

Pro3 Series-How to Replace the Auto-Leveling Assembly

Tools:

- ① 2mm hex wrench
- ② 1.5mm hex wrench



1. Make sure the filaments are unloaded from both extruders. For how to unload filament, refer to the related tutorial [Pro3 Series-How to Load and Unload the Filament-V1.0](#) in the Support Center.
2. Lower the build plate to a height suitable for operation, and move the extruders to the center position.
 - 1) Enter the “Utilities” page and select “Disable Motor”. Now you can move the extruder freely. Move the extruder to the center position to facilitate subsequent operations.



Figure 1 Disable the motor and move the extruders to the center position.

2) Select the Z-axis, select the up and down arrows to adjust the build plate to a position suitable for operation.

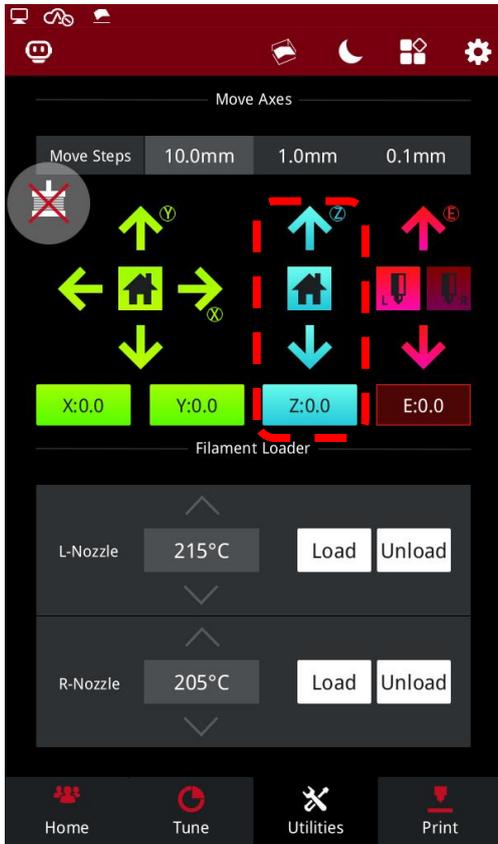


Figure 2 Adjust the build plate to a position suitable for operation.

3. Turn off the printer and cut off the power.



Figure 3 Cut off the power.

4. Remove the left and right interchangeable hotend from the extruders.

1) Release the red buckle. Then use the handle to remove the interchangeable hotend from the extruders.

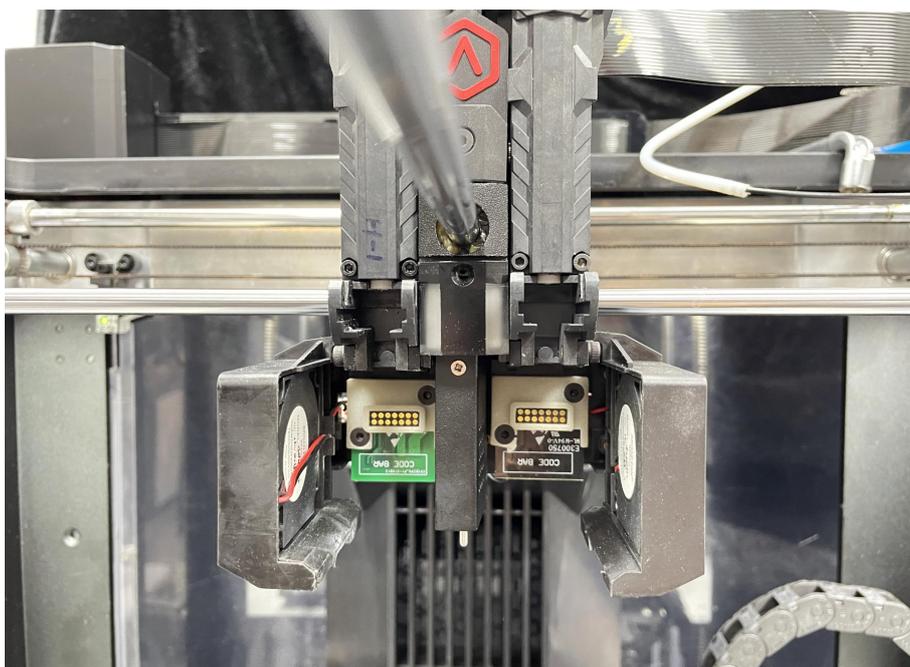
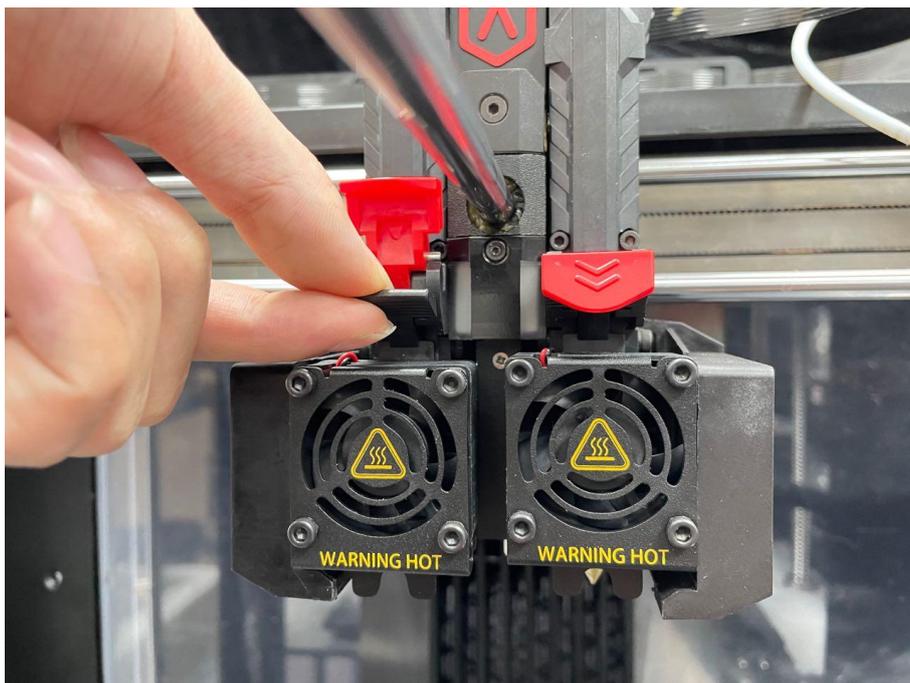


