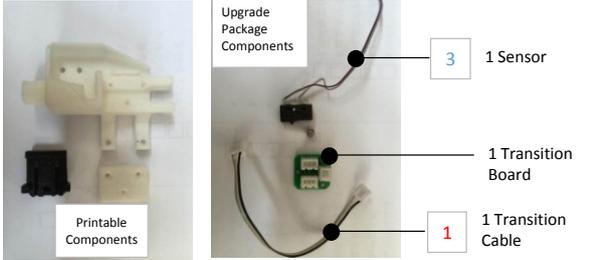
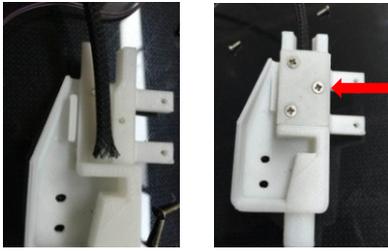
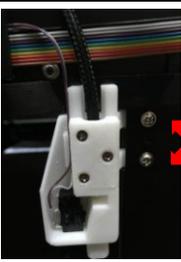
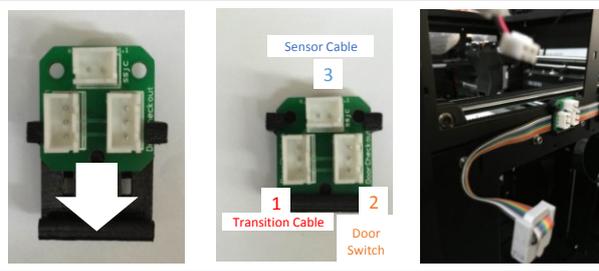
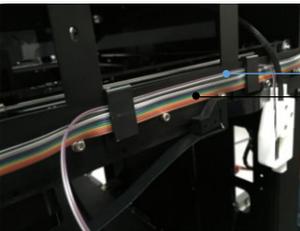
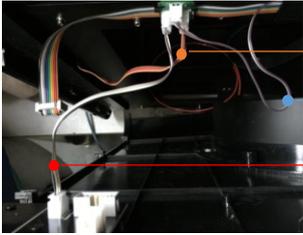
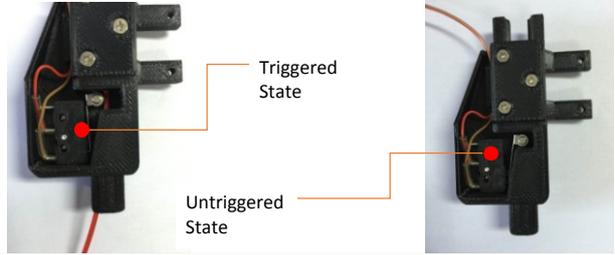


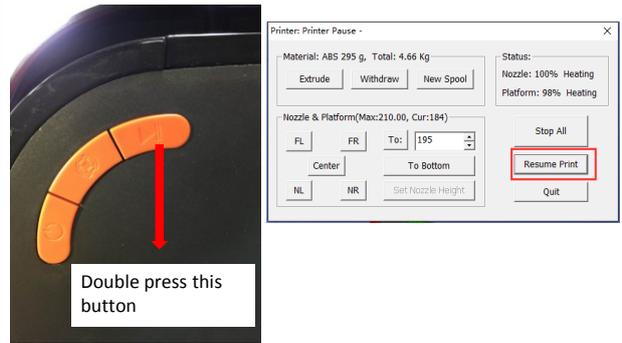
Feeding Tube Upgrade Manual

<p>Upgrade Kit</p>	<p>Check the components included in the upgrade package, print the model(as shown in the picture). The file name for the model is "XXXXX_MERGE"</p>	
	<p>Unscrew all 8 Allen screws from the back of the UP BOX and remove the cover;</p>	
<p>1</p>	<p>For removing the side cover, unscrew all 3 Allen screws at the rear, 3 Allen screws and 1 Philips screw under the side cover.</p>	
	<p>Remove the 3 clips(as shown in the pic) from the metal sheet on the right side of the printer;</p>	
<p>2</p>	<p>As shown in the picture, remove the old filament feeding mechanism;</p>	
<p>3</p>	<p>Cut off 50mm from one end of the filament tube, as shown in the picture;</p>	

