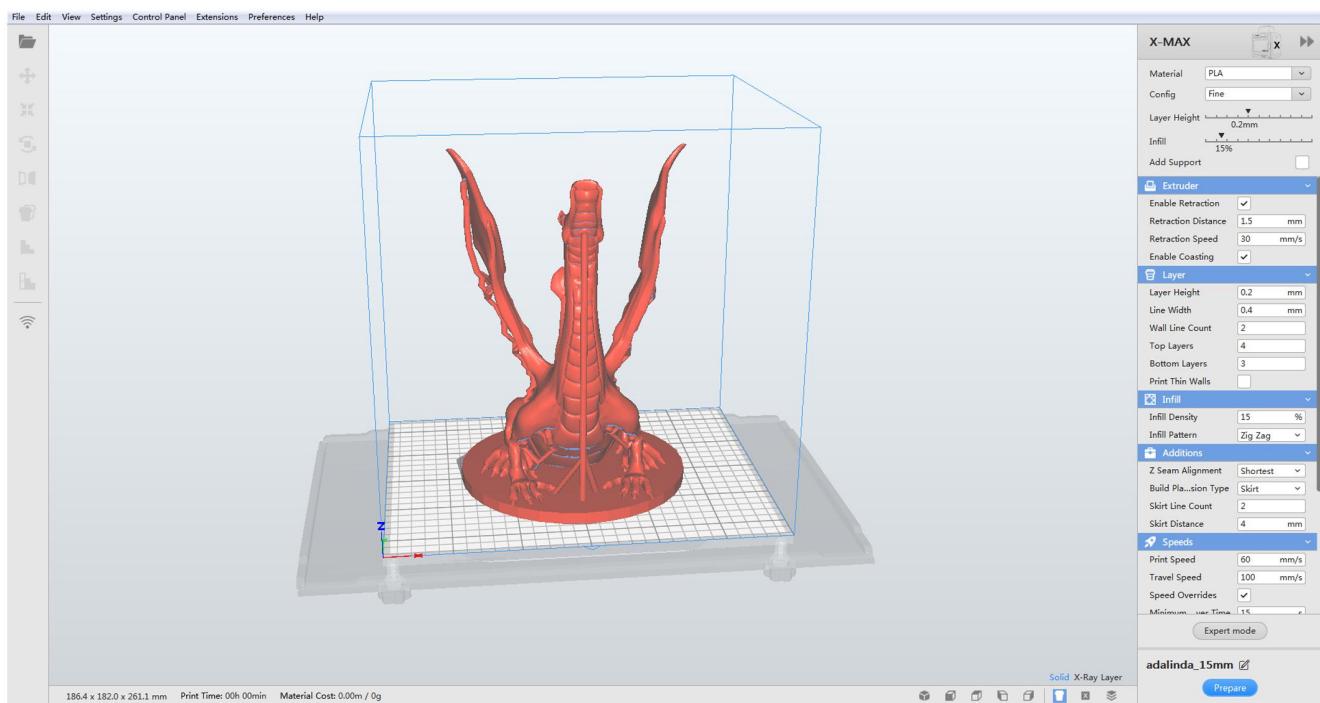


# X-MAX

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## Slicer operation process

**NOTICE: QidiPrint slicer does not support X-max printing via USB cable,support ethernet connection printing.**



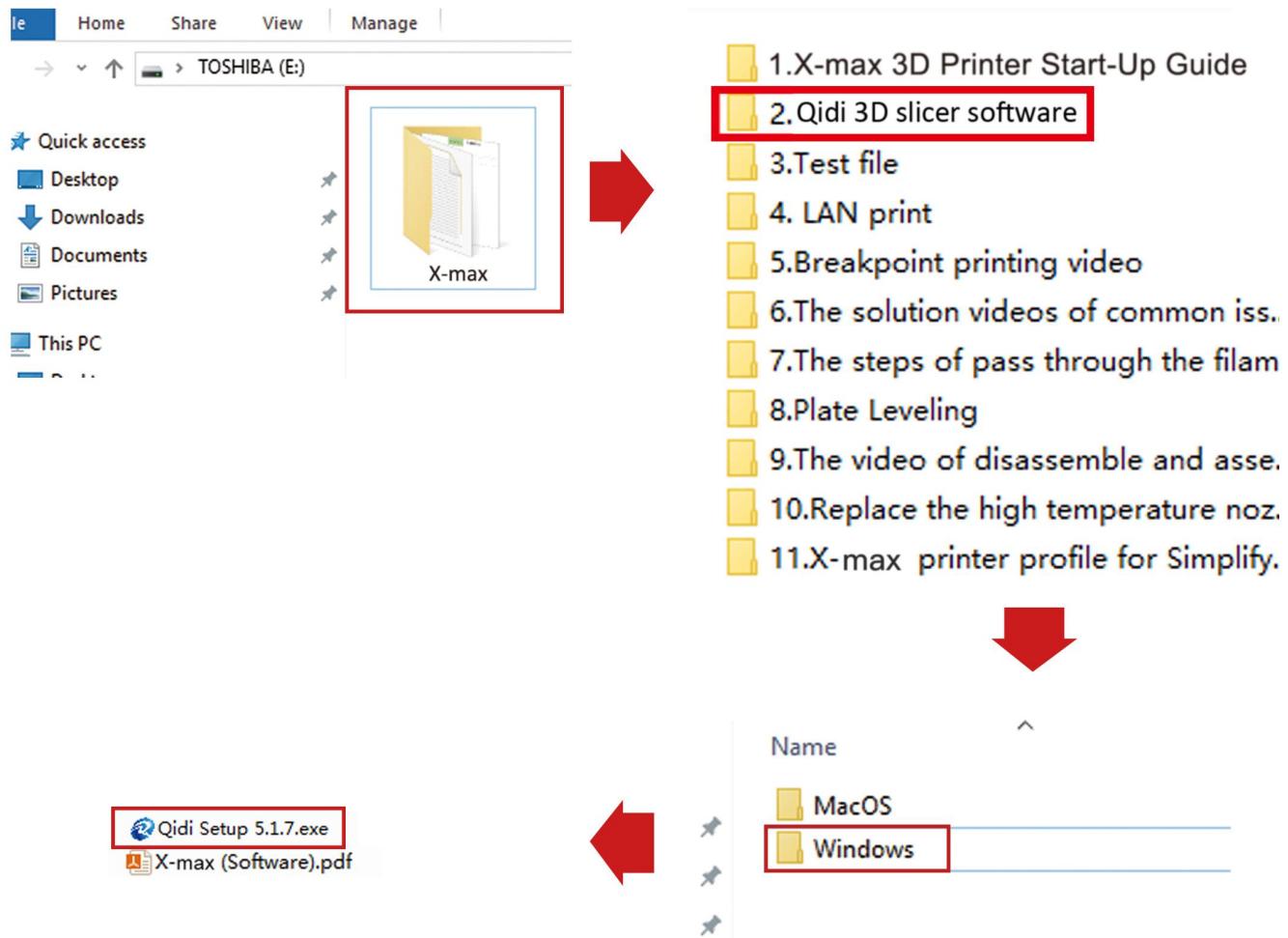
# For Windows users

## Slicer install

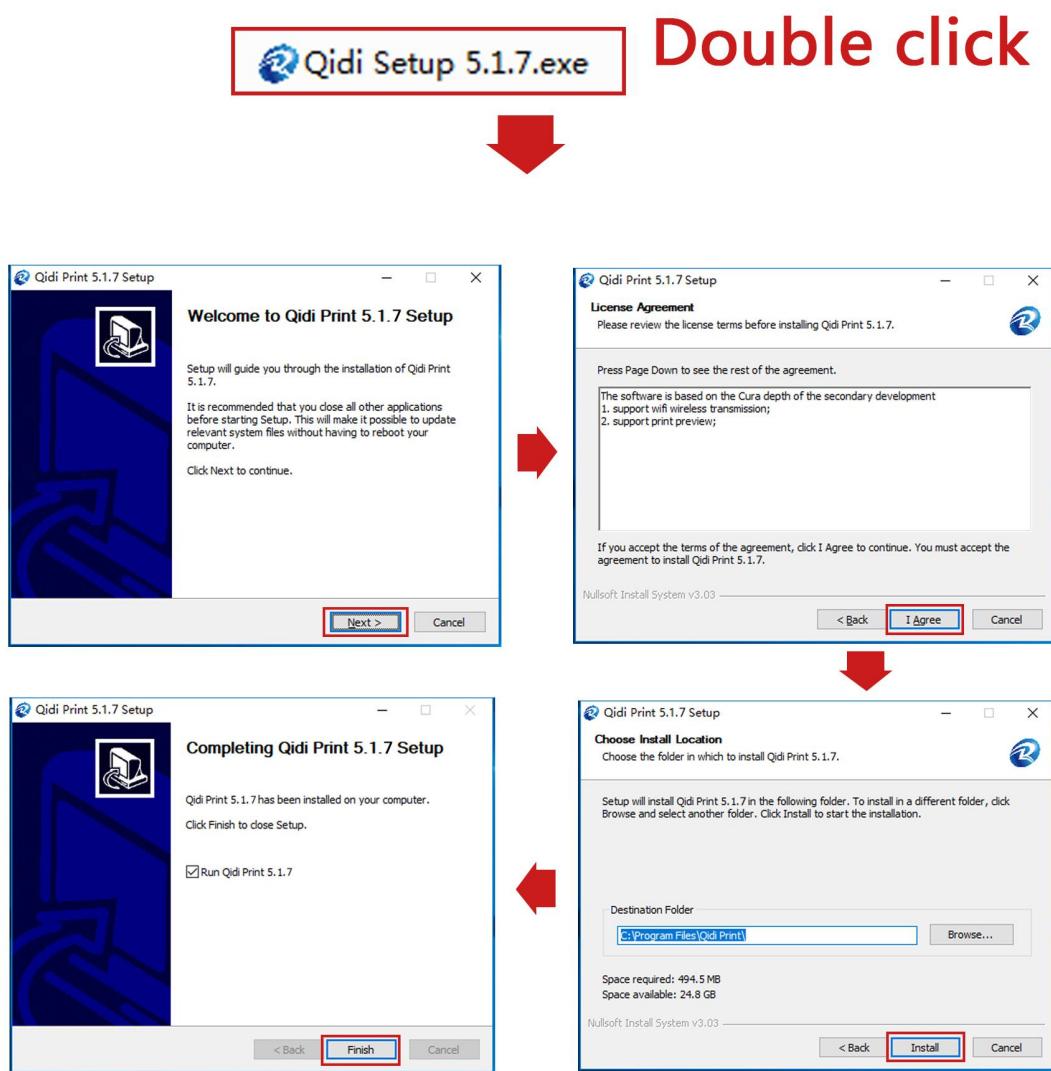
- ① Insert the USB flash drive into the computer.



② Create a new folder on the computer desktop, copy the USB flash drive software to the new folder.



③ Double click to run the installer, install the software as below pictures.



Please click on the desktop shortcut to open the slicer.

Choose the printer type “ X-max ”.



