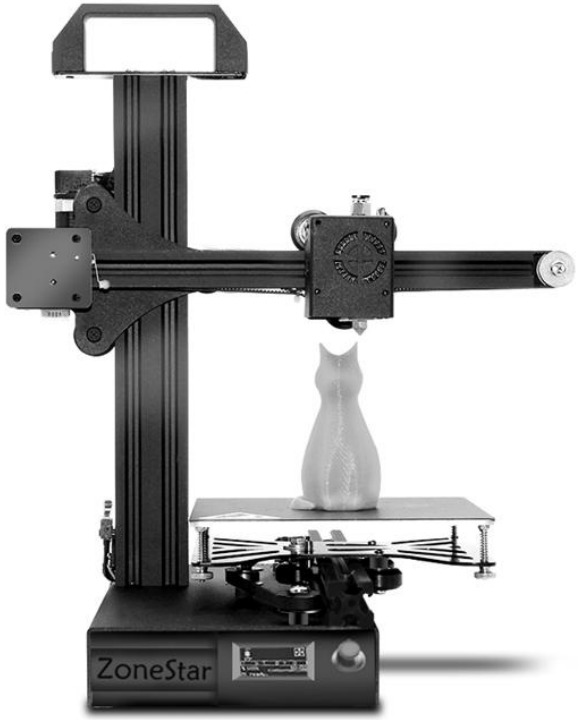
ZONESTAR



Model: Z6F/Z6FB/Z6X

User Manual

!! ATTENTION !!

Please strictly follow the standard operation when installation.

Please put the printer away from the reach of kids.

Must be guided by adults when children are installed or used.

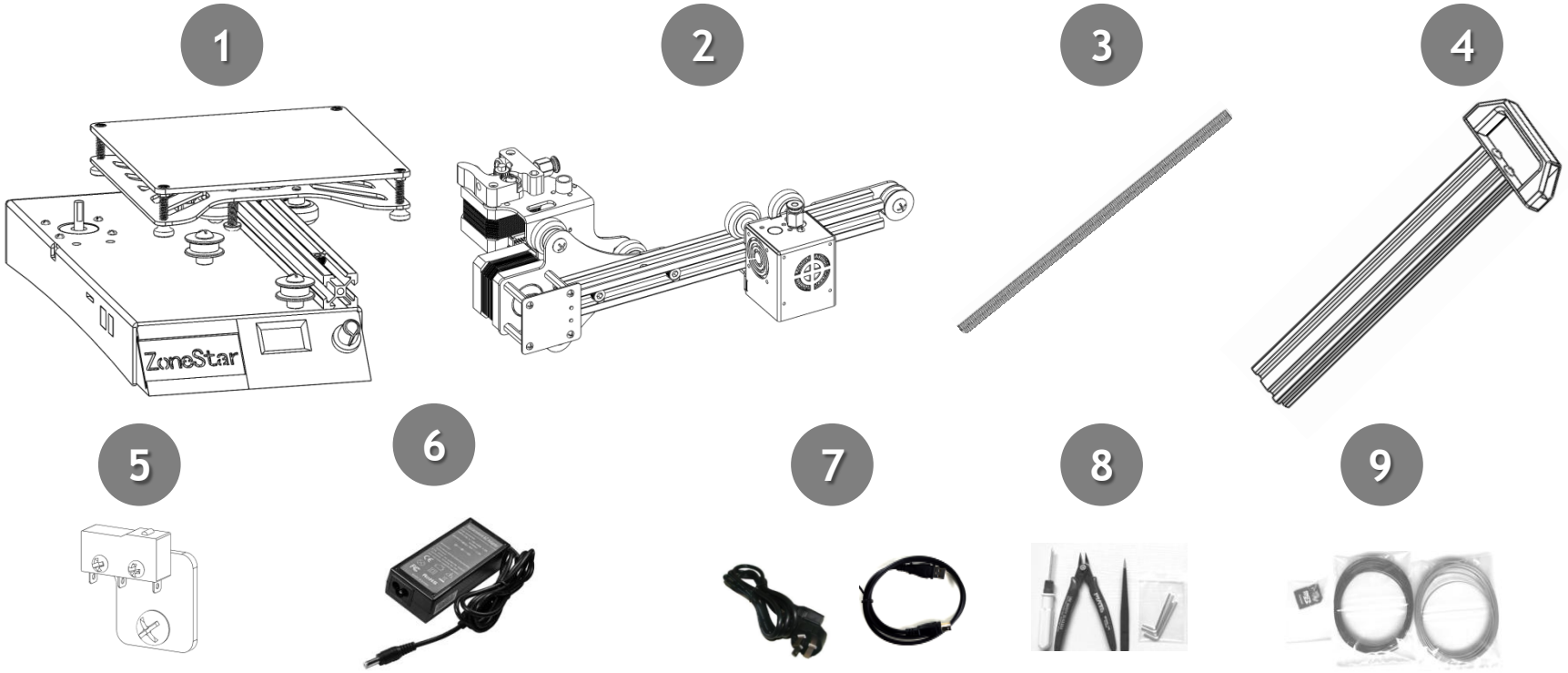
Take care when installation, to avoid electrical shock hazards.

Caution: Hot!
Hotend has high temperature even the printer stop working.

Caution: Hot!
Hotbed has high temperature even the printer stop working.

Please keep well-ventilated condition! May produce toxic gases when printer working.

