

XY-2 PRO User's manual Instruction Manual



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Please read the instruction carefully



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Relevant information is stored in SD card, please check



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XY-2PRO Pro Install video QR Code



Aftersale contact QR Code



Facebook QR Code

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1. Machine parameters

Print parameters :

Print size	:	255*2	255*260	mm				
Print accuracy	:	0.1-0.	3mm					
Print principle	:	FDM	(fused o	depos	itic	on mo	lding)	
Nozzle size	:	0.4m	m					
Nozzle quantity	:	1						
Print speed	:	20-10	0mm/s	(adv	ise	60mr	n/s)	
Position accuracy	:	X/Y -(0.006251	mm,	Z -	- 0.00	125mn	า
Filaments support	:	PLA、	ABS					
Temp parameters	5:							
Print environment	:	8-40	°C					
Nozzle temp	:	275°	C (MAX	()				
Power supply:	AC	110/2	20V 50/	60Hz	[DC 24	V/360V	v

Software :

Slicer	:	Tronxy、Cura、Simplify3D
Input format	:	.stl、.obj
Output format	:	.gcode
Connection	:	SD card、USB cable

Machine parameters :

Machine size	:	478*455*520mm
Package size	:	510*480*230mm
Weight	:	≈12kg

2. Packing list

	P	Upper bracket	Base	Filament bracket
			IIII	
XY-2 PRO		Installation Manual	HM5*50 4PCS	Tools
	20		THEORY	
Shovel	Power line	USB cable	Stickers	Reader (with SD card)
Filament 0.25KG	Clips (Color random)			

Notes : Please check if all the items are included before installing the printer. If you have any questions , please contact the customer service.

3. Machine details



NO.	Commodity	NO.	Commodity	NO.	Commodity	NO.	Commodity
1	Upper bracket	8	Y axis wheels	15	Touch screen	22	Y axis motor
2	Filament run-out	9	Feeding tube	16	Lead screws	23	Y limited switch
3	X axis motor	10	Right slicer	17	Extruder motor	24	USB/SD card interface
4	X limited switch	11	Print head component	18	30P single cable		
5	Left slicer	12	Extruder	19	Z axis motor		
6	Auto level sensor	13	Heatbed	20	Control box		
7	Power	14	Adjustment nuts	21	Power switch		

4. Installation

Note: Please make sure the voltage is consistent with the local voltage before printing . If not, please adjust it (110V-220V)







Loosen the screws with the socket wrench and remove the touch screen from the beam. Remove the screws and nuts.

Pass the removed screw through the touch acreen bracket and carry the ship nut.

Lock the ship nut with socket wrench and fix the touch screen on the front beam profile of the base.

Note: the controller must be locked on the front beam, otherwise it will collide with the hot bed.



6

Take the upper bracket and match the four holes to the four holes of the base. Use four M5*50 screws to lock the upper bracket to the base.

Filament bracket

Take out the filament bracket, lock the ship nut with hexagon wrench, and fix the bracket on the upper beam.



done

5. Wiring connection





Power 110v-220v switch

Switch line installation method:

Remove the buckle, and put it on the notch side of the quasi-adapter plate on the raised side of the adapter, and insert it firmly until the buckle bounces back.



6. Structure debug

If the machine structure is loose during transportation, it can be solved by adjusting the eccentric nut.As shown in the figure below (eccentric nut in red circle), turn the nut with a wrench to adjust the tightness of the pulley (the pulley should not be adjusted too tight to avoid smooth operation).









Left slicer

Right slicer

Print Head

HeatBed





If the structure is loose in other places, you can tighten the screws directly.Before debugging, make sure the machine structure is in a stable and smooth state. You can slide the print head and platform module by hand to ensure smooth and stable sliding before leveling printing.

7. Operation & Print





Manual leveling :

Click the four points of ABCD (see the picture), the print head will move to the corresponding position, and then adjust the leveling nut M, to ensure the space between the nozzle and the platform is a piece of A4 paper. After adjusting the four points in turn, it needs to be verified again. If the interval is appropriate, the leveling is completed.



Auto leveling :

- ① Click the leveling function in the figure to automatically pop up the interface, select "automatic leveling", jump out of the figure (1) interface, and start leveling. After the Detection is completed, the error value of each point will be displayed. If the value is greater than 0.8, adjust the leveling nut in the corresponding area, and then reset until all values are less than 0.8, then the automatic leveling is finished.
- ② Then click "Z offset", the print head will move to the middle of the platform, observe the height of the nozzle and platform, and then click ①②, making the space between the nozzle and platform is a piece of A4 paper thickness, then click ③, reset the zero. Then finished.



Load and unload filaments :



After waiting for temperature up to 180 $^{\circ}$ C, filament go through from the filament detection, extruder and feed pipe to the nozzle until the filaments are squeezed, as the following picture shows :



If the filaments cannot stick on the first layer or the nozzle hits the hotbed crazy when printing, then the distance of the nozzle and the hotbed is not suitable . Then please readjust the Z offset value.

1. Installation

Find out slice software in SD card "TronxyInstall.exe "click twice, Then follow these steps to complete the installation.

