FAQ

01 Introduction

- **Printing TECH：** FDM（Fused Deposition Modeling）
- **Print size：** 205*205*245mm
- **Print layer size：** 0.05-0.3mm
- **Precision：** X/Y-0.002mm Z-0.0125mm
- **Printing speed：** 20~200mm /sec.
- **Free running speed：** **150**mm / sec.
- **Nozzle diameter：** 0.4mm / 1.75mm（Standard）
- **Nozzle application：** 0.2mm-0.8mm
- **Nozzle operating temperature：** Max : 260°C
- **Number of extruders：** 1 pc
- **Printing speed：** 20~200mm /sec。
- **Print material：** PLA，ABS，HIPS，WOOD-PLA
- **Printer structure：** Aluminum profile aluminum 6065
- **Hot bed temperature：** **Max** 110°C

Power supply：
Operating Voltage： 24V DC / 15A
Input voltage： 110-220 VAC，50/60Hz.

- **Package**
  PACK SIZE: 50 * 30 * 30cm
  G.W: 12kg

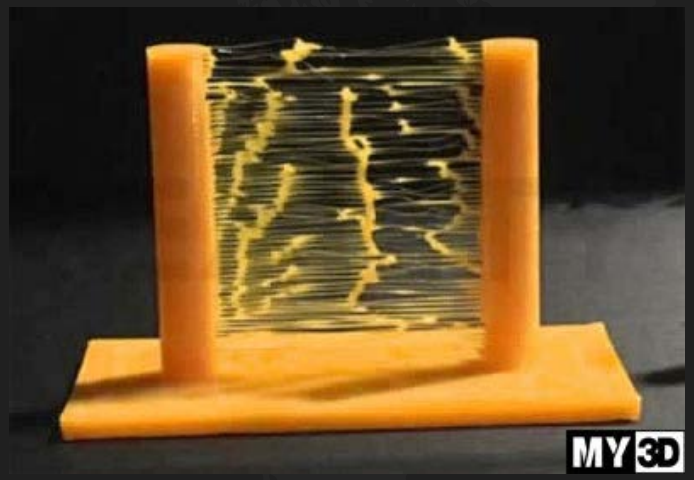
- **Machine specification：** 410x410x500mm
- **Printer working environment temperature：** 8°C-40°C

Software:

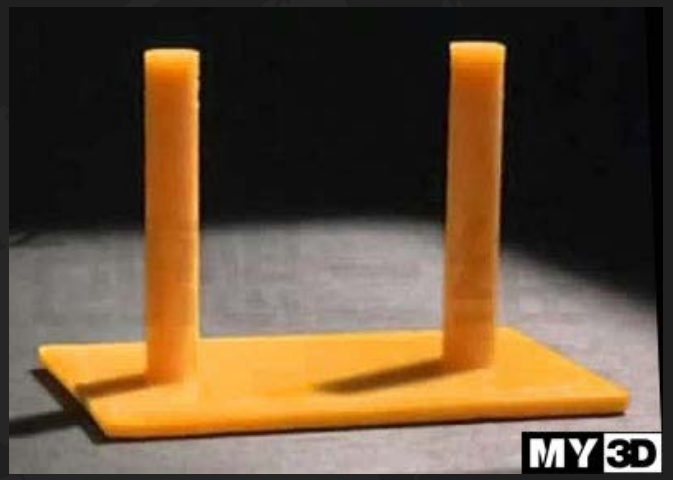
- **Identification format：** Stl Obj dae AMF bmp
- **Output format：** Gcode
- **Connection：** TF-card，USB（For experienced users only）
- **3D software support：** PROE，Solid-works，UG，3d Max，Rhino ETC.
- **Operating system：** Windows，ISO

FAQ

Travel move



Unusual



Normal

Problem :

1. Print head temperature setting is too high
2. Back pumping (rollback) is not set properly
3. Delay in feeding tube and joint loosening

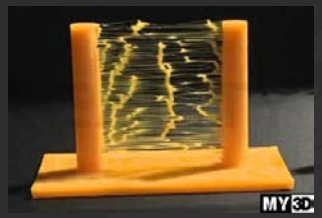
Solution :

