TRONXY

User's manual

XY-3 PRO

Installation Manual

Attention

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

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

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

The machine contains high speed moving parts and high temperature parts. Children are not allowed to use the machine without permission

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

Turn off the power in the urgent situation

Do not refit or disassemble the core parts of the machine without permission

Relevant information is stored in SD card, please check

Directory

Service email ： Support@tronxy.com

Tronxy Support FaceBook

1. Machine parameters

Print parameters：

Print size	:	300*300*400mm
Print accuracy	:	0.1-0.3mm
Print principle	:	FDM（fused deposition molding）
Nozzle size	:	0.4mm
Nozzle quantity	:	1
Print speed	:	20-100mm/s（advise 60mm/s）
Position accuracy	:	X/Y -0.00625mm，Z – 0.00125mm
Filaments support	:	PLA、ABS、PETG、TPU

Temp parameters：

Print environment	:	8-40℃
Nozzle temp	:	275℃（MAX）

Power supply： AC 110/220V 50/60Hz DC 24V/360W

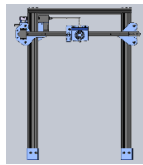
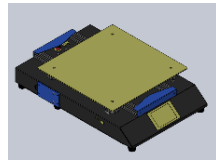
Software：

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

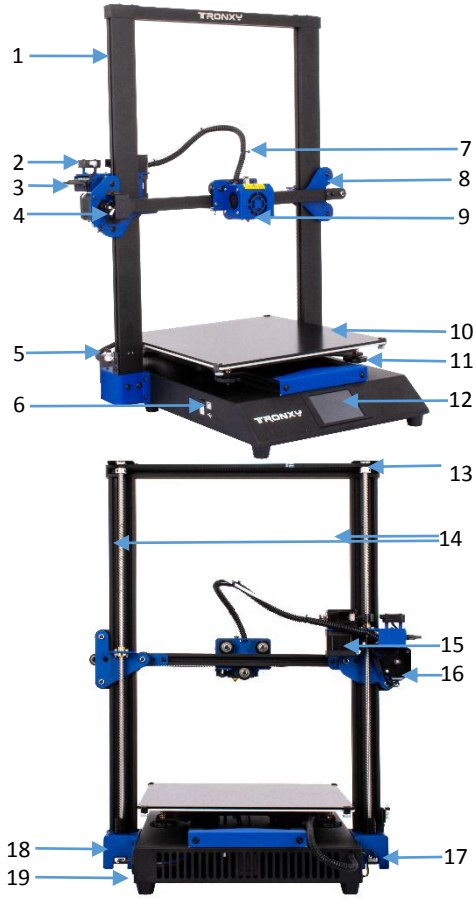
Machine parameters：

Machine size	:	485*482*643mm
Package size	:	700*540*210mm
Weight	:	≈11.5kg

2. Packing list

<table>
<tr><td colspan="2" rowspan="2">  </td><td>  </td><td>  </td></tr>
<tr><td>Upper bracket</td><td>Base</td></tr>
<tr><td colspan="2" rowspan="2">XY-3 PRO</td><td>  </td><td>  </td></tr>
<tr><td>Z stop</td><td>Filament bracket</td></tr>
<tr><td>  </td><td>  </td><td>  </td><td>  </td></tr>
<tr><td>Power line</td><td>USB cable</td><td>Reader （with SD card）</td><td>Shovel</td></tr>
<tr><td>  </td><td>  </td><td>  </td><td>  </td></tr>
<tr><td>Hot End</td><td>HM4*10 8PCS</td><td>Tools</td><td>10mPLA
（Color random）</td></tr>
<tr><td colspan="4">Notes ：Please check if all the items are included before installing the printer.
If you have any questions , please contact the customer service.</td></tr>
</table>

