INTRODUCTION
• **Target:**
  
  Propose a visual assembly instruction guide of the MicroDelta Rework.

• **Designers of the MicroDelta Rework:**
  
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• **Photographic credits:**
  
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• **Update:**
  
  Last update : 10/02/2017

• **Links:**
  
  You can find more informations on the following links :

  eMotion Tech’s website : http://www.emotion-tech.com
  RepRap community : http://reprap.org/wiki/reprap

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
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In case of trouble, please follow the FAQ available on our website, in the «Support» section.
MICRODELTA REWORK INTRODUCTION

The MicroDelta Rework is developed by eMotion Tech. This new 3D printer is easy to assemble and to operate without loss of performances.

Data sheet :

DATAS

- Printing surface : Ø150x200mm
- Layer height : [0.1 - 0.4]
- Electronic type : eMotronic (32 bits, 96 MHz)
- Motors : NEMA 17
- Belt type : GT2
- Extrusion Head : Hexagon 0.4
- Dimensions : Height 440mm, Width 250mm, Depth 250mm
- Nominal printing speed : 80mm/s
- Max speed : 200mm/s
- Nominal travel speed : 150mm/s
- Average precision (X,Y) : 100 microns
- Average precision (Z) : 50 microns
- Operating system : Windows, Linux and Mac OS
- Consumable : PLA 1.75mm (or ABS and others plastics with heated bed option)
- PROVIDED with Repetier-Host pre-configured for µdelta
- Connectivity : USB
- Power supply provided : 24V, 150W

STRUCTURE

- Upper and lower plates made of bended stainless steel
- Machined aluminium core
- 10mm rectified Smooth rods
- Plastic injected sliders

ERGONOMY

Easy to mount : A 3D printer kit with an intuitive assembly
- Simple electronic, no soldering
- Easy wiring and assembly
- Belt adjustment with ergonomic belt tensioners

Easy to calibrate : A simplified software
- Fully software calibration
- Pre-configured open-source software (no firmware upload required, Repetier Host and Slic3r pre-configured)

Easy to maintain
- Quick height adjustment with the software
- Easy to reload the filament
Documents and guides

User guide

How to use the MicroDelta Rework?
Under Windows and Linux: Windows / Linux User Guide
Under Mac OS X: MAC OS X User Guide

Other resources

Configuration files
Path: MicroDelta Rework > Logiciels-Software > Configuration

3D resources
Diferents 3D printed parts are availables for the MicroDelta Rework.
Path: MicroDelta Rework > Ressources_3D>

IN CASE OF TROUBLE

Frequently Asked Questions
Path: «Support» section.
Link: Frequently Asked Questions
In order to upgrade your printer to make its use more pleasant, it is possible to add different elements:

- Heating bed kit up to 110°C
- LCD controller screen to print without a computer

Coming soon:

- Lighting LED designed for the Micro Delta Rework
- Dual extrusion head for bi-color printing
SAFETY INSTRUCTIONS

General safety instructions

NEVER LEAVE THE PRINTER WORKING WITHOUT SUPERVISOR.

The nozzle can reach 270°C, do not touch the nozzle while the printer is working.

A supervisor is needed when the printer is used with young people.

KEEP PRINTER AWAY FROM CHILDREN AND ANIMALS

Operate in a ventilated room. Plastic vapors effects are not known. In case of use in a closed room, we recommend the use of an extractor fan.

The addition of protections is your own responsibility. Safety can be improved by:

• An emergency stop button
• Housing protection
• Smoke detector

Electrical safety

The power supply provided is labelled CE. The power supply is protected against short-circuit and do not need any modification. The µdelta operate at 12V and is not concerned by the low voltage directives.

Further informations

Informations above are not exhaustive.

We used sources of informations that we consider reliable. However, we cannot guarantee that all these informations are true and complete.

