



# Routine Maintenance

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## Routine Maintenance

Each time the the printer runs out of Filament the FL Supervisor will conduct the following Routine maintenance:

1. Run a 10cm length of nozzle cleaning filament through the printer by selecting the **Nozzle Clean** script on the SD Card.
2. Clean extruder teeth with brush and blow clear with canned air
3. Wipe smooth rods with clean of any visible grease or dirt build up with a piece of paper towel.
4. Load new roll of filament into the machine by preheating the machine (via LCD menu) and inserting filament into the throat of the extruder.
5. Wash Flexible Steel Printing Sheet with clean chux or sponge in warm soapy water (**DO NOT USE ABRASIVE CLEANERS**), rinse well and dry with paper towel.
6. Run **Routine Maintenance** script on the SD Card this will run a Z axis calibration check and print a small test print. Verify result.
7. Date and initial Maintenance Badge

This is an operation for Level 2 or 3 inductees and staff only