



Ultimaker S5 Pro Bundle

Installation and user manual

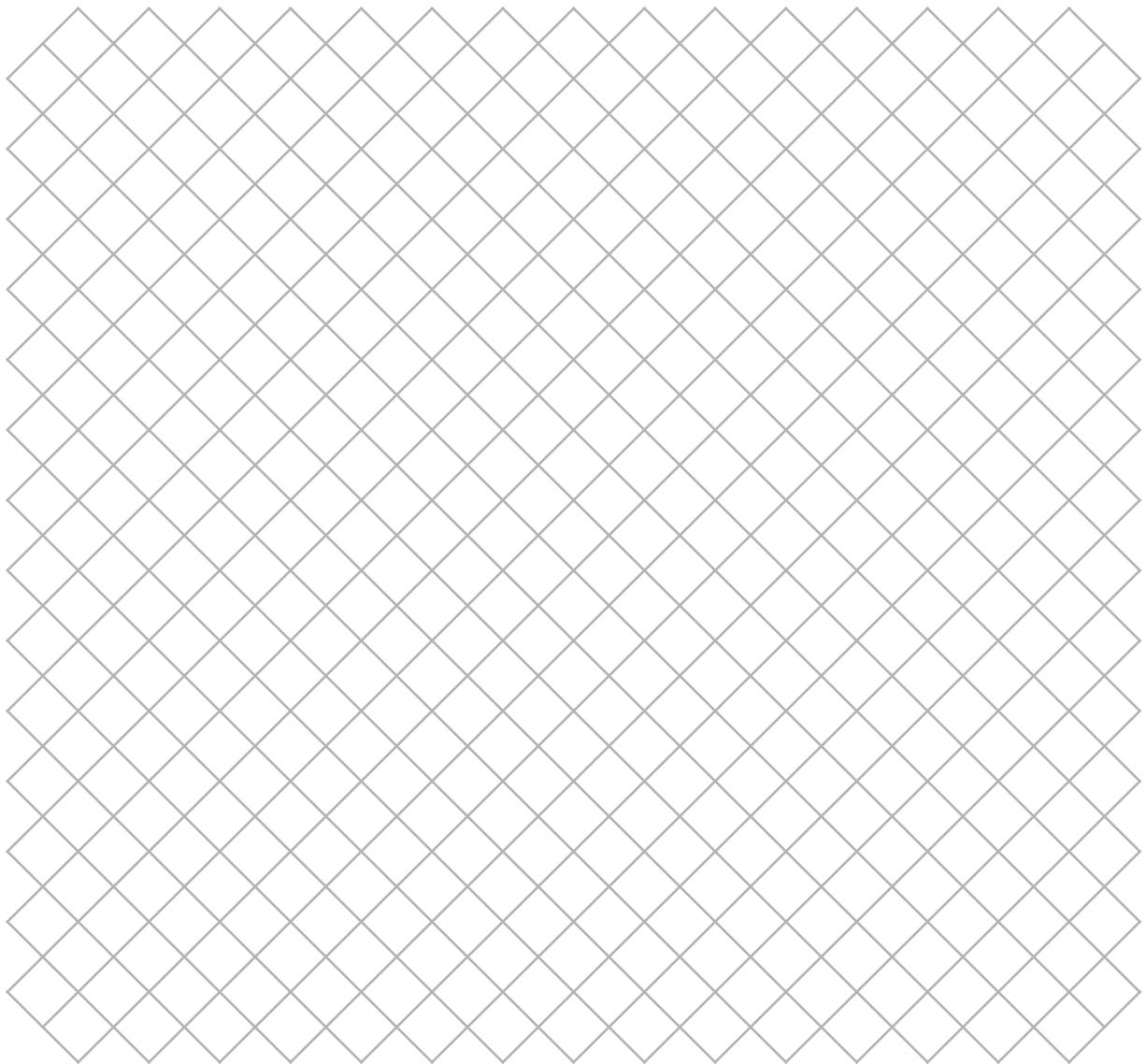




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Disclaimer

Please carefully read and understand the contents of this installation and user manual. Failure to read the manual may lead to personal injury, inferior results or damage to the Ultimaker S5 or its peripherals. Always make sure that anyone who uses this 3D printer knows and understands the contents of the manual to make the most out of the Ultimaker S5 Pro Bundle.

The Ultimaker S5, together with the Material Station and the Air Manager form the Ultimaker S5 Pro Bundle. This user manual specifically describes the intended workflow and operation for the Ultimaker S5 Pro Bundle.

The conditions or methods used for assembling, handling, storage, use or disposal of the device are beyond our control and may be beyond our knowledge. For this and other reasons, Ultimaker does not assume responsibility and expressly disclaims liability for loss, injury, damage, or expense arising out of or in any way connected with the assembly, handling, storage, use, or disposal of the product.

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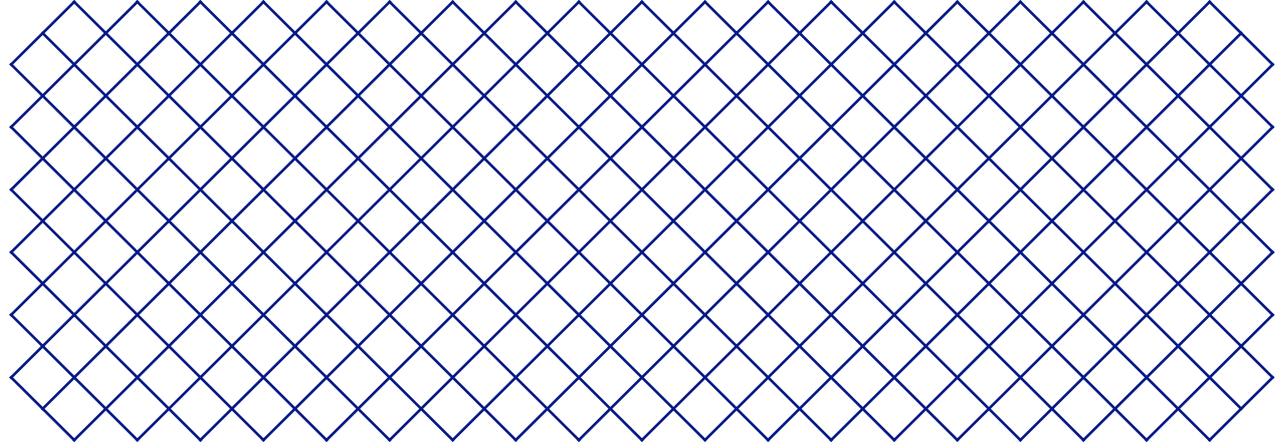
Intended use

The Ultimaker S5 Pro Bundle is a unique combination of the Ultimaker S5, Ultimaker S5 Air Manager, and the Ultimaker S5 Material Station, which operate together.

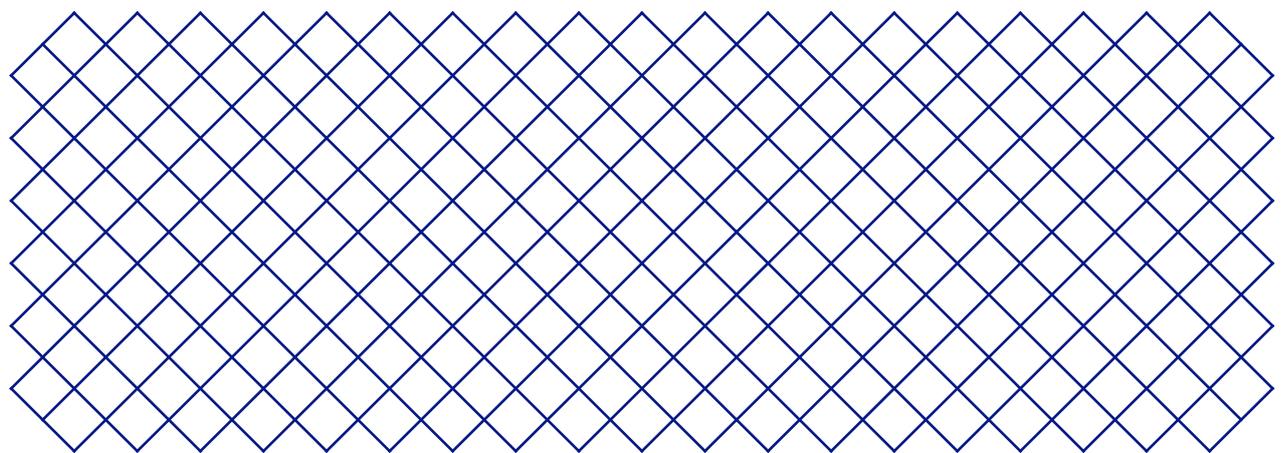
Optimized software profiles precisely control Air Manager filtering for every Ultimaker material and compatible third-party filaments. No worries about ultrafine particles (UFPs), and no extra time is required configuring your printer.

The Material Station and Air Manager empower the Ultimaker S5 to deliver high-quality 3D printed parts and models at maximum output. The Ultimaker S5 Pro Bundle's huge capacity and end-to-end material handling increases print success rate, print quality, and uptime to 24/7 reliable production while minimizing human error, print job time, and operator time.

The Ultimaker S5 Pro Bundle is built to deliver; it boosts confidence to unlock more demanding applications with an extended range of materials, while busy engineers and designers can focus all day doing their best work.



1. Safety and compliance



1.1 Safety messages

This guide contains warnings and safety notices.

The information provided below is applicable to the Ultimaker S5, Material Station, and Air Manager (“Ultimaker S5 Pro Bundle”).

 Provides additional information that is helpful to do a task or to avoid problems.

 Warns of a situation that may cause material damage or injuries if the safety instructions are not followed.

1.2 General safety information

The following safety information is applicable:

- The Ultimaker S5 generates high temperatures and has hot moving parts that can cause injury. Never reach inside of the Ultimaker S5 while it is in operation. Always control the printer with the touchscreen at the front or the power switch at the back. Allow the Ultimaker S5 to cool down for 5 minutes before reaching inside
- Do not change or adjust any parts of the Ultimaker products unless the change or adjustment is authorized by the manufacturer
- Do not store items inside Ultimaker products, except for compatible filament spools within the Material Station
- Ultimaker products are not intended for use by persons with reduced physical and/or mental capabilities, or lack of experience and knowledge, unless they are supervised or have been given instructions concerning the use of the appliance by a person responsible for their safety
- Children should be under constant supervision when using Ultimaker products
- Do not touch the fan of the Air Manager when changing the filter

1.3 Hazards

Electromagnetic compatibility

This equipment has been tested and found to be compliant with the limits for a Class A digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy, and if not installed and used in accordance with the instruction manual may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference, in which case the user will be required to correct the interference at his or her own expense.

An electrostatic discharge in some metallic parts of the device may cause the interruption of NFC communications, affecting the initial detection of the material spool. In these cases, a device restart should solve the problem.



Electrical safety

- ⚠️ Ultimaker products have been tested according to the IEC 62368-1. All relevant products have undergone and passed Hi-pot testing before shipment. This test guarantees the right level of insulation against electrical shock. An earthed mains socket must be used. Be sure that the building installation has dedicated means for over-current and short-circuiting. For more information, please visit our website for the CB certificate. The printer is powered by mains voltage, which is hazardous when touched. This has been marked with a high-voltage symbol on the bottom cover. Only trained staff should remove the bottom cover.
- ⚠️ Always unplug Ultimaker products before performing maintenance or modifications

Mechanical safety

- ⚠️ Ultimaker products are compliant with the Machine Directive 2006/42/EU. The EC declaration of conformity can be found on our website. The Ultimaker S5 contains moving parts. No damage to the user will be expected from the drive belts. The force of the build plate is large enough to cause damage, so stay out of the reach of the build plate during operation.
- ⚠️ Always unplug the Ultimaker products before performing maintenance or modifications.

Risk of burns

There is a potential risk of burns: the print head of the Ultimaker S5 can reach temperatures up to 280 °C, while the heated bed can reach temperatures of 140 °C. Do not touch either of these parts with your bare hands.

- ⚠️ Always allow the Ultimaker products to cool down for 30 minutes before performing maintenance or modifications.



1.4 Health and safety

 3D printing thermoplastics may result in the release of Ultra Fine Particles (UFPs) and Volatile Organic Compounds (VOCs) depending on the thermoplastic used and settings of the 3D printer.

The Ultimaker products are designed for use with Ultimaker materials and are open for use with materials from third-party suppliers.

Ultimaker materials

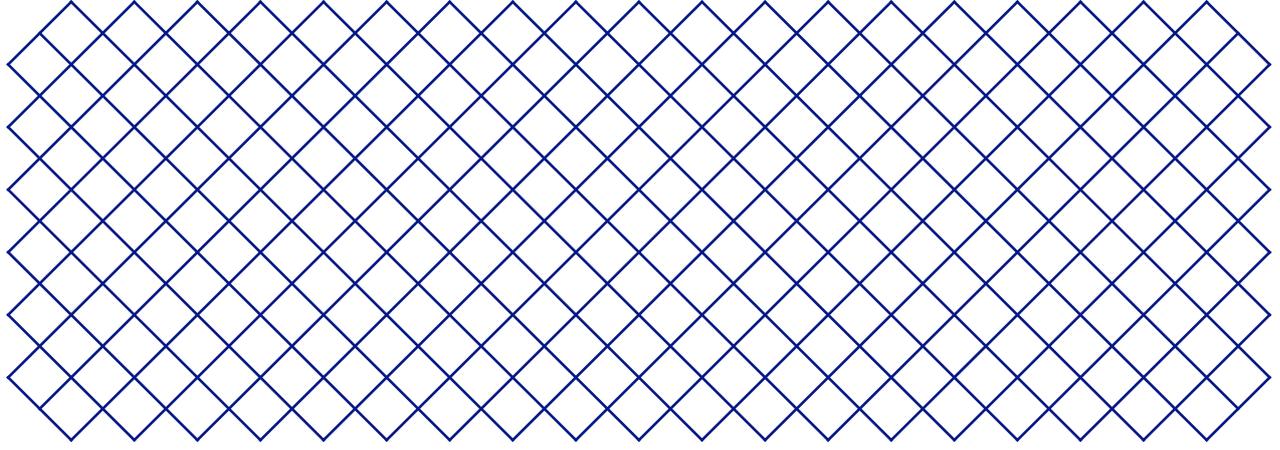
Ultimaker materials can be printed safely without any filtering using the recommended temperatures and settings in a well-ventilated area (minimum refresh rate of 1.8 for a room size of 30.6 m²). When multiple Ultimaker 3D printers are operated in a contained environment, emissions of UFPs and/or VOCs may vary. Please consider other safety measures, such as a filter, cabinet and/or dedicated ventilation system depending on your specific situation.

