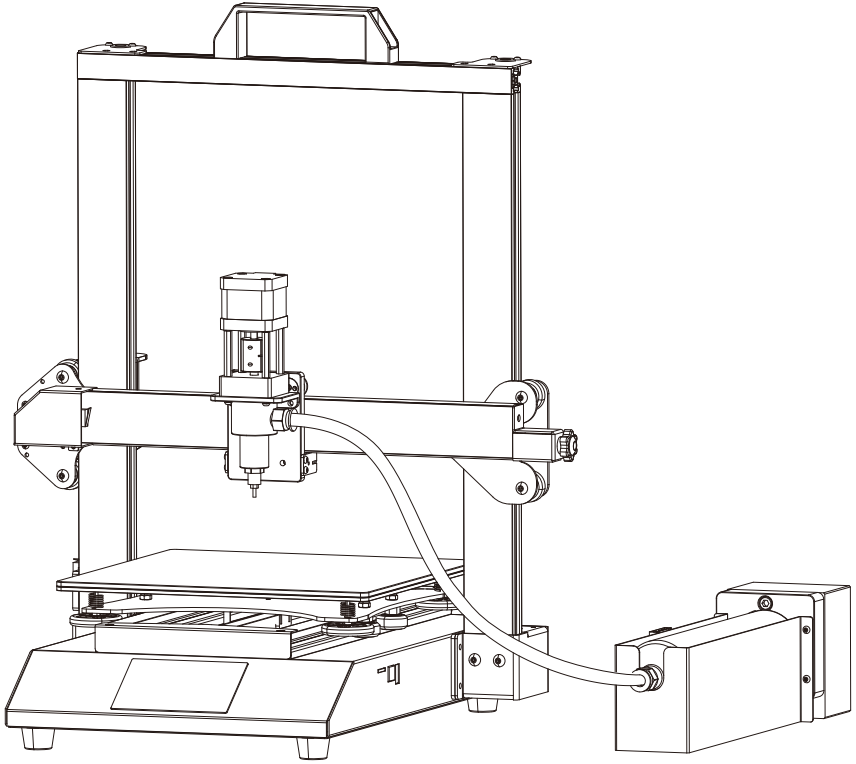
TRONXY

MOORE 2 PRO

Clay 3D printer User Manual

陶泥3D打印机使用说明书



User notes 用户须知

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. Children are not allowed to use the printer alone.
It is not recommended to use this 3D printer when unattended.

该机器包含高速运动部件，儿童不得单独使用打印机；
无人看管情况下，不建议运行 3D 打印机。

The recommended room temperature for 3D printers is 8 °C-40 °C, and the humidity is 20% - 80%. If used outside this temperature and humidity range, it may lead to a bad printing effect.

3D 打印机的使用环境温度建议为 8°C-40°C，湿度为20%-80%，
在此范围之外使用，可能带来不良的打印效果。

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

在紧急情况下，可直接关闭电源。

If the user's unauthorized modification or disassembly causes damage to the core components of the machine, the situation is not covered by the warranty.

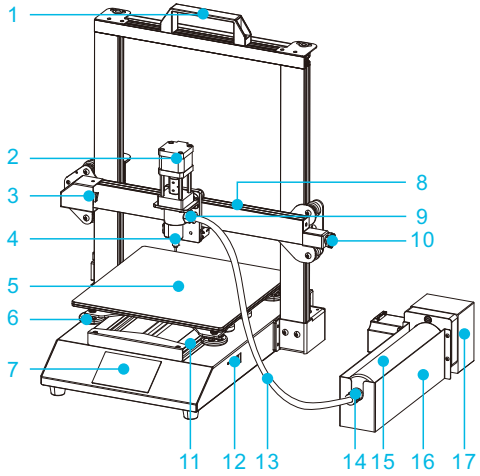
如果用户擅自改装或者拆卸导致机器的核心部件损坏，则该情况不在保修范围内。

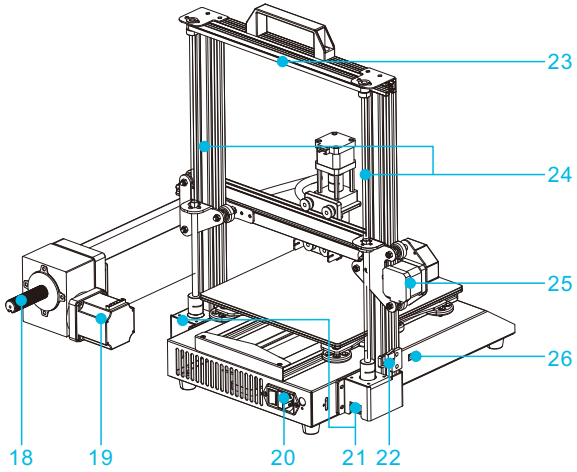
Video, software and other related information are stored in the TF card, please check.

视频，软件等相关信息存储在TF卡中，请查看。

Directory 目录

Introduction 设备简介





1 Handle
提手

2 Print head motor
打印头电机

3 X-axis lmited switch
X限位开关

4 Print head nozzle
打印头喷嘴

5 Printing platform
打印平台

6 Platform leveling nut
平台调平螺母

7 3.5 "full color touch screen
3.5寸全彩触摸屏

8 X-axis guide rail
X轴导轨

9 PC10-03 pneumatic connector
PC10-03气动接头

10 X axis belt adjustment knob
X轴皮带调节旋钮

11 Y-axis aluminum profile
Y轴铝型材

12 USB-A, USB-B and TF card sockets
USB-A、USB-B和TF卡插口

13 Tube
料管

14 PC10-02 pneumatic connector
PC10-02气动接头

15 Barrel
料筒

16 Barrel support plate
料筒支撑板

17 Transmission
变速器

18 M18 feeding screw
T18螺杆

19 57 feeding motor
57挤出电机

20 Power cord sockets and switches
电源线插口和开关

21 Z-axis motor
Z轴电机

22 Z-axis limit switch
Z轴限位开关

23 Closed loop timing belt
闭环同步带

24 Z-axis screw rod
Z轴丝杆

25 X-axis motor
X轴电机

26 Power supply voltage switch
电源电压切换开关

Parameter 设备参数

Print parameters
打印参数

Printing principle : 打印原理	LDM (Liquid Deposition Molding) LDM (液体沉积成型)
Print volume : 打印体积	255*255*260 (mm)
Printing accuracy : 打印精度	0.3-3.0mm
Positioning accuracy : 定位精度	X/Y: 0.00625mm, Z:0.00125mm
Number of printhead : 喷头数量	1
Nozzle diameter : 喷嘴直径	1.0-3.0 mm (optional) 1.0-3.0 mm (可选)
Print speed : 打印速度	10~40mm/s (20mm/s is recommended) 10~40mm/s (建议20mm/s)
Moving speed : 移动速度	60mm/s
Consumables : 耗材	Ceramic mud, porcelain mud, purple sand mud, etc 陶泥 瓷泥 紫砂泥等

Temperature parameter
温度参数

Ambient temperature : 环境温度	8°C - 40°C

Software parameters
软件参数

Slicing software : 切片软件	Cura
Input format : 输入格式	.STL .OBJ
Output format : 输出格式	Gcode
Connection method : 连接方式	TF card, USB disk, USB cable (for skilled users) TF卡、U盘、USB线(适用于熟练使用者)

Power parameters
电源参数

Power input : 电源输入	100V-220V AC, 50/60Hz
Power output : 电源输出	24V/360W

Physical parameters
物理参数

Machine size : 机器尺寸	410*414*510 (mm)
Machine weight : 机器重量	≈10kg

Packing list 包装清单

1. Upper frame *1
   上架 *1
2. Base *1
   底座 *1
3. M4*10 screw *14
   M4*10螺丝 *14
4. Print head * 1
   打印头 *1
5. Handle *1
   提手 *1
6. Fiberglass board plate *2
   玻纤板 *2
7. Clip *4
   夹子 *4
8. Z-axis limit switch *1
   Z轴限位开关 *1
9. Feed transmission *1
   进料变速器 *1
10. M18 extrusion screw * 1
    M18挤出螺杆 *1
11. Piston * 1
    活塞 *1
12. M4*20 screw *1
    M4*20螺丝 *1
13. Barrel 0.5L * 2
    料筒 0.5L *2
14. Clay *2
    陶泥 *2
15. PC10-02 pneumatic connector * 2
    PC10-02气动接头 *2

Packing list 包装清单

16 Barrel holder * 1
料筒支撑板 *1

17 Tube * 2
料管 *2

18 Stretch film *1
缠绕膜 *1

19 Power cord *1
电源线 *1

20 USB cable *1
USB数据线 *1

21 Card reader and TF card *1
读卡器和TF卡 *1

22 A box of nozzles (spare) *1
喷嘴一盒(备用) *1

23 PC10-03 pneumatic connector (spare) *1
PC10-03气动接头(备用) *1

24 Shovel (Random color)*1
铲刀 (颜色随机) *1

25 M4 straight handle wrench *1
M4直柄扳手 *1

26 Slotted screwdriver *1
一字螺丝刀 *1

27 14-17 open end wrench *1
14-17开口扳手 *1

28 8-10mm open end wrench *1
8-10mm开口扳手 *1

29 6mm open end wrench *1
6mm开口扳手 *1

30 L-type wrench (1.5/2/3/5) *4
L型扳手(1.5/2/3/5) *4

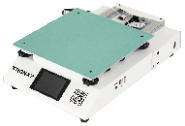
31 Tie(Random color)
扎带(颜色随机)

