

Extruder Printed Cover Replacement

SOURCE:

<https://support.zortrax.com/printed-extruder-cover-replacement/>

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Plugging the Power Cable

The extruder printed cover is placed over the extruder in order to give protection to the extruder cable and all the cables plugged into the extruder PCB. The cover secures the extruder PCB on the extruder aluminum cover as well as functions as a distance piece between these two components. Therefore, if you notice visible signs of wear and tear on the extruder printed cover (cracks or breaks), replace the cover to avoid any kind of failures.

At first, print the cover and then replace it according to this manual. The model is available for download [here](#).

The following manual shows the M200 repair work. For the M300, these procedures are the same.

Unloading the Material



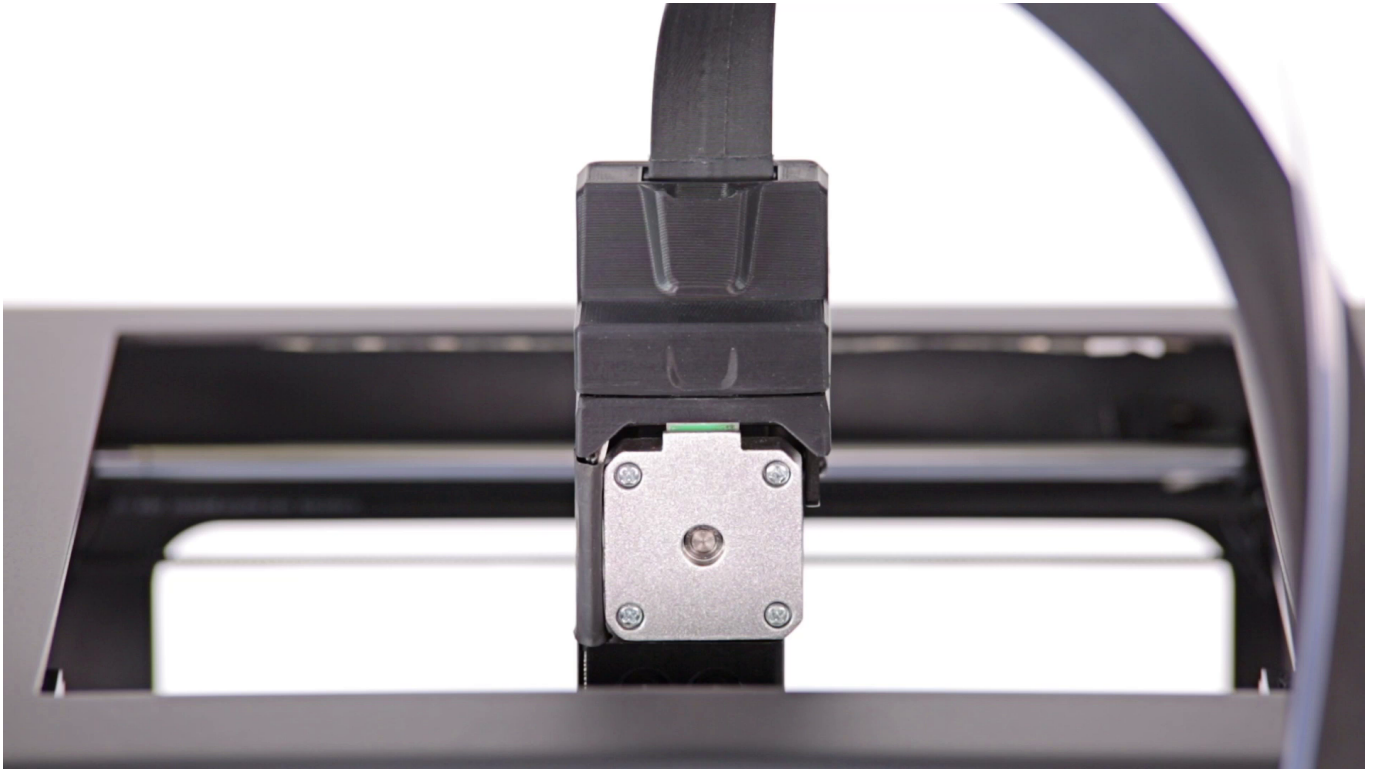
From the menu choose “Material” and then “Unload the material” option. The extruder should start to heat up automatically. Once the extruder is hot, the motor will start to unload the material.

