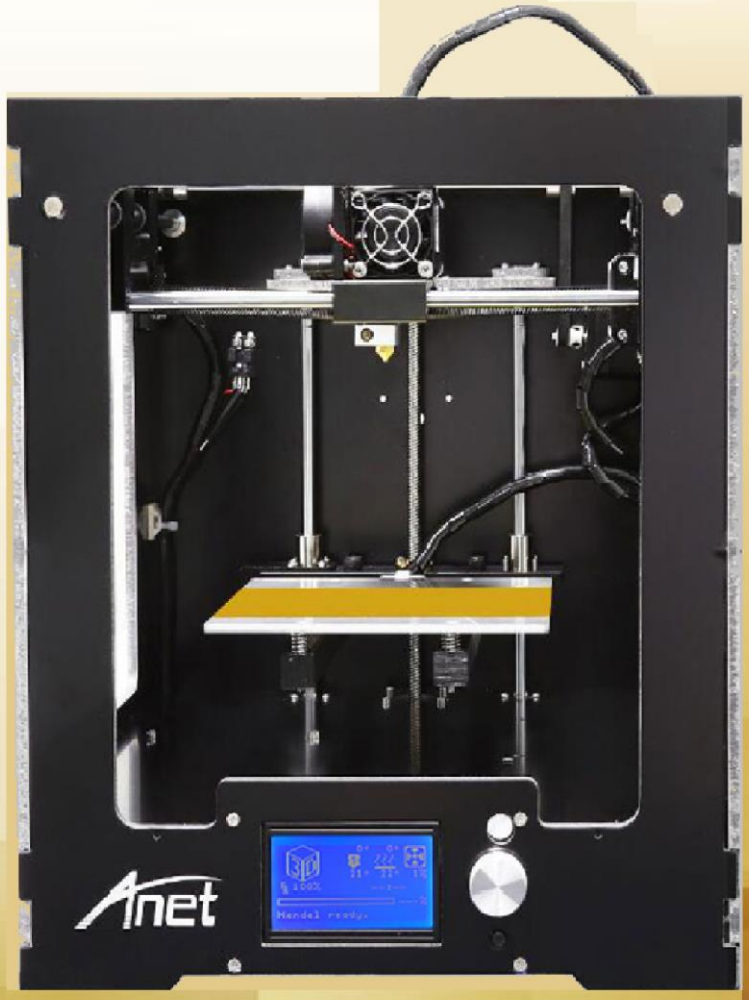
Operation Instruction

Model: A3-S



Contenu

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INTRODUCTION

L'imprimante 3D A3-S FDM peut imprimer le modèle d'imprimante 3D CAD en réel. L'A3-S utilise de l'acrylique pour construire son cadre tout en utilisant des roulements linéaires, des courroies et des tiges filetées pour construire X, Y, Axe z .

Il permet à l'A3-S d'imprimer régulièrement sans vibration.

Remarque:

1. Toutes les déclarations incluses dans ces instructions ont été soigneusement vérifiées, le cas échéant erreurs typographiques ou malentendus, nous avons l'interprétation finale.

2. Aucune notification en cas de mise à jour.

UNE. Considérations de sécurité

Pour éviter tout danger lors de l'utilisation d'une imprimante 3D, veuillez faire attention aux précautions ci-dessous.

Danger

Pendant le fonctionnement, la température maximale de la buse peut être de 260 ℃ tout chaud

peut être 100 ℃ . Pour votre sécurité, pendant l'impression ou le refroidissement, ne touchez pas le

buse, foyer et modèles en cours d'impression. La puissance fonctionne à 110V / 220V 50HZ AC

et le terrain d'alimentation nécessaire. N'utilisez pas d'autre bloc d'alimentation, car cela pourrait

dommages aux composants, incendie ou choc électrique. Et nous n'en prenons aucune responsabilité.

avertissement

Nous suggérons de porter des lunettes de protection lors du retrait des matériaux de support auxiliaires.

Certains filaments émettront de légers gaz irritants, nous vous suggérons donc d'utiliser une imprimante 3D

environnement ventilé.

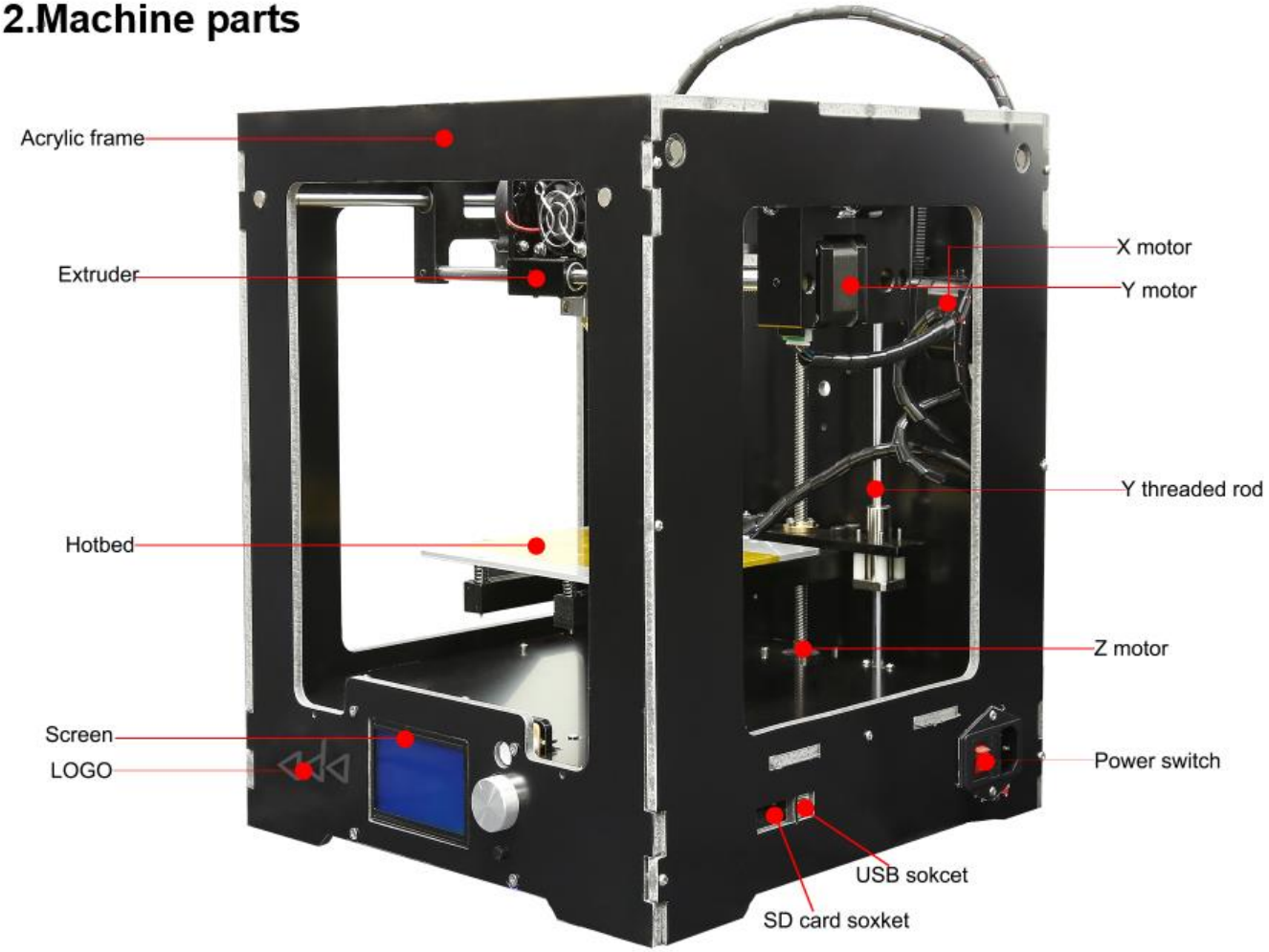
Remarque: le filament ABS émet un peu de gaz toxiques lorsqu'il fond.

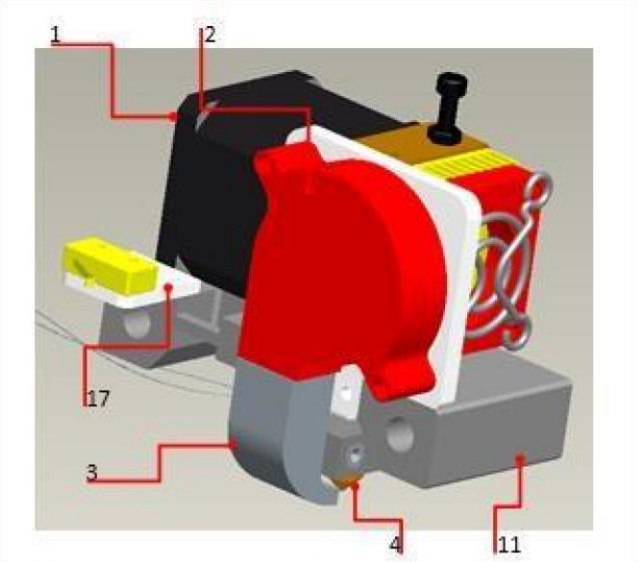
B. détails du produit

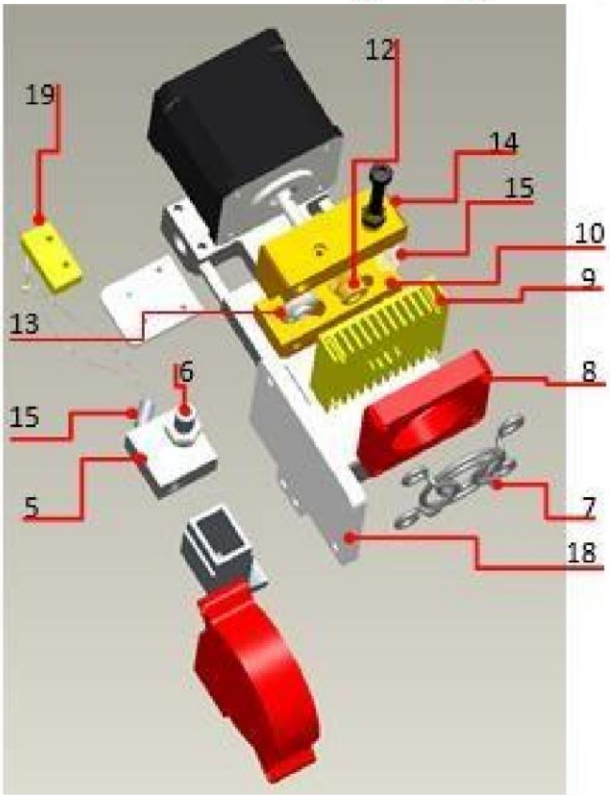
1. spécifications

Modèle ： A3-S	Diamètre de buse ： 0,4 mm
Épaisseur de couche ： 0,1-0,3 mm	Taille de la machine ： 315 mm * 333 mm * 375 mm
Vitesse d'impression ： 10-300 mm / s	Poids de la machine ： 10KG
Précision de la position de l'axe XY ： 0,012 mm	Taille d'emballage ： 400 * 380 * 440 mm
Précision de la position de l'axe Z ： 0,004 m	Poids brut ： 11,4 kg
Matériel d'impression ： ABS, PLA	Taille de construction ： 150 * 150 * 150 mm
Tendance matérielle ： PLA	écran LCD ： 12864 LCD
Diamètre du filament ： 1,75 mm	Impression hors ligne ： CARTE SD
Langage logiciel ： Anglais, chinois	Format de fichier ： STL 、 G-Code 、 OBJ
Fonction de support ： automatiquement	OS ： fenêtres (linux 、 Mac)
Logiciel ： Cura	Condition de travail ： 10-30 ℃ ， Humidité 20-50%

2.Machine parts







NO	Part Name	Quantity
1	Extruder Motor	1
2	Blower	1
3	Wind Mouth	1
4	Nozzle(0.4mm)	1
5	Heating Block	1
6	Throat	1
7	Fan Cover	1
8	Fan	1
9	Heat Sink	1
10	Extruder Seat	1
11	Bend Parts	1
12	Brass Wheel	1
13	U-Bearing	1
14	Briquetting	1
15	Spring	1
16	Heating Pipe	1
17	Limited Switch Seat	1
18	Blower Seat	1
19	Limited Switch	1

3.Exploded drawing

4.Liste d'outils

Item	Picture	Name	QTY	Check
1-1		Plastic nippers	1	
1-2		5mm*160mm Screwdriver	1	
1-3		1.5M U SB wire	1	
1-4		1.5M Power line	1	
1-5		16GB TF card and card reader	1	
1-6		Rack rod	1	
1-7		Cover	1	
1-8		Hex wrench	1	

C. Logiciel Cura

1.Installation de Cura14.07 une:

Où puis-je trouver le logiciel?

1) carte SD avec expédition; 2) téléchargement à partir d'Internet; b:

Processus d'installation

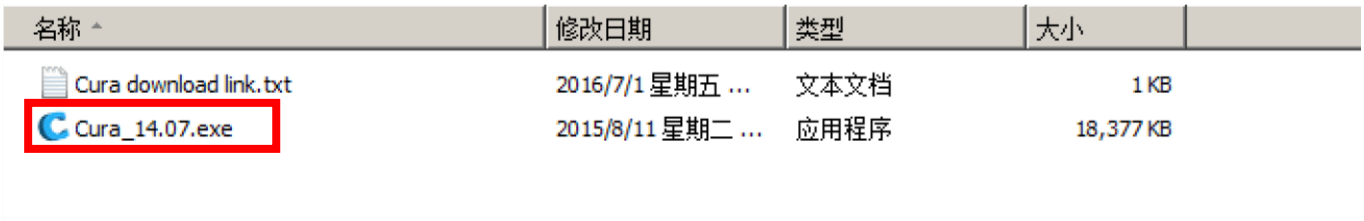
1) De la carte SD avec expédition

Insérez la carte SD et ouvrez le fichier 1.1 Emplacement des fichiers sur la carte TF

1) Insérer SD carte, ouvrez le fichier







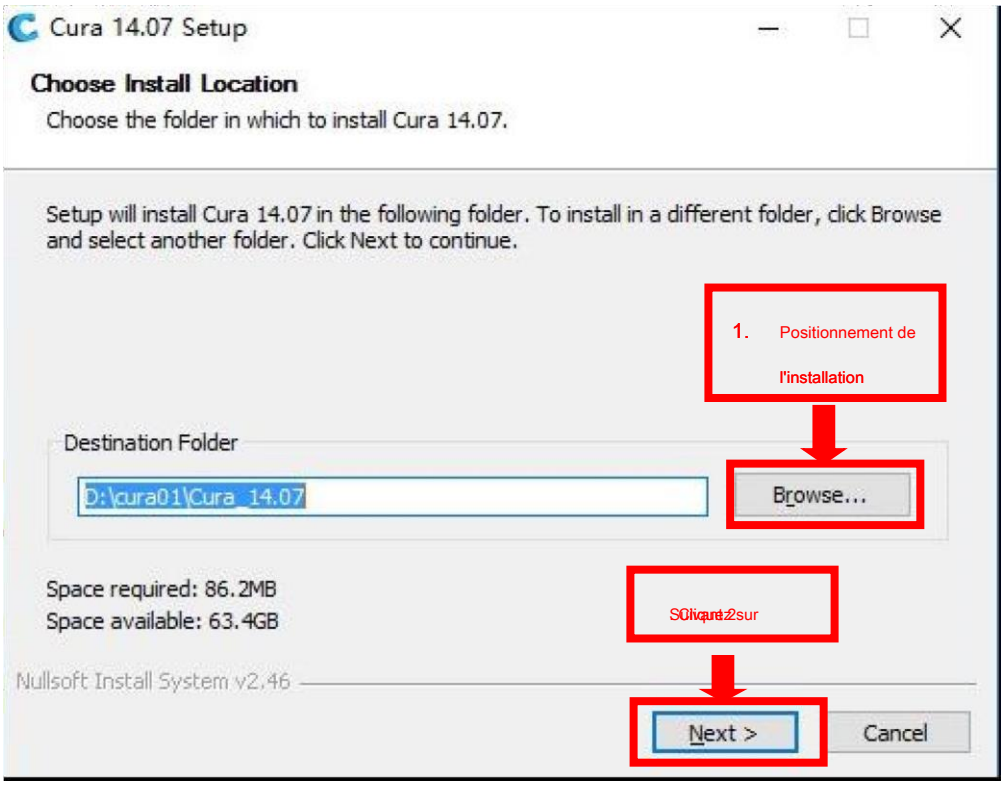
2) Télécharger depuis Internet

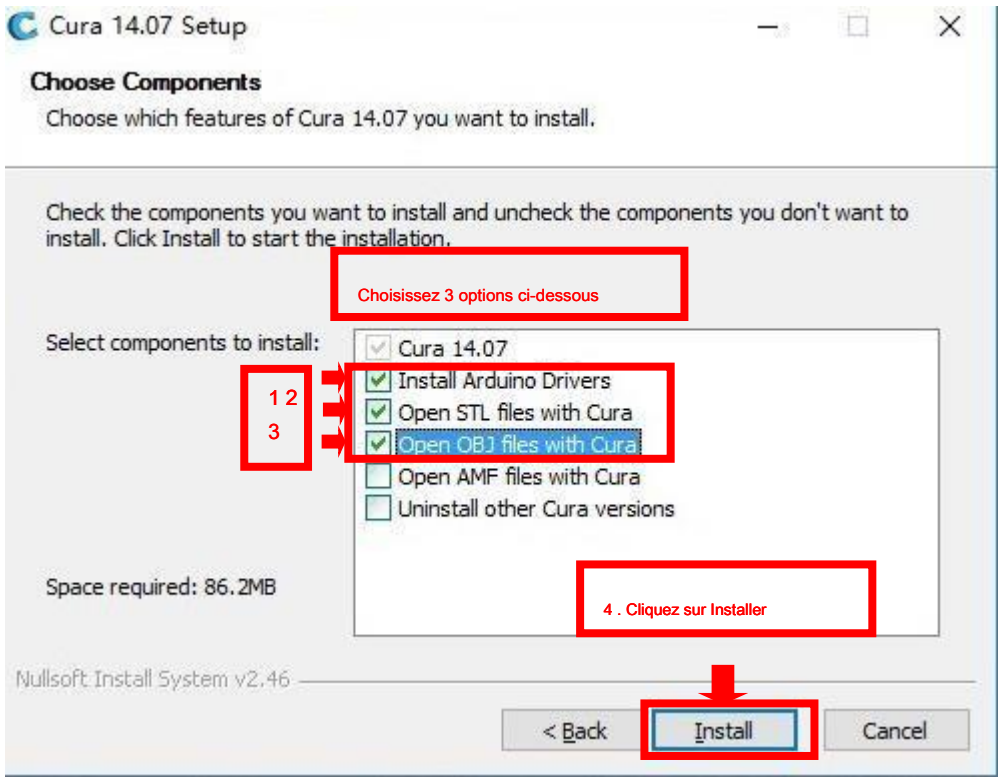


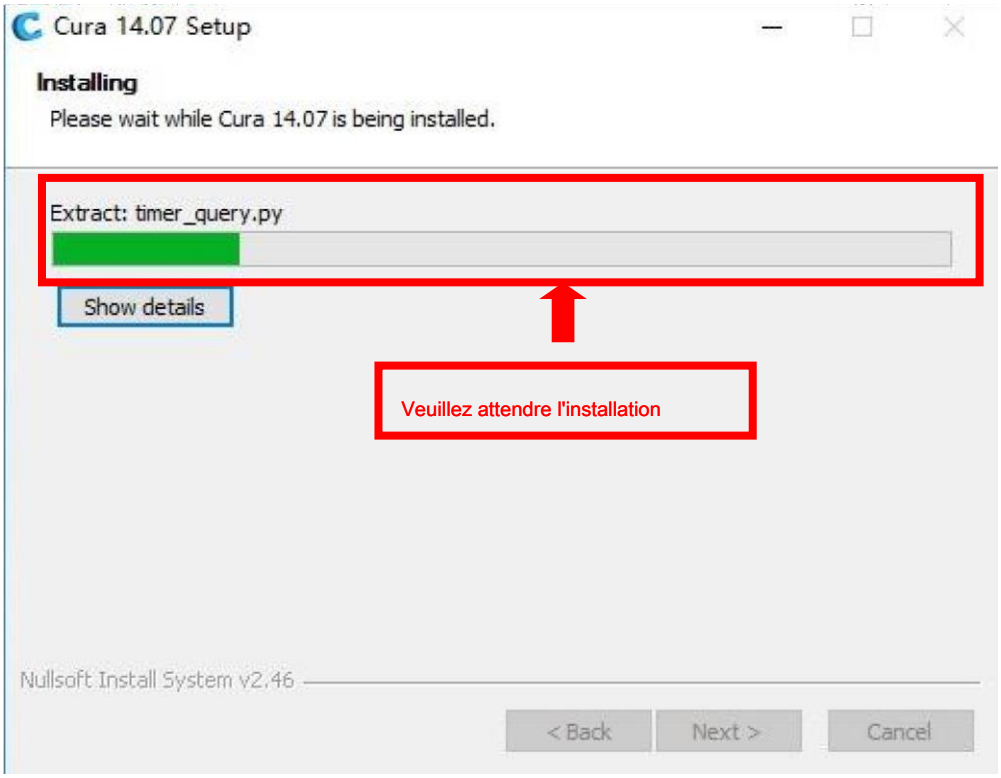
Site Internet : https://ultimaker.com/en/cura - logiciel / liste

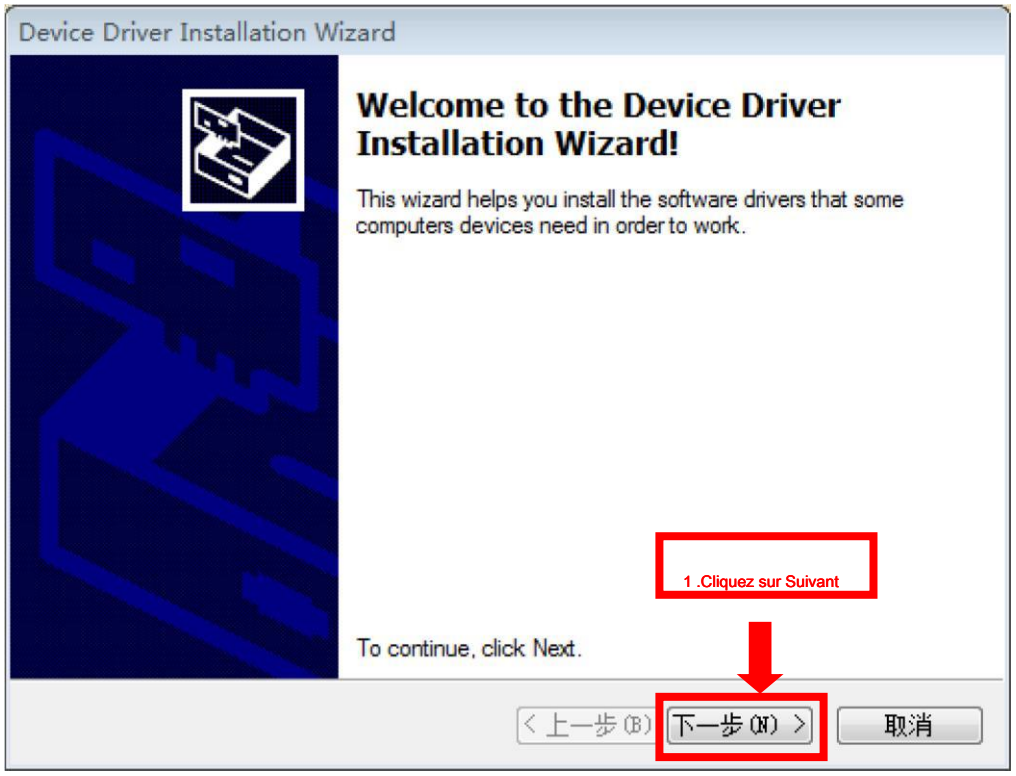
Choisissez le logiciel correspondant pour télécharger Official

b. Processus d'installation du logiciel

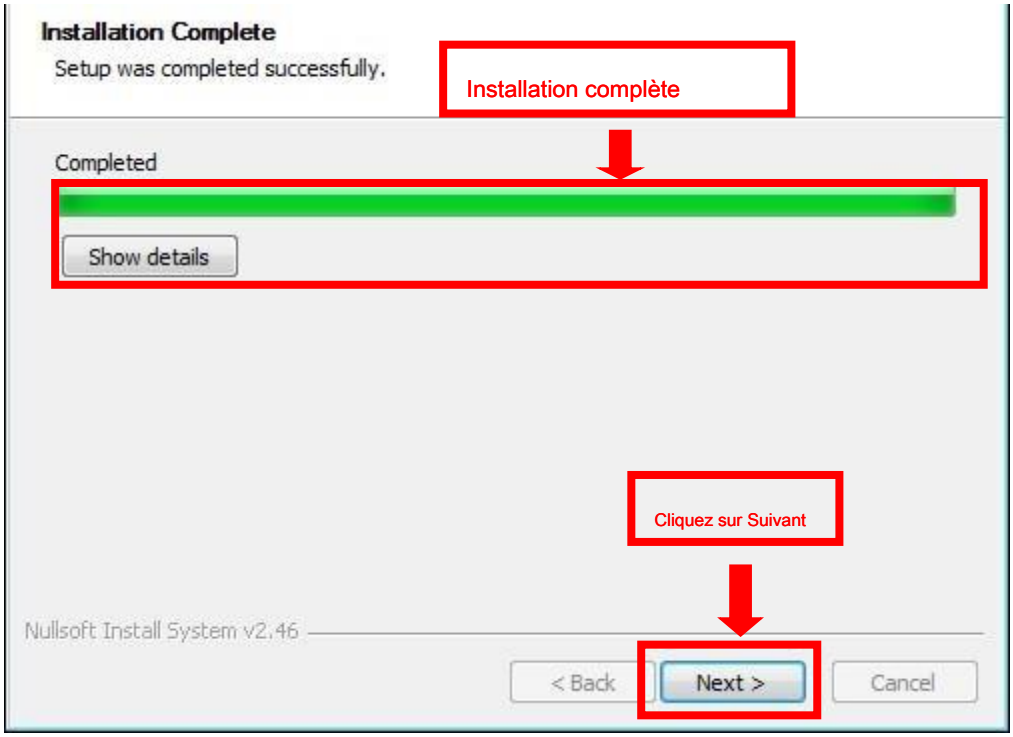





Cura 14.07 Setup
Installing
Please wait while Cura 14.07 is being installed.
Extract: timer_query.py
Show details
Veuillez attendre l'installation
Nullsoft Install System v2.46
< Back
Next >
Cancel

