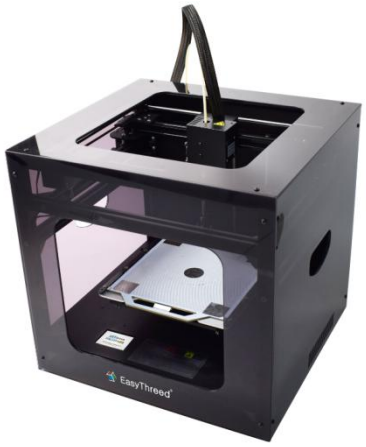
QUICK START GUIDE

VERSION 1.1



ELITE 3D PRINTER

EasyThreed®

Please read this User's Manual carefully before use.
Please keep this User's Manual properly for future reference.
Pictures are for reference only, subject to our available products.

Table of Contents

1 SAFETY INSTRUCTIONS

Before installing and using this machine, make sure to read the following contents. Please do not use this machine with the methods not described in this User's Manual.

1.1 Machine placement

- When moving the machine, pay attention to handle it gently to avoid touching the interior structure of the printer.
- This machine is suitable for placed in a ventilated, cool, dry and dustless environment.
- When using the printer, pay attention to the heat dissipation of its surrounding environment and avoid placing it on thick carpeting or close to wall.
- Please do not put the machine near explosives and high heat sources.
- Please do not put this machine in an unstable working environment or a working environment with large vibration.
- Please do not pile weights on this machine.

1.2 Specification for use of power supply

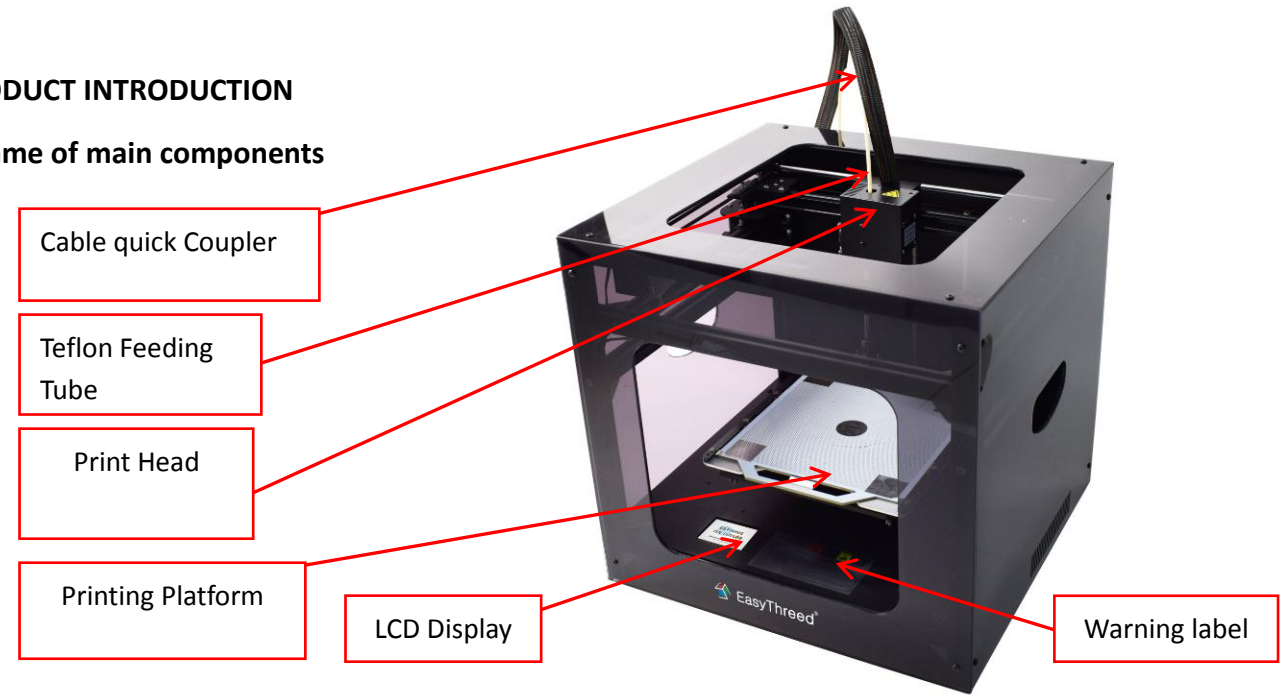
- Please use the power cord supplied with this machine.
- This machine applies to 110 - 240V power supply.
- Please do not plug and unplug the power connector with wet hands.
- Please make sure to insert the plug completely into the socket.
- Please do not deliberately pull and excessively bend the wire supplied with this machine to avoid open circuit or short circuit.

