



Phœtus®



DXC2 Installation

Directly Compatible with Creality K2 Series



Printing the Required Parts

DXC2 requires the use of a compatible riser.

1. Option 1 – Purchase the official kit:

Official riser (ABS-GF) + front cover (ASA with magnets embedded)

2. Option 2 – DIY print:

You may print the riser yourself. The front cover can also be printed separately.

Note: If magnetic attachment is desired, embed $\phi 4 \times 5$ mm magnets into the cover.

3. Download the 3D models here:

<https://github.com/Phaetus/DXC-2-Extruder/tree/main>



**Download and
Print Adapters**

Or scan the QR code to access Phaetus DXC-2 GitHub page.

Download the STL files for:

Cable chain riser

Custom front cover

Import the files into your slicer, choose your filament, slice, and print.

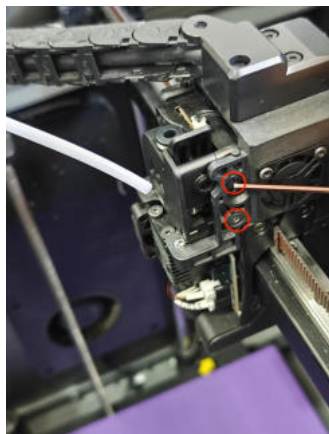
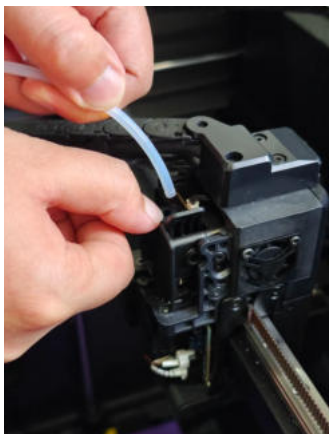
✓ Recommended material: ABS or other high-temp resistant filament

⚠ If printed with PLA/PETG, avoid printing high-temperature materials — high chamber temperatures may cause deformation.

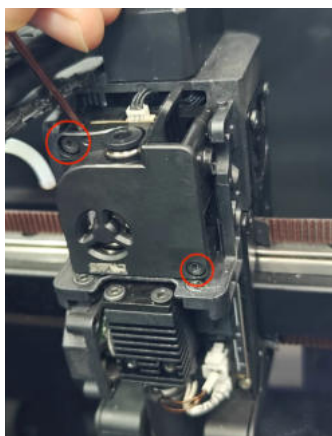
Removing the Original Extruder



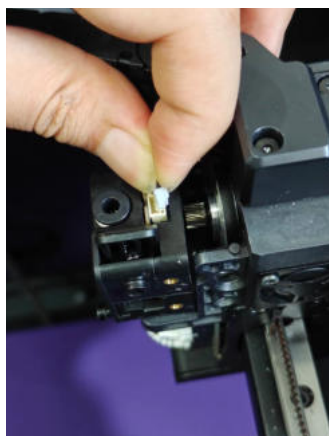
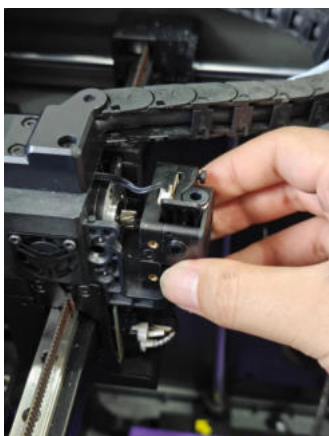
1. Power off the printer. Open the tool head front cover, press the round cap, and pull out the PTFE tube.