32 Raw material belt *1
生料带 *1

33 Sealing ring *2
密封圈 *2

Machine installation 机器安装

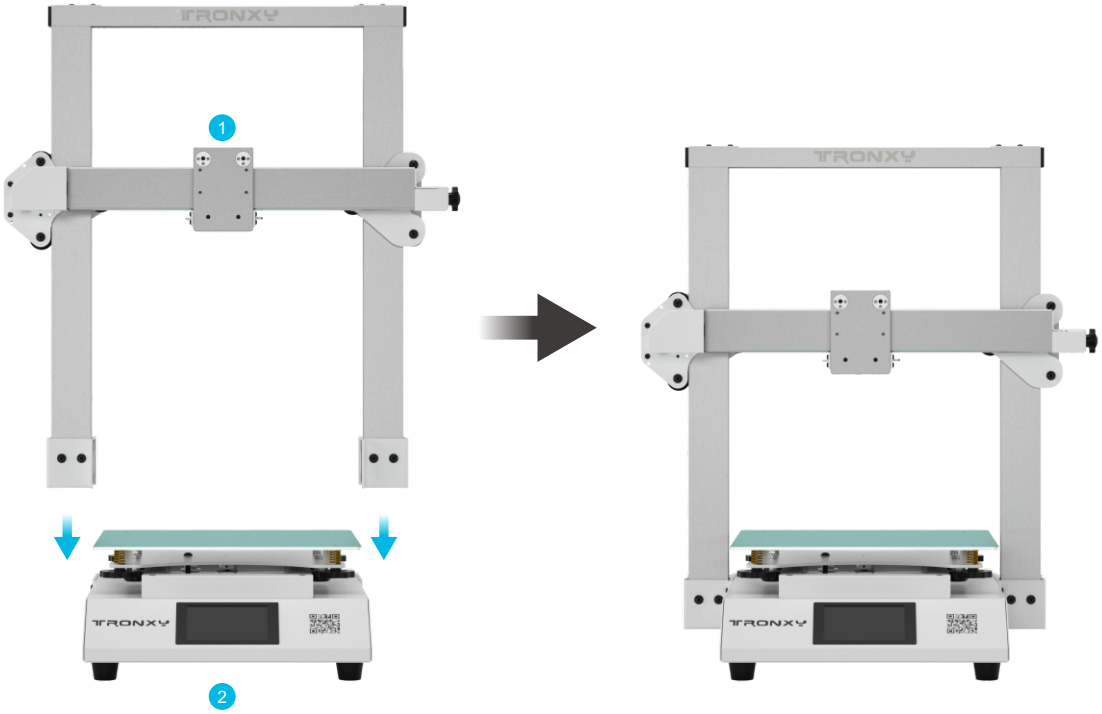
1
Upper frame *1
上架 *1



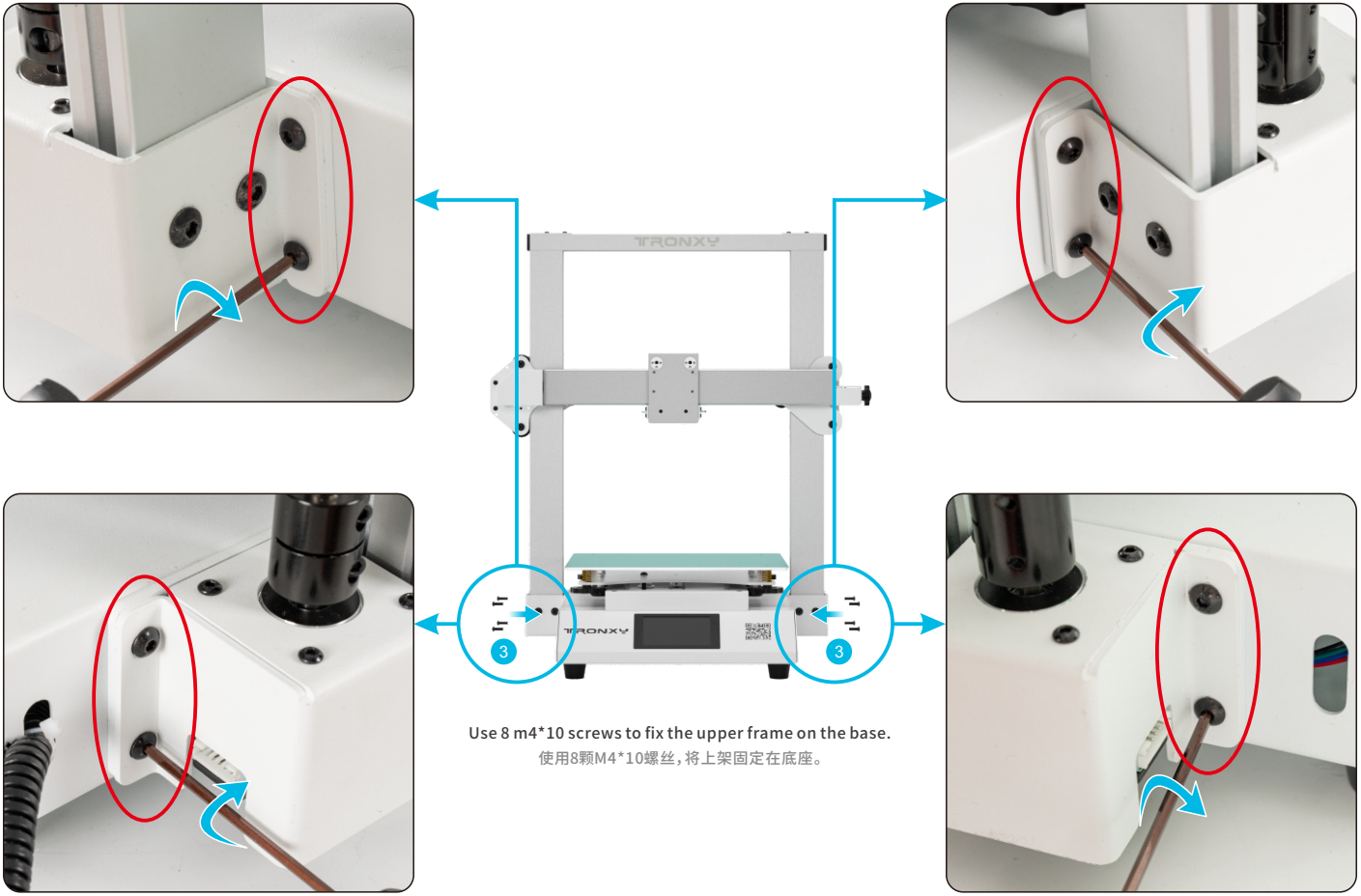
2
Base *1
底座 *1

3
M4*10 screws *8
M4*10螺丝*8

1. Installation of upper frame and base
安装上架和底座



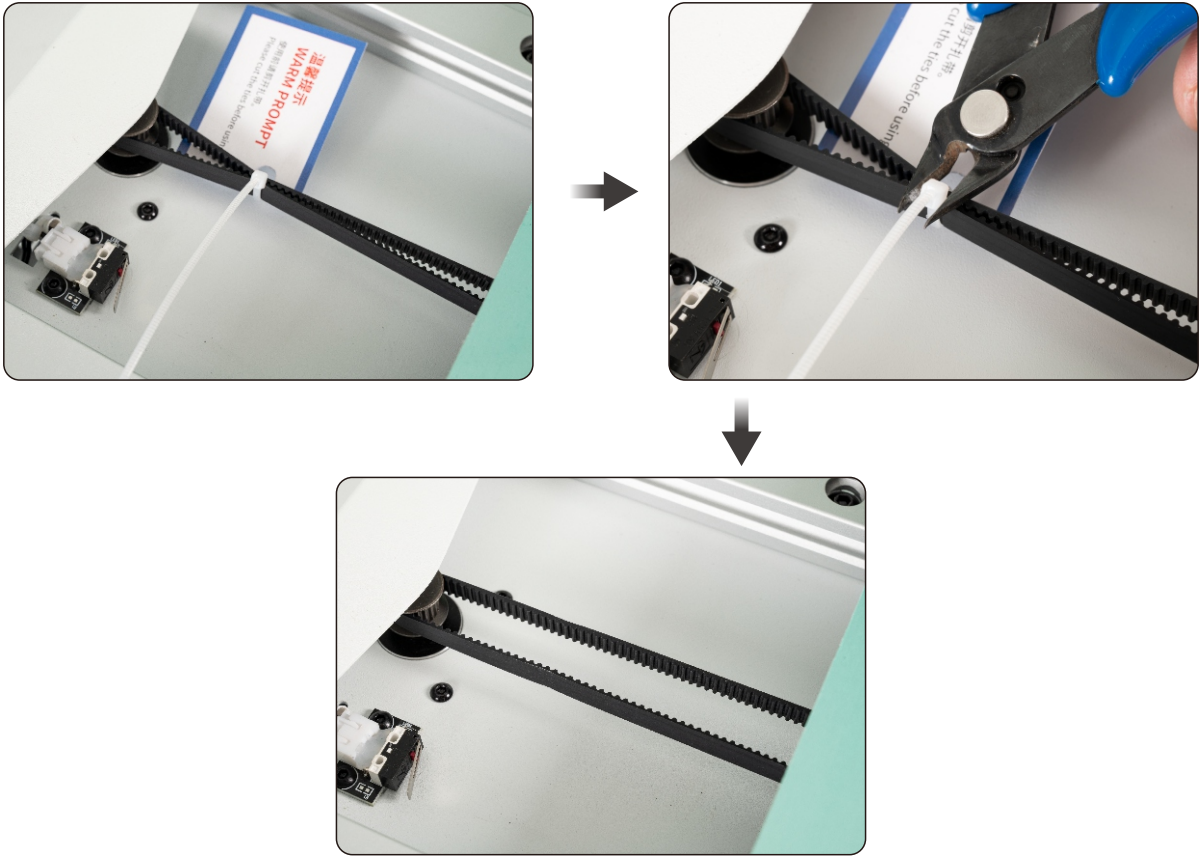
Machine installation 机器安装



Use 8 m4*10 screws to fix the upper frame on the base.

