



TM

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3D SYSTEMS University

Cube 3D Printer

“Lesson – Troubleshooting Printing Quality”

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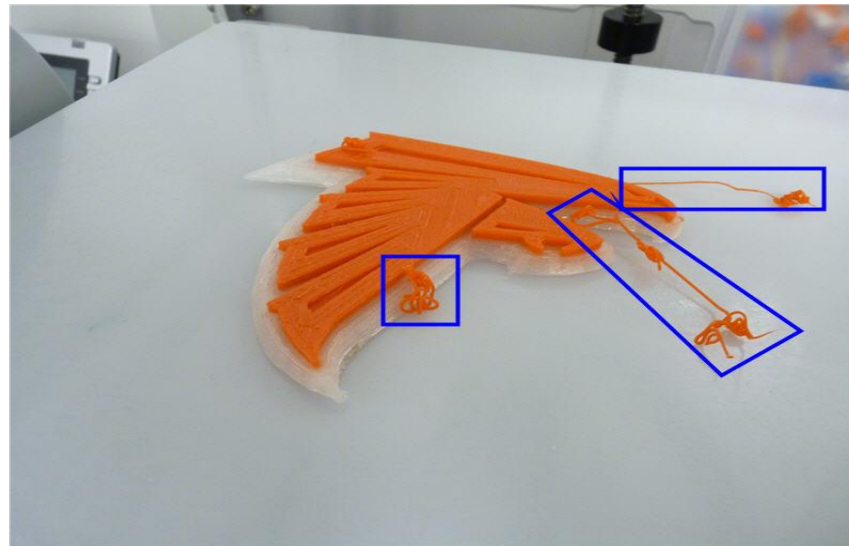
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Filament Balls in Multi Color Print

Symptom	Test	Cause	Solution
Filament balls in multi color print	None	Badly adjusted print jet wipe	Please see course 3.4- setting up the print tip wiping system



Poor Wall Quality

Symptom	Test	Cause	Solution	Notes
Poor wall quality	None	Loose print tip	Tighten clamp torx screw. Please see lesson 3.2 how to replace a print tip (the last slide will show you the location of this bolt)	If the print tip is loose, it will wobble during the print, causing flaws in smooth surfaces.
		Loose Print Pad	Adjust white stabilizer bar at the front of the aluminum print bed to improve fit of the Print Pad.	If the Print Pad shifts during a print, flaws can appear in the print.

Shift in Multi Color Prints

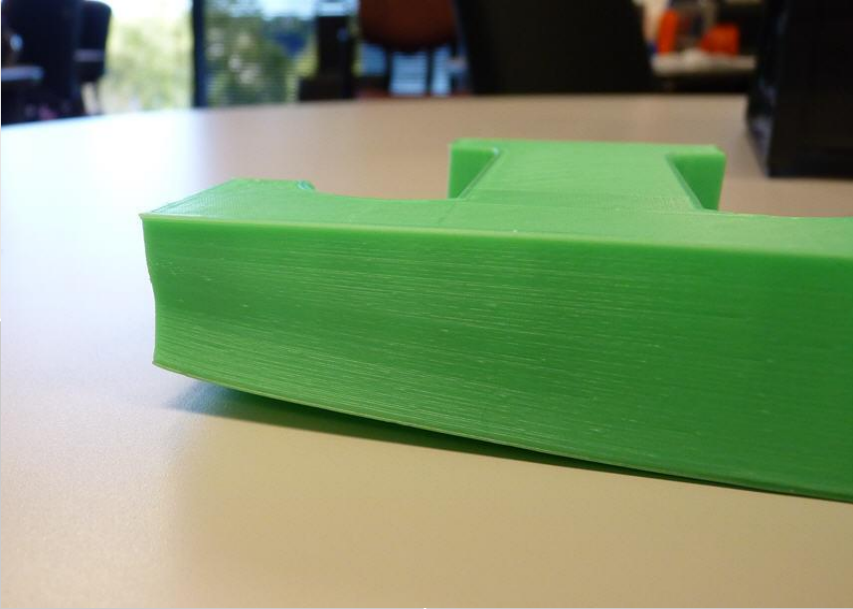
Symptom	Test	Cause	Solution
Shift in multi color prints	None	Incorrect print jet offsets	Print Calibration file and adjust offsets. (see course 1.11 for detailed instructions)



Print Jet Hits Model While other Jet is Printing

Symptom	Test	Cause	Solution
Inactive Print Tip hits model while another jet is printing	None	Print jet Z alignment is incorrect	Level Print Tips in Z axis. (Please refer to lesson 1.8 for leveling the print tips)

Print is Warping in Areas

Symptom	Test	Cause	Solution
Warping issues during print	None	Poor glue application	Use 3 small layers of glue and allow 30 seconds for the glue to get tacky
		Insufficient surface contact	Add the raft option the Cube X software to help keep the part attached to the build tray.
		Unleveled print pad	Level the print pad if certain corners warp every time

Sagging Material on Print

Symptom	Test	Cause	Solution
Sagging material on print	None	Unsupported overhanging geometry	Add supports to the build or re-orient the geometry to minimize the problem areas