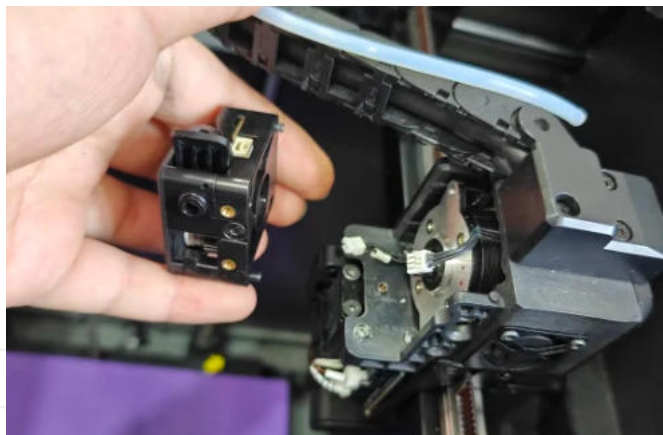
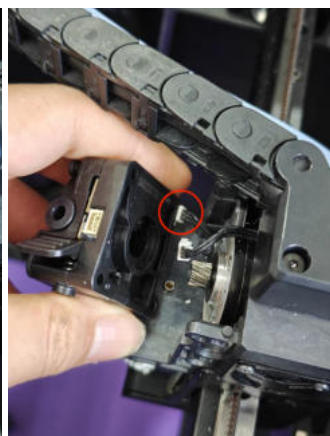
2. Remove 2 screws on the right side and 1 screw on the left side of the extruder.



3. Remove the 2 screws securing the extruder motor. Gently pull the extruder forward to separate it from the motor.

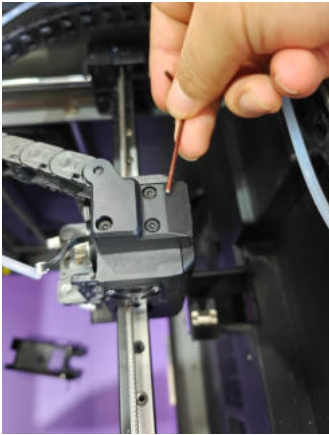


4. Press the side clips of the connectors and unplug:
· Filament runout sensor connector
· Cutter sensor connector



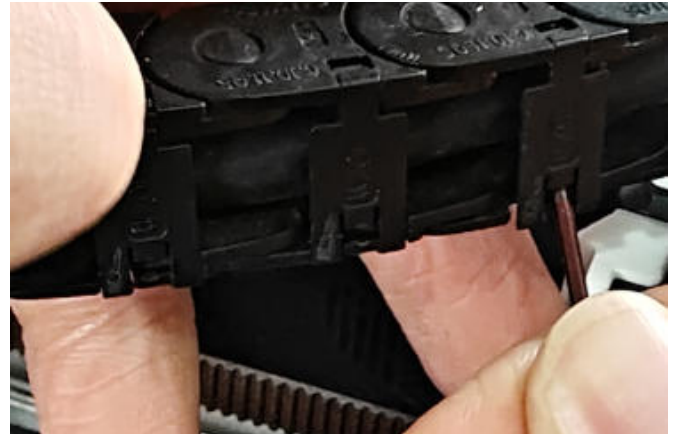
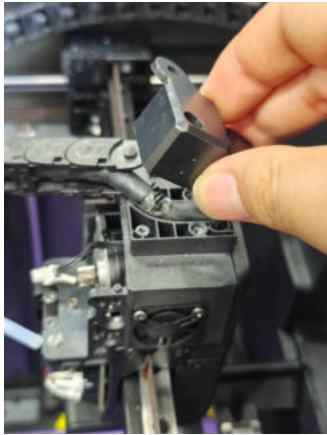
5. Remove the original extruder. Keep the 3 side screws from the original extruder — they will be reused to install the DXC2.

Replacing the Cable Chain Mount



1. Remove the original cable chain mount:

Use a wrench to remove the 3 screws securing it. Lift the top cover from both sides and set it aside. Keep the 3 screws for later use.



2. Remove the last link of the cable chain:

Insert an H1.5 hex wrench into the slot, pry upward to release the clip, and remove the last link.



