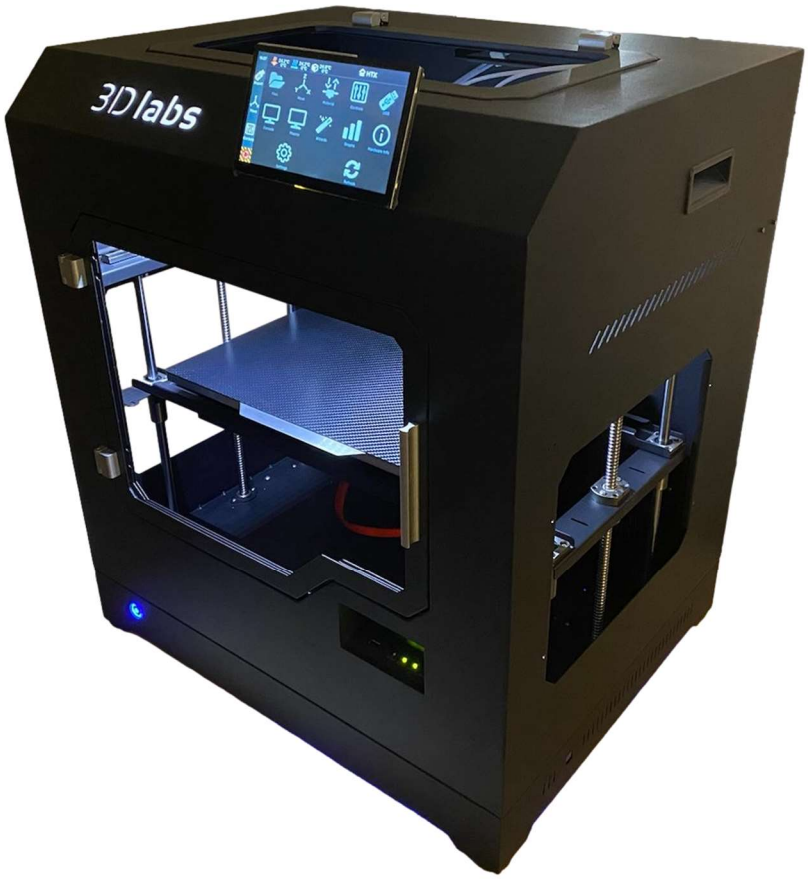
WORKING WITH HOTENDS

READ THIS DOCUMENT BEFORE USING YOUR 3D PRINTER



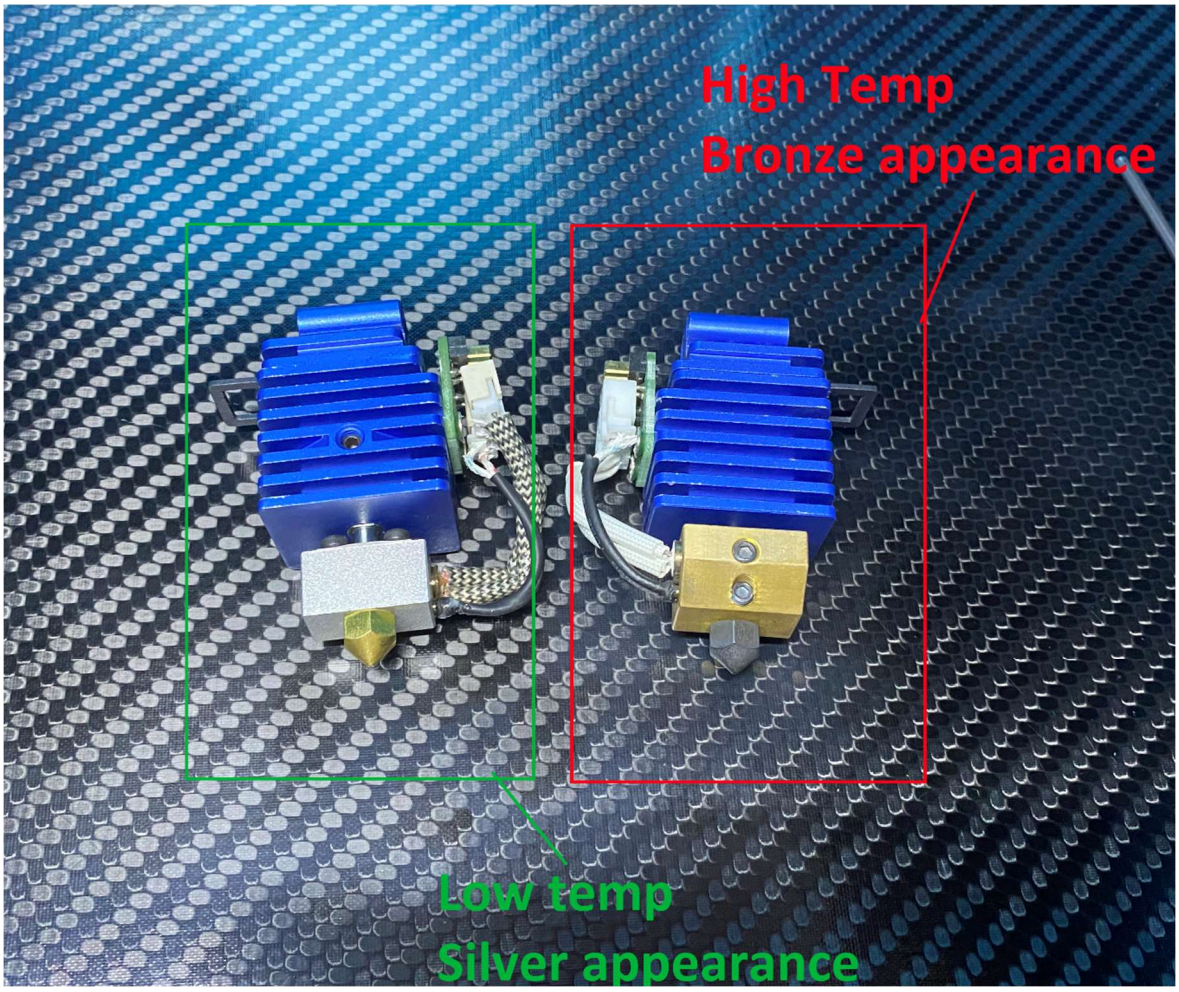
Rev. 2.00 – 7/1/2022

CONTENTS

HIGH TEMP AND LOW TEMP HOTENDS

There's a very important distinction between the high-temperature and low-temperature hotends that come with the 3D Labs HTX 3D Printer.