1.3 Instructions during printing

- Please do not operate this printer in the absence of personnel supervision.
- During the printing process and right after the printing process, please do not touch the interior structure and accessories of the printer to avoid scalding.
- If the printer discharges smoke when printing, please turn off power switch immediately to stop printing and contact the support service.

2 PRODUCT INTRODUCTION

2.1 Name of main components



2.2 Basic Parameter

- **Print parameters**
  Working environment - Working temperature: 5 °C- 35°C, Relative humidity: 30%-90%

- **Electric parameters**
  Power input: 110-240V AC, 50/60Hz;
  Power output: 24V/DC, 8A
  Maximum power: 300W

Nozzle diameter	**0.4mm**	**Print material**	**PLA/ABS**
Extrusion temperature	180-240°C	Recommended print head temperature	PLA: 190-210°C ABS: 210-230°C
Bed temperature	0-120°C	Recommended bed temperature	PLA:50-70°C ABS:90-110°C
Print speed	10-60 mm/S	Layer thickness	0.05-0.2mm
Molding size	L190*D190*H180mm	Machine size	D440 x W420 x H420mm
Compatible systems	Windows	Connection	SD Card USB connection for printing
3D format supported	STL,OBJ	Slicing software	EASYWARE, CURA
Machine recognition format	gcode	Net weight of the product	20Kg

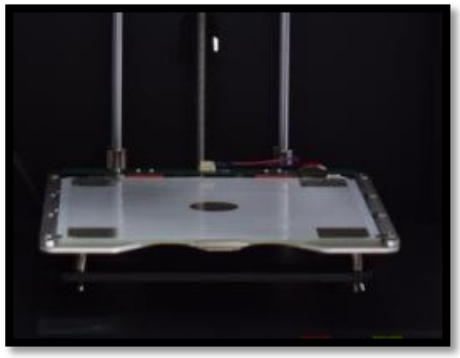
3 UNPACKING AND INSTALLATION

1. Open the packing box and check if it is sealed?

2. Unwrap the packing box to take out the manual and check if the accessories are complete.

3.Take out the top accessory box and then take out 3DPrinter. Remove all packing foam and put printer on a level table. **Use side panels to lift the Printer from the Box.**

4. Assemble the **glass-reinforced epoxy laminate sheet** platform into the 3D printer.

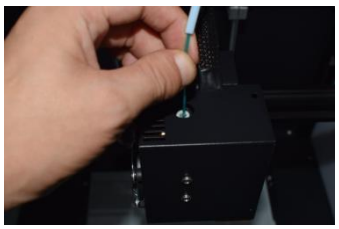


5. Fix the material holder onto the 3D printer. Take out the printing Filament and hang them on the material rest.

Rocker arm

6. Put the material through the Teflon hose.

Teflon hose

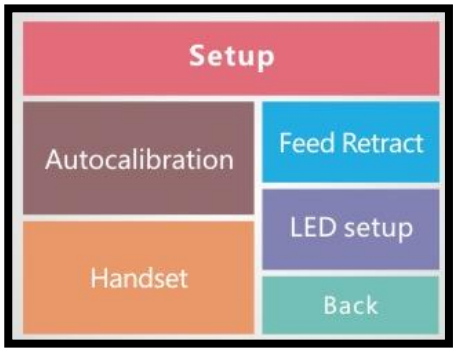


4 INTRODUCTION OF STARTING UP THE PRINTER

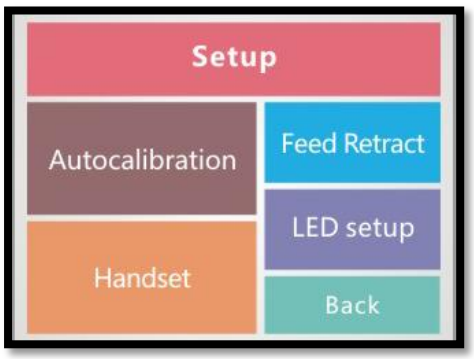
4.1 Power On

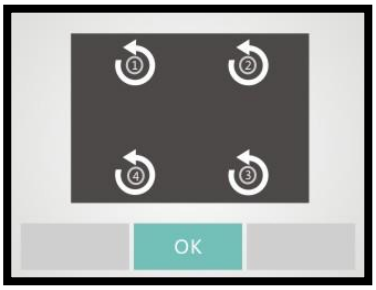
- Plug the power cord -> Insert SD card -> Power Switch on. The 3D printer starts up, as follows,