1. Print head temperature is reduced by 5-10 degrees Celsius
2. Slicing software

Increase the withdrawal speed and length

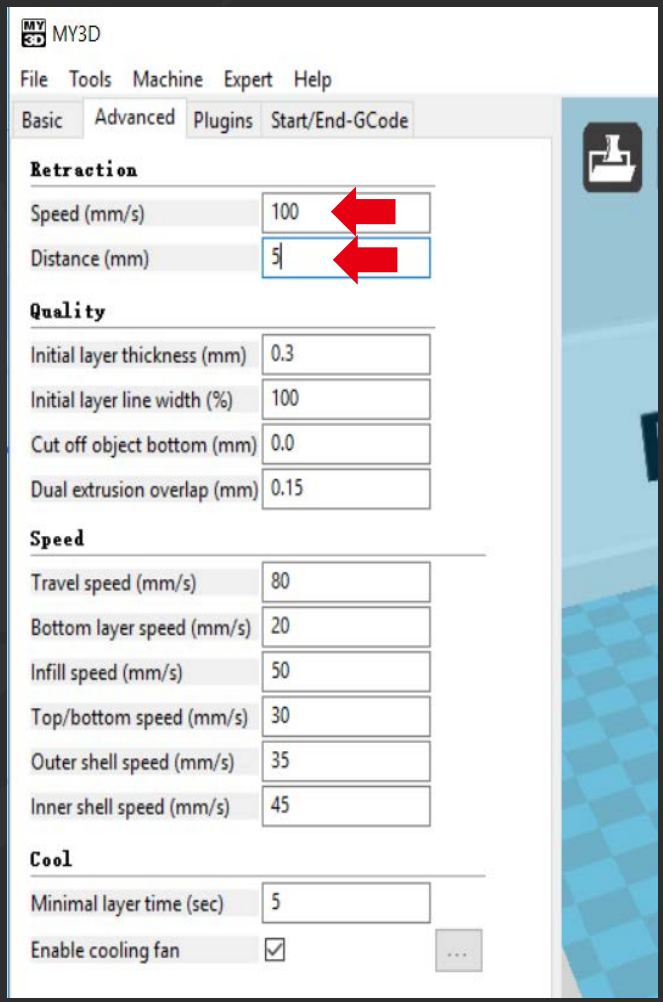
FAQ

Travel move



There is a range of retraction speed, and the pumping effect is better. It is recommended to be 80-120mm/s.

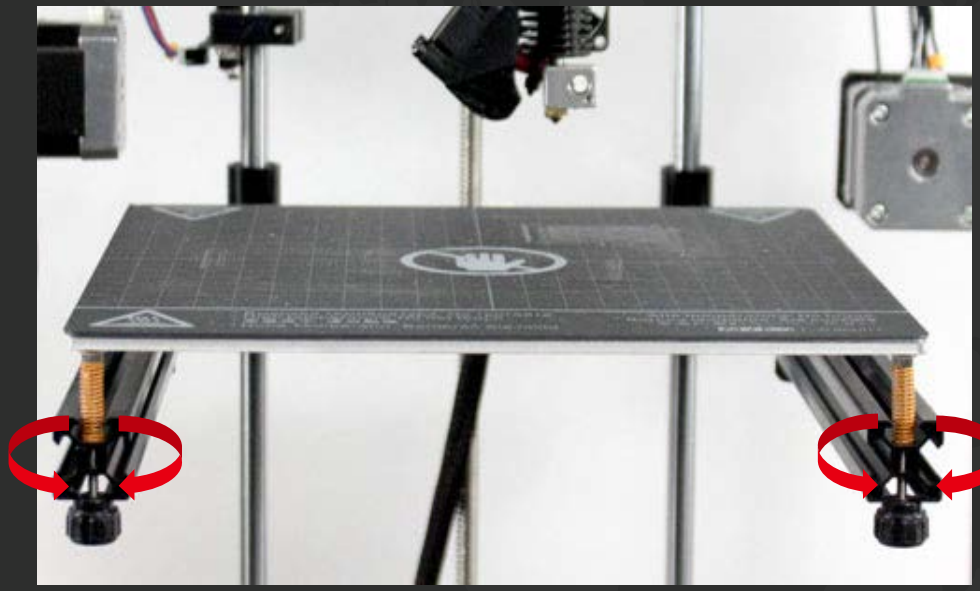
Retraction distance - try to increase the retraction distance, increase by 1mm each time, observe the improvement. (Different consumables have different effects)

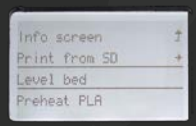


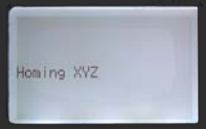
FAQ

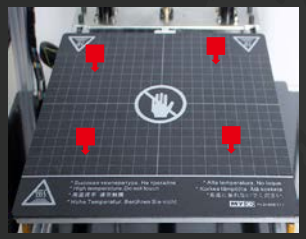
The first layer does not stick to the hot bed

Hot bed tilting - adjust the 4-point elastic nut - to ensure that the hot bed has the same nozzle preheating bed at 4 point.
Hot bed automatic leveling can be performed again





