

## **Possible errors with lack of material pressure in extruder.**

First, check if the pump can turn with full rpm, if not, check if the heating of the extruder is sufficient, check hydraulic flow and pressure, engine rpm ect.

1. Check if the shutters/gates can open fully, check the function of the shutters from the computer, the solenoids or directly on the shutter with a spanner or similar.
2. Separation of thermoplastic paint in the connection between the tank and the extruder pump or in the bottom of the extruder. Blocks of hard paint, or major impurities, in the system, can also cause this problem.



3. The screw pump shaft can be worn out due to much work or much work with very abrasive paint.  
The measure on a new shaft is 118 mm.



4. The Teflon rope sealing on the top of the shaft is too tight and therefore restricting the turning of the pump shaft.