Unplugging the Power Cable



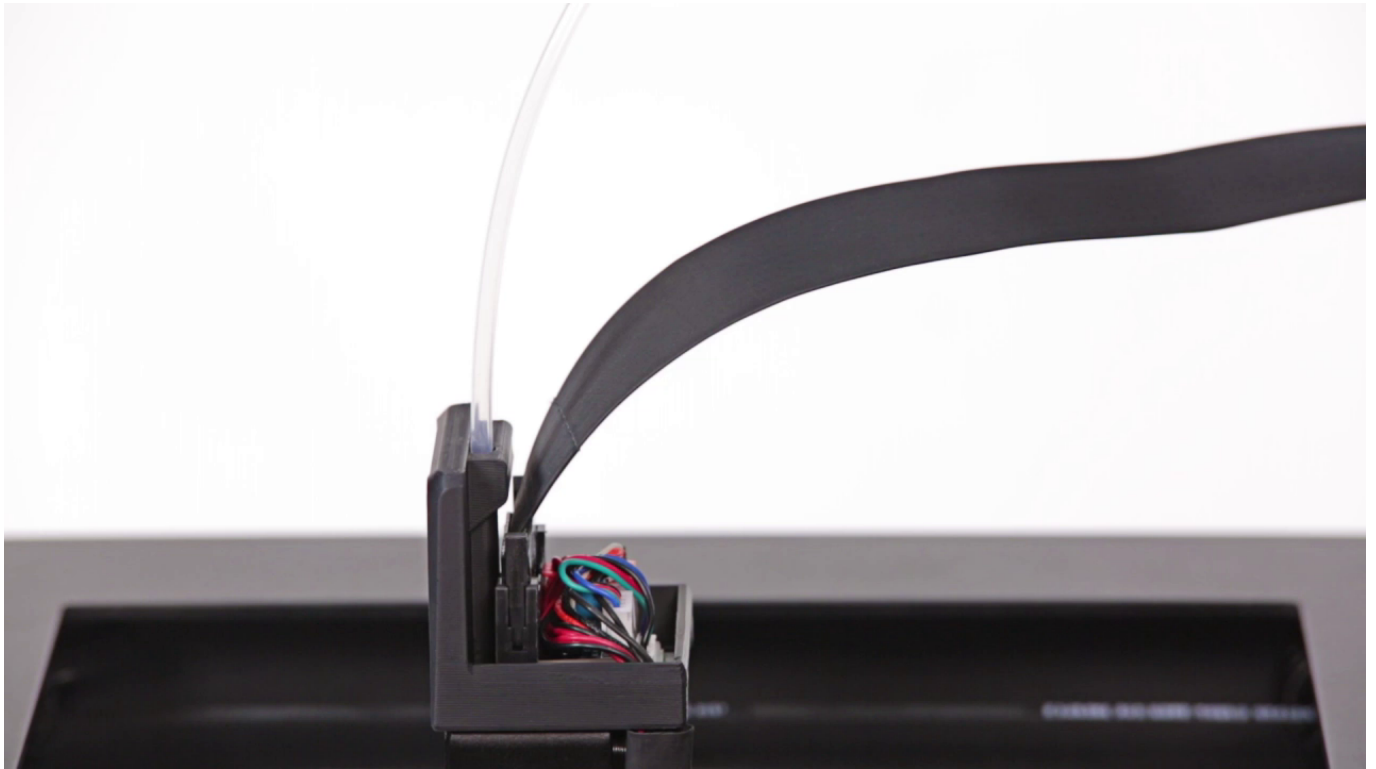
Turn off the printer and unplug the power cable.

Extruder Upper Printed Cover Removal



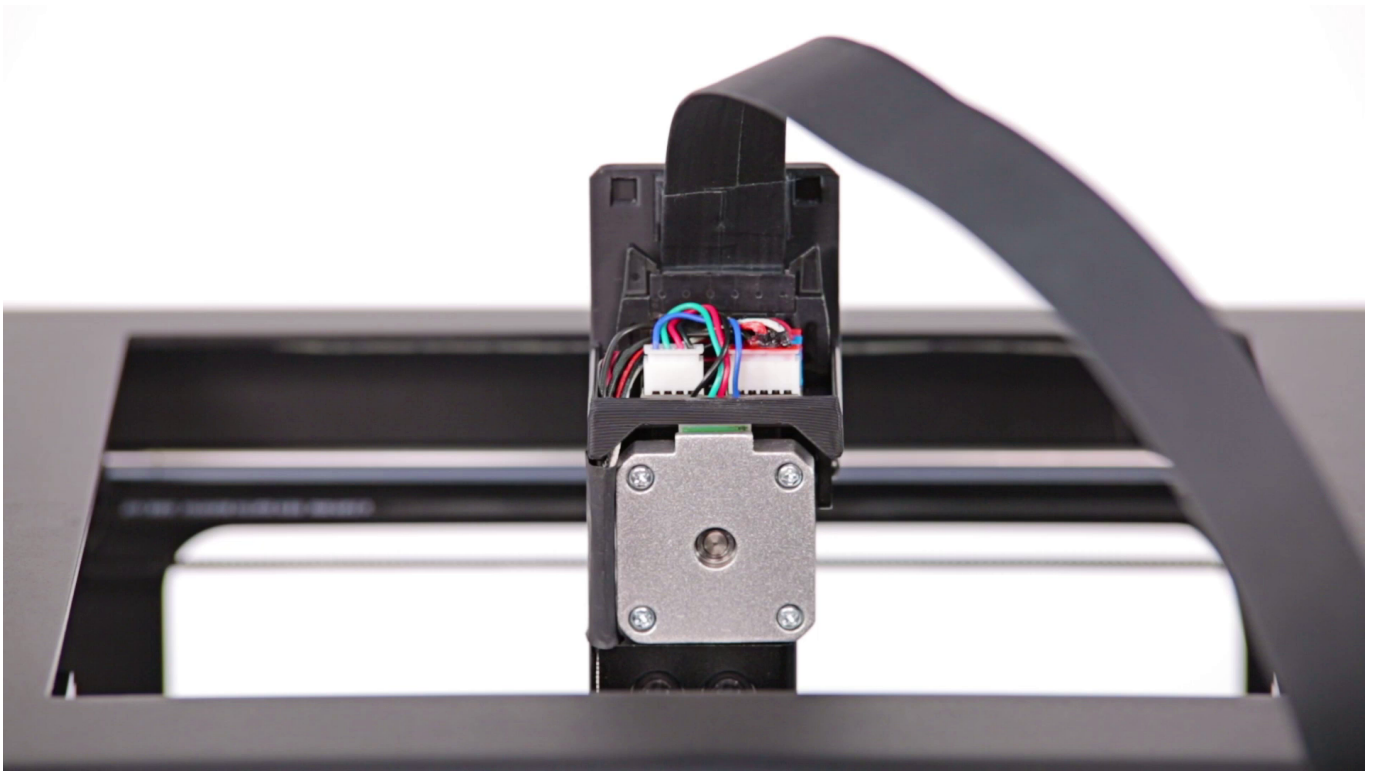
Detach the extruder upper printed cover from the extruder.

