5

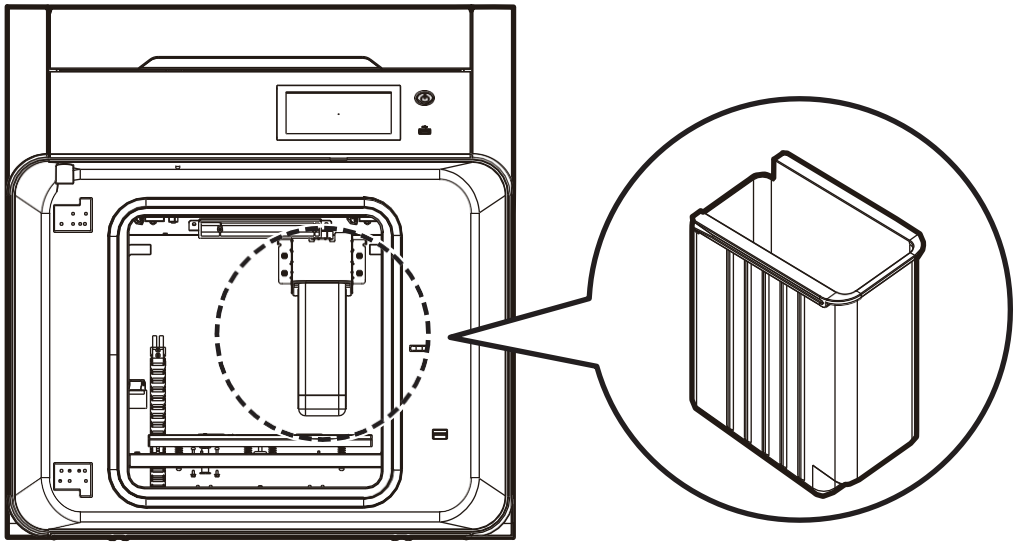
Maintenance

type A530

1. Product Cleaning

1. Maintenance of Cleaning Case

Empty the cleaning case for residual filaments regularly



2. Internal Cleaning

Filament residues may fall into the printer when it is in operation. If the filament residues are not removed, they may affect the printer's operation. Clean the inside regularly.

3. Regular Inspection

Inspecting Oil/Grease

The drive shaft is coated with oil or grease when the printer is delivered.
After a certain time of period, the oil or grease is dried and noise may be generated. Check the oil/grease conditions about once a month.
In particular, if noise occurs when the printer is operated, immediately check the oil or grease conditions. If necessary, contact the after-sales service center.

4. Cleaning of Flexible Bed and Nozzle

If filament residues or debris are left on surface of the bed, the bed may not be normally leveled. Improper bed leveling may affect the print quality.
Clean the bed surface and the tip of nozzle regularly.

Caution

- When the nozzle or bed is heated, components are very hot. Be careful of burns.

2. Error Messages and Solutions

Error Code	Description	Solution
301, 302, 303, 304 & 305	The nozzle heater or the temperature sensor fails.	① Reboot the printer or install the nozzle again. ② Replace the failed nozzle.
312, 313 & 314	The leveling sensor fails.	① Check the bed installation. ② Replace the leveling sensor.
321	The nozzle fan fails.	① Check if there are debris in the fan, and remove them if necessary. ② Replace the nozzle fan.
325	The cooling fan fails.	① Check if there are debris in the fan, and remove them if necessary. ② Replace the cooling fan.
341	Nozzle 1 and Nozzle 2 cannot be used together.	After the power is turnedoff, install available nozzles.
343	Nozzle data cannot be recognized.	① Reboot the printer or install the nozzle again. ② Replace the failed nozzle.
351, 353, 354 & 355	The bed temperature is not proper.	① Reboot the printer. ② Check the chamber heater. ③ Replace the bed heater.
381, 382, 383 & 384	The main fan operates abnormally.	① Check if there are debris in the fan, and remove them if necessary. ② Replace the main fan.
390, 391, 392, 393 & 394	The chamber heater or temperature sensor fails.	① Reboot the printer. ② Replace the chamber heater, temperature sensor, or harness.
396, 397, 398 & 399	The chamber fan operates abnormally.	① Check if there are debris in the fan, and remove them if necessary. ② Replace the fan.
401	Filament transfer fails during printing.	See P.5-4,1 How to Handle Error 401.
405 & 406	The filament is used out, or is cut.	Remove the residual filament and load a new filament.
408	Gcode exceeds the printable scope.	Check the 3D model and Gcode.
411,412,413	Filament transfer fails during loading.	After removing the filament, check the debris in the transfer path.
422 & 423	Filament transfer fails during unloading.	After removing the filament, check the debris in the transfer path.
431, 432, 433, 434 & 435	Smart chip problems occur.	Check the smart chip recognition, residual quantity, information, etc.
501	Movement of Nozzle 2 to the X-axis fails.	Check the motor and the sensor.
502	Movement to the Y-axis fails.	Check the motor and the sensor.
504	Movement of Nozzle 1 to the X-axis fails.	Check the motor and the sensor.

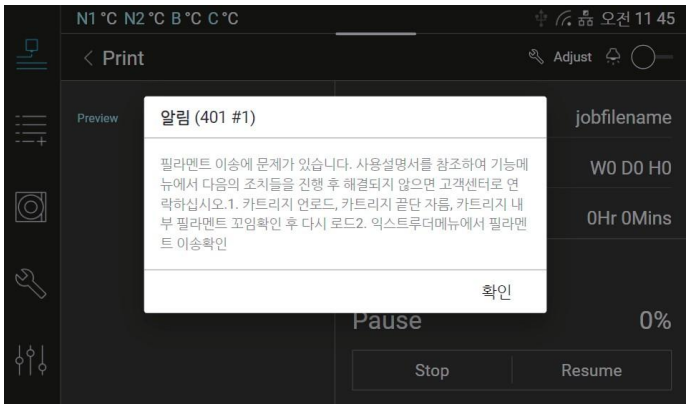
3. Troubleshooting

1. How to Handle Error 401

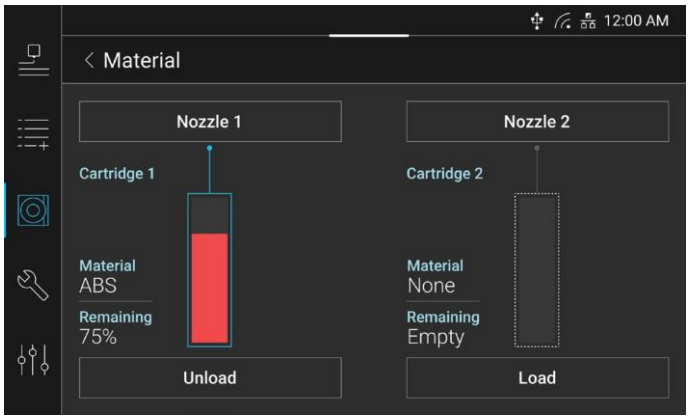
Error 401 is generated when the filament is not properly transferred.

