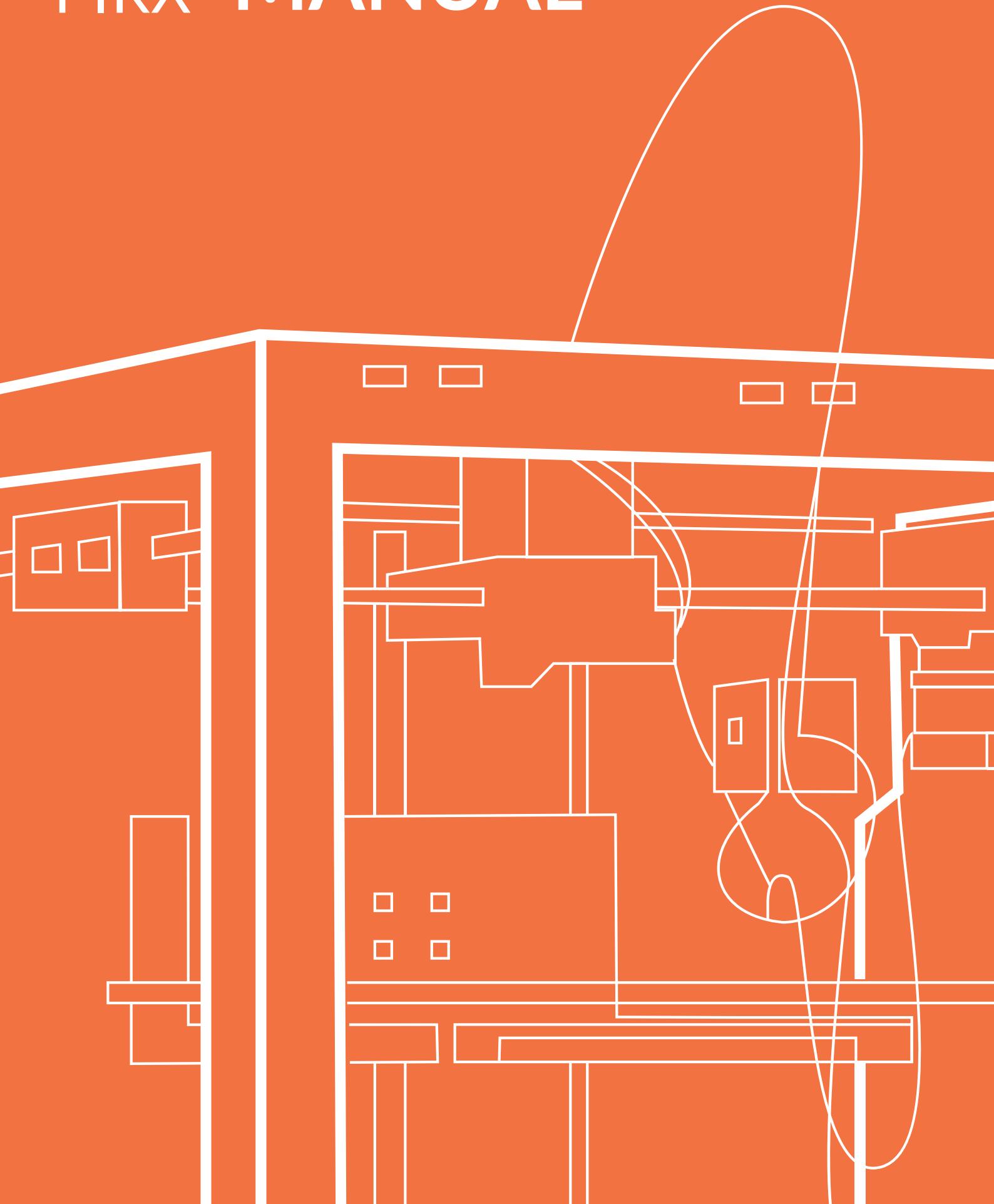




PIRX INSTRUCTION MANUAL

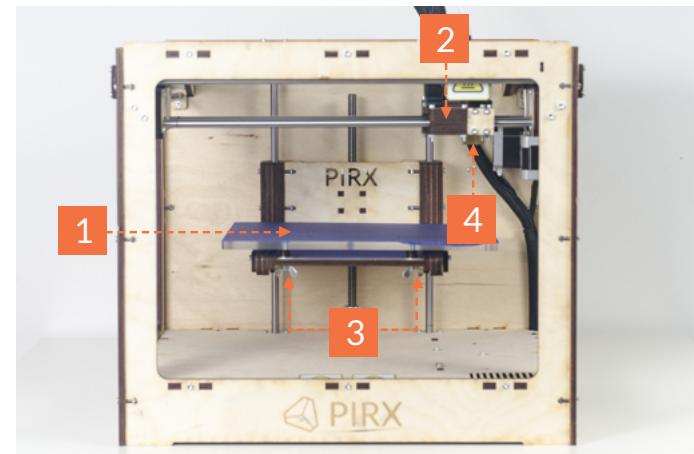


CONTENTS

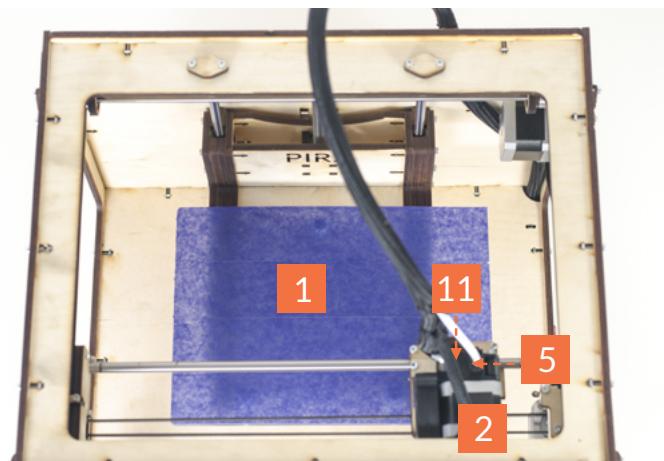
ELEMENTS OF THE PRINTER	3
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ELEMENTS OF THE PRINTER

