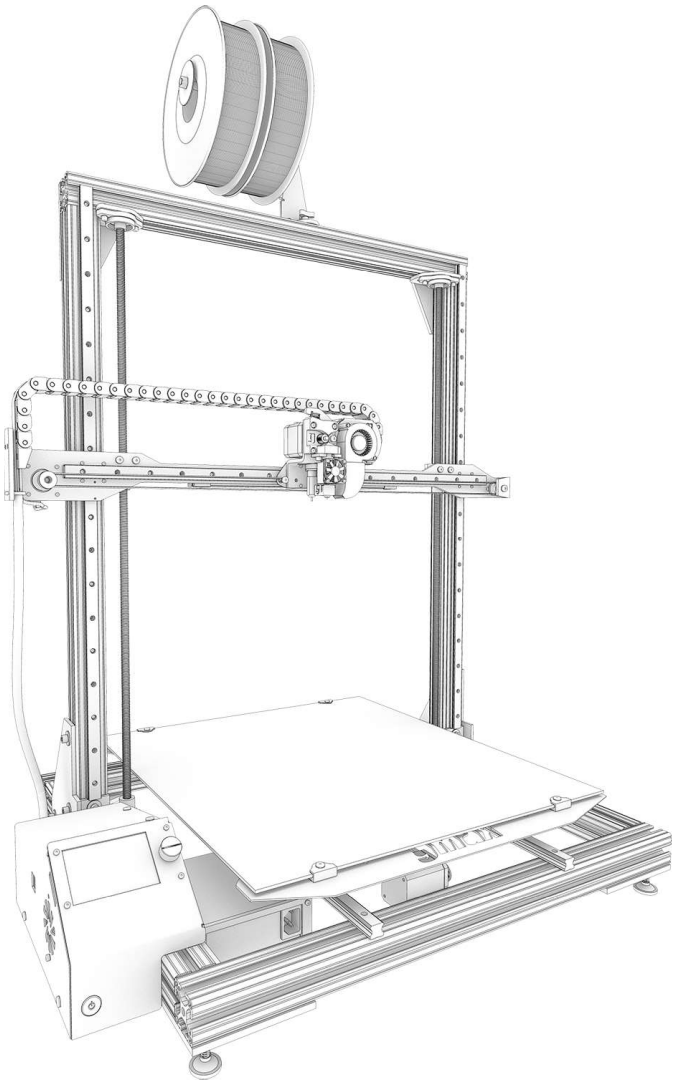
# gMax 2 PRO
# Unboxing and Setup

v220214

**For Single and Dual Extruders**



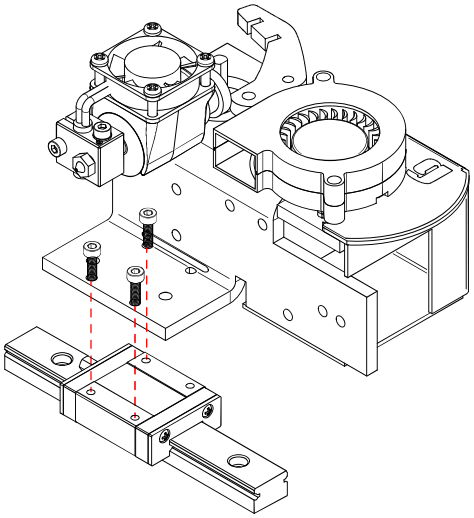
---

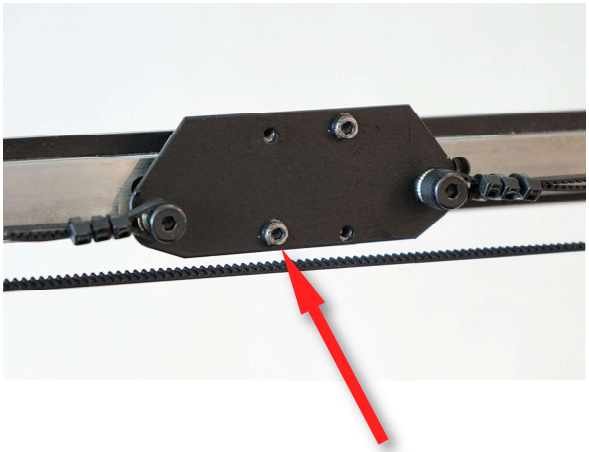
*This guide should be used for the initial unboxing and setup of your gMax2 3D printer.*
*Please Use the additional guide for the first use of your printer.*

**Make sure to inspect the printer through the unboxing process for loose wires or damage. Retain the original packaging for future use.**

# Install Extruder

*Images show a Single extruder. Pages 1-5 follow the same installation process for both Single and Dual Extruders*