Figure 4 Remove the left and right interchangeable hotend from the extruders.

5. Remove 1 securing screw on the light control board with a 1.5mm hex wrench. The control board is used to control the heating indicator light.

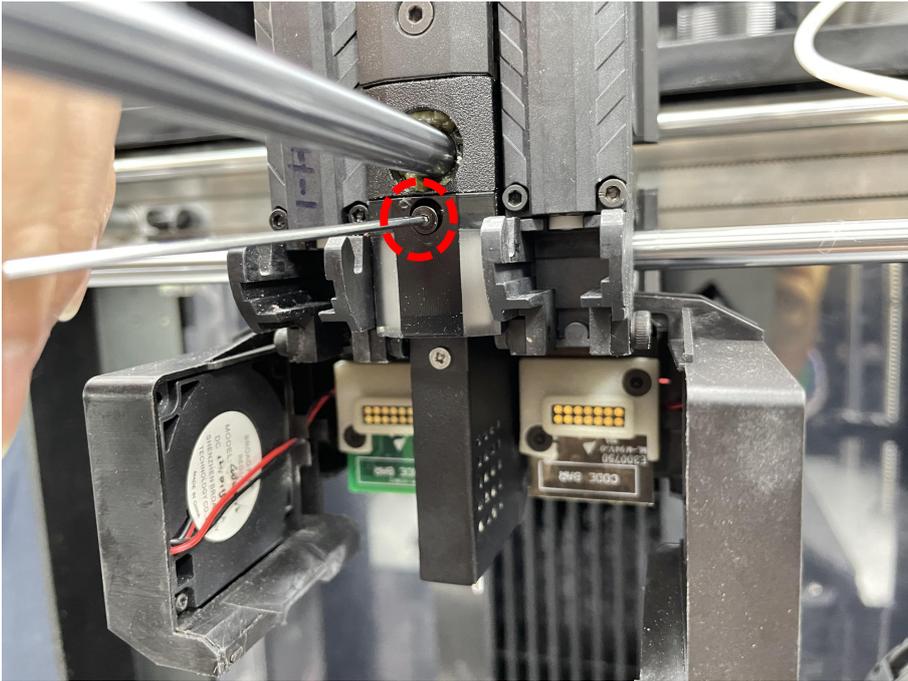


Figure 5 Remove 1 securing screw on the light control board.

6. Gently twist the light control board (as shown in the figure below), lift it about 10 degrees, and slowly pull out the light control board.

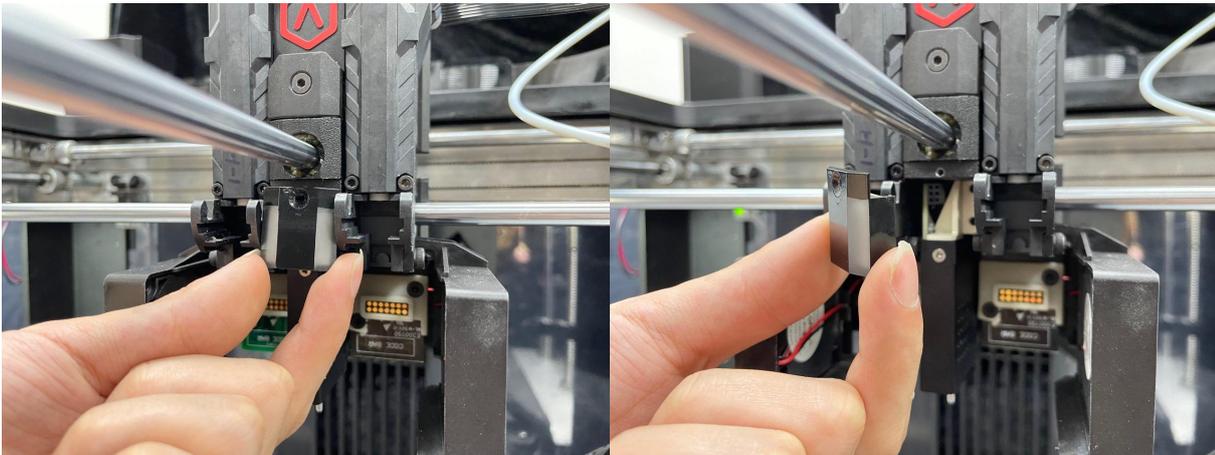


Figure 6 Gently twist and pull out the light control board.

