M4 Voron 0 Mod Manual

Mod By: xbst_ M4 Original M4 Extruder By: Voron Design

## BOM

Part	Qty
GT2 188T Belt Loop	1
GT2 20T Pulley	1
Powge Voron GT2 80T Pulley*	1
F695-2RS Bearing	2
Bondtech Extruder Gear Kit	1
Bondtech BMG Extruder Spring Assembly	1
5x46mm Shaft w/ Flat	1
Nema17 Pancake Motor (Max 24mm)	1
TriangleLab Bowden Collet	1
M3 Threaded Insert	5
M3 Washer	2
M3x30 SHCS	4
M3x12 SHCS	2
M3x8 SHCS	1
M3x12 BHCS	2

*This is the flangeless black 80T pulley sold only by Powge on AliExpress. If using printed 80T pulley, rear panel won't fit. Add another GT2 20T pulley, and 5x M3x6 BHCS to the BOM, replace 46mm shaft with 50mm shaft.
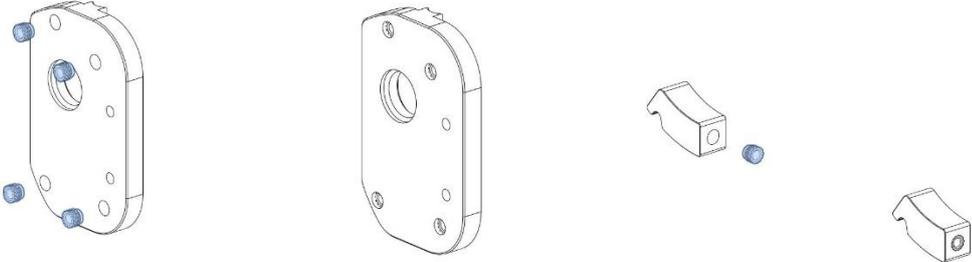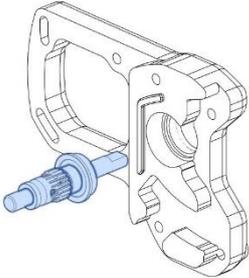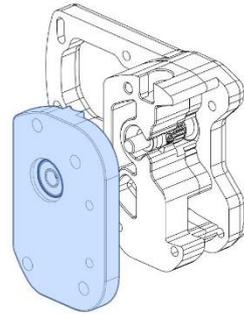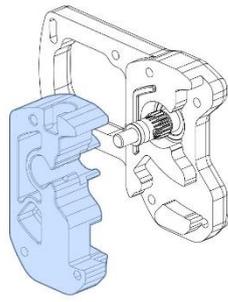
1.
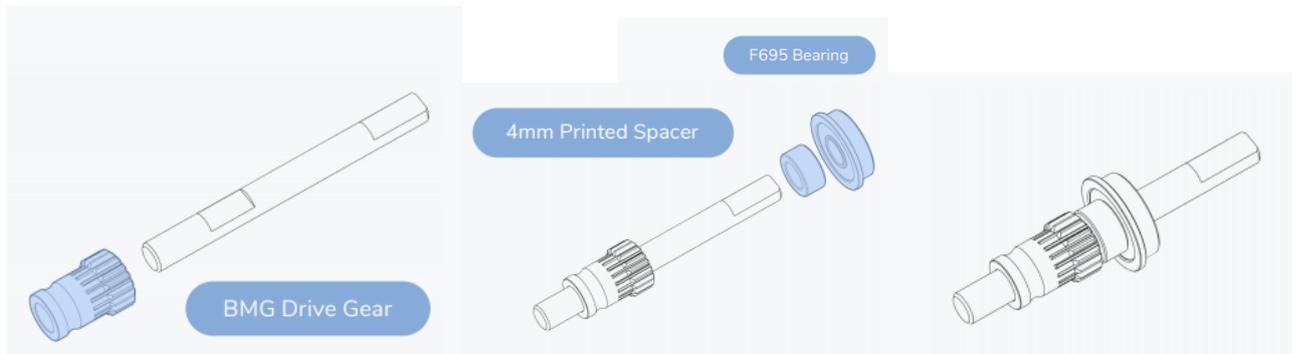
2. Remove Built-in Support

3.

4.

5.

6.

7.

8.

9.