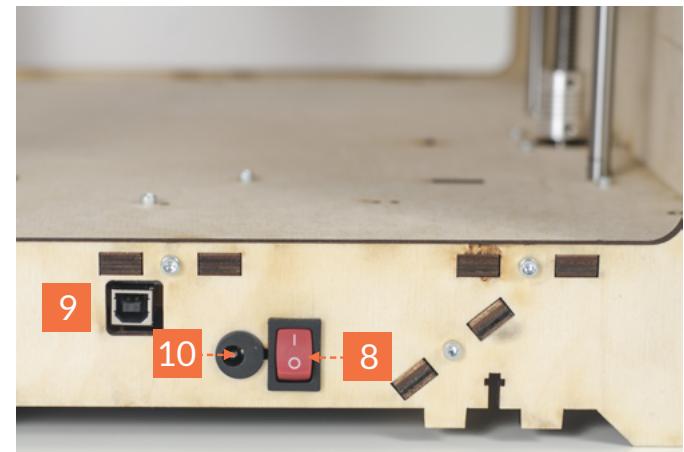
- 1** Bed
- 2** Extruder
- 3** Wing-nuts with screws
- 4** Hotend



- 1** Bed
- 2** Extruder
- 5** Slot for filament
- 11** The end-piece of the teflon tubule in a free slot on the extruder



- 8** Power key
- 9** USB cable
- 10** Socket



- 6** Teflon tubule
- 7** Spool holder



Lorem ipsum dolor sit amet, consectetur

I HAVE JUST TAKEN PIRX OUT OF THE BOX

PREPARE THE PRINTER TO WORK:

1. Place the device on an even surface.
2. Cut through all the zips securing
the extruder during transport (2).
3. Push the teflon tubule into the slot
at the back of the printer.



SOFTWARE

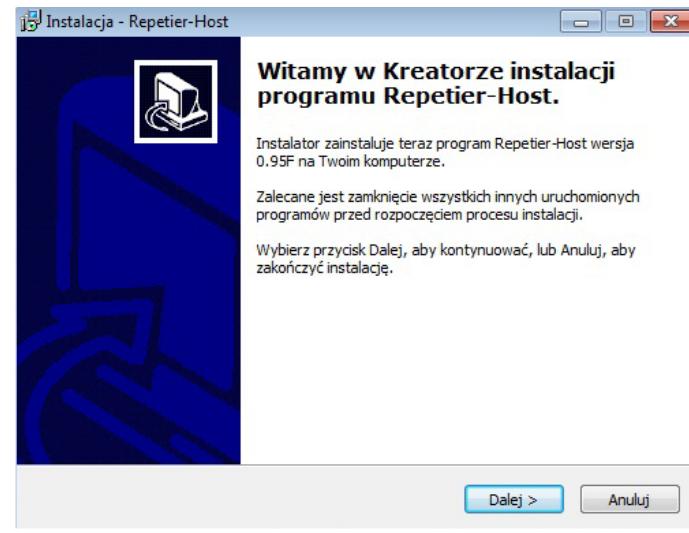
THE PRINTER NEEDS THREE PROGRAMMES TO WORK PROPERLY:

1. Drivers.
2. Repetier-Host software to control
the device.
3. Kiss Slicer for 3D models processing.



INSTAL DRIVERS - ONLY FOR WINDOWS' USERS

1. Download drivers from this website
http://pjrc.com/teensy/serial_install.exe.
2. Launch the downloaded installation programme and reboot the computer after the installation is completed.
3. If you have an operating system other than Windows skip the steps listed on this page.



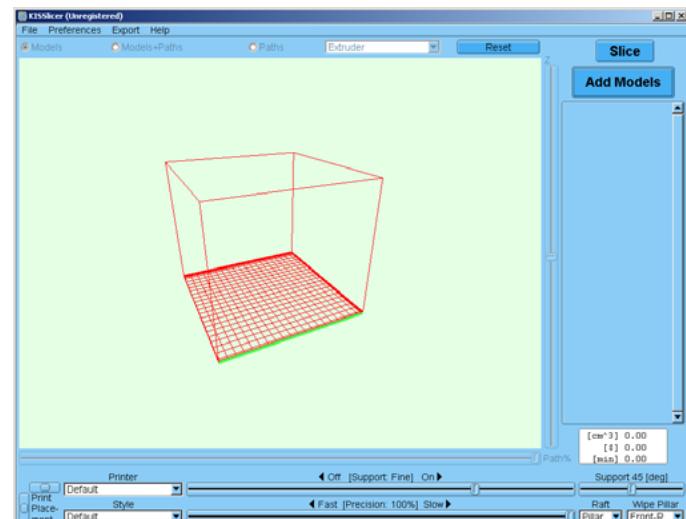
INSTALL REPETIER-HOST

1. Go to www.repetier.com/download and download a version of the programme that will be compatible with your operating system.
 The Windows version requires installation of additional software:
www.microsoft.com/en-us/download/details.aspx?id=30653
2. Run the downloaded installation programme.



INSTALL KISSLICER

1. Download and unpack KISSlicer from the slicer.rar file, that we have attached to the mail including the instruction manual.



USING THE PRINTER - STEP BY STEP

THE PRINTER NEEDS THREE PROGRAMMES TO WORK PROPERLY:

1. Follow the instructions concerning “Connecting the printer” on page 7.
2. Follow the instructions concerning “Preparing a model for printing” on page 7.
3. Follow the instructions concerning “Printing” on page 9.

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CONNECTING THE PRINTER

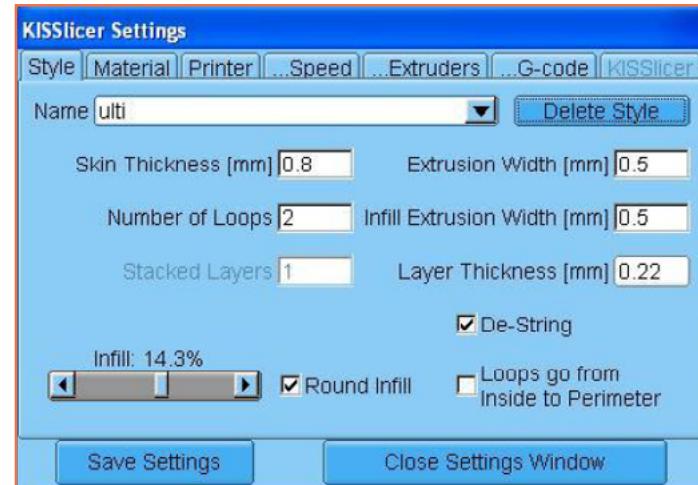
1. Plug the attached power adapter to the mains.
2. Plug the power adapter to the printer's socket ([10](#)).
3. Switch on the printer ([8](#)).
4. Connect the printer to the computer using the USB cable ([9](#)).

