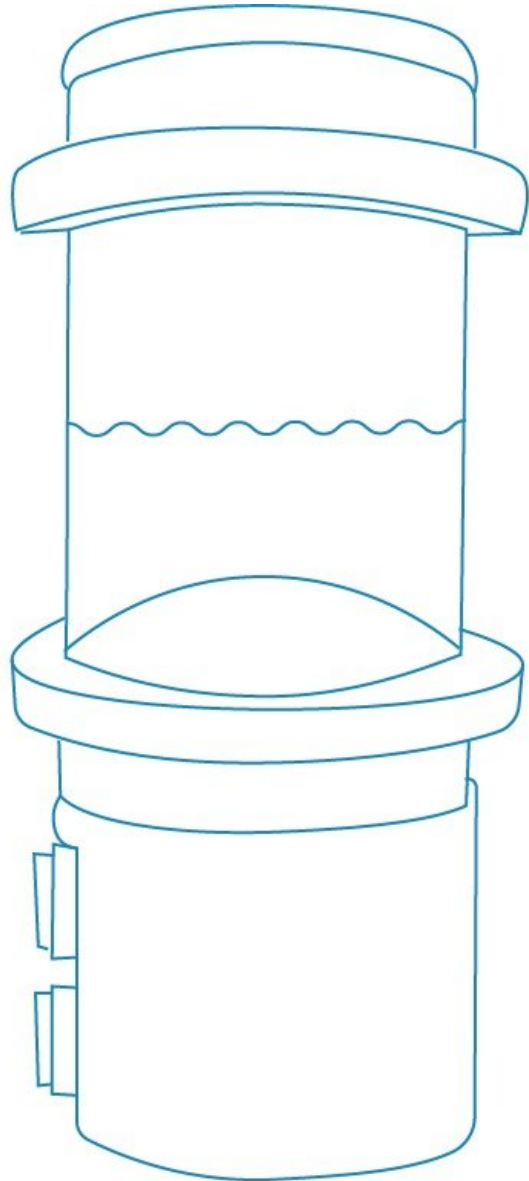
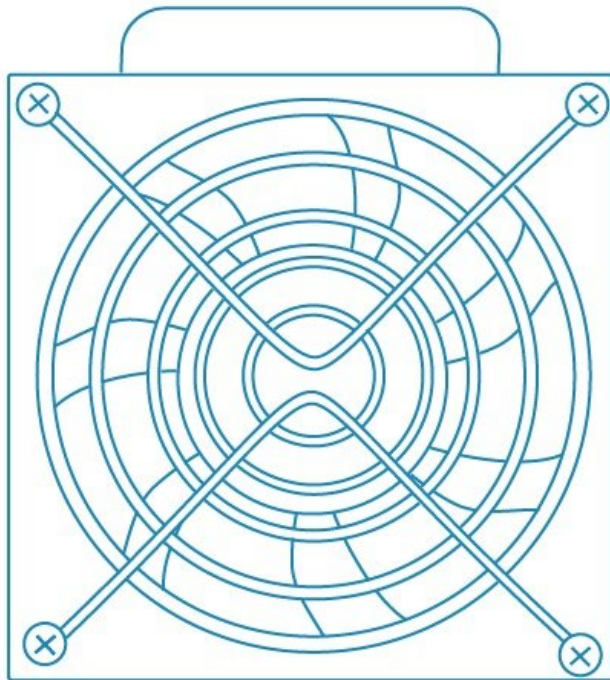


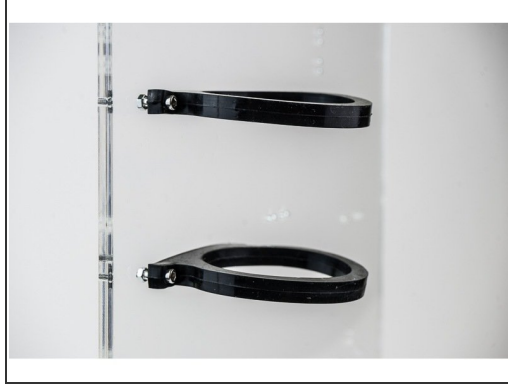
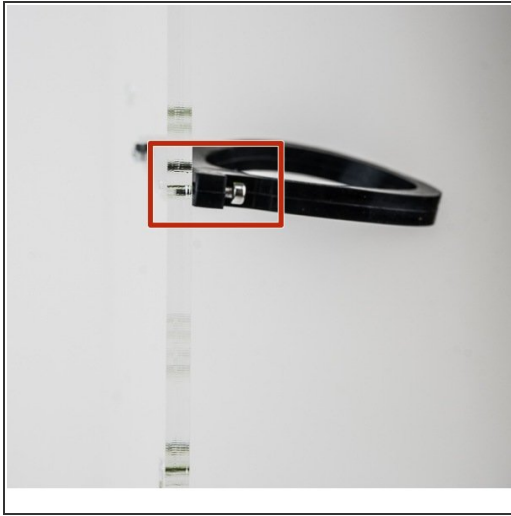



