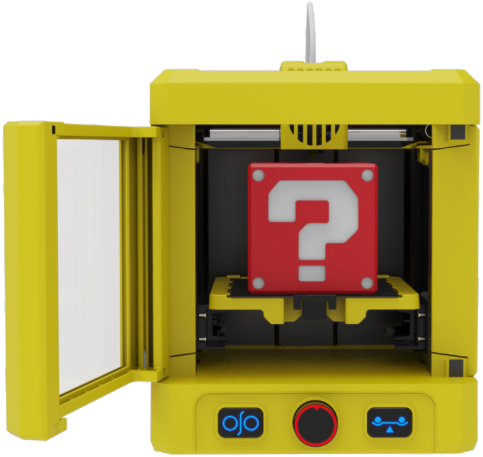

# User manual for MIXWARE WAND 3D Printer

Thank you for choosing Mixware.Your satisfaction is our driving force.

Please read the user manual carefully before using it.

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## First Start


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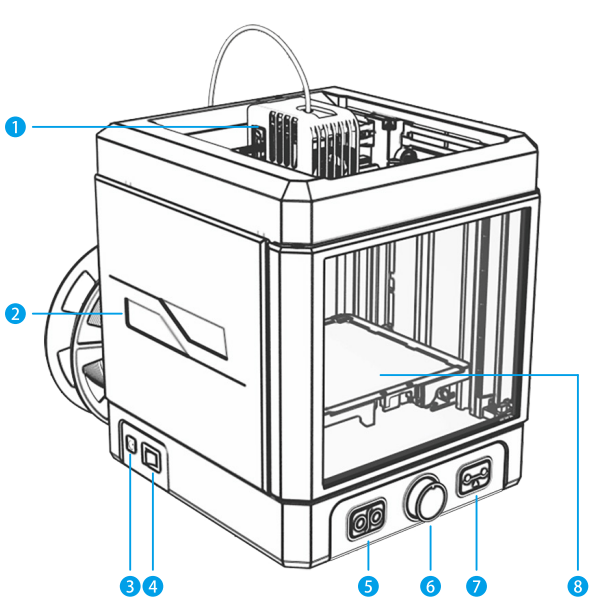
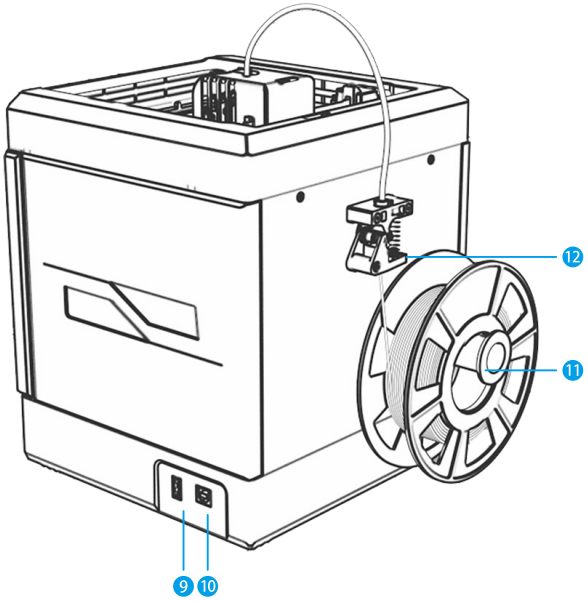
## First Start

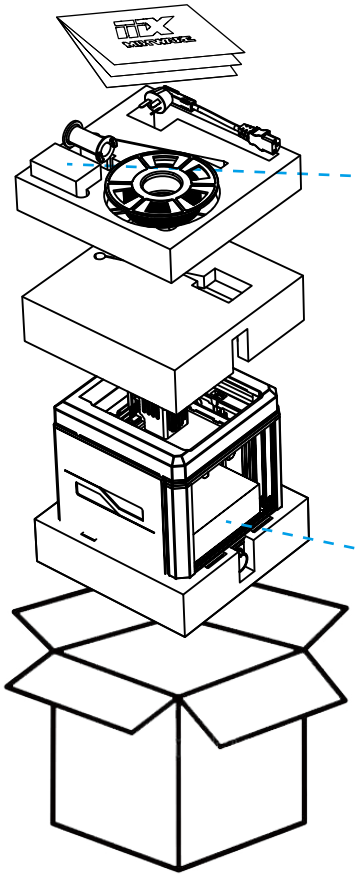
- Introduction



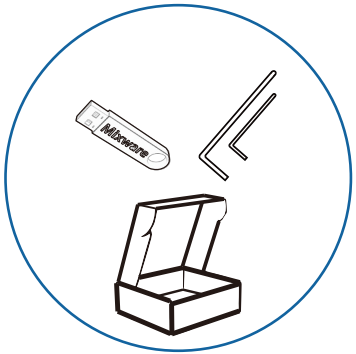




1. Nozzle
2. Indicator
3. Power Port
4. Power Button
5. Button for Load/Unload Filament
6. Print Knob
7. Button for Auto-Leveling
8. Print Platform
9. USB Port
10. USB Data Cable Interface
11. Spool Holder
12. Extruder

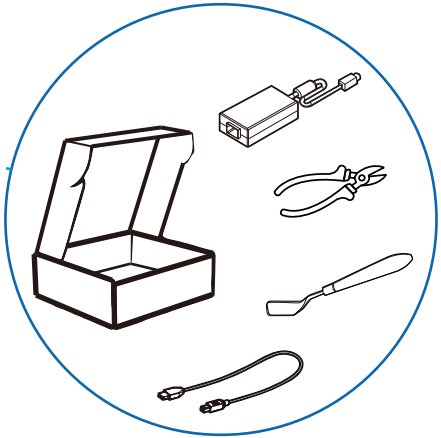
## Packing List



1 Master Carton



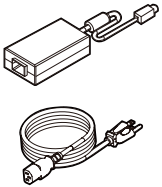
2 Small Accessories Box



3 Large Accessories Box

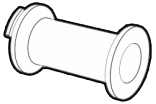
## Accessories List

1. Filament 250g

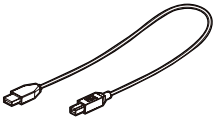


2. Power Adaptor

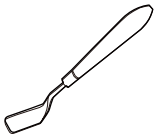
3. USB Flash Disk



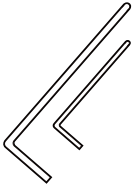
4. Spool Holder



5. USB Data Cable



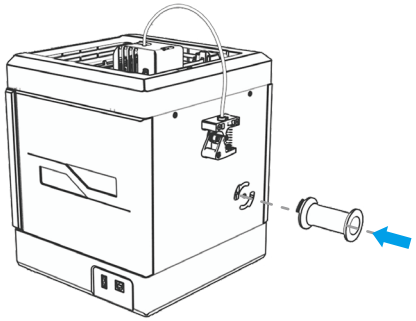
6. Clean Shovel



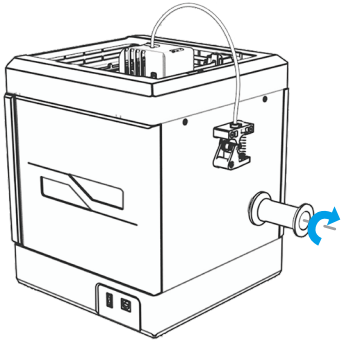
7. Allen Key

8. Cutting Plier

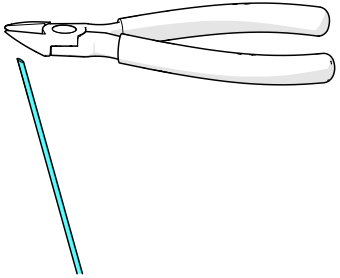
## • Hardware Assembly



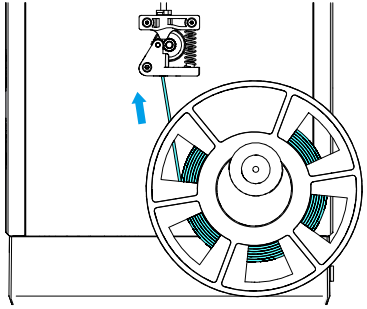
1 Install the spool holder into the printer as the picture.