Double click



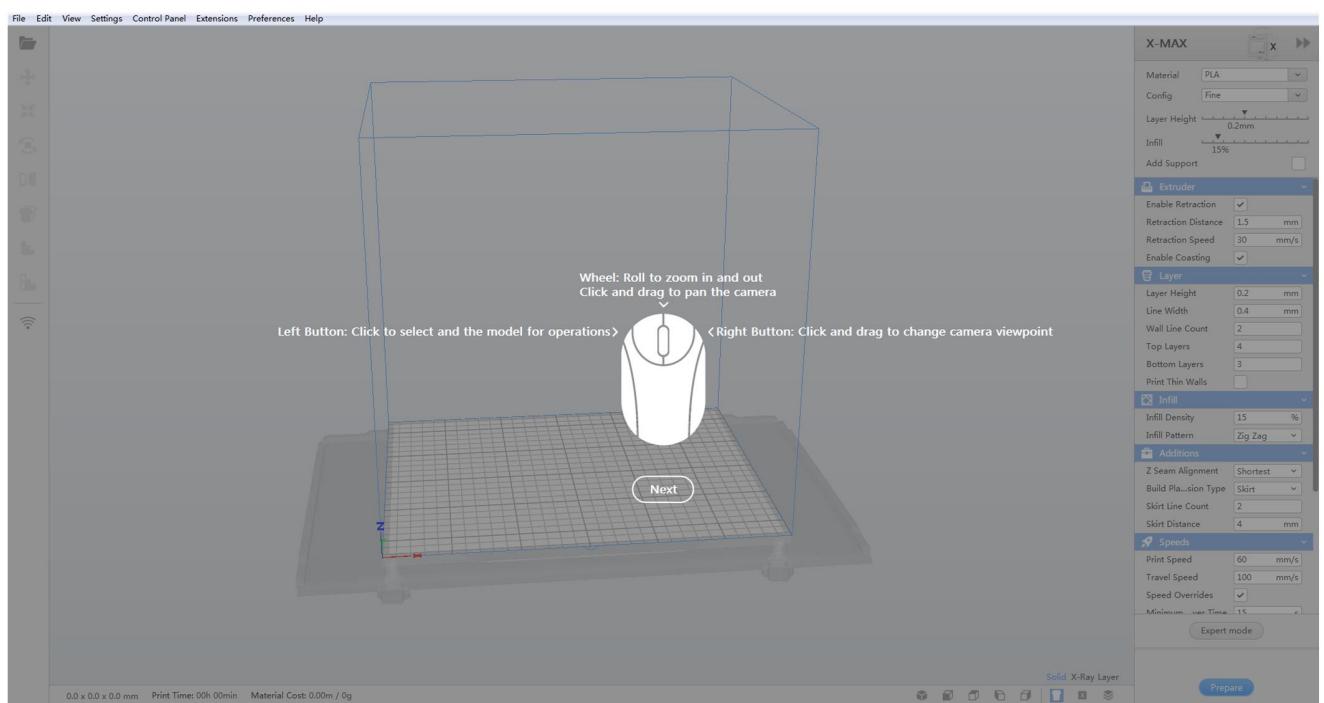
# (A) Introduction of Mouse Function

Left Button: Click to select and the model for operations.

Wheel: Roll to zoom in and out

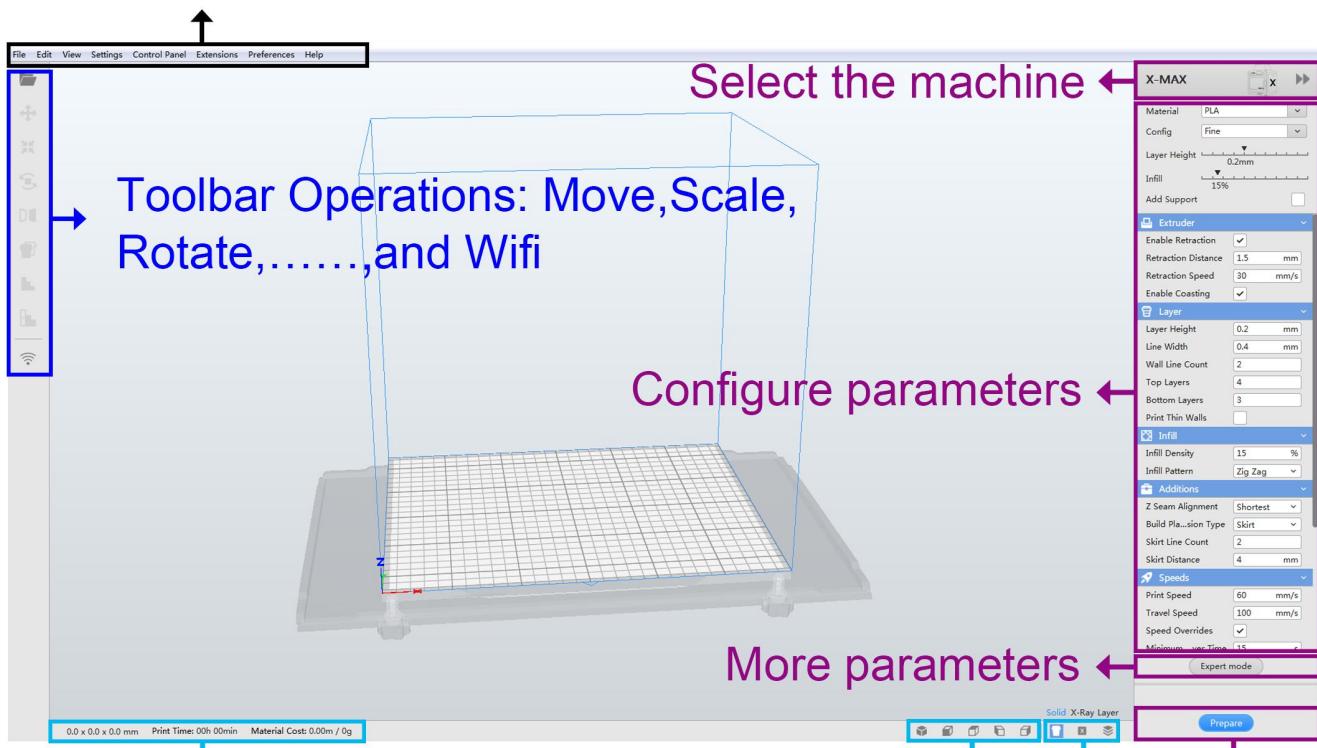
Click and drag to pan the camera.

Right Button: Click and drag to change camera viewpoint.



## ( B ) Icon function introduction

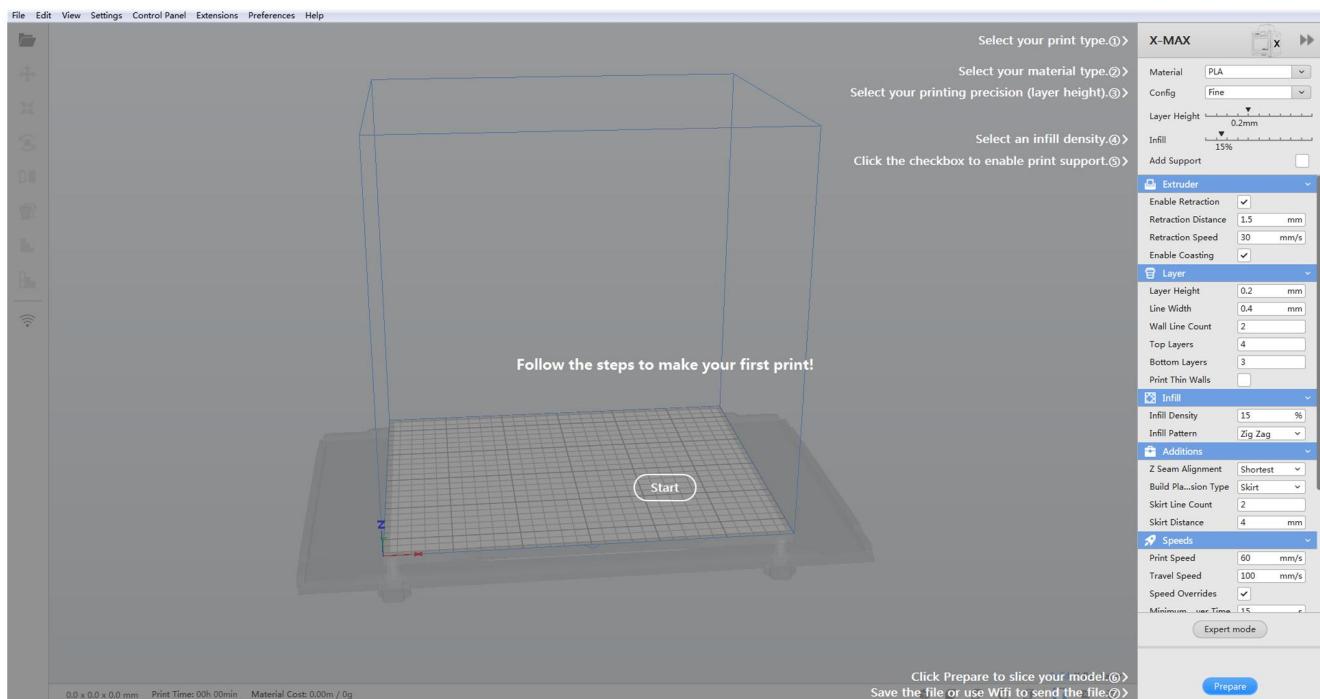
Menubar: Includes Control Panel, Configure Qidi,First Run Wizard, Factory setting.....



