

Schedule of maintenance (Form 3/Form 3B)

Component	Inspection	Maintenance ONLY if problems are noted:	Est time	Frequency	Incidental	Resource	D	M	Q	I
Build platform	Inspect the build platform for liquid resin, tackiness, or cured resin on the print surface.	Use isopropyl alcohol and paper towels to remove liquid resin or tackiness. Use a paint scraper to remove cured resin.	0.1 h	Daily	Perform this check for each print.	Guide	X			X
Optical window	Remove the build platform, resin tank, and resin cartridge. On the touchscreen, tap the wrench icon to enter the Settings menu, then tap Maintenance , then LPU Replacement . Follow the on-screen prompts. When the LPU moves to the center, use a light to inspect the optical window for contamination.	Remove any contamination using a dry photographic wipe (PEC*PAD) and a rubber bulb blower. If the contamination is difficult to remove, a small amount of isopropyl alcohol (IPA) may be applied to the photographic wipe to aid in removal. The optical glass should be cleaned in a slow, straight wipe from one side to the other. Repeat until all contamination is removed.	0.2 h	Monthly	Perform this check when your prints have visual defects, missing features, etc.	Guide		X		X

PreForm	Open PreForm and check for version updates. Select Help > About PreForm from the menu bar to check for PreForm updates.	If PreForm is unable to connect to the internet, PreForm versions can be downloaded manually using the resource guide provided here.	0.1 h	Monthly	Perform this check any time your printer behaves unexpectedly or displays an error message.	Guide		X		X
Printer firmware	Open PreForm. Expand the right panel by clicking the < button. Click the Printer Name to open the Job Setup window. Click the downward facing arrow to open the Printer List . Select the appropriate printer from the list to open the Printer Details window. Click Update .	If the printer is unable to connect to the internet, firmware versions can be downloaded to your computer. Manually downloaded files can be loaded via PreForm in the Update window.	0.1 h	Monthly	Perform this inspection any time your printer behaves unexpectedly or displays an error message.	Guide		X		X
X-axis lead screw	The printer makes a clicking sound, the LPU fails to move normally, or printed parts are shifted on the X-axis.	The X-stage lead screw located horizontally within the printer cavity needs to be cleaned and lubricated. Contact Formlabs Support or your authorized reseller for an X-axis cleaning kit. Alternatively, print the thread cleaner and applicator . Use the printed thread cleaner to snap over the lead screw	0.5 h	Quarterly	Perform this check when the printer is making clicking sounds or when the LPU fails to move properly.	Guide			X	X

		and thread it along the full length to remove any residue or contamination. Using the printed applicator, apply a thin layer of white lithium grease to the lead screw.								
Print failure	The print fails to adhere to the build platform or parts of the raft are curling off the build platform.	<ul style="list-style-type: none"> • Perform an optical window check. • Starting a print before it reaches the correct temperature can result in poor adhesion to the build platform—ensure that the printer has reached the correct temperature before printing. • In PreForm, using the Slicer tool, check the first layer to ensure your part has good contact with the build platform. In some cases, the raft is too small or narrow for adequate adhesion. 	0.5 h	Incidental	Print fails or partially fails to adhere to the build platform.	Guide				X
LPU housing	The printer makes a clicking sound when the LPU moves all the way to the left side of the resin tank and is picking up or dropping off the mixer.	The mixer coupler is rotating too far when trying to engage/disengage the mixer. This does not harm your printer, however if you hear it, contact Formlabs Support or your authorized reseller to schedule a software fix.	0.5 h	Incidental	Perform this check when the printer is making unusual noises.	Formlabs Support or your authorized reseller				X

Resin tank	The printer indicates that the resin tank is nearing expiration or has reached the end of its life.	Using a resin tank beyond its life expectancy greatly increases the risk of a resin spill. Discontinue use of the resin tank and replace it. Resin can be transferred from the old resin tank to the new one.	0.1 h	Incidental	Perform this replacement when prompted by the printer.					X
Resin tank	The printer displays a Mixer Check Failure .	This failure typically occurs when cured resin is left on the resin tank or on the build platform . Inspect both and remove any cured resin. If the mixer decouples in a new or unused resin tank, it may help to remove the resin tank and pour resin directly into the tank to add lubrication . If the error persists, replace the resin tank and contact Formlabs Support or your authorized reseller .	0.3 h	Incidental	Perform this check when the printer displays a Mixer Check Failure .	Guide				X
Resin cartridge	The printer has been in the Filling stage for a prolonged period of time but is not dispensing resin.	Put on a pair of nitrile gloves, close the vent cap on the resin cartridge and remove it from the printer. Turn the cartridge over and locate the black rubber bite valve on the bottom of the cartridge. Squeeze the bite valve several times against the hard shell of the cartridge until it unseals and fully opens. If unable to open the bite valve in this way, please contact Formlabs Support or your authorized reseller .	0.1 h	Incidental	Perform this check if the printer fails to dispense resin.	Guide				X

Resin cartridge	Inspect the resin cartridge thoroughly for leakage, especially around the cartridge skirt and the rubber bite valve.	Do not use the resin cartridge if you notice resin leakage. Place the resin cartridge in a plastic bag and contact Formlabs Support or your authorized reseller .	0.1 h	Incidental	Perform this check before inserting a resin cartridge into the printer.	Formlabs Support or your authorized reseller				X
Resin cartridge	Check to see if the resin is more than 24 months old. The production date is located on a white sticker on the bottom of the cartridge.	Dispose of liquid resin according to environmental regulations.	0.1 h	Incidental	Perform this check before inserting a resin cartridge into the printer.	Guide				X
Resin cartridge	A cartridge is inserted but the touchscreen displays a Cartridge Missing error.	Locate the two metal chips on the underside of the resin cartridge and inspect them for damage or contamination. If the chips are intact, clean them with isopropyl alcohol and cotton swabs.	0.1 h	Incidental	Perform this check when the corresponding error message is displayed.	Guide				X
Touchscreen	A resin tank is inserted but the touchscreen displays a Missing Tank error.	Test a different resin tank to determine if the issue is related to the original resin tank or the printer. If the issue is related to the original tank, locate the two metal chips on the underside of the resin tank and inspect them for damage or contamination. If the chips are intact, clean them with isopropyl alcohol and cotton swabs. Locate and inspect the spring fingers located against the back wall of the printer cavity on the left side.	0.1 h	Incidental	Perform this check when the corresponding error message is displayed.	Guide				X

		Clean these with isopropyl alcohol, wiping in the direction of the long axis.												
--	--	-------------------------------------------------------------------------------	--	--	--	--	--	--	--	--	--	--	--	--

D=Daily, M=Monthly, Q=Quarterly, I=Incidental

Contacting Formlabs Services: <https://support.formlabs.com/s/contact-support>

When contacting Formlabs Services, please provide the following information: A description of the issue, SerialName, PreForm Version, Firmware Version, Resin Type, Resin Lot Number, Layer Height, PreForm File and any relevant photos that might help us understand the problem.