

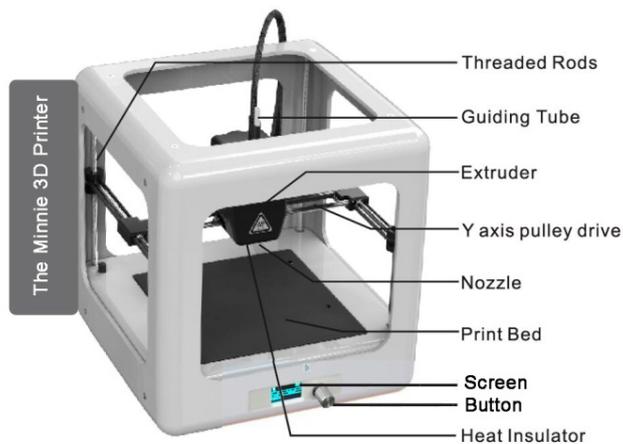


E3D Minnie USER'S MANUAL

Please watch operation video in Website or YouTube

Channel:Easythreed 3D

Thank you for purchasing E3D Minnie 3d printer. Minnie is a kind of consumer 3D printer. Its very good and very easy for kids to use.



specification:

Building size:90*110*110mm
Layer thickness:0.1-0.3mm
Nozzle diameter:0.4mm
Supported filament:PLA
Printing temperature:180°C-230°C
Filament diameter:1.75mm
Print speed:10-20mm/s
Resolution :0.1-0.2mm
Slicing software: **Easyware,CURA,Simplify3D**
Supported file format:.STL
Support OS:Windows XP/7/8/10 (32 bit/64bit)
MAC
Machine size:188X188X198mm
Machine net weight:1.5KG

This Manual is subject to change. For updated information, please visit www.easythree.com

1, Un-Boxing Minnie 3d printer



1:Lift The Minnie from its packaging box.Remove all bubble wrap,foam,and tape(may repuire scissors).

2:Inside is an Minnie 3d printer and an accessories box with a user manual,3D filament,USB Cable,power adapter,TF card,card reader,scraper,filament holder and screw driver.

3:Be sure to remove the"Gantry Clips" located on the front left and front right corners of the printer.The clips are only for protection during transportation.(As shown in the figure 1)

4:Place the filament holder at the left or right side of the printer (**best is the right side**) ,then hang filament on(As shown in the figure 2)

Precaution:Do not place the filament holder at the front or back of the printer,which will affect the printing quality.

(Figure 2)



2, Slicer software application (STL format 3D file need be sliced to gcode format that printer can recognize).

(1).This 3d printer runs with it's own developed slicing software named Easyware , it is in the TF card included in the accessories box , please copy it to your computer and no need installation ,you can also download Easyware from official website, and you can watch Slicer operation video in Youtube channel.. Easyware slicer can recognize STL format 3D file.

(2). STL format 3D file need be sliced to .gcode format, and save to TF card, and Insert TF card to printer, then can print 3D file. (3D Printer can recognize gcode format file only).

3, Connect and Power The Minnie

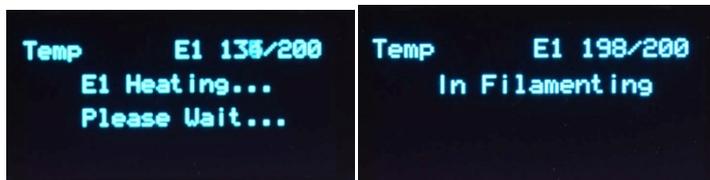
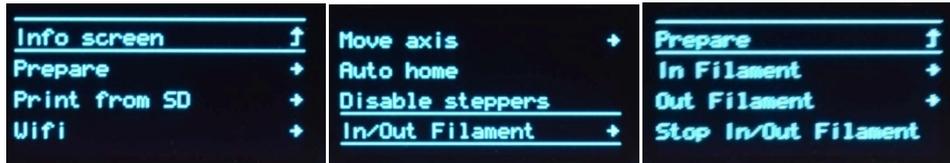
1:Plug the provided original Minnie power adaptor into the socket and the print button indicator light should be on.

2:If need to power off the Minnie after printing completed.Then unplug the power adaptor from the back of the printer .