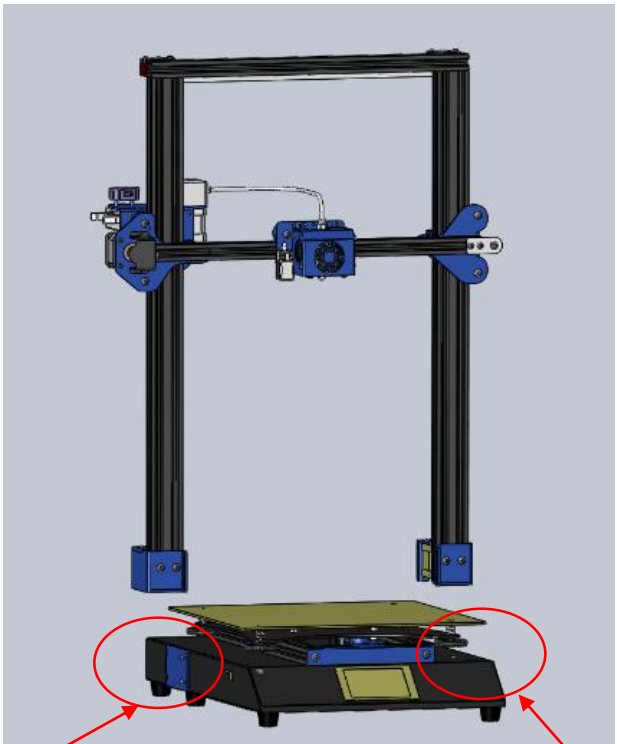
3、Machine Structure

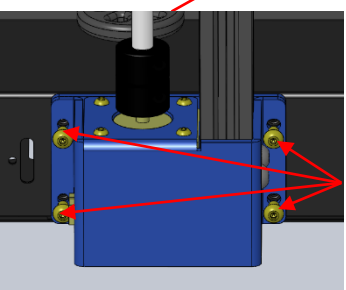


NO.	Part	NO.	Part	NO.	Part
1	Upper frame	8	Right sliding board	15	X axis motor
2	Filament sensor switch	9	Print head	16	Extruder motor
3	30P adapt board	10	Hotbed and Lattice Glass	17	Z1 motor
4	Left sliding board	11	Leveling nut	18	Z2 motor
5	Z limit switch	12	Touch screen	19	power switch
6	USB/SD card interface	13	synchronous belt		
7	Teflon tube	14	Z axis lead screw		

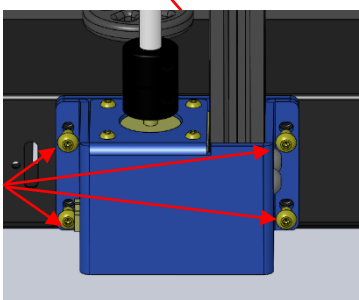
4. Installation

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

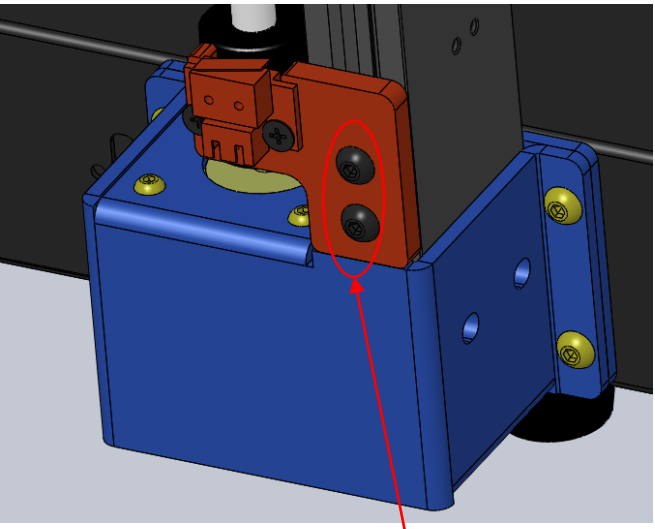




Use 8pcs M4*10 screws to lock the left and right motor part of above frame to the base.

