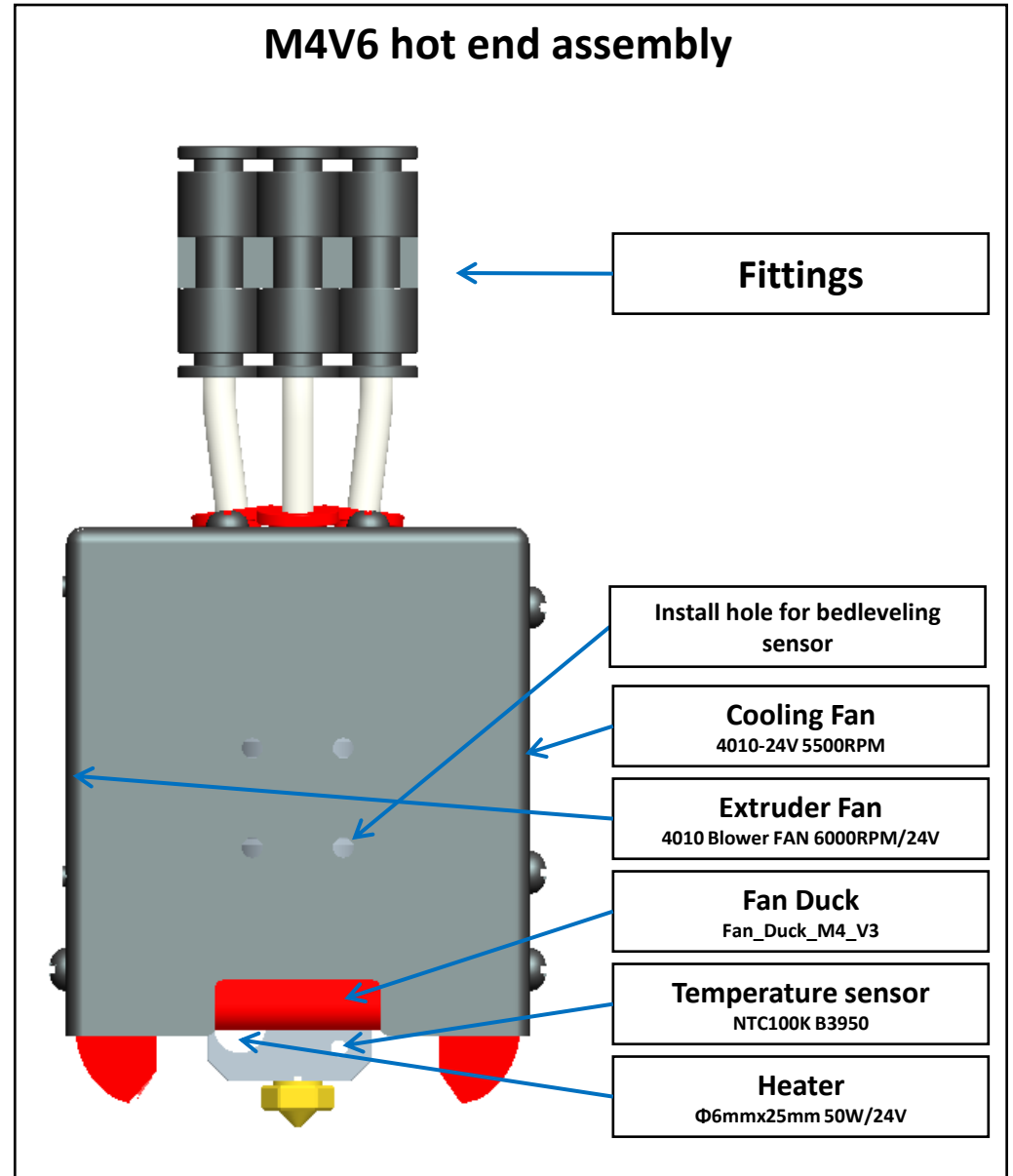
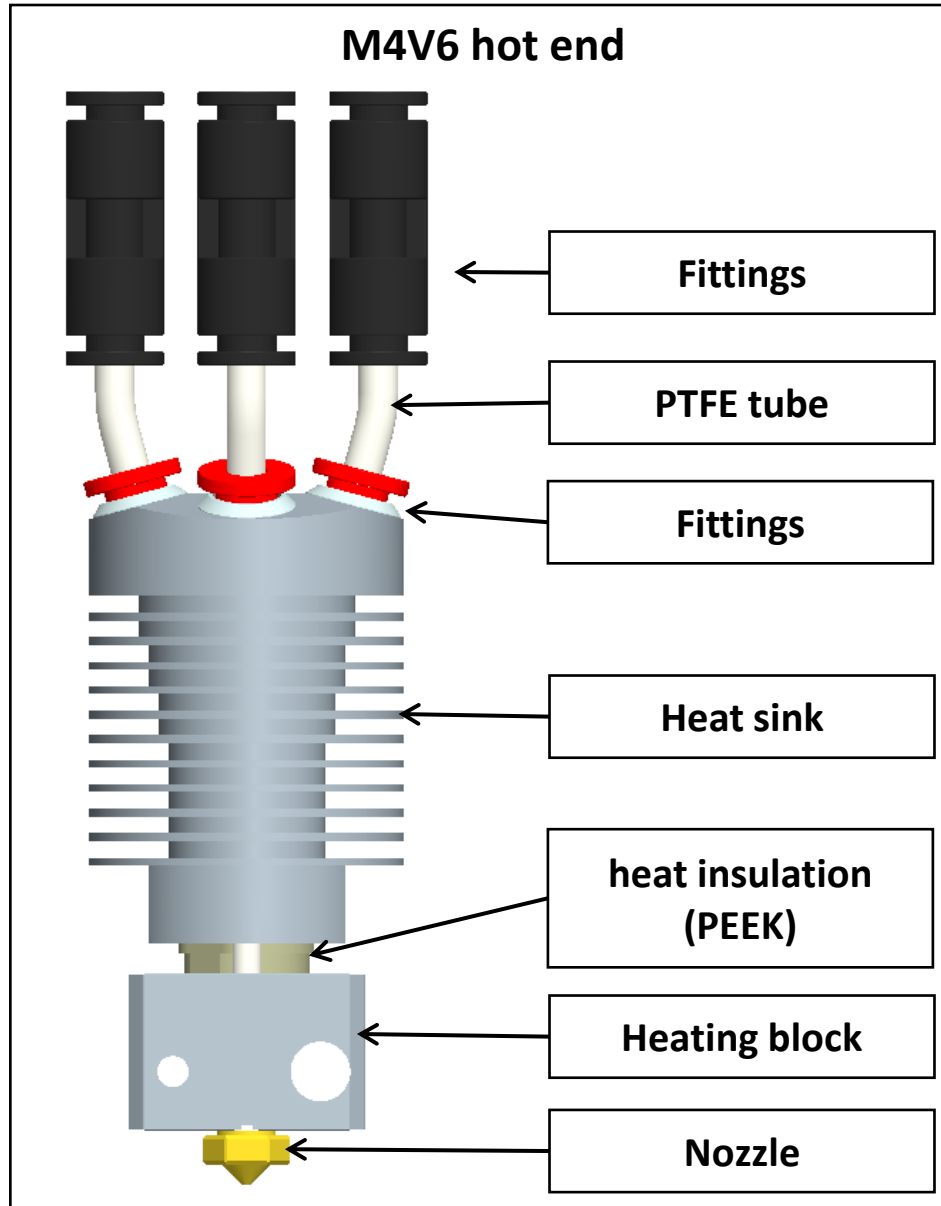
