



# Creator Max 3D Printer



—— User's Manual ——

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# Safety Warnings & Guidelines

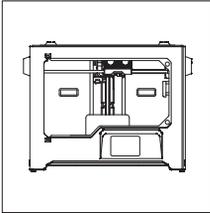
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Please read this entire manual before using this device, paying extra attention to these safety warnings and guidelines. Please keep this manual in a safe place for future reference.

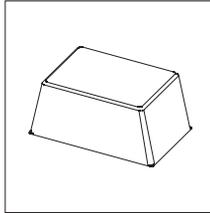
- Take care to avoid touching hot parts, including heat blocks, extruder nozzles, build plate, and the extruded filament.
- Do not wear gloves when operating or repairing to avoid entanglement.
- Keep the printer and all accessories out of reach of children.
- Do not remove or disconnect the USB cable when printing from a computer.
- Do not force or tear anything during unpacking and setup. This may cause damage to the printer and/or its accessories.
- Do not reach inside the printer during operation.
- Always allow the printer and extruded filament to cool before reaching inside.
- Ensure that the printer is turned off and unplugged from its power source before making repairs or performing service.
- Do not install this device on an unstable surface where it could fall and cause either personal injury or damage to the device and/or other equipment.
- Do not subject the product to extreme force, shock, or fluctuations in temperature or humidity.
- This device is intended for indoor use only.
- Do not expose this device to water or moisture of any kind. Do not place drinks or other containers with moisture on or near the device. If moisture does get in or on the device, immediately unplug it from the power outlet and allow it to fully dry before reapplying power.
- Do not touch the device, the power cord, or any other connected cables with wet hands.
- Use only in a well-ventilated area. Do not use in close, confined spaces.
- Prior to operation, check the unit and power cord for physical damage. Do not use if physical damage has occurred.
- Before plugging the unit into a power outlet, ensure that the outlet provides the same type and level of power required by the device.
- Unplug this device from the power source when not in use.
- Take care to prevent damage to the power cord. Do not allow it to become crimped, pinched, walked on, or become tangled with other cords. Ensure that the power cord does not present a tripping hazard.
- Never unplug the unit by pulling on the power cord. Always grasp the connector head or adapter body.

# Package Contents

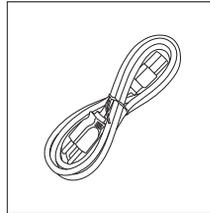
Please take an inventory of the package contents to ensure you have all the items listed below. If anything is missing or damaged, please contact Customer Service for a replacement.



