



Micro Swiss All Metal Hotend with SLOTTED Cooling Block for Duplicator 6

Step by Step Installation Instructions



Included in the kit:

- Slotted Cooling Block
- Thermal Barrier Tube
- Plated nozzle for Micro Swiss Allmetal Hotend Kit
- 3/32 Allen Key

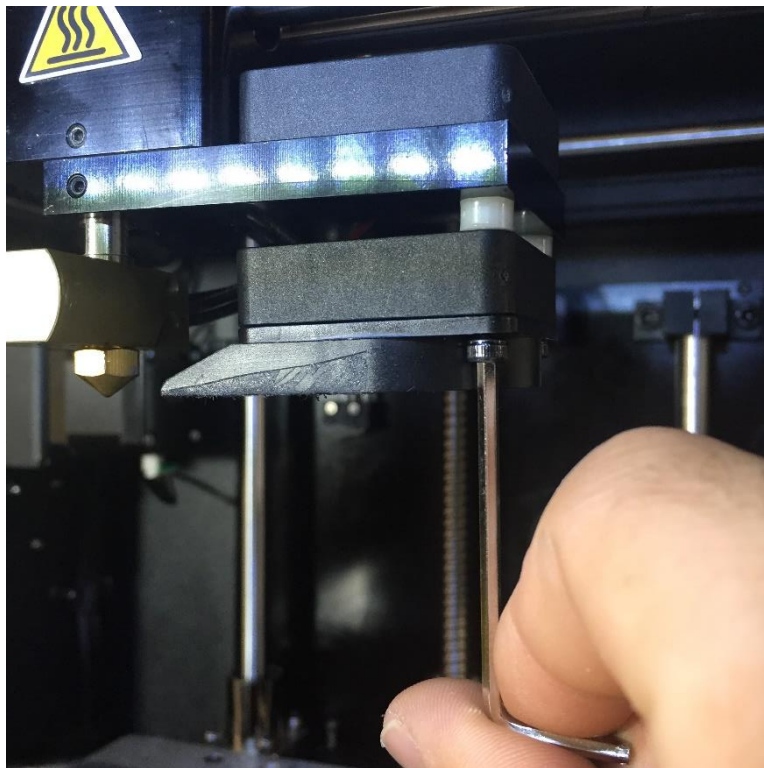


Tools Needed:

- Small adjustable pliers or wrench
- 9mm socket
- 1.5mm Allen Key
- 2.0mm Allen Key
- 2.5mm Allen Key
- 3/32 Allen Key (included with kit)



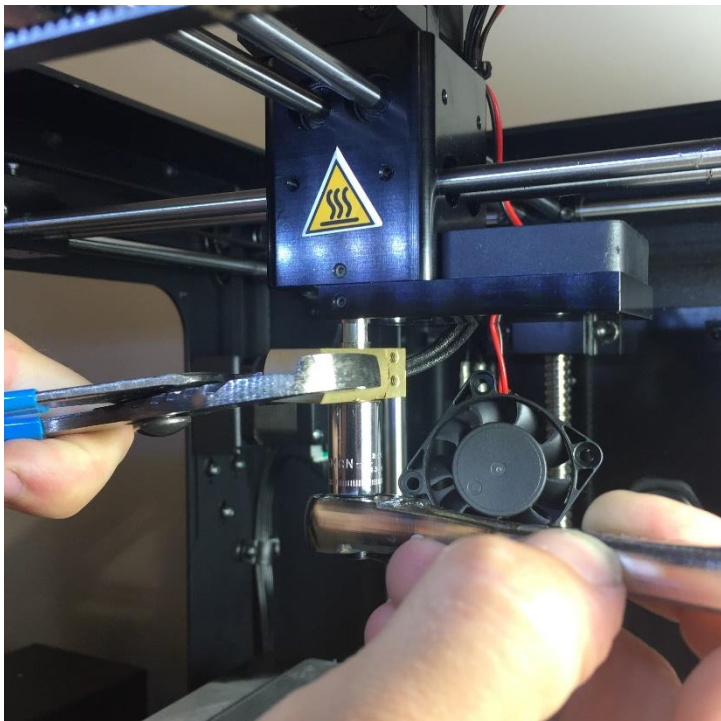
1. Lower the build plate to have enough clearance for disassembly.



