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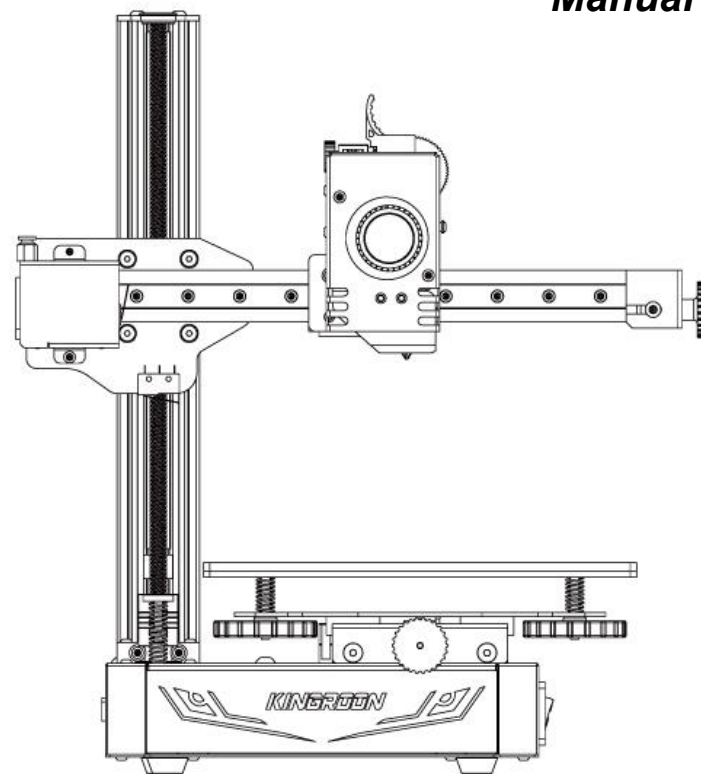
Bantian Street, Longgang District, Shenzhen

Facebook/YouTube: KingRoon 3D Printer

KINGROON

KP3S PRO S1-FDM 3D Printer

Manual



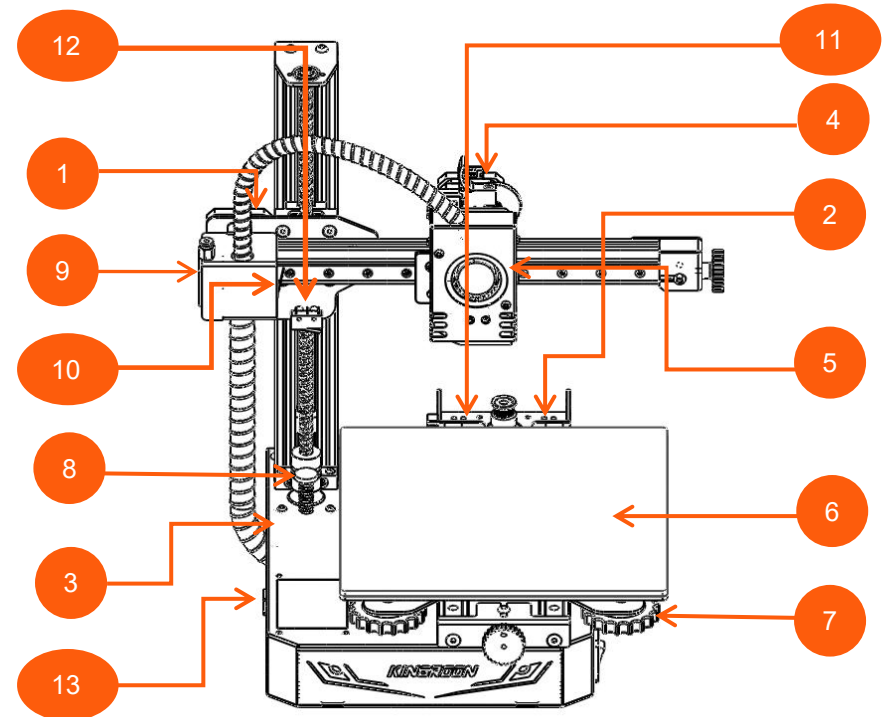
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Notes:

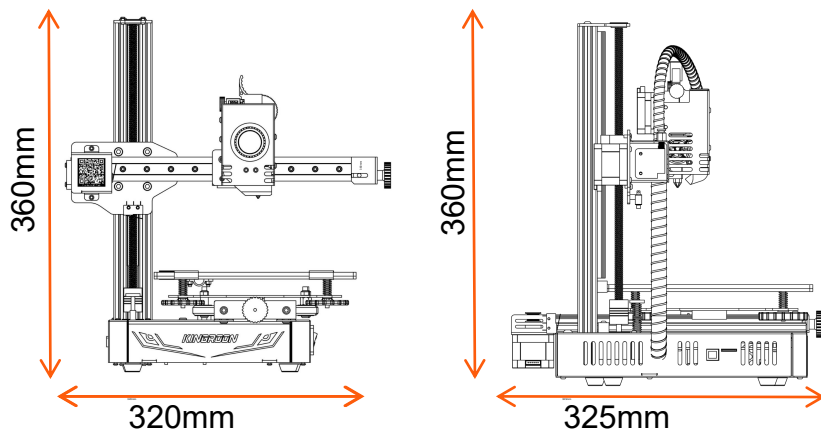
In order to use the product correctly, please read the manual completely

1. Diagram



1. X-axis motor	8. Z-axis Limit
2. Y-axis Motor	9. Filament Sensor
3. Z-axis Motor	10. X-axis Limit Switch
4. E-axis Motor	11. Y-axis Limit Switch
5. Extruder	12. Z-axis Limit Switch
6. Hot Bed	13. USB Port
7. Leveling Knob	14. TF Card Port

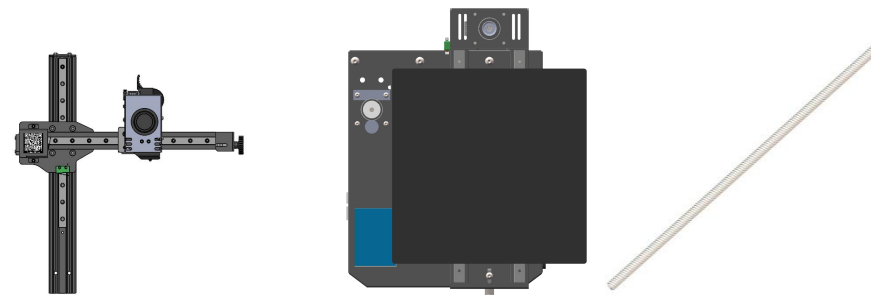
2. Parameters



Model Number	KP3S Pro S1
Technology	FDM
Nozzle Quantity	1
Nozzle Diameter	0.4mm
Print resolution	0.05-0.3mm
Filament Diameter	1.75mm
Applicable Filament	PLA/WOOD/TPU
Max Nozzle Temp	≤260 °C
Max Bed Temp	≤100 °C
Max Axis Speed	≤200mm/s
Print Speed	≤100mm/s
Proposal Speed	20mm-60mm/s
Print Via	USB/TF Card
Compatible File Format	STL/Obj/Gcode

Compatible O.S.	Win7-10/Mac/Linux
Slicer	Cura/Slice/Host...
Language	CN/DE/EN/RU/JP/FR/IT
Rated Power	200W
Rated voltage	110V-220V
Power Supply	24V12.5A 300W
Filament Sensor	Yes
Auto Leveling	Upgradeable 3D Touch
Resume Printing	Yes
Net Weight	6kg
Machine Size	320*325*360mm
Build Volume	200*200*200mm