Parts

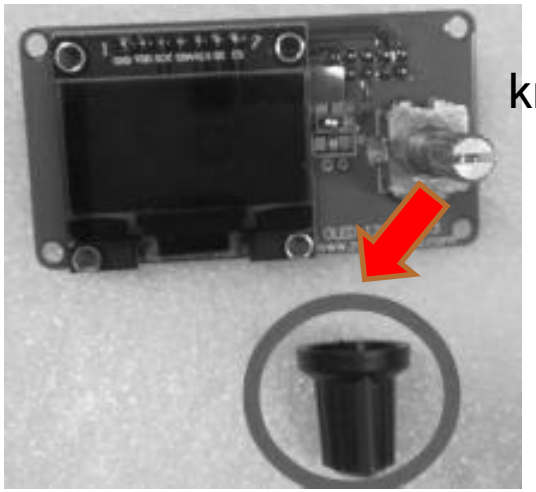


1	Base Module	6	Power adapter (The newer version used PSU and has assmbled to Base module)
2	X-axis Module	7	USB cable and Power cord
3	Lead screw	8	Tools
4	Z-axis Module (For Z6X, Handle may not be Pre-assembled)	9	Gift and TF card
5	Z-EndStop(Pre-assembled with Base Module)		

Pre-assembled

NOTE: In order to protect the LCD screen, we un-assemble the control panel before send out the kit, please loosen the 4 screws and then install the control panel to the Base Module. Pull out the knob cap from the knob before install the control panel, and install it back after finished to install it.

