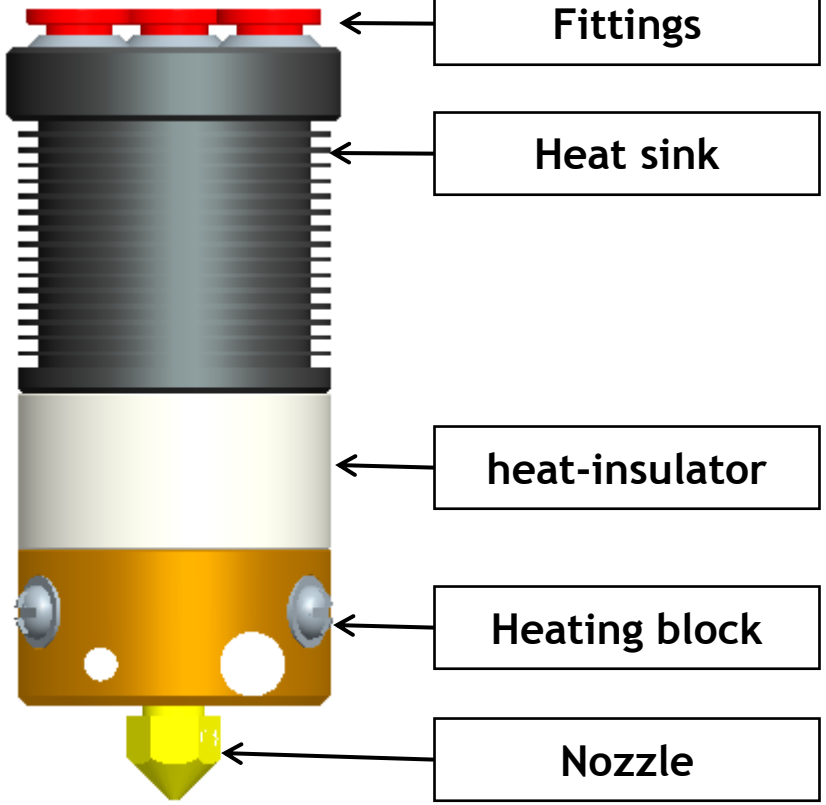
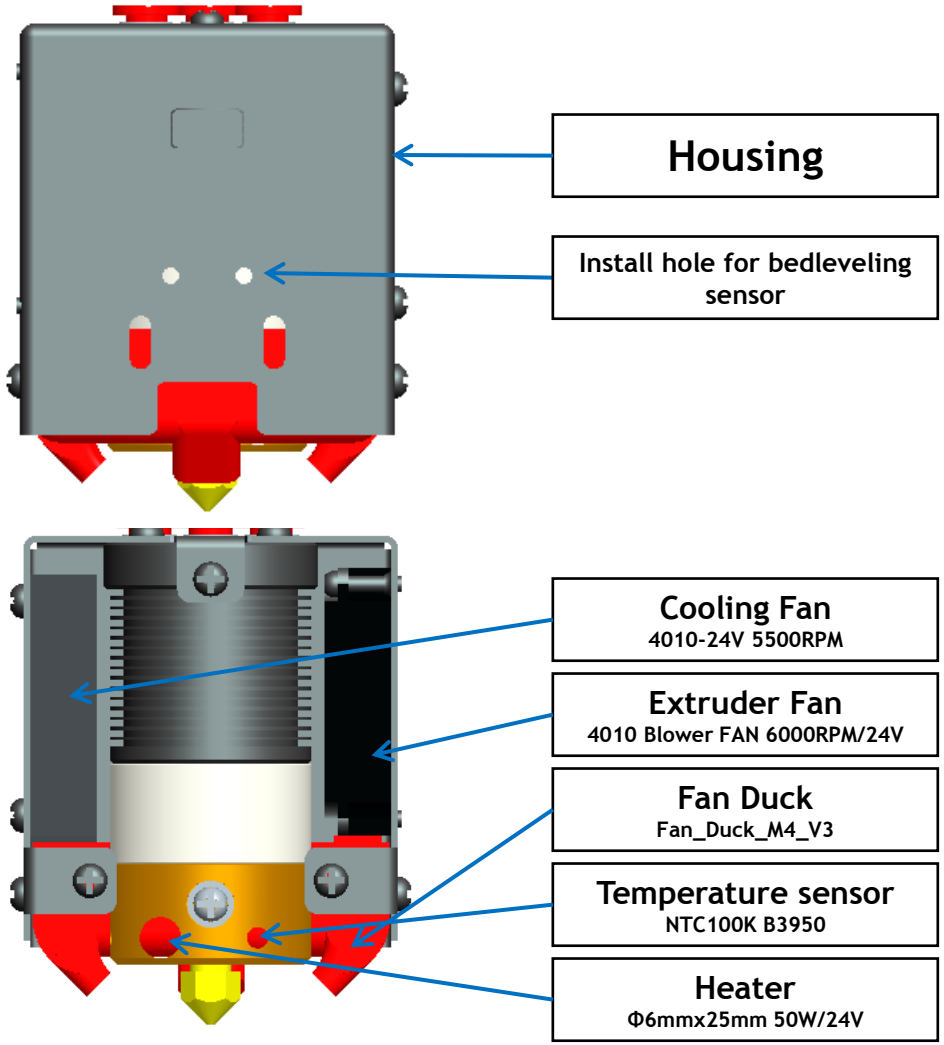
M4V5 hotend

