User manual of

ELEGOO 3D slicing software

ELEGOO 3D Printer

INTRODUCTION

Dear Friends,
Thank you very much for purchasing our 3D Printer. For optimum performance, safety and convenience, please read the instruction before DIY.

I. User Information

a. External Memory/Micro SD Capacity

From 2G to 16GB;

b. SYSTEM REQUIREMENTS

Support Window 10 / MAC

> **Note: Because of 3D Printer are bare metal, you have to pay attention to electrical safety during use! And the power outlet must be three-hole grounded outlet!**

2. Safety Precautions

Before installing and using the machine, be sure to read the following. Do not attempt any user manual does not describe to use the machine to avoid personal injury and property damage accidents may cause.

3. Select the proper placement

- The machine is suitable for placement in a ventilated, cool, dry and less dusty environments.
- Note that when using thermal printer surroundings, avoid placing on a thick carpet or against a wall.
- Do not place the machine near flammable materials or high heat.
- Do not place the unit in a larger vibration or other unstable environment.
- Do not pile heavy objects on the unit.

4. Follow the standard use of power
- Use the power cord supplied with this unit.
- Refer to the "Installation" section of the machine performance parameters to select the appropriate 220V power supply.
- Do not plug the power cord when your hands are wet.

Website : www.elegoo.com

ELEGOO 3D Printer

- Please use a plug, be sure to fully inserted into the power outlet.
- Do not deliberately pull, twist the machine over the distribution line, to avoid causing an open or short circuit。

**5. Note that in the printing process**

- Do not use the machine without the supervision of staff.
- Printing process and print just completed, avoid touching the printer's internal structure and prints, to prevent burns.
- If occur when printing printer smoke, abnormal noise, immediately turn off the power switch, the printer stops working, and contact your purchaser.
- Often do product maintenance
- Do not attempt to use the method described in the manual does not disassemble or modify the machine to prevent damage to the printer or other more serious accidents.
- Regularly in case of power failure, the printer clean with a dry cloth, wipe the dust and bonding of printed materials. If you must use a damp cloth to clean, do not use flammable solvents, flammable solvents to prevent contact with the printer's internal circuitry result in a fire or electric shock.

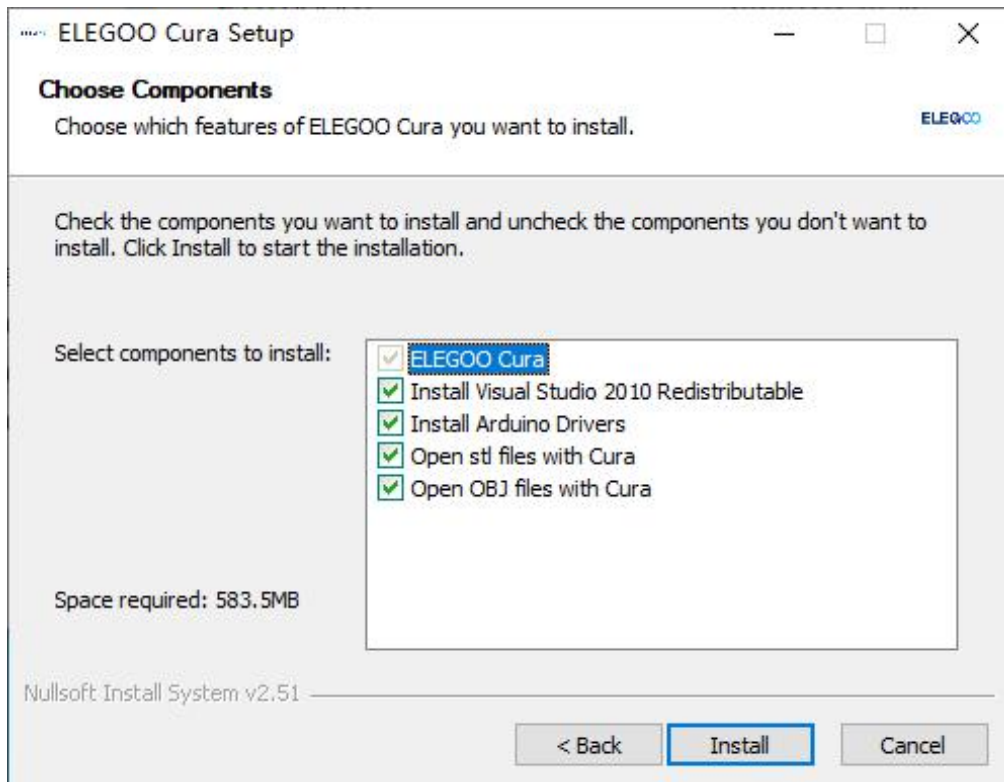# II. ELEGOO Installation and Setup

1. Slice software installation

a. Install the software

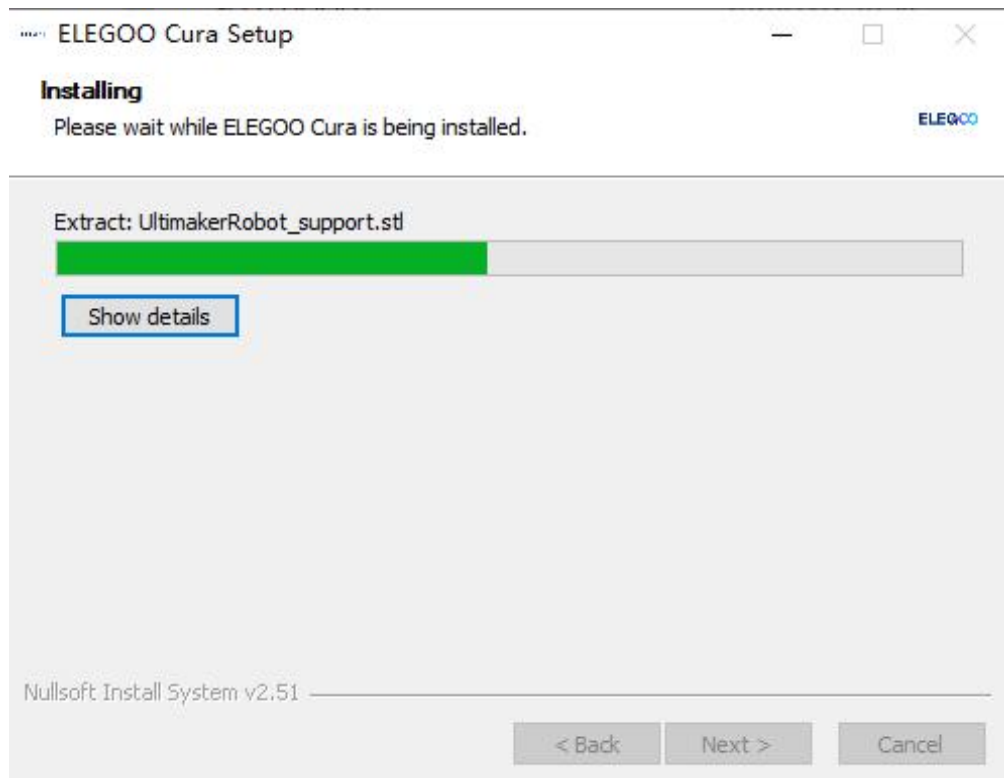Click Setup ELEGOO_Cura_4.8.0 , pop-up installation window, always click Next to complete the installation.
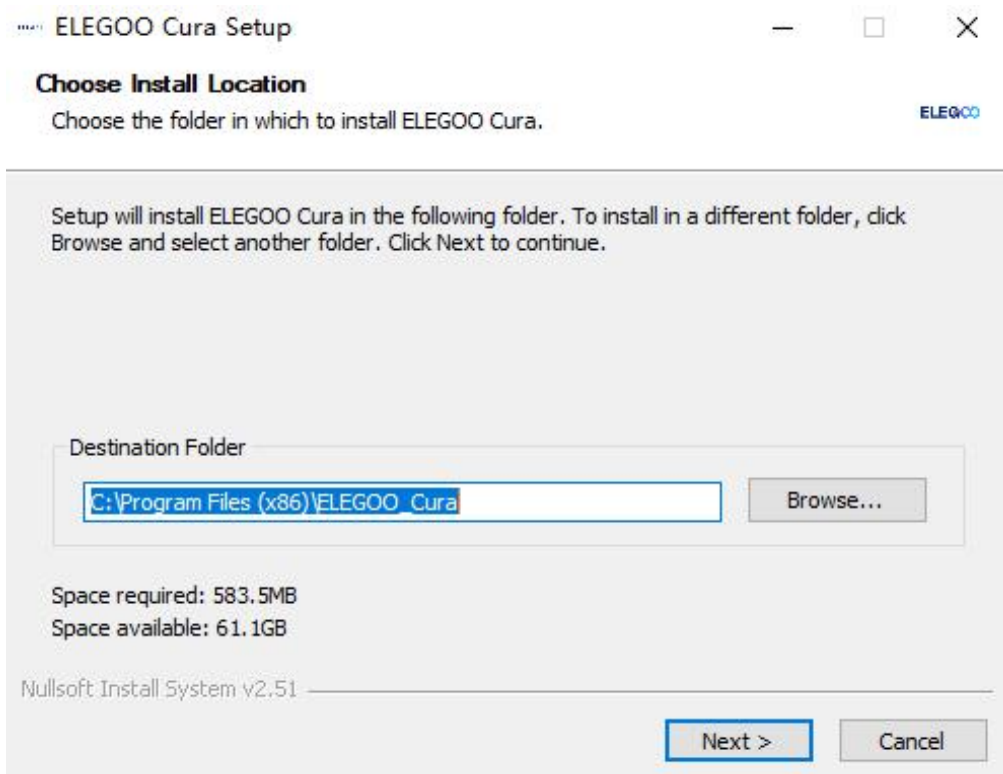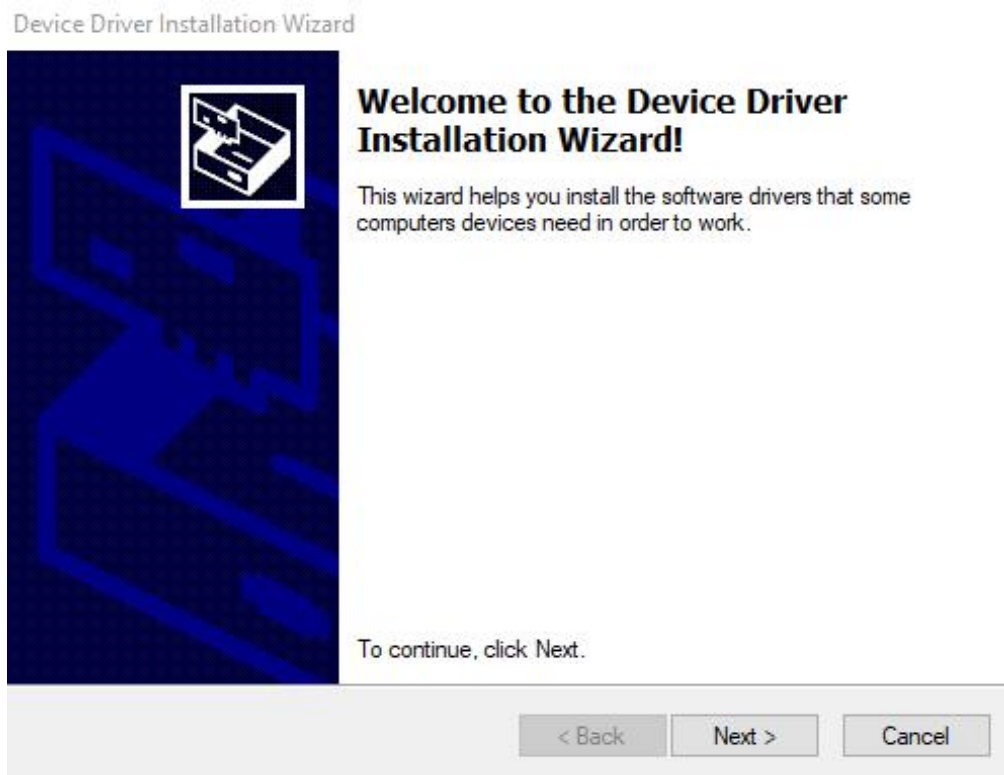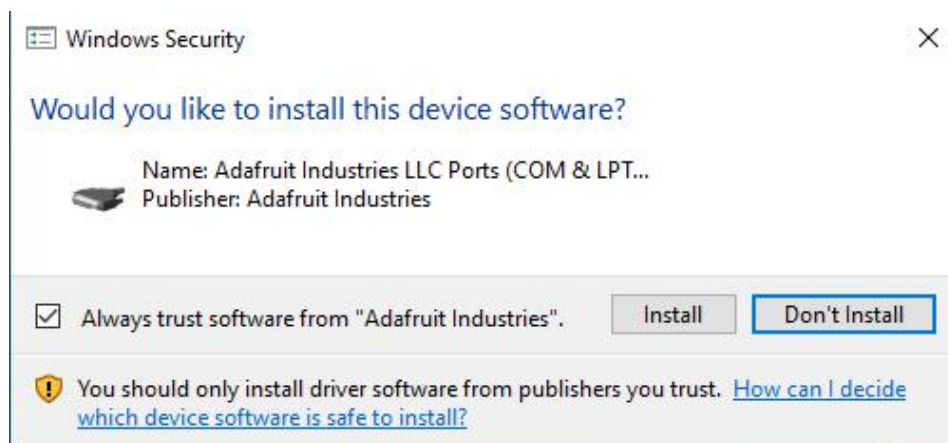

