



QUALITY ASSURANCE RECORD

Model: LulzBot Mini 1.0 3D Printer

Serial Number: _____

Date Completed: _____

Tested by: _____

Configuration:

Electronics: Mini-RAMBo 1.3a

Firmware: Marlin 1.1.0.9

Nozzle: 0.5mm diameter nozzle

Settings:

| Stepper Motor | Steps/mm | Max Length | Microstep Mode | Digipot |
|---------------|----------|------------|----------------|---------|
| X | 100.5 | 155 | 16 | 175 |
| Y | 100.5 | 155 | 16 | 175 |
| Z | 1600 | 155 | 16 | 220 |
| E0 | 833 | NA | 16 | 135 |

| Z Offset |
|----------|
| |

General:

- ☐ Are all the screws and zip ties tight?
- ☐ Are the current version of parts being used?
- ☐ Is the Spool Mount properly mounted so it flips up and sits securely?
- ☐ Is the Finger Clip properly mounted with the taller side on the left?
- ☐ Are the switches installed securely?
- ☐ Are all 4 rubber feet installed?
- ☐ Is the PEI tape free of bubbles and wrinkles?
- ☐ Is the heat bed adhesive smooth and consistent?
- ☐ Is the frame free of scratches and scuffs?

Y Axis:

- ☐ Does the Y bed move freely back and forth?
- ☐ Is the Y bed tight side to side from motion and twisting?
- ☐ Does the Y belt rub on the y-idler by the bearings?
- ☐ Are the Y pulley set screws tight with one aligned with the flat on the motor shaft?
- ☐ Is the Y belt tight?
- ☐ Are the four bed leveling washers tight?
- ☐ Are the belts trimmed far enough to not interfere with the pulley or bearing?



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X Axis:

- ☐ Are the X pulley set screws tight with one aligned with the flat on the motor shaft?
- ☐ Does the X belt rub on the x-idler by the bearings?
- ☐ Does the X belt rub on the screw heads of the belt mount?
- ☐ Is the X belt tight?
- ☐ Does the X axis move freely end to end?
- ☐ Are the belts trimmed far enough to not interfere with the pulley or bearing?
- ☐ Are the wires and zip ties behind the carriage free from touching the case wall?

Z Axis:

- ☐ Do the Z drive rods rotate smoothly?
- ☐ Are the coupler set screws tight?
- ☐ Are the drive rods and motor shafts aligned so the couplers are not bent?

Extruder:

- ☐ Are the extruder springs set to 8mm between the cap and the latch?
- ☐ Are the V grooves on the extruder gears lined up?
- ☐ Is the hobbing aligned to the hole in the extruder?
- ☐ Can you feed filament about 100mm from the top of the extruder?

Electronics:

- ☐ Are all connections to the Mini-Rambo plugged in correctly?
- ☐ Are all cables free from contacting any moving parts?

Test and Verification Results:

- ☐ Verify case fan is running.
- ☐ Verify heat sink fan is running when motors are engaged.
- ☐ Verify control of the extrusion fan.
- ☐ Nozzle temperature control verified.
- ☐ Extruder control verified.
- ☐ X, Y, and Z min and max stop switches verified.
- ☐ Bed leveling is functioning properly.
- ☐ Bed temperature control verified.
- ☐ Bearing conditioning complete.
- ☐ Test print (Octopus*) successful.
- ☐ Print head moved to shipping position.

*Octopus by yeoldbrian is licensed under CC BY-SA 4.0



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