

# Frequently Asked Questions

Desktop Filament Extruder E1.5 by ARTME 3D

Version 21.06.21

## Filament FAQ:

Problem:	Reason and possible solutions:
The surface of the filament is not smooth	a) Increase the temperature a little (in 2 ° C steps) b) hang a small weight on the sensor c) Material too damp (dry beforehand)
Bubbles in the filament	a) Lower the temperature a little (in 2 ° C steps) b) Speed a little lower or higher c) Material too damp (dry beforehand)
Filament turns gray	a) The extruder screw rubs against the extruder tube (realign the screw, realign the mounting bracket, see assembly instructions) b) Temperature clearly too low c) Material cannot be processed

## Extruder Motor FAQ:

Problem:	Reason and possible solutions:
Motor stops / loses steps	a) Temperature too low b) Clean or replace the filter c) Speed too high d) unsuitable material e) Motor current too low f) The extruder screw is tilted or installed incorrectly
Motor turns in the wrong direction	a) Connection according to plan in documentation

# Display/Arduino FAQ:

Problem:	Reason and possible solutions:
The display shows only two lines with bars	a) Pin on the ramp board bent, display adapter not properly connected.
The display restarts when it heats up	a) Check whether the electronics fan is running. b) transistor at D10 of the ramp board too weak (= use external mosfet)
The display no longer shows anything during operation.	a) Press the rotary button on the display once
Display only blue without characters	a) Set the potentiometer for contrast on the back of the display

# Aufwicklung FAQ:

Problem:	Reason and possible solutions:
Windermotor stops	a) Motor current too low ( $V_{rev}$ for TMC2208 = 0.8V) b) Filament too thick (does not fit through PTFE tube) c) Filament spool is spinning (pull wing nut wester)
Unclean winding	a) Filament too thin (too little braking effect in PTFE hose) b) Bottle gear ratio (choose a different puscher with a different number of teeth) c) Time of the change of direction of the filament lead. (Move the filament guide a little) d) Wrong filament spool dimensions
Winder squeaks	a) Grease the area between the roll holder and the mounting bracket of the winding motor.