



Removing the Extrusion Screw

Tools required

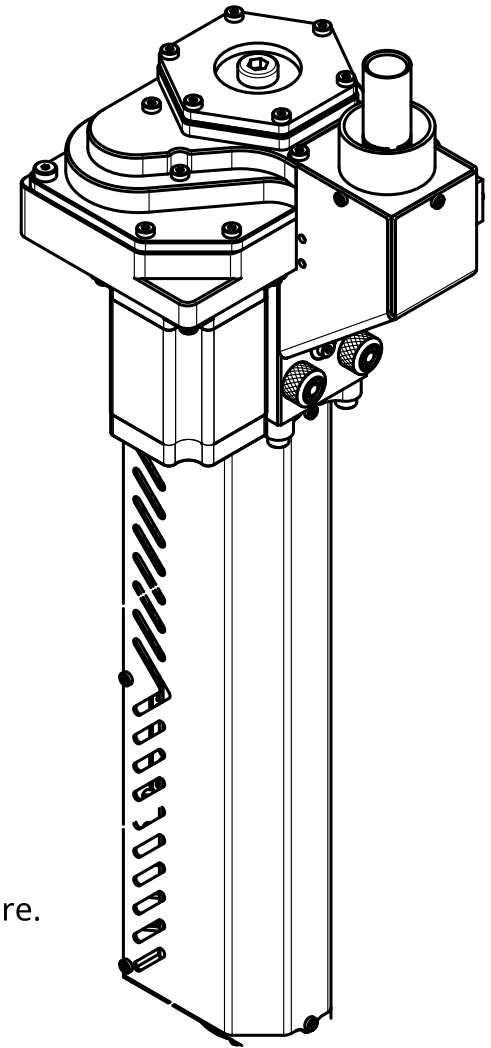
- 2.5 mm Allen key
- 3 mm Allen key
- 7 mm Allen Key
- 16 mm Wrench
- Furnace gloves

Disclaimer :

- Purge the Extruder with low temperature resin before proceeding with the following
- This procedure must be performed hot. Take necessary precautions not to burn yourself.
- Take the time to read this procedure and learn the steps ahead of performing the procedure.
- Proceed with caution. In depth knowledge of the Extruder and this procedure is required

Procedure

1. Empty the Hopper & Barrel
2. Cut the power and unplug the connectors
3. Remove the Hopper
4. Remove the Heatcore.
5. Remove the Extrusion Screw



The information contained in this drawing is the sole property of Dyze Design. Any reproduction in part or in whole without the written permission of Dyze Design is prohibited.



Product Name

Removing Extrusion Screw

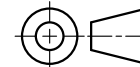
SIZE

A

UNITS

MM

THIRD ANGLE PROJECTION



SCALE

1:3

SHEET

1 of 6

DATE

2022-03-23

Drawing Number:

CSDT V005

STEP 1 : Empty the Hopper & the Barrel

Tools required :

