Pangu I3-C 3D Printer user manual

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Pangu I3-A 3D Printer user manual

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1. PREFACE

Thank you for purchasing Pangu I3 product series-Pangu I3-A 3D printer.It is a wood-frame, base, extruder , heated bed assembled.Before purchase, please look rp3d manufacturers -Shenzhen rp3d technology co.ltd. rp3d technology co.ltd is the first professional 3D printer and peripheral products development , production and sales of technology limited company in Shenzhen.The company has a strong technical force and strong product quality, we can provide you with a 3D printer for professional services.

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1.1. INTRODUCTION

The Pangu i3—A is an improvement of the prusa i3, with the Melzi Electronics and K extruder. It belongs to series of Pangu I3 and was released in December 2013.

1.2. MAIN PARAMETERS

Host software: Repetier-host or Pronterface

Firmware: All of the Pangu I3-A's firmware has finished packing, you need not prepare any firmware.

Build volume: 210x200x195mm, Overall size:440x420x380mm

Printing materials: ABS, PLA, 3mm or 1.75mm diameter thermoplastic.

Build surface: PCB-heated bed to reduce complexity of assembly and to ensure parts do not warp.

Computer interface: USB

Motion: Linear ball bearings on X and Y and Z axes

Pre-soldered electronics with built-in microSD card slot for standalone printing. $_{\circ}$

Enhancements to the printed parts to improve the ease of assembly.

1.3. MAIN IMPROVEMENTS

The following is a list of the main improvements made on the original Prusa :

The whole frame is made of wood; wood thickness is 6mm/0.24 inch.

Enhanced frame rigidity , easy to assembly.

All are linear bearings

Square M3 Nuts(new improvements from 2014.1.9)

Preassembled MK2 Heated bed and K Extruder

The belts were GT2 belts and professional belt pulleys

GT2The belts were GT2 belts and professional belt pulleys

Professional Couplings

The Z axis is M6 threaded rod

X ends were redesigned for M6 threaded rod and the X endstop

2. PACKING LIST

2.1. OPEN THE BOX

Use a knife to open the Pangu I3-A boxes in which are boxes/packages.





2.2. PANGU I3-A BOM

Item	Description	Qty.	Unit.	Remark.
1	Extruder	1	Kit	Pre-assembled K Extruder with Nozzle and Fan.
2	Heated bed	1	Kit	Pre-assembled Mk2b with glass and Thermistors.

3	Power supply	1	PCS	Mean well NES-200-12	
4	Melzi Electronics	1	PCS	Firmware is ready	
5	Wood-Frame	1	Kit	Drawing number: pangu_i3_20131225	
6	Printed parts	1	Kit	For Pangu I3-A.	
7	M6 threaded rods	2	PCS	About 295mm, for Z.	
8	M8 threaded rods	4	PCS	About 215m, for base、Filament	
9	M8 threaded rods	3	PCS	About 290mm, for base、Filament	
10	M8 threaded rods	2	PCS	About 415mm, for base.	
11	Ø8 Smooth rods	2	PCS	About 384mm, for X axis.	
12	Ø8 Smooth rods	2	PCS	About 405mm, for Y axis.	
13	Ø8 Smooth rods	2	PCS	About 320mm, for Zaxis.	
14	Nylon spacer	4	PCS	For the Melzi Electronics	
15	Winding tube	2	М	For finishing wires	
16	625 Bearing	4	PCS	For XY idler	
17	Linear Bearings	10	PCS	LM8UU, Pre-assembled into the print- ed parts	
18	Motor	4	PCS	X_{x} Y axis with one ,Z axis two	
19	Couplings	2	PCS	With hollow screws, 2kits	
20	Belt	2	М	GT2-6mm, X, Y axis with one meter.	
21	Pulley	2	PCS	For X and Y, with hollow screws.	
22	Endstop	3	PCS	With wires	
23	USB cable	1	PCS	Used to connect the computer.	

24	wire connector	2	PCS	For Z axis motor wires series connec- tion
25	Zip tie	20	PCS	
26	Power line	1	PCS	Connect the power supply
27	Red and black wires	2	PCS	Connect the power and Melzi Electron- ics.
28	M5 nut	2	PCS	For X、Y axis idler
29	M5*20 bolt	2	PCS	For X、Y axis idler
30	M4*20 bolt	2	PCS	To fix the extruder on the X carriage
31	M4 nut	2	PCS	To fix the extruder on the X carriage
32	M4*10 bolt	4	PCS	To fix the power supply on the wood- frame
33	M8*30 washer	4	PCS	To fix the wood-frame and the base
34	M8 Locknut	4	PCS	For base.
35	M8 nut	36	PCS	For base.
36	M8 washer	40	PCS	For base.
37	M3*16 bolt	36	PCS	To fix the wood-frame
38	M3*10 bolt	10	PCS	To fix the Z axis motorto and the wood-frame
39	M3*12 bolt	6	PCS	To fix the Y axis motor and Melzi Elec- tronics.
40	M3*20 bolt	4	PCS	To fix the X motor.
41	M3 nut	15	PCS	To fix the wood-frame
42	M3 square nut	26	PCS	To fix the wood-frame
43	M3 Locknut	4	PCS	To fix the Melzi Electronics.
44	M3 flat washer	36	PCS	To fix the wood-frame

45	M3 spring washer M3	36	PCS	To fix the wood-frame.	
46	M3*25 bolt	1	PCS	Z-axis end stop is triggered by it.	
47	M2*16 bolt	6	PCS	To fix the end stop.	
48	M2 nut	6	PCS	To fix the end stop.	
49	M6 nut	2	PCS	For Z axis M6 threaded rods.	