We assume no liability for loses, injuries or damages due to assembly, transporting, storage or removal of the product.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
ASSEMBLY

BILL OF MATERIALS

A. Metal parts

1 x Core
1 x Upper plate
1 x Lower plate
6 x Ø 8 x 430mm smooth rod
1 x Cowling

B. Plastic parts

6 x Connecting rod
3 x Slider

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**ASSEMBLY**

**C. Printed parts**
- 1 x Hexagon Holder
- 1 x Hexagon bracket
- 2 x Fan duct
- 1 x Board cover
- 1 x Leveling sensor holder

**D. Mechanical parts**
- 3 x GT2 Pulley
- 3 x GT2 belt
- 12 x Plain bearing
- 12 x Ball joint
- 1 x thrust roller bearing AXK5070
- 2 x Olive compression fitting
- 3 x Idler pulley 623zz kit

**E. Hardware**
- 6 x M2.5x8 Screw
- 2 x M2.5x12 Screw
- 29 x M3x8 Screw
- 14 x M3x12 Screw
- 4 x M3x20 Screw
- 12 x M6x16 Screw
- 16 x M3 Washer
- 2 x M3 Knurled nut
- 1 x M5x12 Knurled screw
- 10 x 3mm Spacer

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
H. Kit Hexagon (printhead)

1 x Hexagon hotend
1 x Cartridge heater 100mm
1 x Thermistor
1 x Allen key 3
1 x wrench 4.5

1 x Silicone cap

H. Other

12 x Cable clamp
6 x Rubber foot
1 x PTFE Tube
3 x Elastic band

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
LIST OF NEEDED TOOLS

• Wrench 5.5; 8; 9; 10.
• A set of allen key (fournie)
• Cutting pliers
• WD40
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
-needed parts:
- 3 x Slider
- 6 x Rod ball
- 12 x Plain bearing

**Target:** screw the 6 ball joints (2 per slider) as shown in the following figures.

1. **Result**
2. **3X**
   *: do the same for all sliders.

Do not over tighten as this may damage the thread.
**MECHANICAL ASSEMBLY**

**Target**: insert the plain bearings in their housing as shown below (4 pieces per slider).

3

![Diagram showing a slider with plain bearings](image)

**Slide**: Plain bearing

**Result**: 3X*

* : do the same for all sliders.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
MECHANICAL ASSEMBLY

PRINTERHEAD ASSEMBLY

1°) thermistor into the heating block (fold the thermistor’s cables)
2°) silicon sleeve on to the heating block
3°) heater cartridge into the heating block
4°) grub screw in the heating block
5°) Unscrew the brass insert (not used)

Caution ! If the thermistor goes out of the hot end, your printer could be damaged.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Result

Thermistor

Heating cartridge
UPPER PLATE ASSEMBLY

Needed parts:
- 1 x Upper plate
- 3 x Idler pulley
- 3 x Endstop
- 3 x Ø 3 mm spacer
- 3 x Ø 3 mm washer
- 3 x M3 x 12 mm screw
- 3 x 623zz bearing
- 6 x M2,5 x 8 mm

Target: Mount the pulleys on the upper plate

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**MECHANICAL ASSEMBLY**

**Target**: mount the endstops on the upper plate

Each endstop connector has a different color:

- Alpha axis endstop: red
- Bêta axis endstop: blue
- Gamma axis endstop: yellow

Be sure to mount each endstop on its dedicated location. Respect the color code.

> Pay attention to the direction of mounting.

Endstop’s steel blade should be directed outward from the plate.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Make sure the 3 pulleys rotate freely.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
If you have the HeatBed option, please go to the page 72 to mount this element!
LOWER PLATE ASSEMBLY

Needed parts:
- 1 x Lower plate
- 3 x Short motor
- 16 x M3 x 8 mm screw
- 12 x Ø 3 mm washer
- 3 x GT2 pulley
- 4 x M3 x 12 mm screw
- 1 x 3 cm fan
- 1 x On/Off switch
- 1 x «Reset» button
- 4 x Ø 3 mm spacer
- 1 x eMotronic board

Target: mount the stepper motors on the lower plate

Repeat the operation on the two other towers & check the motor’s orientation using the connectors as reference.

