



Mako™ Hotend Clogging with Low-Temperature Filaments

Some users may experience clogs when printing with PLA or other filaments with low melting temperatures. This can occur if heat rises within the hotend & causes the filament to soften too early, leading to blockages in the hotend/nozzle.

Recommendations for Avoiding Clogs

- Keep your printer in a room with an ambient temperature of at most 25°C.
- Use the Bambu Lab Cool Plate or keep the bed temperature at 50°C or below.
- Ensure the filament is dry.
- For enclosed machines, print with the door & lid open.
 - If you are using the AMS on your printer, you can try printing this [Lid Lift Device](#) from YelTrik Designs to have the lid open, without needing to relocate your AMS from the top of your printer.
- Bambu Studio Slicer Settings
 - Make sure to use our custom material profiles for the Mako Hotend [here](#).
 - In the Bambu Studio Slicer, reduce the retraction length to 0.6 mm ([Printer Settings > Extruder](#)) & disable “Long Retraction When Cut” ([Filament Settings > Setting Overrides](#)). If you don’t see the “Long Retraction When Cut” setting, there’s no need to worry. It appears this setting is only available for certain versions of Bambu Studio and for specific printers.
- More in depth information can be found in [Bambu Lab's Recommendations for Clog Reduction](#).

Unclogging Procedures

If you do experience a clog, please [follow these instructions](#) to clear it. If the issue persists after making the changes listed above, please contact our [Customer Support Team](#) and we will make sure the issue is fixed.