

Subject:**Figure 4® Modular**

Managing long-term idle periods for your printer

Issue:

In the event in which the Figure 4 Modular will be off for one month or more, there are certain steps that are recommended to prevent issues from occurring upon starting the machine after the extended shut down.

Solution:**To properly prepare your printer for long-term storage of one month or more:**

Refer to the [Material Changeover](#) or other applicable section of the User Guide for detailed instructions relating to each of the below steps.

1. Power down the printer.
2. Remove material cartridge, tighten ventilation cap, and put the valve cap over the valve.



NOTE: Material may be stored in the material cartridge until the cartridge's labeled expiration date. After the expiration date, dispose of the material according to all government regulations.

3. Remove the MCO Tubing Kit and place it in its provided protective zipper bag.



NOTE: The kit may be stored in the provided bag for up to three months and still be reinstalled and used normally. After three months of idle storage, perform the MCO-kit recovery procedure seen on the next page.

4. Either place the resin-tray lid over the resin tray and store unclamped in the printer, or remove the resin tray and store in its garage.



NOTE: A full resin tray may be stored, properly covered, for three months. After three months of idle storage, dispose of the material according to all government regulations and clean the resin tray.

Please see next page...

To bring the printer back up properly after extended idle time of one month or more:

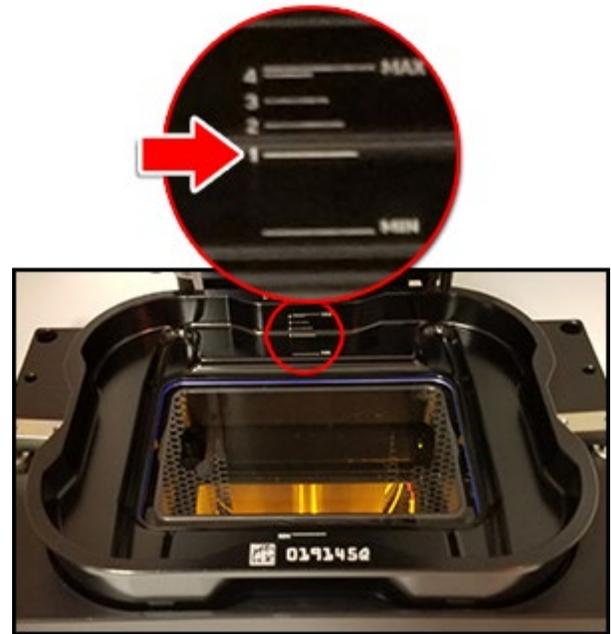
1. Install and/or uncover the resin tray. Stir material stored in the resin tray per [User Guide](#).
2. Install the [MCO tubing kit](#).
3. Install [properly mixed](#) and unexpired material cartridge.
4. Power on printer.

If you were unable to perform these steps prior to leaving the printer for an extended time, when you arrive back after your absence:

1. Remove the material cartridge, cap it on both ends, and mix the cartridge according to the [User Guide](#). Uncap the cartridge and re-insert it in the printer.
2. Insert a cleaned or new resin tray in the printer. If you are using the same resin tray that was in the printer before your extended leave, inspect the tray for punctures or marks around the area where it sits on the Membrane Interface Lip. If the tray is damaged, or if you are unsure if it is damaged, use a new resin tray and contact your reseller.
3. Power on the printer and follow the steps in the User Guide section [Fill Resin Tray from Empty](#). However, instead of letting the tray get to the fill level, you may open the printer door to stop material flow once the material level in the resin tray is at level 1. This is equal to the amount of material in the MCO tubing.



NOTE: Depending on the thickness of the installed material, filling could take a while. If you receive a pump error, clear the error and the printer will pump again.



4. After the filling cycle ends, discard the material according to all government regulations. This old material from the MCO tube cannot be used for printing.
5. Clean the resin tray and re-insert it in the printer. When you close the top door, the filling cycle will begin again.
6. Resume printing as normal.