使用8颗M4*10螺丝，将上架固定在底座。

2. Unfasten the belt under the printing platform of the base
解开底座打印平台下方的皮带

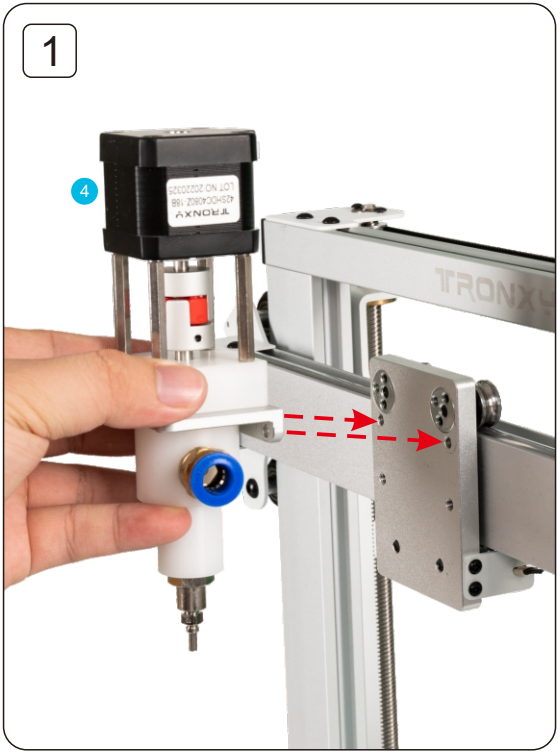


3. Installing the print head and handle
安装打印头和提手

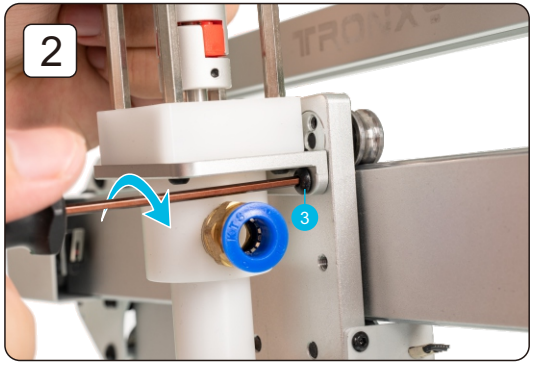
4
Print head*1
打印头 *1

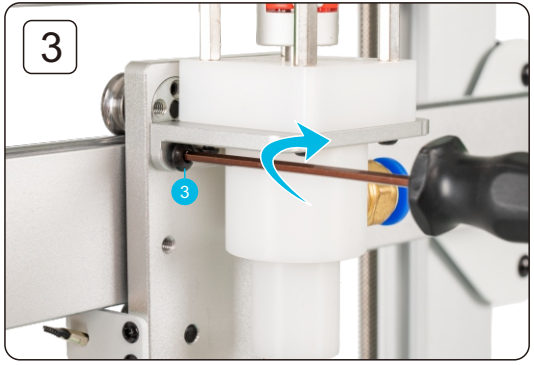
5
Handle *1
提手 *1

3
M4*10 screws *2
M4*10螺丝*2

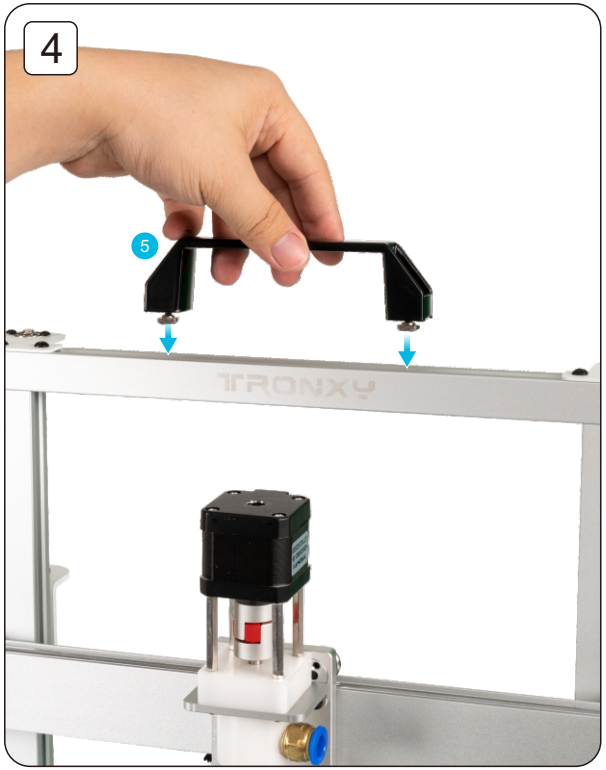


Install the print head on the slider as shown in the figure
如图所示，将打印头安装到滑块上





Tighten the screws
拧紧螺丝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5
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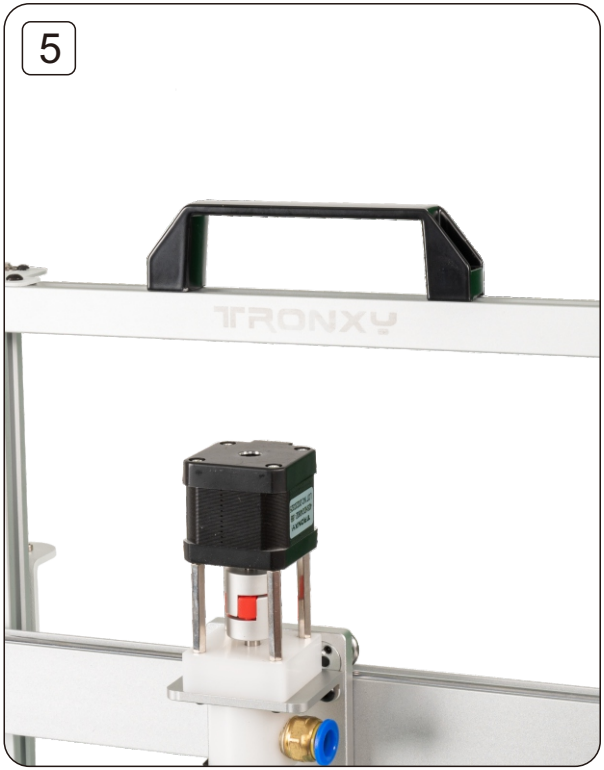
5
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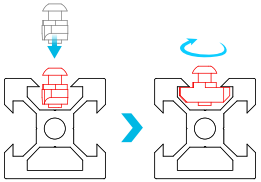
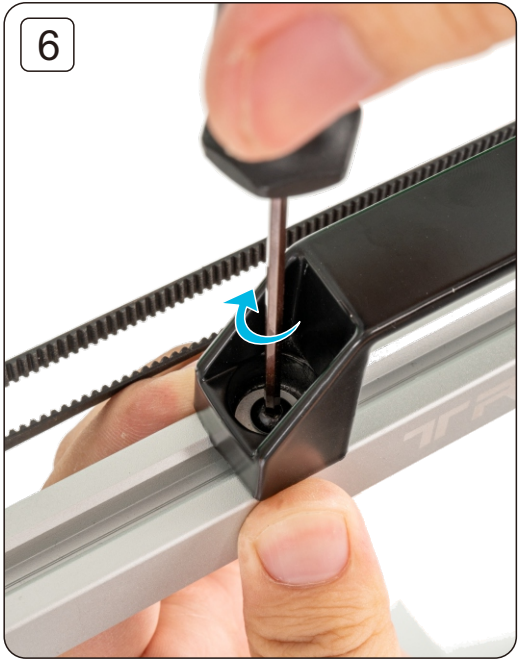
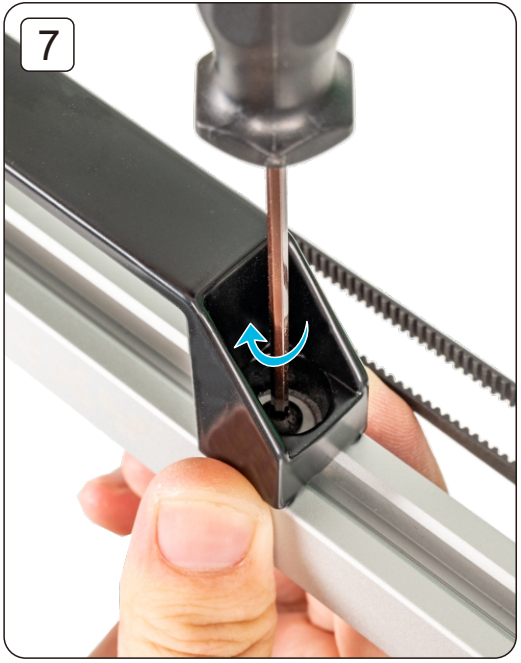
Working principle of boat nut
船型螺母的工作原理



Loosen the boat nut on the Filament rack 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。





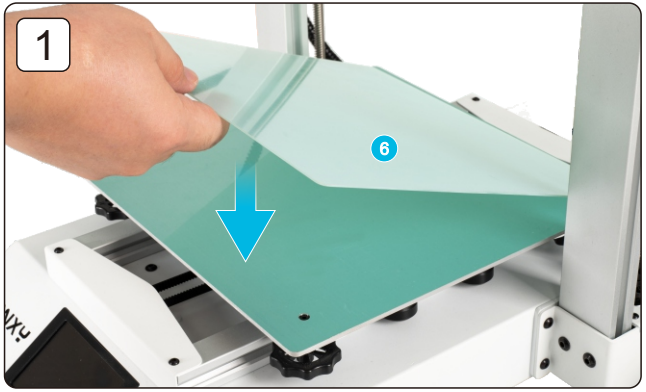
Tighten the screws
拧紧螺丝

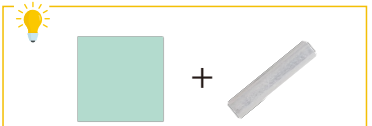
6
Fiberglass board plate*1
玻纤板 *1

7
Clip *4
夹子 *4

8
Z-axis limit switch *1
Z轴限位开关 *1

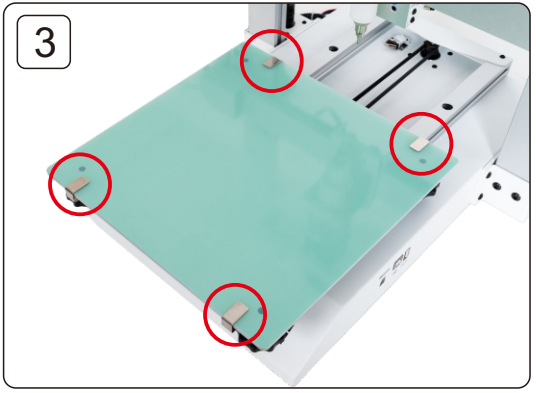
4. Install fiberglass board and Z-axis limit switch
安装玻纤板和Z轴限位开关

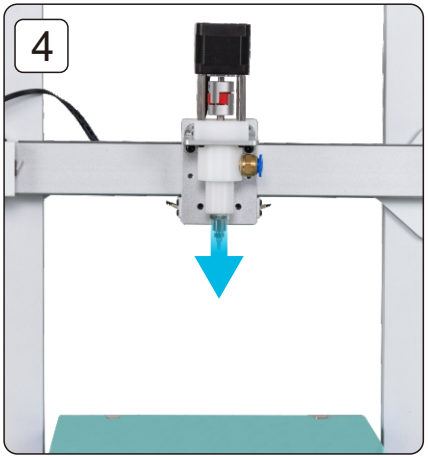




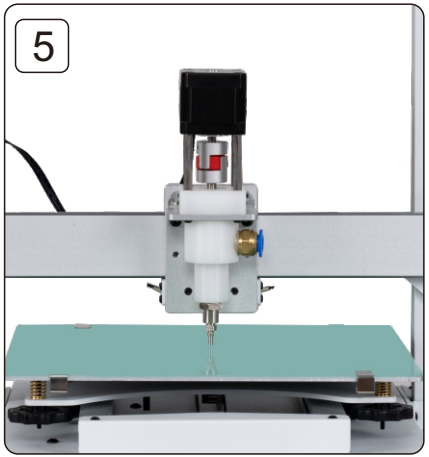
Before printing, cover the fiberglass board plate with a layer of stretch film, It can prevent the bottom of the model from cracking.

在打印之前，在玻纤板上覆盖一层缠绕膜，可以防止模型底部干裂。



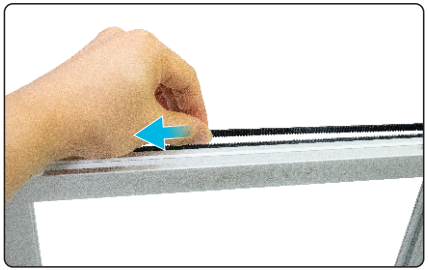


Lower the x-axis
降低X轴



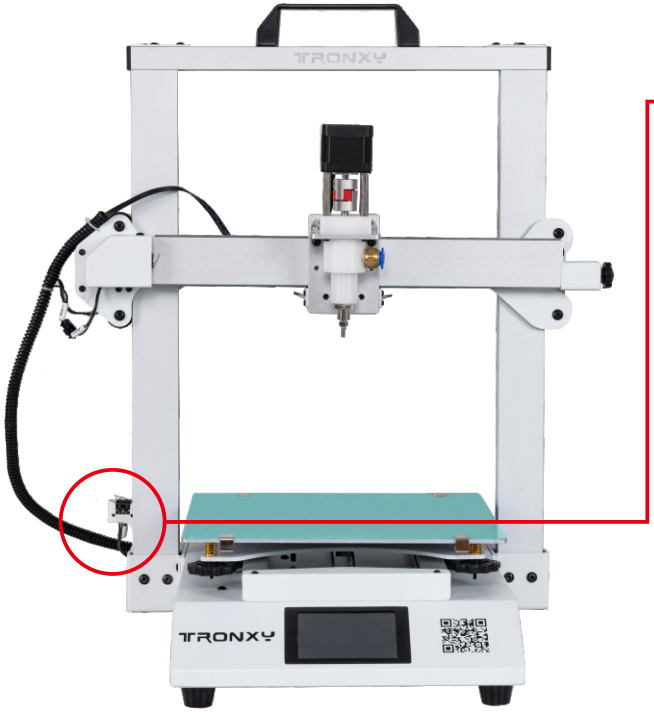
As shown in the figure
如图所示

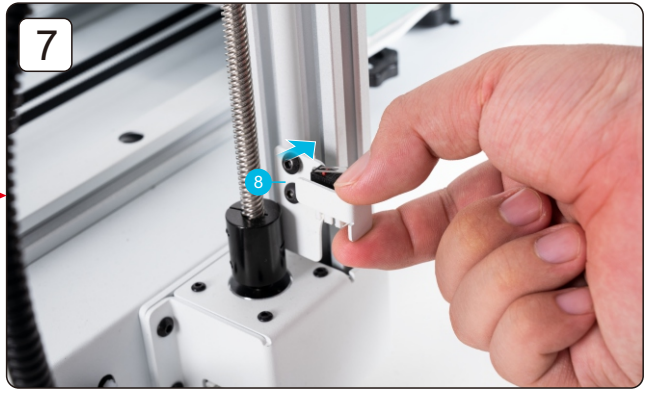
Fine tune to almost touch the platform
微调至几乎碰到平台



As shown in the figure, pulling the belt to the left can control the x-axis downward movement.

