

How to replace the extruder's hot end

Warning: We strongly recommend using the filament or metal stick to dredge the clogged extruder or the stuck filament inside the extruder instead of replacing the parts, so you don't have to disassemble anything. The metal sticks under the diameter 1.75 mm are ok. For example this loop metal stick:<https://www.aliexpress.com/item/2037221587.html> or www.amazon.com/dp/B01COSU6CW/ . We can push down the filament or metal stick by hand again and again to the heated extruder to dredge the clogged extruder or the stuck filament, and this way usually works.

Please be careful for human electrostatic especially in winter when touching the motherboard or extruders or laser. The easiest way to solve this problem is that we can touch the metal part nearby by hand first before touching the motherboard or extruders or laser. So the electrostatic usually will be gone before touching the motherboard or extruders or laser.

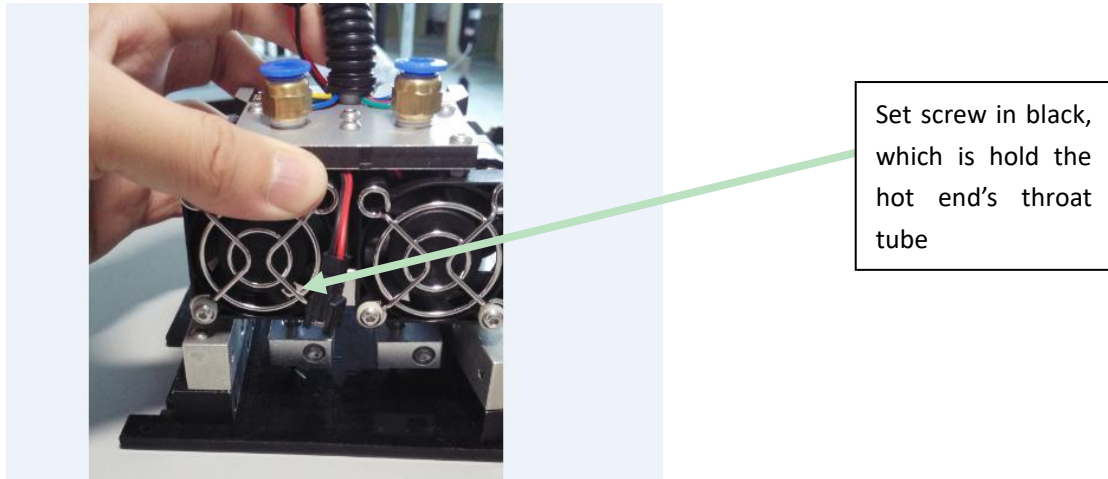
Note: Thermistor is very fragile, please handle it with care. Insert the thermistor to the hole on hot end and tie the thermistor to the hot end **just let a little contact with black bolt or the set screw, not to press the thermistor (keep loose), or the thermistor will be broken. The cartridge heater is fixed with the set screw or a black screw, and please loose the set screw or the black screw first, then take the cartridge heater out carefully.**

1. Print level support first with lower extruder first. You can download the stl file from here: <https://drive.google.com/file/d/1hYi0CndAwpTahpmextx2Vg9lt-Pv0l8D/view?usp=sharing>

If you want to download the printing gcode file for PLA directly, please download E1 printing here: <https://drive.google.com/file/d/1j2y-soPVzVz5cLAgLswKGBgyzib3Mnq5/view?usp=sharing>