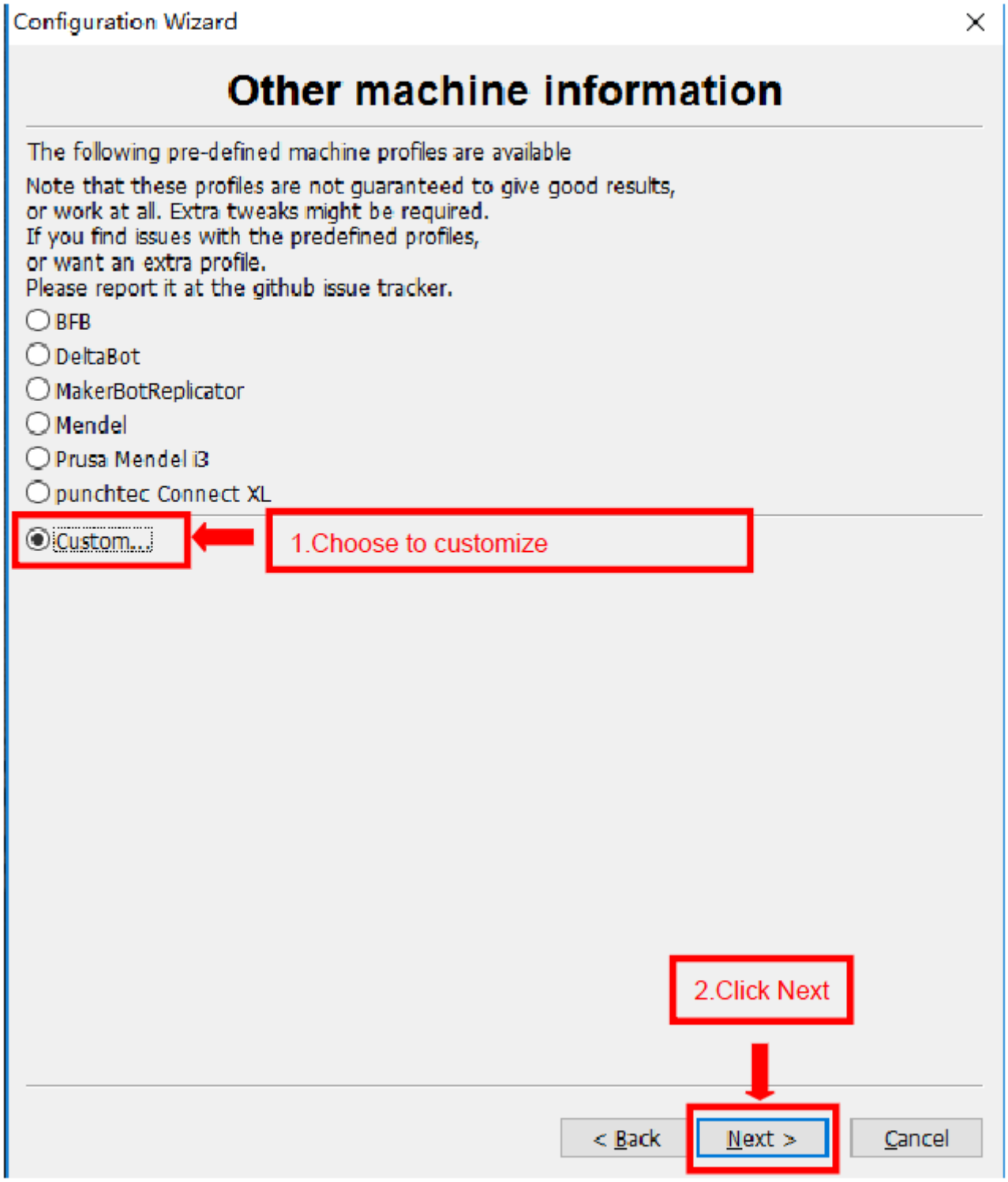

Device Driver Installation Wizard
Welcome to the Device Driver Installation Wizard!
This wizard helps you install the software drivers that some computers devices need in order to work.
1 .Cliquez sur Suivant
To continue, click Next.
< 上一步(B)
下一步(N) >
取消

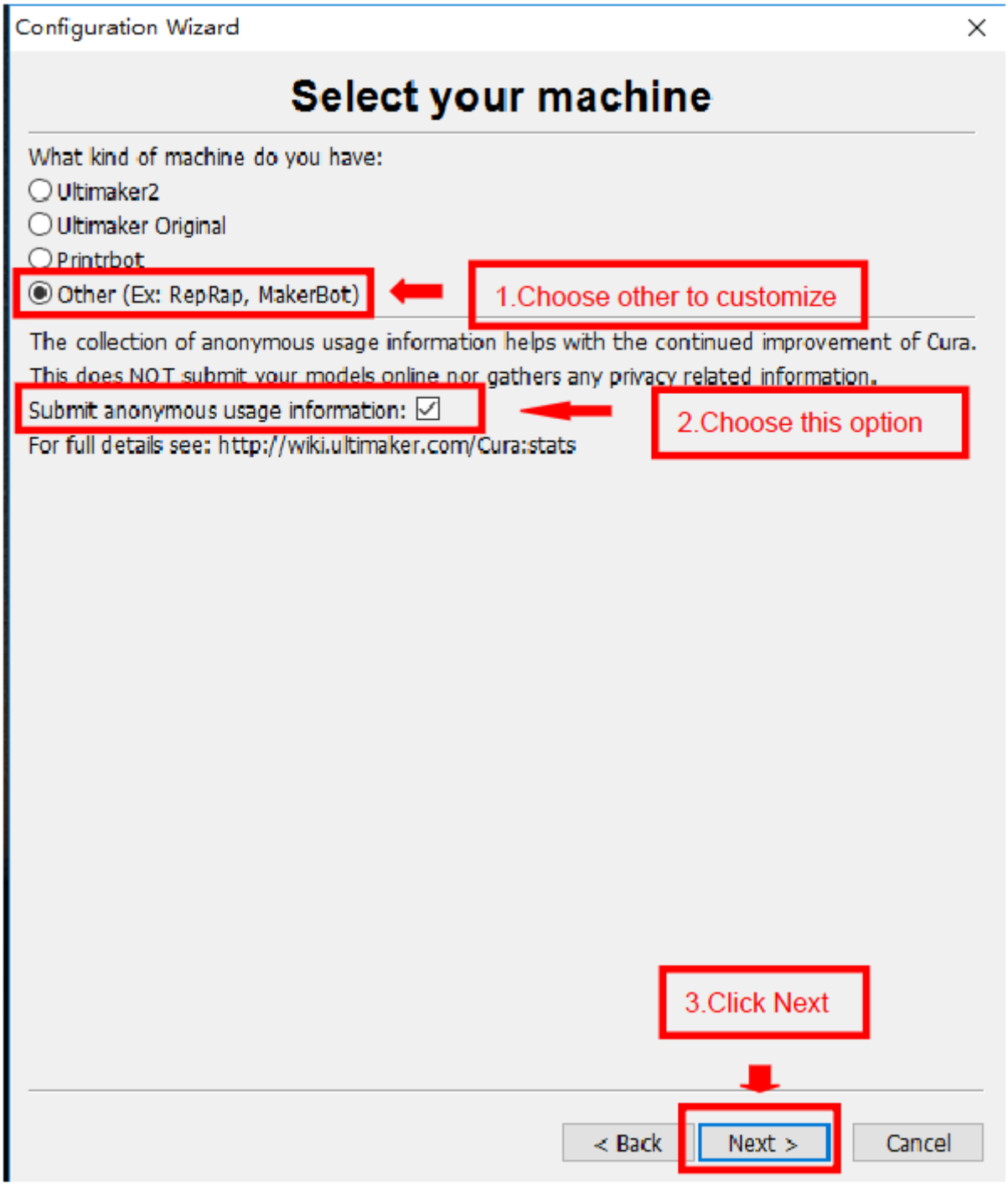

Device Driver Installation Wizard
Completing the Device Driver Installation Wizard
The drivers were successfully installed on this computer.
You can now connect your device to this computer. If your device came with instructions, please read them first.
1 .Installation réussie
Driver Name
Status
Arduino LLC (www.ardui...
Ready to use
2 .Cliquez pour terminer
完成
取消

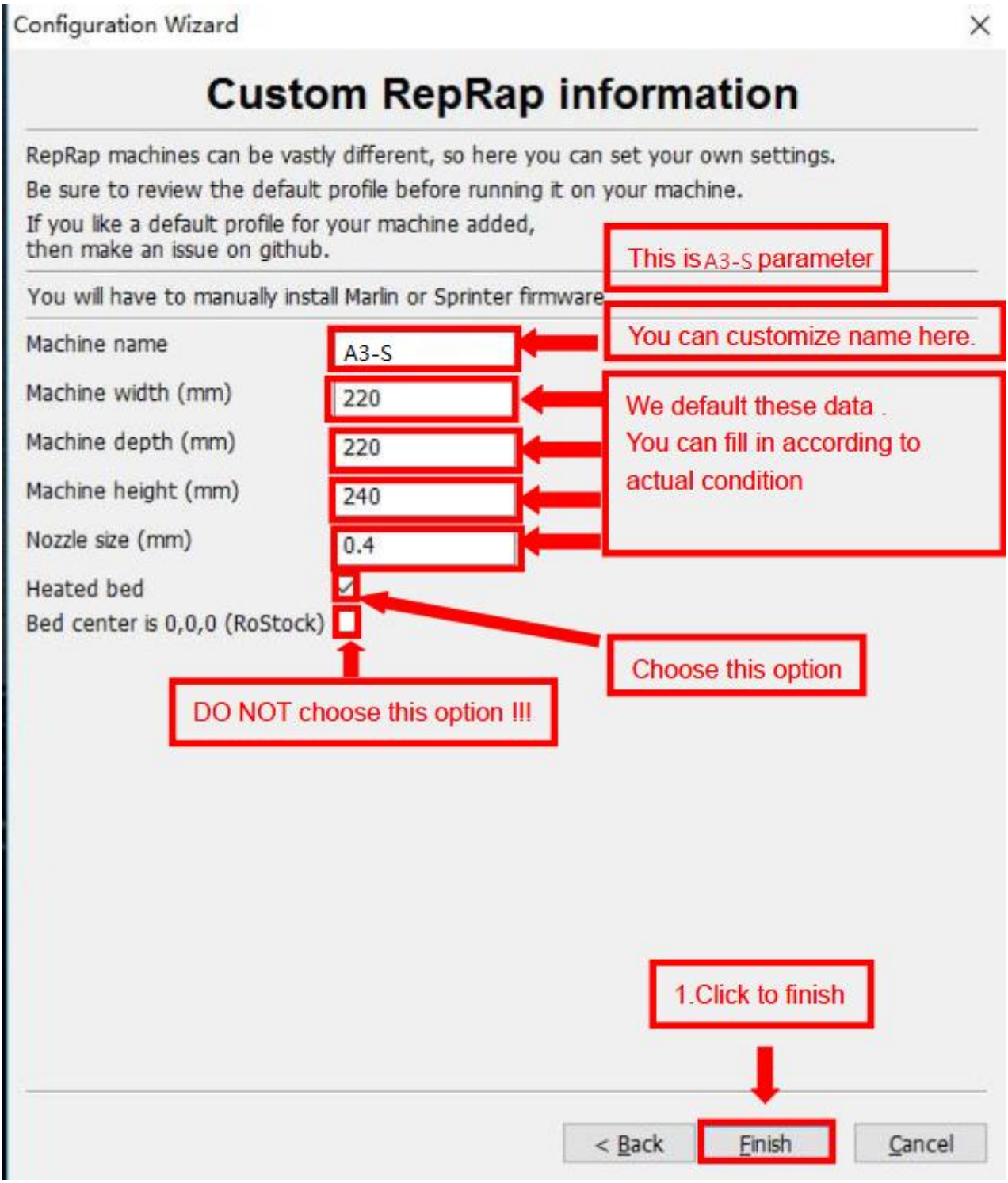

Installation Complete
Setup was completed successfully.
Installation complète
Completed
Show details
Cliquez sur Suivant
Nullsoft Install System v2.46
< Back
Next >
Cancel

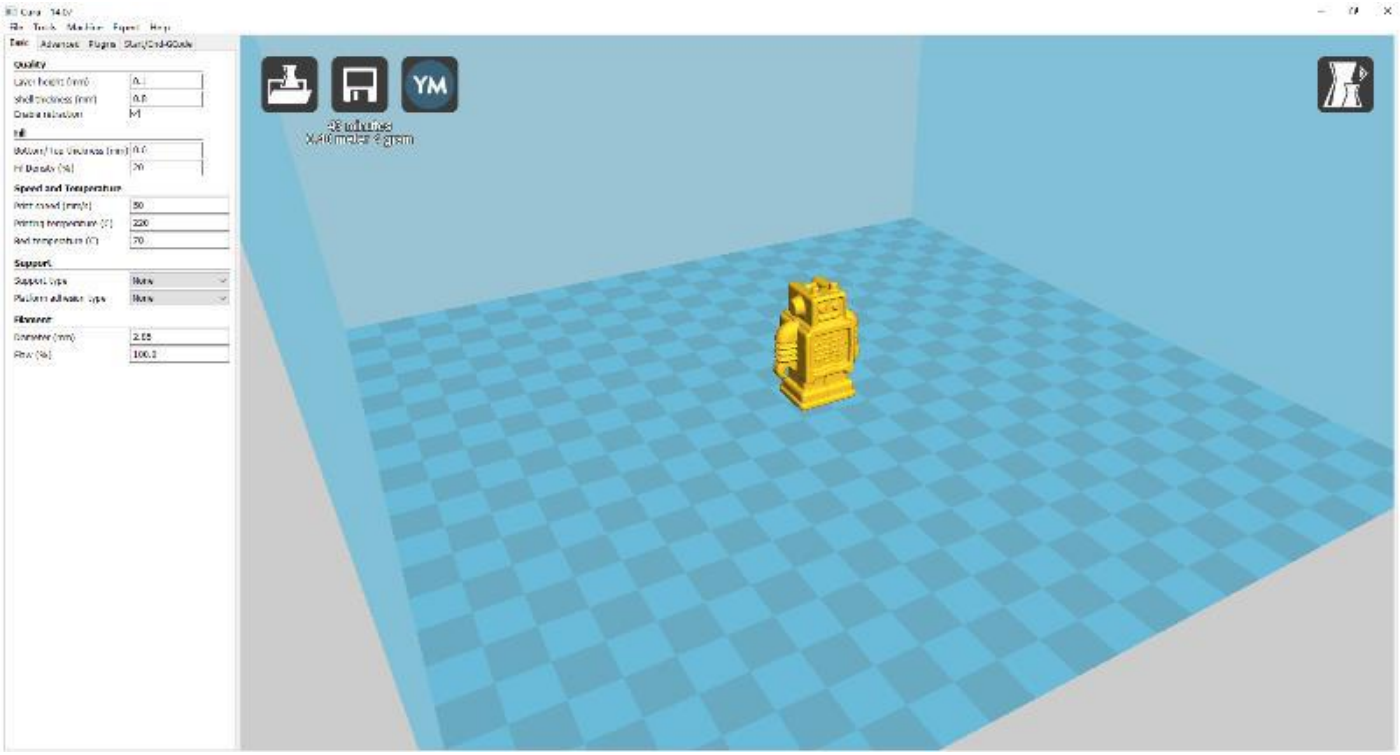

Cura 14.07 Setup
Completing the Cura 14.07 Setup Wizard
Cura 14.07 has been installed on your computer.
Click Finish to close this wizard.
Start Cura 14.07
1 .Choisissez d'exécuter Cura
2 . Cliquez pour terminer
< Back
Finish
Cancel


Configuration Wizard
First time run wizard
Welcome, and thanks for trying Cura!
This wizard will help you in setting up Cura for your machine.
Cliquez sur Suivant
< Back
Next >
Cancel


Configuration Wizard
Other machine information
The following pre-defined machine profiles are available
Note that these profiles are not guaranteed to give good results,
or work at all. Extra tweaks might be required.
If you find issues with the predefined profiles,
or want an extra profile.
Please report it at the github issue tracker.
BFB
DeltaBot
MakerBotReplicator
Mendel
Prusa Mendel i3
punchtec Connect XL
Custom...
1.Choose to customize
2.Click Next
< Back
Next >
Cancel


Configuration Wizard
Select your machine
What kind of machine do you have:
Ultimaker2
Ultimaker Original
Printrbot
Other (Ex: RepRap, MakerBot)
1.Choose other to customize
The collection of anonymous usage information helps with the continued improvement of Cura.
This does NOT submit your models online nor gathers any privacy related information.
Submit anonymous usage information:
2.Choose this option
For full details see: http://wiki.ultimaker.com/Cura:stats
3.Click Next
< Back
Next >
Cancel


Configuration Wizard
Custom RepRap information
RepRap machines can be vastly different, so here you can set your own settings.
Be sure to review the default profile before running it on your machine.
If you like a default profile for your machine added,
then make an issue on github.
You will have to manually install Marlin or Sprinter firmware
This is A3-S parameter
Machine name
A3-S
You can customize name here.
Machine width (mm)
220
Machine depth (mm)
220
Machine height (mm)
240
Nozzle size (mm)
0.4
We default these data .
You can fill in according to
actual condition
Heated bed
Bed center is 0,0,0 (RoStock)
Choose this option
DO NOT choose this option !!!
1.Click to finish
< Back
Finish
Cancel



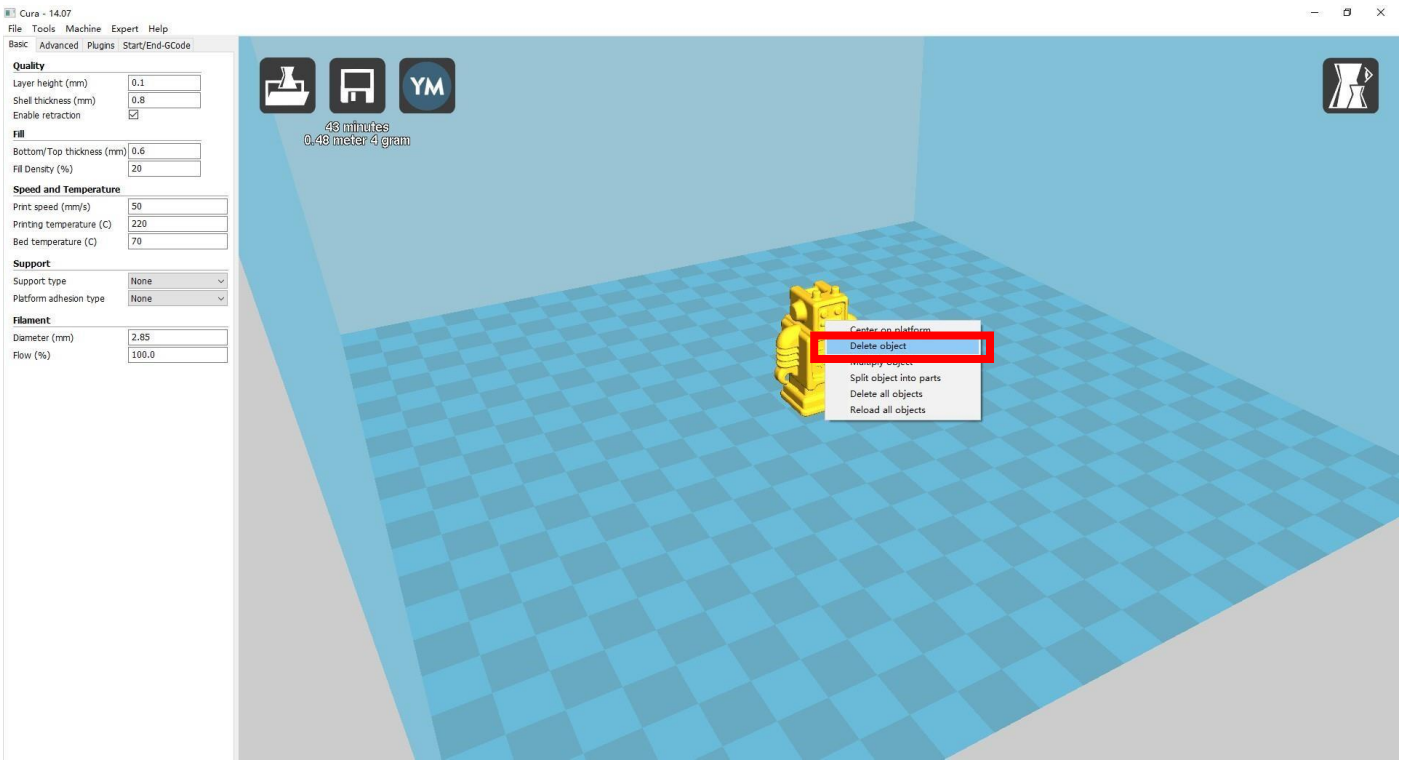
Vous avez maintenant terminé l'installation. Ensuite, entrez Cura.

2. Réglage Cura

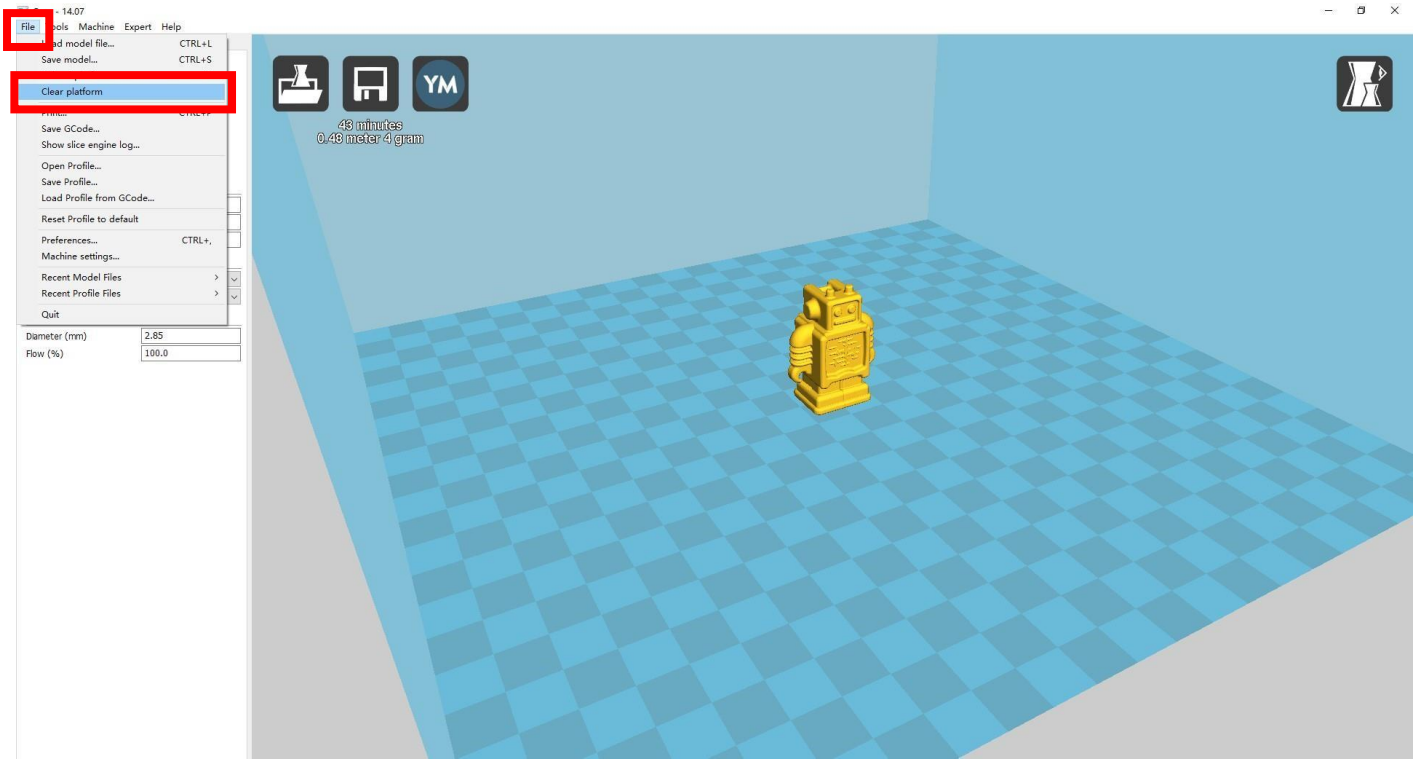
2.1 Plate-forme claire

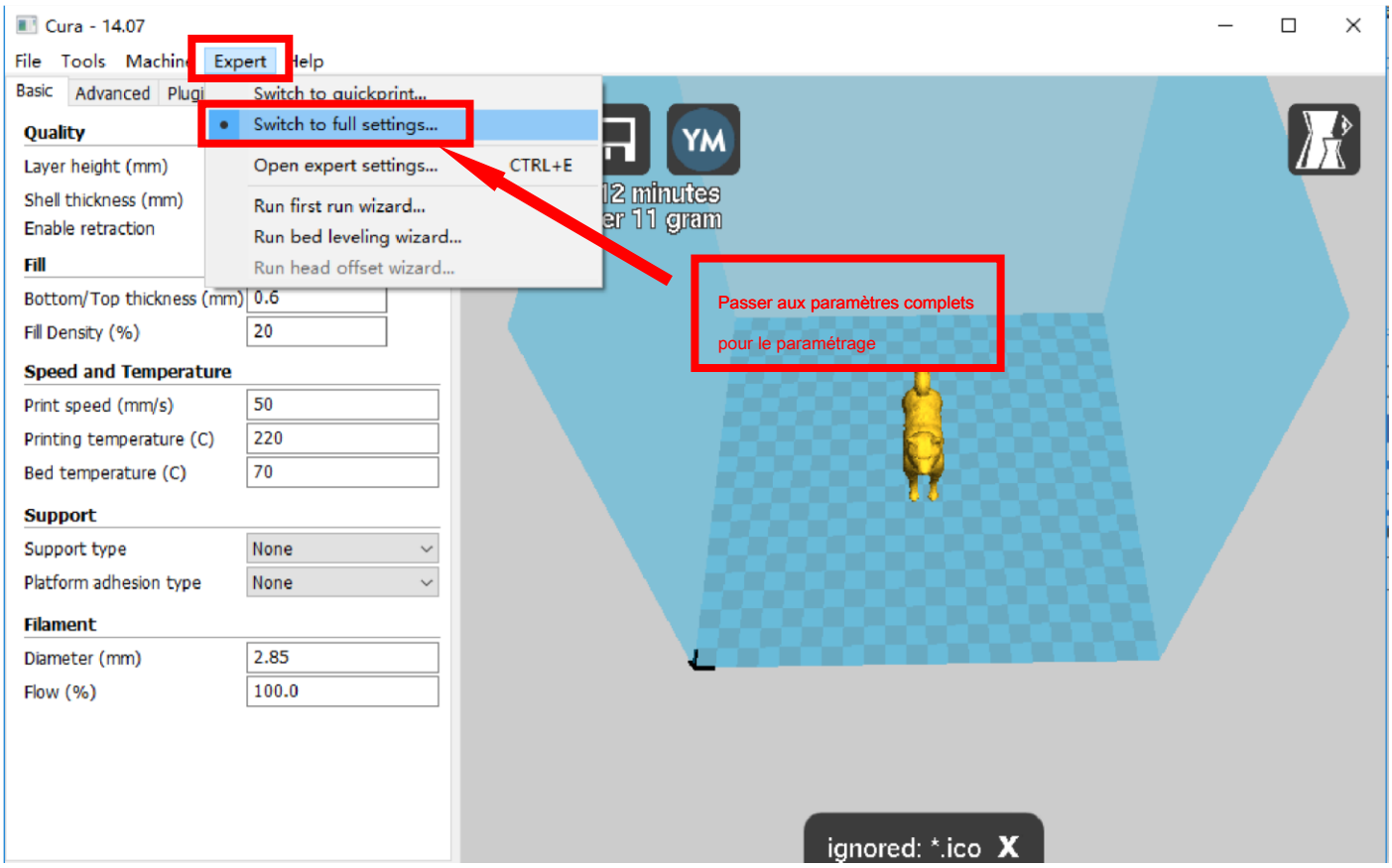
Supprimez le chien. Deux façons pour vous:

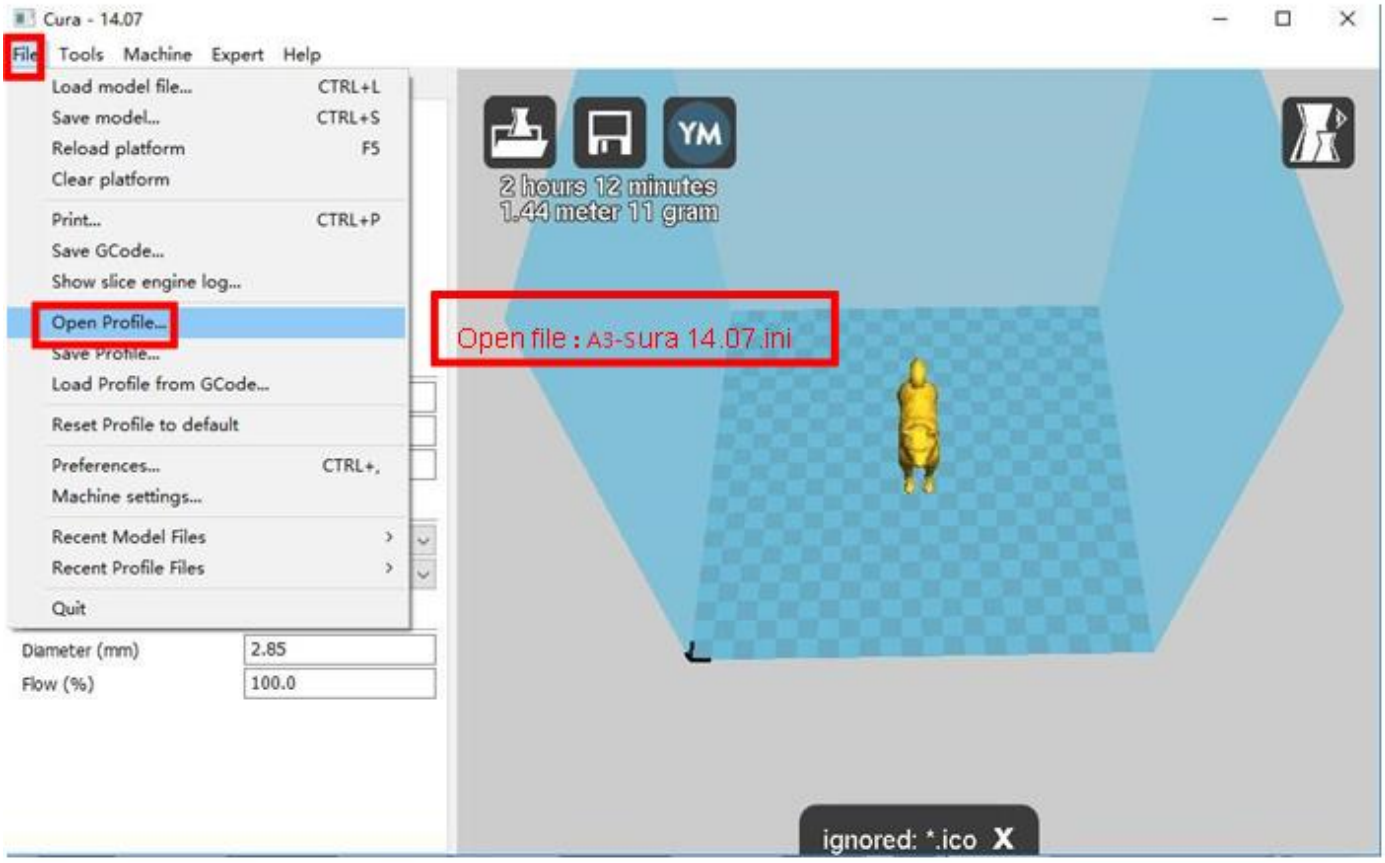
1. Déplacez la souris vers le chien, faites un clic droit, cliquez sur «supprimer l'objet».