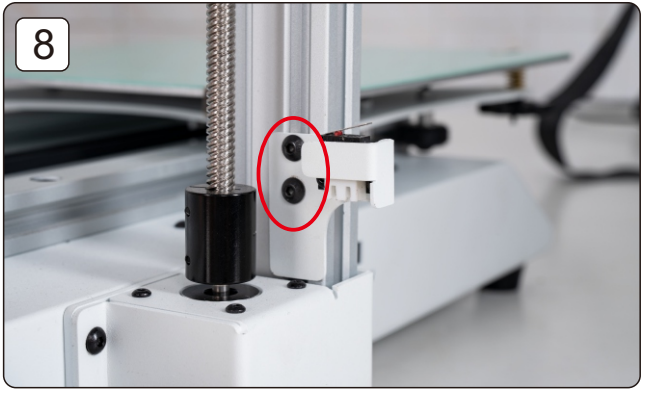
如图所示，向左拉动皮带可控制X轴向下移动。





Install the Z-axis limit switch as shown in the figure

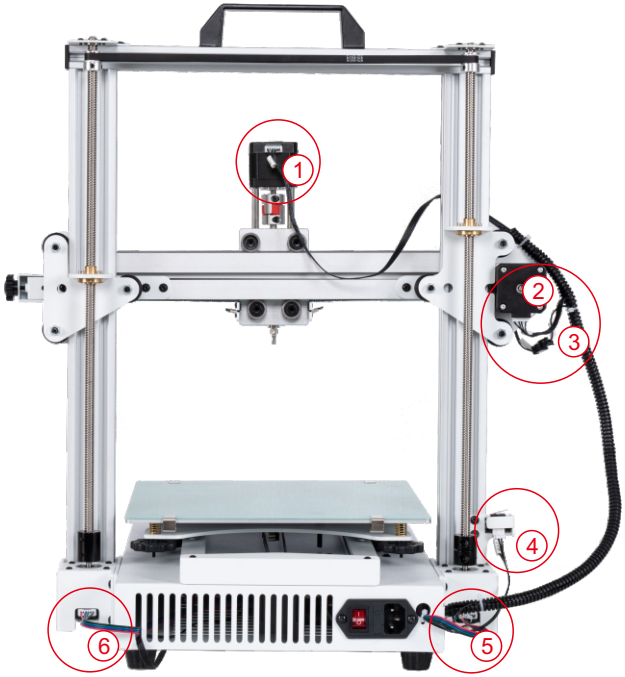
如图所示安装Z轴限位开关

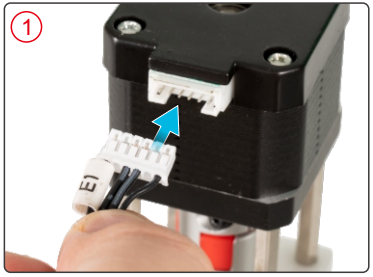


Tighten the two screws

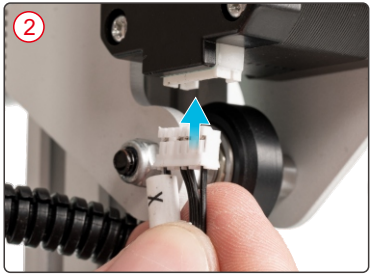
拧紧两颗螺丝

6. Insert connection line
插入连接线

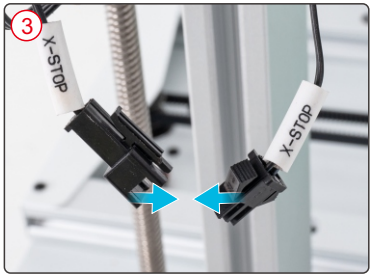




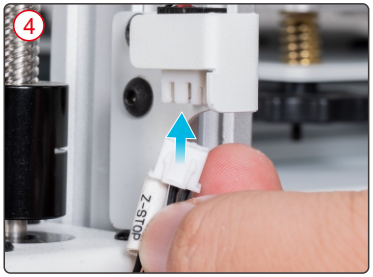
Plug in E1 motor line
插入E1电机线



Plug in X motor line
插入X电机线

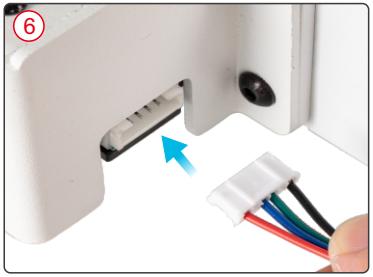


Plug in X-STOP line
插入X-STOP线



Plug in Z-STOP line
插入Z-STOP线

Plug in Z1 motor line
插入Z1电机线



Plug in Z2 motor line
插入Z2电机线

9

Feed transmission *1
进料变速器 *1

10

M18 extrusion screw * 1
M18挤出螺杆 *1

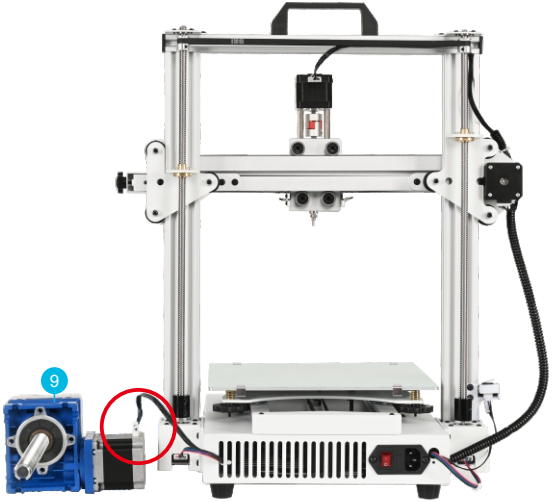
11

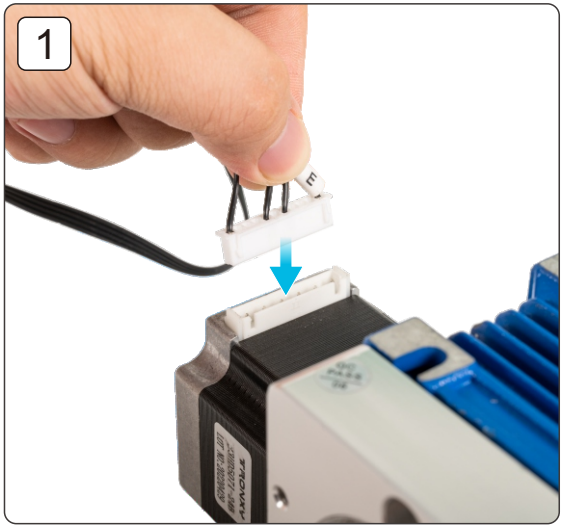
Piston * 1
活塞 *1

12

M4*20 screw* 1
M4*20螺丝 *1

7. Installing the feeder
安装送料装置



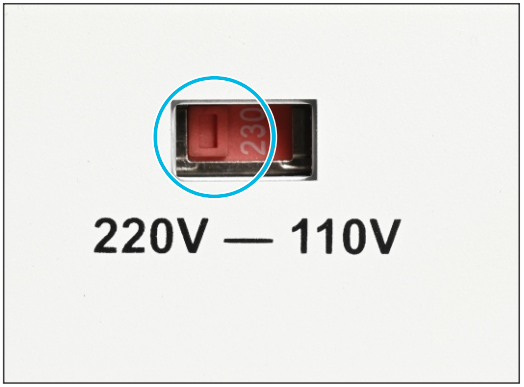


Plug in the E motor switch connection line of the infeed transmission
插入进料变速器的E电机开关连接线

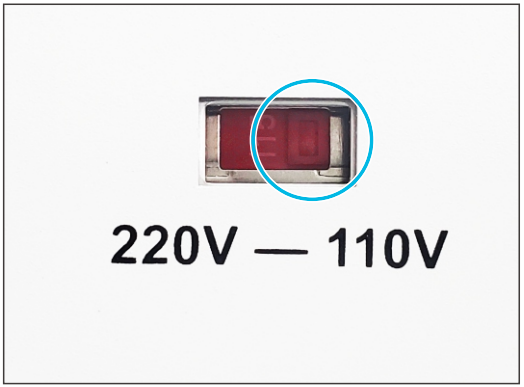
Important 重要提示

Before starting the printer for the first time, you must check whether the power supply voltage of the printer meets the local standard. Generally, the default setting is enough. For adjustment, please refer to the following contents.

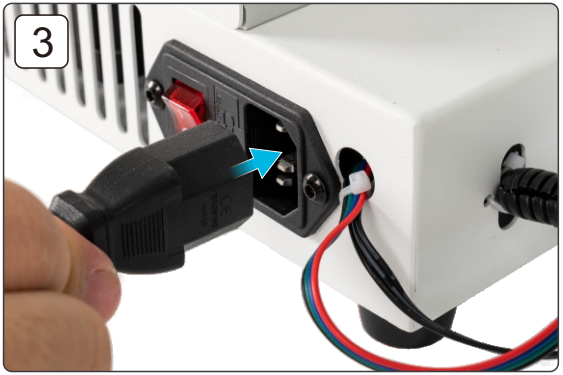
第一次打开电源前，必须检查电源电压是否符合当地标准，一般保存默认设置即可，如需调整可以参考以下内容。



Turn left, the voltage changes to 220V
往左拨为电压220V

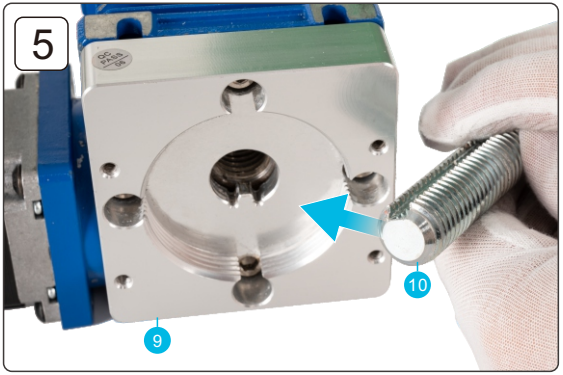


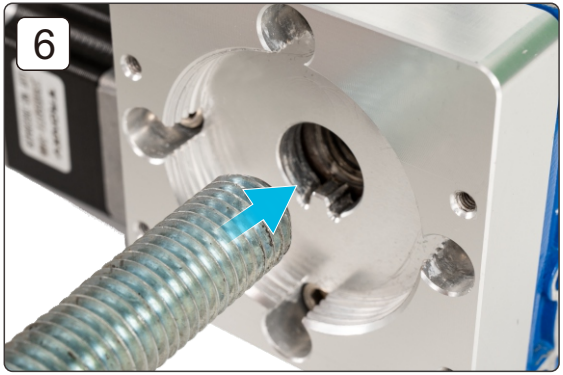
Turn right, the voltage changes to 110V
往右拨为电压110V



Plug in the power cord
插入电源线

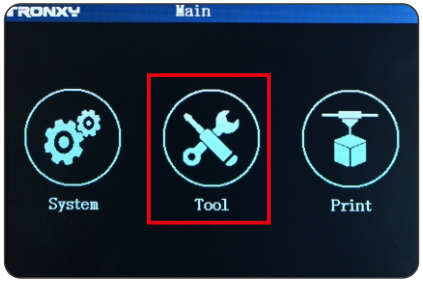
Switch ON
打开开关



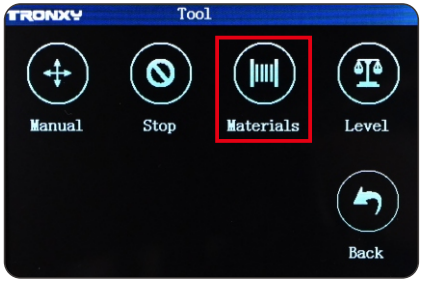


Insert the M18 extrusion screw into the feed transmission at the side without screw hole
将M18挤出螺杆没有螺丝孔的一边，插入进料变速器中

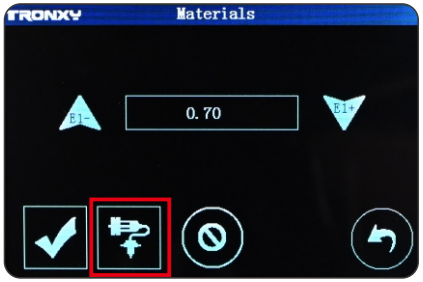
7 Start the transmission and feed the screw into the transmission
启动变速器，将螺杆送入变速器中



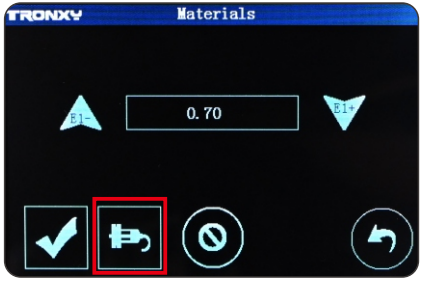
Select "Tool"
选择“工具”



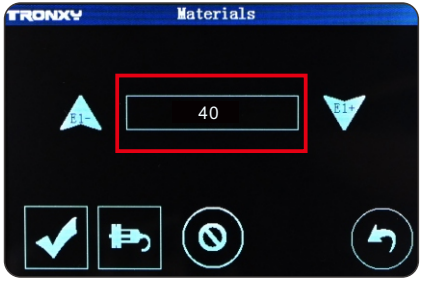
Select "Materials"
选择“材料”



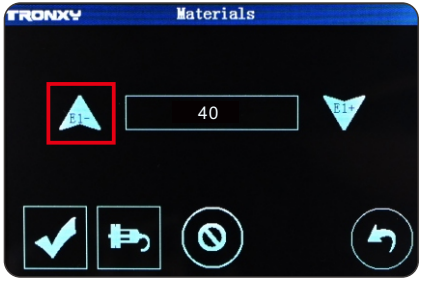
Click the icon here to switch to "control extruder only"
点击此处图标，切换到“只控制挤出机”



