



# QUALITY ASSURANCE RECORD

Model: LulzBot Mini 1.0 3D Printer

Serial Number: \_\_\_\_\_  
Date Completed: \_\_\_\_\_  
Tested by: \_\_\_\_\_

Configuration:

Electronics: Mini-RAMBo 1.1b  
Firmware: Marlin for Mini 2015-Q4  
Nozzle: 0.5mm diameter nozzle  
Settings:

Stepper Motor	Steps/mm	Max Length	Microstep Mode	Digipot
X	100.5	155	16	175
Y	100.5	155	16	175
Z	1600	155	16	220
E0	833	NA	16	135

Z Offset

General:

- Are all the screws and zip ties tight?
- Are the current version of parts being used?
- Is the Spool Mount properly mounted so it flips up and sits securely?
- Is the Finger Clip properly mounted with the taller side on the left?
- Are the switches installed securely?
- Are all 4 rubber feet installed?
- Is the PEI tape free of bubbles and wrinkles?
- Is the heat bed adhesive smooth and consistent?
- Is the frame free of scratches and scuffs?

Y Axis:

- Does the Y bed move freely back and forth?
- Is the Y bed tight side to side from motion and twisting?
- Does the Y belt rub on the y-idler by the bearings?
- Are the Y pulley set screws tight with one aligned with the flat on the motor shaft?
- Is the Y belt tight?
- Are the four bed leveling washers tight?
- Are the belts trimmed far enough to not interfere with the pulley or bearing?





# QUALITY ASSURANCE RECORD

## X Axis:

- Are the X pulley set screws tight with one aligned with the flat on the motor shaft?
- Does the X belt rub on the x-idler by the bearings?
- Does the X belt rub on the screw heads of the belt mount?
- Is the X belt tight?
- Does the X axis move freely end to end?
- Are the belts trimmed far enough to not interfere with the pulley or bearing?
- Are the wires and zip ties behind the carriage free from touching the case wall?

## Z Axis:

- Do the Z drive rods rotate smoothly?
- Are the coupler set screws tight?
- Are the drive rods and motor shafts aligned so the couplers are not bent?

## Extruder:

- Are the extruder springs set to 8mm between the cap and the latch?
- Are the V grooves on the extruder gears lined up?
- Is the hobbing aligned to the hole in the extruder?
- Can you feed filament about 100mm from the top of the extruder?

## Electronics:

- Are all connections to the Mini-Rambo plugged in correctly?
- Are all cables free from contacting any moving parts?

## Test and Verification Results:

- Verify case fan is running.
- Verify extruder blower is running.
- Verify control of the extrusion fan.
- Nozzle temperature control verified.
- Extruder control verified.
- X, Y, and Z min and max stop switches verified.
- Bed leveling is functioning properly.
- Bed temperature control verified.
- Bearing conditioning complete.
- Test print (Octopus\*) successful.
- Print head moved to shipping position.

\*Octopus by yeoldbrian is licensed under CC BY-SA 4.0



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

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