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Solidscape
Title:
Procedure For Draining Tanks and Replacing Material

Date:

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1. Purpose

The purpose of this Service Technical Bulletin is to describe the procedure to drain the material tanks and replace the material with fresh or new material.

2. Scope

This STB applies to all R66/T76/D76 and R66P/T76P/D76P machines.

3. Required Tools & Materials

- Solidscape software USB drive, PN 945085 (rev H or above)
- Disposable heat resistant container of approximately 1 quart (1 liter) capacity
- Eye protection and heat resistant gloves are highly recommended

4. Cautions

This procedure involves working with hot, molten materials. Caution must be used to avoid burns.

5. Procedure

1) Cut a small hole in the lid of the heat resistant container, see figure 1. An empty material bottle is a good container to use as well.



Figure 1 – Modifying container



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2) Remove the heated line from the printhead associated with the tank to be drained. Remove the splint and junction from the end of the heated line. Insert the end of the heated line into the hole cut into the lid of the container. See figures 2a and 2b. Ensure that the heated line cannot accidently come out of the container.

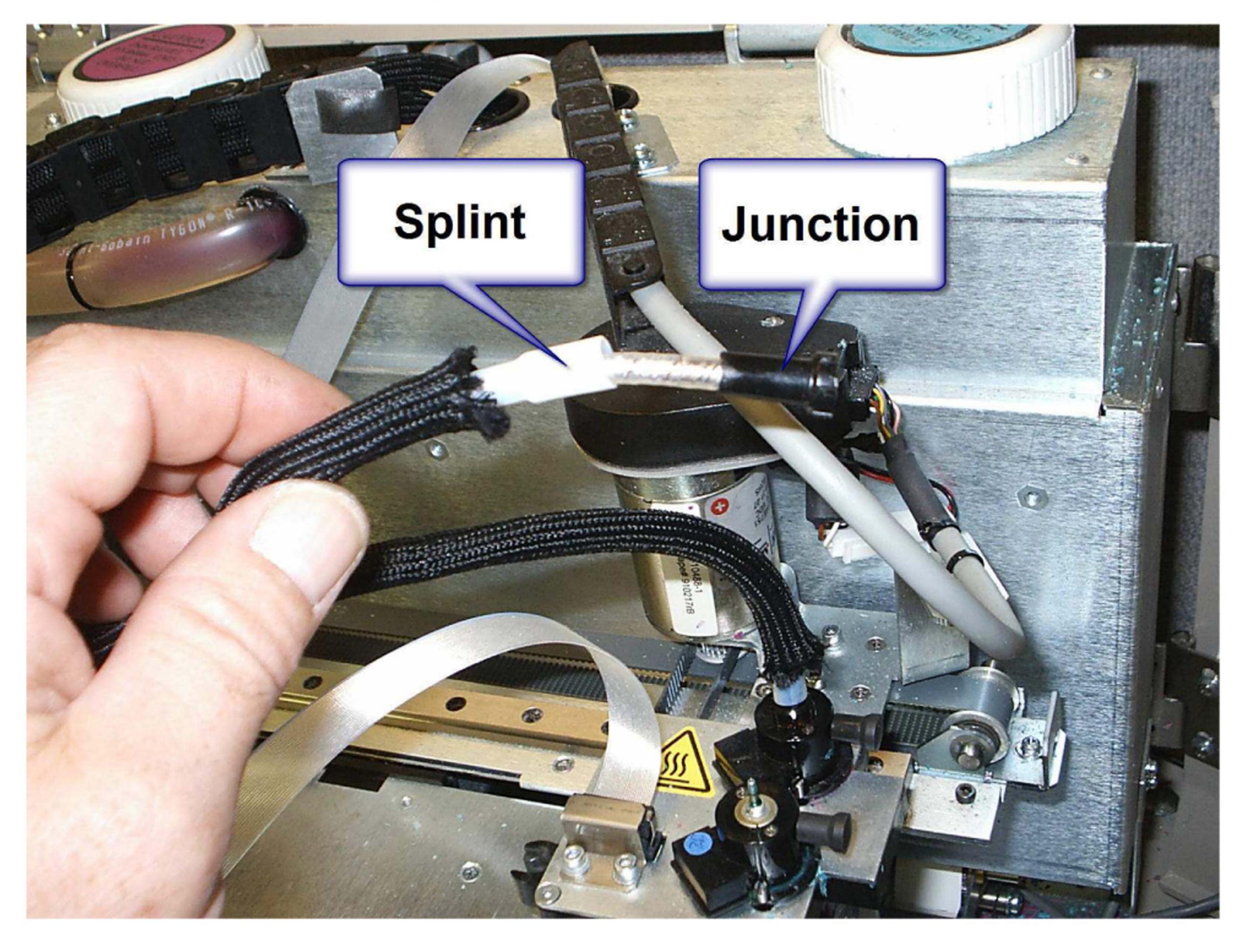


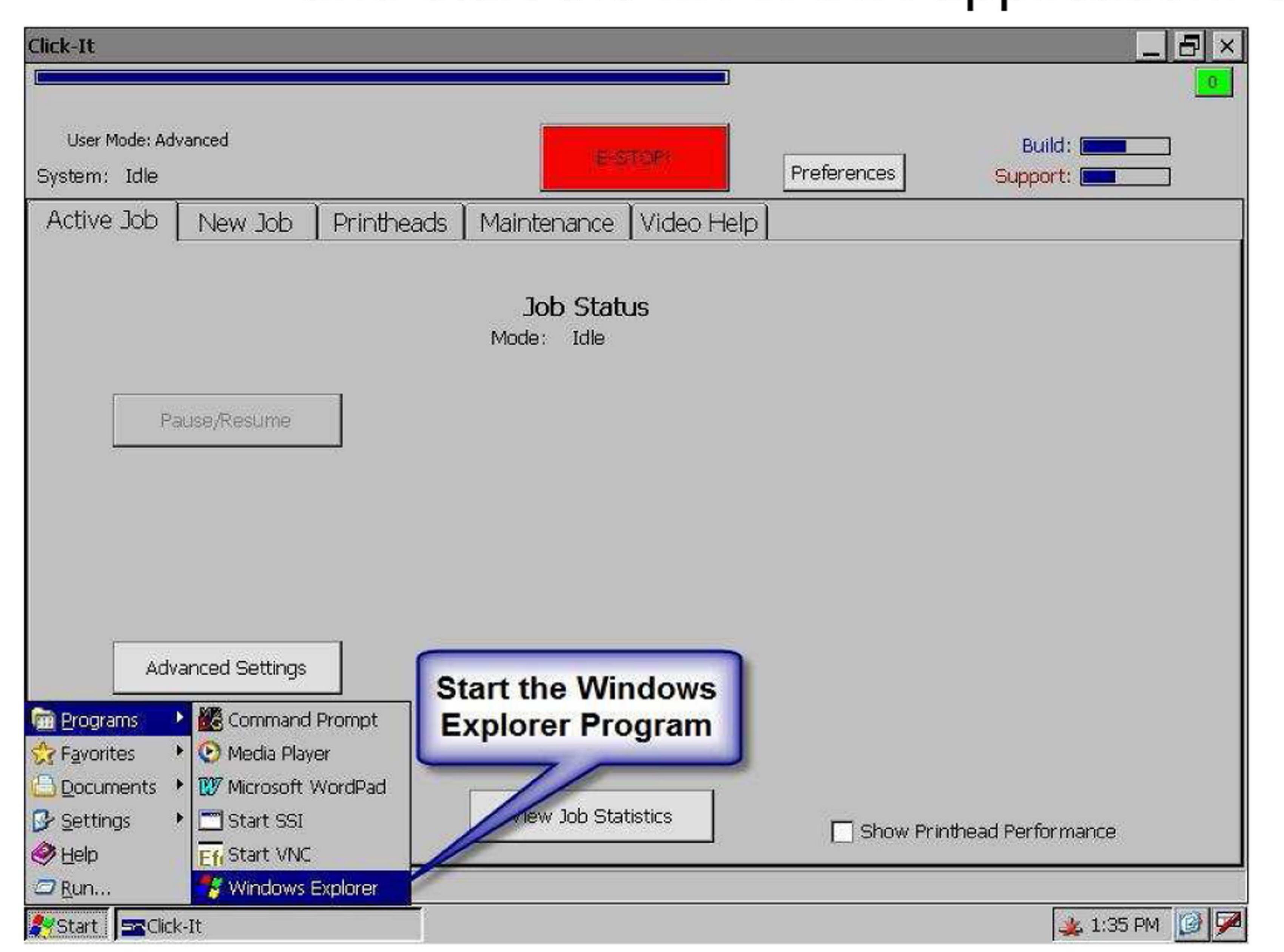


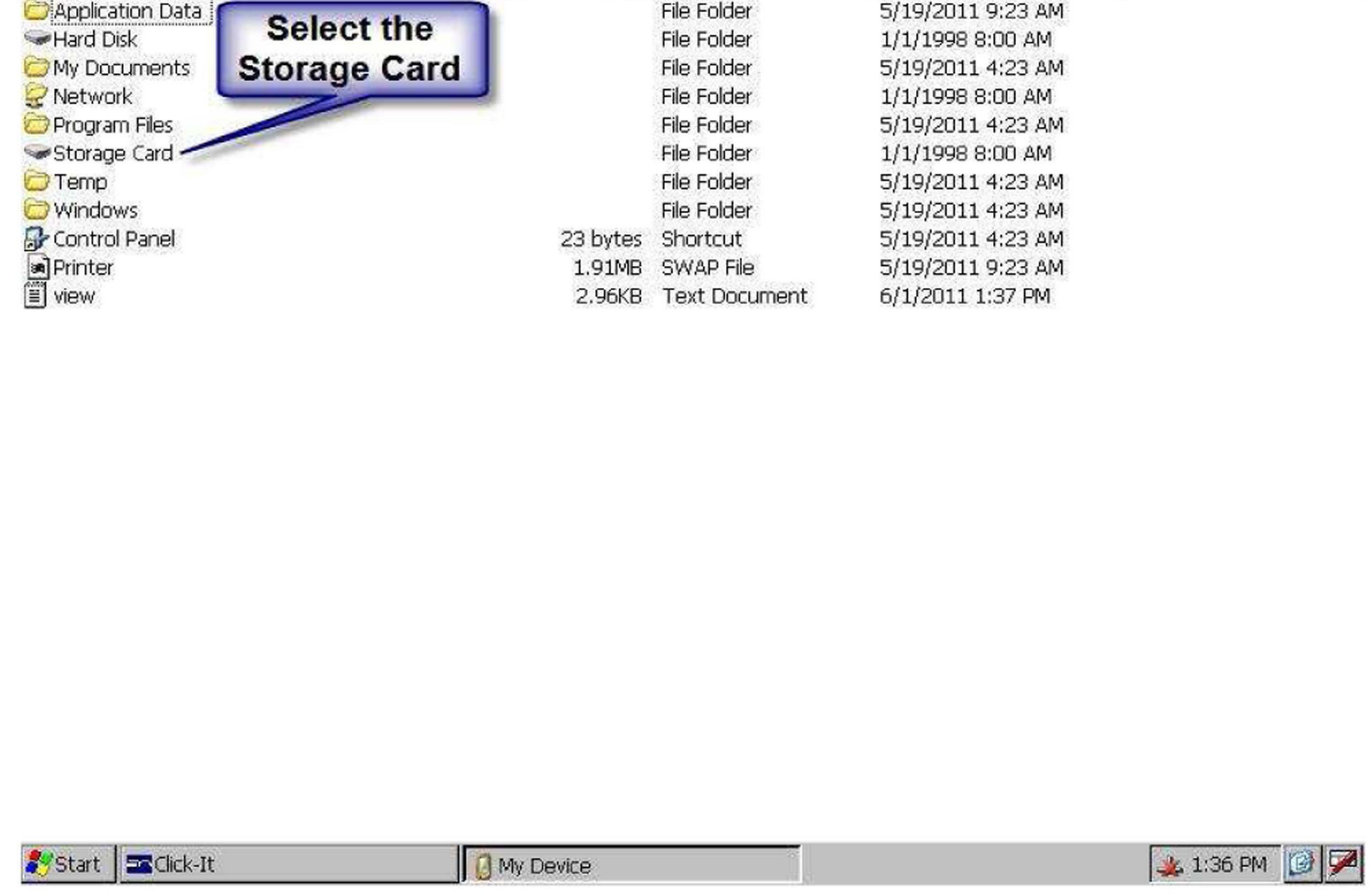
Figure 2a – Remove splint and junction

Figure 2b – Insert heated line into container

3) Insert the USB drive into the machine. Click the Windows start button, select Programs, and then select Windows Explorer. Browse to the Storage Card and start the MTTANK application. See figures 3a, 3b, 3c, and 3d.