Filament transfer failure may be caused by many reasons. Thus, take the following steps:

1 Check the number of the filament box where Error 401 occurs, and press the **[OK]** button.



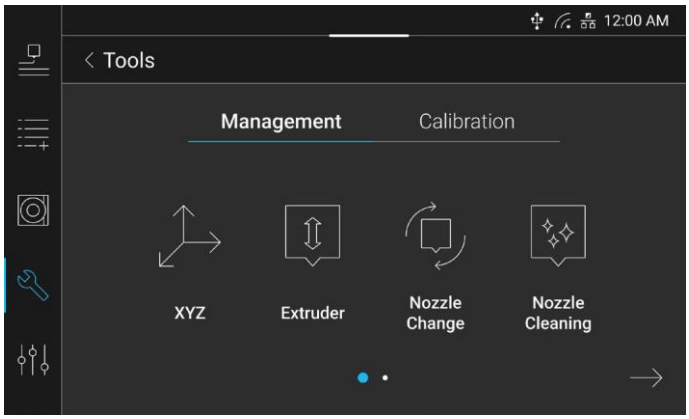
2 Press the **[Material]** menu on the left. Select the spool of the filament box that matches the number checked in step , and unload it. Once the unloading is completed, open the filament box and check if the filament is tangled.

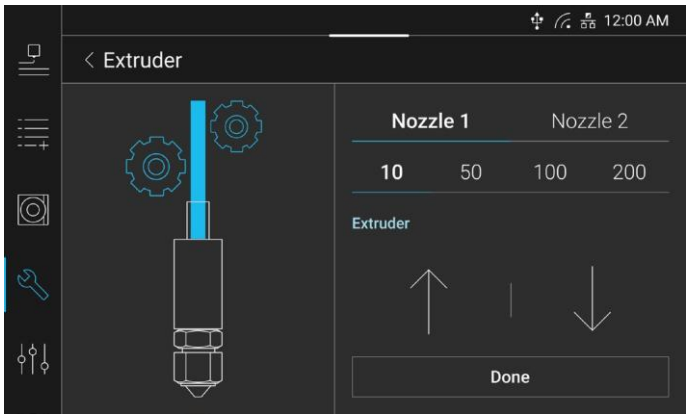


3 Press the **[Tool]** button on the left and select the **[Extruder]** menu of the **[Management]** tab.
Wait until the nozzle reaches the target temperature.
Use the button to feed 50mm in the direction in which the filament is inserted. (Repeat this process 2–3 times until the filament is ejected.)

Reference

- For the information on how to use the Extruder menu, see "Extruder" on Page 2-7.





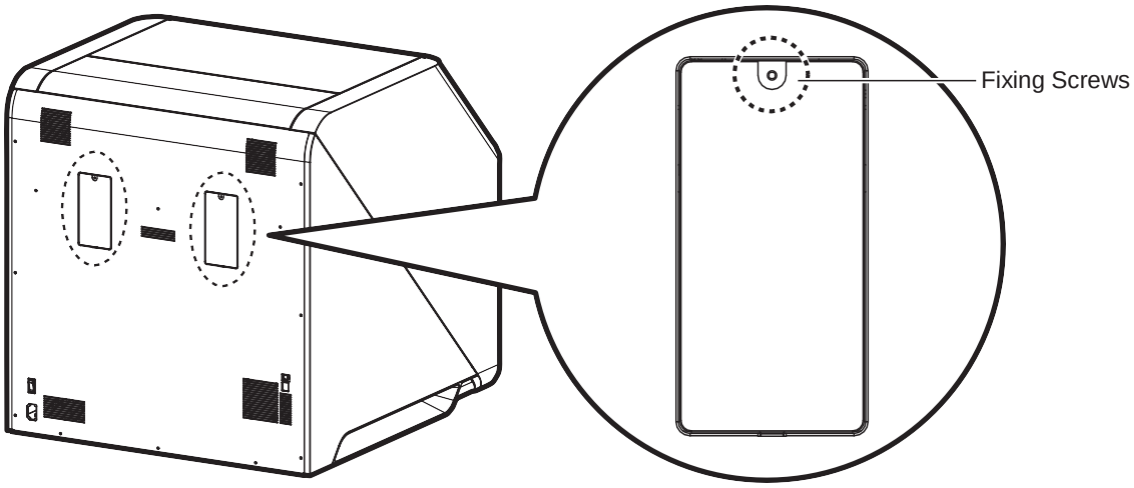
4 If steps – do not solve this problem, see "3.2 Filament Fragment Stuck in Junction".

Reference

- If Error 401 is not solved through steps – , contact the customer center with the information on problem occurrence provided including videos and photos.

