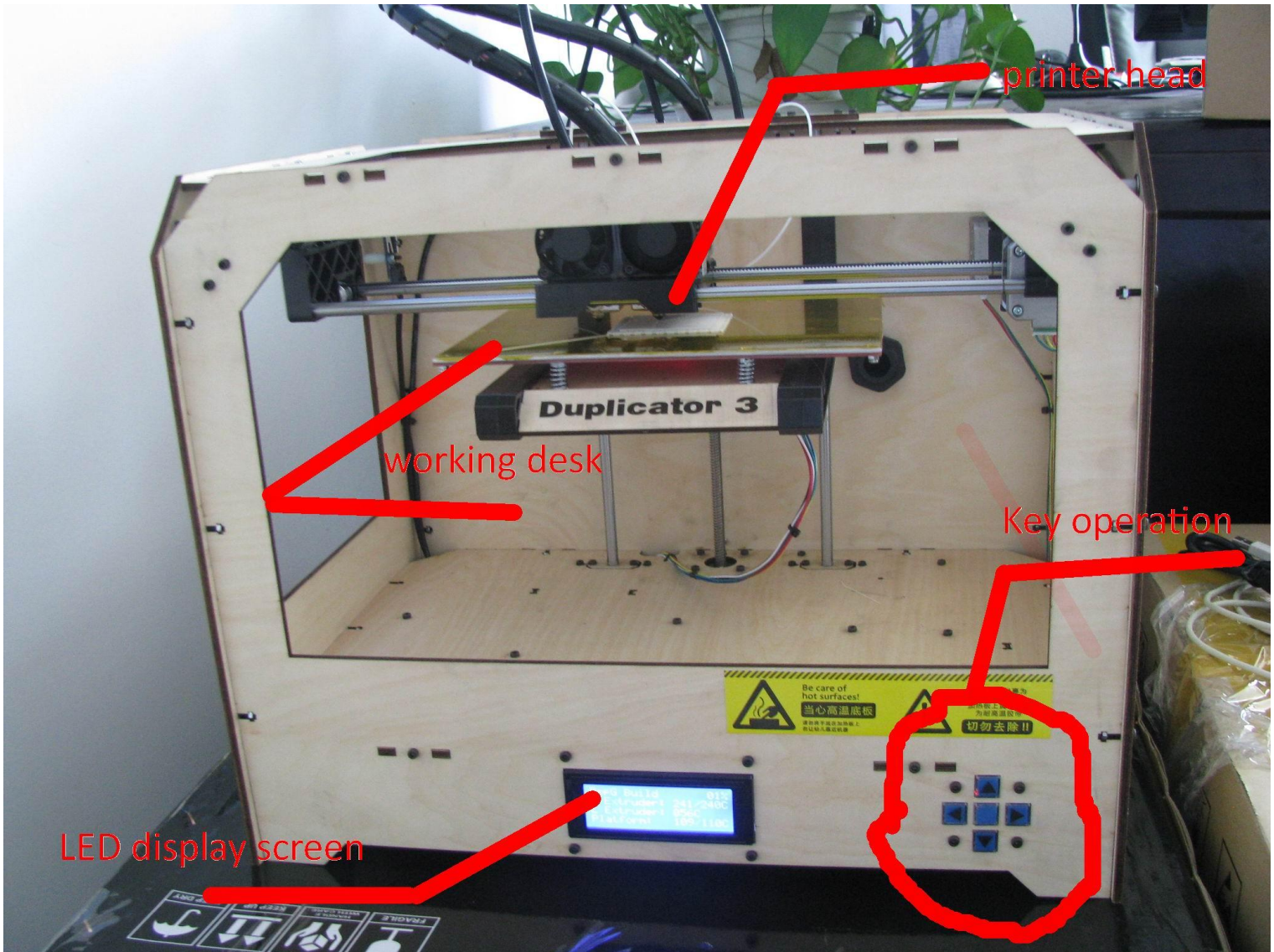




Desk-top 3Dprinter Operating Instructions



1.Unpacking Guid

5. Two heads print

2.Install the printer driver

6.Put in/out material

3.General parameter settings

7.SD card print

4.Connect printer

Unpacking Guide

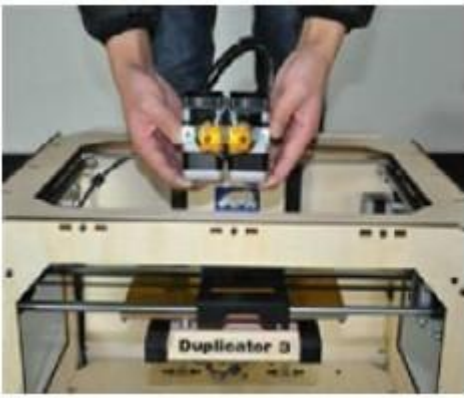
- 1) Remove the plug at top of the rectangular tray, then out of laminated cardboard circumference around the printer.



- 2) Out of the printer, open the printer small box, out of toolkit and nozzles.



- 3) Install the nozzle according to the chart below shows (using the supplied tools) in the plastic rail.



Install the printer driver

1) Install JAVA driver



JavaSetup6u27 (1)

2) Install PYTHON driver

Install PYTHON.



python-2.6.6 (2)

3) Install PYSCO driver

Install Pysco(optional)



psyco-1.6.win32-py25
(4)

4) Install 3G graph driver

1. Install drive software REPLICATOR G.



ReplicatorG-0040-...

General parameter settings



一般参数设置

- 1) Slice configuration select: replicator slicing defaults
- 2) Select the left and right nozzle print, If select left, the left nozzle will print. If select right nozzle, the right nozzle will print.