2. Remove Cooling Fan and Duct.

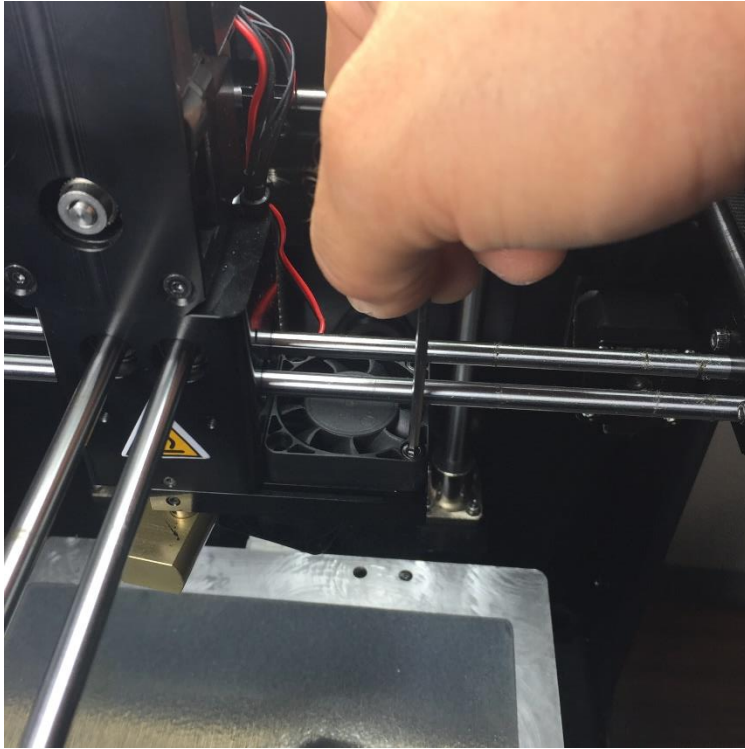


3. Preheat the extruder to 230C.

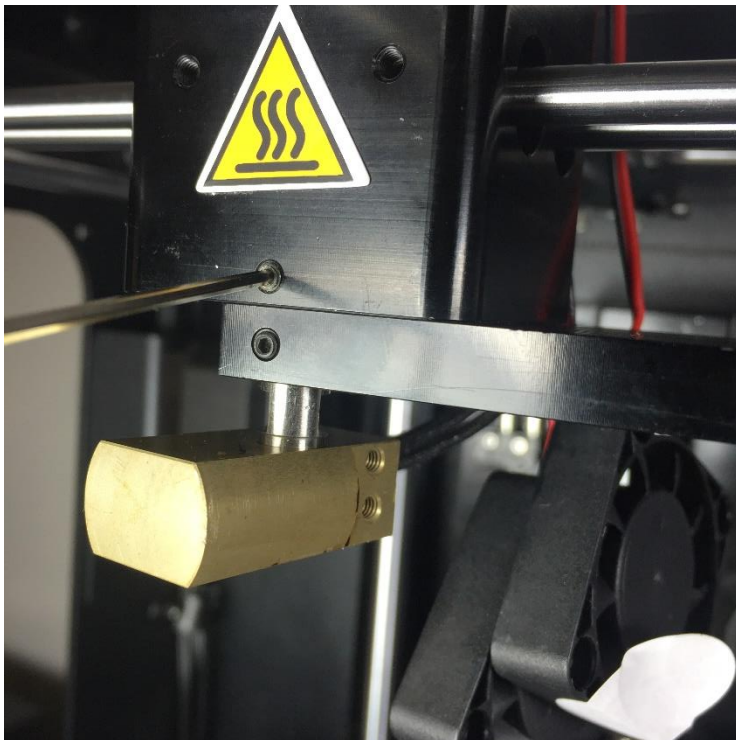


4. Remove original nozzle while supporting heater block with adjustable pliers /wrench. **Be very careful, nozzle is extremely hot.** Use 9mm socket for the nozzle.