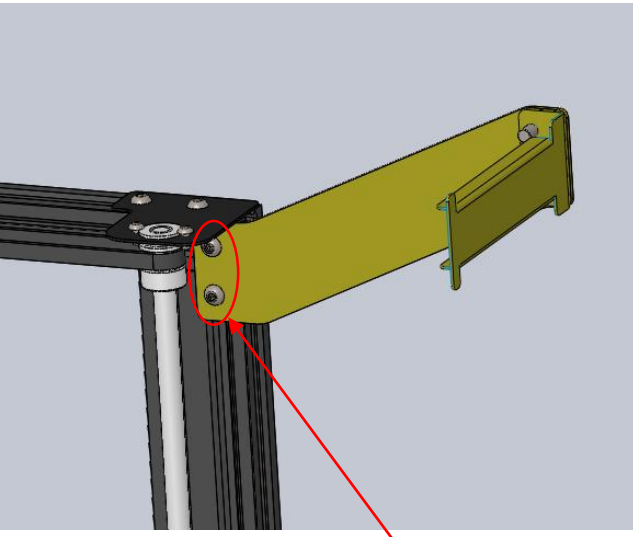


1



2

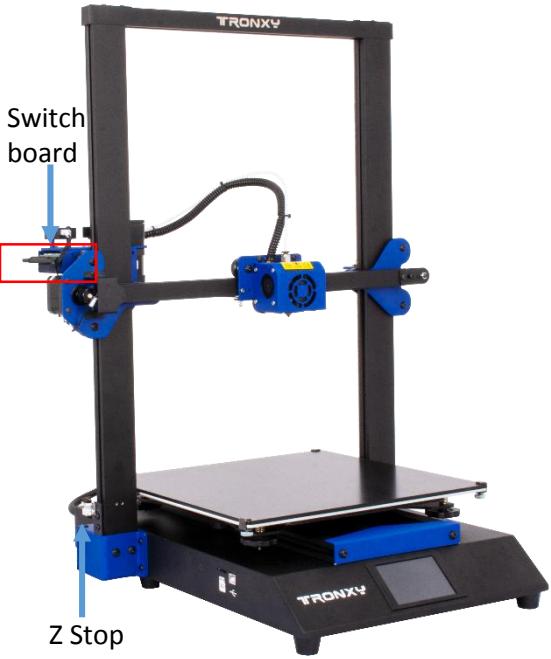
Use a hex wrench to tighten the boat nut to fix the Z stop on the aluminum extrusions of the Z axis

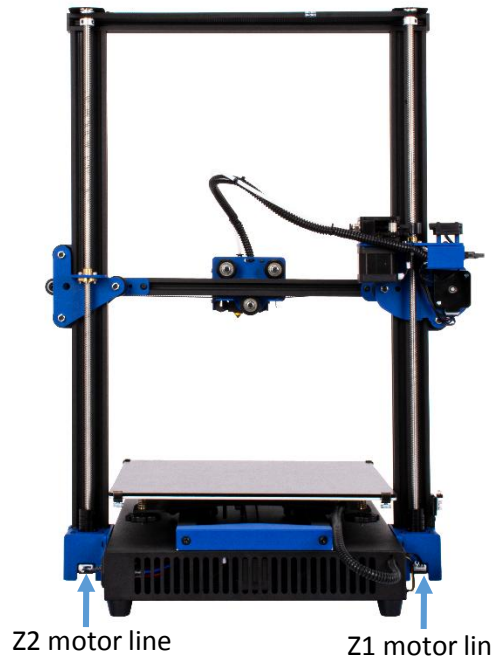


Use a hex wrench to tighten the boat nut to fix the filament holder on the aluminum extrusions of the upper frame

