

FUNMAT PRO 410 QUICK START GUIDE

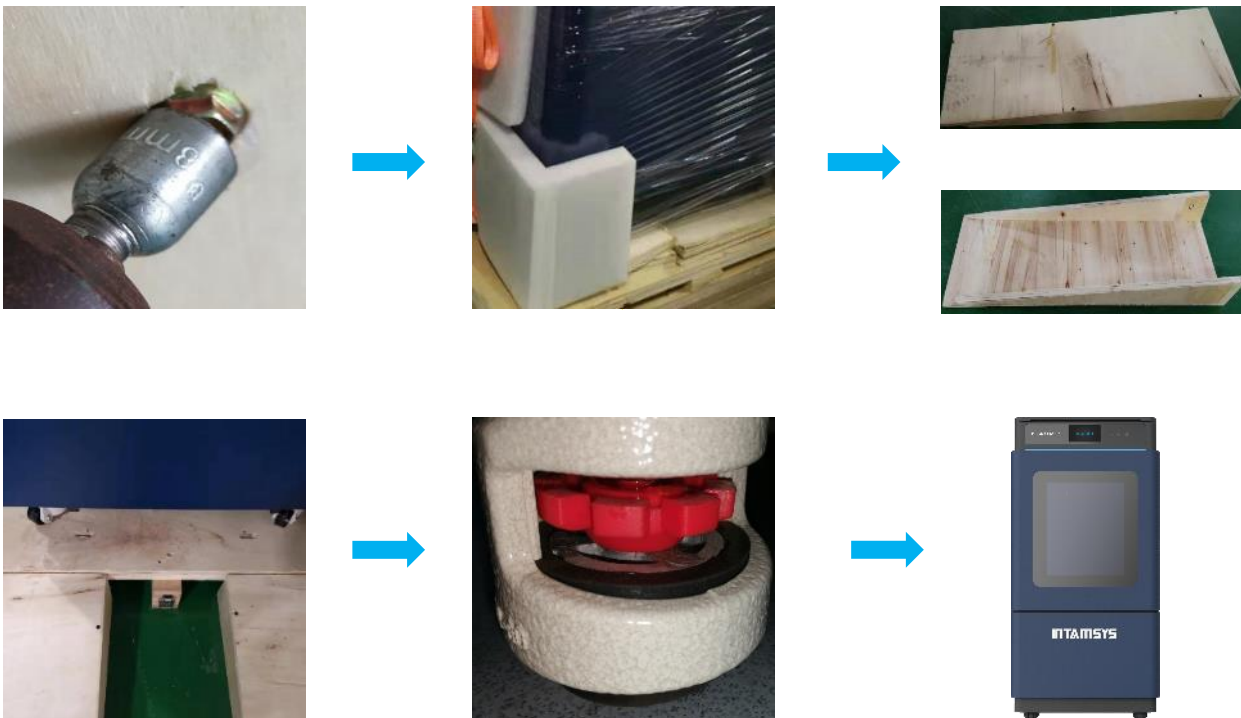
Remove the packaging

STEP 1: Unscrew the wooden box with an 8mm sleeve, remove all the plates, the ties, the stretch film.