Next

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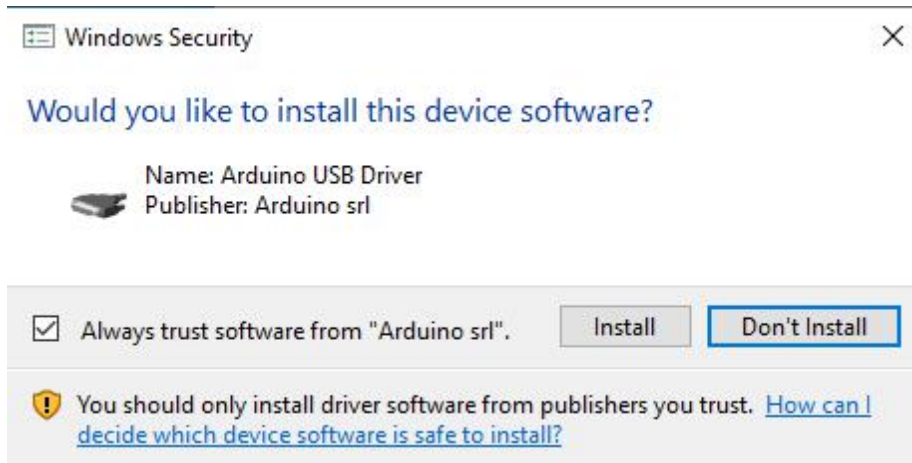**Install**