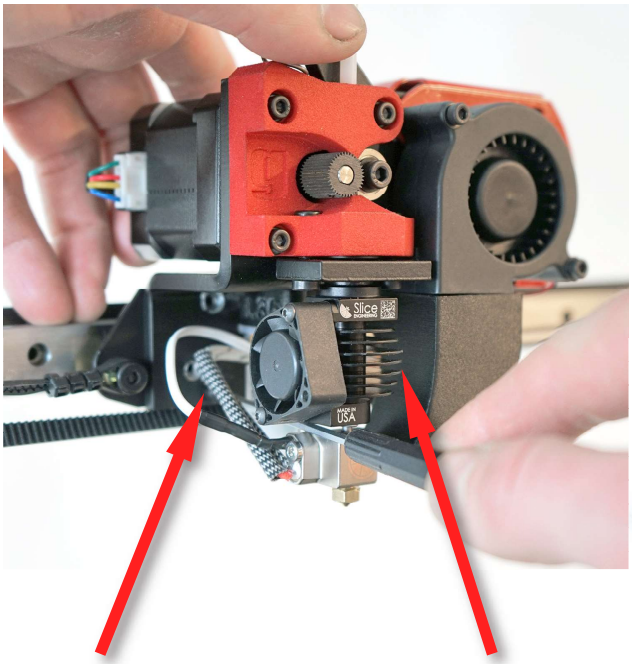


Remove this M3x8mm bolt

1. Open the accessory box and remove the extruder and hardware. The extruder needs to be installed on the linear block using (3) M3x8mm socket head screws. The extruder will go over the belt bracket already installed

2. Use the supplied 2.5mm hex driver to install (3) screws on extruder bracket.

3. Tighten all (3) screws and make sure the extruder slides smoothly on the linear rail.



Install extruder with (3) M3x8mm bolts

Other (2) screws are on right side of hotend (hidden from view)

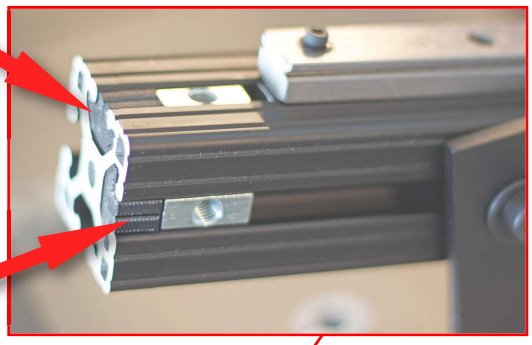
M3x8mm

2.5mm Driver

# Rotate Upper Gantry

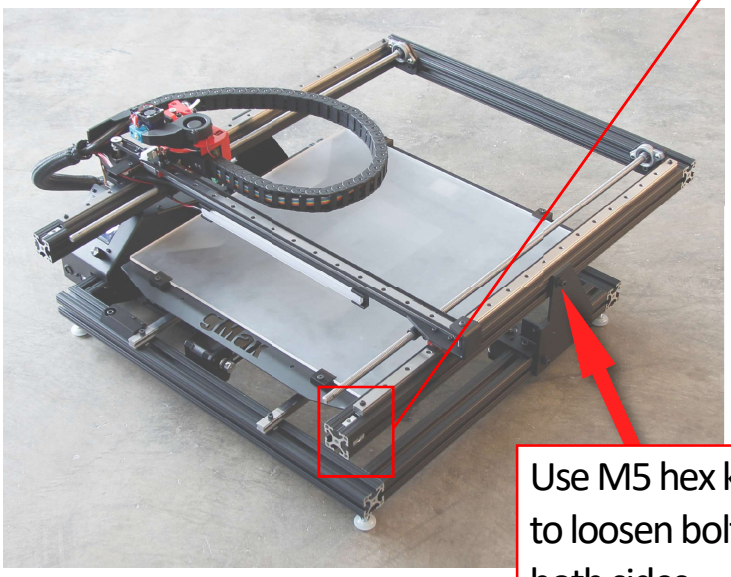
Tall Rubber Spacer

Short Rubber Spacer



**Note**

Make sure T-Nut rubber spacers are in place. They can be easily reinstalled if they fall out.

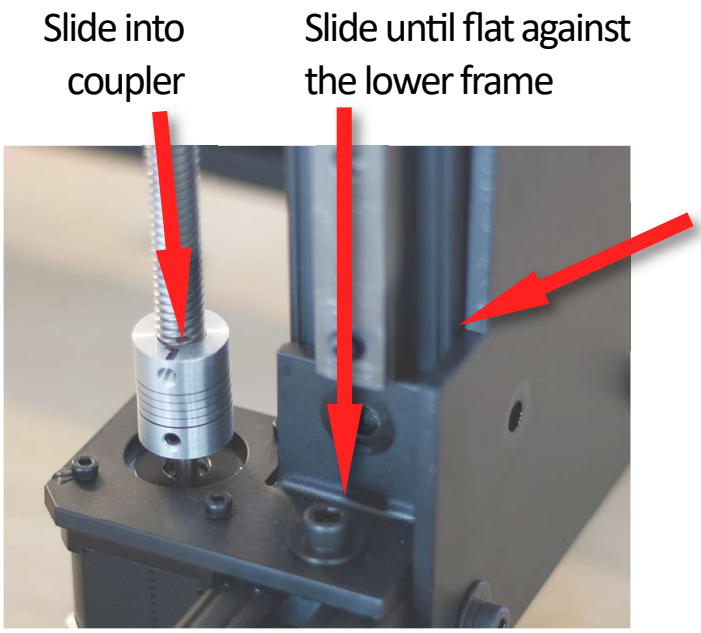


Use M5 hex key to loosen bolts on both sides.