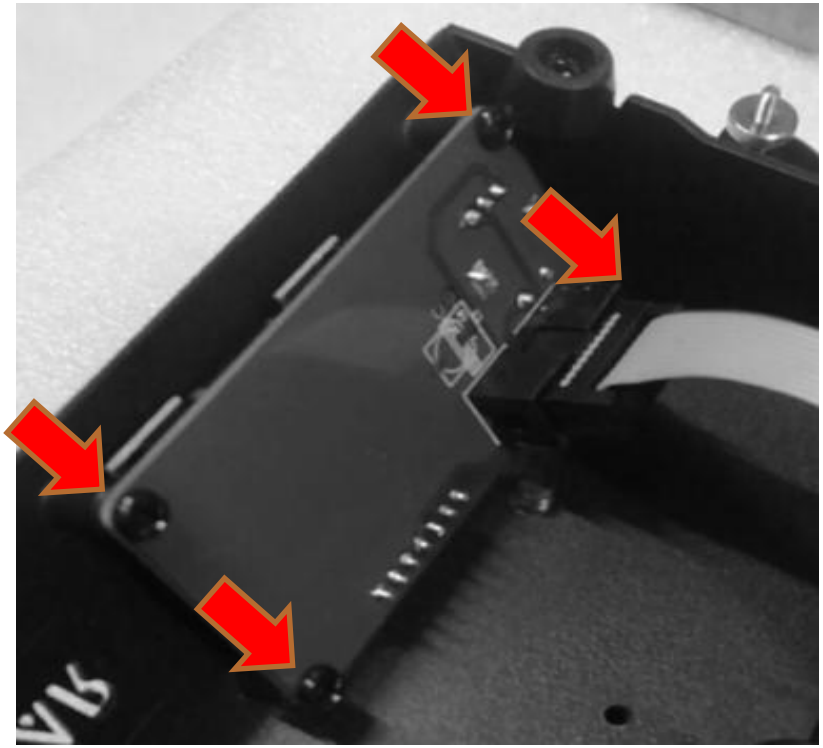
Step 1: Pull out the knob cap



knob

knob cap

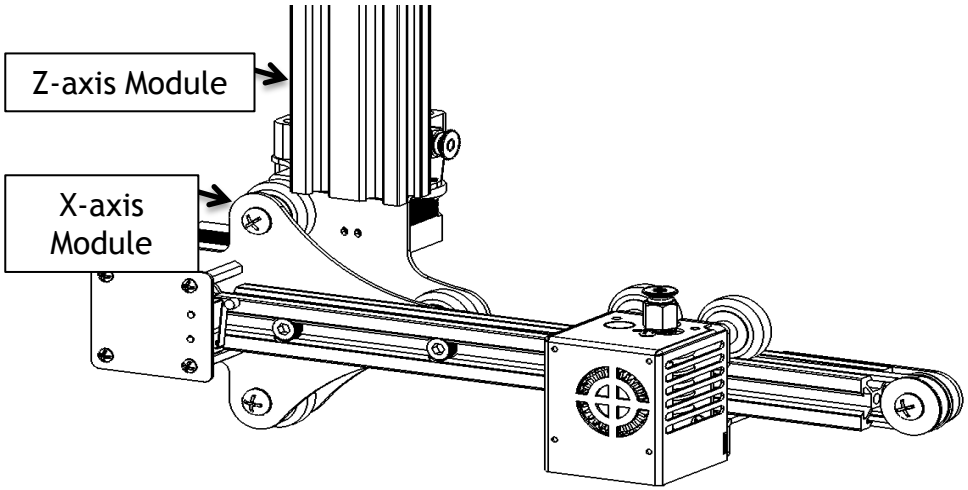
Step 2: Install control panel



Install

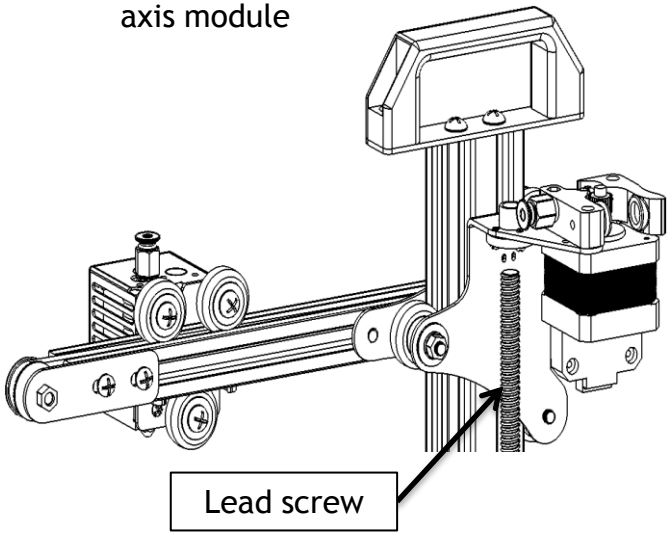
Step 1

Insert the Z-axis Module into the carrier of X-axis Module



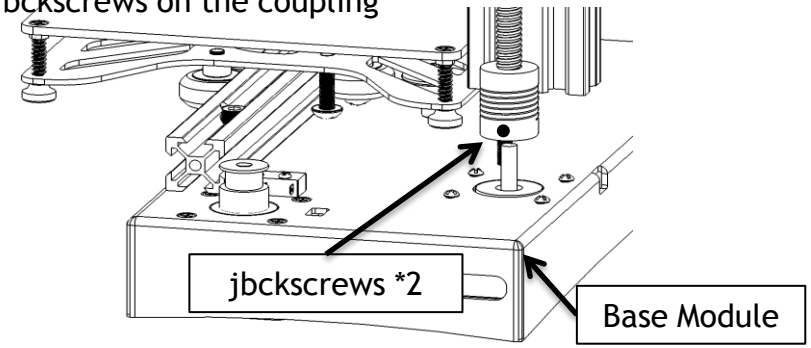
Step 2

Screw the Lead screw into the carrier of X-axis module



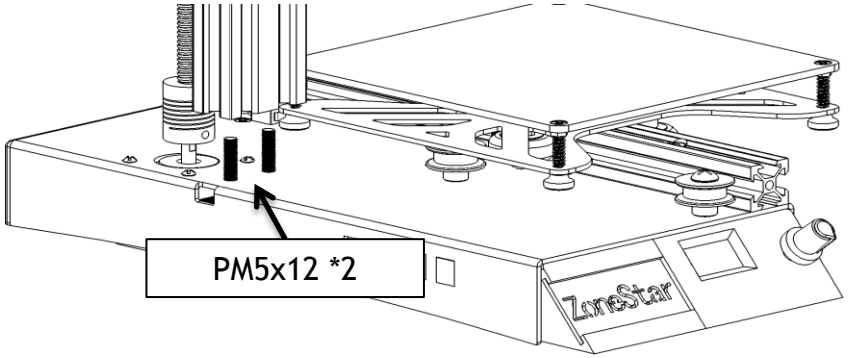
Step 3

Install the coupling into the motor shaft and tighten the jbckscrews on the coupling



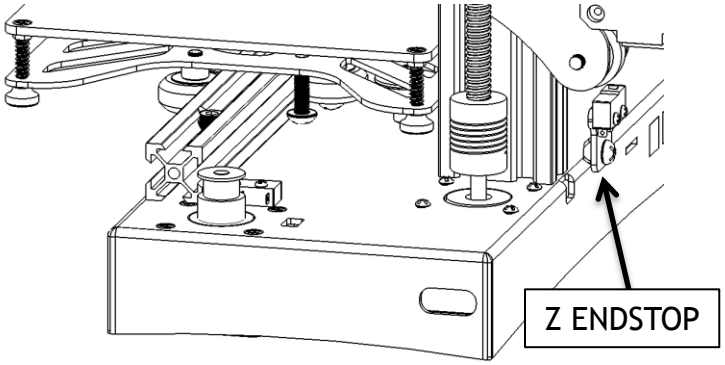
Step 4

Fixed the Z-axis module to the base module by screws
(Take down the two screws from the end of profile first)



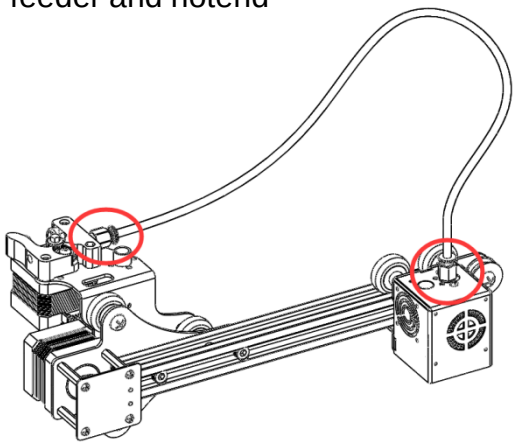
Step 5

Install the Z-ENDSTOP to Z-axis aluminum profile and tighten the screws.