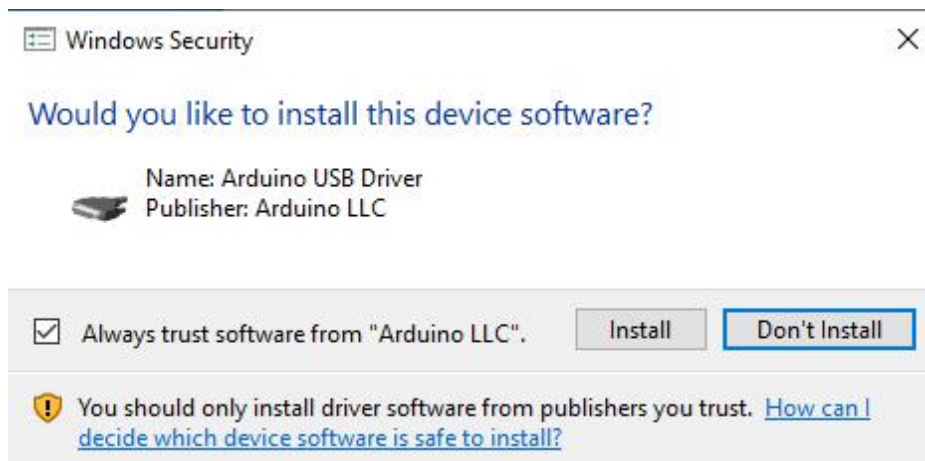
wait for

ELEGOO 3D Printer

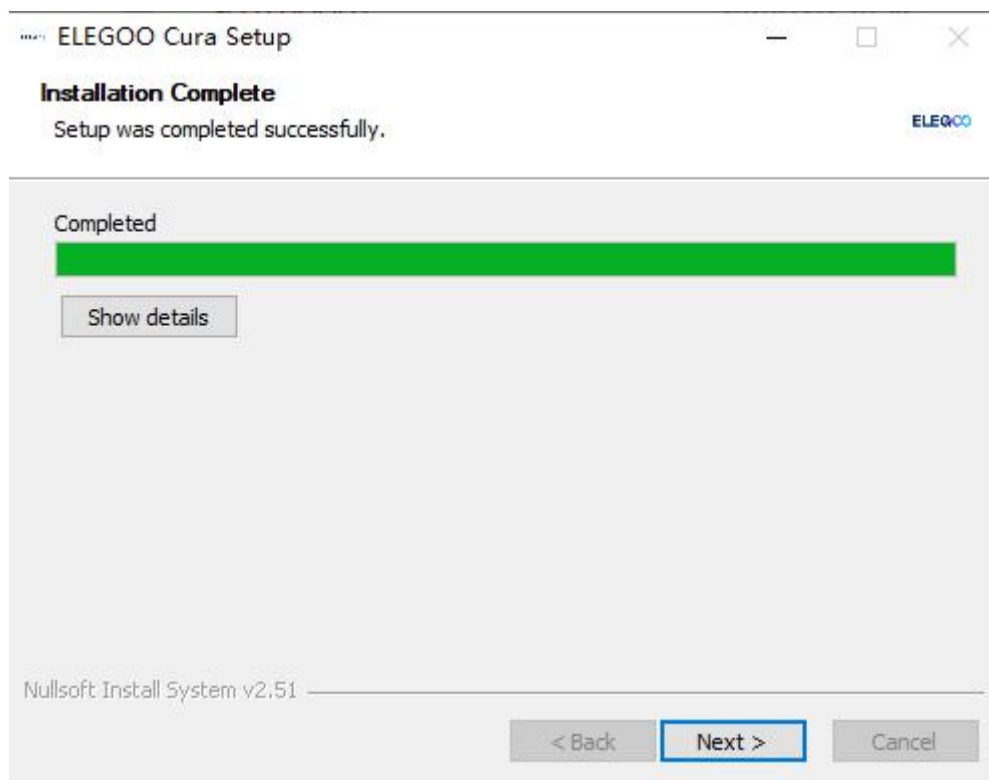

Next

Install

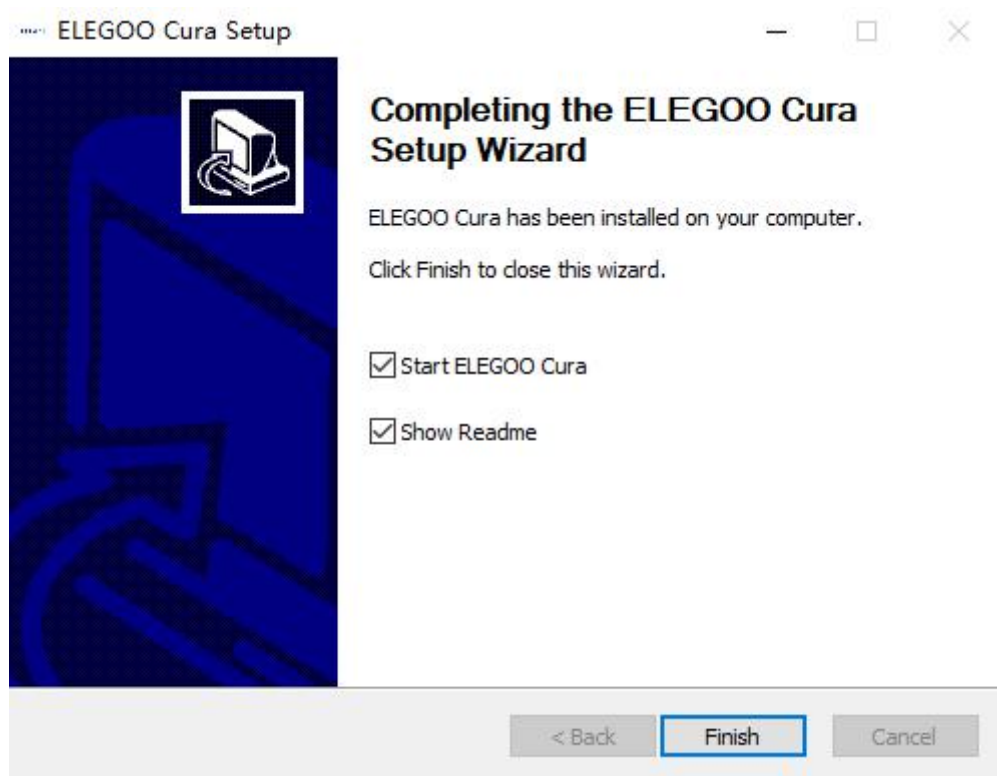# ELEGOO 3D Printer

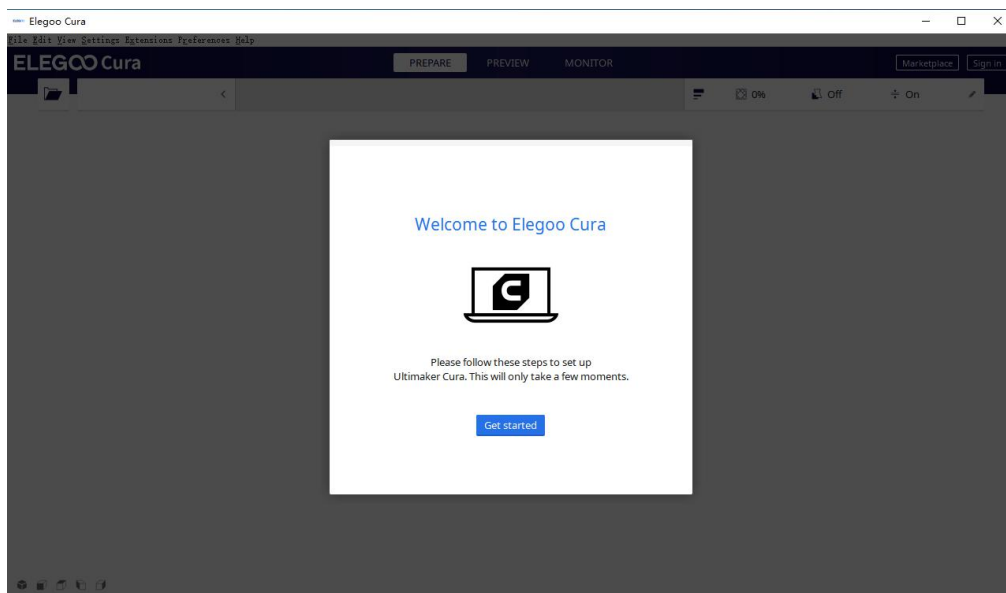**Install**

Install

ELEGOO 3D Printer
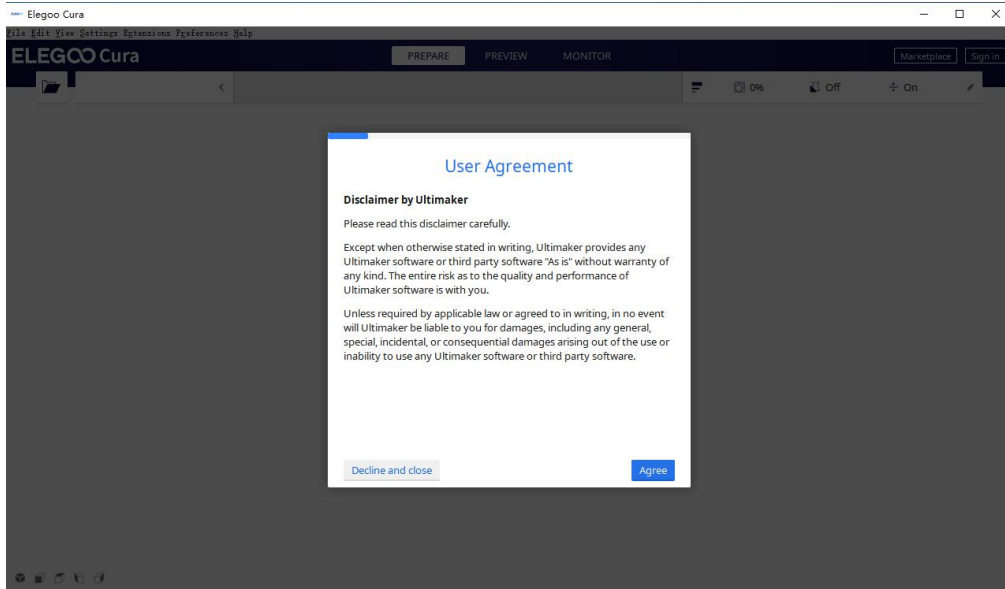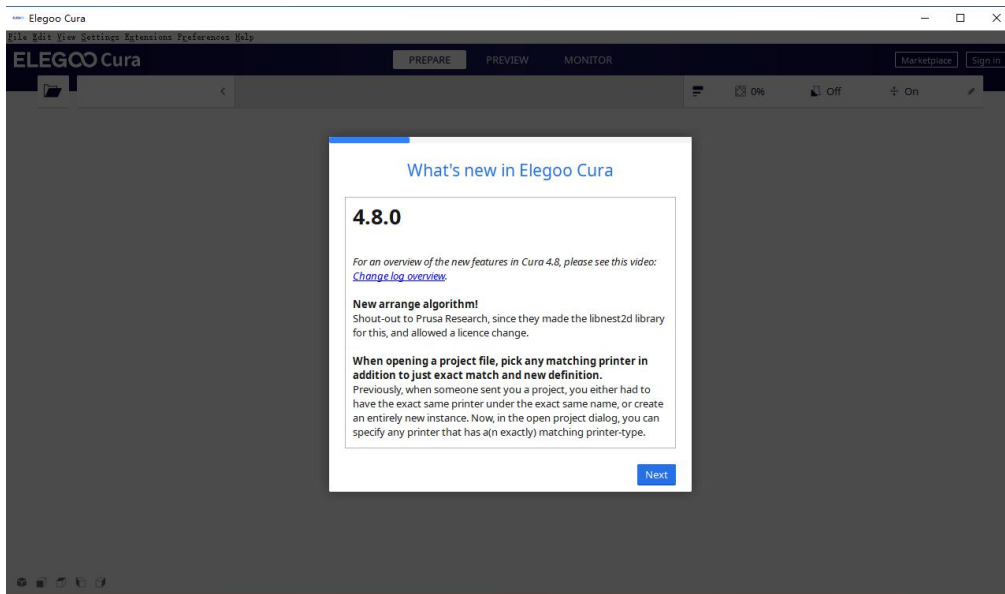

Finish

Next

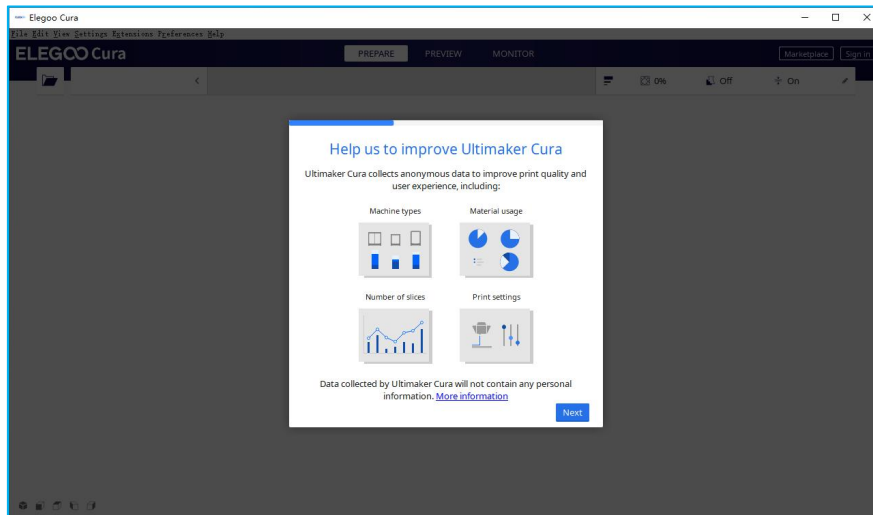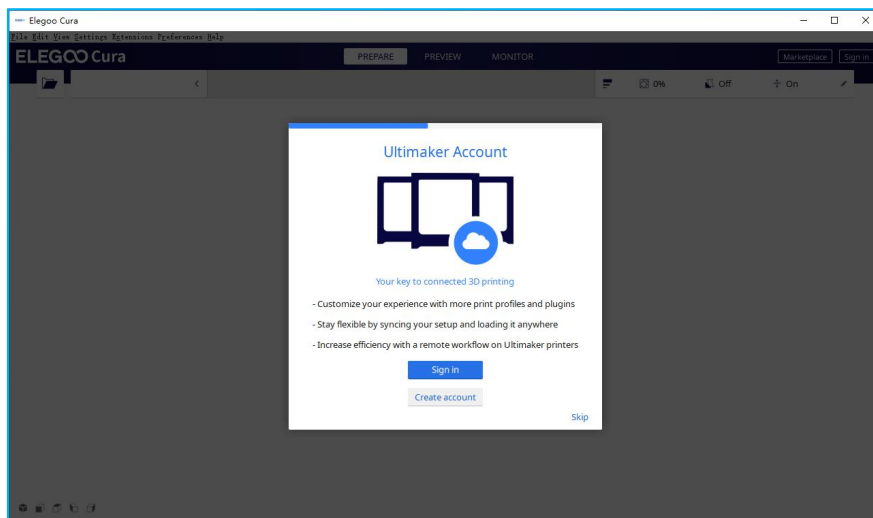# ELEGOO 3D Printer