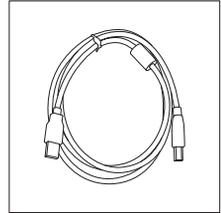
3D Printer



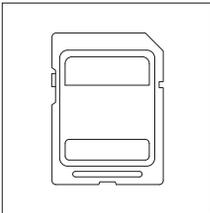
Lid



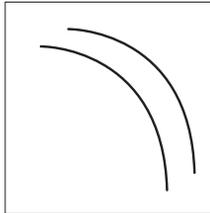
Power Cable



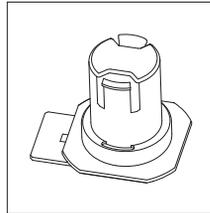
USB Cable



SD Card



Filament Guide Tube x 2



Spool Holder x 2



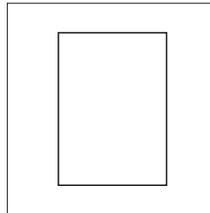
Build Tape x 2



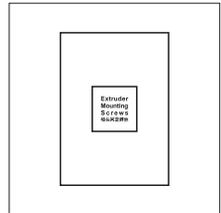
User's Manual



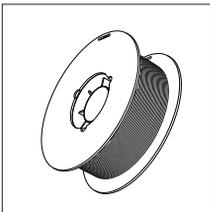
Leveling Card



Tool Bag



Extruder's Accessory Kit



1kg Red PLA Filament

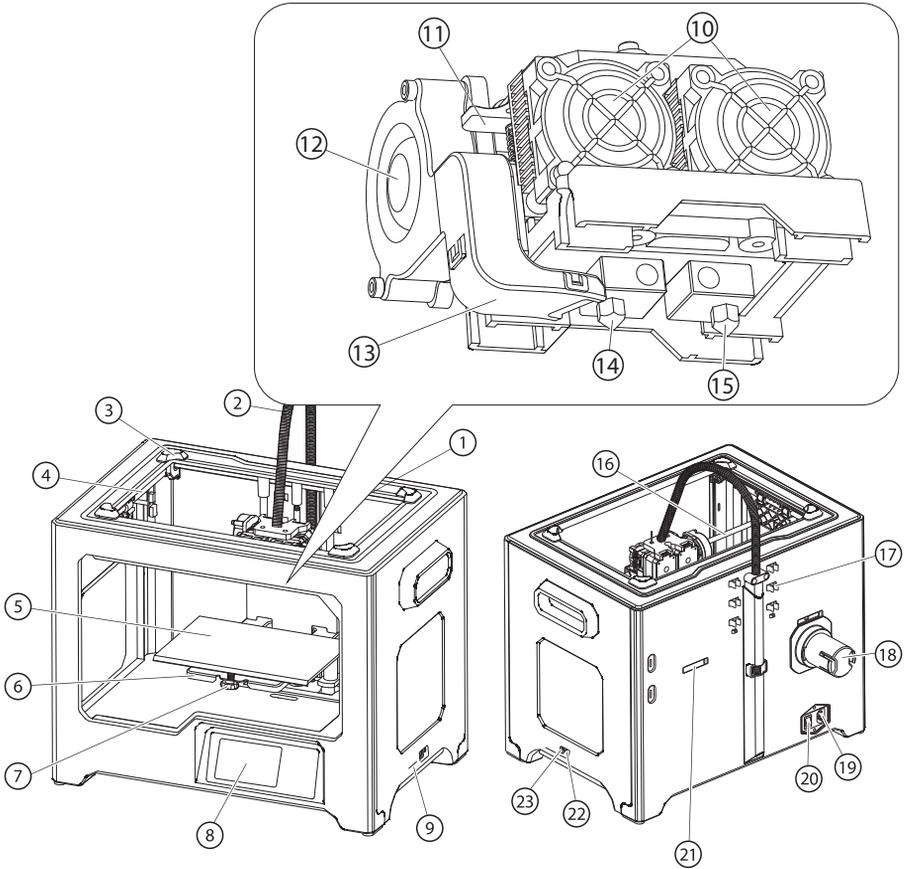
## Tool bag:

(Allen Wrench X 2 / Leveling knob X 1 / M3X8 Bolt X 2 / PTFE Tube X 2 / Grease X 1)

## Extruder's accessory kit:

(M3X8 Bolt X 2 / M3X6 Bolt / Turbofan baffle)

# Product Overview



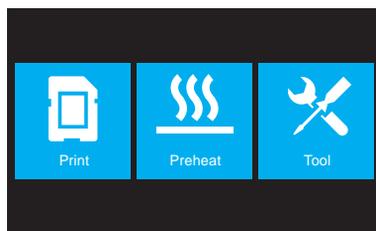
- |                                |                         |                    |                      |
|--------------------------------|-------------------------|--------------------|----------------------|
| 1. Z-Axis Guide Rod            | 2. Extruder Cable Bunch | 3. Slot            | 4. Y-Axis Guide Rod  |
| 5. Build Plate                 | 6. Build Platform       | 7. Leveling Knob   | 8. Touch Screen      |
| 9. SD Card Slot                | 10. Cooling Fan         | 11. Spring Presser | 12. Turbofan         |
| 13. Turbofan Baffle            | 14. Left Nozzle         | 15. Right Nozzle   | 16. X-Axis Guide Rod |
| 17. Filament Guide Tube Buckle | 18. Spool Holder        | 19. Power Input    | 20. Power Switch     |
| 21. Spool Holder Slot          | 22. Reset Button        | 23. USB Input      |                      |

## Main Menu System

### Top Menu

The Top Menu is displayed after the printer is powered on and initialized.

- Touch the Print button to enter the Print Menu.
- Touch the Preheat button to enter the Preheat Menu.
- Touch the Tools button to enter the Tools Menu.



### Print Menu

The Print Menu is displayed by touching the Print button from the Top Menu.

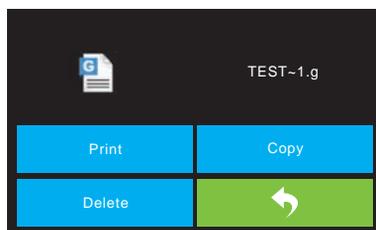
- Touch the Internal Memory button to read the print file from internal memory.
- Touch the SD™ Card button to read the print file from the SD card.
- Touch the Back button to return to the previous menu.



### Print File Screen

The Print File Screen is displayed after selecting a print file from internal memory or the SD™ card. The print filename is displayed.

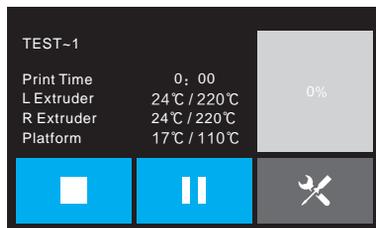
- Touch the File icon to display a list of available model files.
- Touch the Print button to begin printing the loaded print file.
- Touch the Copy button to copy the loaded print file.
- Touch the Delete button to delete the loaded print file.
- Touch the Back button to return to the previous menu.



### Print Progress Screen

The Print Progress Screen is displayed while printing is in progress. It shows the print filename, the actual and target temperatures, and the print progress with the remaining time displayed.

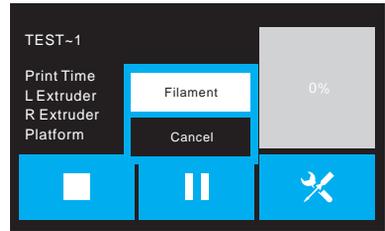
- Touch the Stop button to cancel the print in progress.
- Touch the Pause button to pause the print. Touch the Resume button to resume printing.
- Touch the Tools button to display the Print Tools Menu.