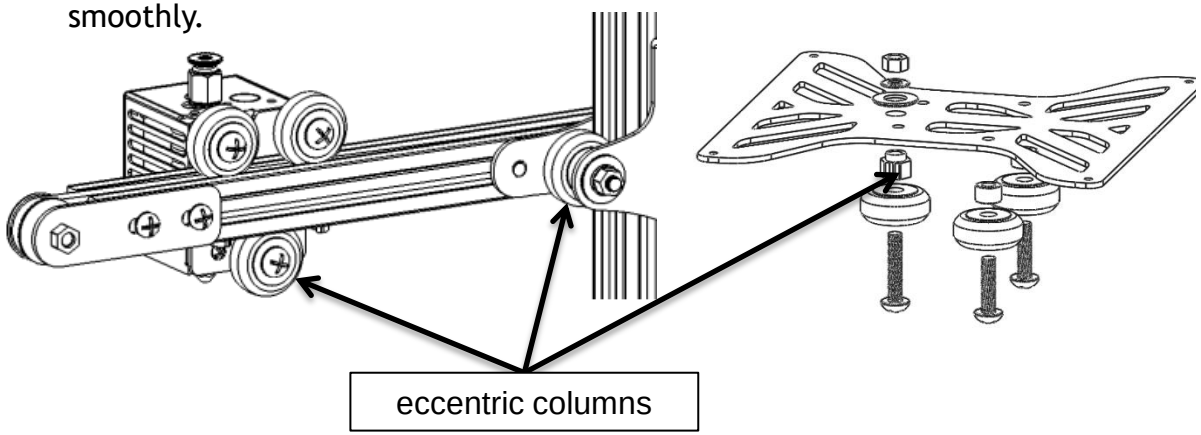
Step 6

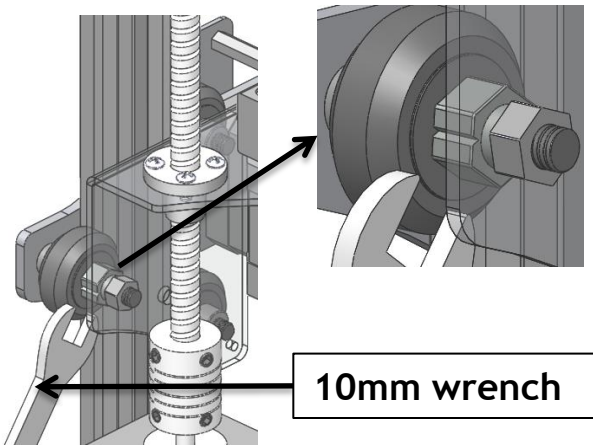
Plug the PTFE tube into the fittings to connect the extrusion feeder and hotend