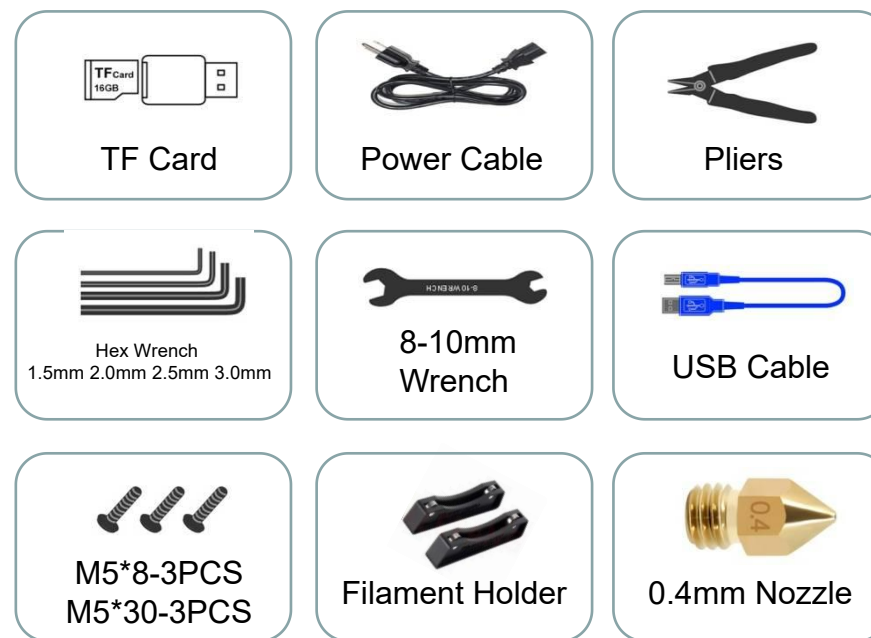
3. Packing List



Cantilever

Base

T8 Leadscrew



TF Card

Power Cable

Pliers

Hex Wrench
1.5mm 2.0mm 2.5mm 3.0mm

8-10mm
Wrench

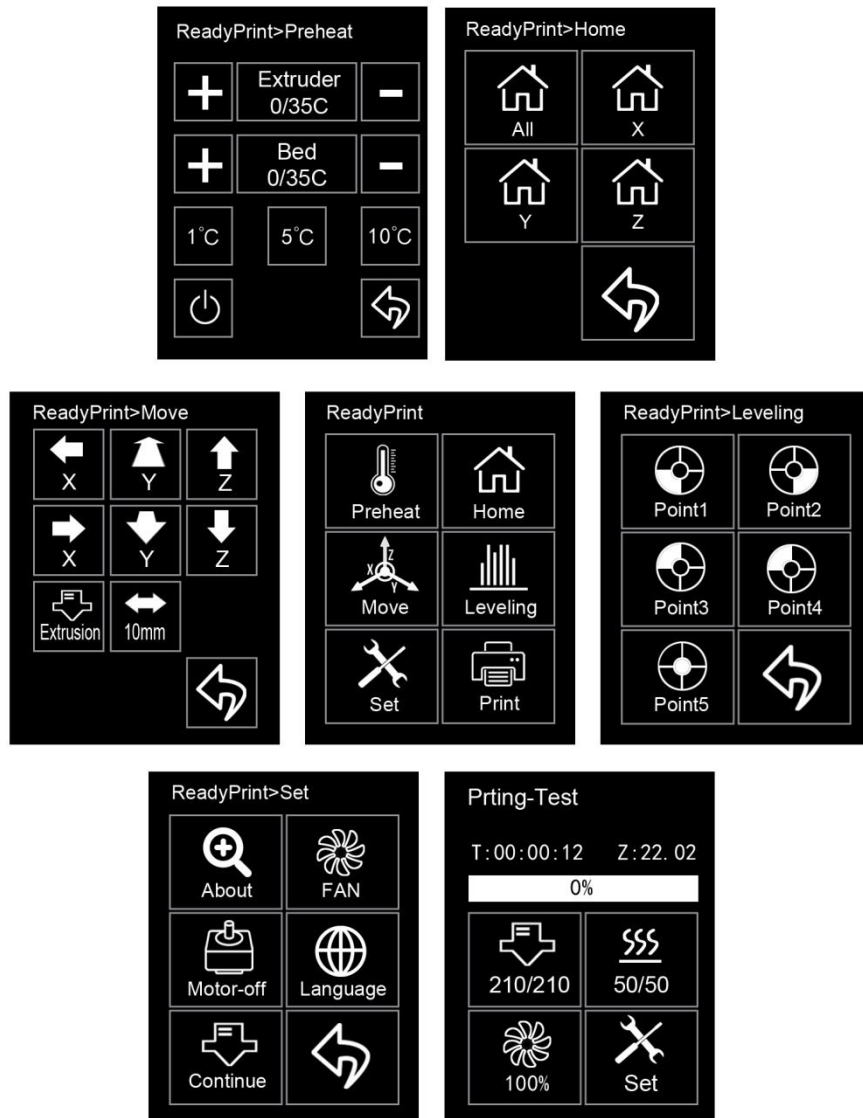
USB Cable

M5*8-3PCS
M5*30-3PCS

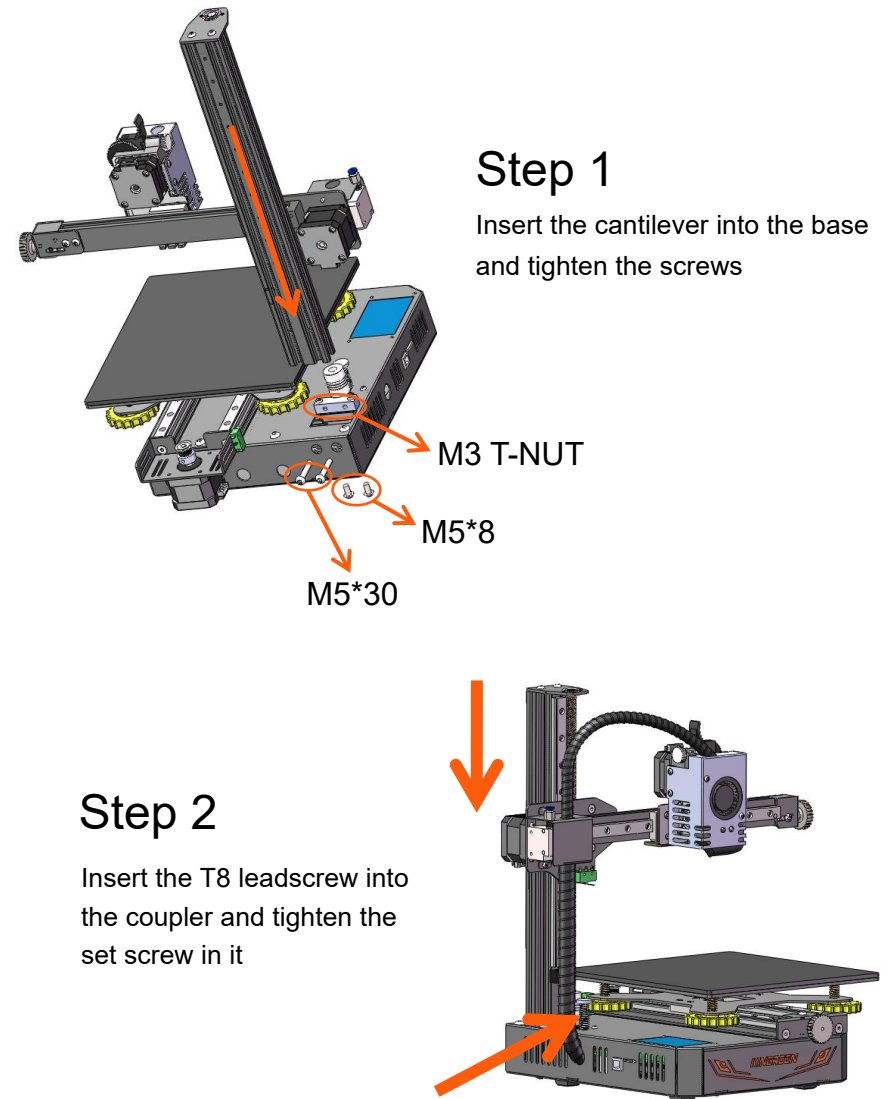
Filament Holder

0.4mm Nozzle

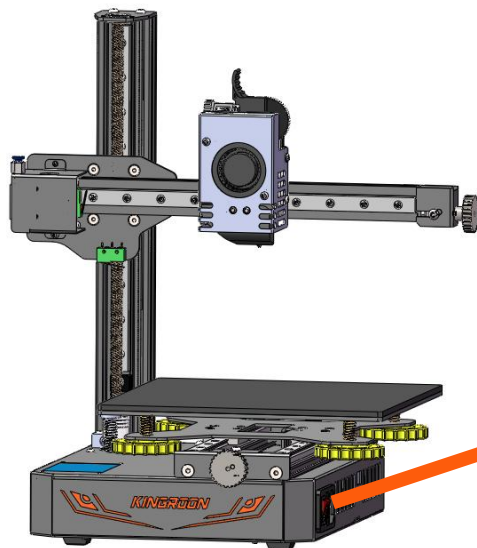
4. Operation Interface



5. Installation

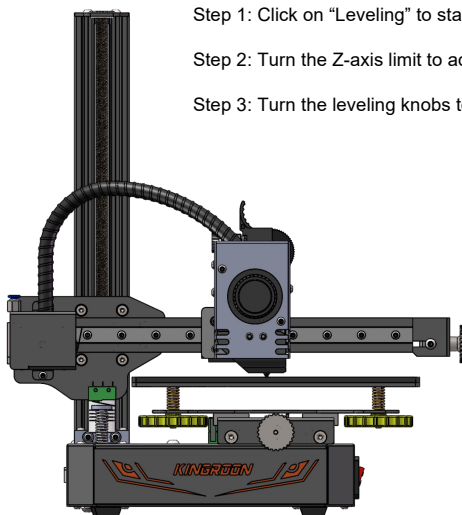


6. Bed Leveling / Add Filament