Material Guide Removal



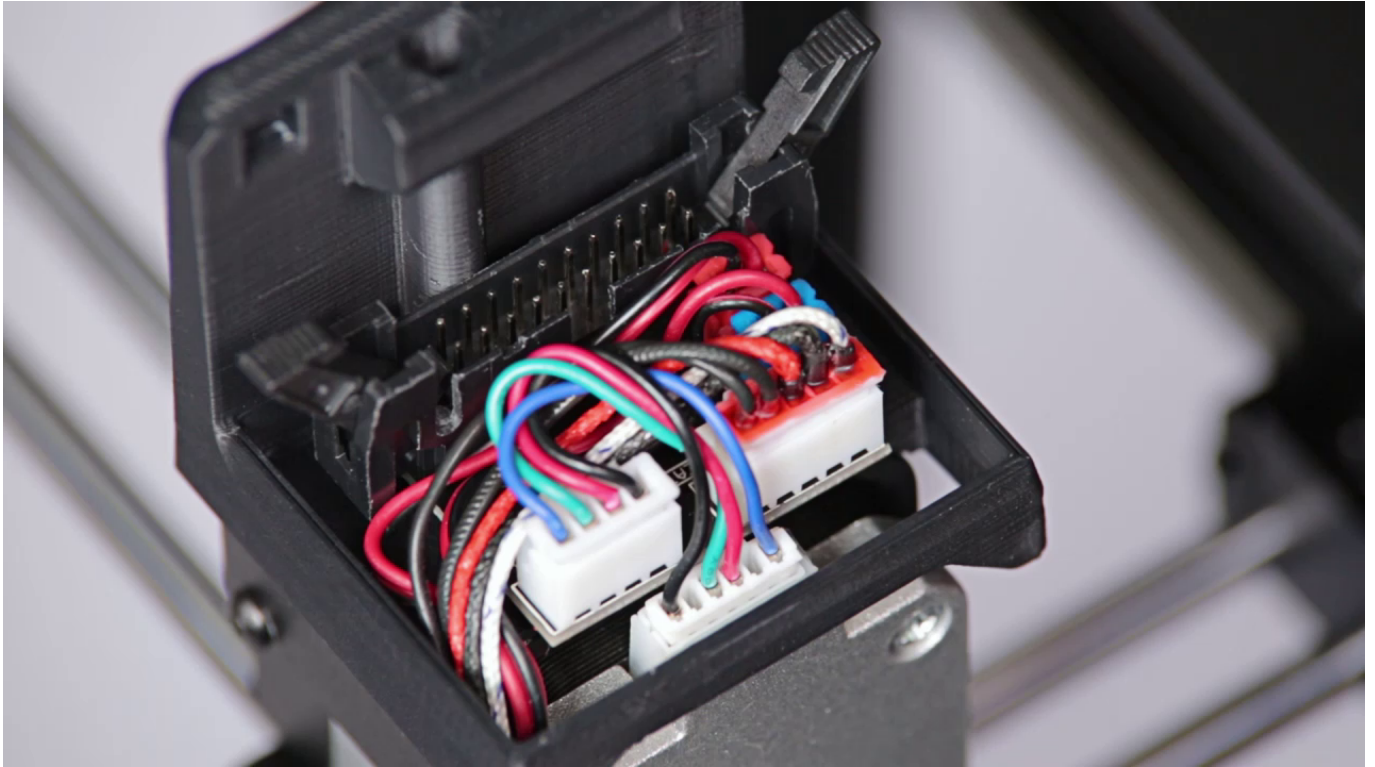
Detach the material guide from the extruder cover.