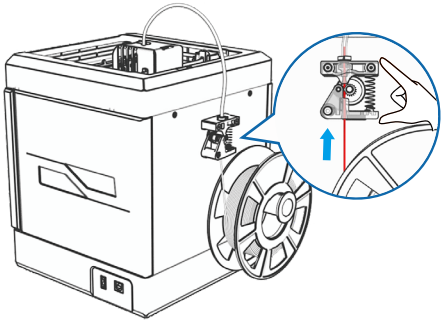
2 Fix the spool holder by rotating clockwise.



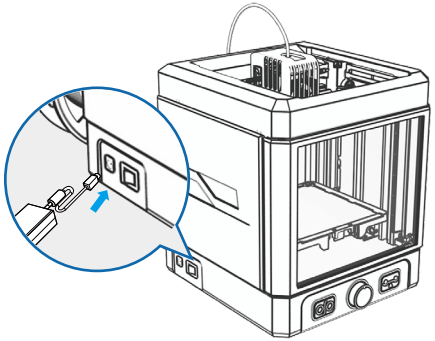
3 Sharpen the end of the filament by the cutting nippers



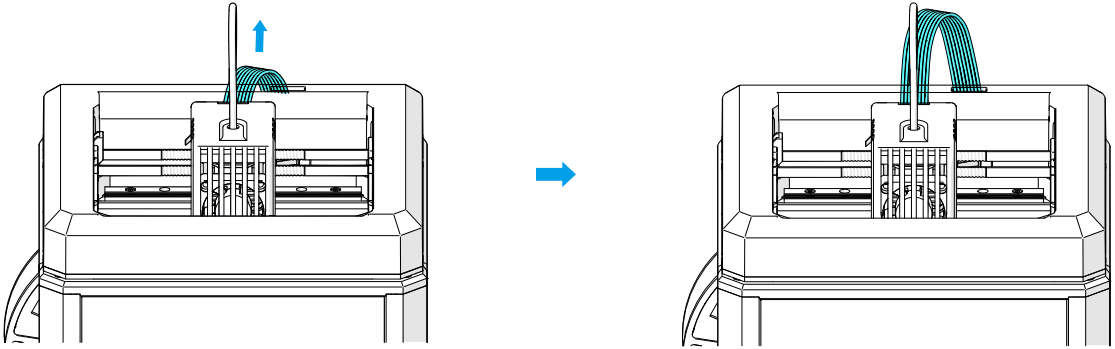
4 Place the filament roll as photo



5 Put the filament on the spool holder, and load one end of the filament from the hole at the bottom of the extruder until it extends into the white material tube.



6 Connect the power adaptor and start the power.



7 Make sure the flat cables are upward before printing gets started.

## U-Disk Data

* Please backup the data on the U disk to your computer.

- 3D Models
- Test print.gcode
- WAND User_Manual_EN.jpg
- WAND使用说明书-CN.jpg
- WAND User_Manual_EN.pdf
- WAND使用说明书-CN.pdf
- Mixware Slicer win64 Setup.exe
- vcredist_x64.exe

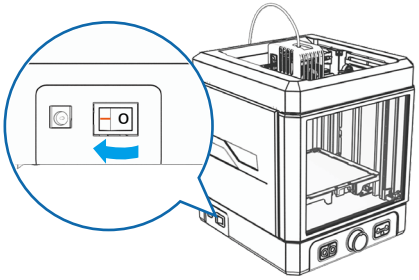
**3D model folder containing 10 selected models:**

| | |
|---|---|
| walrus.png | --- Print product pictures |
| walrus.stl | --- Model file-.STL (Type of file read by the Mixware Slicer) |
| Wand_walrus_fast_3h52m_31g.gcode | --- Gcode file (The Wand reads files |
| Wand_walrus_slow_7h19m_30g.gcode | that can be printed directly on a USB drive) |

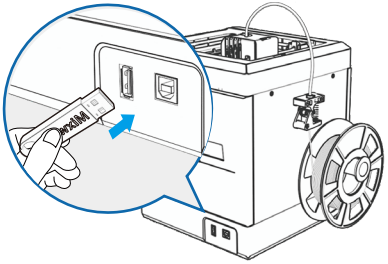
1. After backup the contents of USB flash drive to computer, copy the 'Test Print. Gcode' (Test model) to USB drive;
2. Just keep 'Test print.gcode' on the drive;
3. We'll use the Wand to print 'Test print.gcode'.

## Prepare for Printing

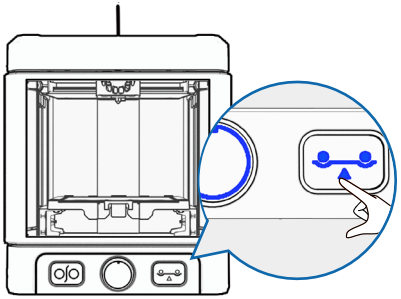
* All of the following must be done when the printing platform is installed correctly.



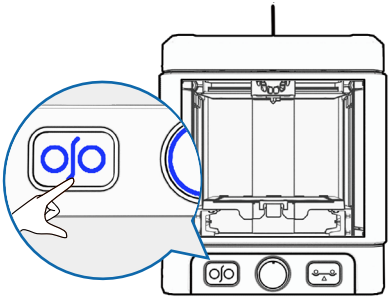
1. Press the power switch on the left side of the Wand and wait for the lights to twinkle one time.
   After twinkle one time, you can start the printing journey.



2. Insert the USB Flash Disk and make sure the red light on the front print knob goes out and the side panel lights up.



3 Press the Auto-leveling button and the bule light comes on. Then press the middle knob and wait for leveling to be completed. About 2 minutes 30 seconds.

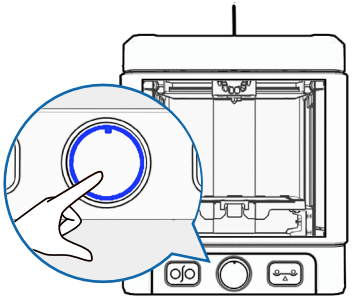


4 Press the load/unload filament button and the blue light comes on. Then press the middle knob and wait for the feed to be completed. About 3 minutes 40 seconds.
In the presence of consumables, there is no need to re-feed.

* The Nozzle is heating when the Wand does leveling, load/unload filament, and printing.
Please do not touch it with your hands to avoid burns.

## • Start Printing

* Please pay attention to clean the foreign body on the platform before printing.

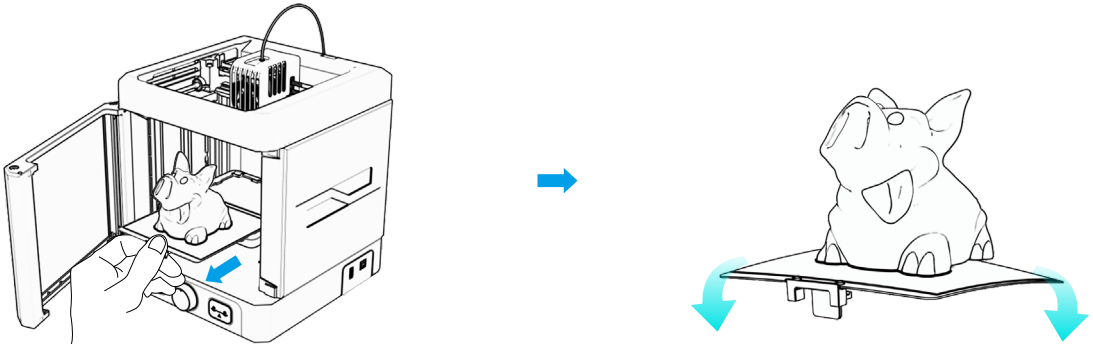


1 Press the Print knob for two seconds to start printing.
It is recommended to observe whether the first layer prints properly.