Power supply and press
1 to turn on the printer

110V-230V



Step 1: Click on "Leveling" to start bed leveling

Step 2: Turn the Z-axis limit to adjust the lowest position of the nozzle

Step 3: Turn the leveling knobs to adjust the distance between the nozzle and the hotbed

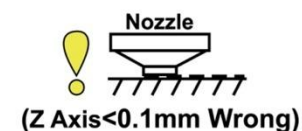
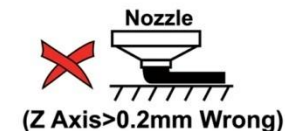
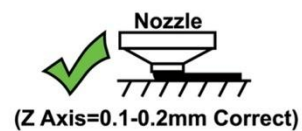


The appropriate distance between the nozzle and hot bed is in between 0.1mm to 0.2mm, which is similar to the thickness of an A4 Paper (can be used for leveling).

6. Bed Leveling / Add Filament

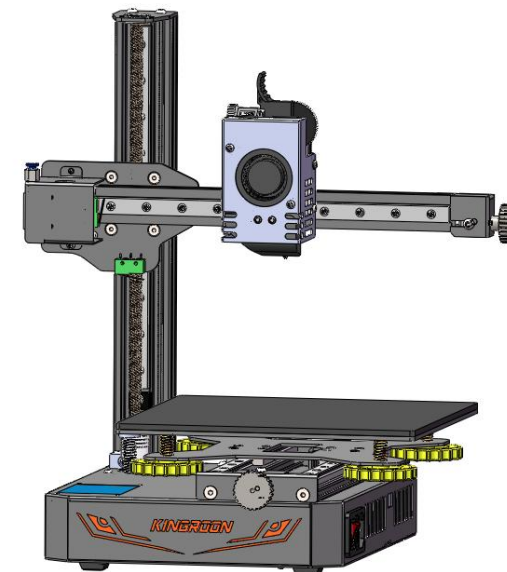
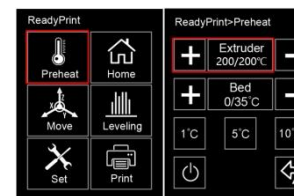


1. If the distance is 0.1mm or even less, poor filament extrusion or blocked nozzle will happen;
2. If the distance is more than 0.2mm, filament won't stick to the bed;
3. If the distance is in between 0.1 to 0.2mm, the print will be perfect.



Add filament:

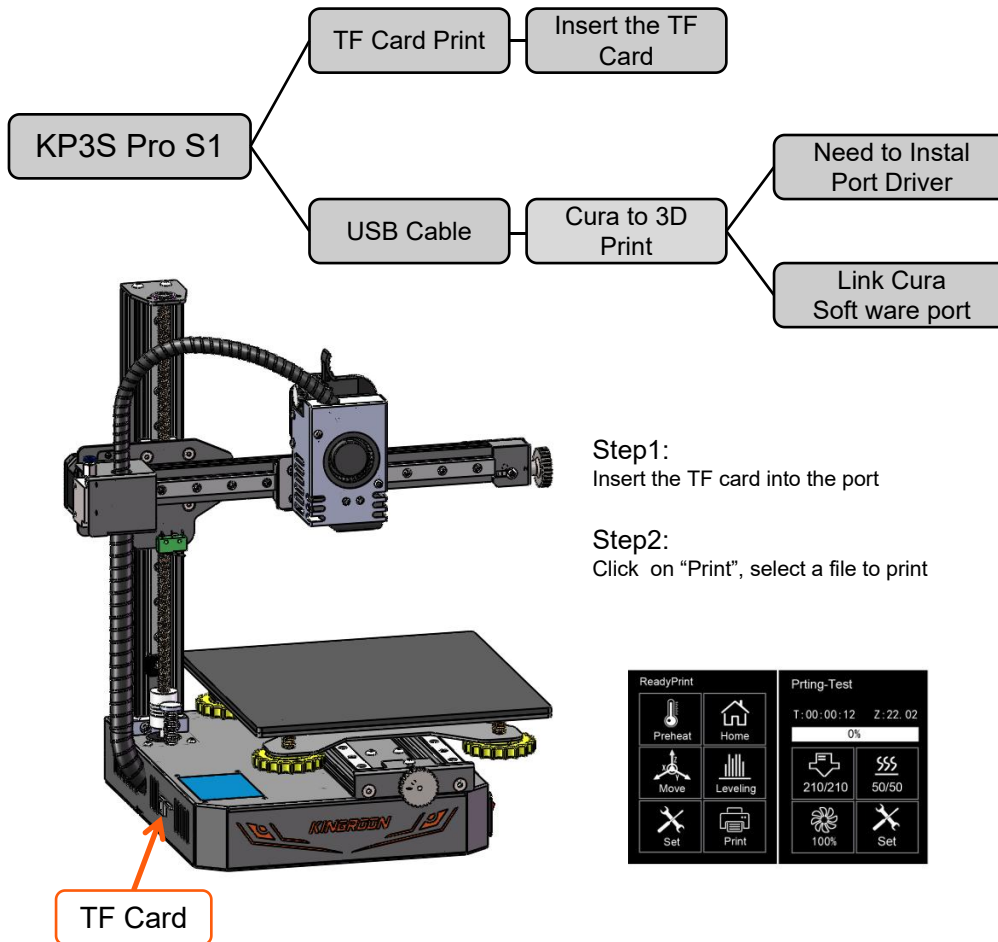
1. Click on "Preheat"
2. Click on "+" to increase the "Extruder" temperature in between 180-200°C
3. Press and hold the extruder handle
4. Insert the filament into the extruder until it extrudes out from the nozzle



7. Print via TF Card or PC

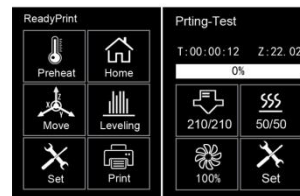
Printing method: online printing and TF card printing

- 1、Online printing: connect computer to KP3S Pro via USB cable and run the chip software such as Cura, which is used to control printing. However, it is easy to be interfered and interrupted via USB cable, so online printing is not recommended.
- 2、TF card printing: After leveling, insert the TF card into the printer and select the file to print by touching the LCD screen.



Step1:
Insert the TF card into the port

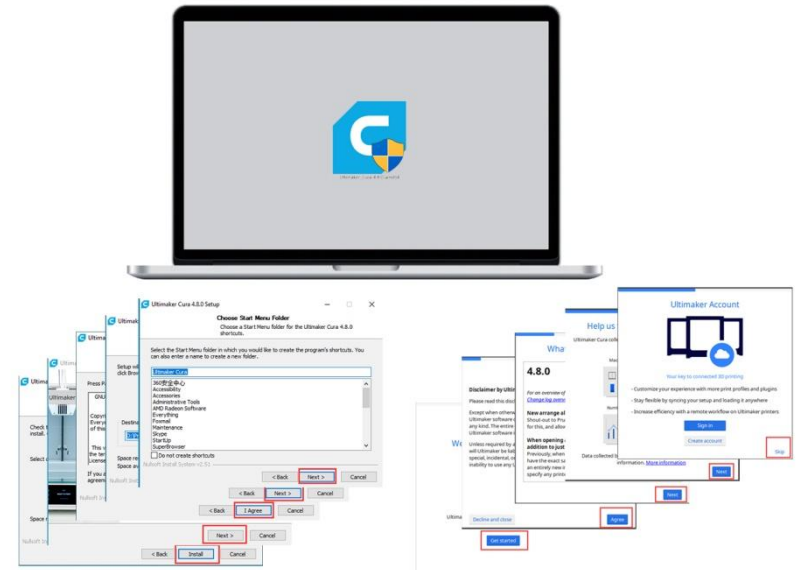
Step2:
Click on "Print", select a file to print



