Hotend unit replacement

Item No.: 2902594
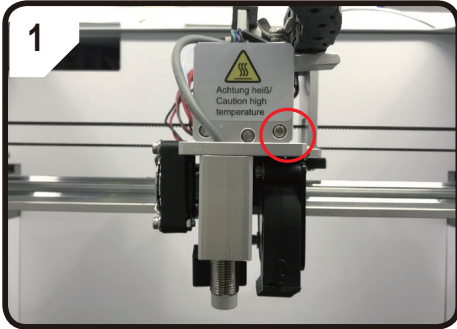
1
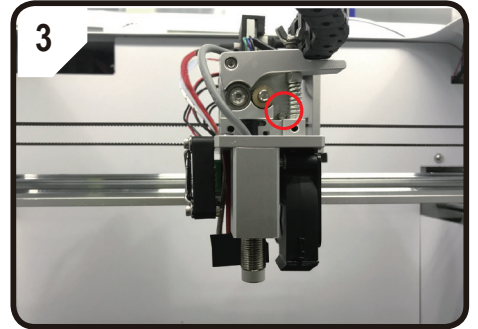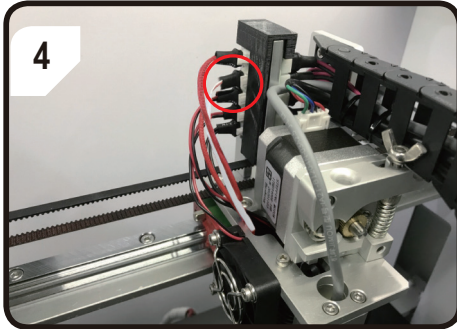
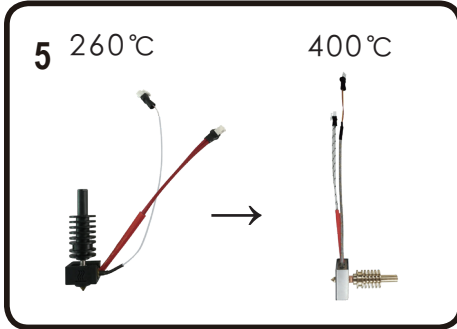Loosen the screw and take off the extruder cover.
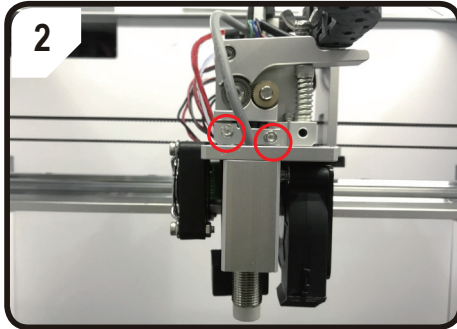
2

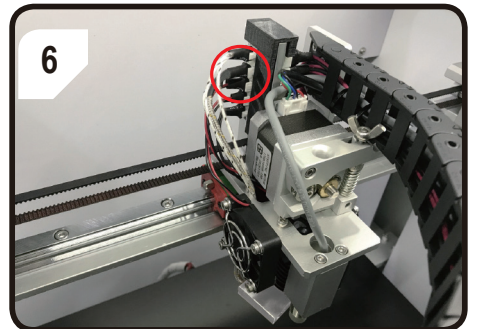Loosen the clamping block of the heatsink