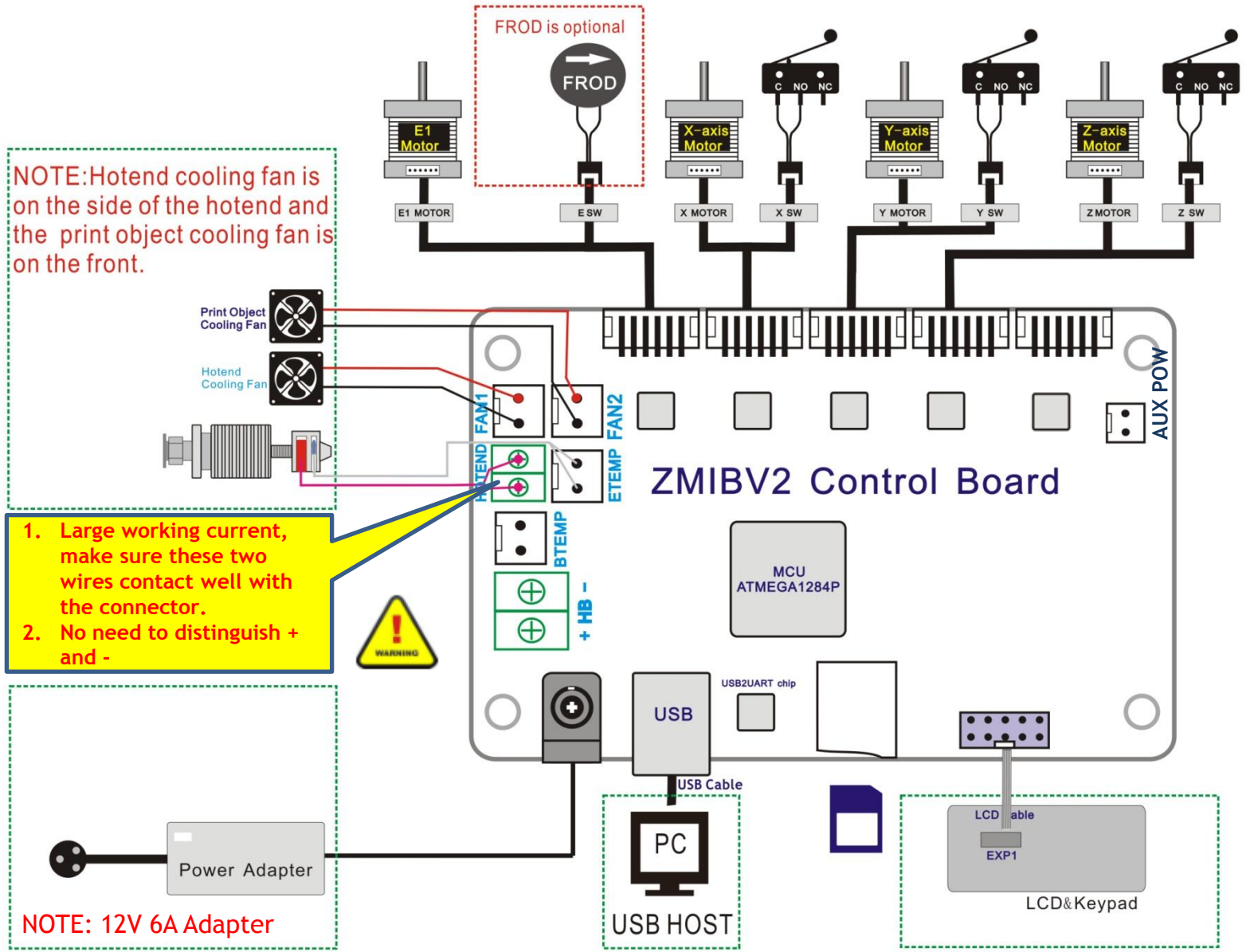
Step 7

Use a spanner to rotate the three eccentric columns, so that the wheels can hugged the tracks closely and move smoothly.