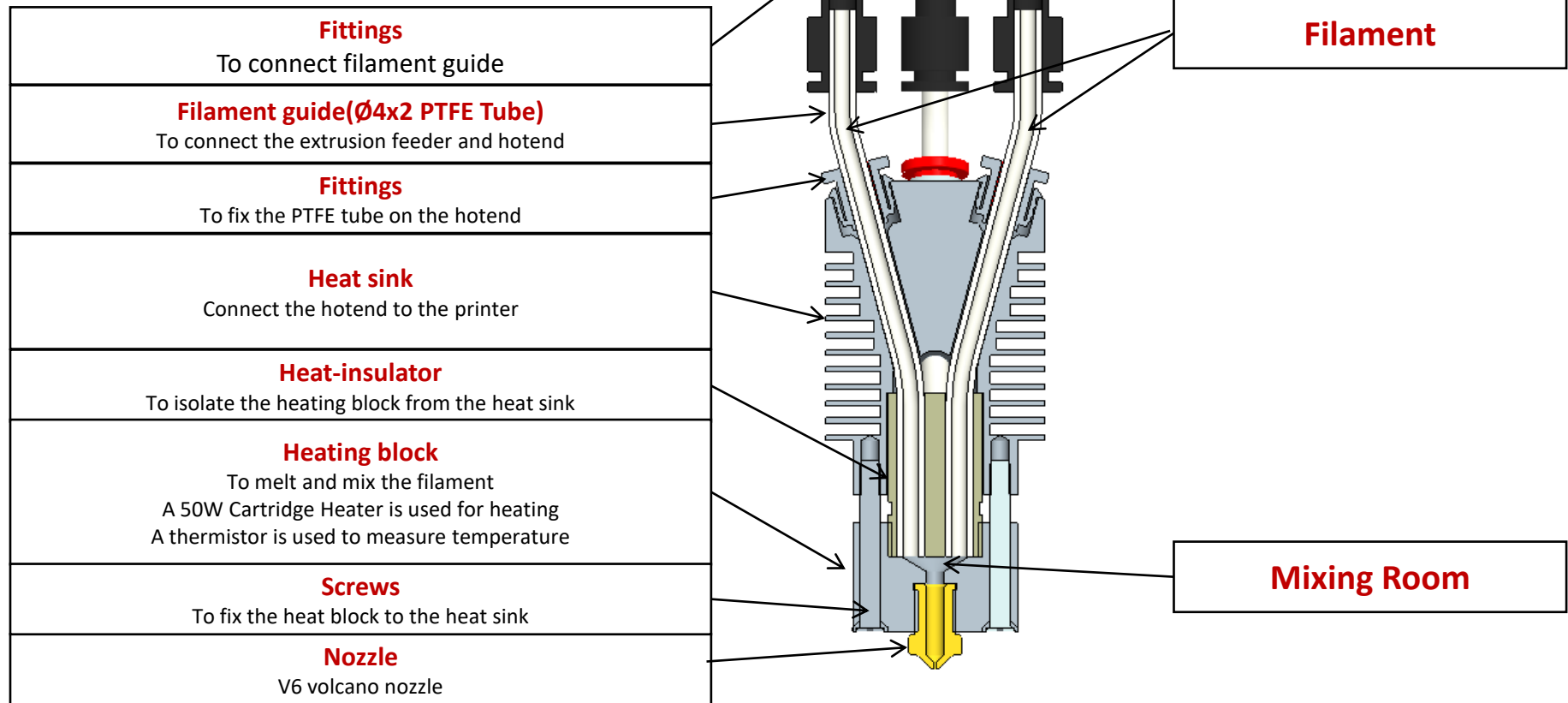