Finish

Get starts

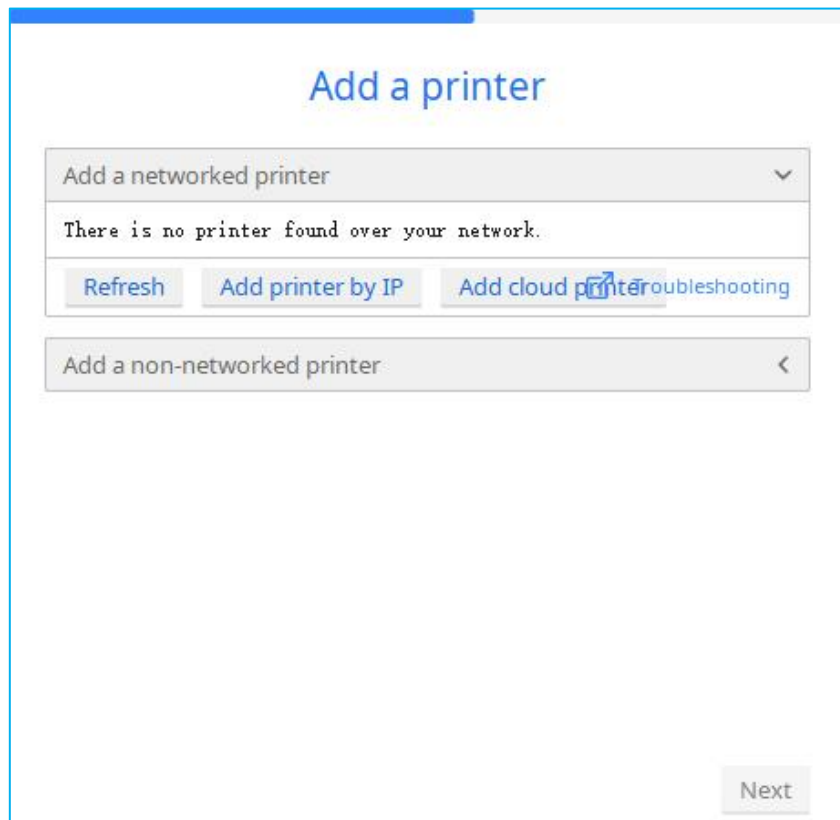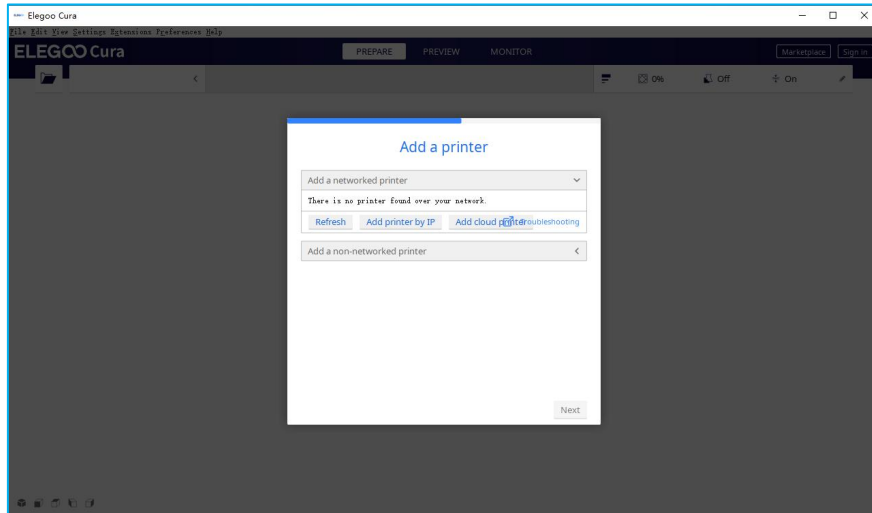# ELEGOO 3D Printer

Agree

Next

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Next

Skip

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The selected machine model is a demonstration example, please select the model based on the actual machine received.
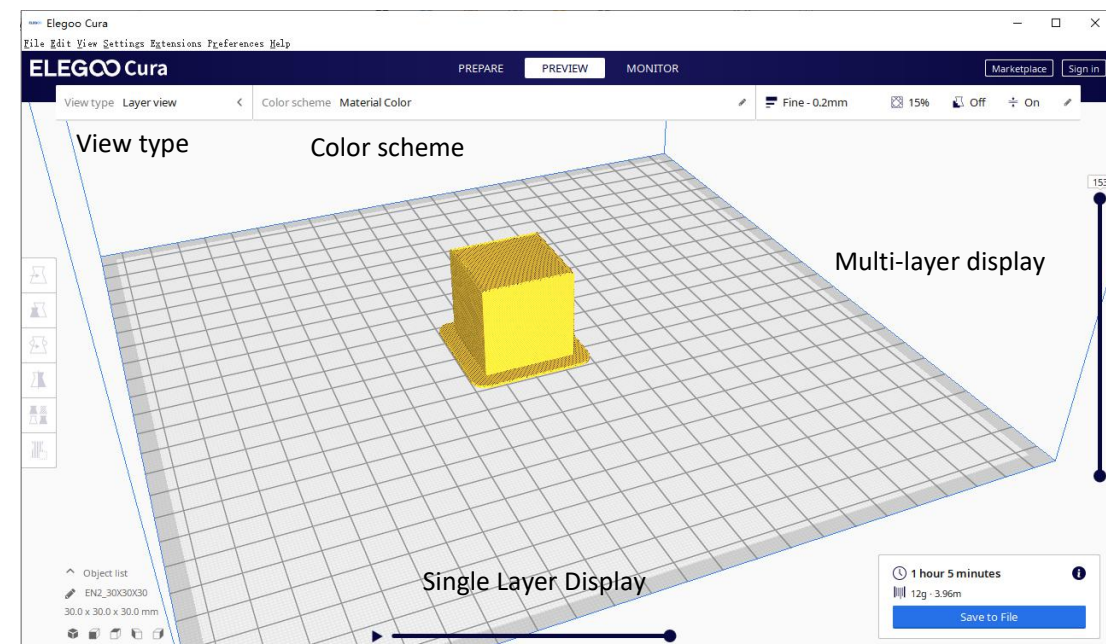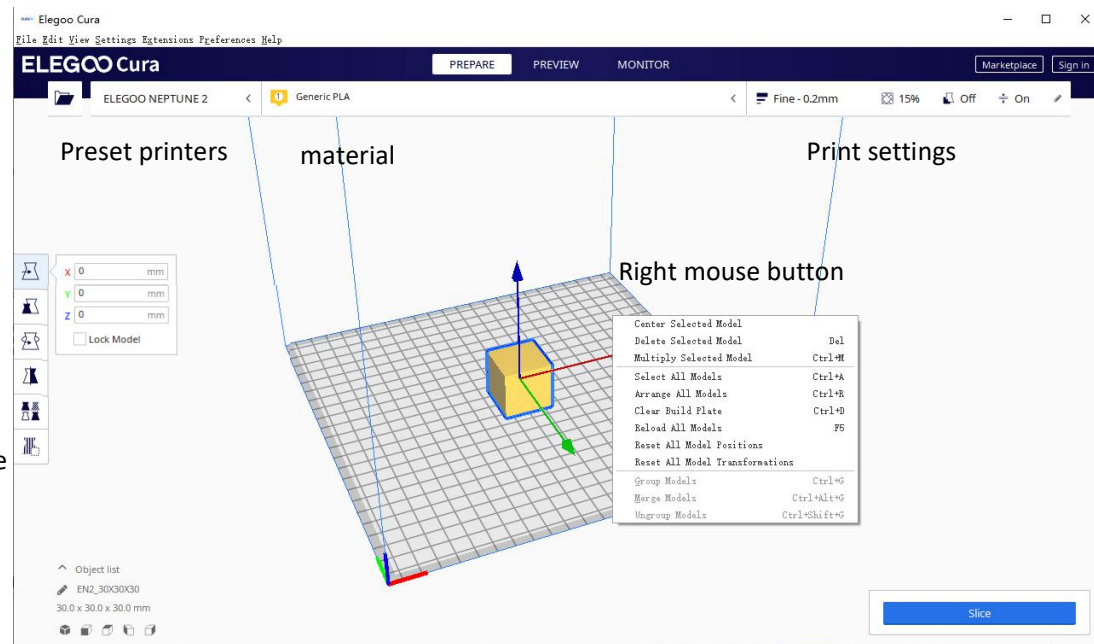
b. Language
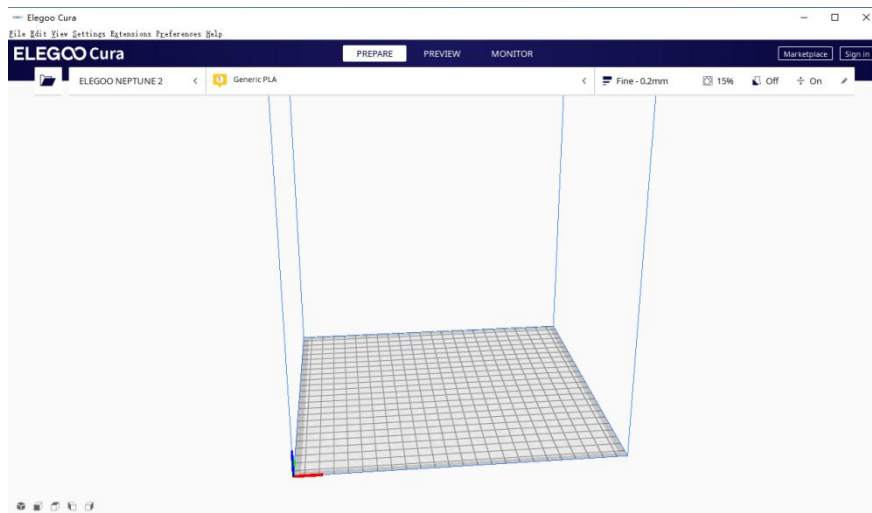
Preferences→Configure Cura→Language→Close

▲ **You will need restart the application for these changes to have effect.**
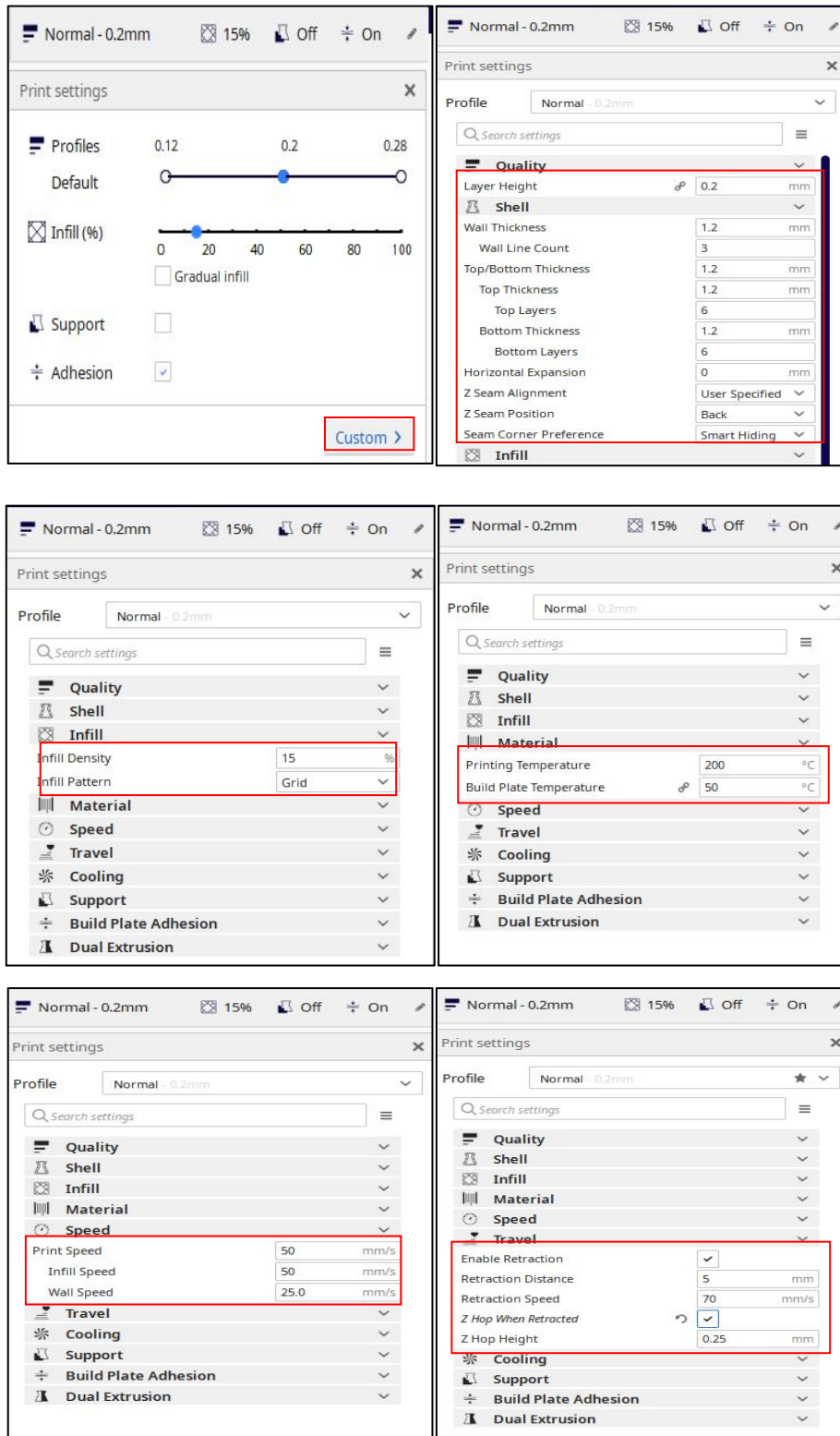
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III. ELEGOO Setup.