After importing the model and adjusting the parameters, click on this button to slice

## ( C ) First print

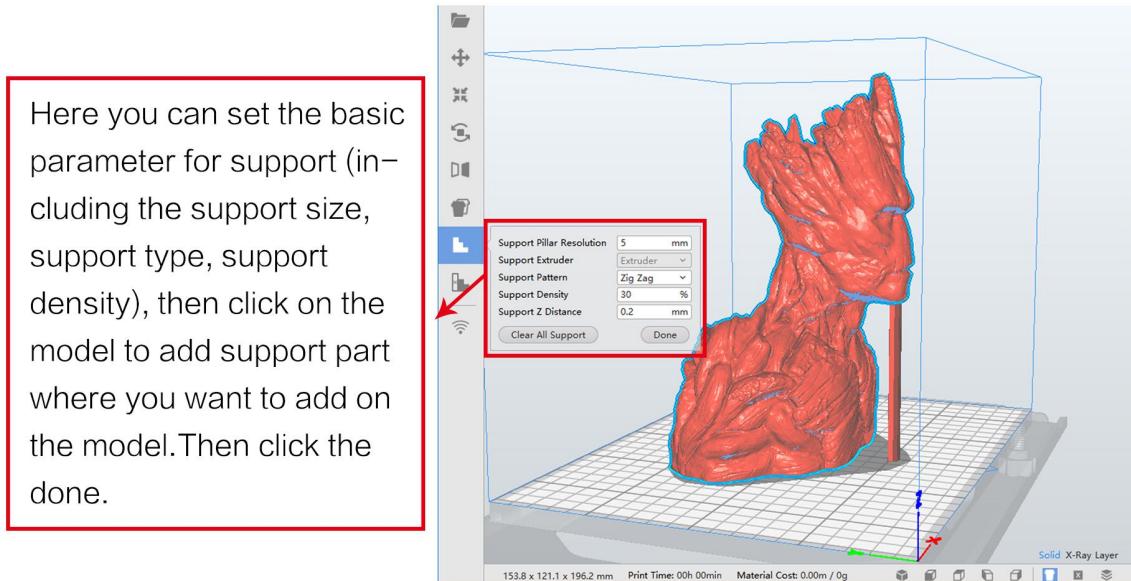
- ① Select your print type.
- ② Select your material type.
- ③ Select your printing precision(layer height).
- ④ Select an infill density.
- ⑤ Click the checkbox to enable print support.
- ⑥ Click prepare to slice your model.
- ⑦ Save the file use Wifi to send the file.



# ( D ) Addition Feature Instruction

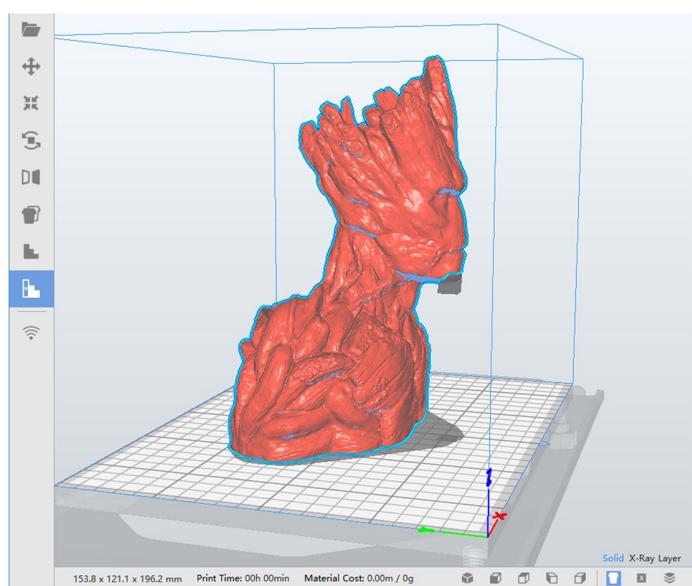
## 1. Adding the support manually

The operation of adding the support manually. First, please click the model, and add support tools manually in the toolbar on the right side of the main interface  .



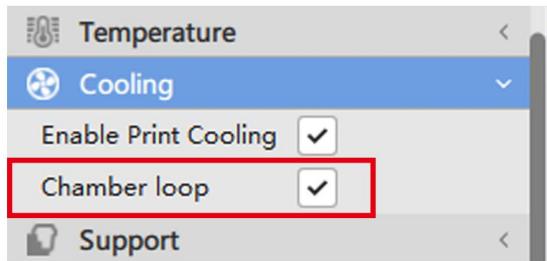
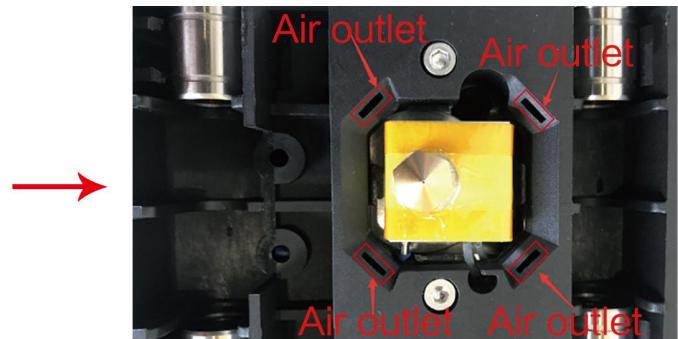
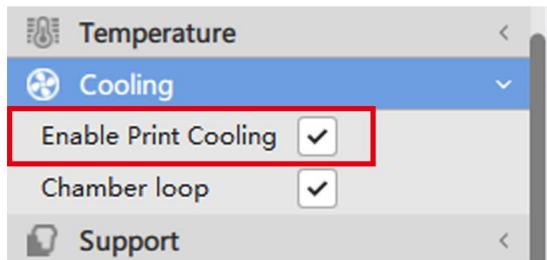
## 2. Support Blocker

Click the model then click the support blocker  ,click on the part of the model that does not need the support, and the support will not be automatically added to this part.

