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> KOYOFEI Creality CR-6 SE Extruder Kit Instruction Manual

KOYOFEI KYF-3D-065

KOYOFEI Creality CR-6 SE Extruder Kit

Instruction Manual

1. PRODUCT OVERVIEW

The KOYOFEI Creality CR-6 SE Extruder Kit is an upgraded filament feeding system designed for Creality CR-6 SE and CR-6 MAX 3D printers. This kit features an improved filament feeding gear for smooth and stable extrusion, and a user-friendly design for effortless one-hand filament feeding. It is engineered for high wear resistance and durability, supporting various 1.75mm filaments including PLA, ABS, and soft materials like TPU with Bowden extrusion.

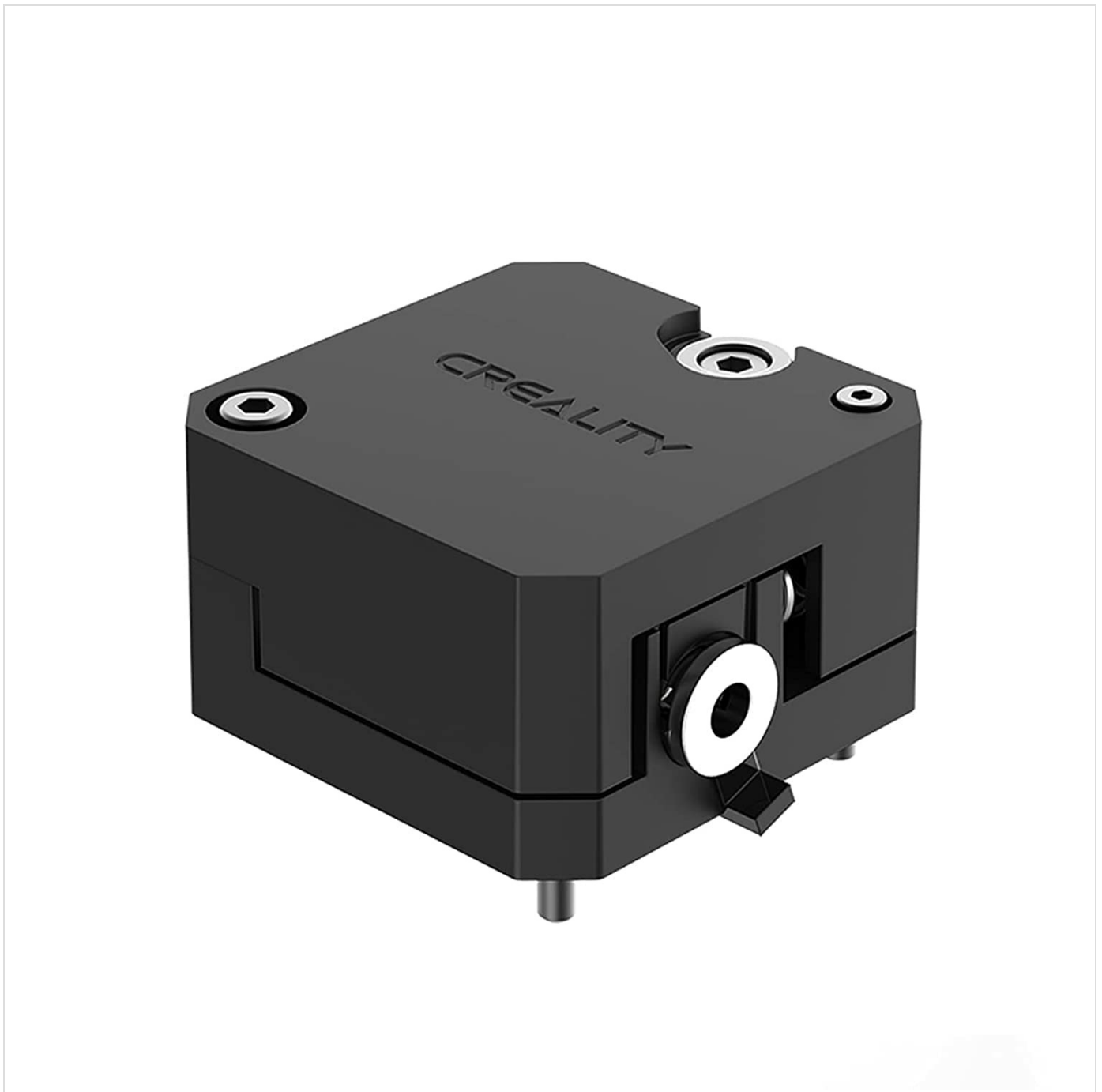


Image 1.1: The KOYOFEI Creality CR-6 SE Extruder Kit, a compact black unit designed for 3D printers.

2. PACKAGE CONTENTS AND COMPONENTS

Before beginning installation, please verify that all components are present in your kit. The extruder kit is not pre-assembled and requires assembly prior to installation on your 3D printer.

CR-6 SE Extruder Anatomy Graphics



Image 2.1: Exploded view of the CR-6 SE Extruder Kit, showing all individual components including the main body, gears, springs, and various screws.

Creality CR-6 SE Extruder | Inventive Design



Image 2.2: A close-up view of the disassembled Creality CR-6 SE Extruder, highlighting its internal mechanism and components.

List of Components:

- Extruder main body (front and back halves)
- Extruder gear (brass)
- Idler wheel/bearing
- Tension spring
- Lever arm/clip
- Various screws and fasteners
- Pneumatic fittings
- Blue clip for Bowden tube retention

3. SETUP AND INSTALLATION

This section outlines the general steps for assembling and installing the extruder kit. Due to the modular nature of 3D

