



# USER MANUAL

## GEMINI S IDEX 3D PRINTER

3D打印机使用说明书







When unpacking, please check the packing list to ensure that no parts are lost or damaged. If any, please contact our after-sales personnel immediately and we will reissue them for you in the shortest time.

开箱时,请对照装箱清单,确保无零件的丢失及损坏,如有发生,请立即联系我们的售后人员,我们会在最短时间内为您补发。



Please use the machine in a ventilated, dry, clean and flat environment.

请在通风、干燥、清洁、平坦的环境中使用机器。



The machine contains high-speed moving parts and high-temperature parts. Children are not allowed to use the printer alone.

该机器包含高速运动部件和高温部件,儿童不得单独使用打印机。



Part of the accessories are consumable, the warranty time is different.

部分配件为易耗品,保修时间不同。



In an emergency, you can turn off the power directly.

在紧急情况下,可直接关闭电源。



If user modifies or disassembles the core components of the machine without authorization, the situation is not covered by the warranty.

如果用户擅自改装或者拆卸导致机器的核心部件,则该情况不在保修范围内。



Video, software and other related information are stored in the SD card, please check.

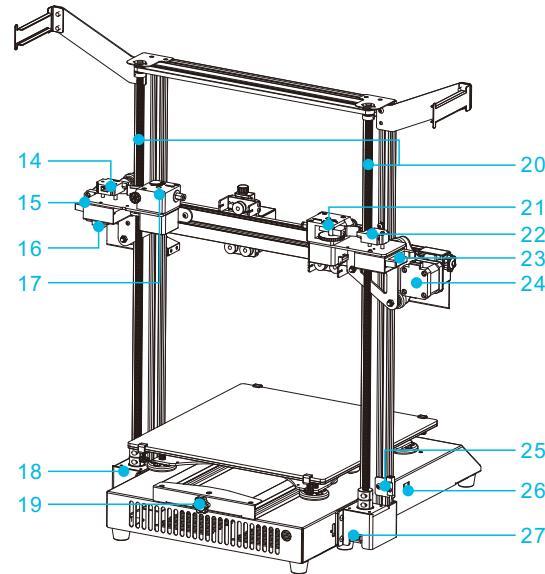
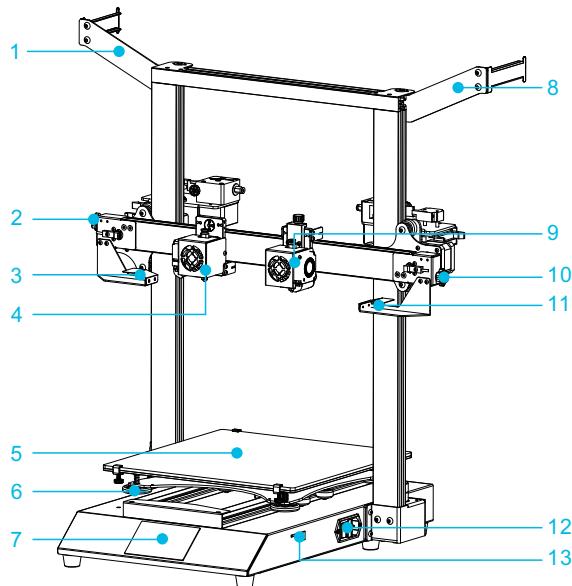
视频,软件等相关信息存储在SD卡中,请查看。

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1 Left filament holder 左料架

2 Left belt regulator 左皮带调节器

3 Left nozzle brush 左喷嘴刷

4 E1 print head E1打印头

5 Hot bed 热床

6 Leveling adjustment nut 调平螺母

7 Touch screen 触摸屏

8 Right filament holder 右料架

9 E2 print head E2打印头

10 Right belt regulator 右皮带调节

11 Right nozzle brush 右喷嘴刷

12 Power switch and power cord slot 电源开关和电源线槽

13 TF card and USB cable slot TF卡和USB插槽

14 E2 filament run-out detector E2断料检测器

15 Right adapter board wiring port 右转接板接线口

16 X axis right motor 右X轴电机

17 E2 TITAN extruder E2泰坦挤出机

18 Right Z axis motor 右Z轴电机

19 Y-axis belt regulator Y轴皮带调节器

20 Screw rod 丝杆

21 E1 TITAN extruder E1泰坦挤出机

22 E1 filament run-out detector E1断料检测器

23 Left adapter board wiring port 左转接板接线口

24 X axis left motor 左X轴电机

25 Z axis metal limit switch Z轴金属限位开关

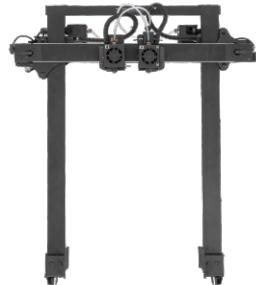
26 Voltage switch 电压转换开关

27 Left Z axis motor 左Z轴电机

## Parameter 设备参数

Print parameters 打印参数	
Print size 打印尺寸	300*300*390mm (Single head printing 单头打印)
Print accuracy 打印精度	0.1-0.3mm
Print principle 印刷原理	FDM (fused deposition molding 熔融沉积成型)
Nozzle size 喷嘴尺寸	0.4mm
Nozzle quantity 喷嘴数量	2
Print speed 打印速度	20-150mm/s (advise 60mm/s 建议 60mm/s)
Position accuracy 位置精度	X/Y -0.00625mm, Z - 0.00125mm
Filaments support 耗材支持	PLA, ABS, PETG, TPU...
Temp parameters 温度参数	
Printing environment temp 打印环境温度	8-40°C
Nozzle temp 喷嘴温度	275°C (MAX 最大)
Power supply 电源参数	
DC 24V/360W AC 110/220V 50/60Hz	
Software 软件	
Slice software 切片软件	Cura, Simplify3D
Input format 输入格式	.stl, .obj
Output format 输出格式	.gcode
Connection 连接	TF card, USB cable TF卡、USB接口
Machine parameters 机器参数	
Machine size 机器尺寸	660*495*695mm
Package size 包装尺寸	720*630*235mm
Machine weight 机器重量	≈16.5kg

# Packing list 包装清单



1 Gantry frame  
龙门架



2 Base  
底座



3 Lattice glass  
晶格玻璃



4 Filament holder\*2  
料架\*2



5 Nozzle cleaning iron sheet\*2  
喷嘴清理片\*2



6 Filament\*2  
耗材\*2



7 Power cable  
电源线



8 Shovel  
铲刀



9 Cutting pliers  
剪刀



10 Toolkit  
工具包

## Toolkit list

### 工具包清单



11  
Clip  
夹子



12  
T-shaped allen wrench  
T型内六角扳手



13  
Slotted screwdriver  
一字螺丝刀



14  
L-shaped allen wrench  
L型内六角扳手



15  
Wrench  
扳手



16  
M4\*10 screws  
M4\*10螺丝



17  
M3\*4 screws  
M3\*4螺丝



18  
Card reader and memory card  
垫读器与内存卡片



19  
Tie  
扎带



20  
USB cable  
USB连接线

# Install the gantry frame 安装龙门架



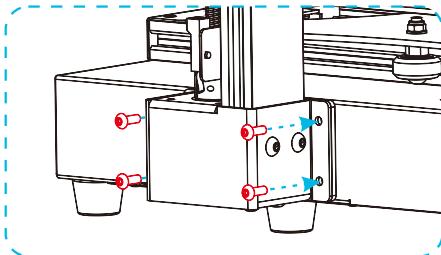
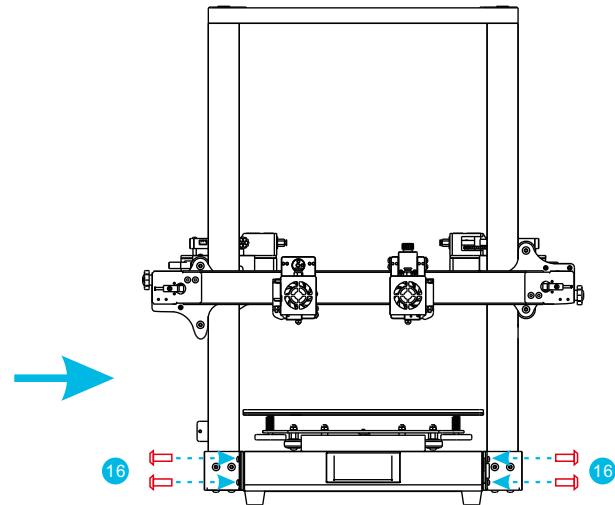
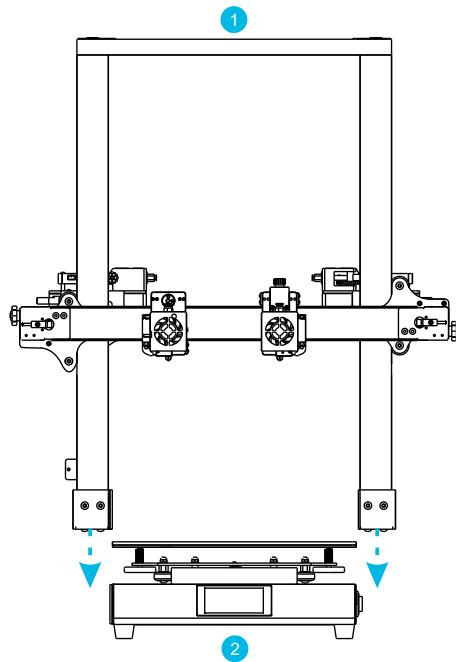
1 Gantry frame 龙门架



2 Base 底座



16 M4\*10 screws \*8  
M4\*10螺丝



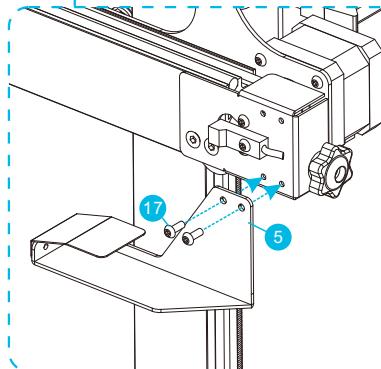
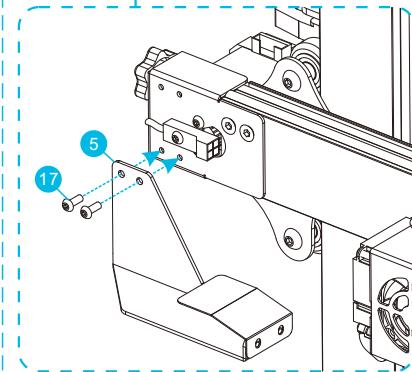
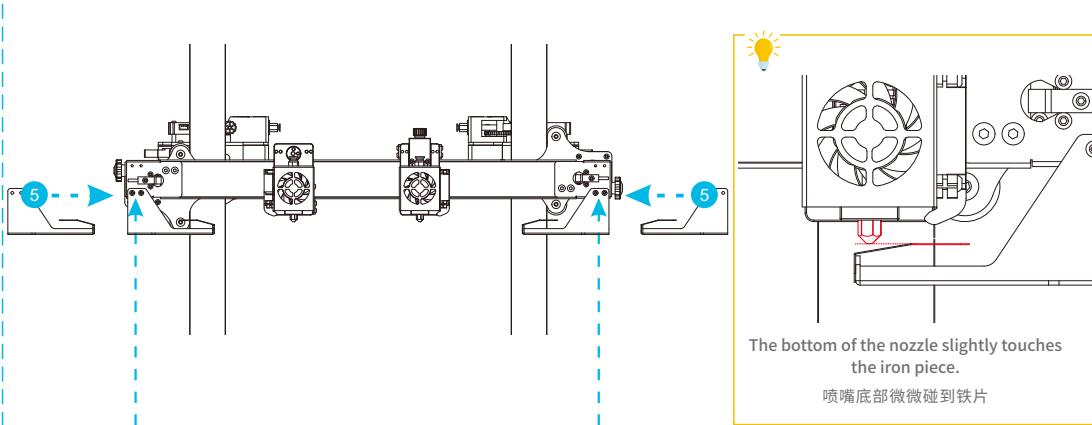
# Install the Nozzle cleaning iron sheet 安装喷嘴清理片