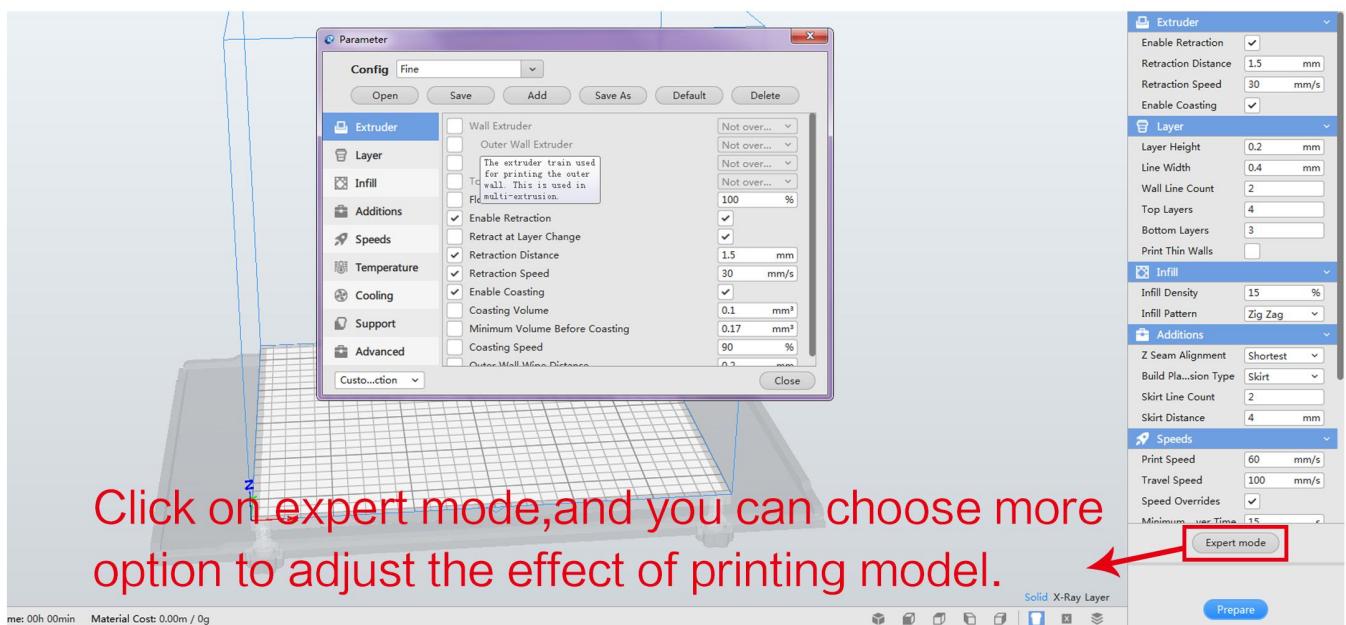


# ( D ) Addition Feature Instruction

## 3. The function of the fan



## 4. Expert mode

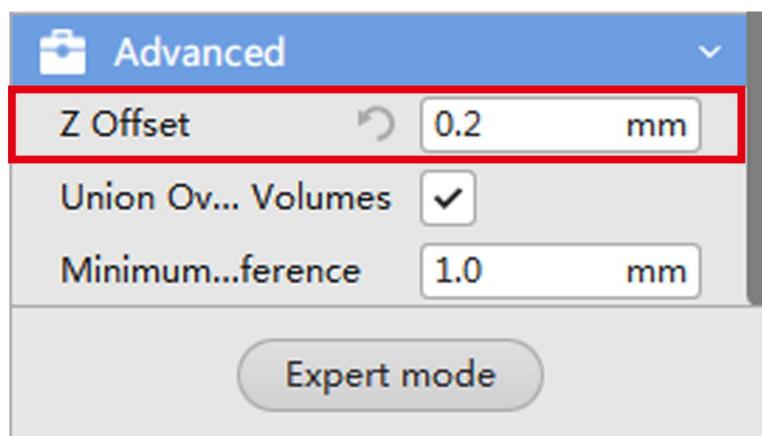


Click on expert mode, and you can choose more option to adjust the effect of printing model.

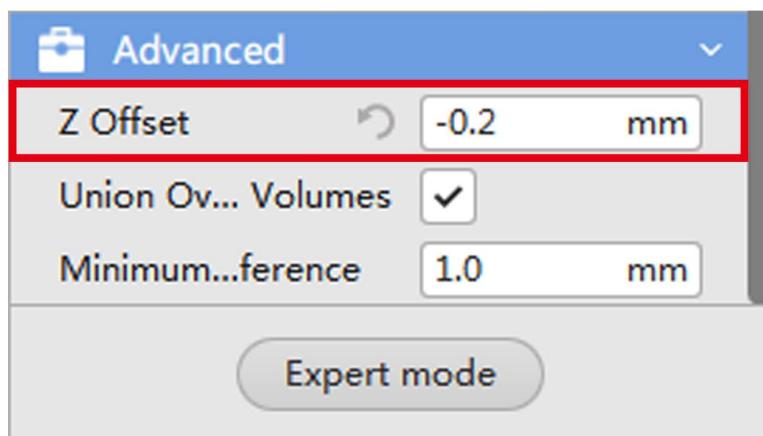
# ( D ) Addition Feature Instruction

## 5. Z-axis shifting

- a. Increase the distance between the nozzle and build bed to 0.2 on the first layer.



