

STRATASYS FDM SUMMER STORAGE REQUIREMENTS



TO DO before leaving your FDM machine for an extended break (more than 2 weeks)

1. Follow the standard **Unload Procedure** to remove the material cartridges/spools (**see User Manual**).
2. Place used cartridges/spools in a zip-lock (airtight) bag with extra packets of desiccant/silica gel to keep them dry.
3. Turn the Printer **off**, by using the **main on/off switch**.
4. Once it goes through a proper shutdown, the display screen will go black.
5. **Turn the breaker off on the back of the machine and unplug the unit from the wall.**
6. Relax and don't worry about it.

WARNINGS:

The head in your machine is a mechanically and electronically calibrated assembly. Improper removal or cleaning of parts not described in the manual may result in part build errors and/or permanent damage to your machine

DO NOT disassemble parts of the head beyond the detailed instructions provided in the User Manual.

DO NOT put any part of the head, tips, shrouds, shields, or trays into the Clean Station.

DO NOT use any liquid cleaners to attempt to remove excess material or clean interior components of your machine.

GENERAL MAINTENANCE – FDM Systems

1. Check GrabCad Print for Printer Firmware Updates on the Printer Menu. If one is available, Send the update to the printer as soon as possible.
2. Empty the purge bucket regularly.
3. Clean build envelope regularly of stray material and dust (or vacuum it out carefully with the machine off): Both bottom and top areas.
4. Check your brush and flicker assembly. Remove excess material. Replace if rubber is torn or there are deep grooves in the wire brush
5. Wipe dust, debris, and built up grease off of the rails and lead screw.
6. (Only 768/Elite series machines) – Use a small wire brush to gently brush the tips under the head.
7. (Only 1200s and uPrints) – Replace tip shrouds with new black shrouds if current shrouds are worn or covered with material. **Note: You must have updated backend software to use the black tip shrouds for Dimension 1200 series machines.**

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LOCATION:

- *Keep machine away from windows and drafts.*
- *Keep machine away from dusty machines/environments.*
- Make sure the machine is plugged directly into a wall outlet dedicated 20 Amp circuit or an APC2200 Battery Backup.
- **Do not** put the machine on an extension cord, a surge protector, or a surge protected outlet. (Marked with an orange triangle.)

If you are waiting for a dedicated circuit to be installed, put the machine on a circuit with none or the fewest possible number of other devices.

Clean power is a very important part of your machine's health and ability to produce good, consistent models.

MATERIAL STORAGE:

#1. DO NOT USE NON-STRATASYS MATERIALS IN YOUR MACHINE! This will void your warranty and most likely leave your machine disabled. We have had customers who have tried this and it DOES NOT WORK!

Material sitting out, unsealed, for longer than a few weeks can accumulate moisture from the environment. When extruded, the water steams out, possibly causing damage to the head of the machine as well as jams or the need for head cleaning. There are detailed instructions in the *User Guide* you received for *Cleaning a Head Jam, Head Cleaning, and Tip Replacement* procedures. Multiple head jams due to bad material can result in the need for head replacement. This is covered for customers on maintenance but, can be a costly repair for those users not on contract. If you encounter material that has moisture in it (Hazy SR-20 or if you notice small bubbles in the support structures of your builds), Stratasys may replace the cartridge if there is over 90% of the material remaining. Contact your service rep to arrange this exchange. Additionally, if you have trouble clearing a head jam or replacing tips in your machine, please feel free to contact us.

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Please put a copy of these instructions with the machine as a reminder.

This will help avoid extra repairs, service calls, jams, malfunctions, and other performance issues.