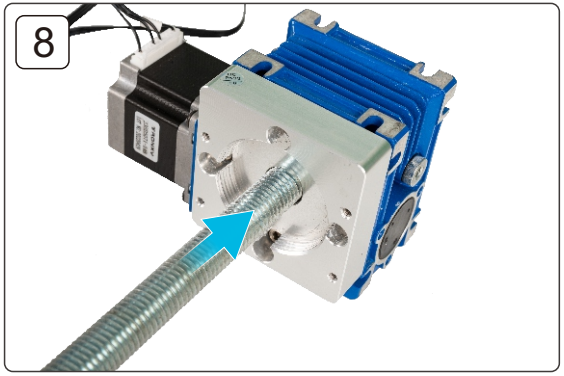
This icon indicates "control extruder only"
此图标表示“只控制挤出机”



Click "speed display box" to set the speed to 40 (maximum)
点击“速度显示框”，将速度设置为40（最大值）

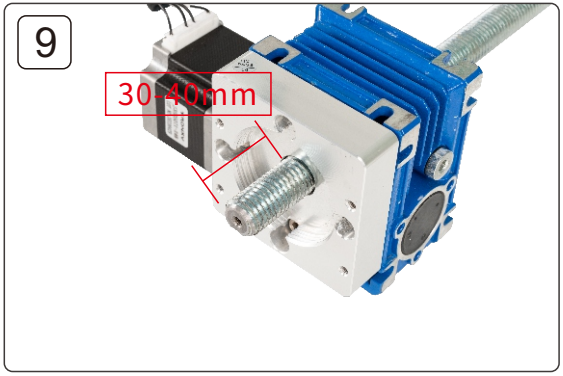


Click the "e1-" icon, at this time, the feeding transmission will start, and the screw will be sent to the transmission.
点击“E1-”图标，此时进料变速器会启动，将螺杆送入变速器。



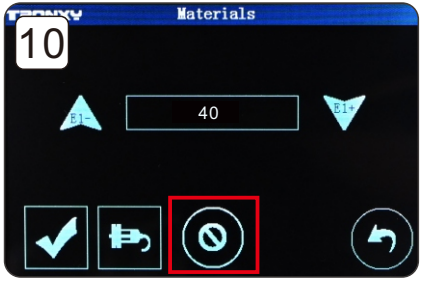
The feeding transmission is started and the screw is fed into the transmission

进料变速器启动，将螺杆送入变速器



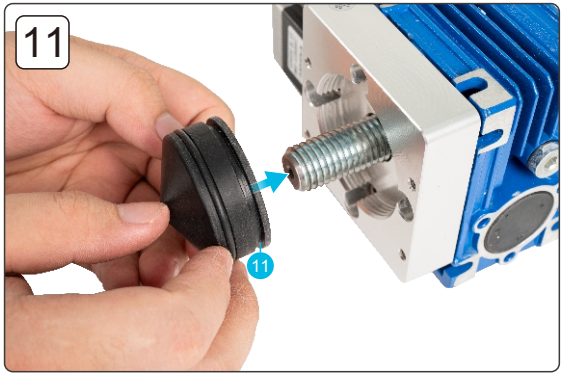
Keep the protruding length of the screw about 30-40mm to install the piston

保留螺杆凸出长度约30-40mm,用来安装活塞

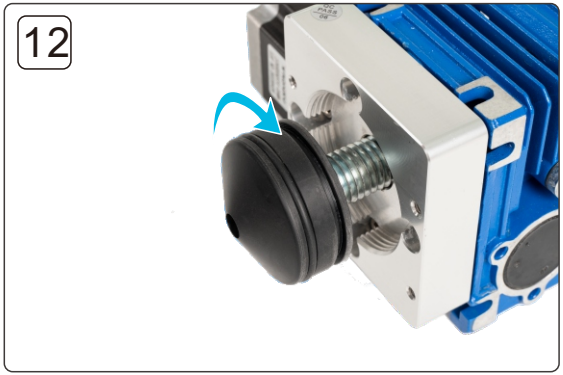


Click the "Stop" icon

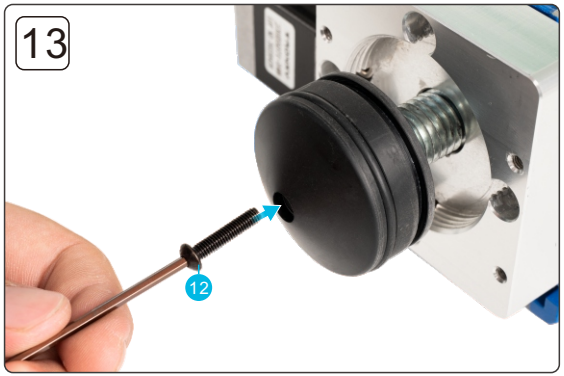
点击“停止”图标



Install the piston
安装活塞



Tighten the piston clockwise
顺时针拧紧活塞



Fix the piston with an M4*20 screw
使用一颗M4*20螺丝固定活塞

Piston installation completed
活塞安装完成

13
Barrel 0.5L *1
0.5L料筒 *1

14
Clay *1
陶泥 *1

15
PC10-02 pneumatic connector *1
PC10-02气动接头 *1

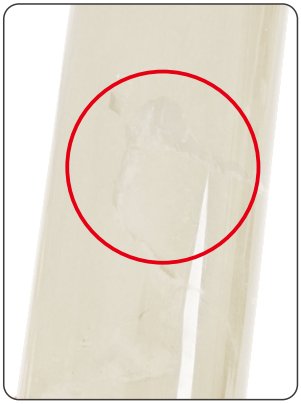
8. Load the clay into the barrel and install the barrel
将陶泥装入料筒中，并安装料筒

Knead the dough into a cylindrical shape slightly smaller than the material barrel
将泥团揉成比料筒略小的圆柱形

Put the clay into the barrel

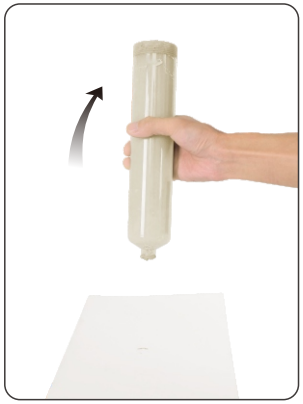
将泥团放入料筒里

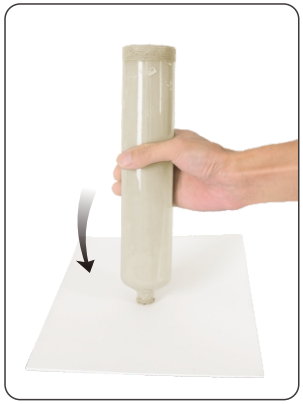
3



Bubbles were found after filling the mud

装泥后发现有气泡





Beat the barrel up and down

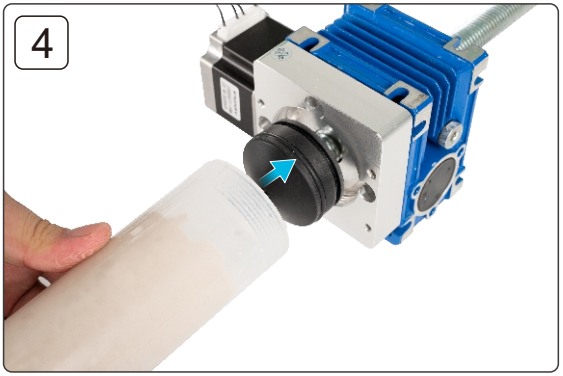
上下捶打料筒

After squeezing out the bubbles

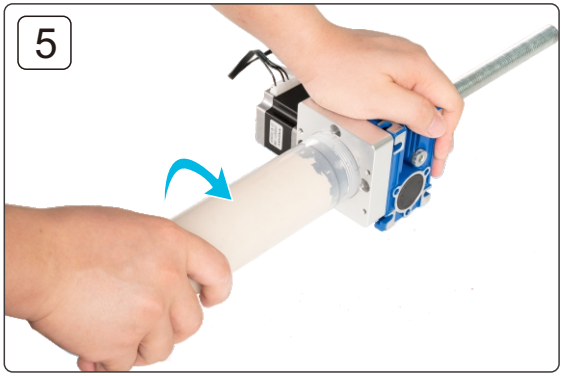
挤出气泡后

Find a piece of paper material with a certain thickness and lay it on the ground. Hammer the barrel up and down several times to squeeze out the bubbles in the barrel.Find a piece of paper material with a certain thickness and lay it on the ground. Hammer the barrel up and down several times to squeeze out the bubbles in the barrel.

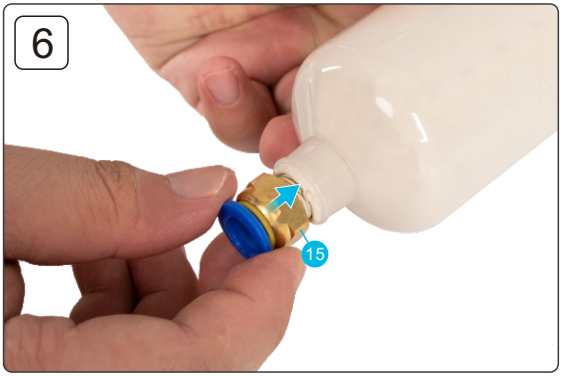
找一张有一定厚度的纸质材料铺在地上，上下捶打料筒几次，将料筒中的气泡挤出。



Install the clay charging cylinder onto the transmission
将装好陶泥的料筒安装到变速器上



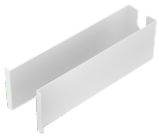
Tighten the barrel clockwise
顺时针拧紧料筒



Install pc10-02 pneumatic joint on the barrel
安装PC10-02气动接头在料筒上

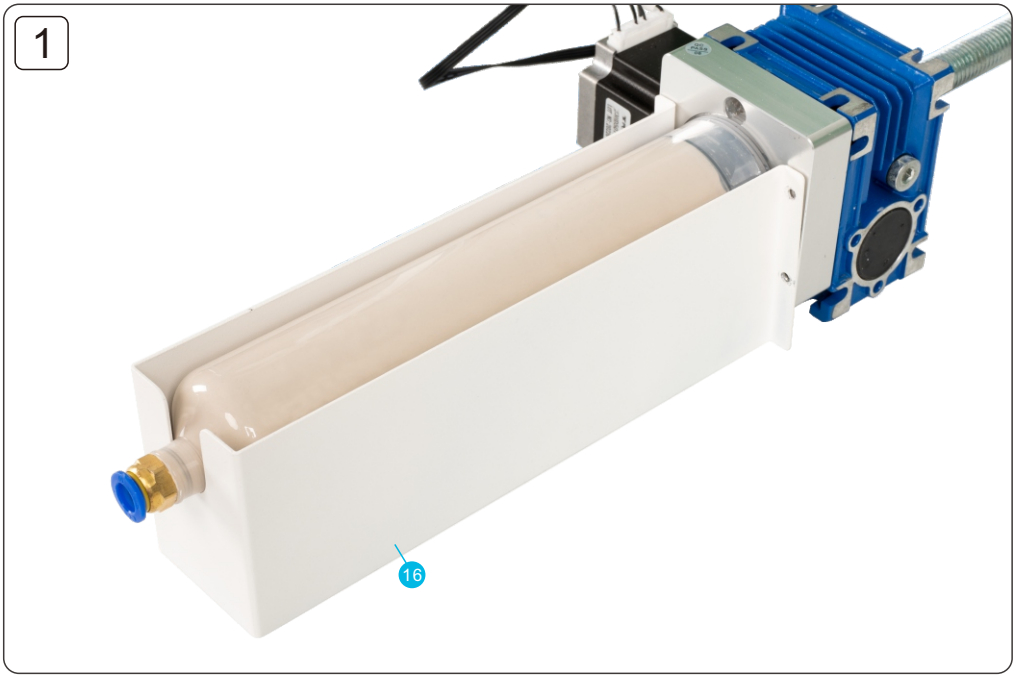
Tighten the pneumatic coupling with a wrench
使用扳手拧紧气动接头

