

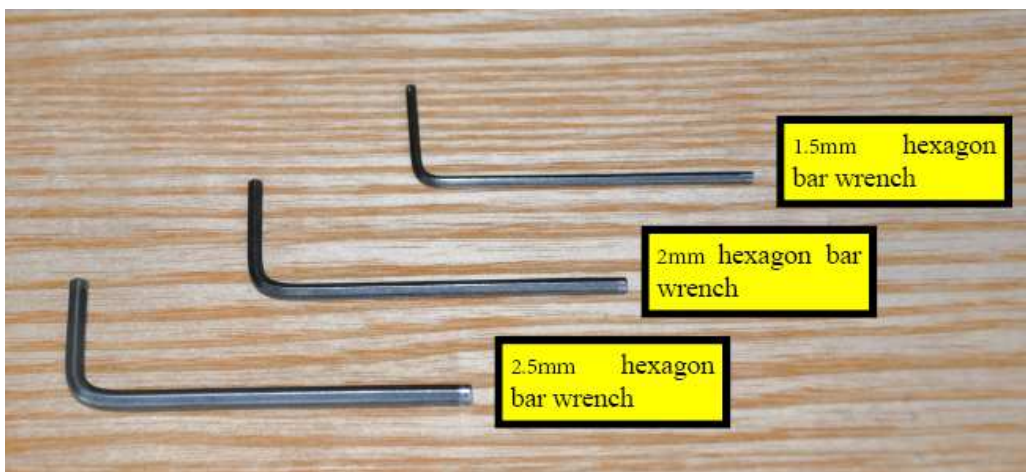
EXRRUDER REPAIRING

A. This Manual can be applied to the following situation.

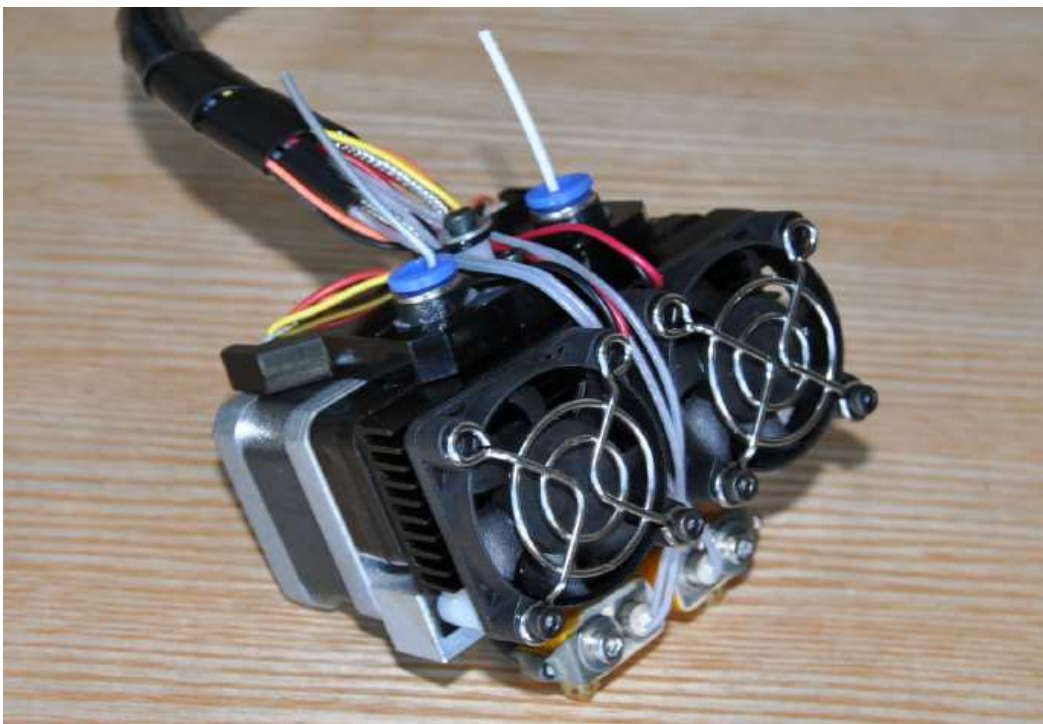
1. The extruder nozzle clogged. You have tried many times un-loading the filament and load the filaments, but still can not get the filaments through. And when loading the filaments, it sound Ka,ka.....
2. There's no driving force while loading the filaments. Nof filaments get out of nozzle.
3. There's one pc filaments stuck in extruder. Loading and unloading filaments both failed.

