

### Dredging the extruder

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/](https://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.

**Restart the printer**, then preheat the extruder to **250 or 260 degrees**. Push the filament down to the extruder **by hand** (if you have done the extrusion through touch screen menu after restarting the printer, the extruder motors will be locked, and you can't push the filament down by hand and have to restart the printer again) . **Please push the filament down and pull it back about 10mm and push the filament again**. Do this again and again, usually the clogged filament can come out from the nozzle.

If the above way doesn't work, please use the metal stick (smaller than 1.75mm in diameter, and at least 80 mm long) to dredge the heated extruder instead of the soft filament . You can get the similar metal stick here: [www.aliexpress.com/item/2037221587.html](https://www.aliexpress.com/item/2037221587.html) (choose the loop shape stick)

USA: [www.amazon.com/dp/B01COSU6CW/](https://www.amazon.com/dp/B01COSU6CW/)

UK: [www.amazon.co.uk/dp/B002FOK63A/](https://www.amazon.co.uk/dp/B002FOK63A/)

DE: [www.amazon.de/dp/B00B7WSC9G/](https://www.amazon.de/dp/B00B7WSC9G/)

CA: [www.amazon.ca/dp/B007E0I0UQ/](https://www.amazon.ca/dp/B007E0I0UQ/)

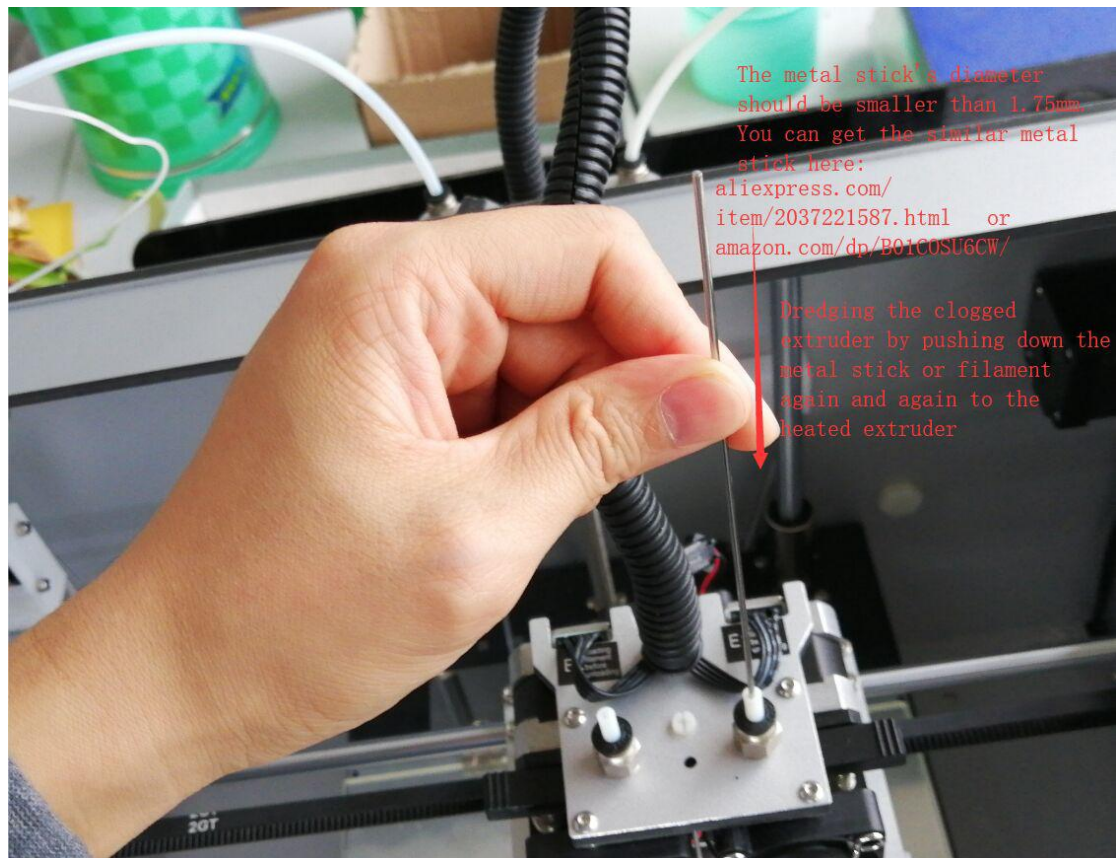
JP: [www.amazon.co.jp/dp/B07QXMJVQP](https://www.amazon.co.jp/dp/B07QXMJVQP)

FR: [www.amazon.fr/dp/B00B7WSC9G/](https://www.amazon.fr/dp/B00B7WSC9G/)

ES: [www.amazon.es/dp/B00B7WSC9G/](https://www.amazon.es/dp/B00B7WSC9G/)

IT: [www.amazon.it/dp/B002FOK63A/](https://www.amazon.it/dp/B002FOK63A/)

The solution is below:



Now preheat the clogged extruder in high temperature such as 240 degree.

Insert the metal stick (**the diameter must be smaller than 1.75 mm, and at least 80 mm long**) to dredge the extruder. Usually this way works.

**If still doesn't work, please use the fire to heat the metal stick first, then push down the heated metal stick at once. Usually the heated metal stick will melt the stuck filament and solve the problem.**

If still don't work, we have to replace the hot end. You can get the hot end on our amazon store or here: [https://www.aliexpress.com/store/product/4pcs-lot-M6-3d-printer-throat-PTFE-Pipe-inside-stainless-steel-feed-tube-nozzle-throat-for/212001\\_32691416405.html?spm=2114.12010608.0.0.399b6fcfyHT20a](https://www.aliexpress.com/store/product/4pcs-lot-M6-3d-printer-throat-PTFE-Pipe-inside-stainless-steel-feed-tube-nozzle-throat-for/212001_32691416405.html?spm=2114.12010608.0.0.399b6fcfyHT20a)

If you need it urgently, you can choose the fast shipping way such as UPS, and it will arrive in 2 or 3 working days.

The normal delivery time for your reference:

USA: 7-14 working days.

UK: 5-10 working days.

Canada: 8-15 working days.

Germany: 8-15 working days.

Spain: 8-19 working days.

France: 8-12 working days.

Italy: 10-16 working days.