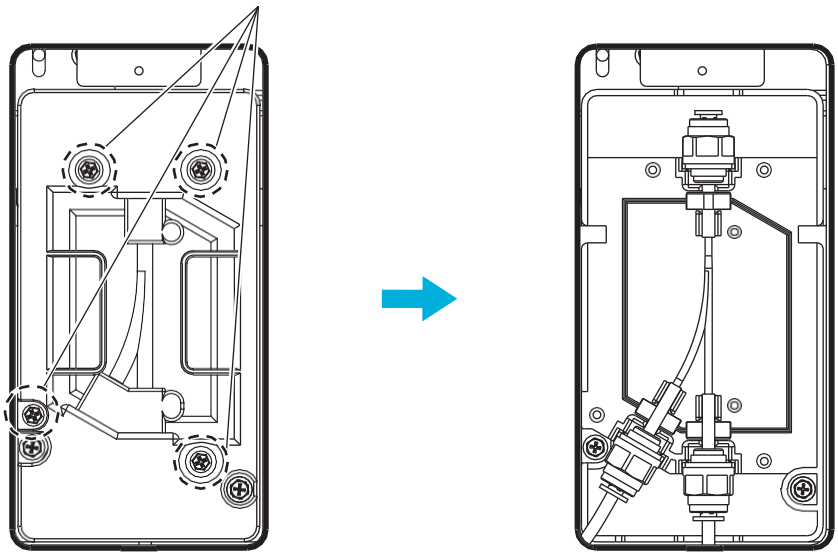
3.2 Filament Fragment Stuck in Junction

1 Remove the cover by loosening the junction cover fixing screws on the back of the main body.

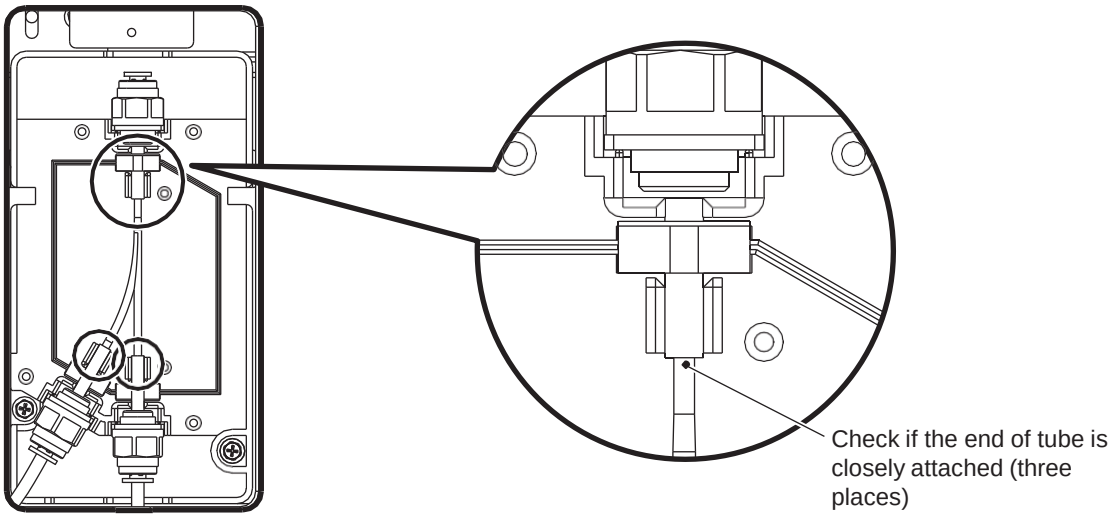


2 Remove the transparent cover by unscrewing fixing screws of the junction where the filament is hanging, and remove the filament piece.

Removal of Four Fixing Screws



3 Check if the end of tube is closely attached as shown below, assemble the transparent cover again, and tighten the fixing screws:



4 Assemble the junction cover again and tighten the fixing screws.

4. How to Replace Consumables

1. Bed Replacement

Removal and Installation of Flexible Bed

Reference

- See "Output Separation" on Page 4-2.

Note

- Bed sheets are consumables. If a bed sheet is excessively scratched or damaged and an output is not properly adhered, replace the bed.

4.2 Filter Replacement

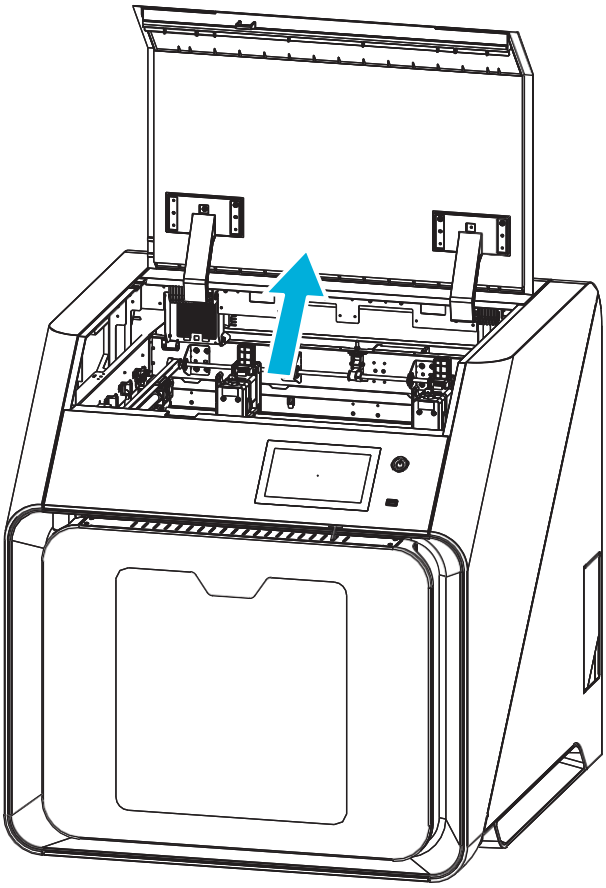
Caution

- After the power of the printer is turned off, replace the filter.

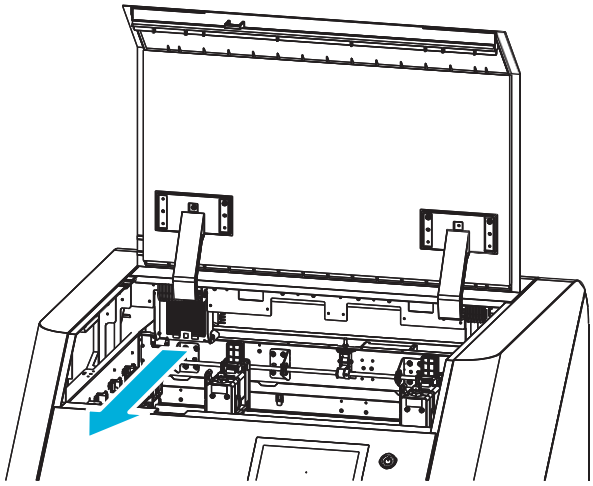
Note

- The filter replacement interval may vary depending on environment conditions. If you smell a strong odor from the filter during printing, replace the filter.

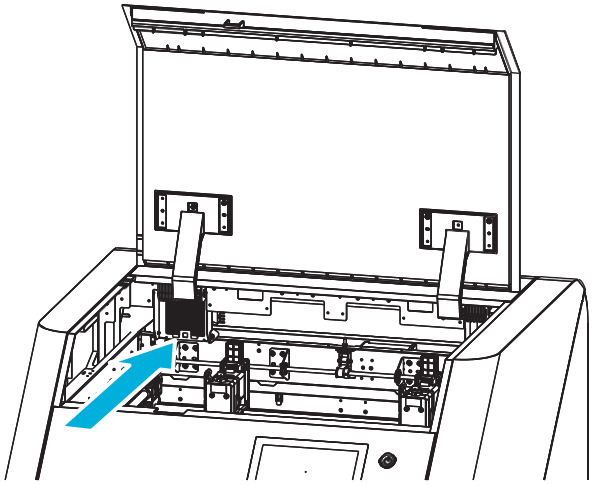
1 Open the top door.



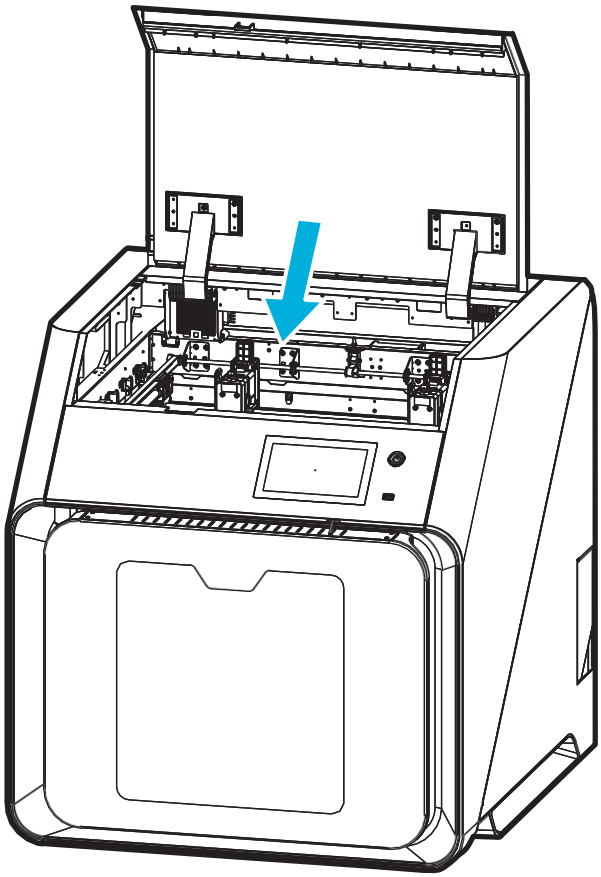
2 Pull the filter in the direction of the arrow to remove the filter.