Note: There are pins and chips on the light control board. Do not pull them out forcibly to avoid damaging the pins and chips.

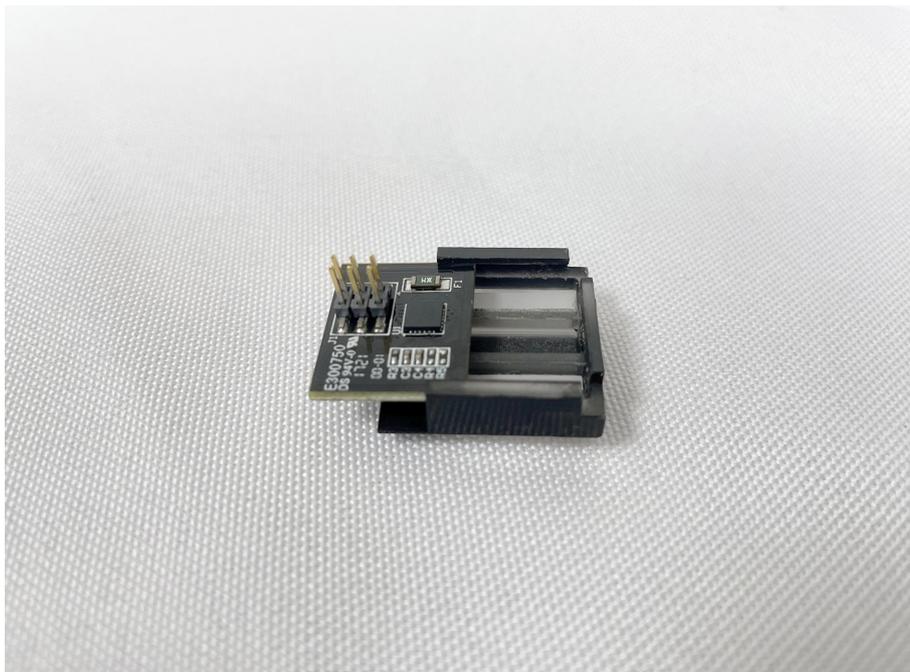


Figure 7 Take care of the chip and the pin.

7. Remove 2 securing screws on the auto-leveling assembly with a 2mm hex wrench.

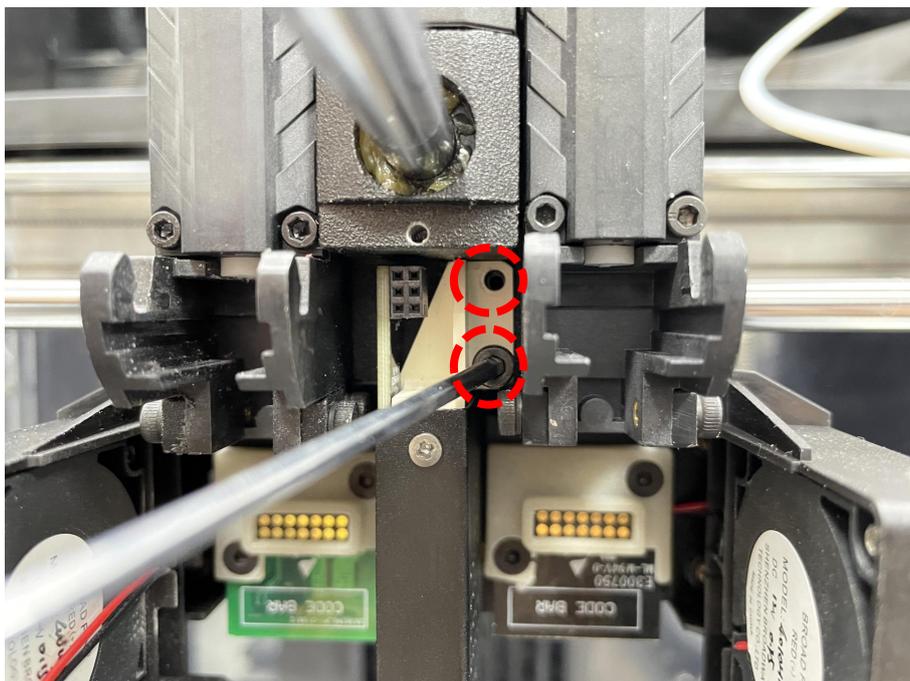


Figure 8 Remove 2 securing screws on the auto-leveling assembly.

8. Use a 2mm hex wrench to remove the 1 screw on the back of the auto-leveling assembly.

Note:

1. The screw is located under the back of the printer head.
2. If the screw cannot be unscrewed smoothly, you can remove the PCB cover of the printer head before proceeding.

