Technical manual

How to change the hotend

How to change the hotend

By default, the Sigma is equipped with 0,4 mm hotends, but is possible to change them to tackle different print jobs.

Changing the hotend is an easy operation that can be performed in a few minutes. You will need:

- Scissors or cutting pliers
- 2,5mm hex key
- Pliers
- Zip ties

1. Operating the printer via the LCD screen, go to *Utilities --> Printer setup --> Change hotend.*

Utilities	
⫼⫼ **Filament**	⊡ **Calibration**
✎ **Maintenance**	🗒 **Printer Setup**

🗒 Printer Setup	
⬦ **Change Hotend**	⊡ **Components Setup**
💡 **Light Intensity**	⚙ **Run Setup Assistant**

2. Select the hotend to change and unload the filament (in case there's some loaded).

⬦ Change Hotend	
Left Hotend	**Right Hotend**
Press NEXT to unload or skip if there's no filament loaded.	
Skip	**Next**

3. Wait while the hotend cools down.

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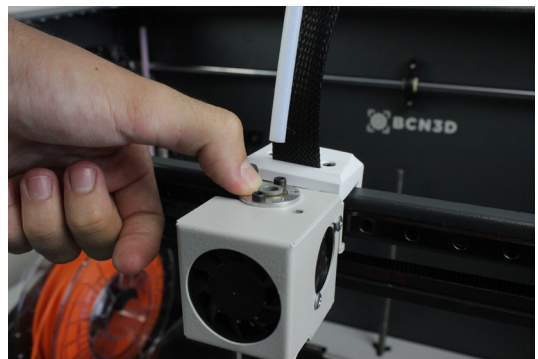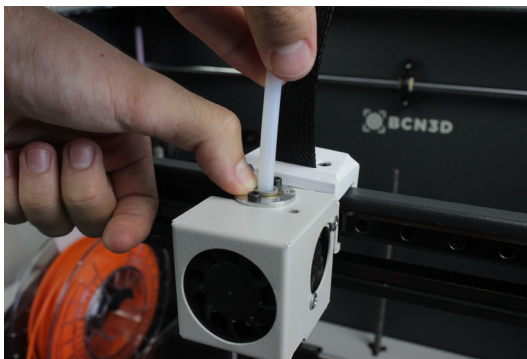
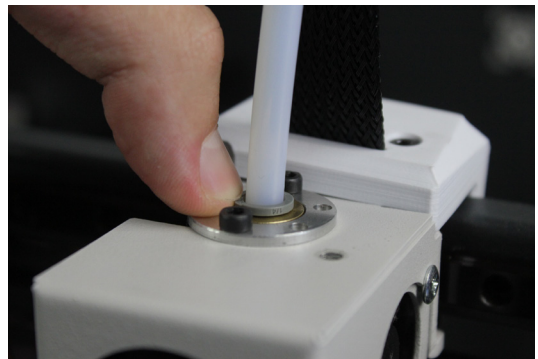**4.** Turn off the Sigma when the LCD indicates it.

Turn off the Sigma and change the hotend.
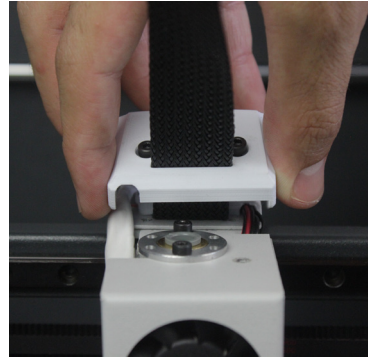
Learn how at
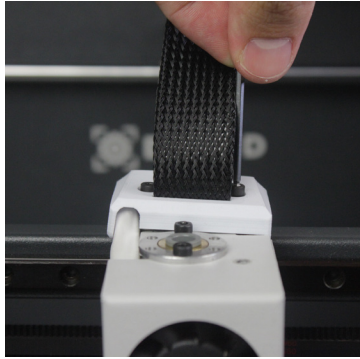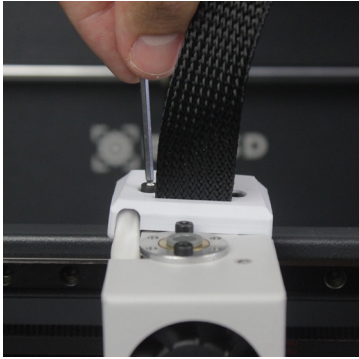bcn3dtechnologies.com/changehotend