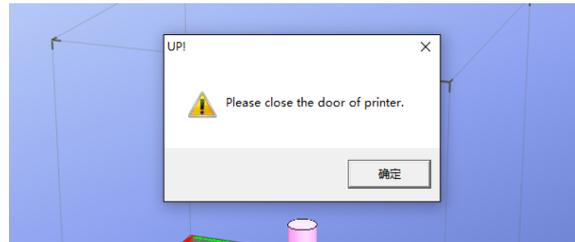
	<p>①Take the upgrade package components and the printed model;</p>	
4	<p>②Place the recently cut end of the filament tube into the printed model as shown in the picture. Place the cover on top and tighten the screws(M2.5 x 12mm);</p>	 <p>M2.5×12mm Screws</p>
	<p>③Place the filament detection switch into the printed model and insert the 2 screws(M2.6 x 8mm self drilling screws) from the back of the model to hold the detection switch in place. Make sure that the sensor works when the filament goes through the hole. Pass the wire through the gap, as shown in the picture;</p>	
5	<p>Attach the printed model(shown in pic) to the metal frame;</p>	 <p>M3×6 Phillips Self Drilling Screws</p>
6	<p>Insert the transition board in the printed part and clip it to the printer's metal frame over the rainbow ribbon cable, as shown in the picture;</p>	 <p>Sensor Cable 3 1 2 Transition Cable Door Switch</p>
	<p>Re-insert the 3 clips that you removed earlier and make sure that the sensor cable and the ribbon cable are firmly held in place;</p>	 <p>3 Sensor Cable Button Rainbow</p>

7	<p>Attach the wires to the corresponding sockets, connecting the transition board and the Button Board. [2] Door switch cable, [3] Sensor cable and [1] the transition cable(connecting the transition board with the button board);</p>	 <p>2 Door Switch Cable 3 Sensor Cable 1 Transition Cable</p>
	<p>Check and confirm that all components are installed properly. Passing a piece of filament through the feeding tube should trigger the sensor(as shown in pic). When triggered, you can hear a clicking sound from the sensor;</p>	 <p>Triggered State Untriggered State</p>
8	<p>As shown in picture, double press the "re-print last job" button on the operation button board. After the printer has started printing, cut the supply of filament to the tube to check if the sensor is working. As the sensor detects that there is no filament is being fed, it should pause the printing process. If not, please recheck the installation steps.</p>	 <p>Double press this button</p>
	<p>While paused, insert the filament into the tube and double press the "Pause/Resume" button. If the printer doesn't resume, please recheck the installation steps and make sure that all components are installed according to this manual.</p>	 <p>Double press this button</p>
9	<p>Install the side cover back on to the printer, using the same screws that were taken off previously.</p> <p>Re-install the back cover of the printer using the 8 Allen screws.</p>	 

Usage: The upgraded feeding tube will make sure that your prints don't get wasted due to an empty spool or filament breakage during printing. In case of filament breakage or an empty filament spool, the sensor will send a "Pause" command to the printer, which will pause (with a beep sound) the current print and prevent air printing. You will have to double press the Pause/Resume button on the side of the printer or by clicking "Resume Print" from the Maintenance window to resume the printer.



Error Notification: If there is no filament in the feeding tube when starting a new print, the UP 2.17 and 2.18 software versions will display an error notification stating that the door needs to be closed. The same error will also be displayed when the door is open. When this error notification is displayed, please check the filament and the door of the printer. If there is no filament, install the filament and then resume the print.



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Thank you very much for upgrading your UP BOX!
 If you face any difficulty or have need any technical assistance, please feel free to contact our Technical Support Team.
 Email: support@pp3dp.com