Rotate to exactly 90 degrees

See next Page

# Slide Down Upper Gantry




1. Slide the upper rails down until they lay flat against the lower frame. Make sure the lead screw slides all the way into the coupler and make note of the flat spot. Turn the coupler by hand to ensure a solid connection.

**IMPORTANT: Make sure the uprights are perfectly perpendicular to the bottom frame. You can use a machinist square to get a perfect 90 degree angle on the back side of the rail.**

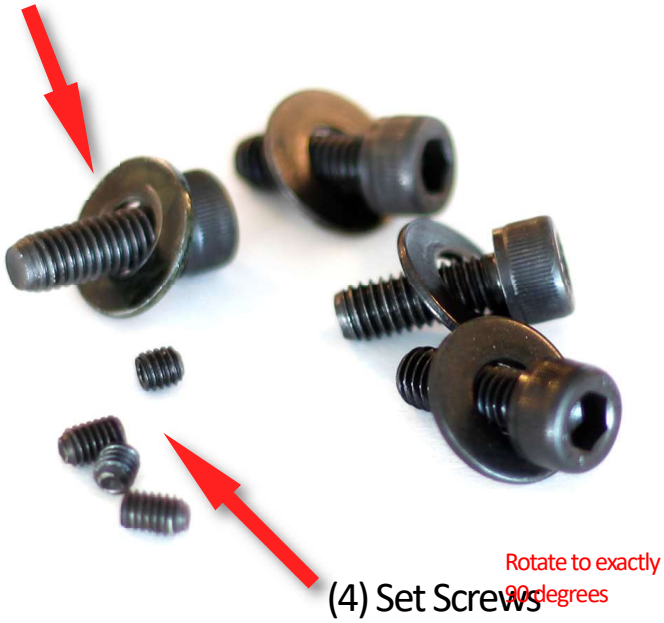
2. In the accessory box, open the bag containing the M6 bolts, washers and set screws.

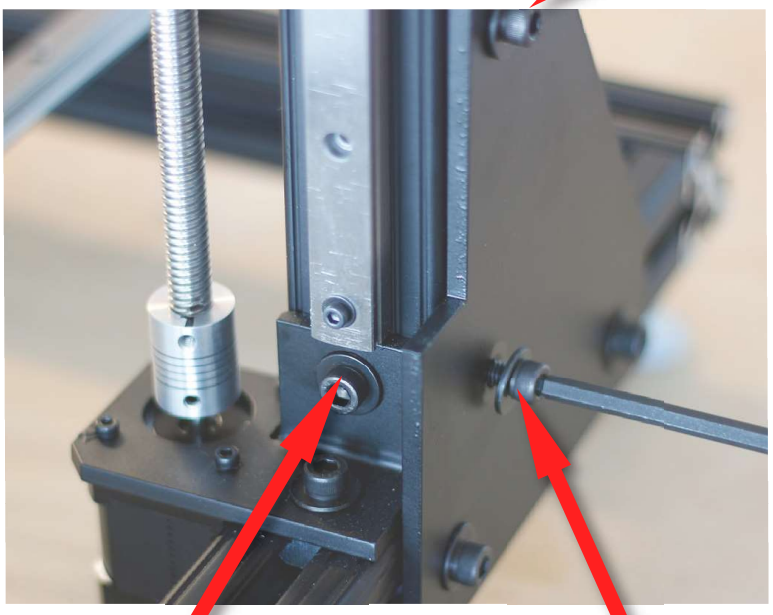
3 Screw in the M6 Bolts and washers into the T-nuts already in the vertical rail. Tighten the side bolts first then the front.

**Note**

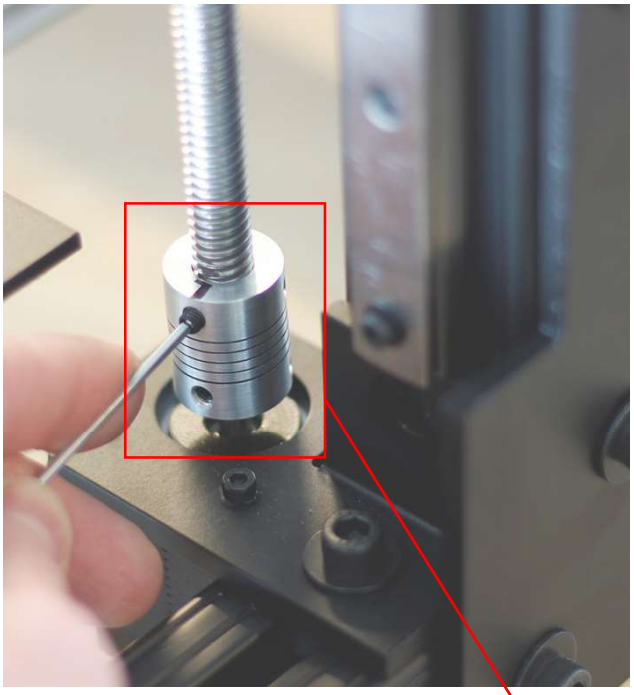
If the rubber spacers came out they can be easily pressed back in. These spacers help line up the T-Nuts with the holes.

