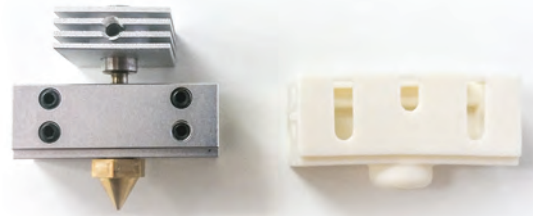


# Raise3D Pro2 Nozzle Replacement

For the instructions on removing or re-installing the assembled hotend onto the extruder head, please refer to the Manual Pro2 - 402 Hotend Replacement

## Step 1: Nozzle Removal

Remove the silicone sock from the hotend.



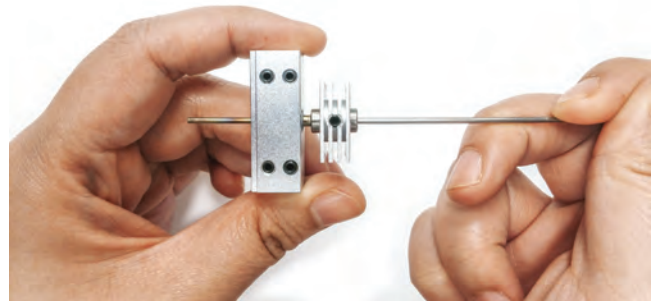
Remove the old nozzle from heating block with an 8mm socket wrench.

To prevent damage to components, do not exert force on the throat tube. Hold from the solid section of the heating block during adjustments.

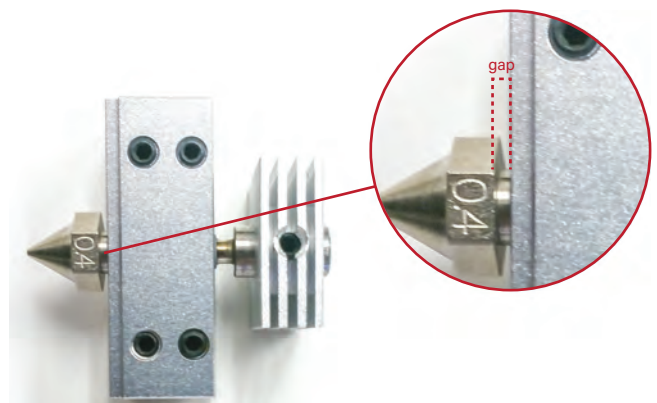


## Step 2: Nozzle Installation

Insert a cleaning rod completely through the hotend and ensure that the tube is completely clear of blockages.



Screw the new nozzle into the heating block. Do not tighten completely. Ensure that there is a visible gap between the nozzle and the heating block.

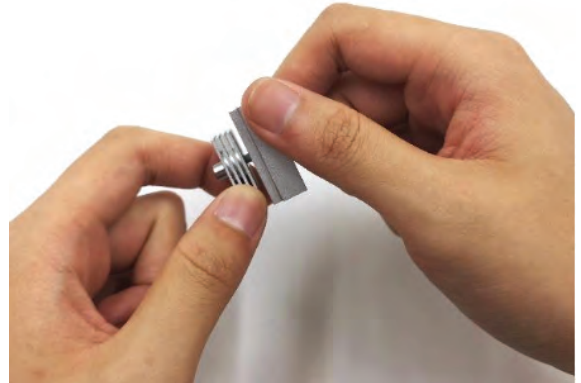


## Step 3: Tighten the Throat Tube

Hold onto the heating block, and tighten the throat tube by rotating the heat sink. Rotate until the nozzle "catches" onto the tube (begins to spin).

(The heat sink may be askew when the right position is achieved. This is normal, and will be adjusted in the latter steps.)

**\*\*If the heat sink is loose on the throat tube, secure the fixing screw prior to tightening the throat tube.**



## Step 4: Tighten the Nozzle

Hold onto the heating block, and tighten the nozzle completely using an 8mm socket wrench. Check that a gap between the nozzle and the heating block has been maintained.



## Step 5: Adjust Heat Sink

Re-Attach the silicone sock, then loosen the fixing screw on the heat sink.

Lie the hotend assembly on a flat surface, rotating the heat sink so that the fixing screw is facing outwards.

Move the heat sink down so that it rests on the silicone sock, and tighten into place.

If you do not have a silicone sock, adjust the heat sink so that it is flush with the bottom of the large cylinder.