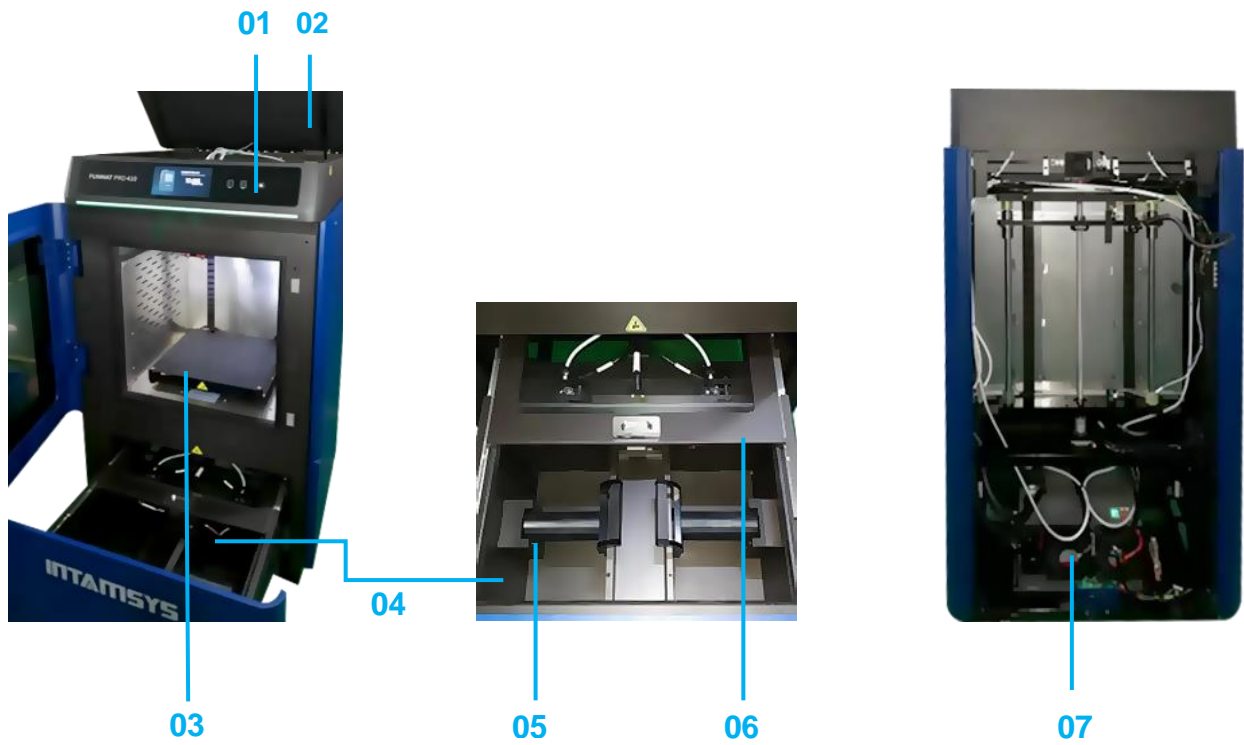
STEP 2: Take out the wooden plates under the printer, use a cross screwdriver to assemble them into ramps with the nails attached on the plate, then connect the ramps to the baseplate. Make sure the ramps are properly and securely mounted together.

STEP 3: Release the caster wheels by rotating clockwise, gently move the printer to a flat, solid and sturdy ground.

STEP 4: Push the filament door, open the filament box, then take out the power cable and the funnel.



Layout of printer



01 Smart touch panel

02 Top cover

03 Build plate

04 Filament chamber

05 Filament shaft

06 Filament chamber hatch

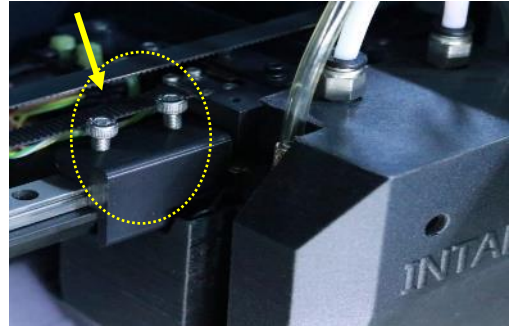
07 Water cooling unit

Prepare the printer

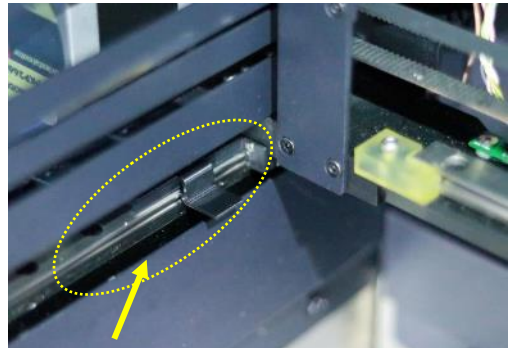
1. Release XY Modules

STEP 1: Pull out the door from the right side of the machine.