8. Cura Installation

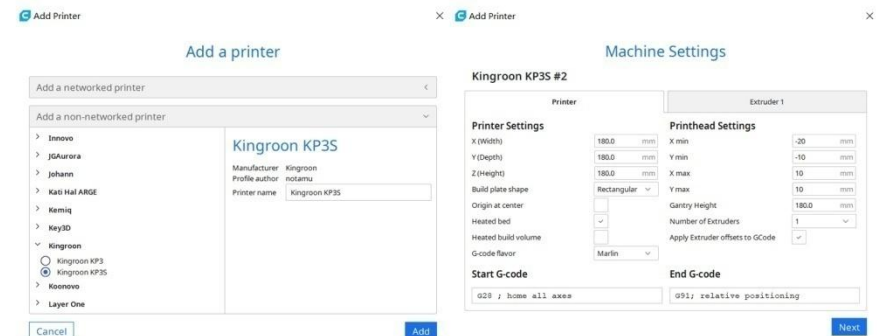
Step 1: Install Cura on your PC

Click on "Ultimaker Cura ***.exe" in the TF card and install it according to below procedures



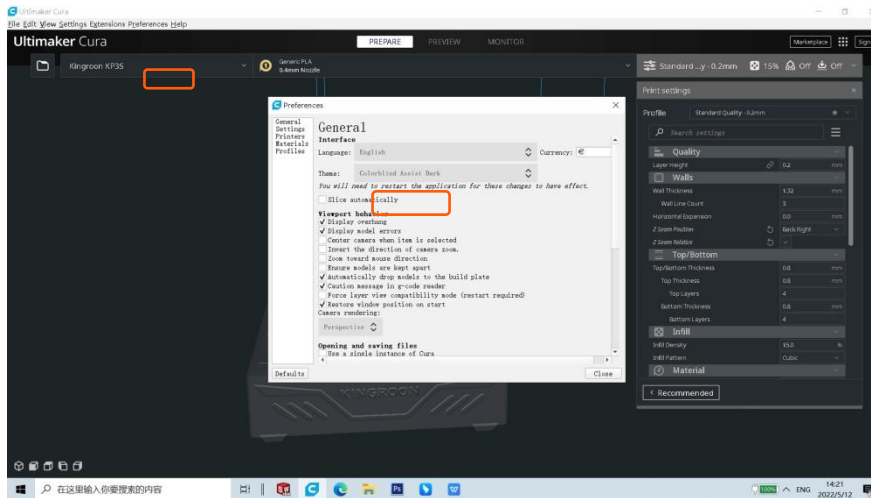
Step 2: Add your printer to Cura

Start Cura – Click on "Settings" – "Printer" – "Add Printer" – "Add a networked printer" – select "Kingroon" – "KP3S" on the dropdown menu