6  
Nozzle cleaning iron sheet\*2  
喷嘴清理片\*2



17  
M3\*4 screws \*4  
M3\*4 螺丝\*4

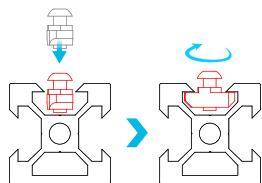


# Filament holder installation 安装料架



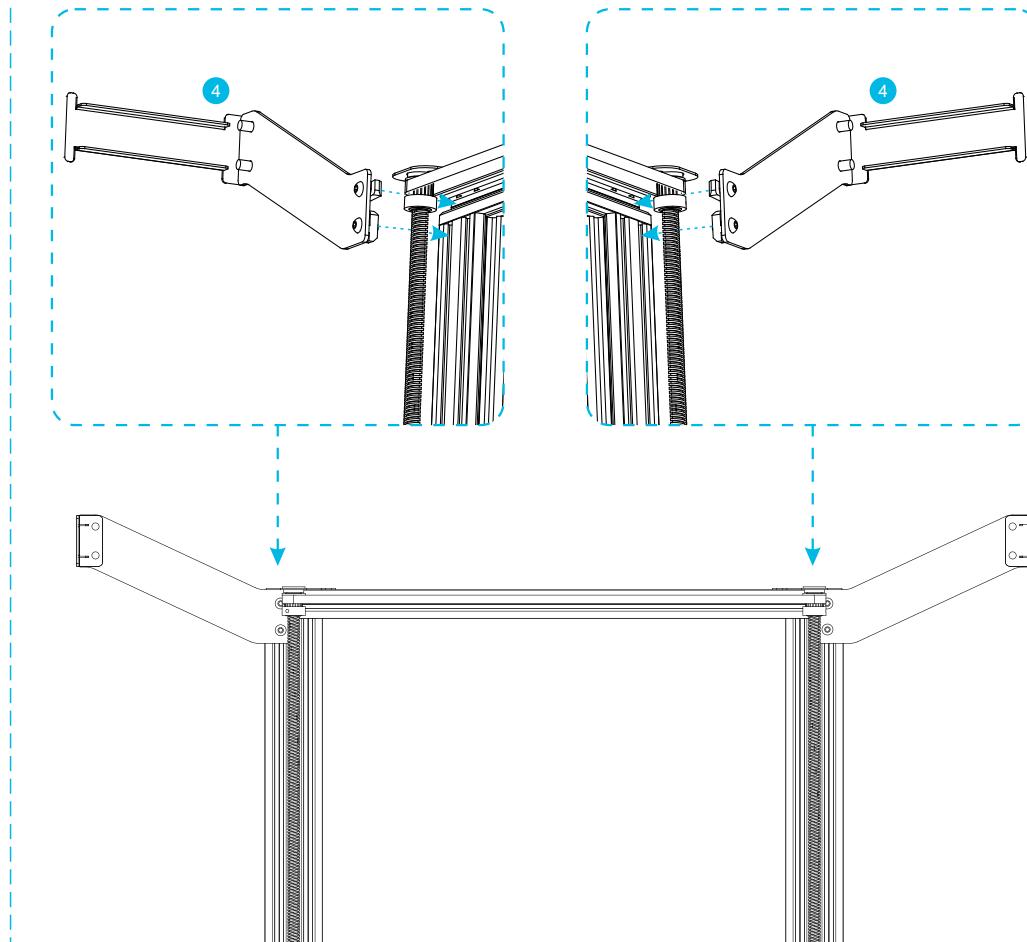
Filament holder\*2  
料架\*2

## Working principle of boat nut 船型螺母的工作原理

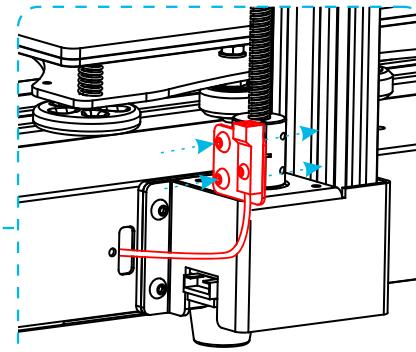
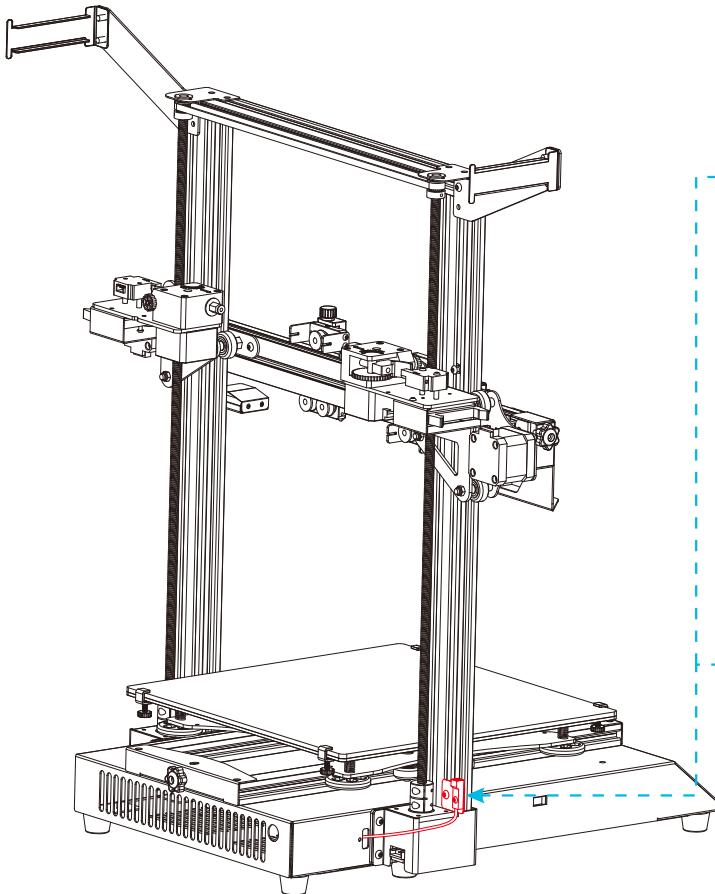


Loosen the boat nut on the filament holder slightly, pay attention not to remove the nut, then put it into the groove of the aluminum profile in parallel direction, and tighten the screw clockwise quickly, so that the boat nut is stuck in the groove of the aluminum profile at 90°.

略微松开料架上的船型螺母，注意无需取下螺母，然后平行方向放入铝型材的槽内，顺时针快速拧紧螺丝，使得船型螺母90°卡在铝型材的槽内。

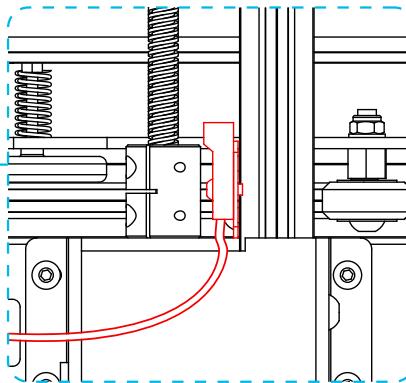


## Install limit switch of z axis 安装z轴限位开关



Use the ship nut to install the limit switch to the position shown in the gantry. Note that the installation position is in the outer groove of the aluminum profile.

使用船型螺母将限位开关安装到龙门架的图中位置，  
注意安装的位置是在铝型材的外槽。



Install it close to the bottom position

紧贴最下方的位置安装即可

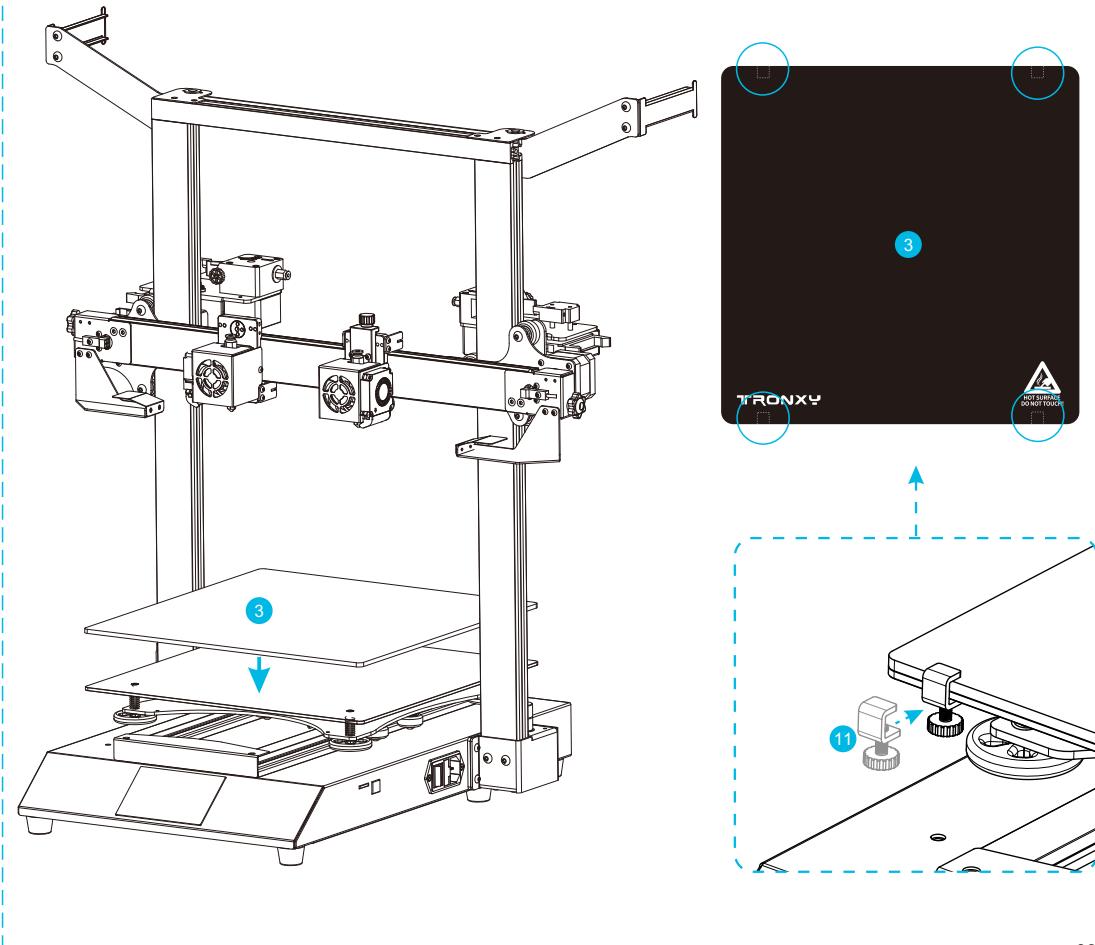
## Install the lattice glass plate 安装晶格玻璃面板



3  
Lattice glass  
晶格玻璃



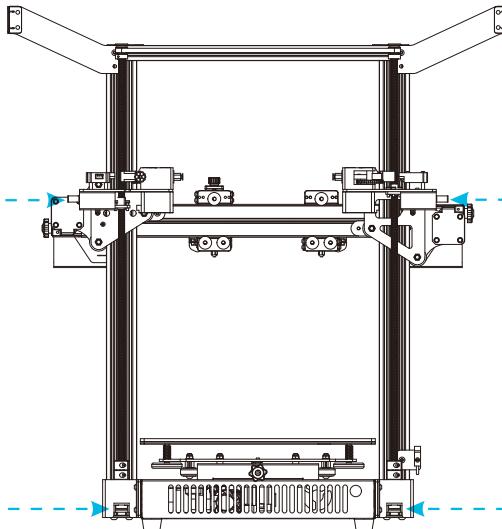
11  
Clip\*4  
夹子\*4



## Cable connection 设备接线



Right adapter board wiring port  
右转接板接线口



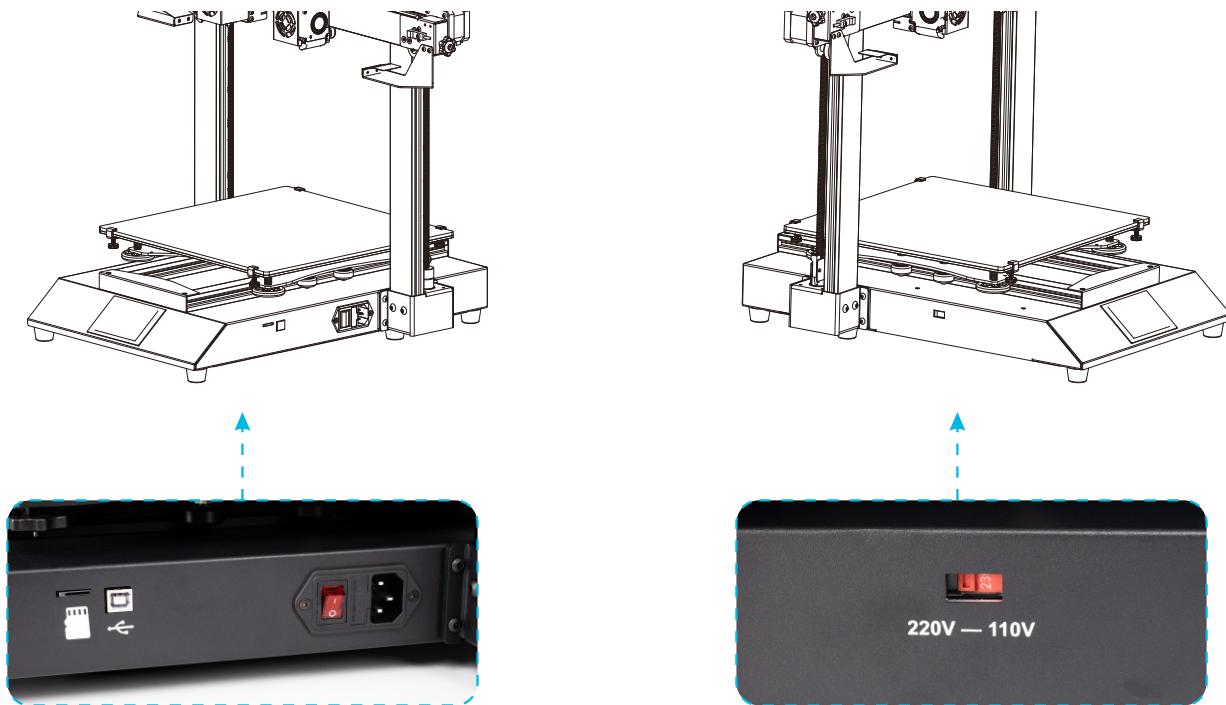
Left adapter board wiring port  
左转接板接线口



Right Z axis motor  
右Z轴电机



Left Z axis motor  
左Z轴电机



The slot of TF card, USB cable and power cord, and the power switch of the printer are all on the right side of the printer, as shown in the figure.