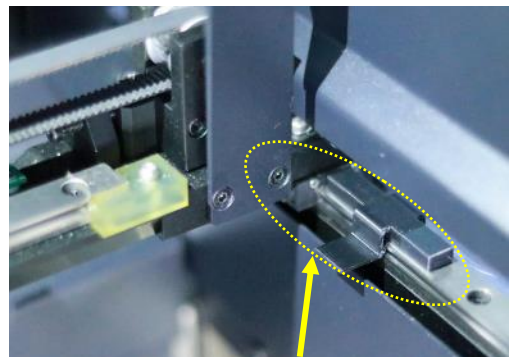
STEP 2: Unscrew and take away the stop block on the extruder linear guide.



STEP 3: Pull the buckle upward and take away the stop block on the left linear guide.



STEP 4: Pull the buckle upward and take away the stop block on the right linear guide.



2. Power on the printer

STEP 1: Unscrew the backboard of the printer with a 13mm sleeve, and inject 600~700 ml Anhydrous Coolant with green or other colors. (A measuring cup is recommended. The cap of water cooling unit should be re-tightened after injecting coolant).



STEP 2: Connect the power cable and power on the printer, touch anywhere on the screen to exit the screensaver.



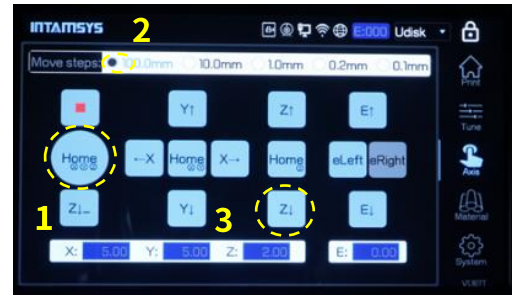
STEP 3: Press “Axis” , and then press “Home z” .
Finally, take out the accessory box.



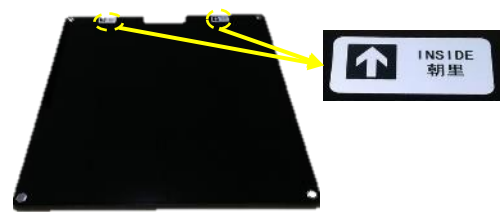
3. Install the build plate

STEP 1: Press the “Home” icon for X, Y, Z.

STEP 2: Move the heating bed by pressing “Z↓” with 100mm step to a suitable height. (No more than 3 times)

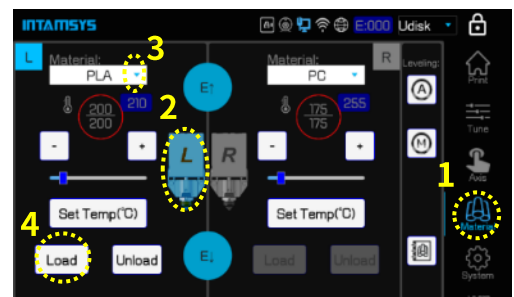


STEP 3: Install the build plate on the heating bed according to the build plate insertion direction.



4. Load material

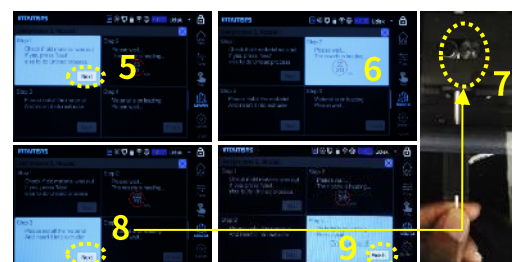
STEP 1: Press the “Material” icon, and then press “L” icon to select left extruder. The icon will be highlighted when it has been selected. (Same with the right extruder.)



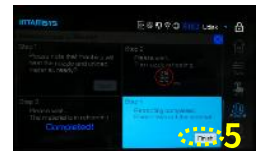
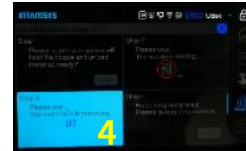
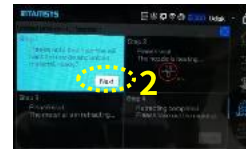
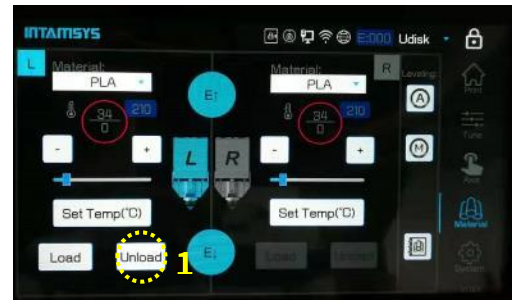
STEP 2: Press the drop-down menu to select material.