2.3. PRINTED PARTS

The [pangu i3B stl] for the pangu i3-A has all the STL files you need in order to make the printer. The following is a list of what needs to be printed:

Item	Photo	STL name	Qty.	RP3D P/N
0	Printed Parts			02020000
1		Y_Idler.stl	1	02020001
2	1	Y_Motor_Mount.stl	1	02020002
3		Y_Busing.stl	3	02020003
4		Endstop_Holder.stl	2	02020004
5	- Coro	Y_Belt_Clamp.stl	1	02020005
6		X-End_Motor.stl	1	02020006

7		X_End_Idler.stl	1	02020007
8		X_Carriage_Belt_Clamp.st l	1	02020008
9	Contraction of the second	X_Carriage.stl	1	02020009
10	Co	Bar-clamp .stl	2	02020010
11		K_Extruder_base.stl	1	02020011
12		K_Extruder_ Spring_Holder.stl	1	02020012
13		K_Extruder_ Bearing_Holder.stl	1	02020013
14		Y_Corners.stl	4	02021001
15		Filament_holder.stl	2	02021002

2.4. PANGU I3-A TOOL BOX

Item	Item Name		Unit.	Specification.
1 Hexagon wrench		1	PCS	1.5mm
2	2 Hexagon wrench		PCS	2.0mm
3	3 Hexagon wrench		PCS	2.5mm
4	Watch opener	1	SET	
5	High-temperature adhesive tape	1	Spool	5mm
6	High-temperature adhesive tape	1	Spool	50mm
7	Three pieces of wood carving knife	1	SET	
8	Таре	1	PCS	1.5m
9	Cutting nippers	1	PCS	
10	Nipper pliers	1	PCS	
11	Open spanner	1	SET	
12	Nippers	1	PCS	

13	Grease	1	bottle	
14	SD card	1	PCS	2GB,with fat file system, support off-line print, user manual, driving pro- gramm, STL, control software inside.
15	Card Reader	1	PCS	
16	USB wire	1	PCS	Included in the list of I3-A BOM
17	Zip tie	20	PCS	Included in the list of I3-A BOM
18	Winding tube	4	М	Included in the list of I3-A BOM
19	Clip	4	PCS	Have been assembled in the heated bed.
20	Leather working gloves	1	SET	
21	Filament	5	М	ABS Ø3mm
22	Drill bit	1	PCS	0.4mm
23	Drill bit	1	PCS	3mm
24	Back-up screws and nuts	1	BAG	
25	502 glue	1	bottle	

3. ASSEMBLY 3D PRINTER

Before you begin

This document will guide you through putting together your Pangu I3-A 3D Printer. Please read it

through briefly before starting your build, and make sure you have everything you need to continue. It's

frustrating to be stuck with a half-finished machine because you are missing a part or tool.

3.1 ASSEMBLE THE Y AXIS

3.1.1 ASSEMBLE THE Y AXIS BASE		
Things needed:		
English		
1 x Y-motor-bracket		
1 x Y-Idler		
4 x Y-corner		
22 x M8 nuts		
12 x M10 nuts		
22x M8 washers		
4x M10*30 washers		
8x M10 washers		
4 x M8 215mm threaded rod		
2 x M10 415mm threaded rod		

3.1.1.1 STEP ONE : ASSEMBLE THE Y_MOTOR_MOUNT



3.1.1.2 STEP TWO : ASSEMBLE THE Y_CORNER



3.1.1.3 STEP THREE : TIGHTEN THE NUT , FIXED FRAME FOOT , TO ENSURE THAT THE GASKET IN THE

TWO-FOOT DISTANCE IS 150MM



3.1.1.4 STEP FOUR : ASSEMBLE THE Y-IDLER



3.1.1.5 STEP FIVE : ASSEMBLE THE Y-CORNER



3.1.1.6 STEP SIX : FIXED FRAME FOOT , TO ENSURE THAT THE GASKET IN THE TWO-FOOT DISTANCE IS

150MM, TIGHTEN THE NUT.



3.1.1.7 STEP SEVEN : USE TWO M10*415MM THREADED RODS TO CONNECT THE ASSEMBLED Y_CORNER



3.1.1.8 STEP EIGHT : ADJUST THE DISTANCE FROM FRONT- BACK OF Y_CORNER , MAKE THEM TO PUT IN THE SMOOTH RODS JUST TWO Ø8*405 MM ,TIGHTEN THE NUT



3.1.2 INSTALL THE Y	AXIS MOTOR
Things needed:	
English	
1 x Y-motor	
1 x Pulley	
2 x M3*4 Jackscrew	
2 x M3*10 bolts	

3.1.2.1 STEP ONE: INSERT PULLEY IN Y-MOTOR



3.1.2.2 STEP TWO : SCREW THE JACKSCREW INTO BOLT'S HOLE, ONE OF A BOLT HOLE PERPENDICULAR

MOTOR D SURFACE



3.1.2.3 STEP THREE : USE BOLT TO ASSEMBLE THE ASSEMBLED MOTOR TO FIX ONTO THE MOTOR-

BRACKET (SEE THE FOLLOWING PICTURE)



3.2. ASSEMBLE WOOD – FRAME



Things needed:	
English	
1x Wood- board -Frame	
2x Wood-side -Frame	
2x Z axis cover-wood motor-holder	
4x Z axis side-wood motor-holder	
20x M3*16 bolt	
20x M3 square nut	

3.2.1.1 STEP ONE : ASSEMBLE THE SIDE WOOD FRAME



3.2.1.2 STEP TWO : ASSEMBLING FRAME FIXED BOARD



3.2.1.3 STEP THREE : ASSEMBLE THE Z_MOTOR_MOUNT



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3.2.2 INSTALL THE Z A	XIS MOTOR AND COUPLINGS
Things needed:	
English	
2 x Z-motor	
2x Couplings	
8 x M3*10 bolts	

3.2.2.1 : STEP ONE : ASSEMBLE THE ELECTRIC MOTOR 1



3.2.2.2 STEP TWO : ASSEMBLE THE ELECTRIC MOTOR 2



3.2.2.3 STEP THREE : ASSEMBLE THE COUPLINGS, JACKSCREW PERPENDICULAR D SURFACE









2x Assembly wood-frame

3.2.3.1 STEP ONE : PUT THE BASE INTO THE WOOD FRAME, ENSURE THAT THE DISTANCE BETWEEN THE

TWO GASKET FOR 110MM, TIGHTEN THE SCREW



3.3. ASSEMBLE THE HOT BED

3.3.1 ASSEMBLY HOT BED ACCESSORIES		
English		
1 X 220*200*5mm glass		
1X 220*200*3mm Wood		
1 X Hot-bed-PCB		
1 XAlu- base-board		
3X Y_Busing		
1 X Y_Belt_Clamp		