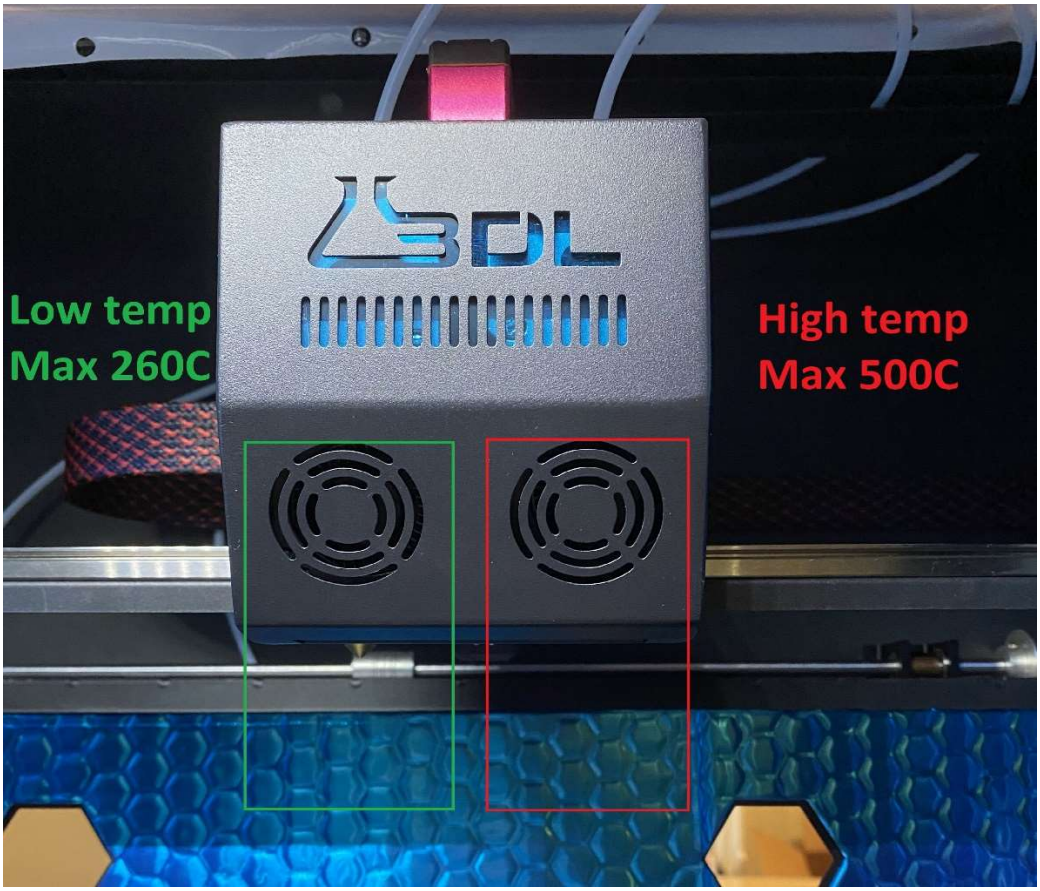
DO NOT ATTEMPT TO PRINT HIGH-TEMPERATURE MATERIALS IN A LOW TEMPERATURE HOTEND. FIRST INSTALL A HIGH-TEMPERATURE HOTEND OR USE THE FACTORY INSTALLED ONE AS SHOWN.



The **low-temperature** hotends are made of aluminum and have a **silver** appearance.

The **high-temperature** hotends are made of a copper alloy and have a **brass** appearance.

1) Hotends are installed in the following configuration out of the box