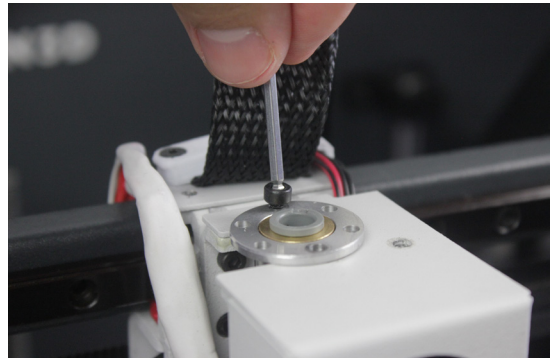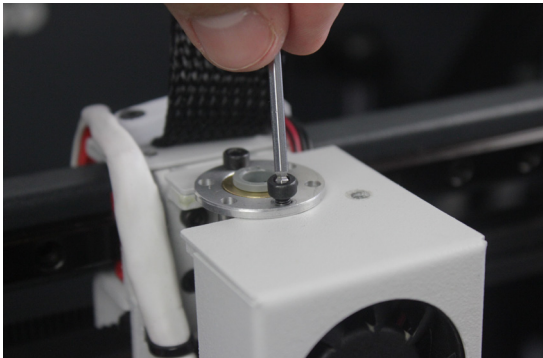**5.** Remove the black clip. Then hold down the coupling collet and pull out the teflon tube.
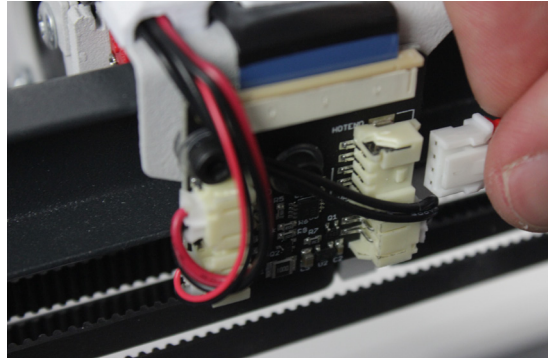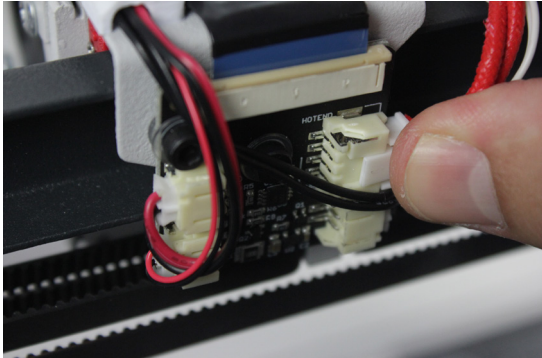
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6. Unscrew the cover and remove it.

