

Fortus® 360/380/400/450mc Cleaning Purge Filament Procedure

Step-by-step procedure on using Purge Filament in model and support tips:

- Unload material(s) from whichever tip(s) you are using the purge filament in (model and/or support) by selecting, **Operator Controls→Load/Unload Material→Unload Material**. Wait for material to unload from the tips.
- Remove canisters after material is unloaded.
- Open hood and remove Model and/or Support Feed Tube from head.
- On main screen, select **Operator Controls→Load/Unload Material→Unplug Tips**. This will activate rocker switches on top of head.
- On Rocker Switches select **Load** for Model and/or Support Material. Wait for tip(s) to reach purge temperature(s).
- Once temperatures are reached, manually feed the Purge Filament into Model and/or Support Tip and hold down Material Rocker Switch to **Load**.
- Material will begin to purge from Tip(s). Continue to purge until extrusion is similar color to the Purge Filament (Approx. 12 inches of Purge Filament is necessary)
- Once tips clean press **Unload** on Material Rocker Switch and remove Purge Filament, reconnect Feed Tube(s).
- Once completed, reload both Model and Support Materials and manually calibrate Tips as the Tip Offset Values may need adjusting.

We recommend you use Purge filament to de-carbonize tips & melt tubes every 300cu in.

Combined with our tip cover rehabilitation process results in 2 to 3x tip life.

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