printers, specific steps may vary slightly depending on your printer's configuration. It is recommended to consult your 3D printer's original manual or online resources for detailed disassembly/assembly instructions for your specific model.

3.1. Extruder Assembly:

1. Carefully unpackage all components and lay them out on a clean, flat surface.
2. Insert the brass extruder gear onto its shaft within one half of the extruder body. Ensure it rotates freely.
3. Place the idler wheel/bearing into its designated slot.
4. Position the tension spring correctly, ensuring it applies pressure to the lever arm.
5. Align the two halves of the extruder body, ensuring all internal components are correctly seated.
6. Secure the two halves together using the provided screws. Do not overtighten.
7. Attach the lever arm/clip to the extruder body, ensuring it can pivot freely to open and close the filament path.
8. Install the pneumatic fittings into the designated ports on the extruder body.

3.2. Installation on 3D Printer:

1. **Power Off:** Ensure your 3D printer is powered off and unplugged from the mains before beginning any work.
2. **Remove Old Extruder:** Carefully disconnect the Bowden tube and any wiring from your existing extruder. Unscrew and remove the old extruder assembly from the printer frame.
3. **Mount New Extruder:** Align the new KOYOFEI extruder kit with the mounting points on your printer frame. Secure it in place using the appropriate screws.
4. **Connect Bowden Tube:** Insert the Bowden tube firmly into the pneumatic fittings on the new extruder. Use the blue clip to secure the tube in place if provided.
5. **Reconnect Wiring:** If applicable, reconnect any motor or sensor wiring to the new extruder. Ensure connections are secure and correct.
6. **Test Movement:** Manually check that the extruder lever operates smoothly and that the filament path is clear.