Third-party materials

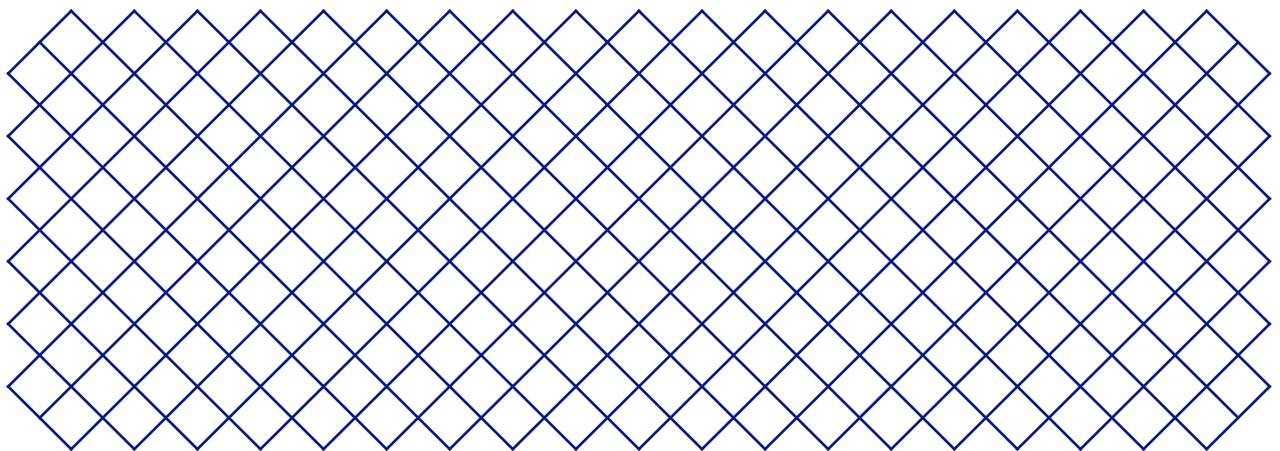
Third-party material manufacturers can supply print profiles that contribute to reliable results with Ultimaker hardware (“The Ultimaker Material Alliance Program”).

The use of print profiles and materials from Ultimaker’s Material Alliances and/or other suppliers may require additional safety measures, such as a filter, for the safe usage of such materials. Please take the relevant information provided by the supplier of such filament/material into account at all times for safe operation. Please check the safety data sheet of each specific material for more information.

Ultimaker cannot be held responsible for any adverse effects from the use and/or performance of these materials.

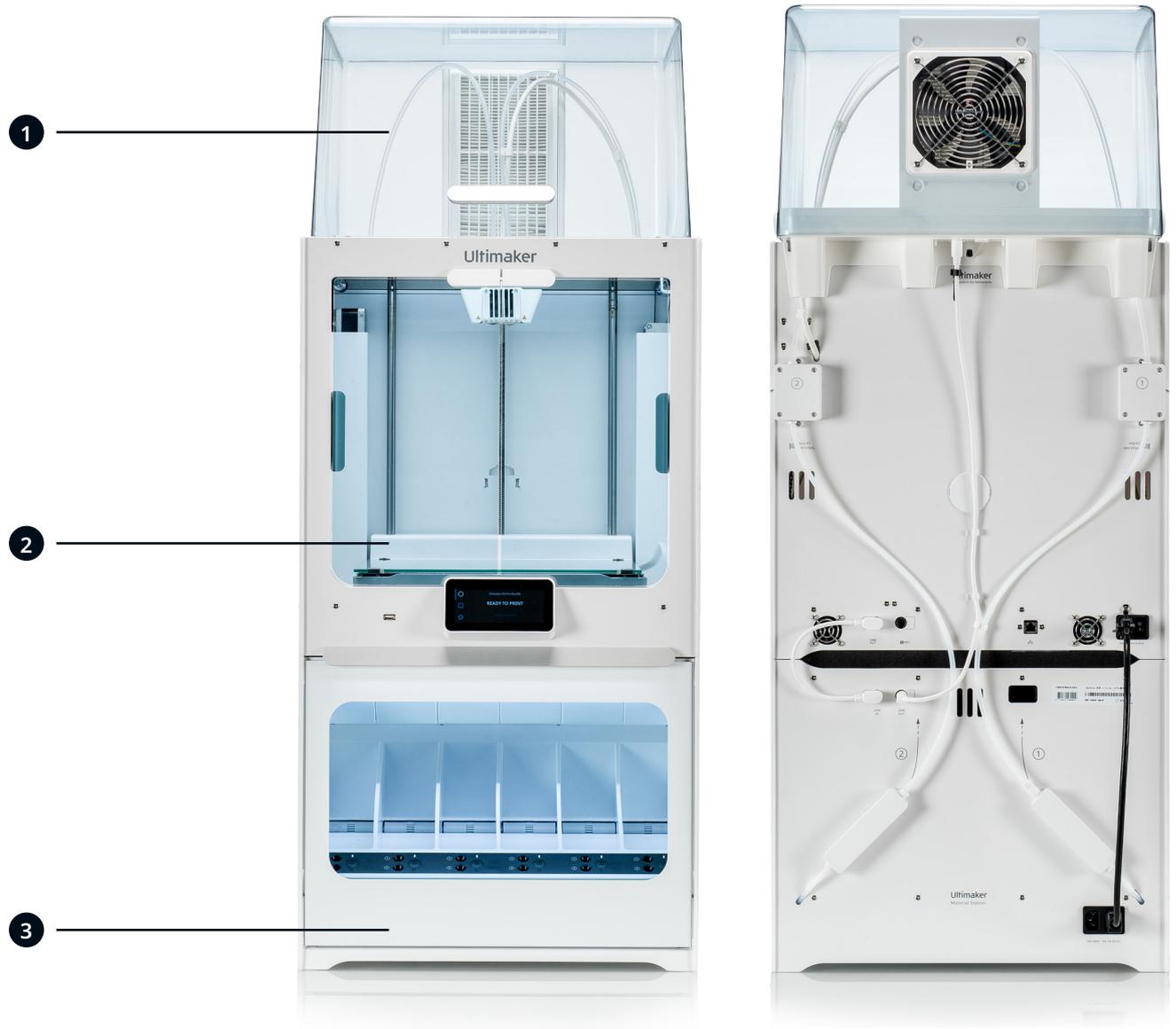


2. Introduction



2.1 Main components

Ultimaker S5 Pro Bundle

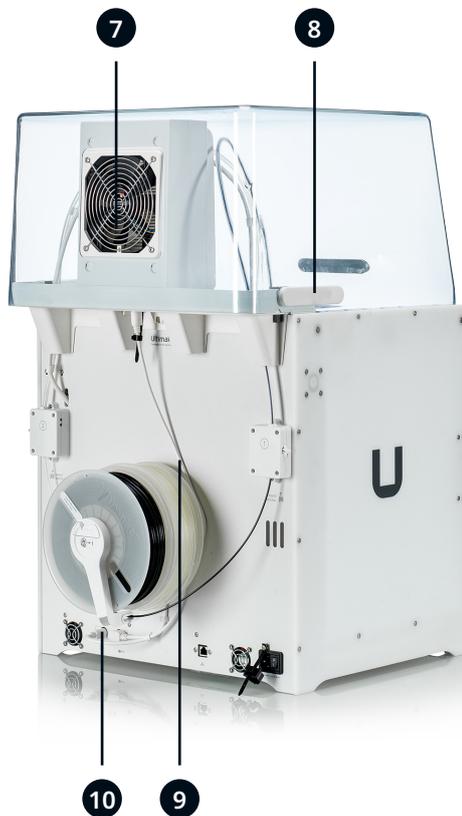


1. Air Manager
2. Ultimaker S5
3. Material Station

Air Manager and Material Station



- 1. Cover
- 2. Filter housing
- 3. Filter
- 4. Handle
- 5. Stress relief



- 6. Mounting bracket
- 7. Fan
- 8. Hinge
- 9. Air Manager cable
- 10. UMB OUT port

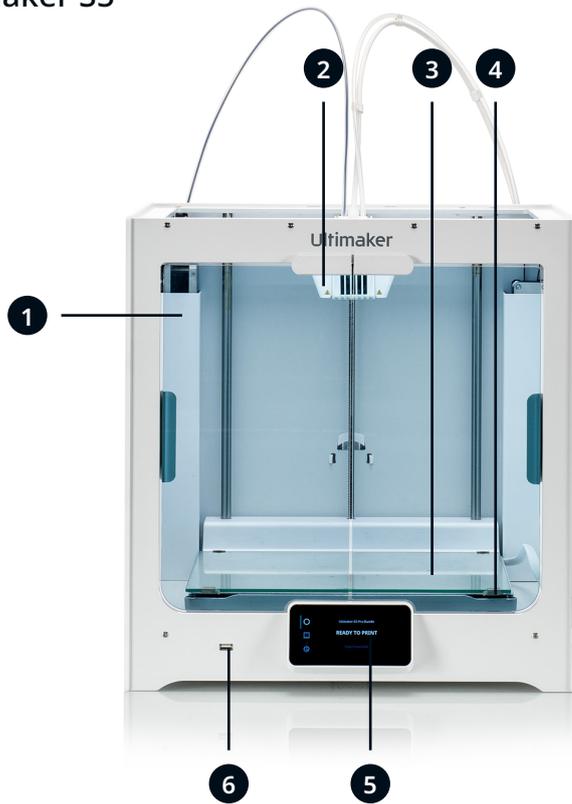


- 1. Glass door
- 2. Material bay
- 3. Filament entry ports 1(top) and 2 (bottom)
- 4. Eject button



- 5. UMB IN port
- 6. UMB OUT port
- 7. Dehumidifier exhaust
- 8. Decoupler
- 9. Power entry

Ultimaker S5



1. Glass doors
2. Print head
3. Build plate
4. Build plate clamps
5. Touchscreen
6. USB port



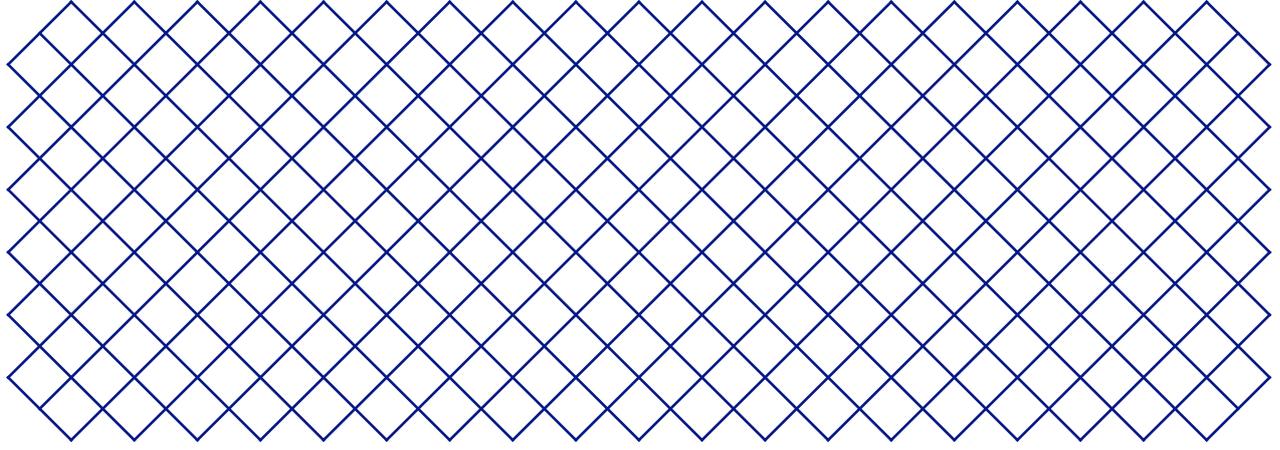
7. Feeder 2
8. Bowden tubes
9. Feeder 1
10. Power socket and switch
11. Ethernet port
12. Double spoolholder with NFC cable*
13. NFC socket

* Not used in the full Ultimaker S5 Pro Bundle

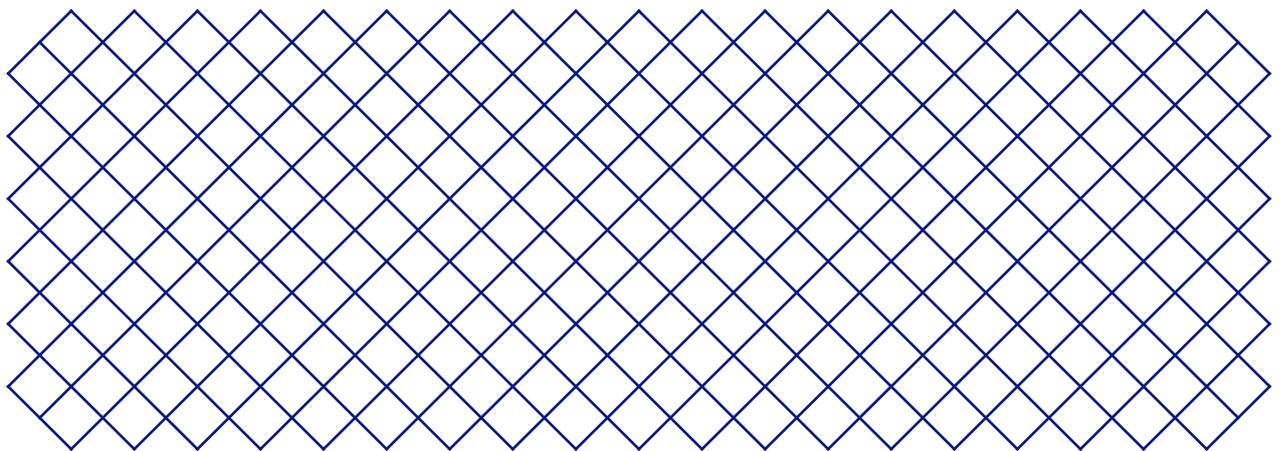
2.2 Specifications

Ultimaker S5 Pro Bundle specifications

Properties	Technology	Fused filament fabrication (FFF)
	Print head	Dual-extrusion print head with a unique auto-nozzle lifting system and swappable print cores
	Build volume (XYZ)	330 x 240 x 300 mm (13 x 9.4 x 11.8 in)
	Layer resolution	0.25 mm nozzle: 150 - 60 micron 0.4 mm nozzle: 200 - 20 micron 0.6 mm nozzle: 300 - 20 micron 0.8 mm nozzle: 600 - 20 micron
	XYZ resolution	6.9, 6.9, 2.5 micron
	Build speed	<24 mm ³ /s
	Build plate	Heated glass build plate (20 - 140 °C)
	Nozzle diameter	0.4 mm (included) 0.25 mm, 0.6 mm, 0.8 mm (sold separately)
	Operating sound	< 51 dBA
	Connectivity	Wi-Fi, LAN, USB port
Air Manager	Filter technology	EPA filter
	Fan technology	Air extraction by low-noise brushless fan
	Filter efficiency	Up to 95%
	Filter replacement	Recommended every 1,500 print hours (approx. 1 year)
Material Station	Filament diameter	2.85 mm
	Material Spool dimensions	Width: 50 - 70 mm (2 - 2.7 in) Diameter: 197 - 203 mm (7.8 - 8 in) Core diameter: > 98 mm (3.8 in)
	Feeder type	Dual-gear, abrasion-resistant
Power requirements	Input	100-240 VAC, 50-60 Hz
	Output	Max. 600 W
Physical dimensions	Dimensions	495 x 500 x 1197 (19.5 x 19.5 x 47.1 in)
	Net weight	42 kg (92.6 lbs)
Software	Supplied Software	Ultimaker Cura, our free print preparation software Ultimaker Connect, our free printer management solution Ultimaker Cloud, enables remote printing
	Supported OS	MacOS, Windows and Linux
Warranty	Warranty period	12 months



3. Installation



3.1 Unboxing

The Ultimaker S5 Pro Bundle consists of three products, each packaged separately. The Ultimaker S5, the Material Station, and the Air Manager come in reusable, durable packaging, specially designed to protect the products. Follow the steps below properly to unpack your Ultimaker S5 Pro Bundle.

i Please retain all packaging for warranty purposes.