2 .Gauche cliquez sur "Fichier", choisissez ” Plate-forme claire ».

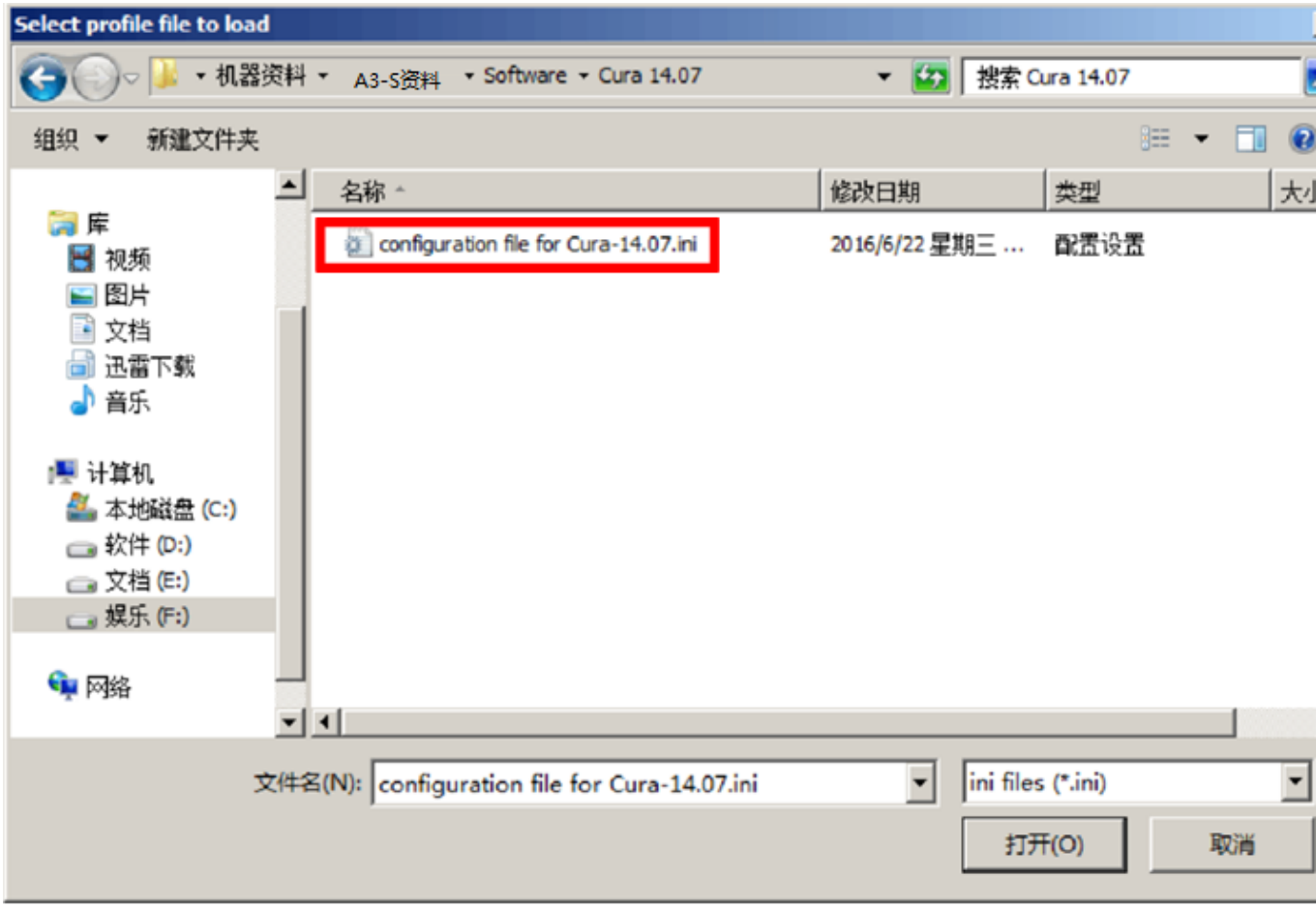


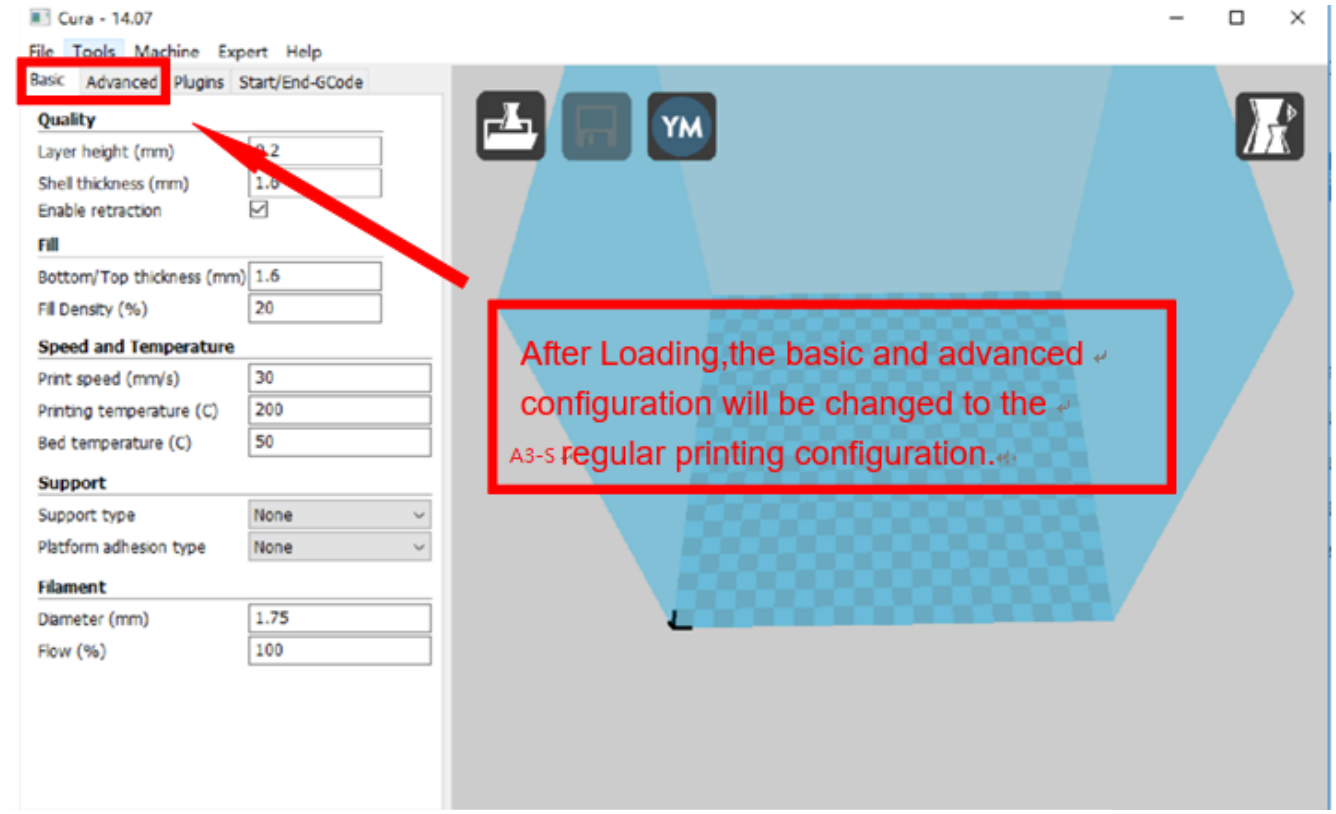

Cura - 14.07
File Tools Machine Expert Help
Basic Advanced Plugi
Switch to quickprint...
Switch to full settings...
Open expert settings... CTRL+E
Run first run wizard...
Run bed leveling wizard...
Run head offset wizard...
Quality
Layer height (mm)
Shell thickness (mm)
Enable retraction
Fill
Bottom/Top thickness (mm) 0.6
Fill Density (%) 20
Speed and Temperature
Print speed (mm/s) 50
Printing temperature (C) 220
Bed temperature (C) 70
Support
Support type None
Platform adhesion type None
Filament
Diameter (mm) 2.85
Flow (%) 100.0
YM
12 minutes
er 11 gram
Passer aux paramètres complets
pour le paramétrage
ignored: *.ico X

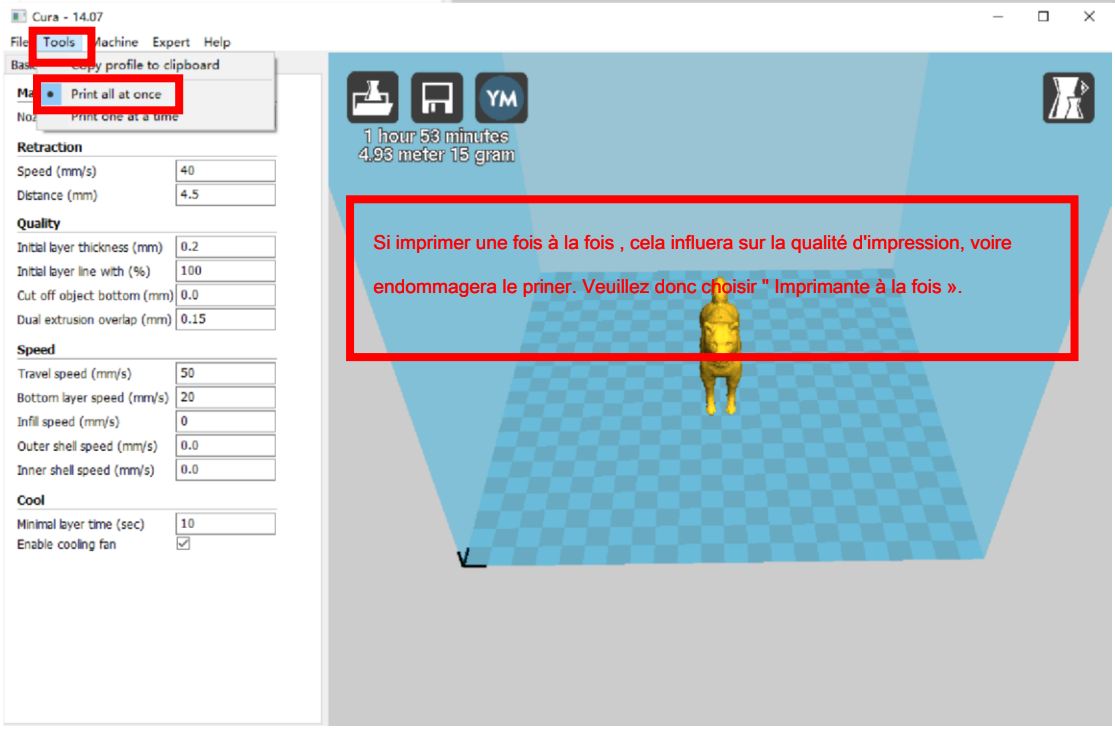

Cura - 14.07
File Tools Machine Expert Help
Load model file... CTRL+L
Save model... CTRL+S
Reload platform F5
Clear platform
Print... CTRL+P
Save GCode...
Show slice engine log...
Open Profile...
Save Profile...
Load Profile from GCode...
Reset Profile to default
Preferences... CTRL+,
Machine settings...
Recent Model Files
Recent Profile Files
Quit
Diameter (mm) 2.85
Flow (%) 100.0
YM
2 hours 12 minutes
1.44 meter 11 gram
Open file : A3-sura 14.07.ini
ignored: *.ico X

Position du fichier de configuration: ordinateur / carte SD) / fichier de configuration pour cura-14.07

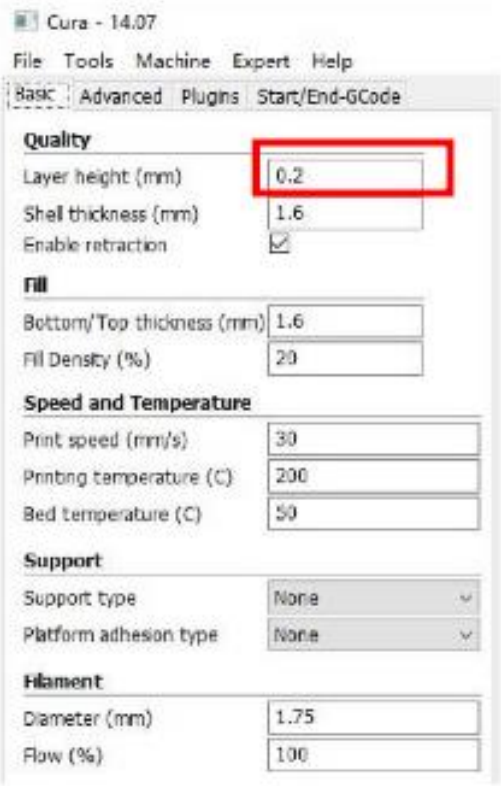
（ suggestion: conservez cette copie du fichier sur votre ordinateur ）



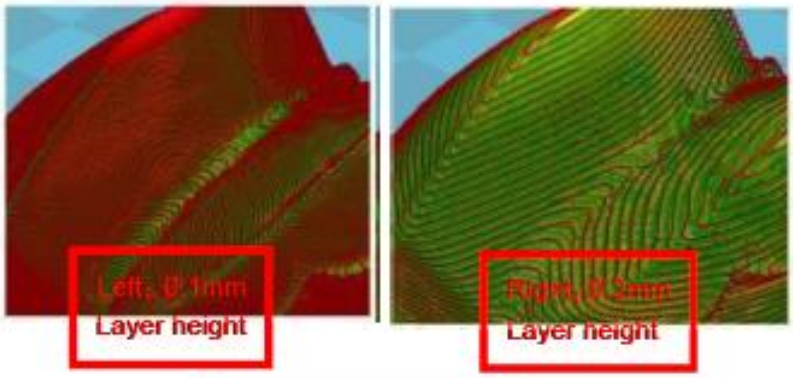

Cura - 14.07
File Tools Machine Expert Help
Basic Advanced Plugins Start/End-GCode
Quality
Layer height (mm) 0.2
Shell thickness (mm) 1.6
Enable retraction
Fill
Bottom/Top thickness (mm) 1.6
Fill Density (%) 20
Speed and Temperature
Print speed (mm/s) 30
Printing temperature (C) 200
Bed temperature (C) 50
Support
Support type None
Platform adhesion type None
Filament
Diameter (mm) 1.75
Flow (%) 100
YM
After Loading,the basic and advanced configuration will be changed to the A3-S regular printing configuration.


Cura - 14.07
File Tools Machine Expert Help
Copy profile to clipboard
Print all at once
Print one at a time
Retraction
Speed (mm/s) 40
Distance (mm) 4.5
Quality
Initial layer thickness (mm) 0.2
Initial layer line with (%) 100
Cut off object bottom (mm) 0.0
Dual extrusion overlap (mm) 0.15
Speed
Travel speed (mm/s) 50
Bottom layer speed (mm/s) 20
Infill speed (mm/s) 0
Outer shell speed (mm/s) 0.0
Inner shell speed (mm/s) 0.0
Cool
Minimal layer time (sec) 10
Enable cooling fan
YM
1 hour 53 minutes
4.93 meter 15 gram
Si imprimer une fois à la fois , cela influera sur la qualité d'impression, voire endommagera le priner. Veuillez donc choisir " Imprimante à la fois ».

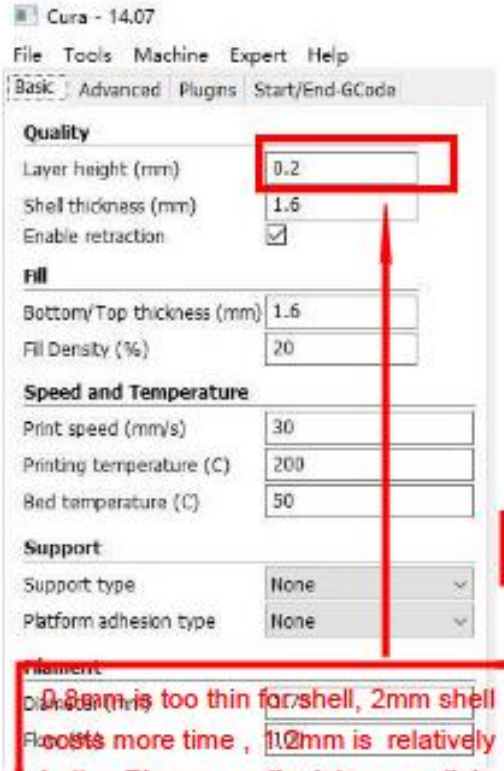
2.3 Layer height settings



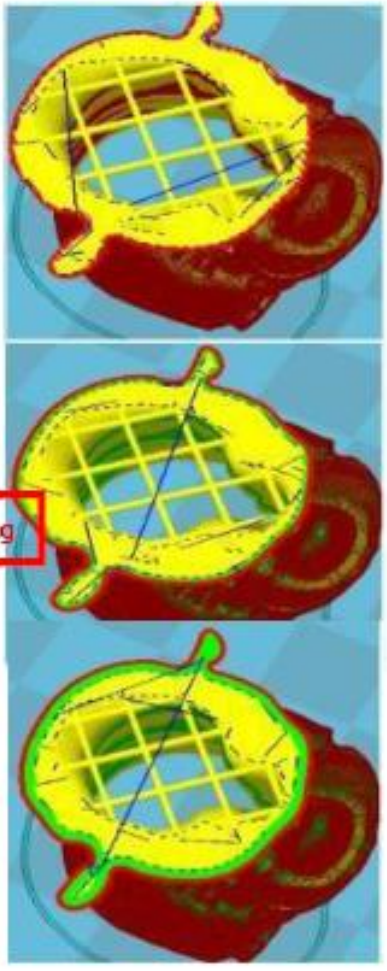
Layer height： 0.1mm cost long time but have the best printing precision. 0.2mm cost half time compared to 0.1mm , but have general printing precision. 0.3 cost less time with not good precision. It defaults 0.2mm.



Layer height setting



Shell thickness setting

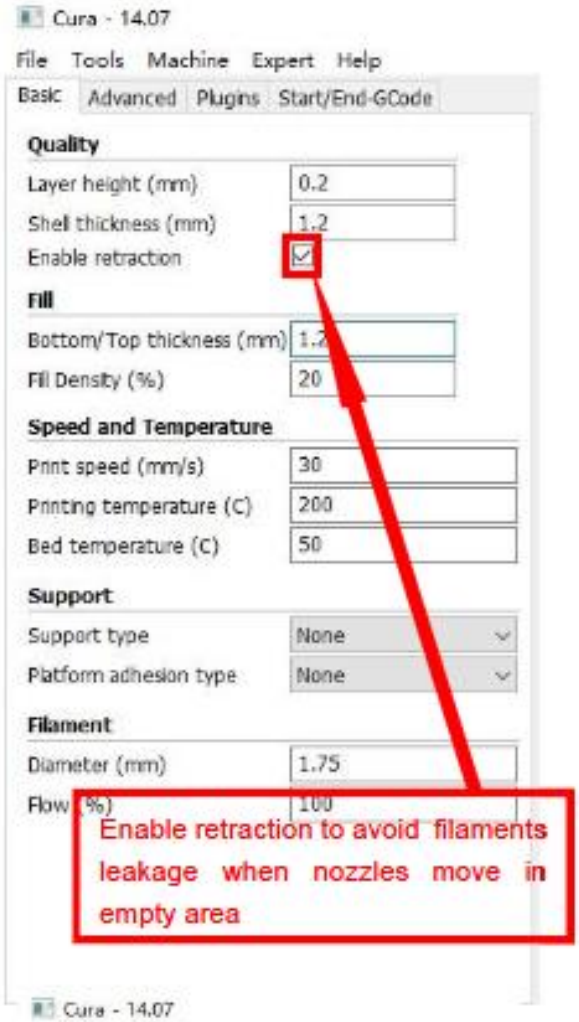


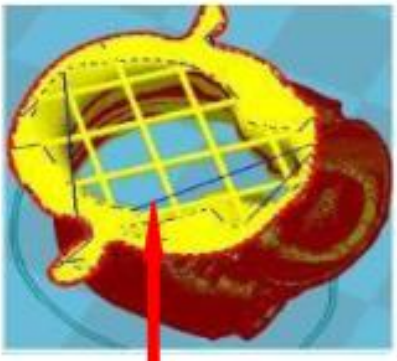
0.8mm

1.2mm

2mm

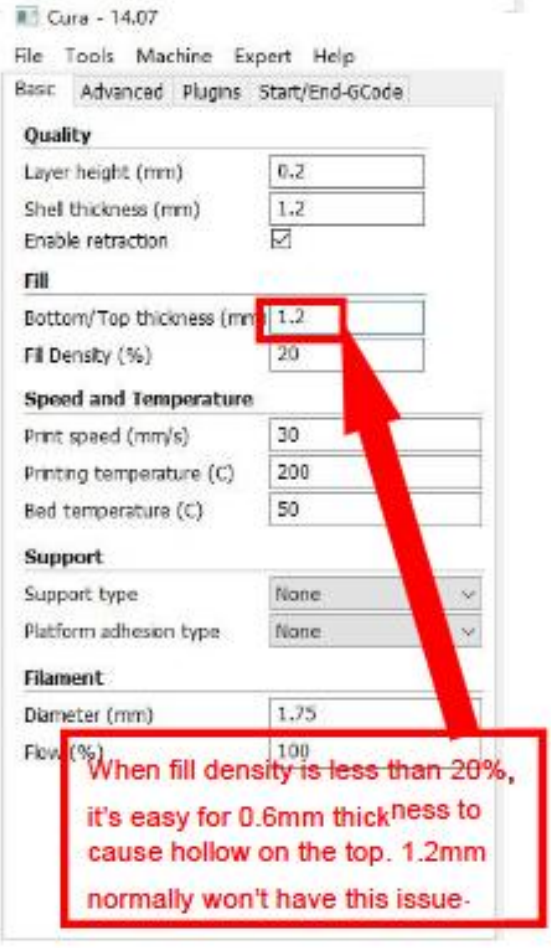
0.8mm is too thin for shell, 2mm shell costs more time , 1.2mm is relatively better. Please use the integer mutiple of nozzle diameter.

