

CG-1 Glue Purge

Tools Needed:

- 10-15cm of 6mm diameter PVC pipe.
- Waste Glue Container (preferably with cc or ml indication)

There are a number of scenarios in which a glue purge may help restore a poorly functioning printer.

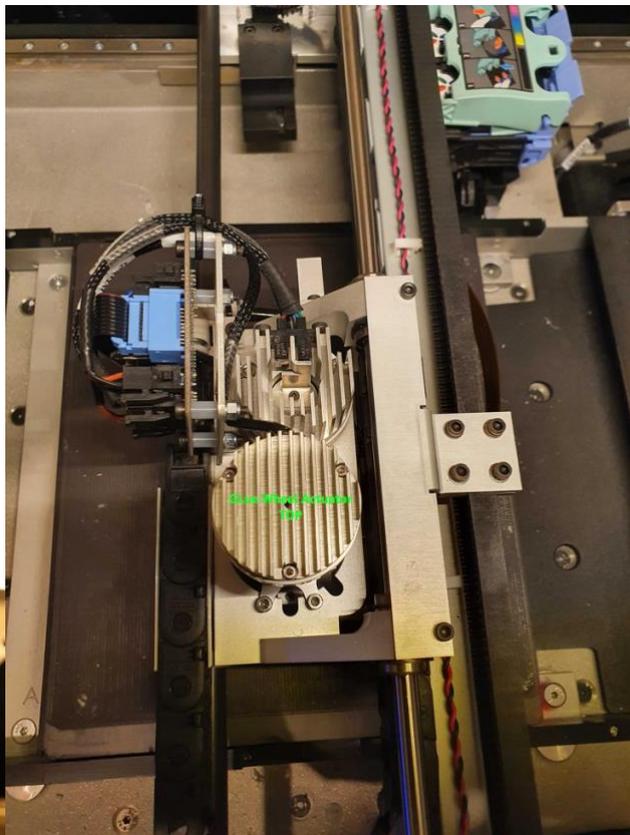
1. If the system has been shipped by air pressurisation and/or thermal cycling of the system while in transit can impair the glue performance.
2. The longer a system is stored without use the more likely it is that you'll encounter a glue system that has blockages or glue that is out of date.
3. Glue has a shelf life unopened of 1 year and should be used within 6 months of opening for best performance. You may need to replace out of date glue.

Simple checks for a good glue system.

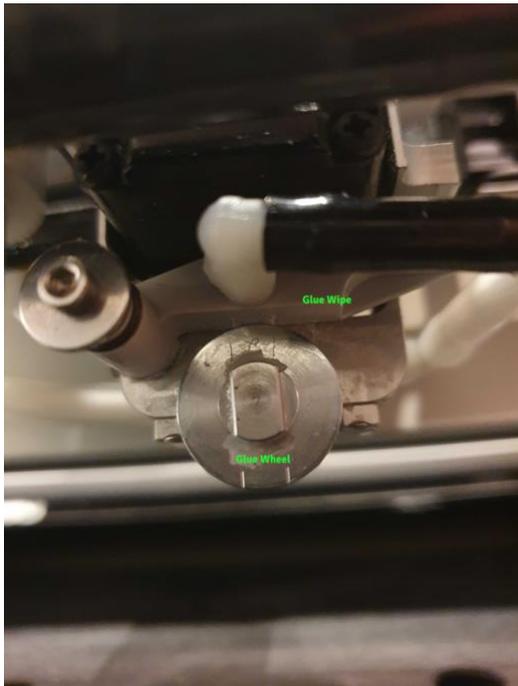
- Check for glue pressure by opening the glue bottle top (pic 1) on a powered on machine paused at the job start check knife , glue dialogue or a paused during a job. You will hear the glue pressure pump running continuously to try to achieve the set pressure. Once you screw the top tight again this motor will slow its pace as the set pressure is reached.
- If the glue pump is working ok, lift the grey plastic wipe (pic 3) off the top of the glue wheel and check for a small amount of glue coating the top of the wheel.



Pic 1 Glue Bottle Top



Pic 2 Top of Glue Wheel System.

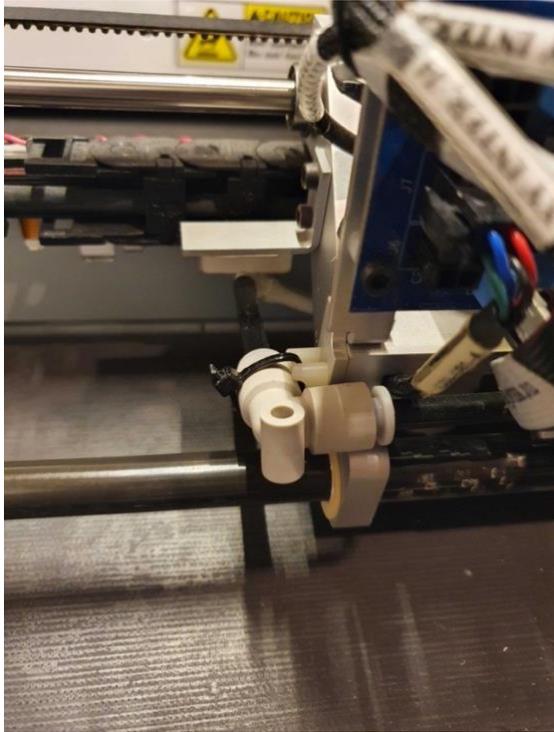


Pic 3 Glue Wheel and Wipe. (Bottom of glue wheel system)

Purge Procedure.

1. Using the setup / build plate menu drop the bed to about halfway to its lowest position.
2. Detach the glue pipe from the quick release fitting at the rearward side of the X-Y gantry (pic 3) and seal it with masking tape on the wipe side.
3. Place the waste glue container on the build table, connect the purge tube to the supply side and run it onto the container. (pic 4)
4. Close the printer door.
5. Start Orange on a computer that's on the same network as your printer. Connect to the printer and select the 3D Printers / Service Setup.
6. In Orange select "Request Service Setup"
7. When the machine has entered Service Setup Mode select "Adjust Set Glue Pressure"
8. Select Run Test. This will set the glue pump on.
9. Record the Set pressure of the machine. You'll need this later if you change the pressure for the purge.
10. Leave the machine until you have reached the min level on the glue bottle.
11. Top up the glue to the maximum level.
12. Repeat 10 and 11 until you have collected at least 120=150ml of glue in your container.
13. Open the glue bottle to relieve the pressure and remove the purge tube and replace the wipe-side tube you removed in 2.
14. Run a short job like Align Image to make sure you have glue flow and can build a model.

Pic 3 Quick release fitting before detachment.



Pic 4 Ready for glue purge.