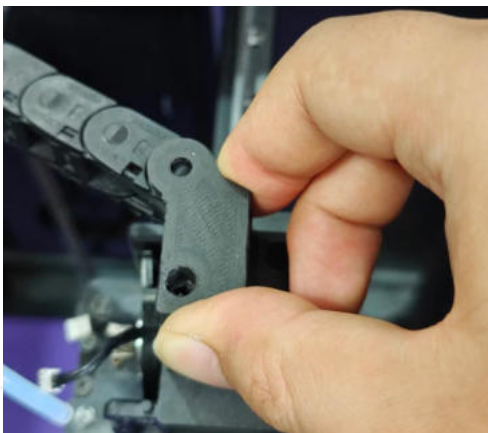
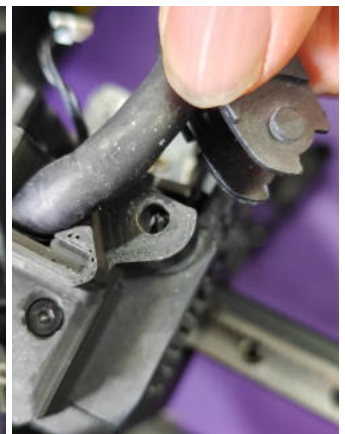
3. Install the printed riser:

Take the cable chain riser printed earlier. Insert the print head cables into the opening of the chain mount as shown in the diagram.



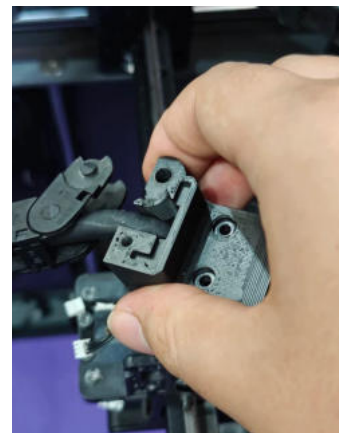
4. Attach the riser to the print head:

Secure it using the 3 original screws saved earlier. Route the cables through the opening and place them into the semicircular cable channel.



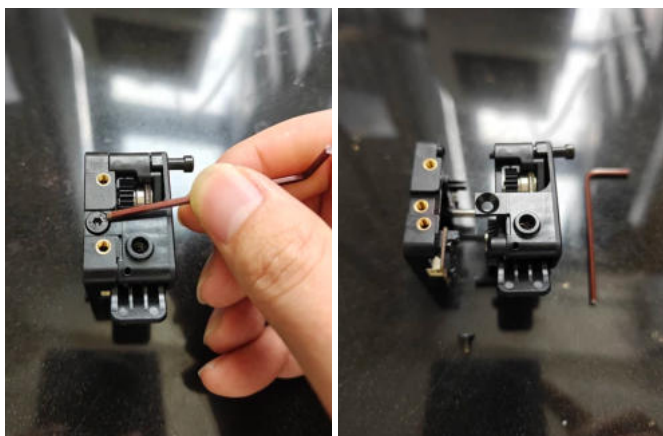
5. Install the top cover:

Insert the lower tab of the last chain link into the hole on the chain mount. Insert the upper tab into the hole on the top cover. Align the protrusions on the underside of the top cover with the recesses on the mount. Secure the left side with 1 remaining original riser screw. Secure the right side with 1 M3×15 self-tapping screw (included in the accessory kit).