3 Install a new filter by sliding it as shown below:



4 Close the top door.



4.3 Spool Replacement

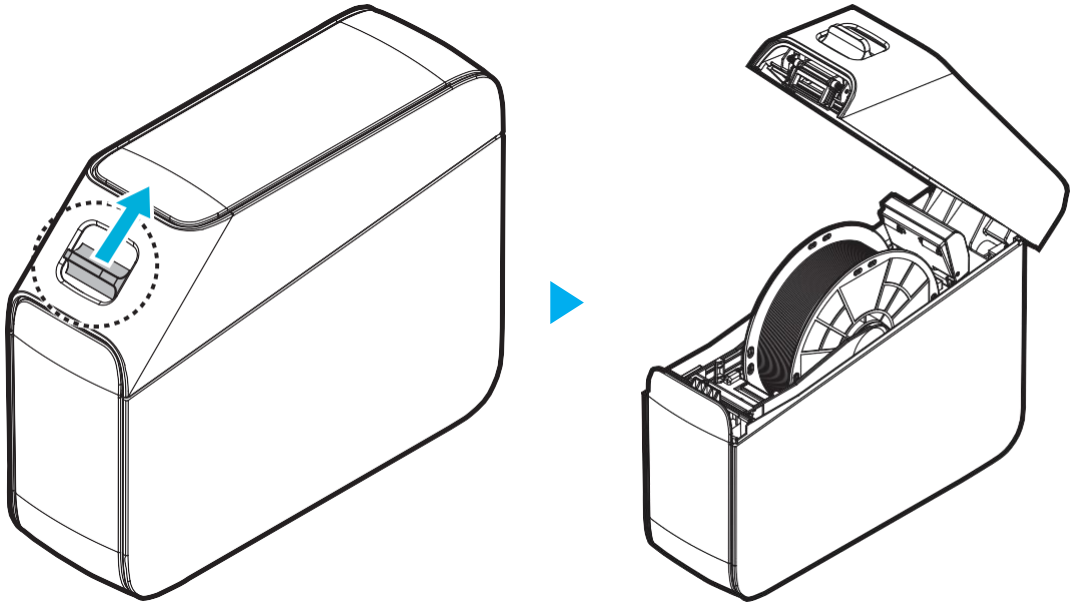
The used filament spool can be replaced with a new one, or a filament can be replaced with a material filament of different color.

1 Unload a spool to replace.

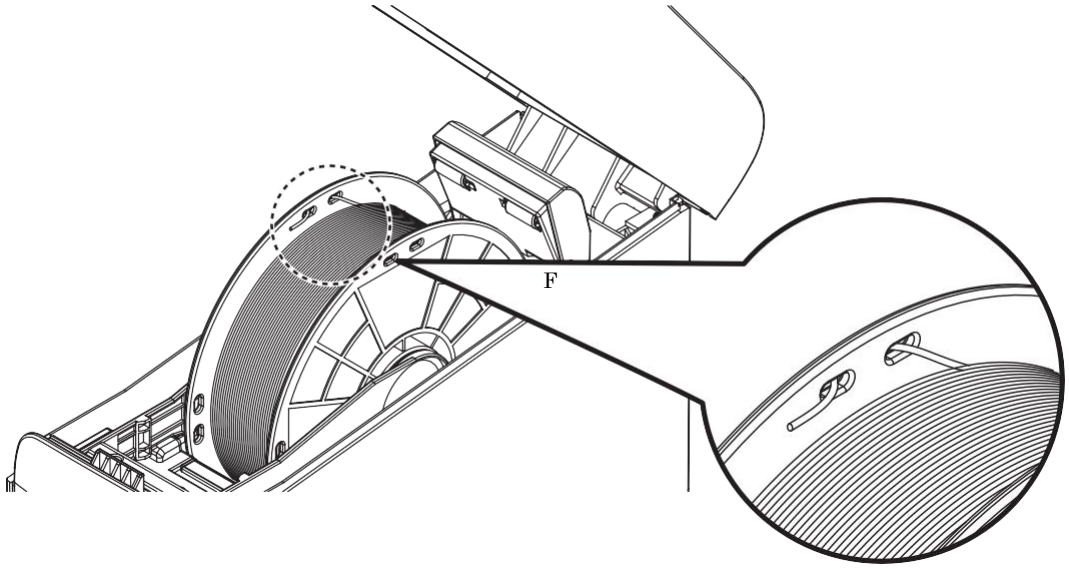
Reference

- For the information on how to unload a filament, see "Material Unload" on Page 2-7.

2 Once the unloading is completed, lift the opening/closing lever of the filament box and open the box.



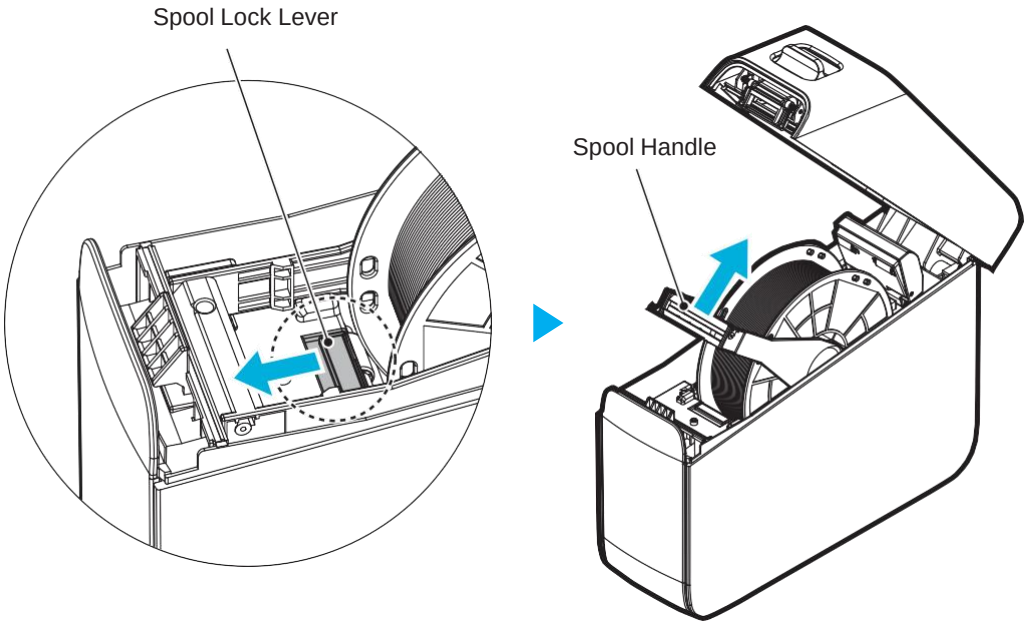
3 Wrap the filament around the spool and thread the end into the hole on proper side of the spool to prevent it from being twisted.