PREPARING A MODEL FOR PRINT - KISSLICER

1. Double-click the kiss.exe icon to run KISSlicer.
A window resembling the one from the previous page should pop up.
2. Click Open Models to select the .stl file you want to print.
3. Click the Slice button and wait until a .gcode file is generated.
4. Save it - this file is ready for printing.



PREPARING A MODEL FOR PRINT - MANAGING KISSLICER



1. In the KISSlicer programme, open the tab with Preferences -> Advanced Settings

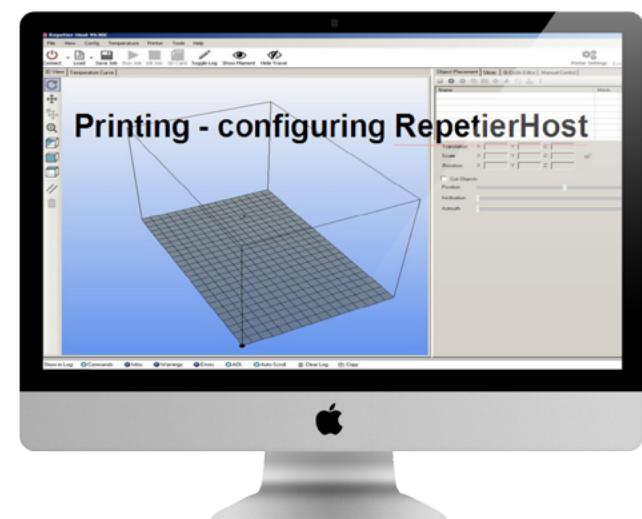
PREPARING A MODEL FOR PRINT - MANAGING KISSLICER

1. The Infill parameter determines the density of the model's infill, and therefore also its weight and durability. Increasing this parameter will significantly extend the printing time.
2. The Layer Thickness parameter determines the layers thickness, and therefore also the quality of the printout. You can choose between 0.1 and 0.3 mm layer thickness. The smaller the value, the longer it takes to print the model.

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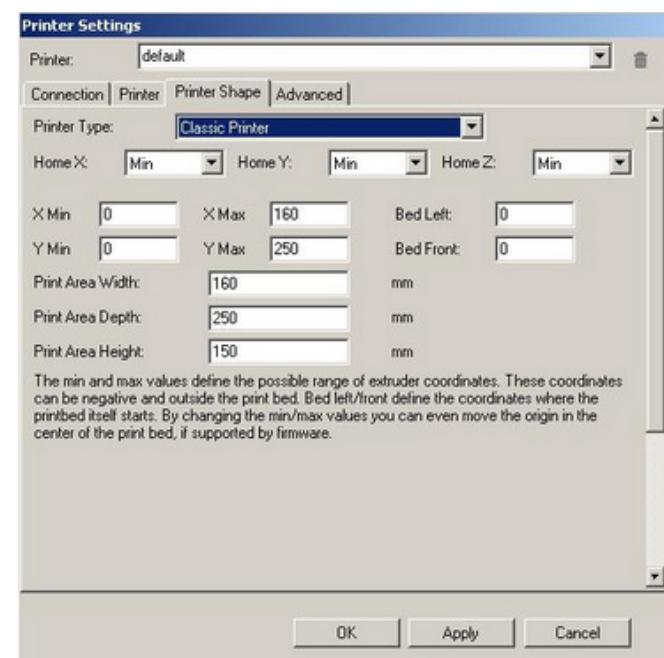
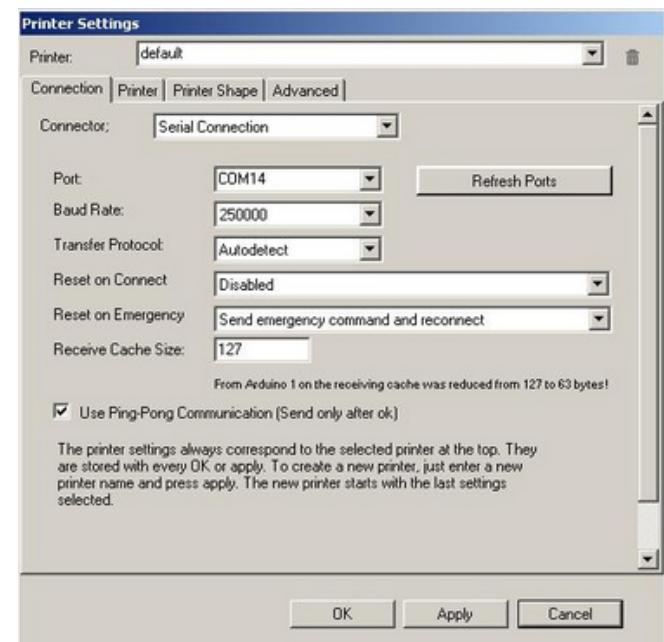
PRINTING

1. Configure RepetierHost following the instructions (image)
2. Prepare the printer for printing following the instructions on page 11.
3. Run the printing process following the instructions on page 13.
4. Voila! Wait until the devices completes its work and enjoy the object you created.



PRINTING - CONFIGURING REPETIERHOST

1. Open the printer's settings - click the icon in the right upper corner of the window.
2. Set the options in tabs Connections and Printer Shape according to values provided on the photograph on the next page. This does not concern the Port option which should be set so as to indicate the printer's port (usually it's the last port on the list, e.g. COM4 or COM6, see page 10)
3. Click the Apply button and then the Ok button.