- 3) If your sample is vacant structure, you need to select printer support. **NONE** is not need support, **EXTERIOR** is surface support, **FULL SUPPORT** is all the support.
- 4) Fill ratio: 100% is solid print, we generally choose 10% filled in order to save consumable
- 5) Layer thickness: Layer thickness is depend on precision. We generally printer small thickness of 0.18mm, usually print thickness 0.27mm.
- 6) Wall thickness: usually 1

Connect printer

- 1) Connect printer and computer by data cable, and turn on the power supply
- 2) Click the printer options



- 3) Select the serial port to connect, if there is no serial port to connect, please rescan



4) Multiple scans does not appear to serial port shall be driven: Right-click the computer----Attribute---Device Manager



5)

6) Click the replicator right-hand button, select update driver software, select browse my computer for driver software.

您想如何搜索驱动程序软件？

→ 自动搜索更新的驱动程序软件(S)
Windows 将在您的计算机和 Internet 上查找用于相关设备的最新驱动程序软件，除非在设备安装设备中禁用该功能。

→ 浏览计算机以查找驱动程序软件(R)
手动查找并安装驱动程序软件。

7) Click browse software location, click drivers file's ftdi USB drivers and confirm it, then click next, re-scan the serial port.

8) Click on the button of “link the printer” when the frame turns green, it mean successful connection.