4 Pull the spool lock lever inside of the filament box to release the fixed spool. After that, grab and lift the spool handle up to remove the spool.

Caution

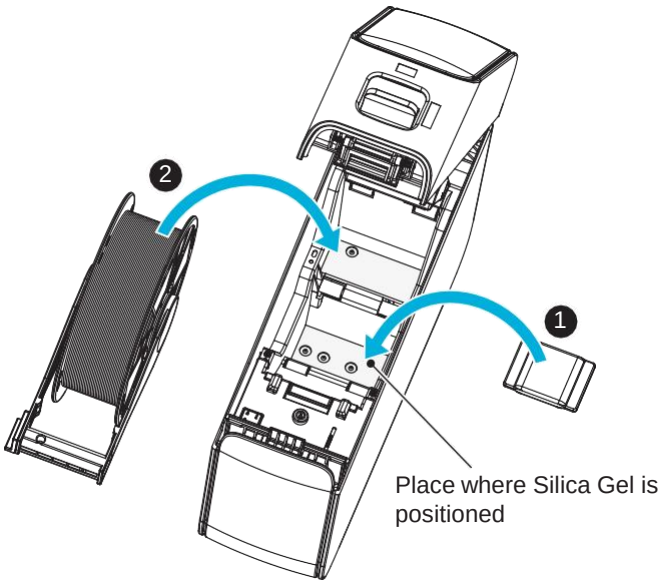
- Lift the spool by grabbing the spool handle. If not, the smart chip may be damaged.



5 Before inserting a new spool, place the silica gel included with the spool on the floor inside the filament box.

Caution

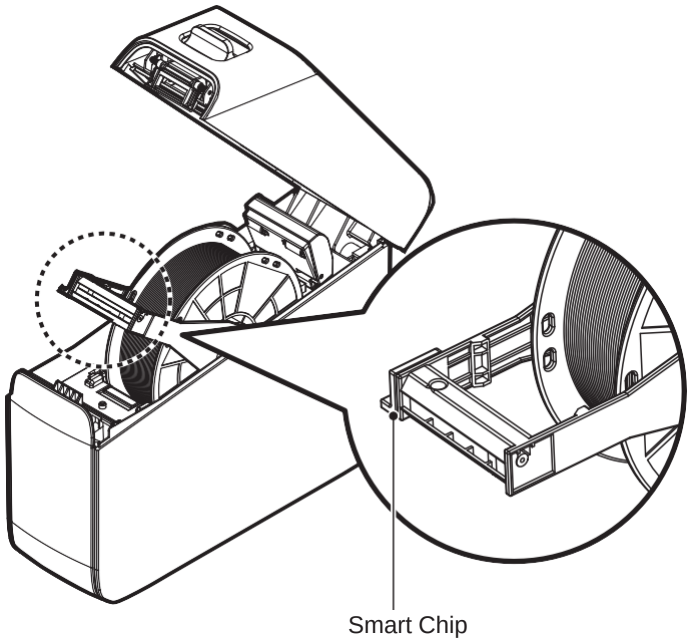
- The silica gel's dehumidification function decreases in a high-humidity environment after a certain period of time (about 2 weeks). When a spool is replaced, replace the silica gel together, which is mandatory.



6 Insert a spool into the filament box and push the spool handle down until the spool is fixed by the lock lever.

Caution

- **Pay attention to the spool installation direction. Insert the spool so that the smart chip faces down.**
- **If the spool is inserted in reverse, the filament and the product may be damaged.**



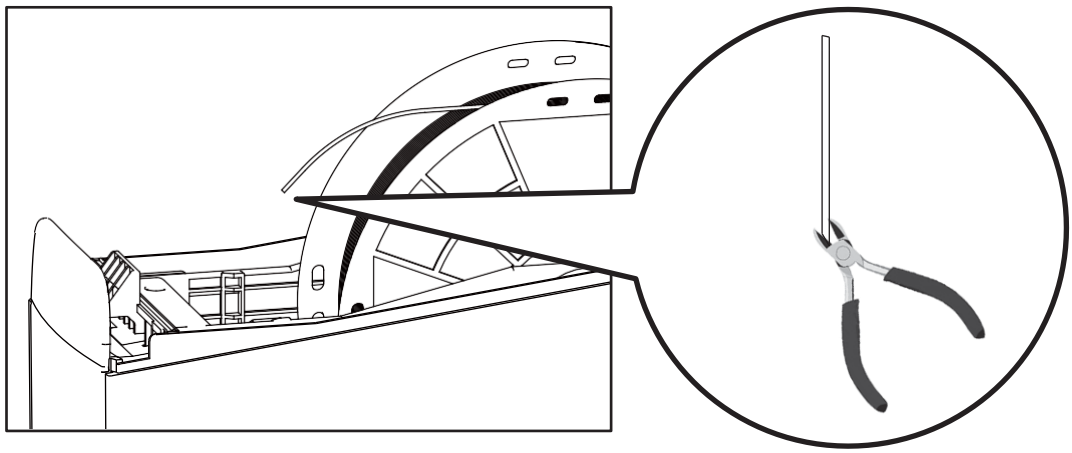
7 Cut the end of the filament diagonally.

Reference

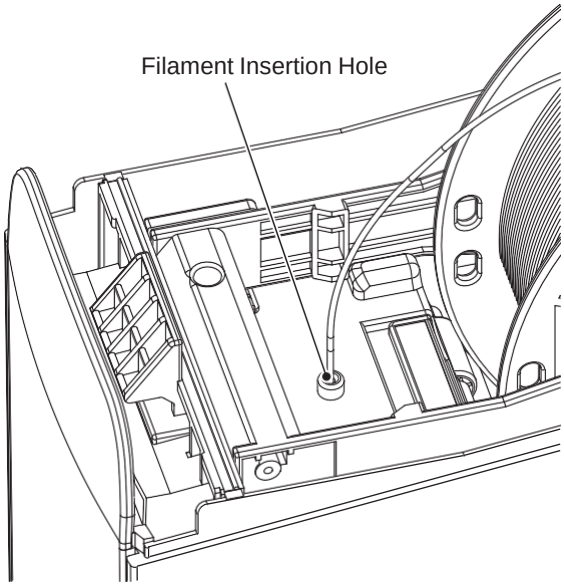
- If a spool is new, also remove the tap that fixes the filament.

Caution

- **When cutting the end of a filament, be careful NOT to miss the filament and come untangled to prevent it from being twisted. It may cause filament transfer failure.**



8 Insert a filament into the hole inside the filament box. Fully insert the filament until the filament box automatically pull it. The "Half Load" operation screen is displayed in the LCD screen.