Ultimaker S5

i We recommend removing the packaging with the box placed on the floor for safety.

1. Remove the plastic locking clips from the lower section of the box
2. Holding the handles, lift the upper section of the box to reveal the printer
3. Lift the top foam section away from the printer, pulling the print head cable free
4. Remove the cardboard insert with the materials from the top of the printer
5. Place the printer on a flat surface

⚠ When placing the printer on a shelf or table, take proper measures to prevent the printer from falling.

6. Slide the center seal at the bottom of the glass doors to one side, then remove all remaining seals
7. Carefully open the glass doors and take out the accessory box and foam pieces from inside the printer
8. Remove the plastic protection from the touchscreen

⚠ If the printer needs to be transported without the outer box, be aware of the weight and dimensions of the printer. According to the UL 60950-1 definition, the printer is not portable. Use proper transport means to do so safely.

Material Station

1. Remove the plastic locking clips from the lower section of the box
2. Holding the handles, lift the upper section of the box
3. Remove the quick start guide, the safety and warranty information booklet, and the bag with accessories
4. Remove the two foam pieces from the top of the Material Station
5. Lift the Material Station out of the bottom tray and place it on a flat surface

Air Manager

1. Remove the plastic locking clips from the lower section of the box
2. Holding the handles, lift the upper section of the box
3. Remove the quick start guide and the safety and warranty information booklet
4. Remove the six foam pieces

The rest of the boxes will be removed during the installation of the Air Manager.

3.2 What's in the box

Each of the products in the Ultimaker S5 Pro Bundle comes with a quick start guide and several hardware accessories:

Ultimaker S5

Accessories

1. Glass build plate
2. Spool holder with material guide¹
3. Power cable
4. Ethernet cable
5. USB stick
6. Print core AA 0.4²
7. Print core BB 0.4
8. XY calibration sheet
9. Calibration card
10. Nozzle cover (3x)

Consumables

11. Tough PLA (750 g)
12. PVA (750 g)
13. Glue stick
14. Oil
15. Grease

Tools

16. Hex screwdriver 2 mm

¹The spool holder and filament guide are not required for the Ultimaker S5 Pro Bundle

²Another print core AA 0.4 is placed in print head slot 1 of the Ultimaker S5

Material Station

1. Tube coupling collet (2x)
2. Clamp clip (2x)
3. Spool holder cap
4. Material Station cable
5. Power extension cable
6. Wire cutters

Air Manager

1. Cover
2. Filter housing
3. Filter
4. Mounting bracket
5. Removal tools
6. Bag with screws + key
7. Cable + clips

3.3 Hardware installation

The Ultimaker S5 Pro Bundle will be installed in three stages. First, the Ultimaker S5 will be prepared, followed by the Material Station. Third, the Air Manager will be mounted. Finish the Pro Bundle installation by connecting all cables.

Ultimaker S5

1. Remove the clamp clips from the print head and insert the Bowden tubes. The Bowden tubes connect to the corresponding numbers on the print head.
2. Secure the Bowden tubes with the clamp clips
3. Fit the print head cable clips onto Bowden tube 2 and divide equally
4. Open the glass doors and the two build plate clamps at the front of the build plate
5. Gently slide the glass plate onto the build plate and ensure that it snaps into the build plate clamps at the back
6. Close the two build plate clamps at the front to secure the glass build plate and close the glass doors

Material Station

1. Carefully place the Ultimaker S5 on top of the Material Station
2. Insert a tube coupling collet in the bottom of each feeder of the Ultimaker S5
3. Insert the left Bowden tube of the Material Station into the left feeder, and the right Bowden tube into the right feeder
4. Secure the Bowden tubes with clamp clips
5. Place the spool holder cap into the hole of the Ultimaker S5's spool holder

Air Manager

1. Align the mounting bracket with the back of the Ultimaker S5
2. Guide the Bowden tubes and print head cable into both mounting bracket slots. Above feeder 2, make sure that the Bowden tube is placed in front of the print head cable
3. Gently push down on the mounting bracket until it clicks firmly into place
4. Align the bottom of the filter housing with the slots in the mounting bracket and push it into place
5. Gently push the filter completely into the filter housing
6. From the front of the printer, place the cover over the filter housing
7. Align the hinges with the mounting bracket and drop the cover into place

Connections

1. Connect the Air Manager cable to the port at the back of the Air Manager
2. Place the stress relief clip attached to the mounting bracket around the Air Manager cable and close it
3. Slide the stress relief clip upwards until it cannot go further to secure the cable in place
4. Connect the other side of the Air Manager cable to the **UMB OUT** port on the Material Station
5. Connect the Material Station cable to the **UMB IN** port on the Material Station and the other end to the **UMB OUT** port on the Ultimaker S5
6. Connect the power extension cable to the Ultimaker S5 and the Material Station
7. Connect the power cable to the Material Station and the other end to a power outlet

3.4 Welcome setup

To perform the setup steps, turn on the printer using the power switch at the back. You will first be asked to select your preferred language. After this, the welcome setup will appear on the touchscreen. Follow the steps on the touchscreen and described on the next pages of this user manual.

i The language on the printer can always be changed by navigating to *Preferences* → *Settings* → *Language*.

Confirm that the glass build plate is installed

For the first use, it is recommended to print with the materials that were delivered with the printer: (Tough) PLA and PVA. In this step of the welcome setup, you must confirm that you have installed the glass build plate.

A thin layer of glue should be applied to the glass build plate to ensure reliable adhesion.

Print core installation

Print cores

The Ultimaker S5 uses two interchangeable print cores in the printhead. There are three types of print cores:

- Type AA: for printing build materials and Ultimaker Breakaway material
- Type BB: for printing water-soluble support material
- Type CC: for printing composite materials

Each Ultimaker S5 comes with two print cores AA 0.4 (of which one is already installed in print head slot 1) and one print core BB 0.4. This means that it is possible to print with two build materials or with a build and support material.

The print cores contain information on a small chip, so that the printer always knows which print cores are installed and which materials can be used with each print core.

Install the second print core

During the welcome setup, the second print core must be installed. To do this, go to *Print core 2* and select *Start*. Follow the steps on the Ultimaker S5:

1. Carefully open the glass doors and the print head fan bracket and press *Confirm*
2. Install the second print core (BB 0.4) in print head slot 2 by squeezing the levers of the print core and sliding it into the print head until you hear a click

i Do not touch the contact points on the back of the print core with your fingers.

⚠ Make sure to keep the print core completely vertical while installing it, so it will smoothly slide into the printhead

3. Carefully close the print head fan bracket and press *Confirm* to proceed with the welcome setup

Load filament

Before you can start printing with the Ultimaker S5 Pro Bundle, you need to load materials into the Material Station. For the first use, it is recommended to use the spools of Tough PLA and PVA that come with the printer.

⚠ If the welcome setup shows how to install the spool holder, the Material Station is not yet recognized by the Ultimaker S5. The Material Station will only function correctly when your Ultimaker S5 is running supported firmware. Using an unsupported version may cause damage to your printer. Skip loading material, go directly to *Network Configuration*, and first install the latest firmware. See section 3.5 for more information about updating the firmware.

- 
1. Unpack the spool of Ultimaker Tough PLA Black
 2. Use the wire cutters to cut off the piece of filament hooked in the spool. Ensure that the filament has a short, sharp tip before loading the filament
 3. Place the spool of filament into one of the material bays of the Material Station with the NFC tag on the left side
 4. Insert the tip of the material into filament entry port 1 until the prefeeder grabs the material
 5. Wait for the Material Station to detect the material and select *Confirm* to continue

i When using a third-party material, you can manually select the material type.

6. Repeat the steps above for Ultimaker PVA Natural, but insert it into filament entry port 2

You can load more materials in the Material Station at this point, or do so later by navigating to the configuration menu. See chapter 4 - 'Operation' - for more information.

Network installation

The Ultimaker S5 can connect to a local area network, using either Wi-Fi or Ethernet. To connect to a network, select *Network setup* from the welcome setup list. If you want to set up a wireless network connection, select *Wi-Fi setup*. If you want to use Ethernet, or don't want to set up network connectivity, select *Skip*.

Set up Wi-Fi

To connect your Ultimaker S5 to a wireless network, you will need a computer or a smartphone. Start the Wi-Fi setup and follow the steps on the touchscreen:

1. Wait until your printer has created a Wi-Fi hotspot. This may take a moment
2. Use a computer or smartphone to connect to the printer. The name of the Wi-Fi network is shown on the printer's touchscreen
3. A pop-up will appear on the display of your computer or smartphone. Follow the steps to connect the printer to your local Wi-Fi network. The pop-up will disappear when you have completed these steps

i If the pop-up does not appear, open a browser and go to a website that is not yet known by your browser.

i Within some network environments the Ultimaker S5 may experience difficulties connecting wirelessly. When this happens, repeat the Wi-Fi setup from another computer or smartphone.

4. Go back to the Ultimaker printer and wait until the Wi-Fi setup is finished

i If you skip the Wi-Fi setup during the welcome setup, you can start it again by going to *Preferences* → *Network* → *Start Wi-Fi setup*.

Connect via Ethernet

You can set up a wired network connection after completing the welcome setup by performing the following steps:

1. Connect one end of an Ethernet cable to the Ethernet port at the back of the printer
2. Connect the other end of the cable to a network source (router, modem, or switch)
3. Enable Ethernet in the network menu by navigating to *Preferences* → *Network* and enabling Ethernet

3.5 Firmware update

After completing the welcome setup, the Ultimaker S5 will check if the latest firmware is installed as a final step. If an older version is detected, it will download the latest firmware and install it. This process may take several minutes to complete.

You will only be prompted to install the latest firmware if the printer is connected to a network and an older firmware version is detected. Visit ultimaker.com/firmware to check if the latest version is currently installed.

The Material Station and Air Manager will only function correctly when your Ultimaker S5 is running firmware that supports them. Using an unsupported firmware version may cause damage to your printer.

3.6 Install Ultimaker Cura

After successfully setting up your printer, please install Ultimaker Cura – Ultimaker’s free print preparation and management software – on your computer. You can download Ultimaker Cura at ultimaker.com/software.

i For more information about Ultimaker Cura and system requirements, please consult the Ultimaker Cura user manual at ultimaker.com/manuals

After downloading, run the installer to complete the installation of Ultimaker Cura. When opening Ultimaker Cura for the first time, you will be asked to select your 3D printer. Select the Ultimaker S5 profile, and you are ready to go. You can now directly connect to the printer and start using Ultimaker Cura.

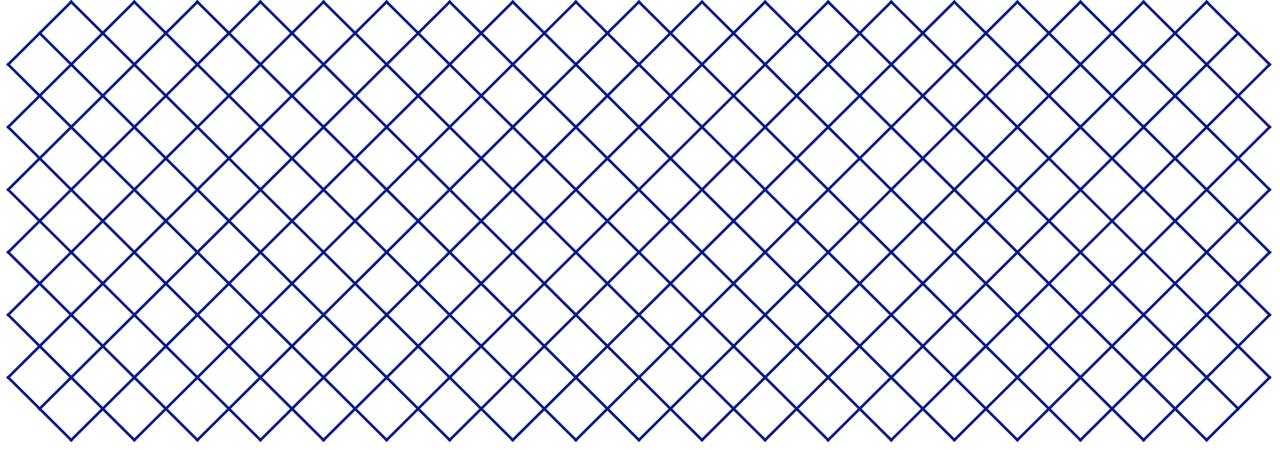
i For best printing results, always use the latest version of Ultimaker Cura (version 4.3 and above)

3.7 External ventilation (optional)

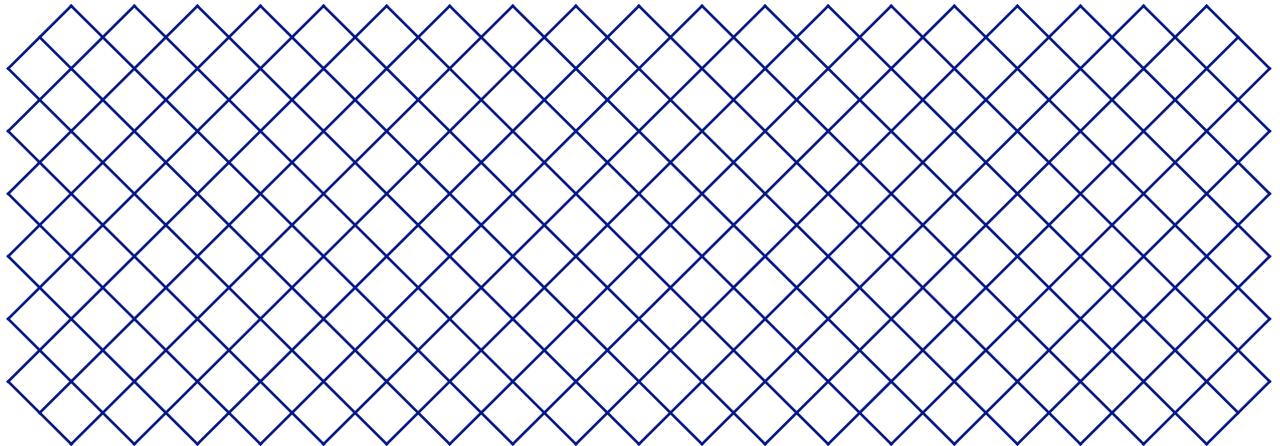
The Ultimaker S5 Air Manager can be connected to an external exhaust system. At the back of the Air Manager, holes in the cover facilitate this. The accessory box of the Ultimaker S5 includes four M4x16 bolts, four M4 lock nuts, and a 2.5 mm hex key. These can be used for the installation.

