

## Nozzle blocking or Extrusion gear rebound



1. Manually controlled heating extrusion head (PLA heated to 210 -220), then use a small iron wire (to find a wire filament can be used) from the bottom nozzle comb, Control extruder(E) to move material. this process may suddenly spit out a lot of hot filaments, so pay attention to protect the hand, to avoid being scalded! When printing, nozzle temperature is over 215 to 220, it may be improved.



2. If it does not have effect, you should replace nozzle. First preheat nozzle to 210, unload material. Following picture, use a pliers to fix the heating block. The nozzle sleeve fits with the nozzle, clockwise rotation to take off nozzle. Do not let heating block move too much.

## Filament not stick on hot bed ?

For newcomers, this is the most common problem. Do not worry, you can solve it easily. Generally, the distance between nozzle and platform is too far or near. So rotary the knob under platform to adjust the distance between the nozzle and platform again, at a piece of A4 paper distance or less).

## The display shows "Min temp"?

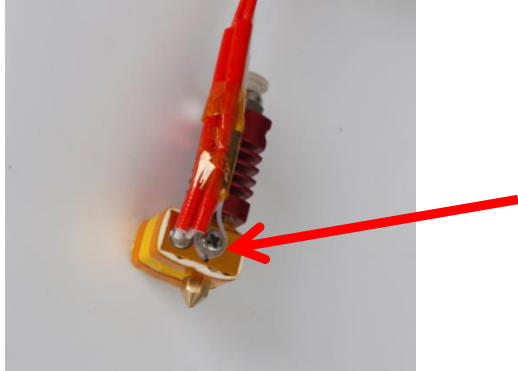
This happens for the following reasons:

1. Thermistor port of nozzle is not plugged into the motherboard above, or poor contact;
2. Thermistor port of nozzle is broken, you need to replace the

spare thermistor.

## The display shows "MAX temp"?

This happens for the following reasons:



1. Thermistor port of nozzle screw is locked tightly, cause the temperature can not be sensing;

2. Thermistor port of nozzle is broken, you need to replace the spare thermistor.

## Axis movement is not normal ?

Please check axis lines and limit lines ,whether the one-to-one correspondence,whether loose. When you check the extruder motor, you must preheat nozzle over 185°C.

## Circles not round, Lines not touching?

If X/Y belt is loose, you can find circles are not round, Lines not touching when printing. Tighten all belts as far as possible.

## Stringing or oozing

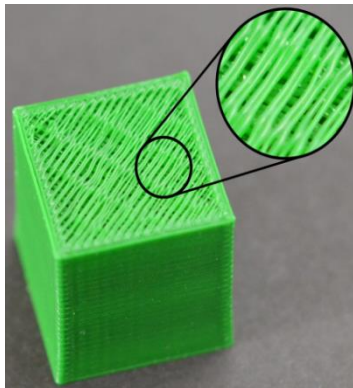


1. In the software, you can add retraction speed and distance to avoid this phenomenon.

2. Lower nozzle temperature (5-10 °C).

3. Change other material may improve .

## Holes and Gaps in the Top Layers



1. In software, the top/bottom thickness is not enough.

2. Fill density is too low.

3. Not Extruding Enough Plastic section, nozzle will block.