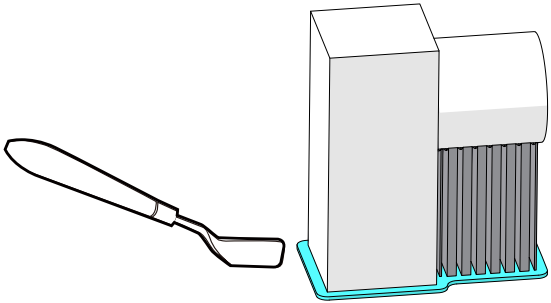
2 The 'Test Print' model on a USB disk took about 25 minutes to print.

3 In the printing process, double click the Print knob to pause the printing;
Double-click the Print knob after suspension to resume printing;
Long press the Print knob for more than 2 seconds, you can stop printing.

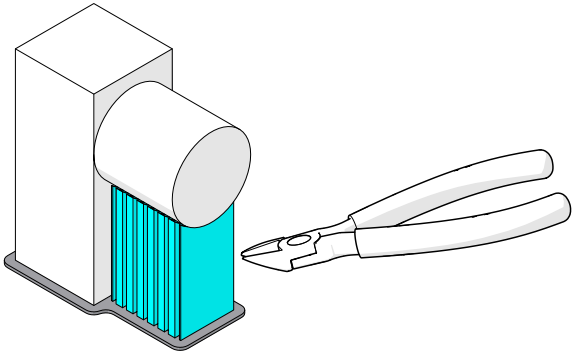
## • After Printing



1. After printing is finished, the printing platform can be pulled out to easily take down the model.



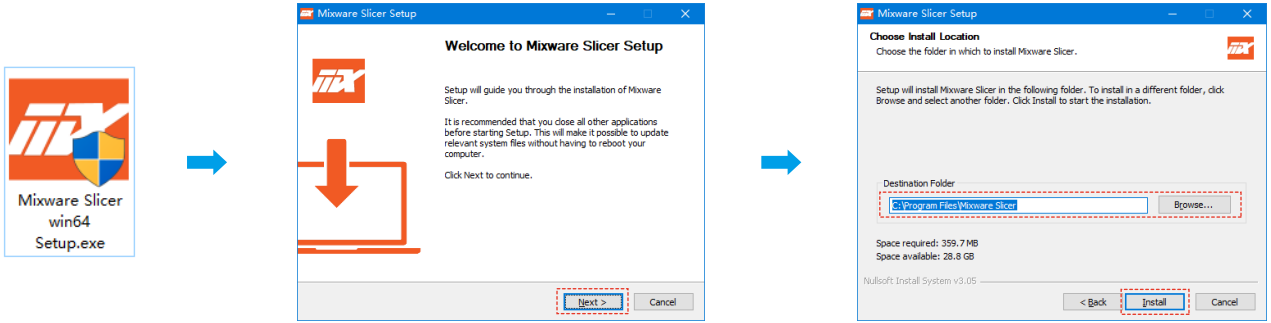
2. Use the scoop to remove the finished model from the bottom



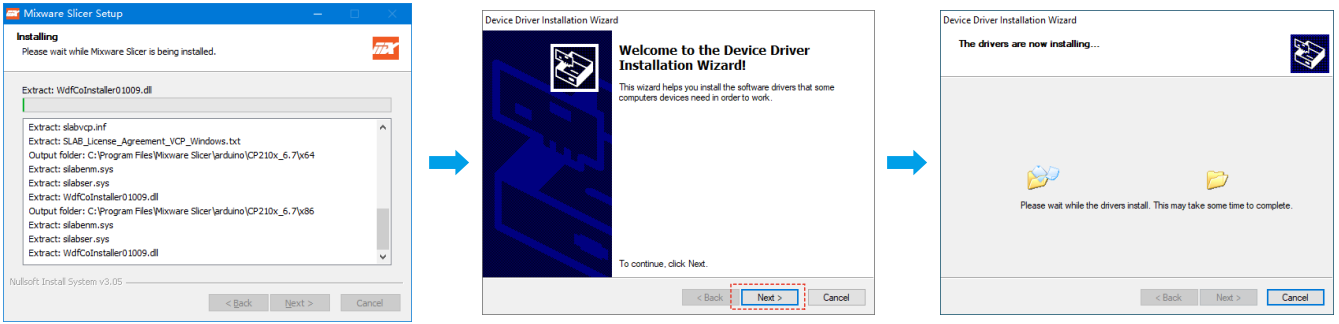
3. Remove the supports of the model by the cutting nippers.

# Daily Usage

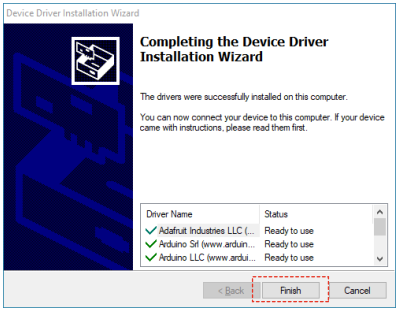
## • Software Installation

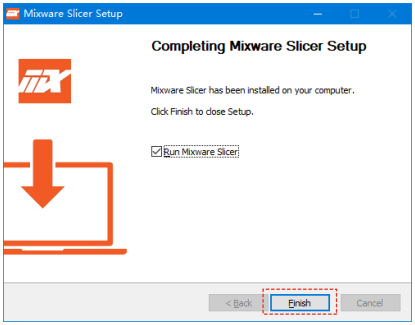



❶ Double-click to open the “Mixware Slicer win64 Setup.exe” file, follow the prompts to set the installation path, and click "Install" to continue.



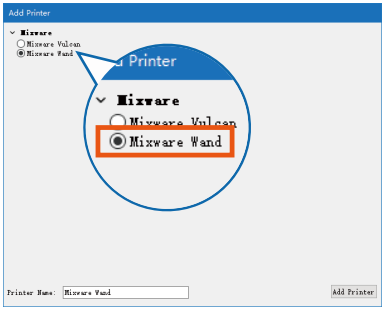

❷ Follow the prompts to install the device driver and click "Next" to continue.

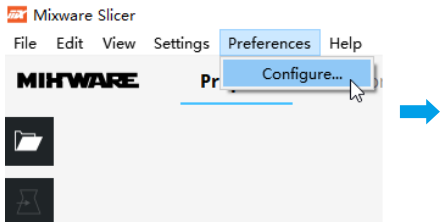


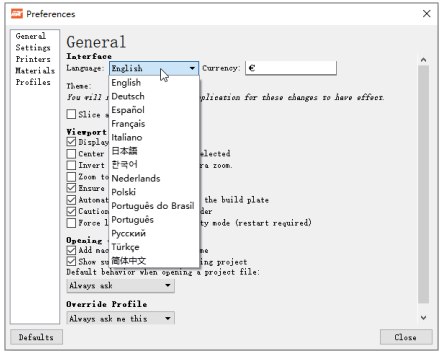




3 Click“Finish”, and Mixware Slicer is installed successfully.

* When the installation fails or the interface does not display properly after installation, please check the system configuration of the computer.
System requirements: Win7 +.
Graphics card requirements: support OpenGL2.0 or above.