1. Download the airflow connector STL from ultimaker.com and print it
2. Insert the four lock nuts into the recesses in the airflow connector
3. Open the Air Manager cover
4. Insert the four bolts from the inside through the holes in the cover of the Air Manager
5. Align the airflow connector with the bolts and use the 2.5 mm hex key to secure the connector to the Ultimaker S5 Air Manager’s cover
6. Connect your ventilation system to the airflow connector

i The implemented fan control will not interact with the external exhaust system. It may be necessary to tune the airflow of the external system. An airflow of 50m³/h is recommended when the fan is running at top speed. A hose guided outside (not attached to a ventilation system) is also supported. A diameter of >120 mm and a maximum length of 2 m are recommended.



4. Operation



4.1 Touchscreen

You can control the Ultimaker S5 Pro Bundle by using the touchscreen at the front of the printer.

When turned on for the first time the Ultimaker S5 Pro Bundle will run the welcome setup. After this, the main menu will be shown when turning the printer on.

Interface

The main menu offers three options, represented by the following icons:

-  **The status overview** is automatically shown next to the main menu. From here, you can start a print from USB or view the progress of the print while printing.
-  **The configuration overview** shows the current configuration of the printer. Here you can see which print cores and materials are installed, as well as change the configuration.
-  **The preferences overview** consists of three sub-menus: settings, maintenance, and network. In the printer settings menu you can change general settings, such as the language. In the maintenance menu, the most important maintenance and calibration procedures can be performed, in addition to saving logs for diagnostics. The network menu allows you to change network settings or perform the Wi-Fi setup.

4.2 Materials

Material compatibility

The Ultimaker S5 comes with two AA print cores and one BB print core. The AA print cores can be used for printing build materials and Breakaway support material. The BB print core can be used for water-soluble support material (PVA).

The Ultimaker S5 Pro Bundle supports all Ultimaker materials that are currently available, of which most can be printed with the 0.25, 0.4, and 0.8 mm print core sizes. The print core CC Red 0.6 can be used for third-party composite materials.

-  For an overview of possible dual-extrusion material combinations, please refer to the Ultimaker website.

All Ultimaker materials have been extensively tested and have optimized profiles in Ultimaker Cura to ensure the best print results. Therefore, for the highest reliability, it is advised to use one of the default profiles in Ultimaker Cura. Using Ultimaker materials will also allow you to benefit from the NFC detection system. Ultimaker spools will be automatically recognized by the Ultimaker S5 Material Station. This information can be directly transferred to Ultimaker Cura when connected to a network, for a seamless connection between the printer and Ultimaker Cura software.

Spools with the following dimensions are compatible with the Material station:

- Width: 50 - 70 mm (2 - 2.7 in)
- Diameter: 197 - 203 mm (7.8 - 8 in)
- Core diameter: > 98 mm (3.8 in)



Print recommendations

Each material requires different settings for optimal results. If you use Ultimaker Cura to prepare your model, these settings are automatically set correctly if the correct print core(s) and material(s) are selected.

It is recommended to apply a thin layer of glue (using the glue stick from the accessory box) or an adhesion sheet to the glass build plate before starting a print. This will ensure that your print adheres reliably to the build plate, and also prevents the glass build plate from chipping when removing materials.

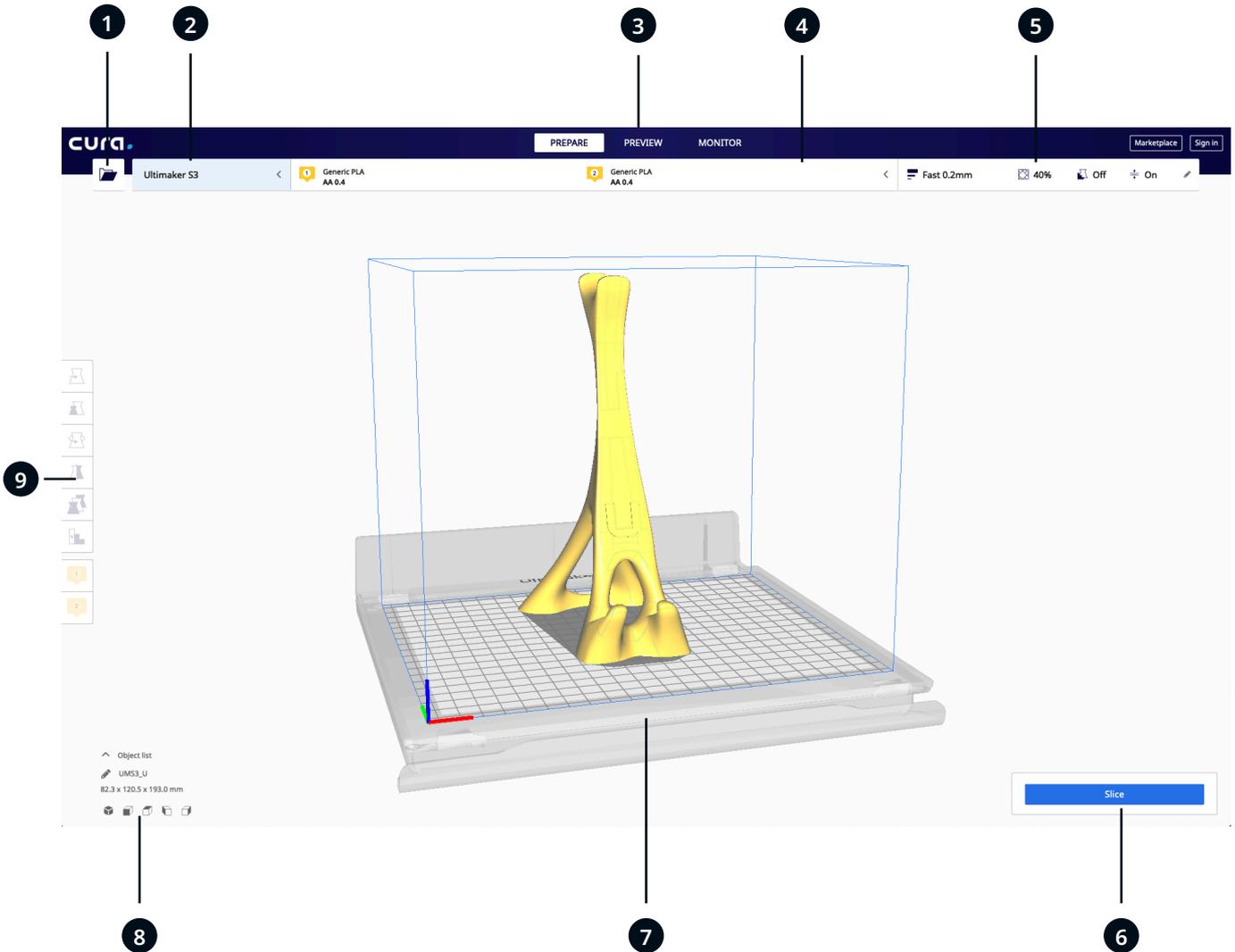
For detailed instructions on which settings and adhesion method to use per material, take a look at the material manuals on the Ultimaker website.

To benefit from the automatic material switching during a print when a spool runs out, it is recommended to have at least two spools of the same material loaded into the Material Station.

4.3 Preparing a print with Ultimaker Cura

Interface

After you have added the Ultimaker S5 in Ultimaker Cura, the main interface will become visible. Here is an overview of the user interface (UI):



UI elements:

1. Open file
2. Printer selection panel
3. Stages
4. Configuration panel
5. Print settings panel
6. Action panel
7. 3D Viewer
8. Camera position tool
9. Adjustment tools

Ultimaker Cura workflow is arranged in three stages, seen at the top of the interface. These are the prepare, preview and monitor stages.

Prepare stage

Load a model and prepare it for slicing in the prepare stage of Ultimaker Cura.

1. Load the model(s) by clicking the 'open file' folder icon
 2. In the configuration panel, select the material type you wish to print with
- ⓘ When printing with a networked printer the loaded configuration is detected. You can select from the different configurations of your Material Station to prepare your print more quickly.
3. Use the adjustment tools to position, scale and rotate the model as desired
- ⓘ The adjustment tools are visible when a model is loaded and selected on the 3D viewer.
4. Select your desired settings (layer height/print speed, infill, support, and build plate adhesion) in the Print Settings panel
- ⓘ When printing with support, you have the option to select the extruder that you want to use to print the support structure. This allows you to print your model with PVA support, Breakaway support, or build material support.
5. When satisfied with your print settings and print strategy, press the *Slice* button on the action panel
 6. When slicing is complete, the action panel will direct you to the preview stage

Preview stage

The preview stage allows you to see exactly how your model will be printed. Use the different color schemes to get various information about your model. You can view the different line types, differentiate infill from skin, or use the X-Ray view to detect gaps within your model.

When satisfied with your model print preview, the action panel guides you to print over the network if connected to a networked Ultimaker 3D printer.

- ⓘ Alternatively, you can save the G-Code to a USB for printing with offline printers.

For more information on the preview stage, see the Ultimaker Cura user manual found on the Ultimaker website.

Monitor stage

The monitor stage utilizes the Ultimaker Connect functionality so that you can easily monitor the status of your networked Ultimaker printer.

When printing on a networked Ultimaker printer you can send your print jobs directly from Ultimaker Cura to the printer. The status of the printer will change to printing, and you can begin to track the print's progress. You can also queue multiple print jobs and view them in the print queue.

Ultimaker Cloud

The Ultimaker S5 Pro Bundle benefits from integration with Ultimaker Cloud. To make the most out of your Ultimaker printer, you must first associate the printer with your Ultimaker account.

For more information on the Ultimaker Cloud, visit mycloud.ultimaker.com.

4.4 Remove the print

Once your 3D print is finished, it must be removed from the build plate. There are several methods to do this.

- ⚠ When using a brim, be aware of the danger of cutting yourself when removing the print from the build plate. Use a deburring tool to remove the brim once the print is taken from the build plate.

Wait for cooldown

If you printed directly onto the build plate, simply allow the build plate and the print to cool down after printing. The material will contract as it cools, allowing you to easily remove the print from the build plate.

Use a spatula

If your print is still adhered to the build plate after cooling, you can use a spatula to remove the print. Place the spatula under the print, parallel to the build plate, and apply a small amount of force to remove the print. A spatula can also be used to carefully remove remaining parts of the print from the build plate, such as the brim or support structures.

- ⚠ Take the build plate out of the printer to avoid damaging the build plate clamps.

Use water

If you printed on the build plate with glue and if neither of the above methods are effective, remove your print using water. Remove the build plate with print from the printer. Be careful not to burn your fingers if the build plate is still warm. Run cool tap water on the back side of the plate to quickly cool it. The print material will contract more than with normal cool down. Once cool, the print will pop off.

Alternatively, you can run lukewarm water over the print side of the plate to dissolve the glue. Once the glue is dissolved, it is easier to remove the print. If PVA was used, place the build plate and print in water to dissolve the PVA. This makes print removal easier.

Once the print has been removed and the build plate is placed back in the printer, select *Confirm removal* on the display of the Ultimaker S5. This will allow the next print job to start.

4.5 Remove support material

Dissolve PVA support

PVA support structures can be removed by dissolving the PVA in water. This takes several hours and leaves no trace afterwards.

1. **Submerge the print in water.** By placing a print with PVA in water, the PVA will slowly dissolve. This process can be sped up by using:
 - Warm water. Warm water will decrease the dissolving time. When using PLA for the build material, ensure that the water is no hotter than 35 °C, otherwise the PLA part may deform. Never use water above 50 °C, as this increases risk of burning
 - Stirring. Use stirred/running water to decrease the dissolving time. Moving water enables the PVA to dissolve more quickly (in some cases under three hours, depending on the amount of support material used)
 - Pliers. You can also speed up PVA dissolution by placing the print in water for approximately 10 minutes, then removing most of the support with pliers. When the print is placed back in the water, only the remaining parts of PVA will need to be dissolved
2. **Rinse with water.** After PVA supports are totally dissolved, rinse the print with water to remove any excess PVA
3. **Let the print dry completely** and apply additional post-processing to the build material if desired
4. **Disposal of waste water.** PVA is a biodegradable material, and in most cases disposing of used water afterwards is easy. However, it is recommended that you check local regulations for more comprehensive guidance. The water can be disposed of down the drain, providing your waste water distribution network is connected to a wastewater treatment plant. After disposal, run hot water from the tap for approximately 30 seconds to remove any excess saturated PVA water and to avoid longer-term clogging issues

It is possible to use the water for more than one print, however this might extend the dissolving time. Through repeated use, the water becomes saturated by previously dissolved PVA. For the quickest result, fresh water is recommended.