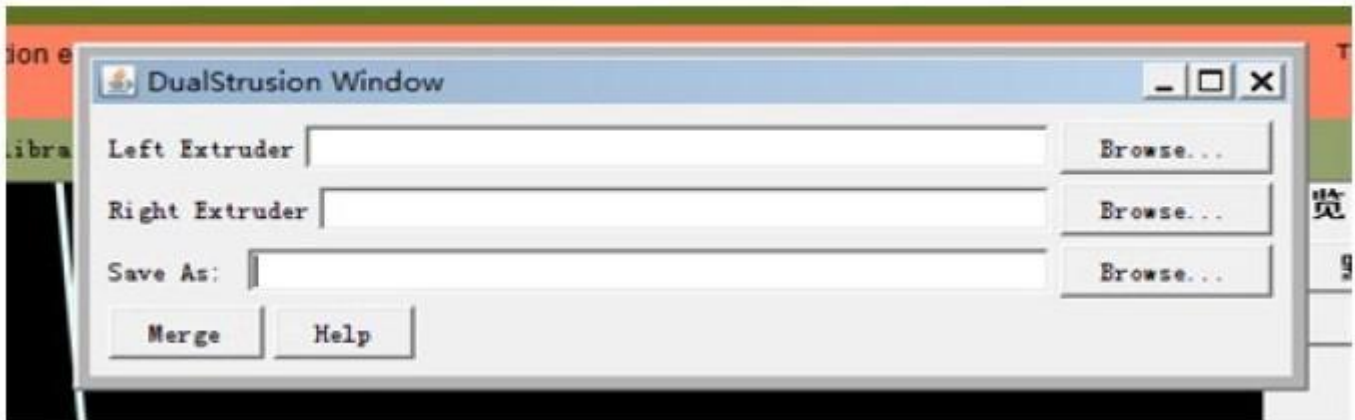


Two-head printing

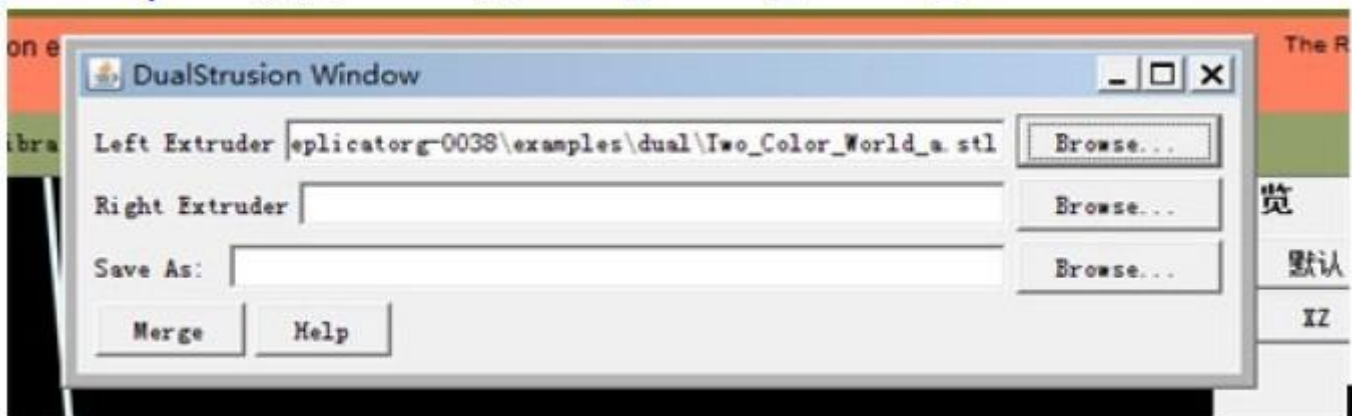
1) Open replicator G operating software, then click “gcode”, select last column double-headed merger print. “.stl” option..



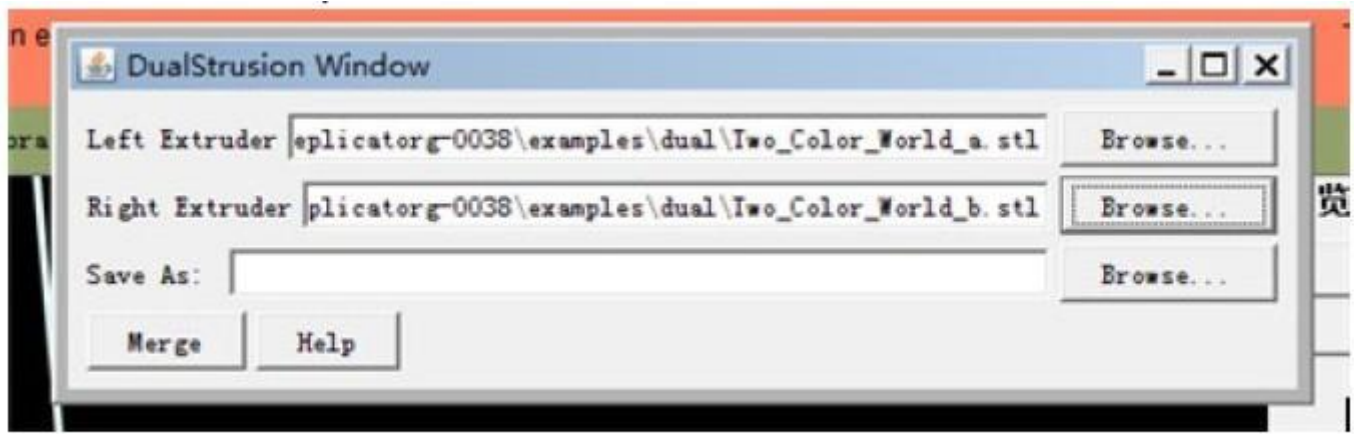
2) Click double-head merger printer. “stl” option will appear the following dialog box