Product Showcase

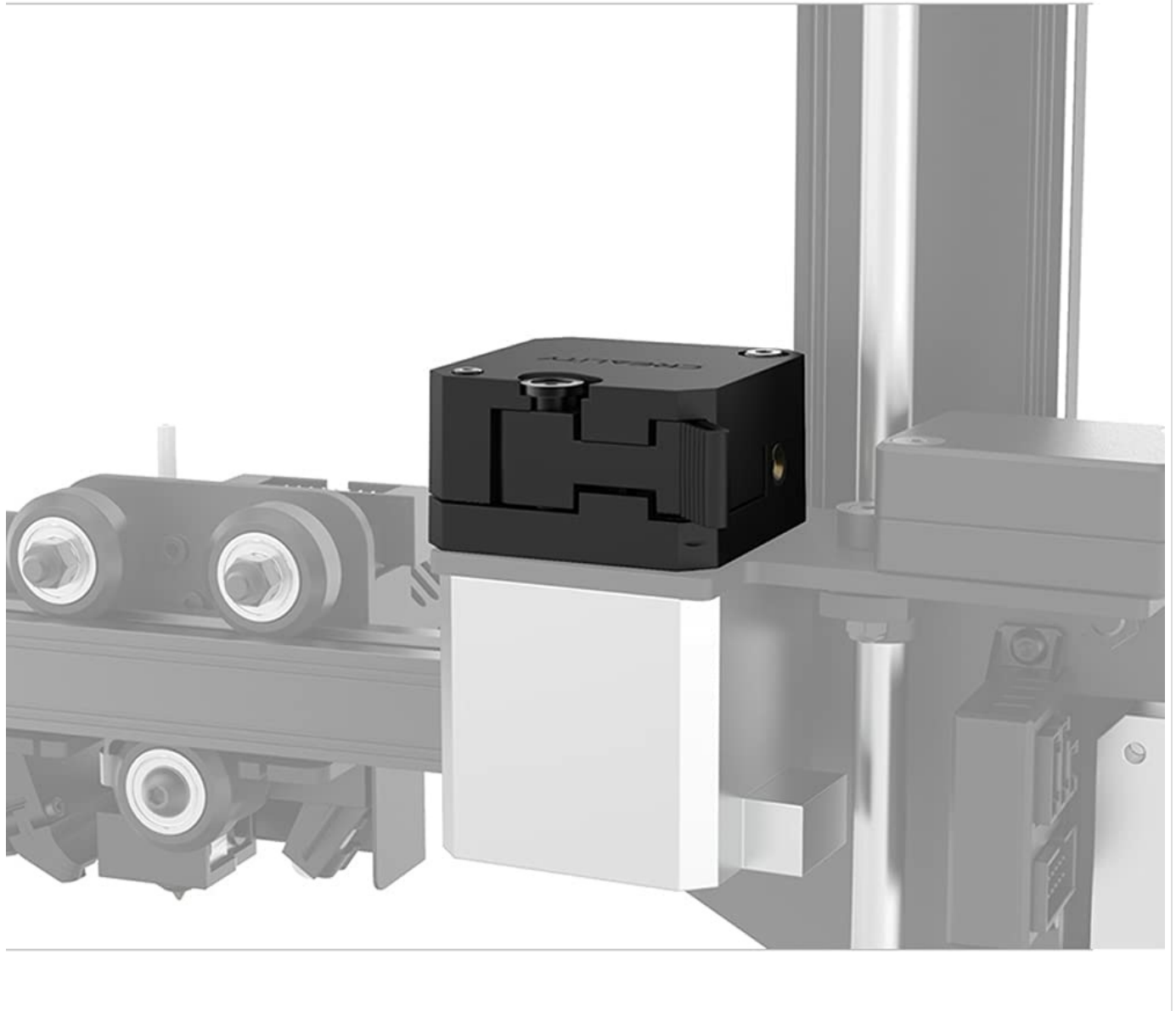


Image 3.1: The KOYOFEI extruder kit shown mounted on a 3D printer frame, demonstrating its integrated appearance.

4. OPERATING INSTRUCTIONS

This extruder kit is designed for ease of use, particularly for filament loading.

4.1. Filament Loading:

1. **Prepare Filament:** Ensure the end of your 1.75mm filament is cut cleanly and at an angle to facilitate easy insertion.
2. **Open Extruder Clip:** Gently press the extruder clip (lever arm) to open the filament path. This releases the tension on the filament gear.
3. **Insert Filament:** Insert the prepared filament into the extruder's input hole. Guide it through until it passes the extruder gear and enters the Bowden tube.
4. **Secure Filament:** Release the extruder clip. The spring tension will engage the filament with the gear, holding it securely.
5. **Verify Feed:** Manually push the filament slightly to ensure it moves smoothly through the extruder and into the

Effortless Filament Feed-in with One Hand User-friendly Design

Hey! You don't have to press hard on the extruder clip with one hand and feed in the filament with another hand, any more!