Address My Device





Size Type

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Figure 3a – Selecting Windows Explorer

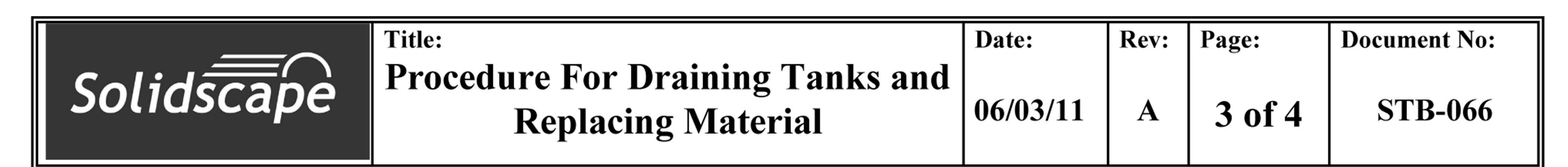
Figure 3b – Browse to the Storage Card

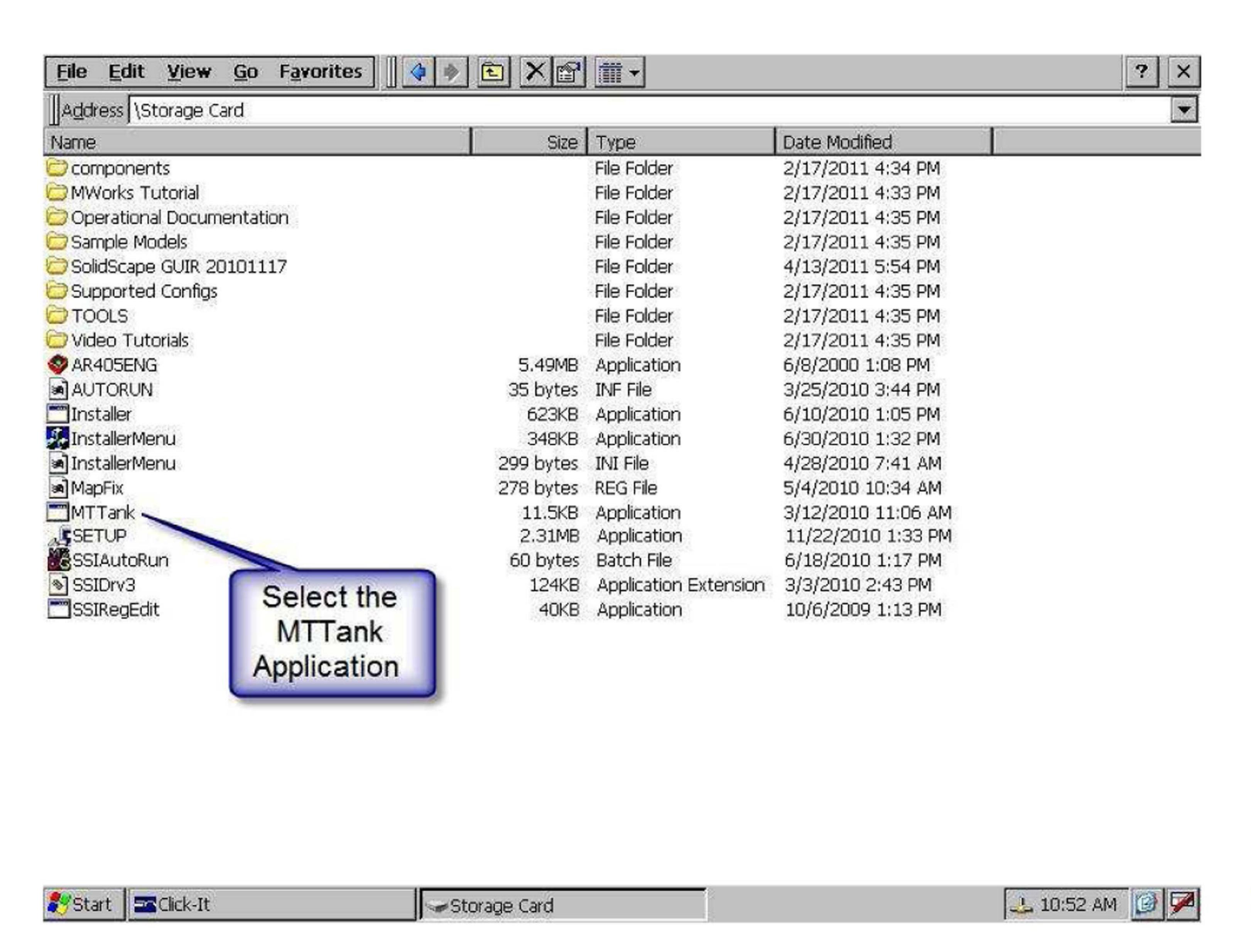


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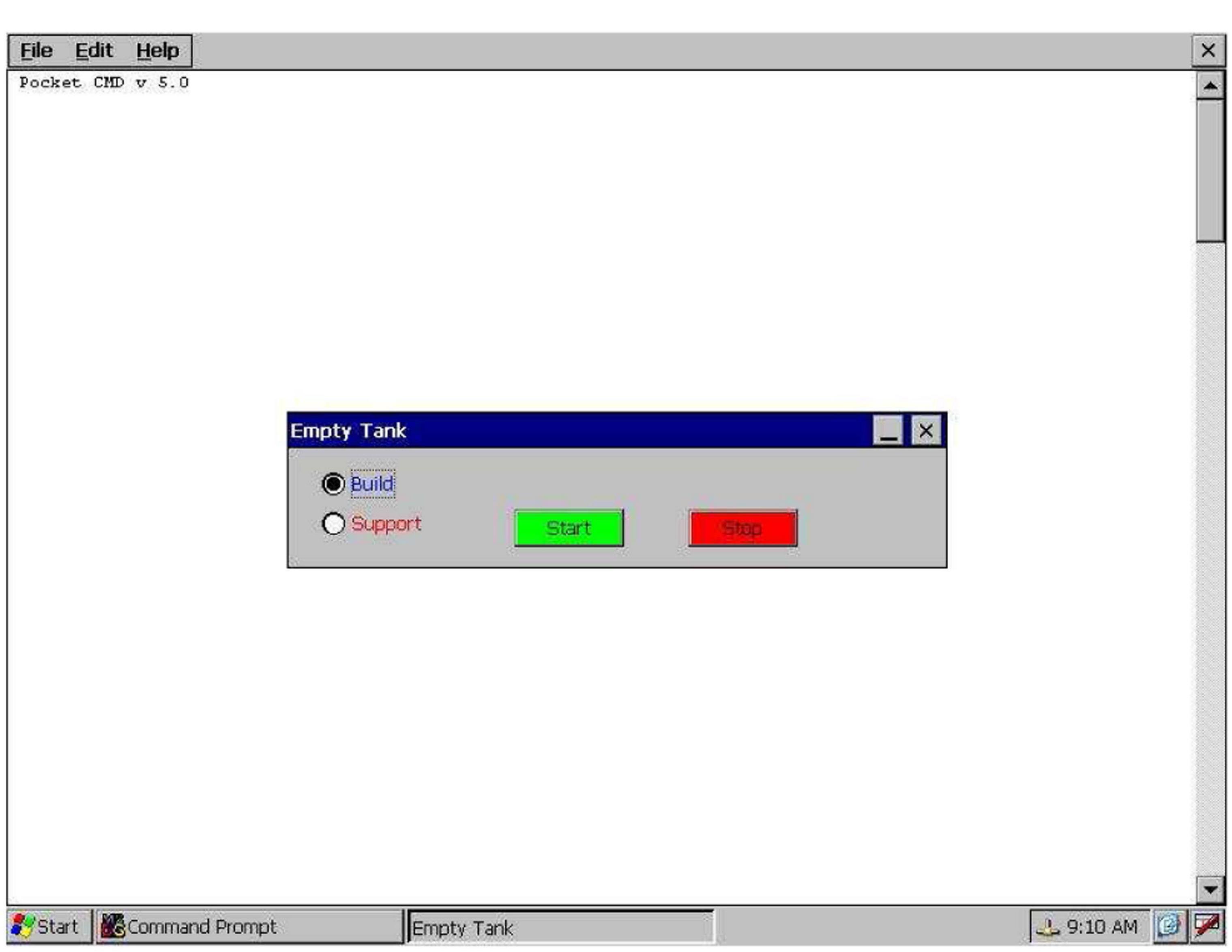