4, Steps to Print

4.1 Install 3D filament

Feed: before print need load filament inside the nozzle, step as followed, Insert filament into the guiding tube until it can not go further, and gently press the filament to stop it runs back. Then use another hand to operate the screen, choose **“prepare”** and confirm, and choose **“in/out filament”** and confirm. then choose **“in filament”** and confirm, The printer head has a heating process when feeding. Please wait patiently for a while. wait till there will be 10cm silk filament come out from the nozzle. Filament feed successfully. Choose **“Stop in/out filament”** to return.



4.2 slice model and save to TF card.

Use our Easyware Slicer software to slice the model .STL file.(pls visit our website to watch our Slice Video Video to learn how to use our Slicer), after slice save gcode file to TF card. And insert TF card to printer.

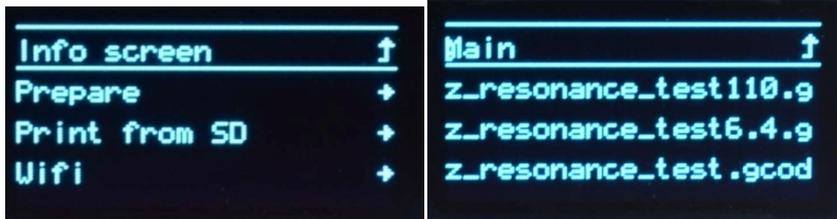
Note: there is a gcode file inside the TF card when it come from factory.

The TF card insert with right direction



4.3 Start to print.

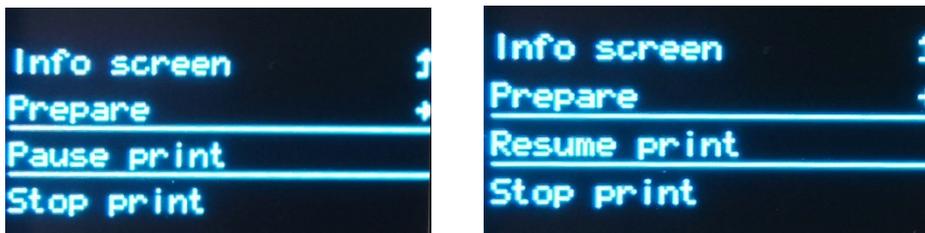
From the screen you can choose **“print from SD”** and enter inside the TF card, Choose the gcode file inside the TF card And confirm. then printer start to print.



4.4 Pause/Restore

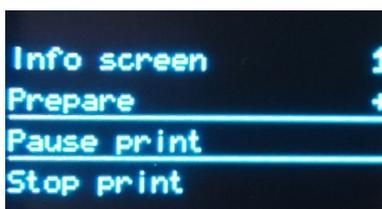
during printing, choose ” **Pause print**” press button , then printing paused.

If need to continue print , choose ” **Resume print**” press button , the printer goes back to print .



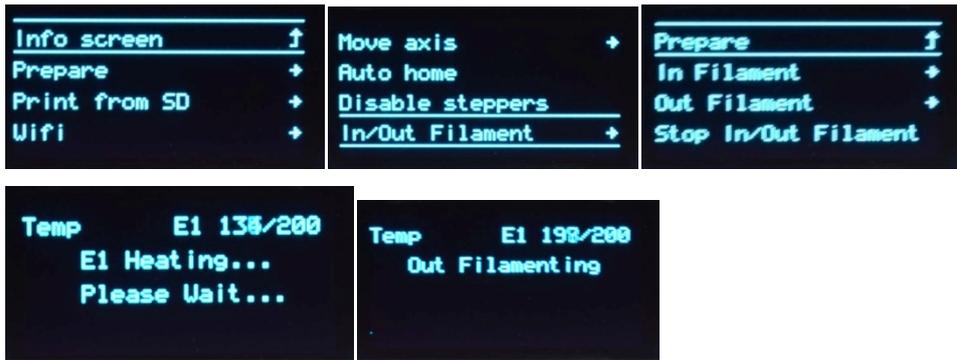
4.5 Stop Print

If you want to stop print during printing , choose ” **Stop print**” press button, the machine will stop printing, then printing cancelled.