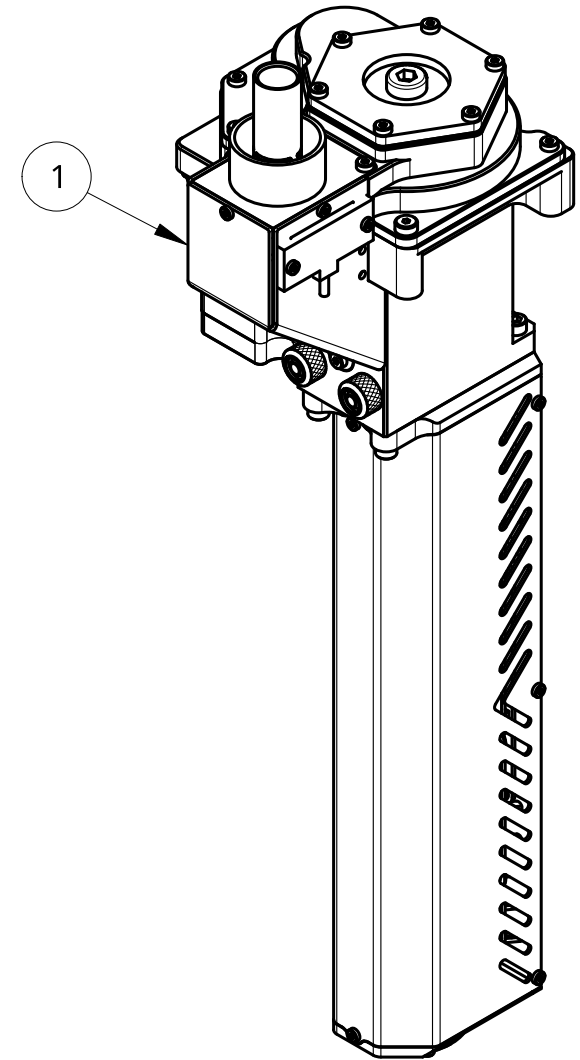
- None

Procedure :

1. Cut the material feeding
2. Empty the Hopper [1] & Recycle the unprocessed pellets
3. Heat the Heatcore to the material processing temperature
4. Empty the Barrel as much as possible using the extrusion command
5. Leave the Heatcore to the material processing temperature

WARNING

- Do not go above the safe melt temperature of your material
- Some manipulation performed will demand you manipulate Extremely hot parts. Take all the appropriate safety precautions. The use of furnace pliers and gloves is recommended



No	Description
1	Hopper

The information contained in this drawing is the sole property of Dyze Design. Any reproduction in part or in whole without the written permission of Dyze Design is prohibited.



Product Name

Removing Extrusion Screw

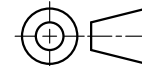
SIZE

A

UNITS

MM

THIRD ANGLE PROJECTION



SCALE

1:3

SHEET

2 of 6

DATE

2022-03-23

Drawing Number:

CSDT V005

STEP 2 : Cut the power and unplug the connectors

Tools required :

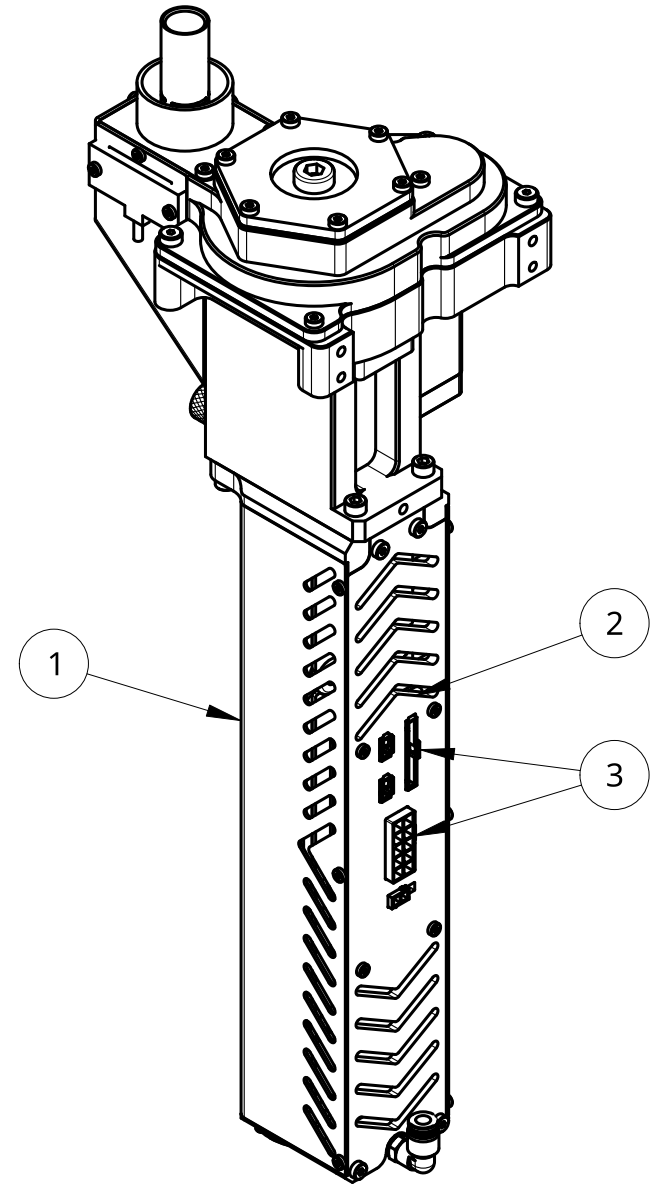
- None

Procedure :