(4) M6 Socket Head Bolts
(4) 1/4" Washers

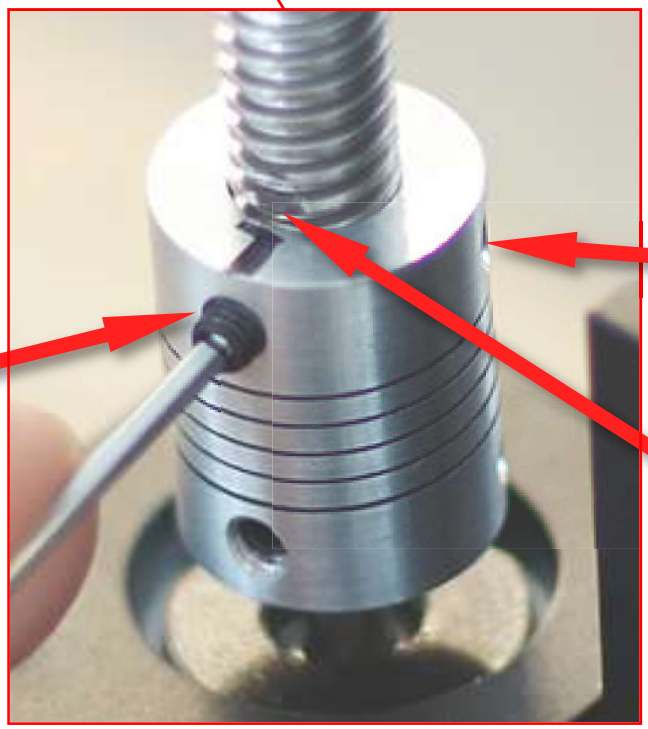


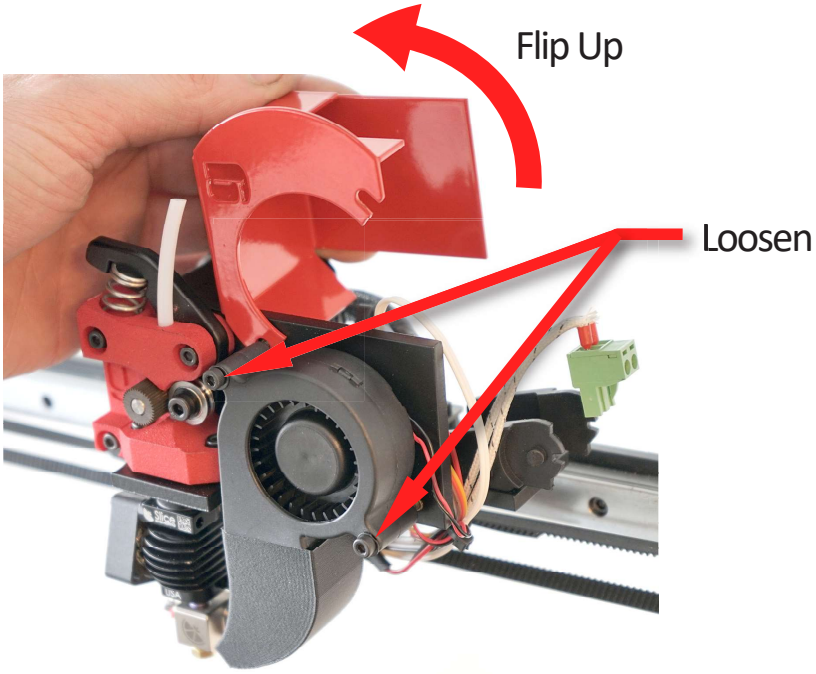
# Tighten Set Screws



1. Line up the coupler set screw with the flat spot on the lead screw and tighten both set screws on each coupler. You may have to lift the lead screw to see the flat spot.