12 X M3 nuts	
8 X M3*16 bolts	
2 X M3*12 bolts	
4X M3*25 bolts	
8x M3 washers	
4x Ø6*25 Spring	

3.3.1.1 STEP ONE : INSTALL THE HOT BED PRINTING



3.3.1.2 : STEP TWO : INSTALL THE HOT BED TEMPERATURE PROBE



3.3.1.3 STEP THREE : FIXED HOT BED PCB BOARD AND WOOD BOARD



3.3.1.4 STEP FOUR : USE NIPPER TO FIXED GLASS, CONNECT THE WINDING TUBE





3.3.2 CONNECT HOT BED AND THE Y AXIS BASE		
Things needed:		
English		
1 X assembled-hotbed		
1X assembled –Y base		
2 X Ø8 Smooth rods		

4X Zip tie

3.3.2.1 STEP ONE : PUT SMOOTH ROD THOUGH HOT BED LINEAR BEARINGS, INSERT Y BASE



3.3.2.2 STEP TWO : USE ZIP TIE TO FIXED SMOOTH ROD



3.3.3 INSTALL THE Y AXIS BELT
Things needed:
English
1X GT2-6mm belt

3.3.3.1 STEP ONE : ADJUST Y_MOTOR_MOUNT AND Y-IDLER'S POSITION, MAKE IT IN THE SAME DIREC-

TION WITH HOT BED BELT_CLAMP



3.3.3.2 STEP TWO : STUCK THE BELT ON THE BELT_CLAMP, TIGHTEN THE NUT





3.4. ASSEMBLE THE X AXIS



3.4.1.1 STEP ONE : ASSEMBLE THE 623ZZ BEARING

1.Things needed:	Assemble the	623zz bearing
English		
1 x K-Extruder-Bearing-Holder		
1 x 623zz bearing		
1 x M3x16 flat head screw		
1 x M3 Washer		
1 X M3 Spring Washer		
1 x M3 nut		



Tighten the bolt



3.4.1.2 STEP TWO : INSTALL THE DRIVING GEAR

2.Things needed: Install	he driving gear
English	
1 x Motor	
1 x extruder driving gear	
1 x M3x4 Hollow-lock socket set screw	

Insert the gear on the motors axis, make sure the distance from the gear to the motor is 6.25mm.



Tighten the bolt



3.4.1.3 STEP THREE : INSTALL THE EXTRUDER SPRING HOLDER

3.Things needed: ins	stall the extruder spring holder
English	
1 x extruder spring holder	
1 x M3x16 screw	

Fix the spring holder with a M3x16 bolt.



3.4.1.4 STEP FOUR : INSTALL THE EXTRUDER BEARING HOLDER

4.Things needed:	install the extruder bearing holder	
English		
1 x M3x16 screw		

Fix the bearing holder with a M3x16 bolt.





3.4.1.5 STEP FIVE : INSTALL THE EXTRUDER SPRING HOLDER

5.Things needed:	Install the extruder spring	
English		
2 x extruder spring		

Put the spring between the spring holder and the bearing holder. Maybe you need parallel 2 PCS spring to

push the filament on the gear.





3.4.1.6 STEP SIX : INSTALL THE EXTRUDER FAN

6.Things needed:	Install the extruder fan	
English		
2x M3x16 screws		

Fix the fan with the M3x16 screws. Please note the label of the fan face to the holder.





3.4.1.7 STEP SEVEN : INSTALL THE X-CARRIAGE

7.Things needed:	Install the X-Carriage
English	
1 x k-Extruder–Motor-Holder	
1 x X-Carriage	
2 x M3x16 screws	
2 x M3 nuts	
1 x M3x14 screws	
1 x X-Carriage-Belt-Clamp	

Fix the X-Carriage with the M3x16 screws. Please note the back of the X-Carriage face to the extruder-

motor-holder. Fix the X-Carriage with the M3x14 screws. The screw don't need to tighten.





8.Things needed:	Install the extruder motor
English	
2 x M3x30 screws	
2 x M3 washer	
2 x M3 spring washer	

3.4.1.8 STEP EIGHT : INSTALL THE EXTRUDER MOTOR



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9.Things needed:	Assemble the I head nozzle
English	
1 x J-Head Noz-	
1 x Nozzle Holder	
1 x Heat Cartridge	
1 x PTFE liner	
1 x Thermistor	
1 x Hollow-lock socket set screw	
2 x PTFE tube 0.5mm	
2 x Wire to wire terminal	
2 x 60cm wires for thermistor	

3.4.1.9 STEP NINE : ASSEMBLE THE J HEAD NOZZLE

It is the MKII. Please refer to for more information. It include the nozzle, nozzle holder, ptfe tube, heater,

sensor and so on.



J head nozzle assembling picture



J head nozzle image photo









10.Things needed:	assemble the K	K-extruder and extruder
English		
2 x M3x30 screw		

3.4.1.10 STEP TEN : ASSEMBLE THE K-EXTRUDER





3.4.2.1 STEP ONE : ASSEMBLE THE LINE BEARING



Push the LM8UU into the

Printed part

2.Things needed: Assem	ble the X motor
English	
1 x motor	
1x Pulley	
2 x M3*4 Jackscrew	

3.4.2.2 STEP TWO : ASSEMBLE THE END_IDLER

Insert the End_Idler into motor , one of the bolt hole perpendicular D surface







Tightening the jackscrew into the bolt's hole. Tighten the jackscrew.



tighten the bolt



3.Things needed:	assemble the X-motor
English	
1 x Motor (step2)	
1 x End-Motor-holder (step1)	
4 x M3x20 flat head screw	
1 x M6 nut	

3.4.2.3 STEP THREE : ASSEMBLE THE X-MOTOR

Put the motor into the X-motor holder's hole , tighten the bolt.