1. Leave the heaters at their setpoint
2. Cut the Main Power of the 3D Printer or Robotic arm
3. Unplug all the Connectors[3] on the Back Plate[2]

WARNING

- Although without sensor readings, The Heatcore Shield[1] remains extremely hot.
- To prevent Electric Shock Risk, unplug and lock the main Power to your machine



No	Description
1	Shield
2	Backplate
3	Connectors

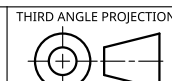
The information contained in this drawing is the sole property of Dyze Design. Any reproduction in part or in whole without the written permission of Dyze Design is prohibited.



Product Name
Removing Extrusion Screw

SIZE
A

UNITS
MM



SCALE
1:3

SHEET
3 of 6

DATE
2022-03-23

Drawing Number:

CSDT V005

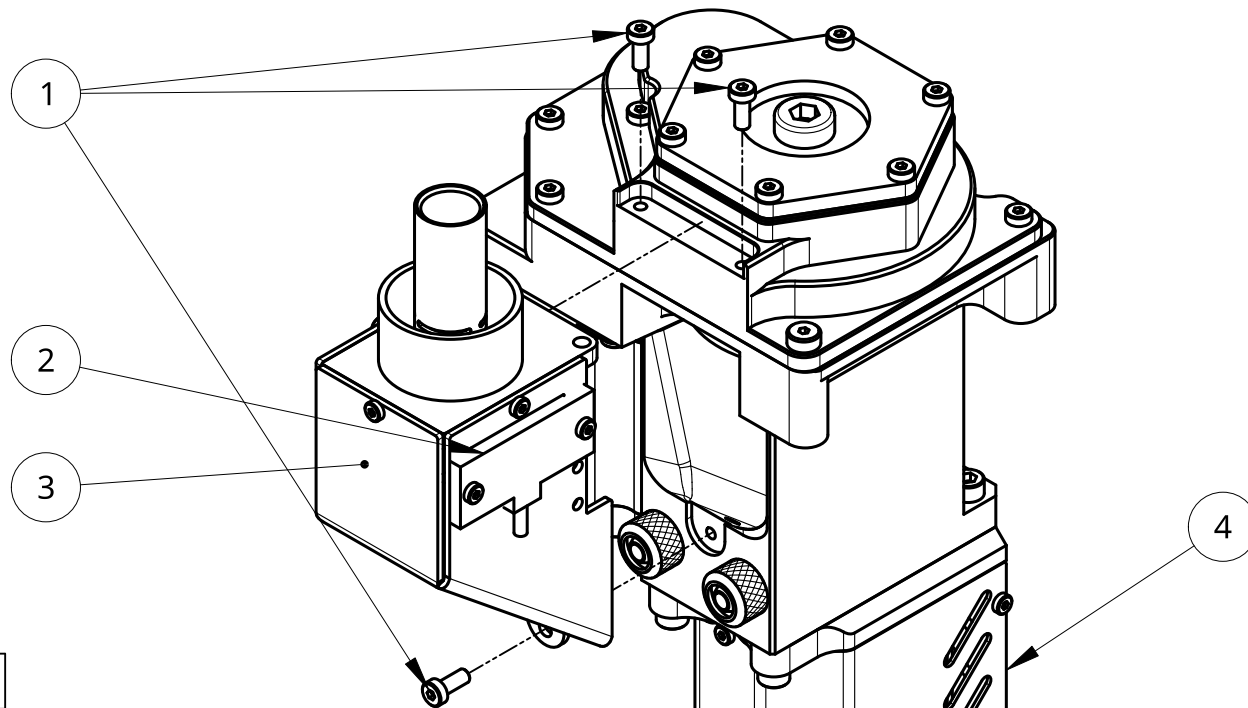
STEP 3 : Remove the Hopper

Tools required :

- 2.5 mm Allen Key

Procedure :

1. Unscrew the M04 screws[1]
2. Disconnect the Proximity sensor[2] from the Back Plate[4]
3. Pull The Hopper[3] & Set Aside
4. Remove any unprocessed Pellets



No	Description
1	M04 Screws
2	Proximity Sensor
3	Hopper
4	Back Plate

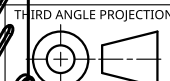
The information contained in this drawing is the sole property of Dyze Design. Any reproduction in part or in whole without the written permission of Dyze Design is prohibited.