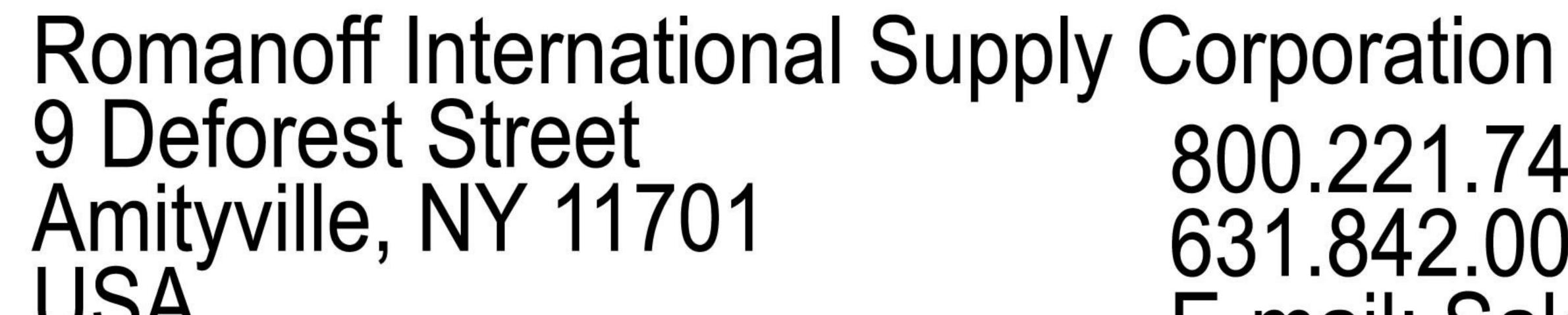
Figure 3c – Start the MTTANK application

Figure 3d – MTTANK application

- 4) Use the radio buttons to select which tank you want to drain. Click the button to drain the tank. The machine will begin to purge the material from the tank into the container.
- 5) When the tank is empty, the heated line will begin to purge air instead of material. button and verify the tank is empty with the dipstick. If the tank is not empty, click the button again. Note: There may be up to 1/8 inch (3mm) of material left at the bottom of the dipstick when the tank is empty.
- 6) Add between 75ml to 100ml of material to the tank and allow it to fully melt.
- 7) If you are draining both tanks, repeat steps 1, 2, 4, 5, and 6 for the second tank while waiting for the material in the first tank to melt.
- 8) Verify the material is fully melted and repeat steps 4 and 5 for the first tank.
- 9) Verify the material is fully melted and repeat steps 4 and 5 for the second tank.
- 10) If the tank filters have been in use for more than 6 months, this is an excellent opportunity to replace them. See Solidscape document MP-0154 for information on changing the tank filters.
- 11) Click the Management button to exit the tank drain utility. You must click this button to close the program. Exiting the program by any other means will require a correction to the Click-It software! See figure 4.