Make sure the material you select is the same with the one you want to load.

STEP 3: And then press “Load” icon, there are in total 4 steps to load material, after 120 seconds loading process ended, press “Finish” . (If the filament is not extruded out from the nozzle, long press “E↓” till the filament comes out.)




* Unload material by pressing “Unload” icon and then follow the instructions on the screen.

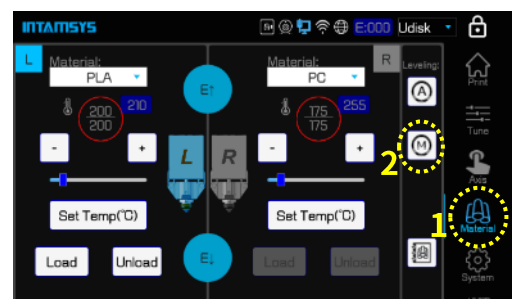


5. Bed Leveling

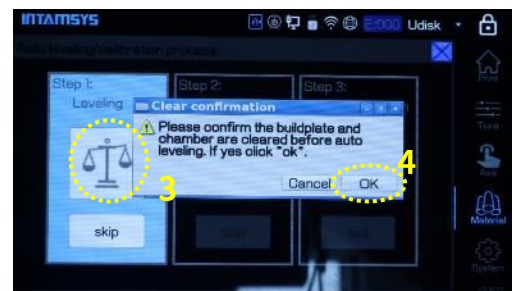
There are two methods of bed leveling: Manual Leveling and Auto Leveling.

Manual Bed Leveling

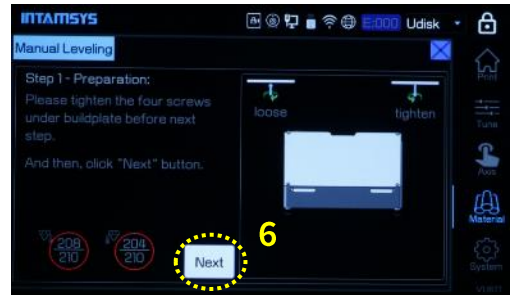
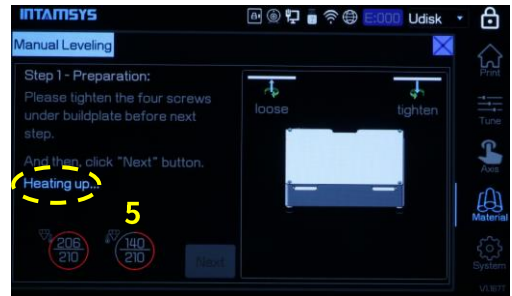
STEP 1: Press the “Material” icon, and then press the  icon.



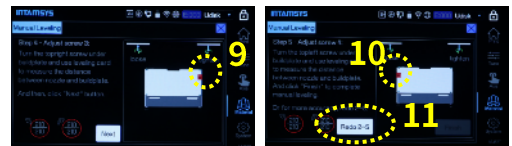
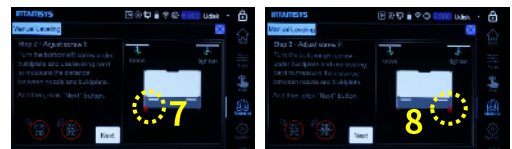
STEP 2: Press the leveling  icon, and then press OK.



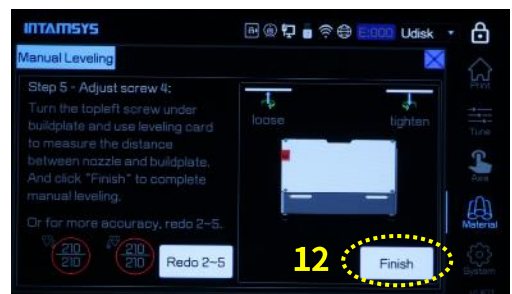
STEP 3: After the nozzle is heated up, press “Next” .