3

5. Wiring connection



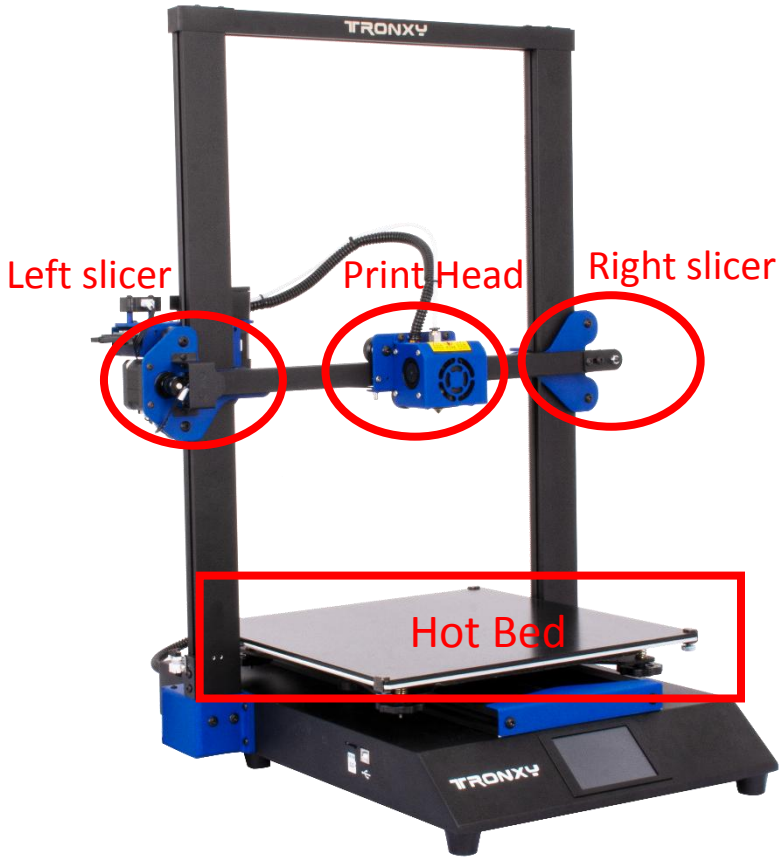


Switch line installation method:

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.

