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Clean the feeders on the Ultimaker 3

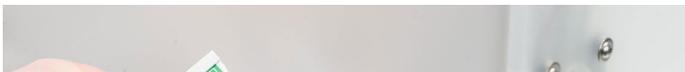
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The feeders forward filament to the print head. To make sure that exactly the right amount of material is extruded, it is important that the feeder gears can turn smoothly.

After many hours of printing, or when material has been ground down, there is a chance that there are small filament particles in the feeders. In addition to blowing out the particles once a month, it is recommended to also clean the inside of the feeders after one year of printing. In order to do this, the feeders have to be removed from the printer.

The following steps need to be performed for both feeder 1 and feeder 2:

1. Remove the material by navigating to *Material/PrintCore* -> *Material [x]* -> *Unload*. After this, turn off the printer
2. Remove the clamp clip from the feeder-end of the Bowden tube, press down on the tube coupling collet and pull the Bowden tube upwards out of the feeder
3. Reduce the tension of the feeder by turning the bolt in the top of the feeder, until the indicator is at the highest mark
4. Use the hex screwdriver to loosen the two bolts that hold the feeder to the back panel and slide the feeder backward away from the printer

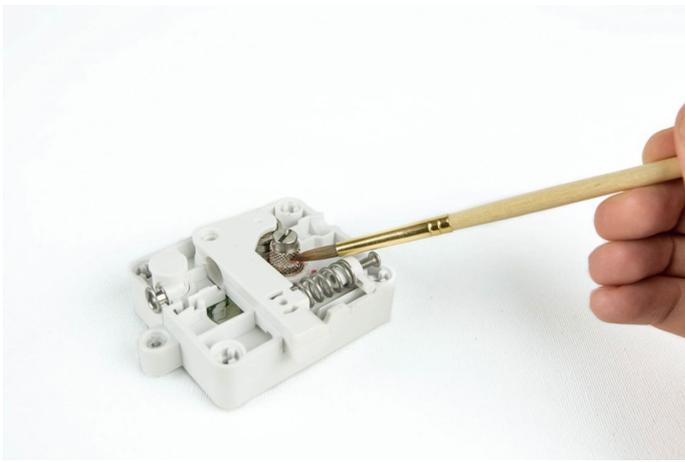


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5. Open the feeder by removing the four bolts that hold the housing parts together. Place the two halves in front of you, making sure that all parts are in the back section of the feeder
6. Use a clean cloth or a cotton swab to wipe all filament particles from the feeder parts. Use a paintbrush or an old toothbrush to clean the knurled wheel. Also clean the small gear attached to the feeder motor
7. Apply a small amount of Magnalube to the gear attached to the feeder motor. There is no need to spread this out; the feeder will do this automatically when it turns
8. Reassemble the feeder by placing the front section over the back section, making sure that all parts are still in place. Insert the four bolts and tighten them in a cross pattern, starting in the top-left corner
9. Place the feeder back on the printer
10. Insert the Bowden tube into the feeder by pressing down on the tube coupling collet in the feeder and pushing the Bowden tube all the way in. Secure the tube with the clamp clip
11. Reset the tension of the feeder by turning the bolt in the top of the feeder, until the indicator is at the middle mark





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