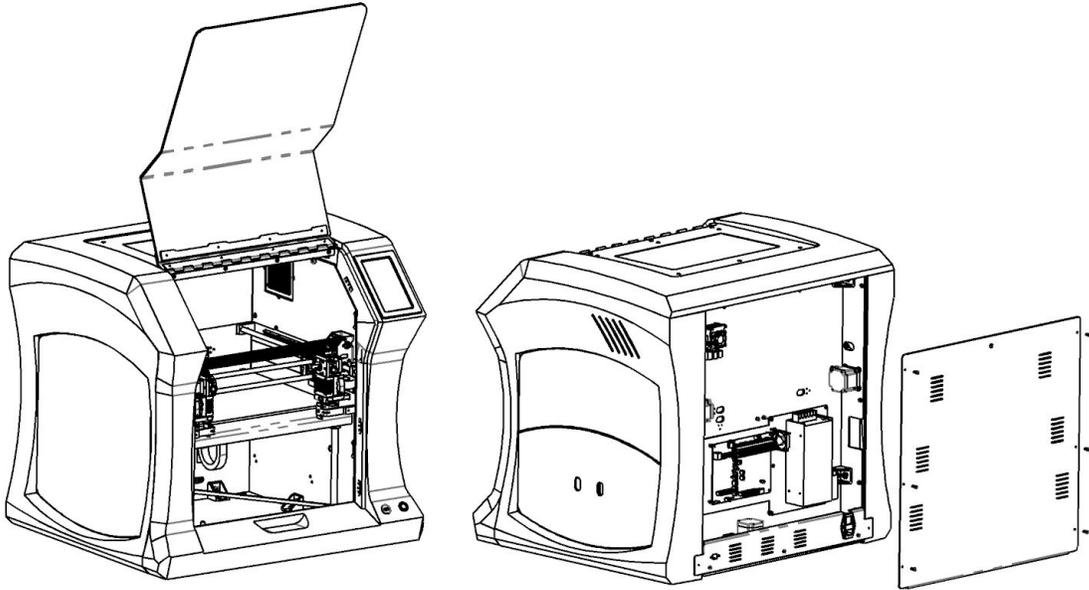




Title	Maintenance Schedule
Models	Bolt PRO
Document	Maintenance Manual
Version	1.5
Revision date	03-08-2018
Expected duration	-

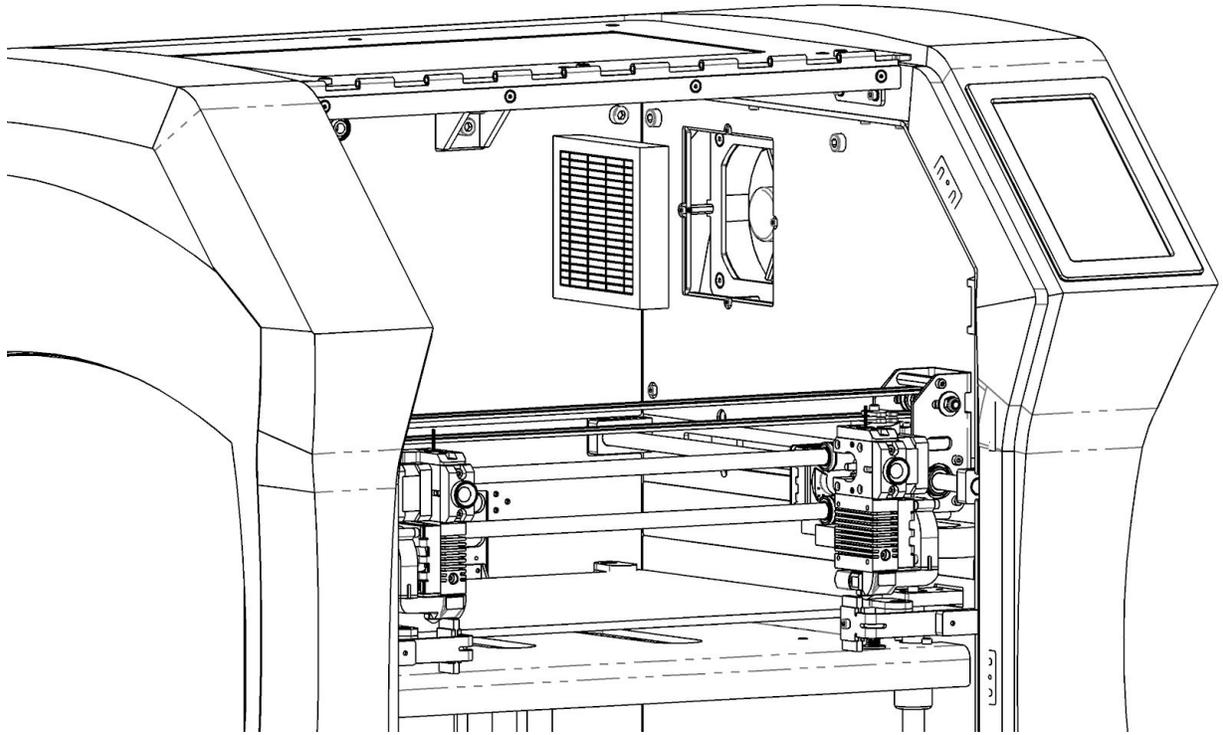
Description
<p>To maintain your Leapfrog Bolt PRO correctly and keep it running smoothly we recommend the following maintenance work periodically.</p> <p>Before doing any maintenance activity make sure the machine is completely turned off using the switch on the back of the machine. Ensure the machine is completely cooled down by waiting 30 minutes after the last use.</p> <p>Remember to use protective gloves, glasses, and clothing for each of these activities.</p>