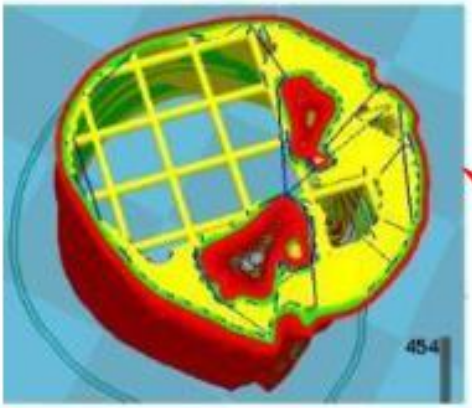




The Blue line is the leak filament

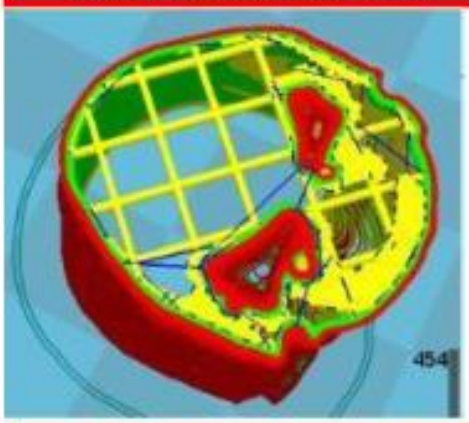
Enable retraction



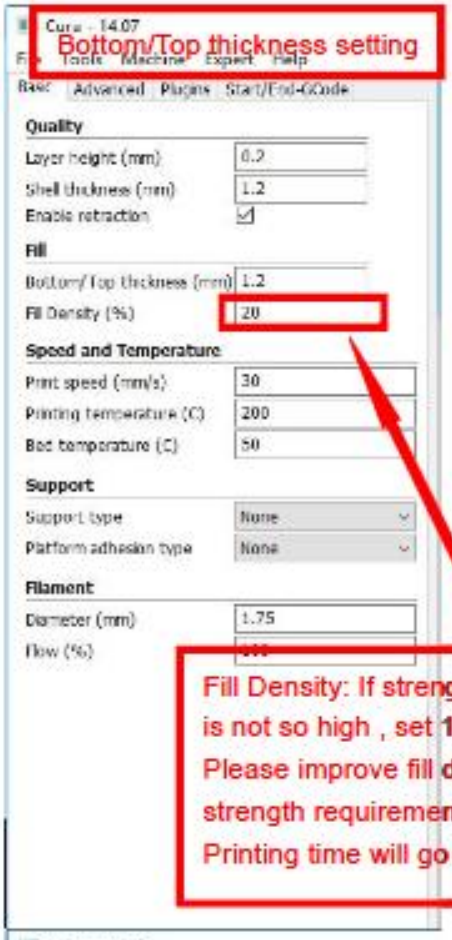


Bottom/Top thickness: 1.2mm

Under the same fill density



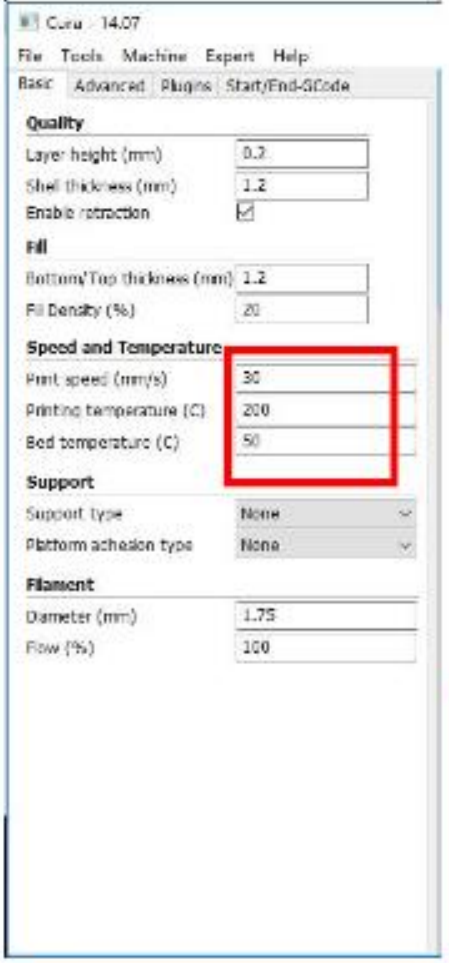
Bottom/Top thickness: 0.6mm

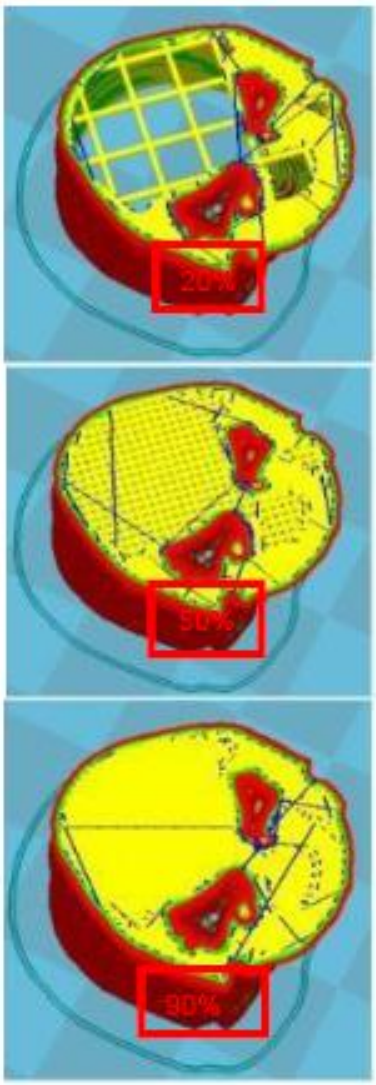


Bottom/Top thickness setting

Fill Density Setting

Fill Density: If strength requirement is not so high , set **10% is ok.**
Please improve fill **density when** strength requirement **gets higher.**
Printing time will go **up as well.**



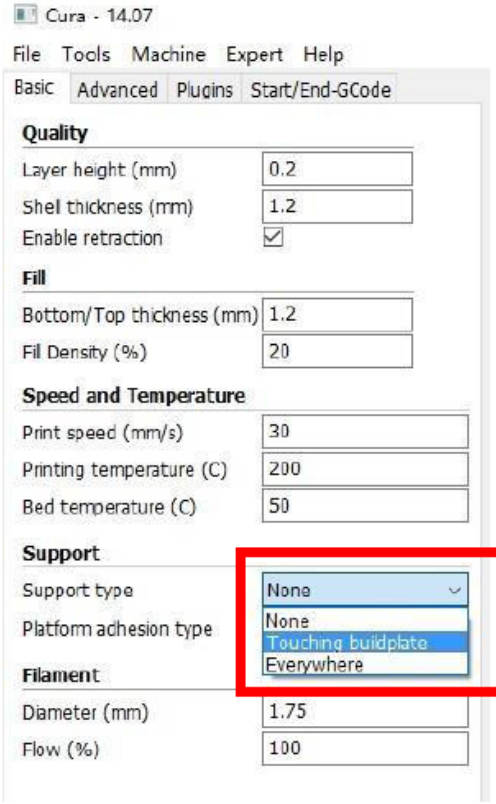


Printing Speed setting

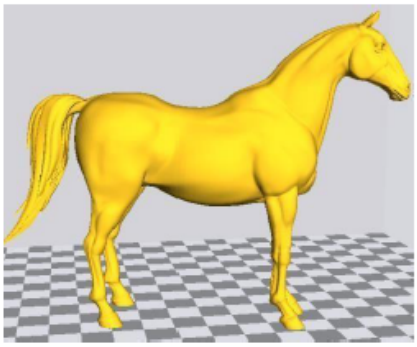
This is default speed. If other settings aren't changed, it prints more accurately while the printing process takes more time.
High printing speed takes less time while it cannot print accurately , making the model have bad quality.
Normally 40-60 print speed is suitable for printing.

Pringting Temperature

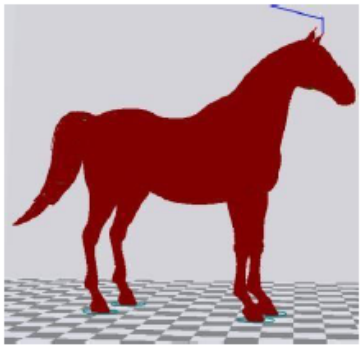
PLA filament temperature setting: nozzle: 190-210 ℃ hotbed: 40-60℃
ABS filament temperature setting: nozzle: 230-250℃ hotbed: 60-90℃
Please set higher temperature of nozzle when it prints fast and the thickness is big
Please set lower temerature of nozzle when it prints slow and the thickness is small



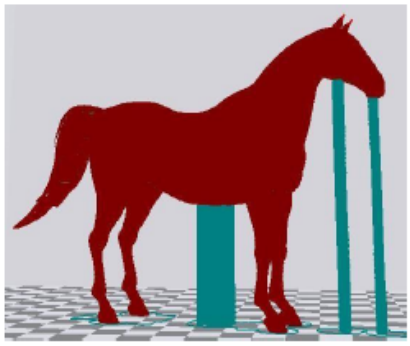
Support type setting



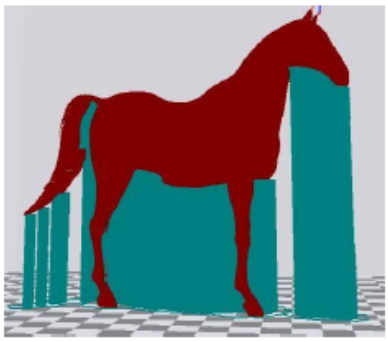
Original Model



Support type: None



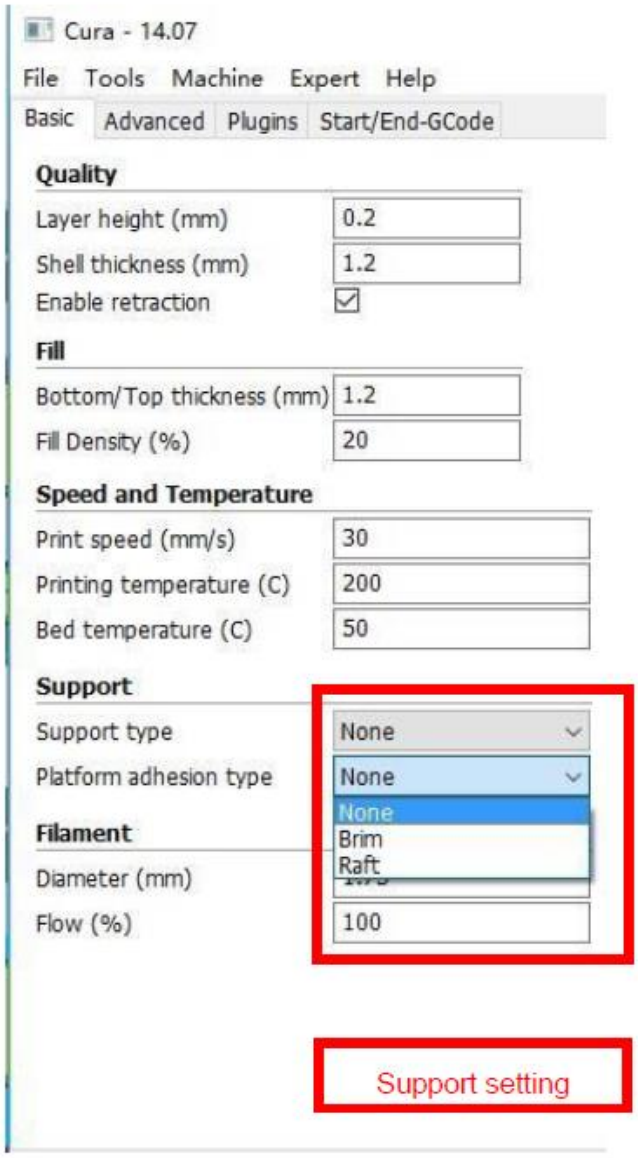
Support type: Touching

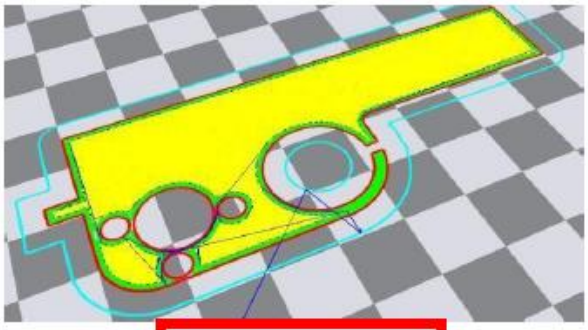


Support type: Everywhere

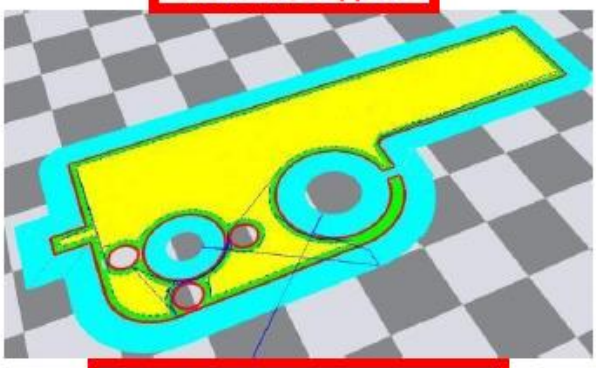
Attention: Normally we add support to complex model or model with vacant parts. It may have influence on the surface if you choose everywhere. You d better circle around the model and try to avoid unnecessary support



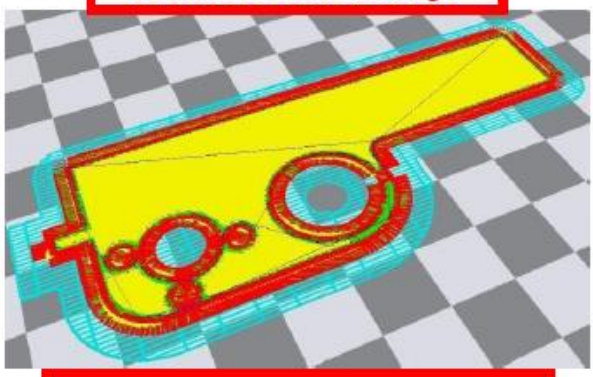




None: no support

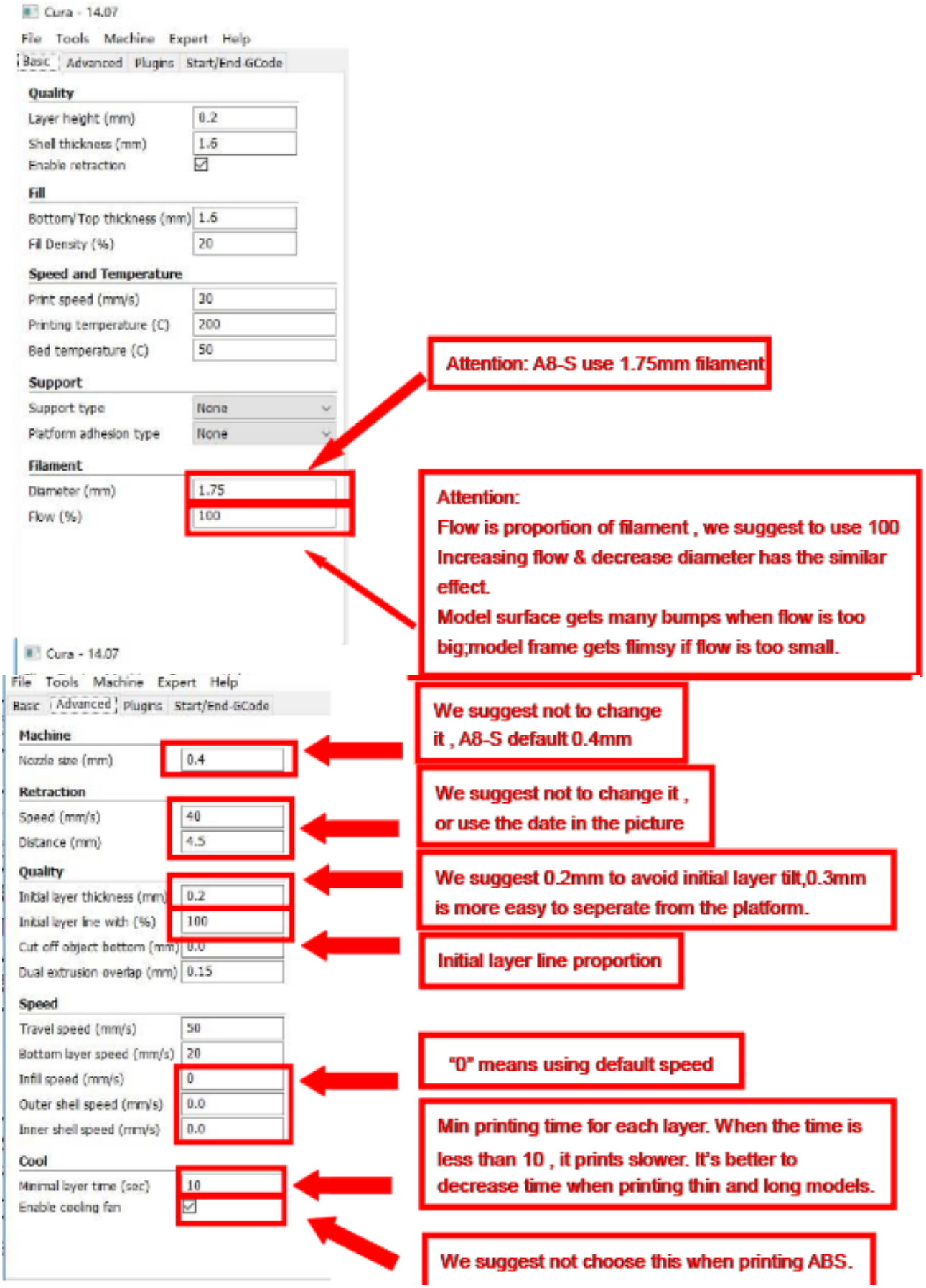


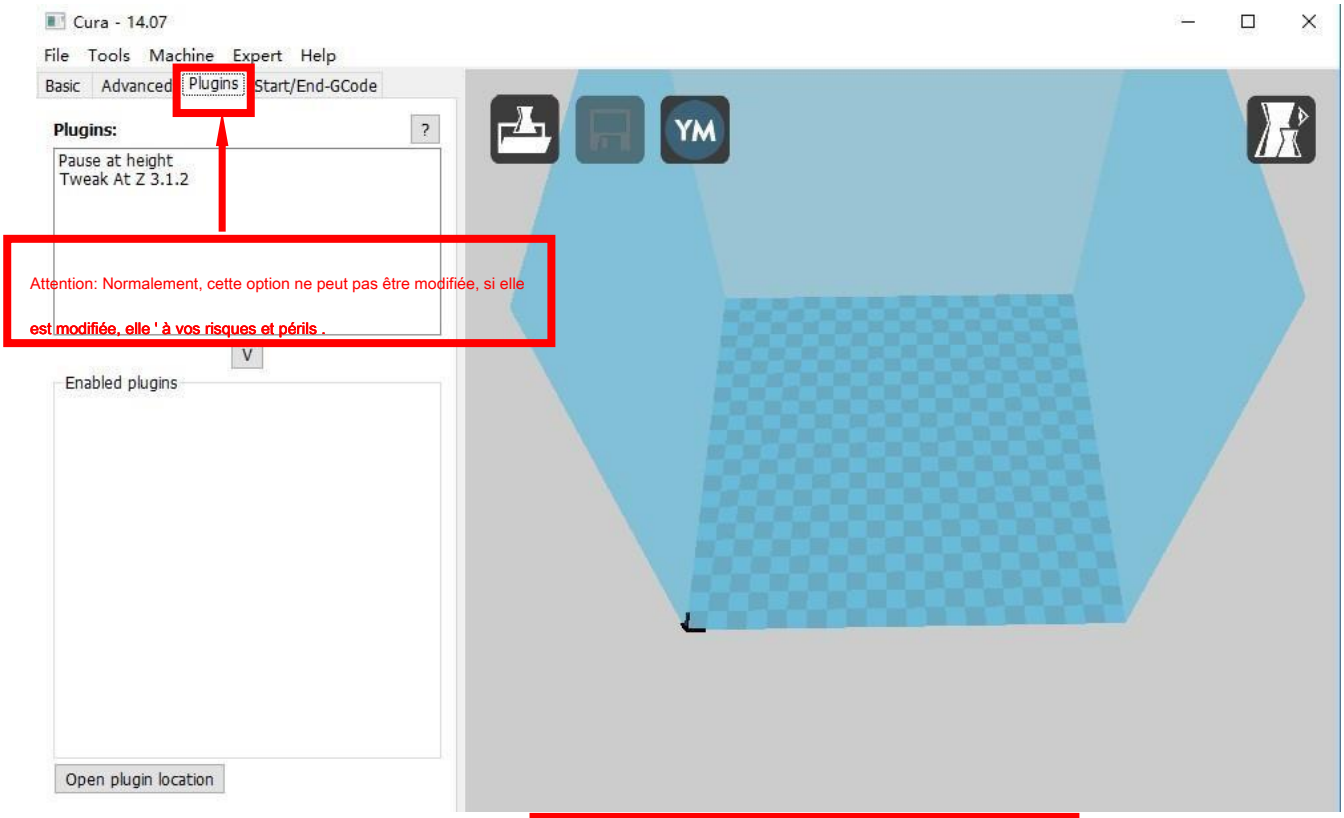
Brim:Touch with the adge

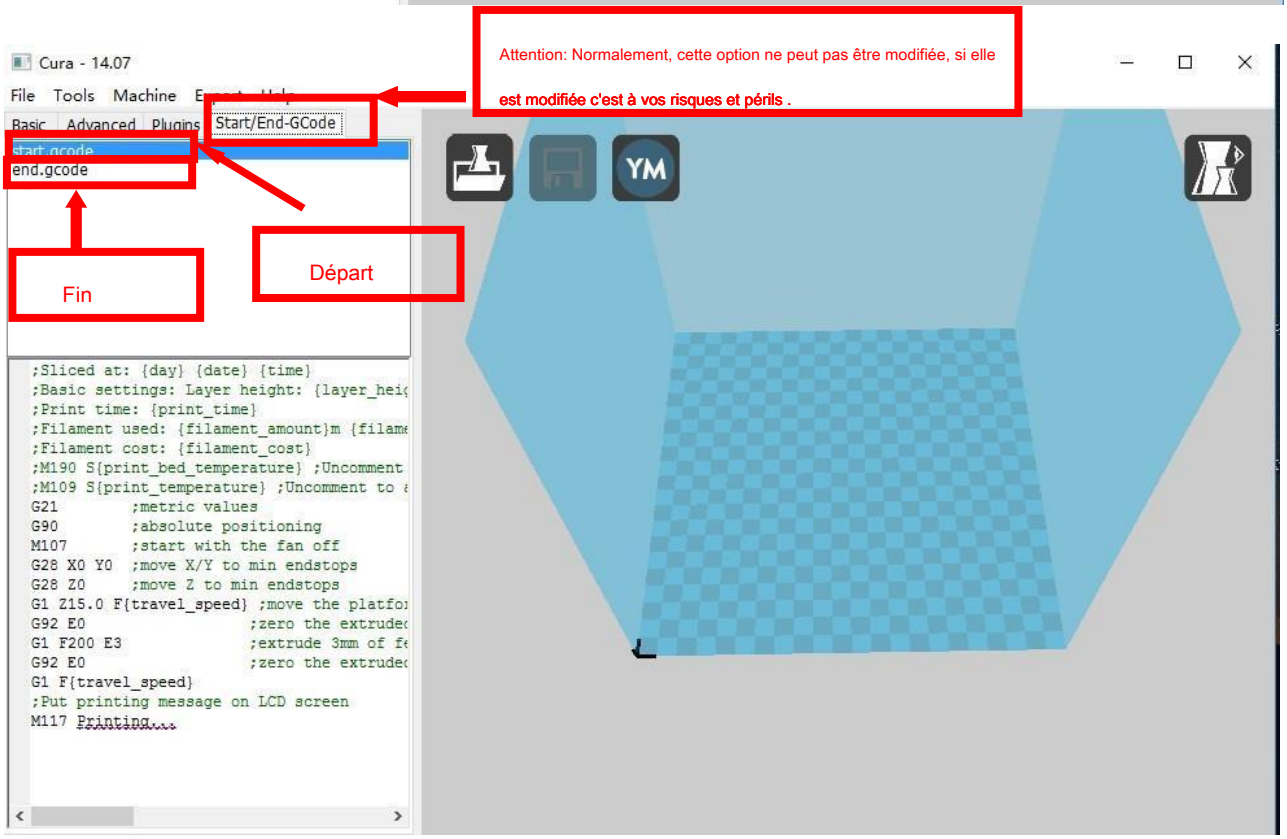


Raft: Totally touch with the bottom

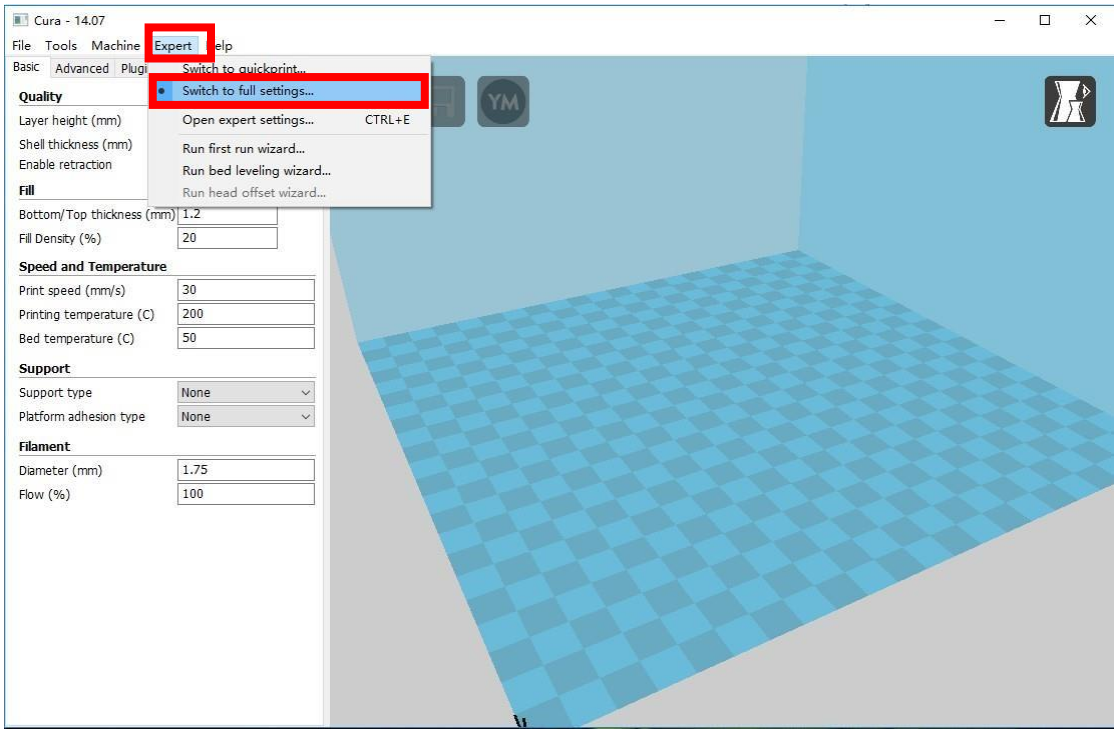
Attention: please choose None if the printing platform is ready and the high temperature adhesive tape is good. Please choose Brim when the model is small . Choosing Raft makes it difficult to seperate model from the platform

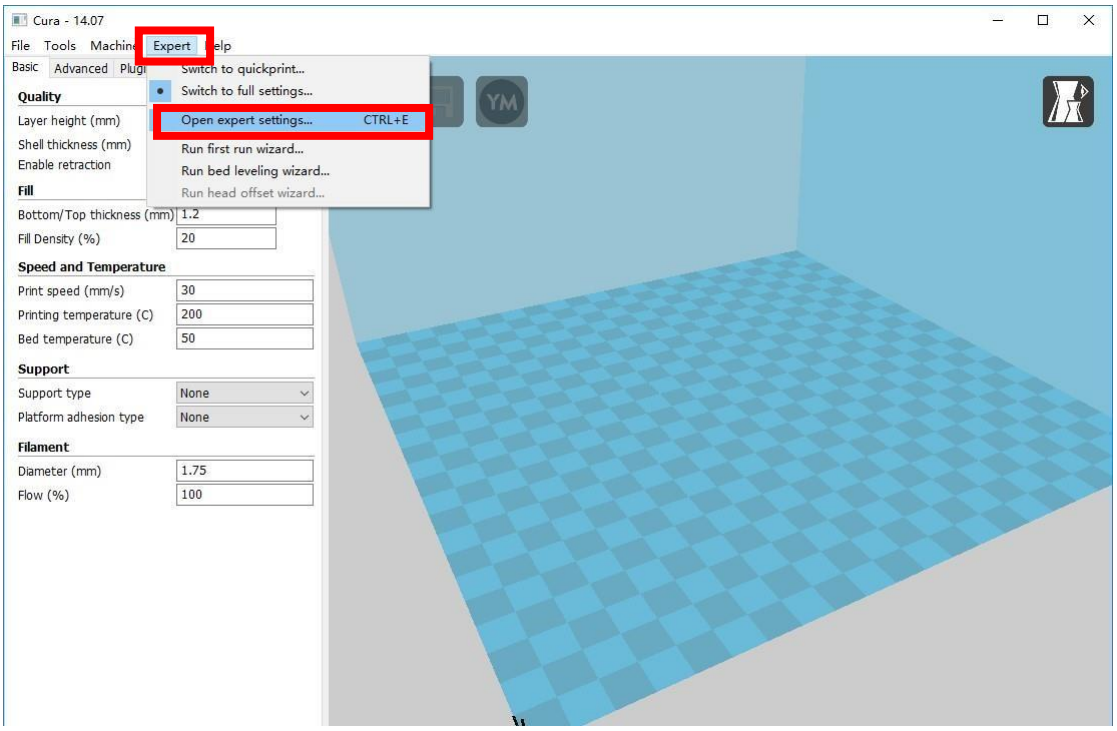

Cura - 14.07
File Tools Machine Expert Help
Basic Advanced Plugins Start/End-GCode
Quality
Layer height (mm) 0.2
Shell thickness (mm) 1.6
Enable retraction
Fill
Bottom/Top thickness (mm) 1.6
Fill Density (%) 20
Speed and Temperature
Print speed (mm/s) 30
Printing temperature (C) 200
Bed temperature (C) 50
Support
Support type None
Platform adhesion type None
Filament
Diameter (mm) 1.75
Flow (%) 100
Attention: A8-S use 1.75mm filament
Attention:
Flow is proportion of filament , we suggest to use 100
Increasing flow & decrease diameter has the similar effect.
Model surface gets many bumps when flow is too big;model frame gets flimsy if flow is too small.
Cura - 14.07
File Tools Machine Expert Help
Basic Advanced Plugins Start/End-GCode
Machine
Nozzle size (mm) 0.4
Retraction
Speed (mm/s) 40
Distance (mm) 4.5
Quality
Initial layer thickness (mm) 0.2
Initial layer line with (%) 100
Cut off object bottom (mm) 0.0
Dual extrusion overlap (mm) 0.15
Speed
Travel speed (mm/s) 50
Bottom layer speed (mm/s) 20
Infill speed (mm/s) 0
Outer shell speed (mm/s) 0.0
Inner shell speed (mm/s) 0.0
Cool
Minimal layer time (sec) 10
Enable cooling fan
We suggest not to change it , A8-S default 0.4mm
We suggest not to change it , or use the date in the picture
We suggest 0.2mm to avoid initial layer tilt,0.3mm is more easy to seperate from the platform.
Initial layer line proportion
"0" means using default speed
Min printing time for each layer. When the time is less than 10 , it prints slower. It's better to decrease time when printing thin and long models.
We suggest not choose this when printing ABS.