Remove Breakaway support

Prints using Ultimaker Breakaway as support material will require post-processing to remove the support structures. This can be achieved by breaking the support structures from the build material.

 It is advised to wear protective gloves when the support structure contains sharp corners or when working with bigger models.

1. **Tear the inner support structure.** Start by removing the walls of the support structure with a gripping plier. This allows you to quickly tear away the majority of the inner support structure
2. **Pull the Breakaway support from the build material.** After removing most of the support structure, the remaining part(s) can be pulled from the build material. Use cutting pliers to grip the Breakaway support in a corner and try to carefully get underneath it, then bend it upwards. Repeat this for several corners, so that you can loosen the support from the model around the corners. After this, pull the Breakaway support from the model
3. **Peel the last traces from the model.** Sometimes a final layer of the support material remains after pulling the Breakaway support from the build material. If this happens, use cutting pliers to peel it off from a loose edge. Any leftover traces on the model can be removed with tweezers

4.6 Change the printer configuration

Changing materials in the Material Station is easy and intuitive. This is possible during printing as well as in an idle state:

1. Gently open the glass door of the Material Station
 2. Press the eject button of the corresponding material bay to unload the filament
- i** The materials in use during a print are blocked from unloading. Pressing the eject button of an active material will not have any effect.
3. Remove the material spool from the material bay
- i** When removing a spool that is not yet empty, put the end of the filament through the small hole in the spool to prevent unwinding. Store the material according to the recommended storage conditions as described in section 5.2
4. Take a new spool and use the wire cutters to ensure that the filament has a short, sharp tip before loading the filament
 5. Place the spool of filament into the material bay of the Material Station with the NFC tag on the left side
 6. Insert the tip of the material into filament entry port 1 or 2 until the prefeeder grabs the material
 7. Wait for the Material Station to detect the material and select *Confirm* to continue
- i** Alternatively, select the material type manually.
8. Close the glass door of the Material Station
- i** Removing an empty spool does not require pressing the eject button. There will be a length of filament left at the end of an empty spool. This will rewind back into the Material Station. It is recommended to timely remove empty spools from the Material Station.

Change print core

Print cores can be easily changed on the Ultimaker S5 by using the procedure from the menu. Besides changing print cores, you also have the option to only load or unload a print core:

1. Go to the configuration menu, select the print core you want to change and select '*Change*'
 2. Wait for the print core to heat up, unload the material, and cool down again
 3. Open the glass doors of the Ultimaker S5 and the print head fan bracket and '*Confirm*' when completed
 4. Remove the print core carefully by squeezing the levers and sliding the print core out of the print head
- ⚠** Do not touch the contact points on the back side of the print core with your fingers.
- i** Make sure you keep the print core completely vertical while removing or installing it so it will smoothly slide into/out of the print head.
5. Insert a print core by squeezing the levers of the print core and sliding it into the print head slot until you hear a click
- i** It is possible that the print core includes a ring around the nozzle. Remove this nozzle ring before using the print core on the Ultimaker S5. Learn more about this on the Ultimaker website.
6. Carefully close the print head fan bracket and *Confirm* when completed
 7. Wait for the Ultimaker S5 to load the material into the print core

4.7 Calibration

Build plate leveling

While using the Ultimaker S5, build plate calibration should be performed to ensure reliable adhesion of the print to the build plate. If the distance between the nozzles and build plate is too wide, your print won't properly adhere to the glass build plate. On the other hand, if the nozzles are too close to the build plate, it can prevent material from extruding.

⚠ Make sure there is no excess material below the tip of the nozzles and the build plate is clean before the start of a print or when you want to calibrate the build plate, or you might get inaccurate results.

Active leveling

Active leveling is automatically performed by the printer at the start of a print to create a reliable first layer. During active leveling, the Ultimaker S5 will create a detailed heightmap of the build plate surface. This information is used to compensate for any inaccuracies of the build surface during the first layers of the print. It will do this by adjusting the build plate height while printing.

⚠ Do not touch the Ultimaker S5 during the active leveling procedure, as this could affect the calibration process.

Manual leveling

Perform manual leveling when the level of the build plate is too far out of range for active leveling to compensate for.

1. Go to *Preferences* → *Maintenance* → *Build plate* → *Manual leveling* and select *Start*
2. Wait while the Ultimaker S5 prepares the manual leveling procedure
3. Use the touchscreen controls to move the build plate until there is approximately 1 mm distance between the first nozzle and the build plate. Make sure that the nozzle is close to the build plate without touching it. Select *Confirm* to continue
4. Adjust the front-right thumb wheel to roughly level the front of the build plate. There should be a distance of approximately 1 mm between the nozzle and build plate
5. Repeat step 4 for the front-left thumb wheel and select *Confirm* to continue
6. Place the calibration card inbetween the nozzle and build plate. Use the touchscreen controls to adjust the position of the build plate until you feel some resistance when moving the card. Select *Confirm* to continue

⚠ Do not apply force to the build plate while fine-tuning with the calibration card, as this will lead to leveling inaccuracies.

7. Place the calibration card in between the nozzle and build plate in the front right corner. Adjust the thumb wheel until you feel some resistance when moving the card. Select *Confirm* to continue
8. Repeat step 7 for the front left corner and select *Confirm* to continue

i After calibrating the build plate with the first nozzle, the second nozzle needs to be aligned as well, to ensure the heights of both nozzles are set correctly. For this it is only necessary to set the correct height by using the calibration card.

9. Place the calibration card in between the second nozzle and build plate. Use the controls to adjust the position of the build plate until you feel some resistance when moving the card. Select *Confirm* to continue
10. Wait for the printer to finish the manual leveling procedure



XY offset calibration

Besides the vertical offset, the horizontal distance between the nozzles in the X and Y direction also needs to be configured. The print cores that are supplied with the Ultimaker S5 are already calibrated, but when the printer detects a new combination, you will need to perform an XY offset calibration again. This calibration must only be done once; after this, the information is stored on the printer. A correct XY calibration will ensure that the two colors or materials align well.

- i** To perform the calibration you will need an XY calibration sheet, which can be found in the accessory box or downloaded at ultimaker.com/XYcalibration.

Ensure 2 print cores and materials are installed before starting the calibration.

To start the calibration:

1. Go to *Preferences* → *Maintenance* → *Print head* → *Calibrate XY offset* and select *Start calibration*
2. The Ultimaker S5 will now print a grid pattern on the build plate. Wait until it is complete
3. Once the Ultimaker S5 has cooled down, remove the build plate from the printer and align it with the XY calibration sheet. Ensure the printed grid is precisely placed on the two rectangles on the sheet
4. Find the best aligned lines on the printed X grid and note which number corresponds to these lines. Enter this number as the X offset value on your Ultimaker S5
5. Find the best aligned lines on the printed Y grid and note which number corresponds to these lines. Enter this number as the Y offset value on your Ultimaker S5

- i** It is important that the printed XY offset print adheres well to the build plate and shows no signs of underextrusion. If it does, it is recommended to repeat the calibration print.

Lift switch calibration

The switch bay enables the second print core to be lifted and lowered. For successful dual-extrusion prints, it is important that print core switching functions well. The lift switch is already calibrated when the Ultimaker S5 is shipped, but calibration can also be performed manually if needed.

To perform the lift switch calibration:

1. Go to *Preferences* → *Maintenance* → *Print head* → *Calibrate lift switch* and select *Start calibration*
2. Move the lift switch on the side of the print head to point towards you. Select *Confirm* to continue
3. Move the print head so that the lift switch fits in the switching bay. Select *Confirm* when completed
4. Wait for the print head to go to the home position and test the lift switch
5. Did the lift switch lower and raise the print core? If so, press *Yes* to complete the calibration. If not, select *No* to perform the calibration again

4.8 Uninstalling the Air Manager

In some cases, it may be necessary to uninstall the Air Manager, for example for transportation or maintenance reasons. Special tools are included in the box to remove the Air Manager from the Ultimaker S5.

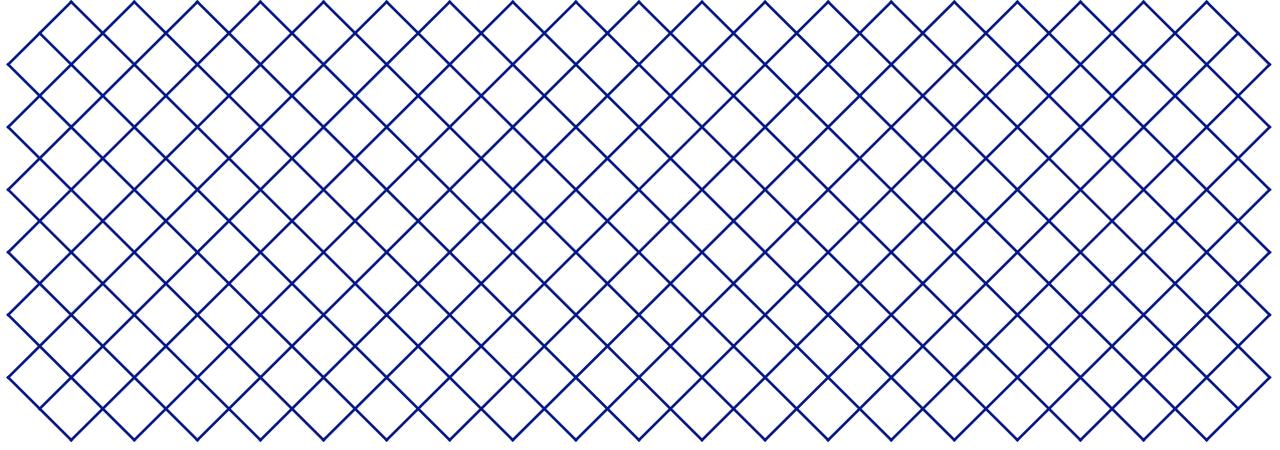
- ① It is recommended to uninstall the entire Air Manager, without removing individual modules.
 1. Turn off the Ultimaker S5 using the power switch at the back
 2. Disconnect the Air Manager cable from the UMB OUT port on the back of the Ultimaker S5 or the Material Station
 3. Take the two removal tools and align them with the leaf springs in the mounting bracket
 4. Insert the removal tools behind the leaf springs
 5. Push upwards until you hear a click
 6. Gently lift the entire Air Manager off the Ultimaker S5
- ① Upon rebooting the Ultimaker S5, a popup will appear on the touchscreen informing that the Air Manager has been disconnected. Select *Yes* to confirm the removal of the Air Manager.

4.9 Humidity control

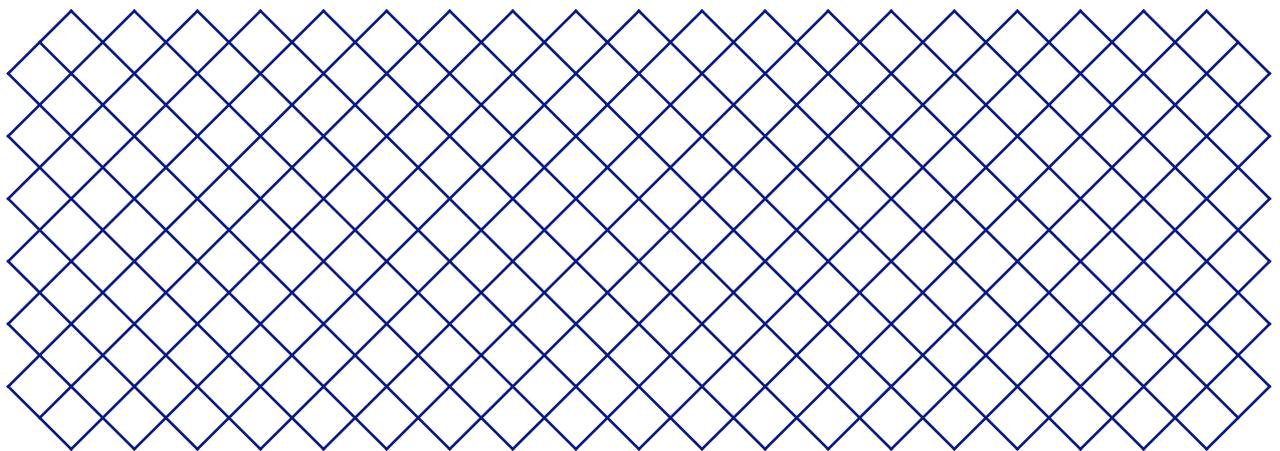
The Material Station has a built-in dehumidifier. The dehumidifier controls the humidity inside the Material Station. Silica beads absorb the moisture in the chamber and maintain relative humidity under 40%. The dehumidifier will regenerate the silica beads when they are saturated.

- ⚠ The dehumidifier can only regenerate if power is supplied to the Material Station.
- ① If the Material Station has been unplugged for a long period, the dehumidifier can take longer than usual to reach stable conditions.

It is not recommended to store (moisture sensitive) materials in the Material Station if the power cable is disconnected.



5. Maintenance



5.1 Update the firmware

Periodically, a new version of the Ultimaker S5 Pro Bundle firmware is released. To ensure that your Ultimaker S5 Pro Bundle is equipped with the latest features it is recommended to keep the firmware updated to the latest version.

- ⓘ Updates for the Material Station and Air Manager are automatically installed alongside the newest Ultimaker S5 firmware.

Update your Ultimaker via the network

If the Ultimaker S5 Pro Bundle is connected to a network, it automatically checks for available firmware updates. When a new firmware is available, the printer will prompt you to download and install it via the touchscreen interface. Alternatively, check for updates manually by navigating to *System* → *Maintenance* → *Update firmware*.

⚠ Do not power off the printer during the firmware installation.

Update your Ultimaker via USB

If your Ultimaker S5 Pro Bundle is not connected to a network, you can update to the latest firmware via USB. The firmware files are found on the Ultimaker website:

1. Navigate to ultimaker.com/firmware, and select Ultimaker S5
2. Download the firmware image and store it in the root directory of your USB stick
3. Insert the USB stick into the USB port of the Ultimaker S5
4. Go to *Preferences* → *Maintenance* → *Update firmware* and select the new firmware in the update menu

5.2 Material handling and storage

The optimal storage temperature for PLA, Tough PLA, Nylon, CPE, CPE+, PC, TPU 95A, PP and Breakaway is between -20 to +30 °C. For ABS the advised temperature is between 15 and 25 °C, and for PVA 0 to 30 °C. Furthermore, a relative humidity of below 50% is recommended for PVA, TPU 95A, PP and Breakaway. If these materials are exposed to a higher humidity the quality, of the material can be affected.