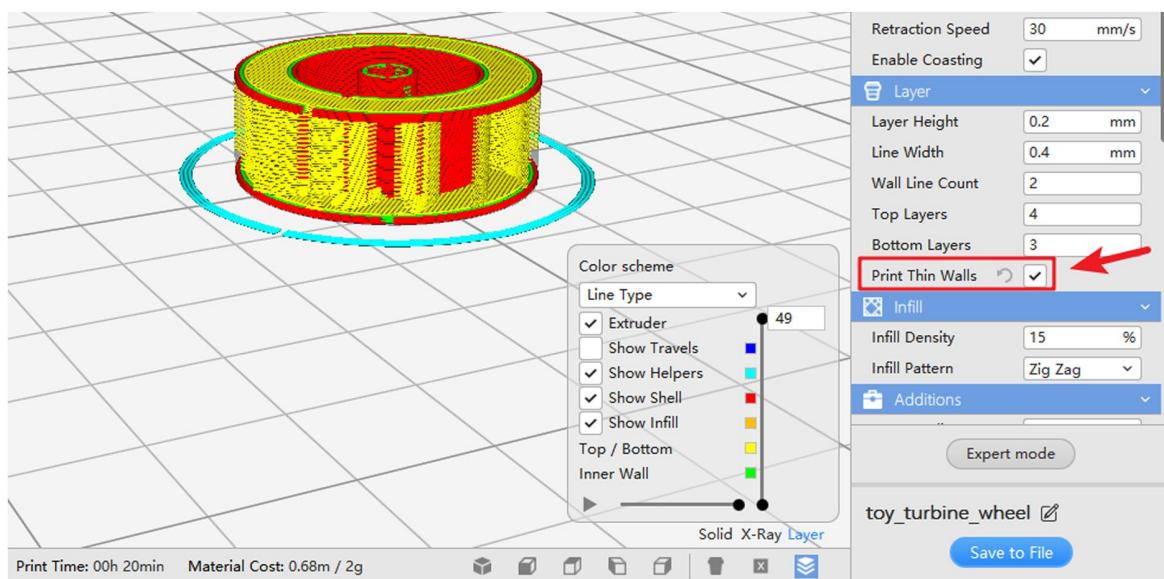
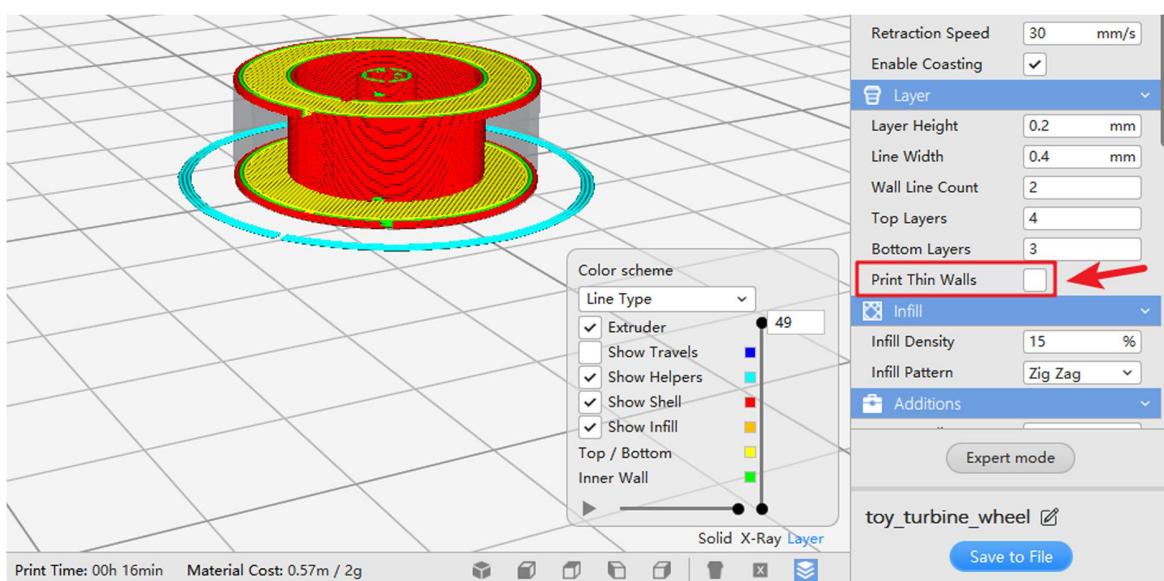
- b. Decrease the distance between the nozzle and build bed to 0.2 on the first layer.



# ( D ) Addition Feature Instruction

## 6. Print thin wall

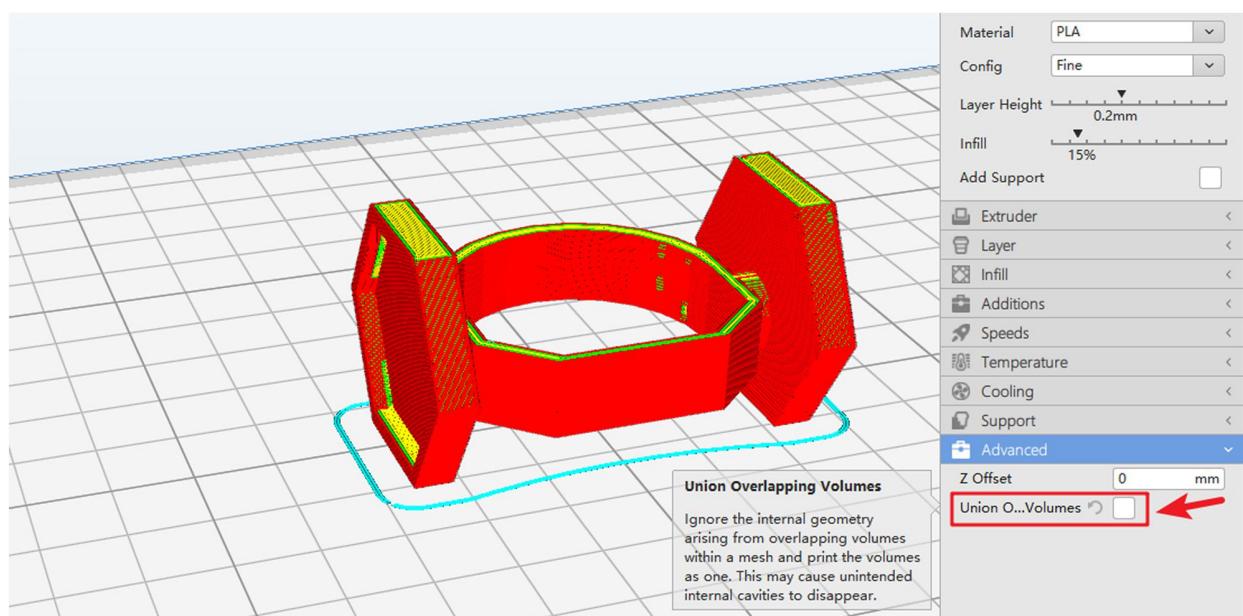
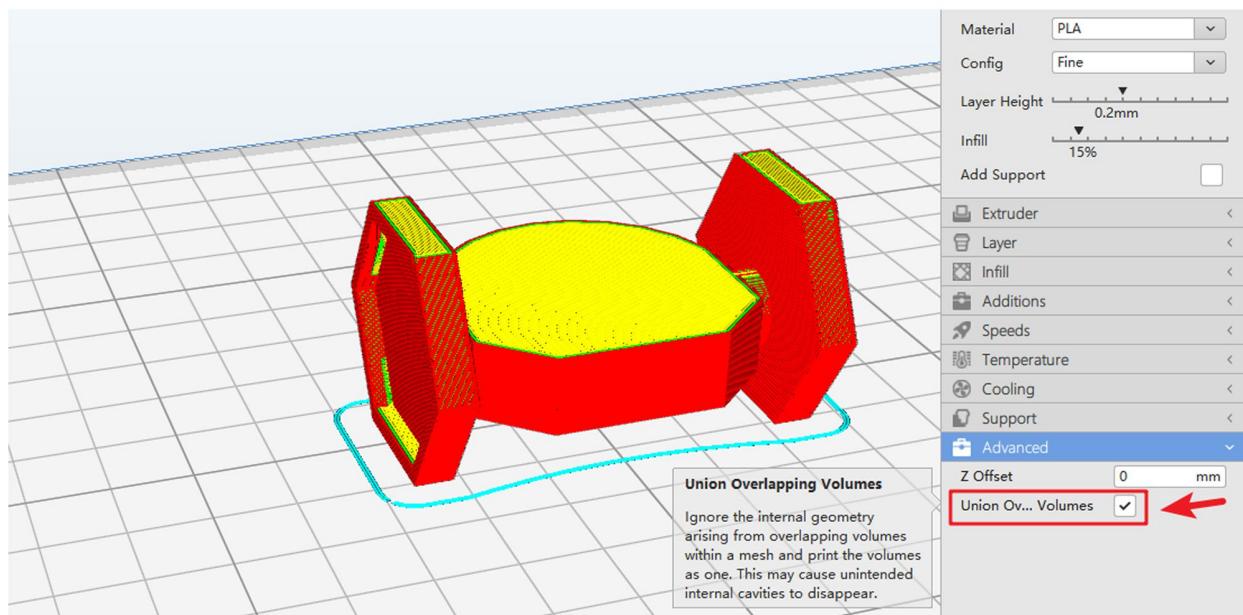
We need to use this feature when the model is thinner than 0.4mm.