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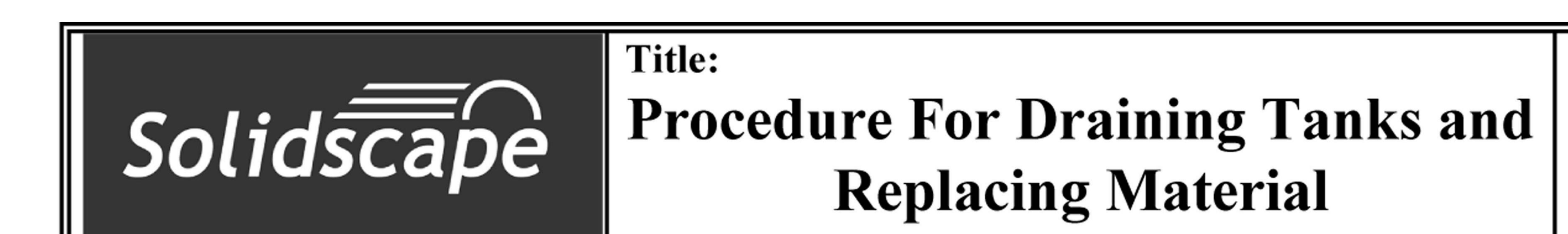
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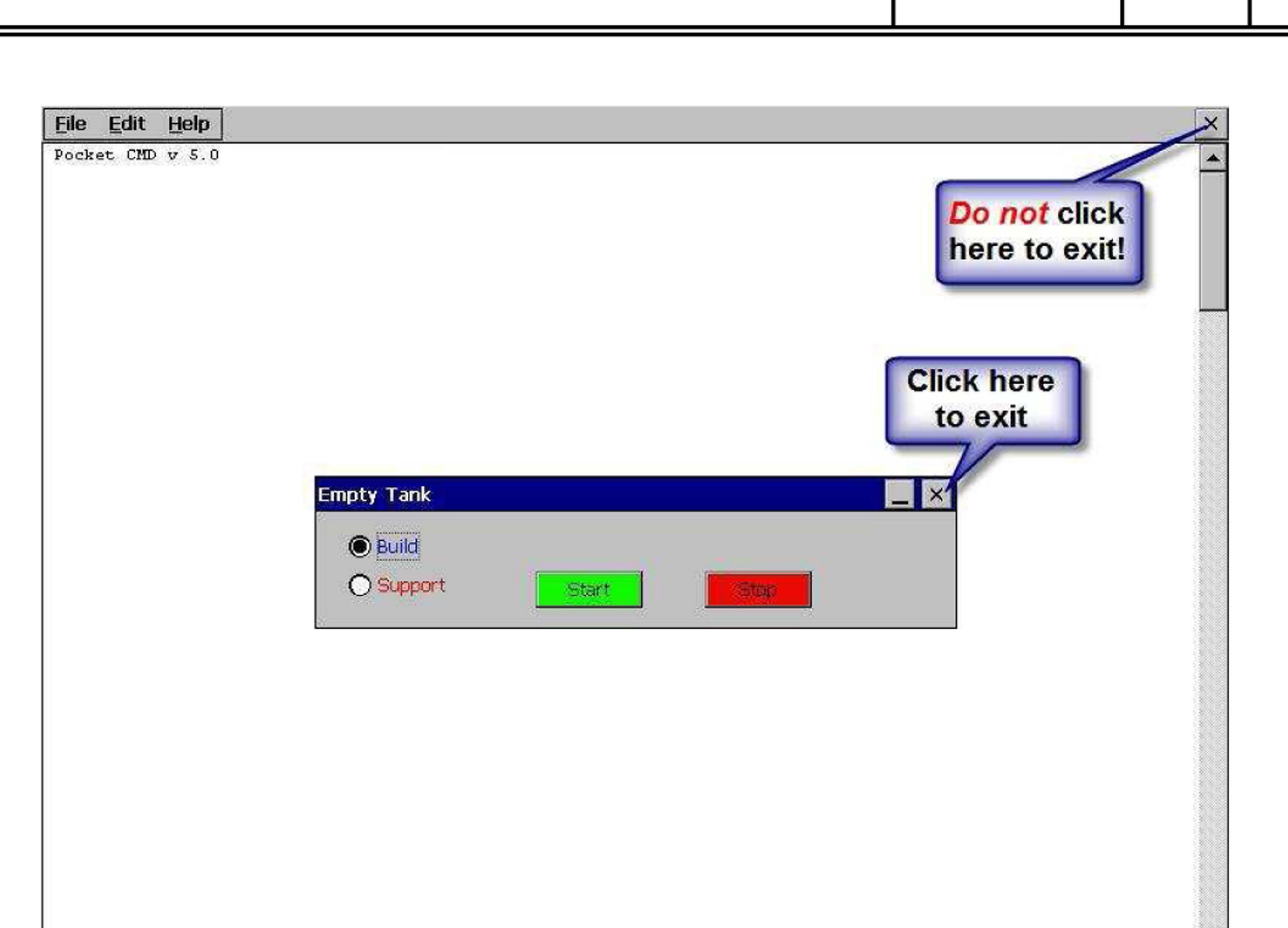


Figure 4

Empty Tank

12) Remove the USB drive from the machine.

Start Command Prompt

- 13) Reinstall the splints and junctions onto the heated lines. The junction will usually "click" onto the end of the heated line. Reattach the heated line(s) to the correct printhead(s).
- 14) Turn the machine off and then back on.
- 15) Add material to the tank(s) to bring the tank level up to approximately 50% and allow the material to fully liquefy. Set up the printhead(s) as normal.