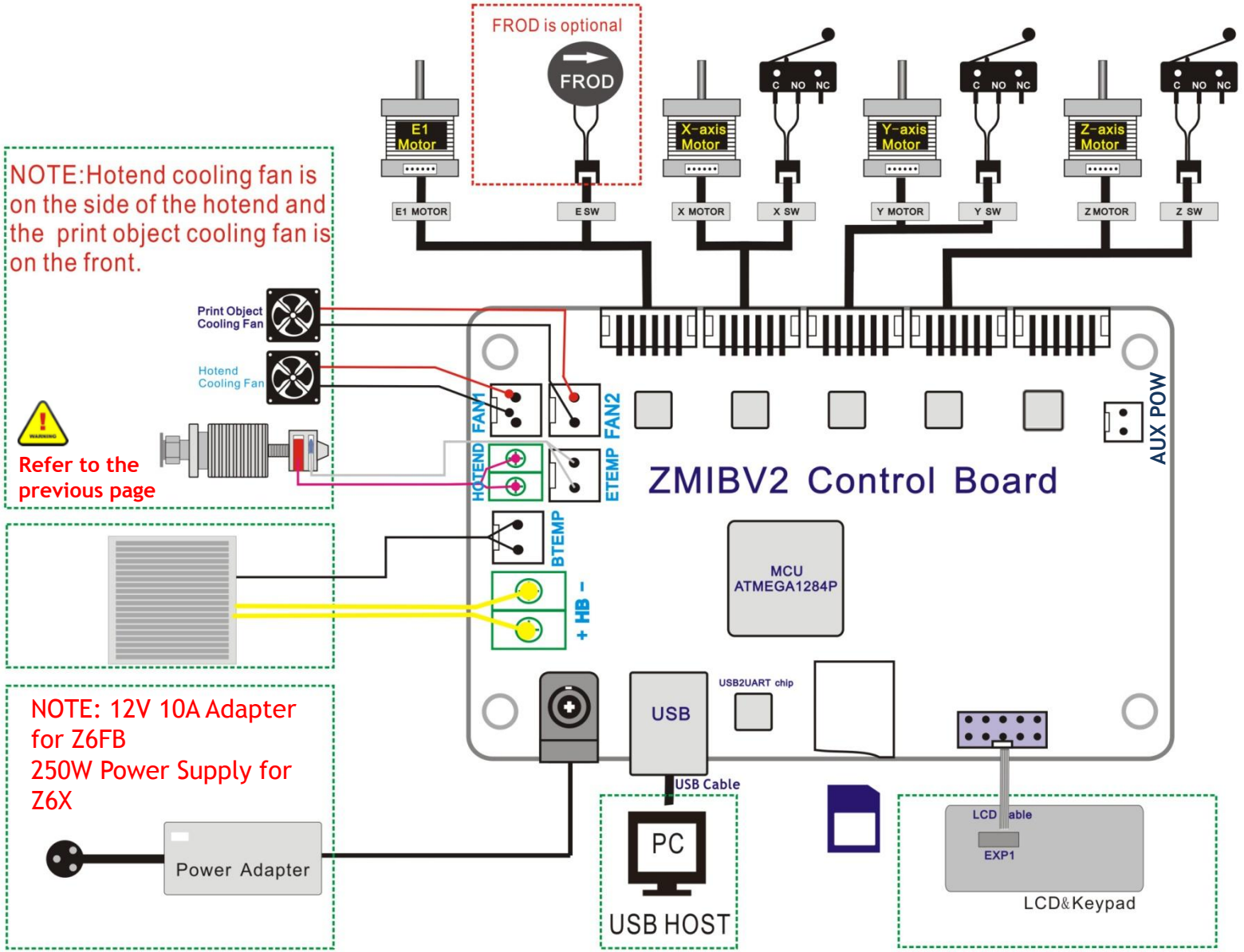




Z6F Wiring Diagram

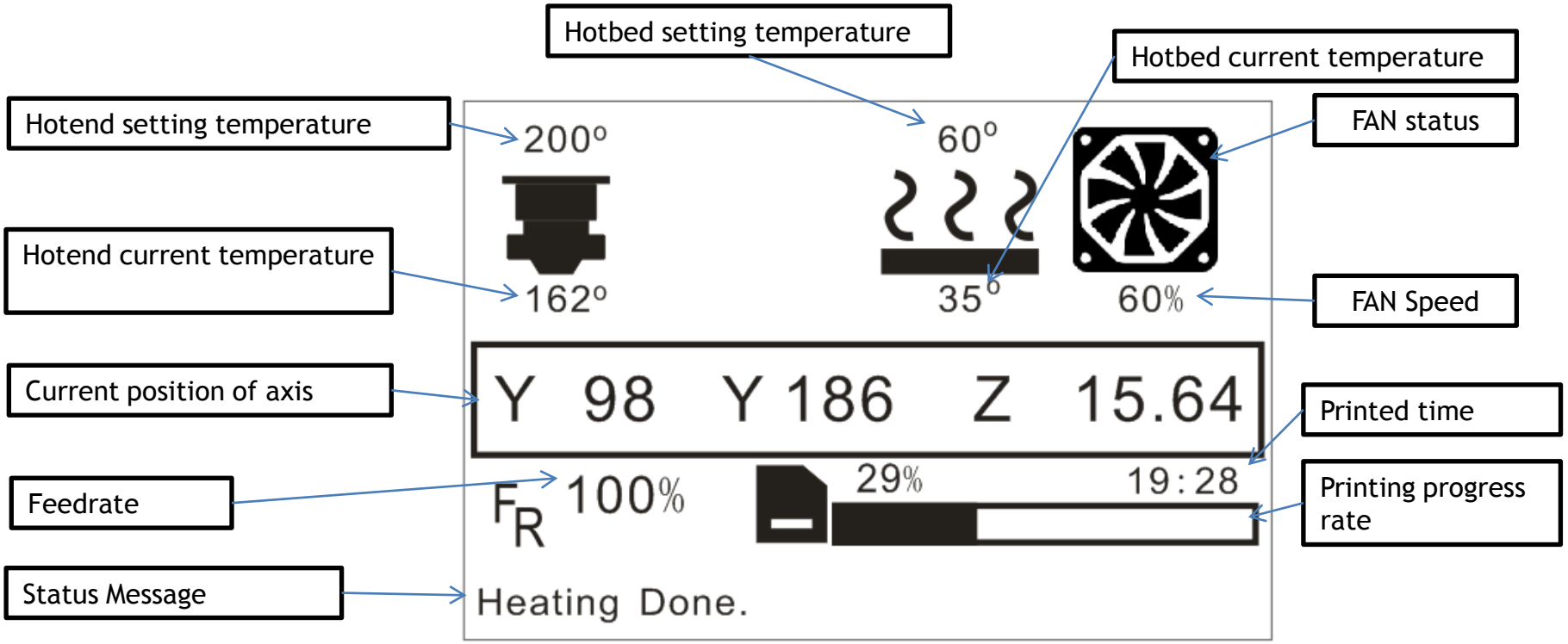


Z6FB/Z6X Wiring Diagram



LCD Menu and Operation

Knob operation: <***Clockwise rotation***>: Next Item / Value +. <***Counterclockwise rotation***>: Previous Item / Value -. <***Push***>: Enter / Execute.



For details on the LCD menu, please refer to the file "LCD Menu Description.pdf" in the TF card.

Prepare to print - level the hotbed

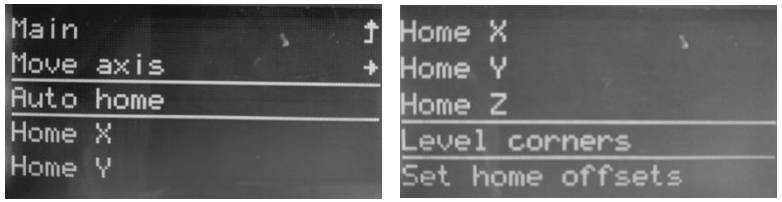
1. Clean nozzle: make sure there aren't any filament at the end of nozzle, if not, remove it by a diagonal pliers.

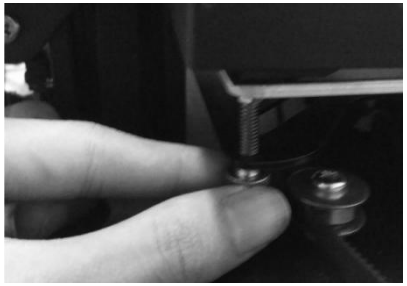
2. Choose “Prepare”>> “Auto Home”>>, wait the hotend go to the orig position.

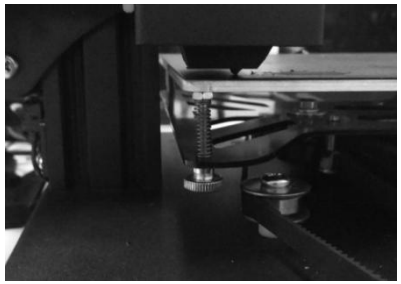
3. Watch the nozzle and make sure the nozzle is higher than the bed, otherwise tighten the hand nuts under the bed to pull down the hotbed or loosen these nuts to move up the bed.

4. Choose “Prepare”>> “Level Corners”>>, the nozzle will go to the first corner, adjust the hand nuts under the hotbed, let the nozzle almost touch the hotbed. In order to get a properly distance, you can put a A4 paper on the hotbed, and when the distanse between the nozzle and hotbed can only insert a paper, it will be perfect.

5. Choose “next corner”, and adjust again. Repeat this step again and again, until all of the four corner at the same height.







