**PRINTER MAINTENANCE**

Lubricate the rails that form the print head gantry system every 4-6 months or as needed. Refer to the User’s Manual for details.

Replace the HEPA filter after 300 hours of use or every 6 months, whichever happens first. The filter is inside the round filter cover with the white trim located to the left of the platform. Refer to the User’s Manual for details.

**CHANGE FILAMENT DURING PRINTING**

1. **Pause Printing**
   - **DOUBLE PRESS**

2. **Withdraw filament**
   - **DOUBLE PRESS**

3. **Remove filament**
   - When printer beeps remove old filament and insert new filament

4. **Extrude filament**
   - **LONG PRESS**

5. **Resume Printing**
   - **DOUBLE PRESS**

**WARNINGS**

- **Warning!** Never attempt to remove the nozzle from the print head without first doing a "Withdraw". The nozzle temperature must be above 230°C before attempting to remove it. **Always** ensure the "drive cog" is clean before suspecting the nozzle is blocked.

- **Warning!** Turn off the printer and unplug the power before performing any service on the printer such as removing parts, cables or covers. Contact Technical Support for instructions.

- **Warning!** Always have adult supervision when children are present. Small printed parts may be choking hazards – please keep small parts from children.

- **Warning!** Tools and parts should be stored at a suitable height away from small children. Tools should be used in conjunction with safety gloves and glasses.

- **Warning!** Make sure to tie back loose clothing and long hair while the printer is in operation.

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**SUPPORT**

If you encounter any issues, have any questions, feature requests, or feedback for our support team, please contact your local reseller.

- **Email Support**
  - support@afinia.com

- **Software, FAQs & updates**
  - www.afinia.com/support

- **Phone Support**
  - USA (952) 279-2643 (M-F 8-5 CT)
  - UK +44 (0)845 230 7800
  - Japan 03-3561-2266