B. Tools needed

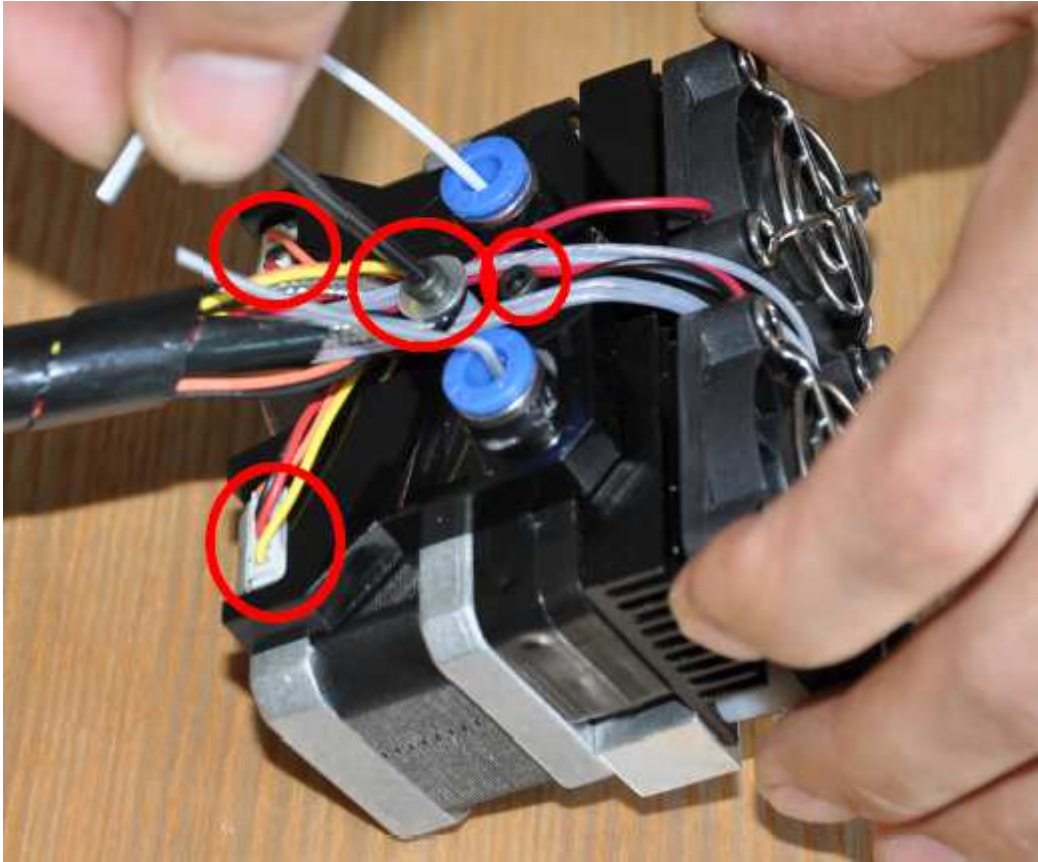
1. 2.5mm hexagon bar wrench, 2mm hexagon bar wrench (inside repairing kit)



