

# Quick Start Guide

high speed 3D printer



## 1. Accessories list

### Packing list

High Speed 3D printer	The Power Adapter	Power Cable	Filament Spool Holder
USB Cable	External Fan	Filament Tube	M3 screw
Printing platform A	Inner hexagon spanner	HS Filament	Tweezers
AR Identification Sticker	Quick-start guide	USB flash disk (including RV slicing software, etc.)	Cut Pliers

## 2. Accessories setup



(1) Connect the power cords



(2) Install the Filament Spool Holder



(3) Install the External Fan on the upper right and connect the cable



(4) Install the Filament Tube into the tube holder

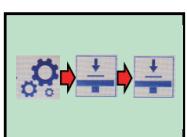


(5) Check whether the "Printing platform A" is placed correctly



(6) Place the filament and feed filament through the tube until approx. 5cm are visible on the extruder end

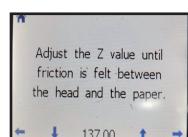
## 3. Platform calibration



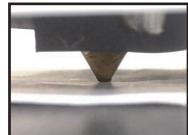
(1) Switch on, select the icons shown above in order on the main menu



(2) After tightening, loosen the screw one circle and click the right arrow



(3) Read the instruction on the screen and adjust the distance between the nozzle and the platform, about 1 ~ 2mm



(4) Place the leveling card between the nozzle and the platform

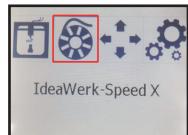


(5) Turn the "screw 1" and move the leveling card until the card has a slight friction, and then adjust the "screw 2" and "screw 3" in order

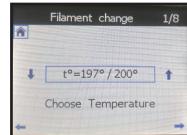


(6) Going back 2 steps in the process and use the leveling card again to reconfirm the adjustment

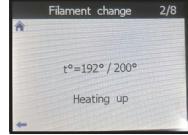
## 4. Filament change



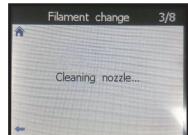
(1) Click the "Filament loading" button



(2) Set the target temperature and go to the next step



(3) Temperature will rise up as set and wait until next step



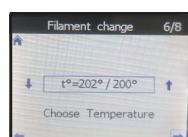
(4) Wait until next step



(5) Wait until next step



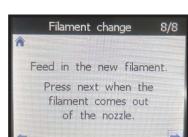
(6) Click next step



(7) Click next step



(8) Insert the filament into the hole of the extruder

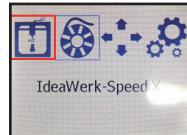


(9) Click next step when the filament comes out of the nozzle

## 5. Model printing



(1) Insert USB flash drive



(2) Click "printing" icon (touch screen)



(3) Select Print File

## 6. FAQ

### Why is the model not sticking or warping?

A: the model may not stick or the edge may be warped as follows:

- If the leveling is not well adjusted, the printing platform is high on one side and low on the other side, it leads the edge warped, and it needs to be leveled again
- If the leveling is not well adjusted, the gap between the platform and the nozzle is too large, which leads to the model not sticking, so it needs to be leveled again
- The first layer printing speed is too fast, so it is necessary to adjust the first layer printing speed in slicing software parameters
- The printing platform has water, oil or other things that affect adhesion, so it needs to be cleaned

### Why doesn't the nozzle discharge or make "thump" sound?

A: there may be several cases of non discharging::

- The printing head is not used for a long time at high temperature, which results in carbonization of the material inside. It is necessary to clean the extrusion head. Refer to the detailed operation manual for disassembly method
- There is no gap between the leveling nozzle and the platform, or the nozzle directly scrapes onto the platform, so that the material can not be extruded, so it needs to be leveled again. If the printing platform is seriously scratched, the printing platform needs to be replaced
- The nozzle hole is blocked due to foreign matters in the printing material, which can be cleaned up with a needle or a pair of scissors

### Why is the printed model too tight to take off?

A: there is no gap between the nozzle and the platform, resulting in the nozzle directly scraping on the lower layer of the printing platform when printing, resulting in the adhesion with the platform and the need for releveling