7. Unscrew the hotend.

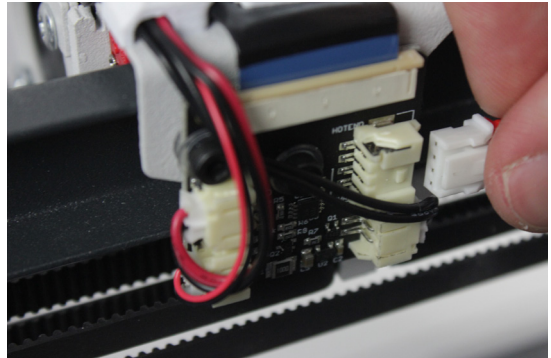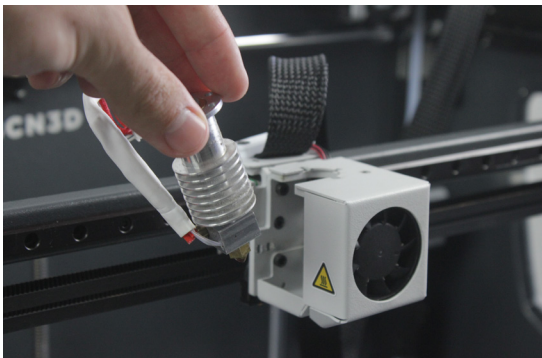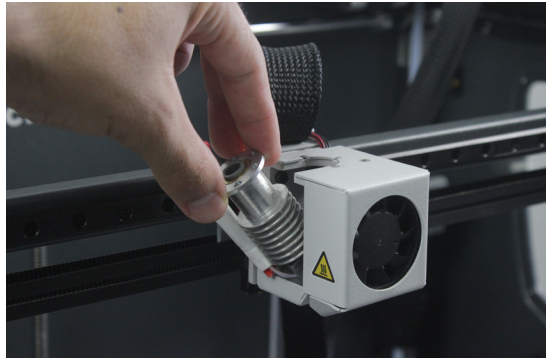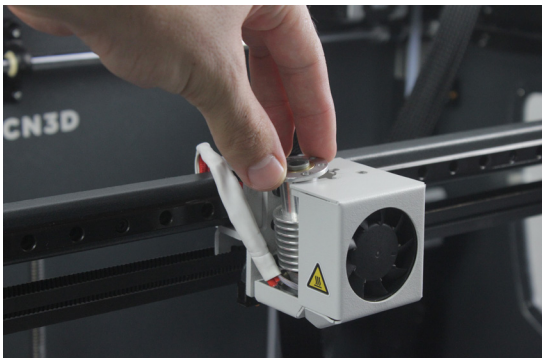**8.** Cut the zip tie and remove it.

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9. At the back of the toolhead carriage, press the connector to remove the cable of the hotend.
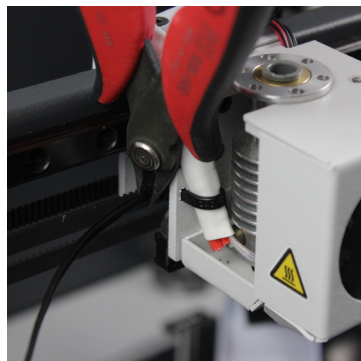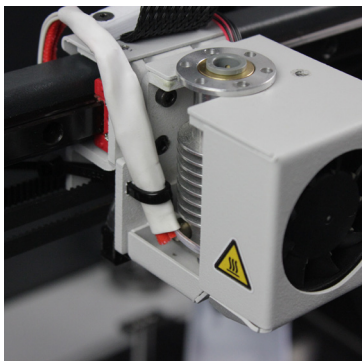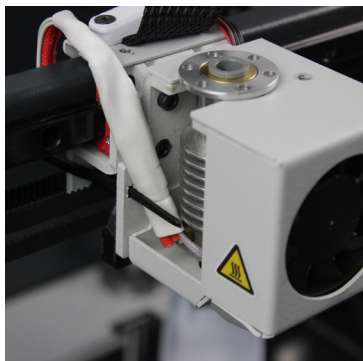