Allow gravity to drop the motor to the bottom of the notch and pre-tighten a single screw to hold the motor in this position.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: mount GT2 pulleys on the motor’s axis

The grub screw must be in contact with the flat side of the axis.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: repeat steps 2, 3 and 4 on the other two peaks of the lower plate.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

**MECHANICAL ASSEMBLY**

**Target**: fix the electronic board fan like shown below

Pay attention to the mounting direction of the fan, for proper orientation use the notches as reference.

- **M3 x 12 mm screw**
- **3 cm fan**
Target: mount the On/Off switch and the «Reset» button on the lower plate.
Target: install the eMotronic board and its protective cover.
Add rubber feet

In case of trouble, please follow the FAQ available on our website, in the «Support» section.

MECHANICAL ASSEMBLY
EXTRUDER ASSEMBLY

Needed parts:
- 1 x Extruder cover
- 1 x Body extruder
- 1 x Extruder mobile
- 1 x Driving wheel
- 1 x M5 x 12 mm Knurled screw
- 1 x Ø 3 mm washer
- 1 x 693zz bearing
- 1 x M3 x 8 mm screw
- 4 x M3 x 20 mm screw
- 1 x Long motor
- 1 x Spring

Target: mount the extruder

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

Body extruder

Spring
MECHANICAL ASSEMBLY

Place «Extruder Mobile» on «Body extruder.»
The spring should remain in its place.

Extruder mobile

Body extruder

Result

Screw the knurled screw slightly

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
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In case of trouble, please follow the FAQ available on our website, in the «Support» section.

Driving wheel

M3 grub screw

approximately 0.5 mm

The grub screw must be in contact with the flat side of the axis.

Result
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

---

**CORE ASSEMBLY**

Needed parts:
- 1 x Core
- 6 x ball joints
- 3 x 3 cm fan
- 4 x M3 x 8 mm screw
- 3 x M3 x 12 mm screw
- 5 x M3 x 20 mm screw
- 2 x Fan duct
- 3 x Ø 3 mm spacer
- 1 x Hexagon holder
- 1 x Hexagon bracket

**Target**: mount the ball joints on the core

1.

**Target**: mount the printhead’s fan

2.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: mount the 2 other fans

Pay attention to the orientation of the fans.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: mount the interface board on the core

Ø 3 mm spacer

Result

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: mount the Hexagon holder on the core

- **M3 x 12 mm screw**
- **M3 x 8 mm screw**

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
MECHANICAL ASSEMBLY

Target: mount the printhead and the bracket

Hexagon printhead

Hexagon bracket

Printhead cables side (thermistor and heating cartridge). To use as reference for the printhead orientation.

Result

Printhead cables routing

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: connect core's components on the interface board

- Heating cartridge
- Thermistor
- Secondary fans
- Secondary fans
- Secondary fan 2
- Secondary fan 1
- Printhead fan
- Printhead fan

Don't use these connectors
FINAL ASSEMBLY

Needed parts:
- 1 x Lower plate
- 1 x Upper plate
- 1 x Cowling
- 6 x Smooth rod
- 12 x M6 x 16 mm screw
- 7 x M3 x 8 mm screw
- 3 x Slider
- 1 x Extruder
- 1 x Core extension
- 3 x GT2 belt
- 11 x Cable clamp
- 6 x Connecting rod
- 1 x PTFE tube
- 2 x Olive compression fittings
- 3 x Elastic band

Target: assemble the machine and each of the pre-assembled elements

Do not tighten the screws yet.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

Result

Do not tighten the screws yet.

M6 x 16 mm screw
Target: tighten the smooth rods and check that sliders slide as free as possible.

**Warning:** this step is very important. It is imperative for the proper functioning of translations in order to obtain the best printing quality.

Adding WD40 to the rods and plain bearings will greatly assist sliding.