a.Software parameter setting

Preset printers
material
Print settings

Right mouse button

Move
Zoom
Rotate
Mirror image
Model setting
Support structure
interception

View type
Color scheme

Multi-layer display

Single Layer Display

save to file/Online Printing

b. Recommended parameter settings:

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The Settings of these parameters are based on the Settings of Neptune 2

models. Different models have slightly different parameter Settings.

Please print and test according to the updated parameters of machine. The

withdrawal distance of the proximal extrusion and the distal extrusion

will be different, and the withdrawal distance of the proximal extrusion is

usually shorter.

IV: For in-depth study, refer to the following notes

1、Layer height

Description:

① Height: the height unit is mm, which is the most important setting to

determine the printing quality. Generally, the height setting of 0.4mm

nozzle needs to be less than 0.4mm. Rough is: 0.32mm, common layer
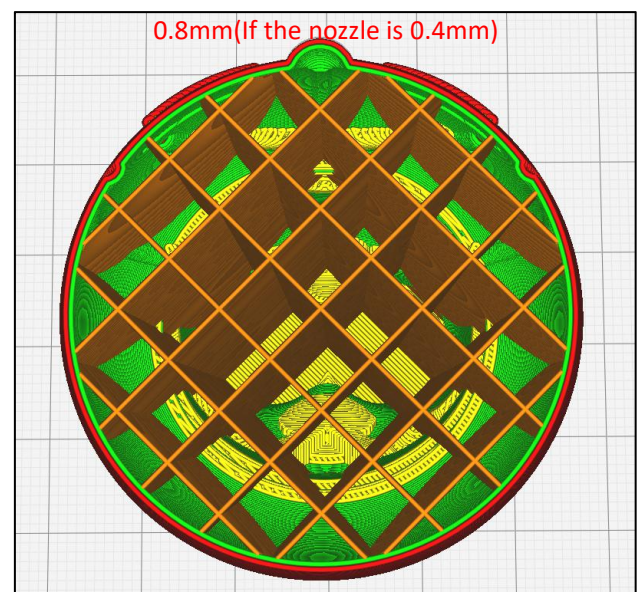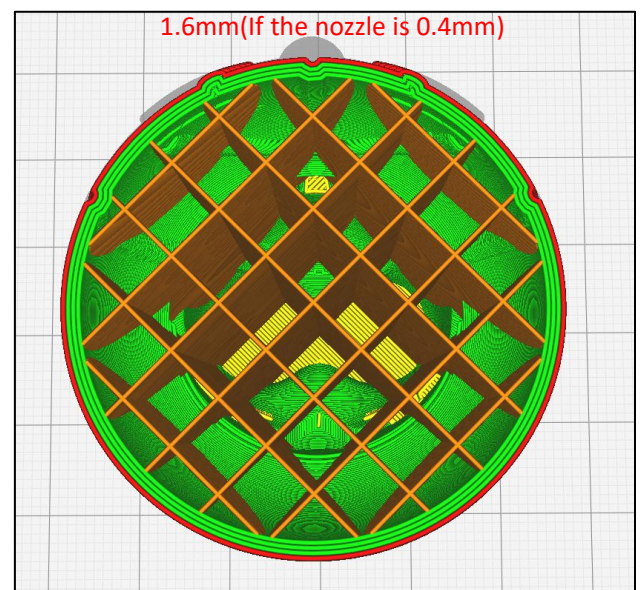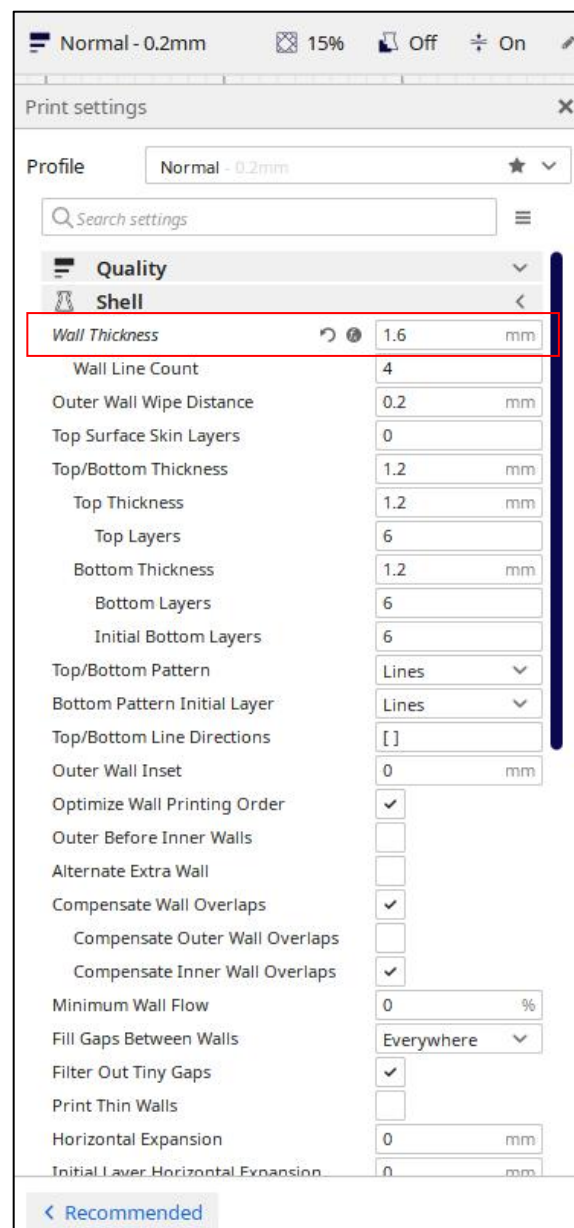
thickness is 0.2mm, high quality is 0.12mm, fine is: 0.08mm.

② The initial line width flow rate of the layer is increased by 25%,

which is conducive to the consumables adhering to the platform plate,

and can be adjusted according to the actual situation.
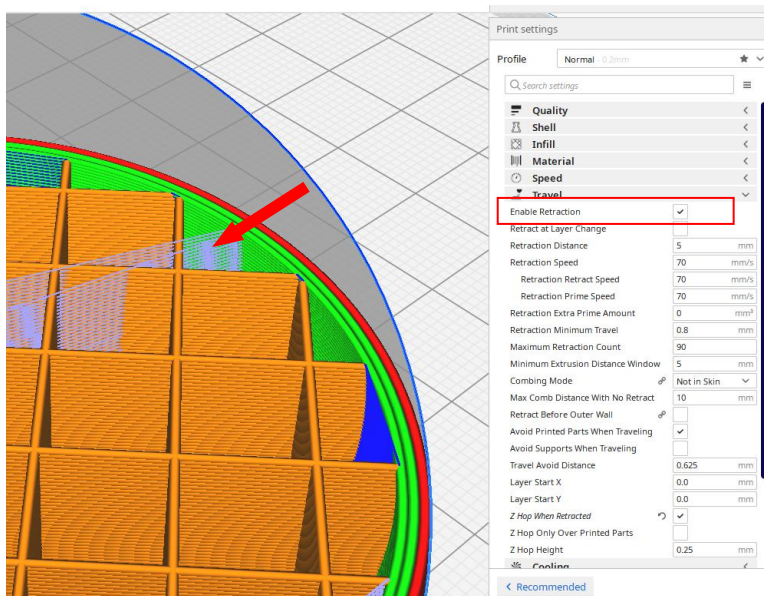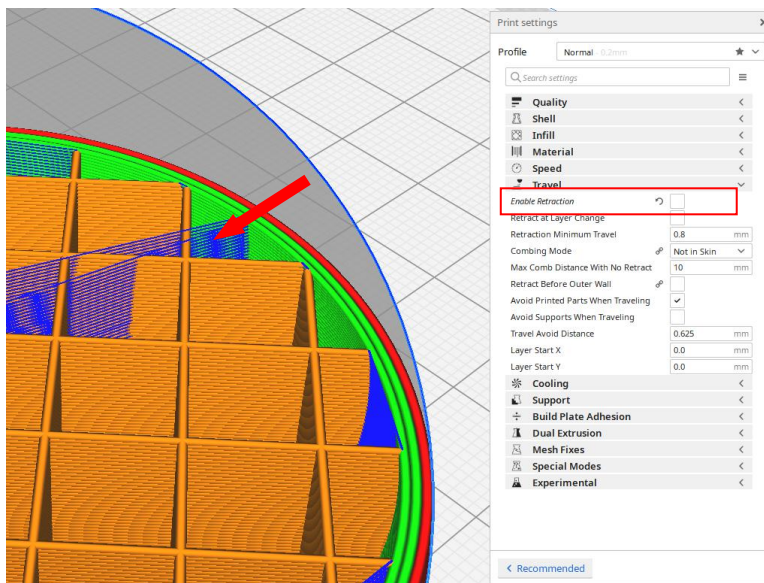
2、Shell thickness

