

# Microswiss FlowTech™ Hotend for Bambu Lab P1S

## INSTALLATION INSTRUCTIONS

**Tools Required:**

2.0mm Allen wrench

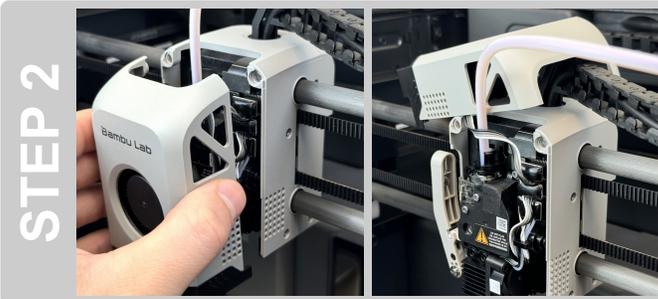
**What's in the box:**

Heatsink	0.4mm Plated Brass Nozzle	Fan Mounting Screws (2x)
Titanium Mounting Screws (2x)	Silicone Sock	
Heater Core	3D Printed Torque Wrench (4in-lb)	



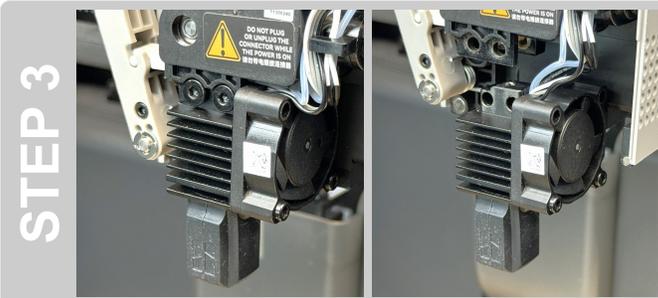
**SAFETY / PREPARATION**

- Allow the hotend to cool down to room temperature.
- Power off the printer.
- Disconnect the power cable.
- Press the Filament Cutter Lever on the left side of the print head.



**REMOVE THE FAN SHROUD**

- Pull the magnetic fan shroud off of the print head.
- Set the fan shroud on top of the print head.  
Leave the connector attached to the breakout board.



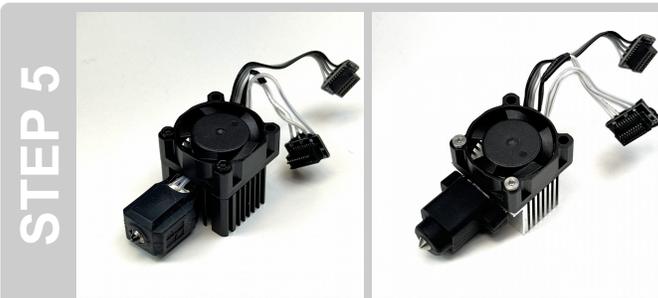
**UNFASTEN THE ORIGINAL HOTEND**

- Remove the two screws located near the top of the heatsink. (2.0mm Allen wrench)
- Pull the original hotend down to detach it from the carriage.



**DISCONNECT THE CABLES**

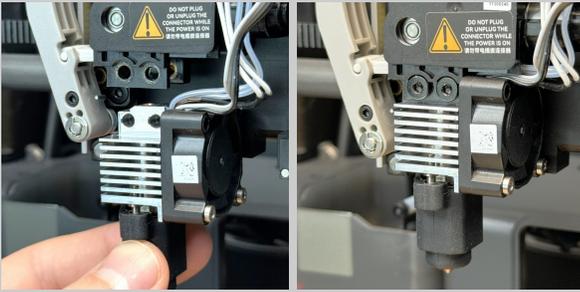
- Disconnect the original hotend's thermistor, heater, and fan cables from the breakout board.



**TRANSFER THE FAN**

- Remove the two screws securing the cooling fan to the original hotend's heatsink. (2.0mm Allen wrench)
- Attach the cooling fan to the FlowTech heatsink using the two new screws provided with the kit. (2.0mm Allen wrench)

## STEP 6



### FASTEN THE FLOWTECH HOTEND

- Secure the FlowTech hotend to the carriage using the original mounting screws. (2.0mm Allen wrench)

## STEP 7



### CONNECT THE FLOWTECH HOTEND

- Connect the hotend and fan connectors to the matching ports on the breakout board.

## STEP 8

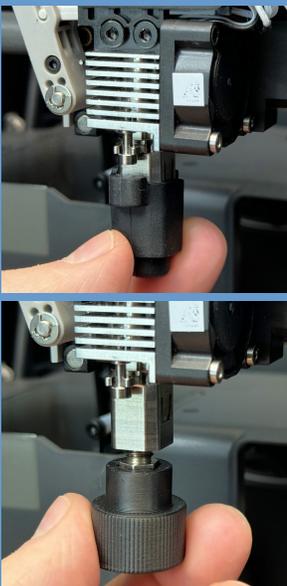


### INSTALL THE FAN SHROUD

- Tuck the cables in so that they do not get in the way of the fan shroud.
- Reinstall the magnetic fan shroud.

[Installation Complete!](#)

## SERVICE NOTE



### NOZZLE REPLACEMENT PROCEDURE

The FlowTech nozzles can be swapped while the hotend is at room temperature.

- Press the Filament Cutter Lever on the left side of the print head.
- Detach the magnetic fan shroud and set it on top of the print head.
- Pull the silicone sock off of the heater core.
- Use the provided 3D printed torque wrench to unscrew the nozzle.
- Install and finger tighten the new nozzle until snug.
- Torque the nozzle using the included 3D-printed torque wrench until you feel it click once. [The 3D printed torque wrench is designed to click at 4 inch-pounds of torque.](#)  
**Be careful to not over tighten the nozzle if using a socket wrench.**
- Replace the silicone sock.
- Reinstall the magnetic fan shroud.

[Click here for replacement nozzles](#)

### FLOWTECH NOZZLE OPTIONS



**M3001**  
Brass Plated Nozzle

Sizes available:  
0.25mm, 0.3mm,  
0.4mm, 0.6mm,  
0.8mm, 1.0mm



**M2904**  
CM2 Nozzle  
[Hardened Steel Tip](#)

Sizes available:  
0.4mm, 0.6mm,  
0.8mm, 1.0mm



**M2905**  
CHT Nozzle  
[High-Flow](#)

Sizes available:  
0.4mm, 0.6mm,  
0.8mm, 1.0mm



**M2907**  
CHT CM2 Nozzle  
[High-Flow Hardened Steel Tip](#)

Sizes available:  
0.4mm, 0.6mm,  
0.8mm, 1.0mm



**DBFT-175-04**  
DiamondBack Nozzle  
[Diamond Tip](#)

Sizes available:  
0.25mm, 0.4mm,  
0.6mm, 0.8mm,  
1.0mm