STEP 4: There are 4 screws which need to be adjusted one by one for at least twice, by using the leveling card with 0.2mm thickness.

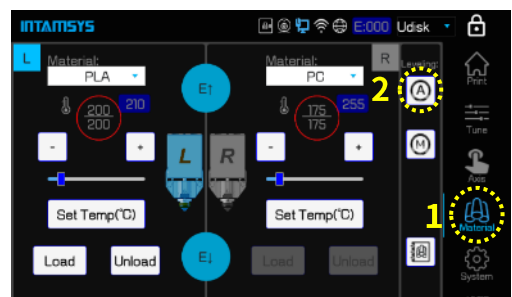


STEP 5: Press “Finish” to exit the process after adjustment is completed.

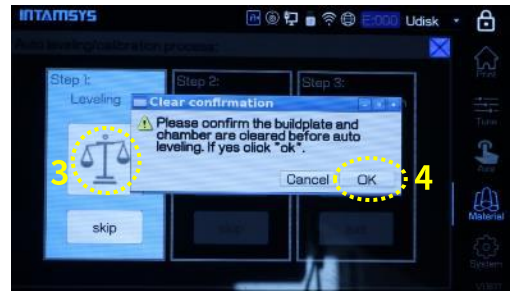


Auto Bed Leveling

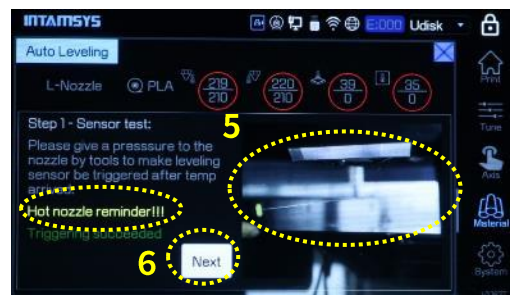
STEP 1: Press the “Material” icon, and then press the  icon.



STEP 2: Press the leveling  icon, and then press OK.



STEP 3: After the nozzle is heated up, press the nozzle up with the tool as shown in the figure. When seeing **“Triggering succeeded”**, press **“Next”** .

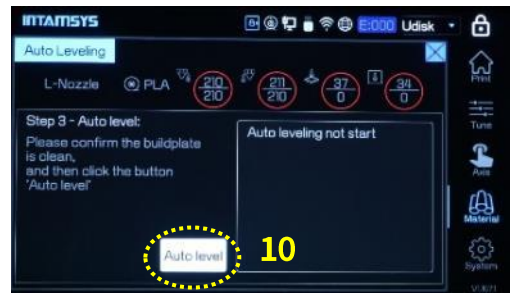


STEP 4: Clean the nozzle and the build plate, then adjust the Z axis with a leveling card with a thickness of 0.2mm according to the instruction on screen.

STEP 5: Remove the leveling card after adjustment is OK, and then press **“Calibrate”** . When calibration is done press **“Next”** .



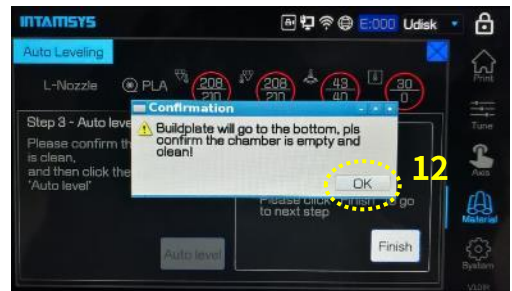
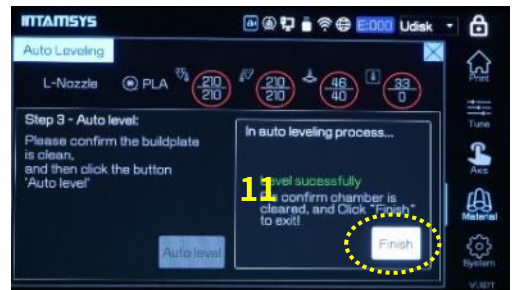
STEP 6: Keep the nozzle and build plate clean, then press “Auto level” .



