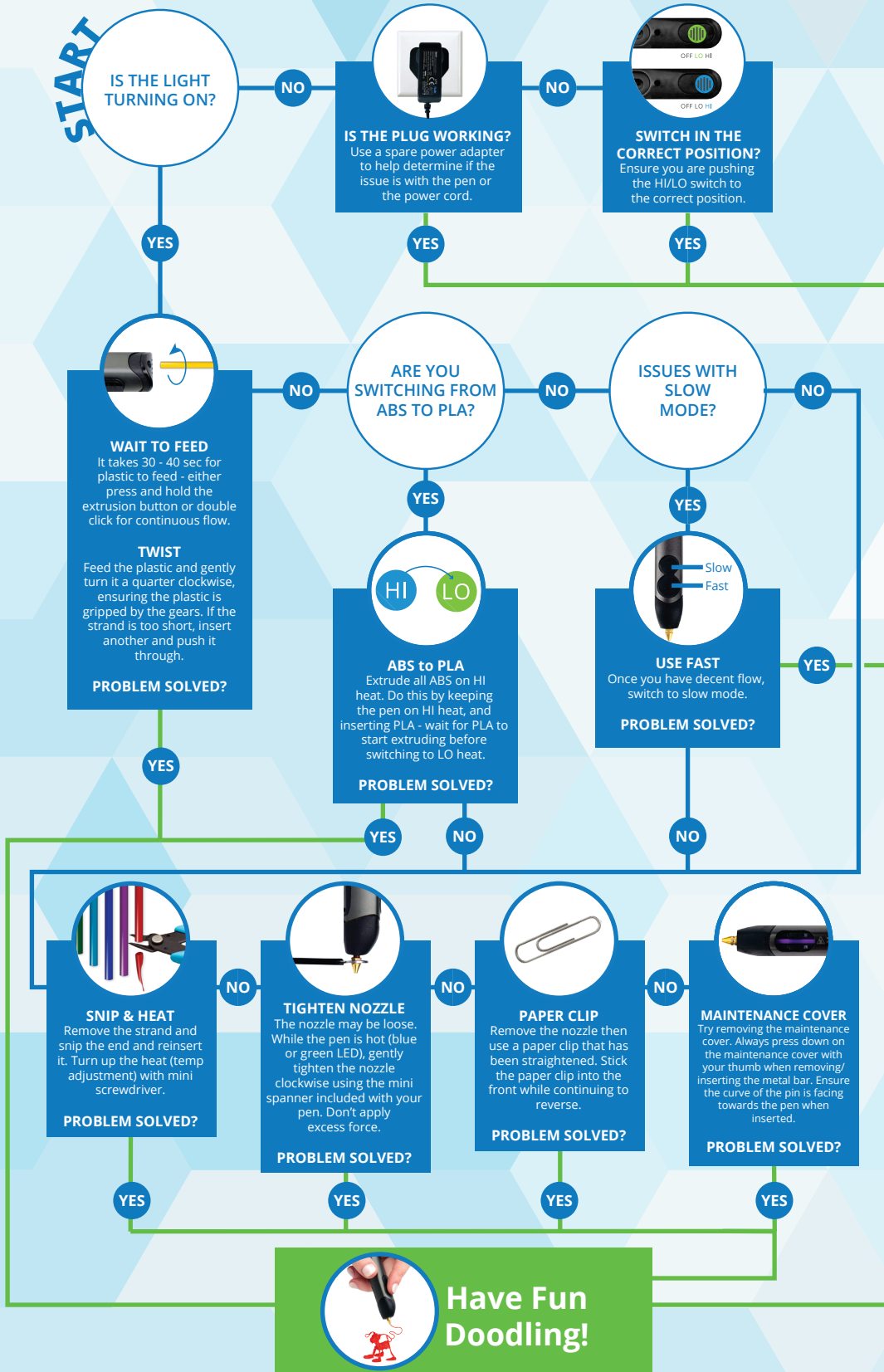


**Before you begin, note the following tips:**

1. Use **PLA** plastic on **LO/low** heat setting, and **ABS / FLEXY** plastic on **HI/high** heat setting (check the pack color)
2. It takes 30-40 second for extrusion to begin after first inserting a plastic strand
3. Push the plastic down the pen and gently twist it clockwise to get it to engage with the pen's gears
4. Extrude all **ABS** plastic on **HI/high** heat before switching to **PLA** plastic on **LO/low** heat



How-to and help videos on our YouTube Channel:  
[YouTube.com/3Doodler](https://www.youtube.com/3Doodler)

**Still having issues?**

If you are still having problems please message us at [help@the3Doodler.com](mailto:help@the3Doodler.com) or call us at: (US) 718 618 9904

Please let us know what type of plastic you're using (ABS, PLA or FLEXY)? What color is the LED on the pen once warmed up? Please also let us know the full serial number on the underside of the pen.



## Are you having trouble reversing plastic?

1. Hold down on BOTH extrusion buttons at the same time to reverse the plastic strand.
2. If your strand is too short to fully reverse, you will not be able to retrieve it. If this happens turn the pen on and wait for the pen to heat up the LED light will change to Blue or Green.
3. Remove the nozzle with the spanner provided in the box.
4. Now take a straightened paperclip and feed it into the nozzle end of the pen to dislodge any blocked plastic. The dislodged plastic should shake free from the back of the pen. If it doesn't shake free, please proceed to remove the maintenance hatch to clear out the plastic.
5. Replace the nozzle while the pen is hot and then try the pen again don't overtighten the nozzle or apply excess force.



## Is there small amount of white smoke around the nozzle?

A small amount of white smoke isn't unusual or a concern! This is caused by excess plastic heating up around the nozzle, or because plastic has become lodged around or underneath the nozzle. To prevent/reduce this, simply wipe the nozzle

down with a tissue while the pen is hot (being sure not to burn yourself). For good measure, tighten the nozzle. If you are also seeing the plastic bubble a lot when extruding, please use the miniscrewdriver to turn the temperature adjuster down a bit.



## Is the plastic curling around the nozzle/ not sticking to paper?

Fret not, this is one of the most common questions we get. If you are finding that the plastic won't hold to the paper, or goes off in random directions, don't worry, the solution is very simple: **Push your**

**pen firmly into the paper, allow the plastic to extrude for a couple of seconds, and then lift the pen up off the paper.**



## Is the light going red while you Doodle?

Your 3Doodler is functioning normally. The pausing is caused by the pen heating up to stay at optimal temperature. The 3Doodler needs to pause while doing this. Wait a few seconds and keep Doodling!