9. Installing barrel holder
安装料筒固定支架

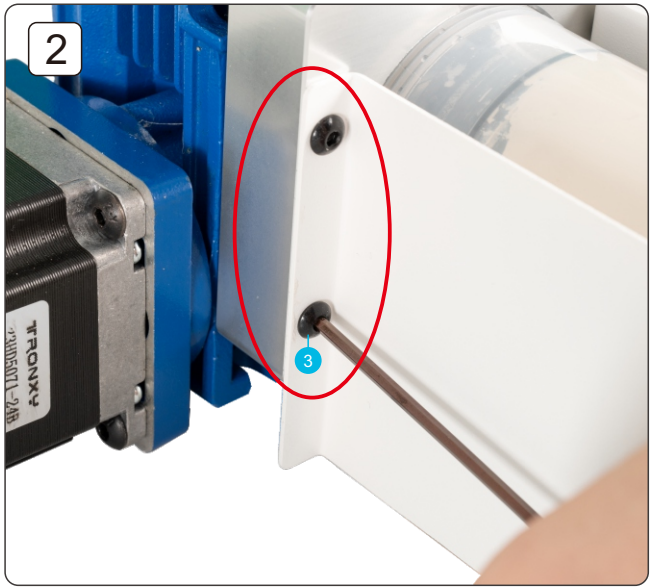


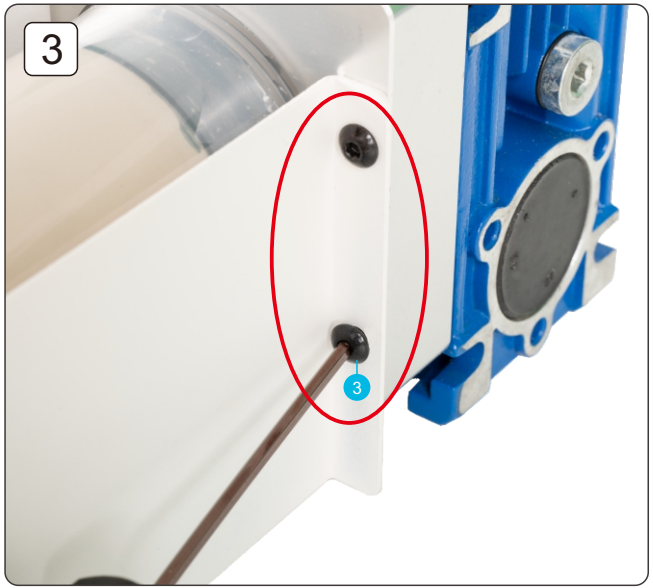
16
Barrel holder *1
料筒固定支架 *1

3
M4*10 screws *4
M4*10螺丝*4



As shown in the figure, place the barrel on the barrel holder
如图所示，将料筒放在料筒固定支架上



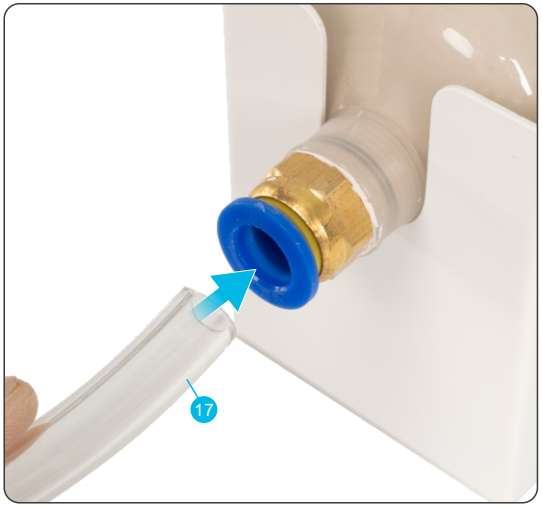


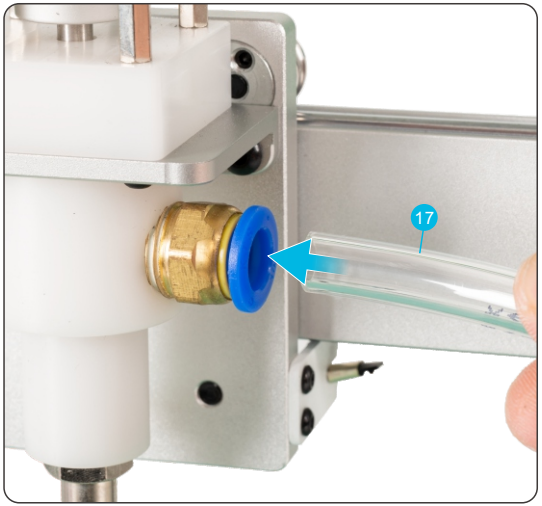
Use 4 M4*10 screws to fix the barrel holder
使用4颗M4*10螺丝固定料筒固定支架

10. Install tube
安装料管

17

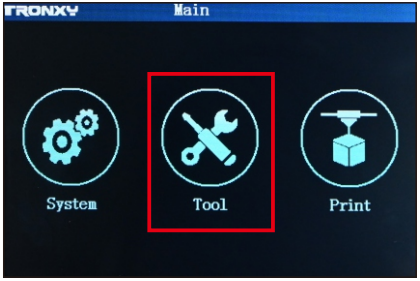
Tube *1
料管*1



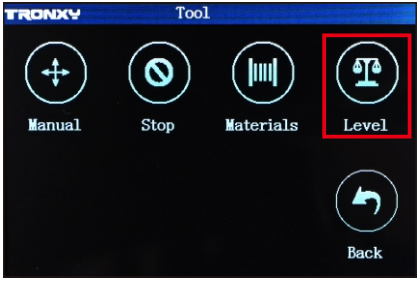


Insert the tube, and the machine installation is completed
插入料管，机器安装完成

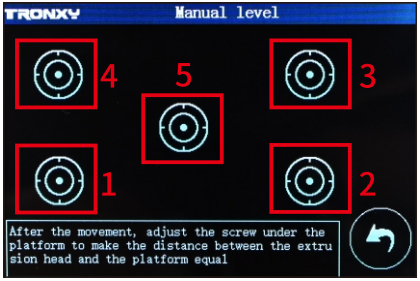
Platform leveling 平台调平



Select "Tool"
选择"工具"

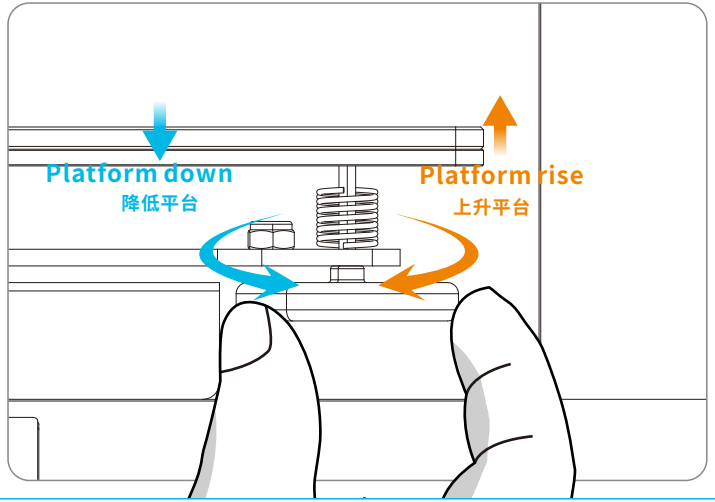


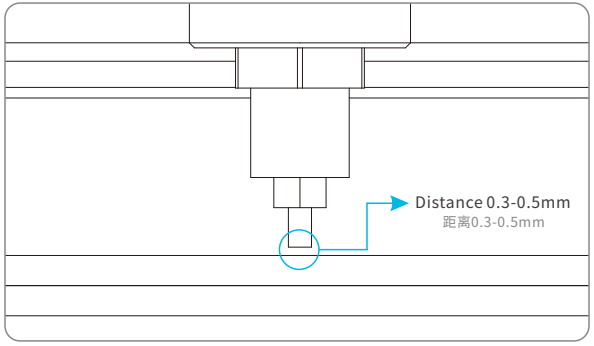
Select "Level"
选择 "调平"



According to the sequence given in the figure, level the five positioning points one by one.
(Refer to the picture below 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。(调平方法参考下图)

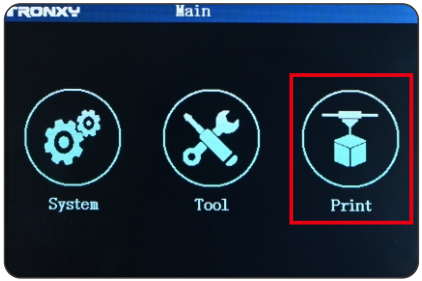




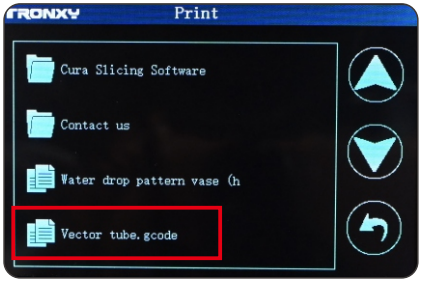
Adjust the four nuts under the platform to make the distance between the nozzle and the platform 0.3-0.5mm.

调节平台下方的四颗螺母，使喷嘴与平台的距离为0.3-0.5mm

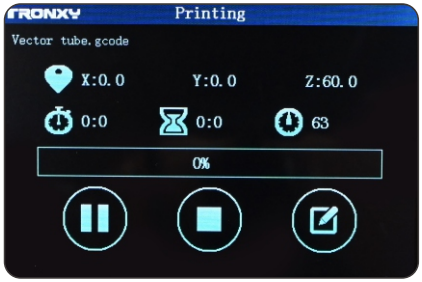
Printing operation tutorial 打印操作教程



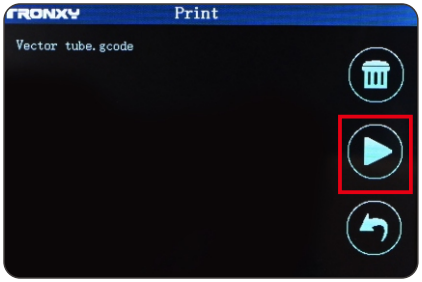
Select "Print"
选择“打印”



Select a file
选择一个文件



The machine enters the printing state
机器进入打印状态

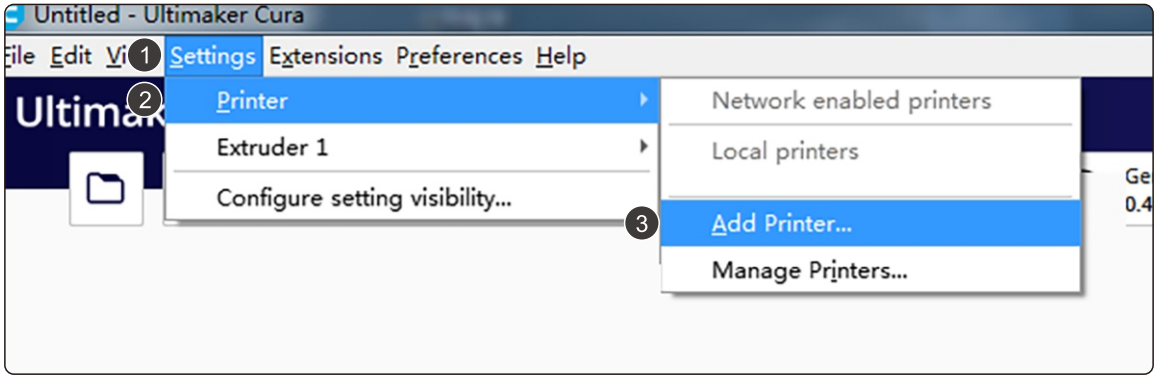


Confirm to print the document and click the "start printing" icon
确认打印文件，点击“开始打印”图标

Slice Software Installation Steps 切片软件安装设置

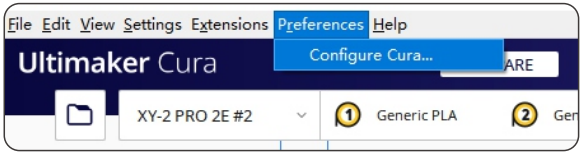
1. Install "Ultimaker_Cura-amd64"on the computer, double-click to install the software, and follow the prompts to complete the installation steps;
在电脑上安装“Ultimaker_Cura-amd64”，双击安装软件，按照提示完成安装步骤；