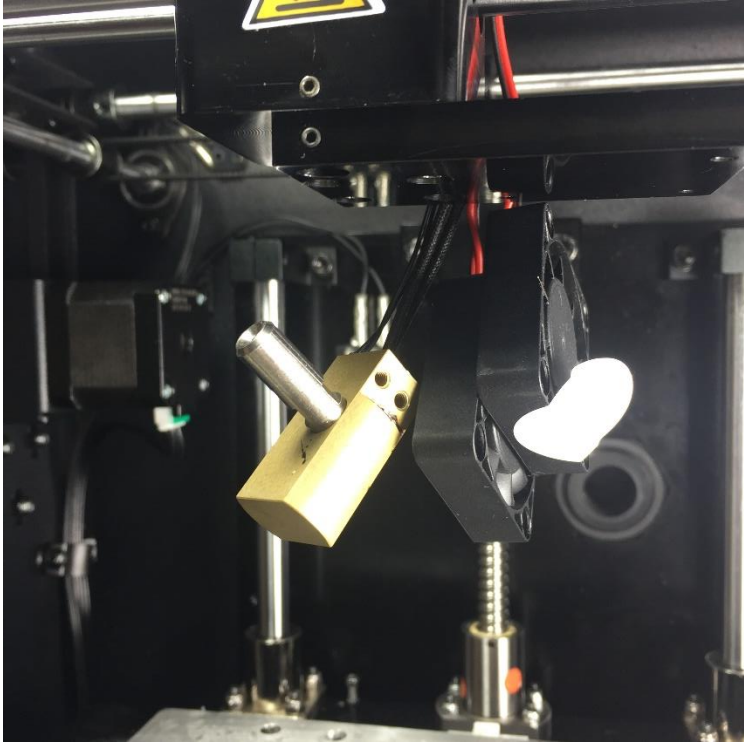
5. **Shut the power off.** Let the machine and nozzle cool down before proceeding



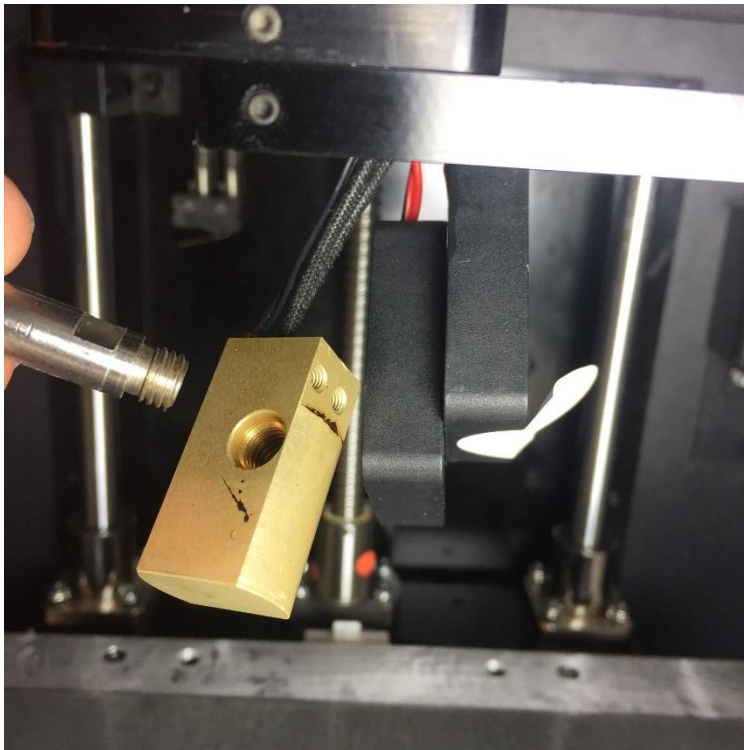
6. Remove top cooling fan. (Mark it with identification label because top and bottom fans can be mixed up when assembling back)