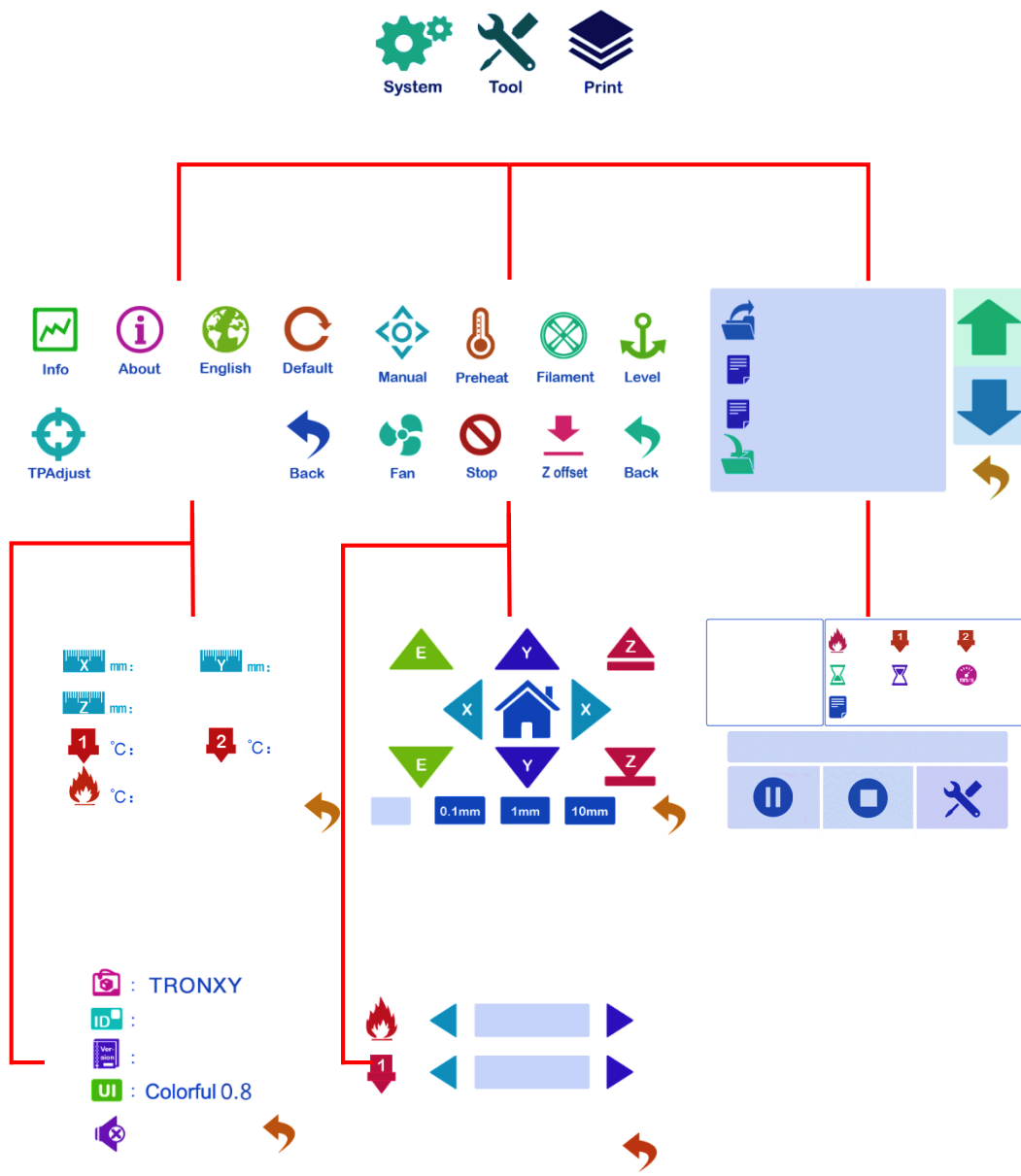
6. Structure debug

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).



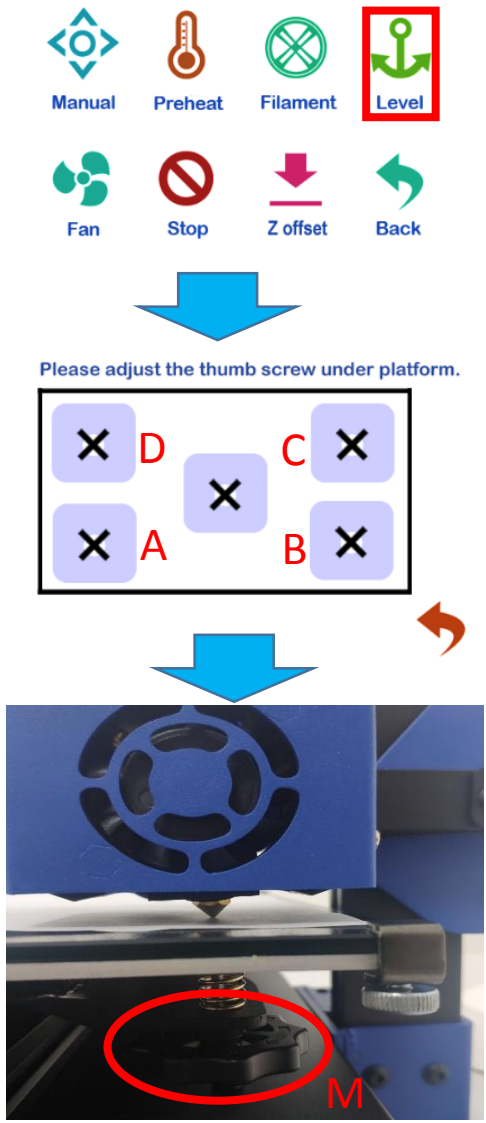
If the structure is loose in other places, you can tighten the screws directly.Before debugging, make sure the machine structure is in a stable and smooth state. You can slide the print head and platform module by hand to ensure smooth and stable sliding before leveling printing.

7. Operation & Print



Manual leveling：

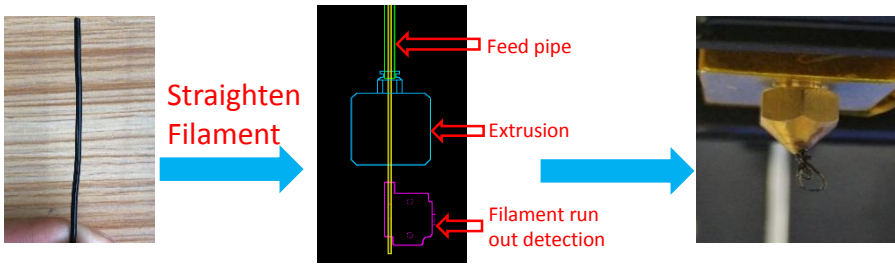
Click the four points of ABCD (see the picture), the print head will move to the corresponding position, and then adjust the leveling nut M, to ensure the space between the nozzle and the platform is a piece of A4 paper. After adjusting the four points in turn, it needs to be verified again. If the interval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