1x	X	End	_Idler
----	---	-----	--------

2x line bearing

3.4.2.4 STEP FOUR : ASSEMBLE THE X_END_IDLER LINE BEARING.



Push the LM8UU into the Printed part



5.Things needed:	assemble the 62	23zz bearing
English		
1x X_End_Idler (step4)		
2x 623zz bearing		
1x M5*20 nuts		
1x M5 nuts		

3.4.2.5 STEP FIVE : ASSEMBLE THE 623ZZ BEARING

Put the two bearing into the following picture's position , insert the screw , tighten the nut.



6.Things needed: ass	semble the nut
English	
2x M6 nut	
1 x X_End_Idler (step5)	

1 x End-Motor-holder (step3)

3.4.2.6 STEP SIX : ASSEMBLE THE NUT

Put two M6 nut into the X_End_Idler and the X_End-Motor-holder's hole, in order to avoid the nut falling off, please use 502 glue around the edges , take care to avoid the glue inflow to the threads.



X_Motor_Mount.



X_End_Idler

7.Things needed:	assemble the X – axis
English	
2x Ø8*400mm Smooth rods	
1 x X_End_Idler (step6)	
1 x End-Motor-holder (step6)	
1x K Extruder (step4.1)	

3.4.2.7 STEP SEVEN : ASSEMBLE THE X -AXIS

Insert two smooth rods into the End_Idler 's two holes.

RP3D Tech Co.,Ltd.

Tel: +86 755 2870 0806



3.4.2.8 STEP EIGHT: PUT IN THE K-EXTRUDER ALONG THE SMOOTH RODS



3.4.2.9 STEP NINE : PUT IN THE END_IDLE ALONG THE SMOOTH RODS .



3.4.2.10 STEP TEN : ADJUSTING THE DISTANCE BETWEEN THE CENTER OF THE TWO BEARING

After installed, Adjusting the distance between the center of the two bearing for 361mm.





3.4.3.1 INSTALL THE BELT.

Use the Belt_Clamp to clamping the belt, please note the belt to straighten ,not too loose.



3.5. ASSEMBLE THE Z AXIS

3.5.1 INSTALL THE Z AXIS SMOOT	H RODS AND THREADED RODS
Things needed:	
English	
1x assembled frame	
1x assembled X –axis	
1x Ø8 *320 mm Smooth rods	
1x M6*295mm threaded rods	

3.5.1.1 STEP ONE : FIXED THE TWO SMOOTH RODS

The Smooth rods through the top frame printing , X- line bearing, and the bottom frame printing; Smooth rods flush with the top frame printing, and require X –axis should move up and down smoothly.



3.5.1.2 STEP TWO : FIXED THE TWO THREADED RODS

Twist the threaded rods to make it through the M6 nut and Couplings tighten the jackscrew.



tighten the jackscrew



3.6. INSTALL THE END_STOPS

Things needed:	
English	
3 x End_stops with wires	
6x M2 *16 Bolts	
6 x M2 nuts	

3.6.1 INSTALL THE X AXIS END_STOPS



3.6.2 INSTALL THE YAXIS END_STOPS



3.6.3 INSTALL THE Z AXIS END_STOPS



3.7. FIXED POWER SUPPLY

Things needed:	
English	
1x Power	
3x M3 *10 Bolts (1st Power)	
3x M4 *10 Bolts (2nd Power)	

Put the power supply in the back of Motor_Mount's wood frame, tighten the bolts.





3.8. FIXED PCB

Things needed:	
English	
1x Power	
4x Nylon spacer	
4x M3 *16 Bolts	
4x M3 nuts	

Put the PCB into the correspond hole , add a Nylon spacer, screw the bolt , and tighten the nut, Please note the PCB direction.



3.9. INSTALL THE FILAMENT_HOLDER

Things needed:	
English	
2x Bar-clamp	
2x Filament-holder	
3x M8 *290 threaded rods	
4x M8 nuts	
4x M8 washer	

Follow the following picture to install the filament_holder, make sure filament is not be touched





3.10. CONNECT THE 3 D PRINTER

3.10.1 WIRING OF THE Z AXIS MOTOR



。After connected, put the Pressure line on wire connector, compressed with piler



3.10.2 WIRING OF 3 D PRINTER

One thousand individuals have one thousand kinds of wiring connection. Wiring principle: we must have enough travel, but also beautiful, simple operation





back

front

3.10.3 PCB WIRING PCB

Connect wire from left to right: X_motor line ---Y_motor line----Z_motor line----E_motor line----power supply line----hot bed line----X_endstops line----Y_endstops line----Z_endstops line ----hot bed temperature probe line---extruder temperature probe line. Connect wire follows color.



3.10.4 THE POWER SUPPLY WIRING

Connect the power supply blue—N brown—L Connect the red and black wire red—V+ black—V-



4. INSTALL THE SOFTWARE

4.1. INSTALL REPETIERHOST

There is RepetierHost_V0.84 software installer and user manual on the SD card, which wrote details. V0.84 version is stability, good compatibility, it is recommended to use the V0.84 version. Considering user will upgrade using, xiao bian here to give you an example with WIN7 32 system to introduce RepetierHost_0.95F's install.

Way 1 : You can click RepetierHost_V0.84 menu----help window----check upgrade then upgrade

RepetierHost.



Way 2 : you can insert website : <u>http://www.repetier.com/download/</u> download the latest epetierHost to the software install catalog.

SETUP ONE: DOUBLE CLCK SETUPREPETIERHOST_0_95.EXE , ENTER THE SETUP INTERFACE.