TF卡,USB线和电源线的插口以及打印机的电源开关,均在打印机的右侧,如图中所示。

The output voltage of the printer can be adjusted at will according to the customer's needs. Dial the Red Square to the left, and the voltage is 220V. On the contrary, it is 110V. (Before turning on the power supply, customers should pay attention to whether the voltage is consistent with the local voltage.)

打印机的输出电压可根据客户的需求随意调整,将红色方块拨至左侧,电压为220V,相反则为110V,(在接通电源之前,客户需注意该电压是否与当地电压一致。)

# Leveling of the hot bed 热床的调平

## 1. Use the E1 print head to level the hot bed platform

使用E1打印头调平热床

### step 1: Change the printer's printing mode to "Duplicate" or "Mirror" mode.

步骤1：更改打印机的打印模式为“复制”或“镜像”模式。



Select "System"  
选择“系统”



Select "Mode"  
选择“模式”



Choose "AutoPark" mode  
选择“自动停靠”模式

### step 2: Start manual leveling.

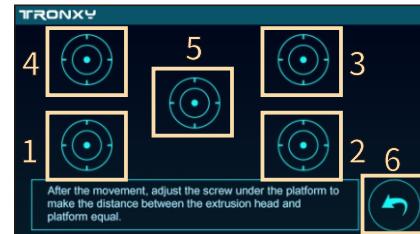
步骤2：进行手动调平操作。



Select "Tool"  
选择“工具”



Select "Level" → "Manual"  
选择“调平” → “手动”



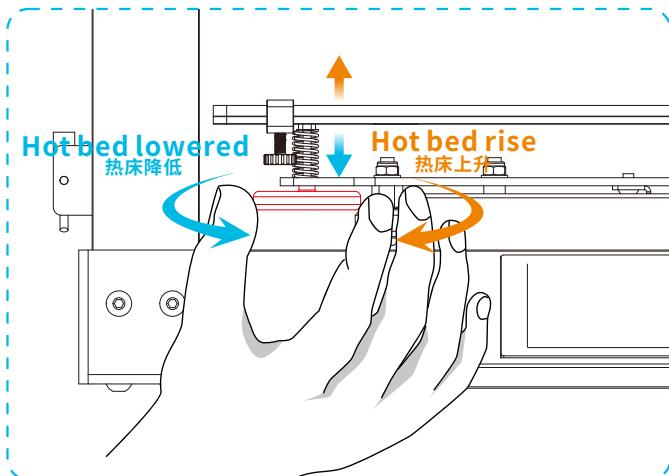
According to the sequence given in the figure, level the five positioning points one by one.  
(Please refer to page 13 for the leveling method)

按照图中给出的顺序，将五个定位点一一调平，  
最后点击返回。(调平方法请参考13页)

# Leveling of the hot bed 热床的调平

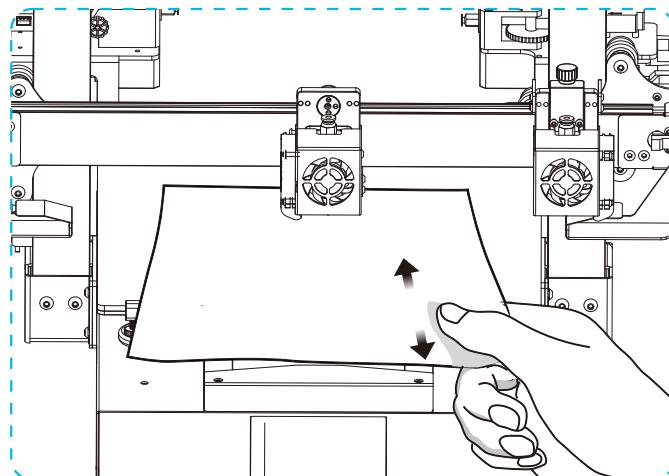
## Leveling the hot bed method.

调平热床方法。



As shown in the figure, adjust the distance between the hot bed and the nozzle through the big nut under the hot bed. The central position of the hot bed requires the overall lifting of the platform, so when adjusting the distance between the central point, the other four corners of the hot bed need to do the same operation.

如图中所示，通过热床下的螺母，调整热床与喷嘴的距离。热床中心位置则需要平台的整体升降，所以在调整中心点的距离时，热床的其他四个角需做同样的操作。



Users can use a piece of A4 paper to verify whether the distance is appropriate and feel the slight resistance given by the nozzle when dragging A4 paper.

用户可使用一张A4纸验证距离是否合适，感受到拖拽A4纸时喷嘴给予的轻微阻力即可。



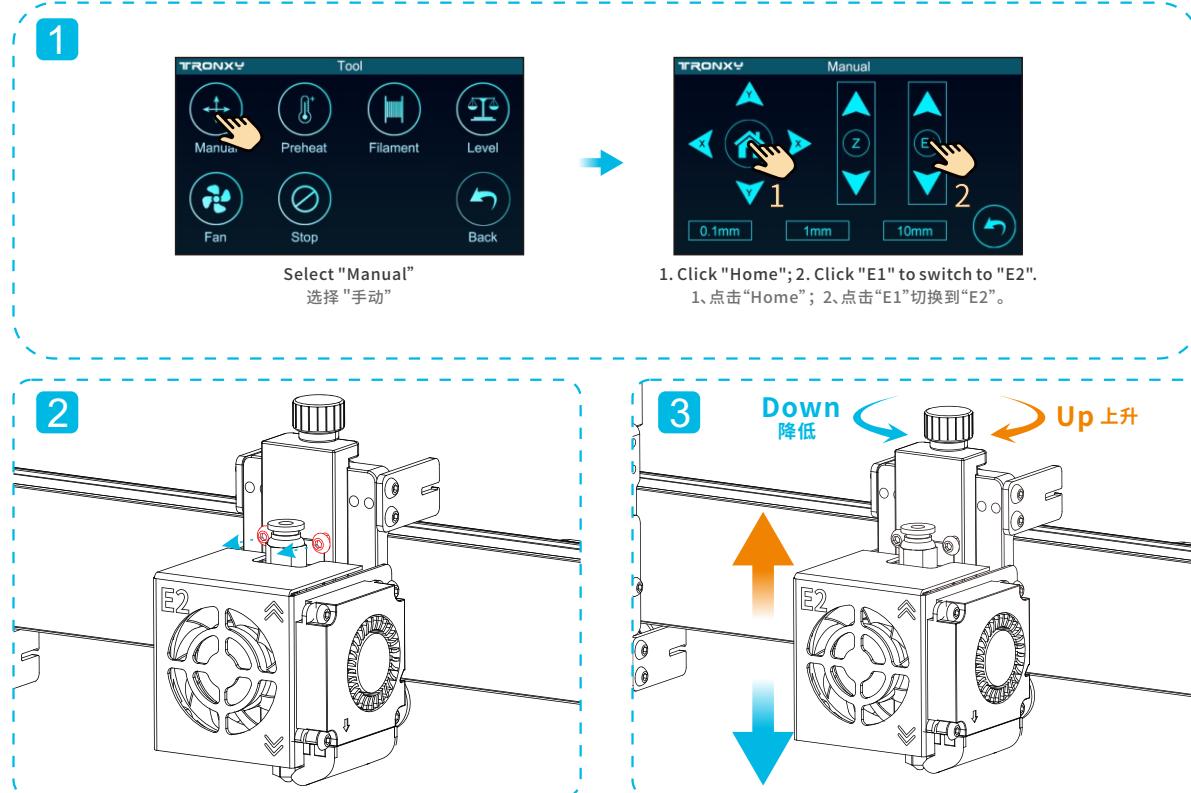
If you pursue the accuracy of leveling, you can perform multiple leveling operations.

如用户追求调平的准确性，可进行多次调平操作。

# Leveling of the hot bed 热床的调平

## 2. Leveling the E2 print head 调平E2打印头

调平E2打印头



Loosen the two screws shown in the picture. (Don't take it off)  
拧松图中所示的E2打印头上的螺丝(不需取下)。

As shown in the figure, the E2 print head can move up and down at this time. After adjusting the distance between the nozzle and the hot bed close to the thickness of A4 paper, re-lock the screws in figure 2.  
(Distance adjustment details are the same as page 13)

如图所示，此时E2打印头可上下移动，调整喷嘴与热床的距离接近于A4纸的厚度之后，重新锁紧图2的螺丝即可。(距离调整细节与13页内容相同)



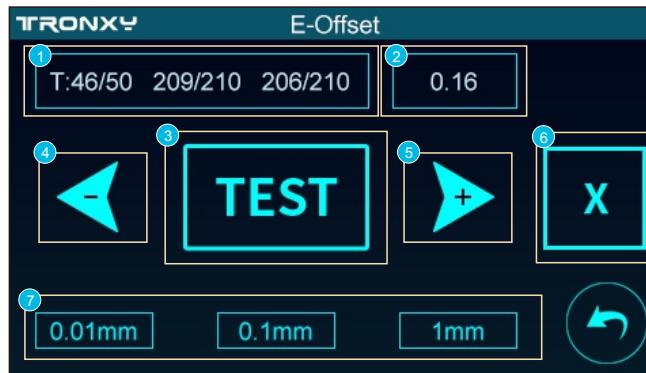
For printing with dual print heads, E-offset must be set to ensure the consistency of the dual heads in the X/Y direction, which is another necessary setting after the distance setting in the Z direction.

E-Offset  
E-偏移

双打印头打印，都需要设置E偏移，确保双头在X/Y方向上的一致，是继Z方向的距离设置后的另一个必要的设置。

## Interface Introduction:

界面介绍



① Temperature 温度参数

② Moving distance 移动的距离

③ Start testing 开始测试

④ Reduce the offset value 减少偏移数值

⑤ Increase the offset value 增加偏移数值

⑥ Switch between X and Y axis X轴和Y轴测试切换

⑦ Choose the distance to move 选择移动的距离

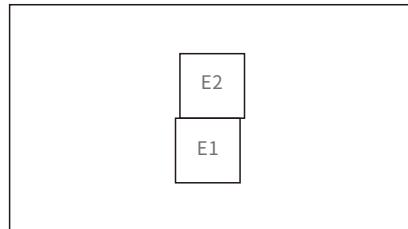
# E-offset function introduction E偏移功能介绍

## 1. X axis offset X 轴偏移



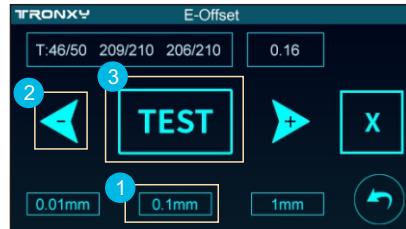
Click "Test" and start the test after the temperature reaches the requirement

点击“测试”，待温度到达要求后开始进行测试



The machine will print two squares and observe whether the two squares are aligned horizontally and in the center. If they are not aligned, the X-axis offset is required.

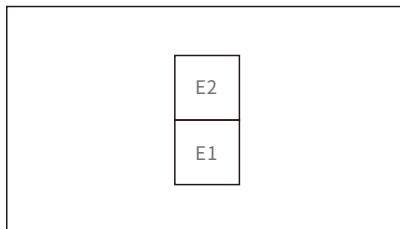
机器会打印两个方块，观察两个方块是否水平居中对齐，如不对齐，需进行X轴的偏移。



Adjust the offset distance of "E2" according to the offset distance of the two square boxes.