7. Loosen both set screws holding thermal tube. Use 1.5mm Allen key.



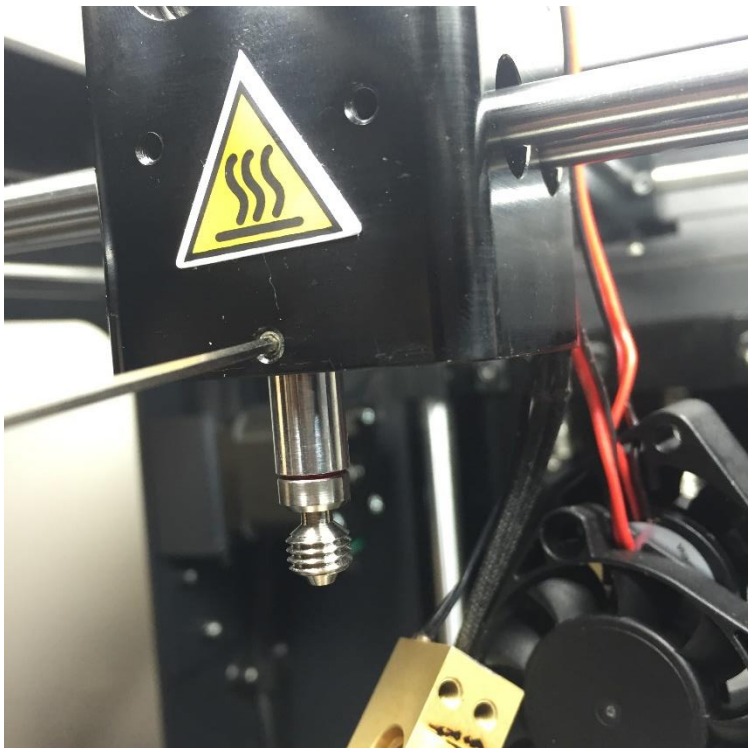
8. Remove hotend from the cooling block.



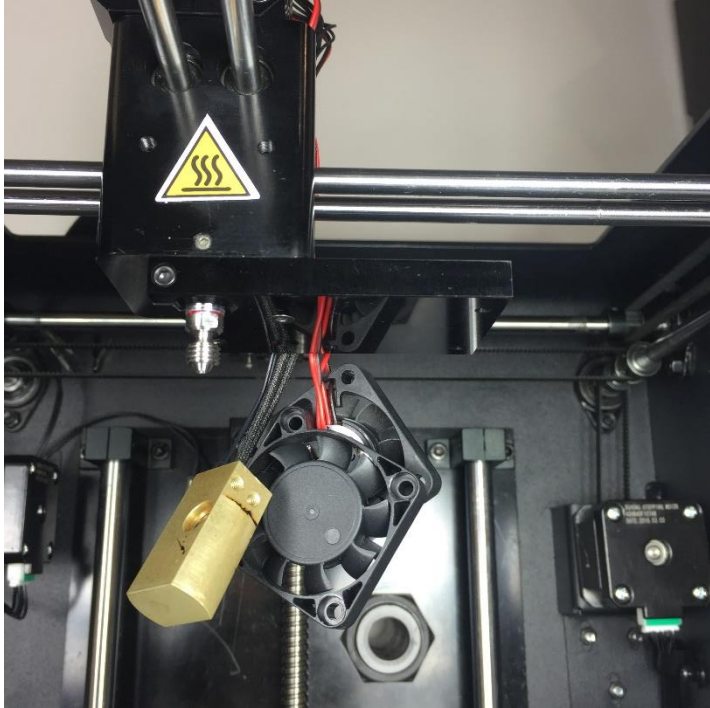
9. Remove thermal tube out of the heater block.