STEP 7: The printer will perform a 3-points automatic leveling.



STEP 8: Press “Finish” after leveling is successful, the build plate will go downwards and then upwards to Z home.



Calibrate the printer

1. Z Calibration

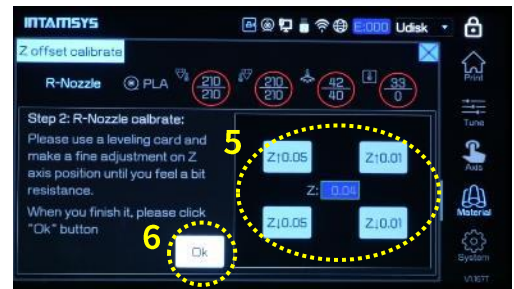
STEP 1: Press “Z calibration” icon and confirm with “OK” .



STEP 2: Press “Z↑” or “Z↓” to perform the left nozzle calibration by using a leveling card with a 0.2mm thickness, and then press “Next” . (There are two steps for different adjusting accuracy, 0.05mm and 0.01mm.)



STEP 3: Perform calibration for the right nozzle by following the same steps, press “OK” to complete the total calibration.

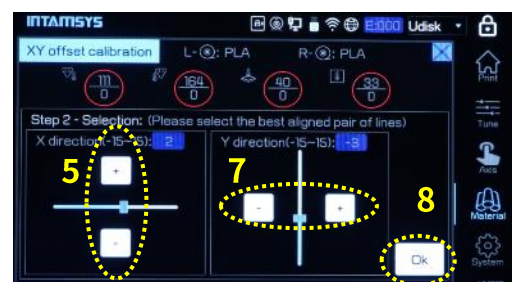
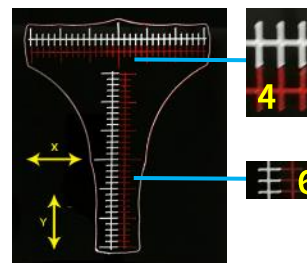


XY calibration

STEP 1: Press “XY calibration” and then press “Next” , the printing process starts. After printing is completed, press “Next” .

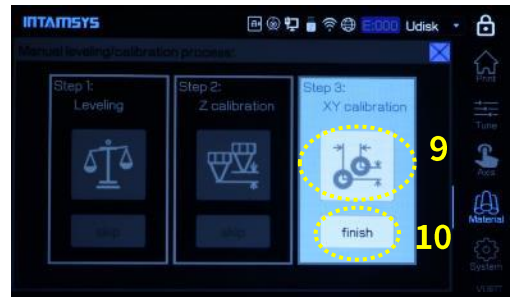


STEP 2: Check the printed model and set the corresponding offset value, press “OK” .



STEP 3: Redo the Printing Calibration as last step, till the centerline are completely aligned and then press “Finish” to complete the calibration.

* If there are no lines are aligned with each other, set 15 firstly on the corresponding direction, redo the printing and reset the offset value.

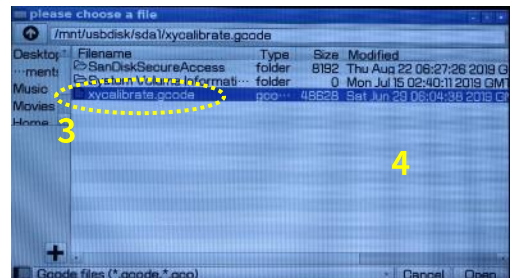


Printing process

STEP 1: Insert the USB flash disk, press Open  icon



STEP 2: Select the file, and press “Open” .



STEP 3: Firstly, the left nozzle is heated up and start printing, then the right nozzle will follow the same process.



Install Software

After successfully setting up the printer, install the INTAM-SUITE software on your computer. It is available for Windows and Linux.

User Manual

You can download it from this link: <https://www.intamsys.com/3d-printer-manuals/>

Support

For more information or technical support please visit: www.intamsys.com/support/ (or contact your nearby reseller)

Warranty

The detail warranty information please refer to spare parts list or user manual.