

# Changing the Material

SOURCE:

<https://support.zortrax.com/m-series-changing-the-material/>

## Table Of Contents

Unloading the Material  
Removing the Spool  
Preparing the New Spool  
Setting the New Spool  
Loading the Material

## 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.

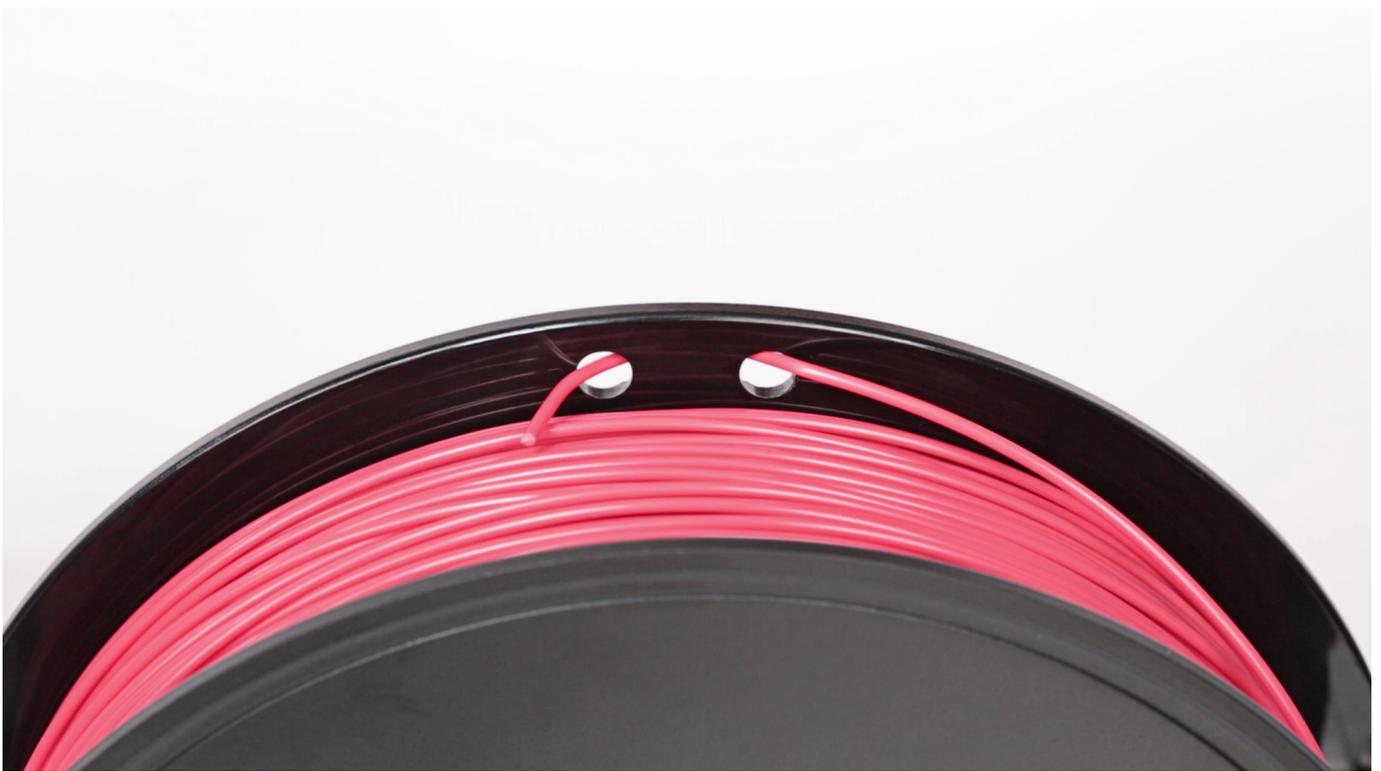
## Removing the Spool



Remove the material from the material guide. Hold the end of the material and take the spool off of the spool holder.

To avoid having tangled threads, secure the end of the material in the spool.

## Preparing the New Spool



Prepare the new spool and cut the end of the material at an acute angle to make the material loading easier.

## Setting the New Spool



Carefully set the material spool on the holder so that the marking on the spool is visible. The spool should rotate anti-clockwise. Next, feed the material into the material guide.

Once the material reaches the extruder, detach the material guide from the extruder, and insert the end of the material into the extruder. Reattach the material guide to the extruder.

## Loading the Material



From the menu choose *Material* and then *Load the material*. At this point the printer will begin to heat up the extruder. Follow the instructions displayed on the screen.