

Heat-Breaker Glogging Repair

PAN, Sept 27, 2022

Problem: Small particles at the top of the heat-breaker, provokes clogging of the filament transport even with clean or new nozzle.

Reason: During filament transport, the extruder drive wheel cuts-off tiny particles off from the filament.

After prolonged use too much such particles enters into the top of the heat-breaker.

The heat-breaker gets clogged, no sufficient filament extraction possible!

Note: this is not Nozzle problem! Nozzle cleaning does not help!

Solution:

1. Remover the nozzle during extruder heated .
2. Tray to clean the heat-breaker with a D2-Driller.
3. This is not enough: still some particles at the top!
4. Apply a D2-reamer and you will note additional particles coming out!
5. For perfect cleaning lubricate a conic pipe cleaner with Acetone and polish the inside of the heat breaker many times. If you note particles on the pipe cleaner: continue!
6. Use a new conic pipe cleaner lubricated with Alcohol for removing Acetone layers. Remaining Acetone could contaminate the next filament PLA or ABS!

Now you may continue your printing work with well cleaned nozzles!

7. In severe case you need to disassembly the heat-breaker from the cooler, using a S1.5. Socket wrench. Clean the heat-breaker as shown above and check it
Apply thermal conductive paste on the heat breaker and mount it back to the cooler, respecting the about 1.5 mm distance between heat breaker and cooler.

Good luck!

Peter

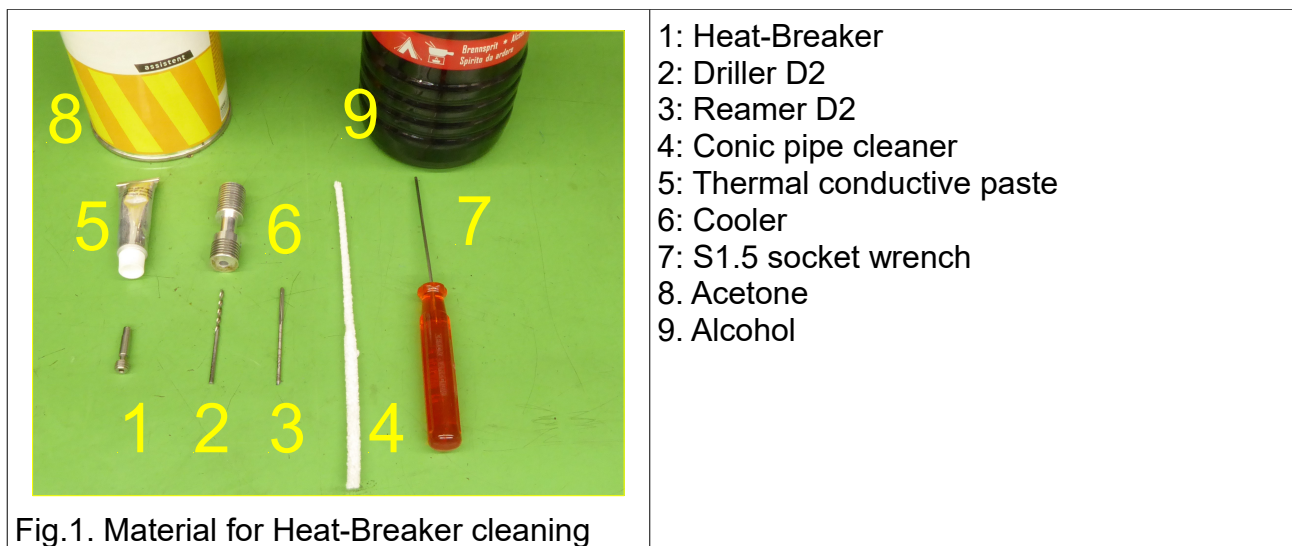


Fig.1. Material for Heat-Breaker cleaning