The Material Station can be used to store up to six spools of material. As long as the Material Station receives power, the intelligent atmospheric management keeps the relative humidity below 40%. This means opened spools can be safely stored in the Material Station.

- ⓘ Keep the door of the Material Station closed to enable optimal humidity control.

Additional opened spools of material must be stored in proper conditions. If material is stored incorrectly, it may affect its quality and usability. To keep your materials in optimal condition, store them:

- Out of direct sunlight
- In a resealable bag

To minimize moisture absorption, store the material in a resealable bag, including the supplied desiccant (silica gel) directly after unloading the spool from the Material Station.

5.3 Maintenance schedule

To keep your Ultimaker S5 Pro Bundle in optimal condition we recommend the following maintenance schedule, based on 1,500 printing hours per year.

Every month	Every 3 months	Every year
Clean the Ultimaker S5, Air Manager and Material Station Lubricate the axles (*)	Check for play on the axles Check tension of short belts Check for debris in front fan of print head Check quality of nozzle cover Lubricate lead screw Z motor Clean the feeders Clean the print cores	Lubricate the feeder gear Replace the Bowden tubes Clean system fans Lubricate hinges Replace the Air Manager filter

- i** (*) The X, Y and Z axles do not need lubrication for the first year of using the printer. After this, they should be lubricated monthly.
- i** If the usage frequency is higher, we recommend performing more frequent maintenance on your printer to ensure optimal printing results.

5.4 Clean the Ultimaker S5, Air Manager and Material Station

For the best print results, it is important to keep the Ultimaker S5 Pro Bundle clean while using it. It is advised not to use the Ultimaker S5 in a room where it can easily be covered with dust, and to remove small pieces of material that might accumulate in the printer. There are a few parts in the Ultimaker S5 Pro Bundle that might require more regular cleaning.

Clean the glass build plate

After printing, there might be print leftovers or excess glue stuck to the build plate. This can cause an uneven print surface. Potential sources of contamination are dust or fatty substances such as finger grease. Removing a print may also reduce the adhesion quality of a layer of glue. It is advised to regularly clean the build plate and reapply glue (if applicable).

Before starting a new print, always check the surface of the build plate. At least once a month, clean the build plate thoroughly by taking the following steps:

⚠ Always make sure that the build plate has cooled down and is lowered to the bottom of the Z axis.

1. Open the build plate clamps at the front, slide the glass build plate forward, and take it out of the printer
2. Use lukewarm water and a non-abrasive sponge to clean the build plate and to remove any adhesives
If necessary, some detergent can be used to remove adhesives, or alcohol gel can be used to get rid of any fatty substances
3. Dry the build plate with a clean microfiber cloth
4. Place the glass build plate on the heated bed with the warning sticker facing upwards. Ensure that it snaps into the build plate clamps at the back and close the build plate clamps at the front to secure it

Clean the glass components

All glass components of the printer (the glass doors and touchscreen) should be cleaned regularly to remove dust or fingerprints. They can be cleaned by using a dry, or somewhat moist microfiber cloth.

Clean the nozzles

While using the Ultimaker S5, material can get stuck to the outside of the nozzles and degrade. Although this will not damage your printer, it is recommended keep the nozzles clean in order to achieve the best print results. Before starting a new print, always check the nozzles. At least once a month, remove the plastic from the outside of the nozzles by taking the following steps:

⚠ During this procedure do not touch the nozzles and be careful while cleaning them as they will become hot.

1. On the Ultimaker S5, navigate to the configuration menu, select *Print core 1*, then click on the icon in the top-right corner and select *Set temperature*
2. Use the controls to set the target temperature to 150 °C. Repeat this for *Print core 2* and make sure this print core is lowered
3. Wait for the material on the outside to soften. When the nozzles are hot, carefully remove the material with tweezers

⚠ The nozzle cover is fragile and has a sealing function. Be careful not to damage the nozzle cover when using tweezers.

i Material may have accumulated higher up on the outside of the nozzle, above the nozzle cover. Check if this is the case by opening the print head fan bracket. To ensure the print head can close smoothly, this material should be removed using tweezers, as described above.

Clean the Bowden tubes

Particles in the Bowden tubes can impede smooth movement of the filament, or mix colors. Clean the Bowden tubes at least once a month, or after experiencing an issue with filament grinding. To clean the Bowden tubes, they must first be removed from the printer.

i This is only necessary for the Bowden tubes to the print head. The Bowden tubes of the Material Station do not require regular cleaning.

1. Turn off the printer and open the Air Manager
2. Place the print head in the front-right corner
3. Remove the clamp clips from the tube coupling collets at the print head and feeders
4. Press down on the tube coupling collet in the print head and at the same time, pull the Bowden tube upwards, out of the print head. Repeat these steps for the feeder

i The cable clips that hold the second Bowden tube to the print head cable do not have to be removed, you can leave them in place. Leave the Bowden tubes in the mounting bracket of the Air Manager.

5. Cut off a small piece of sponge or ball up a piece of tissue
6. Insert this into the feeder end of the Bowden tube and push it all the way through the tube with a length of filament. Do this for both Bowden tubes, using a clean piece of sponge or tissue for each

i To clean the tube most efficiently, make sure the sponge or ball of tissue is a tight fit inside the Bowden tube. Note that if it is too big it will be difficult to push through.

7. Insert the Bowden tube into the feeder by pressing down on the tube coupling collet in the feeder and pushing the Bowden tube all the way in. Secure the tube with the clamp clip. Repeat this for the other Bowden tube
8. Insert the Bowden tube into the print head by pressing down on the tube coupling collet in the print head and pushing the Bowden tube all the way in. Secure the tube with the clamp clip. Repeat this for the other Bowden tube
9. Close the cover of the Air Manager

Inside of the printer

Small pieces of material can gather inside the printer, such as priming blobs. Remove these regularly from the inside of the printer by taking the following steps:

1. Raise the build plate by navigating to *Configuration* → *Build plate* and select *Raise*
2. Clean the inside of the printer with a microfiber cloth or vacuum cleaner. Pay extra attention to the area around the Z limit switch as obstructions here can cause print problems

 Leaving larger objects on the bottom panel can lead to errors, as they prevent the build plate from properly homing.

Air Manager and Material Station

It is recommended to clean the glass door of the Material Station and the cover of the Air Manager regularly to remove dust or fingerprints. All the surfaces – except the Air Manager filter - can be cleaned by using a damp microfiber cloth.

 Only use water and mild detergent to clean the Material Station and Air Manager.

5.5 Lubricate the axles

To make sure that your print head and Z stage can move smoothly at all times, it is advised to lubricate the axles every month after the first year of printing. Dry axles can show as small ridges on print surfaces. Apply some oil to the axles at least once a month.

A bottle of oil is included in the accessory box of your Ultimaker S5. This oil is specifically for the smooth axles of the Ultimaker S5. Only use the supplied oil, as using other oils or grease may affect the coating of the axles, which can affect the performance of your Ultimaker S5.

X and Y axles

Apply a small drop of oil to each of the X and Y axles as well as both print head shafts. Manually move the print head around to evenly distribute the oil.

 Do not apply too much oil to the axles, as it might drip from the axles on to the build plate, which will affect print adhesion. If a drop of oil does fall on the build plate, make sure to clean it thoroughly before printing.

Z axles

Apply a small drop of oil to each of the Z axles. In the Ultimaker menu, go to *Configuration* → *Build plate*. Select *Raise* and then *Lower* to move the build plate up and down in order to evenly distribute the oil.

5.6 Check for play on the axles

The four X and Y axles are locked in place by the pulleys. However, it is possible that one or more of the pulleys can become slightly loose over time, which could affect their alignment. If this is the case, there could be play on the X and/or Y axles which can cause issues with print quality.

It is recommended to check for play on the axles at least once every three months.

1. Open the cover of the Air Manager to access the axles
2. Start with the right X axle. Place the print head in the back-left corner of the printer to keep it out of the way
3. Hold the frame of the Ultimaker S5 with one hand, and firmly hold the right X axle with the other
4. Attempt to move the axle forwards and backwards; do not be afraid to apply too much force
5. Repeat this for the other axles. Make sure to move the print head to the opposite side each time

The axles should not move at all. If one of the axles does move, you will notice a ticking noise caused by the pulleys hitting the frame. In this case, it is recommended to calibrate the print head.

5.7 Check the tension of the short belts

Maintaining correct tension on the short belts is important to ensure good print quality. The short belts transfer the movements of the X and Y motors to the print head. If the belts are too loose, print head movement may not be accurate, which can cause print inaccuracies.

Over time, the belts may become slack. It is recommended to check the tension of the short belts at least once every three months.

Pluck the two short belts to check their tension. They should resonate, like a guitar string. It should not be possible to press the belt against itself. Furthermore, the tension of the two belts should be equal.

To restore the tension, perform the following steps:

1. Open the cover of the Air Manager to access the X and Y motors
2. Loosen the Y motor by using the hex screwdriver to loosen the four bolts that hold the Y motor to the left panel. Do not remove the bolts. The motor should be able to slide up and down
3. Firmly press down on the motor with one hand. This ensures maximum tension on the short belt
4. While still pressing the motor down, tighten the four bolts of the Y motor in a cross pattern. First tighten the topleft bolt, then the bottom-right, followed by the bottom-left and ending with the top-right. This ensures that the motor is attached straight
5. Perform the above steps for the X motor that is attached to the back panel. Afterwards, check the tension of both belts again

5.8 Check for debris in the front fan of the print head

The front fan cools the print cores during a print. This helps to prevent the heat from the nozzle traveling too far upwards.

The fan takes in air from the front of the print head and directs it towards the print cores. Sometimes the airflow causes thin strands of filament to be sucked into the fan during a print. If strands accumulate in the fan, they can decrease the effective cooling and eventually obstruct the fan and prevent it from spinning. Especially high-temperature materials, such as CPE+, PC, and ABS are sensitive to this.

To check the front fan, first gently open the front fan bracket. Blow into the front fan to see if it smoothly spins. If it does not move at all, or stops spinning abruptly, carefully clear any obstructions from the front fan with some tweezers.

 Make sure that the print cores are completely cooled, and the printer is turned off before performing this check.

 Some filament debris can also be visible from the outside of the print head. Make sure to remove this too.

If the fan is still not spinning after removing visible filament debris, it should be replaced.

5.9 Check the quality of the nozzle cover

The nozzle cover shields the print cores from cold airflow from the fans, helping the print cores to maintain a stable temperature while printing. The cover also helps to prevent backflow of material into the print head when something goes wrong during printing.

The heat of the nozzles may cause wear on the nozzle cover over time. It is recommended to check the quality of the cover at least once every three months. The accessory box of the Ultimaker S5 contains three spare nozzle covers.

Examine the bottom of the print head to see if the holes where the nozzles come through are still round and the cover still forms a good seal. Also gently open the fan bracket to check the other side of the nozzle cover.

If the nozzle cover looks like it needs to be replaced, please follow these instructions.

Remove the old cover

1. First, remove both print cores by going to the configuration overview and selecting *Unload* for both print cores
2. Close the print head fan bracket, and manually place the print head in the front center of the printer
3. Peel away the front corner of the nozzle cover, and pull it out of the print head fan bracket

Place the new cover

1. Open the print head fan bracket
 2. Take the new nozzle cover and hold it in the correct orientation behind the print head fan bracket. Make sure the protruding shapes of the cover match the shapes of the holes in the bracket
 3. Insert the middle tab of the nozzle cover through the slot in the print head fan bracket. From the inside of the print head, apply pressure to the metal plate. At the same time, pull the tab through the bracket and plate until the seal locks the cover in place
- i** Use flat tip or round tip tweezers to pull the tab through the metal plate. This makes this action easier, as the tab may be difficult to reach by hand.
4. Pull the right side of the nozzle cover, fold the pocket over the edge of the metal plate, and push the silicone tab under the metal tab of the print head fan bracket. Repeat this for the left side
 5. Push the front tab through the slot in the print head fan bracket, while applying pressure to the metal plate from the inside of the printer. Make sure the seal is pushed through the plate, to lock the cover in place
 6. Close the print head fan bracket and check if the new nozzle cover is correctly placed. Slide your finger across the bottom of the print head. If the nozzle cover easily detaches from the fan bracket, it is not correctly placed. Follow steps 3 - 5 again
- ⚠** If the nozzle cover is not placed correctly, it may get caught on the print. This could cause the fan bracket to open during printing.
7. Insert both print cores, following the guide in the configuration menu
 8. With the front fan bracket closed, hold the nozzle cover at both sides and slightly move it left and right. The metal plate and nozzle cover will now align themselves with the print cores

The nozzle cover should not easily detach from the fan bracket.

- i** It is recommended to check the placement and alignment of the cover by manually lifting and lowering the second print core. To do this, move the lift switch on the right side of the print head. Check if the fan bracket remains closed as the second print core is lowered.

5.10 Lubricate the lead screw of the Z motor

The lead screw is connected to the Z motor and controls the movements of the Z stage. To ensure smooth movement of the Z stage, it is recommended to periodically apply grease to the lead screw.

Over time, grease may need to be reapplied to maintain consistent and accurate movement of the Z stage. A tube of grease is included in the accessory box of your Ultimaker S5.

1. Make sure that the build plate is positioned at the bottom of the Ultimaker S5
 2. Apply a small amount of grease to the lead screw of the Z motor
 3. In the Ultimaker menu, go to *Configuration* → *Build plate*
 4. Select *Raise* and then *Lower* to move the build plate up and down to evenly distribute the grease
- i** Only use the grease on the lead screw of the Z motor.

5.11 Clean the feeders

The feeders forward filament to the print head. To make sure that exactly the right amount of material is extruded, it is important that the feeder gears can smoothly turn.

After many hours of printing, or when material has been ground down, there is a chance that there are small filament particles in the feeders. It is recommended to clean the inside of the feeders after three months. In order to do this, the feeders have to be removed from the printer.