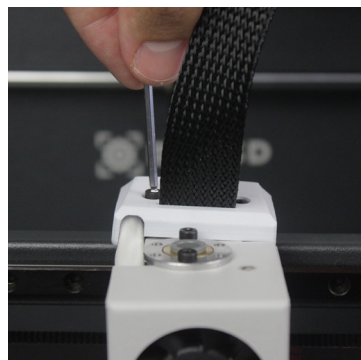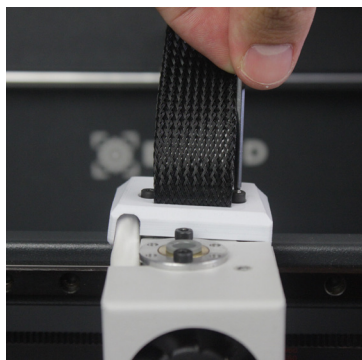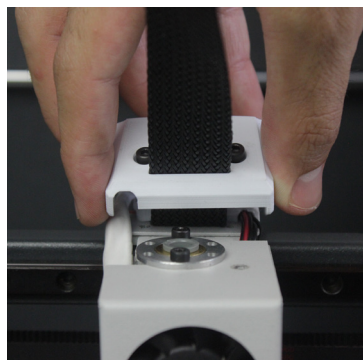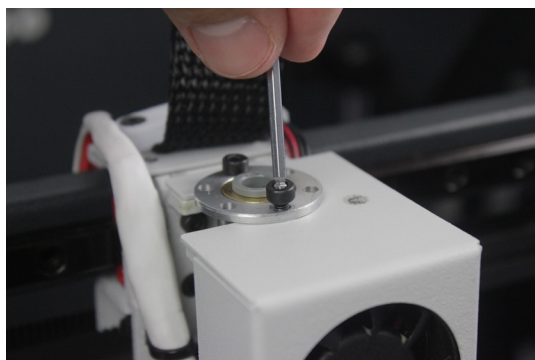**10.** Remove the old hotend and place the new one, connecting it at the back of the toolhead carriage.
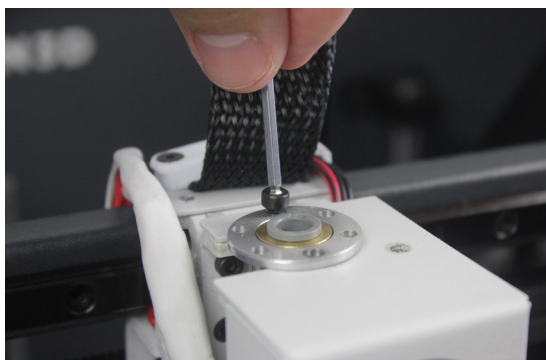
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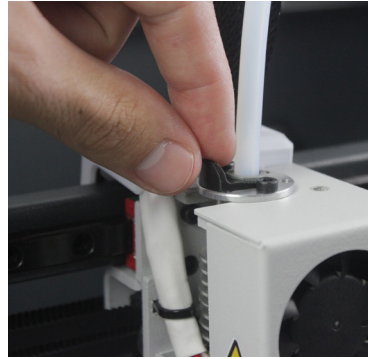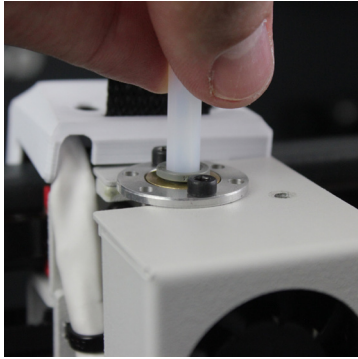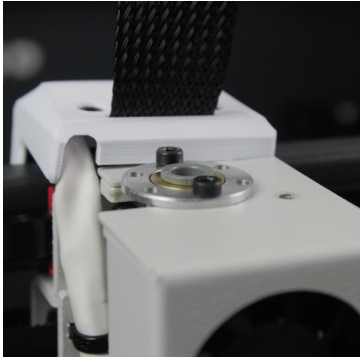**11.** Place and adjust the zip tie, cutting off the excess.

12. Screw the hotend, place the cover and screw it.

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13. Insert the teflon tube until it stops, making sure it is well placed. Put back the black clip.

14. Turn on the Sigma and follow the screen instructions. Select the hotend size you have installed.

‹ 🔻 Change Hotend		
0.3	0.4	0.5
0.6	0.8	1.0
Select the nozzle size that you've installed.		
Save		

15. Load filament and perform an autotune operation.

‹ ‖‖‖ Load Filament	
It's necessary to load filament in order to autotune and calibrate the hotend.	
Skip	Load Filament

16. Finally, calibrate the offset between hotends.

‹ 🖊 Autotune Hotend	
It's recommended to autotune the hotend to improve its thermal stability.	
Skip	Autotune

‹ 🖶 Printer Calibration	
When the hotend is changed the calibration values vary. For this reason, it's required to calibrate the Sigma.	
Skip	Calibrate

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