Explanation：Thickness of the outside shell in the horizontal direction.
This is used in combination with the nozzle size to define the number of
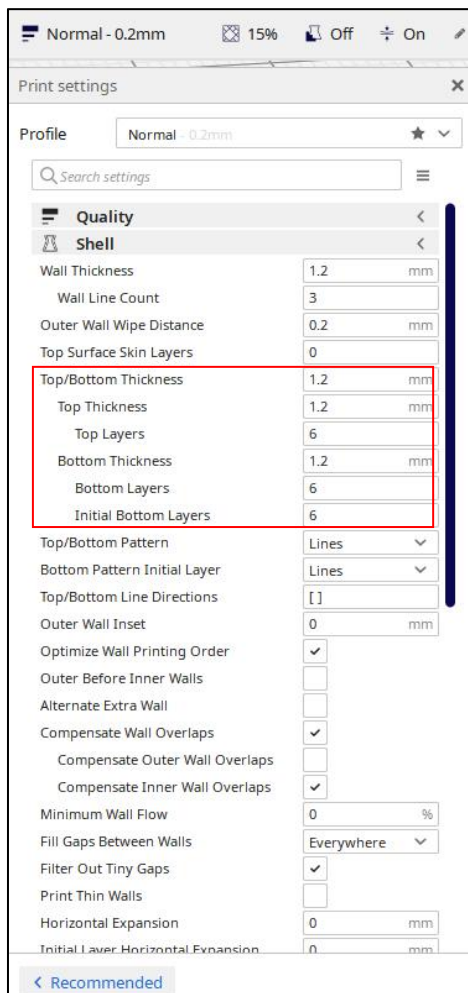
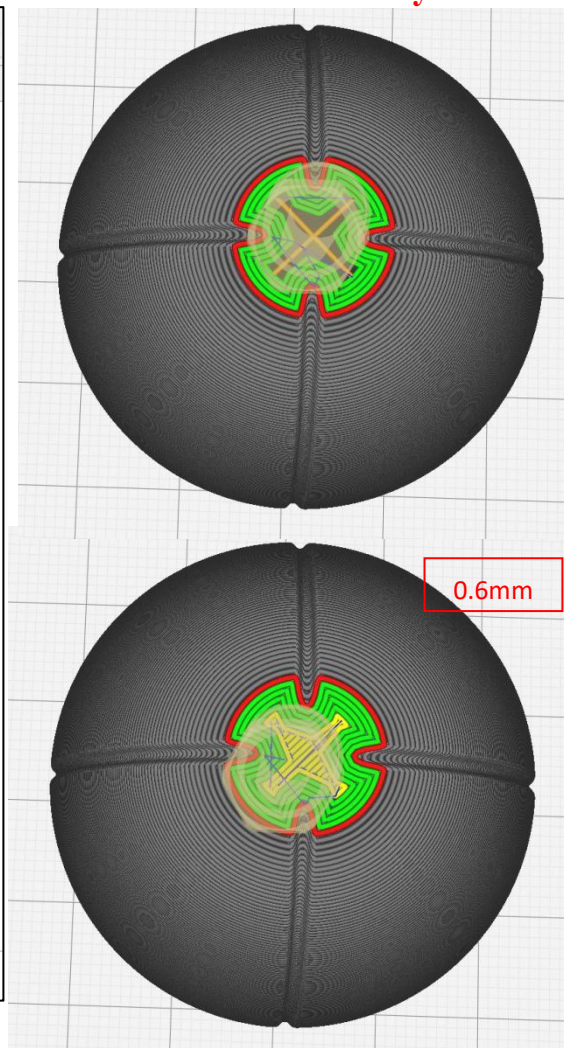**perimeter lines and the thickness of those perimeter lines.**

3、Enable retraction

Explanation：Retraction is for without letting the material flow out during printing, Otherwise it will affect printing surface.

## 4、Bottom/Top thickness

Under the same layers

0.6mm

1.2mm

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Explanation：This control the thickness of the bottom and top layers , the amount of solid layers put down is calculated by the layer thickness and this value .Having this value a multiple of the layer thickness makes sense .And keep it near your wall thickness to make an evenly strong part.
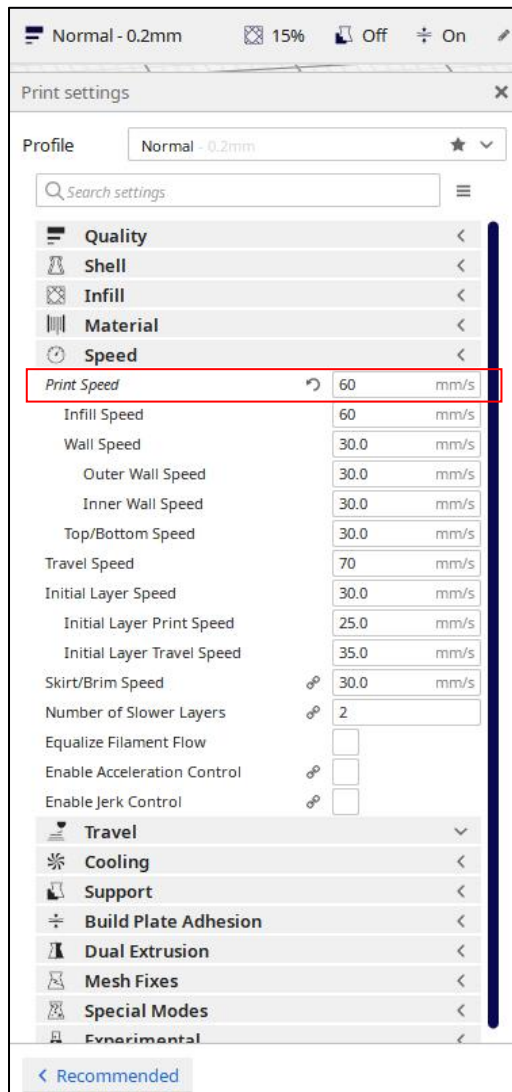
5、Fill Density(％)

（10%）　　　　　　（20%）　　　　　　（30%）
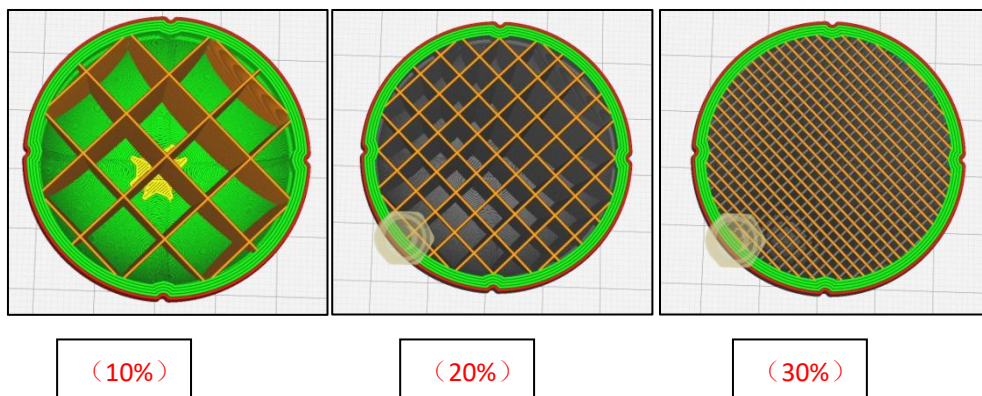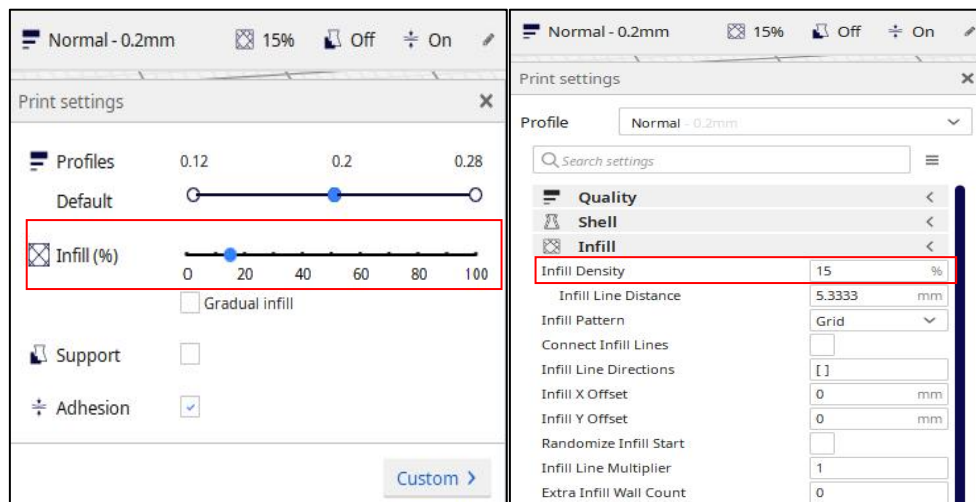
Explanation：For a solid part use 100%,for an empty part use 0%.A value around 20% is usually enough. It adjusts how strong the parts becomes.

6、Print speed（mm/s）

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Explanation：Speed at which printing happens .

Suggest 50-80,according to what you print.Faster speed,worse

effect.

7、 **Print temperature(℃)**

Explanation：Printing temperature used for printing . PLA :nozzle is 190-220,generally 200;Bed is 50-65.