1. Prepare your filament.
2. Open the extruder clip, and insert the filament into the extruder.
3. Make sure the filament is well fed in, and lock the extruder clip.

Image 4.1: A visual guide demonstrating the one-hand filament feeding process, showing the steps of preparing filament, opening the clip, inserting filament, and securing it.

CR-6 SE Extruder Kit

New design | Smooth extrusion | Stable feed | Quick cooling

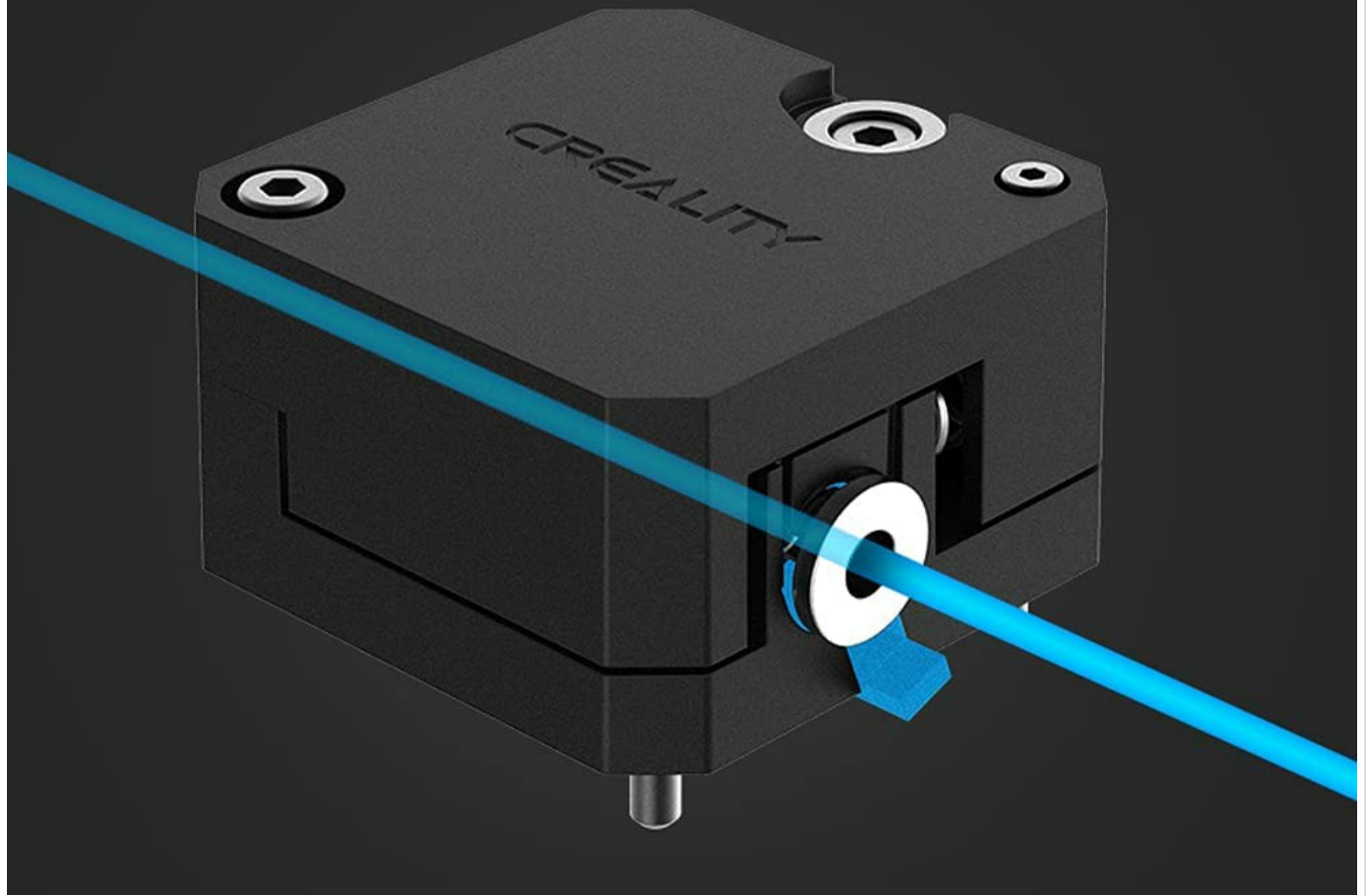


Image 4.2: The CR-6 SE Extruder Kit with a blue line indicating the filament path, illustrating smooth extrusion and stable feeding.