2) The printer comes with 1 extra low-temperature and 1 extra high-temperature hotend. You are free to install any combination of either.

   Example scenarios:

   - Printing ABS with BVOH support materials: 2 x low temperature hotends
   - Printing PEEK with high temp breakaway support: 2 x high-temperature hotends

HOW TO CHANGE OR SERVICE A HOTEND ASSEMBLY

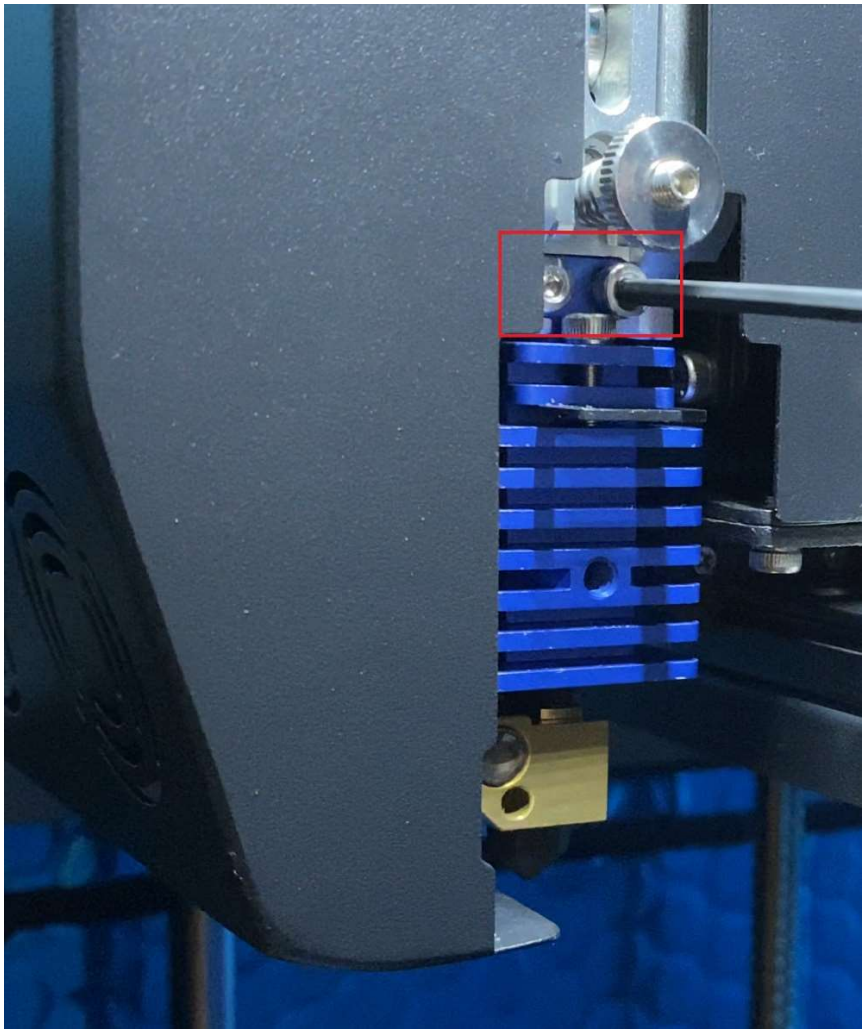
The HTX is equipped with hot swappable hotends for ease of service and maintenance. Additional hotend assemblies can be purchased separately from the 3D Labs online store.