# ( D ) Addition Feature Instruction

## 7. Union overlapping volumes

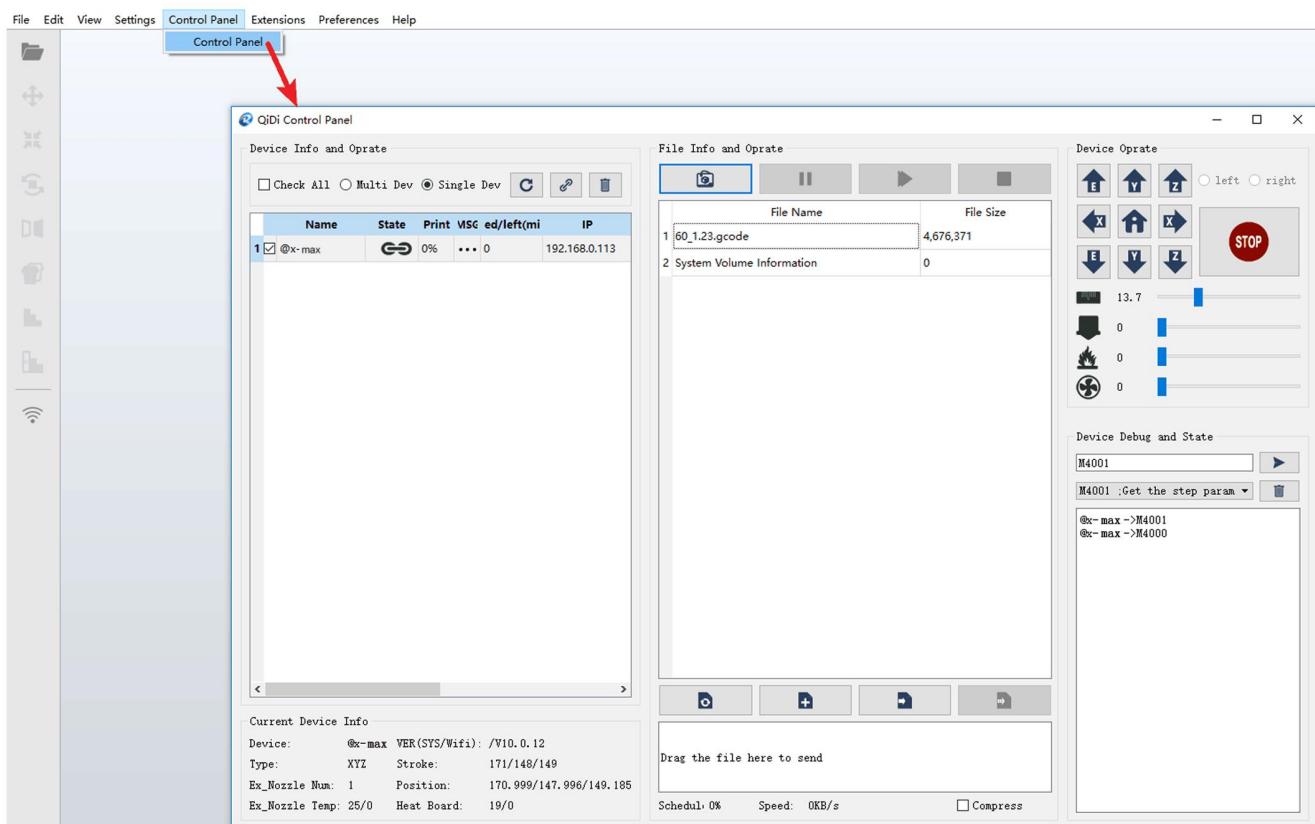
Some models are actually hollow inside, but they will be solid when printed out, so you need to cancel this setting manually.



# ( D ) Addition Feature Instruction

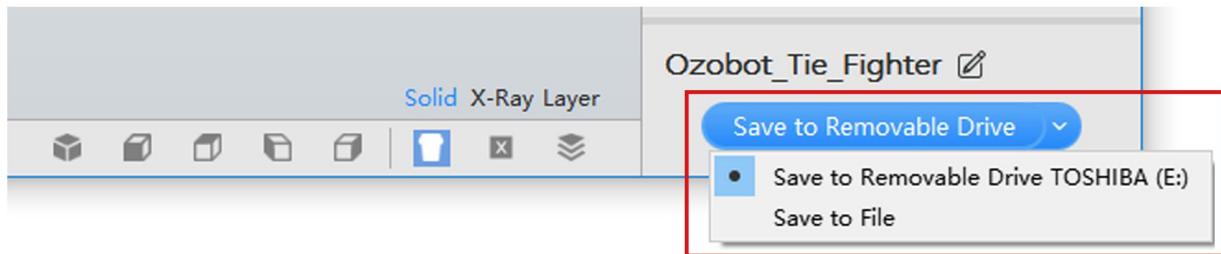
## 8. Control Panel

You can remotely control the printer and view the current status of the printer.