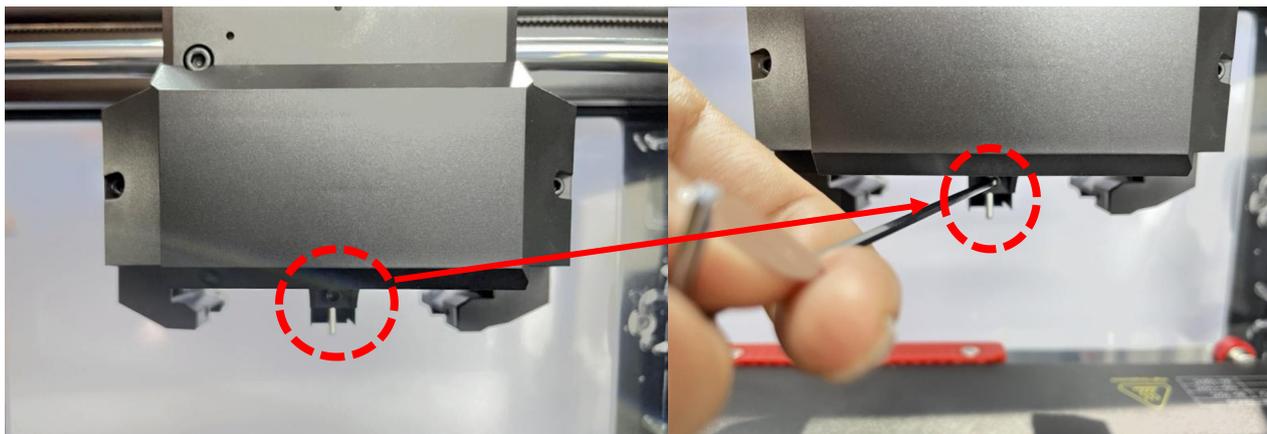


Figure 9 Remove the 1 screw on the back of the auto-leveling assembly.

9. Gently twist the auto-leveling assembly and unplug it from the extruder.

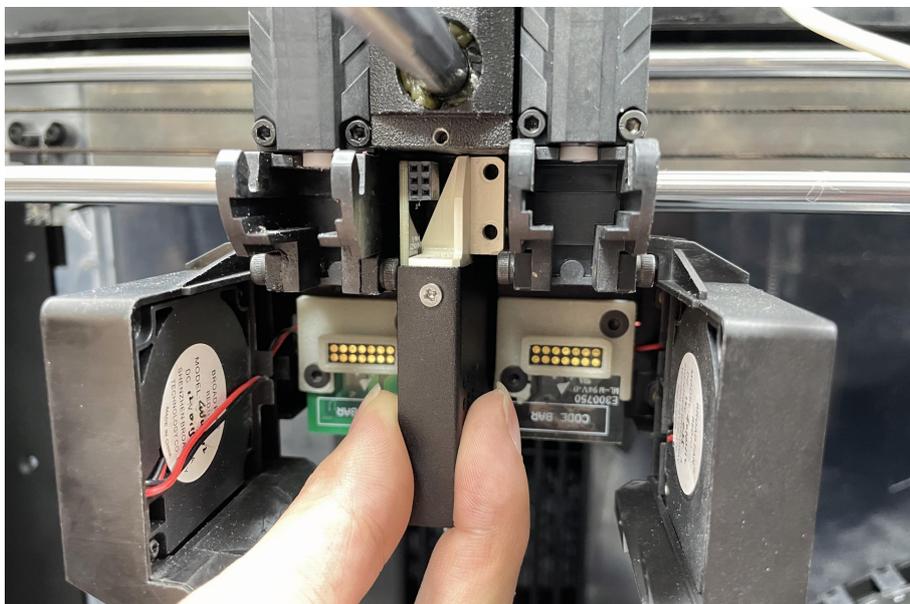


Figure 10 Unplug the auto-leveling assembly from the extruder.