SETUP TWO: CLICK NEXT



SETUP THREE: SELECT AGREEMENT

🖧 Setup - Repetier-Host	X
License Agreement Please read the following important information before continuing.	
Please read the following License Agreement. You must accept the terms of this agreement before continuing with the installation.	
EULA (End User License Agreement) for Repetier-Host (hereinafter called software)	^
IMPORTANT, PLEASE READ THIS AGREEMENT CAREFULLY before you start installing the software. This EULA is a legal agreement between you (hereinafter called licensee) and the company Hot-World GmbH & Co. KG (hereinafter called licensor). By installing or using the software, you agree that you accept this agreement binding. If you do not agree with this agreement, do not install and use the software.	
The software is protected by copyright. All rights to the program remain with the	-
I accept the agreement	
\bigcirc I do not accept the agreement	
< Back Next > C	ancel

SETUP FOUR: SELECT FILE SETUP CATALOG

Setup - Repetier-Host	
Select Destination Location	
Where should Repetier-Host be in	nstalled?
Setup will install Repetie	er Host into the following folder.
To continue, click Next. If you we	ould like to select a different folder, dick Browse.
C:\Program Files\Repetier-Host	Browse
At least 142.0 MB of free disk spa	ace is required.

SETUP FIVE: CLICK NEXT

Select Start Menu Folder		
Where should Setup place the program's s	shortcuts?	Ĉ
Setup will create the program's s	hortcuts in the following	Start Menu folder.
To continue, dick Next, If you would like t	n select a different fold	ar dick Browse
Repetier-Host	o select a unrerent rolu	Browse
All and a state of the state of		

SETUP SIX: CLICK NEXT

👸 Setup - Repetier-Host			
Select Additional Tasks Which additional tasks should be performed?			
Select the additional tasks you would like Setup to perform while installin Repetier-Host, then click Next.	ng	50	
Additional icons:			

SETUP SEVEN: CLICK INSTALL

Ready to Install		
Setup is now ready to begin installing Rep	etier-Host on your computer.	Ĩ
Click Install to continue with the installation change any settings.	n, or click Back if you want to re	eview or
Destination location: C:\Program Files\Repetier-Host		*
Start Menu folder: Repetier-Host		
		*
•		F.

SETUP EIGHT: WAIT FOR THE INSTALLATION IS COMPLETED, CLICK "FINISH"



4.2 INSTALL DRIVER

4.2.1 ON THE DESK, RIGHT-CLICK "MY COMPUTER" CHOOSE "DEVICE MANAGER", ENTER

THE DEVICE MANAGEMENT INTERFACE.



4.2.2 CHOOSE USB COMPOSITE DEVICE, RIGHT-CLICK, COMPOSITE DEVICE.

🔺 🏺 通用串行总线控制器		7
🛶 🏺 Generic USB Hub		
🟺 Generic USB Hub		
🟺 Intel(R) 6 Series/C20	00 Series Chipset Family USB Enhanced Host Controller - 1C26	
🟺 Intel(R) 6 Series/C20	00 Series Chipset Family USB Enhanced Host Controller - 1C2D	
🗝 🏺 Renesas Electronics	USB 3.0 Host Controller	
🗝 🏺 Renesas Electronics	USB 3.0 Root Hub	
🚽 🖟 USB Composite Dev	vice	
🏺 USB Mass Storag	更新驱动程序软件(P)	
USB Root Hub	禁用(<u>D</u>)	
🔲 🏺 USB Root Hub	卸载(U)	
▷ 🐻 图像设备		
🕨 🔮 网络适配器	扫描检测硬件改动(A)	
▷ 📕 系统设备	属性(R)	
▷ 📲 显示适配器 📃 🗕		

4.2.3 IN THE DIALOG WINDOW SELECT DRIVER SOFTWARE



4.2.4 SELECT FIDI USB DRIVERS , CLICK NEXT

2 夏新超动程序软件 - USB Composite Device
浏览计篇机上的驱动程序文件
在以下位曹操素能动程序软件。
E\们型文件资料\產古\驱动程序\FTDI US8 Drivers · 演演图
7.包括子文件典(1)
→ 从计算机的设备驱动程序列表中选择(L) 此利表相显示与组设备重容的已安装的驱动程序软件,以及与该设备处于同一类组下的 所有驱动程序软件。
T-#100 Dia

4.2.5 WAIT FOR FINISHED SETUP , CLOSE



4.3. PARAMETERS SETTING

4.3.1 ON THE DESK, DOUBLE-CLICK REPETIERHOST.EXE, ENTER REPETIERHOST_0.95F USER



INTERFACE.

4.3.2 CLICK PRINT SETTING, SELECT "115200 BAUD RATE", CLICK "USER PING-PONG COMMU-

NICATION

TED机设置			
打印机: defaul	•	• 8	TJ4490602 ML
连接 打印机 打印	机形状「高級		
Connector: 用口	连接	•	Mesh Col.,,
通讯前口	сомз 👻	重新端口	
通讯波特率:	115200 💌		
传输协议:	Autodetect 👻		
连接时夏位	数据传输 低->高->低	*	
遇到紧急时夏位	发送紧急命令并重新连持	¥ -	
184位997年大小、·	63		
THE PERMIT SCITT	00		
	从Arduino1开始。微型课存长度()	#127或少为63比特! =	
☑ 使用Fing-Fong	从Arduino1开始,兼委编译长度的 通讯、(只有收到应答信号OK后	≜127歳少为63比特: 与才发送)	
☑ 使用Ping-Pong 打印机的设置参数示 类型未列出,	从Arduino1开始。要受调存长度 通讯(只有收到应答信号OK员 对应于上面可选择的打印机	±127歳少为63世時: 与才发送) 已经列出的打印机可以直接选择,如果打印机	
☑使用Ping-Pong 打印机的设置参数页 类型未列出。	从Arduino1开始,要变调存长度(通讯(只有收到应答信号org 讨应于上面司选择的打印机,	#127减少为63比哼! 5才发送) 已经列出的打印机可以直接选择,如果打印机。	
I 使用 Ping-Pong 打印机的设置参数5 类型未列出,	《Arduina1开始,要变感音长度 通讯(只有收到应答信号OK员 对应于上面可选择的打印机。	曲127减少为63比等1 5才发送) 已经列出的打印机可以直接选择。如果打印机	
☑ 使用Ping-Pong 打印机的设置参数5 类型未列出。	《Arduino1开始,要变感开关意 通讯(只有收到应答信号OK员 对应于上面可选择的打印机。	曲127减少为63比特1 5才发送) 已经列出的打印机可以直接选择。如果打印机	
☑ 使用Ping-Pong 打印机的设置参数。 类型未列出,	《Arduino1开始,要变误存长度 通讯(只有收到应答信号OK员 对应于上面可选择的打印机。	#127歳か为63世時: 5才发送) 已经列出的打印机可以直接选择、如果打印机	
☑使用Fing-Fong 打印机的设置参数。 类型未列出。	《Arduino1开始,要变误存长度) 通讯(只有收到应答信号OK员 对应于上面司选择的打印机。	#127歳かか63世時: 5才发達) 已经列出的打印机可以直接选择、如果打印机	
☑使用Fing-Fong 打印机的设置参数页 类型未列出。	《Arduino1开始,要变感存长度) 通讯(只有收到应答信号OK月 时应于上面司选择的打印机	#127歳かか63世時: 5才发送) 已经列出的打印机可以直接选择、如果打印机	