# M4V6 hot end



# Structure and Working principle

## •Structure of M4V6 hot end



## •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.

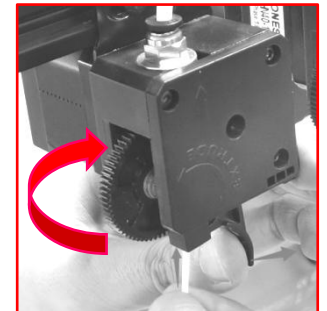
# Load and unload filament

## Load filament

- **MUST load filaments to all 4 channels, DONOT leave any channel empty before printing.**
- While loading filaments, make sure the filaments has been inserted to the bottom of the hot end.
- Before operating one of the channels, rotate all extruder motors to feed in filament at the same time, until that filament flowed out from the nozzle over 50mm.

## Unload filament

- Heating the nozzle before unload filament (200°C for PLA / 230°C for PETG).
- Operature on the LCD menu or rotate the extruder gear to upload filament.



# How to Replace of the PTFE guide

- Prepare 4 piece PTFE tube (ID=2mm/OD=4mm), length is about 100mm (Fig 1). To cut the PTFE pipe by a knife (paper cutter) and try to keep the front end flat.
- Remove the screws which to fix the hot end on the top of the hot end housing (Fig 2).
- Loosen the screws which to fix the heater and temperature sensor (Fig 3).
- Remove the heater and temperature sensor from the hot end (Fig 4).
- Remove the hot end from the housing (Fig 5).
- Remove the 2 screws to fix the heating block (Fig 6).
- Pull out the heating block (Fig 7).
- Press the “RED ring” of the fitting and pull out the PTFE tube (Fig 8).
- Insert the new PTFE tube and install the heating block back in reverse order.
- Push the PTFE guide to the bottom after installed the heating block.

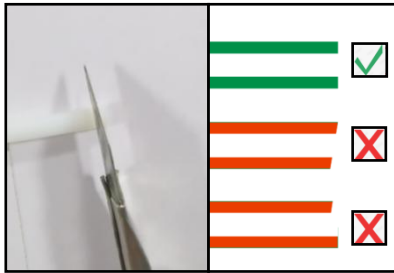


Fig1



Fig2

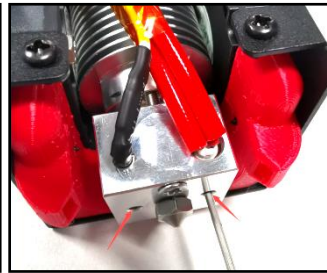


Fig3

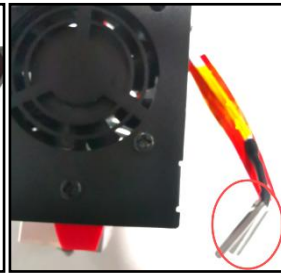


Fig4

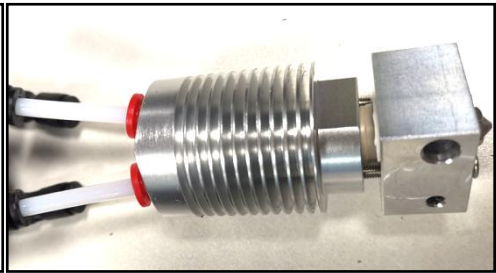


Fig5



Fig6

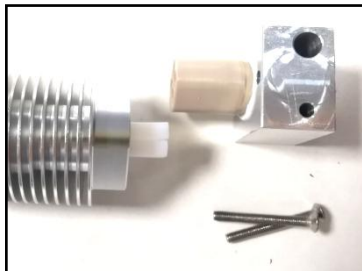


Fig7



Fig 8

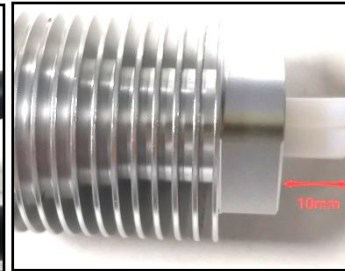


Fig 9