The following steps need to be performed for both feeder 1 and feeder 2:

1. Turn off the printer and remove the power extension cable
 2. Remove the clamp clips from both sides of the feeder, press on the tube coupling collet, and pull the Bowden tubes out of the feeder. Next, remove the two tube coupling collets
 3. Reduce the tension of the feeder by turning the bolt in the top of the feeder with the hex screwdriver, until the indicator is completely at the top
- i** The hex screwdriver that was supplied with the Ultimaker S5 cannot be used for this action in combination with the Air Manager. Use a 2 mm hex key instead.
4. Use the hex screwdriver to loosen the four bolts of the feeder housing
 5. Carefully pull the front part of the feeder away from the printer and put it aside
- i** Be careful not to lose the ring that is located at the bottom of the feeder. If it falls out, place it back in the feeder housing with the widest side at the top.
6. Use a small brush to gently clean all filament particles from the knurled wheel, the flow sensor axis, and the inside of the feeder housing
 7. Place the front part over the feeder again and firmly push it into place. Insert the four bolts and tighten them in a cross pattern, starting in the top-left corner
 8. Insert the tube coupling collets into the feeder and push the Bowden tubes from the Ultimaker S5 and the Material Station all the way in. Secure the tubes with the clamp clips
 9. Reset the tension of the feeder by turning the bolt in the top of the feeder, until the indicator is at the middle mark

5.12 Clean the print cores

Maintenance of the BB print core should be performed once every three months, or after 400 printing hours. Using the Ultimaker cleaning filament is the most effective way to clean and unclog the BB print core on the Ultimaker S5. If you don't have the Ultimaker cleaning filament at your disposal, you can use PLA instead.

Cleaning filament can be used to clean the print core on an Ultimaker S5 by applying hot and cold pulls. Hot pulls are used to get the biggest parts of degraded material out of the print core and are especially necessary when a print core is clogged. With a cold pull, the remaining small particles will be pulled out, ensuring the print core is completely clean.

- i** If necessary, you can also use this method to clean an AA or CC print core. The AA print cores do not require preventive maintenance. The print core CC Red 0.6 benefits from preventive maintenance once a month, or after 150 printing hours.

Preparation

1. Go to *Preferences* → *Maintenance* → *Print head* → *Print core cleaning* and select *Start* to begin the cleaning procedure

i The print head will move to the front-right corner to prepare itself.

2. Select the print core you want to clean: *Print core 1* or *Print core 2*
3. Select the material you want to use for cleaning: *Cleaning filament* or *PLA filament*
4. Wait for the printer to heat up the print core
5. Open the cover of the Air Manager
6. Remove the Bowden tube from the print head. First, remove the clamp clip and then push down on the tube coupling collet while pulling the Bowden tube upwards, out of the print head. Select *Confirm* to continue

Hot pull

1. Insert the filament into the print head until you feel some resistance
2. Hold the filament with pliers and gently apply pressure to the material for ± 1 second so that it extrudes from the print core or until it cannot be pushed any further, and directly pull the filament out with a quick, firm pull

⚠ Use pliers to prevent injuries to your hands in case the material breaks.

3. Cut off the tip of the filament that you have just pulled out
4. Check the color and the shape of the tip of the filament and compare it with the image below. The goal is to have a clean tip
5. Repeat this procedure until there is no more degraded material visible on the tip of the cleaning filament. The tip of the filament should look as clean as the example on the right
6. Once the tip of the filament is clean, manually flush some filament through the print core with pliers and take it out again. Select *Confirm* to continue

Cold pull

1. Insert the filament into the print head until you feel some resistance
2. Hold the filament with pliers and gently apply pressure to extrude some material. Select *Confirm* to continue
3. Maintain pressure on the filament with the pliers for the duration of the progress bar
4. Release the filament and wait until the print core has cooled down
5. Grab the filament with pliers and pull it out with a quick, firm pull. Select *Confirm* to continue
6. Take a look at the tip of the filament and see if it has a clean, cone-shaped tip like shown on the example to the right. Select *Confirm* to continue

i If the tip of the filament is not clean, go back to hot pull or cold pull and repeat the cleaning steps.

Reassembly

1. Insert the Bowden tube into the print head and secure with the clamp clip. Select *Confirm* to continue
2. Wait for the Ultimaker S5 to finalize the cleaning procedure
3. Close the cover of the Air Manager

5.13 Lubricate the feeder gear

To ensure the feeders forward the filament smoothly and accurately, the gears are lubricated. After many hours of printing, it is recommended to reapply this lubrication. As small filament particles may have stuck to the gears, it is advised to clean them first.

- ① It is also recommended to replace the Bowden tubes after one year. While lubricating the feeder gears, follow the instructions to simultaneously replace the Bowden tubes.

The following steps need to be performed for both feeder 1 and feeder 2:

1. Turn off the printer and remove the power extension cable
2. Remove the clamp clip from the feeder-end of the Bowden tube, press down on the tube coupling collet and pull the Bowden tube upwards out of the feeder
3. Use the hex screwdriver to loosen the two bolts that hold the feeder to the back panel
4. Carefully move the feeder away from the back panel and disconnect the filament detection cable from the flow sensor
5. Use a clean cloth or a cotton swab to wipe all filament particles and grease residue from the feeder gears. Clean both the gear connected to the motor and the larger gear inside the feeder
6. Apply a small amount of grease to the gear attached to the feeder motor. There is no need to spread this out; the feeder will do this automatically when it turns
7. Hold the feeder close to the back panel and connect the filament detection cable to the flow sensor
8. Place the feeder back on the printer and secure it with the two bolts
9. Push the Bowden tubes from the Ultimaker S5 and the Material Station all the way into the tube coupling collets. Secure the tubes with the clamp clips

5.14 Replace the Bowden tubes

- ① This only applies to the Bowden tubes on the Ultimaker S5, between the feeders and the print head. The Bowden tubes of the Material Station do not require regular replacement.

The Bowden tubes guide the filament from the feeders to the print head.

Forwarding improperly cut or ground down filament through the Bowden tube could scratch or damage the inside of the tube. If this happens, the filament can no longer be smoothly forwarded to the print head. This can lead to under-extrusion or other print quality issues.

After removing a Bowden tube multiple times, the tube coupling collet can wear out. If this happens, the tube coupling collet will no longer have a firm hold on the Bowden tube. In this case, the Bowden tube will move up and down during prints, which can negatively impact print quality.

If the Bowden tubes are permanently damaged, they need to be replaced. To maintain optimal print quality, it is recommended to replace the Bowden tubes every year.

Disassembly

1. Open the cover of the Air Manager
2. Place the print head in the front-right corner
3. Use your fingernail to remove the clamp clips from the tube coupling collets at the print head and feeders
4. Press down on the tube coupling collet in the print head and at the same time, pull the Bowden tube upwards, out of the print head. Repeat these steps for the feeders
5. Loosen the four cable clips from the Bowden tube (extruder 2)
6. Guide the Bowden tubes through the mounting bracket of the Air Manager to remove them

Reassembly

1. Take the new Bowden tubes and note the two different sides. The side which is chamfered should be inserted into the feeder. This allows easier access of the filament into the Bowden tube. The flat side should be inserted into the print head
 2. Move the Bowden tubes through the slots in the mounting bracket of the Air Manager from the top
- i** Above feeder 2, the Bowden tube should be placed in front of the print head cable.
3. Push the Bowden tubes all the way into the tube coupling collets of the feeders and print head. Secure the tubes with the clamp clips
 4. Click the four cable clips of the print head onto Bowden tube 2 and divide equally
 5. Close the cover of the Air Manager

5.15 Clean the fans

System fans

The system fans are positioned at the back of the Ultimaker S5 and need to be cleaned once every year.

This can be done by blowing into the fans in order to get small filament particles out. If necessary, an air blower or compressor can be used instead.

Air Manager fan

The fan in the Air Manager should be inspected once every year for dust and dirt. If the fan shows dust, this can be removed with a soft brush. Remove any dirt with a damp microfiber cloth.

⚠ Ensure the Ultimaker S5 is turned off when cleaning the fan.

5.16 Lubricate the hinges

To make sure the glass doors will open and close smoothly, the hinges of the glass doors must be lubricated once a year. This can be done by placing a small drop of oil in the top hole of each hinge.

i The hinges of the Air Manager cover and the Material Station door do not require any maintenance.

5.17 Replace the Air Manager filter

The filter in the Air Manager is a consumable. It should be replaced every 1500 printing hours to maintain proper filtering. The printer keeps track of the filter usage time and will alert you when replacement is due.

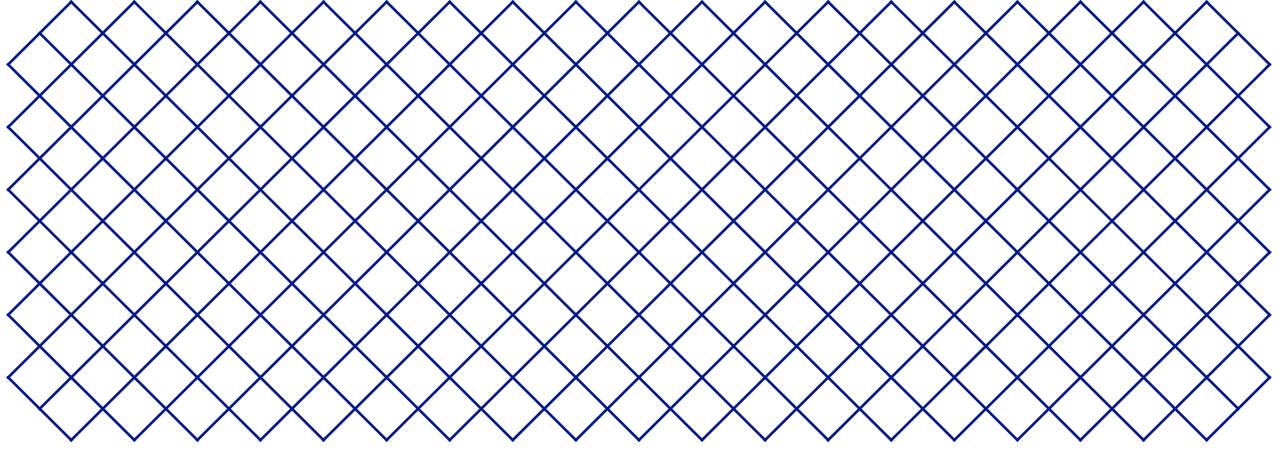
To replace the filter in the Air Manager, navigate to *Preferences* → *Maintenance* → *Air Manager* → *Replace* and follow the steps on the touchscreen:

⚠ The function of the Air Manager's filter is to reduce the emission of ultrafine particles. These particles will remain in the filter. The used filter should be handled with care during the replacement procedure. If the used filter is not properly handled, there is a risk of the ultrafine particles being released.

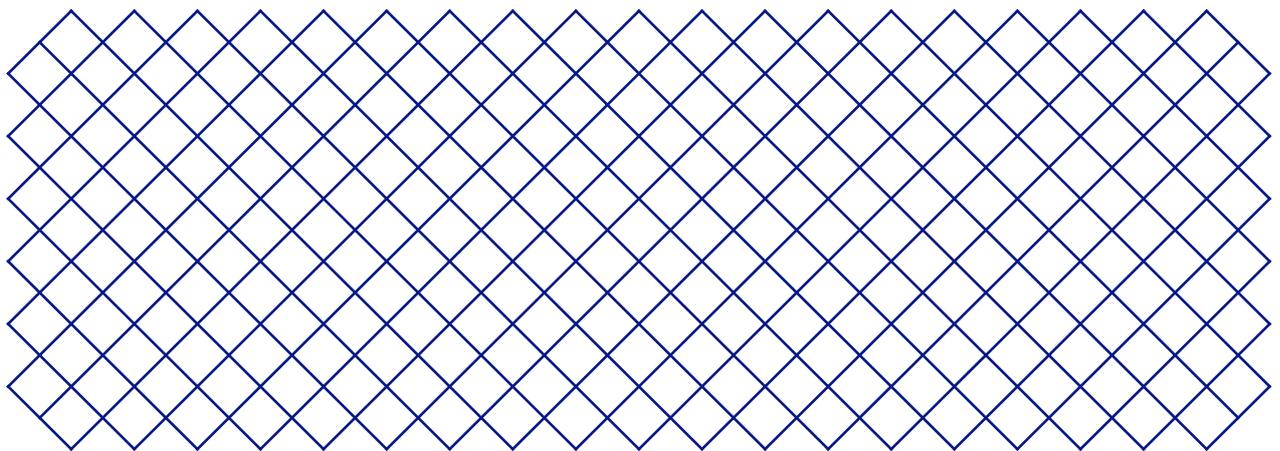
- 
1. Open the Air Manager and wait for the printer to prepare the filter replacement procedure
 2. Take out the used filter by pulling the tab on the filter towards you and removing it from the filter housing
 3. Directly place the used filter in a (resealable) bag and close it
 4. Insert the replacement filter into the filter housing and gently push it. Select *Confirm* when the filter is completely flush
 5. Close the Air Manager to finish the placement and select *Finish* when done

If the filter is not replaced according to the above procedure, the filter usage counter will not be reset.

-  Never replace the filter while the Ultimaker S5 is in operation or if the Air Manager fan is spinning.
-  The filter in the sealed bag can be disposed of with your regular household waste.



6. Troubleshooting



6.1 Error messages

This list shows the most common error messages that relate to the Ultimaker S5 Pro Bundle. For more information on troubleshooting these error messages please go to the error specific page on the Ultimaker website.

Ultimaker S5

- An unspecified error has occurred. Restart the printer or go to ultimaker.com/ER27
- Max temp. error on the print core in print head slot [x]. Go to ultimaker.com/ER28
- Min temp. error on the print core in print head slot [x]. Go to ultimaker.com/ER29
- Max temp. error on the build plate. Go to ultimaker.com/ER30
- Heater error on the print core in print head slot [x]. [Go to ultimaker.com/ER31](https://ultimaker.com/ER31)
- The Z axis is stuck or the limit switch is broken. Go to ultimaker.com/ER32
- The X or Y axis is stuck or the limit switch is broken. Go to ultimaker.com/ER33
- There is a communication error with the print head. Go to ultimaker.com/ER34
- There is an I2C communication error. Go to ultimaker.com/ER35
- There is an error with the safety circuit. Go to ultimaker.com/ER36
- There is a sensor error within the print head. Go to ultimaker.com/ER37
- Active leveling correction failed. Manually level the build plate or go to ultimaker.com/ER38
- An incorrect print temperature is specified. Go to ultimaker.com/ER39
- An incorrect build plate temperature is specified. Go to ultimaker.com/ER40
- The motion controller failed to update. Go to ultimaker.com/ER41
- This print job is not suitable for this printer. Go to ultimaker.com/ER42
- The flow sensor within feeder [x] is not working properly. Go to ultimaker.com/ER43

Air Manager

- Expected Air Manager is missing. [Go to ultimaker.com/ER80](https://ultimaker.com/ER80)
- Air Manager fan is unable to rotate at the desired speed. [Go to ultimaker.com/ER86](https://ultimaker.com/ER86)

Material Station

If you encounter an error in the range of ER50-ER79, there may be an issue within your Material Station. Go to the link shown on your display for steps on how to resolve your issue.