8、 **Support placement**
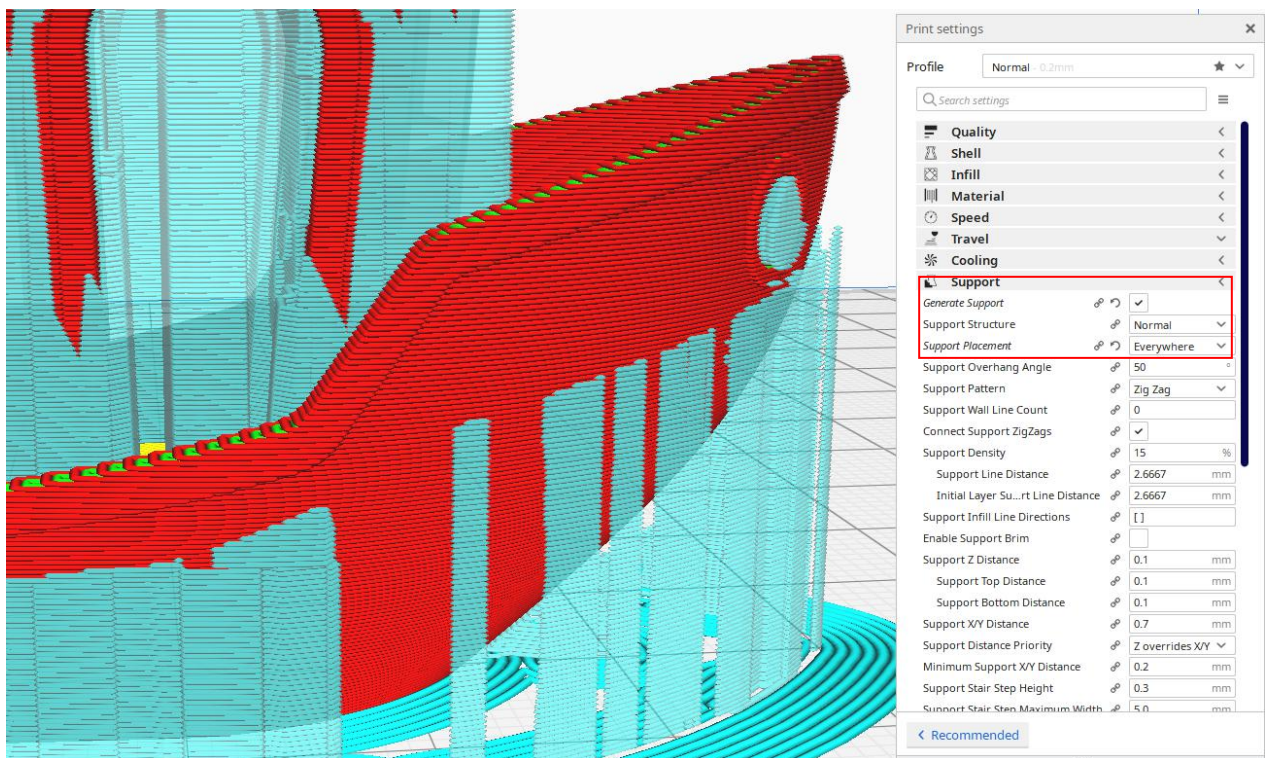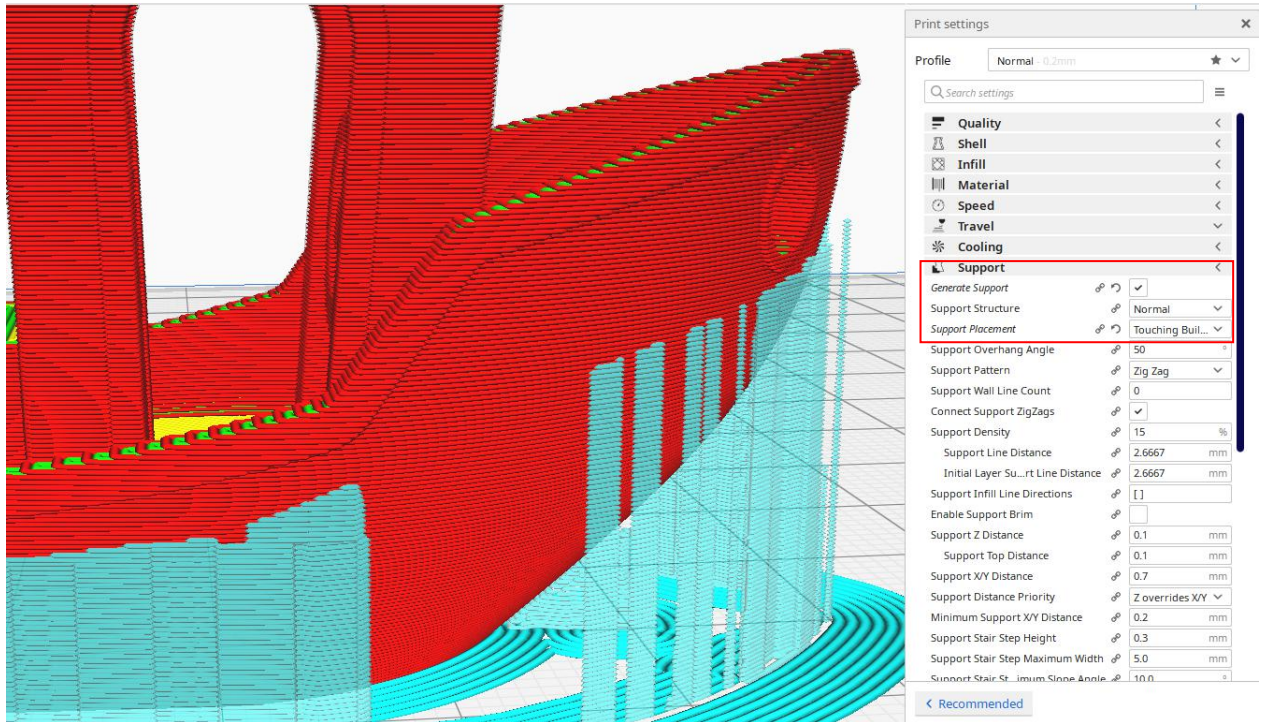
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9、 Platform adhesion type

different options that help in preventing corners from lifting due to warping
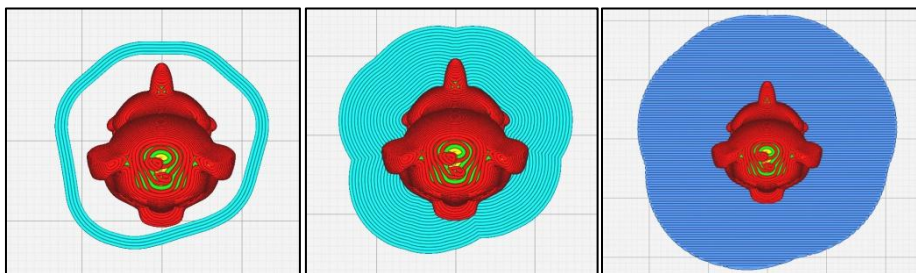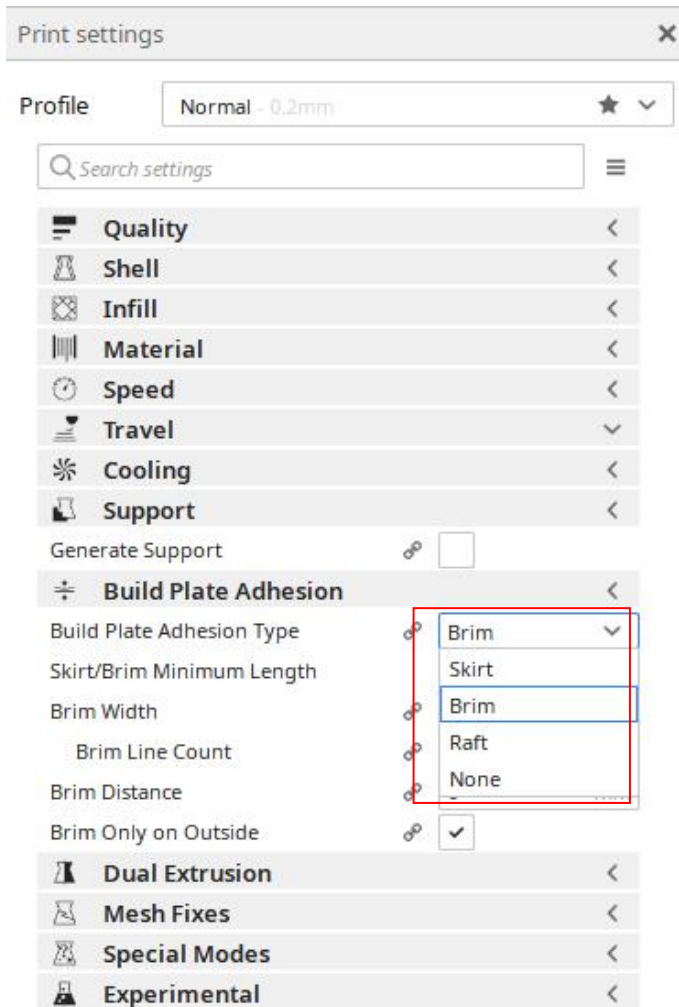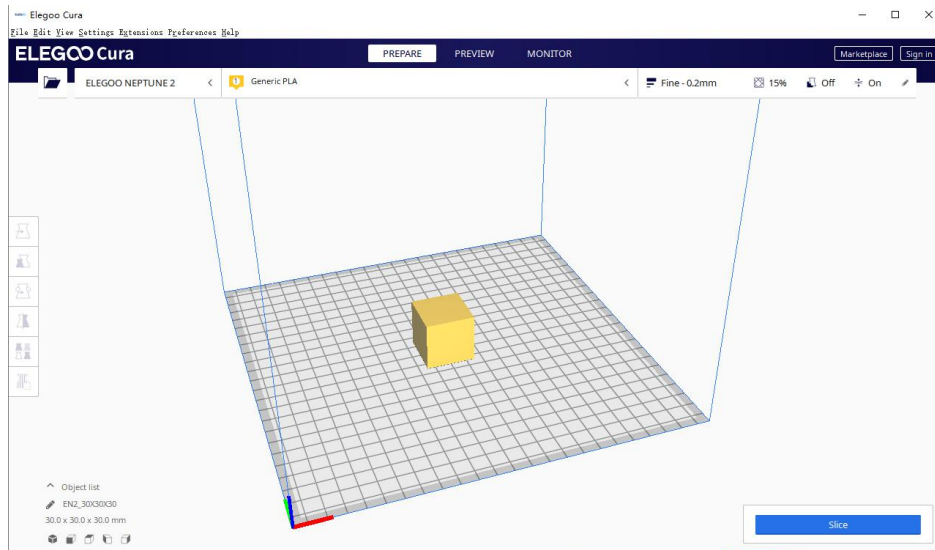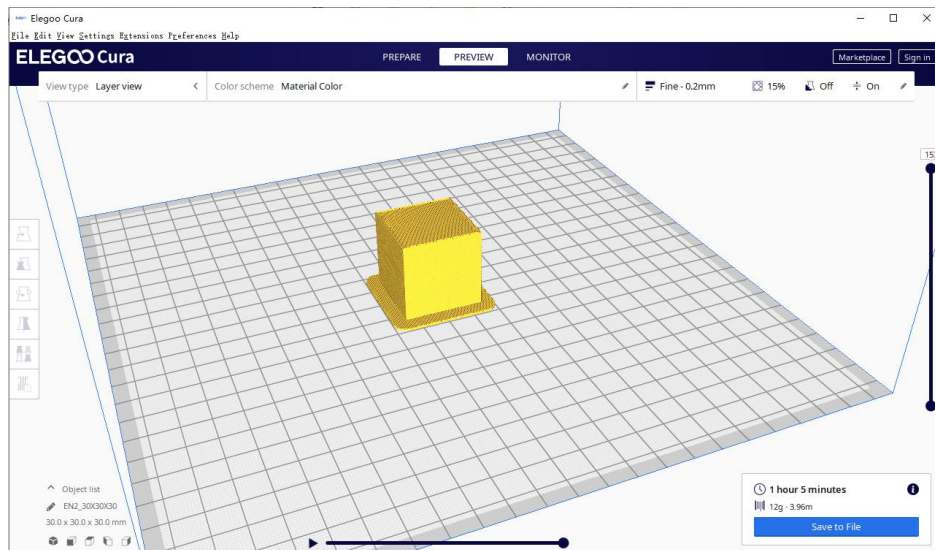
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V: Printing Way[1]