根据两个方框的偏移距离调整“E2”的偏移距离。

- 1 Choose the right moving distance  
选择合适的移动距离
- 2 Adjust the position of the offset  
调整偏移量的位置
- 3 Click test  
点击测试



Adjust until the two boxes are horizontally centered  
调整直到两个框水平居中对齐



Save Settings  
保存设置

- 1 Click back 点击返回
- 2 Select "OK" 选择“确认”

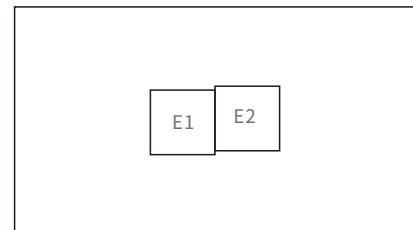


# E-offset function introduction E偏移功能介绍

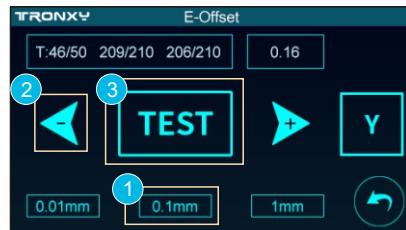
## 2. Y axis offset Y 轴偏移



Switch to "Y", click "TEST", and start the test after the temperature reaches the requirement  
切换至"Y", 点击“测试”，待温度到达要求后开始进行测试

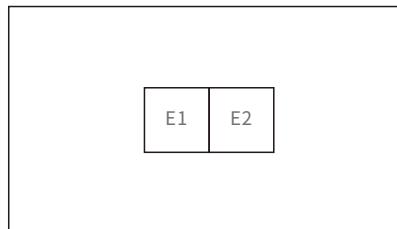


The machine will print two squares and observe whether the two squares are vertically aligned in the center. If they are not aligned, the Y-axis must be offset.  
机器会打印两个方块，观察两个方块是否垂直居中对齐，如不对齐，需进行Y轴的偏移。



Adjust the offset distance of "E2" according to the offset distance of the two square boxes.  
根据两个方框的偏移距离调整"E2"的偏移距离。

- 1 Choose the right moving distance  
选择合适的移动距离
- 2 Adjust the position of the offset  
调整偏移量的位置
- 3 Click test  
点击测试

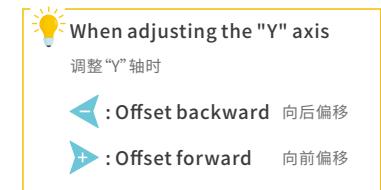


Adjust so that the two squares are vertically aligned in the center.  
调整到两个方块垂直居中对齐。



Save Settings  
保存设置

- 1 Click back 点击返回
- 2 Select "OK" 选择“确认”



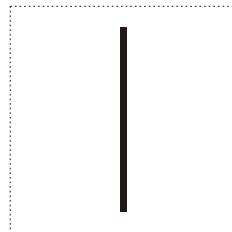
# Load and unload filaments 耗材的装载和卸除

## 1. Install the filament to the holder 安装耗材到料架上

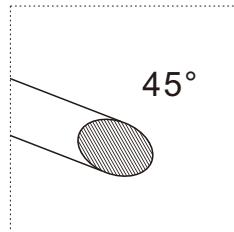


In order to successfully complete the loading, the filament needs to perform some necessary operations, as shown in the figure below.

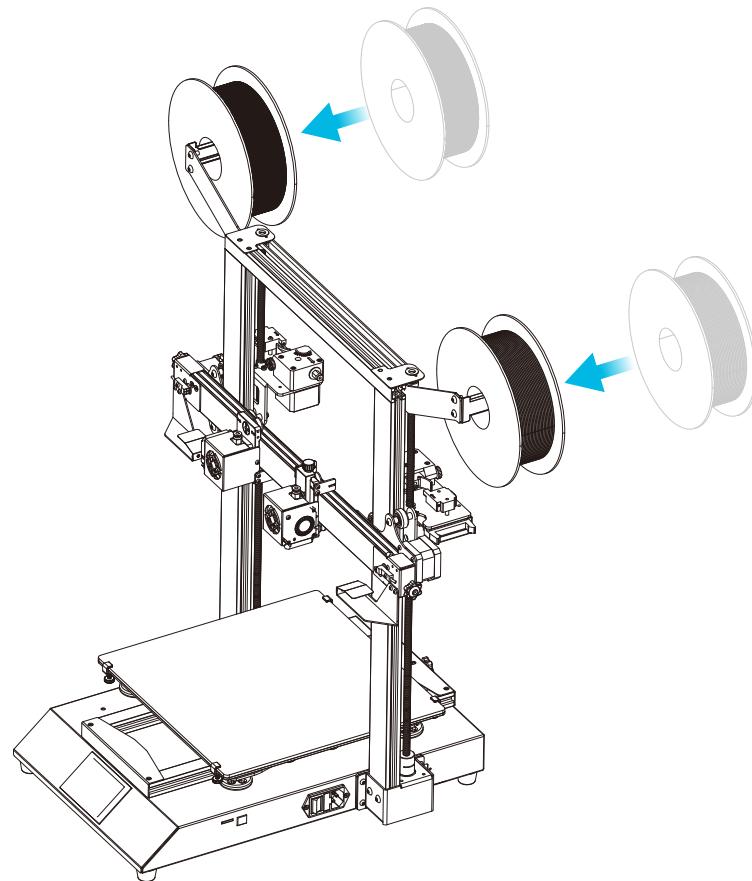
为了顺利完成加载, 灯丝需要进行一些必要的操作, 如下图所示。



Straighten Filament  
拉直耗材

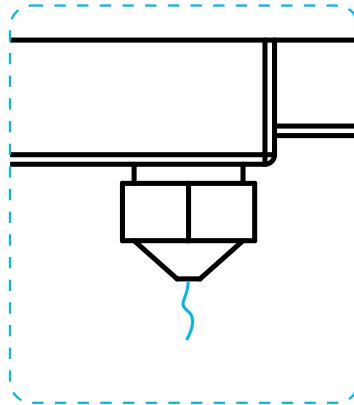
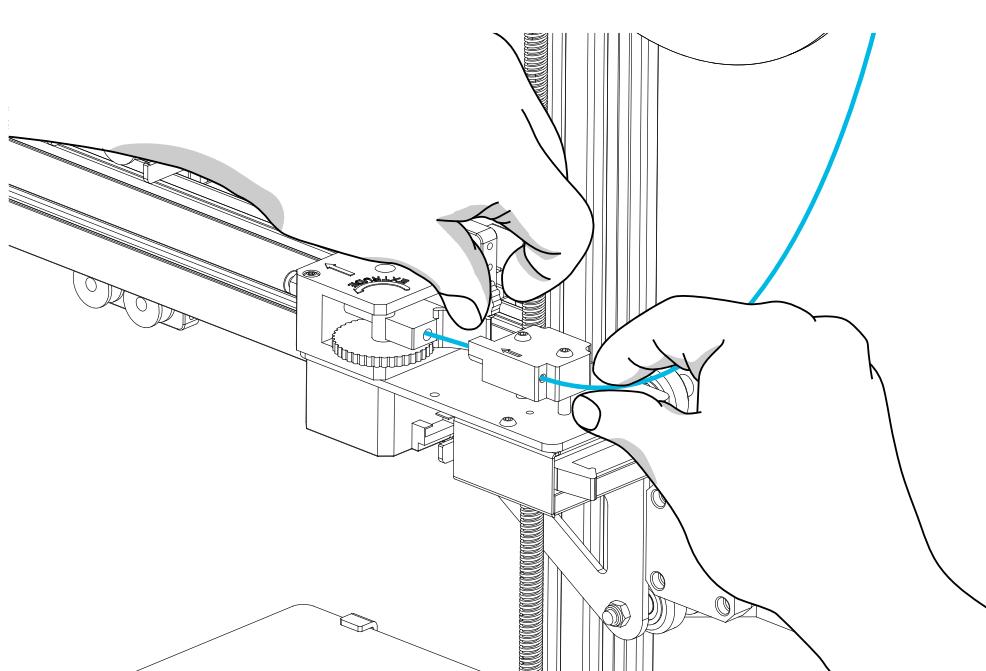


Cut the filament  
to a 45° angle  
将耗材剪成45°角



# Load and unload filaments 耗材的装载和卸除

## 2. Insert the filament 插入耗材



After the preheating is completed, the filament is extruded from the nozzle, which means that the filament is loaded.

预热完成后有耗材从喷嘴挤出即表示耗材装载完成。



### Tips: how to replace the filament?

1. Cutting filament near the extruder and slowly feed new filament until they are fed into the new filament.
2. Withdrawing the filament quickly and feeding the new filament after nozzle preheated and filament pushed a little forward.

提示：如何更换耗材？

方法一、在靠近挤出机处将耗材剪断，将新耗材缓缓送入，直到耗材被送入导料管为止。

方法二、预热喷嘴后，将耗材往前推进一下后，迅速抽出耗材，将新耗材送入。

# Load and unload filaments 耗材的装载和卸除

## 3. Preheat nozzle.

预热喷嘴



## 4. Extruding filament and exiting filament

挤出耗材与退出耗材



1. Unload filament 退出耗材
2. Extruded filament 挤出耗材



After waiting for temperature up to 180 °C, filament go through from the filament detection, extruder and feed pipe to the nozzle until the filaments are squeezed.

等待温度达到180°C后，耗材从断料检测器、挤出机和进料管到喷嘴，直到耗材被挤压。

# Printing mode introduction 打印模式介绍

## 1. Introduction to print mode

打印模式介绍



### Full control mode

In this mode, the default print head is E1, and the print mode is determined by the setting mode of the slicing software.

### 完全控制模式

此模式下，默认打印头为E1，打印模式由切片软件设定模式决定。

FullCtrl  
完全控制



### Automatic docking mode (Double head, two in one)

In this mode, E1 and E2 print heads print the same model, and the print model is a two-color model.

### 自动停靠模式 (双头、2in1)

在此模式下，E1和E2打印头打印同一个模型，打印模型为一个双色模型。

AutoPark  
自动停靠



### Duplicate mode

In this mode, E1 and E2 use the middle of the printing platform as the dividing line, and print the same model on the left and right.

### 复制模式

在此模式下，E1和E2以打印平台中间为分界线，打印左右相同的模型。

Duplicate  
复制



### Mirror mode

In this mode, E1 and E2 take the middle of the printing platform as the dividing line, and print the left and right mirrored models.

### 镜像模式

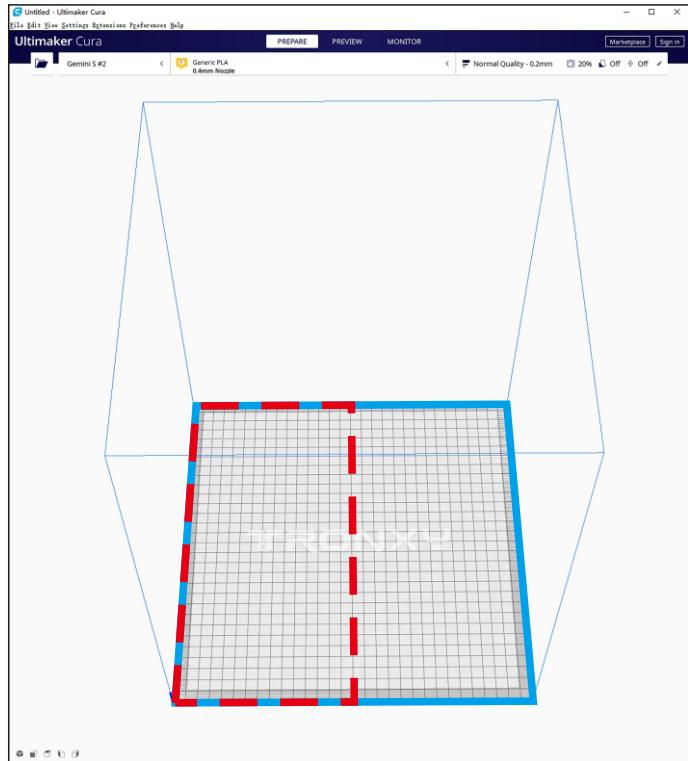
在此模式下，E1和E2以打印平台中间为分界线，打印左右为镜像的模型。

Mirror  
镜像

**Note: When printing different models, you must first switch to the corresponding printing mode.**

注意事项：打印不同模型时，必须先切换到对应的打印模式。

# Print mode size description 打印模式尺寸说明



1. Single-head printing: 300\*300\*390mm
2. Double-head printing: 300\*300\*390mm
3. Duplicate mode: 150\*300\*390mm
4. Mirror mode: 120\*300\*390mm
5. When copying and mirroring printing, the model can only be positioned on the left half of the platform (as shown on the left)

- 1、单头打印:300\*300\*390mm
- 2、双头印刷:300\*300\*390mm
- 3、复制模式:150\*300\*390mm
- 4、镜像模式:120\*300\*390mm
- 5、复制和镜像打印时,模型只能定位在平台的左半部分(如左图所示)

  Single-head and double-head printing range  
单头和双头打印范围

  The printing range of duplication mode and mirror mode  
复制模式和镜像模式的打印范围



Metal side up  
金属面朝上

- When inserting the SD card into the desktop card slot, make sure that the metal surface is facing up and do not use excessive force. There is a risk of damaging the SD card or motherboard card slot.
- If the content on the SD card cannot be read, please format it with FAT32 and try again.
- The printer is compatible with other SD cards of the same size.
- Save the data to be printed in the root directory of the SD card. Do not save other folders or files in the SD card. And it is best to name the G-CODE file name with numbers.