## Print Tools Menu

The Print Tools Menu is displayed by touching the Tools button on the Print Progress Screen.

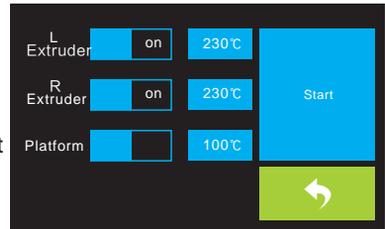
- Touch the Filament button to change filament during printing. Note that the print must be paused first.
- Touch the Camera button to turn the camera on or off.
- Touch the Cancel button to return to the Print Progress Screen.



## Preheat Menu

The Preheat Menu is displayed by touching the Preheat button on the Top Menu.

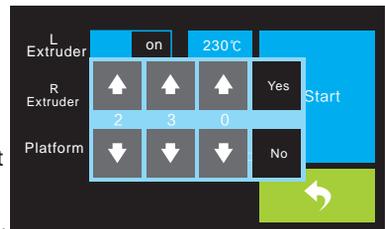
- Touch the slider buttons to turn extruder and platform heating on or off.
- Touch the target temperature buttons to set the preheat temperature. The default target print temperature for the extruders is 230°C and 100°C for the platform.
- Touch the Start button to start preheating the extruder(s) and/or platform.
- Touch the Back button to return to the previous menu.



## Preheat Temperature Screen

The Preheat Menu is displayed by touching the Preheat button on the Top Menu.

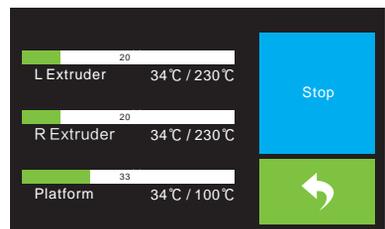
- Touch the slider buttons to turn extruder and platform heating on or off.
- Touch the target temperature buttons to set the preheat temperature. The default target print temperature for the extruders is 230°C and 100°C for the platform.
- Touch the Start button to start preheating the extruder(s) and/or platform.
- Touch the Back button to return to the previous menu.



## Preheating Screen

The Preheating Screen is displayed during the preheating process. It displays the preheating progress, as well as the actual and target temperatures of each element.

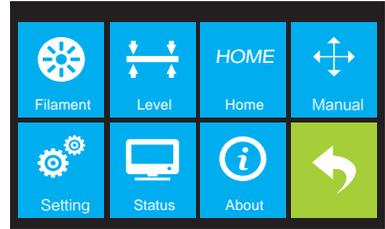
- Touch the Stop button to abort the preheating process.
- Touch the Back button to return to the previous menu.



## Tool Menu

The Tool Menu is displayed by touching the Tool button on the Top Menu.

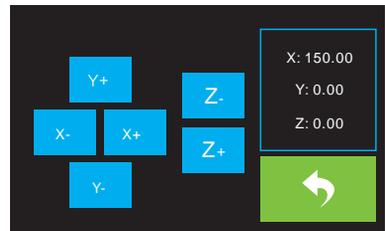
- Touch the Filament button to load or unload filament.
- Touch the Level button to level the build plate.
- Touch the Home button to move the extruder to the home position.
- Touch the Manual button to display the Manual Adjustment Screen.
- Touch the Setting button to display the Setting Menu.
- Touch the Status button to display the Printer Status Screen.
- Touch the About button to display About Screen.
- Touch the Back button to return to the previous menu.



## Manual Adjustment Screen

The Manual Adjustment Screen displays the X and Y positions of the extruder and the Z position of the build plate.

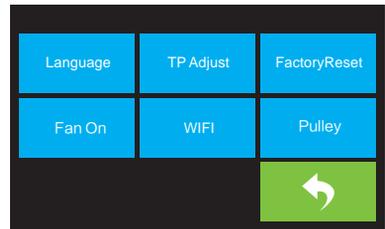
- Touch the X+ button to move the extruder to the right.
- Touch the X- button to move the extruder to the left.
- Touch the Y+ button to move the extruder towards the back of the printer.
- Touch the Y- button to move the extruder towards the front of the printer.
- Touch the Z+ button to raise the build plate.
- Touch the Z- button to lower the build plate.
- Touch the Back button to return to the previous menu.



## Setting Menu

The Setting Menu is displayed by touching the Setting button on the Tool Menu.

- Touch the Language button to select the language for the OSD Menu System.
- Touch the Fan button to turn the fan on or off.
- Touch the TP Adjust to recalibrate screen.
- Touch the WIFI button to display the WIFI Screen.
- Touch the Factory Reset button to reset the printer's settings to their factory default values.
- Touch the Update button to update the printer's firmware.
- Touch the Pulley button to display the Pulley Type Selection Screen.
- Touch the Back button to return to the previous menu.