Reference

- If a filament is inserted while the product is in operation, the filament may not be automatically pulled. Insert the filament into the hole when the product is in standby

9 Once the "half load" operation is completed, press the **[Material]** menu in the LCD screen and load the spool.

Reference

- For the information on how to load the filament, see "Material Load" on Page 2-7.

4.4 Nozzle Change

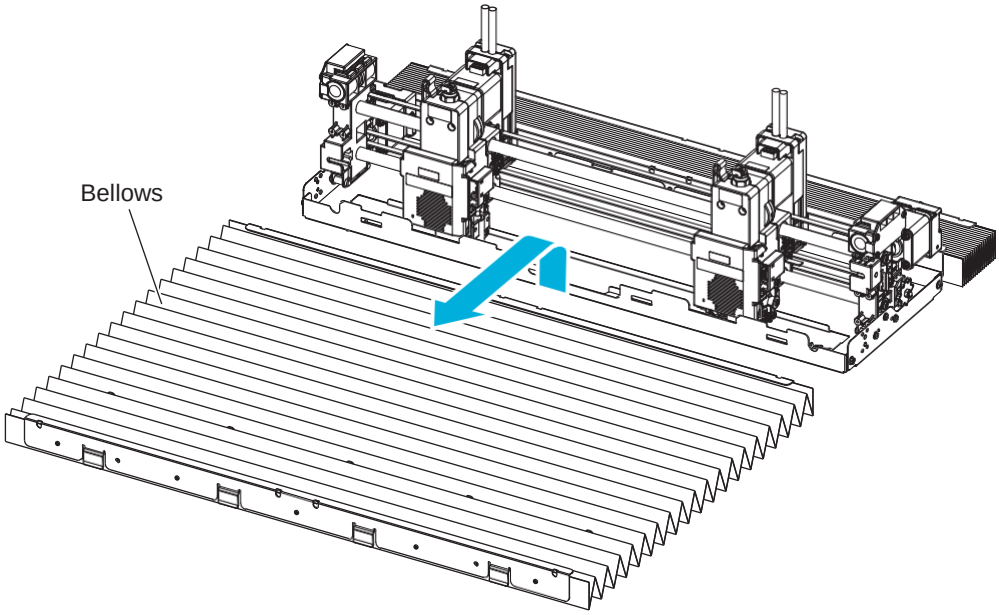
Caution

- When the nozzle is heated, the parts are very hot. Be careful of burns.

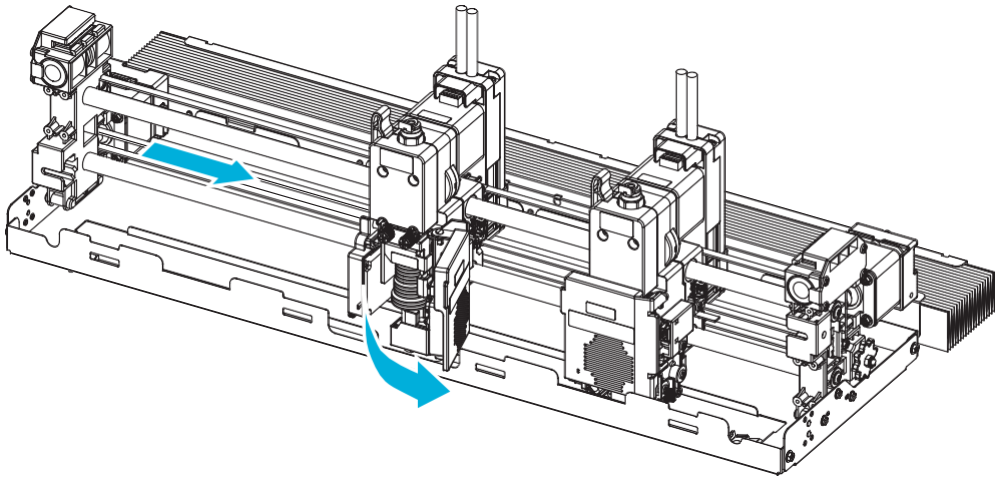
Important

- **Before replacing the nozzle, unload the filament.**
- **It is recommended to replace the nozzle when the power is turned off for safety.**

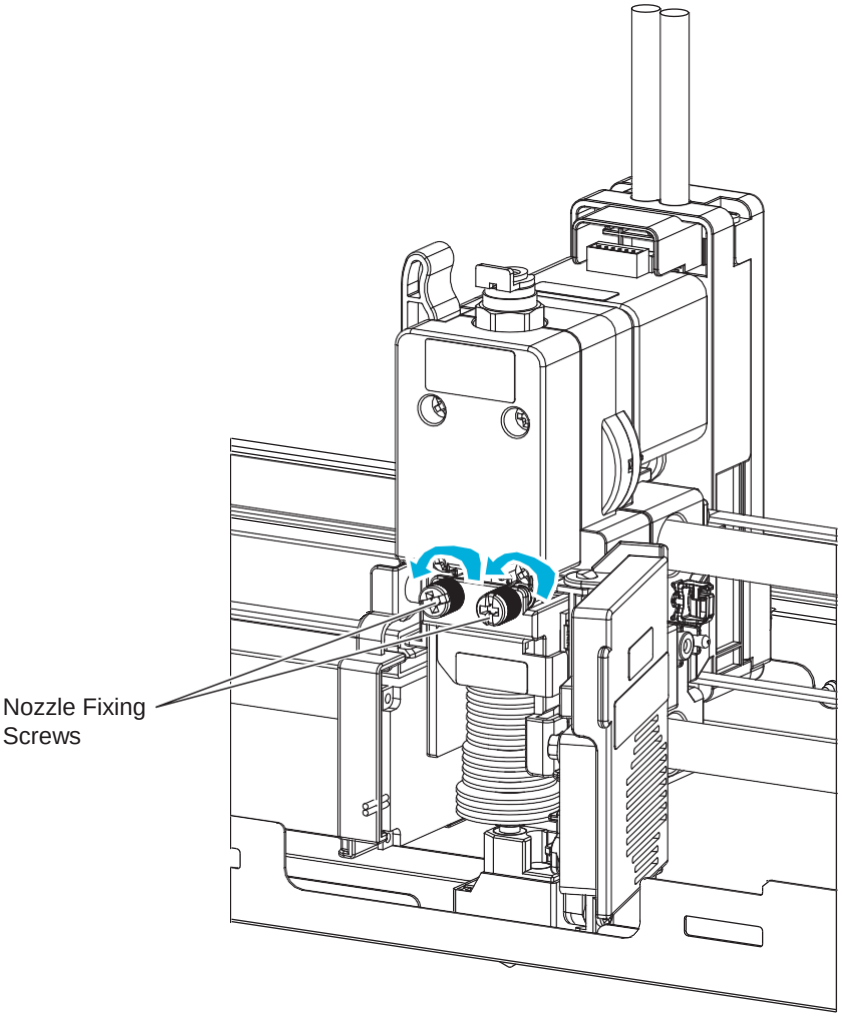
1 Separate the bellows fixed to the X-axis driving part.