4.2. Filament Unloading:

1. **Heat Nozzle:** If the printer was recently printing, heat the nozzle to the printing temperature of the filament to soften any melted plastic.
2. **Open Extruder Clip:** Press the extruder clip to release tension on the filament.
3. **Pull Filament:** Gently pull the filament upwards and out of the extruder.

5. MAINTENANCE

Regular maintenance ensures optimal performance and longevity of your extruder kit.

- **Clean Extruder Gear:** Periodically inspect the extruder gear for any accumulated filament dust or debris. Use a small brush or compressed air to clean it.
- **Check Tension Spring:** Ensure the tension spring provides adequate pressure on the idler wheel. If the spring

appears weak or damaged, it may need replacement.

- **Inspect Pneumatic Fittings:** Verify that the Bowden tube is securely seated in the pneumatic fittings. Loose fittings can lead to filament grinding or inconsistent extrusion.
- **Lubrication:** The extruder gear typically does not require lubrication. Avoid applying lubricants that could attract dust or interfere with filament grip.
- **Component Wear:** While the extruder gear is reinforced for durability, regularly check for signs of excessive wear on the gear teeth or idler wheel. Replace components as needed.

6. TROUBLESHOOTING

This section addresses common issues you might encounter with your extruder kit.

Problem	Possible Cause	Solution
Filament not feeding / Grinding	Clogged nozzle, insufficient extruder tension, worn extruder gear, tangled filament.	Clear nozzle clog. Adjust extruder tension. Inspect and replace worn gear. Untangle filament spool.
Inconsistent extrusion	Loose Bowden tube fittings, partial nozzle clog, inconsistent filament diameter, extruder motor issues.	Secure Bowden tube fittings. Clear partial clog. Use quality filament. Check extruder motor connections.
Filament difficult to load/unload	Improperly cut filament end, cold nozzle (for unloading), misaligned filament path.	Cut filament end cleanly and at an angle. Heat nozzle before unloading. Check for obstructions in filament path.
Extruder clicking sound	Nozzle clog, print speed too high, print temperature too low, insufficient extruder tension.	Clear nozzle. Reduce print speed. Increase print temperature. Adjust extruder tension.

7. SPECIFICATIONS

Detailed specifications for the KOYOFEI Creality CR-6 SE Extruder Kit.

Product Name: CR-6 SE Extruder Kit

Model Number: KYF-3D-065

Color: Black

Applicable Models: Creality CR-6 SE, Creality CR-6 MAX

Filament Diameter: 1.75 mm

Compatibility: Supports PLA, ABS, TPU, and other 1.75mm filaments with Bowden extrusion.

Key Features: Upgraded filament feeding gear, effortless one-hand filament feeding, reinforced extruder gear for high wear resistance.

Package Dimensions: 4.61 x 3.19 x 2.6 inches

Item Weight: 3.53 ounces

Manufacturer: KOYOFEI

First Available: November 11, 2021

Wide Compatibility

Capable of printing all 1.75mm filament, and compatible to print soft material like TPU with Bowden extrusion.



Image 7.1: Illustration of the extruder's wide compatibility with various 1.75mm filaments, including PLA, ABS, and TPU.

8. WARRANTY AND SUPPORT

For information regarding product warranty, please refer to the terms and conditions provided by your retailer or contact KOYOFEI directly. KOYOFEI specializes in 3D printer accessories and can provide further assistance.

Manufacturer: KOYOFEI

Seller: Koyofei (via Amazon)

For technical support or inquiries, please visit the official KOYOFEI store or contact their customer service channels.