1. Main body Cleaning and Inspection



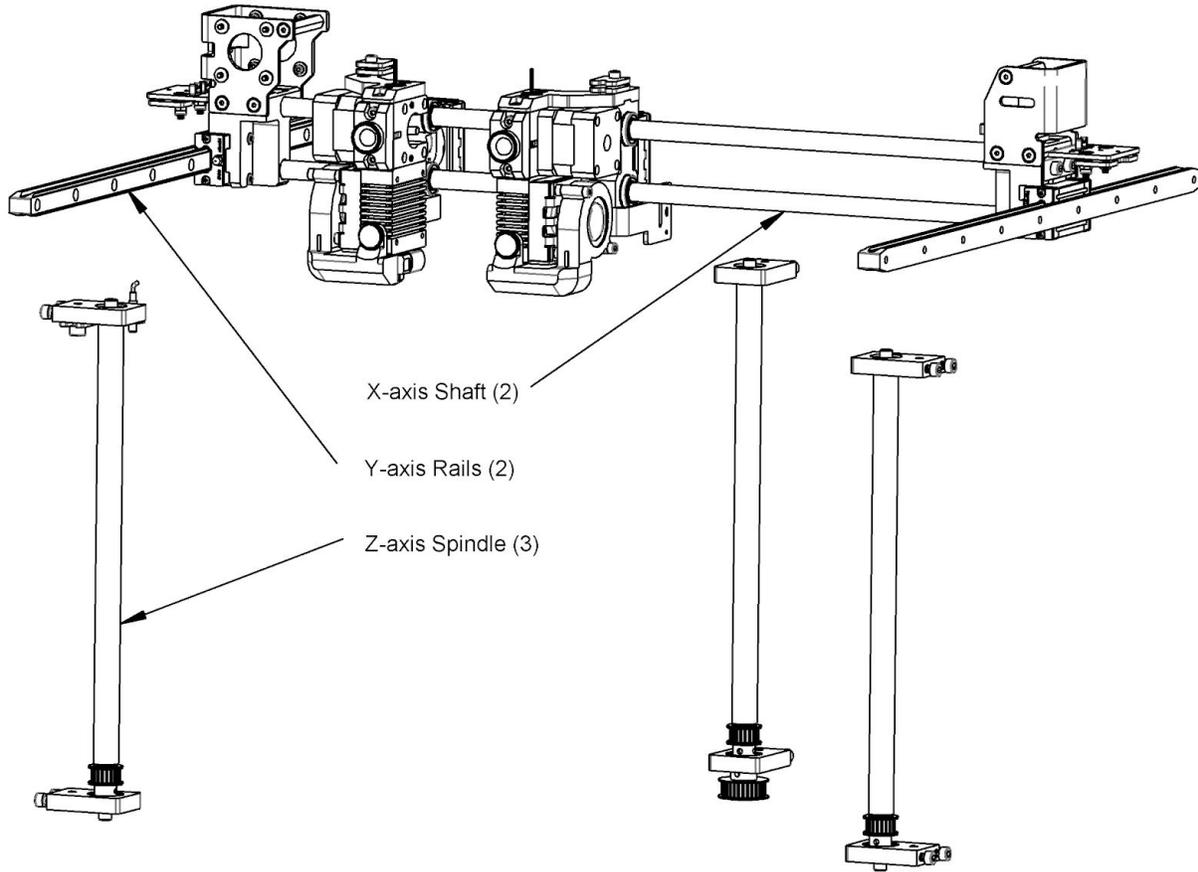
a.	Clean machine interior and surroundings.	Before each print.
b.	Clean the motherboard and power supply unit with compressed air.	Every 500 working hours.