## Language Menu

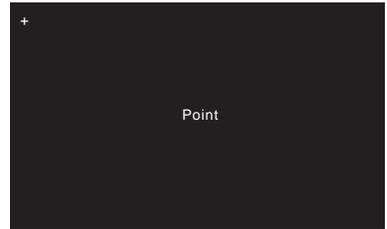
The Language Menu is displayed by touching the Language button in the Setting Menu.

- Touch the specific language name to set the OSD menu system to use that language.
- Touch the Down button to display the next page of languages.
- Touch the Up button (not displayed) to display the previous page of languages.
- Touch the Back button to return to the previous screen.



## TP Adjust

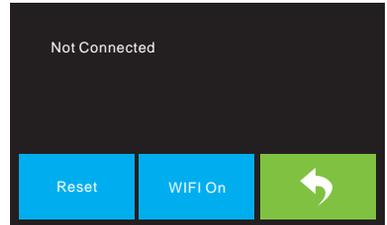
The TP Adjust is displayed by touching four point showed in the screen to recalibrate screen. It just follow and touch the plus sign.



## WIFI Screen

The WIFI Screen is displayed by touching the WIFI button on the Setting Menu.

- Touch the Reset button to reset the Wi-Fi® radio.
- Touch the WIFI On button to turn the Wi-Fi radio on, release the Wi-Fi hotspot, and set the Wi-Fi on the computer.
- Touch the Back button to return to the previous menu.



## Pulley Type Selection Screen

The Pulley Type Selection Screen is displayed by touching the Pulley button on the Setting Menu.

- Touch the Down Arrow next to the currently selected pulley type to display a list of available pulley types.
- Touch the name of a pulley type to select it.
- Touch the Yes button to save changes to the selected pulley type.
- Touch the Cancel button to abort any changes to the selected pulley type.



## Status Screen

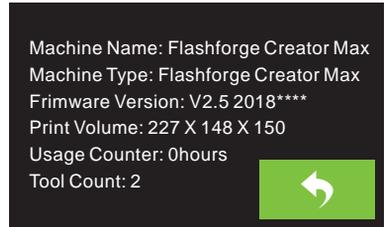
The Status Screen is displayed by touching the Status button on the Tool Menu. It displays the real-time status of the printer.

- Touch the Back button to return to the previous menu.

## About Screen

The About Screen is displayed by touching the About button on the Tool Menu. It displays basic information about the printer.

- Touch the Back button to return to the previous menu.



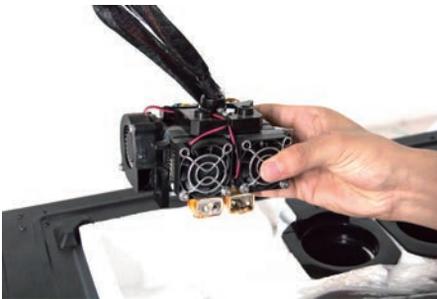
# Unpacking



1. Place the box on a flat, clean work surface. After opening the box, you can find two filament guide tubes, two Build Tape, a Leveling Card, and this User's Manual.



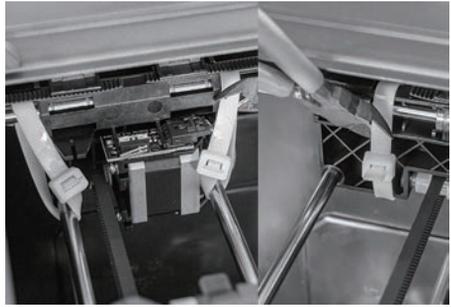
2. Firmly grasp the two side handles, lift it out from the carton and place it on a stable surface.



4. Take the dual extruder out and place the extruder carefully because the extruder cable bunch is short.



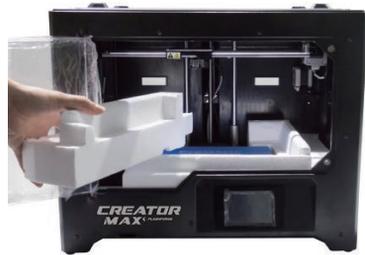
5. Remove the foam container. It should contain: power cable, USB cable, two spool holders, SD card, tool bag, extruder's accessory kit, one 1kg red pla filament.