1、将SD卡插入桌面卡槽时，确保金属面朝上，不要用力过猛，存在损坏SD卡或主板卡槽的风险。

2、如果无法读取SD卡上的内容，请使用FAT32格式化并重试。

3、打印机兼容其他同大小尺寸的SD卡。

4、将要打印的数据保存在SD卡根目录下，不要在SD卡中保存其他文件夹或文件，并且最好用数字命名G-CODE文件名。



Click to print  
选择“打印”



Select test file  
(20mm calibration cube.gcod)  
选择测试文件  
(20mm calibration cube.gcod)



Start printing  
开始打印

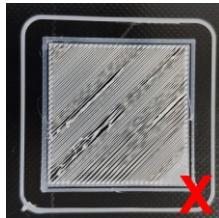
# Print test 打印测试

## Possible situations and solutions when extruding consumables

挤出耗材时可能出现的情况以及解决的办法

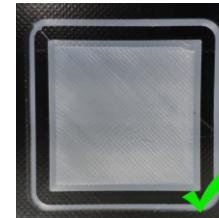


The distance between the hot bed and the nozzle is too close, you need to adjust the Z compensation, press the **arrow 1** in the figure to compensate the difference.

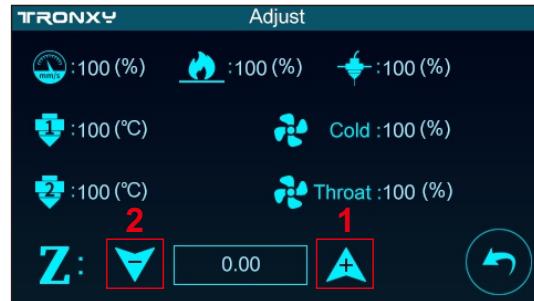


The distance between the hot bed and the nozzle is too far, you need to adjust the Z compensation, press the **arrow 2** in the figure to compensate the difference.

热床与喷嘴距离太近，需要调整Z补偿，按图中**箭头1**补偿差值。



Proper nozzle height  
Good extrusion and adhesion  
合适的喷嘴高度良好的挤出和附着力



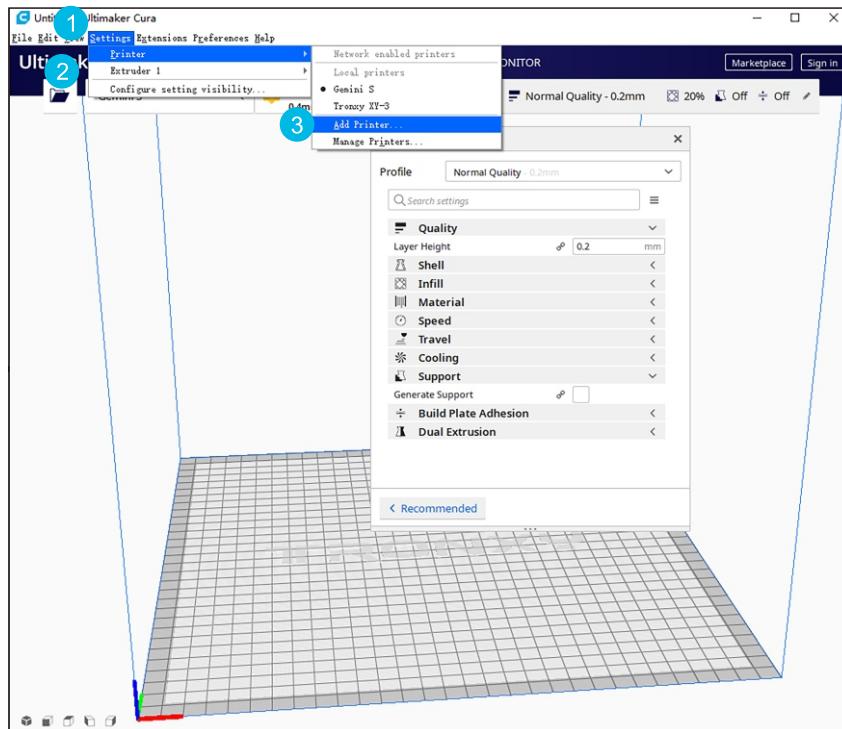
# Slice software installation steps 切片软件安装设置

1. Install "Ultimaker\_Cura-4.8.0-amd64", double-click to install the software, follow the prompts to complete the installation steps.

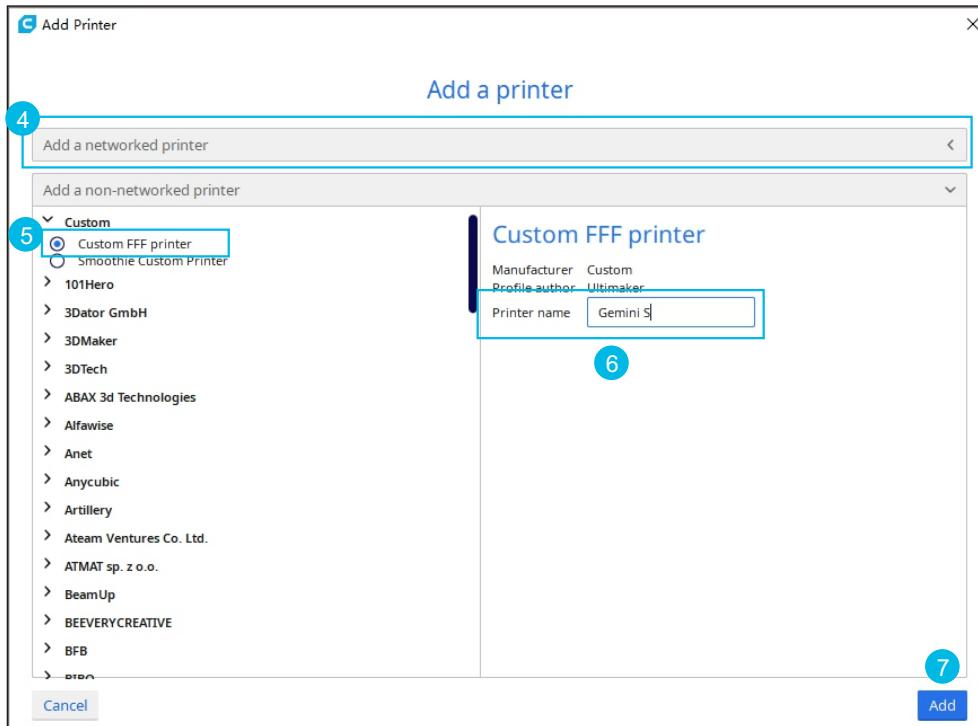
2. Add a printer and set it up according to the figure below.

1、安装“Ultimaker\_Cura-4.8.0-amd64”，双击安装软件，按照提示完成安装步骤。

2、根据下图添加打印机并进行设置。



① Settings → ② Printer → ③ Add printer  
设置                  打印机                  新增打印机



④ Add a non-networked printer → ⑤ Select "Custom FFF printer"

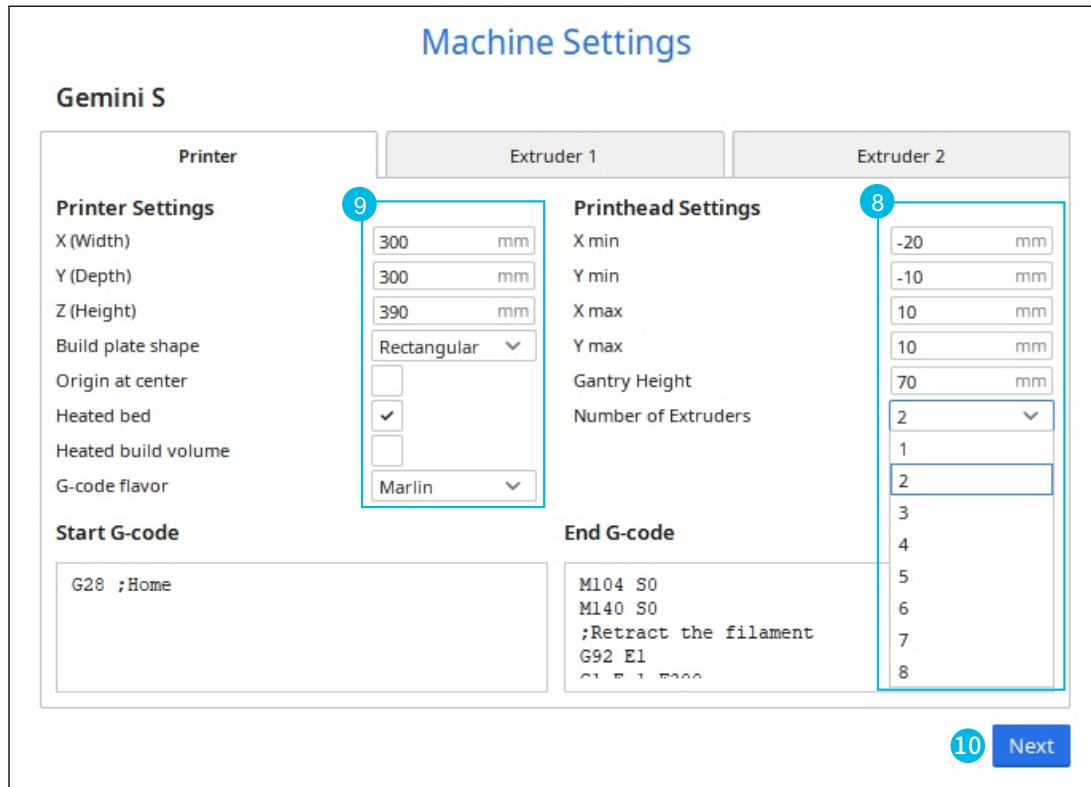
添加已联网打印机

选择“自定义打印机”

→ ⑥ Enter Gemini S → ⑦ Click "Add"

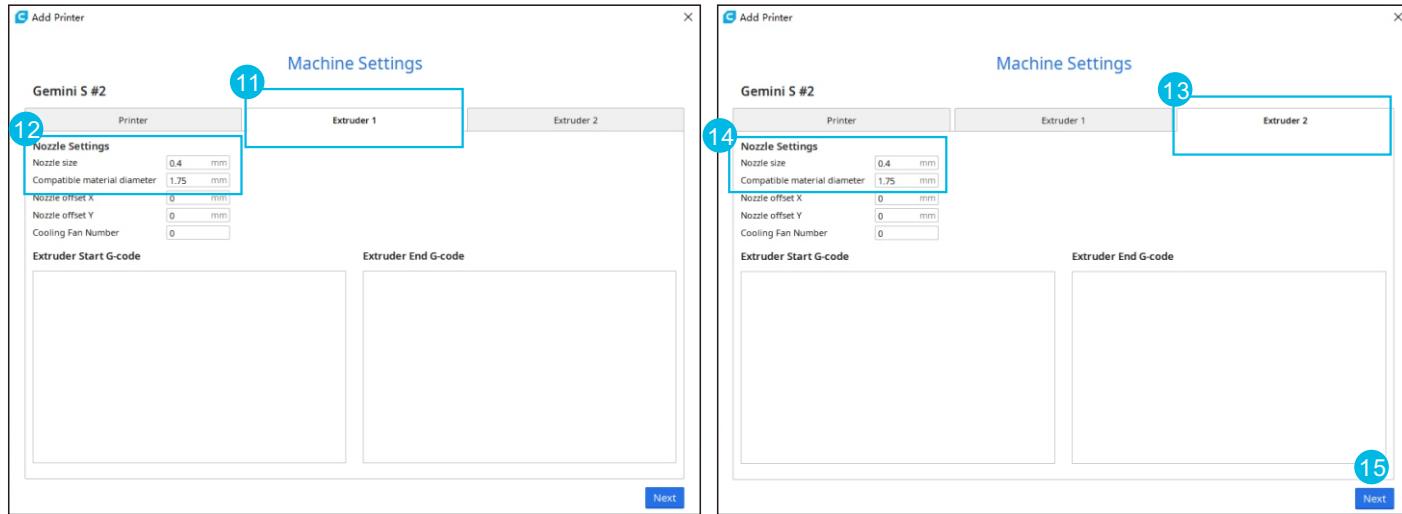
输入 Gemini S

点击“添加”