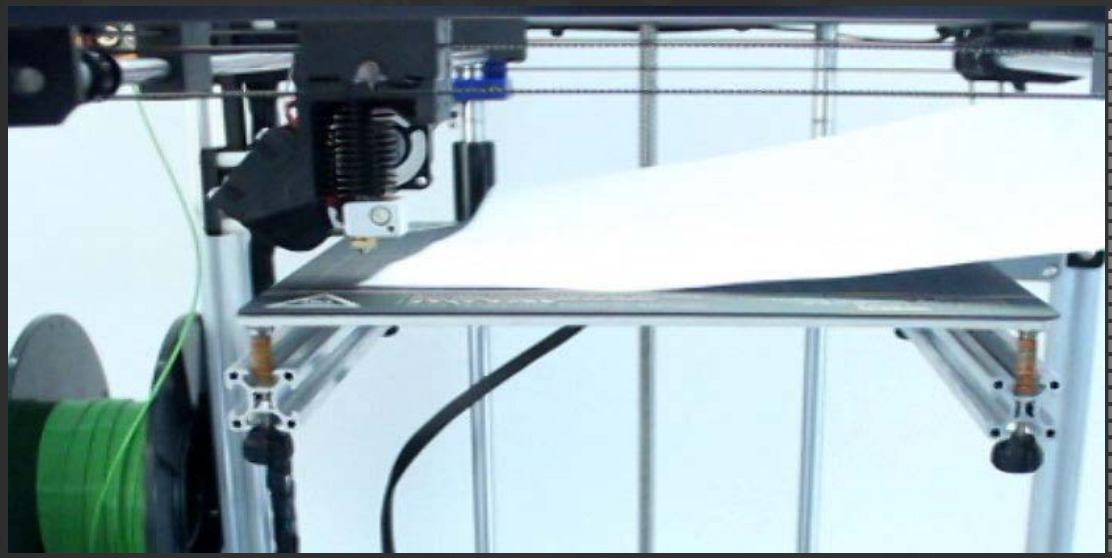




FAQ

The first layer does not stick to the hot bed

The nozzle is too far from the hot bed

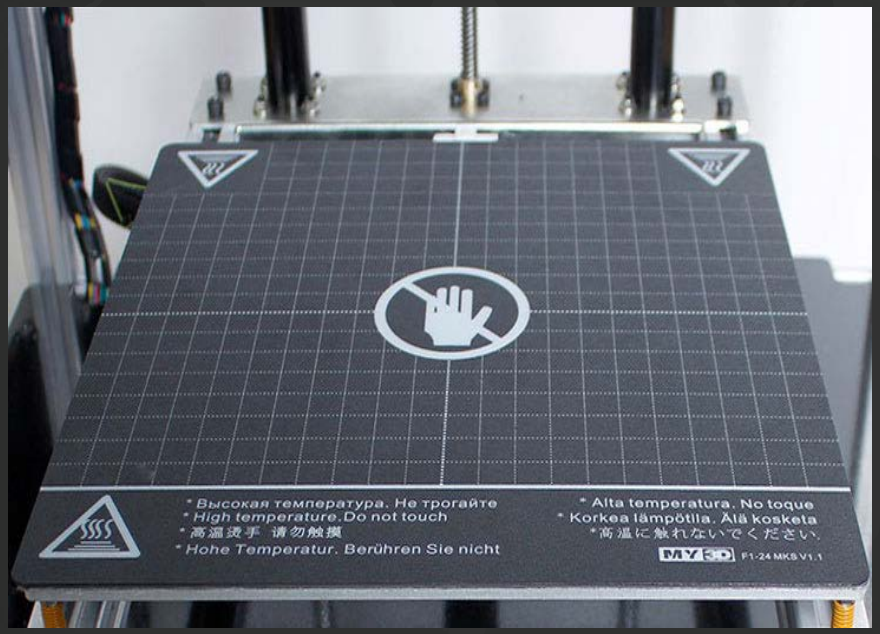


① Correct test spacing
② A4 paper can move freely with a little friction

FAQ

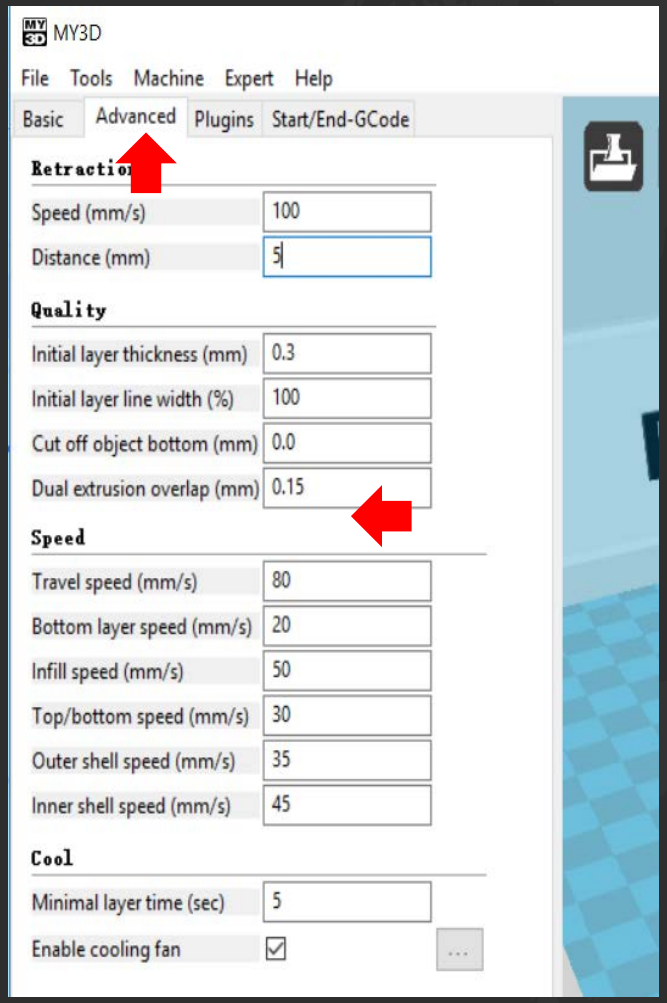
The first layer does not stick to the hot bed