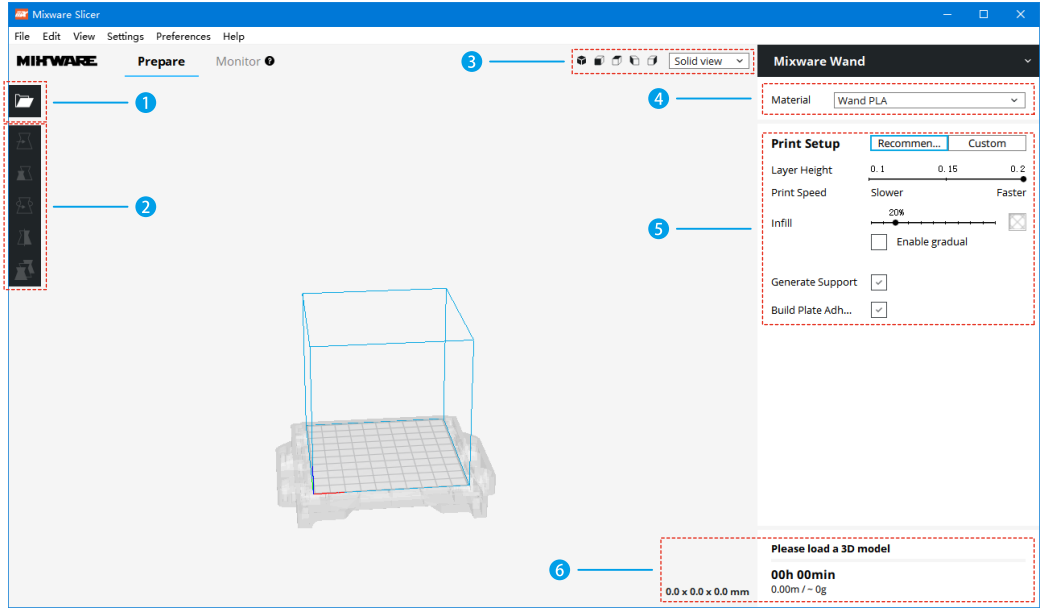




* Be careful not to choose the wrong model.

4 When Mixware Slicer is first opened, the user need to select the model of 3D printer. Tick “Mixware Wand” and click “Add Printer” to start using.

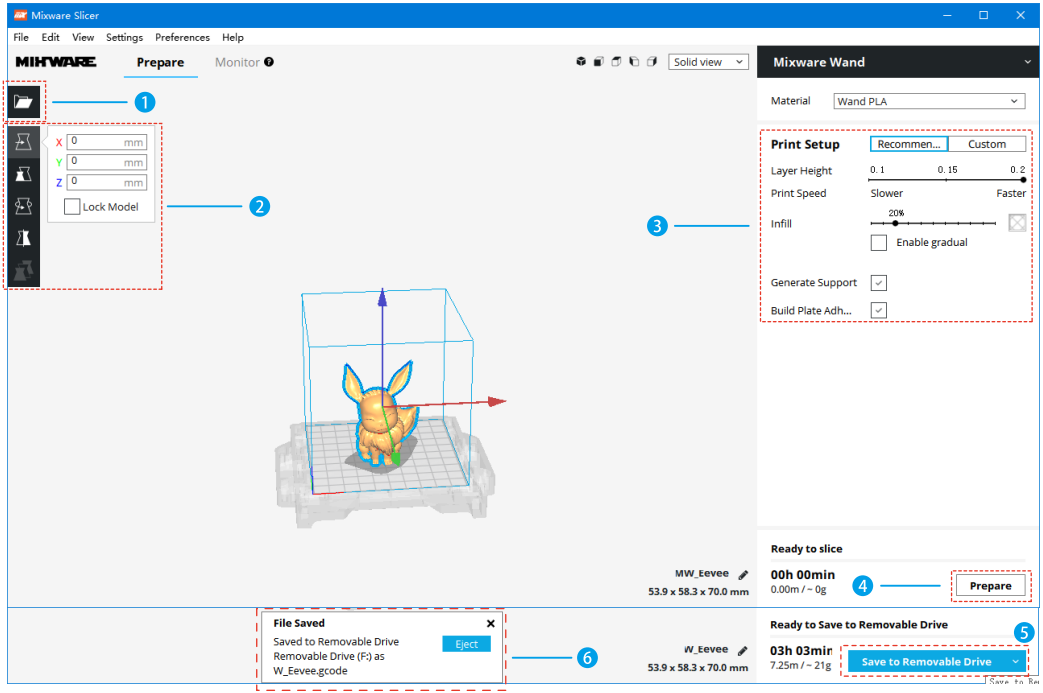
5 The default language is English, press “Preferences->Configure...” On the interface of “Preferences”, choosing the appropriate language. Then re-star the software to change the language you need.

## Interface Description




1. Load the model
2. Adjusting tool
3. View display
4. Print material type Settings
5. Print related Settings
6. Slice information

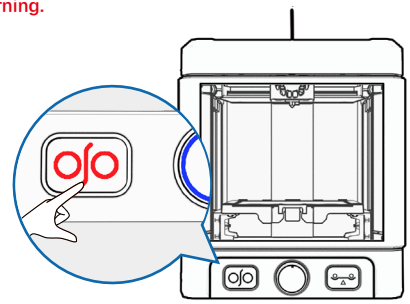
## Model Slice




1. Load your favorite model into Mixware Slicer.
2. Select the loaded model, and use the adjustment tool to position, scale, rotate, and mirror the model.
3. Adjust the print parameters appropriately.
4. Click "Prepare" to generate the slice file. When the slice is finished, the "Prepare" button will be changed to "Save to File"/" Save to Removable Drive".
5. Click "Save to Removable Drive". After successfully saving to U-Disk, the software will prompt the completion of saving and provide U disk exit button.
6. Click "Eject" to pull out the U-Disk and prepare to print.

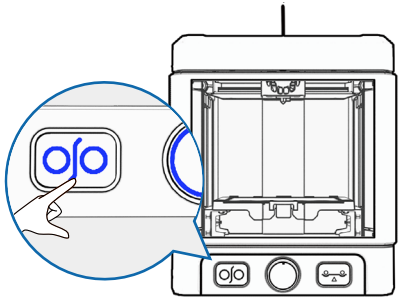
## Replace Filament

* When exchanging the filament, the printing head is heating.
  Do not touch the printing head to avoid burning.



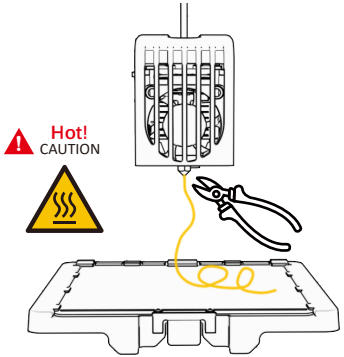
1. Double click the load/unload filament button and the red light comes on.
   Then press the middle knob and wait for the unload filament to be completed.
   About 1 minute 30 seconds.

* Reminder: Please confirm the filament is inserted before printing.
  Do not repeat inserting filament

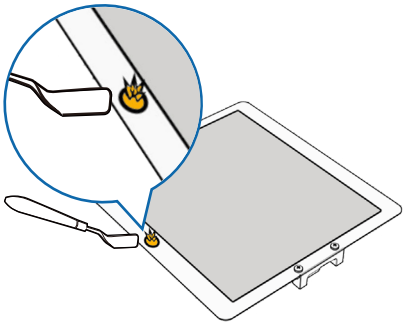


2. Press the load/unload filament button and the bule light comes on.
   Then press the middle knob and wait for the feed to be completed.
   About 3 minutes 40 seconds.

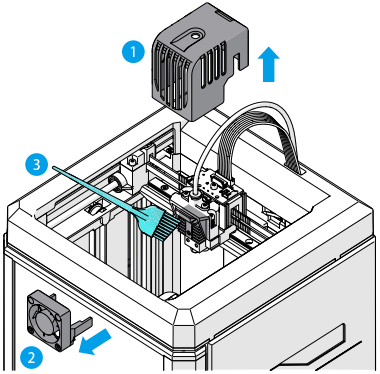
## Clean and Maintenance




1. After the filament exits, please wait patiently for a few minutes to let the temperature of the print head lower, and ensure your safety to avoid burns.



2. Before each printing, please remove the residue on the platform to ensure that the platform is flat.
3. After each printing is finished, please clean the residue of the frosted layer on the printing platform in time.