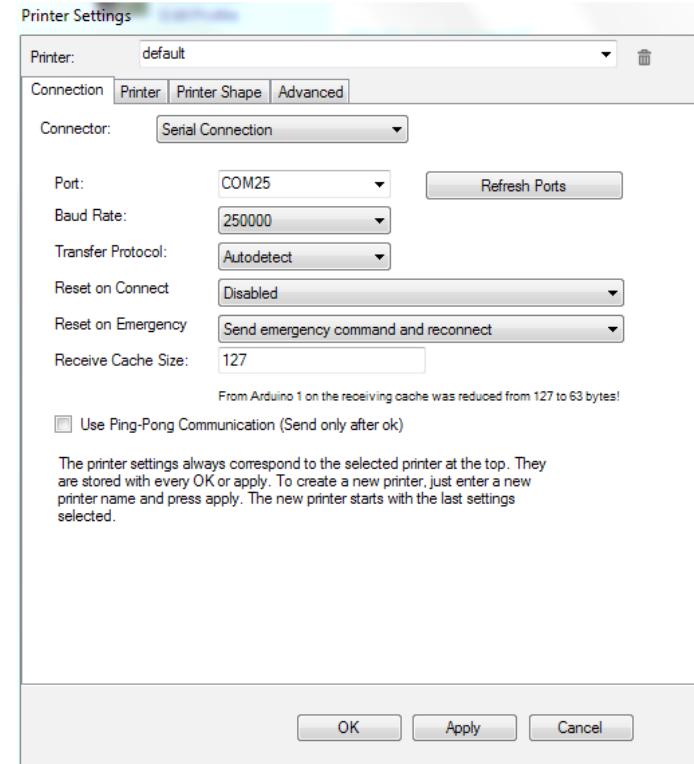


PRINTING - CONFIGURING REPETIERHOST - THE PRINTER'S PORT

In order to establish which port belongs to the printer:

- unplug the USB cable from the computer (9),
- look through the list of ports on the previous page,
- plug the USB cable to the computer (9),
- check if a new port occurs.

This new port that occurs upon connecting the printer is the printer's port. Select it.

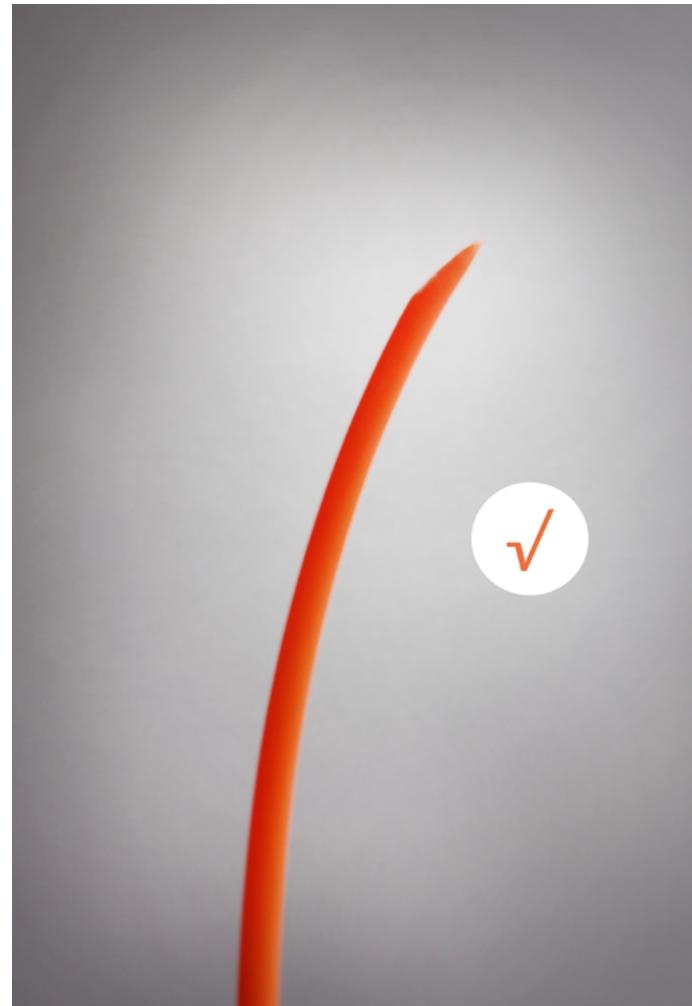


PRINTING, PREPARING THE PRINTER FOR PRINTING - FILAMENT

1. Prepare filament as shown in the picture.

Double-check whether it is properly cut and not crooked.

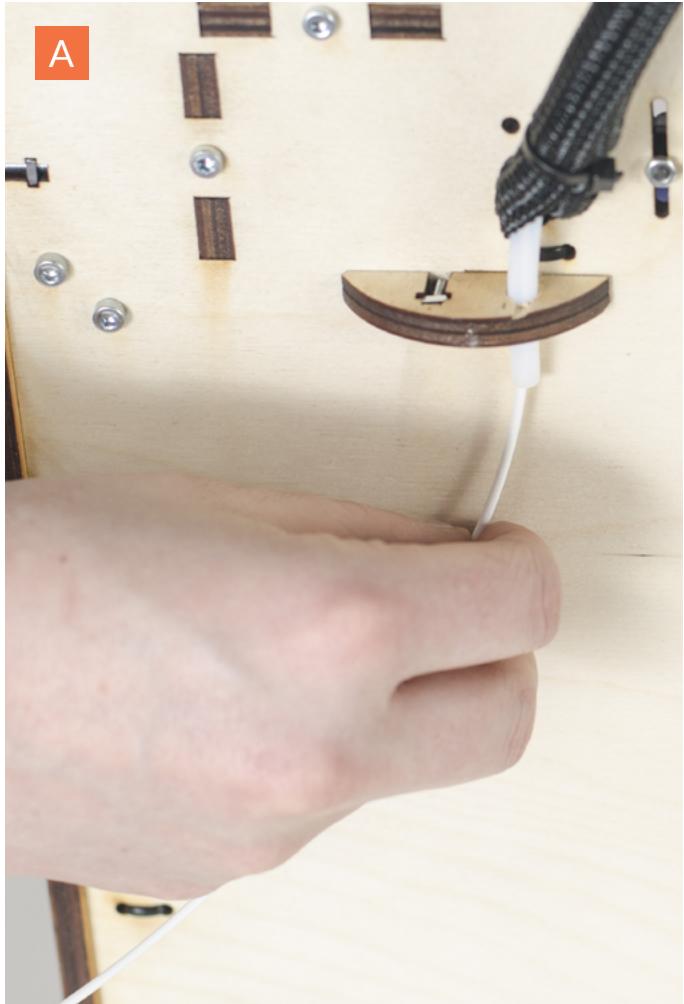
The printer can source filament in two different ways: from a spool placed on the spool holder attached at the back of the device or directly, e.g. if the coil of filament lies on a table next to the printer.