2. HEPA Filter



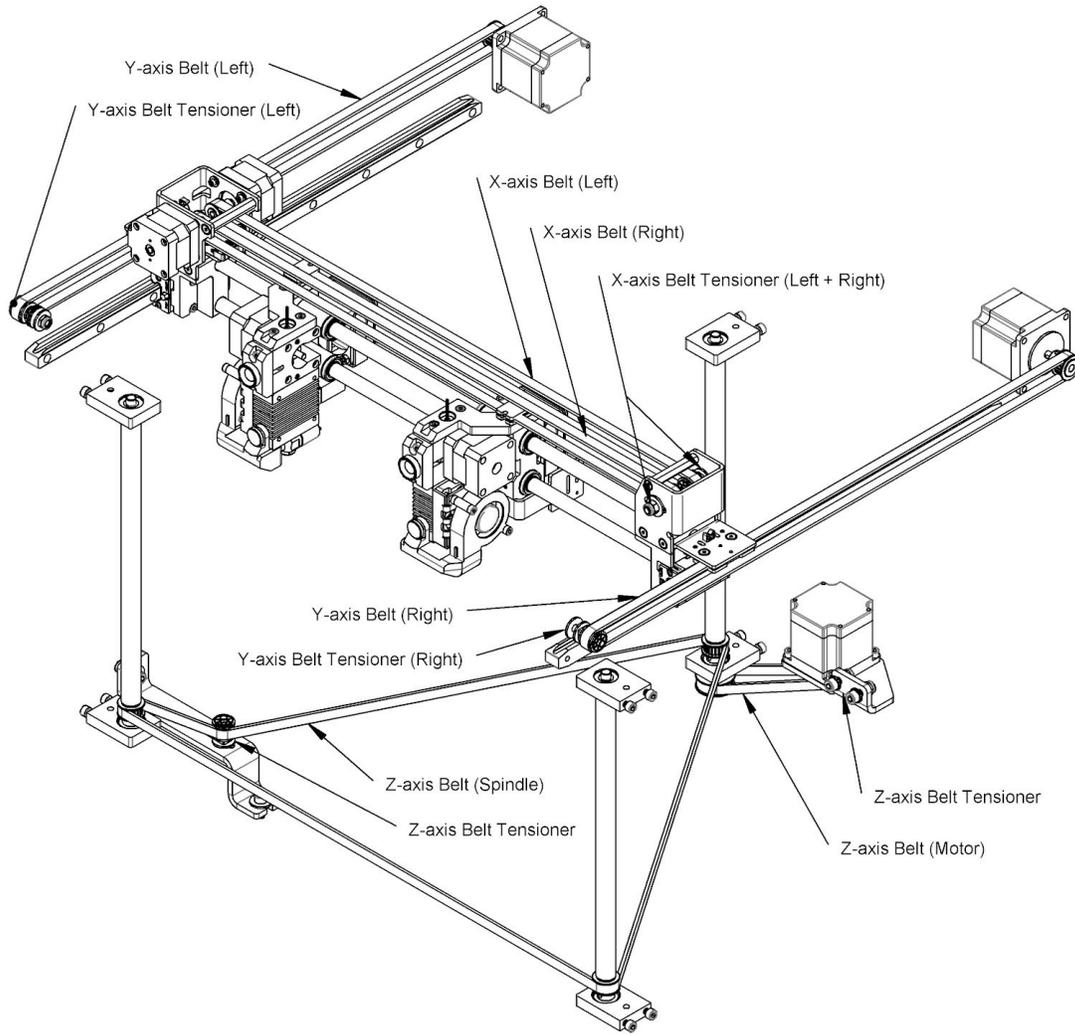
a.	Install the HEPA carbon filter in the machine.	Before each print.
b.	Store the HEPA carbon filter in an airtight box.	After each print.
c.	Replace the HEPA carbon filter.	Every 6 months.