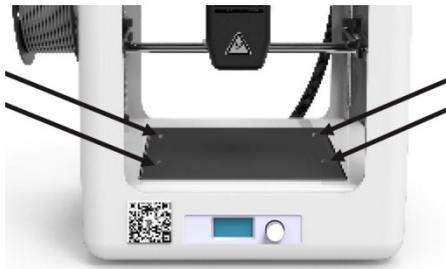
4.6 Retract:

If want to replace another roll of filament or the machine does not print for long time.Then needs to retract the filament. Step as followed, operate the screen choose”**prepare**”and confirm, and choose “**in/out filament**” and confirm .then choose”**out filament**” and confirm, The printer head has a heating process when retracting. Please wait patiently for a while.Filament will retract successfully in the normal situation. Please Pay attention to that,gently pull up the material to help till filament completely get out of the printer. Choose”**Stop in/out filament**” to return.

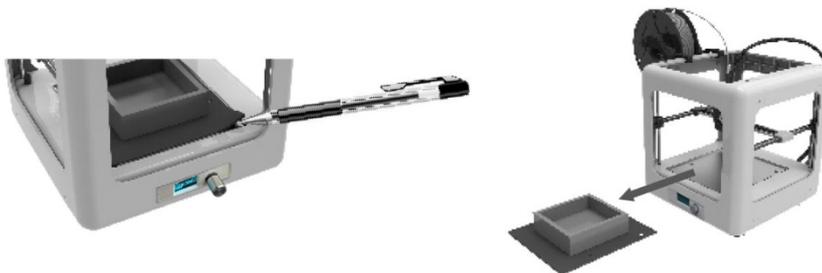


Precaution:Printing bed leveling and removable platform plate

If found the bed is not leveled in the process of printing, then needs to adjust the screws in the bed, Gently rotate the screws clockwise,the bed will goes down,rotate the screws anti-clockwise,the bed will goes up.



After print you can take off the platform magnet plate (can use a pen to assist with)



5. Online printing(For Experts):

5.1:Install the USB driver(in TF card or download from easythreed.com)to computer.

5.2:Install Cura-15.04.6 slicing software(in TF card or download from easythreed.com)

5.3:The above software installation and how to print online,please refer to the electronic version of “Nano online printing user manual”(in TF card or download from easythreed.com)

Safety Considerations



Caution:Hot!Keep your fingers away from the Nozzle Tip and Black Insulator when the printer is on as these areas reach temperatures over 200 degrees Celsius.Always be sure to keep your hands away from moving parts when Minnie is in operation.

6. Maintenance

Do not try to use the methods those not described in this manual to disassemble or modify this machine,in order to avoid damage to the printer or other more serious accidents.

When power is cut off,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.

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:Relative humidity should not exceed 80%,the minimum should not be less than 20%.

7. Safety

(1) Safety and Warnings:

Children under the age of 10 should use the product under adult supervision. The printhead, exposed nozzle, extruded plastic, and areas near the nozzle may be extremely hot. Keep fingers away from the printhead and extruded material unless it has been unplugged for at least 10 minutes. Use the products in a well-ventilated area. Use the printer only as intended, as described by the user manual. Do not leave the product running while unattended.

(2) Precaution:

None of the components of the Minnie 3D Printer or parts printed from it or using filaments are certified for food safety nor should they be regarded as food-safe therefore should not come in contact with the mouth or foods/liquids that will be ingested by humans or animals.

(3) Maintenance:

Long or improper use, nozzles, nozzle assembly parts, or other may need to be replaced or cleaned, print platforms and its overlays may need to be replaced, the extruder may need to be cleaned.

8. FAQ

Q1: Why the printing head can not move after pressing the printing button in initial printing?

A: Please remove the clips in front left and right before using the machine. The clips are for transportation protection.

Q2: How to feed the filament and how to judge filament feed successfully?

A: First, straighten the filament and gently push into the feeding hole, at the same time, use the other hand to operate the screen to "in filament" choose it and confirm. Then wait about 1 minute (machine is warming up), release the material when feel the filament is caught by the machine. Then wait another 10 seconds to observe if there has "silk" coming

from the machine. There is about 10cm filament come out.Till this time,filament feed successfully.If you operate based on the above steps,but no silks come out from nozzle after waiting for more than 5 minutes,please re-power machine and try again.