# Plug In Extruder




1. Loosen the two bolts on the extruder blower fan to gain access to the electronics.

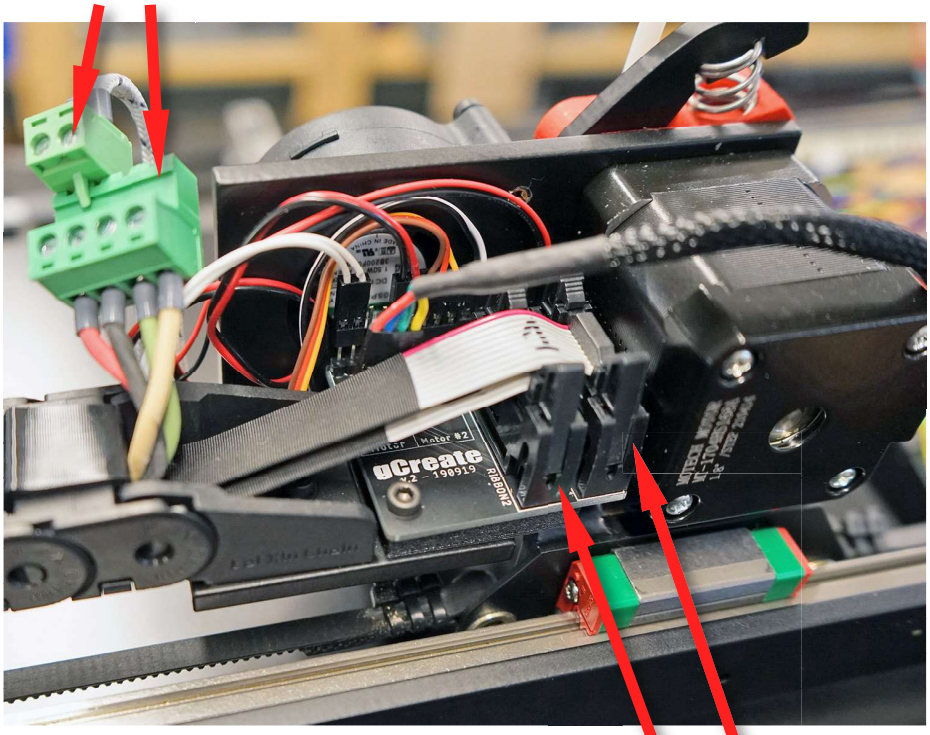
2. Plug in the ribbon cable #1 into the socket closest to the motor and #2 in the other socket.

3. Plug the green extruder wire connector into the 4-pin green connector. Make sure to plug it into the black and red wires for a single extruder. The plug should be labeled #1.

**Note**

The green and white wires are for the second hotend on dual extruder setups..

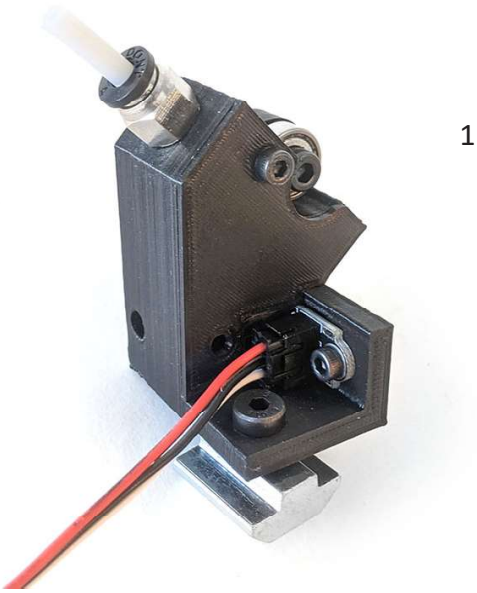
Plug green connector to red/black wires for hotend #1 and green/white wires for hotend #2 (for dual extruder setups).



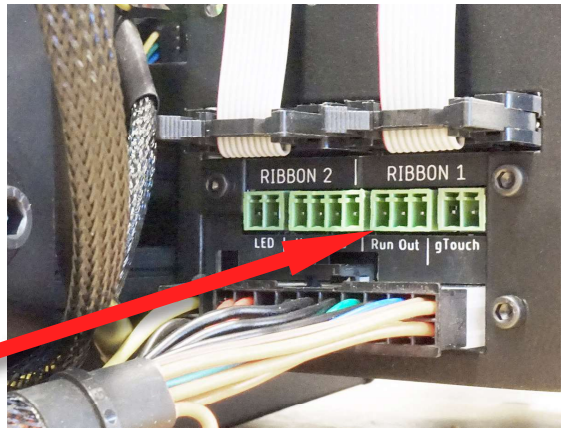

4. For dual extruders plug hotend #1 into the red/black wires and hotend #2 in the green/white wires.

5. Rotate metal cover back down when finished, and tighten bolts.

# Plug in Filament Run-Out Sensor



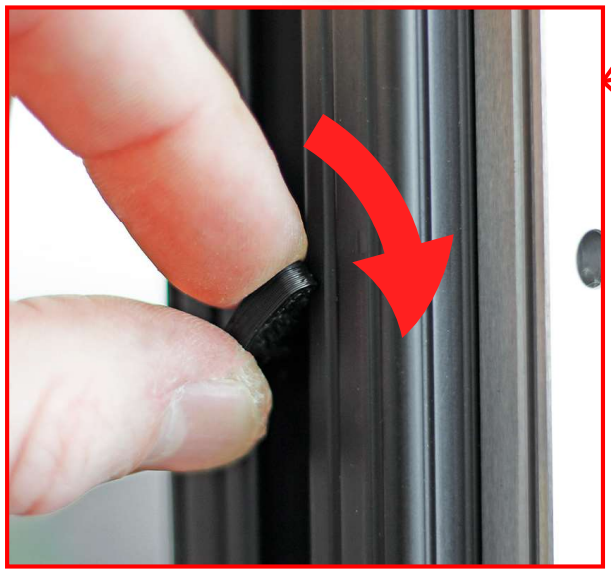
1. Plug in the filament runout sensor wire from the runout sensor to the back of the printer in the spot labeled “Runout”. The wire is in the bag with the sensor(s).

