

Use of the cleaning filament

Variant A: (for low impurities -> effort: low -> thoroughness: low)

The cleaning filament can be used both before and after printing.

Before using the cleaning filament, ensure that the extruder temperature is maintained at the extrusion temperature of the previous filament.

Cut off approx. 30cm of the cleaning filament and insert into the extruder and allow to extrude.

This variant should be repeated until the cleaning filament no longer contains any impurities or residual filament.

Once this step is completed, the direction of the filament can be reversed to remove the cleaning filament.

Variant B: (for low impurities -> effort: low -> thoroughness: low)

The cleaning filament can also be used as an intermediate filament between different filament types (with different extrusion temperatures or colours).

Before cleaning, make sure that the extruder temperature is maintained at the extrusion temperature of the previous filament.

Insert the cleaning filament into the extruder and allow the old residual filament to exit the extruder completely.

Once this step is completed, the conveying direction can be reversed to remove the cleaning filament.

The extruder temperature can then be reduced or increased to that of the next filament to be used. If the temperature of the next filament to be used is higher than that of the previous one, then repeat the cleaning process at the higher temperature.

Variant C: (for heavy impurities -> effort: medium to high -> thoroughness: high)

Cold Pull:

Go to approx. 230°C extrusion temperature, push the cleaning filament through until it comes out clean/clear.

Then turn off the heater and watch the temperature drop passively until it is between 85°C and 110°C.

Then carefully but decisively pull out the cleaning filament.

The temperature at which the cold pull is done has a

strong effect on the cleaning process, so test the process at several different temperatures.

A complete "negative form" of the inner area should have been pulled out.

Usually you can see at the end piece in the area of the nozzle tip that it is glued with residual materials.

Repeat the procedure several times until no residual material sticks to the pulled out piece.

If the area at the nozzle tip is not pulled out, it can help to pierce the nozzle tip from the outside with a nozzle tip cleaner and thus get it free again.



The variants given are only recommendations and are not carved in stone. :-)

Each printer model and user has different settings and requirements. Therefore, try and test which procedure works best for you and your printer.

Difficulties, ambiguities, suggestions for improvement?

Get in contact with us.

We will help you! Write us a message at info@3d-drucker-filament.de.