

# QUALITY ASSURANCE RECORD

## Printer:

Model: LulzBot TAZ Pro Desktop 3D Printer  
 Serial Number: KT-PR0050-\_\_\_\_\_  
 Date Completed: \_\_\_\_\_  
 Completed by: \_\_\_\_\_

## Configuration:

Electronics: Archim 2.2b  
 Firmware: Marlin  
 Nozzle: Hardened Steel 0.5mm (2X)

## Stepper driver settings:

Axis	Steps/mm	Max length	Micro step mode	Current
X	1600	321mm	16 steps/step	975 mA
Y	1600	303mm	16 steps/step	975 mA
Z	500	299mm	16 steps/step	975 mA
E0	420	N/A	16 steps/step	960 mA
E1	420	N/A	16 steps/step	960 mA

## Offsets:

Name	Datum	Relative to	Offset	Backlash
X	E2 nozzle center	E1 nozzle center	mm	mm
Y	E2 nozzle center	E1 nozzle center	mm	mm
Z	E2 nozzle center	E1 nozzle center	mm	mm
Z offset	E1 nozzle center	Top of leveling washers	mm	N/A

## Belt tensions:

Belt	Type	Length	Tension
X	Cut to length	1164	N
Y	Continuous	956	N
Z Left	Continuous	866	N
Z Right	Continuous	866	N



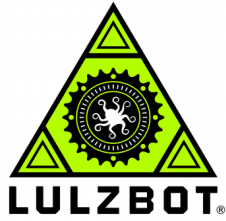


# QUALITY ASSURANCE RECORD

## Final assembly

- There are no loose screws.
- The X and Y axis have been checked for squareness.
- Frame extrusions have been checked and are flush with no gaps.
- The USB drive can be inserted without interference.
- The filament guide tubes are not crossed over.
- The spool arms are at the intended height on the frame.
- The end stop switches are not loose.
- 10 flexible feet are installed.
- The screws that fasten the control box to the frame are torqued to spec.
- There are two caution hot stickers on the back of the x-carriage.
- The extruder mount is not loose on the x-carriage.
- The y-axis mounting brackets are flush to the extrusions and not loose.
- Filament passes through the filament guide tube without interference.
- The touchscreen functions normally.
- The belts are aligned on the idler bearings and properly tensioned.
- The case fan is spinning freely.
- The extrusion fan turns on and off as intended.
- The hot end temperature control is verified.
- The level-during-home feature works as intended and the x-axis is level.
- The cables are secure and free of interference/contact with bed motion.
- The cable connectors fully engaged and oriented correctly.
- Dual linear actuator motion is verified.
- Verify machine can be auto-homed 5x without issues.





# QUALITY ASSURANCE RECORD

## Calibration

- The bearing conditioning (burn in) is complete.
- The X, Y and Z motion is smooth over range and speeds.
- The PEI print surface is free of bubbles and wrinkles.
- The printer passes hi-pot testing.
- Verify automatic calibration and record values.
- The wipe sequence is in center of wiper pad.
- The flat of the nozzle contacts all four bed corners.
- The z-offset is calibrated and verified.
- The bed temperature control verified.
- Test print successful.
- There is no filament error message displayed during the test print.
- Belt tensions are still within spec after burn-in and test prints.
- Print head moved to shipping position.
- The certification sticker free of air bubbles, debris, and is parallel with the edge of the case.



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

[www.alephobjects.com](http://www.alephobjects.com)  
[www.lulzbot.com](http://www.lulzbot.com)  
+1-970-377-1111