3. Lubricating moving components



a.	Ensure X, Y, and Z axes are clean from material remains and dust.	Before each print.
b.	Lubricate X-axis Shafts using sewing machine oil.	Every 500 working hours.
c.	Lubricate Y-axis Rails using HIWIN G05 Grease.	Every 500 working hours.
d.	Lubricate Z-axis Spindles using Magnalube PTFE.	Every 500 working hours.

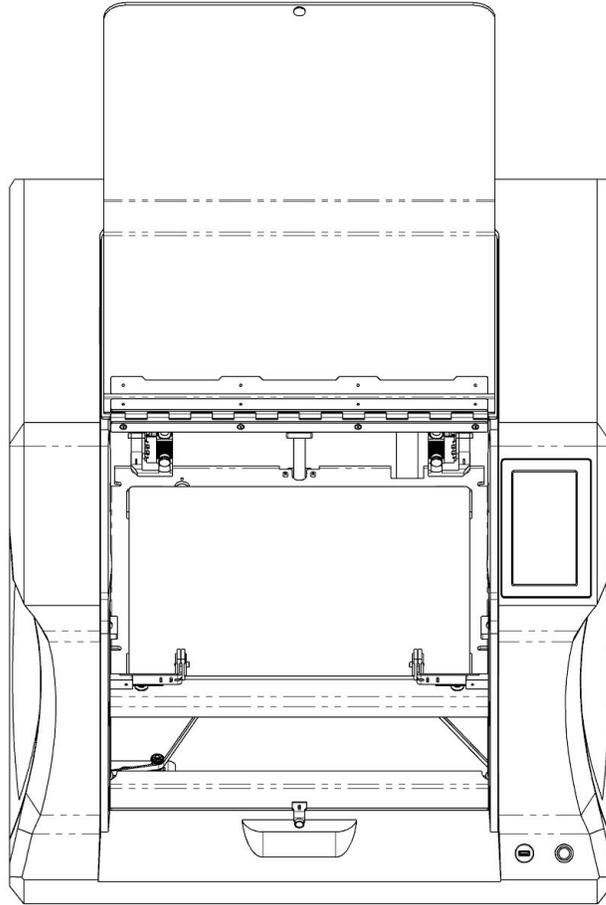
4. Belts Tensioning and Inspection



a.	Inspect the tension on X-axis belts (L+R).	Every 700 working hours.
b.	Inspect the tension on Y-axis belts (L+R).	Every 700 working hours.
c.	Inspect the tension on Z-axis Belt (Spindle).	Every 700 working hours.
d.	Inspect the tension on Z-axis Belt (Motor).	Every 700 working hours.