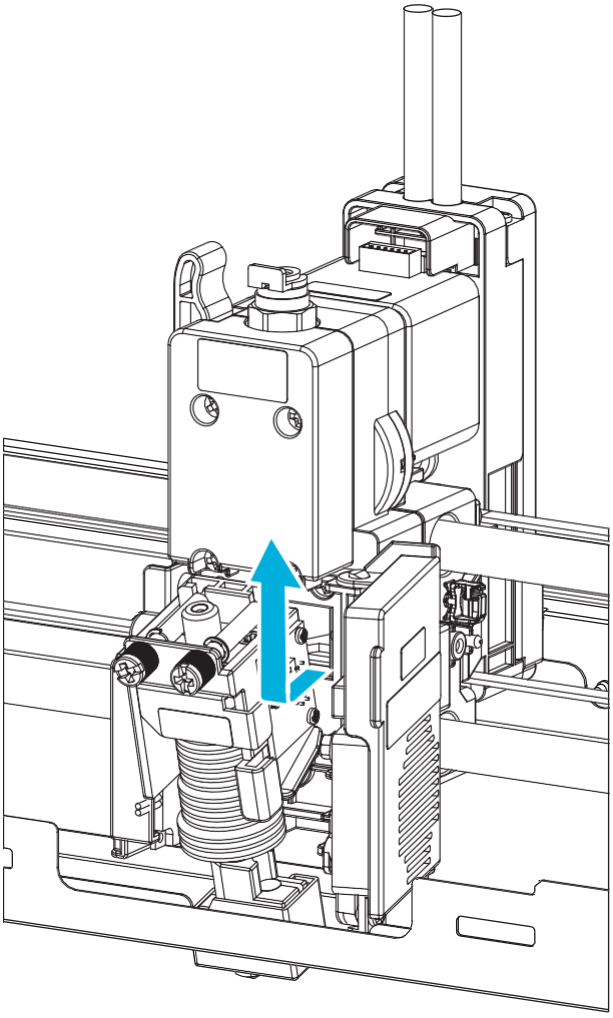
2 Place the replacement nozzle in the center of the X-axis driving part, and open the door in front of the nozzle.



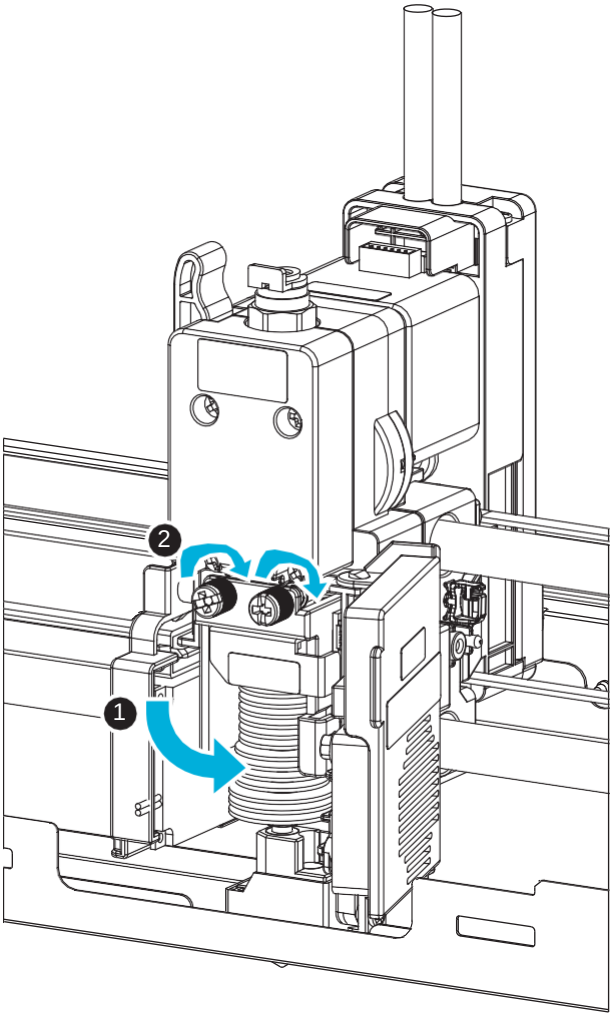
3 Loosen the two nozzle fixing screws on the front by turning counterclockwise.



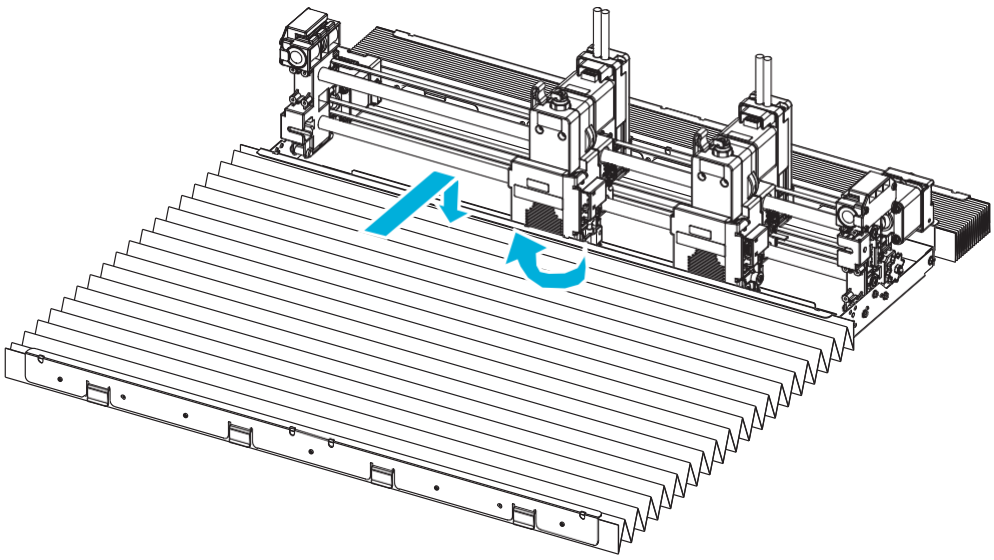
4 Pull the nozzle core forward and lift it up to remove it.



5 Assembly the replacement nozzle core at the same position, and fix the core by turning the two nozzle fixing screws on the front clockwise.