4. Printing head cleaning: Confirm it's powered off, and pull up the cover of the printing head. Pull out the fan and clean it with the small brush

Keep it clean at all times, Wand will work better!

## Other

- **3D Printing Flow Chart：**

- **Recommended Model download website**

  Thingiverse：www.thingiverse.com

- **"One click print" function：**

  ① Long press the print knob: start printing.

  ② Double-click the print knob during printing: pause printing and resume printing.

  ③ Long press the print knob during printing: stop printing.

  The printer only read the slice file with the Gcode extension on the SD card and only recognizes the file with the most current time attribute.

## Indicator lights description

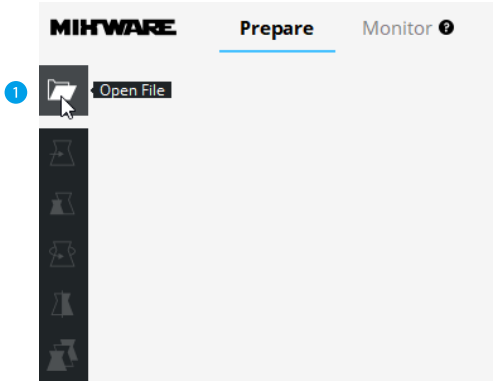
| | | | |
|---|---|---|---|
| | Twinkle：the Nozzle is heating up / load filament<br>ON ：the Nozzle is heating finish | | Twinkle：the Nozzle is heating up / unload filament<br>ON ：the temperature of Nozzle is in an abnormal state |
| | Twinkle：the model is printing<br>ON ：the function of load/unload filament and auto-leveling is waiting for confirmation | | ON ：USB Flash Disk is in an abnormal state |
| | Twinkle：Automatic leveling is in progress | | ON ：Limit switch is in an abnormal state |

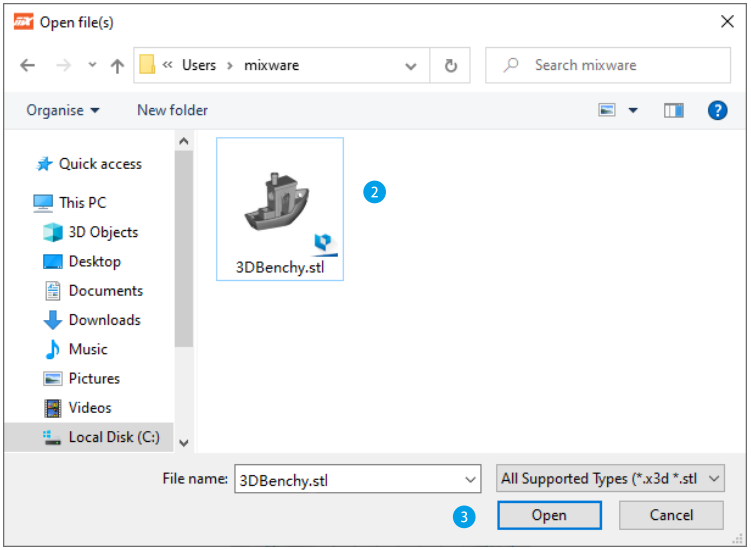
* When the sidelight panel is off and the red light of any button/knob is on, it means the machine is out of order. Please refer to the description of the indicator status for details.

* When the sidelight panel goes off and all three buttons turn red, it indicates that the machine has experienced a power failure and is locked. Press the 'load/unload filament' button and the 'auto leveling' button for more than 2 seconds to unlock. Please clean the foreign body on the platform before unlocking.