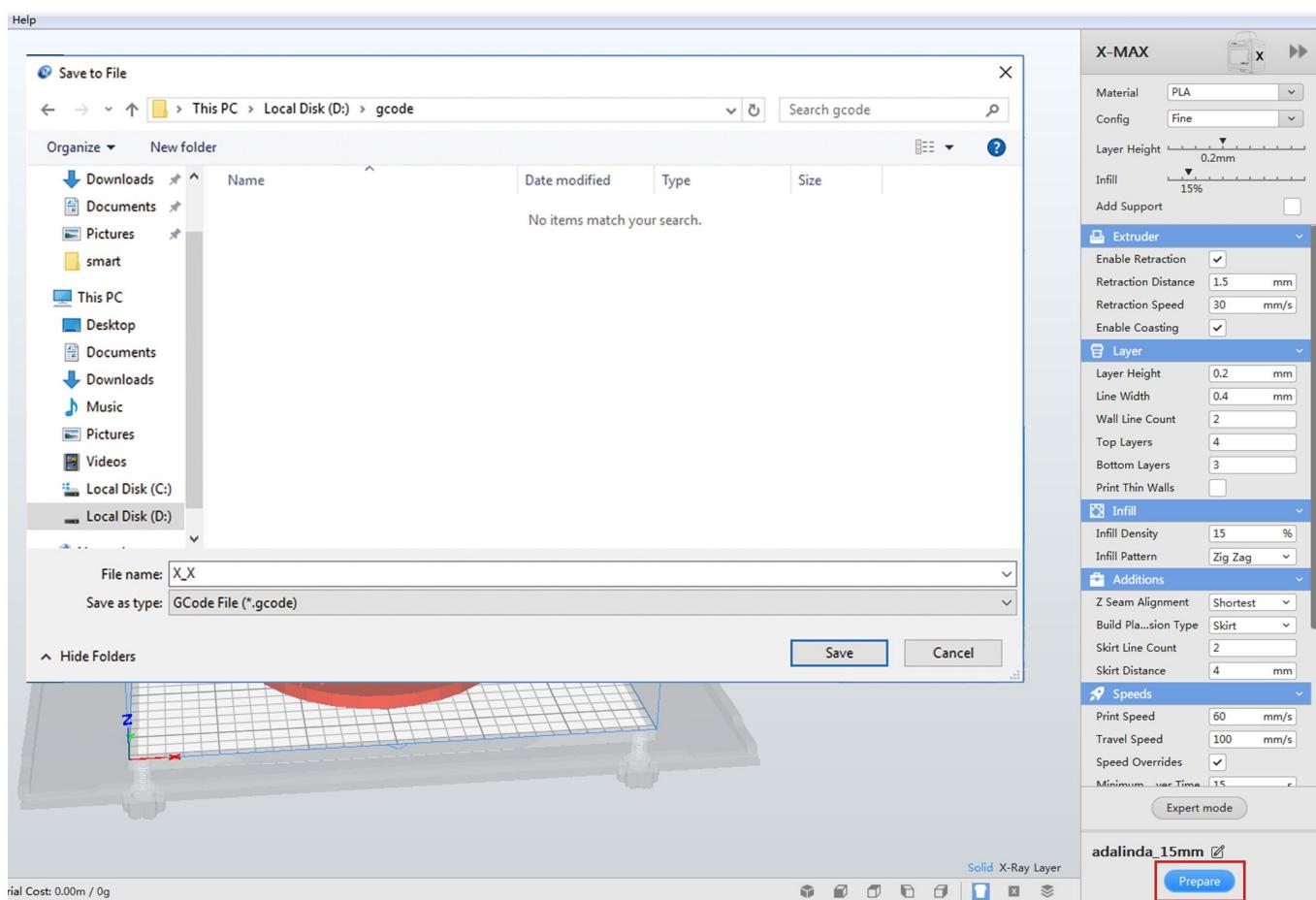


# Save the g-code file

Method 1: When the USB flash drive is inserted into the computer, the g-code file can be save to the USB flash drive or the computer.

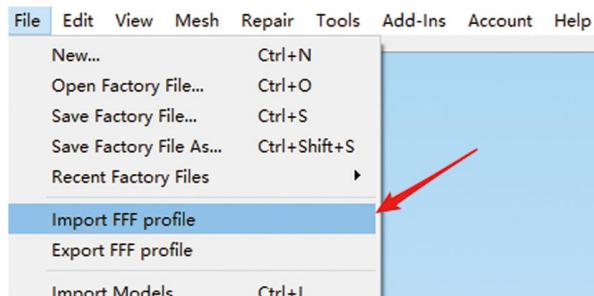


Method 2 : When the USB flash drive isn't inserted into the computer, the g-code file can be saved to the computer.



# Adding printer profile for simplify 3D

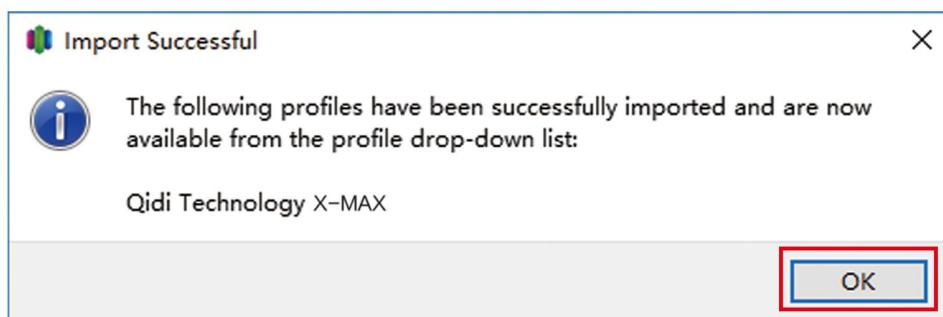
1. Open Simplify3D, select “import FFF profile” in the File section.



2. Import the X-max printer profile for Simplify 3D from the USB flash drive that we provided.



3. The message pops up when import successful.



4. Open the FFF setting, choose “Qidi Technology X-max” that we just added in the select profile section.