PRINTING, PREPARING THE PRINTER FOR PRINTING - INSERTING FILAMENT

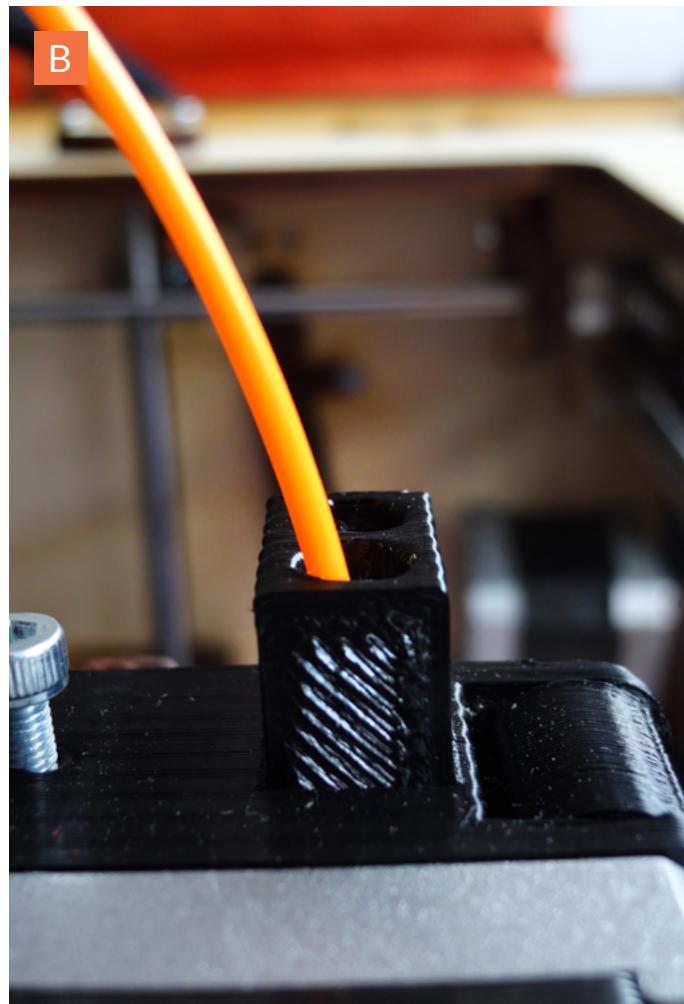
A) DIRECTLY

1. Put the filament into the extruder following the instructions on page 16 (picture beside)



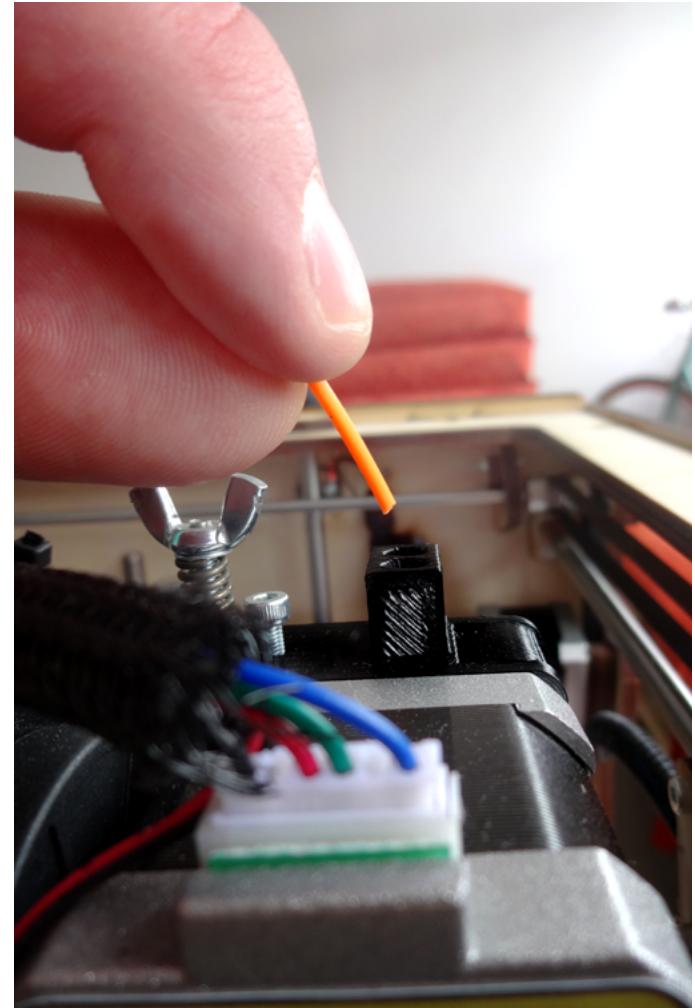
B) FROM A SPOOL VIA A TEFLON TUBULE

1. Take the teflon tubule out from the extruder (from the free slot (11)).
2. Pass filament through the teflon tubule (6) (see next picture)
3. Insert filament into the extruder following the instructions on page 13.
4. Push the teflon tubule into the slot for filament (5).