**Process description**

1) Lay the printer on its side as shown in Figure #5.

2) Push the slider to the far right and tighten screws on this side.

3) Push the slider to the far left and tighten the screws on the left side.

4) Push the slider again to the far right and check that it slides well. If it is not the case, loosen the right screws and re-tighten.

5) Push the slider again to the left and check that it slides well. If this is not the case, loosen the left screws and re-tighten.

6) Repeat this process as many times as necessary until the slider slides freely. Low resistance on the left side is ok (next to the bottom plate).

Repeat this process for each axis.

Note: if the sliding of a slider forces: you may need to remove one plane bearing of the 4 in the slider.
Target: mount the filament driving system on the upper plate.
**MECHANICAL ASSEMBLY**

**Target**: mount the belts on each slider

1. Form a loop as shown in the illustration.
2. Insert the loop in place.

*Teeth on this side* GT2 belt

*In case of trouble, please follow the FAQ available on our website, in the «Support» section.*

Version 1.1.14
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

8. Pulley’s and belt’s teeth aligned

9. Make a loop and insert it into the slot.

- GT2 belt
- GT2 pulley
- Slider
- Idler pulley
- Wrap the belt around the idler pulley
Mount a belt on each axis.

1) Loosen the screw holding the motor
2) Press the motor down for tensioning the belt
3) Tighten the four screws
Target: clip the connecting rods on the sliders ball joints

- Clip the connecting rods on the ball joints
- Put the 3 elastic bands around the connecting rods.

Result

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: clip the connecting rods on the ball joints of the core
Target: stick cable clamps on the cowling

Target: stick the cable clamps on the upper plate

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: prepare the machine and the cowling before wiring

1°) put the machine on its upper plate

2°) lay down the cowling next to machine as shown below

Be careful at the orientation of the cowling

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: organize the cables from the upper plate through the cowling.

The core’s extension must exceed 30 cm from this level.

- Red: Alpha axis endstop
- Blue: Bêta axis endstop
- Yellow: Gamma axis endstop
- Purple: core’s extension
- Green: extrusion motor wire

The colors are purely indicative. No cables are colored. Only some connectors are to facilitate further assembly.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Stand up the cowling along the Z axis

Route the cables through the two dedicated holes as shown above.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: Fix the cowling to the machine

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Objectif : Assembly of the olive compression fitting OR of the pneufits

Olive compression fitting:

Pneufit:

Warning: if you do not have olive compression fitting but pneufits, please go to page 62.
1. Insert the PTFE tube in the upper part, in the olive and in the lower part to the max.

2. Unscrew the upper part of the connector

3. Tighten the two parts of the fitting to crush the olive so that it can not move on the tube.
   Be careful to not overtighten to prevent tube deformation.

4. Check that the olive has bitten the tube (not moving) then reassemble.

5. Insert the provided filament in the PTFE tube to check if there is any hard point around the olives.
   Remove the filament once done.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: install the PTFE tube on the 3D printer

NOTE: If you have pneufit in place of the olive fittings, insert the PTFE tube into the pneufit.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**Target**: cut the belt to prevent it sticking in the idler pulley

**Result**: Cut the belt as much as you can of the exceeding belt. Maximum 5mm should be left.
**BED LEVELING SENSOR ASSEMBLY**

Needed parts:

- 1 x Leveling sensor holder
- 1x Bed Leveling sensor
- 2x M2.5x12 screw
- 1x M3x12 screw
- 1x Knurled nut

**Target**: assemble the bed leveling sensor to perform the bed calibration operation

**Result**

Mount the bed leveling sensor on the leveling sensor holder as shown below. Screw the M3x12 screw in its dedicated place.

Pay attention to the sensor’s orientation.

Route the sensor’s cable through its dedicated slots on the leveling sensor holder.

**NOTE:**
This assembly will subsequently be used to calibrate the printer, more precisely to level the printing surface in order to obtain an identical first layer height over the entire printing plate. Instructions of use of this item will be detailed in the user’s guide.