- Before printing starts, please check if there is no dust, grease or the like on the platform.
- Use water or alcohol to clean the platform.



FAQ

The first layer does not stick to the hot bed

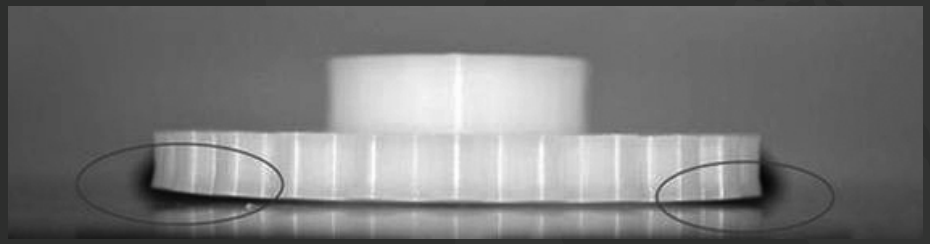


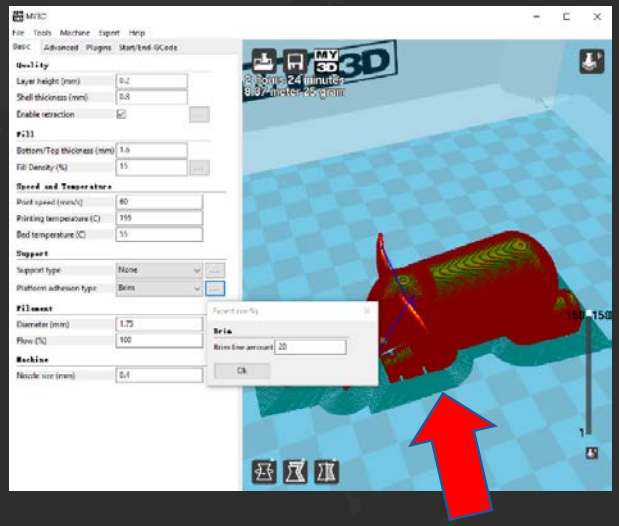
- The filment are normally adhered to the surface of the hot bed when the first layer is printed.
- If the first layer prints too quickly, the consumables may not have enough time to stick to the platform.
- To solve this problem, a very common method is to set the print speed of the first layer to 10mm/s.

FAQ

Sharp edge

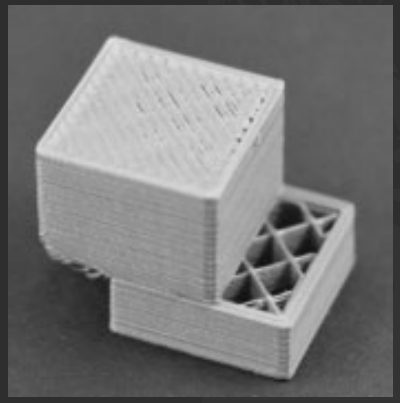
- The reason for plastic thermal expansion and contraction.
- PLA ABS shrinkage is about 0.5%
- It is recommended：
- PLA hot bed temperature be 55
- ABS nd the hot bed temperature be 100-110.
- Increase the number of base turns.





FAQ

Print misplacement



（1） Check if the synchronous wheel is locked and adjust the tightness of all the belts. ;

（2） Slice model error, re-slice printing ;

（3） Model problem Re-slice or misplacement, change the model that was successful before, if it is normal, please repair the model ;

（4） High-power appliances such as air conditioners suddenly turn off, please add voltage regulators to the print power supply. 。