- ⑧ Set the "Number of Extruders" to "2" → ⑨ Set the size of the printing platform, check "Heated bed"  
挤出头设置为“2”  
设置打印平台尺寸, 勾选“加热床”  
→ ⑩ Click "Next"  
点击“下一步”

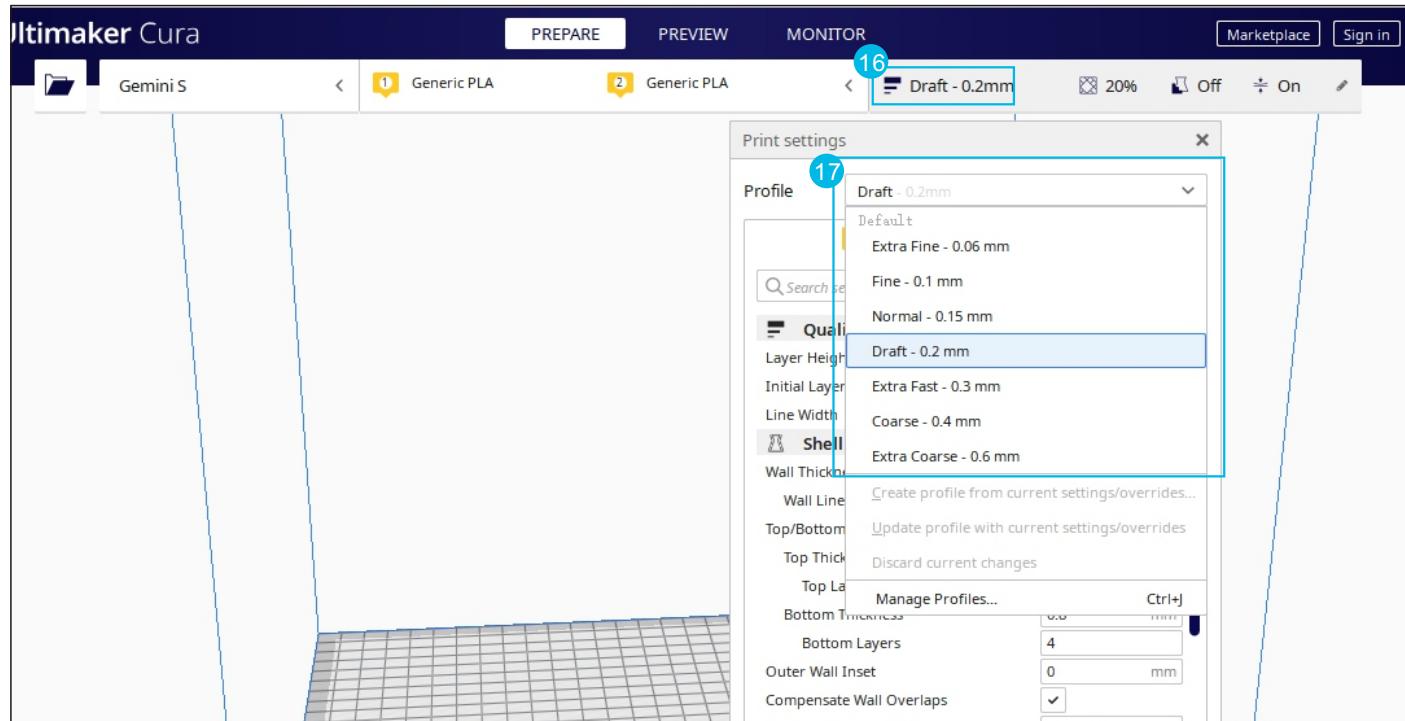
# Slice software installation steps 切片软件安装设置



⑪ Select "Extruder 1" → ⑫ "Nozzle size" is 0.4, "Compatible material diameter" is changed to 1.75  
选择“Extruder 1”  
“喷嘴孔径”为0.4, “兼容的材料直径”为改为1.75

→ ⑬ Select "Extruder 2" → ⑭ "Nozzle size" is 0.4, "Compatible material diameter" is changed to 1.75 → ⑮ Click "Next"  
选择“Extruder 2”  
“喷嘴孔径”为0.4, “兼容的材料直径”为改为1.75  
点击“下一步”

# Slice software installation steps 切片软件安装设置

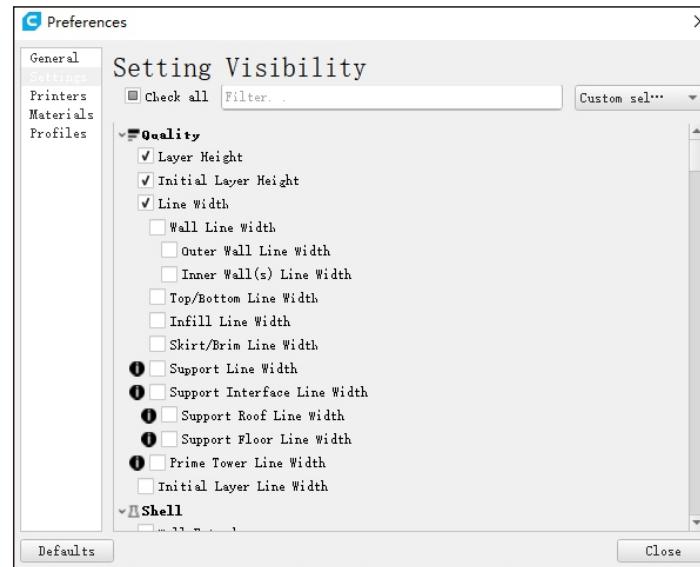
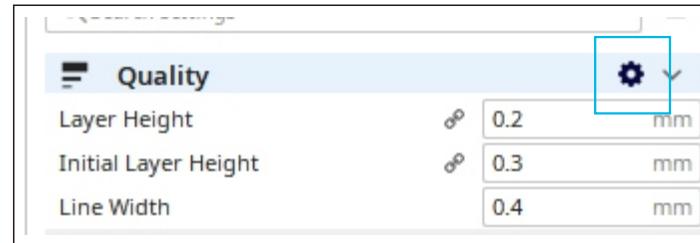


- 16 Open the settings panel → 17 Select “Draft - 0.2mm”  
打开设置面板 选择“Draft - 0.2mm”

# Slice software installation steps 切片软件安装设置

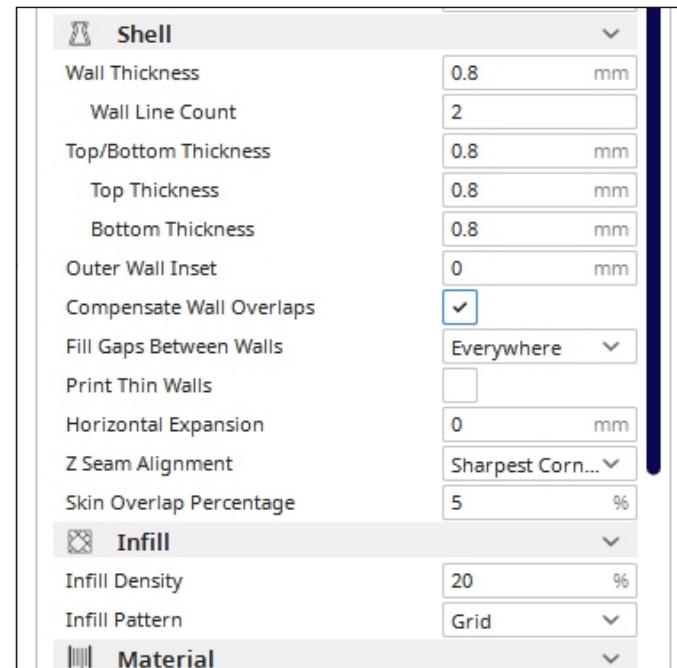
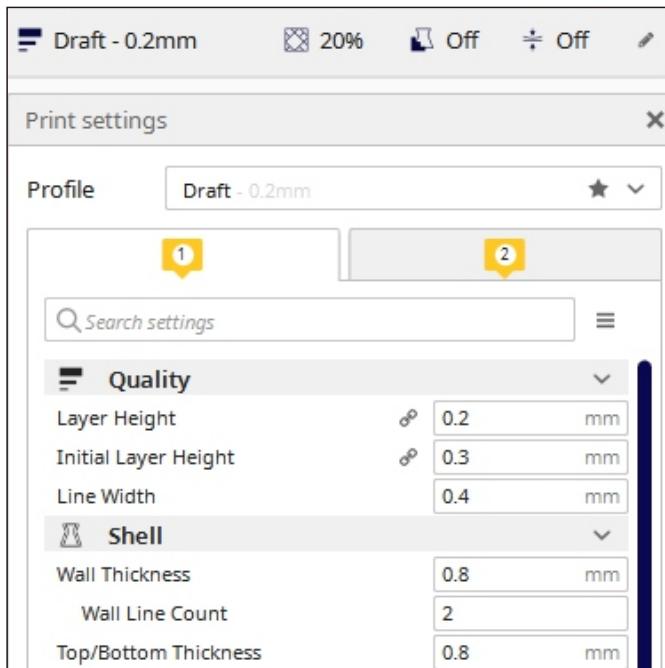
Open the hidden parameters as shown in the figure below

如下图所示打开隐藏的参数



# Slice software installation steps 切片软件安装设置

Set the printing parameters as shown in the figure



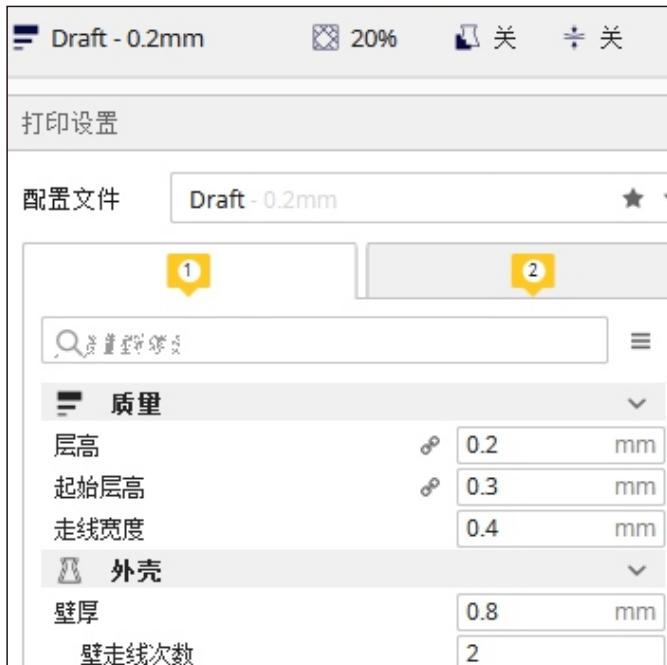
# Slice software installation steps 切片软件安装设置

<b>Material</b>		
Printing Temperature	200	°C
Flow	100	%
Wall Flow	100	%
Top/Bottom Flow	100	%
<b>Speed</b>		
Print Speed	60	mm/s
Infill Speed	60	mm/s
Wall Speed	30.0	mm/s
Top/Bottom Speed	30.0	mm/s
Travel Speed	120	mm/s
Initial Layer Speed	30.0	mm/s
<b>Travel</b>		
Enable Retraction	<input checked="" type="checkbox"/>	
Retraction Distance	6.5	mm
Retraction Speed	25	mm/s
Retraction Minimum Travel	0.8	mm

<b>Travel</b>		
Enable Retraction	<input checked="" type="checkbox"/>	
Retraction Distance	6.5	mm
Retraction Speed	25	mm/s
Retraction Minimum Travel	0.8	mm
<b>Z Hop When Retracted</b>		
<b>Cooling</b>		
Enable Print Cooling	<input checked="" type="checkbox"/>	
Fan Speed	100.0	%
Minimum Layer Time	5	s
<b>Support</b>		
Generate Support	<input type="checkbox"/>	
<b>Build Plate Adhesion</b>		
Build Plate Adhesion Type	<input checked="" type="radio"/> ♂ <input type="radio"/> ♀	None
<b>Dual Extrusion</b>		

# Slice software installation steps 切片软件安装设置

如图所示设置打印参数



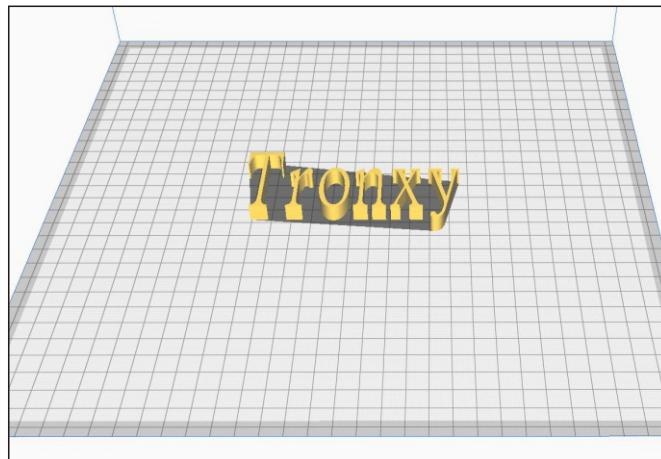


# The slicing method of the 4 printing modes 四种打印模式的切片方法

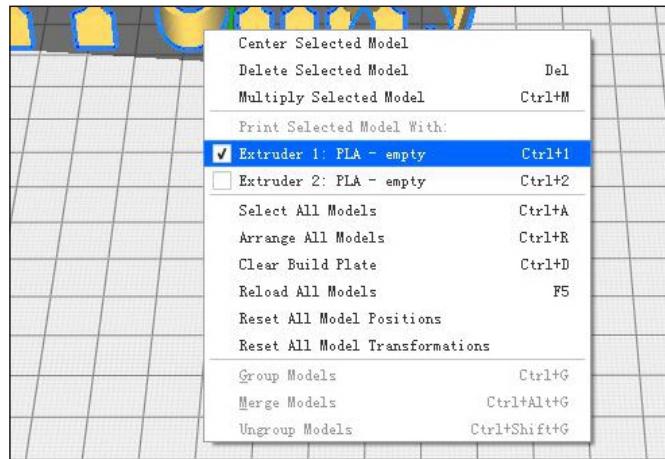


FullCtrl  
完全控制

Import a single model, the model is centered, select print head 1 to print the monochrome model, and then click the slice to output the G-code file, and finally select the "Full Control" mode on the printer to start printing.