4.3.3 SET THE DEFAULT EXTRUSION HEAD , HOT BED TEMPERATURE

Click "printer", select " task interruption then close motor (ABS 230/110 °C PLA 190/60 °C)

TTCDTD I TOTO IN A MAIN			• 💼
E接 【打印机】打印机形状 捻出头亚动速度·	昌级	[mm/min]	
7-方向运动速度:	4000	[mm/min]	
10.75的运动运行。 14.25位中止温度。	230	• c	
	110		
城自加烈床加支, 挤出头数曰:	1		
 ── ── ● 任务中断结束后回到停机 ● 任务中断结束后关闭挤出 	位 头 庄		
 任务中断结束后关闭加热 任务中断结束后关闭马达 	м		

4.3.4 CLICK "PRINTER FORM" SET THE PRINTER ACTUALLY PRINT AREA.

日印机设置	ALC: N	1.00	A LOOM	
打印机: defau	lt		▼ m ²	
连接 打印机 打	泖机形状 高	级		
Printer Type:	经典打印机		•	^
起始位 X: 最小	▼ 初始	位化	最小 ▼ 初始位 Z: 最小 ▼	
X 最小 0	X 最大	200	加热床左: 0	
Υ 最小 0	Υ 最大	200	加热床 <mark>前</mark> : 0	
打印区域宽度:	200		m	
打印区域长度:	200		mn	
打印区域高度:	100		mm	E
这些最小最大值定义 热床的范围,加热床 最大/最小值如果固约	了挤出头可以 的左/前坐标5 转可以移动	【移动的范 定义了打印 动挤出头到	围,坐标如果为负值表明挤出头超出了加 扣开始时的加热床位置,通过更改这里的 则固件定义范围之外。	
			- errors + course of outside Court 1 -	

4.3.5 CLICK "CODE GENERATOR ", SELECT CONFIGURE PARAMETER DEVICE.

		於 8 打印机设置 紧	うる
物体放置(代码生成)	器 代码编辑 手动控制		
▶ 开5	治生成代码Slic3r	中止操作	
代码生成软(Slie3r	-	© Manager	
		Configure	
Print Setting:	pangu	-	•
Printer Settings:	pangu	-	•
Filament settings:			
挤出头 1:	pangu(abs)	-	·]
挤出头 1: 挤出头 2:	pangu (abs)	•	

4.3.6 CLICK "PRINT SETTINGS" SETTING LAYERS THICKNESS

pangu 0.5mm nozzle and filament 3mm ABS for material.

Sie Window Belp				
Print Settings Filament Setting	s Printer Settings			
pangu -	Layer height			-8
Covers and perimeters	Layer height	0.4	mm	
trill	First layer height:	100%	mm or %	
 Speed Skirt and brim Support material Notes 	Vertical shells Perimeters (minimum):	2		
 Output options Multiple Extruders Advanced 	Spiral vase: Horizontal shells			
	Solid layers:	Top(3	Bottom: 3	
	Quality (slower slicing)			
	Extra perimeters il needed: Avoid crossing perimeters: Statt nerimeters at:	22 Concase	noists Non-overhand points	

4.3.7 INFILL PROPORTION SETTING.

File Window Help			
Print Settings Filament Settings	Printer Settings		
pangu 🔹 🗃 🧯	Infil		
Lavers and perimeters	Fill density:	1	
Infil	fill patterns	rectificaar ·	
Speed	Top/bottom fill patterns	rectilisear 🔫	
Support material	Reducing printing time		-
G Output options	Combine infill every:	1 ayers	
White Extruders	Only infill where needed:		
Advanced	Advanced		
	Solid infill every	1 ayers	
	Fill angles	45 (a)	
	Solid infil threshold area:	70 imm#	

"1" for 100% solid fill , "0.5" for 50% solid fill.

4.3.8 PRINT SPEED SETTING

The speed for 30mm/s is the safest.

<u>File W</u> indow <u>H</u> elp			
Print Settings Filament Settings	Printer Settings		
pangu	Speed for print moves Perimeters: Small perimeters: External perimeters: Infill: Solid infill: Top solid infill: Support material: Bridges: Gap fill:	30 30 100% 30 30 30 30 30 20	mm/s mm/s or % mm/s or % mm/s or % mm/s or % mm/s mm/s mm/s
	Speed for non-print moves	ġ.	
	Travel	130	mm/s

4.3.9 SKIRT AND BRIM SETTING.

angu (modified) 🔹 🔚 🍕	Skirt		
 Layers and perimeters Infill Speed Skirt and brim Support material Notes 	Loops: Distance from object: Skirt height: Minimum extrusion length:	3 6 1 0	mm iayers mm
Output options Multiple Extruders Advanced	Brim width:	3	mm

4.3.10 SUPPORT MATERIAL .SETTING.

Check there is support, not checked without support.