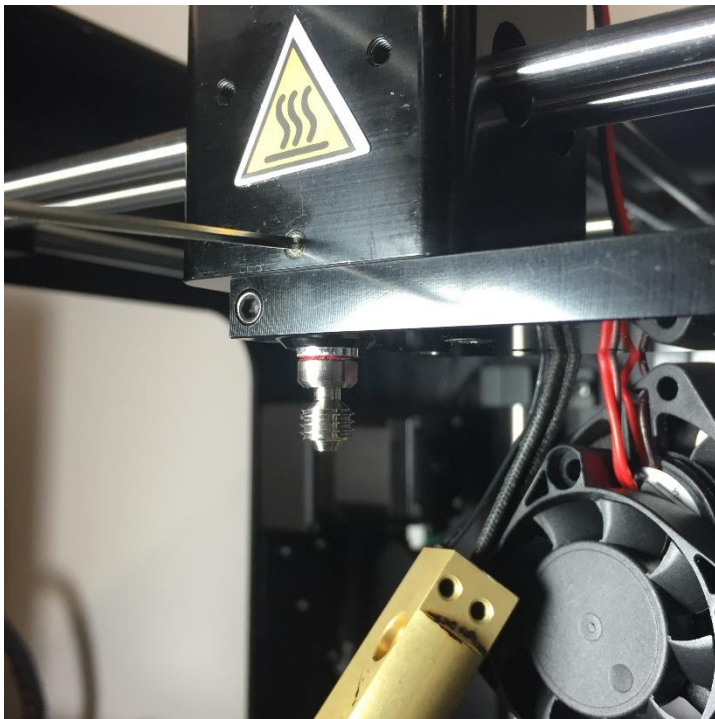
10. Remove cooling block using 2.0mm Allen Key.



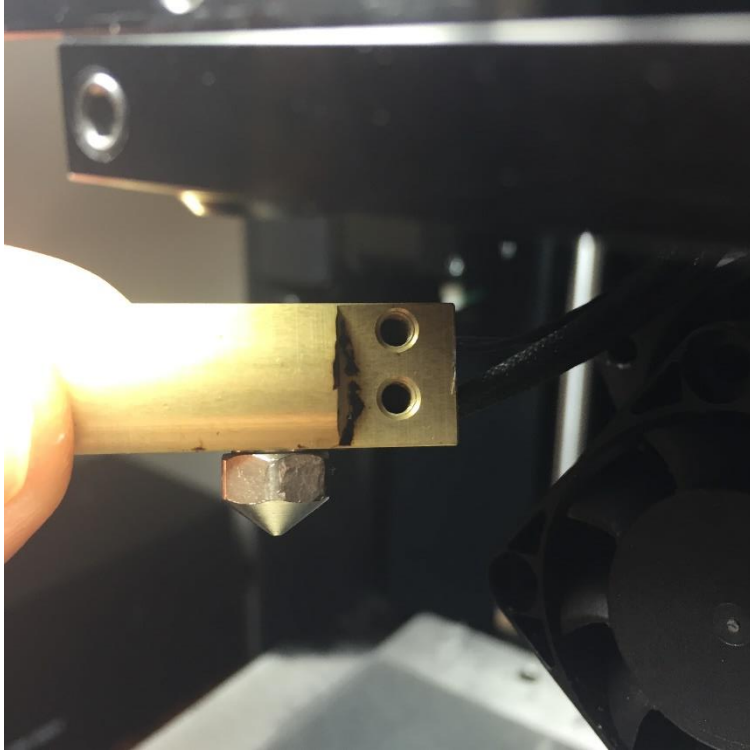
11. Before installing new Slotted Cooling block, insert All Metal thermal tube and lightly tighten in with the top set screw