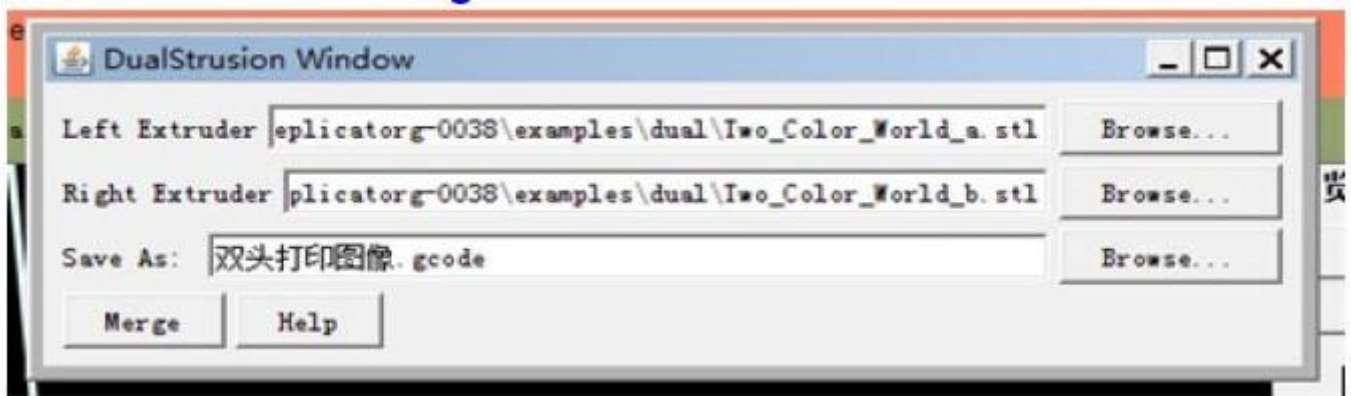
3) Left nozzle click browse, find the file of “replicatorg-0038”, click “examples” select Two_color of dual_world_a.stl



