IMPORTANT IMPROVE FOR MIXING COLOR HOTEND
Fixed the strings (ooze) issue

Step 1: Upload the newest firmware to the control board

firmware HEX file and tools download link:https://www.jianguoyun.com/p/Dd00chMQyoP1BxiCo8IC

Hex file download directory (find it at here: **Marlin\Marlin_1.1.8\Z9\Z9F**):
For default extruder: . \For Default Extruder\Z9F_V2_xx.hex
For Titan extruder: . \For Titan Extruder\Z9F_Titan_V2_xx.hex
PS : Both Z9S and Z9T can upgrade this firmware. If your machine is an older version, please contact with us.

Hex file download directory (find it at here: **Marlin\Marlin_1.1.8\Z8\Z8S\Z8S_M3\V3**):
For default extruder: . \For Default Extruder\Z8SM3_V3_xx.hex

NOTE: We strongly recommend that you upgrade your extruder to Titan extruder, which can effectively improve the hotend sticking (clog) issue. We will provide preferential service for customers to upgrade. Please contact our business personnel at the shop you purchased.

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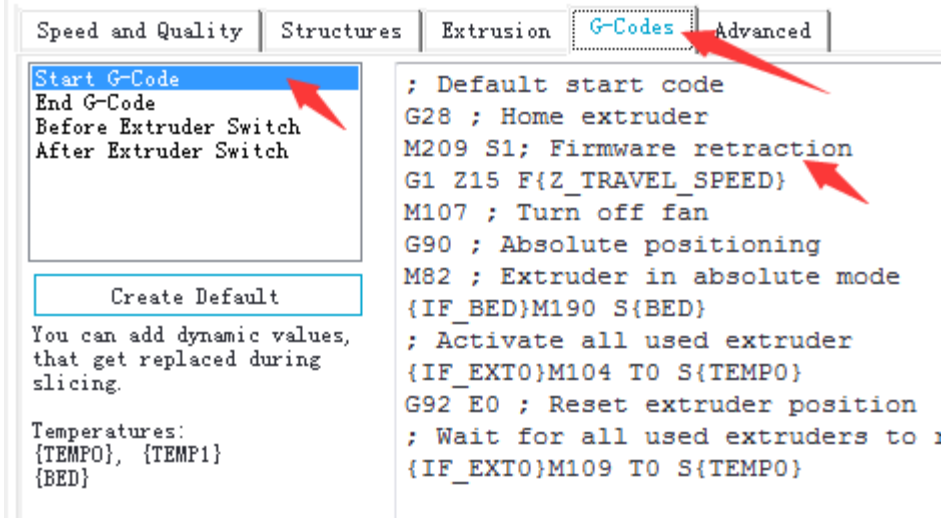
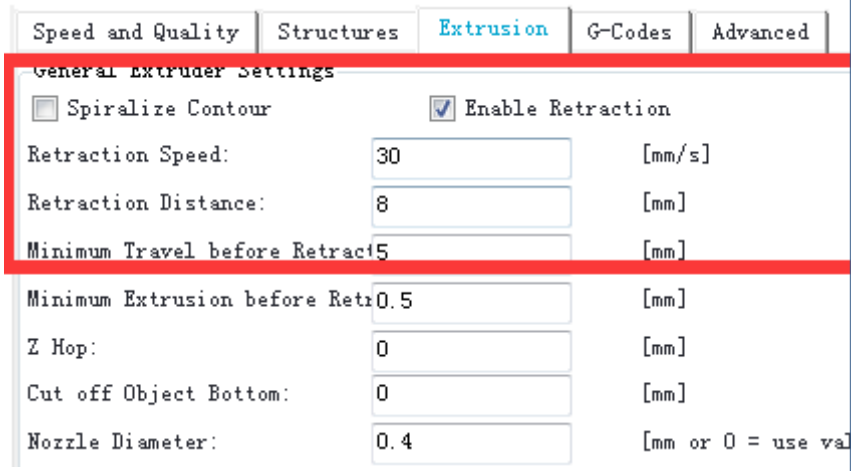
Step 2: Modify the settings in slicing software

1. Add a "M209 S1" command on the start code
2. Enable Retraction and set the retraction distance to 8mm and retraction speed to 30mm/s

