

#### Assembly of extruder

Warning: Usually we don't recommend that you disassemble the extruder as there is the calibration there and some customers may even make the thing worse. You can contact [bibo@ourbibo.com](mailto:bibo@ourbibo.com) for better solution.

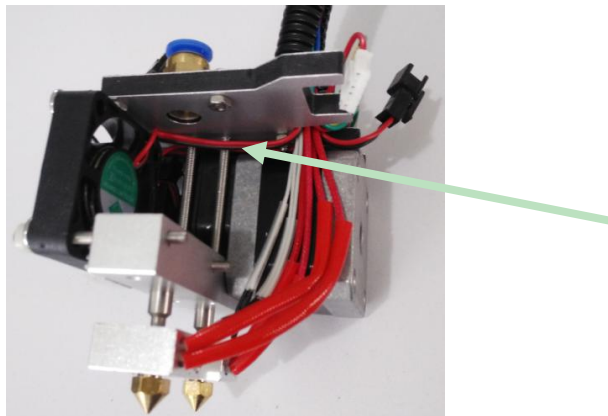
Please be careful for human electrostatic especially in winter when touching the motherboard or extruders or laser. The easiest way to solve this problem is that we can touch the metal part nearby by hand first before touching the motherboard or extruders or laser. So the electrostatic usually will be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

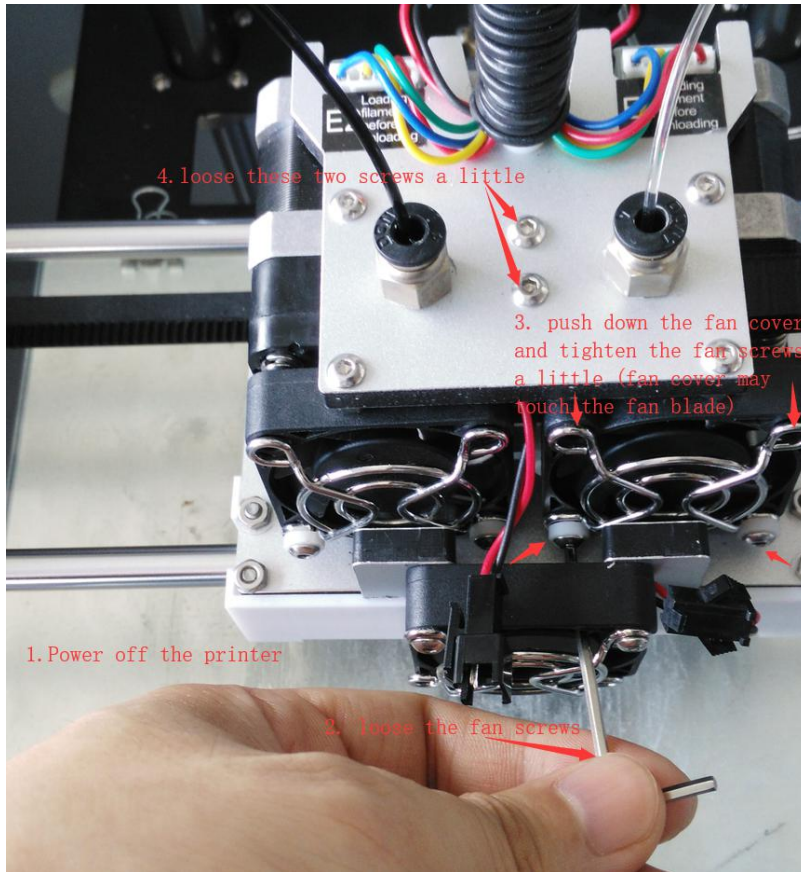
Please kindly check the disassembly video link below:

[https://drive.google.com/file/d/0B148jWiv\\_vJebE10Nm5DTIZNUDA/view?usp=sharing&resourcekey=0-eUFQm\\_Yq\\_iOTrDQ0sZbJCA](https://drive.google.com/file/d/0B148jWiv_vJebE10Nm5DTIZNUDA/view?usp=sharing&resourcekey=0-eUFQm_Yq_iOTrDQ0sZbJCA)

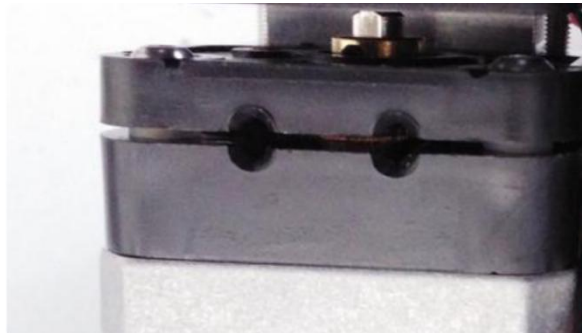
**When adjusting an extruder you may get a misalignment with the throat of the hot end, to avoid this try inserting a length of filament while the extruder is loose and wiggling it around until the filament passes through to the nozzle, then tighten the extruder.**

