QUALITY ASSURANCE RECORD

Model: LulzBot Mini 1.0 3D Printer

Serial Number: _____
Date Completed:_____
Tested by:_____

Configuration:

Electronics: Mini-RAMBo 1.3a
Firmware: Marlin _____
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?

QUALITY ASSURANCE RECORD

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.

Aleph Objects, Inc.
626 West 66th Street
Loveland, Colorado 80538 USA

www.alephobjects.com
www.lulzbot.com
+1-970-377-1111