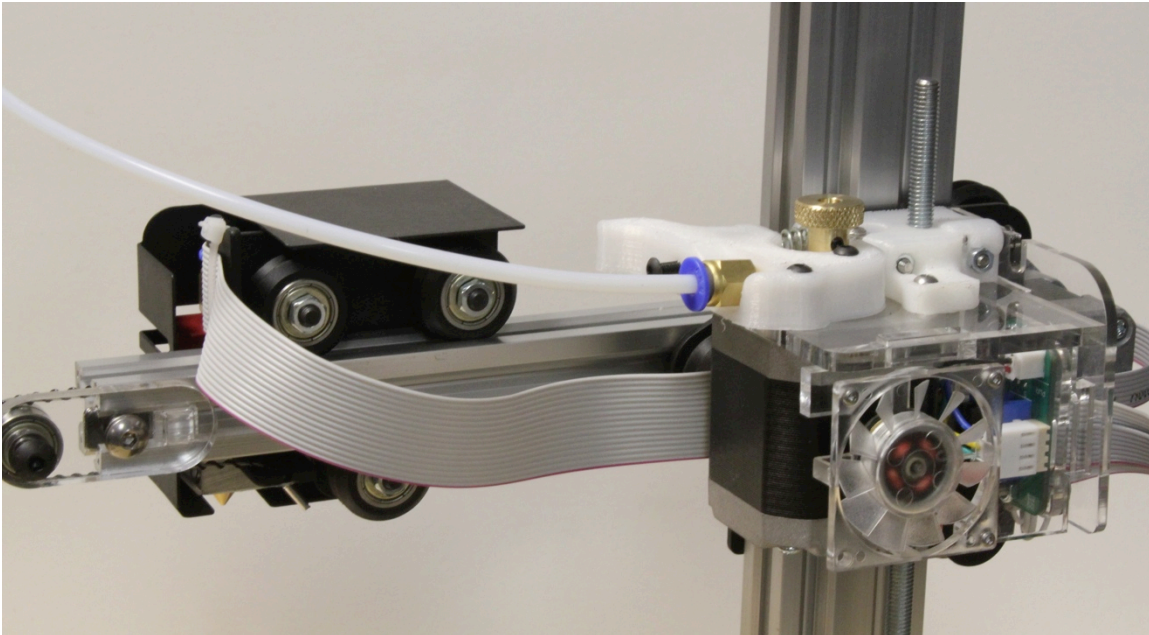
Handle

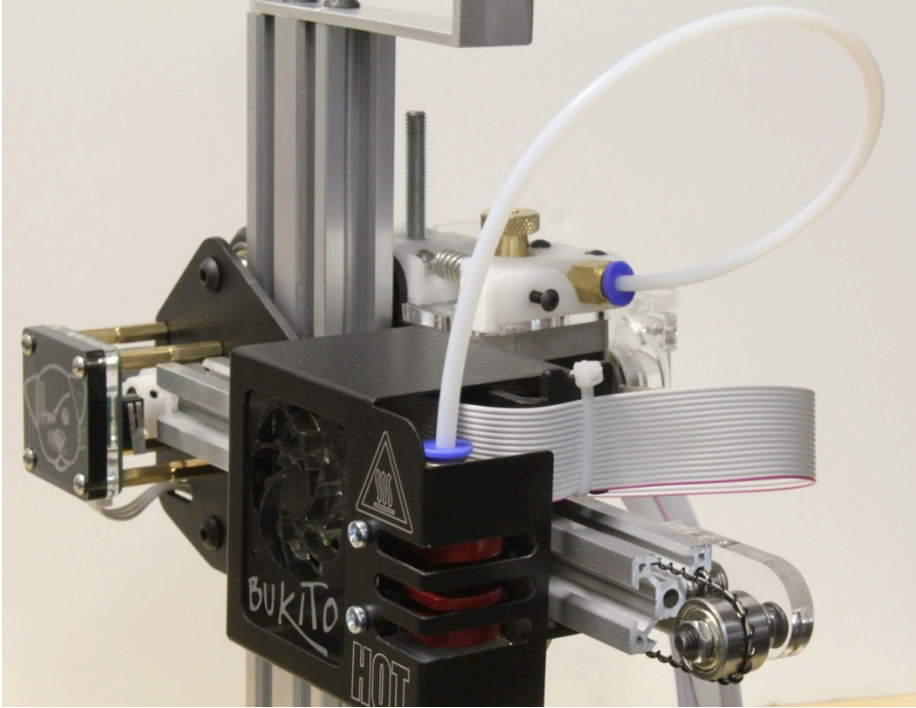
Put on the handle, using the two screws provided. The top holes are meant for clearance for the screwdriver and also for you to add your own 3D printed handle additions if you like.



Filament tube

Attach the filament tube to the blue flanges on the extruder drive assembly and on the extruder block.