PRINTING, PREPARING THE PRINTER FOR PRINTING - INSERTING FILAMENT

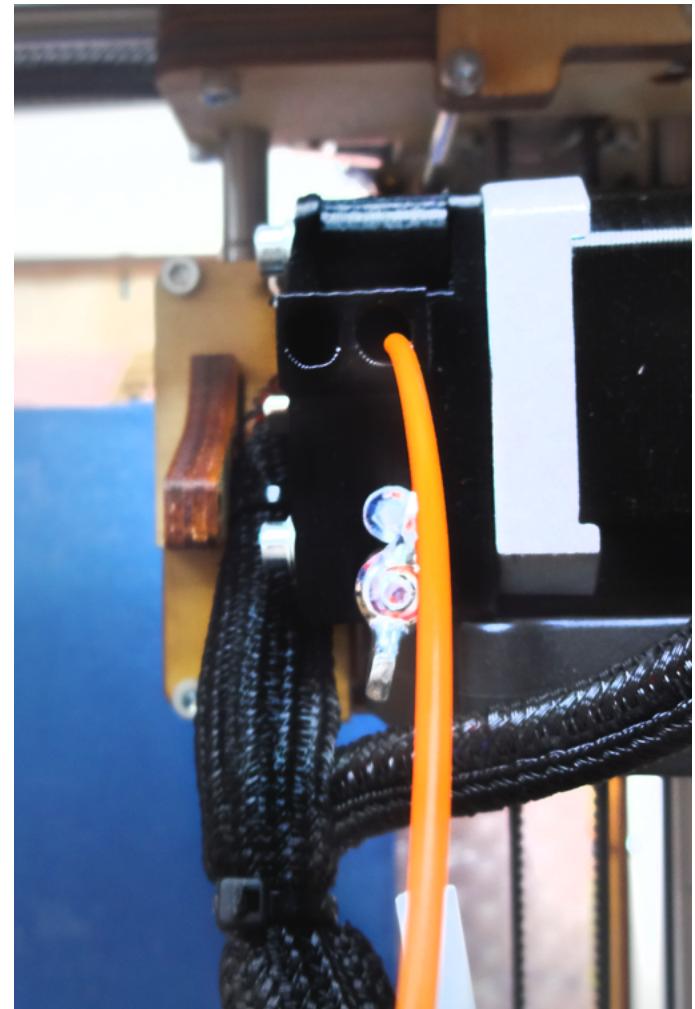
1. If the printer is switched on and connected to a computer, click the Turn motors off button in RepetierHost
2. Put about 5 cm of filament into the filament slot (5).



RUNNING THE PRINT

IN REPETIERHOST:

1. Connect a computer to the printer by clicking the Connect button.
2. Open a previously prepared .gcode file.
3. Click the Run Job button.



PRINTING - TAKING THE PRINT OUT OFF THE BED

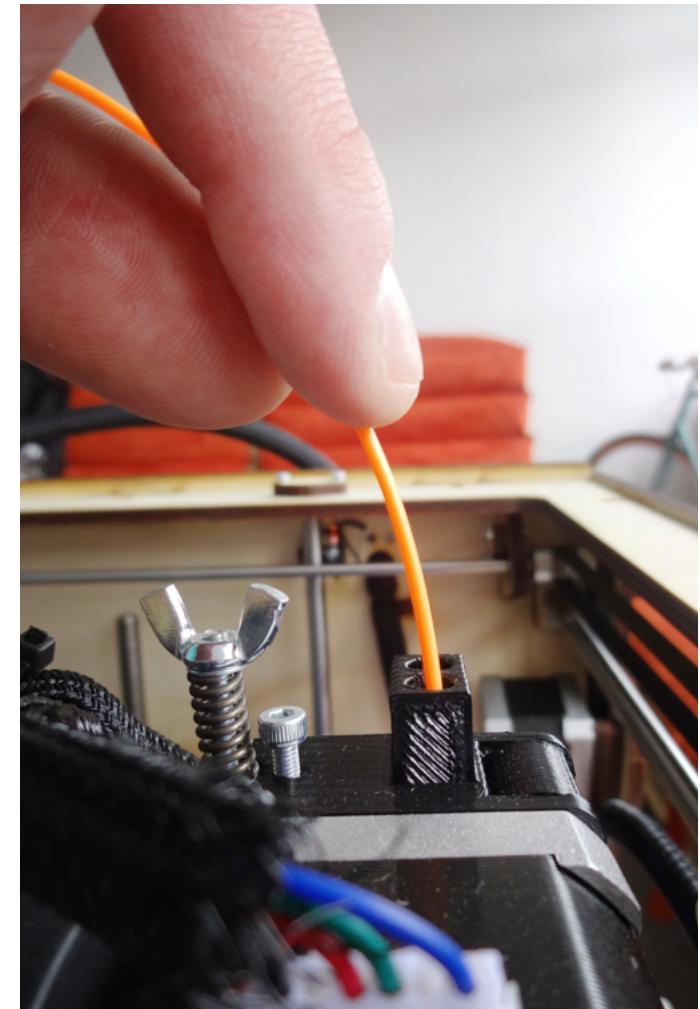
Once the print is complete you can take the print-out off the bed. Usually, you can do it simply with your hand but you can also use a screwdriver or a knife (picture on the bottom).



PRINTING - PULLING OUT FILAMENT

1. Warm up the extruder: in RepetierHost, in the Manual Control tab on the right set the temperature to ca. 180° celsius and click the Heat Extruder button.
2. Click the Turn Motors Off button.

Once the extruder is properly heated up you can pull filament out of the extruder with your hand.