2. Add a printer;
添加打印机；

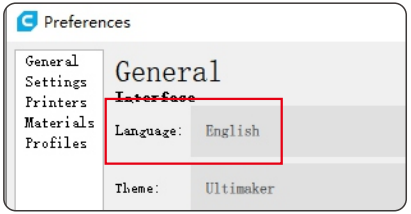


1 Settings 设置 → 2 Printer 打印机 → 3 Add Printer... 新增打印机

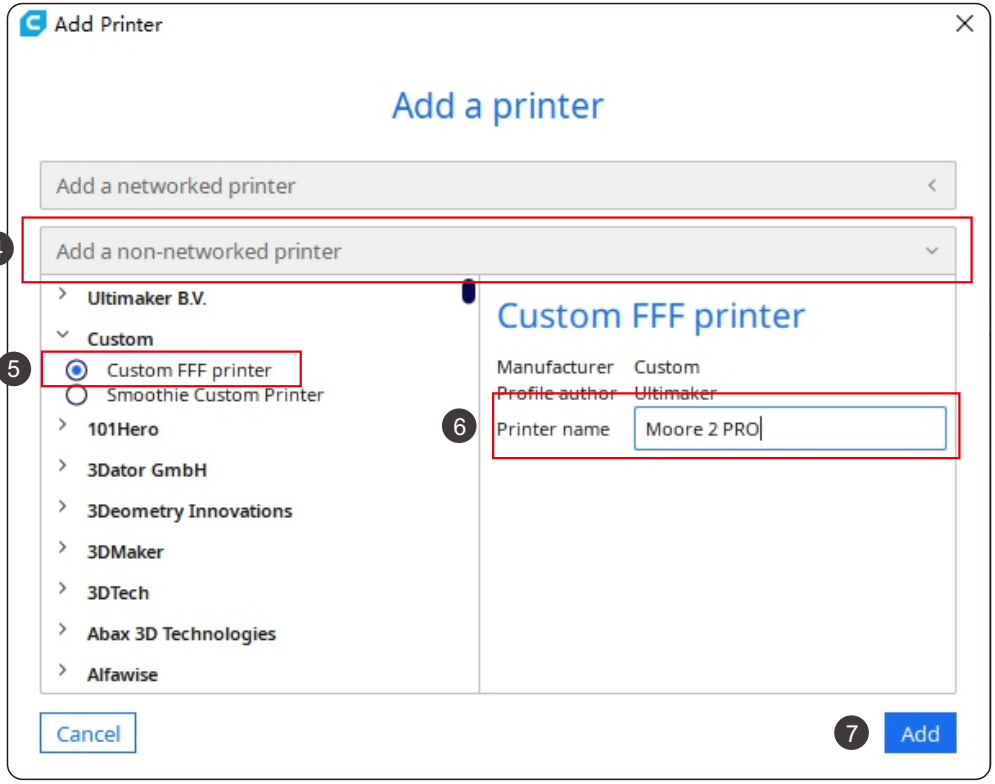
How to change the language of slicing software
切片软件如何更换语言



Preferences 偏好设置 → Configure Cura... 配置Cura



After selecting the desired language, restart the software
选择好需要的语言后，后重启软件即可



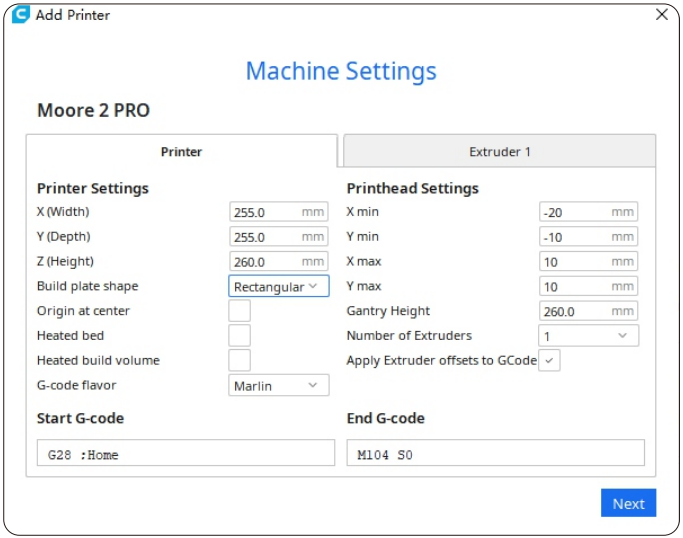
4 Add a non-networked printer
点击“添加未联网打印机”

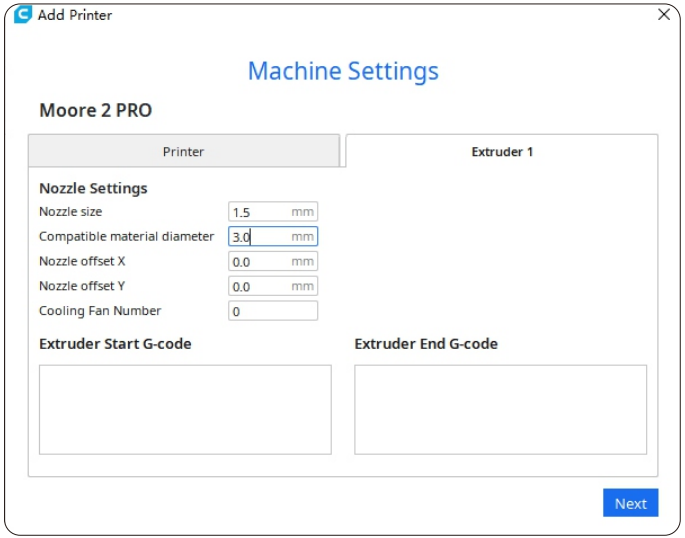
→ 5 Custom FFFprinter
选择 “Custom FFFprinter”

→ 6 Enter "Moore 2 PRO"
输入 “Moore2 PRO”

→ 7 Add
点击“添加”