Product Name
Removing Extrusion Screw

SIZE
A

UNITS
MM



SCALE
1:2

SHEET
4 of 6

DATE
2022-03-23

Drawing Number:

CSDT V005

STEP 4 : Remove the Heatcore

Tools required :

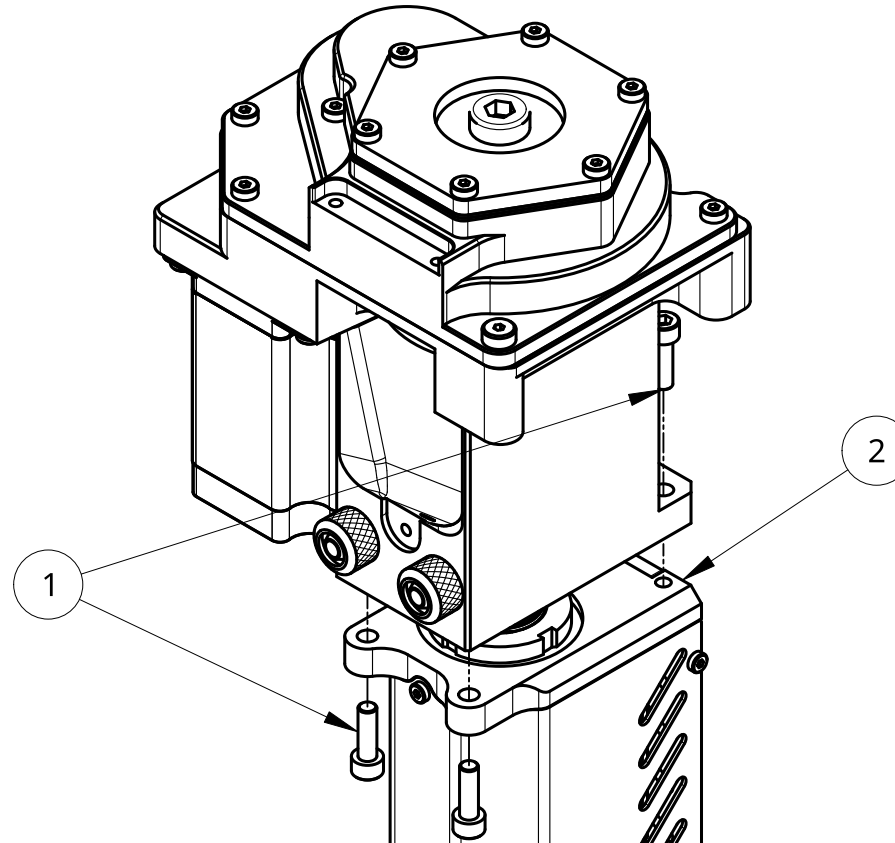
- 3 mm Allen Key
- Furnace Gloves
- 350 mm clearance below the nozzle tip

Procedure :

1. Unscrew the M05 screws[1]
2. Slowly pull the Heatcore[2] & Set aside, leaving the Extrusion Screw exposed.

Warning :

- Hot parts needs to be manipulated. Molten plastic while be exposed. Work with PPE.
- Prepare a safe and stable space to deposit the Heatcore to cool.



No	Description
1	M05 Screws
2	Heatcore

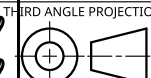
The information contained in this drawing is the sole property of Dyze Design. Any reproduction in part or in whole without the written permission of Dyze Design is prohibited.



