Nozzle Cleaning

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M Series Printers Maintenance

Zortrax M Series includes two printer models right now: M200 and M300. These printers remain similar in terms of design and technology. The most important difference is their size: M200 with a 200x200x180mm workspace, whereas M300 with an increased 300x300x300mm workspace.

Therefore, maintenance and repair work can be carried out in the same manner with both models. The following manual shows M200 maintenance work. In the case of M300, these procedures look the same.

Unloading the Material

From the menu choose "Material" and then "Unload the material" option. The extruder should start to heat up automatically. Once the extruder is hot, the motor will start to unload the material.

Scrubbing the Nozzle

Take the spatula from the Starter Kit and gently scrub the material remains from the nozzle.

Nozzle Removal

Unscrew the nozzle counterclockwise (when viewed from below). Use the nozzle key from the Starter Kit box. Removing the nozzle should take place while the extruder is still hot. When the nozzle is loose, take it out using pliers.

Unplugging the Power Cable

Turn off the printer and unplug the power cable. Wait about 15 minutes and let the machine cool down.

Cleaning the Nozzle

If you were printing with Z?GLASS / Z?PETG / Z?PCABS / Z-ESD, print a small-sized object using Z?ABS. This will help to extrude Z?GLASS / Z?PETG / Z?PCABS / Z-ESD remains from the nozzle.

Using the pliers, place the nozzle in a container filled with acetone.

Make sure that the nozzle is cold before putting it into the container.

Removing the Nozzle from the Container

After 8-10 hours take the nozzle out of the container with pliers.

Nozzle Assembly

Install the nozzle in its place in the hotend and screw it clockwise using the nozzle key (when viewed from below).