



# Ultimaker 3, 3 EXT - Adaptor Setup

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## INTRODUCTION

This installation uses the [1.75mm Adaptor A](#)

## Step 1 — Bowden tube replacement



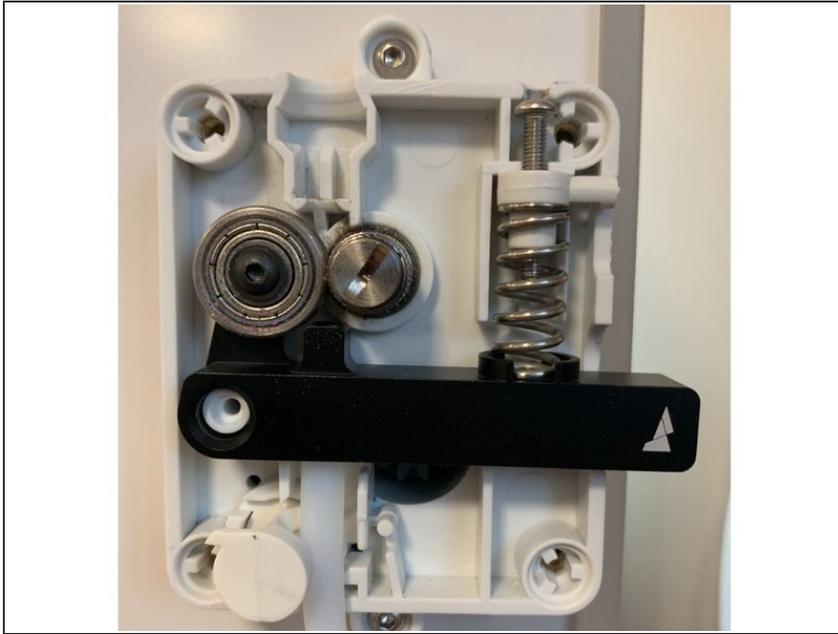
- [How to replace the Ultimaker bowden tube with the PTFE tube used for 1.75mm filament.](#)

## Step 2 — Install the short hot-end PTFE sleeve



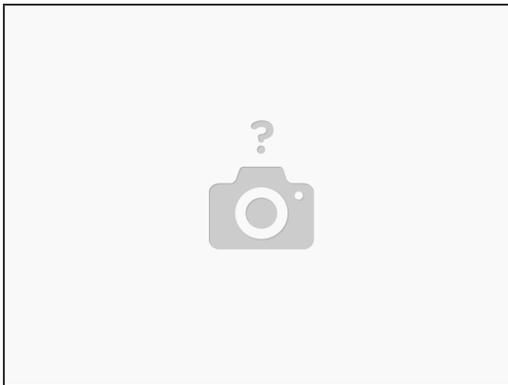
- [How to install the short hot-end PTFE sleeve into the hot-end.](#)

### Step 3 — Swap the extruder drive arm



- [How to swap the extruder drive arm in the Ultimaker filament feeder on the back of the printer.](#)

### Step 4 — Install the Palette tube into the extruder input



- [Install the Palette outgoing tube into the filament feeder or extruder input.](#)

## Step 5 — Single Color Test

Specify the thickness of the outer shell of your model. This thickness will be used for top and bottom layers, as well as adding solid material to the outside of your part when set thicker than your number of perimeters. A higher value will provide a stronger part and more filled-in top and bottom layers. However, more material will be used and print times will increase.

Shell 3 layers Perimeters 2

Shell thickness  
3 layers

Solid layer speed  
48 mm/s

Semi-solid layers below top surfaces

Travel movement

XY travel speed  
100 mm/s

Z travel speed

Perimeters

Number of perimeters  
2

Perimeter order  
 Inside-out  Outside-in

Perimeter speed  
30 mm/s

Perimeter seams

Coast distance  
0 mm

Discard corners on corners when possible

- [Run a test print using 1.75mm filament to see if the adaptor installation is done correctly.](#)

## Step 6 — Palette 2 Calibration with Ultimaker 3 or Ultimaker 3 EXT



- [Please proceed to the calibration guide.](#)