M4V5 hotend

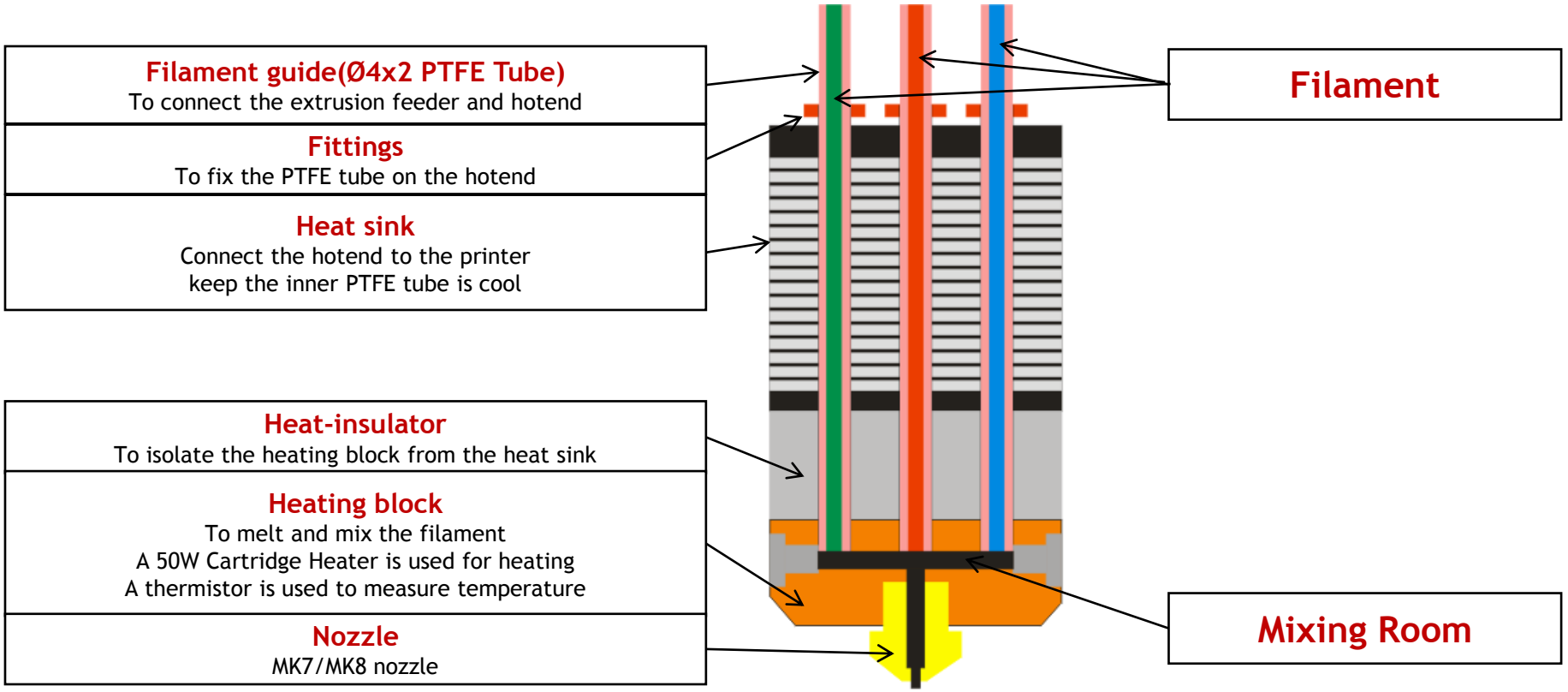


M4V5 hotend assembly



Structure and Working principle

•Structure of mixing color hot end

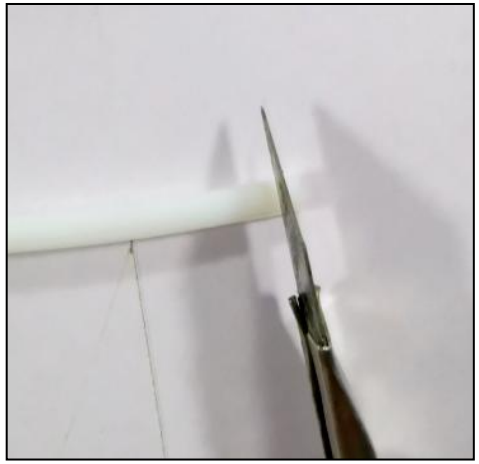


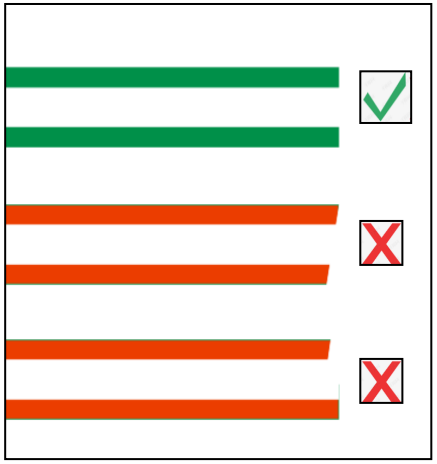
NOTE: This diagram only explains the mixing principle, so only three color channels are drawn.

•Color mixing principle:

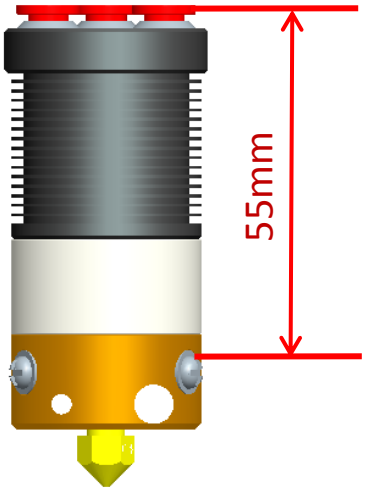
1. Filaments melt and mix in the mixing room, and then flow out from the nozzle.
2. To change the feed ratio in different color filament, it can get different color filament.

How to insert / pull out PTFE guide





To cut the PTFE pipe by a knife (paper cutter)
try to keep the front end flat

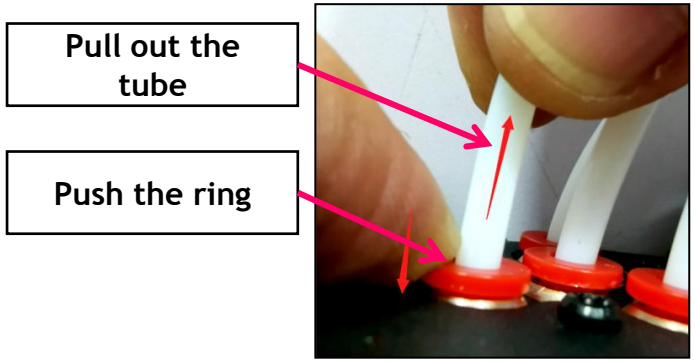


Insert the PTFE to the hotend as far as deeply
(depth is about 55mm)

Pull out the PTFE tube:

ATTENTION: If there is filament in the hotend, unload the filament first, about how to unload filament, please refer to the nex page.

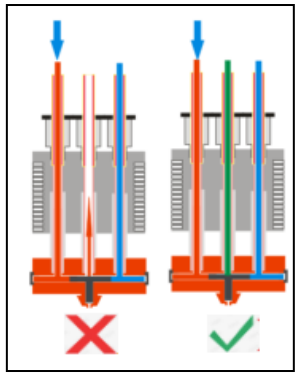
1. Push the red ring of the fitting, and then pull out the PTFE tube.
2. If the PTFE tube can't be pull out, heating the hotend to 200 degree and try again.



Load and unload filament

Load filament

1. MUST load filaments to all 4 channels, DONOT leave any channel empty before printing.
2. While loading filament, make sure the filaments has been inserted to the bottom of the hotend.
3. Before operating one of the channels, rotate all extrduer motors to feed in filament at the same time, and ensure that filament flows out from the nozzle over 50mm.



Unload filament

1. Heating the hotend before unload filament 180 ℃ for PLA and 210 degree for PETG.
2. Feeder 50mm filament at least before unload filament.
3. Operature the LCD menu or rotate the extruder gear to upload filament.