6. Snip beltings on both sides of X-axis guide rod.



7. Remove lid.



8. Remove side protective foam sheets from inside the printer.



9. Elevate the build plate to its limit with care.



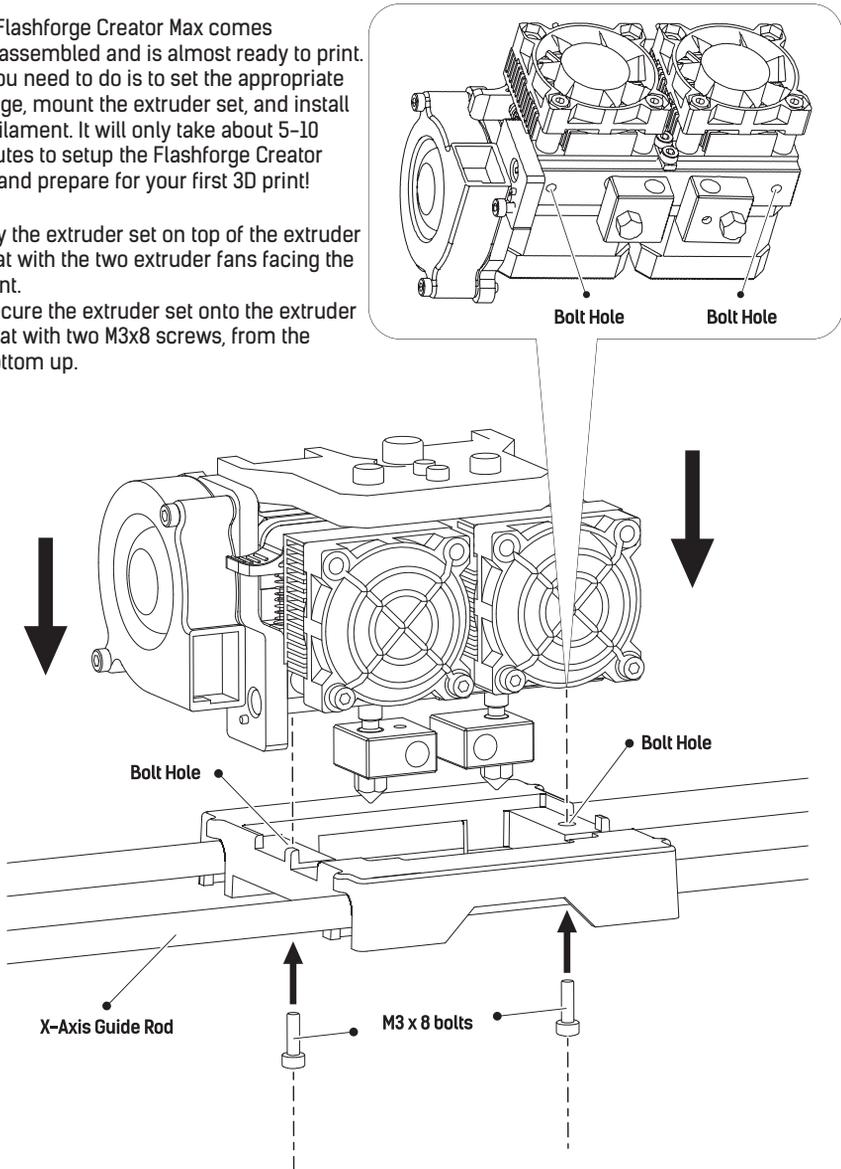
10. Take the bottom protective foam from the printer and then lower the build plate back.

Congratulations, you have finished unpacking your 3D printer!

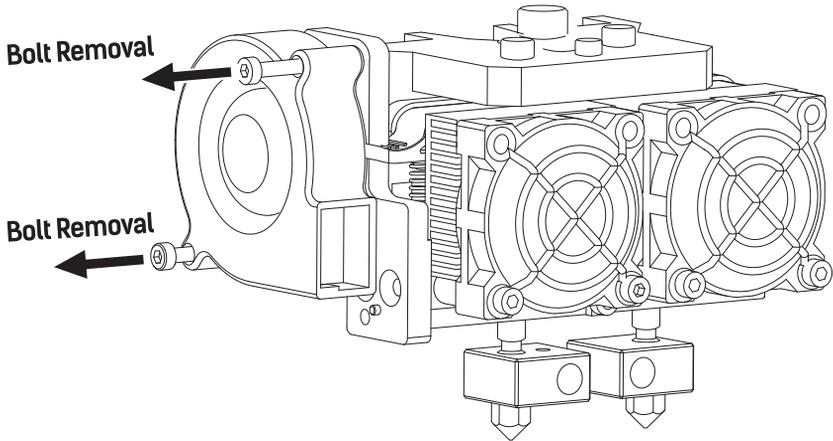
# Hardware Assembly

The Flashforge Creator Max comes pre-assembled and is almost ready to print. All you need to do is to set the appropriate voltage, mount the extruder set, and install the filament. It will only take about 5-10 minutes to setup the Flashforge Creator Max and prepare for your first 3D print!

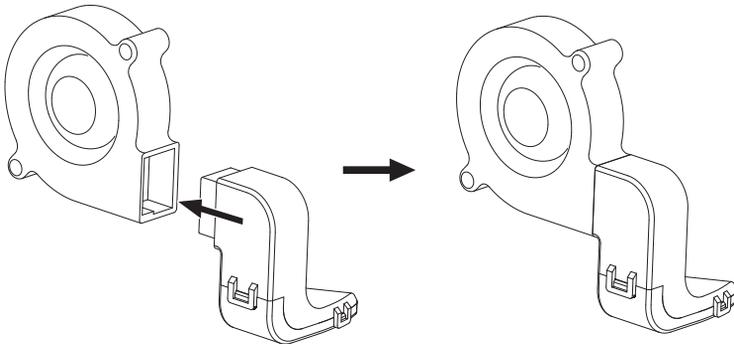
1. Lay the extruder set on top of the extruder seat with the two extruder fans facing the front.
2. Secure the extruder set onto the extruder seat with two M3x8 screws, from the bottom up.