When you assemble the extruder again, please make sure **the fan wire is not pressed by the screw's thread. The Fan metal cover should be pushed down and the screws on the extruders top piece should not be tightened, or the fan will have the noise or can't run.** Check the photo below:



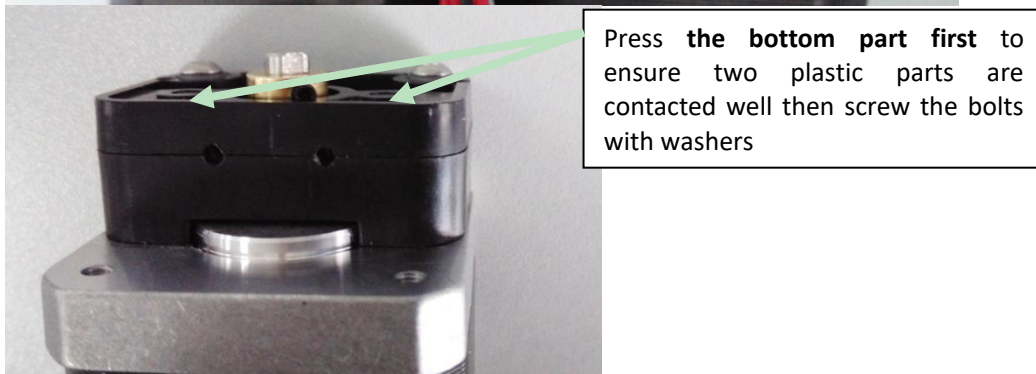
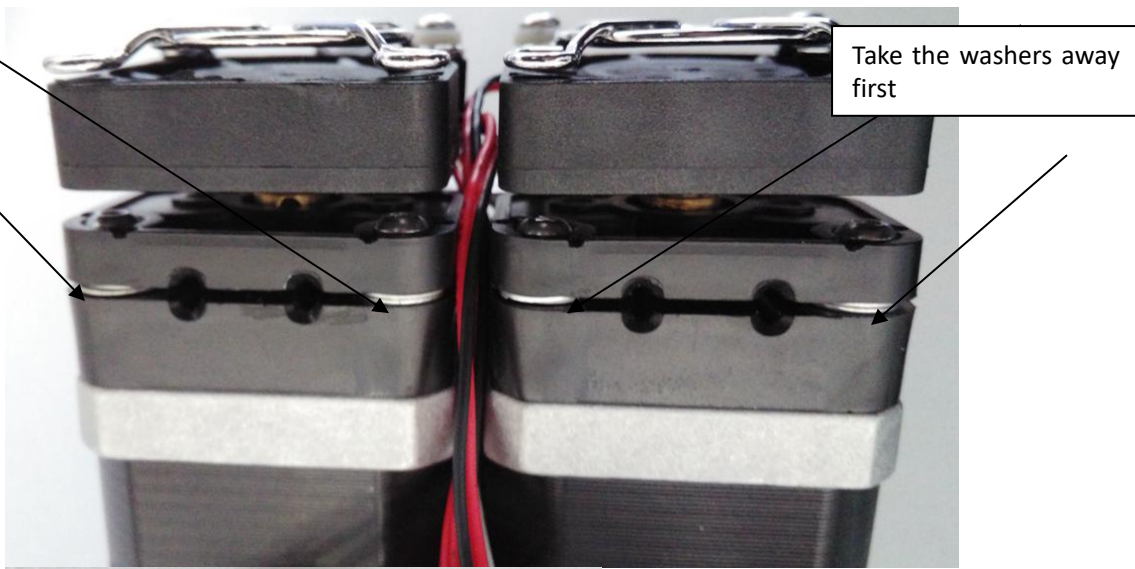


Please don't disassemble the extruder part as the photo below:



We have calibrated the tension for extruding system. If you disassemble them, the calibration will be broken.

If you want to reassemble them and there are washers between two plastic parts, please take the washers away first. If no washers, please skip this step.



Sometimes the filament can't be extruded, as the extruder assembly is too tight or too loose . If it is hard for you to get the correct tension for two bolts, please check this link:  
<https://drive.google.com/file/d/0B76TjeOksIHITzJ5RWZIT2ZaQ00/view?usp=sharing&resourcekey=0-JUhrp2fA7iifRcAZuHn7qg>

When you press the filament on the back of the extruder motor, the filament can still be

extruded properly , and this tension is usually ok.

