

VORON x Phaeus

Dragon Hotend HF Instructions



Please read and keep the manual carefully before using our products properly.

Product Appearance

Born For Enthusiasts



Thank you for buying Phaeus x Voron Dragon HF Hotend.

Product Features

- Well-designed compact structure
- Superior thermal isolation of heatseek
- Reinforced rigid structure
- High-temperature resistance

Compatible Filaments

Compatible with all Filaments, including: PLA, ABS, PETG, TPU, PP, PC, Nylon, PEEK, PEI, and composite materials containing abrasive additives such as carbon fibers, steel, wood, boron carbide, tungsten and phosphorescent pigment.

Specifications

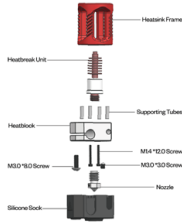
Product Name: Dragon HF Hotend Voron Edition
 Product Size: 26.3mm*19.0mm*45.6mm
 Nozzle Diameter: Can Be Matched Arbitrarily
 Color: Voron Red
 Product Net Weight: 47.17g

Parts & Accessories



M2.5x8 screws *4pcs
 M2.5x12 screws *4pcs
 M1.4x12 screws *2pcs
 H127 / H16 / H20 hexagon bar *1pcs
 H8.0 open wrench *1pcs
 Heat conducting silicone grease
 Brass sleeve

Product Exploded View



Heatseek Frame
 Heatseek Unit
 Heatseek
 Supporting Tube
 M4*12.0 Screw
 M3.0*10.0 Screw
 M3.0*10.0 Screw
 Nozzle
 Silicone Sock

Product Advantage

- Heatseek with an ultra-thin wall thickness as thin as 0.1mm, realizing an excellent thermal insulation.
- Increased rigid support structure guarantee the heatseek remaining intact under the impact of external force.
- Integral frame rigid structure makes nozzle replacement more convenient without grasping the heatseek.
- The inner hole roughness of nozzle and heatseek is Ra0.4, which allow a smoother movement of filament, resulting higher resolution prints.
- Standard hotend and high flow hotend have the same overall dimension, which realize a zero barrier for interchangeability.
- The hotend is mainly composed of copper alloy material which has the advantage of faster heating and better heat dissipation.
- Standard all metal kit, with overall high temperature resistance up to 500 °C.

Supported 3D Printer Models

HF	Compatible with all VB hotend interfaces Prusa i3 MK3/MK3S Titan extruders BMG extruders
ST	Compatible with all VB hotend interfaces Prusa i3 MK3/MK3S Titan extruders BMG extruders

To view the version of this Dragon Hotend product, see the information on the packaging.





Phaeus

欢迎使用
 Welcome
 Bienvenu
 Willkommen
 Bienvenida
 Välkommen


The user guide helps you get started using Dragon Hotend Voron Edition. And discover all the amazing things it can do on a 3D printer.

Assembly Steps

- Use H8.0 open - ended wrench to screw the heatseek into surface A of the heatseek. The torque is about 4.5Nm.
- Install the 4 supporting tubes into the 4 holes at the bottom of the heatseek.

3. Carefully align the 4 supporting tubes of the heatseek with the 4 holes on the A side of heatseek, press them completely. Meanwhile, please note that the top of the heatseek should be completely close to the holes on the top of the heatseek. If not properly aligned, heatseek would be damaged during hot-tightening.
 Note: Heatseek should be properly oriented so that the 2 threaded holes at the bottom of the heatseek are oriented the same as the 2 holes on the A side of the heatseek.
4. In side B of the heatseek (4 holes), screw the 3 screws as shown in the figure below into the corresponding screw holes with the appropriate hexagon bar.
 Attention: Over-tightening of the M1.4*12 screw may damage the thread, or lead to screw fracture and hex nut slip, etc.



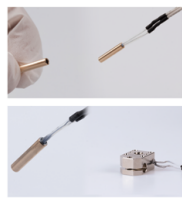

5. Cover the heatseek with the silicone sock.
6. If you are using glass ball type thermocouple, put the thermocouple into the brass sleeve in the attachment first (the brass sleeve is shown in the figure below), and the port should be sealed with the heat conducting silicone grease carried in the attachment, and then put it into the heatseek and lock them with the head screw.




Hot - Tightening

1. Hot - tightening is the last mechanical step before the hotend is ready to use. It is essential for the sealing of the nozzle and heatseek to ensure that molten filaments do not leak out of the hotend during use.
2. Using the printer's control software (or LCD screen) to set the hotend's temperature to 285°C. Wait one minute after its temperature reaches 285°C to equalize the temperature of all components.
3. Gently tighten the nozzle while fixing the heatseek with a wrench, and finally tighten the nozzle with a smaller 7.8mm wrench. This will keep the nozzle close to the heatseek and ensure that the hotend does not leak.
4. The tightening torque of the hot nozzle is about 2.5Nm, which is about the pressure applied by one finger on the small wrench.

ATTENTION: Do not seal the heatseek directly with your hands during heating and within a period of time after heating.



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VORON x Phaeus

Dragon Hotend ST Instructions



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Product Appearance

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Thank you for buying Phaeus x Voron Dragon ST Hotend.

Product Features

- Well-designed compact structure
- Superior thermal isolation of heatseek
- Reinforced rigid structure
- High-temperature resistance

Compatible Filaments

Compatible with all Filaments, including: PLA, ABS, PETG, TPU, PP, PC, Nylon, PEEK, PEI, and composite materials containing abrasive additives such as carbon fibers, steel, wood, boron carbide, tungsten and phosphorescent pigment.

Specifications

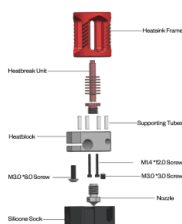
Product Name: Dragon ST Hotend Voron Edition
 Product Size: 26.3mm*19.0mm*45.6mm
 Nozzle Diameter: Can Be Matched Arbitrarily
 Color: Voron Red
 Product Net Weight: 44.17g

Parts & Accessories



M2.5x8 screws *4pcs
 M2.5x12 screws *4pcs
 M1.4x12 screws *2pcs
 H127 / H16 / H20 hexagon bar *1pcs
 H8.0 open wrench *1pcs
 Heat conducting silicone grease
 Brass sleeve

Product Exploded View



Heatseek Frame
 Heatseek Unit
 Heatseek
 Supporting Tube
 M4*12.0 Screw
 M3.0*10.0 Screw
 M3.0*10.0 Screw
 Nozzle
 Silicone Sock

Product Advantage

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 Note: Heatseek should be properly oriented so that the 2 threaded holes at the bottom of the heatseek are oriented the same as the 2 holes on the A side of the heatseek.
4. In side B of the heatseek (4 holes), screw the 3 screws as shown in the figure below into the corresponding screw holes with the appropriate hexagon bar.
 Attention: Over-tightening of the M1.4*12 screw may damage the thread, or lead to screw fracture and hex nut slip, etc.

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