Problems with Incomplete Prints

SOURCE:
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If there are any deficiencies in the bottom layer of your model, it is most likely due to improper settings in Z-Suite.

To solve this problem, go to Advanced Options -> Surface Layers in Z-Suite and increase the value of the BOTTOM layer by adding additional bottom layers.
Burn Marks on the Model

If burn marks appear on the surface of the model, there may be some problems with the nozzle, for example there are material residues on it.

To solve this problem, clean the nozzle with acetone and the needle (the needle can be found in the Starter Kit box) or replace the nozzle with a new one. See the manuals: Nozzle Cleaning or Nozzle Replacement.
Delamination of Layers (They Split Apart)

The problem of delamination and cracks on the model often happens with large models when the printer was exposed to draught or when an improper material was used.

To solve this problem, remember to avoid draught and print at a temperature of 20 Celsius degrees or more. Use side covers and turn off the bottom fan. To avoid cracking, use material with a low shrinkage level (Z-ULTRAT or Z-HIPS).
Hanging Strands

Inadequate SUPPORT, LAYER THICKNESS and FAN SPEED settings can cause the problem of hanging strands on the model.

To avoid such imperfections on your model, increase the value of the SUPPORT ANGLE. Set the lowest possible LAYER THICKNESS and set additional FAN SPEED – 80-100%.
Irregular Walls or Material Deficiency in the Model

If your model has irregular layers or walls or there is a lack of material on the top and bottom part of the print, here are some possible recommendations:

- clean the nozzle with acetone and the needle (the needle can be found in the Starter Kit box) or replace the nozzle with a new one. See the manuals: Nozzle Cleaning or Nozzle Replacement,

- replace the extruder cable. See the manual: Extruder Cable Replacement

If replacing the extruder cable doesn’t help:

- replace the thermocoupler and the heater. See the manual: Thermocoupler and Heater Replacement,
- replace the extruder PCB. See the manual: Extruder PCB Replacement.
Layers Displacement on the X or Y Axis

Relocated layers appear on models pulleys on the X or Y axis motors are loosened.

To solve this problem, tighten the screws on the pulleys on the X or Y axis motors. See the manual: [Eliminating Axis Problems](#).
Missing Walls

If there are walls missing on your model, LAYER THICKNESS settings are probably inadequate.

Redesign the model and place it on the platform so that the walls in X and Y plane are not 0.4mm thick or less. Printing 0.4mm or less is possible in a plane perpendicular to Z axis and with right LAYER THICKNESS settings.
Problem with Extrusion

If you can hear a clicking sound coming from the extruder motor during the material loading or printing, at first check if your cables are connected properly. See the picture.

If the cables are connected properly, check if there are no material remains in the extruder. See the manual: Extruder Maintenance.

If the problem still occurs, the extruder cable is probably damaged. Replace the extruder cable. See the manual: Extruder Cable Replacement.

If replacing the extruder cable doesn’t help:

- replace the thermocoupler and the heater. See the manual: Thermocoupler and Heater Replacement,
- replace the extruder PCB. See the manual: Extruder PCB Replacement.
Raft Does Not Stick to the Platform

While printing large models or when the platform maintenance was not run properly, or when the printer was exposed to draught, it is possible that the raft may not stick to the platform.

To solve this problem, calibrate the platform and run platform maintenance. See the manuals: Platform Calibration and Platform Maintenance.

Remember to avoid the draught and print at a temperature reaching 20 Celsius degrees or more. Use side covers to keep a stable temperature inside the chamber.
The Size of Holes is Too Small

While designing holes in your model you have to keep in mind that the designed hole should be bigger than the desired one. The hole should be ~0,3mm bigger than the one you want obtain.

You can redesign your model or use OFFSETS -> HOLES in Advanced Options in Z-Suite.