10. Prepare a new auto-leveling assembly.

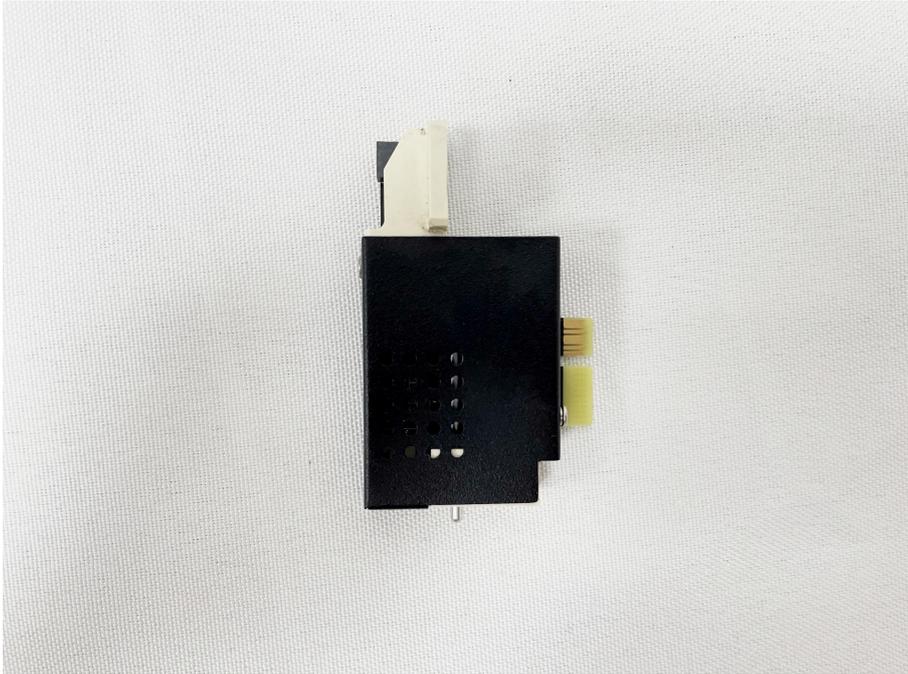


Figure 11 Prepare a new auto-leveling assembly.

11. Insert the auto-leveling assembly into the slot on the extruder. Make sure that each plug is aligned with the slot. Gently twist the auto-leveling assembly until the auto-leveling assembly is installed in place.

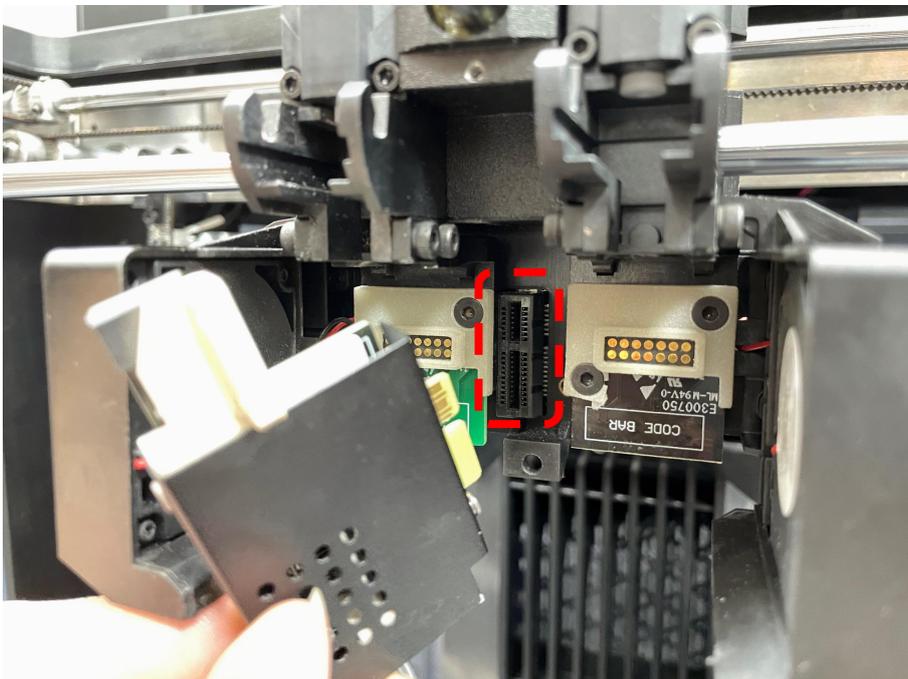


Figure 12 Insert the auto-leveling assembly into the slot.

12. Fix the 2 securing screws on the auto-leveling assembly with a 2mm hex wrench to fix the auto-leveling assembly in place.