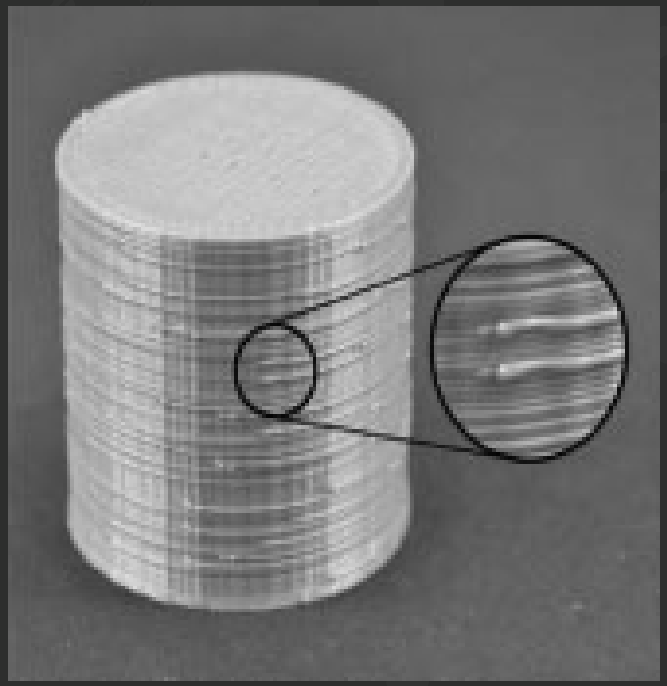
（5） The above problems can not solve the misplacement, while printing different models are the same height misplacement, replace the motherboard.