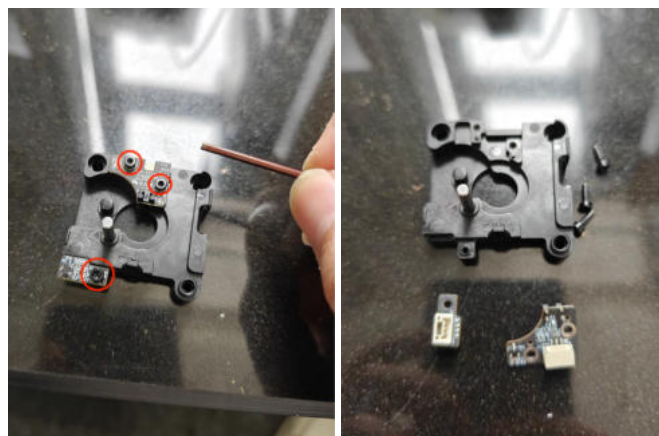


6. Installation complete.

Installing the DXC2 Extruder



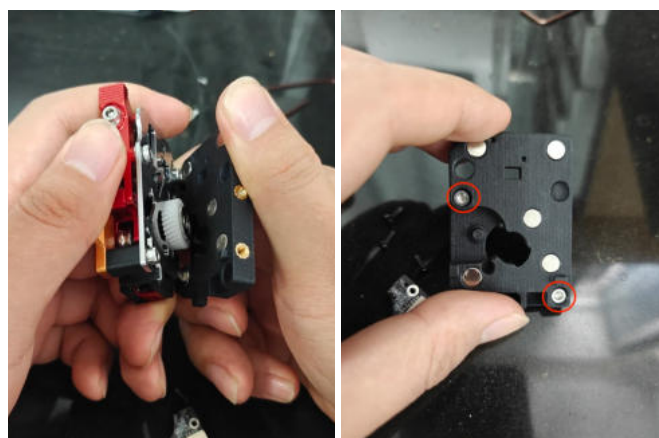
1. Take the original extruder you removed earlier. Use a wrench to unscrew the **side screws** and separate the front and rear covers.



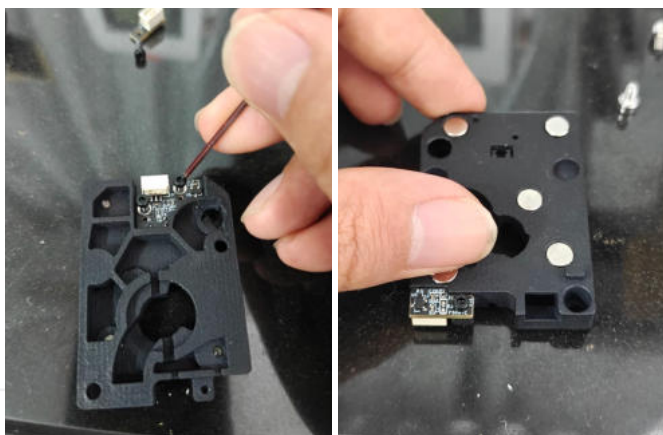
2. Remove the **3 screws** securing the sensor PCB on the rear cover. Detach the **cutter sensor** and **filament runout sensor**. Reassemble the remaining parts of the original extruder and store them properly.



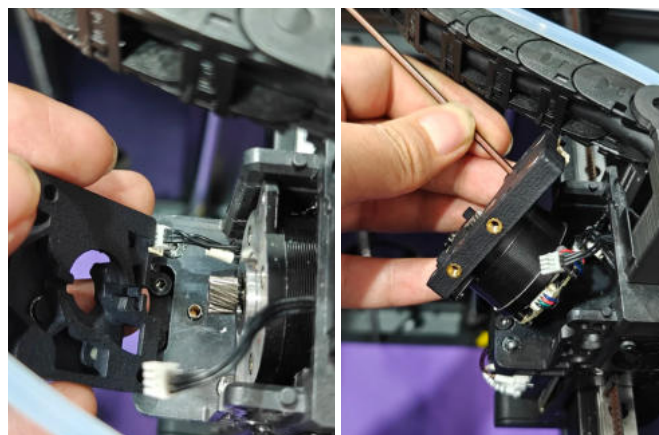
3. Take out the DXC2 extruder and the 2 original sensor PCBs. Prepare 3 M2×4 self-tapping screws from the accessory kit.



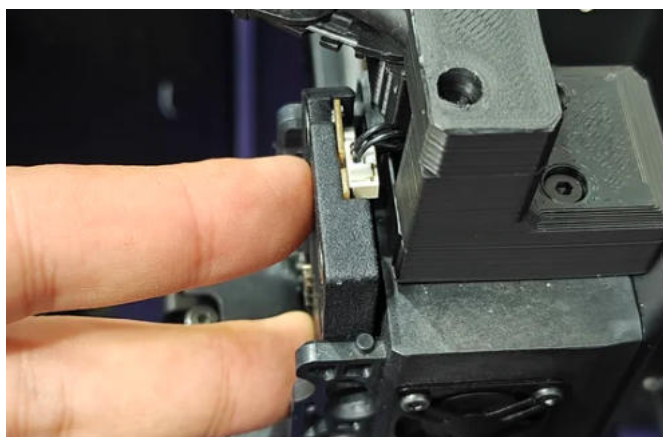
4. Carefully **snap open the DXC2 extruder** to separate the front cover assembly from the rear cover. Remove the motor screws from the rear cover and set them aside temporarily.