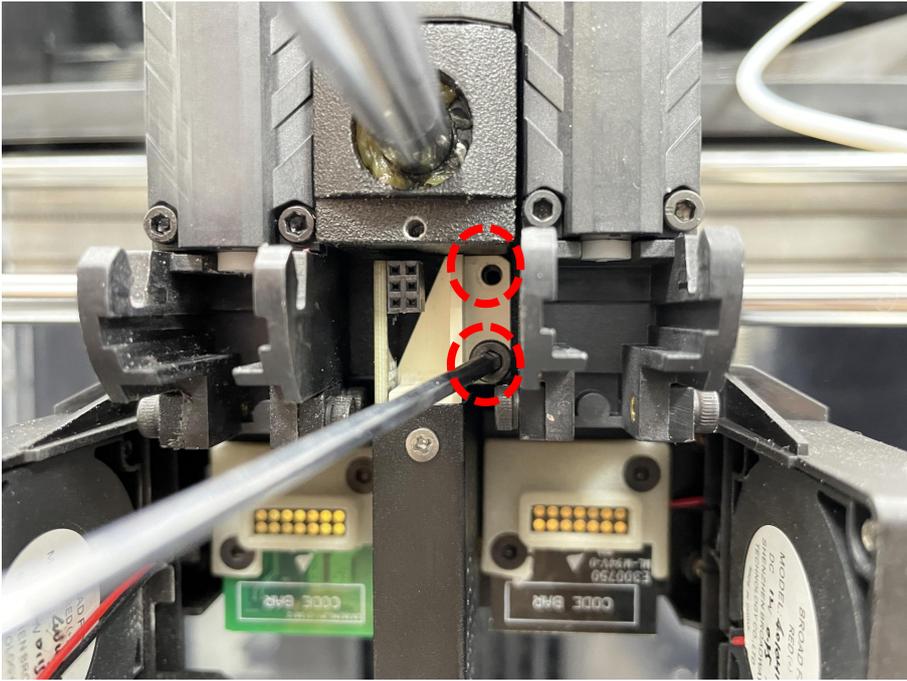
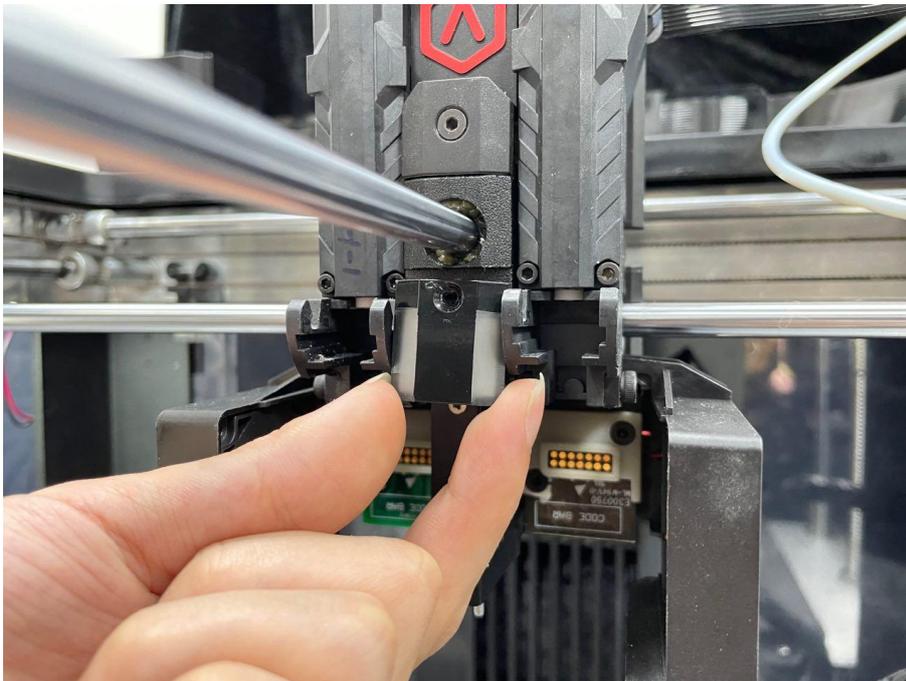


Figure 13 Fix the 2 securing screws on the auto-leveling assembly.

13. Insert the lighting control board into the slot, making sure that the pins of the lighting control board are aligned with the slot. Swing the light control board gently to install the light control board in



place.

Figure 14 Insert the lighting control board into the slot.

14. Install the securing screws on the light control board with a 1.5mm hex wrench in place.

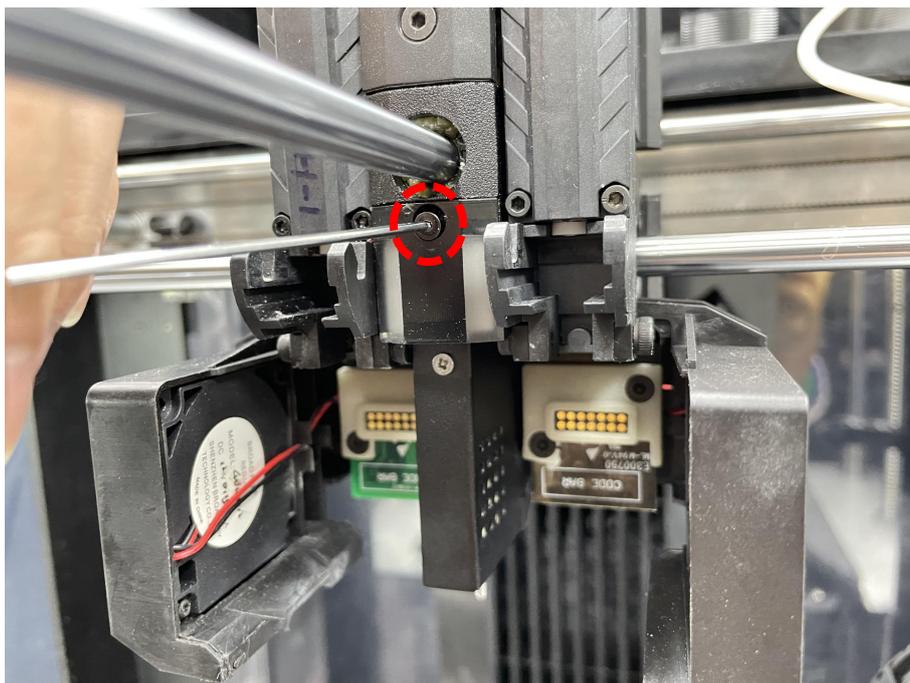


Figure 15 Install the securing screws on the light control board.

15. Reinstall the two interchangeable hotend on the extruder and close the red buckles. For how to install the interchangeable hotend, please refer to the related tutorial [Pro3 Series-How to replace the interchangeable hot end-V1.0](#) in the Support Center.