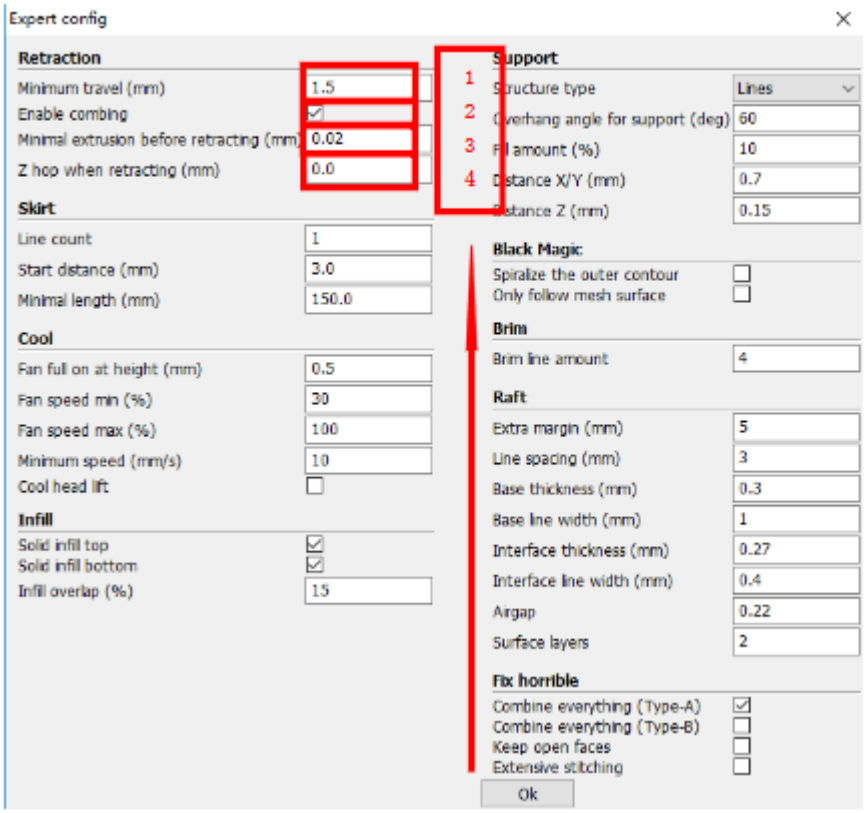

Cura - 14.07
File Tools Machine Expert Help
Basic Advanced Plugins Start/End-GCode
Plugins:
?
Pause at height
Tweak At Z 3.1.2
Attention: Normalement, cette option ne peut pas être modifiée, si elle
est modifiée, elle ' à vos risques et périls .
V
Enabled plugins
Open plugin location
YM


Attention: Normalement, cette option ne peut pas être modifiée, si elle
est modifiée c'est à vos risques et périls .
Cura - 14.07
File Tools Machine
Basic Advanced Plugins Start/End-GCode
end.gcode
Fin
Départ
;Sliced at: {day} {date} {time}
;Basic settings: Layer height: {layer_heig
;Print time: {print_time}
;Filament used: {filament_amount}m {filame
;Filament cost: {filament_cost}
;M190 S{print_bed_temperature} ;Uncomment
;M109 S{print_temperature} ;Uncomment to
G21 ;metric values
G90 ;absolute positioning
M107 ;start with the fan off
G28 X0 Y0 ;move X/Y to min endstops
G28 Z0 ;move Z to min endstops
G1 Z15.0 F{travel_speed} ;move the platfo
G92 E0 ;zero the extrude
G1 F200 E3 ;extrude 3mm of fe
G92 E0 ;zero the extrude
G1 F{travel_speed}
;Put printing message on LCD screen
M117 Printing...
YM

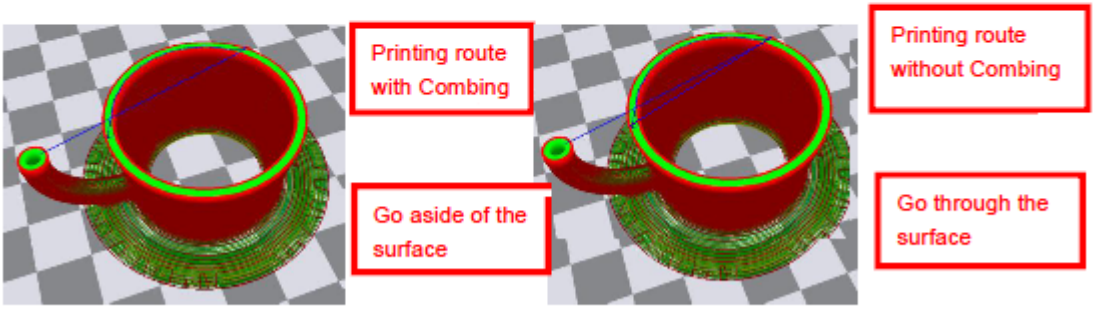
3. Réglage de l'expert

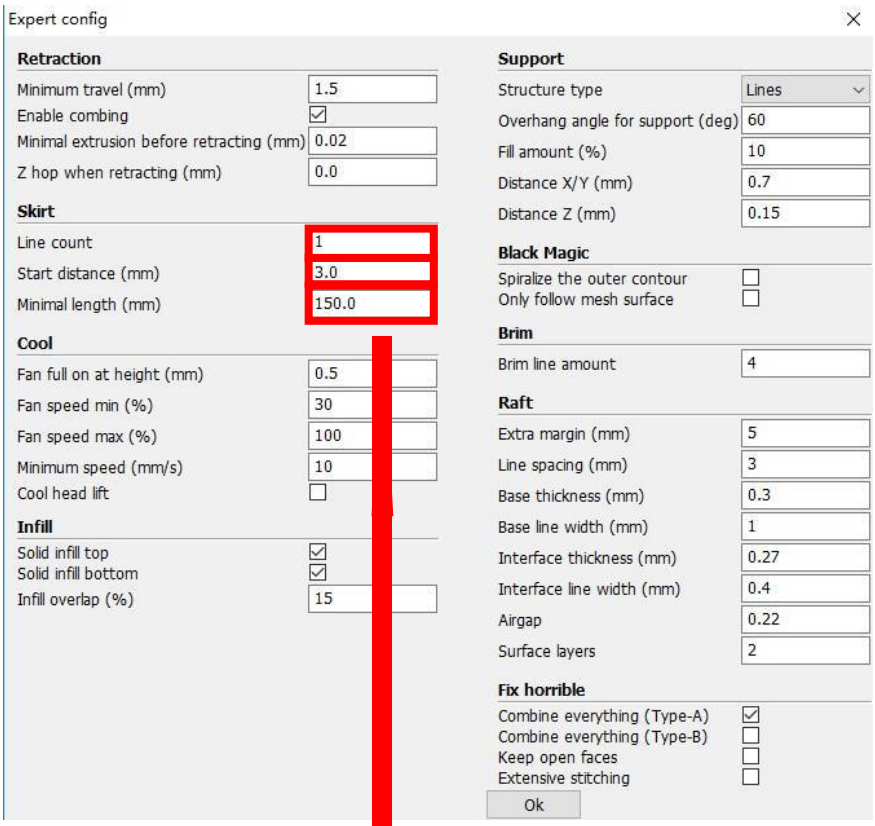






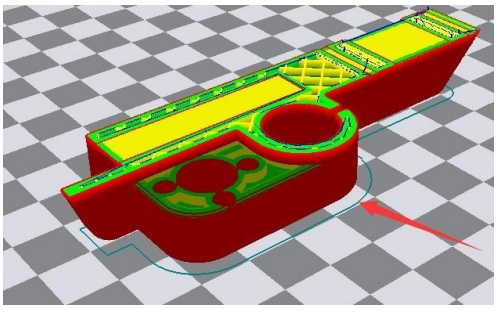
1. The minimum length before retraction . Used to avoid frequent retraction. No need to change.
2. Enable Combing: Digital for surface quality , the nozzle will try not to go through surface , that's why Cura is better than Slic3r.
3. Minimum extrusion length , to avoid frequent extrusion.





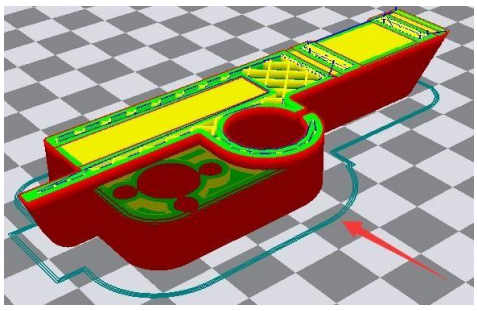
La jupe est pour éviter l'extrudeuse non rempli avant l'impression, et il n'apparaît que lorsque le type de pièce jointe de la plateforme est

Aucun. Normalement "1" est ok. Remplacez-le par «0» lorsque votre modèle atteint la taille maximale, ou la taille d'impression sera trop grande.



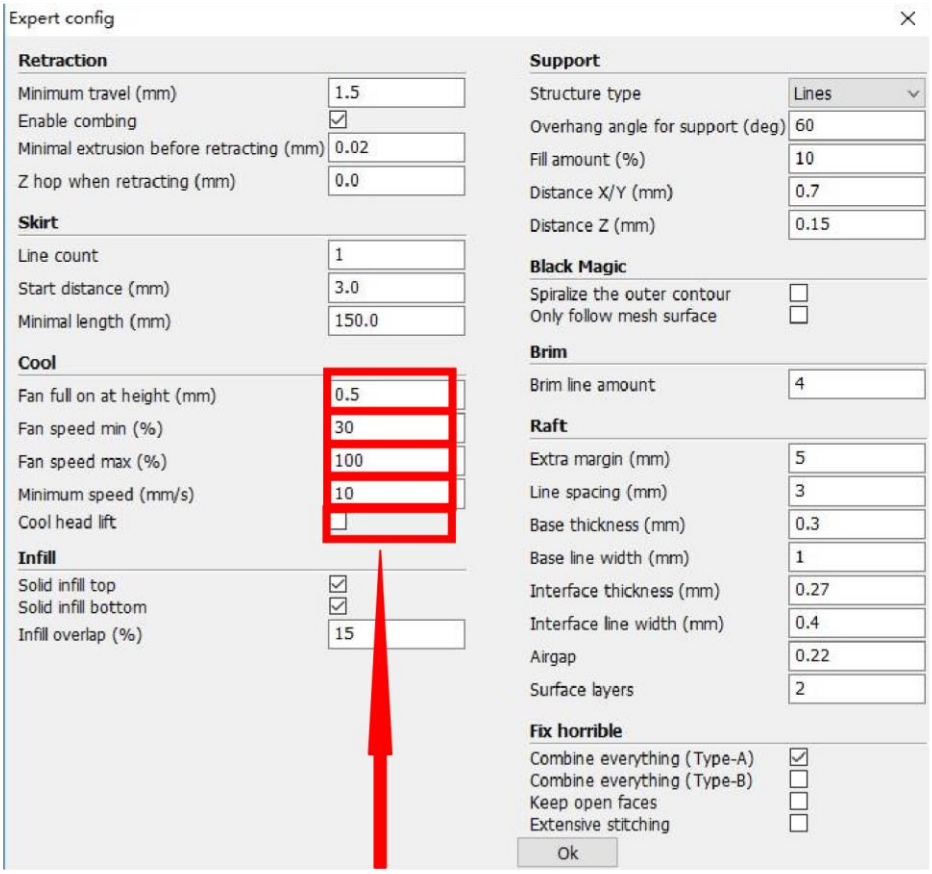
Quantité de ligne périphérique: 1 Distance

de départ: 3



Quantité de ligne périphérique: 1 Distance

de départ: 3



1. To ensure the attachment of model to platform , fan won't start at the beginning.

2-4. Fan speed min & max : If they are not equal , the soft ware will choose a suitable speed during them.

5. Condition to choose cool head lift : When it's printing with the minimum speed but still cannot reach the minimum time , you need to choose cool head lift . But it may cause filament leak.

Expert config

Retraction

Minimum travel (mm)	1.5
Enable combing	☑
Minimal extrusion before retracting (mm)	0.02
Z hop when retracting (mm)	0.0

Skirt

Line count	1
Start distance (mm)	3.0
Minimal length (mm)	150.0

Cool

Fan full on at height (mm)	0.5
Fan speed min (%)	30
Fan speed max (%)	100
Minimum speed (mm/s)	10
Cool head lift	☐

Infill

Solid infill top	☑
Solid infill bottom	☑
Infill overlap (%)	15

Support

Structure type	Lines
Overhang angle for support (deg)	60
Fill amount (%)	10
Distance X/Y (mm)	0.7
Distance Z (mm)	0.15

Black Magic

Spiralize the outer contour	☐
Only follow mesh surface	☐

Brim

Brim line amount	4

Raft

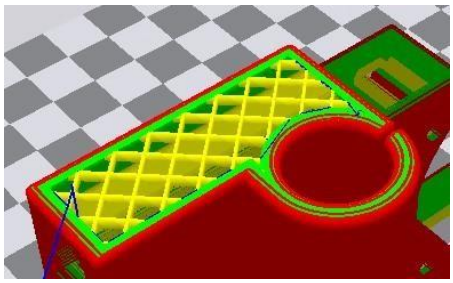
Extra margin (mm)	5
Line spacing (mm)	3
Base thickness (mm)	0.3
Base line width (mm)	1
Interface thickness (mm)	0.27
Interface line width (mm)	0.4
Airgap	0.22
Surface layers	2

Fix horrible

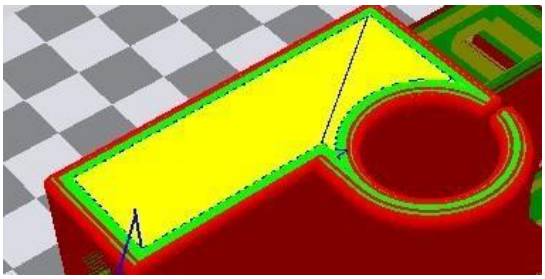
Combine everything (Type-A)	☑
Combine everything (Type-B)	☐
Keep open faces	☐
Extensive stitching	☐

Ok

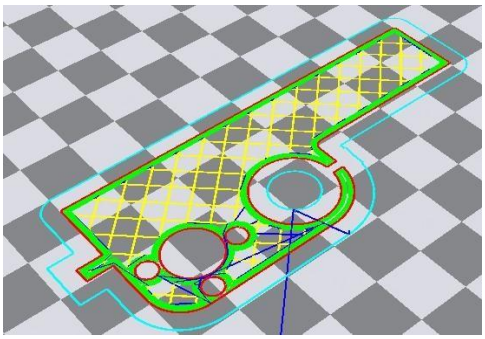
Si aucun dessus de remplissage solide, la seule qualification est la surface épaisseur.



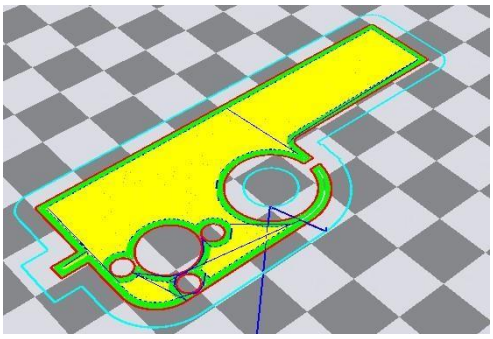
Aucun haut de remplissage solide



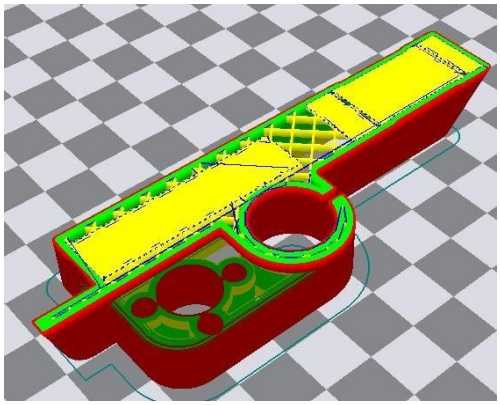
Avec plateau de remplissage solide



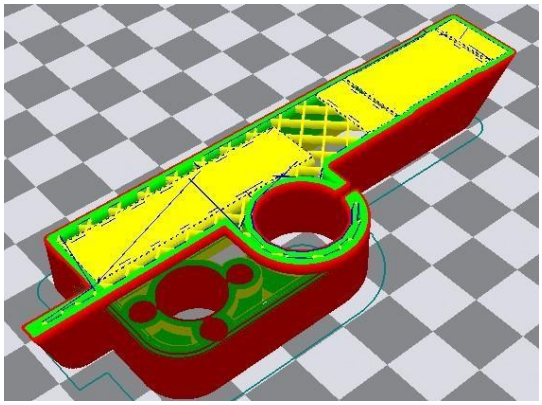
Pas de fond de remplissage solide



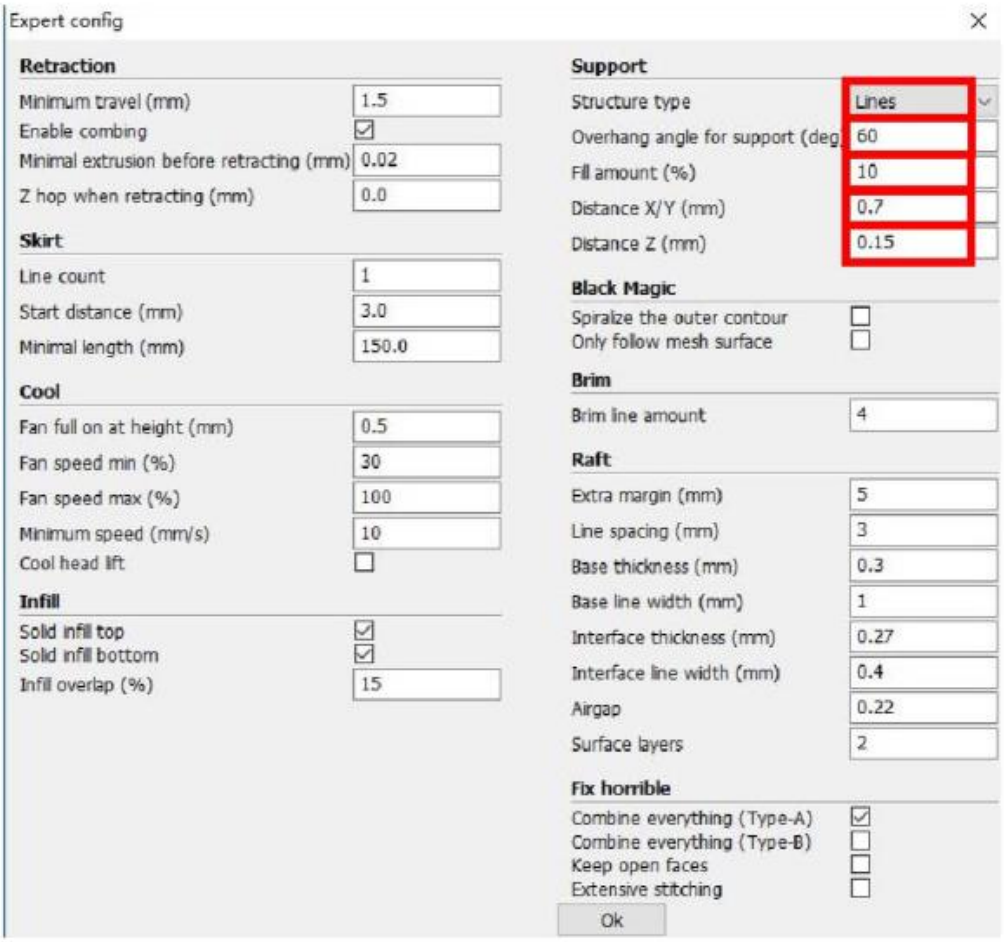
Avec fond de remplissage solide

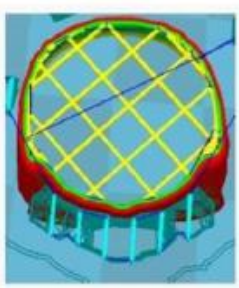


Couverture de remplissage: 20

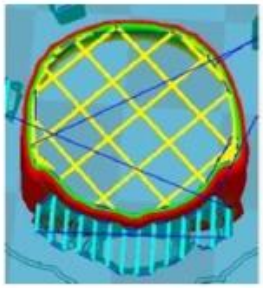


Couverture de remplissage: 40

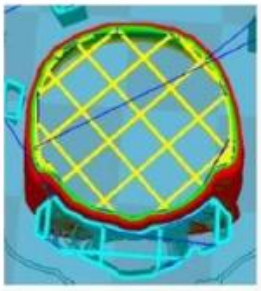




Structure types:lines
Infill covertap: 15
Distance X/Y: 0.7

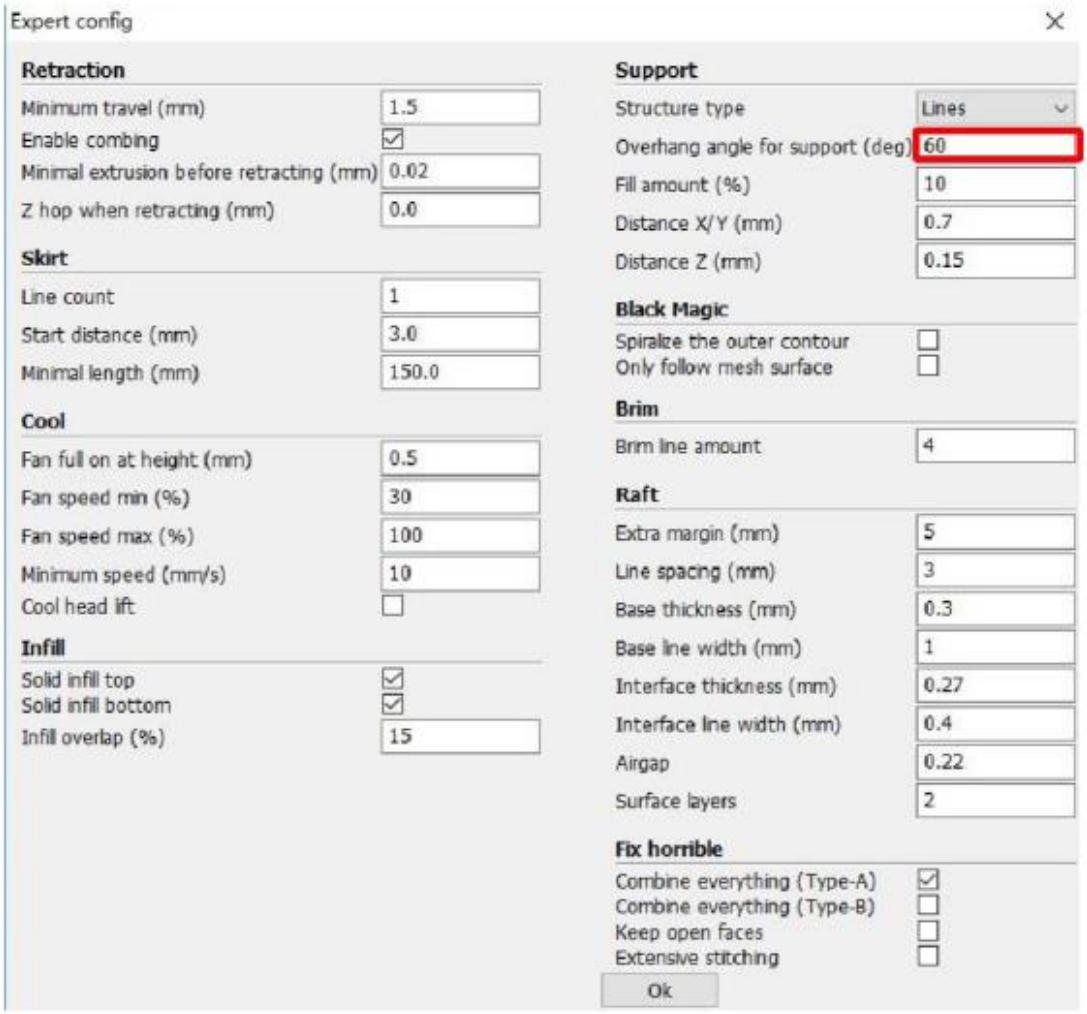


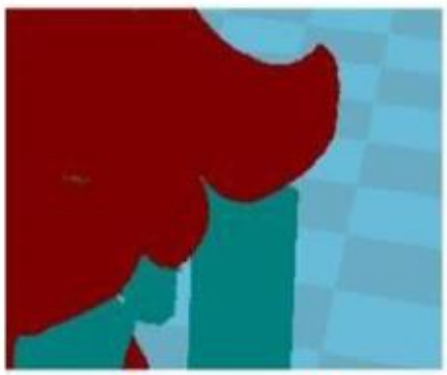
Structure types:lines
Infill covertap: 30
Distance X/Y: 0.7



Structure types:grids
Infill covertap: 15
Distance X/Y: 0.7

These above are examples , you can set these options according to actual requirements. The biggest progress Cura has made is the kinds of support structure types , making it easier to seperate from the model.