lie window Help				
Print Settings Filament Setting	gs Printer Settings			
pangu (modified) 🔹 🚽	Support material			
Layers and perimeters	Generate support material:			
Infill	Overhang threshold:	0	*	0
Speed Skirt and brim	Enforce support for the first:	0	×	layers
📃 Support material	Raft			
Notes Output options	Raft layers:	0	A.	layers
Wultiple Extruders Advanced	Options for support material a	nd raft		
	Pattern:	recti	linea	•
	Pattern spacing:	2.5		mm
	Pattern angle:	0		•
	Interface layers:	3	*	layers
	Interface pattern spacing:	0	- Access	mm

4.3.11 AFTER PRINT SET , SAVE IT.

<u>File Window</u>	Help			
P <mark>rint Settings</mark>	Filament Settings	Printer Settings		
pangu Layers an Infill Speed	d perimeters	Layer height Layer height: First layer height:	0.4 100%	mm mm or %
Skirt and Support r Notes Output op Multiple E	brim nateria ptions extrude	settings as:	2	
Javaneeu		Solid layers:	Top: 3	Bottom: 3
		Quality (slower slicing) Extra perimeters if needed: Avoid crossing perimeters: Start perimeters at:	☑ □ Concave	points: Non-overhang poir

4.3.12 FILAMENT SETTING

Select filament window setting, filament diameter setting, number of extruder heads, extruder temperature and heated bed temperature, save it after finished. Filament diameter is 3mm and 1.75mm. ABS filament extruder temperature : 230° Heated bed temperature : 110°

PLA filament extruder temperature : 90° Heated bed temperature : 60°

e <u>W</u> indow <u>Help</u>					
nt Settings Filament	Settings	Printer Settings			
ingu(abs)	-) 🗐 🥥	Filament			
Filament		Diameter:	3	mm	
Cooling		Extrusion multiplier:	1		
		Temperature (°C)	1257 17		(con (
		Extruder:	First layer:	230	Other layers: 230
		Bed:	First layer:	110	Other layers: 110

4.3.13 PRINTER SETTINGS

Select printer settings, set the bed size and print center.

Slic3r				
<u>F</u> ile <u>W</u> indow <u>H</u> elp				
Print Settings Filament Settings	Printer Settings			
pangu 👻 🔚 🧔	Size and coordinates			
General	Bed size:	x: 200	y: 200	mm
💮 Custom G-code	Print center:	x: 100	y: 100	mm
🖗 Extruder 1	Z offset:	0 mm		
	Firmware G-code flavor: Use relative E distances:	RepRa	p (Marlin/	Sprinter/Repetier) 🔻
	Capabilities Extruders:	1	A Y	
	Advanced Use firmware retraction:		-14	

4.3.14 NOZZLE SETTING

Nozzle is 0.3, 0.4, 0.5mm, according to the size of nozzle to set the diameter , save it.

Slic3r			
<u>F</u> ile <u>W</u> indow <u>H</u> elp	٦		
Print Settings Filament Settings F	rinter Settings		
pangu 🗾 🚽	Size		
General General	Nozzle diameter:	0.5	mm
 Custom G-code Extruder 1 	Position (for multi-extruder printe Extruder offset:	ers) x: 0	y: 0 mm
	Retraction		
	Length:	1	mm (zero to disable)
	Lift Z:	0	mm
	Speed:	30	mm/s
	Extra length on restart:	0	mm
	Minimum travel after retraction:	2	mm
	Retract on layer change:		

5. TEST 3D PRINTER

5.1. SUPPRESSED ZERO

5.1.1 USE BUS DATA WIRE TO CONNECT COMPUTER AND 3D PRINTER



5.1.2 OPEN THE REPTEIER-HOST, THE COMPUTER WILL AUTOMATICALLY INSTALL THE DRIVER,

WAIT UNTIL THE INSTALLATION IS COMPLETED , SELECT "PRINT SETUP".

体放置	代码生成器	代码编辑	手动控制		袋 打印机	
0 6	0 111 0	+ S.	L i			
ame					Mesh	Col
平移	X	Y	Z			
缩放	x	Y	z	af a		
旋转	x	Y	z			
	hingto					
Cut 0	ojects					

5.1.3 IN THE PRINT SETTING , CHOOSE "COMMUNICATION PORT" DROP-DOWN MENU SELECT

THE PORT AND UPDATE IT , AFTER APPLICATION CONFIRM IT.

通讯端口:	2011/25 ▼ 更新端口	
世境及行業。	115200	
\$18007 \$2.5 \$P\$时复位	Autodetect ▼	
男 繁急时复位	数据限制并大 ▼	
	反広糸忌叩文井里利汪佐 🔹	
w缓存大小: ☑ 使用Ping─Pong 打印机的设置参数	63 从Arduino1开始。接受级存长度由127减少为63比特: 通讯(只有收到应答信号OIX后才发送) 对应于上面可选择的打印机,已经列出的打印机可以直接选择。如5	果打印机



TRUDER HEAD AND HEATED BED. ABS FOR EXAMPLE, EXTRUDER HEAD TEMPERATURE FLUCTUATION









extruder motor rotation (parameter can be set)

5.1.9 ADJUST THE BALANCE OF Z-AXIS AND HEATED BED





just on the heated bed center surface ①, the distance is about a sheet of A4 paper thickness;



5.1.9.4 Double-click arrow position 's first gird, move the nozzle up 0.2mm, to observe the distance a of the nozzle and heated bed's center surface ①

-**X**

5.1.9.5 Click the back arrow 's third gird , move the nozzle from left 100mm , which is moving to the heated bed surface on ②, to observe the distance b of the nozzle and heated bed surface ②, if b higher than a, contratotate to left of the couplings. Make b and a are equal; if b less than a . Clockwise rotation to left of the couplings. Make b and a are equal.



5.1.9.6 Double click the back arrow 's third gird, move the nozzle from right 200mm, which is moving to the heated bed surface on ③, to observe the distance c of the nozzle and heated bed surface

③ , if c higher than a, contratotate to right of the couplings , Make c and a are equal; if c less than a; Clockwise rotation to left of the couplings. Make c and a are equal.