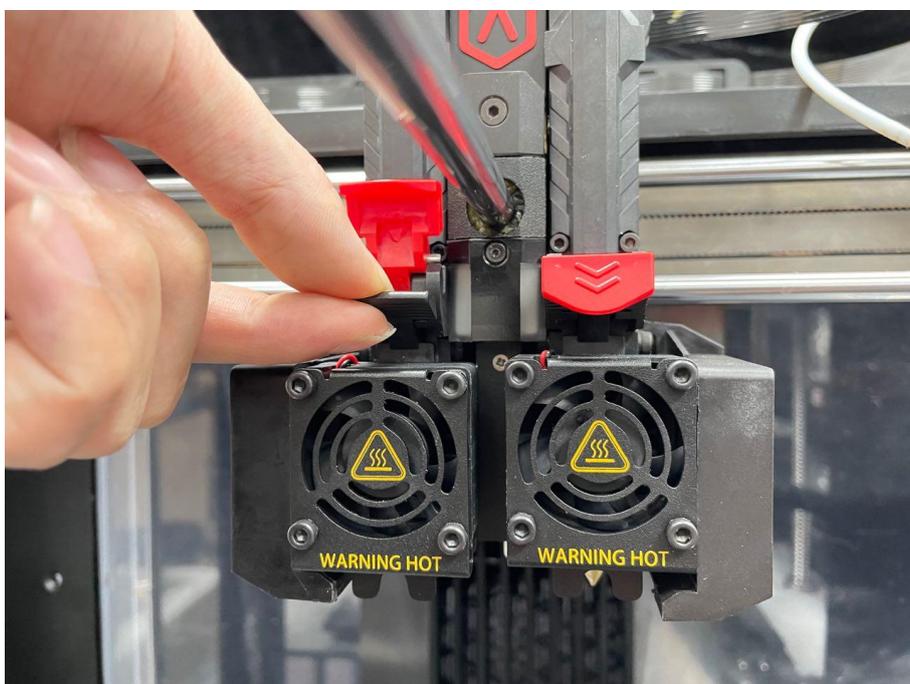


Figure 16 Reinstall the two interchangeable hotend on the extruder.

16. After replacing the new auto-leveling assembly, run the whole 5-step Offset Calibration.

- 1) Make sure that you have loaded 2 spools of Raise3D Premium PLA filaments into the printer and they can be extruded normally. For how to load the filament, please refer to the related tutorial [Pro3 Series-How to Load and Unload the Filament-V1.0](#) in the Support Center.

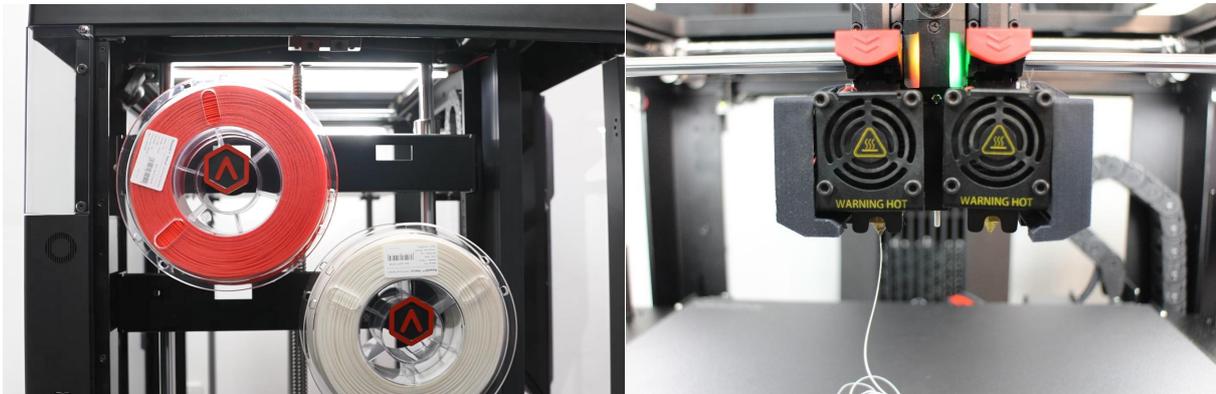


Figure 17 Load the filament.

- 2) On the homepage, select the "Settings" icon in the upper left corner to enter the settings interface.

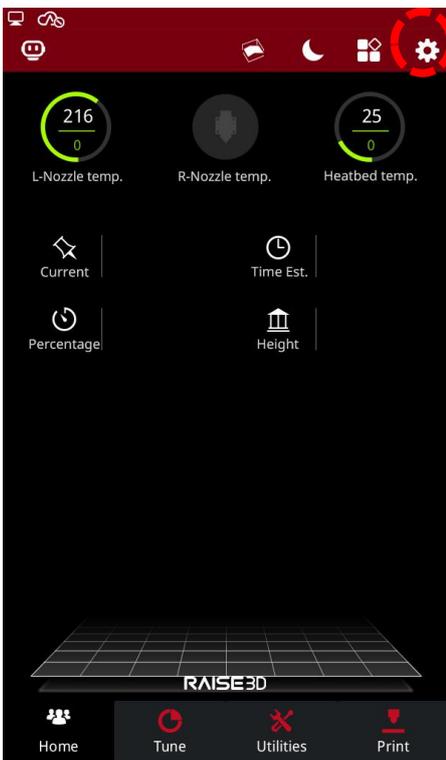


Figure 18 Enter the Settings interface.

