PiKA3D PRO
User Manual

For the best user experience, please read this manual completely before usage.

www.PiKA3D.com

⚠ WARNINGS

🔥 - The Nozzle of the PiKA3D PRO can become hot. DO NOT touch the Nozzle, or you may be burned!
- DO NOT allow the Nozzle near or in contact with flammable materials.
- Inform others in the area that the Pen is hot and should not be touched.

⏻ Unplug and set the Control Switch to OFF when not in use or before storing.

Allow the Nozzle to cool completely before storing.

DO NOT use the PiKA3D PRO near bathtubs, showers, basins or other vessels containing water. This could result in death due to electric shock.

⚠ The PiKA3D PRO should only be used with ABS, PLA filament approved by PiKA3D. Misuse of your PiKA3D PRO, setting your pen to the wrong heating temperature, and/or use of non-approved plastics or other materials may result in damage to your pen or injury to you, and will void your warranty. Injuries to the user may include, but are not limited to, harm sustained from inhaling substances that are not suitable for heating; or burns from flammable materials used in the PiKA3D PRO.

⚠ This 3D Printing Device - when used with a styrene filament (ABS / HIPS / or PC-ABS) - can expose you and others in the same room to styrene, which is a chemical known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov. **ALWAYS OPERATE YOUR 3D PRINTING DEVICE IN A WELL-VENTILATED AREA.**

CARE & MAINTENANCE
For care and maintenance information, and more advice on how to use your PiKA3D PRO pen, please refer to our website: **PiKA3D.com**
To troubleshoot, please visit: **PiKA3D.com/troubleshooting**

SPECIFICATION OF POWER ADAPTER
Input: 100~240V AC, 0.5A MAX, 50-60Hz
Output: 5V, 2A

LIMITED WARRANTY
For more details on your limited warranty, please visit
PiKA3D.com/warranty
For PiKA3D Terms and Conditions and other notices refer to our website:
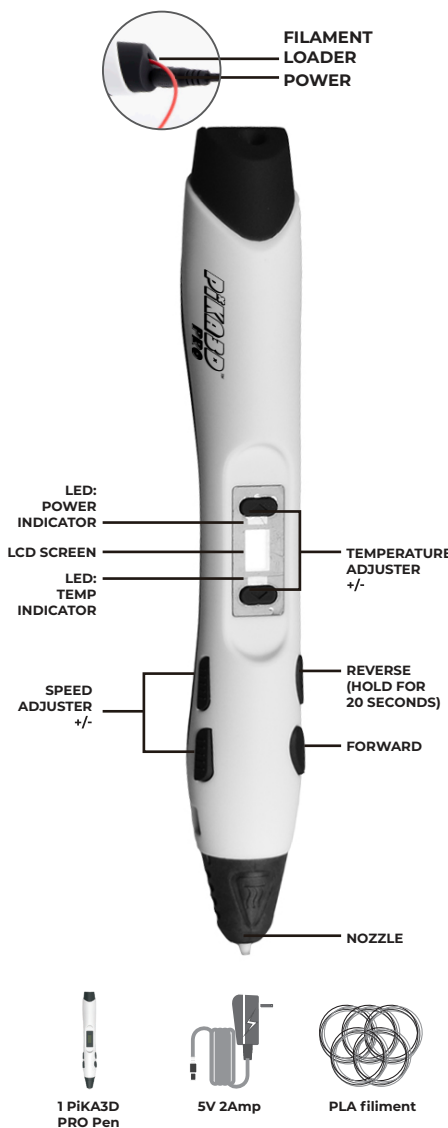**PiKA3D.com/terms-and-conditions**

AGES 14+ ONLY
KEEP OUT OF REACH OF CHILDREN.

🗑 The symbol indicates that the product should not be discarded as unsorted waste but must be sent to separate collection facilities for recovery and recycling. The WEEE marking must appear on any electrical and electronic equipment placed on the EU market.