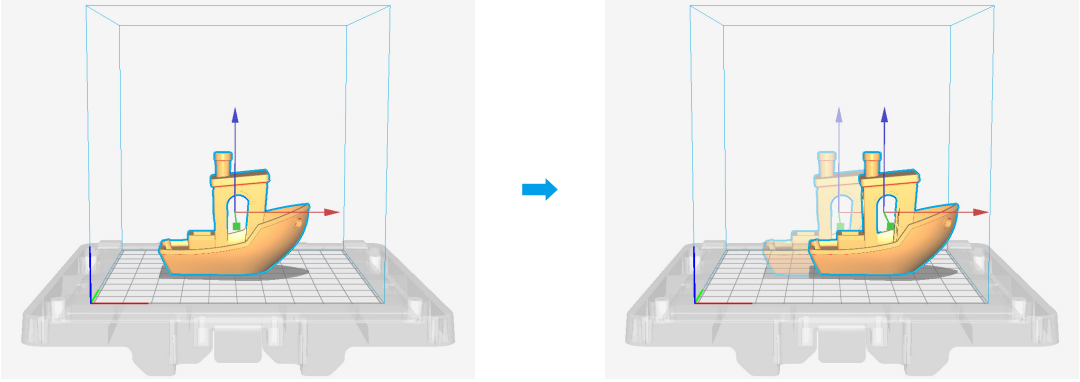
## Stage Of Software

- Model Management

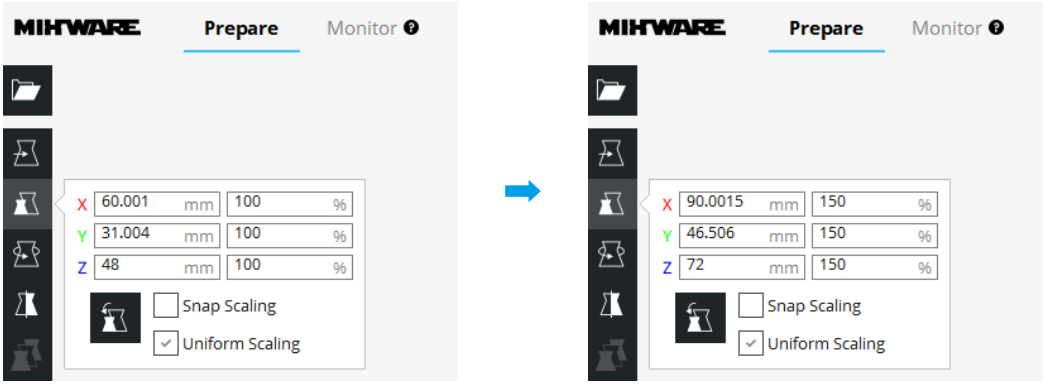


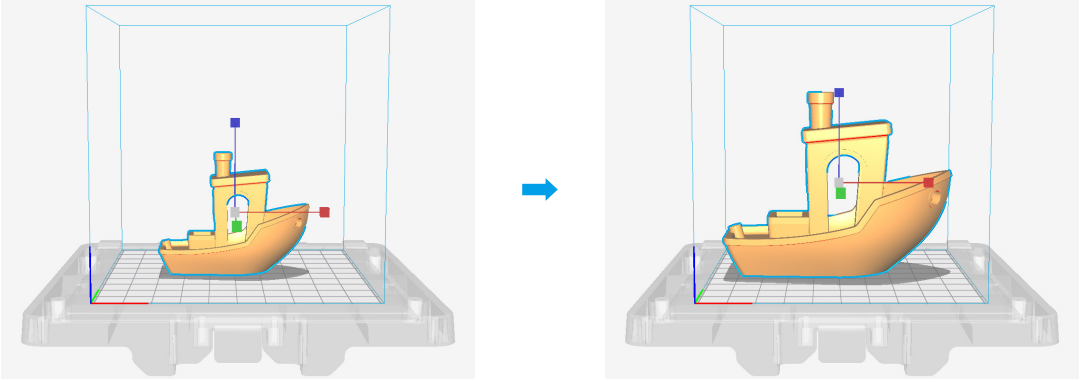




1 Click “Open file” and select the model you like, then click open to load it.

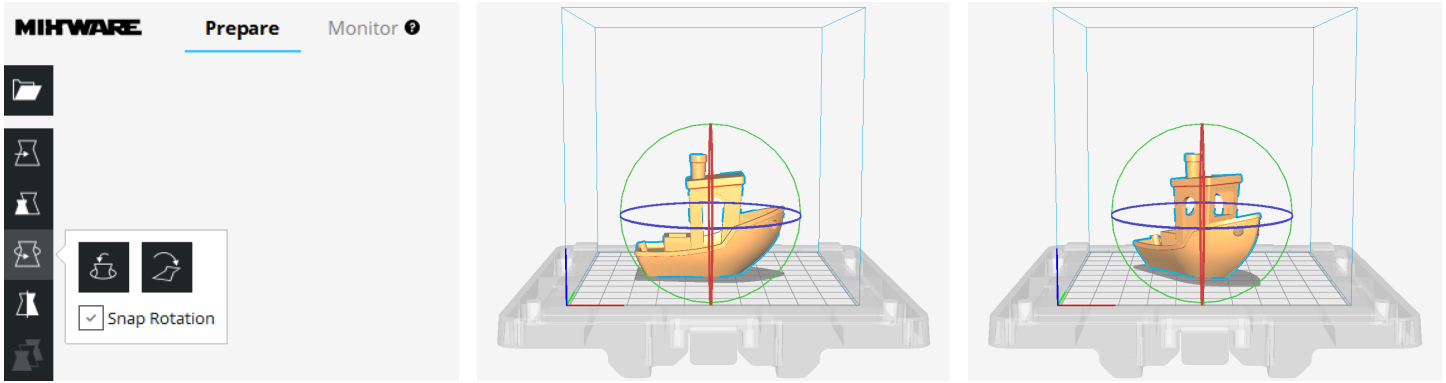


2 Select the model and use the “move”tool to adjust the placement of printing or place the model to the specified placement.