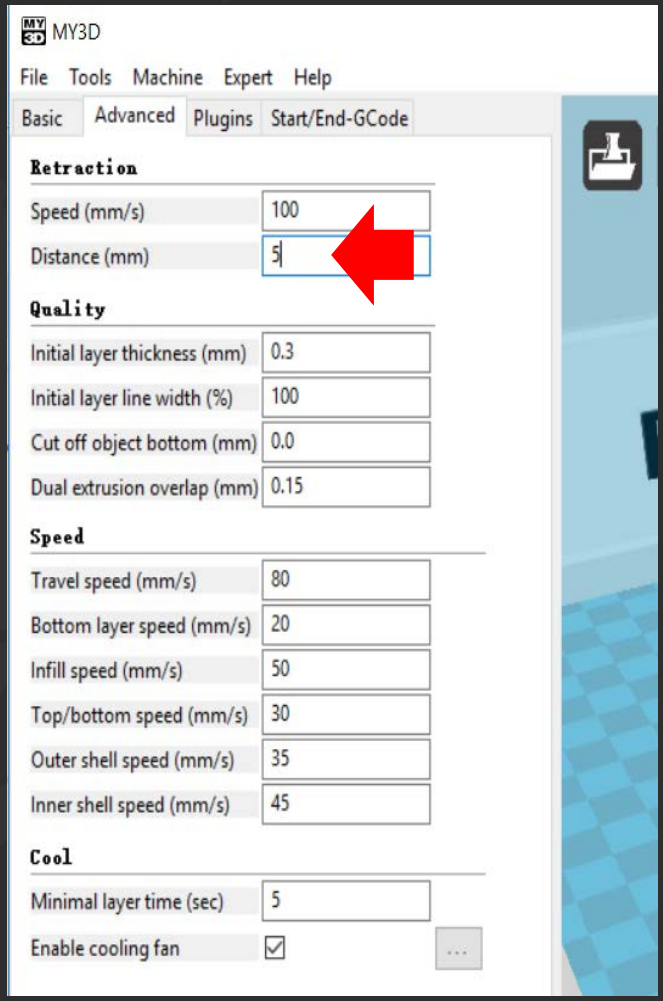
FAQ

Spots and scars on the surface of the print

(1) Increase the Retraction speed and length

- Recommended setting
- Speed 100 mm/s
- Distance 5 mm

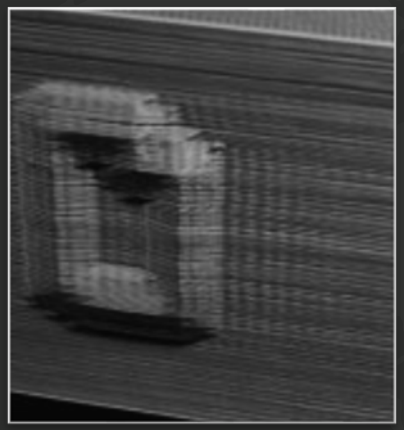


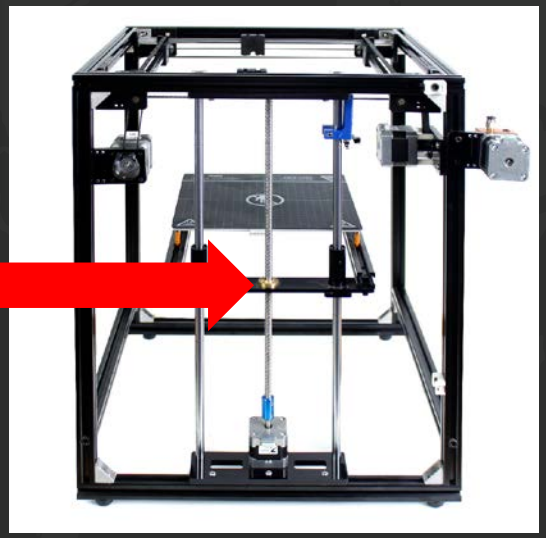


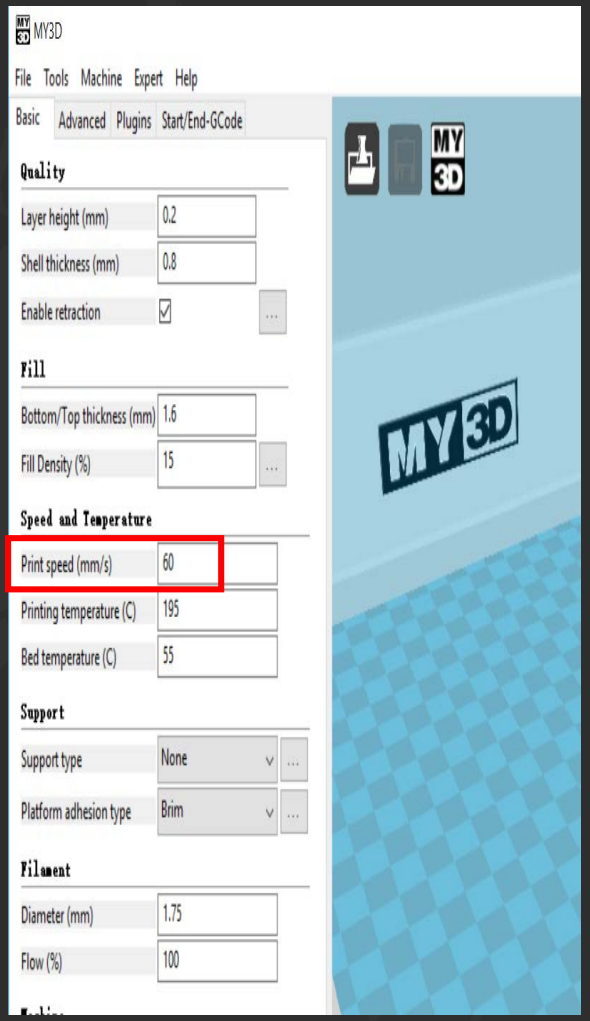
FAQ

Print surface relief

- Printing speed is too fast , Recommended speed 50-80mm/s
- Check the Z axis , Appropriate grease



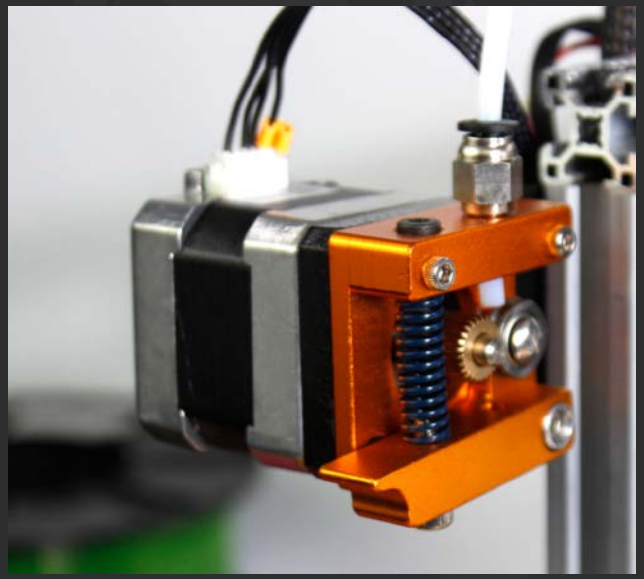




FAQ

Filamet enter not smooth

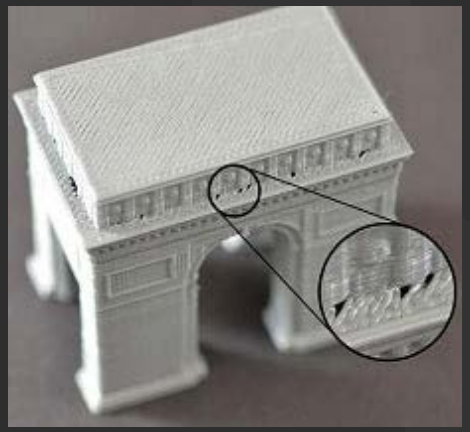
- the extruder gear jumps back and there is a “da da da″ sound
- Extruder, insufficient spring pressure, replacement of spring
- Clean the nozzle - block or replace the nozzle