12. Slide Slotted Cooling block over the thermal tube and bolt it down.



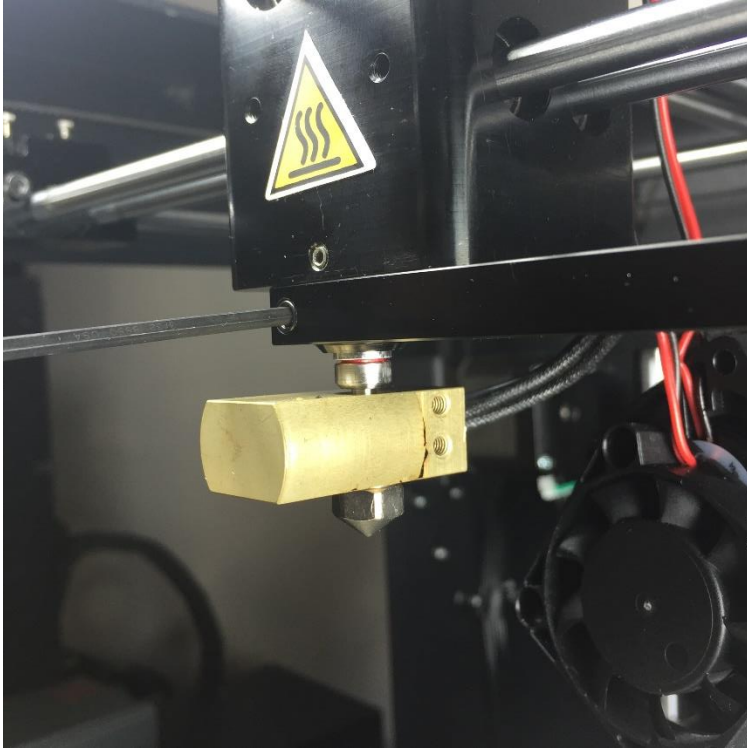
13. Loosen top set screw and remove All Metal thermal tube.



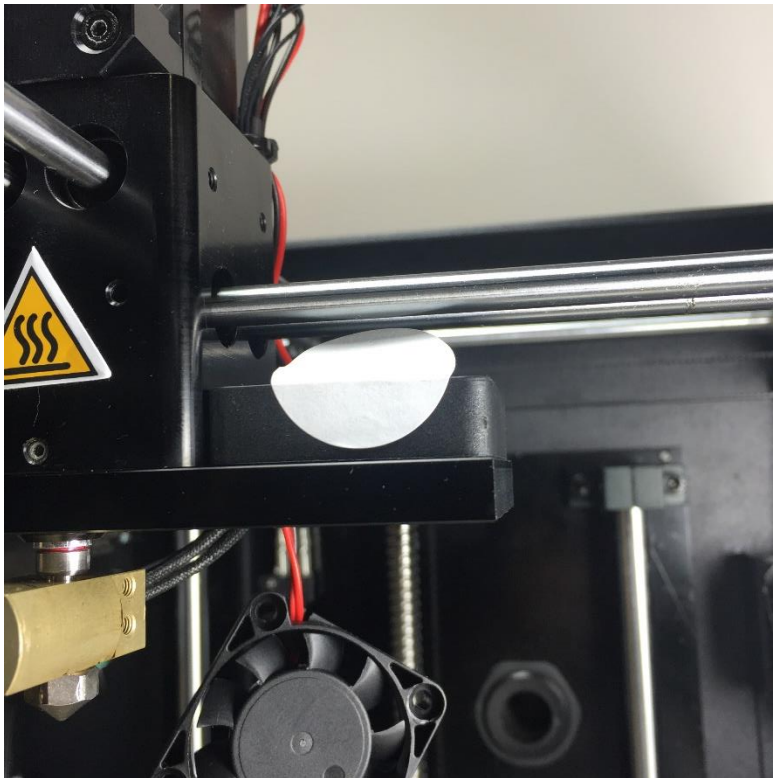
14. Install Micro Swiss Allmetal Hotend Nozzle. Screw it in all the way in, until it bottoms out, then back it off $\frac{1}{4}$ of a turn.