Load and unload filaments :

Click 

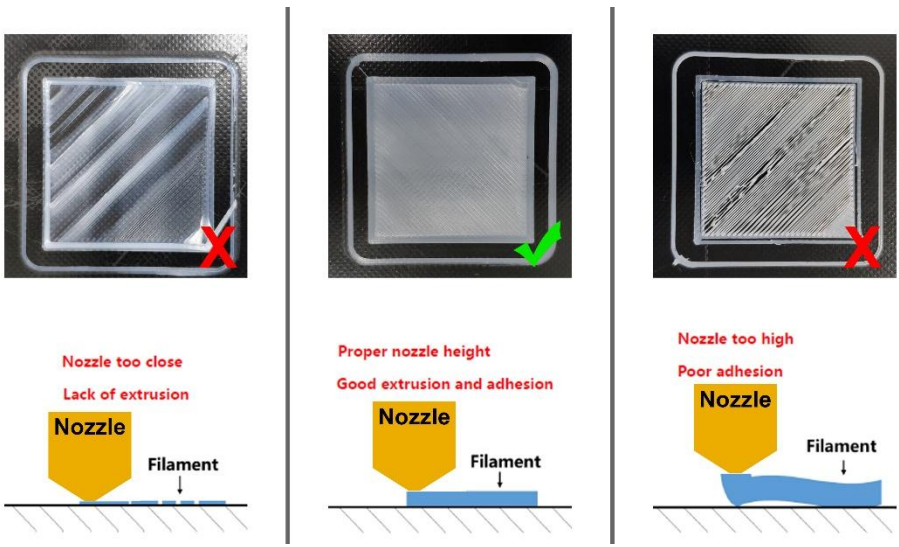
After waiting for temperature up to 180 ℃, filament go through from the filament detection, extruder and feed pipe to the nozzle until the filaments are squeezed , as the following picture shows :



Print test :