Import model  
导入模型



Select "Extrusion Head 1"  
选择“挤出头1”

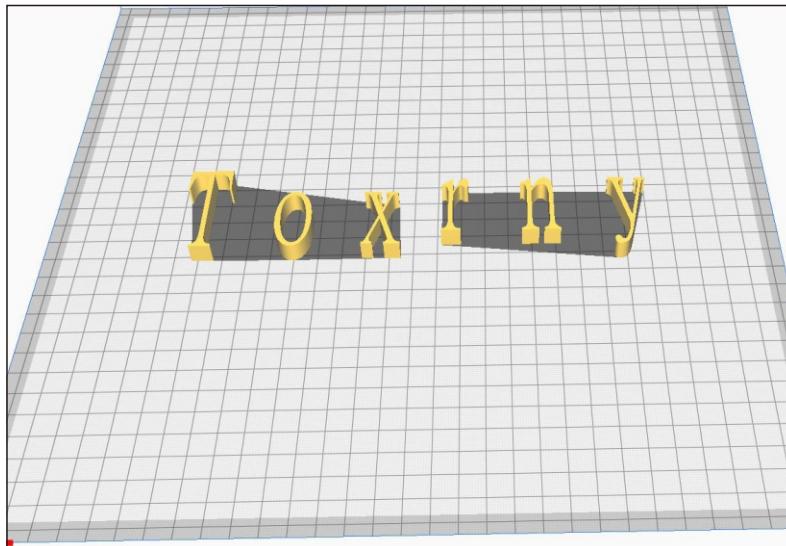
# The slicing method of the 4 printing modes 四种打印模式的切片方法



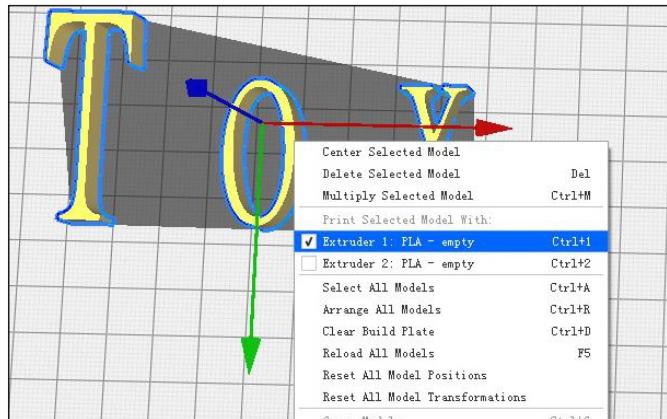
AutoPark  
自动停靠

1. Import two stl two-color model files;
2. Select "Extruder 1" to print on the left model;
3. Select "Extruder 2" to print on the right;
4. Right click, "Select All Models";
5. Right-click, select "Merge Models", and finally click the slice to output the G-code file, and select "AutoPark" mode on the printer to print.

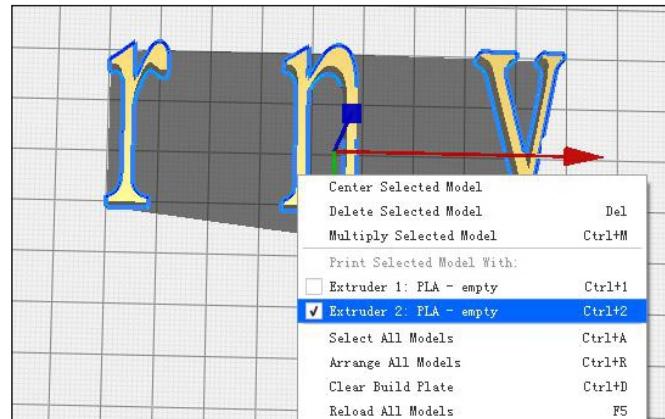
1. 导入两个stl双色模型文件；
2. 左边模型选择“Extruder 1”打印；
3. 右边选择“Extruder” 2打印；
4. 单击右键，“选择全部模型”；
5. 单击右键，选择“合并模型”，最后点击切片即可输出G-code文件，选择打印机上的“自动停靠”模式打印。



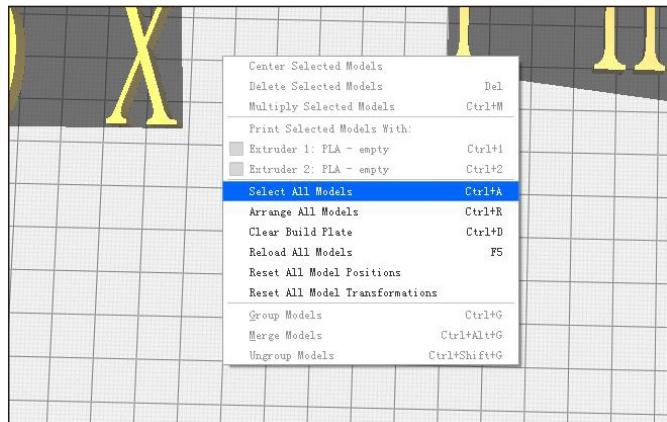
# The slicing method of the 4 printing modes 四种打印模式的切片方法



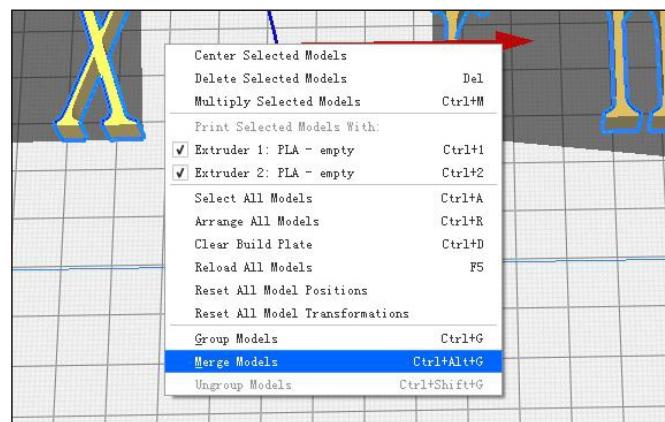
2



3



4



5

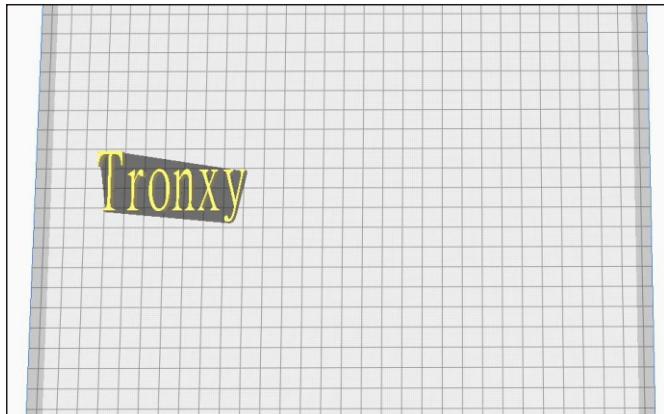
# The slicing method of the 4 printing modes 四种打印模式的切片方法



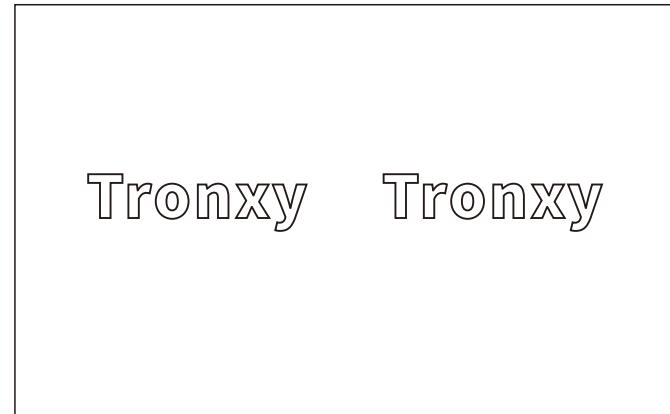
Duplicate  
复制

1. Import a single model and place the model to the left of the middle line;
2. Click on the slice to output the G-code file, select "Duplicate" mode on the printer (the printing effect is shown in the figure).

1、导入单个模型,模型放中间线的左边; ;  
2、点击切片即可输出G-code文件,选择打印机上的复制模式(打印效果如图)。



1



<sup>2</sup>  
(Simulation printing effect diagram)  
(模拟打印效果图)

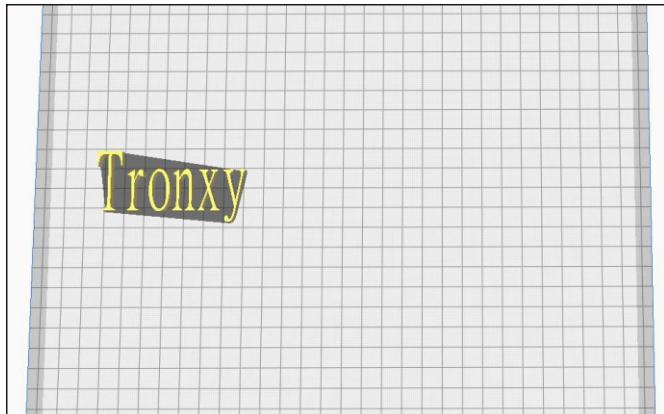
## The slicing method of the 4 printing modes 四种打印模式的切片方法



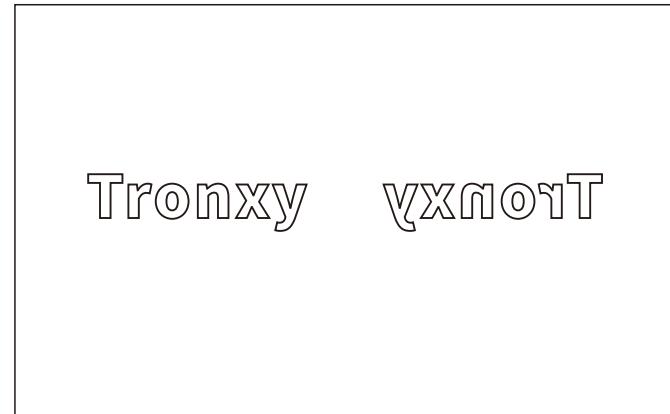
Mirror  
镜像

1. Import a single model and place the model to the left of the middle line;
2. Click on the slice to output the G-code file, select "Mirror" mode on the printer (the printing effect is shown in the figure).

1、导入单个模型,模型放中间线的左边; ;  
2、点击切片即可输出G-code文件,选择打印机上的镜像模式(打印效果如图)。



1



<sup>2</sup>  
(Simulation printing effect diagram)  
(模拟打印效果图)

## 1. Machine cannot start

- 1) Check the power line and other wires are connected well or not.
- 2) Check whether the supply voltage suits the local standard.
- 3) Check whether the screen or power supply is damaged and replace it in time.
- 4) Check if the wires are damaged or broken.
- 5) Check whether the power fuse is burnt out.

## 1. 机器无法启动

- 1) 检查电源线和其他电线是否连接好。
- 2) 检查供电电压是否符合当地标准。
- 3) 检查屏幕或电源是否损坏，及时更换。
- 4) 检查电线是否损坏或断裂。
- 5) 检查电源保险丝是否烧断。

## 2. The contents of the SD card cannot be read

- 1) Check the card reader if it is good.
- 2) If the computer can't read the SD card , please format it and try again.
- 3) Check whether the SD card is inserted correctly.
- 4) The filename has an illegal character, please rename it.
- 5) Please replace the damaged SD card and try again.