Water-Cooling Kit Assembly

Written By: Daniel Halsall



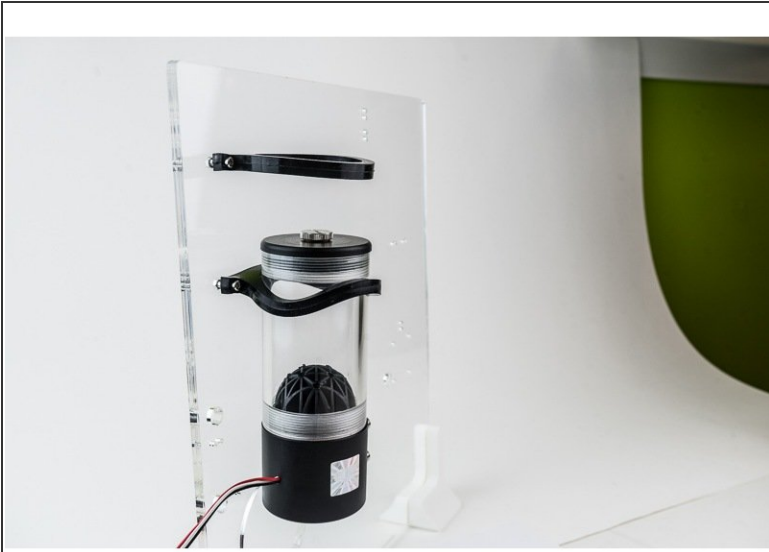
Step 1 — Water-Cooling Kit Assembly



 **MAKE SURE YOUR PRINTER IS TURNED OFF AND UNPLUGGED**

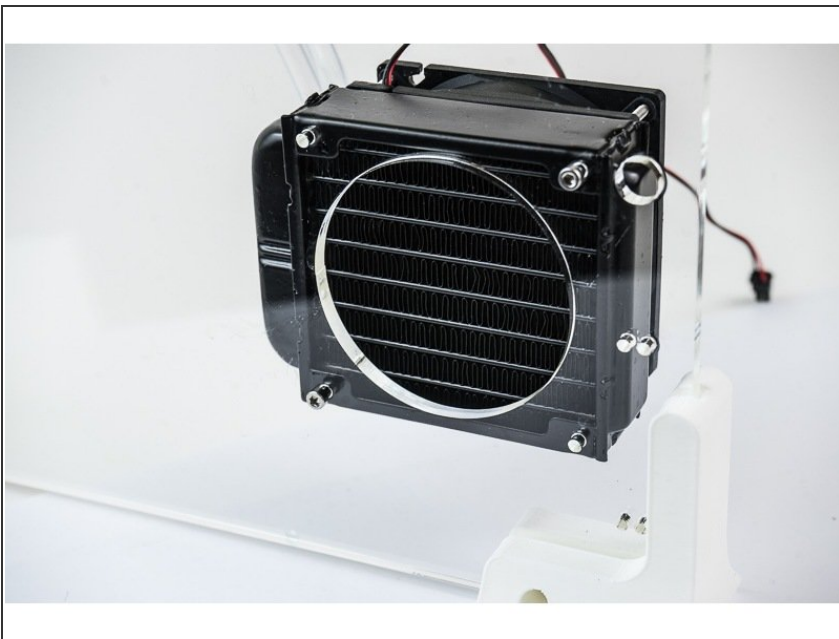
- Screw in the pump holders using the fixings provided. The holes are 63.5mm apart.
- We recommend mounting the pump in the vertical orientation to keep the pump submerged at all times
- Screw the mounts 6 to 8cm apart

