

FDM jams: what to check

Find the cause. Change one thing. Check the result.

Stop the print if filament grinding continues. Maintain cooling during normal cooldown. Follow your printer's procedure before working on it.

1

Record when it fails

First layer, after a while, in fast sections or after frequent retractions. These are clues for choosing the first check.

2

Check filament feeding

The spool should turn freely. Check guides, tubes, drive gears and feeding pressure. Check nozzle-to-bed distance too.

3

Check the hotend cold section

Check the fan, fins and airflow to the heatsink. Review the recommended enclosure conditions for your material.

4

Reduce demand and calibrate

Check temperature and flow. Calibrate in OrcaSlicer only once feeding is stable and save a limit with a margin in the profile.

5

Adjust retraction; clean if needed

Start with the recommended profile. If a blockage persists, follow the manufacturer's cleaning procedure and check the nozzle before replacing it.

6

Validate before a long print

Remove the chewed section using the printer's normal unloading procedure. Run a short print and record the change and result.

Printer / hotend: _____

Filament / nozzle: _____

Change and result: _____