## Turbofan Baffle Assembly

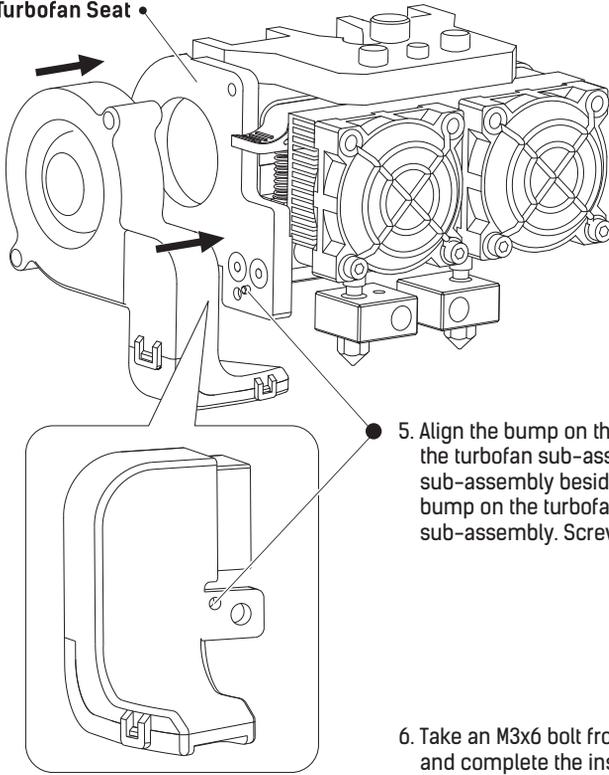


3. Use the M2.5 Allen wrench to unscrew the two turbofan bolts.

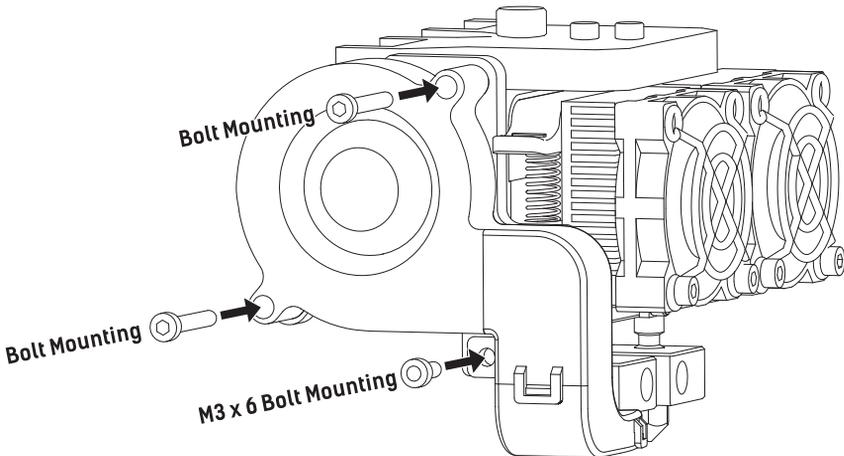


4. Take the turbofan baffle from the extruder's accessory kit and install it onto the turbofan.

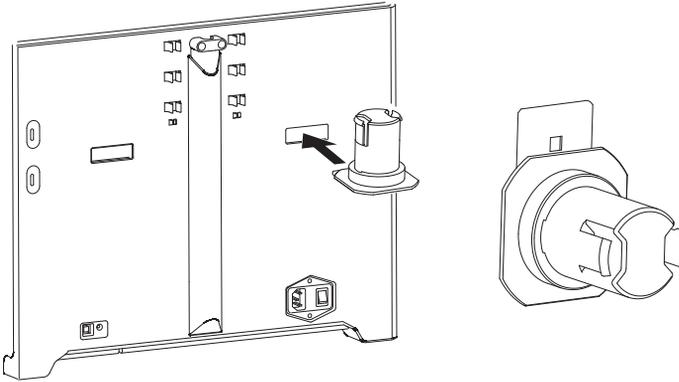
**Turbofan Seat**



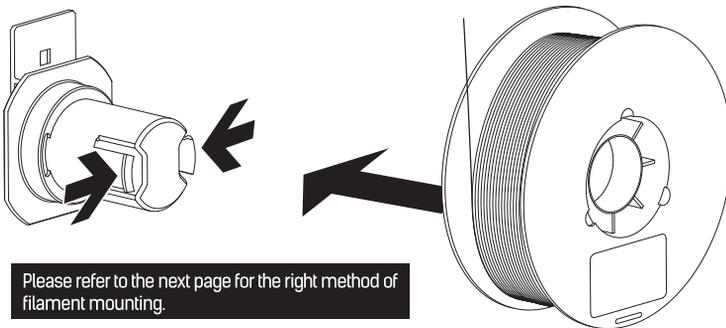
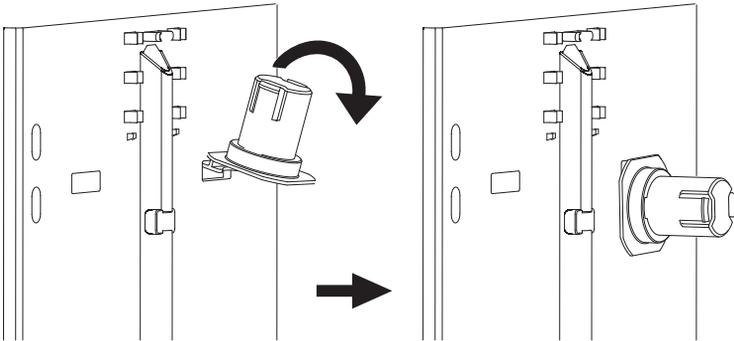
6. Take an M3x6 bolt from the extruder's accessory kit and complete the installation.



7. The next step goes to the installation of the spool holders. Install one on each side. To install a spool holder, level it and insert the end into one of the openings.

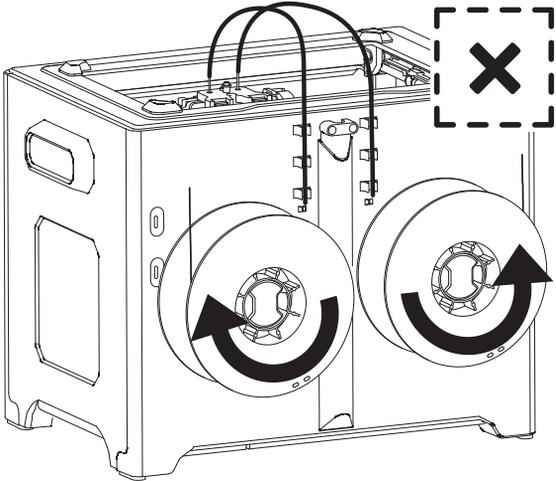