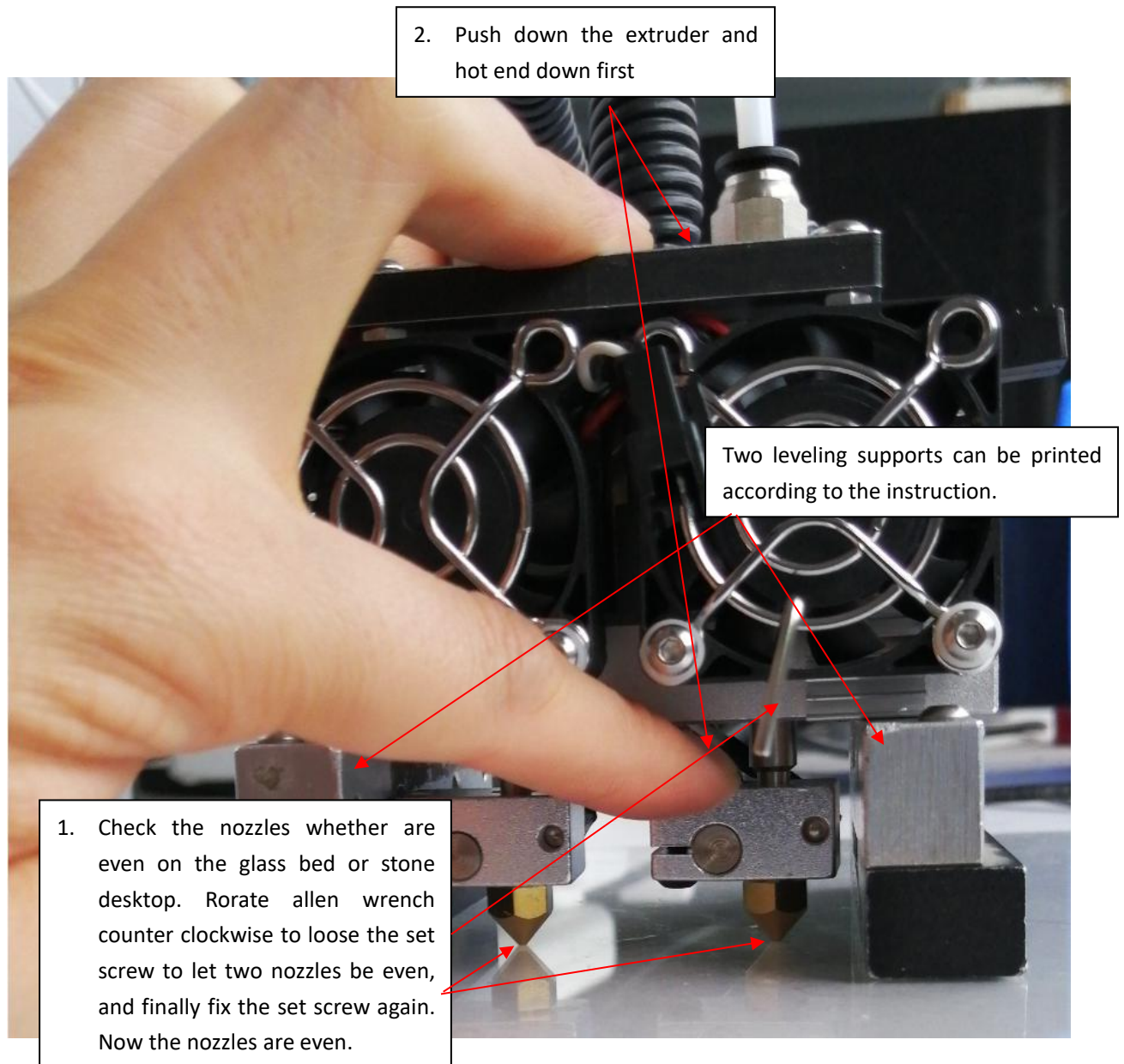
E2 printing here: <https://drive.google.com/file/d/1PE9-3zYMXtoJO0TCv1yyeLpvzO7GjVTs/view?usp=sharing>

2. Take the thermistor and cartridge heater out from the hot end's heating block first carefully.



Please use the allen wrench to loose this black set screw, then you can pull the hot end down from the extruders. The video is here:
https://drive.google.com/file/d/0B148jWiv_vJebjIORlVkdNjyRjg/view?usp=sharing&resourcekey=0-2J47gx-E5OJR7U-3tOi9AA

3. Put the extruders on these level supports your printed before to level the hot ends.



If the nozzles are still not even, we can put some slim such as paper or tape under the hot ends mounting block. More details, please kindly check this:
https://drive.google.com/file/d/1Id9LY1zaYfUNU6KqLy3YznuAQ7wq_aGd/view?usp=sharing