INSTRUCTIONS ON USE
DIANOZ 3D PRINTER NOZZLE

GENERAL INSTRUCTIONS

- store nozzle carefully after use
- avoid contact with hard surfaces
- carry out nozzle spacing and levelling as usual
- avoid contact between nozzle tip and print bed surface
- clean the outside of the nozzle with a brass brush while it is heated up

ASSEMBLY

- screw the nozzle into the cold system by hand
- heat up the heating system and wait two minutes
- tighten nozzle with appropriate tool (recommendation: use socket wrench)

IMPORTANT: Do not exceed tightening torque of 1 Nm! The nozzle must be screwed against the heatbreak and must not lie flat on the heating block (see manufacturer's specifications).

TIP: Assemble silicone sock for more stable heating system temperature. Carry out PID tuning of the heating system according to the manufacturer's information.

DISASSEMBLY

- unload filament
- heat up the heating system and wait two minutes
- release nozzle with appropriate tool (recommendation: use socket wrench)
- switch off the heating system and

TIP: When unloading, perform cold pull with a light filament until the filament comes out without residue (no contamination or mixing of materials).

CLOGGING

Recommended sequence for nozzle system clogging:

- increase pressure temperature gradually and extrude material
- if unsuccessful: perform cold pull with light filament until filament is removed without residue
- if unsuccessful: heat up heating system and carefully remove with suitable cleaning needle filament residues in the duct, avoiding lateral forces in the outlet opening

TIP: For filled filaments, follow the manufacturers geometry recommendation and use a larger exit diameter if necessary.

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