60°



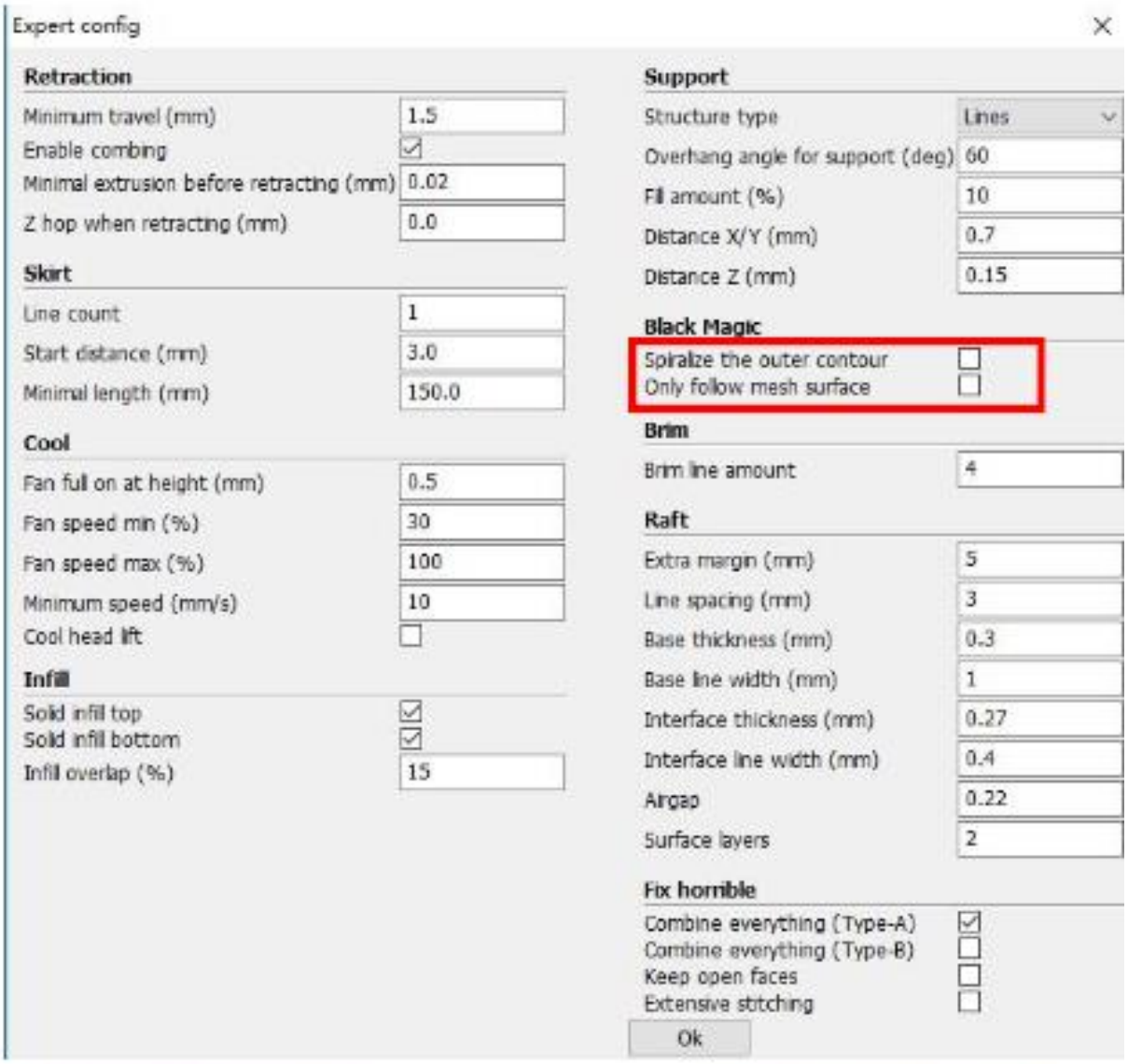
45°

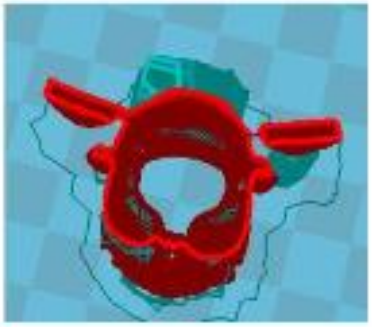


30°

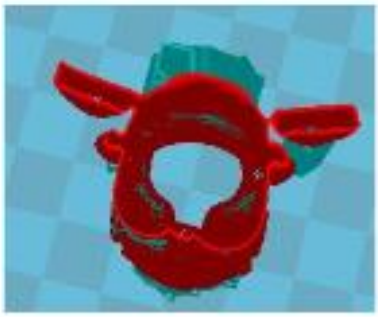
Il est difficile de se séparer si la distance entre le support et le lieu soutenu est trop proche; La surface sera influencée si la distance est trop éloignée.

Un angle différent générera un support différent, vous pouvez essayer les exemples que nous fournissons ci-dessus qui auront un effet différent.





When choosing "Spiralize the outer contour" : Z axis rises while X,Y axis moves , and only a hollow bottom and a single layer of surface.



When choosing "Only follow mesh surface" : The nozzle prints along the surface.

Attention: The software defaults not open the option above , you'd better not turn it on .

Expert config

Retraction

Minimum travel (mm)	1.5
Enable combing	☑
Minimal extrusion before retracting (mm)	0.02
Z hop when retracting (mm)	0.0

Skirt

Line count	1
Start distance (mm)	3.0
Minimal length (mm)	150.0

Cool

Fan full on at height (mm)	0.5
Fan speed min (%)	30
Fan speed max (%)	100
Minimum speed (mm/s)	10
Cool head lift	☐

Infill

Solid infill top	☑
Solid infill bottom	☑
Infill overlap (%)	15

Support

Structure type	Lines
Overhang angle for support (deg)	60
Fill amount (%)	10
Distance X/Y (mm)	0.7
Distance Z (mm)	0.15

Black Magic

Spralize the outer contour	☐
Only follow mesh surface	☐

Brim

Brim line amount	4

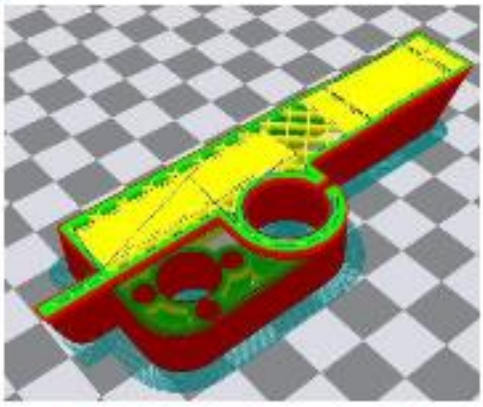
Raft

Extra margin (mm)	5
Line spacing (mm)	3
Base thickness (mm)	0.3
Base line width (mm)	1
Interface thickness (mm)	0.27
Interface line width (mm)	0.4
Airgap	0.22
Surface layers	2

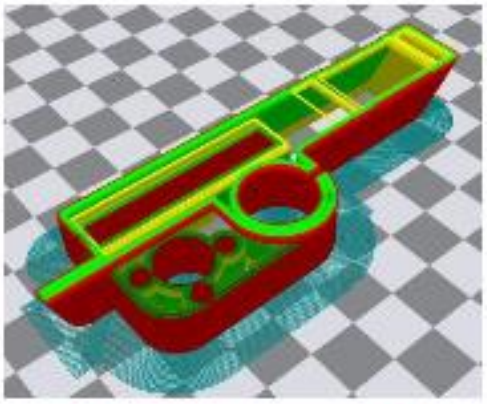
Fix horrible

Combine everything (Type-A)	☑
Combine everything (Type-B)	☐
Keep open faces	☐
Extensive stitching	☐

Ok

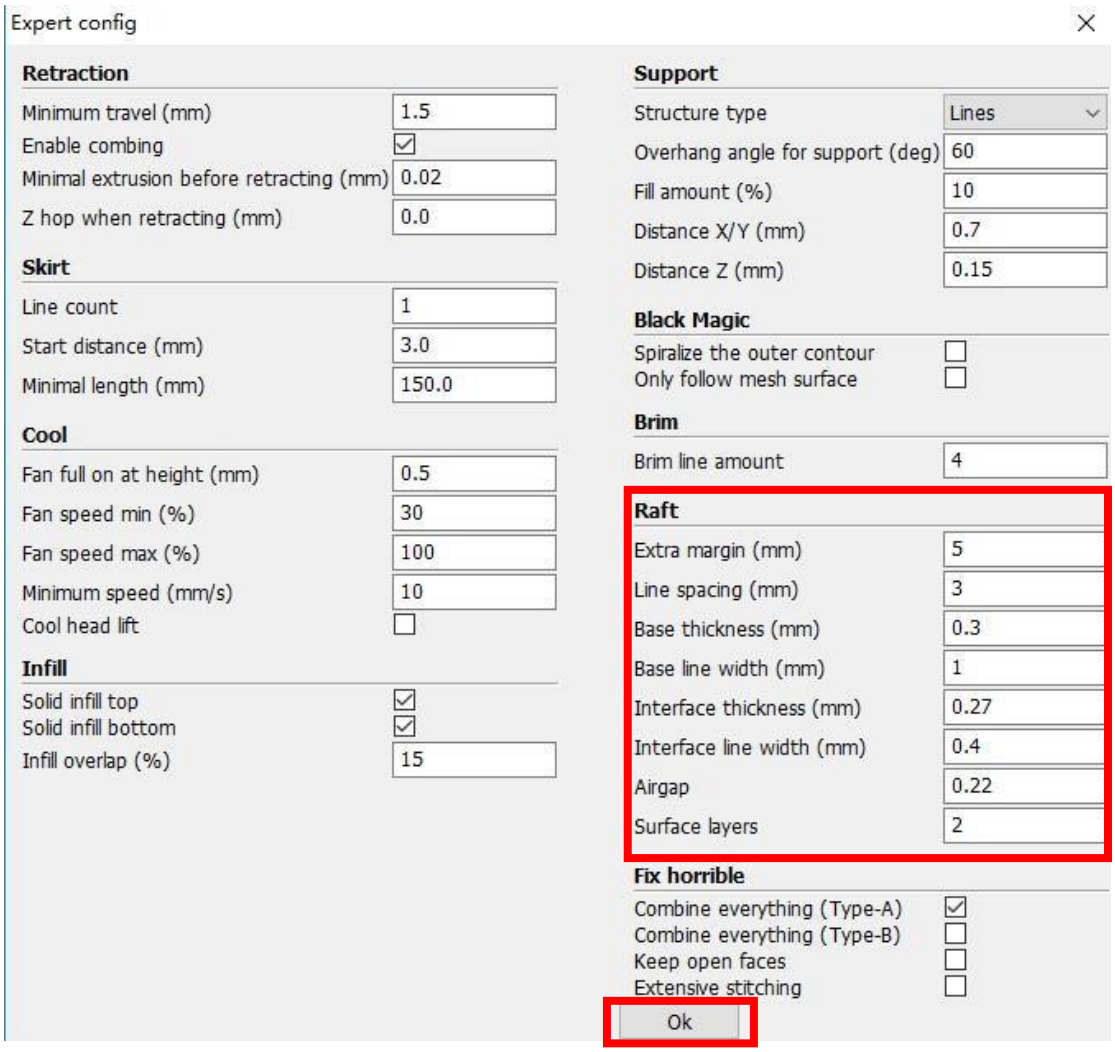


Brim line amount: 10



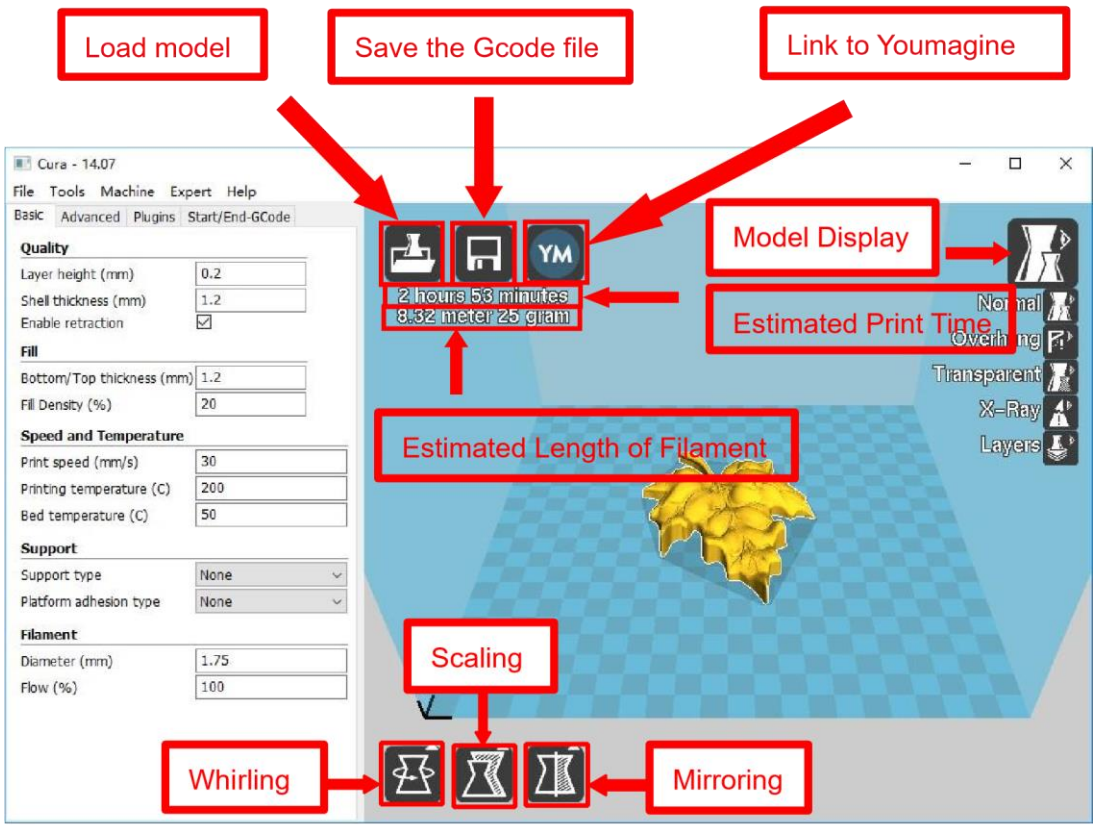
Brim line amount: 20

Guidance to use Brim if needed: Expert → Expert Settings → Support → Support Types → Birm.
The images above are only for reference , please set the parameter according to actual requirement.



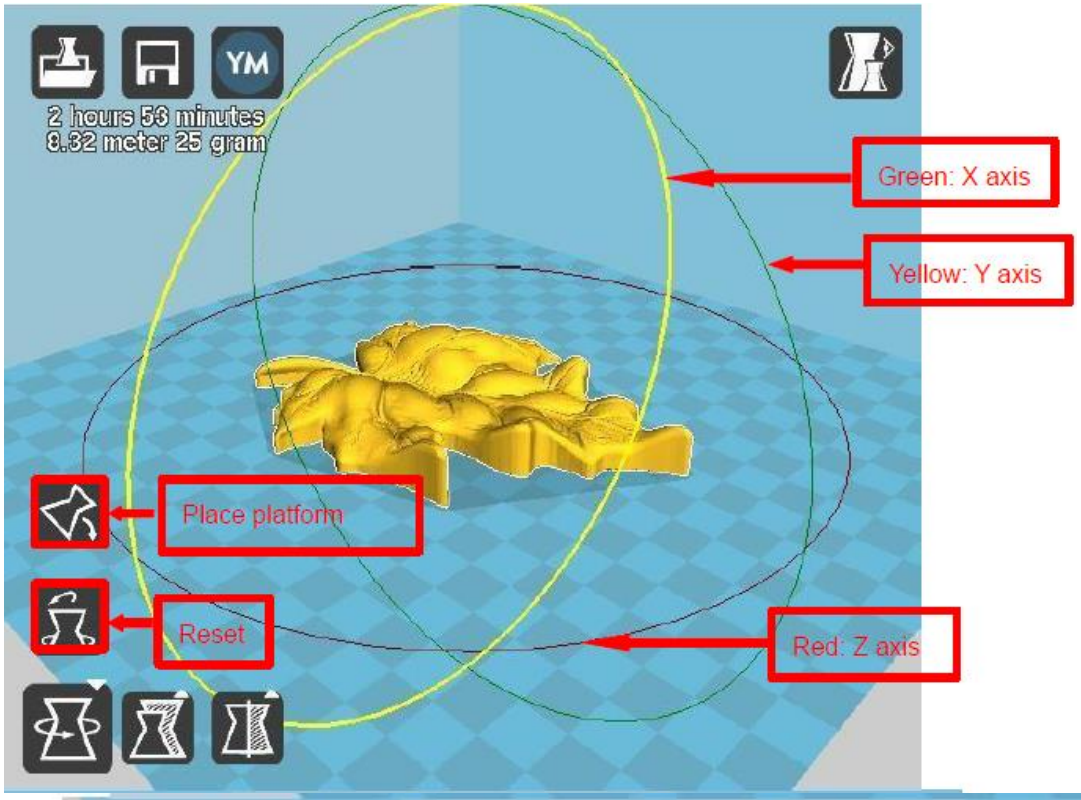
Conseils pour utiliser Raft si nécessaire: Expert → Paramètres experts → Support → Types de support → Radeau.

Les images ci-dessus sont uniquement à titre de référence, veuillez définir le paramètre en fonction des besoins réels.

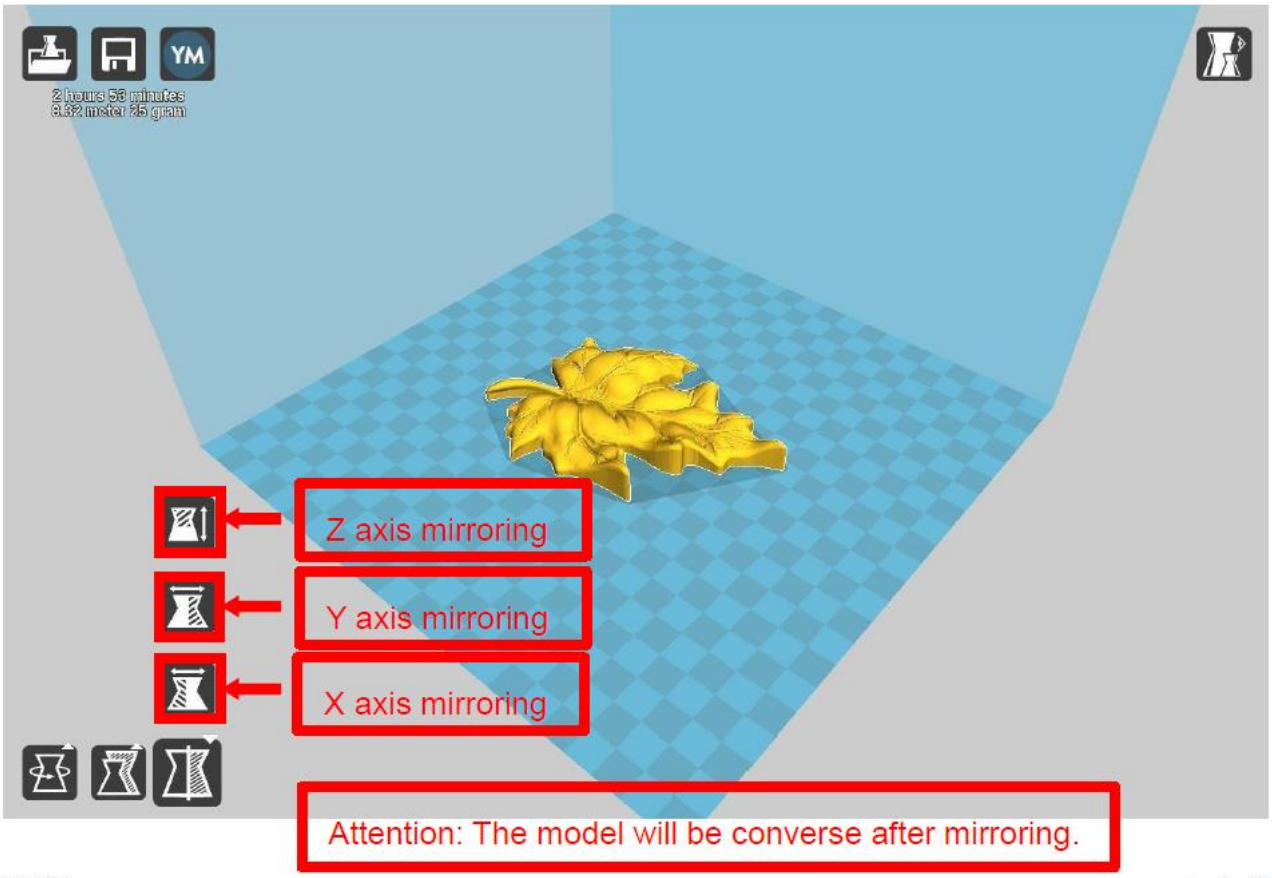


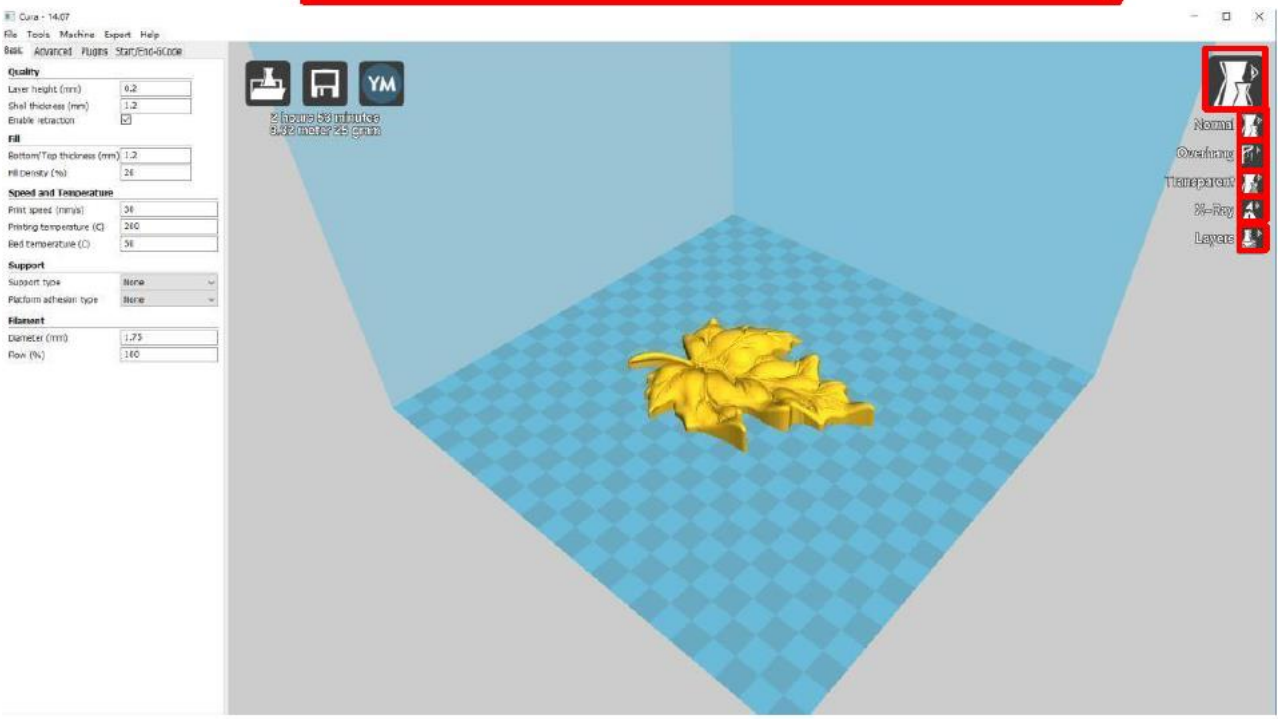
Left click the model and you will see the icon of “whirling, scaling, mirroring.

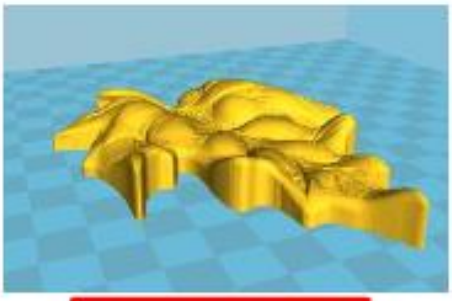
Left click to select model and move → move model.
Slide mouse wheel → scaling.
Right click to select model and move → whirling.
Shift + right click platform and move → move platform


2 hours 53 minutes
8.32 meter 25 gram
Green: X axis
Yellow: Y axis
Place platform
Reset
Red: Z axis

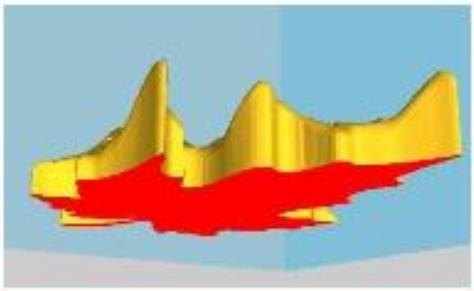

W, D, H: 84.0, 106.4, 13.9 mm
Zoom to max size
Scale X 1.0
Scale Y 1.0
Scale Z 1.0
Size X (mm) 84.0
Size Y (mm) 106.42
Size Z (mm) 13.92
Uniform scale
Scaling ratio
Modification ratio
Reset


2 hours 53 minutes
9.32 meter 25 gram
Z axis mirroring
Y axis mirroring
X axis mirroring
Attention: The model will be converse after mirroring.


Cura - 14.07
File Tools Machine Expert Help
Basic Advanced Plugins Start/End-GCode
Quality
Layer height (mm) 0.2
Shell thickness (mm) 1.2
Enable retraction
Fill
Bottom/Top thickness (mm) 1.2
Fill Density (%) 20
Speed and Temperature
Print speed (mm/s) 50
Printing temperature (C) 200
Bed temperature (C) 50
Support
Support type None
Platform adhesion type None
Filament
Diameter (mm) 1.75
Flow (%) 100
2 hours 53 minutes
9.32 meter 25 gram
Normal
Overhang
Transparent
X-Ray
Layers



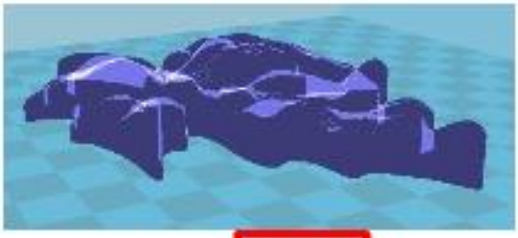
Normal: Most used.



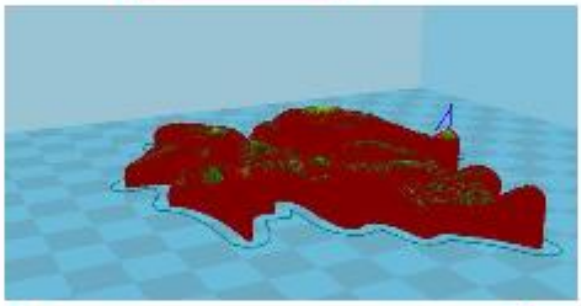
Overhang: Used to see the vacant part.