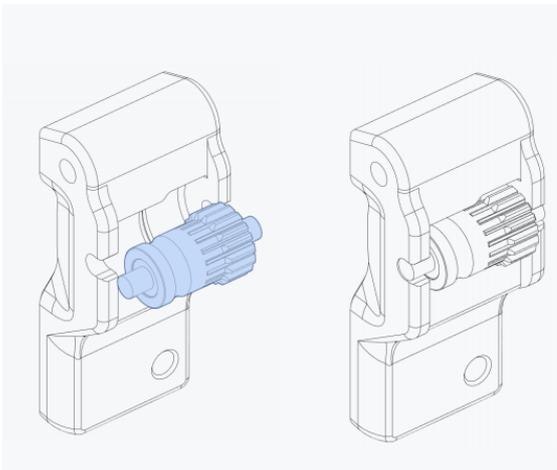**10.**

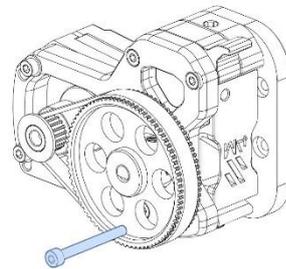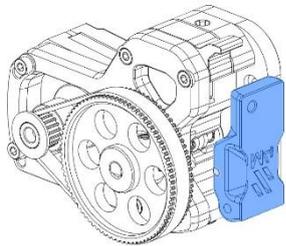**11.**

12.