## 2. 无法读取SD卡内容

- 1) 检查读卡器是否完好。
- 2) 如果电脑无法读取SD卡，请格式化后再试。
- 3) 检查 SD 卡是否正确插入。
- 4) 文件名含有非法字符，请重命名。
- 5) 请更换损坏的 SD 卡并重试。

## Failure cause analysis 故障原因分析

### 3. If the print head does not squeeze enough filament or can't squeeze any filament.

- 1) Check whether the print head temperature reaches 200 °C above (PLA), leading to filament unable to be squeezed, waiting for the temperature to rise to the set target.
- 2) Check whether the filaments are knotted, which leads to unsatisfactory feeding.
- 3) Check whether the filaments or pipes are not inserted correctly, resulting in feeding failure.
- 4) Check whether the temperature of the print head is too high, which leads to excessive softness of filaments and cannot be extruded normally.
- 5) Check whether the diameter of filaments is consistent with the diameter set in the slicing software, so that the amount of extrusion filaments is not enough.
- 6) Check whether consumables are blocked by dirt or nozzle blocked during extrusion.
- 7) Replace with better quality filaments.

### 4. If the first layer upwarp

- 1) Check if the hot bed has been leveled well.
- 2) Check the surface of the hot bed for dirt.
- 3) Check whether the distance between the nozzle and the platform is too high, resulting in insufficient adhesive force.
- 4) Check the hot bed for adequate temperature.
- 5) Check the first layer of the slicing software to see if it is printing too fast.

### 3. 如果打印头没有挤压足够的耗材或无法挤压任何耗材。

- 1) 检查打印头温度是否达到200°C以上(PLA)，导致灯丝无法挤压，等待温度升至设定目标。
- 2) 检查细丝是否打结，导致送料不畅。
- 3) 检查灯丝或管道是否没有插入到位，导致送料失败。
- 4) 检查打印头温度是否过高，导致耗材过于柔软，不能正常挤出。
- 5) 检查长丝直径是否与切片软件中设置的直径一致，以免挤出长丝数量不够。
- 6) 检查耗材是否被脏物堵塞或挤出时喷嘴堵塞。
- 7) 更换质量更好的灯丝。

### 4. 如果第一层向上翘起

- 1) 检查热床是否平整。
- 2) 检查热床表面是否有污垢。
- 3) 检查喷嘴与平台之间的距离是否太高，导致粘合力不足。
- 4) 检查热床是否有足够的温度。
- 5) 检查切片软件的第一层，看是不是打印太快了。

## 5. The model is not easy to take off

- 1) Try to heat the hot bed to 50-70 °C take off it by the shovel.
- 2) It is recommended to buy TRONXY magnetic stickers.

## 5.模型不易脱模

- 1) 尝试将热床加热至 50-70 °C 用铲子将其取下。
- 2) 建议购买TRONXY磁贴。

## 6. Can't heat it up

- 1) Check the heating rod and thermistor for poor contact or damage.
- 2) Check that the slice software has set the target temperature.
- 3) Check whether the thermistor wire falls off.

## 6.不能加热

- 1) 检查加热棒和热敏电阻是否接触不良或损坏。
- 2) 检查切片软件是否设置了目标温度。
- 3) 检查热敏电阻丝是否脱落。

## 7. Motor out of step

- 1) Check the tightness of the belt, whether the pulley is not locked.
- 2) Check the current voltage.
- 3) Check X/Y/Z axis motion is smooth.
- 4) Print speed too fast.
- 5) Environment temp too high.
- 6) Need flash the firmware.

## 7.电机失步

- 1) 检查皮带松紧，皮带轮是否未锁紧。
- 2) 检查当前电压。
- 3) 检查 X/Y/Z 轴运动是否顺畅。
- 4) 打印速度太快。
- 5) 环境温度过高。
- 6) 需要刷固件。

## 8. Abnormal motor noise or vibration

- 1) Check whether the motor line is in bad contact, loose or wrong connection.
- 2) Motor temperature is too high.
- 3) Check whether the motor is damaged.
- 4) Flash the firmware.
- 5) The printing load is too heavy.

## 8. 电机异常噪音或振动

- 1) 检查电机线是否接触不良、松动或接错。
- 2) 电机温度过高。
- 3) 检查电机是否损坏。
- 4) 刷固件。
- 5) 打印负荷过重。

## 9. Model dislocation and fault

- 1) Nozzle feeding not smoothly, please clean the nozzle or replace the nozzle.
- 2) Check that if the printing speed is too fast.
- 3) The quality of filaments is poor, please replace with new filaments.

## 9. 模型错位与故障

- 1) 喷嘴进料不顺畅, 请清洁喷嘴或更换喷嘴。
- 2) 检查打印速度是否过快。
- 3) 灯丝质量差, 请更换新灯丝。

## 10. Abnormal sound and vibration of filaments feeding motor

- 1) Please check whether the nozzle is blocked.
- 2) The nozzle feeding is not smooth, please clean the nozzle.
- 3) Whether the software Settings are incorrect.
- 4) Check whether the motor does not work.
- 5) Check the motor working or not or feeding gear is not working .

## 10. 灯丝异常声音和振动送料电机

- 1) 请检查喷嘴是否堵塞。
- 2) 喷嘴进料不顺畅, 请清洁喷嘴。
- 3) 软件设置是否有误。
- 4) 检查电机是否不工作。
- 5) 检查电机是否工作或送料齿轮不工作。

## 11. Screen related questions

- 1) No screen/blue screen, please restart or check whether the cable is plugged in.
- 2) Touch screen malfunction, check whether the screws are installed too tight.
- 3) Garbled/splash screen, static, ground connection or restart.

## 11. 屏幕相关问题

- 1) 无屏/蓝屏, 请重启或检查网线是否插好。
- 2) 触摸屏故障, 检查螺丝是否安装过紧。
- 3) 乱码/闪屏、静电、接地或重启。

## 12. Motherboard related issues

- 1) The wiring is not responding. Please check the wiring installation.
- 2) Automatic shutdown restart, may be abnormal firmware or module of “resume print after power failure” damaged.
- 3) Lack of heat dissipation, please lower the ambient temperature.
- 4) No response due to motherboard damage.

## 12. 主板相关问题

- 1) 接线无反应。请检查接线安装。
- 2) 自动关机重启, 可能是异常固件或“断电恢复打印”模块损坏。
- 3) 散热不足, 请降低环境温度。
- 4) 主板损坏无反应。

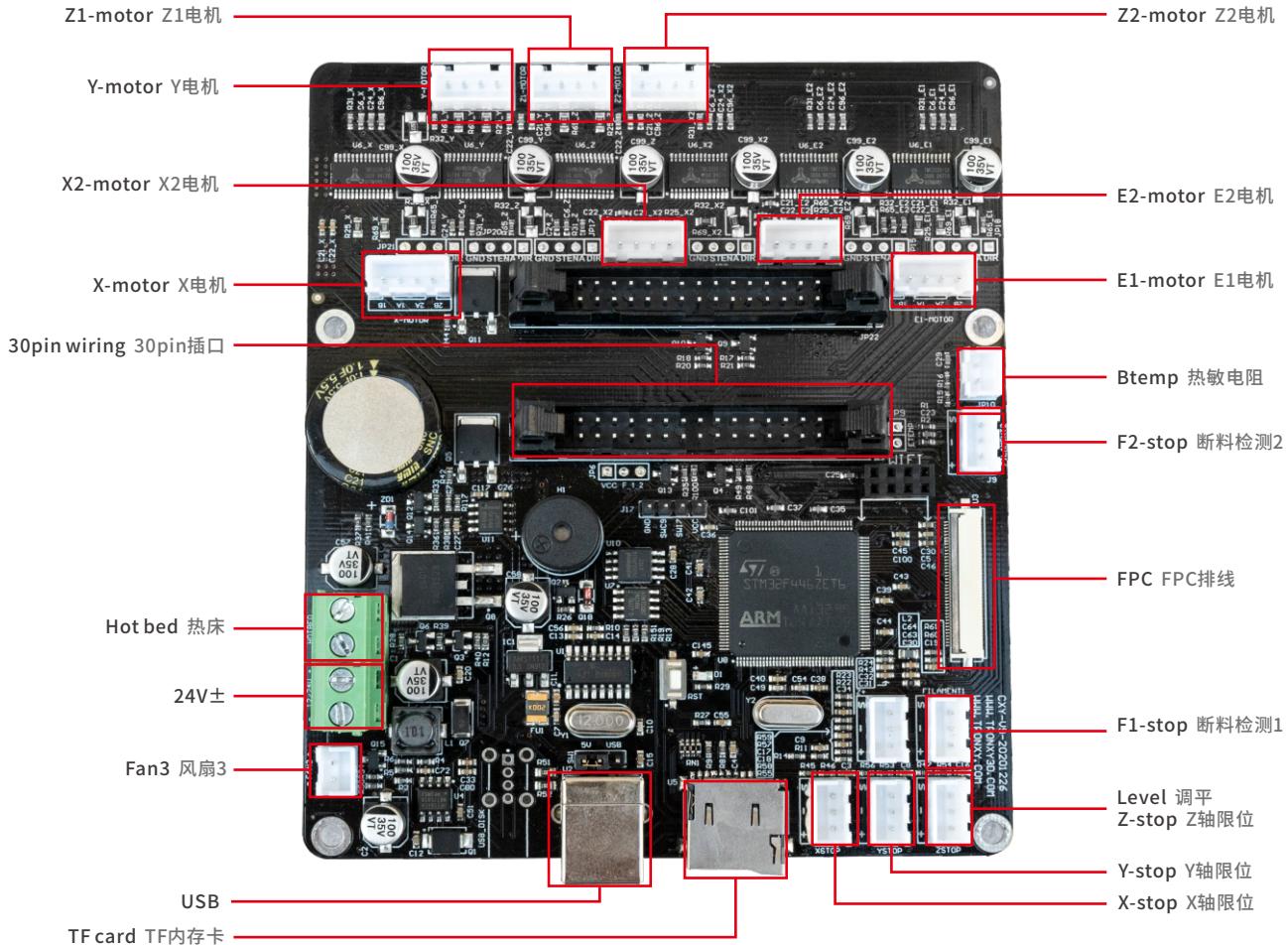
## 13. Unable to connect to printer

- 1) Check that the driver is not installed or properly installed.
- 2) The serial port was not selected correctly.
- 3) The software parameters do not match.

## 13. 无法连接到打印机

- 1) 检查驱动程序是否未安装或正确安装。
- 2) 串口选择不正确。
- 3) 软件参数不匹配。

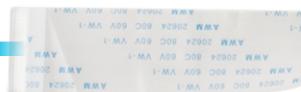
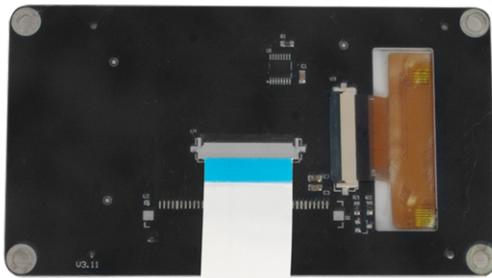
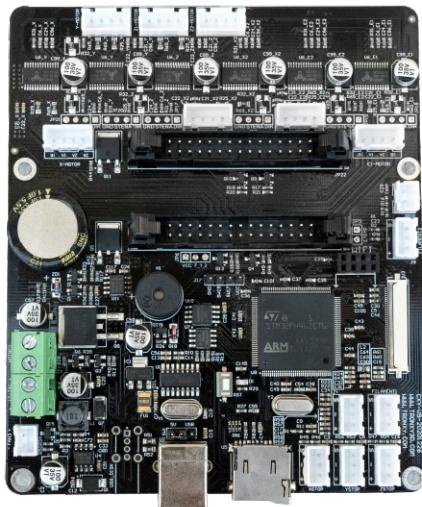
# Motherboard wiring diagram 主板接线图



## Caution



Please strictly follow the following instructions to insert the cable.  
Otherwise, it will cause the motherboard chip to burn out.  
(请严格按照以下提示插入屏线，否则会导致主板芯片烧坏。)



Pins face up  
金属面朝上



If you have any usage problems, you can directly contact the manufacturer to master the machine's first-hand information, advanced gameplay, and user communication, all in the GEMINI S Facebook user group, scan it and join us!

如遇使用问题可直接联系厂家,掌握机器的第一手资料,  
进阶玩法,用户交流,尽在GEMINI S脸书用户组,扫一扫 加入我们吧!

The actual product may be different from the picture. Please refer to the actual product. The final explanation belongs to Shenzhen Chuangxinyuan Technology Co., Ltd.

实物与图可能有所差异,请以实物为准,最终解释归深圳创星元科技有限公司所有。



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