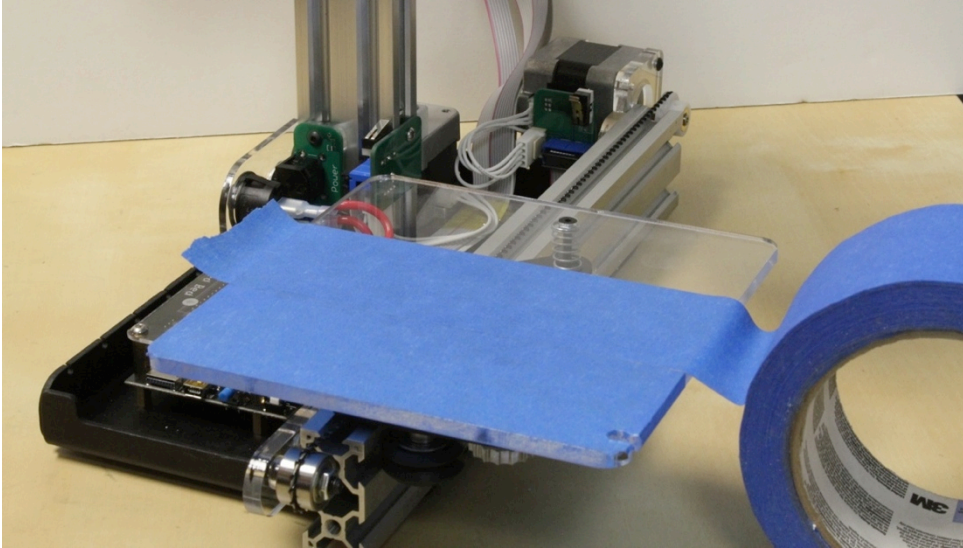


Final cable clearance check

Be sure that the ribbon cables that run from the x carriage down to the main electronics board are clear of the Z screw. Pull them out the back to get them out of the way.

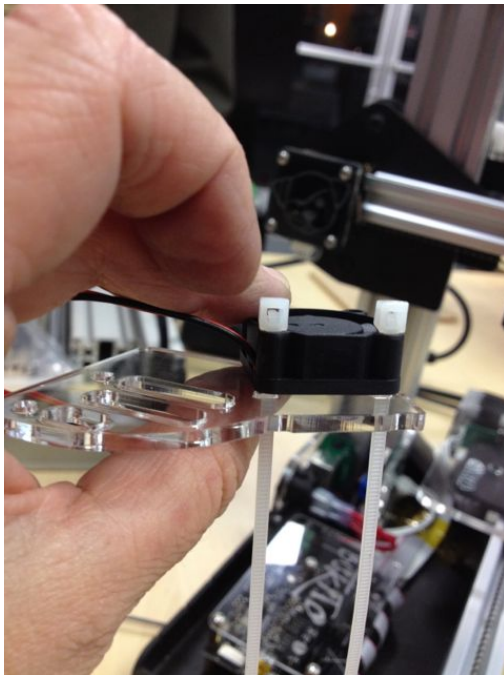
Applying blue tape

If you are going to print in PLA, now put on blue tape; we include one platform's worth of tape. (Garolite as-is works for nylon.) Purchase a roll of 3M "ScotchBlue" painter's tape. (Other brands do not seem to work as well.) This tape is used so that the PLA will stick to the platform. Cover the platform carefully (one layer thick, preferably without lapping or bubbles.) Be sure to punch a little hole for the extruder well. The included tape is intended to go front-to-back.