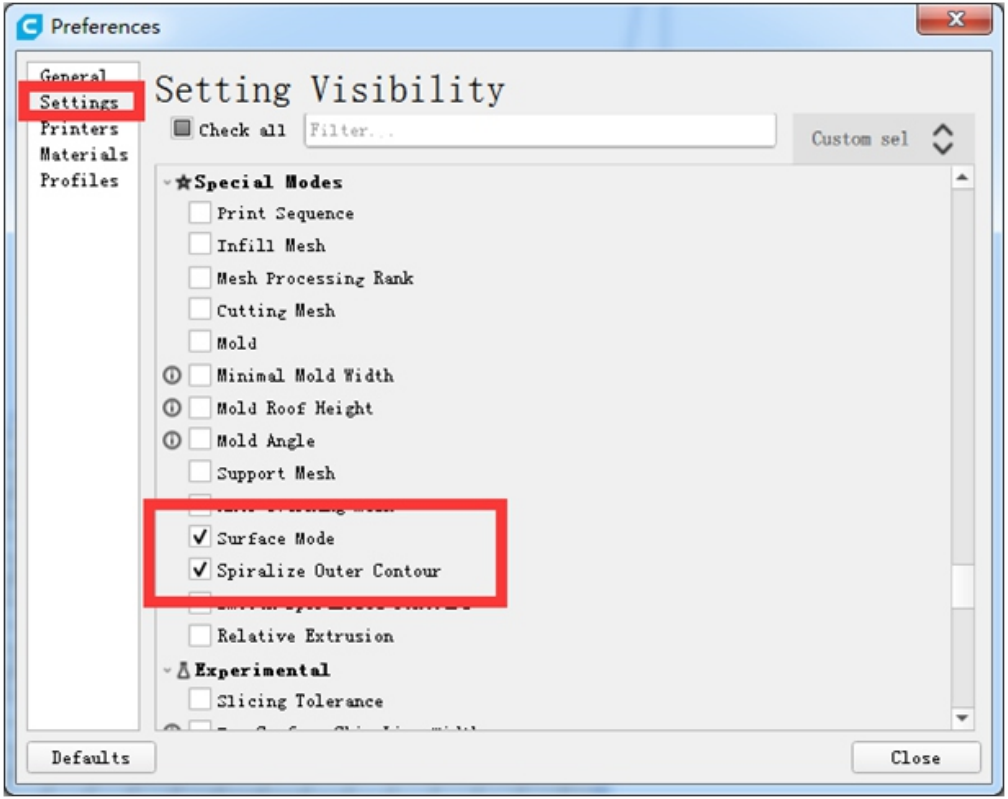
Slicing software settings 切片软件的设置





Set the value as shown in the figure

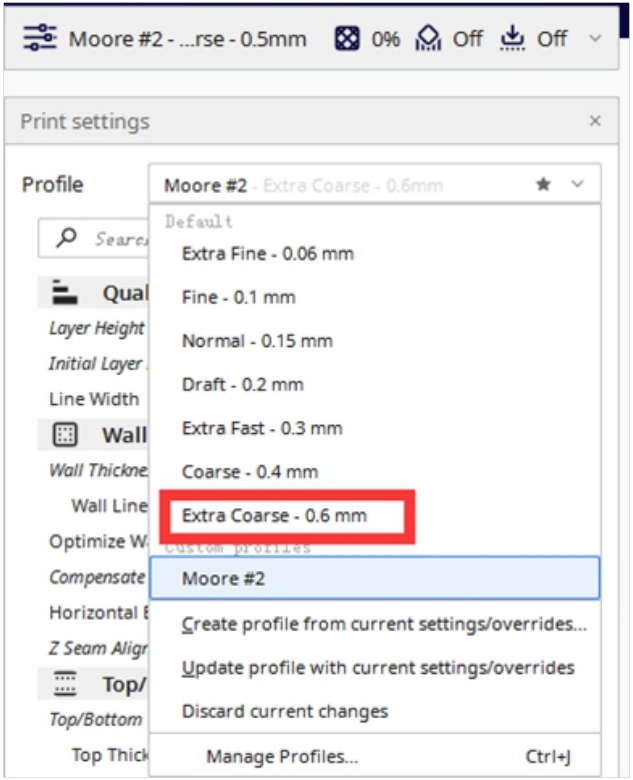
如图所示设置数值

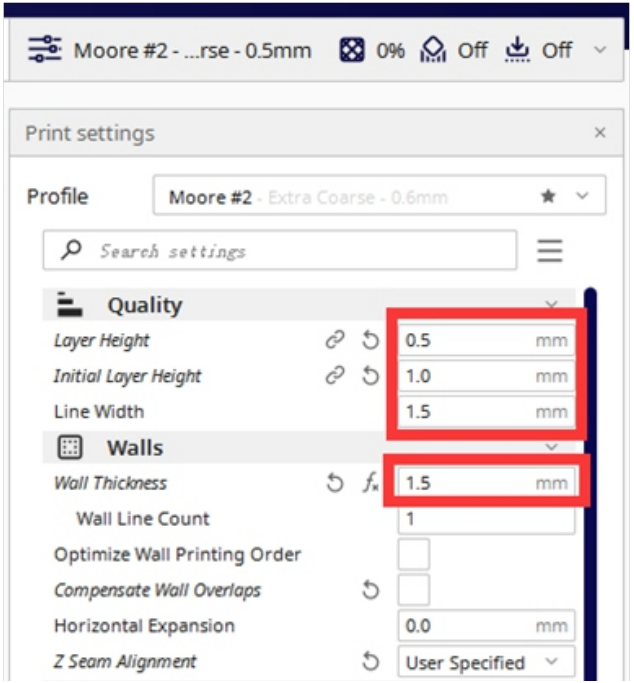


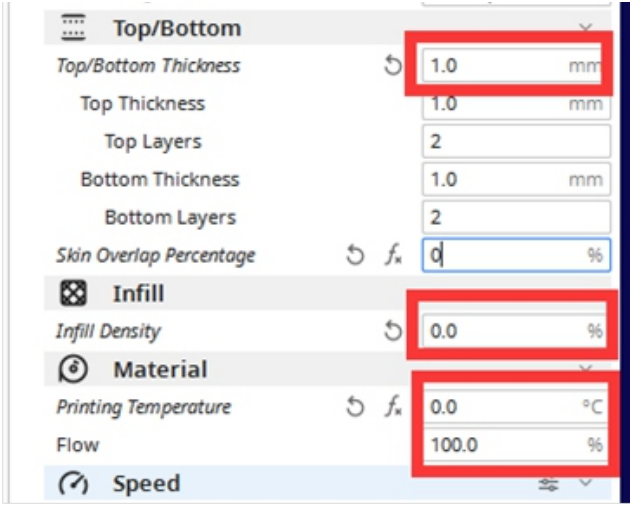
Select the option in the red circle

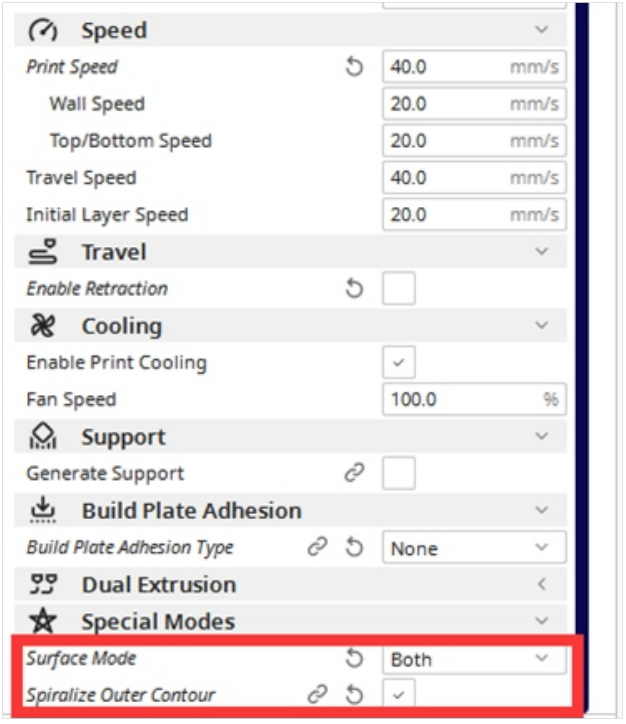
勾选红圈中的选项

2. parameter settings 参数设置

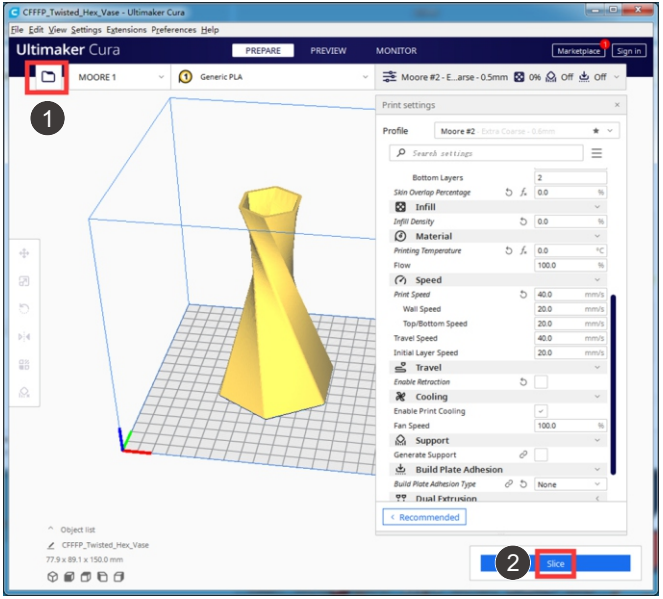




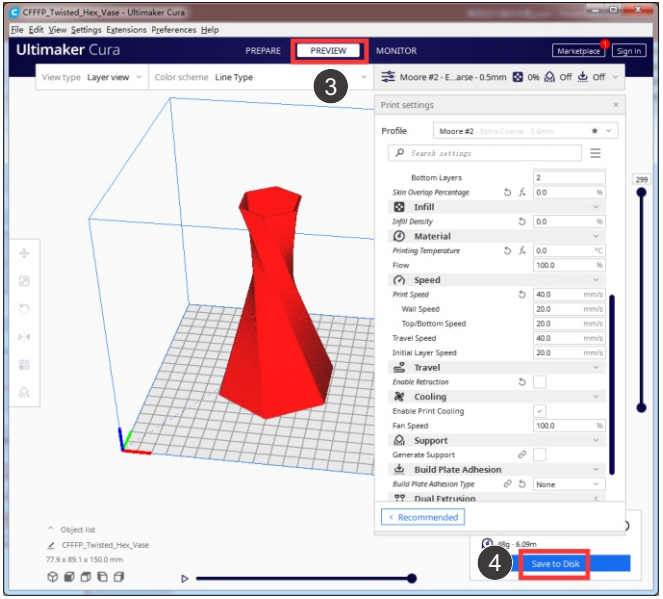

Top/Bottom
Top/Bottom Thickness
1.0
mm
Top Thickness
1.0
mm
Top Layers
2
Bottom Thickness
1.0
mm
Bottom Layers
2
Skin Overlap Percentage
0
%
Infill
Infill Density
0.0
%
Material
Printing Temperature
0.0
°C
Flow
100.0
%
Speed


Speed
Print Speed
40.0
mm/s
Wall Speed
20.0
mm/s
Top/Bottom Speed
20.0
mm/s
Travel Speed
40.0
mm/s
Initial Layer Speed
20.0
mm/s
Travel
Enable Retraction
Cooling
Enable Print Cooling
Fan Speed
100.0
%
Support
Generate Support
Build Plate Adhesion
Build Plate Adhesion Type
None
Dual Extrusion
Special Modes
Surface Mode
Both
Spiralize Outer Contour

Slicing software settings 切片软件的设置



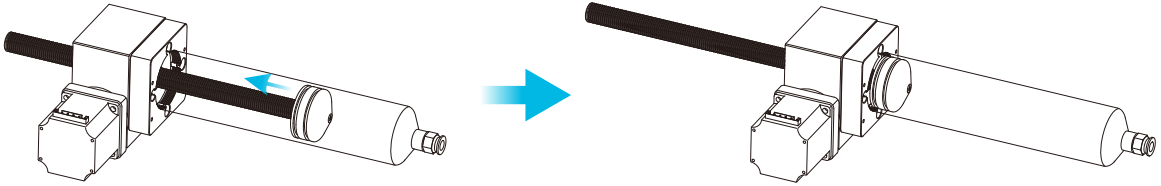
❶ Open a file → ❷ Slice
打开一个文件 切片

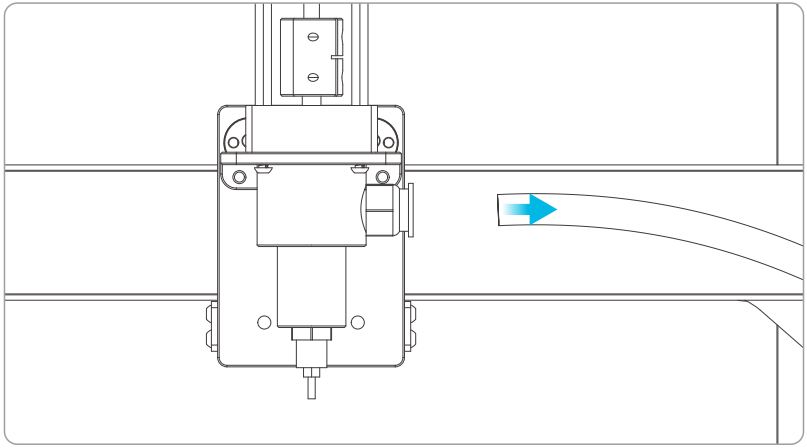


❸ Preview → ❹ Save to Disk
预览 保存到磁盘

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作

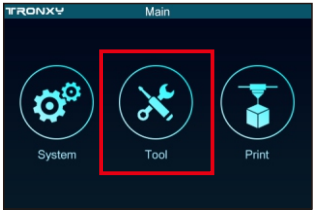
The piston must be moved to its original position before changing the barrel.
更换料筒前，必须将活塞移动到初始位置。



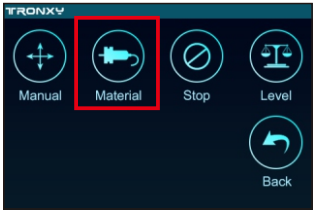


The feed tube of the print head must be unplugged before operation.
操作之前必须拔下打印头的进料管

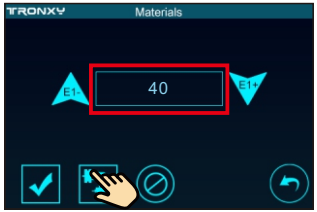
Precautions and operations for replacing the barrel 更换料筒的注意事项与操作



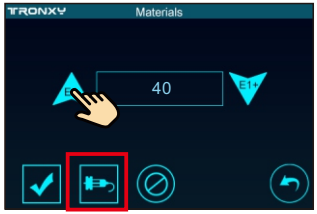
Select "Tool"
选择“Tool”



Select "Materials"
选择“Materials”



Click 点击 switch to 切换到
(Speed range 0~40)
(速度范围0~40)



Click "E1-" to retraction
点击“E1-”进行回抽

Three control methods of Materials
耗材的三种控制方式

Linkage mode (default)
Can control the feeding device and the motor of the print head at the same time.

联动模式(默认)
可以同时控制送料装置与打印头的电机。

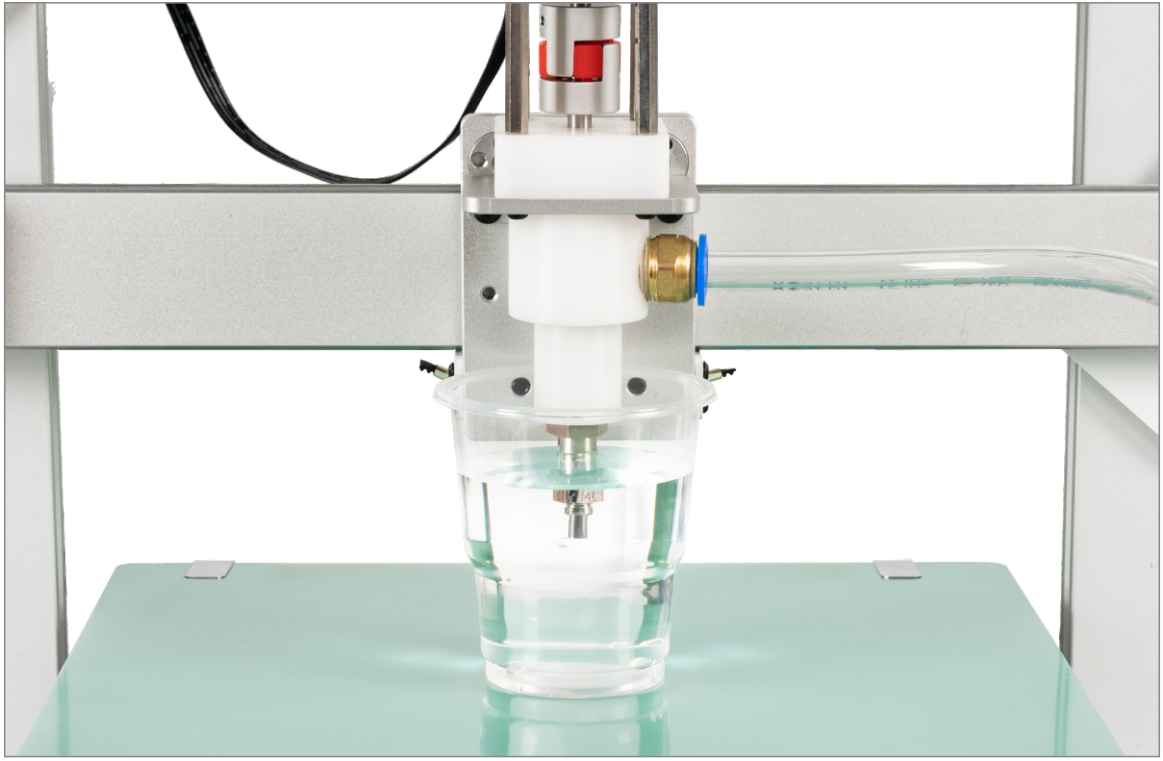
Feeding device mode
Separately control the motor of the feeding device.

送料装置模式
单独控制送料装置的电机。

Print head mode
Separately control the motor of the print head.

打印头模式
单独控制打印头的电机。

Cautions after printing 打印完成注意事项



Note: soak the printhead/nozzle in the water after printing to prevent the mud from drying and clogging the printhead

注意:打印完将喷嘴浸泡在水中以防泥料干掉

Due to the differences between different machine models, the physical objects and the final images can differ.
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TRONXY

Intelligent print for you

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