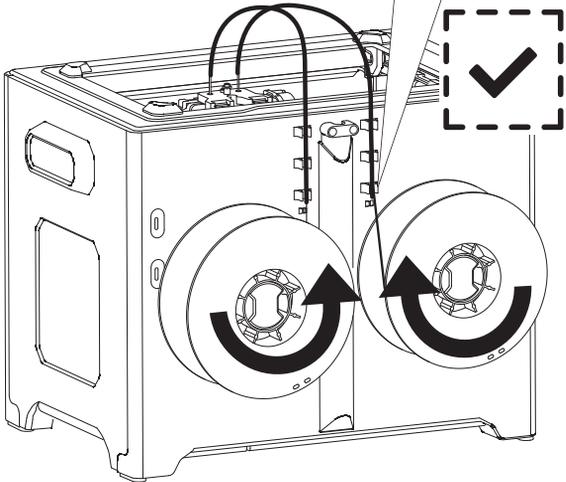
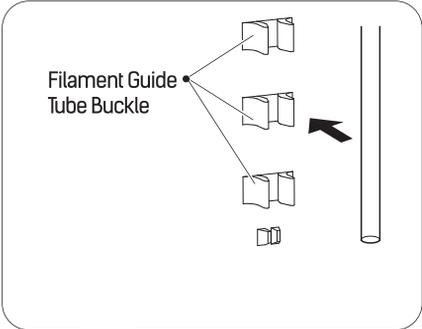


8. Turn down the spool holder to make the holder bottom cleave to the printer back.

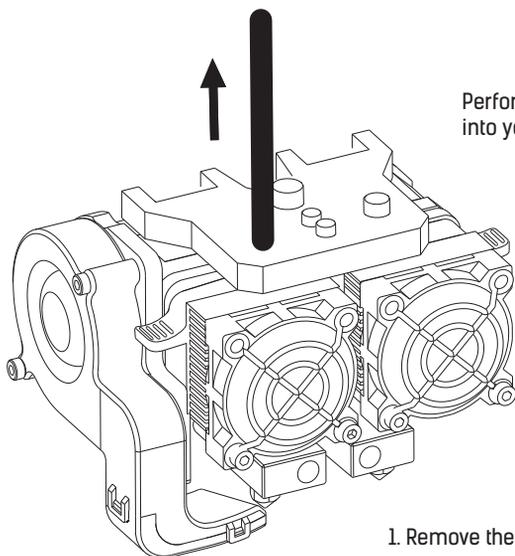


Please refer to the next page for the right method of filament mounting.

9. To lock the filament guide tube with R-shape buckles and insert another end to the filament intake. To avoid filament jams, always ensure that any filament spool you mount on the p feeds from the bottom of the spool toward the top. Filament mounted on the right spool holder when viewed from the back should always unspool clockwise and filament loaded onto the left spool holder should always unspool counterclockwise.