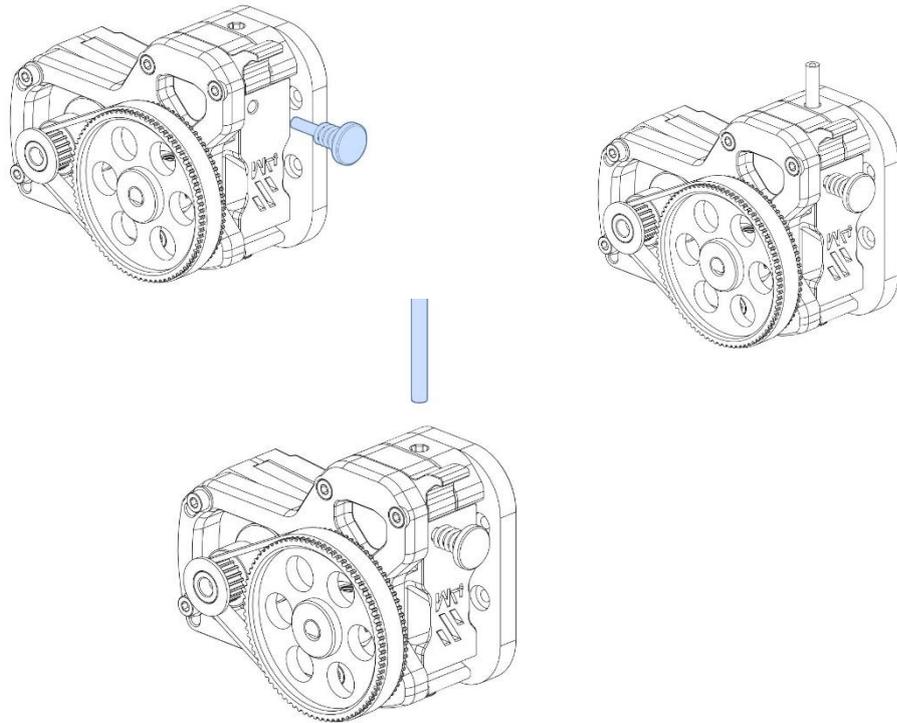**13.**

BMG Idler Assembly
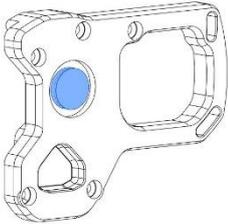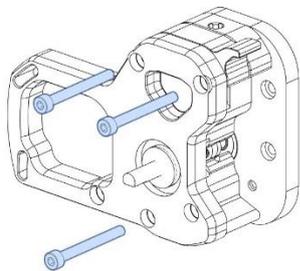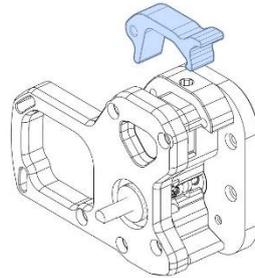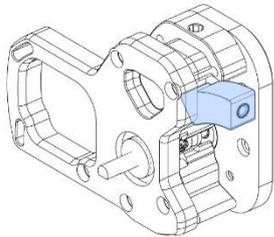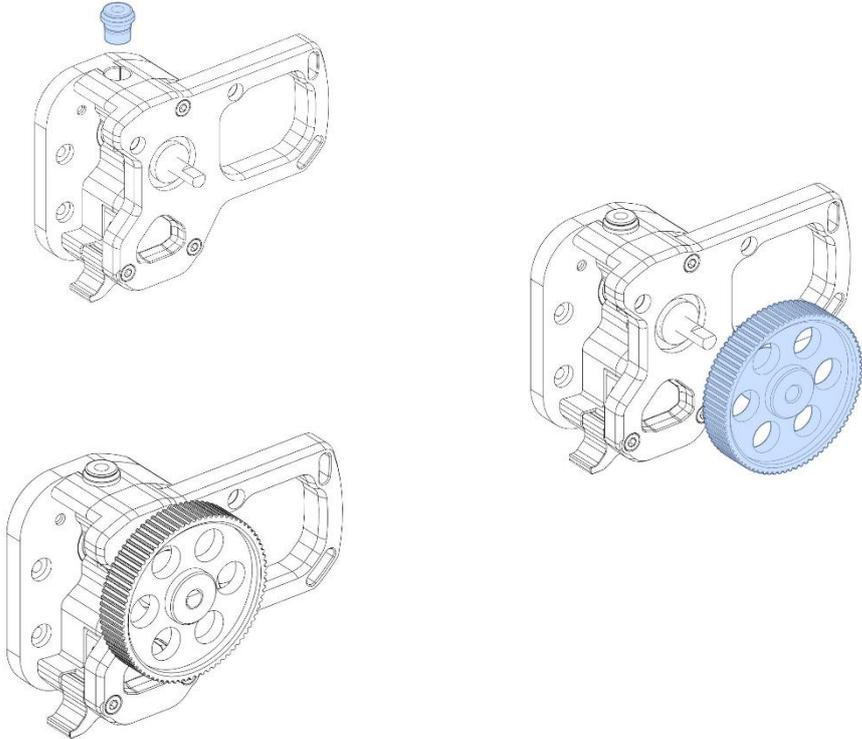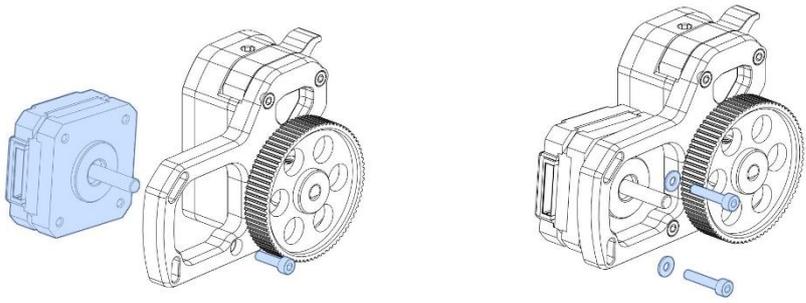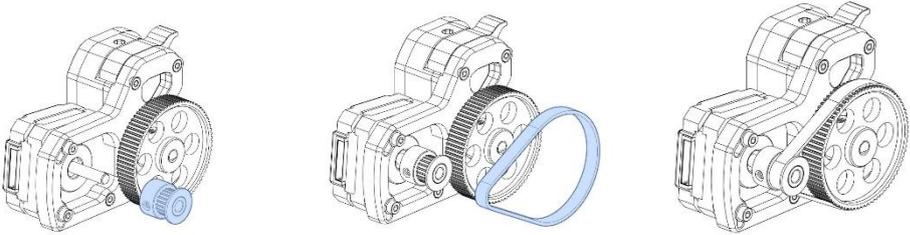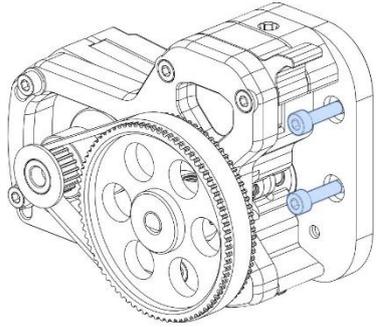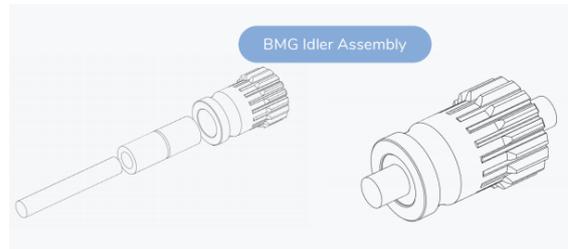
14.

15.

15. Edit printer.cfg for according to new gear ratio (Pocketwatch was 3:1, M4 is 4:1).