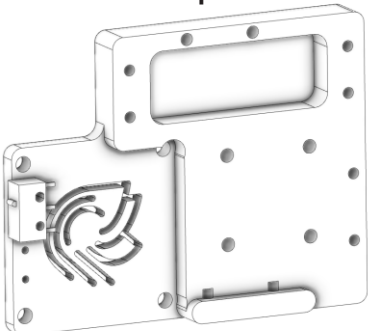




# Hemera Y Carriage Installation Instructions

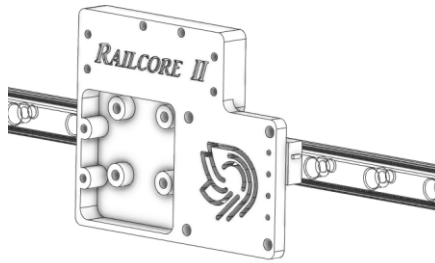
Assemble the hotend assembly in the order shown in the images below.  
Printed parts can be obtained from: <https://www.thingiverse.com/thing:3999571>

## Step 1



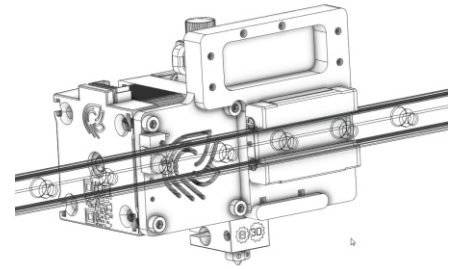
Use the supplied m2x10 screws to install your endstop switch. Please note, there are 4 holes giving you 3 positions for the limit switch. Choose the one you are most comfortable with.

## Step 2



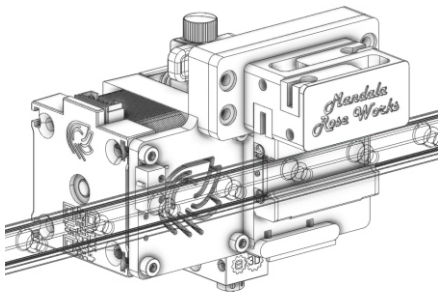
Mount the Hemera Y Carriage to your linear rail with m3 x 10 screws.

## Step 3



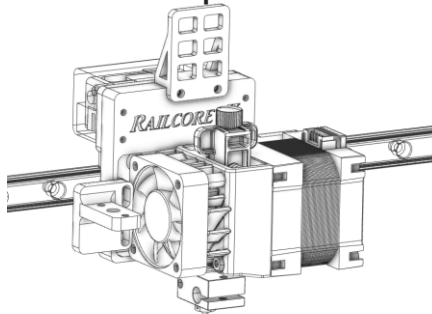
Mount your Hemera to the Hemera Y Carriage with the screws and T-Nuts provided with your Hemera.

## Step 4



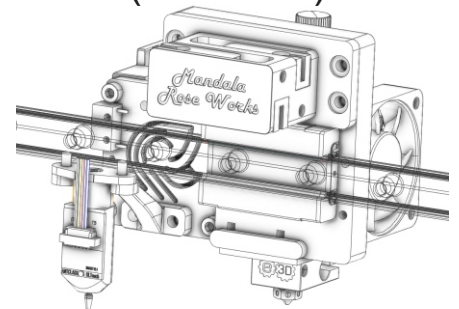
Attach your belt retainer to the Hemera Y Carriage with m3x8 screws.

## Step 5



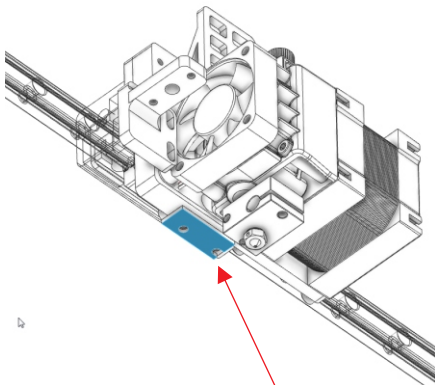
Attach the Printed Carriage Bundle Mount with m3x8, and the BLTouch mount to the Hemera Y Carriage. BLTouch mount will require 2 m3x10 button heads.

## Step 6 (Alternate)



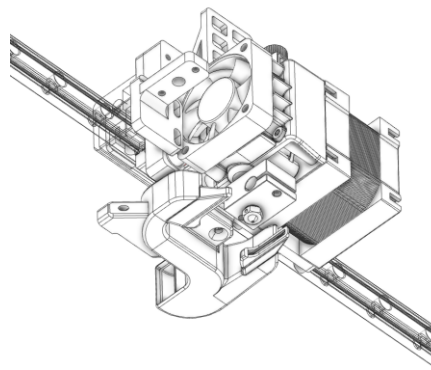
If you want to gain approx 11mm of extra Y range, you can install the BLTouch at the Rear location as shown above.

## Step 7



The spacer will go in this position, then in Step 7 you will attach the "Printed Carriage" version of the James Tongue shroud with 2 m3 screws.

## Step 8



### BL Touch Rear Mount Offset Information

We have determined that if you are using the BL Touch Rear Mount location (see step 6 alternate) that the correct offset is 45mm in X and -40mm in Y. This is the offset from the nozzle tip.

Using the rear mount, you should get approximately 285mm in X, and 290mm in Y. Below are **suggested starting points** for your modifications to **bed.g** in your Railcore configuration for a 300 ZL/ZLT:  
G30 P0 X45 Y0 Z-99999  
G30 P1 X45 Y245 Z-99999  
G30 P2 X235 Y245 Z-99999 S3

**Config.g** will need the G31 line changed to G31 X45 Y-40 Z### P25  
(Insert your Z papertest values in place of ###)

**We do not take responsibility for damage using these settings as it is up to the end user to verify and test all settings during final setup.**