Click 

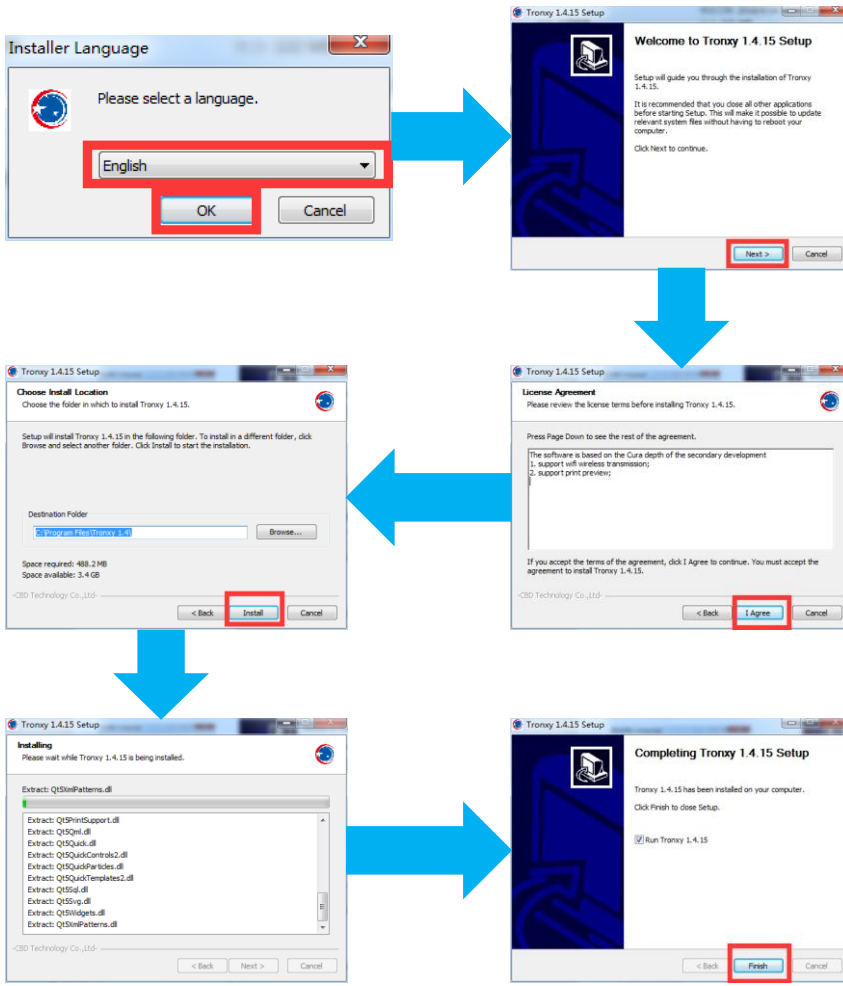
→"TEST FILE"→  Start printing



You can fine tune the leveling nut according to the first layer printing, so that the consumables can be completely attached to the lattice glass.