2. The full assembled extruder Pic as below

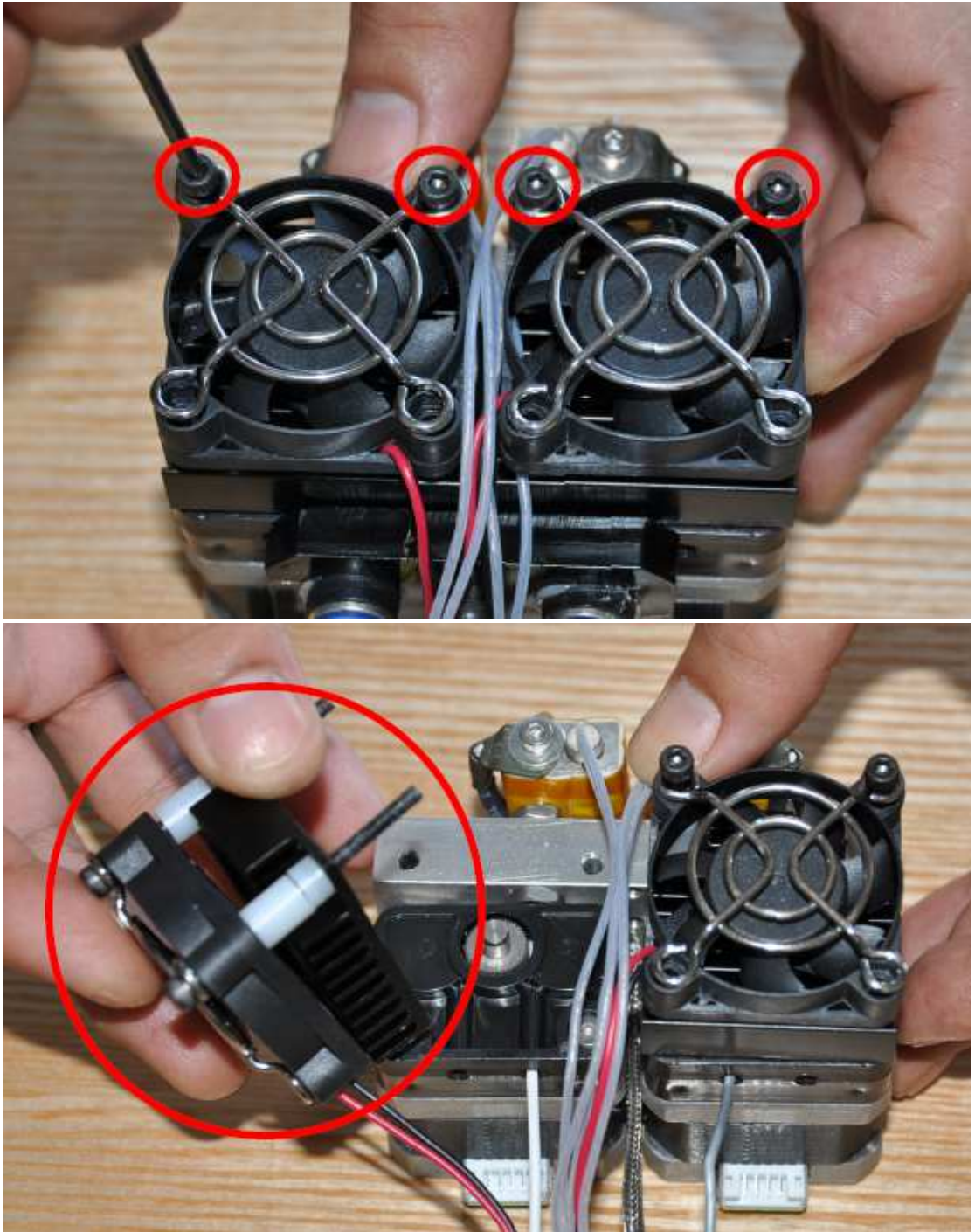


3. Unload the 2 upper M3 bolt (check pic below) ,the motor cable and the upper black plate.

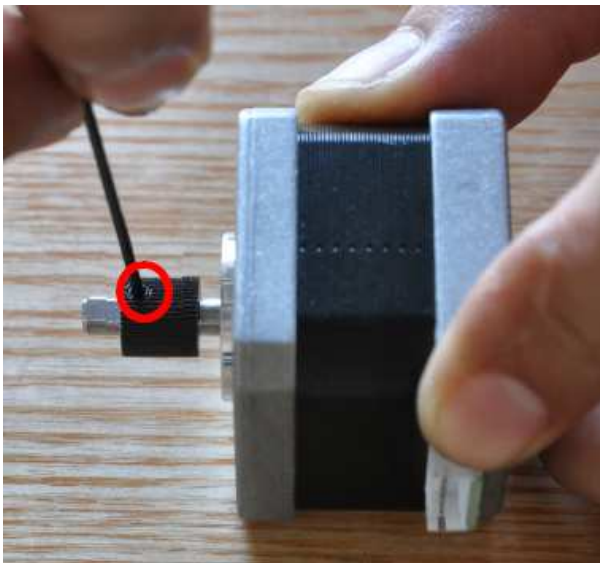


4. Disassemble the 4 locking bolt and put the fan and cooling plate set. Then the motor can be took off from the extruder and the clogged filaments can be removed.
If there is still one pc left inside the thread pipe, please heat the extruder and then pull it

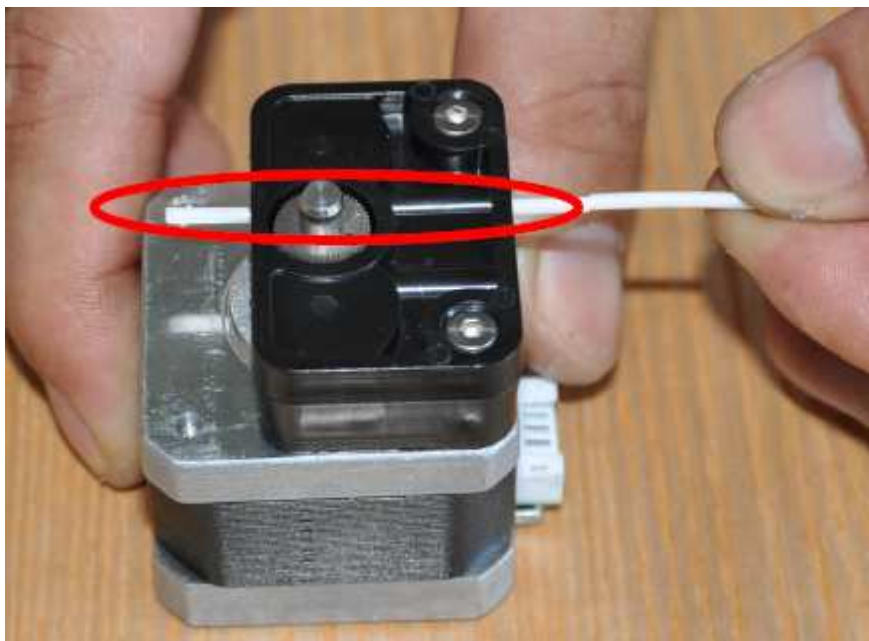
out.