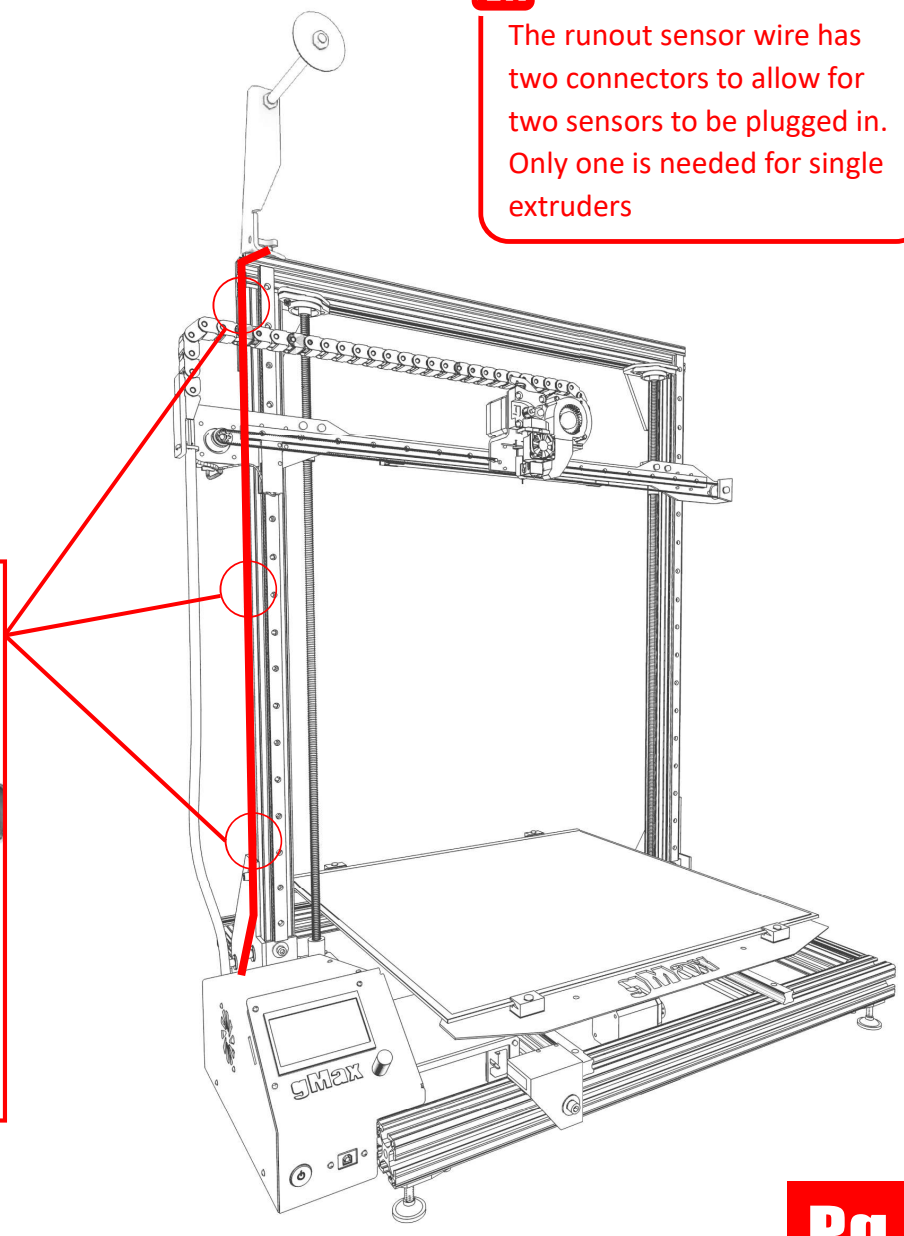



**Note**

The runout sensor wire has two connectors to allow for two sensors to be plugged in. Only one is needed for single extruders