	Tronxy 1.4.15 Setup	
Installer Language		Welcome to Tronxy 1.4.15 Setup
		Setup will guide you through the installation of Tronxy 1.4.15.
Please select a language.		It is recommended that you close all other applications before starting Setup. This will make it possible to update relevant system files without having to reboot your computer.
		Click Next to continue.
English Cancel	R	
		Next > Cancel
Tronxy 1.4.15 Setup	Tronxy 1.4.15 Setup	
Choose Install Location Choose the folder in which to instal Transy 1.4.15.	License Agreement Please review the license term	is before installing Tronxy 1.4.15.
Setup will install Tronxy 1.4.15 in the following folder. To install in a different folder, dick Browne and related another folder. Click Install a start the installation.	Press Page Down to see the n	est of the agreement.
	The software is based on the 1. support will wreless trans 2. support print preview; 1	Cura depth of the secondary development inssion;
Destination Polder Bit Schwards (R) Branse		
Space required: 488.2 MB Space available: 3.4 GB	If you accept the terms of the agreement to install Tronxy 1.	agreement, click I Agree to continue. You must accept the 4.15.
-CBD Technology Co.,Ltd	-CBD Technology Co., U.d	< Back I Agree Cancel
Tronxy 1.4.15 Setup	Tronxy 1.4.15 Setup	
Installing Please wait while Tronxy 1.4.15 is being installed.		Completing Tronxy 1.4.15 Setup
Extract: QtSXimPatterns.dl		Tronxy 1.4.15 has been installed on your computer.
Pytrart: 019PinIS mont.dl		Click Finish to close Setup.
Extract Q25mldbgbdal Extract Q25mldbgbdal Extract Q25Qubd		V Run Transy 1.4.15
Extract: QtSQuidPartides.dl Extract: QtSQuid/Templates2.dl		
Extract: QtSiql.dl Extract: OtSiyo.dl		
Extract: QcSNidgets.dl Extract: QcSNidgets.dl v		
-380 Technology Co., Ltd-		
< DBOX MEXT > Cancel		Cancel

2. How to use slice software

① Type setting: follow the steps below to complete the setting.



② Parameter setting: (The following figure gives the reference value, according to their own needs can be modified)

🔵 Tronxy Slicer V	1.4.15	CC 2- 2 mon	🔵 Tronxy Slicer	V1.4.15	CONTRACTOR NO.
File Edit Settings Extensions File Edit Settings Extensions					
_					
,	XY-2			XY-2	
	Recommended	Custom		Recommended	
	Layer Height	<i>i</i> 0.2 mm		Bottom Lavers	<i>i</i> 4
	Initial Layer Height	<i>i</i> 0.3 mm		7 Seam Alignment	i User Speci Y
File	Line Width	<i>i</i> 0.4 mm	File	Infill	
	Shell			Infill Density	<i>i</i> 20 %
	Wall Thickness	i 0.8 mm		Infill Pattern	⊃ i Grid ✓
	Wall Line Count	<i>i</i> 2		Material	
	Top Layers	<i>i</i> 4		Printing Temperature	⊃ <i>i</i> 200 °C
	Bottom Layers	<i>i</i> 4		Build Plate Temperature	⇒ <i>i</i> 50 °C
	Z Seam Alignment	i User Speci 🗠		Diameter	<i>i</i> 1.75 mm
Send	Infill		Send	Flow	<i>i</i> 100 %
	Infill Density	20 96		Enable Retraction	i 🖌
	Infill Pattern	□ i Grid 👻		Retraction Distance	⇒ i 5 mm
	Material			Retraction Speed	5 i 70 mm/s
563	Printing Temperature		500	Speed	
272	Diamotor	i 175 mm	2722	Print Speed	i 60 mm/s
Setting	Flow	4 100 M	Setting	Travel Speed	⊃ i 100 mm/s
-	Enable Petraction			Initial Layer Print Speed	⊃ i 20 mm/s
	Patraction Distance			Cooling	
	Retraction Sneed	<i>i</i> 70 mm/s		Enable Print Cooling	i 🖌
	Speed			Support	
	Print Speed	<i>i</i> 60 mm/s		Generate Support	i 🖌
	Travel Speed	i 100 mm/s		Support Placement	i Touching Y
	Initial Layer Print Speed	i 20 mm/s		Support Overhang Angle	<i>i</i> 50 °
	Cooling			Support Pattern	i Lines ~
	Enable Print Cooling	i 🖌		Bulld Plate Adhesion	
	Support			Build Plate Adhesion Type	🗅 i Brim 👻
	Generate Support	\mathfrak{D} i		Special Modes	
	Build Plate Adhesion			Print Sequence	i All at Once 👻
	e sterio de la le	to 2 Mana II		experimental	
Tronxy Slice		Please load a 3d model	Tronxy Slic	e	Please load a 3d model
			Lionay bire	~	

Some parameters are set for reference :

Layer thickness	:	0.1-0.3mm
Print temp	:	PLA - 200 °C ABS - 240 °C
Heatbed temp	:	PLA - 50°C ABS - 80 °C
Print speed	:	20-150mm/s (suggest 60mm/s)
Support	:	Choose according to the model
		structure
Platform support	:	It is recommended to use the
		model when the bottom contact is small

8. Failure cause analysis

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.

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.

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

- Check whether the print head temperature reach 200 °C above (PLA), led to filament cannot squeeze, waiting for the temperature rises to the set target.
- 2) Check whether the filaments are knotted, which leads to unsmooth feeding.
- 3) Check whether the filaments or pipes are not inserted in place, resulting in the failure of feeding.
- Check whether the temperature of the print head is too high, which leads to excessive softness of filaments and can't 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 the 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.

5. The model is not easy to take off

- 1) Try to heat the hot bed to 50-70 $^\circ\!\mathrm{C}$ take off it by the shovel .
- 2) It is recommended to buy TRONXY magnetic stickers.

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.

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.

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.

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

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

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

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

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

ONLY NEEDS 3 STEP TO FINISH THE REST INSTALLATION FILAMENT RUN-OUT DETECTION RESUME PRINT AFTER POWER-OFF AUTO LEVEL ALL METAL



New attack