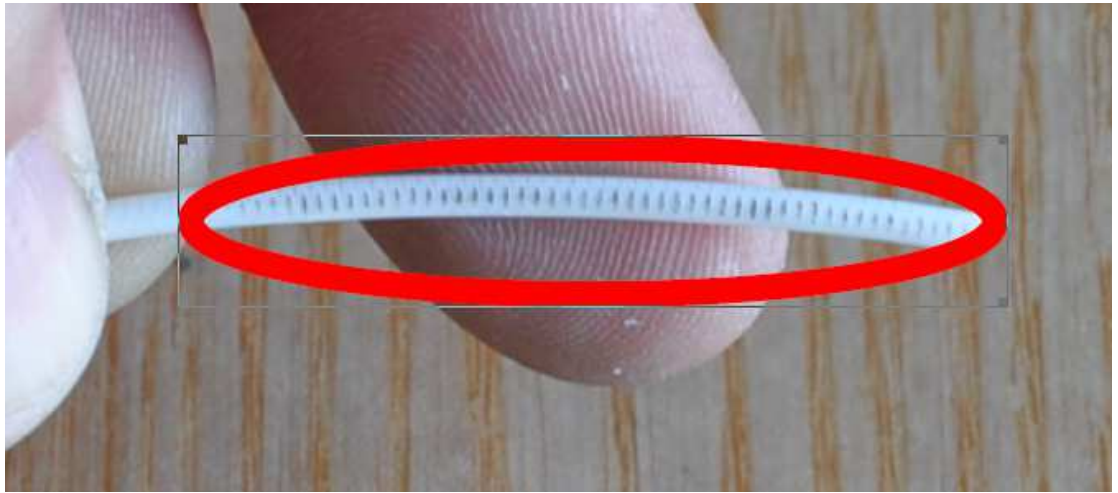


5. To un-bolt the 2 bolts of drive gear set. Then you can un-cover the drive gear set. If there's any jammed article or filaments, remove it. If the drive gear is loose, please re-tighten the bolt.(1.5mm hexagon wrench). If the drive gear has wore, you can move the drive gear a little upper or lower to get the sharp teeth again; or you can replace one



6. Reload the cover, and please make sure the drive gear is in the middle of the RED RING as below. Then you can push one pc filaments through the driving set. Please make sure you get clear driving gear teeth mark on the filaments. If the filament still stuck in the driving set, please re-adjust the bolt until you satisfy the up mentioned items. It may take you several time to meet the requirement.

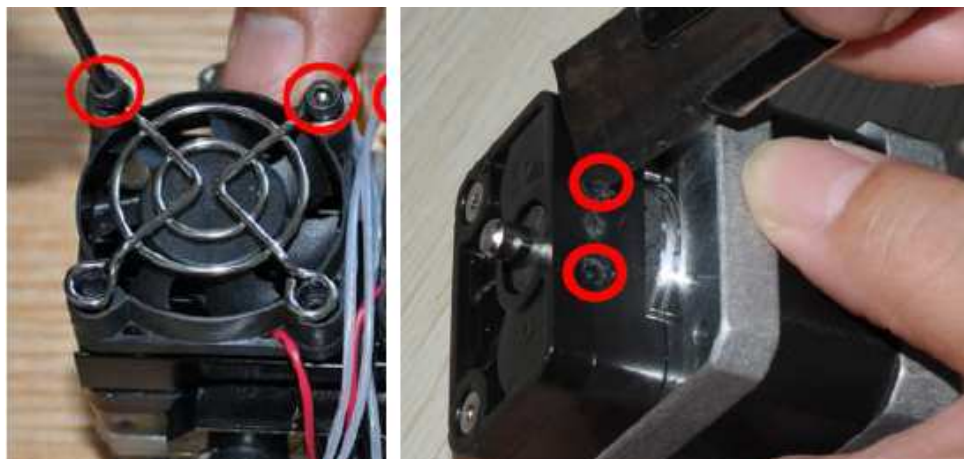




7. Re-assembly the driving set. Please make sure the filaments can get into the thread pipe smoothly. Then you reverse the bolt steps to assembly the extruder. .



If the filaments can not get through the thread pipe. Please adjust the bolt tighter or looser, or to make the following holes bigger by knife. Then assembly the extruder.



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