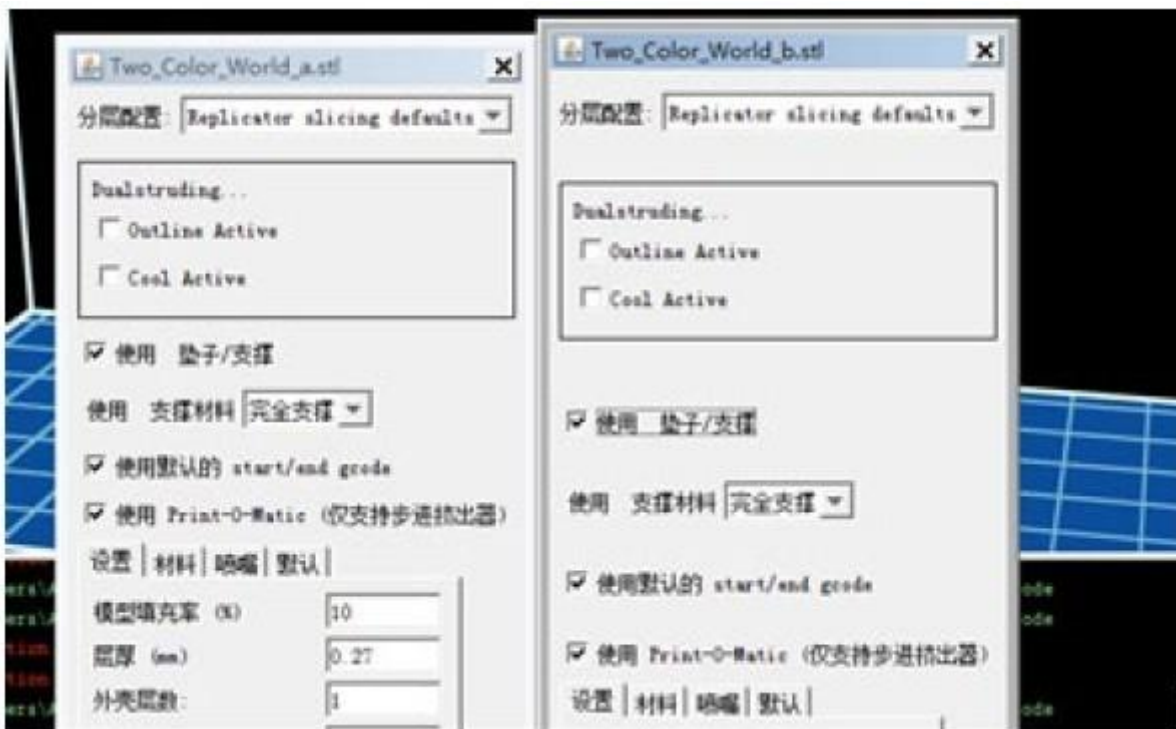
4) Right nozzle click browse, find the file of “ replicatorg-0038” ,click “examples” select the Two_Color of dual_world_b.stl



5) Save it in desktop, suffix named “.gcode”



6) Click “merge”, will appear two dialog box of “G” code, remove “√” of base/support, and then one by one generate G-code



7) When generate finished, start two colors printing

8) Put in /out material

Put in ABS/PLA :

1) Turn on the power of printer, the printer LED screen will appear: Build from SD

Preheat

Utilities

2) Select “Utilities” , click “M” of button plat , it will appear: Montior Mde

Change filament

Level Build Plate

Home Axes

3) Select” Change filament” , click “M” of button plat, it will appear: Load Right

Unload Right

Load Left

Unload Left

4) Select” Load right” , click “M” of button plat, it will appear : I’m heating up, my extruder!

the temperature of right nozzle is warming now, when it reaches 220°C, nozzle will start work, if

it does work, you can click several times of “M” until the nozzle working (left nozzle put in

ABS/PLA working process as same as right nozzle, also choose [load left](#))

Put out ABS/PLA :

1) Turn on the power of printer, the printer LED screen will appear: Build from SD

Preheat

Utilities

2)Select “Utilities” , click “M” of button plat, it will appear: Montior Mde

Change filament

Level Build Plate

Home Axes

4) Select “Change filament” , click “M” of button plat, it will appear: Load Right

Unload Right

Load Left

Unload Left

Select “Unload right” , click “M” of button plat, it will appear: I’m heating up, my extruder! the temperature of right nozzle is warming now, when it reaches 220°C , nozzle will start work, if it does work, you can click several times of “M” until the nozzle working (left nozzle put out ABS/PLA Unload Left, other steps is same as right nozzle)

SD card print

- 1) First, the STL file guided into our printing software to generate G-code.
- 2) When G-code finished, click the third button (create a print file though SD)



- 3) Save it in desktop, then find the S3G format guide to SD card
- 4) When S3G format guide to SD card, put the SD card into the machine SD card socked.(on the bottom right of the front of the machine).Then LED will appear: Build from SD

Preheat

Utilities

- 5) Select “Build from SD” , click “M” right button of the machine, select the S3G format file you need, Then click “M”, then will come out the bottom plate and the nozzle in the heated state. When the temperature is OK , you can print