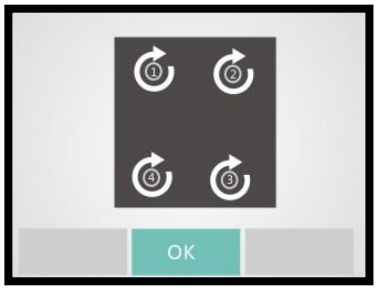
- Touch LCD Display, goes to operation page, click setup, it comes the following.

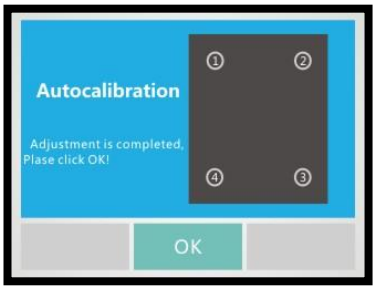


- Click Auto calibration, goes to auto calibration page, operate per instruction, click back after operation completed.

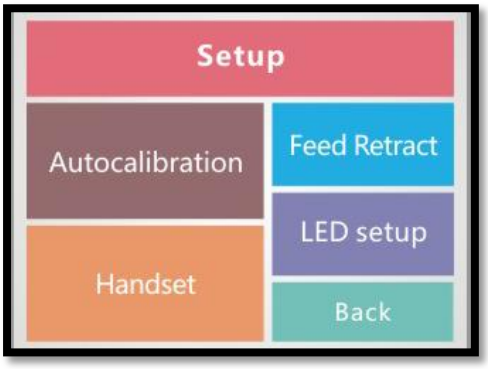


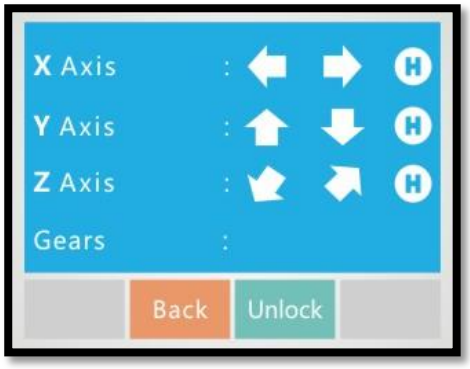




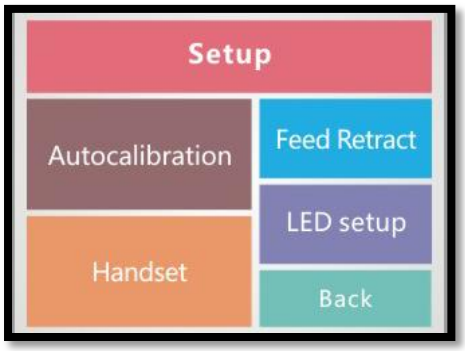


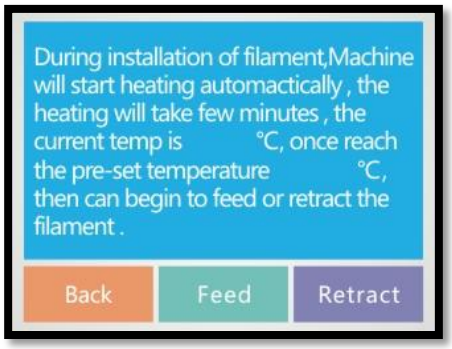
- Click handset, goes to XYZ adjustment operation page, click back after operation completed.
  "+" forward direction ，"-" reverse direction，"H" axis to be zero，"Back" to the setup page，"Unlock" release the motor and can move by hand.