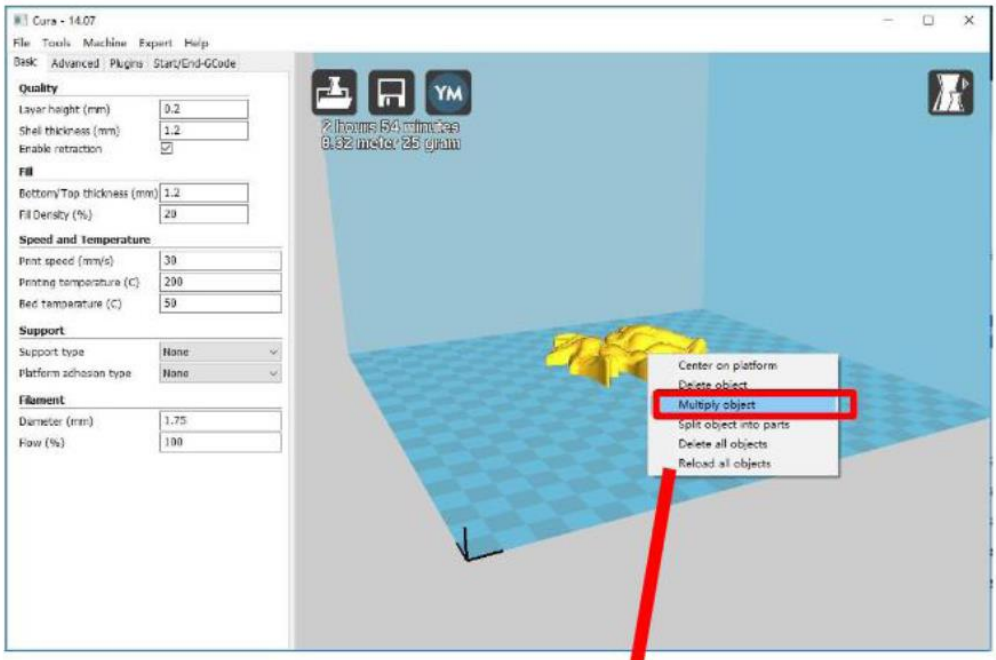
Transparent



X-Ray

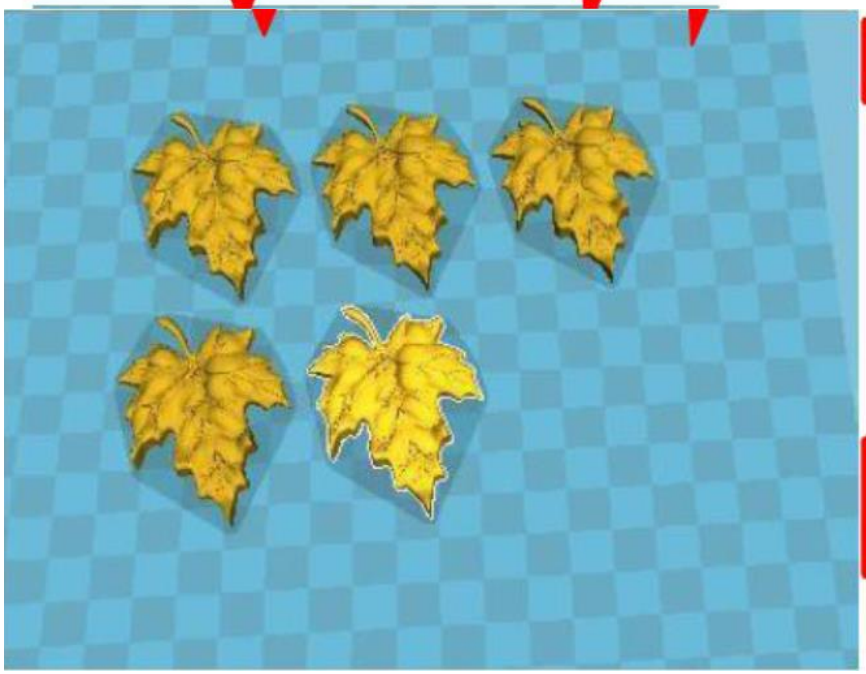


Layers:Used to simulate the effect of each layer and the path.



Right click model → Left click "Multiply object" → Example: copy 4 model

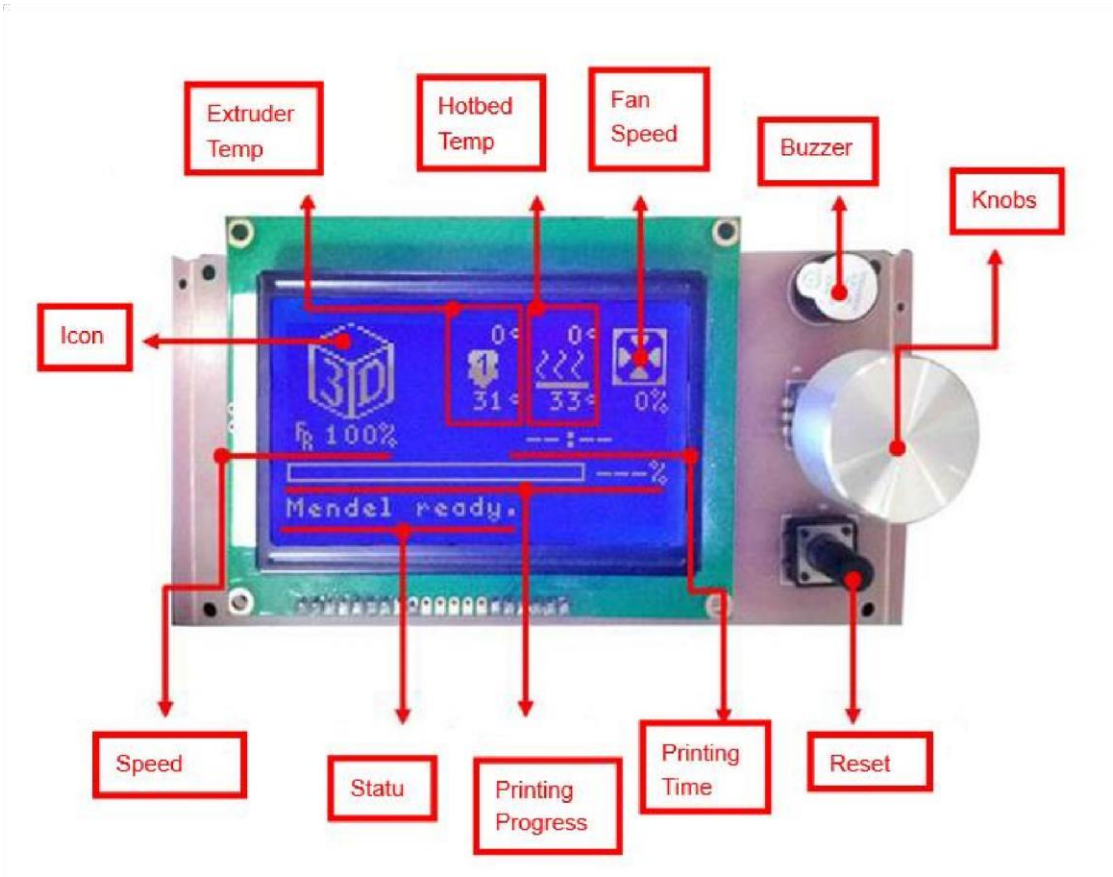




5 models in total

Attention: You can try other functions by yourself.

1.Interface Introduction

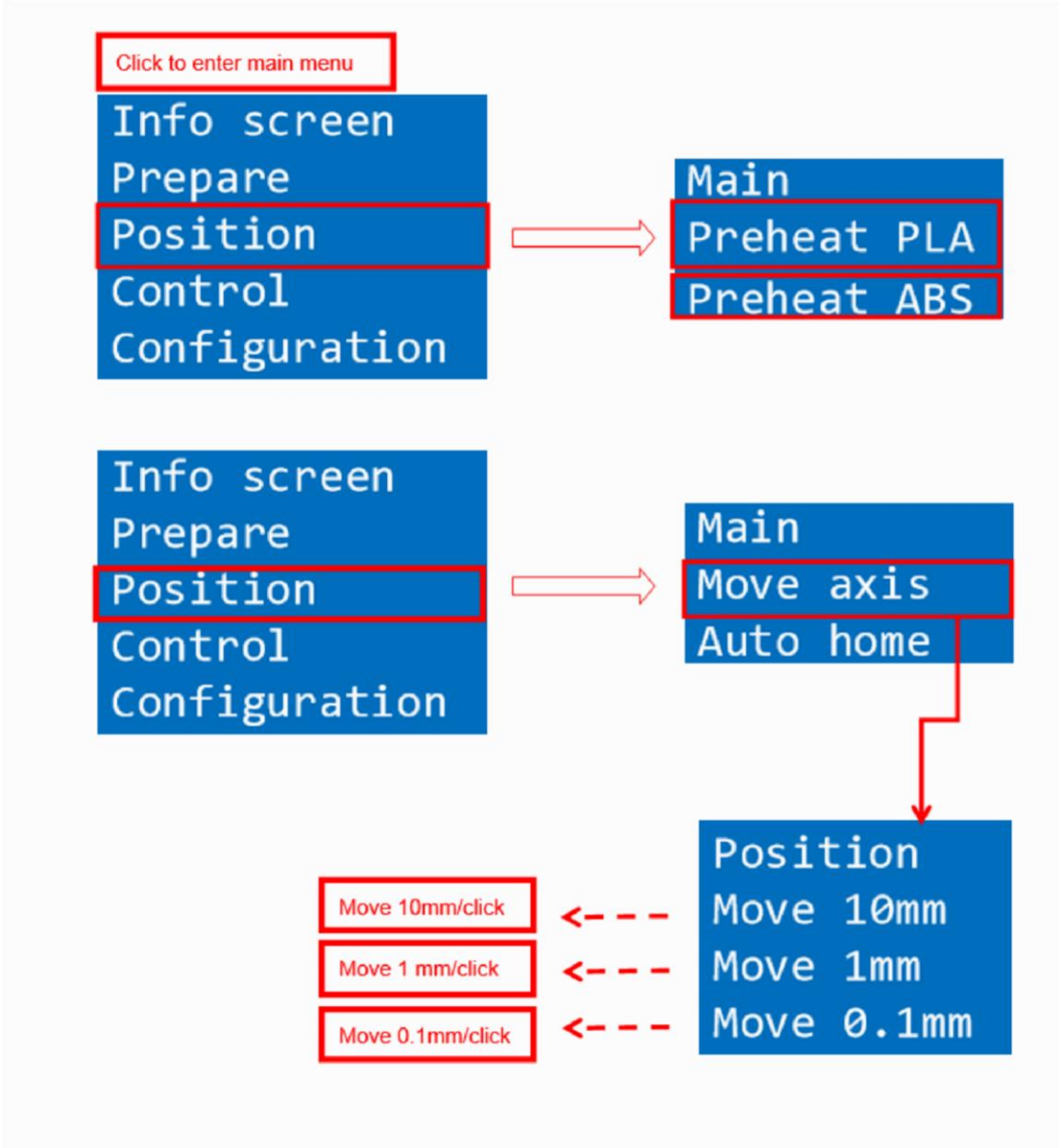


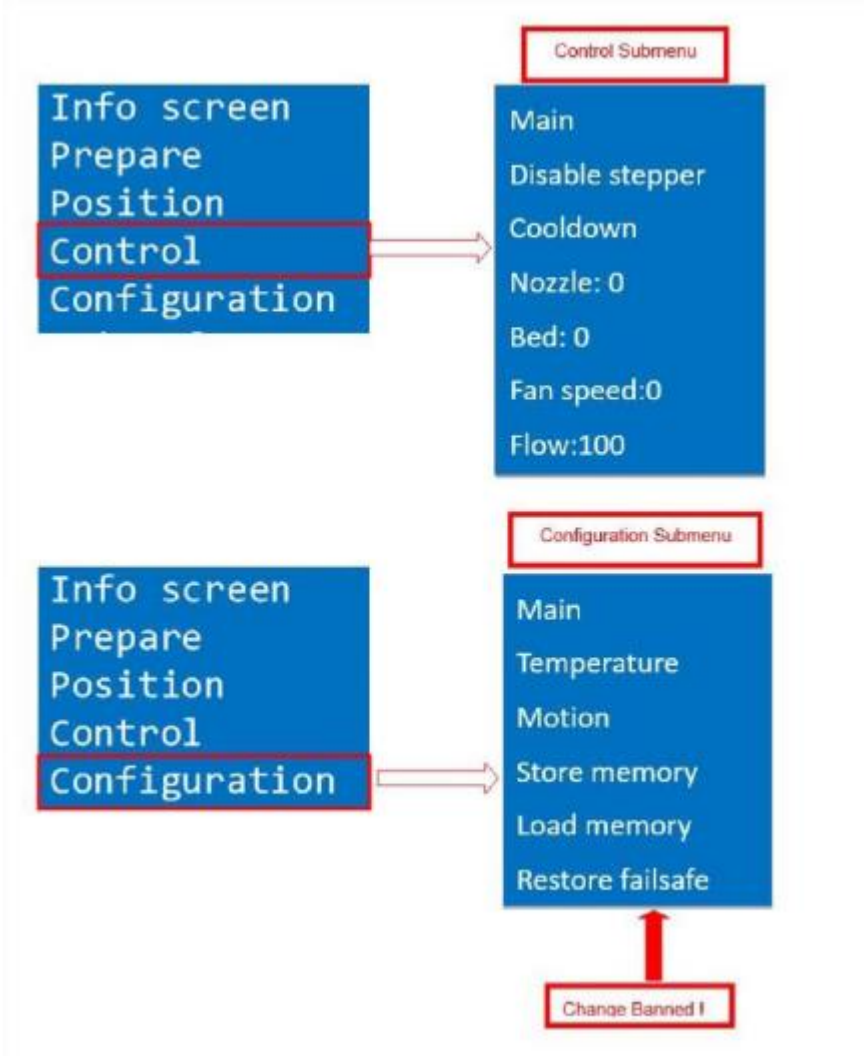


Click to enter main menu

Info screen
Prepare
Position
Control
Configuration
Print from SD
Change SD card

Main menu


Click to enter main menu
Info screen
Prepare
Position
Control
Configuration
Main
Preheat PLA
Preheat ABS
Info screen
Prepare
Position
Control
Configuration
Main
Move axis
Auto home
Position
Move 10mm
Move 1mm
Move 0.1mm
Move 10mm/click
Move 1 mm/click
Move 0.1mm/click

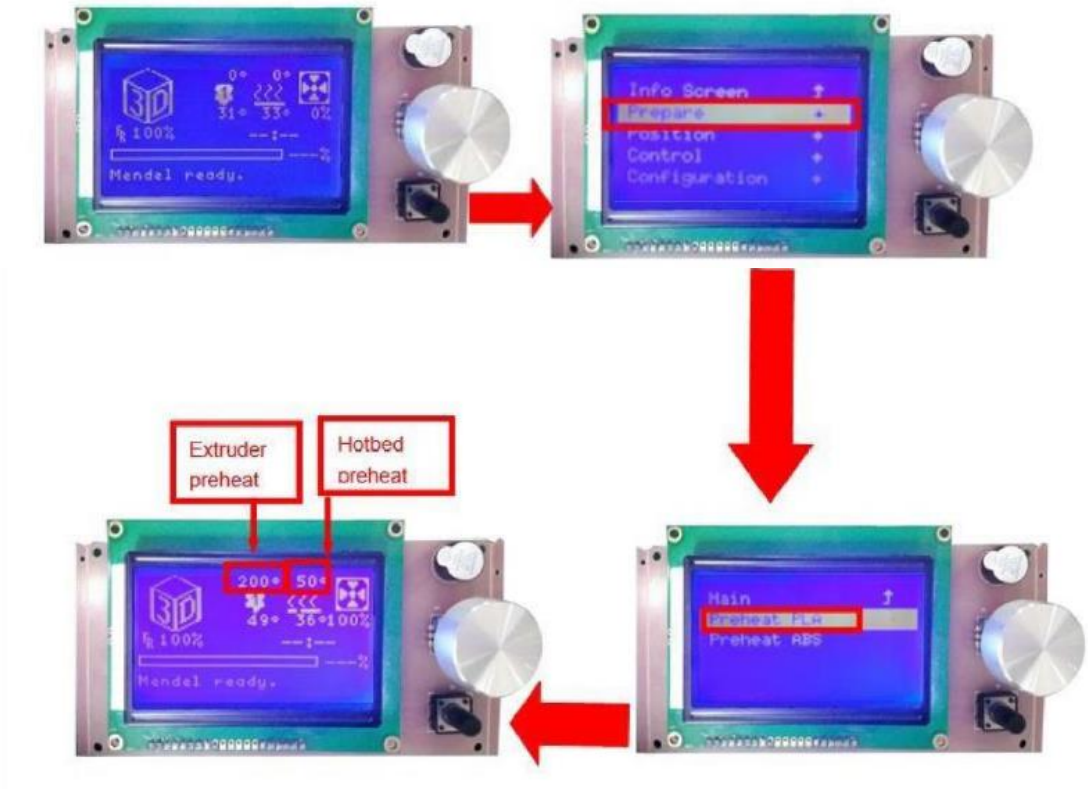

Control Submenu
Info screen
Prepare
Position
Control
Configuration
Main
Disable stepper
Cooldown
Nozzle: 0
Bed: 0
Fan speed:0
Flow:100
Configuration Submenu
Info screen
Prepare
Position
Control
Configuration
Main
Temperature
Motion
Store memory
Load memory
Restore failsafe
Change Banned !

2. Alimentation des filaments

2.1 Régler le préchauffage

Attention: Before filament installation, we need to preheat. Use PLA as example .

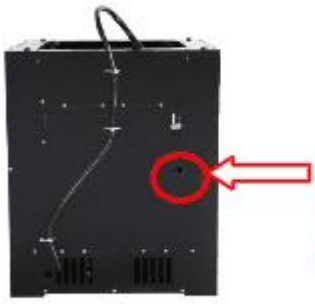
Press Knobs → Prepare → Preheat PAL → Start preheating



Attention: Please choose “Preheat ABS” if you want to print with ABS

2.2 Installation du filament

Install material rack: the material rack is installed on the right mounting hole of the rear panel of the machine. Use 2 M8 nuts to lock, then hang the material and lock the baffle.



The rear panel is mounted on the right



Material rack (specification: length 100mm)



baffle



M8 nut 2 shell



Outside the machine

Lock with the M8 nut

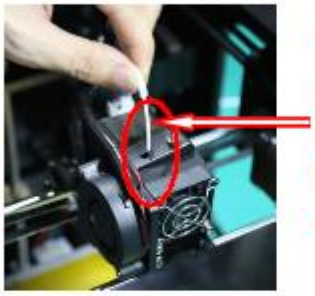


In machine

The precession depth is flat with the M8 nut



The white hose is the feed pipe, and all the materials are imported from here



The material is passed through the feed pipe and then moved on to the next step



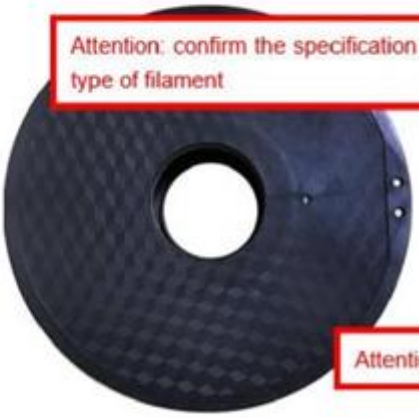
According to the direction of the material suspension, and lock baffle can

Attention: only when extruder temp reaches 200℃ can we put filament in the printer.

Confirm Extruder Temp has reached 190℃ → 1 roll PLA → Stroke the filament head straight → Press extruder screw.Meanwhile ,hold the white wind mouth → Meanwhile, stick filament into the extruder quickly until filament goes out from the nozzle → Filament installation succeed

①

Attention: confirm the specification & type of filament



Specification & type



Recommended printing temp

Attention: For A3-S printer we use 1.75mm filament

②

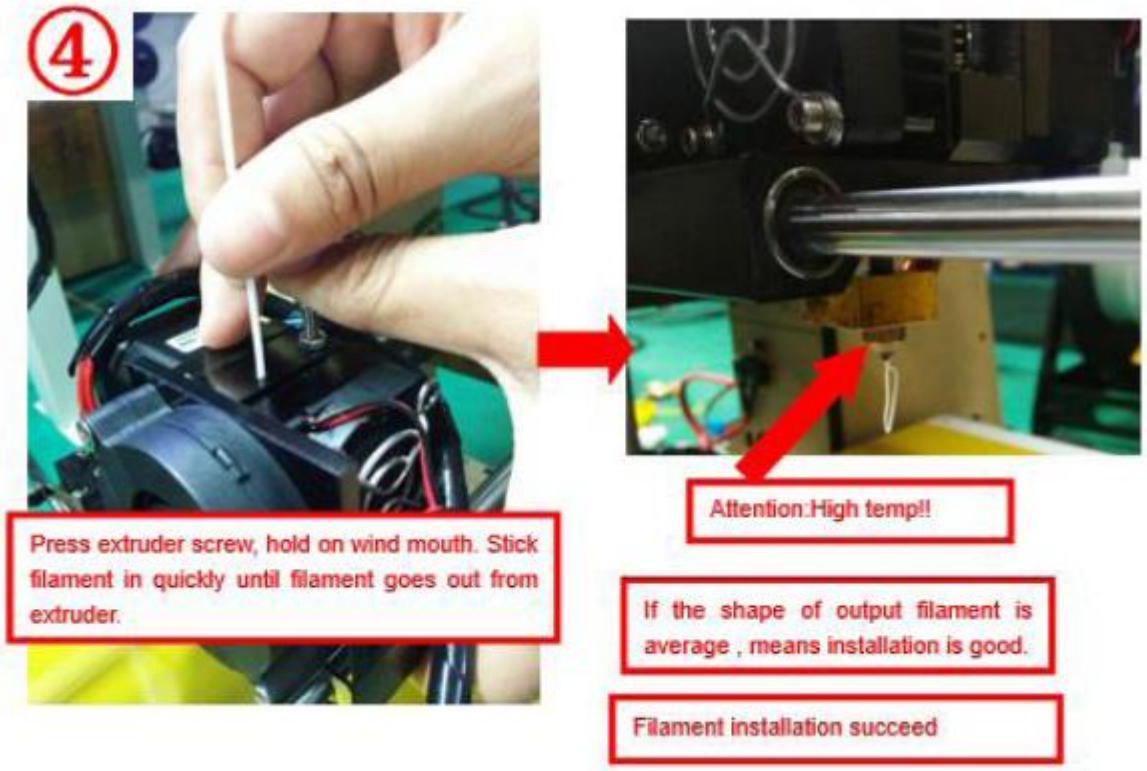
Attention: Install filament only when temp reaches 190℃

③

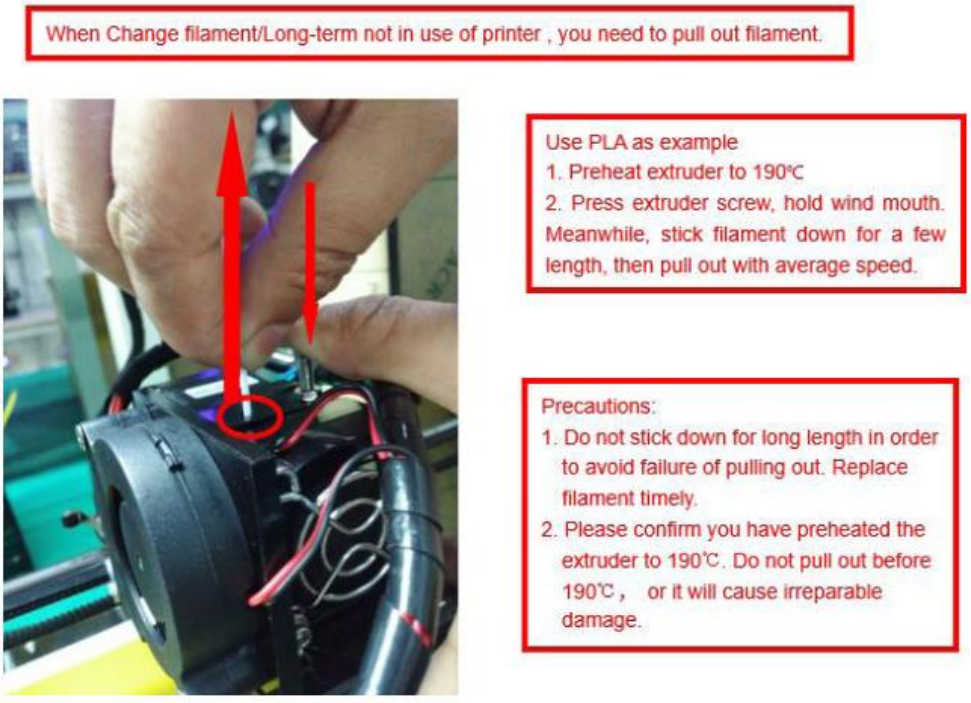
Stroke the filament head straight → Press extruder screw.Meanwhile ,hold the white wind mouth → Meanwhile, install filament into the extruder quickly until filament liquid goes out from the nozzle.



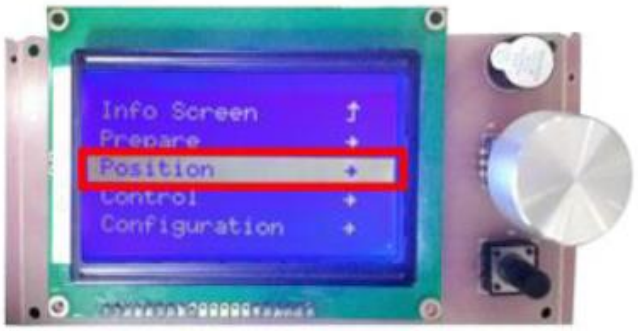




2.3 Extraire le filament



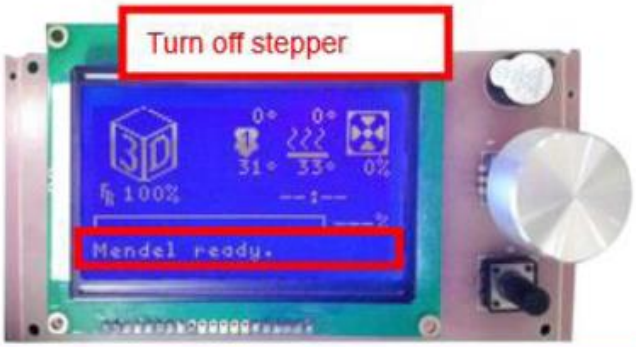
3.Platform Adjustment





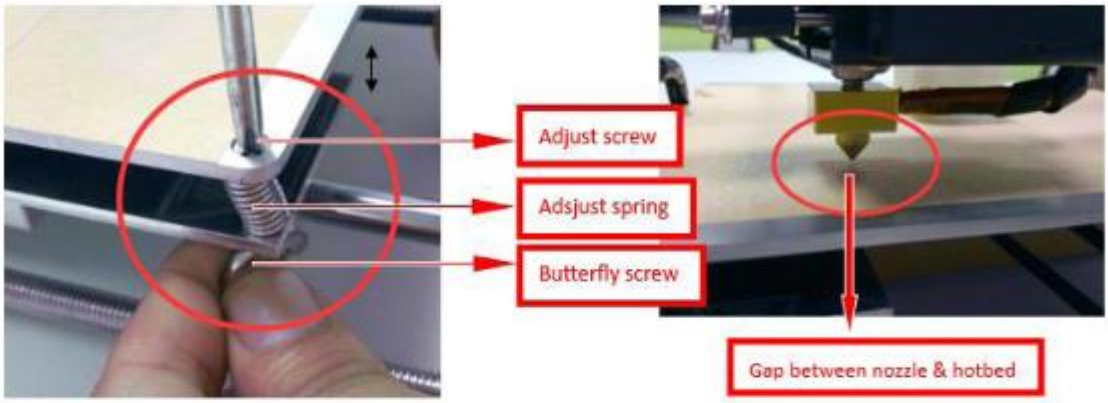
1. Choose “Position” → “Auto home” , printer will move to limited switch until it stops.