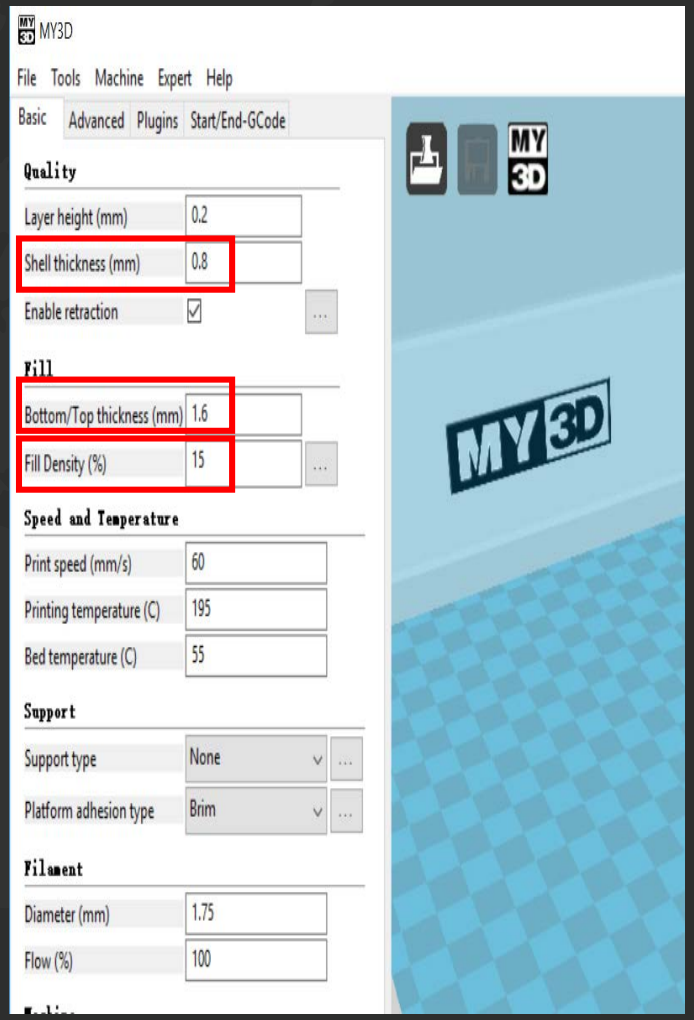


FAQ

Surface hole

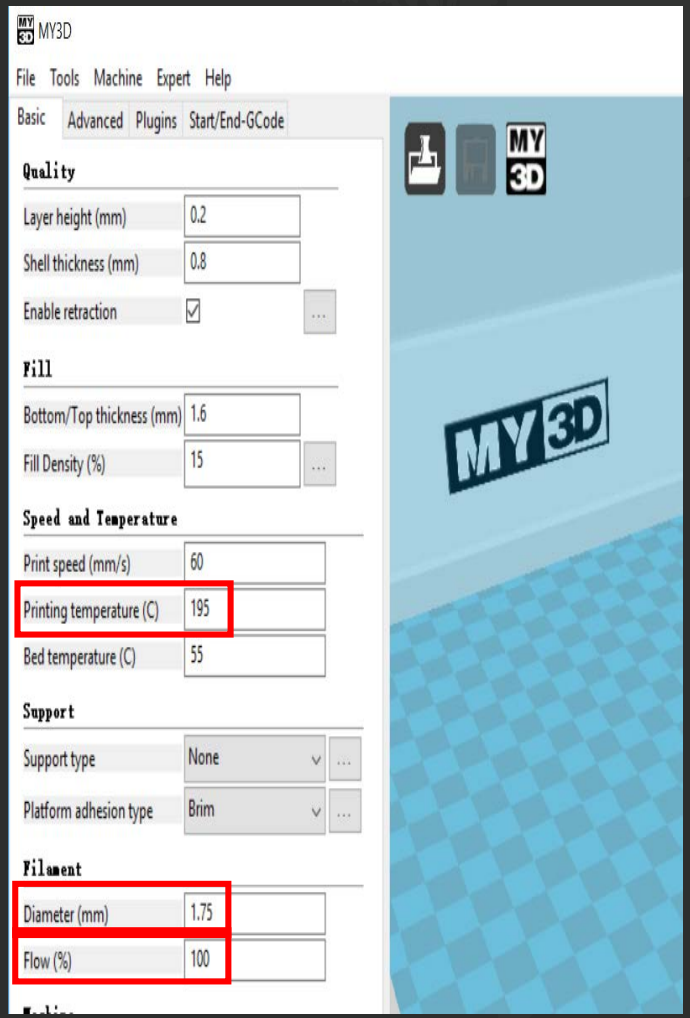
- Adjust the shell thickness or adjust the Fill – fill density % +10.
- Increase the Shell thickness
- Increase the Bottom/Top thickness





FAQ

Print out the outer surface of the model with excess)



(1) The nozzle temperature is too high, the consumables melt too quickly, causing the flow to overflow the printed outer layer; try to reduce the 5-10 degrees