- 3) Select "Maintenance" on the "Utilities" page.

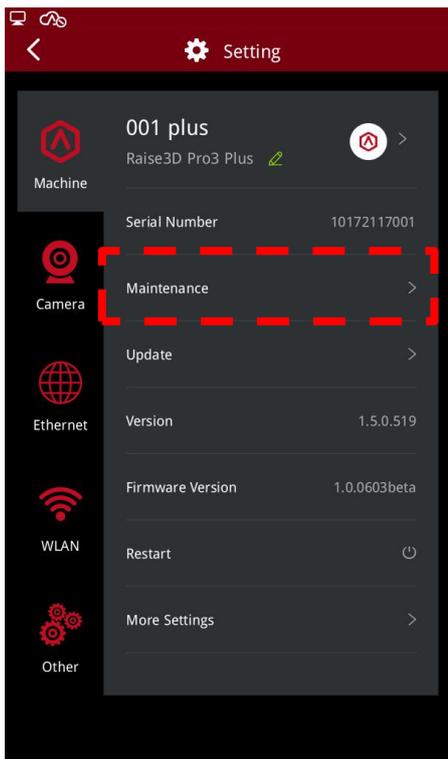


Figure 19 Select Maintenance.

4) Select "Offset Calibration".

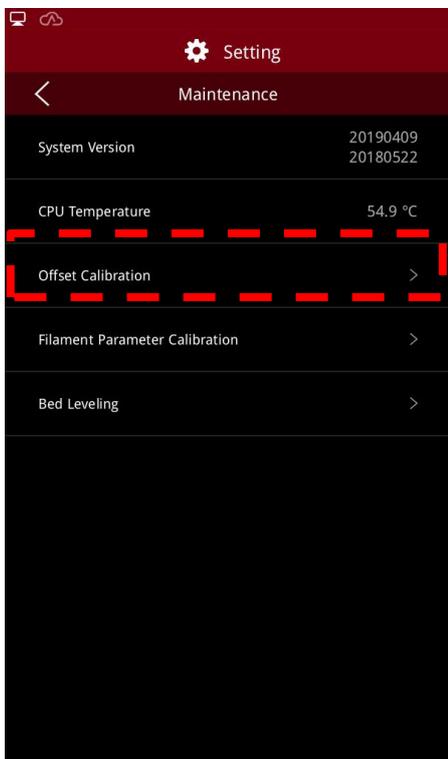


Figure 20 Select "Offset Calibration".

5) Make sure that your printer has met all the requirements on the screen, and then select "Start".

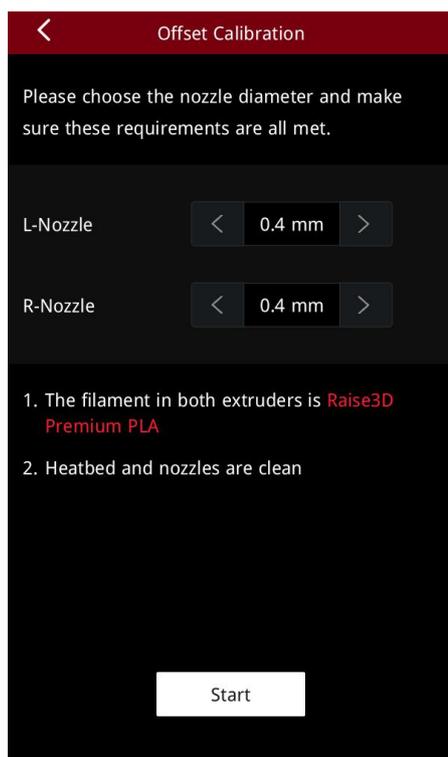


Figure 21 Make sure that your printer has met all the requirements.

6) Completely run the 5-step Offset Calibration. The calibration takes about 1 hour. It will ensure that your nozzle and the build plate are calibrated to the proper position.

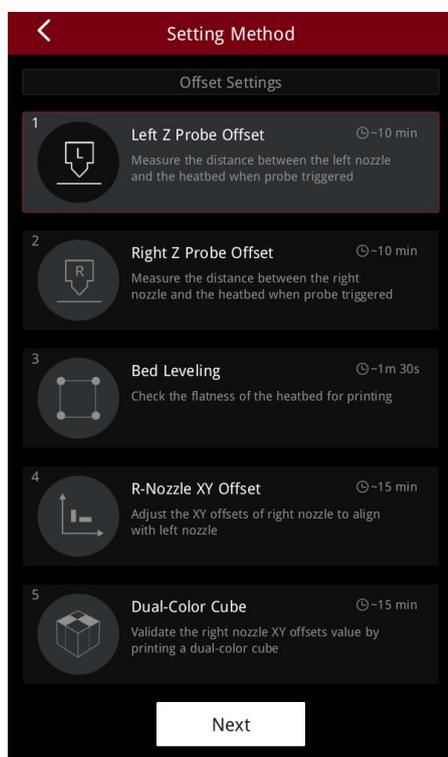


Figure 22 Completely run the 5-step Offset Calibration.

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