Having multiple hotend assemblies provides a path forward when encountering a problem such as a clogged nozzle, bad thermistor, or an unknown issue that needs diagnosis.

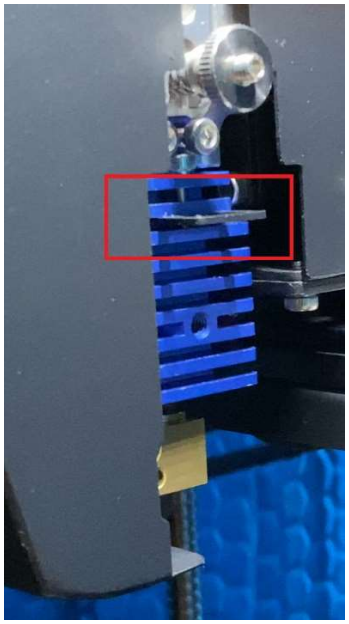
Swapping in a new hotend allows you to continue printing while working with support to determine the issue with your hotend.

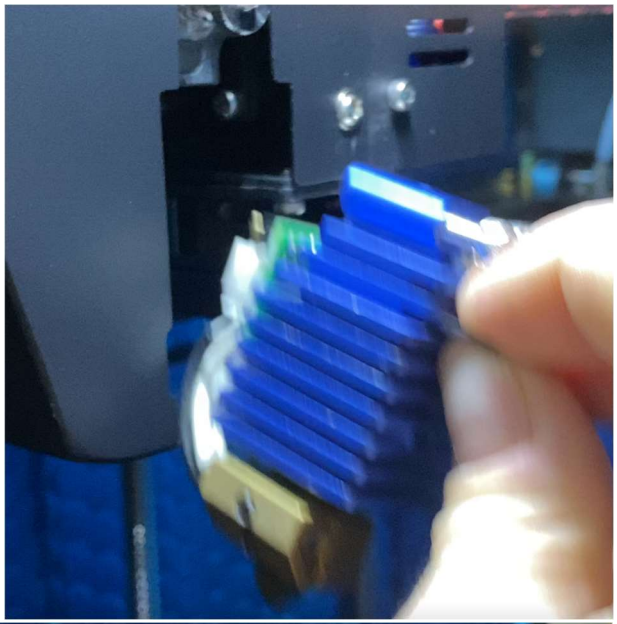
Removing a hotend

1) Unscrew the 2 hex screws that hold the hotend assembly in place



2) Pull the hotend assembly out via the black tab on the side





3) To reinstall the hotend, simply reverse the above steps.