6.2 Print core troubleshooting

Clogged print core

If material does not flow from the print core for at least 10 minutes, it could suggest that the print core is clogged with degraded material. In this case, the print core should be cleaned by performing the hot and cold pull method.

Using the Ultimaker cleaning filament is the most effective way to clean and unclog a print core on the Ultimaker S5. If you don't have the Ultimaker cleaning filament at your disposal, you can use PLA. Take a look at chapter 5.12, 'Clean the print cores' for detailed instructions.

Print core not recognized

If a print core is not recognized by the Ultimaker S5, the printer will inform you. The main reason for this is dirty contact points on the PCB at the back side of the print core. When this happens, clean the contact points with a cotton swab and some alcohol.

 Do not touch the contact points on the back of the print core with your fingers.

6.3 Print quality issues

Poor build plate adhesion

When you experience problems with the adhesion of a print to the build plate, the following actions can be performed:

- Ensure that the correct material settings and adhesion method were used (see chapter 4.2 Materials)
- Recalibrate by using the detailed active leveling mode (see chapter 4.7 Calibration)
- Check the Ultimaker Cura settings that were used, and try printing with one of the default Ultimaker Cura profiles

Grinding PVA

Typically incorrect handling or storage of the material can lead to grinding of the material. PVA should be printed and stored at a low humidity to avoid problems while printing. We advise a humidity below 50% for storage and below 55% while printing. It is also recommended to keep the ambient temperature below 28 °C while printing.

Keep the PVA in the Material Station and ensure the door remains closed to ensure a relative humidity of <40%. When PVA is ground down by the feeder, there are three main causes:

- **Incorrect storage.** PVA is a material that absorbs moisture relatively easily and therefore storing it correctly (resealable bag, with humidity below 50%) is important. If PVA absorbs too much moisture it will get soft and malleable/pliable and in some cases even sticky. This can cause problems in the feeder as it might not be able to forward the PVA properly anymore. If this happens you can dry the PVA
- **Coated Bowden tube.** The Bowden tube can get coated on the inside due to incorrect printing conditions (mainly high humidity). If the humidity of the printing environment is too high (above 55%) and temperature is too high (above 28 °C) PVA might not be able to move easily through the Bowden tube. A solution for this is to clean the Bowden tube and dry it very well
- **Clogged print core.** High humidity can affect PVA quality, and lead to clogs in the print core. As a consequence, filament might get jammed, causing grinding in the feeder. When this happens, the print core should be cleaned by following the procedure described in chapter 5.12

For more information on how to resolve grinding issues, you can take a look the Ultimaker website for further assistance.

Under-extrusion

In simple terms, under-extrusion is when the printer is unable to supply a sufficient amount of material. Your Ultimaker S5 is under extruding when you see missing layers, very thin layers, or layers that have random dots and holes in them.

Under-extrusion can have several causes:

- Use of low-quality material (diameter inconsistency) or wrong settings
- Feeder tension not set correctly
- Friction in the Bowden tube
- Small particles of material in the feeder or Bowden tube
- A partial clog in the print core

If your Ultimaker S5 is affected by under-extrusion, it is advised to take a look at our online resource pages for detailed troubleshooting instructions.

Warping

Warping occurs due to material shrinkage while printing, causing the corners of the print to lift and detach from the build plate. When plastics are printed, they firstly expand slightly but contract as they cool down. If material contracts too much, the print will bend upwards from the build plate.

When your print is warping, ensure you have done the following:

- Use the active leveling to level the build plate
- Ensure the correct adhesion method is used
- Use the correct temperature and other settings as in the default Ultimaker Cura profiles
- Adjust the shape of your model according to the design guidelines described on ultimaker.com/3D-model-assistant
- Use another material that is less prone to warping

To troubleshoot this issue in more detail, take a look at the Ultimaker website.

6.4 Material Station not recognised

If the Material Station is not recognized by the Ultimaker S5, first check if you have installed the latest firmware.

- ⚠ The Material Station will only function correctly when your Ultimaker S5 is running firmware that supports it. Using an unsupported version may cause damage to your printer.

Another possibility is that your system may not be connected properly. Check the Material Station and Ultimaker S5 cables. Ensure the Material Station cable is securely connected to the **UMB IN** port on the Material Station and the other end to the **UMB OUT** port on the Ultimaker S5.

- ⚠ The **UMB OUT** port on the Material Station and the NFC port on the Ultimaker S5 should not be used to connect the Material Station.

If the Material Station is still not recognized, contact your local service provider for support.

6.5 Air Manager not recognized

If the Air Manager is not recognized by the Ultimaker S5, first check if you have installed the latest firmware.

- ⚠ The Air Manager will only function correctly when your Ultimaker S5 is running firmware that supports it. Using an unsupported version may cause damage to your printer.

Another possibility is that it may not be connected properly. Follow the steps below to check the Air Manager cable.

1. Power off the Ultimaker S5
2. Ensure one end of the Air Manager cable is securely inserted into the filter housing
3. Ensure the other end of the cable is securely inserted into the **UMB OUT** port at the back of the Ultimaker S5, or, if you also have a Material Station, in the **UMB OUT** port at the back of the Material Station

- ⚠ The Air Manager cable should not be connected to the NFC port.

4. Turn the Ultimaker S5 on again and select *Add Air Manager*

If the installation continues to fail, contact your local service provider for support.

6.6 Material stuck

Sometimes filament can become stuck within the extrusion train of the Ultimaker S5 Pro Bundle. An error code will be shown if this occurs. The error code can be used to troubleshoot where along the extrusion train the filament blockage has occurred. Please follow the link provided to get more troubleshooting information for the specific case.

Before removing stuck filament, power down machine and remove the power supply plug.

i To remove stuck filament, push it out in a forward-feeding motion.

The best way to troubleshoot this problem, depends on where in the Ultimaker S5 Pro Bundle the material is located. Carefully try to push the filament out from the same filament bay and entry point from which it was broken.

⚠ If you feel a blockage when feeding filament through the extrusion train, it may be that the pathway is blocked by a broken filament strand. Do not exert force as this may cause damage to the internal parts of the Material Station. Instead, try pushing the broken filament strand from another entry point.

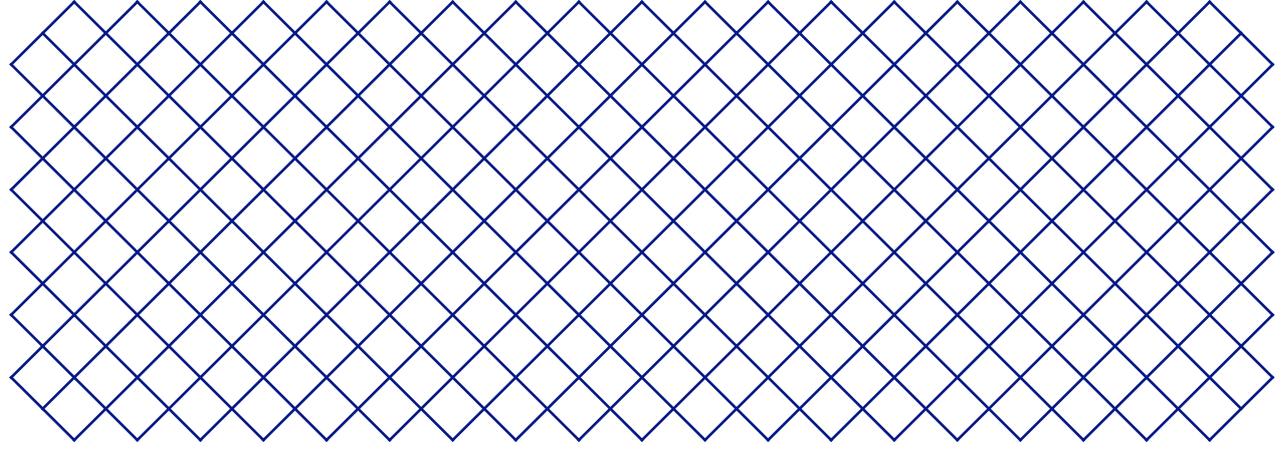
If the broken filament is visible in one of the Bowden tubes, detach the Bowden tube from the Ultimaker S5 feeder and push the broken piece out with another length of filament.

Do not remove the Bowden tube from the decoupler. Instead, forward the filament from the material entry point in the Material Station, until the piece is visible in the Bowden tube above the decoupler.

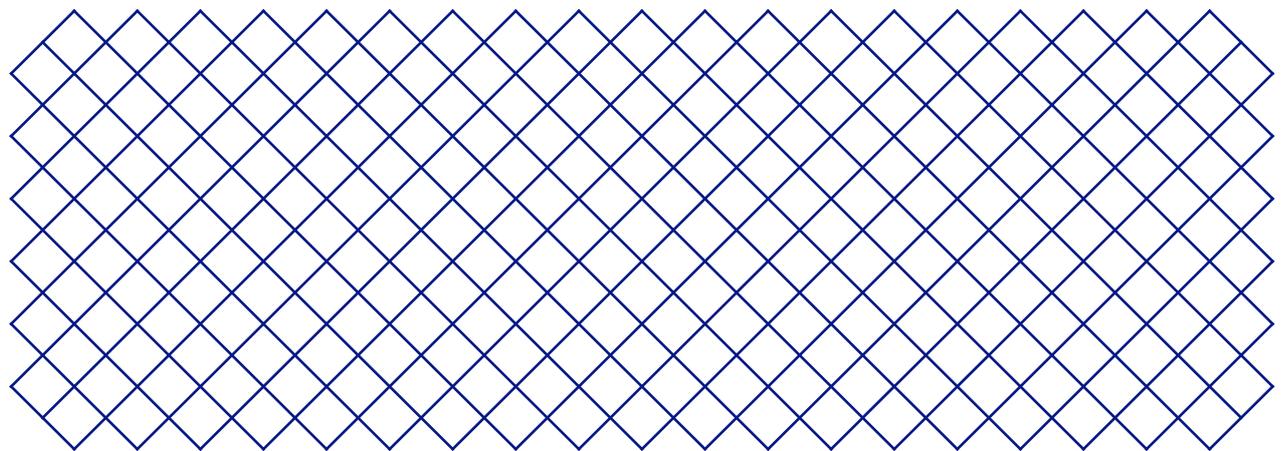
6.7 Material grayed-out

You may encounter grayed-out materials displayed in the materials list on the Ultimaker S5 display. A grayed-out material may not be usable because of either:

- **Material and core incompatibility.** Please check that the loaded material is compatible with the print core of the extruder. The Material Station will prevent materials from being extruded from an incompatible print core
- **Material print profile not updated.** All materials must have their material print profiles updated to be compatible with the Material Station. All Ultimaker materials have been updated and are immediately compatible with the Material Station



7. Warranty



7.1 General

Ultimaker grants a standard warranty on the Ultimaker S5 Pro Bundle ('Product') in the country where the product was purchased.

From the date the product is sold and delivered to an end-customer for the first time, as evidenced by the original customer's purchase invoice, Ultimaker warrants the product is free from defects in material, design and workmanship for a period of twelve (12) months. Only the original purchaser is entitled to claim warranty and the warranty period is limited to his/her lifetime.

For a warranty claim to be valid (i) notification must be made before the end of the warranty period, (ii) conform to any additional stipulations of the warranty, as defined below, (iii) must be substantiated with the original customer's purchase invoice, (iv) the serial number sticker must still be on the product(s) and (v) the product must be returned in the original packaging. Since customers will only be entitled to make a warranty claim on submission of the original invoice and packaging, we advise that both the invoice and official packaging are kept in a safe place. If the original packaging is not available anymore, the customer can purchase such for an additional amount of EUR 25 or equivalent in applicable local currency.

The customer – provided that they are a natural person who is not acting in the course of their profession or business – may claim the rights to which they are entitled under the warranty without prejudice to their rights or claims in accordance with the law.

7.2 Conditions

The Ultimaker warranty is granted under the explicit condition that:

- The product was sold, delivered and assembled by a recognized Ultimaker reseller (see ultimaker.com for addresses of the recognized Ultimaker resellers)
- The product was newly manufactured on the date of purchase and not sold as used, refurbished or manufacturing seconds
- Ultimaker's latest software was installed and used in and with the product
- The Ultimaker's installation and maintenance instructions as described in the manual for the product have been observed. Unless the manual contains 'do-it-yourself' assembly instructions for the product or part thereof and these have been followed up meticulously, the warranty will become invalidated if the product was at any time disassembled or reassembled by any other person than a recognized Ultimaker reseller

Customers are welcome and we encourage them to use third-party materials, accessories, etc. That in itself, does not void the warranty. If, however, the use of third-party elements, causes damage to the product, the part(s) affected by this damage is excluded from warranty.

If a part of the product is repaired or replaced during the warranty period, the warranty period still remaining for the entire product will apply to this part. However, repair and/or replacement will not extend the warranty period.



7.3 Notification

The Ultimaker resellers deal with this warranty on behalf of Ultimaker. Therefore, any notification on the basis of this warranty must be made to the Ultimaker reseller from whom the product was originally purchased, even if this is not in the customer's present country of residence.

Any warranty claim must first be recognized as justified, either by Ultimaker's reseller or by Ultimaker. If so, the reseller is obliged to rectify the defects free of charge according to this warranty. If the defect cannot be repaired, the reseller will, within the warranty period, replace the product free of charge by an identical product, or, if the product is no longer manufactured, by a similar replacement of the same value or offer an appropriate refund.

Depending on the country, the warranty may not automatically include costs incurred for shipping defective products for scrutiny and/or repair, nor for shipping costs of replacement or repaired product(s) back to claimant.

7.4 Exclusions

This warranty does not apply to and therefore does not cover:

- Any defect or damage caused by inappropriate, incorrect or improper use, installation, maintenance, operation and cleaning or normal wear and tear. For correct use, reference is made to the manual of the product
- Any other event, act, default or omission outside Ultimaker's control
- Failure of the product caused by an accident

In any event, Ultimaker is not liable for indirect or consequential damages, including but not limited to loss of use, loss of profit or revenue. Furthermore, Ultimaker's liability is limited to the purchase value of the product.

7.5 Applicable law and competent court

This warranty is exclusively governed by Dutch law. Any dispute arising out of or in connection with this warranty will be exclusively submitted to the jurisdiction of the court (Rechtbank) of Midden-Nederland, location Utrecht.