Add-on PLA cooling fan

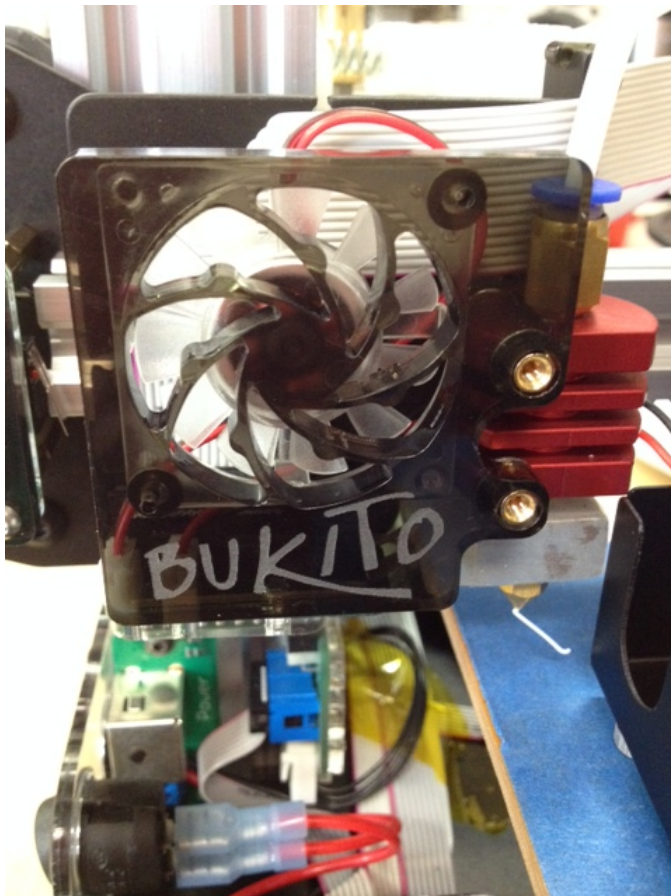
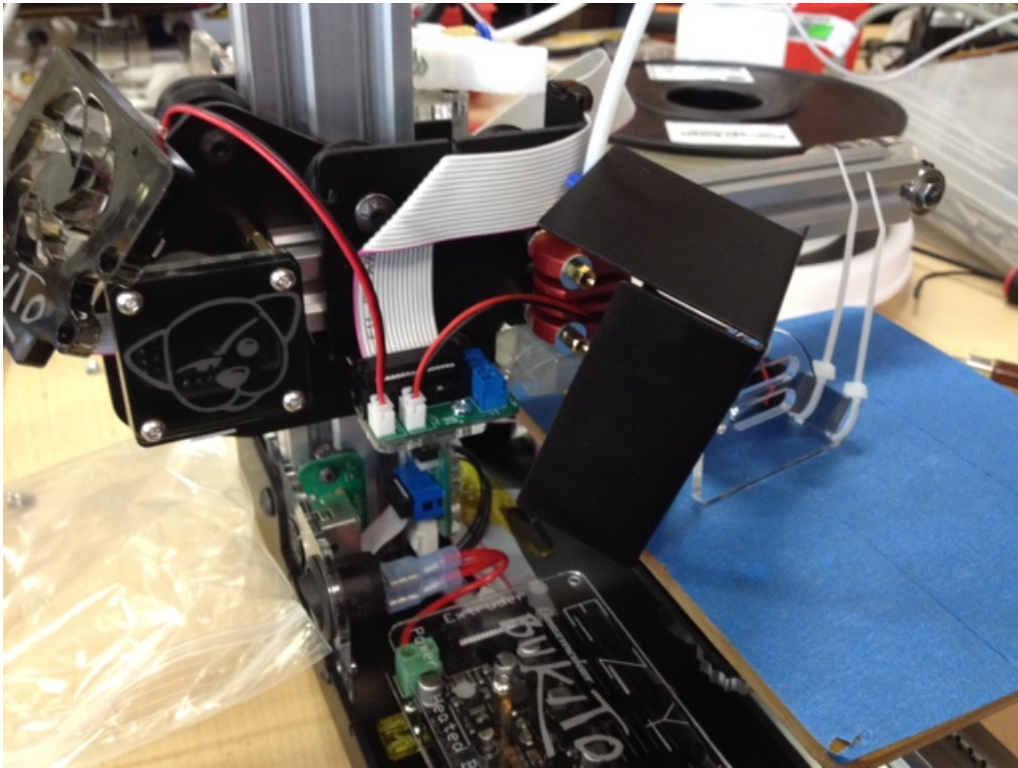
If you have purchased the **PLA cooling fan kit**, you will attach the small fan at 90 degrees to the end of the acrylic piece with two cable ties. The sticker should face down.



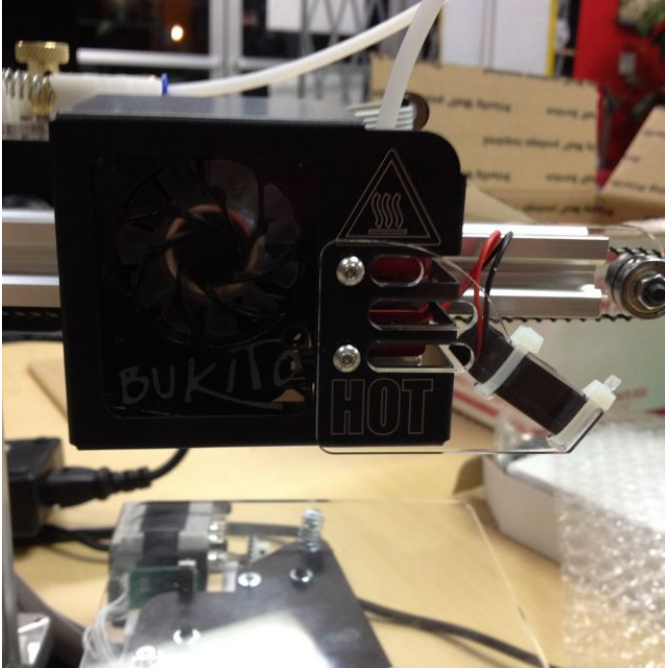
Take off the extruder cover and other fan and plug in the new fan, routing the cables through the covers Trim the cable ties.

Remove the screws holding on the extruder head cover then pull off the other fan, and the fan holder acrylic. Run the power connector for the new fan through the heat vents on the extruder cover and then behind the extruder (between the two standoffs). Be careful not to run any wires where they will impact the fans. Be sure

the wires for any fan do not touch the heater block (the square metal block right above the nozzle.) It is all right for the wires to touch the red heat sink.



Next, clip the original fan back into place over the extruder. Then put the metal cover back and finally the new acrylic. Use the new screws included in the fan kit.



Plug in the power supply.

**Congratulations- you are done! Next, read the "first print"
Bukito directions at bukobot.com.**