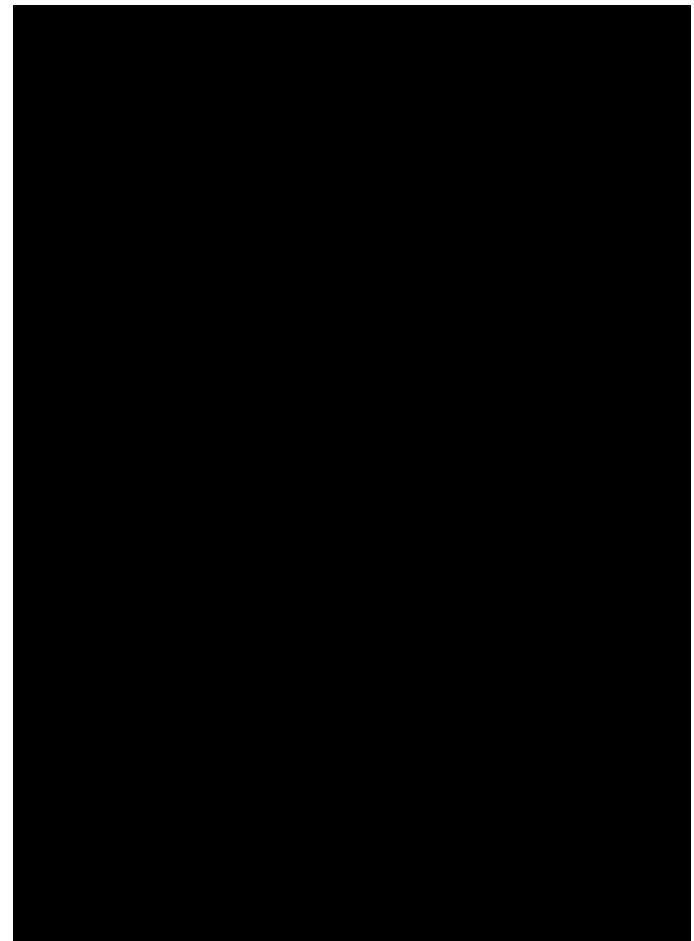


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HOW TO STORE PLA FILAMENT

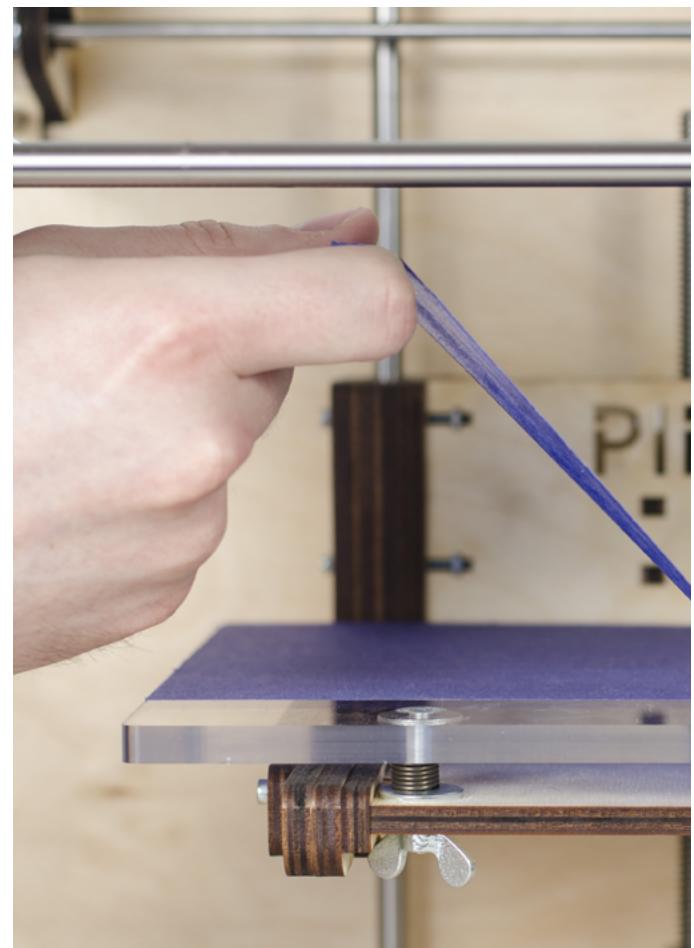
DAMP AND DIRT ARE
THE ENEMIES OF YOUR
FILAMENT!

To ensure that your printer works fine store your filament in a dry and clean place. If you feed the device with dusty filament, specks of dust will clog the extruder.



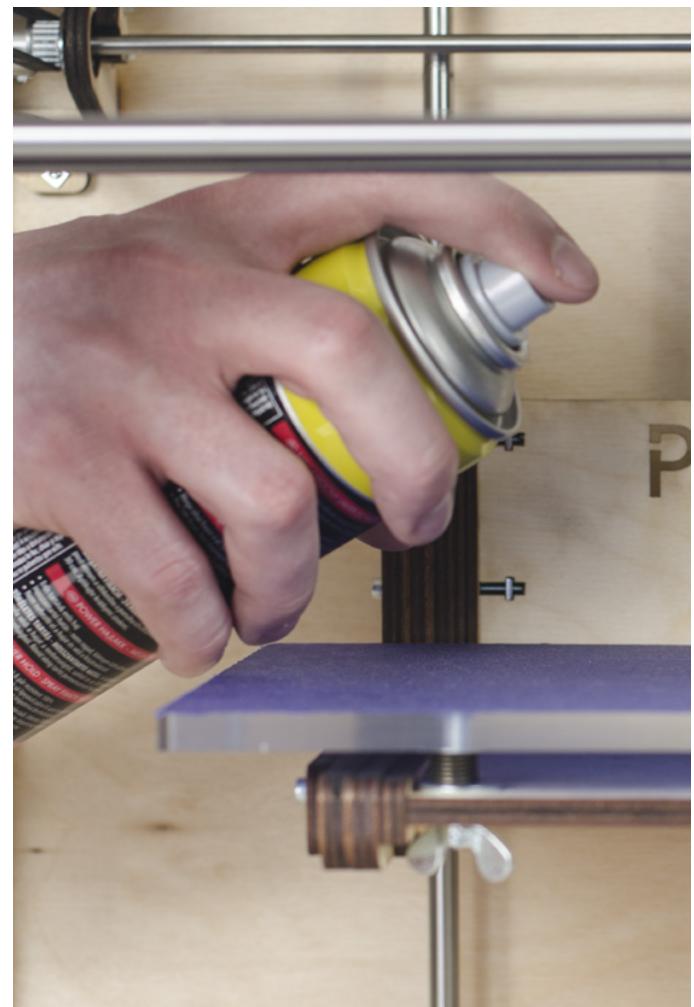
HOW TO MAINTAIN THE PRINTER - THE BED

The surface of the bed (1) is covered with a plain painter's tape (that improves the plastic's adhesion to the bed) available in any construction-repair warehouse. The tape degrades after some time, and you need to replace it with a new layer (picture beside).



HOW TO MAINTAIN THE PRINTER - THE ADHESIVE

Every now and again, cover the surface of the bed with a thin layer of hair spray to improve the print-outs' adhesion to the bed. A hair spray can for a couple of bucks will suffice for a long time. The only hair spray we have tested and can recommend is Taft Extra Strong - it gives 100% satisfaction!