Product Name
Removing Extrusion Screw

SIZE
A

UNITS
MM



SCALE
1:2

SHEET
5 of 6

DATE
2022-03-23

Drawing Number:

CSDT V005

STEP 5 : Remove Extrusion Screw

Tools required :

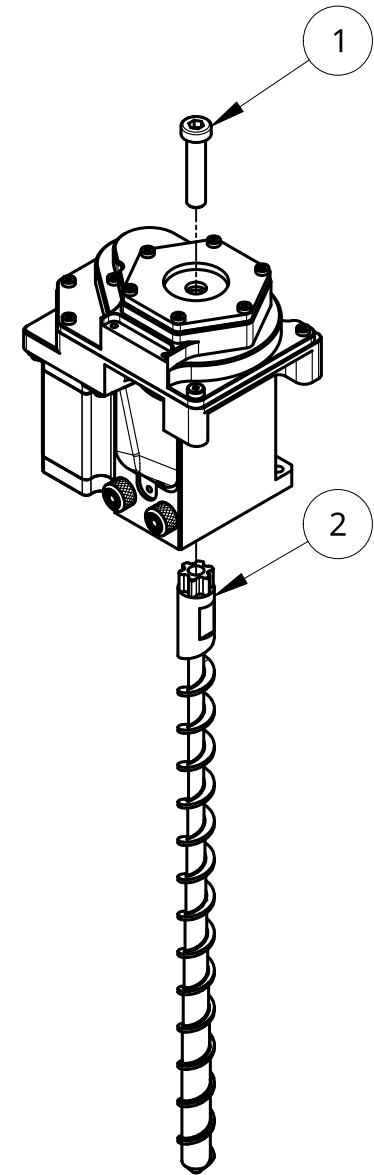
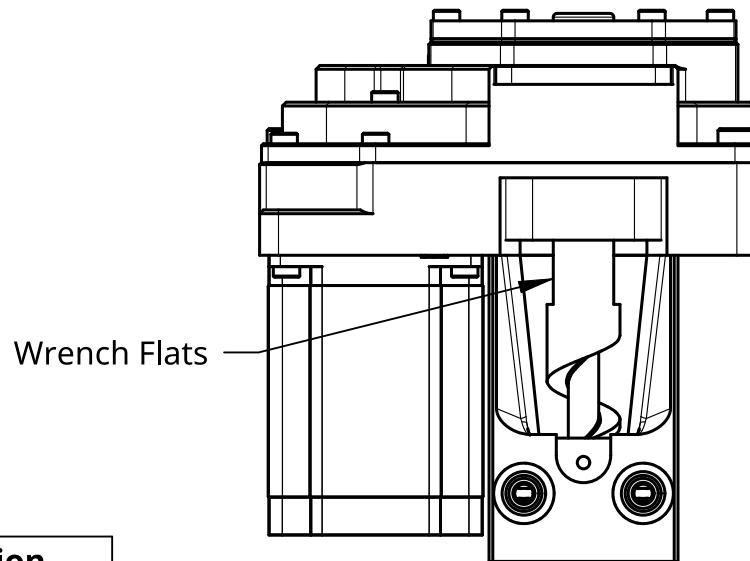
- 7 mm Allen Key
- Furnace Gloves
- 16 mm Wrench

Procedure :

1. Using the 7 mm Allen Key, turn the Extrusion Screw[1] to access the flats for the wrench
2. Secure the Wrench on the flats
3. Unscrew the M10 Screw[2] with the 7 mm Allen Key
4. Pull the Extrusion Screw[1] out & Set aside

Warning :

- Hot parts needs to be manipulated. Molten plastic while be exposed. Work with PPE.
- Prepare a safe and stable space to deposit the Extrusion Screw to cool.



No	Description
1	M10 Screw
2	Extrusion Screw

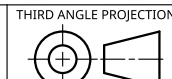
The information contained in this drawing is the sole property of Dyze Design. Any reproduction in part or in whole without the written permission of Dyze Design is prohibited.



Product Name
Removing Extrusion Screw

SIZE
A

UNITS
MM



SCALE
1:2

SHEET
6 of 6

DATE
2022-03-23

Drawing Number:

CSDT V005