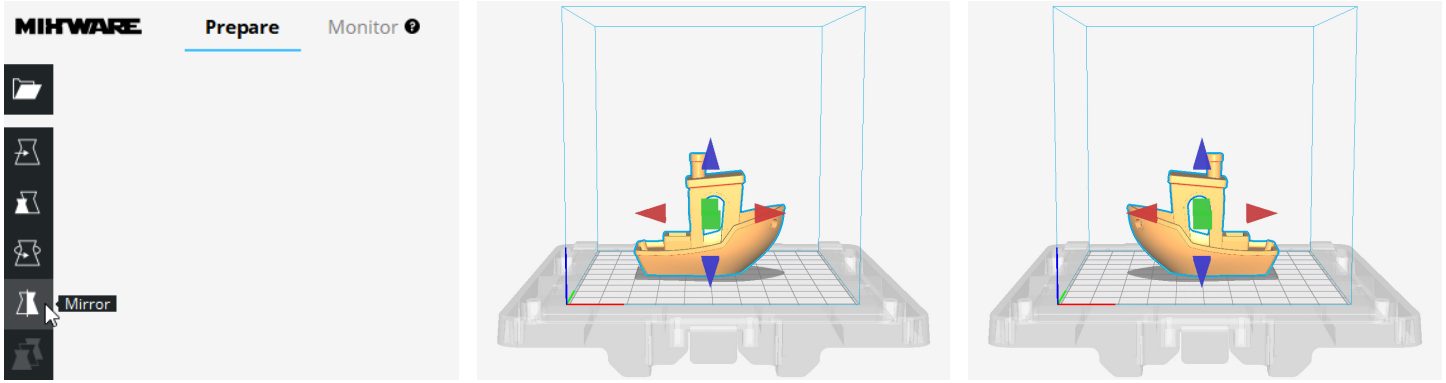


3 Select the model and click “Zoom” to input the needed model size or zoom it to the suitable size.

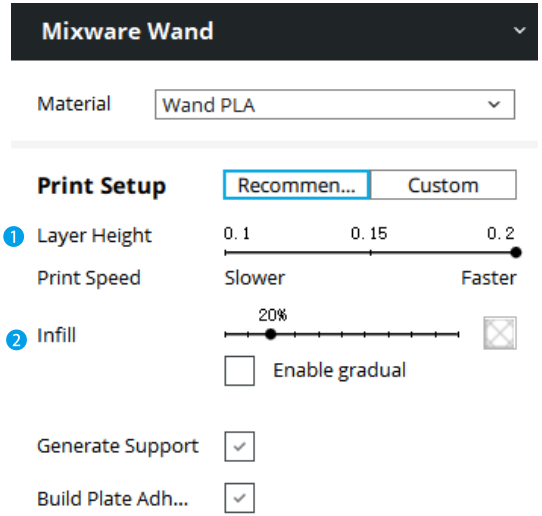


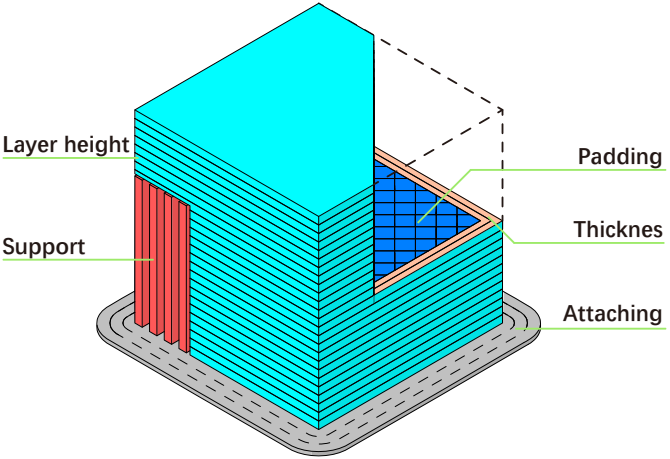

4 Select the model and click “Rotate”to rotate the model.



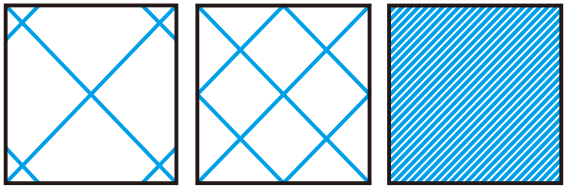

5 Select the model and click “Mirror”to mirror the model by clicking the model periphery button.

## Recommended Parameter

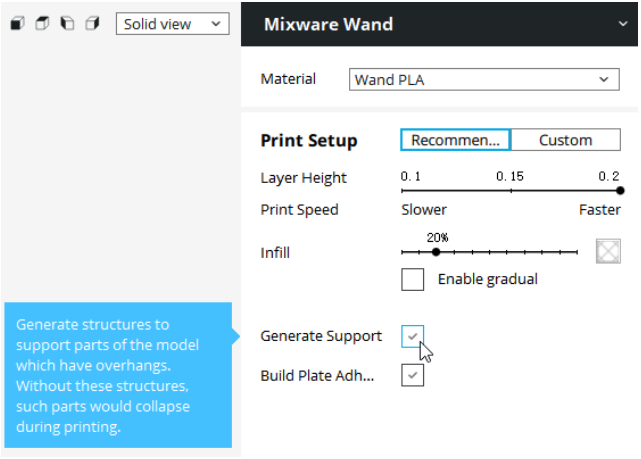


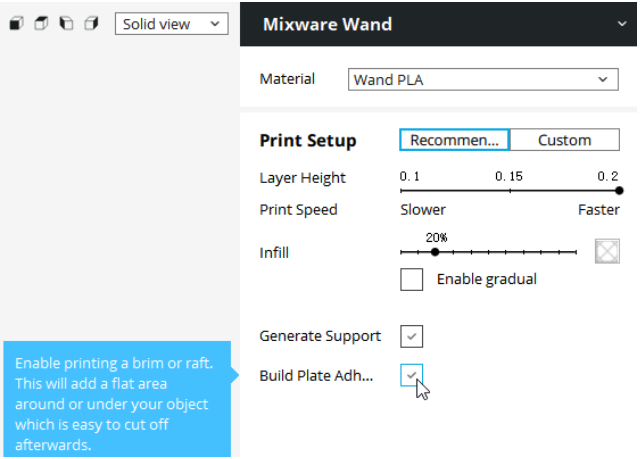
1 Layer height 0.1 0.15 0.2



2 Padding 20% 50% 100%

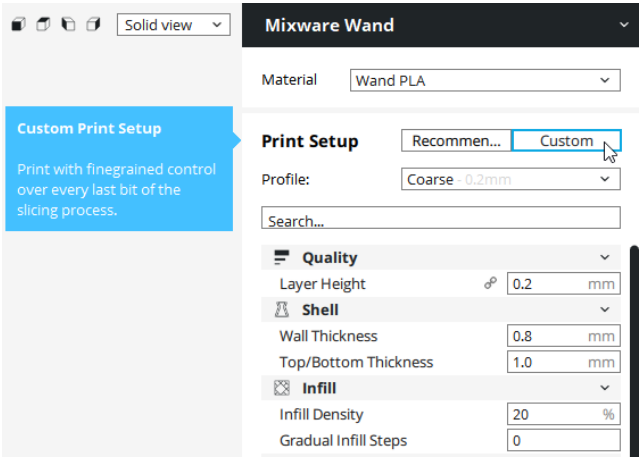


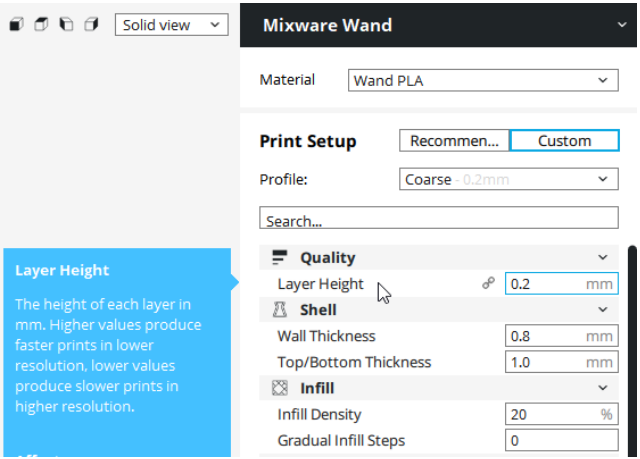

3 Click “Generate Support” to prevent the vacant of the model and avoid falling when printing.




4 Click ”Build Plate Adhesion” to strengthen the attachment of the platform and guarantee printing successfully.

## Customized Parameter

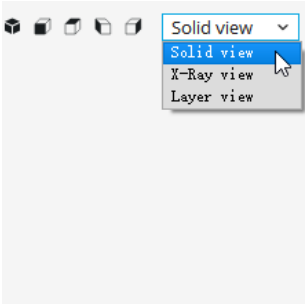


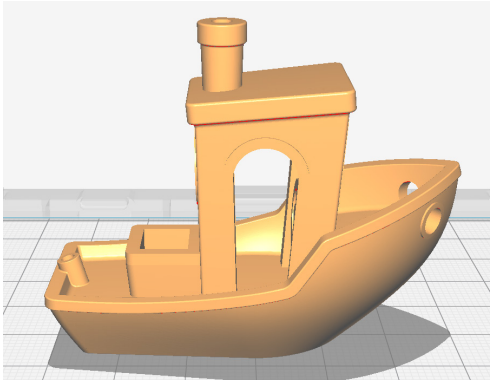




1. If more demands of every slice process, please switch to the Custom setting

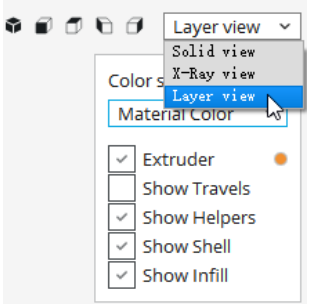
2. In the Custom setting, the professional parameter description can be known by hovering on each blank

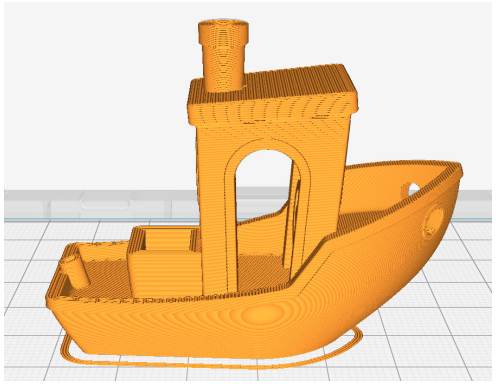
## Slice Preview



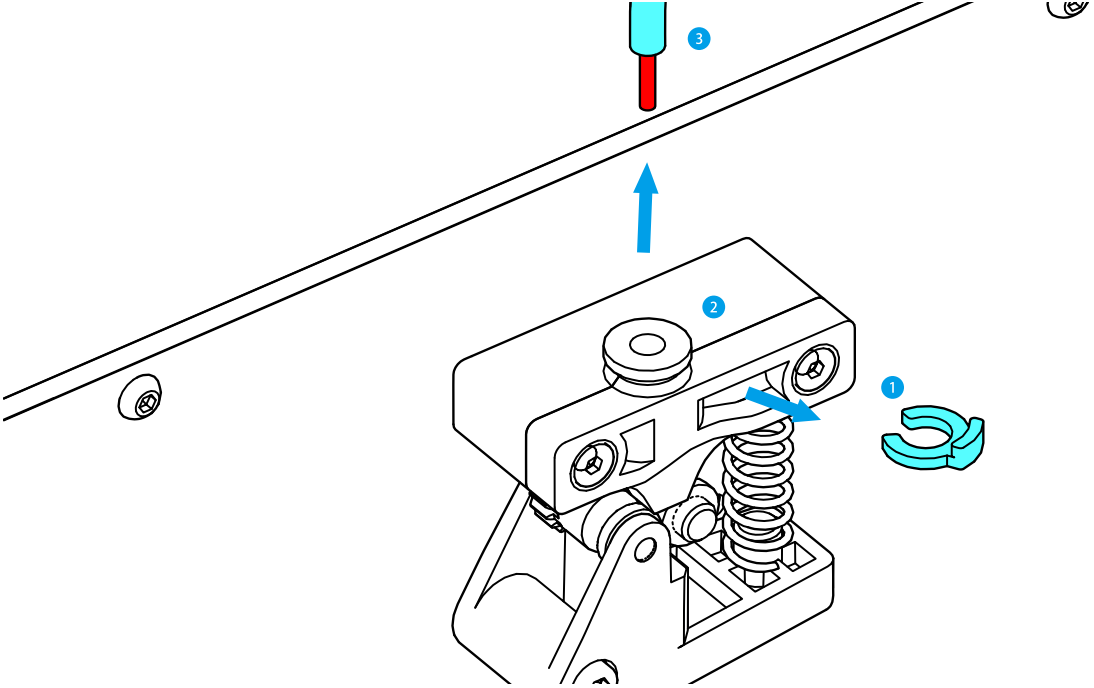



1. Click the visual mode button on the upright corner, it can preview the model in different visuals. The default preview is the actual model