RoHS FC C E ♻

Product Overview

FILAMENT LOADER
POWER

LED: POWER INDICATOR
LCD SCREEN
LED: TEMP INDICATOR

TEMPERATURE ADJUSTER +/-

SPEED ADJUSTER +/-

REVERSE (HOLD FOR 20 SECONDS)

FORWARD

NOZZLE

1 PiKA3D PRO Pen   5V 2Amp   PLA filiment

Getting Started

1. Power On
Plug the USB power cord into the power adapter and connect it to an outlet. Plug the other end of the power cord into your pen. (Note: this 3D Pen can be used with a 3rd party power bank with at least 2 Amps output)

2. Select the Filament
"ABS" or "PLA" will show on the LCD SCREEN, you can use the temperature ADJUSTER buttons to select a mode. Choose a mode that corresponds with the type of plastic you are using. (Note: Using the wrong plastic will make for a poor experience and possibly damage your pen)
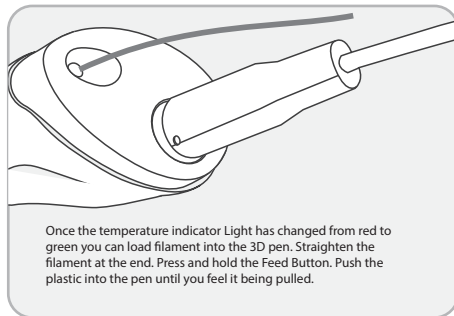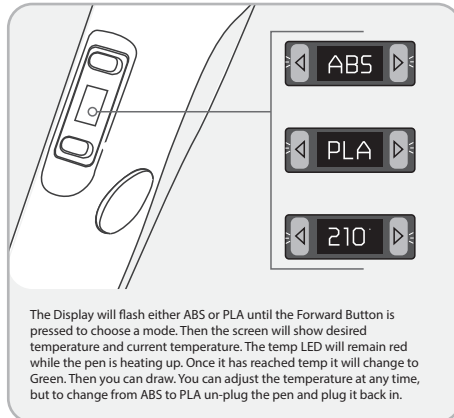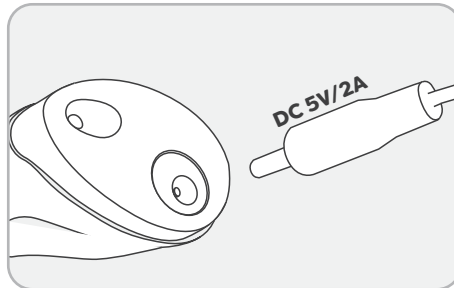
3. Temperature Settings
Press the FORWARD button to activate the selected mode. You can use the TEMPERATURE ADJUSTER buttons to fine tune the temperature depending on need and desired usage. The temperature ranges are ABS: 180-210°C and PLA: 160-180°C.
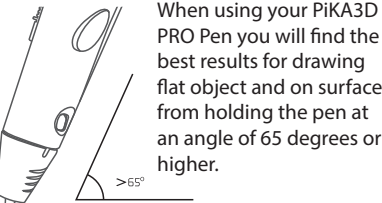
4. Filament Loading & Drawing in 3D
Once the desired temperature has been reached the LED on the pen will turn green. You can click the FORWARD button. Straighten the end of the filament you wish to use and load it into the FILAMENT LOADER while the pen is running. Once plastic starts extruding you are ready to start creating in 3D!

5. Changing Colors
To change colors, press and hold the REVERSE button for 5 seconds. The filament will automatically start to retract out of the back of the pen.

DC 5V/2A

◁ ABS ▷
◁ PLA ▷
◁ 210 ▷

The Display will flash either ABS or PLA until the Forward Button is pressed to choose a mode. Then the screen will show desired temperature and current temperature. The temp LED will remain red while the pen is heating up. Once it has reached temp it will change to Green. Then you can draw. You can adjust the temperature at any time, but to change from ABS to PLA un-plug the pen and plug it back in.