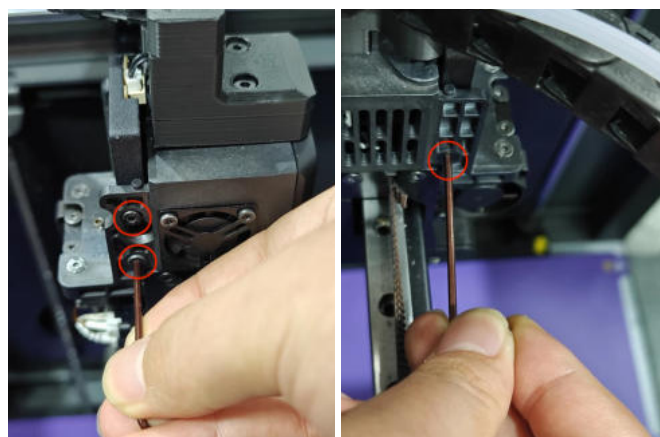
5. Install the **filament runout sensor** and **cutter sensor**. Ensure the cutter sensor sits flush against the extruder body with no gap. Secure both sensors using the **3 M2×4 self-tapping screws**.



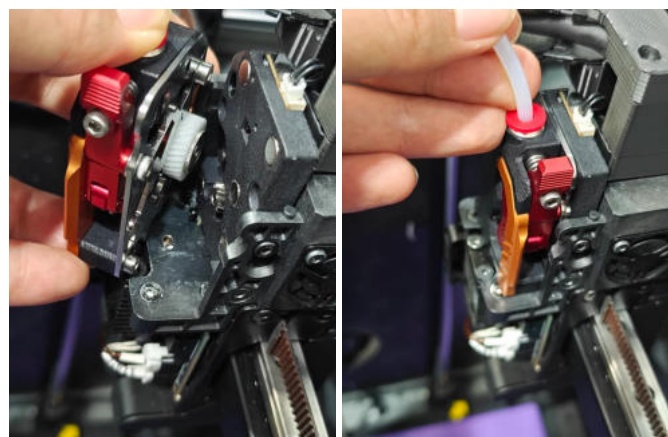
6. Plug in the **cutter sensor connector**. Use the motor screws set aside earlier to **mount the motor** onto the rear cover.



7. Plug the filament runout sensor connector into the sensor.
Align the rear cover with the extruder mounting position — ensure the 3 screw holes on both sides line up.
Take out the 3 original extruder mounting screws.



8. Partially tighten the 3 screws first, then fully tighten them once alignment is confirmed.



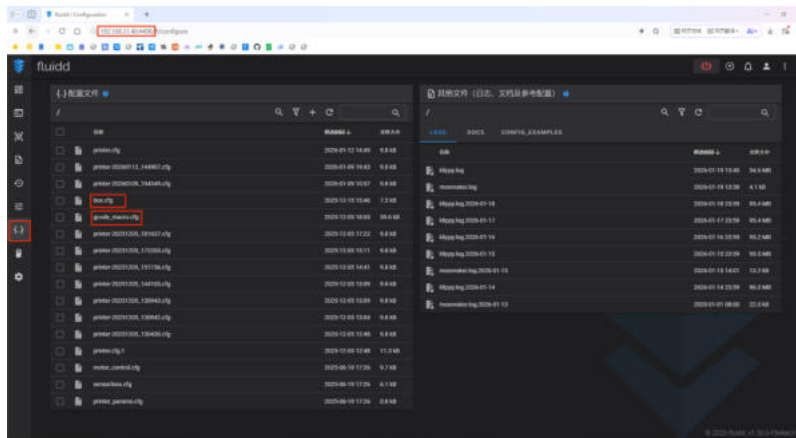
9. Align the front cover assembly with the rear cover and snap them together — no visible gap should remain.
Reinsert the PTFE tube.