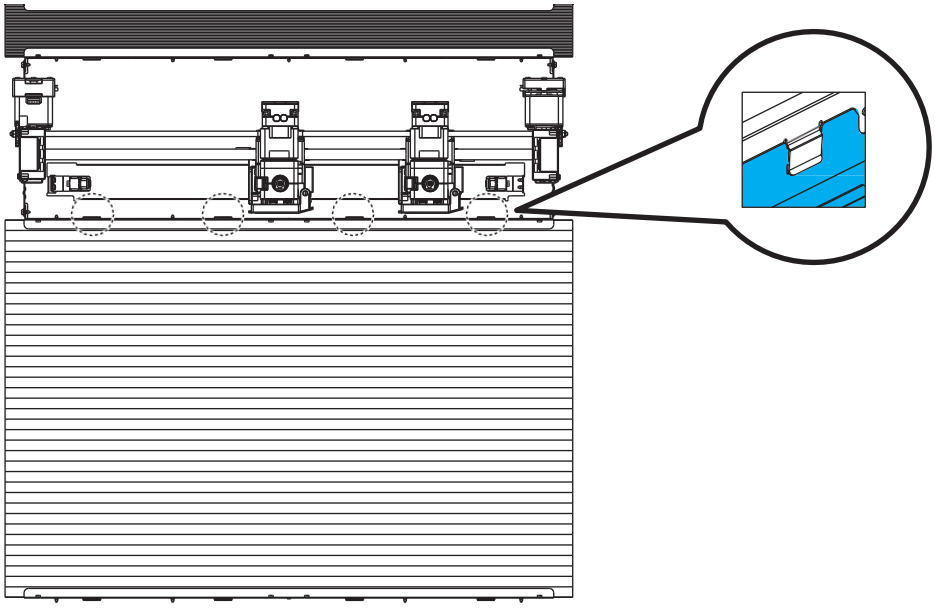


6 Close the door in front of the nozzle and replace the bellows in the X-axis driving part again.



Note

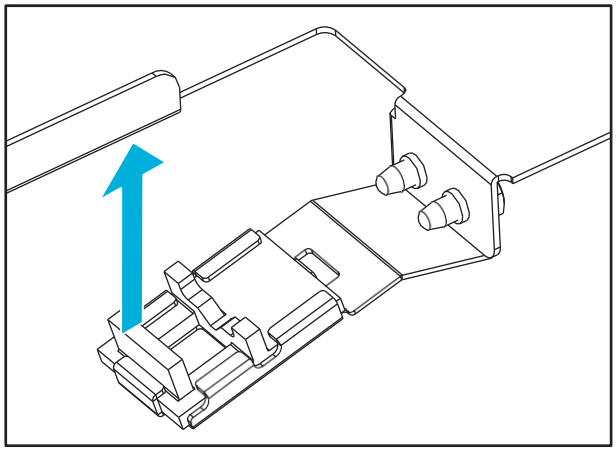
- After replace the bellows, check if all four fixing hooks are properly assembled in the X-axis driving part.



4.5 Nozzle Pad Replacement

If the nozzle pad is damaged and cannot properly block the filament flowing from the nozzle, replace the nozzle pad by the following steps:

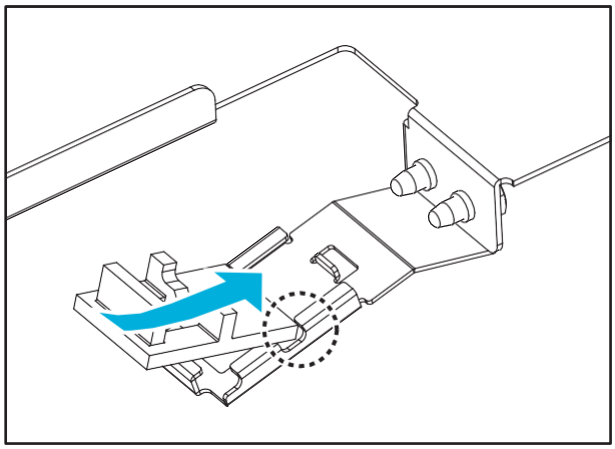
1 Grab the end of the pad and pull it strongly in the direction of the arrow to remove it.



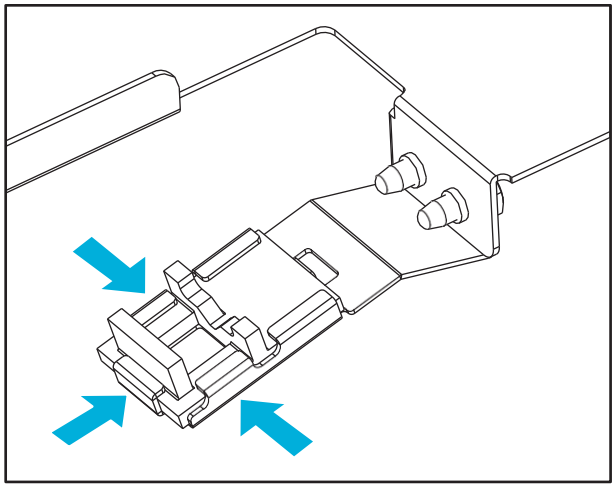
Caution

- Be careful NOT to damage or deform the surrounding parts when replacing a pad.

2 Align the tip of replacement pad with the groove as shown below and push the tip in the direction of the arrow.



3 After inserting the pad, check if the pad is properly fixed on hooks in three directions as follows:



6

Appendix

1. Filament Type (Material & Color)

ABS
Color: Natural color (default), white, black & gray

ASA
Color: Natural color, white & black

ARS
Color: Translucent yellow

PLA
Color: White & blue

Thank you for purchasing this fabWeaver product.
The product is manufactured and sold through strict quality control processes.
For smooth use of the product and service, observe the followings:

1) Use only the consumables and parts specified for the product.
2) Replace and inspect the consumables and general parts of the product in a timely manner.

If genuine consumables and parts are not used, the product may malfunction or its service life may be affected. In this case, if this product fails within the warranty period, we will charge a service fee in accordance with out warranty policy.

Please, keep the attached warranty properly. It will not be reissued. If the product needs to be repaired, present this warranty.
The warranty of this product is only valid in Korea.

fabWeaver Warranty

- **The main body of this product is warranted for 1 year, and the guaranteed output is below 4 km (filament length).**

  If the guaranteed output exceeds this value even within the warranty period, the warranty is voided.

  ※ Claims (for main body & consumables) are determined in accordance with our standards.

- **For the replacement cycle of consumables and major consumable parts, see the table below:**

Consumables	Initial Installation	For Sales	Remarks
ABS	483m	483m	* Default print standard of test sample file * Evaluation environment: Temperature 23±2℃, humidity 50±10%RH
ARS	189m	189m	
ASA	-	491m	
PLA	-	498m	

※ When the product is initially delivered, a cartridge is provided as installed.

- Replacement cycle of major consumable parts

Consumable Parts	Service Life
Nozzle Unit	3,000m
HEPA Filter	3,000m
Bed Unit	3,000m or 3 months

※ The figures of the above replacement items are calculated when they are used at normal operating conditions. Thus, their replacement time may vary.

※ The above replacement items directly affects print quality and the product's operation so that strictly observe the replacement cycles.

※ General parts need to be inspected if necessary or in case of malfunctions. If they fails, contact the technician.

※ The quality assurance of consumables and consumable parts is applied based on the remaining amount set for standard usage within the warranty period.

※ Quality assurance is implemented in accordance with our standards and procedures.

User Guide

• **Class A Equipment** (Commercial telecast equipment)	This equipment has undergone conformity assessment for commercial use. There is a risk of radio wave interference for home use.

※ This product is a Class A equipment.


FabWeaver