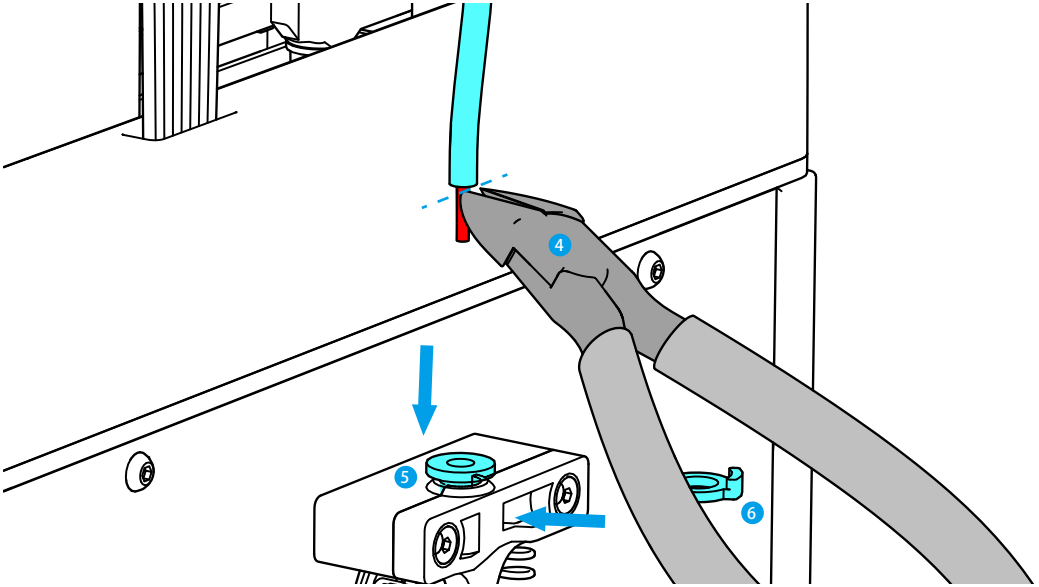



2. The layered view: Preview the printing track of the slice, and check whether the slice is correct or not.

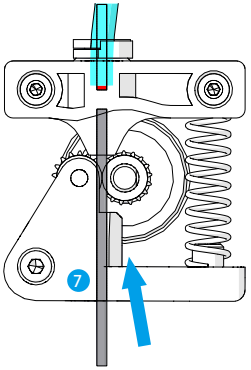



- Q1: How to deal with the crack of filament and the abnormal of extruding?

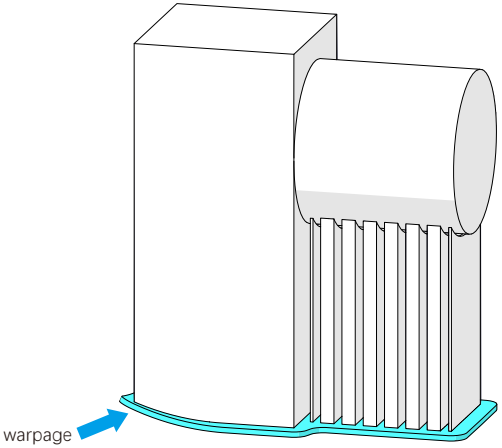
- A1: 1. Pull out the U-plastic ring(①).
  2. Press the black plastic extruder button(②).
  3. Pull out the filament tube(③).

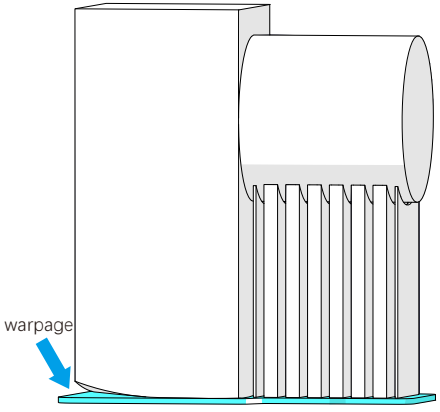



- A1: 4. Take out the cracked filament or shape it flat.
  5. Re-load the new filament.
  6. Insert the black clasp⑥ back.
  7. Put new filament⑦ into the extruder.
  8. Use the load filament function.

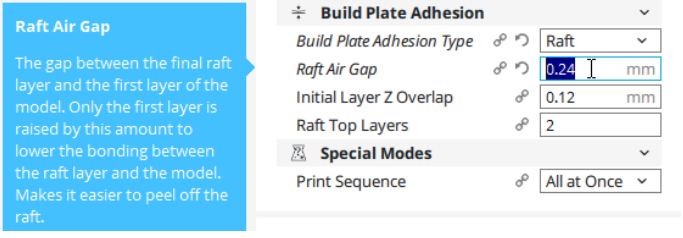


- Q2: What if the model is warping?
- A2: Use the auto-leveling function.

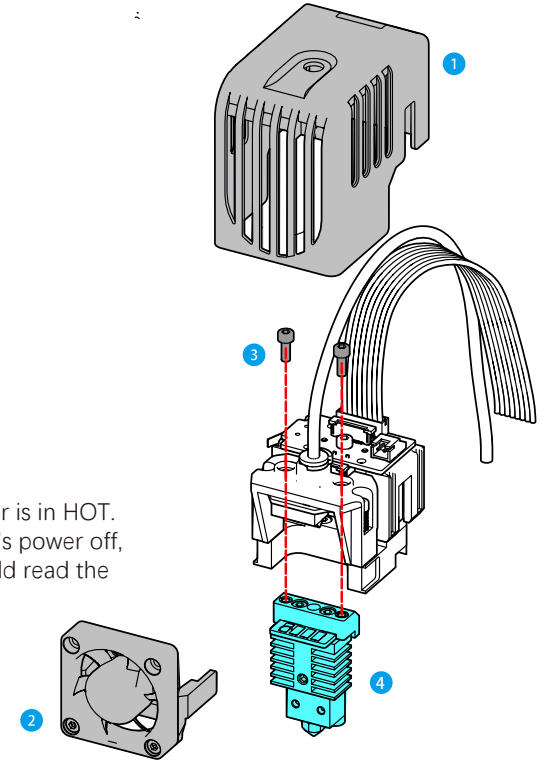



- Q3: What if the model does not adhere to the platform?
- A3: Adjust the “Raft Air Gap” of the “Build Plate Adhesion” in the slicing software.
  Proposed “Raft Air Gap”：0.22 or 0.24.

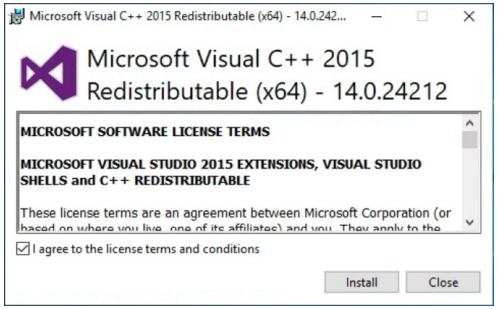


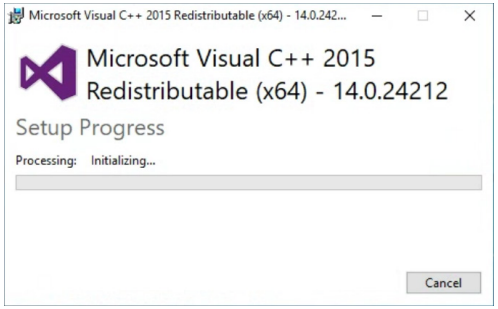
- **Q4: How to deal with the jam of the printing head?**
- **A4: 1. Pull up the printing head cover(①).**
  **2. Pull out the cooling fan(②).**
  **3. Loose the screws(③) of the printing head.**
  **4. Clean or change the printing head(④).**

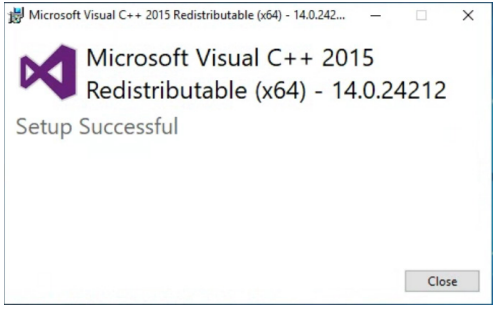



For your safety, do not touch the printing head when it's working or is in HOT. When cleaning or changing the printing head, please do confirm it's power off, the printing head is cool down. If an error occurred, the adult should read the guidebook and guide their children.

- Q5: What if the windows prompt “xxx.dll was not found” after turning on Mixware Slicer?
- A5: Double-click the ‘vcredist_x64.exe’ of the USB drive (Library file missing fix program vcredist_x64.exe )
  Follow the guide to install it on your computer.



## Disclaimer

This user manual is just for installation, operation, and maintenance instruction, not the product warranty.
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