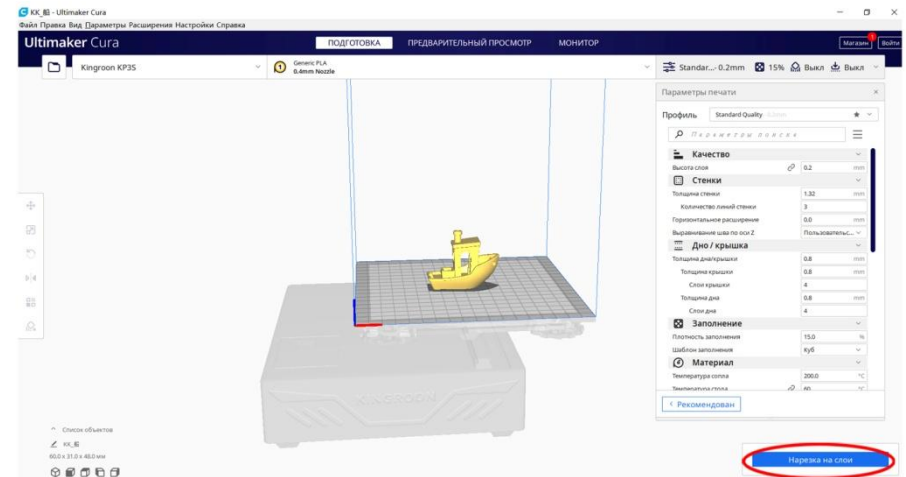


9.Slice Settings

Select the language you want and then exit and restart Cura.



9.Slice Settings



Kingroon has already configured appropriate parameters for printing on this printer, you can directly click on “Slice” and save the Gcode file to the TF card.

If you're having some problem with changed settings, please contact our after-sales service, we will help you out ASAP.

Also welcome to join Kingroon discussion group on Facebook.

FAQ

>An error occurred on the screen:

Err1: hot bed MAXTEMP; Err2: nozzle MAXTEMP;

Err3: hot bed MINITEMP; Err4: nozzle MINITEMP;

Err5: Nozzle heating failure; Err6: Hot bed heating failure;

Err7: Thermal Runaway;

Check the nozzle temperature or hot bed temperature by tapping "Preheat" button. A negative number indicates that the thermistor is in poor contact or damaged.

>Layers are misaligned and shift relative to one another

a) Loose XY timing belt will cause the model to shift, tighten the timing belt and fix it as well.

>Extrusion stuck without discharging:

a) Heat up the nozzle, then remove the material remained in nozzle. Use a 1.5# wrench to clean the nozzle, or replace it with a new one.

>3D printing model warping:

a) Set different temperatures according to different filament, check the software settings for details.

b) The distance between nozzle and platform is large, please re-leveling.

Check out the leveling method for details.

c) The printing speed of first layer is too fast, 20mm/s for first layer printing speed is highly recommended.

Note: Each 3D printer has been tested before leaving the factory. If there is a little filament remaining in the nozzle or a slight scratch on the printing platform, it is normal and it will not affect the performance.

Safe Working Environment

The KINGROON 3D Printer should be equipped with an original transformer or power supply. Otherwise, the machine could be damaged or even cause a fire. Always place the printer on a stable base where it cannot fall or tip over. Please ensure the printer is far away from flammable gas, liquid and dust while it is being operated. (The high temperature generated by the operation of the printer may react with the dust, liquid or flammable gases in the air, which may cause a fire.) The ambient temperature recommended for using the printer is 10 C-30 C, and the humidity 20%-70%. Using the printer outside these ranges may cause poor printing results. Please never expose the printer to moisture or heat. Never use the printer during an electrical storm. The printer is for indoor-use only. If you are not using the printer for a long time, please turn off the printer and unplug the power cord.

Safety Manual

1. When the printer is working, DO NOT TOUCH the heat generating parts, NOT even with gloves, as the extreme heat can melt the gloves causing severe burns. WARNING: THE NOZZLE TIP CAN HEAT TO 260C AND THE PRINT BED CAN HEAT TO 100 C.
2. DO NOT TOUCH any working parts while printer is printing. The nozzle tip and other mechanical parts will run at high speed. Contact with any running parts may cause damage and injury.
3. When printing with PLA or Wood materials ensure the printer is in a well ventilated environment, due to the fumes released by the plastic materials.
4. NEVER allow children or untrained people to operate the printer.

Daily Maintenance

Please do dust removal maintenance and lubricate the printer every month. If you are not using the printer for a long time, please remove the filament and keep the storage environment dry, dust-free. The printer should place in a temperature-stable environment. The sudden drop in temperature can affect the printing quality. When the print nozzle is squeezing, please make sure there is enough space between the nozzle and the platform; otherwise the nozzle will be blocked.

1. Clean/Maintain the print platform, replace the tape if used.
2. Preheat the nozzle and extrude a small amount of filament.
3. While the nozzle is still hot, use a steel brush on it to clean any excess filament.
4. Preheat the print bed and level it.