Unplugging the Extruder Cable



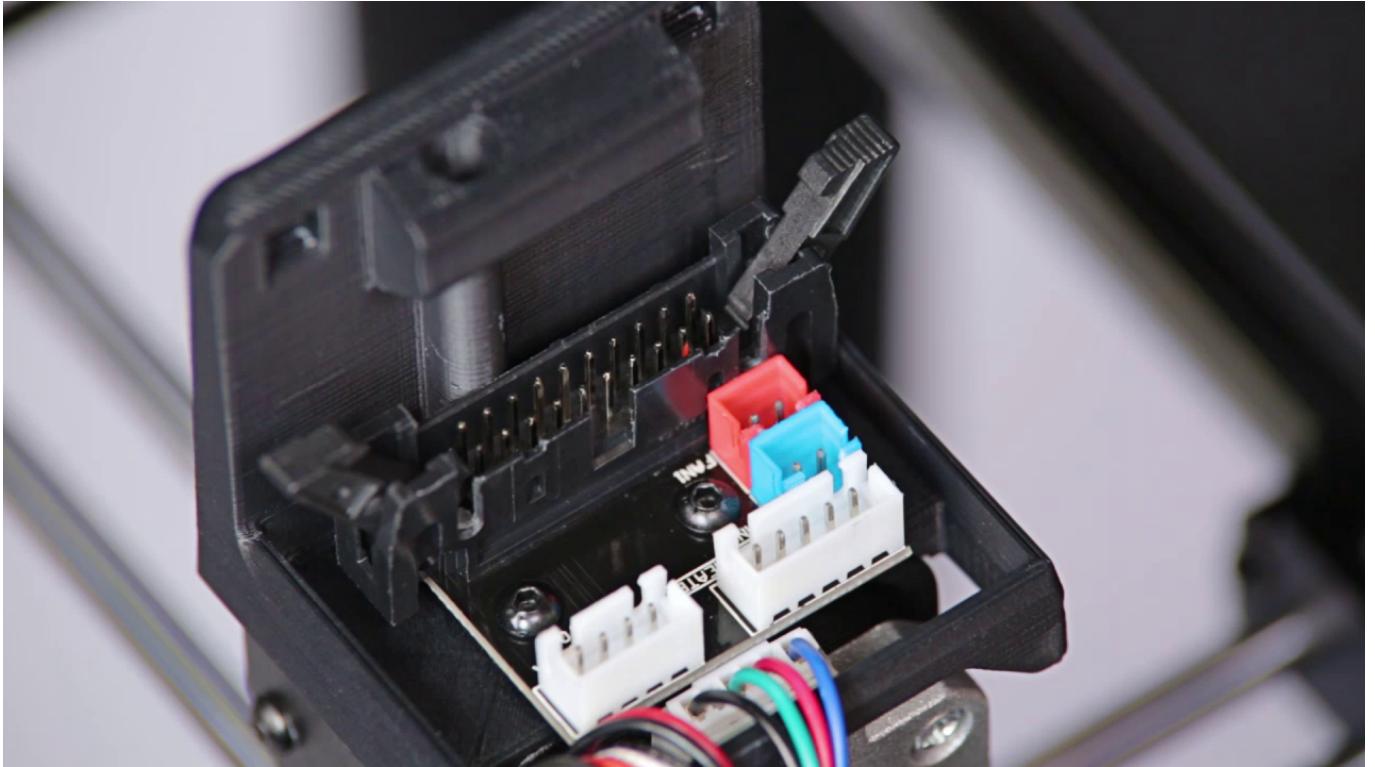
Unplug the extruder cable.