2. Route filament sensor wire along of rear of 80/20 rail. Use 3d printed wire clips to secure the wire.

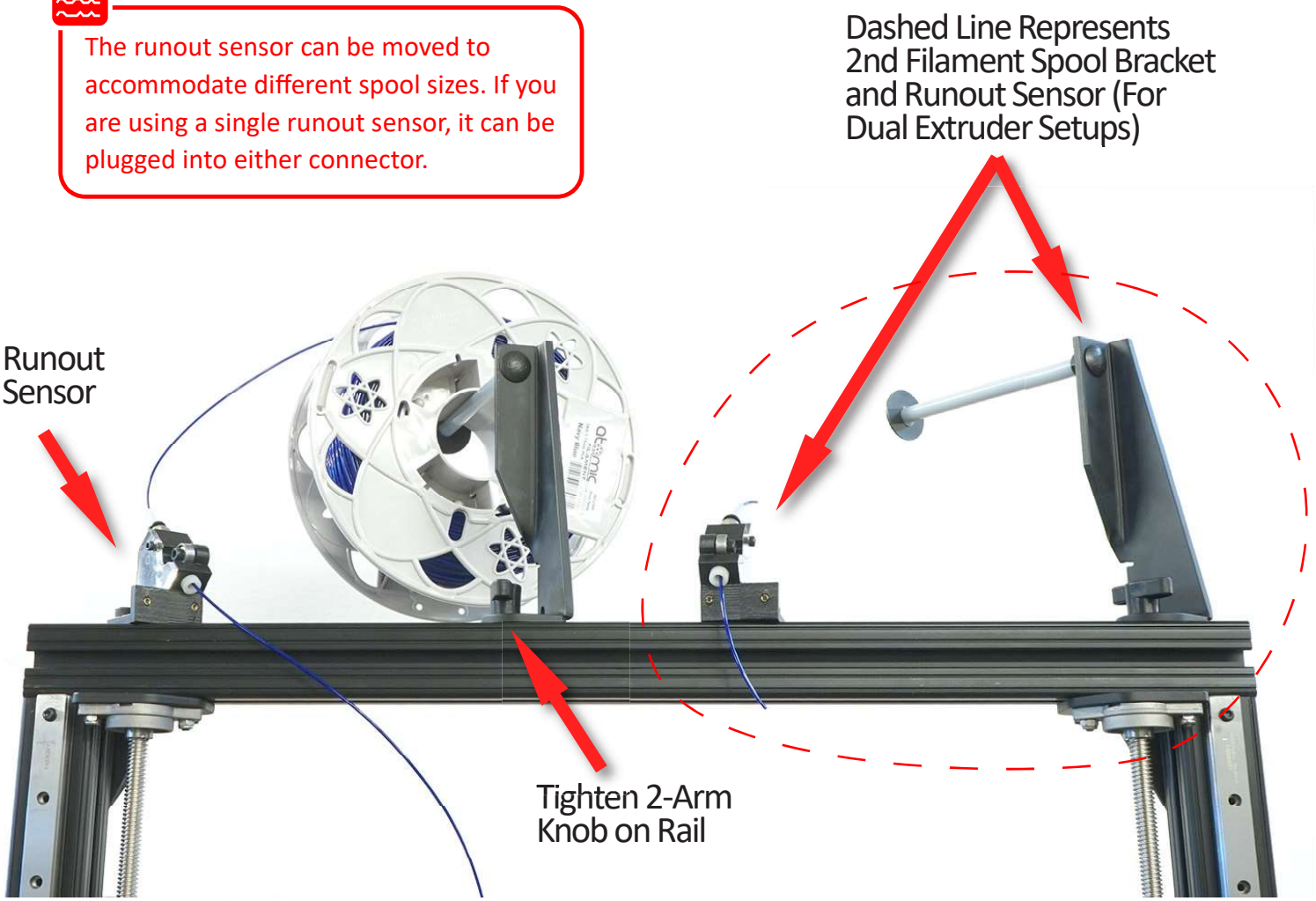




# Install Filament Spool Holder

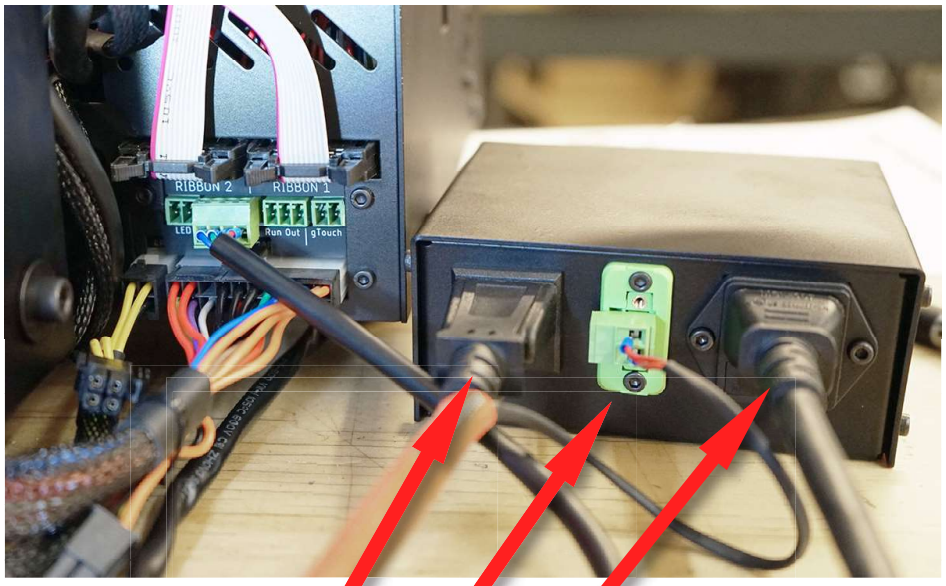
**Note**

The runout sensor can be moved to accommodate different spool sizes. If you are using a single runout sensor, it can be plugged into either connector.

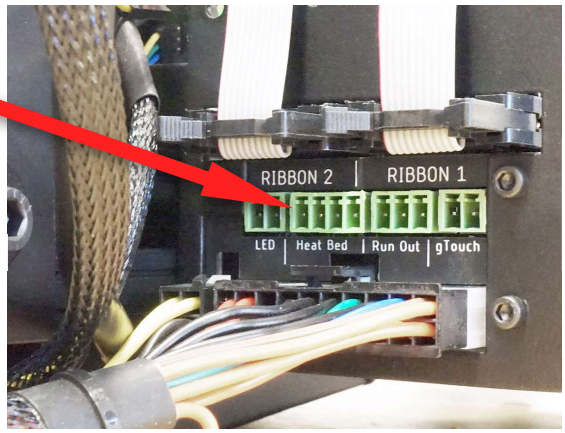



1. Loosen the filament spool bracket knob and t-nut.
2. Slide the filament spool bracket on the top rail and tighten the knob to secure it.
3. Install the runout sensor on the top rail with M6x16mm and tnut. Make sure it lines up with the spool.
4. For dual extruder setups, put a scrap piece of filament in the sensor during the setup to avoid a runout triggering.