**In case of trouble, please follow the FAQ available on our website, in the «Support» section.**
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: connect the stepper motors to the eMotronic

The colors are indicative to facilitate the reading.

Red: Alpha axis
Blue: Bêta axis
Yellow: Gamma axis
Green: Extrusion

Pay attention to the color code when connecting the extruder’s motor.

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**Target**: connect the endstops to the eMotronic board

Plug each endstop to its corresponding connector on the board. Respect the color code.

- **Red**: Alpha axis
- **Blue**: Bêta axis
- **Yellow**: Gamma axis

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: connect the core’s extension cable, the «Reset» button, the On/Off switch and the board fan.
CONGRATULATIONS!

Your 3D printer is now functional!

If you have options > please read the document dedicated to the installation of these options else > continue with the User Guide.
HEATING BED

Needed parts:

- 1 x Lower plate
- 1 x Heating patch
- 1 x Aluminium plate
- 3 x M3 x 10 mm countersunk screw
- 3 x Standoff spacer
- 1 x Adhesive patch «3dBedFix»
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

Top side = **WITH** countersinks

Heating patch and the thermistor will be fixed against the lower side of the plate.

Bottom side = **WITHOUT** countersinks
**Target**: assemble the aluminium plate, the heating patch and the thermistor (2 cases)

**ANNEXE**

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.

Bottom face = WITHOUT countersink
Target: mount the standoff spacers

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**Target**: screw the heated bed on the lower plate

**Result**
**Target**: Apply the adhesive patch «3DBedFix» on the heated bed.
Target: plug the heating patch and the thermistor of the heating bed

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Modifying the configuration file:

1°) Go to the Support section of www.emotion-tech.com. In the «MicroDelta Rework / Software / Software / Configuration» tree you will find all the available versions of the configuration file.

Download the version that corresponds to your printer (depending on your options)

2°) Unzip the downloaded file and copy its content into the SD card of the eMotronic board. Replace existing files if necessary.

3°) Press the Reset button.
LCD SCREEN

Needed parts:

- 1 x Right side LCD cover
- 1 x Left side LCD cover
- 1 x Front plate LCD cover
- 1 x LCD screen
- 6 x M3x12mm screw
- 2 x Ribbon cable

**Target:** Mount the LCD screen on the 3D printer.

**Pre-requisites:**
The two screen covers (right and left) are to be printed by yourself. To download these two parts, go to the Support section of www.emotion-tech.com, then go to «MicroDelta Rework / Ressources_3D / Option LCD».

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**Target**: Preposition the screws in the printed covers.

**Left side LCD cover**

- M3x12 screw

**Right side LCD cover**

- M3x12 screw

**Result**

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
**Target**: Plug the Ribbon cables on the screen

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: preposition the LCD screen between the two covers (right and left)
Target: mount the LCD on the printer

Route the ribbon cables through the rectangular slot

Tighten the two M3x12 screw on the lower plate of the printer

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: mount the front plate LCD cover

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Target: connect the LCD screen to the eMotronic board

Plug both ribbon cables on the emotronic board

In case of trouble, please follow the FAQ available on our website, in the «Support» section.
Modifying the configuration file:

Note: Without modification of the configuration files, your LCD screen will be preconfigured on a stable version (and therefore plug & play). However, if you want to acquire the latest version of the firmware, you can follow the following tutorial.

1°) Go to the Support section of www.emotion-tech.com. In the «MicroDelta Rework / Software / Software / Configuration» tree you will find all the available versions of the configuration file.

You will notice that two versions are available:
- Stable version
- A Beta version (in development, it integrates the function of calibration of the plate)

Download the version that corresponds to your printer (depending on your options)

2°) Unzip the downloaded file and copy its content into the SD card of the eMotronic board. Replace existing files if necessary.

3°) Press the Reset button.
Thank you for choosing MicroDelta Rework