10. Extruder installation complete.

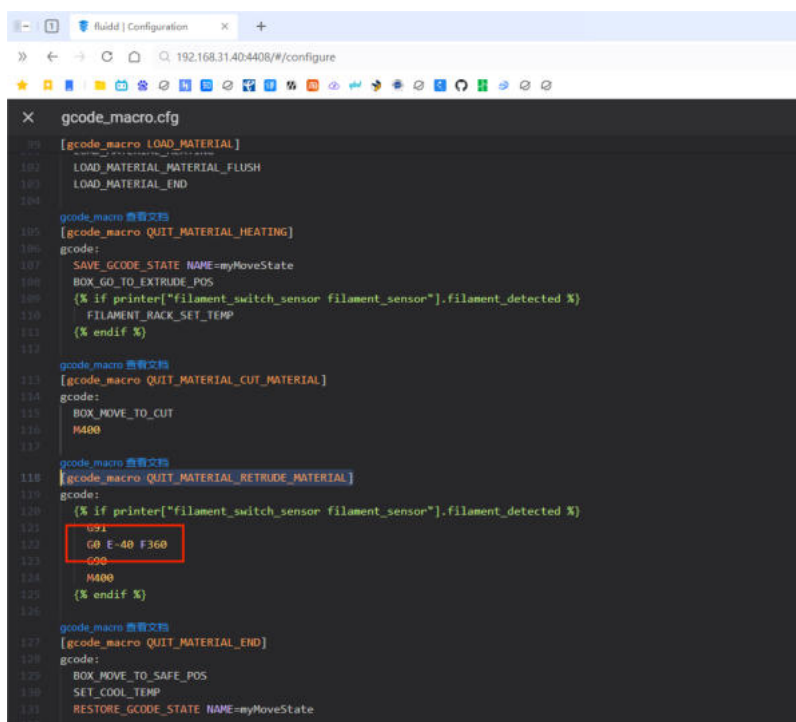
Firmware Modification



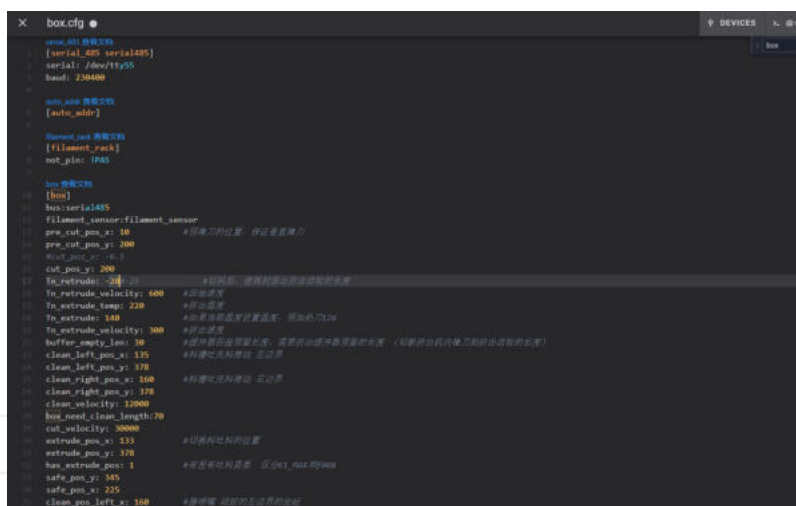
1. On your printer, go to the network settings page and note the IP address (e.g., 192.168.31.40).
Connect your computer to the same network, open a browser, and enter:
IP:4408 (e.g., 192.168.31.40:4408) — this opens the device backend.



2. Go to the Configuration interface, find and open the `gcode_macro.cfg` file.
Locate `[gcode_macro QUIT_MATERIAL_RETRUDE_MATERIAL]` and change the retraction speed to E-40 (as shown in the diagram).
Click Save & Restart in the top-right corner.



3. Find and open the `box.cfg` file.
Locate `[box]` and modify `Tn_retrude` to -20.
Comment out the original value by adding `#` in front (e.g., `#Tn_retrude: -10`). Commented lines will turn gray.
Final: `Tn_retrude: -20`



4. Restart the printer.

Your DXC2 is now ready for a new printing journey!