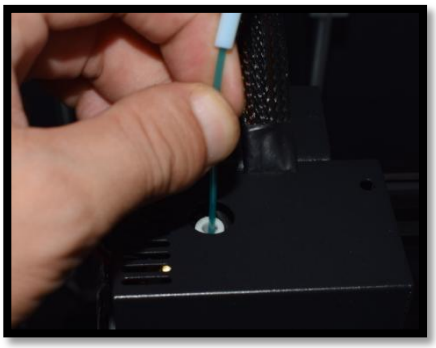




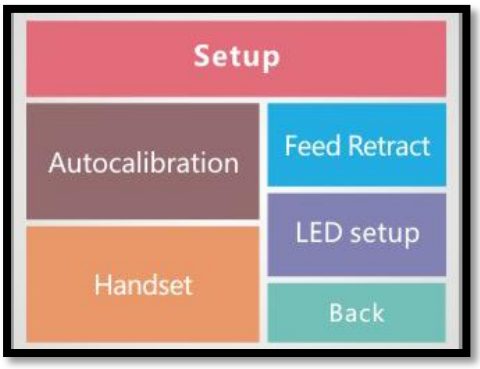
- Click Feed/Retract, goes to Filament operation page, operate per instruction, click back after operation completed.
  Insert filament to the Printer Head, Once reach to the preset temperature, then click Feed, filament will start extrude out from nozzle, then feed is success.
  Click retract, filament will release from the Head.

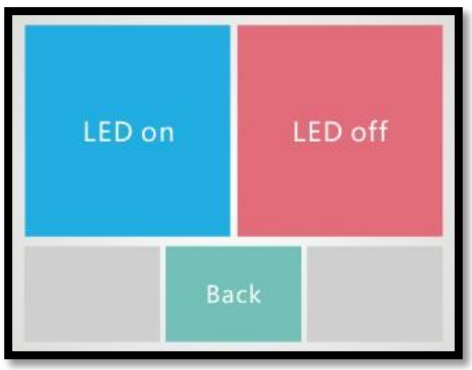






- Click LED Setup to operate the LED Flash Light, Go to LED operation page, click back after operation completed. Then click back again to the home page.

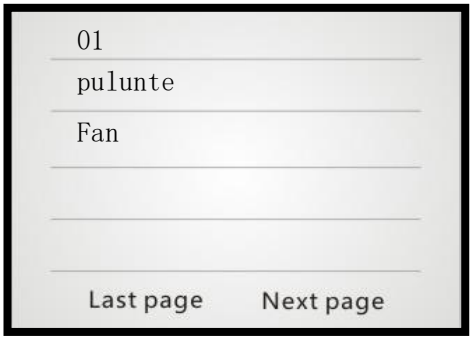


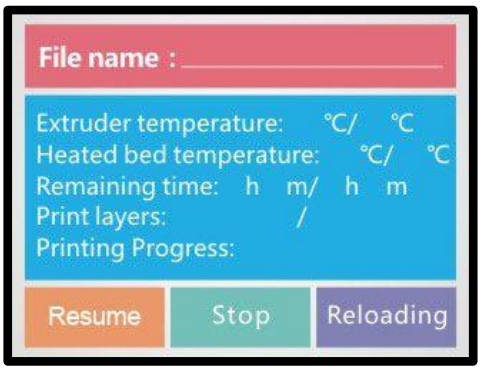


- Click help to go to help operation page, click back after operation completed and goes to home page.

5 PRINTING

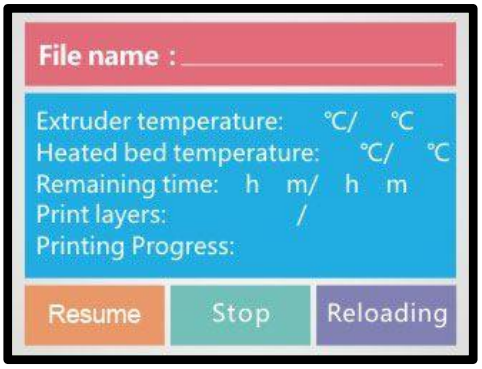
①Select the Model icon to go to Model page, select the desired model to print from the list. It takes a few minutes to wait for the temperature goes to the preset temperature. Once it reach, it will start to print automatically.

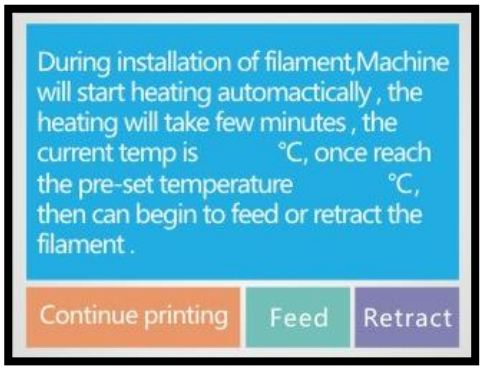




② Reloading filament during printing.

Once click reloading button, the printing would be pause and goes to the reloading page, once reach the preset temperature, click Retract, the filament would come out from the print head. Then put new filament into the hole, once temperature reach to the preset temperature, click Feed, material will feed successfully. then it will go on printing after clicking continue printing.