a:Memory Card Offline Printing

Offline printing is one way to use the storage card for printing, do not need computer, it is easy to use and operate, we advise users to choose offline printing.
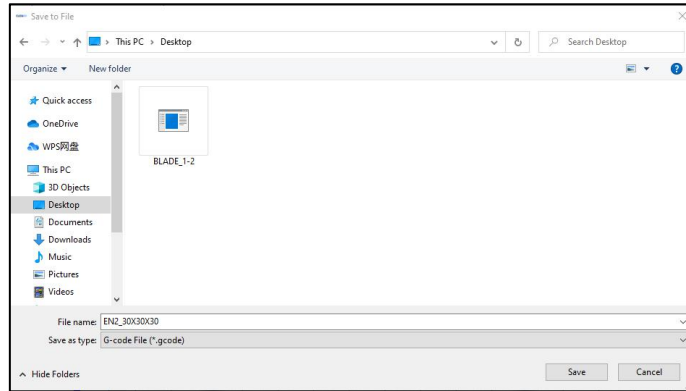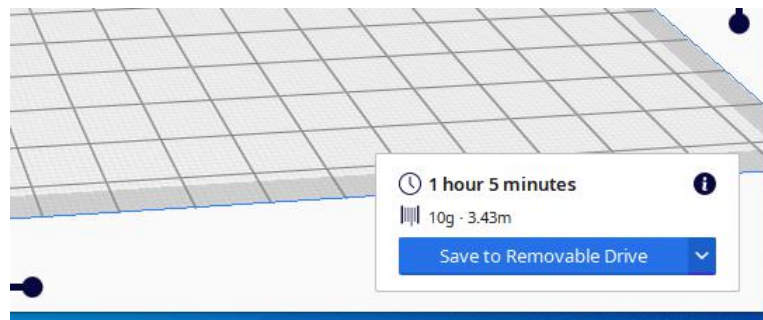

Click slice

Click Save to File

ELEGOO 3D Printer

Select the path in the pop-up window and write the file name，
Insert the storage card，Copy the file to storage card.

b: On line Printing

Online printing need to connect computer to the 3D printer by data cable. The printer cannot be powered off in the printing process, and the computer cannot sleep or go screensaver, or the data transmission will be failure, it is inconvenient to use，we do not advise users to choose this way.

It is recommended to turn off the anti-virus software before installing the driver to prevent the accidental and cause the installation to fail.

The driver installation method is as follows: Open the profile of the TF card to select the path \ Software and Software Driver Folder \ Software Driver Folder \ CH340G USB Driver Folder \ Double-click the [DRVSETUP64] file to run it and click to install it.

Name	Date modified	Type	Size
CH341PT.DLL	11/13/2020 1:49 PM	Application exten...	7 KB
CH341S64.SYS	11/13/2020 1:49 PM	System file	57 KB
CH341S98.SYS	11/13/2020 1:49 PM	System file	20 KB
ch341SER	11/13/2020 1:49 PM	Security Catalog	10 KB
CH341SER	11/13/2020 1:49 PM	Setup Information	6 KB
CH341SER.SYS	11/13/2020 1:49 PM	System file	39 KB
CH341SER.VXD	11/13/2020 1:49 PM	Virtual device driver	20 KB
DRVSETUP64	11/13/2020 1:49 PM	Application	42 KB
SETUP	11/13/2020 1:49 PM	Application	82 KB

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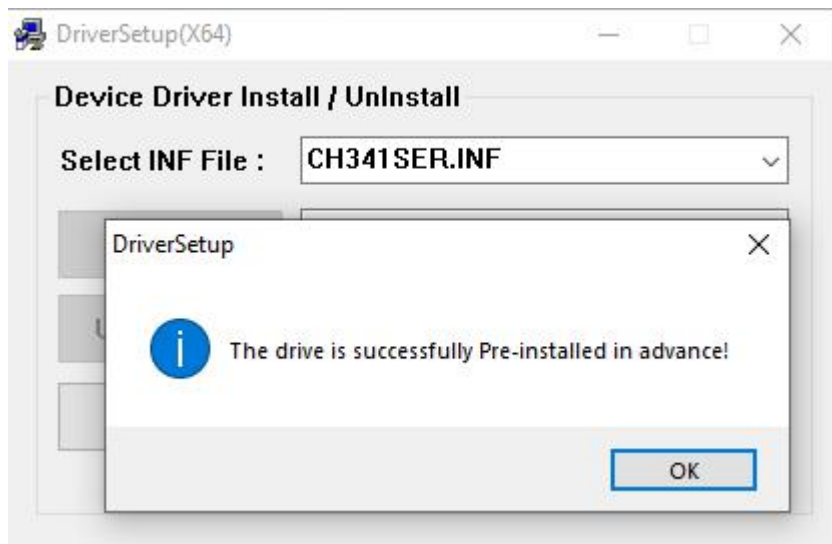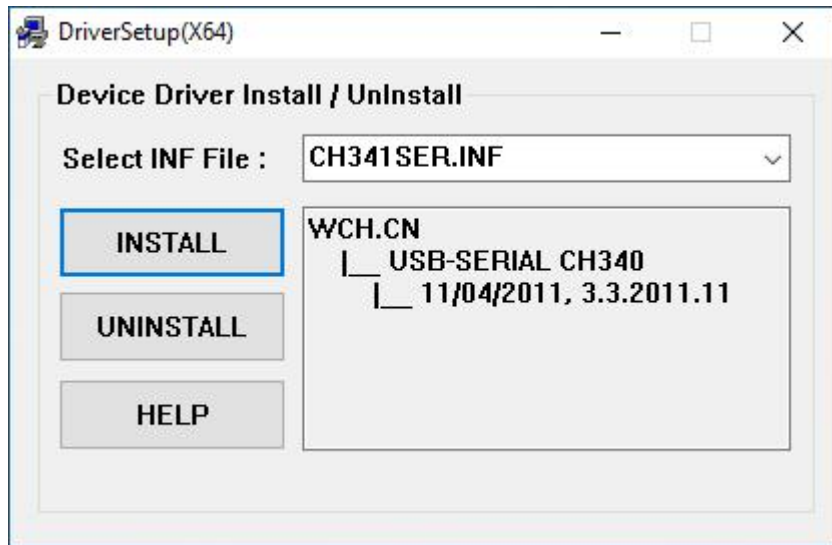

1、Connecting computer to the printer by USB cable.

2、Set up the ELEGOO Slicer as follows.
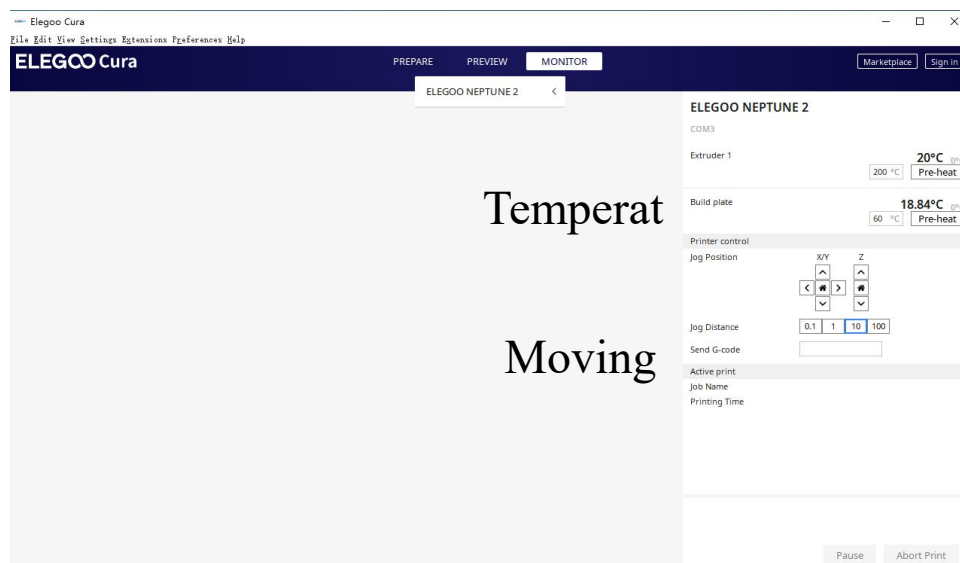
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We can click on the gray ring on the window to control the motion of the XYZE axis. "0.1, 1, 10, 100" are the each amount of motion. The text box in the lower right corner can be input G code to control. If you are not familiar with it, please do not change anything. Click "Print" to start printing. Please be careful during printing to avoid printing failure.
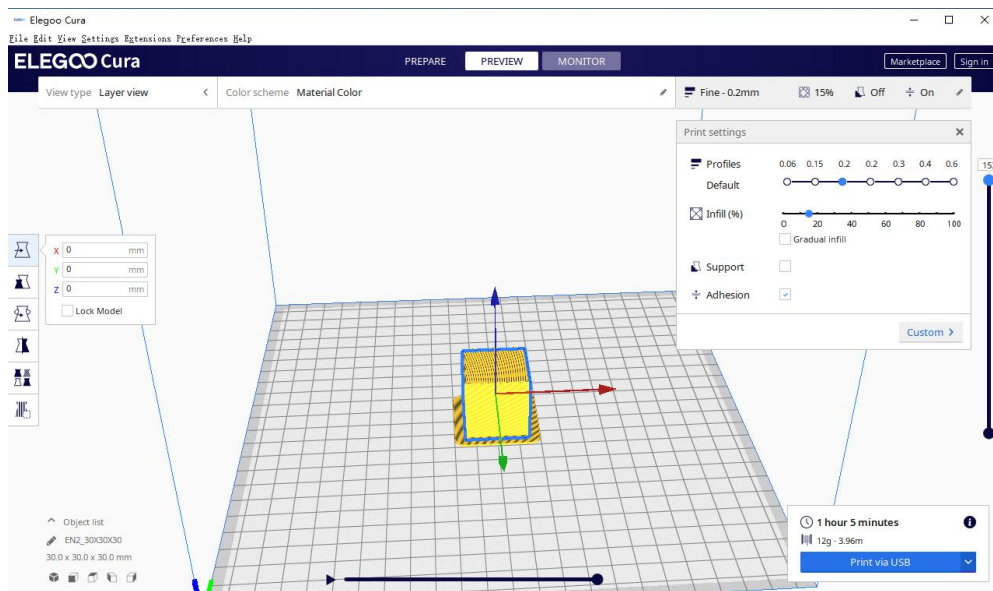
Click Print via USB

Wait for preheating and start printing.

*If you cannot connect properly, please install the corresponding driver or download the third-party driver software.