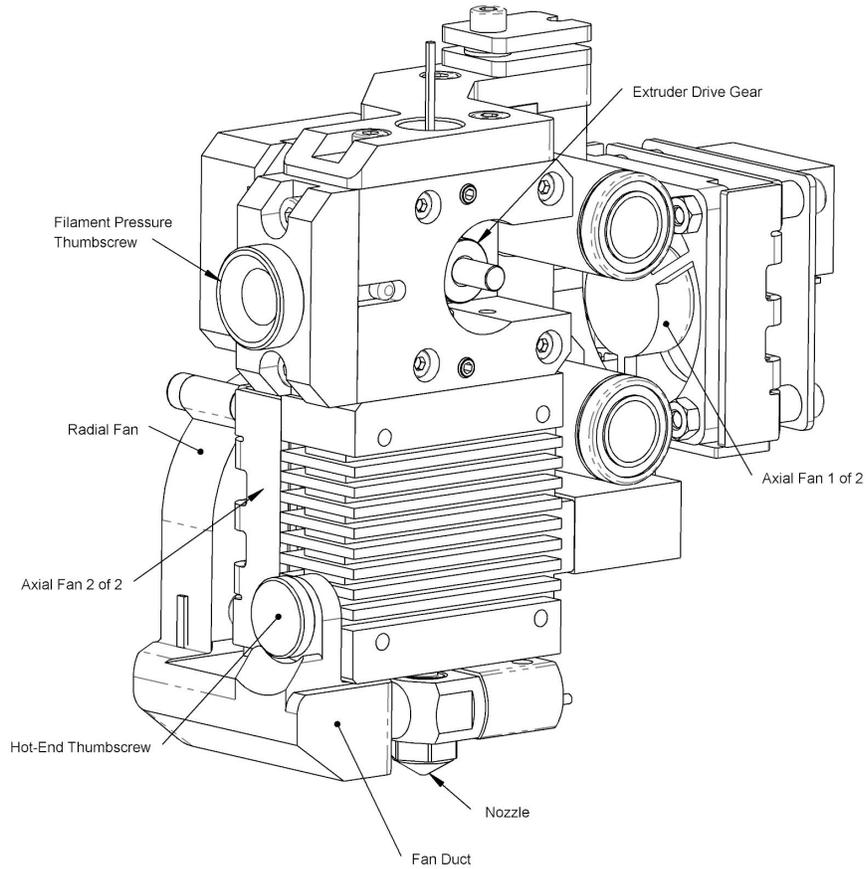
Belts should be tight enough to minimize slack, but not so tight that they start placing a lot of stress on the motor shaft or pulleys.

5. Bed



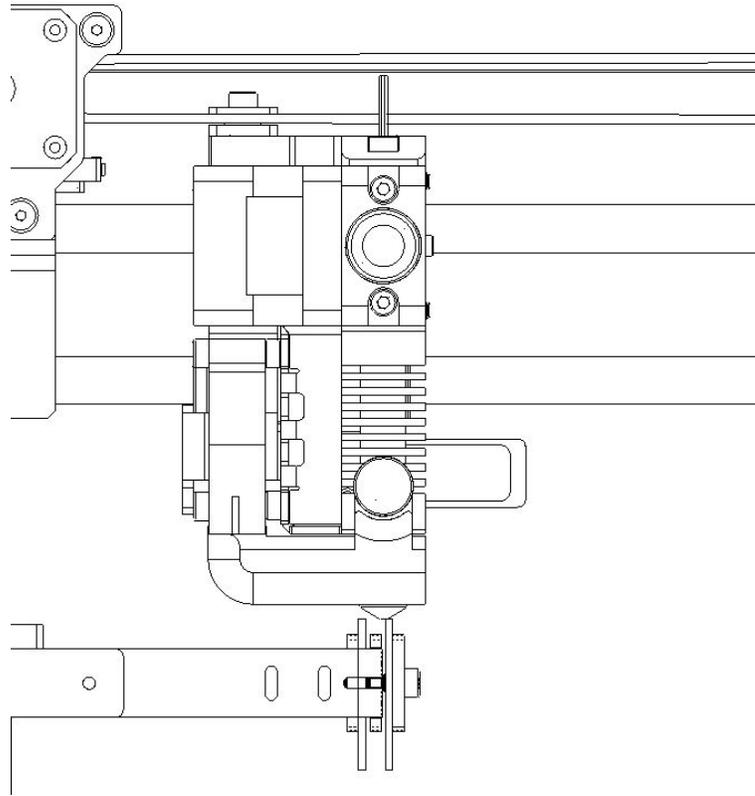
a.	Clean the bed.	Before each print.
b.	Calibrate bed.	Every 200 working hours.

6. Printhead



a.	Check both axial fans are working.	Every 200 working hours.
b.	Remove any material debris on the extruder including the nozzle.	Before each print.
c.	Inspecte the hot-end thumbscrew is properly tightened.	Every 100 working hours.
d.	Filament pressure thumbscrew.	Always adjust accordingly before inserting new filament.
e.	Clean Extruder Drive Gear.	Every 400 working hours.

7. Wiper



a.	Remove any material debris from the wiper blade.	Before each print.
b.	Calibrate the wiper blades.	Every 100 working hours or when changing the hot end.

The wiper blade should be as close to the (clean) nozzle as possible without touching it.