



Quality Checklist

Aleph Objects, Inc. ♦ 626 West 66th Street ♦ Loveland, Colorado 80538 USA

+1-970-377-1111 ♦ www.alephobjects.com ♦ www.lulzbot.com

Model: TAZ 4.0 3D Printer

Serial Number: _____

Date Checked: _____

Checked by: _____

General

- Are all the screws and zip ties tight?
- Are the X and Y axis square to each other?
- Are the gaps at the ends of the extrusion closed?
- Are all the parts flush and straight to the edges with clean lines?
- Are the current version of parts being used?
- Verify that the following are mounted correctly:
 1. Feed tube, tube on back side of mount
 2. Spool Arm, correct height
 3. Double bearing on carriage, step side towards X motor
 4. Finger clip, taller side on left
- Are the switches tight? They shouldn't wiggle side to side.
- Are all 8 rubber feet installed?
- Is the PET tape free of bubbles and wrinkles?
- Is the heat bed adhesive smooth and consistent with no finger prints?
- Does the extruder mount have 4 unused inserts on the sides?
- Does filament slide through the feed tube?

Y Axis

- Does the Y bed move freely back and forth?
- Is the Y bed tight side to side from motion and twisting?
- Are all the screws on the bearing holders tight?



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- Does the Y belt rub the bottom of the y-idler by the bearings?
- Is the Y pulley tight?
- Is one of the set screws on the Y pulley aligned with the flat on the motor shaft?
- Are both pulley set screws tightened?
- Is the level of the Y pulley at the same height as where the belt mounts on the belt holder?
- Is the Y belt tight?
- Are the bed leveling springs/posts in the correct place?
- Are all the Y mounting brackets flush and tight?
- Are the belts trimmed far enough to not interfere with the pulley or bearing?

X Axis

- Is the X pulley tight?
- Is one of the set screws on the X pulley aligned with the flat on the motor shaft?
- Are both pulley set screws tightened?
- Is the belt free from rubbing anywhere during motion?
- Is the X belt tight?
- Does the X axis move freely end to end?
- Are the X bars flush with the left side?
- Are the set screws that hold the X bars tight?
- Are the belts trimmed far enough to not interfere with the pulley or bearing?

Z Axis

- Is the Z adjuster vertical?
- Do the Z drive rods rotate smoothly with no up and down movement between the bearings?
- Are the 4 Z coupler set screws tight and aligned with flats on the drive rods and motors?
- Are the Z smooth rods flush with the top plate?



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Extruder

- Can you adjust the extruder springs?
- Are the V grooves on the extruder gears lined up?
- Is the extruder mount secure on the x-carriage?
- Does the idler bearing stick out of the idler block?
- Is the hobbing aligned to the hole in the extruder?
- Is the set screw in the small gear tight and on the flat of the motor shaft?
- Can you feed filament about 115mm from the top of the extruder?
- Are the gears tight with no back-lash?
- Do the extruder gears turn smoothly for several rotations?

Electronics

- Are the D-Sub connector screws tight?
- Are the LCD connectors in the correct position and pressed in firmly?
- Are the 14 Pos. connectors tight and in the correct position?
- Can you plug in USB cable from the outside of the enclosure?
- Is the plug cover for second extruder installed?
- Are the screws that fasten the control box to the frame tight?