Unplugging all Cables from the Extruder PCB



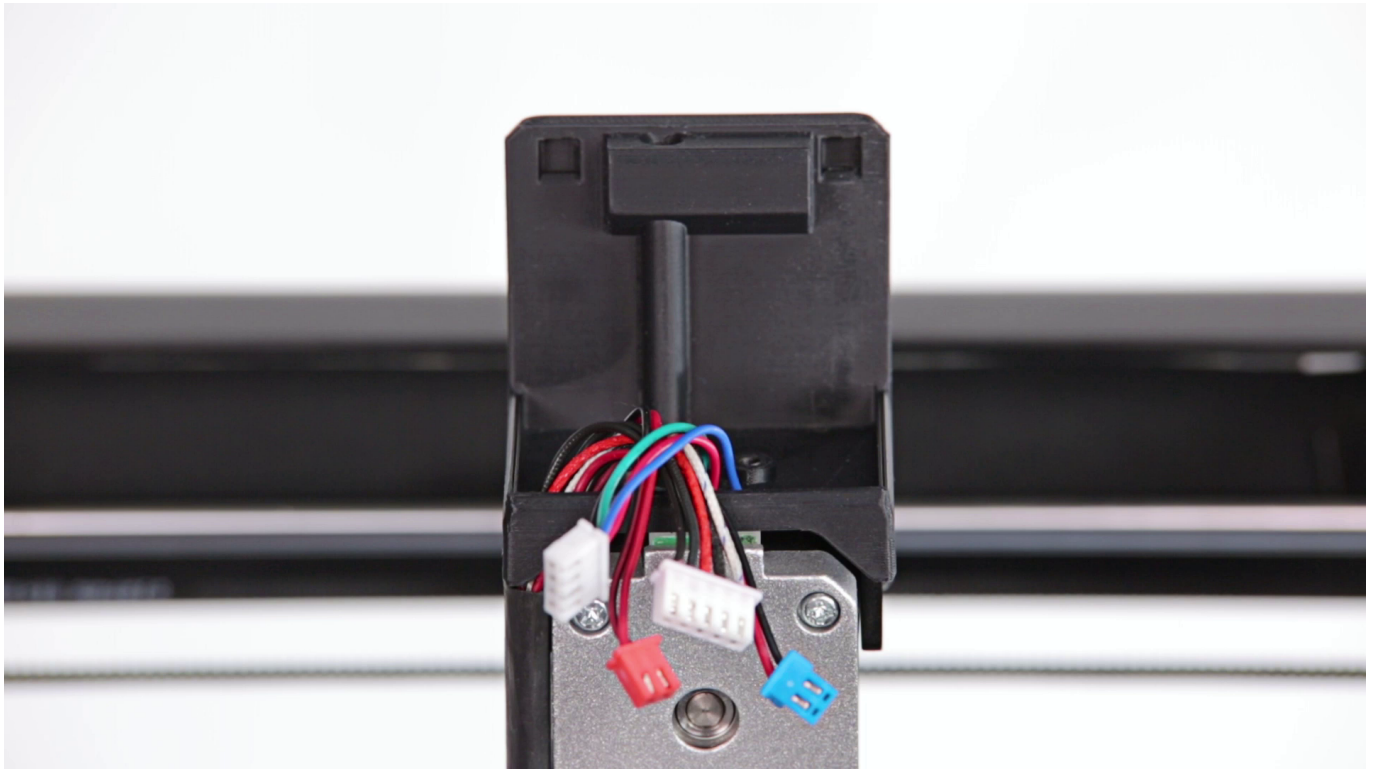
Unplug all the cables from the extruder PCB.

Unscrewing the Extruder PCB



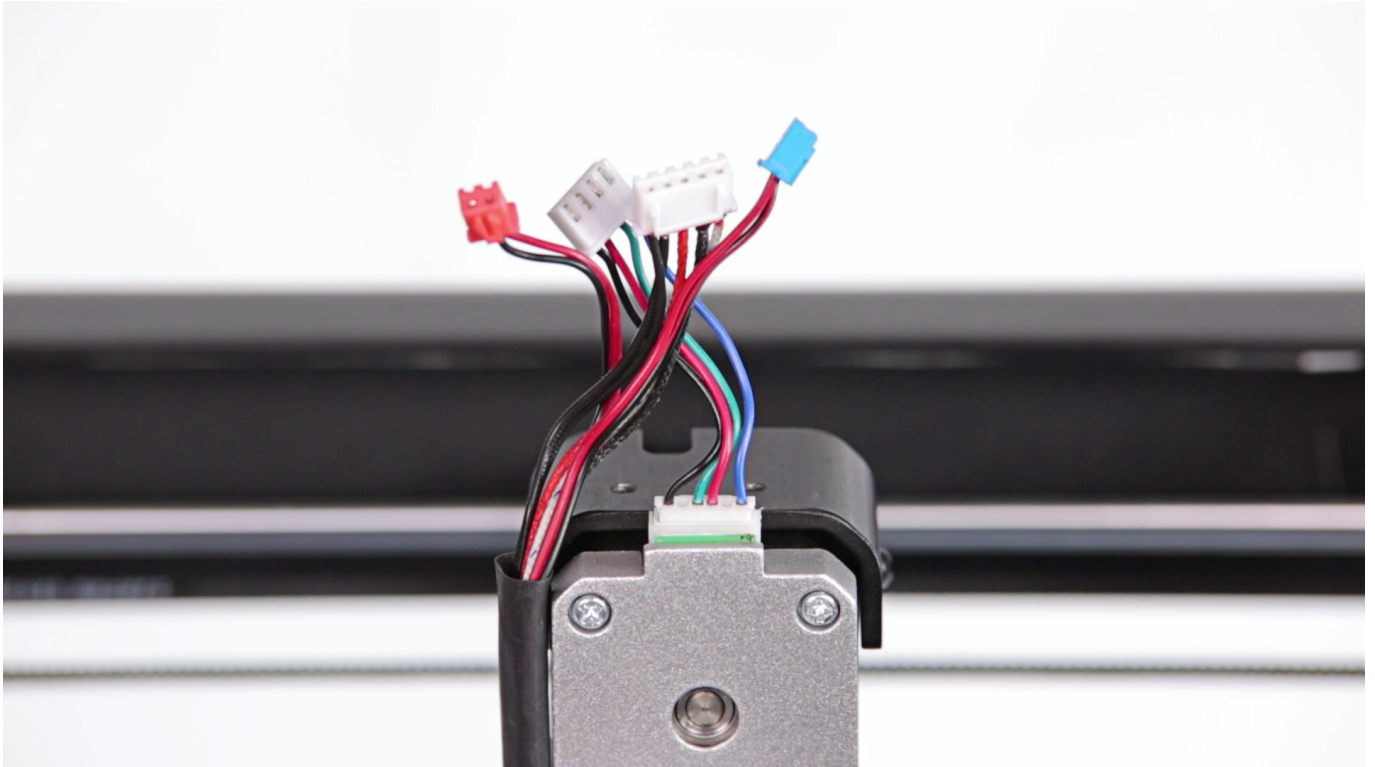
Unscrew the two screws that secure the extruder PCB using a 2mm Allen key. Remove the PCB from the extruder.

