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# Clean the feeders on the Ultimaker S5

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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 the material has been ground down, there is a chance that there are small filament particles in the feeders. It is recommended to clean the inside of the feeders after three months. 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. Start by removing the material. Go to the configuration menu, select the material you want to remove and then *Unload*. After this, turn off the printer and remove the power cable
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 with the hex screwdriver, until the indicator is completely at the top
4. Use the hex screwdriver to loosen the four bolts of the feeder housing
5. Carefully pull the front part of the feeder away from the printer and put it aside
6. Use a small brush to gently clean all filament particles from the knurled wheel, the flow sensor axis and the inside of the feeder housing

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**Tip:** Be careful not to lose the ring that is located at the bottom of the feeder. If it falls out, place it back in the feeder housing with the widest side at the top.



**Note:** It may also be necessary to lubricate the feeder gear. Based on 1,500 printing hours per year, we recommend to lubricate the feeder gear every year.

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