15. Using finger pressure, screw in Allmetal thermal barrier tube, until it bottoms out. (make sure)



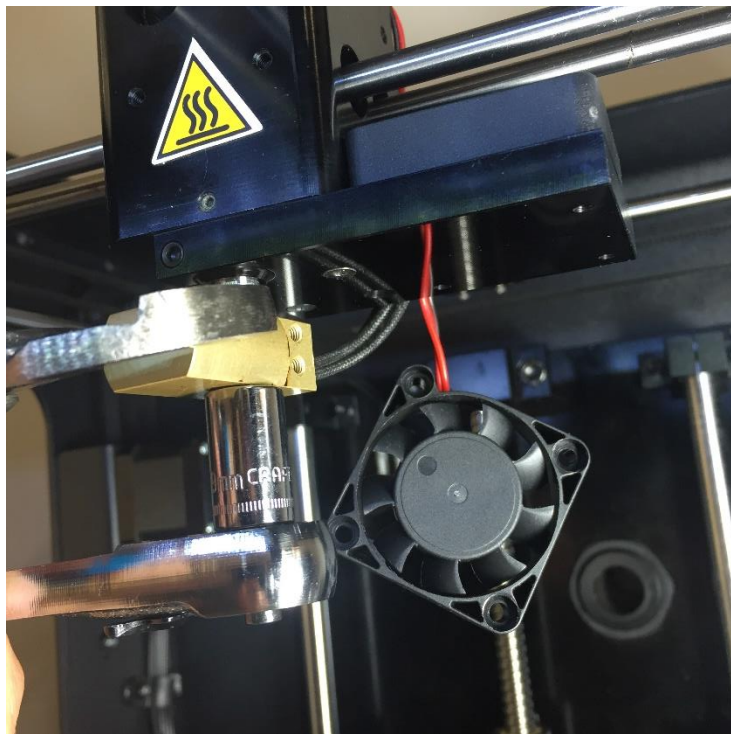
16. Insert Hotend into Slotted Cooling block and clamp it down using 3/32 Allen Key (included with kit) Using 1.5mm Allen Key, tighten top set screw as well.



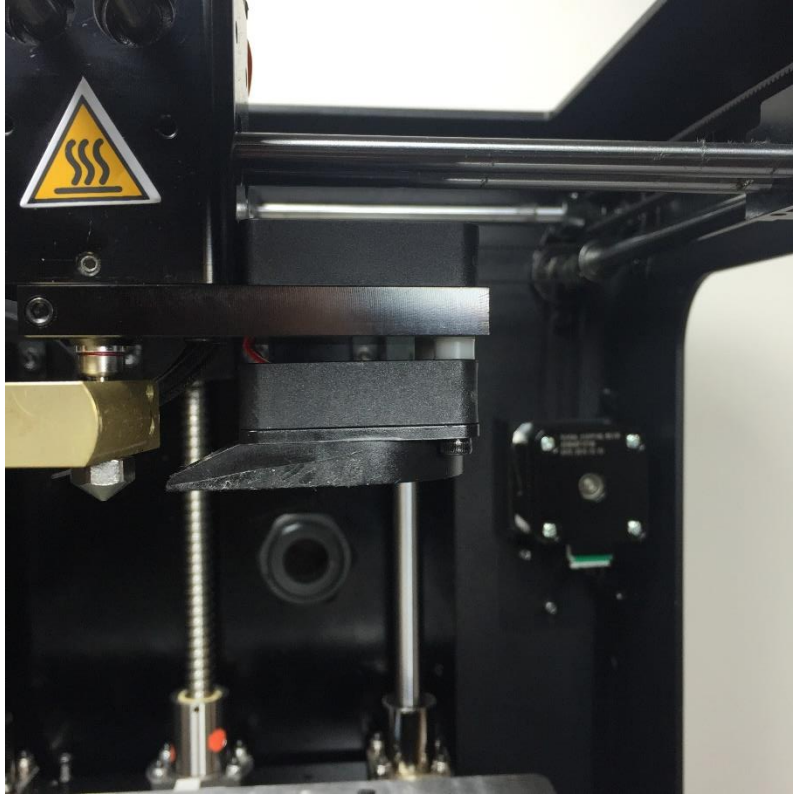
17. Install top fan back on cooling block.



18. Preheat the nozzle to 230C.



19. Tighten and seat the nozzle while supporting heater block with adjustable wrench. (Be careful, nozzle and heater block are now hot)



20. Install lower cooling fan and duct.

21. Re-level the bed.

22. Enjoy your Micro Swiss All Metal Hotend.

Tips to get best results with All Metal Hotend:

- Reduce retraction amount. All Metal Hotend needs a lot less retraction. We had luck printing PLA with as little as 0.5mm retraction, without oozing. For PETG, try 1.0mm retraction.
- For PLA, you might need to increase extruder temperature 10-15 degrees.

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