Extruder Lower Printed Cover Removal



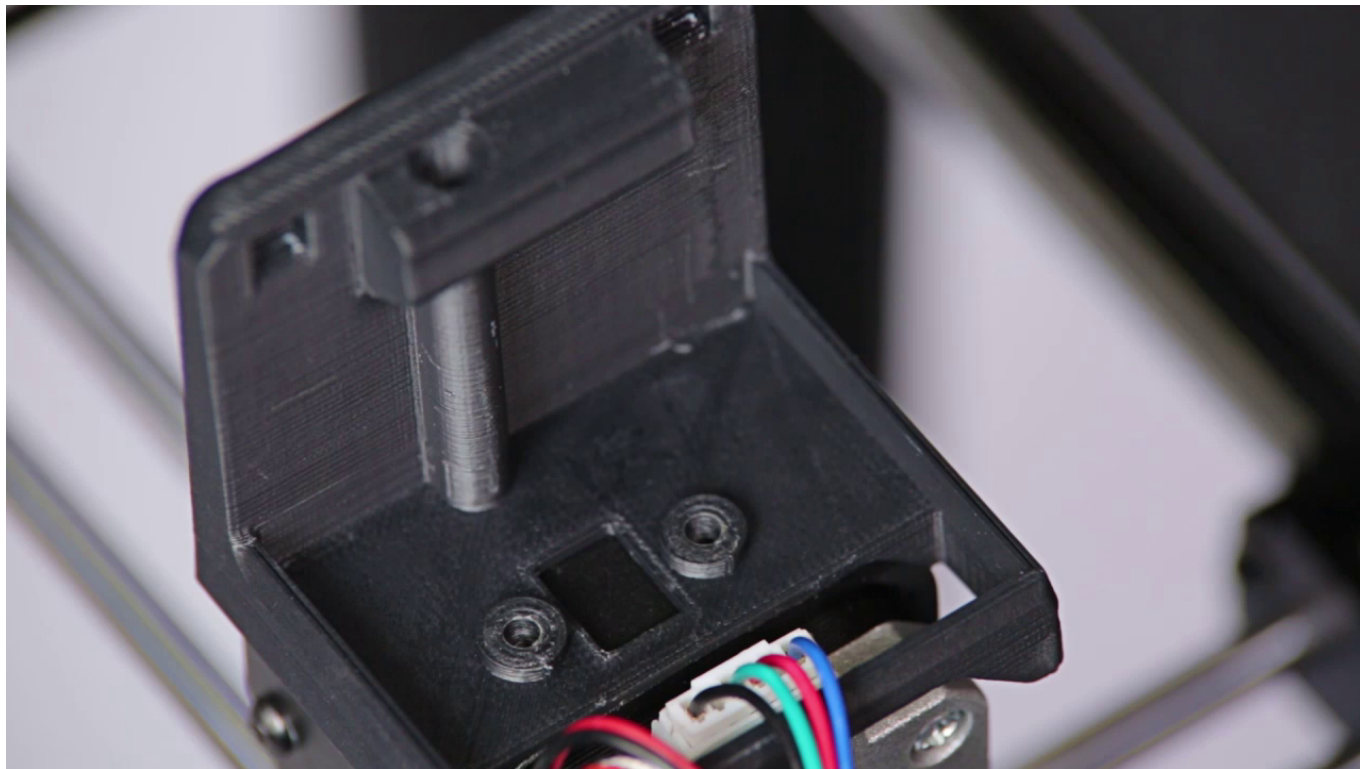
Remove the extruder lower printed cover.

