QUALITY ASSURANCE RECORD

Model: LulzBot Mini 2.0 Desktop 3D Printer

Serial Number: _____

Date Completed: _____

Tested by: _____

Configuration:

Electronics: EinsyRetro 1.0a
Firmware: Marlin Version _____
Nozzle: Nickel plated brass – 0.5mm diameter

Motor Axis	Steps/mm	Travel	Microstep Mode	Digipot	Endstop Offset
X	100	160 mm	16 µsteps/step	920 mA	0
Y	100	160 mm	16 µsteps/step	920 mA	0
Z	200	180 mm	32 µsteps/step	960 mA	
E0	420	NA	16 µsteps/step	960 mA	0

General:
- ❑ Are all the screws torqued to spec?
- ❑ Are all the zip ties tight?
- ❑ Does the spool arm flip up and sit securely?
- ❑ Are the switches and bump stops installed securely?
- ❑ Are all 4 rubber feet installed?
- ❑ Is the PEI sheet free of bubbles and wrinkles?
- ❑ Is the frame free of scratches and scuffs?
- ❑ Is the certification sticker free of bubbles, debris, and straight?

Y Axis:
- ❑ Does the Y bed move freely back and forth?
- ❑ Is the Y bed tight side to side from motion and twisting?
- ❑ Is the Y belt free from rubbing 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 tightened to spec?
- ❑ Are the four bed leveling washers tight?
- ❑ Are the belts trimmed far enough to not interfere with the pulley or bearing?

X Axis:
- ❑ Are the X pulley set screws tight with one aligned with the flat on the motor shaft?
- ❑ Is the X belt free from rubbing on the x-idler by the bearings?
- ❑ Is the X belt tightened to spec?
- ❑ Does the X axis move freely end to end?
- ❑ Are the belt ends secured in the tensioning collar, with no interference with the axis travel?
- ❑ Are the wires and zip ties behind the carriage free from touching the case wall?

Z Axis:
- ❑ Are the Z belts tensioned within spec?
- ❑ Are the compression bushing set according to the instructions in the OHAI?
- ❑ Are the belts aligned, and do they not rub?
- ❑ Are the belt ends secured in the tensioning collar, with no interference with the axis travel?
- ❑ Are the Z-Belt tension collars pushed flush to the printed part?
- ❑ Are the pulley set screws tight?

Extruder:
- ❑ Is the Idler tension set in the middle?
- ❑ Is the hobbing aligned to with the idler lever hole?

Electronics:
- ❑ Are all connections to the Einsy plugged in correctly?
- ❑ Are all cables free from contacting any moving parts?
- ❑ Has the protective plastic been removed from the LCD?
- ❑ Has the protective cover been removed from the clear polycarbonate LCD cover?
- ❑ Does the LCD not move up or down or side to side?
- ❑ Is the LCD knob tightly secure to the LCD?
- ❑ Have you verified that the firmware is correct using checksum?
- ❑ Did the printer pass Hi-Pot Testing?

Test and Verification Results:
- ❑ Verify LCD functions normally.
- ❑ Belts aligned on bearings and properly tensioned.
- ❑ Verify case fan is running.
- ❑ Verify heat sink fan is running when machine is powered on.
- ❑ Verify control of the extrusion fan.
- ❑ Nozzle temperature control verified.
- ❑ Extruder control verified.
- ❑ Verify machine can be auto-homed 5x without issues.
- ❑ Verify that both carriages touch the Z-motor mounts when selecting "Level X Axis".
- ❑ Verify probe functions properly (G29 and clean nozzle to check).
- ❑ Wipe Sequence is in center of wipe pad.
- ❑ Z offset calibrated and verified.
- ❑ Bed leveling is functioning properly.
- ❑ Bed temperature control verified.
- ❑ X,Y, Z motion smooth over range and speeds.
- ❑ Threadlocker applied to all pulley set screws.
- ❑ Test print (Octopus*) successful.
- ❑ Re-check all belt tensions.
- ❑ Print head moved to shipping position.

*Sample Octopus based on work by yeoldbrian licensed 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