Home all axis → **start “level corners” wizard** → **Adjust bed height** → **put a paper on the bed to measure the height**

Debug - Set the nozzle offset on menu

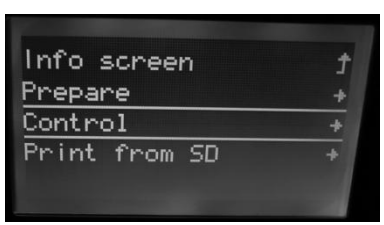
If the printed object wasn't on the center of the printing platform, you can set the offset on LCD menu.

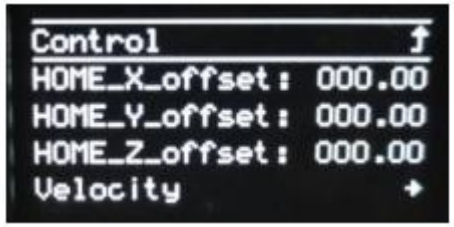
1. Choose ”Control”>> ”Montion”>>” HOME X/Y/Z OFFSET”>>Adjust this value.
2. Choose ”Control”>> ”Store settings ”>>Store the settings.

How to set the offset?

1. Decrease “HOME X OFFSET”, the printed object will move to right.
2. Decrease “HOME Y OFFSET”, the printed object will move to back.
3. Decerase “HOME Z OFFSET”, the printed object will move to higher.

NOTE: These parameters mean the offset of the nozzle from the spatial position of the machine print start point after homing.





Set offset → Store Settings

Prepare to print - Load Filament

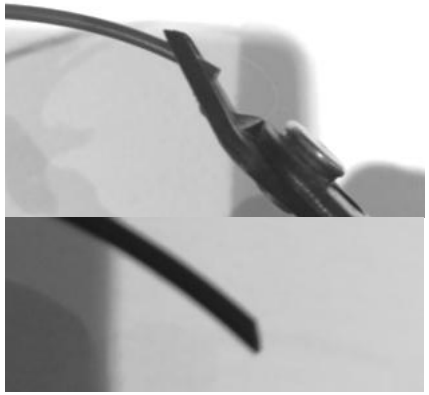
1 Preheat nozzle: Choose “Prepare”>> “Preheat PLA”, then nozzle and hotbed will be heated. **Waiting nozzle temperature reached to setting.**

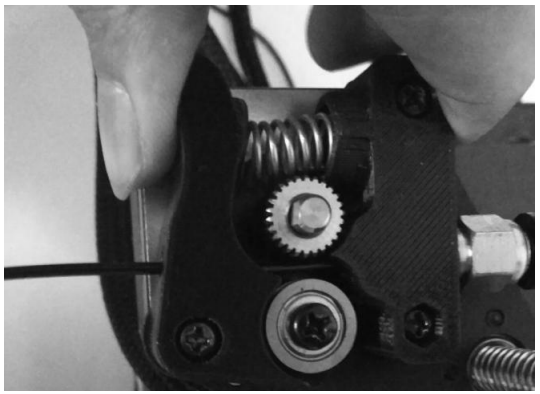
2 ***If there is filament in the hotend, do this step, otherwise skip this step.***
Choose “Prepare”>> “Move axis”>>”Extruder”>>”Move 1mm”>>”extruder: ****mm”, then Clockwise rotate the knob slowly, until you can see the filament flow from the nozzle.

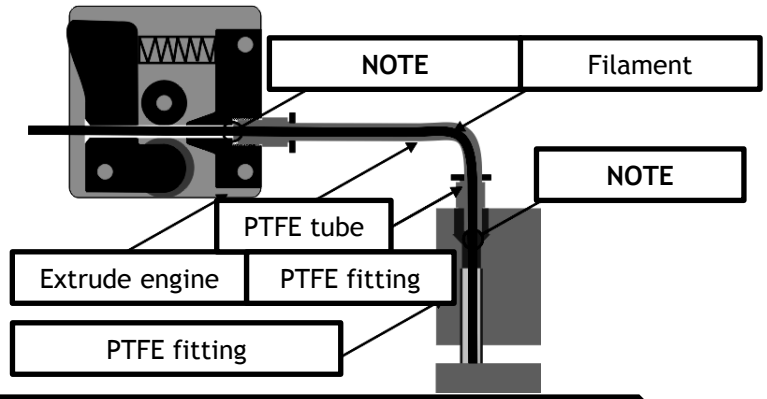
3 ***If there is filament in the hotend, do this step, otherwise skip this step.***
Press the handle on the extrude feeder and pull out the filament.

4 Press the handle on the extrude feeder and insert filament, make sure the filament has been inserted to the hotend.

5 Choose “Prepare”>> “Move axis”>>”Extruder”>>”Move 1mm”>>”extruder: ****mm”, then Clockwise rotate the knob slowly, until you can see the filament flow from the nozzle.







Use a diagonal pliers to cut off the head of filament

Press the handle and insert filament into the extruder engine

When loading filament, make sure it has entered the hotend, if it clog in extruder or hotend, try to remove the fittings and load the filament again.