Extruder Lower Printed Cover Assembly



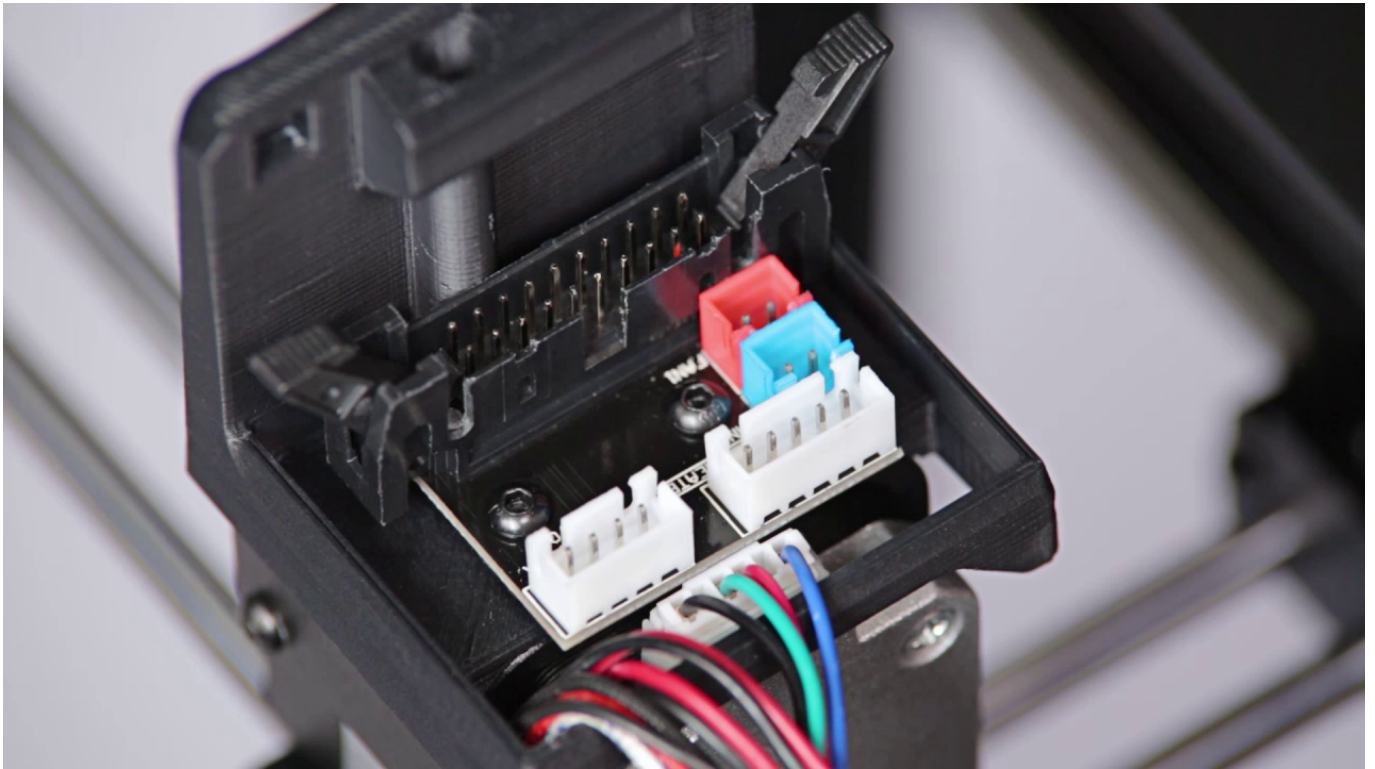
Attach the new extruder lower printed cover to the extruder.

Extruder PCB Assembly



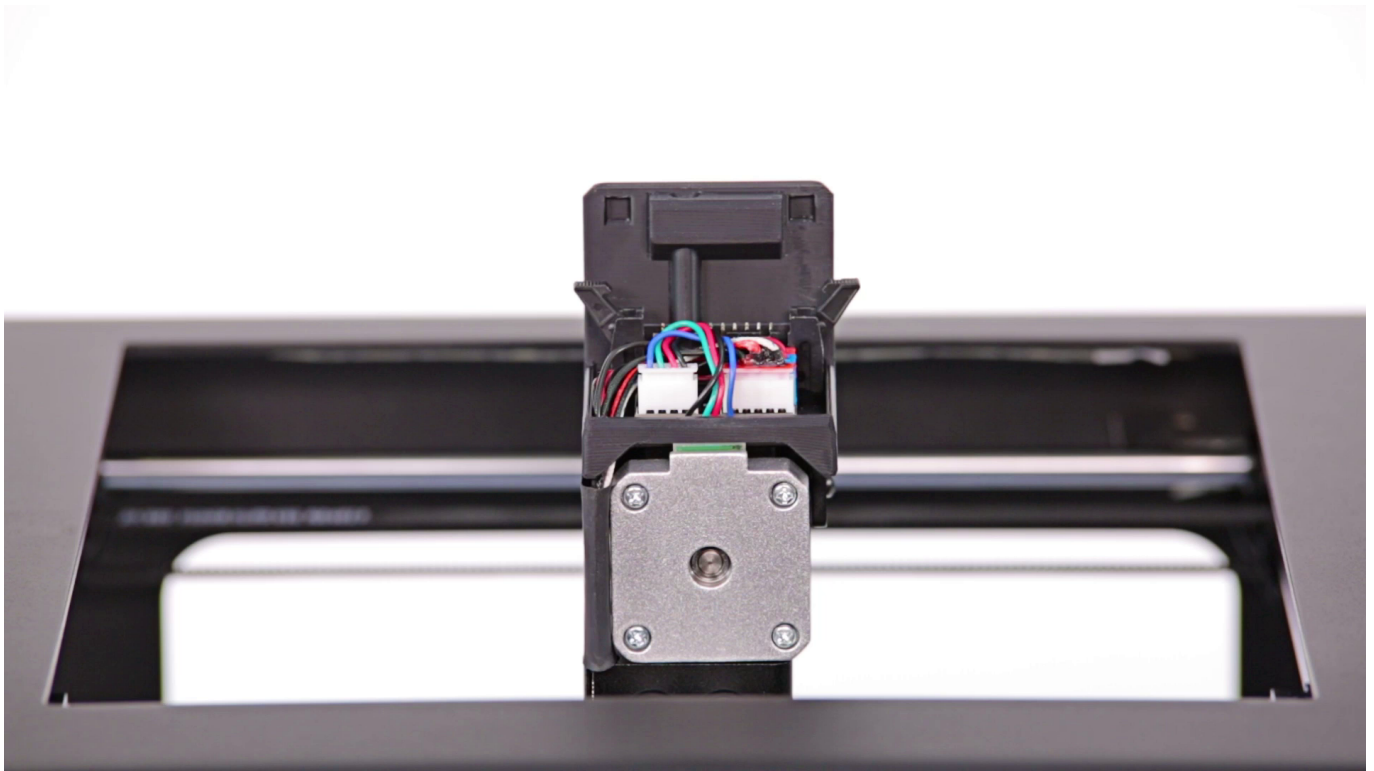
Place the extruder PCB in its place and secure it with the two screws.