3

Loosen the screws of extruder
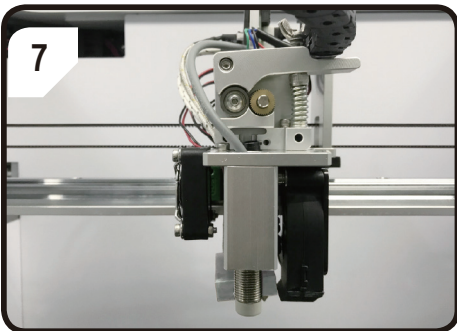
4

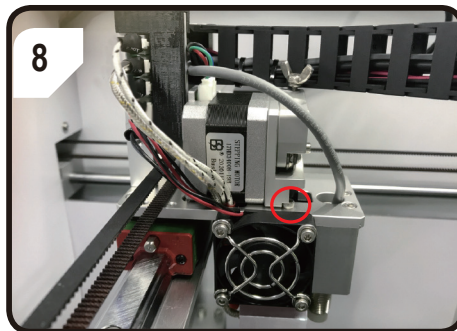Unplug the terminal of heater and NTC

5 260℃   400℃

Replace the hotend unit as your needs. Pay attention to the installation direction, the heater and temperature sensor should be rear face (as shown in picture 7).
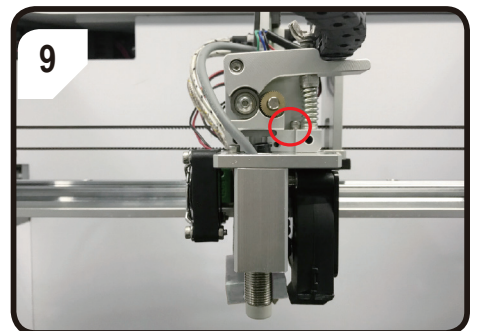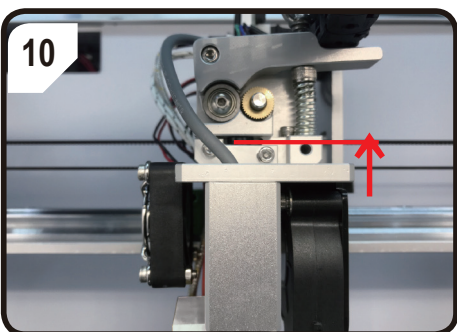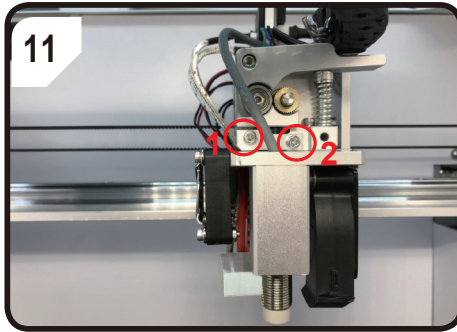
6

7

8

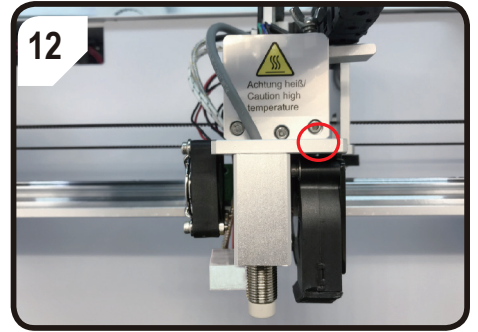Fix the locating slot of the extruder to the locating screw
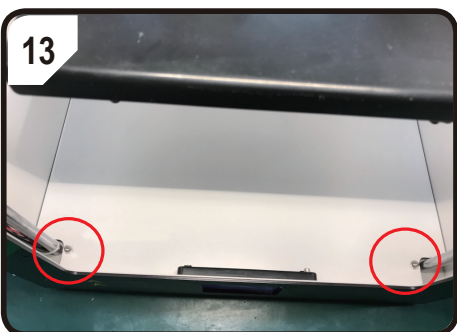
9

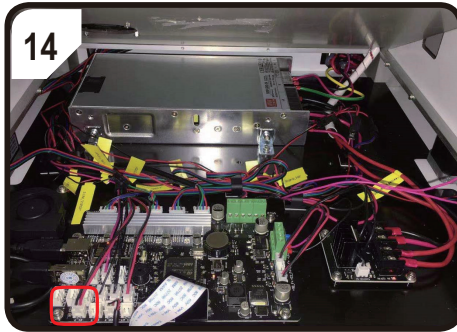Fasten the screw of the extruder

10

11
1 2

12

Push the hotend unit to the top and fasten the clamping block of the heatsink alternately.
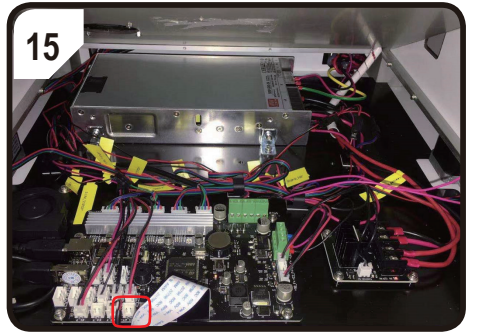
Fasten the screws and install the cover.
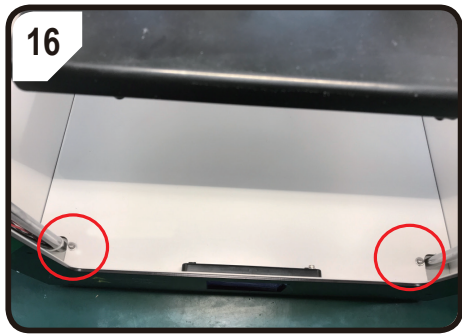
13

Loosen the screw of alum. plastic bottom plane.

14

Unplug the yellow label <E1-T> terminal.

15

Insert it into the <E1-KT> terminal

16

⚠ You will need the USB drive that was included with your printer.

When you finish all steps, remember to refresh the firmware and do the auto-leveling calibration:
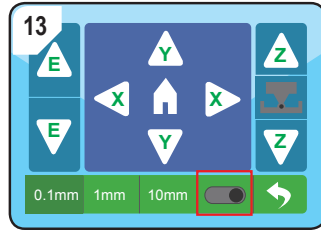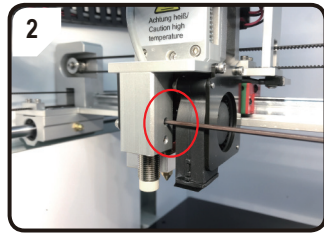1. Firmware refreshing: you can find the refreshing files of "config_KTC.gcode" &"config_NTC.gcode" saved in USB disk:
   A. If you replace from 260℃ to 400℃, then you have to print with the file of "config_KTC.gcode" in the printer to make sure the firmware is compatible with the temperature sensor of thermocouple type "KTC" for hotend unit 400℃.
   B. If you replace from 400℃ to 260℃,then you have to print with the file of "config_NTC.gcode" in the printer to make sure the firmware is compatible with the temperature sensor of thermal resistance type "NTC" for hotend unit 260℃.
2. Calibration of auto-leveling:When we change the hotend unit or the nozzle, the heigth between the nozzle and the sensor has been changed, which has the effect on the auto-leveling results, so we have to do the calibration.