Repetier-HOST Cura Engine





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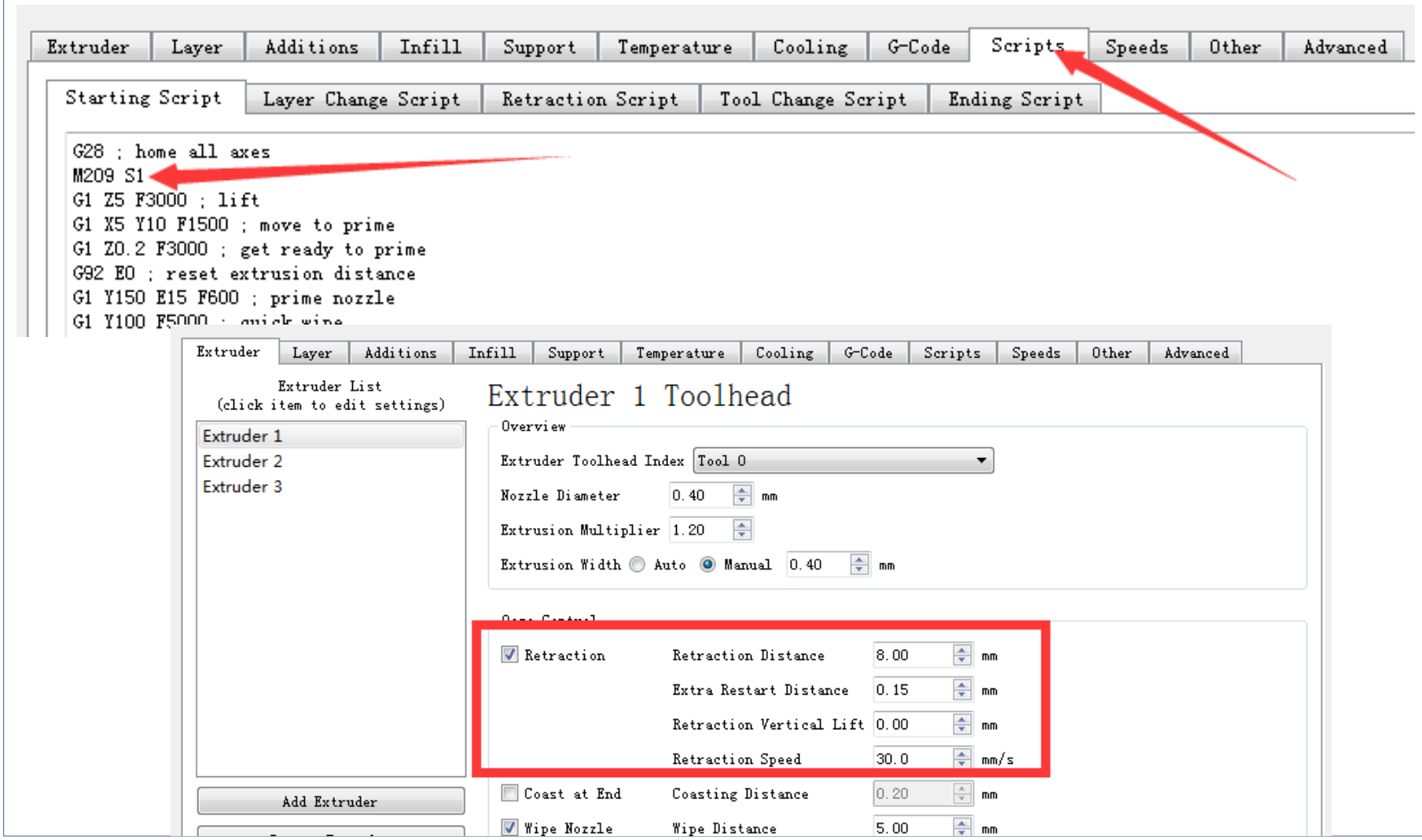
Simplify 3D



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Step 3: Load the filaments to all the extruders and hotend channels,

PS1: You can load filaments into only two channels too. The more channels you load filaments, the effect if the better.

PS2: The channel without filaments shall be closed with hot end cleaning tool.

Step 4: To replace a new FAN duck, it will help to improve the strings issue too.

Fan duck stl file download link:

https://www.jianguoyun.com/p/DcGaCzIQyoP1BxjpgvgC