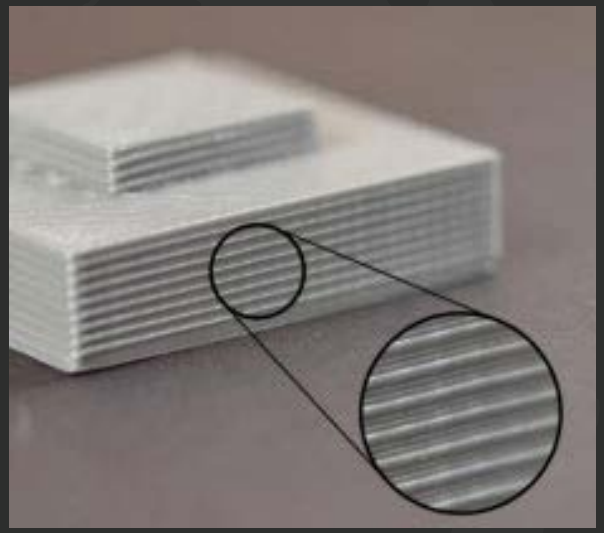
(2) FILMENT FLOW% , The default value is 100%. Reduced to 90% printing;

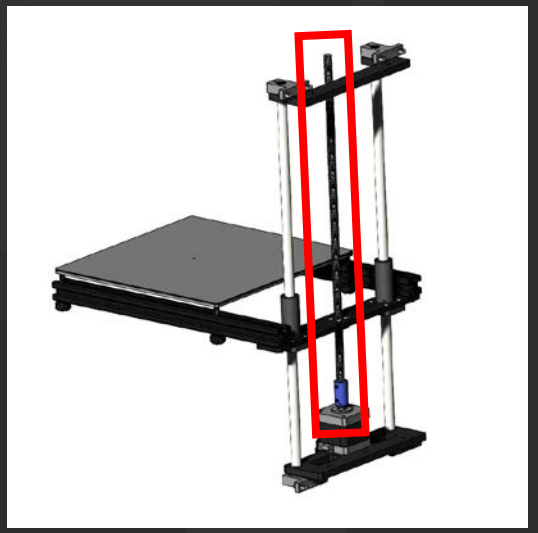
(3) The diameter of filment is set incorrectly.. The consumables are 1.75mm and 3.00mm. Use 1.75mm consumables in the software. Set to: “1.75”, 3.00mm Consumables are set to “3.00” in the software.

FAQ

Ripple on the printed side

(1) Loose printing platform - Solution: Tighten the corresponding connecting screws
(2) The Z-axis screw is loose. Tighten the corresponding screws. Z-axis screw bending - adjust or replace the screw.
(3) The XY shaft belt is loose. Solution: Check the tightness of the belt installation of each shaft.





FAQ

Print without extrusion supplies

Reasons and suggested solutions:

1、Nozzle when printing No printed material inside

Most extruders will self-flow the melted material in the nozzle when it is hovering at high temperatures, which often causes the consumables in the nozzle to drain and form a cavity. It takes a few seconds to discharge when the extruder is extruded; the printing does not start at the beginning. The core of solving this problem is to ensure that there are sufficient melted consumables in the nozzle before starting to print. The most common solution is to add a skirt skirt. Add a few turns of the skirt and draw a few circles around the object before the official start of printing the object, so that there are enough melted consumables in the nozzle.

2、The nozzle is close to the hot bed when starting printing

There is not enough room for the melted supplies to flow out. You can try to level and adjust the height of the first layer of the slicing software.

3、Consumables are smoothed by the extruder

Exit the consumables, cut off the damaged consumables, and re-feed the consumables 。

4、Nozzle blocked

Replace the nozzle or need a professional drill bit - please clean it under heating (pay attention to burns)

FAQ

The display of the machine is garbled or flashed or blank.

- If there is no problem with the model being printed, let the printer continue printing. After printing, please turn off the phone, it will return to normal after booting. This is the flower screen caused by static electricity. This has no effect on the machine itself. Solution, ground wire zero line,

Which 3D drawing modeling software files can be printed?

- It is possible to use common 3D software, such as Rhino3D, Proe, 3dMax, CAD, UG, Soliwork, etc. As long as the file can be saved in STL format.

How long does it usually take to print?

- Our machine print speed and layer height are adjustable, the slower the speed, the better the accuracy. For example, to print an egg-sized object, the fastest twenty minutes, the slowest three hours.

Attention Warning

1. Before printing, please read the product manual carefully, adjust the printing platform first, and then start the official printing;
2. The print head is at a high temperature of 190-260 degrees Celsius. Do not touch it at high temperatures.
3. After the printing work is finished, seal the consumables to avoid the printing quality due to the moisture of the consumables. At the beginning of the next printing, preheat the nozzle first, let the nozzle automatically spin out for about one minute, and then start the official printing;
4. Do not use a fan or air conditioning vent to face the printing platform during printing;
5. Recommended working environment Humidity: The relative humidity should not exceed 80%. Otherwise, the components inside the machine may be deteriorated due to condensation, or even a short circuit may damage the machine. The relative humidity should not be lower than 20%, otherwise it may lead to excessive drying and static interference, causing garbled or wrong operation of the machine LED screen.
6. It is not recommended to run a 3D printer without being taken care of. In case of emergency, you can turn off the power supply directly.
7. Maintenance: When the printer is not in use for a long time, it should be protected from rain and moisture.