Once the temperature indicator Light has changed from red to green you can load filament into the 3D pen. Straighten the filament at the end. Press and hold the Feed Button. Push the plastic into the pen until you feel it being pulled.

Tips

★ When using your PiKA3D PRO Pen you will find the best results for drawing flat object and on surface from holding the pen at an angle of 65 degrees or higher.

>65°
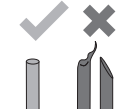
★ Make sure the tip of your filament is flat before loading it into the pen.

✓ ✗

★ Filament quality varies greatly. We recommend using PiKA3D filament, and storing it in a cool, dark, dry place.

★ Plastic may continue to ooze slightly after the pen stops. This is more pronounced with PLA. This is common and normal. You can slightly decrease the temperature of your pen to reduce the oozing.

Temperature Tuning

1. If when using the pen you see the plastic bubbling or you hear a crackling noise coming from the plastic your temperature might be too high. Try lowering it 5~10°C and see if that helps.

2. Filament should come out smooth and with out much bubbling but it is normal to have some small bubbling.

3. While some plastics like PLA are more prone to oozing, if you find that your oozing a lot of plastic you can turn the tempiture down on the pen to help mitigate this. Also check that you are using the correct filament setting

4. If the filament color looks dim and dark and you can hear the motor struggling. This means the temperature is too low increase the temperature by 5~10°C.
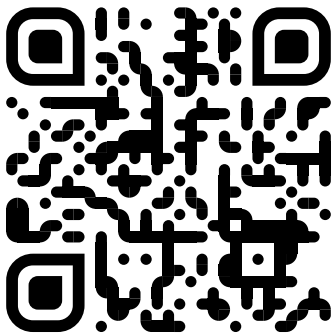
For more getting started tips and tricks, please visit our website www.PiKA3D.com or scan the QR code to visit our YouTube Channel.

Troubleshooting

Here are some common problems and possible solutions to these issue. If you can't resolve the issue let us see if we can help. Email Help@PiKA3D.com.

Problem	Reasons	Solution
Power indicator Light will not turn on	Issue with the AC adapter or plug	Replace the AC adapter with another: 5v, 2A, 3.8mm barrel center + adapter
	Issue with the electronics of the pen	The pen's electronics need servicing please contact help@PiKA3D.com if the pen is under warranty
	Issue with the power socket of the pen	
Red and Green indicator light flashing	Low-power adaptor or power bank	Change power bank or adaptor to one that has a 2 Amp output
Nothing is coming out of the nozzle	The temperature is not high enough or the wrong mode for plastic was selected	Check the mode the pen is in matches the filament type you are using. You can also try adjusting the temp manually
	Filament has stripped ie. a chunk has been taken out of the filament and the drive system can't push it anymore	Reverse the filament out of the pen. Cut of the damaged portion and throw it away and try again
	Filament won't go in	Make sure the filament has a flat surface on the end going into the pen
	No motor noise	Possible issue with the electronics or the motor please contact us at help@PiKA3D.com
Pen not heating up	Probem with the heating element/nozzle	Replace the nozzle. Email help@PiKA3D.com
Motor is struggling	Could be an issue with the filament inside	Reverse out the filament. Cut off any swollen or deformed parts and cut a new end before reinserting.
"ERR" displayed on the screen	Temperature is too high for the mode yo arer in / or the nozzle is loose	Unplug the pen and let it pen cool down for approximately 3 mins / or try to push the nozzle back into place. If issue persists, reach out to customer service: help@PiKA3D.com

NOTE: Your pen will go into sleep mode after being inactive for 5 minuts (as a safety feature). Click any button to wake it up and restart the heating sequence.

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ISSUES?

Before returning to the retailer see if we can help

▶ Check out our tutorials:
PiKA3D.com/troubleshooting

Need more help? Contact us
help@PiKA3D.com