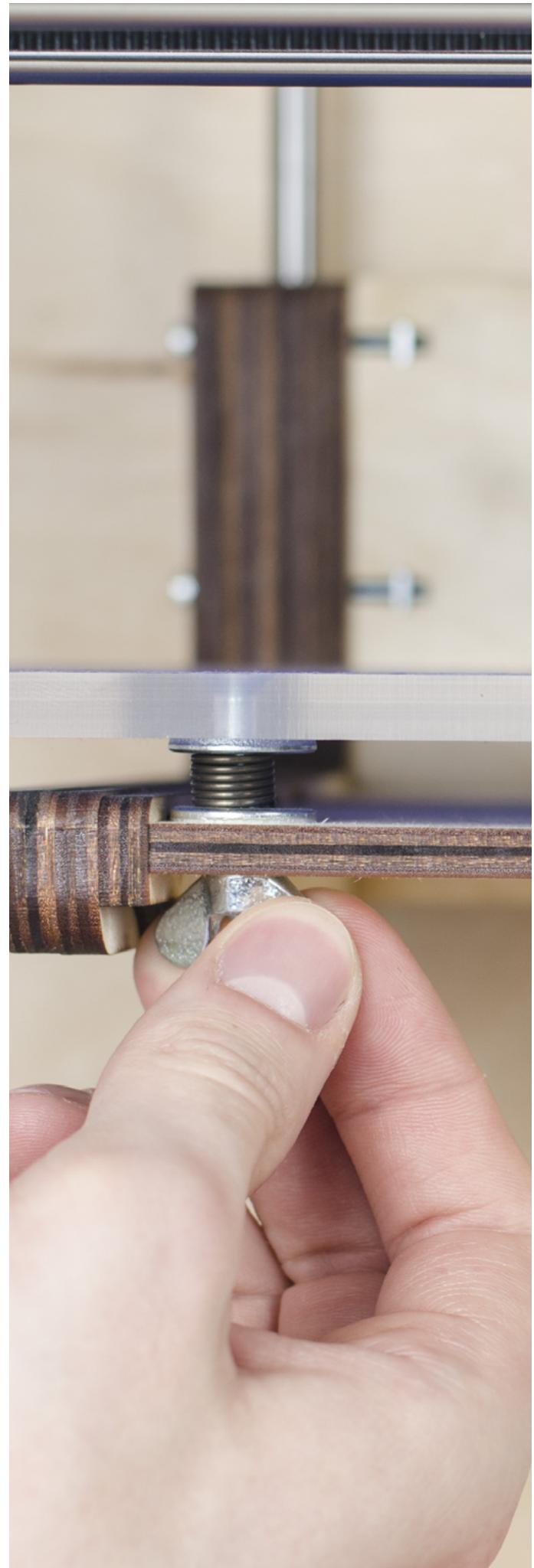


HOW TO MAINTAIN THE PRINTER - LEVELING THE BED

In order for the printer to work well you need to make sure that the bed is at the right height and that it is perfectly parallel to the XY plane.

Fortunately, the procedure is a piece of cake and you don't need to repeat it too often:

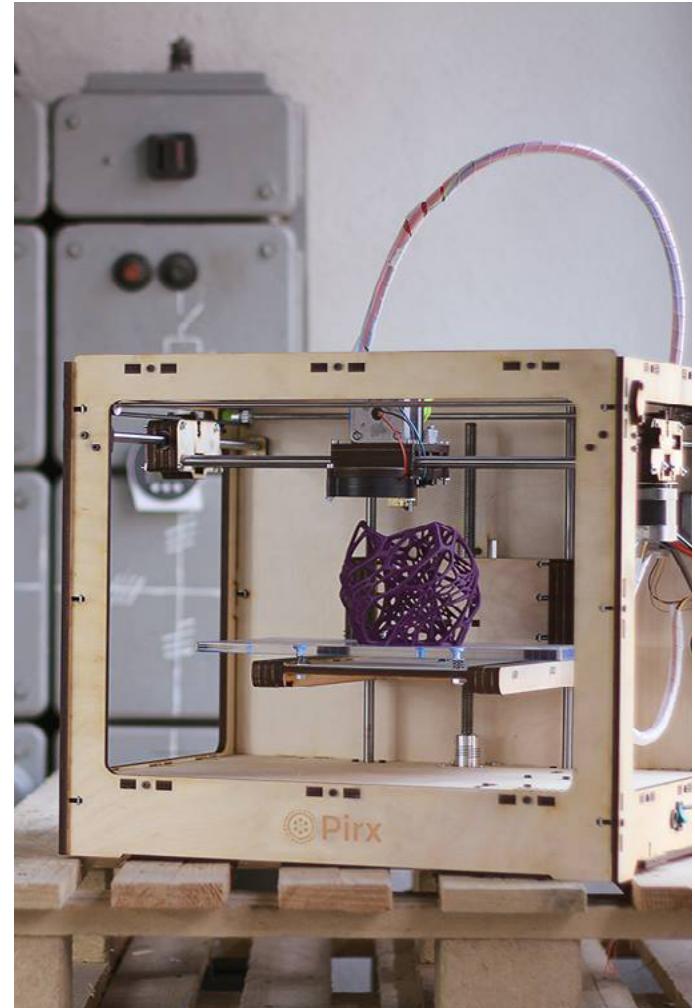
1. Ensure that the end of the nozzle is clean. Connect the printer to a computer, click [Home Z] and [Turn Motors Off].
2. Move the extruder with your hand so that the end of the nozzle is just above one of the wing-nuts (3) that are under the bed.
3. Turn the wing-nut (3) to make the slit between the end of the nozzle and the bed is barely visible. You can use a piece of paper as an aid.
4. Repeat steps 2 and 3 for the remaining two wing-nuts.



HEADLINE

LOREM IPSUM DOLOR
SIT AMET, CONSECTERUR
ADIPISICING ELIT

1. Lorem ipsum dolor sit amet, consectetur adipisicing elit.
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5. Lorem ipsum dolor sit amet, consectetur adipisicing elit.



SAFETY RULES

- ✓ DO NOT TOUCH THE HOT-END (4).
 - ✓ DO NOT TOUCH ANY OF THE MECHANICAL ELEMENTS OF THE PRINTER (TIMING BELTS, ETC.)
 - ✓ SWITCH OFF THE PRINTER WITH THE POWER BUTTON, WHEN IT DOESN'T WORK (8).
 - ✓ DO NOT LEAVE THE PRINTER UNATTENDED WHILE POWERED UP.
-

TECHNICAL SUPPORT:

 SUPPORT@PIRX3D.COM

 + 48 535 101 605