# Plug In Heated Bed and SSR




1. The heated bed comes pre-installed on the gMax however it must be plugged into the solid state relay (SSR) control box.
2. Plug in the bed on the back of the ssr.
3. Plug in the green thermistor connector to the back of the SSR.
4. Using the thick power cable, plug the ssr into the wall.
5. Plug the ssr box into the back of the electronics case.



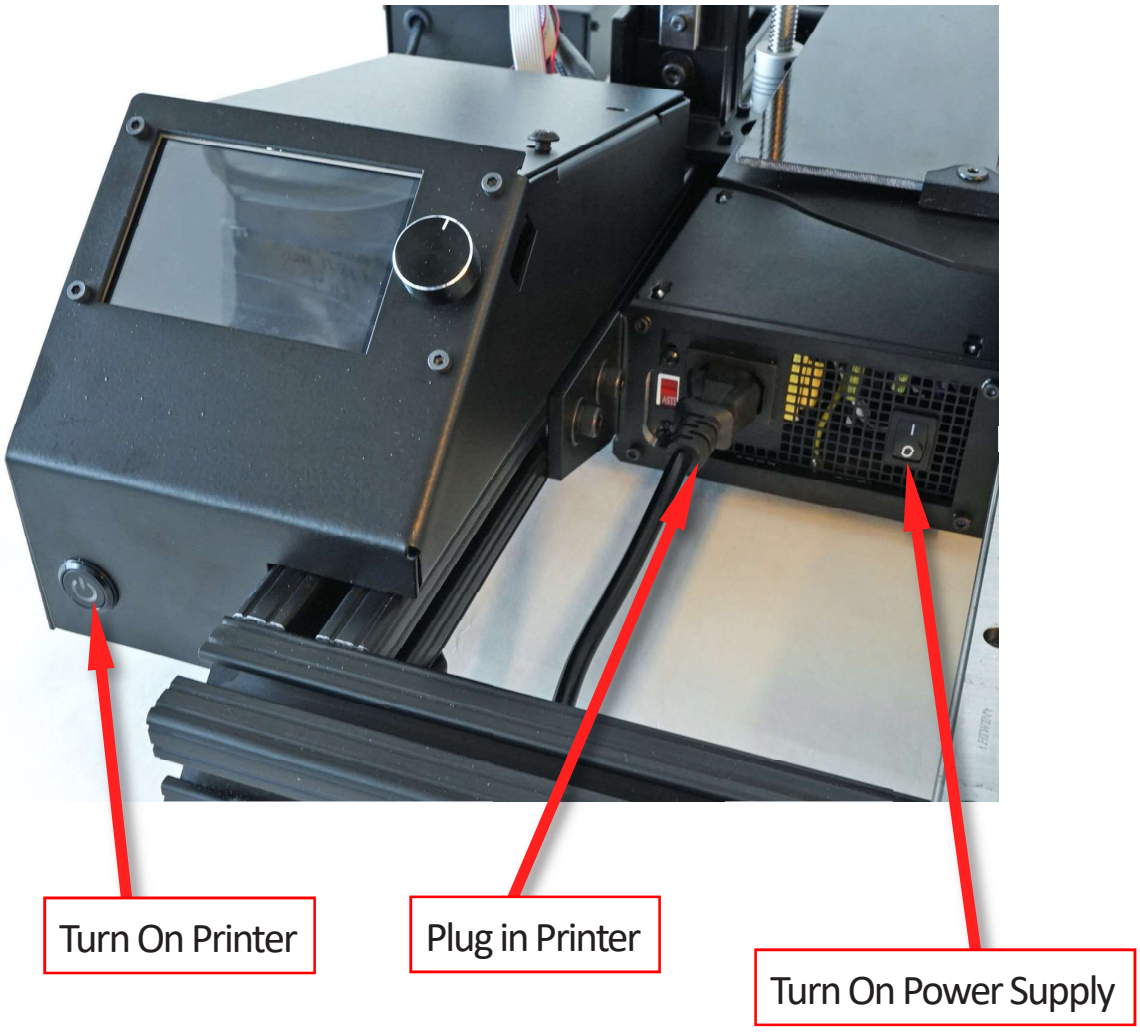

**Note**

The heated bed can only be controlled from the computer. The heated bed also has a 15A fuse inside the power receptacle.

# Plug In Printer

1. Use the supplied power cable from the accessory box and plug in the printer.

2. Make sure to turn on the power supply and push the power button on the printer.




3. Refer to the **"Getting Started Manual"** to start using your gMax 3d printer. Also Refer to the **"User Guide"** found on the SD card for useful information on maintenance, firmware and more.