5.1.9.7 Click , , , move the nozzle around left-right to heated bed surface on ①、②、③, To observe the three points whether on the same plane; if it is not on the same plane, please repeat operation 1.8.4—1.8.5, adjust it till to the same plane, then the three points and heated bed of the distance from the surface for a.

5.1.9.8 Click

-X





heated bed of the distance from the surface for a. Click the back arrow 's third gird, move the nozzle from front 100mm, which is moving to the heated bed surface on (5), to observe the distance d of the nozzle and heated bed surface (5), , if d higher than a, tighten the heated bed screw at the bottom, make d and a are equal; if d less than a , loose the heated bed screw at the bottom, make d and a are equal.



5.1.9.9 Double click the back arrow 's third gird, move the nozzle from front 200mm, which is moving to the heated bed surface on (8), to observe the distance f of the nozzle and heated bed surface (8), , if f higher than a, tighten the heated bed screw at the bottom, make f and a are equal; if f less than a, loose the heated bed screw at the bottom, make f and a are equal.



move the nozzle around front-back to heated bed surface on 2 , 5 , 8,

To observe the three points whether on the same plane; if it is not on the same plane, please repeat operation 1.8.t——1.8.8, adjust it till to the same plane, then the three points and heated bed of the distance from the surface for a. 5.1.9.11 In the same way, move the nozzle around front-back to heated bed surface on 3, 6, 9, ensure that the three points and nozzle of the distance from the surface for a. Then the seven point of 1, 2, 5, 8, 3, 6, 9 distance are equal with heated bed surface, Z-axis is balance with heated bed.

5.1.9.12 Click let three directions of X、Y、Z origin on one point. Click arrow X、Y, for X、Y in any direction is balanced.

5.2. TEST PRINTS

5.2.1PRE-TEST PREPARATIONS

组织 • 新建文件共				道•1
★ 收缩共 ▲	名称	國政自知	太型	大小
▶ 下載 ■ 最近 図 最近時回知世習	📕 StI of Fangu	2014/3/17 18:55	文件夫	
	atl of things	2014/3/17 18:56	文件夹	
	》STL文件查看工具	2014/3/17 18:55	文件夹	
 ● 祝焼 ● 四川 ● 文档 ● 出版下號 ● 目示 ● 计算机 ● にに C) 				
🗣 P346 👱	1			
文件	SiN0 120mmboxst		· GCode/ST	L-Files (*.gcode;*

5.2.2 OPEN THE BOX DOCUMENT STL BY NETFABB



5.2.3 SELECT THE APPROPRIATE SETTING, TO GENERATE G-CODE





6. 3D PRINT

6.1. USE PC PRINT

6.1.1 USE USB WIRE CONNECT 3D PRINTER WITH COMPUTER



6.1.2 OPEN REPETIER-HOST, SELECT "PRINT SETTING"





6.1.3 UPDATED 3D PRINTER PORT, USE IT AND CONFIRM IT .

6.1.4 OPEN THE STL FILE WHICH YOU ARE PRINTING



6.1.5 SELECT APPROPRIATE SETTINGS, AND GENERATES THE G-CODE



6.1.6 WAIT FOR THE CODE IS GENERATED, CLICK "RUNNING TASKS" THEN COMPUTER CAN

PRINT.



6.2. USE SD CARD PRINT

Use SD card print is called off-line printing, rational use off-line which can effectively improve print efficiency.

6.2.1 SD CARD INSERT IN COMPUTER THROUGH THE CARD READER , SAVE THE G-CODE ON SD

CARD.



;

Way 1 : Put the G-code file on the SD card, in Repetier-Host select start printing file on the SD card, then you can plug-off USB wire.

Repetier Host V0.84 - 15 stl + 1	and the second	len ()
214 RE 2R 7.000 FG D. B. D P P P P P P P P T RA STREE DIFES HE SOF REAL ROOM UN 2010		OG N
2月1日 御御御堂	- 把此始后 代码生成器 代码课境音 手站控制	
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Way 2: Rename the G-code file to init.g which you are printing , put it under the SD card catalog, restart printing, press the reset key-press or power-down and on again , the printer will automatically print G-code init.g.

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6.2.2 INSERT THE SD CARD TO ELECTRONICS, DIAL THE USB WIRE WHICH CONNECT WITH

COMPUTER, FOLLOW THE ABOVE TWO METHODS CAN OFF-LINE PRINT.



7. F&Q

7.1. WHAT TO DO IF FILAMENT IS RUNNING OUT ?

Heated to 230, stop the motor , pick up spring , pull out the old one and change the new one. 2.If the material is not attached on the board , which fail to stick , run with nozzle , how to solve it ? 1、Please check the heated bed temperature is enough, PLA is °C, ABS is 110 °C.

2 Please check the first layer of wire, it should be flattening on the heated bed. If it is not enough flat, please adjust a bit trigger position of the Z-axis endstop, make the nozzle distance closer to the heated bed.

3. But do not too flat, the first layer thickness is compressed about half the stander layer thickness.

4、 What to do if nozzle is in a jam? What to do if extruder idle? What to do if it is not discharge material.

There are two drill bit, one is 3mm, and drill nozzle feed back into the big hole; another is 0.4mm, the way to slove the in jam of drill front nozzle small hole is : remove the nozzle, use nipper plier grip drill, hand-operation drill, when heated to 230 °C, to simulate the process of nozzle, drill big hole (note: use drill bit to pick up the waste and garbage in several times), drill small hole, and operation again, then the nozzle would be a new one.

8. CONTACT US

Shenzhen RP3D Technology Co. Ltd is a leader of open-source 3D printer in domestic, the pioneers and practitioners of open source hardware concept, Pangu designers , manufacturers of open source 3D printer.

Company address: Firstfloor,Building D, Ganghua Technology Park,Lixin Road, Danzhutou, Longgang District, Shenzhen, China

Telephone :+86 755 2870 0806

Mobile : +86 133 1656 0709

Contact person : Chris

e-mail: chris@rp3d.com

Website: http://www.rp3d.com/, http://www.

Alibaba: http://szrp3d.1688.com/

Taobao shop :<u>http://rp3d.taobao.com/</u>