Plugging all Cables into the Extruder PCB



Plug all the cables in. Remember to arrange the cables so that they don't get damaged, e.g. by wrapping against each other.

Plugging the Extruder Cable



Plug the extruder cable in.

MAKE SURE THE EXTRUDER CABLE IS PROPERLY PLUGGED IN.

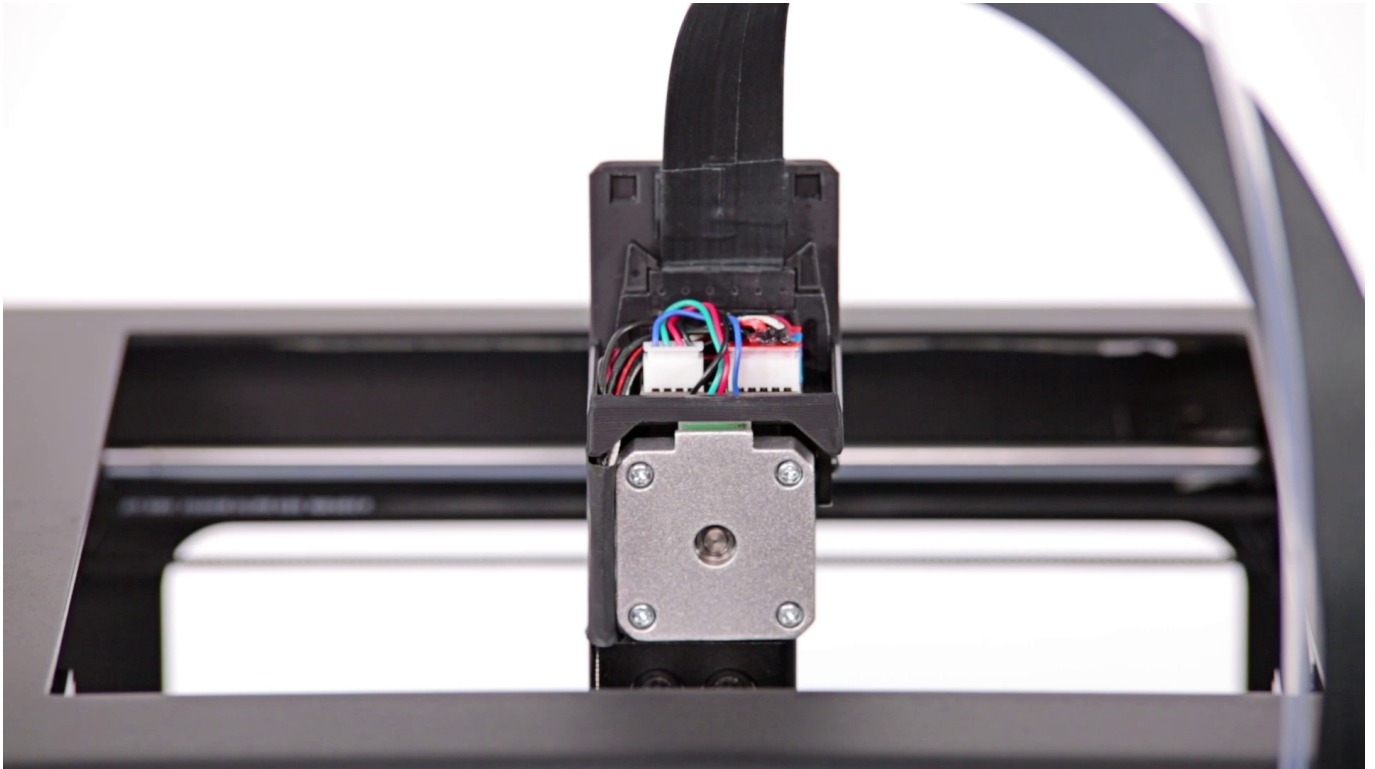
Material Guide Assembly



Attach the material guide to the extruder cover. Next, secure the guide to the extruder cable with the material guide clamps.

MAKE SURE THE MATERIAL GUIDE IS PROPERLY INSTALLED IN THE COVER.

Extruder Upper Printed Cover Assembly



Attach the extruder upper cover to the extruder lower cover.

Plugging the Power Cable



Plug the power cable in.