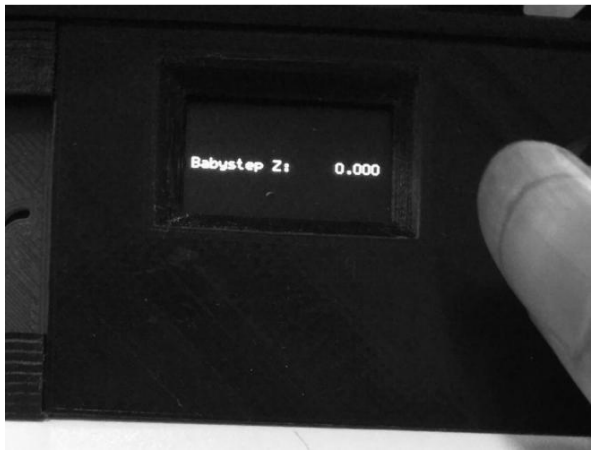
Print a test 3D object (Print from SD card)

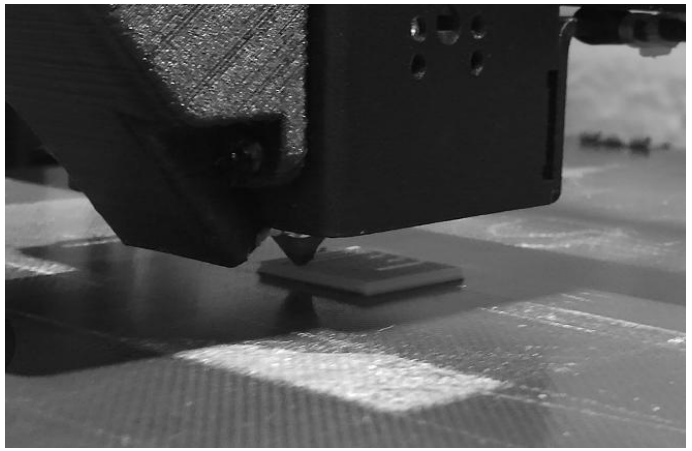
1. Insert the SD card to the SD card socket on the control box, and then power on the control box.
NOTE: the touchpad of Micro SDcard pointing up

2. Choose “Print from SD”>> Choose “Test_gcode\Single Color\xyz_cube.gcode”, push the knob to start printing.

3. Wait the printer to finish heating and start to print, watch the distance from nozzle to bed, double click the knob of LCD menu and set the z offset if the distance is not perfect, let the filament can stick on the hotbed well.

4. If you have a dual extruder printer, you need to print one filament roll dock by yourself, please find “***spoole_ZSD_V2x4.gcode***” file in SD card and print it out.

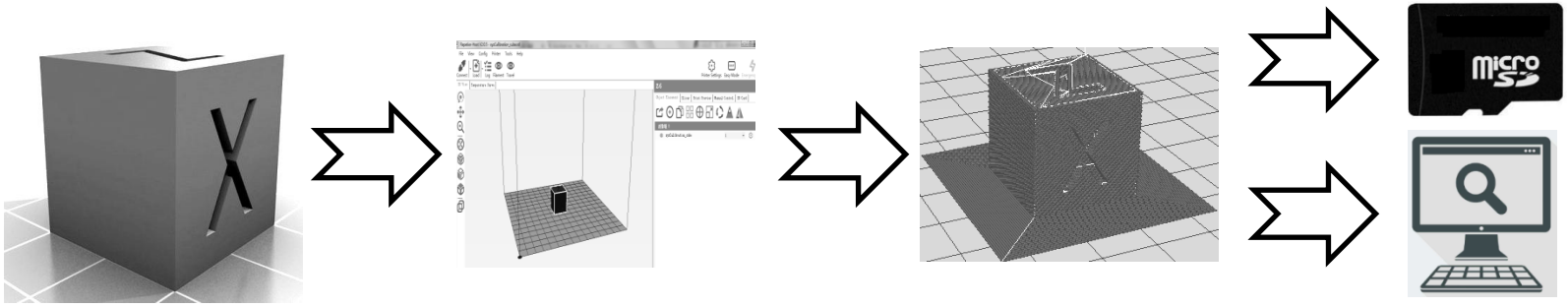




Insert SD card to control box and then start to print → **Adjust z offset if the filament can't stick to bed well** → **Wait for printing finish!**

Slicing, control and printing from PC HOST

1. *Before building a 3d object by using this 3D printer, you need to use a software to convert the 3D models (stl, obj, etc., depending on the type of slicing software) into a machine-recognizable file - **gcode file**. This process is called **"slicing"**.*



2. *Our recommended slicing and HOST software is **repetier-host**, which is a free software, you can also use any other software to slicing the 3d model as long as it can support reprap protocol, for example: Cura, slic3r, KISSlicer, pronterface, simplify3d etc.*

3. *For more about slicing, please refer to the document in the SD card, directory: **"PC Software & Driver\slicing & Host software"**. Y*ou can also download the latest document from our cloud disk:
https://drive.google.com/drive/folders/0B9Z1DbrxfqbpUjNHRXhBWmlVZVU
If you want to control the printer from PC HOST, we store the guide in SD card, please find it out and read it.

About ZONESTAR

ZONESTAR Innovation Technology Co., Ltd. is a high-tech manufacturer specializing in the development and production of 3D printers.

Since began to develop and manufacture 3D printers in 2013, we have successively introduced several series of products such as P802, P805, Z5, Z6, Z8, Z9, and Z10, which are popular with customers all over the world. Now, ZONESTAR has Gradually grew to be a leader in the category of DIY 3D printers.

At the same time, we are committed to applying 3D printing technology to a wider range of fields and have successfully developed 3D printers for use in food, advertising, ceramics, and other fields.

ZONESTAR has always regarded ***Innovation***, ***Quality*** and ***Service*** as our core value of the company and strived to provide customers with high-quality and high-tech products and excellent services.

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