TIP: Follow the instruction of auto-leveling calibration and the video saved in USB disk.
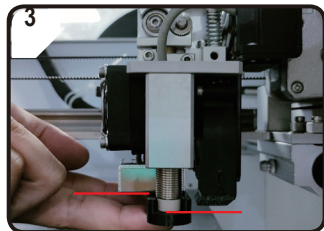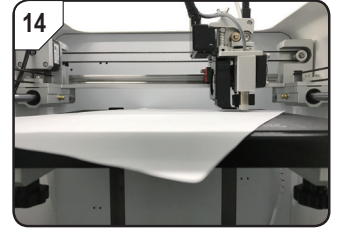
⚠ It is the must to do the Z-offset calibration when you have changed the nozzle or the hotend unit, especially when the height between the nozzle and the sensor has been changed.
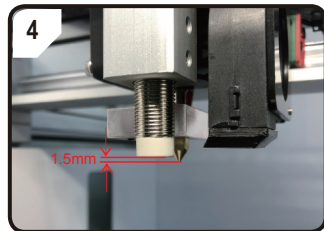
1
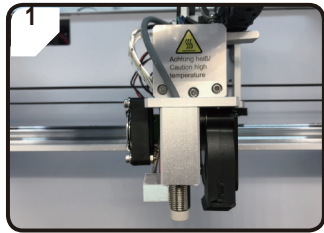
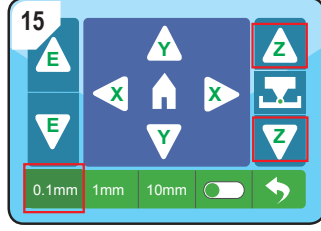Loosen the screws of the sensor to make sure the sensor can be pulled up and down freely.

2

3

Put the black position block under the sensor and nozzle to calibrate the height between each other.

4

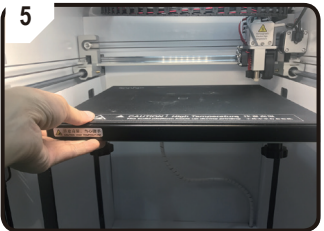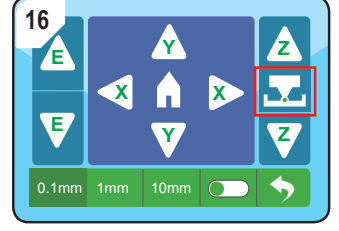Make sure the height of sensor is around 1.5mm higher than the nozzle, when you can fasten the screws of sensor.

5

6

Put inside the metal plate and magnetic mat

7
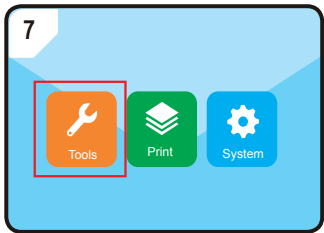
Enter into"TOOLS"-"Preheating"

8

9

Wait until the temperature of the print bed is up to the pre-set value, in this case it is 52℃.

10

11
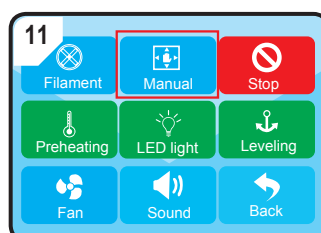
Enter into "Manual" and press "Home" icon, when the extruder will move to the zero position.

12

13

Turn on Z-offset calibration function and put one A4 paper between the nozzle and the print bed.
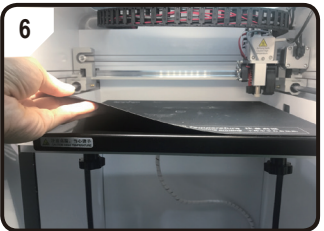
14

15

16

Make sure we do the Z-offset calibration under the distance setting of 0.1mm to avoid any damage on the extruder.
Slide the paper back and forth with ⬆Z ⬇Z icon until there is slight resistance between the nozzle and the print bed, then press ⬇ icon to finish the calibration.
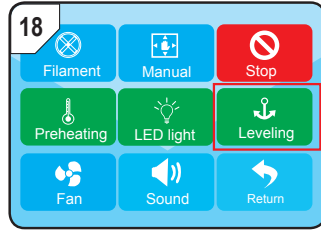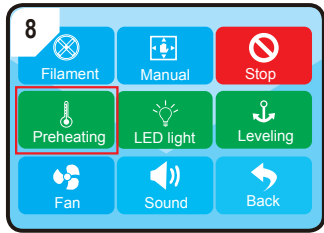
17

Set this position as Z=0, continue?
Confirm Cancel

Press "confirm".

18

Enter into "Tool"--"Leveling" to do the auto-leveling and finish Z-offset calibration.

19