Q3:How to retract filament?How to solve when the filament can not retracted.

A:First, operate the screen to the “out filament” choose it and confirm .Filament will retract successfully in the normal situation,If failed,please try to feed first,then retract again.Please Pay special attention that,gently pull up the material to help till filament completely get out of the printer.

Q4:What's the reason that the model can not stick to the printing bed in the initial printing or in the process of printing?

A:The bed is too far away from the nozzle,need to adjust the distance between the bed and nozzle.rotate the screws counterclockwise,the bed will goes up.

Q5:What needs to pay attention to when adjust the printing bed?Need to check bed before each print?

A:(1)adjust the printing bed,need to use the screw driver in the accessories box to twist the bed screws,when twist screws clockwise,the bed goes down,twist screws counterclockwise,the bed goes up.(2)After each adjustment.Needs to unplug the power , then move the printing head along the bed one lap to assure it will not scratch the bed, then can go next step.(precaution:Needs to cut the electricity then can move the printing head by hand,or the motor will be destroyed).

(3) No need to adjust the bed before each print,but advise to do one time one weed.

Q6:How to judge what's the best distance between nozzle and printing bed?What is the difference when its too close and too far?

A:The standard distance between the nozzle and printing bed is the thickness of a piece of A4 paper, Insert a piece of paper between the bed and the nozzle,with normal pull and with resistance as the standard;in the condition that do not scratch bed.The closer it is, the firmer the model will be.

(1) The right distance between nozzle and bed:the”silks”are flat,spread on bed very smooth and no burrs.

(2) The distance is too far:the “silks”are fine round, spread on bed unevenly, with gaps and tilt. Filament come down to the bed is by gravity force. The rounded strips' adhesion effect is not good,they are easily moved.Printing effect is very unsatisfactory.

(3) The distance is too close:the “silks” are irregular protrusion(with burrs)on the both sides,but thin in the middle. Or there are no silks coming down. Or the bed is scratched with a deep trace .

Q7:Why do there twist lots of filament nearby the nozzle in the process of printing?Model become mess of silks?

A:there are several situation:

(1) When it happens in the initial printing,the distance between nozzle and bed is too far, the silks can not stick to the bed ,so it would become messy filament.Please twist the 4 bed screws 90 degree anti-clockwise.If still not ok , then please twist 90 degree anti-clockwise again till normal printing.

(2) The bed is with oil,please use dry towel to tidy the bed,do not use hand to touch the bed directly.

Q8:How can i move the printing head?

A:Please unplug the power,then use hand to move the printing head to where you want. Please do not try to move the head up and down, move along Z axis can not realized by hand.

Q9:How can i move the printing head up?

A: choose “move axis “ columns on the screen, you can move X, Y, Z axis

Q10:Does the printer need warming up before each printing?

A:There needs to warm up when feed and retract operation,In the normal printing, you only need to choose the model and wait about 1 minute,then printer will start work.

Q11:Can the model continue printing if electricity is cut off?

A:If there is no electricity in the process of printing, the models can not continue printing.

Q12:Can pause printing in the process of printing?

A:Yes, press the screen control button, it will pause. Then press again,it will continue printing.

Q13:How to stop printing?

A:Please press the screen control button, choose stop printing,

Q14:Filament will run out soon in the process of printing, What should to do?

A:Please pause the printing, choose “ out filament “ and press, use hand to pull up the filament.(precaution:please do this before all the filament goes into the feeding hole,or there will be no filament hand can pull up).Then put new filament into the hole and use another hand to choose “in filament “and press, wait about 10 seconds till the filament come down. Choose resume the printing,.**Please pay special attention that clear those filament outside the nozzle before resume**, in avoid that the the filament pimple appear in the model.

Q15:When print the first layer,there is no filament on the bed ,why?

A:Please check if the distance between nozzle and bed is to close cause no space for filament to come out.

Q16:Can the_machine print online?

A:Yes, it needs to use third party slicing software CURA. Please refer to the above step of point 5.0 Online printing(For experts)

Thanks for choosing Easythreed, we will try our best to serve you

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