Step 2



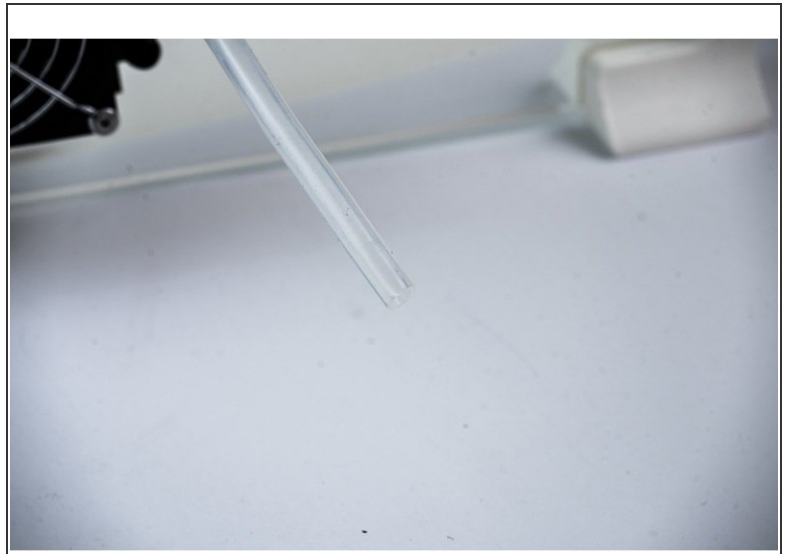
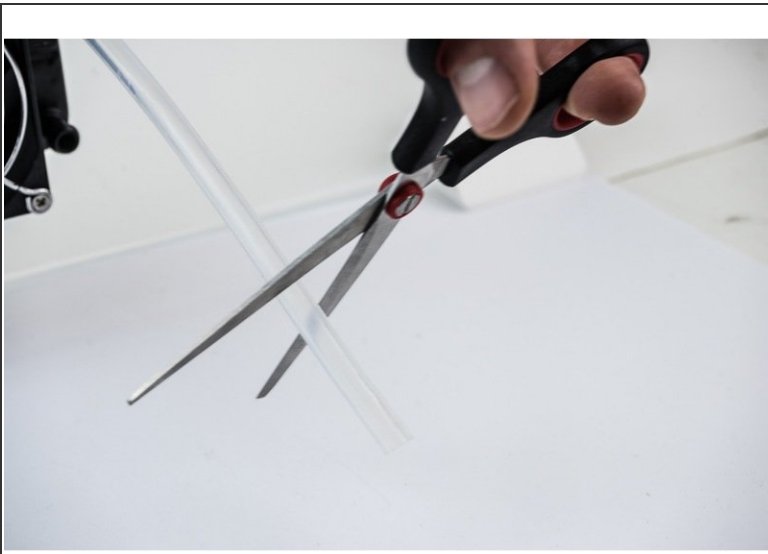
- Slide the pump into the brackets from the bottom
- The holders should be tight enough to hold the pump in position without any modification

Step 3



- Mount the radiator and fan, making sure to leave room for the air to escape on the other side of the radiator
- This can be achieved by either cutting a hole in the frame or mounting the radiator on standoffs

Step 4



- Plan out the routing of your tubes
- We recommend that the tubing adaptors be fixed to the frame and to make the link between the moving toolhead and the frame with the nylon tubing
- Cut the Kraken tubing (silicon tube) to length using scissors, make sure the end is square and not torn

Step 5



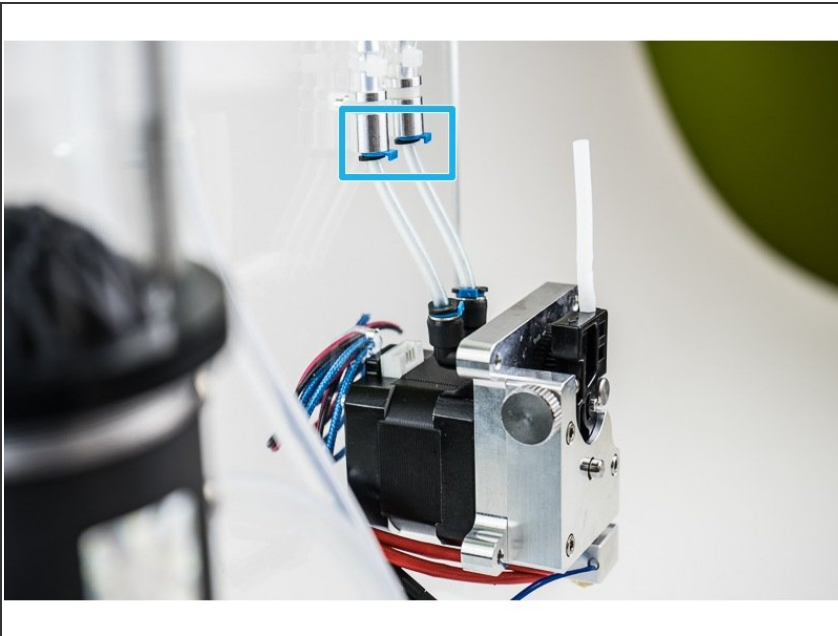
- Attach the tubing adaptors to the frame of your printer
- Rout your tubing so that the coolant flows in the following order: HotEnd -> Radiator -> Pump -> HotEnd
- Use cable ties to secure the tubing and the tubing adaptors, make sure not to tighten the cable ties too much as they might restrict the flow of the coolant in the Kraken tubing
- Take care not to induce any sharp turns in the Kraken tubing to avoid kinks forming and flow being restricted

Step 6



- Make sure all the Kraken tubing ends are fully engaged with the barbs of the adaptors, pump and radiator
- Secure them in place with cable ties

Step 7



- Couple the water-cooling it to your favourite hotend using the clear nylon tubing provided
- Make sure to use the collet clips provided to stop the tubing from getting loose when the hotend moves around

Step 8



- Plug the pump into your power supply so that it runs continuously when the printer is on. This is a safety feature to prevent the hotend from heating up without any cooling
- We recommend that you use dedicated coolant or coolant additives to run in your system rather than plain tap water to prevent the forming of algae