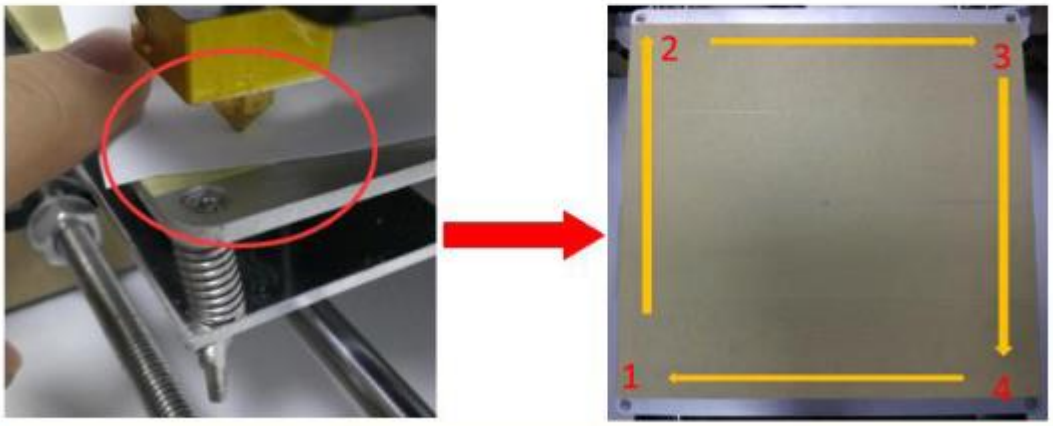


2. Turn off stepper motor: based on step 1 , enter “Quick settings” → “Disable stepper”

3. Please manually move nozzle to platform and check the gap between nozzle and platform.



4. When the gap is more than 2mm, you need to adjust the height of Z limited switch.
Example: When the gap is 12mm , you need to adjust limited switch down by 10mm.The rest 2mm can adjust by spring on the hotbed.



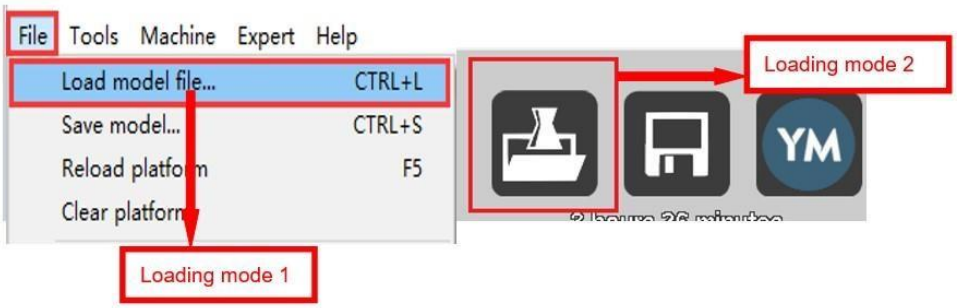
After adjustment of springs, reset printer and close stepper motor to test. Use A4 paper to test the gap.
Tips: When you are familiar with the printer with time going by, we can adjust while it's printing. It's because the printing speed is slow at the beginning so that there's enough time for adjustment. Meanwhile, the printing effect will be better.

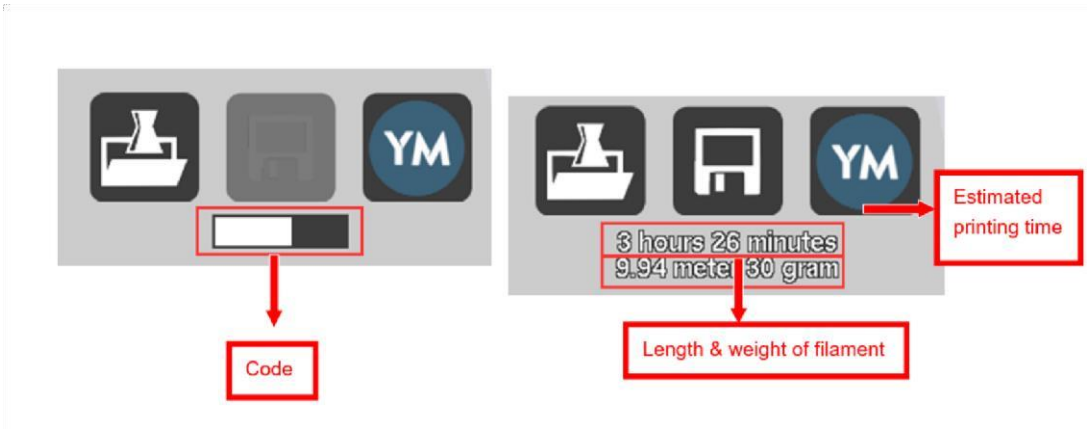
4. impression

1) Impression hors ligne de la carte SD a. Mode

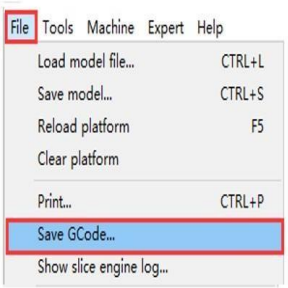
de chargement

Cura prend en charge les fichiers STL et G-code.



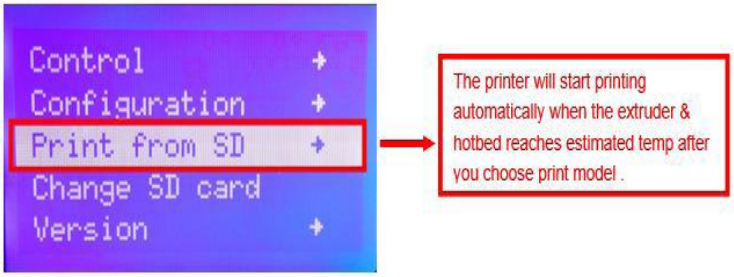


b. Enregistrement de code



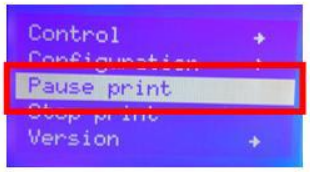


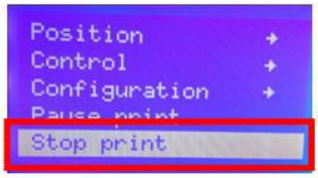
Copy file to SD card . Then connect SD card to printer, click reset. Picture below shows the location of print file , there are 2 methods to find print file.



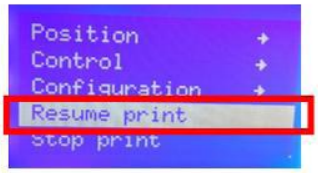
c. introductionArrêt de l'impression, pause de l'impression, poursuite de l'impression:

Ce n'est que lorsque l'imprimante est en cours d'impression que nous pouvons utiliser Arrêter l'impression, Suspendre l'impression, Continuer l'impression.



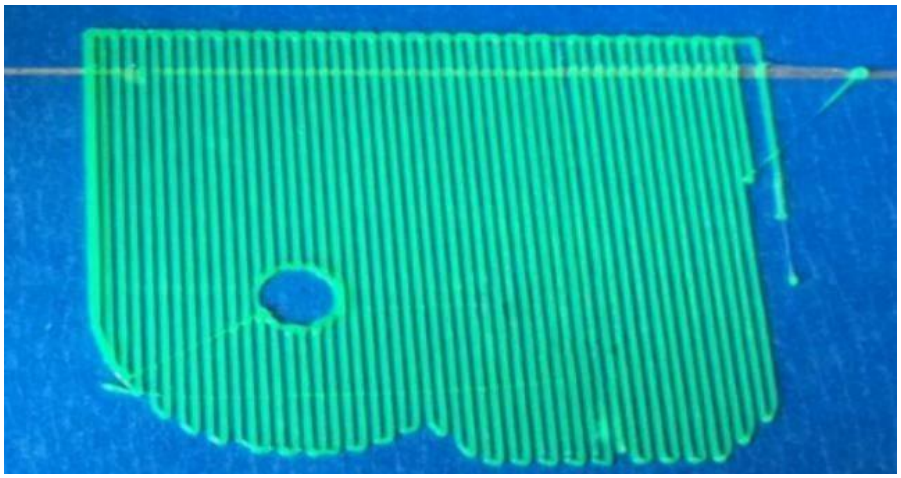


Attention:Please use the function according to your requirment .

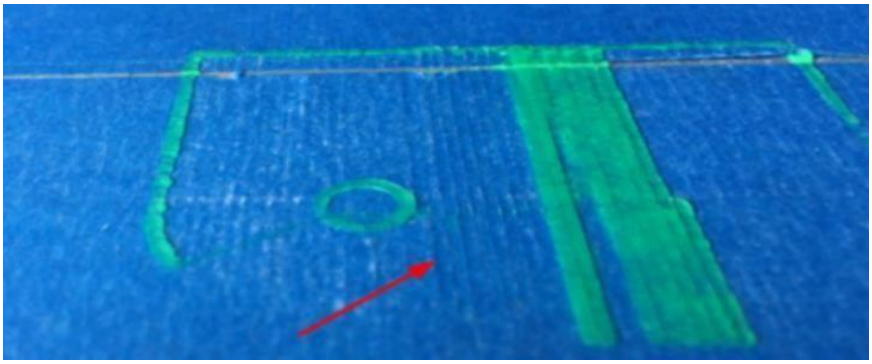


d.Jugement de l'écart entre la buse et la plate-forme.

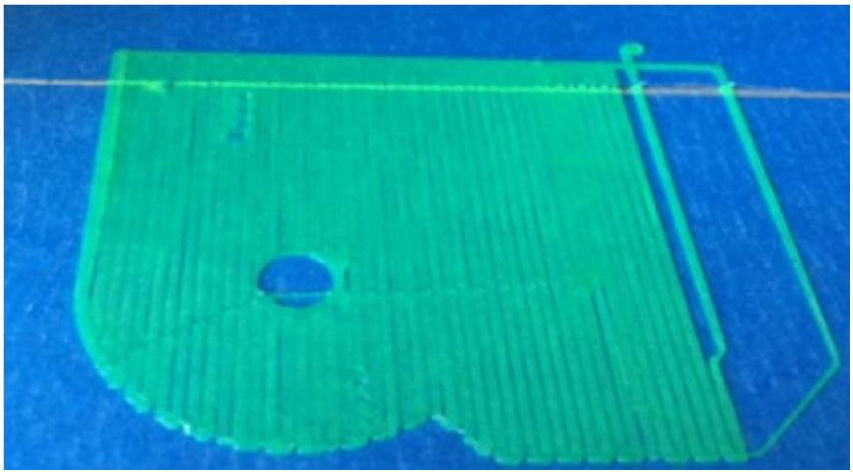
1. Trop grand écart: Le modèle imprimé est inégal, recourbé avec un écart. Cela signifie que l'écart est trop grand pour que le filament atteigne la plate-forme, ce qui rend l'effet d'impression si mauvais.



2. Espace trop étroit: le bord du modèle imprimé présente des projections irrégulières. Cela signifie que l'écart est trop proche pour imprimer normalement. Parfois, il ne peut même pas produire de filament



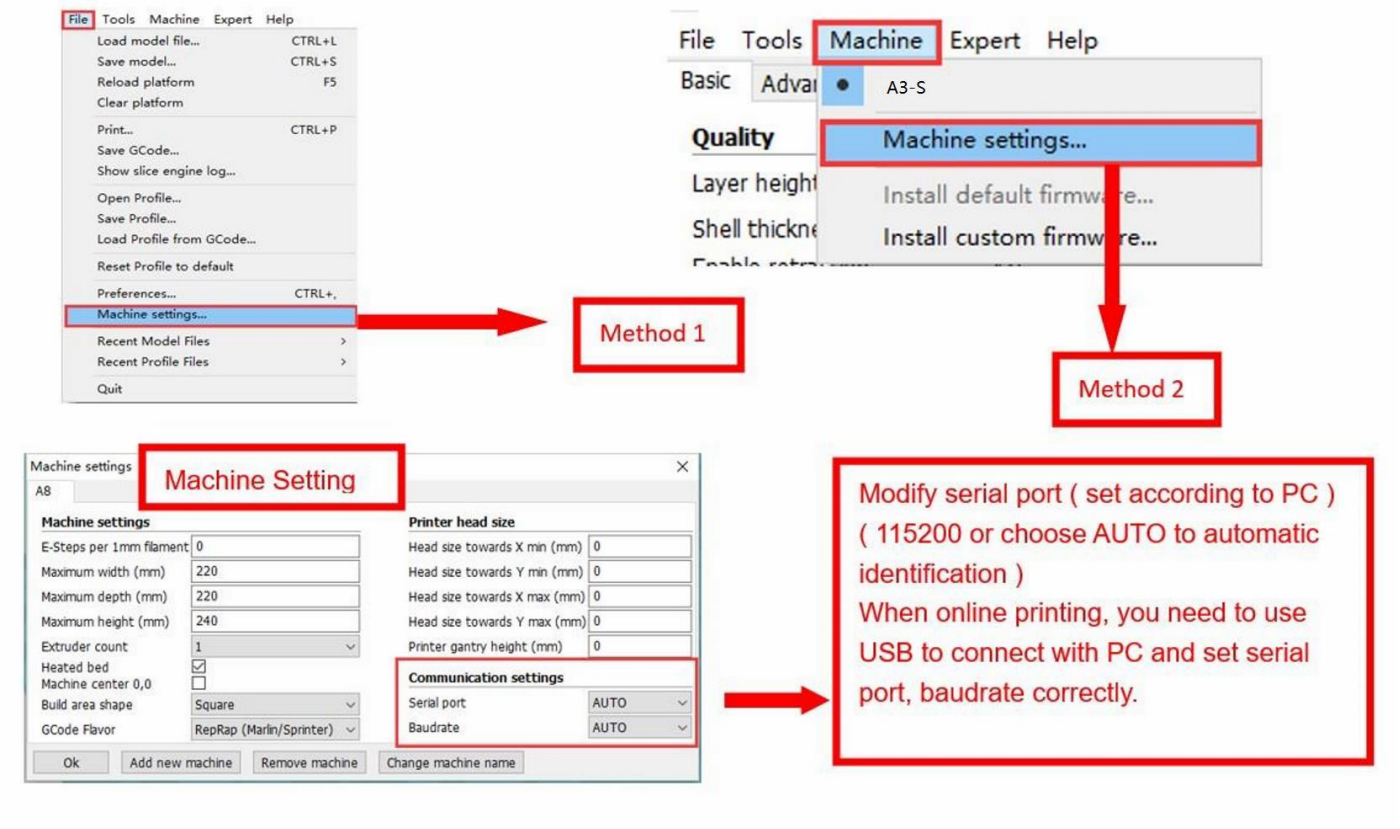
3. Distance appropriée: modèle imprimé à plat sans espace, sans défauts. Cela signifie que la distance est appropriée pour imprimer



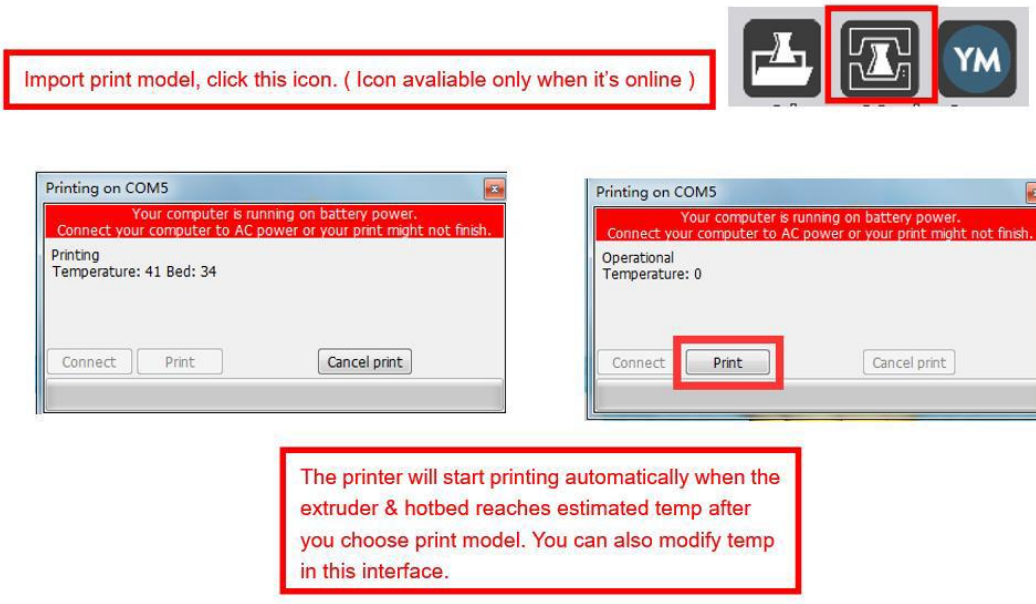
Attendez que l'impression soit terminée après le réglage de l'écart.

2) Impression USB en ligne

une. Paramètres de la machine (utilisez USB pour vous connecter au PC)

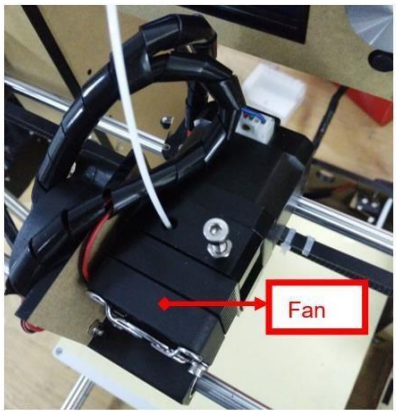


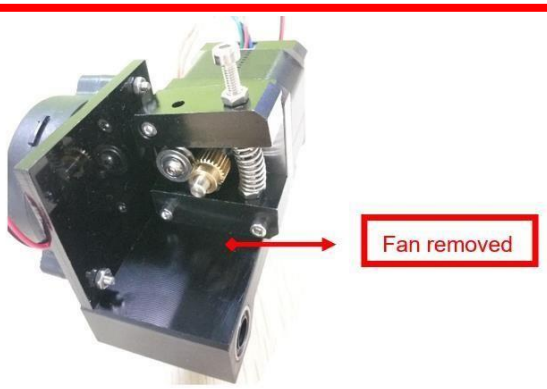
b. Pringting en ligne



1. N ozzl e blocage

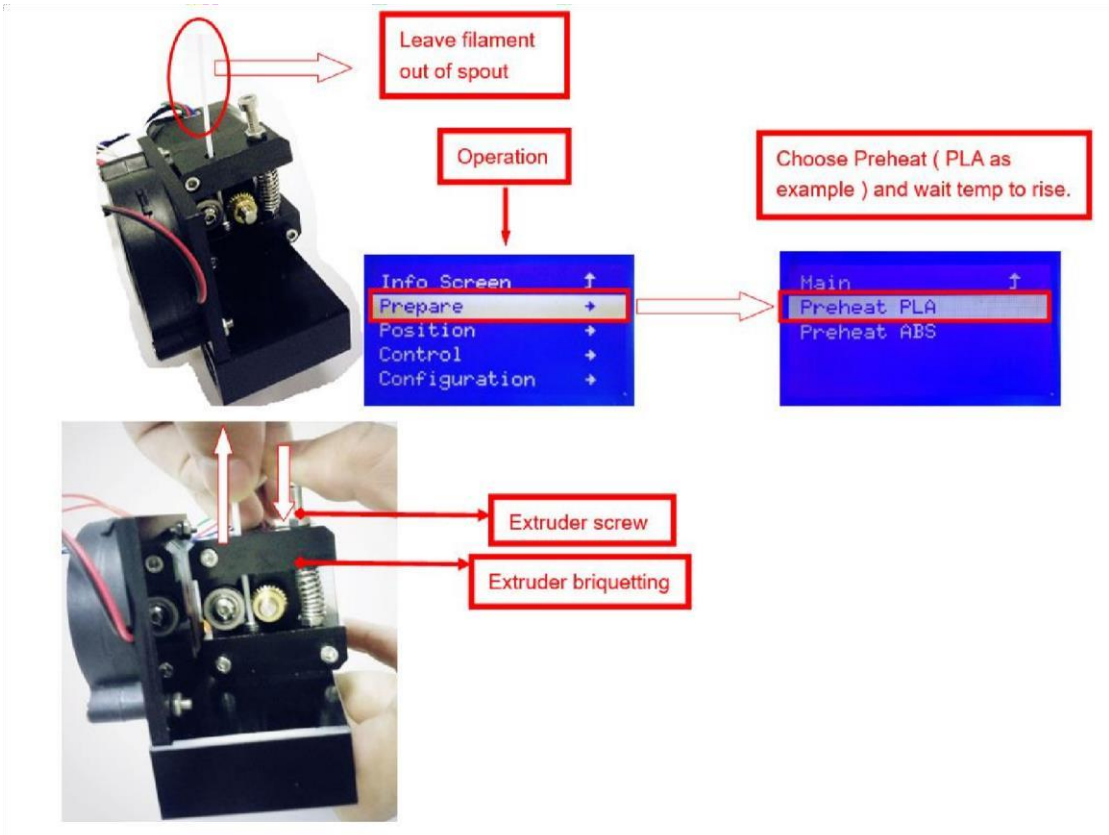
Conseils: Nous avons supprimé le ventilateur pour le montrer de toute évidence. Veuillez mouvement de cosider selon les exigences réelles.



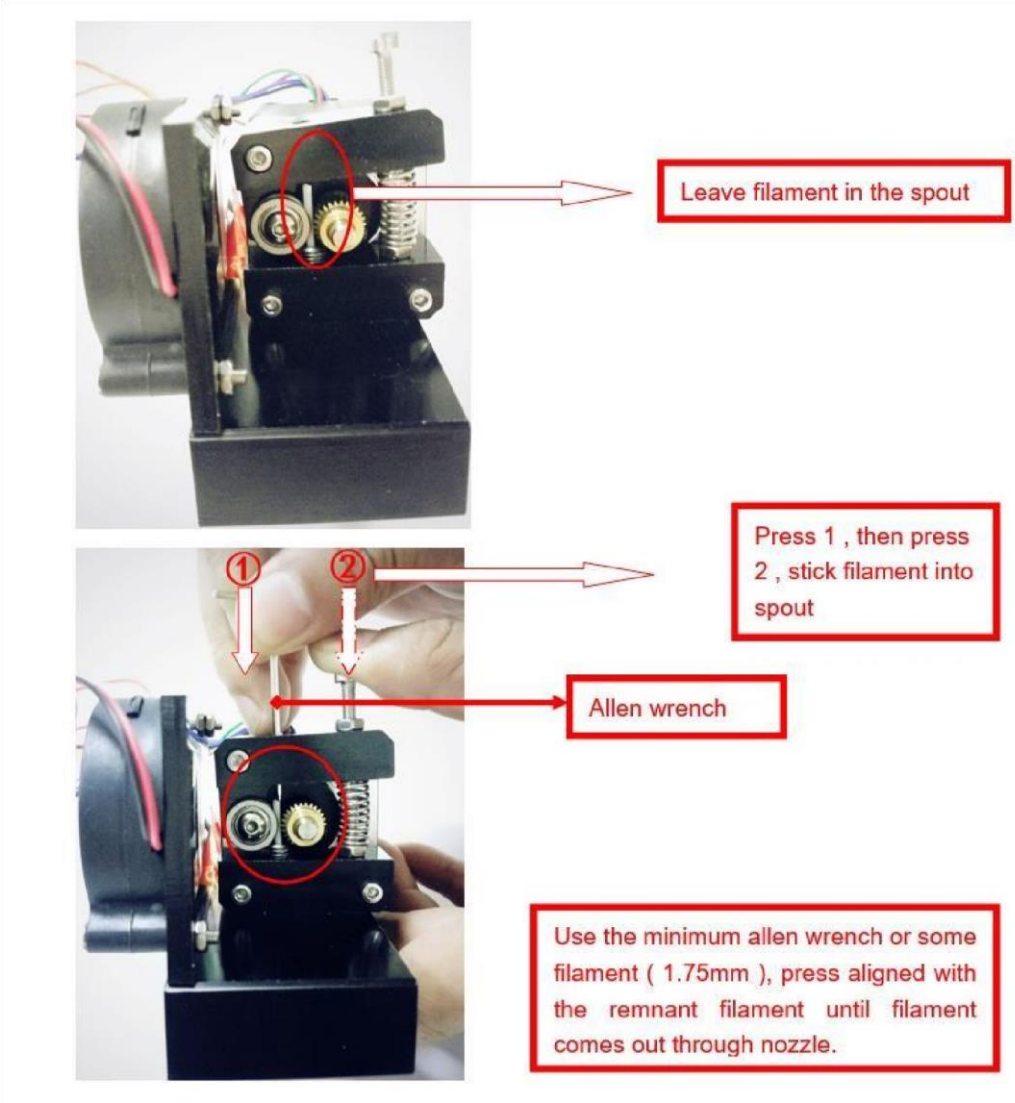


E. **FAQ**

UNE. Il ne reste qu'un petit filament dans la buse et difficile à retirer:



B. Filament plein rempli dans le bec



2. FAQ

Non.	Symptôme	Raison	Méthode
1	Dislocation du modèle d'impression	Roue / courroie synchrone desserrée.	Serrer les vis de réglage ou fixer la courroie
2	Glitch avec le modèle d'impression	Problème de température ou de tranchage trop élevé.	La température de l'extrudeuse est trop élevée et la vitesse de rétraction et la distension sont trop petites
3	Modèle imprimé mousseux	Entrée de filament à basse température ou non lisse.	Augmentez la température de l'extrudeuse ou vérifiez si l'écrou et le roulement en laiton sont bons. Remplacer une buse si les méthodes ci-dessus ne peut pas résoudre le problème.
4	Le modèle d'imprimante est déformé	Le niveau du foyer n'est pas bien ajusté.	Ajuster le foyer
5	Tramsformation de code G non disponible	Mauvais réglage / mauvais chemin de sauvegarde	Choisissez le bon type de machine et changez de chemin
6	L'installation du logiciel a échoué	OS différent	Réinitialiser le système d'exploitation
7	Temp inhabituelle	Capteur de température cassé	Changer un nouveau

F. **Entretien**

Conseils d'entretien importants:

1. entretien des axes X, Y, Z: Ajoutez des lubrifiants sur les tiges pour réduire le frottement lorsque la machine fonctionne bruyant et secoue un peu.

2. Veuillez vous reporter au MANUEL D'UTILISATION avant d'imprimer, faites d'abord la préparation du réglage du lit chaud.

3. Une fois l'impression terminée, le filament doit rester étanche, éviter l'humidité.

4. Préchauffez l'extrudeuse au début de la 2 e impression, laissez le filament pousser automatiquement l'extrudeuse tandis que.

5. La machine doit faire un entretien régulier, déposer de l'huile de lubrification sur la tige filetée, polie tige et roulements pour éviter l'usure par fatigue.

6. Ne laissez pas le ventilateur et la climatisation souffler sur le lit chaud lors de l'impression.

7. Gardez la condition de travail à «Temp: 10-30 ℃ ， Humidité: 20-70% ”.

G. **Prestation de services de maintenance**

1. Ce produit exécute les réglementations de la «Carte de garantie du produit».

2. Veuillez contacter le fournisseur ou le service client si le produit a

problèmes . Ne le réparez pas vous-même, sinon vous avez besoin

supporter toutes les conséquences.