

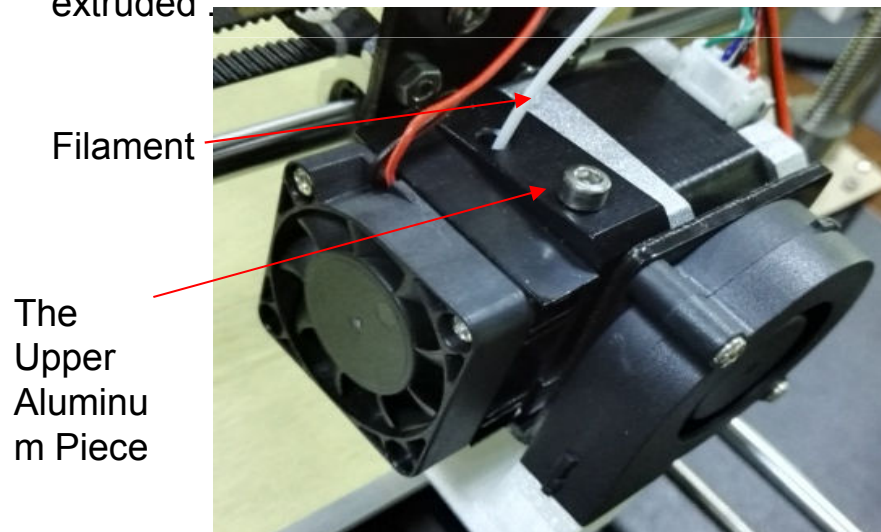
# Change the Filament

## 1. Change the Filament When not Printing

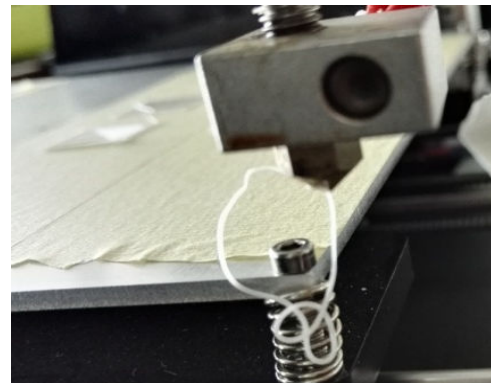
1.1 Pull out the filament: Firstly preheat the nozzle to the exact temperature (PLA: 200~220°C , ABS: 240~260°C) Once the temperature is up to the same as setting, press the upper aluminum piece on the extruder motor with left hand, meanwhile push down to extrude part of filament and then pull out it rapidly with right hand.

(PS: Don't pause in the process to avoid the jam lead by the cooling midway. Picture 1,2)

1.2 Insert the Filament: Press the upper aluminum piece on the extruder motor and meanwhile insert the filament into the throat( You can cut the filament into oblique angle with scissor to plug in smoothly. Picture 3), push down to extrude part of filament (Picture2) , then let the aluminum piece go, finally clear up the filament extruded



Picture 1



Picture 2

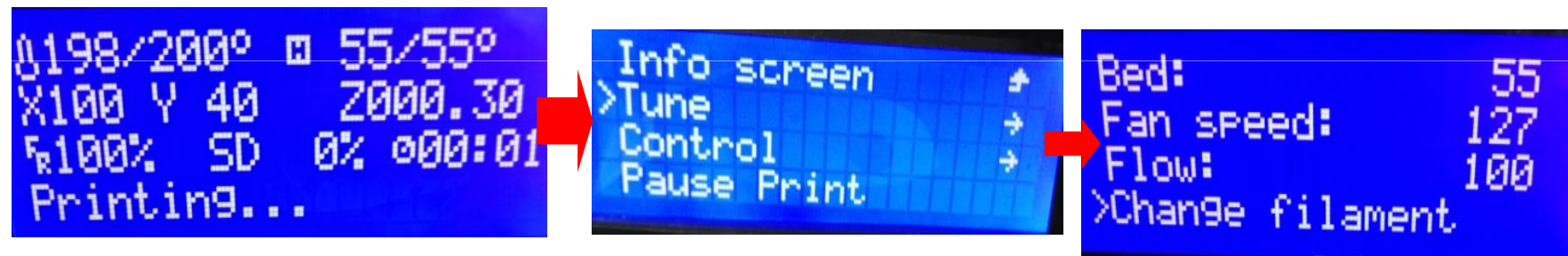


Picture 3

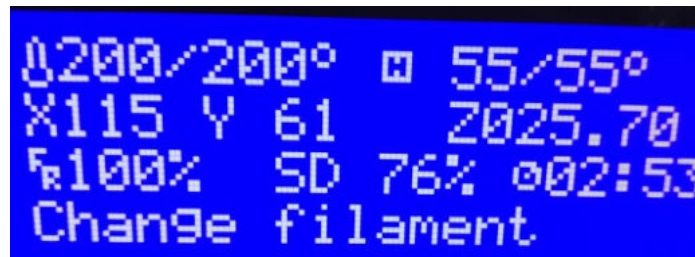
## 2. Change the Filament When Printing

2.1 Click “tune” → “change filament” ; The printer stop working and the XY axis would be back to the origin, then the extruder would send back the filament from the printer automatically (Picture 4) ;

2.2 Change the filament manually and press the knob, then the printer would go on printing starting from the former position of printing model.



Picture 4



Picture 5