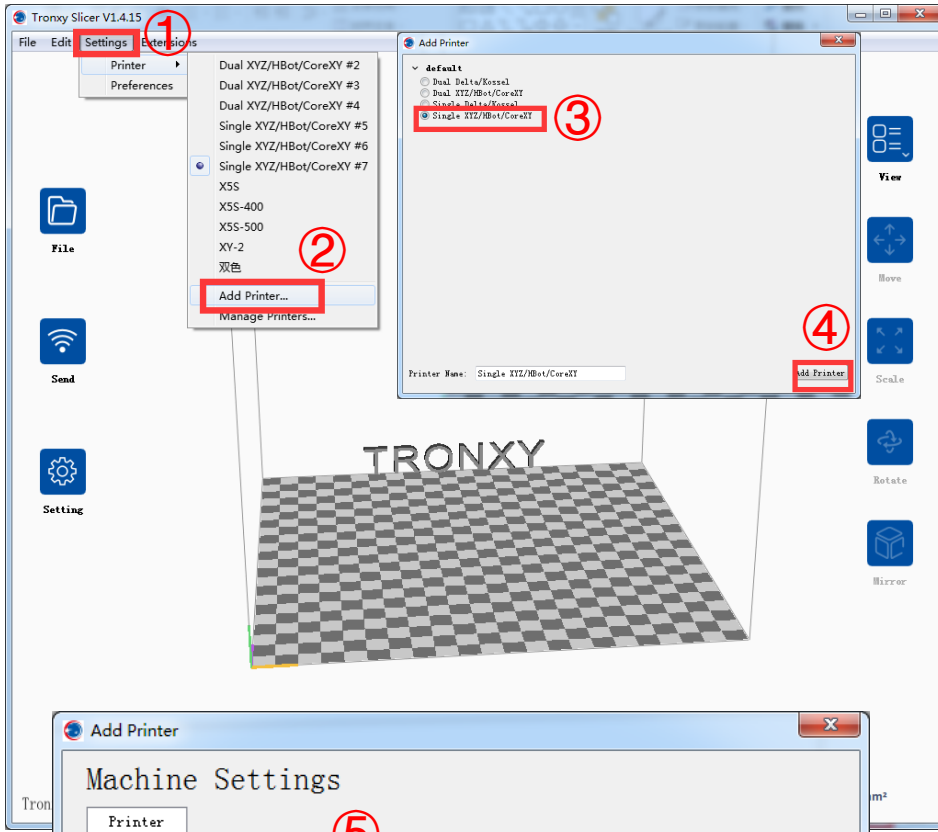
1. Installation

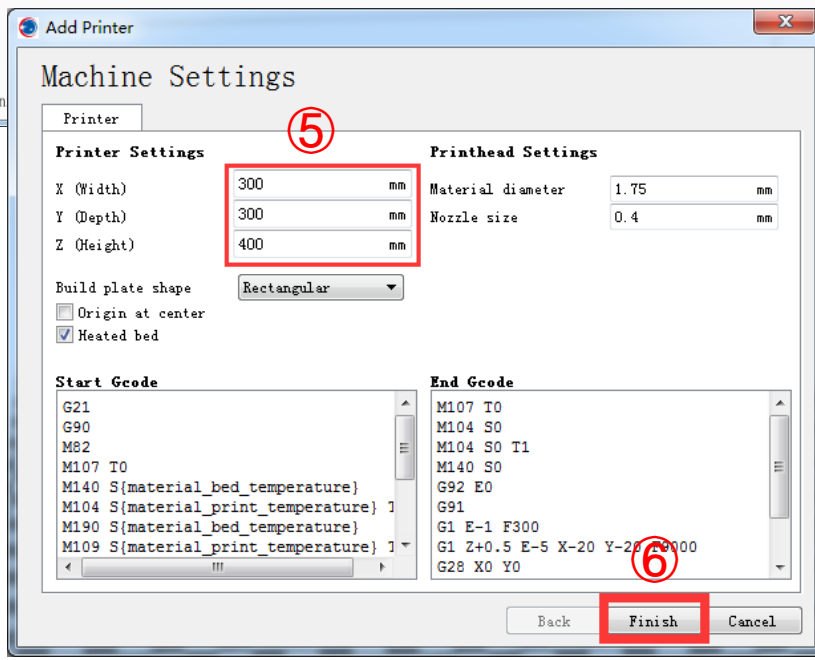
Find out slice software in SD card“TronxyInstall.exe ”click twice ，
Then follow these steps to complete the installation.



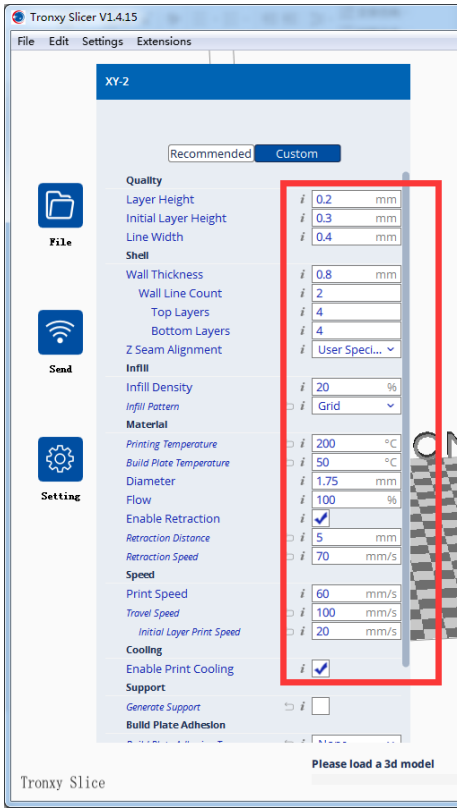
2. How to use slice software

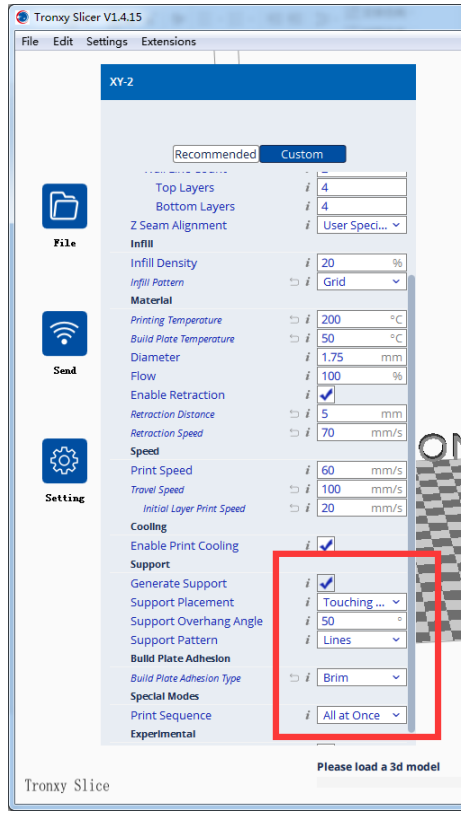
① Type setting: follow the steps below to complete the setting.





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





Some parameters are set for reference：

Layer thickness	：	0.1-0.3mm
Print temp	：	PLA - 200 ℃ ABS - 240 ℃
Heatbed temp	：	PLA - 50℃ ABS - 80 ℃
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.

1）Check whether the print head temperature reach 200 ℃ 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.
4）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 ℃ 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

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