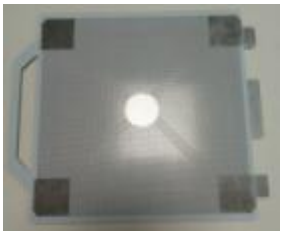
5.1 Instruction of LCD Display

The above images shows the common control function, Customer could adjust per their own need, if any questions, please contact our after-sales department.

6 MAINTANANCE

- Do not try to use the methods those not described in this manual to disassembly or modify this machine, in order to avoid damage to the printer or other more serious accidents.
- Regularly clean the printer with a cloth to wipe off dust and residue. If a wet cloth is needed, do not use flammable solvents to touch the internal circuit of the printer to avoid fire or electric shock.
- After printing, try to discharge the residual print material in the nozzle and the extruder to avoid the nozzle from blockage when printing for the next time! This is the basic maintenance for a 3D printer.
- The guide rail can be added with engine oil for one time every half a year for anti-rusting and lubrication.
- Recommended temperature for the working environment: 5 °C-30 °C , do not air the machine body with a fan during the printing process.
- Recommended humidity for the working environment: 20%-80%.

7 LIST OF ACCESSORIES

Directory	**1. Print material**	**2. Tweezer**	**3. Power cord**	**4. Platform mat**
Quantity	1 roll	1 pcs	1 pcs	1 pcs
Remark				
Directory	**5. Flat head shovel**	**6. Plastic nippers**	**7. Card reader**	**8. SD card**
Quantity	1 pcs	1 pcs	1 pcs	1 pcs
Remark				
Directory	**9. Data cable**	**10. Small wrench and tweezers**	**11.Filament blanket**	**12、Instruction manual**
Quantity	1 pcs	1 set	1 pcs	1 pcs

Remark		 		

8 FAQ

Q1: Why is the printing model not adhesive to the platform?

A1 - The distance between nozzle and platform in not accurate, Adjust the distance between them to assure that the distance is just enough to get through a calibrated film. You can use Auto Calibration function to adjust this.

Q2: Why the filament do not come out from the nozzle?

A1 - Check the filament feeder of heating and feeding filament. Since the Printer is with built-in stepper motor feeder, Please observe if the motor is vibrating and making working sound or not, if no. Then check if the connection cable of filament feeder and motherboard is well connected or not.

A2 - Check temperature.

Printing nozzle temperature of PLA material ranges from 195°C -210°C.

A3 - Check if the nozzle is blocked.

If filament is already heated to then use force to push the filament, if it does not come out, then disassemble the nozzle and clean it or replace the nozzle.

A4 - Check if nozzle is too close to the platform, if yes, then filament cannot come out, so adjust the distance between platform and nozzle to assure it can just enough to get through a calibrated film. You can use Auto Calibration function to adjust this.

Q3, The Print Model is not Accurate (Dislocate the Material placement)

A1 - Problem with slicing, re-slice and reproduce gcode file.

A2 - The model drawings has problem. If the model still not accurate after re-slicing the models, then its drawing has problem.

A3 - the nozzle is forced to stop printing Path (First, You cannot touch the moving nozzle with your hands during the printing process.)

A4 - May be Mainboard Malfunction

If the above problem exist, and if all dislocation happens at the same height of any model, then replace the mainboard. There might be gap between actual and theoretical printing accuracy algorithm.

Q4, Why There are lots of filament piled up on the model surface,

A1 - Nozzle temperature is too high, consumables melt too fast to cause overflowing.

A2 - The filament flow is too large, Software has filament flow settings, the general default value is 100%. Please lower the value to 80% printing.

Q5, Poor surface quality after removing the support of the Model.

A1 - The support can be set up to the 10% density. Then it is easy to remove the support.

A2 - can be slightly trimmed with a grinding tool, and then rubbed with a towel which dipped into acetone. Note to Wear gloves, do not wipe too long so could avoid affecting the appearance and size of the model.

Q6, The inappropriate distance between the platform and nozzle.

The first layer is not formed because of large distance between Nozzle and Platform, if the distance is too small, the nozzle will scratch the platform, Please use Auto Calibration function to adjust the distance between Nozzle and Platform.

Q7. Printing supplies difference

With the maturity of 3D printing, FDM printing supplies on the market is rich and multiple color, But the compatibility of supplies and printers is particularly important.

Thank you for choosing EasyThreed 3D Printer!

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