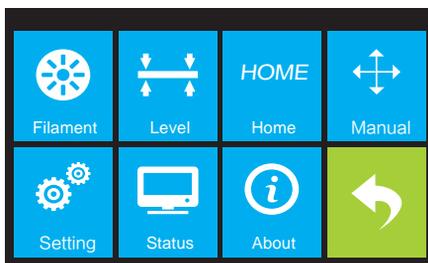
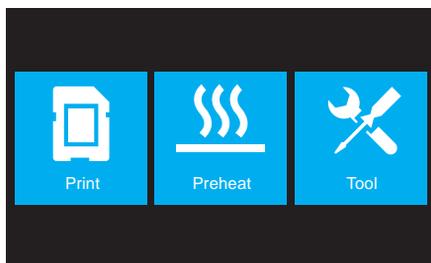


# Loading Filament

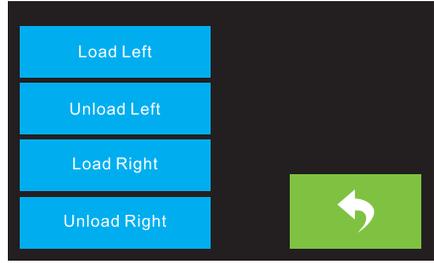
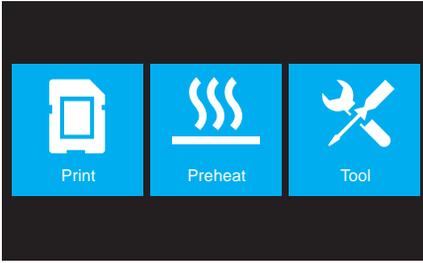


Perform the following steps to load filament into your 3D printer.

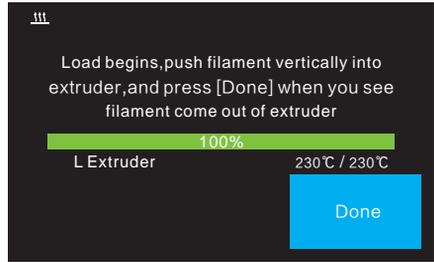
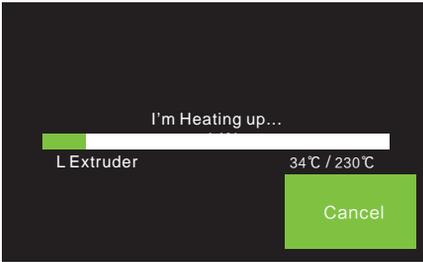
1. Remove the filament guide tube from the extruder.



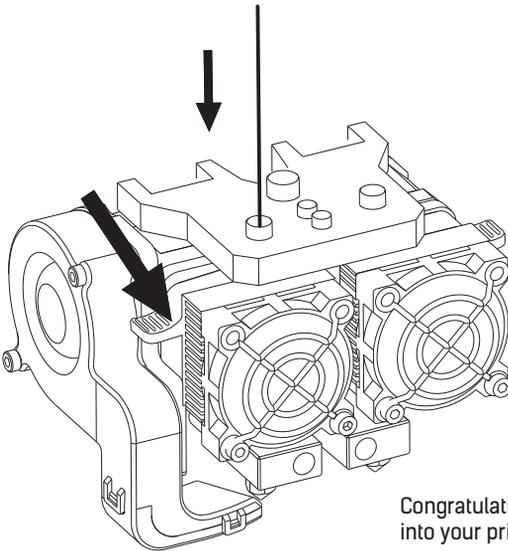
2. If it is not already powered on, flip the power switch to the ON position. Wait for the system to stabilize, then touch the **Tool** button on the **Top Menu**.



3. Touch the Filament button, then touch the Load Left button.



4. Wait for the extruder to heat up to the target temperature. The extruder will alert you when it is at the target temperature.



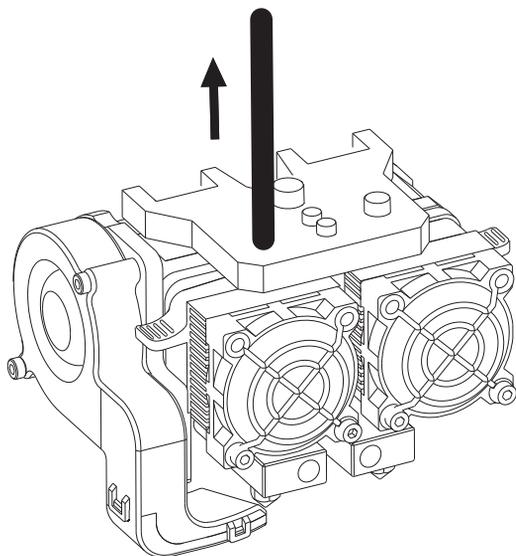
5. Load the filament by inserting it into the extruder at an upright angle. Filament will start to extrude out of the nozzle. Continue loading to ensure that the filament is extruding in a straight line. Refer to the troubleshooting section if the filament is extruding abnormally.

Touch the Done button to finish loading.

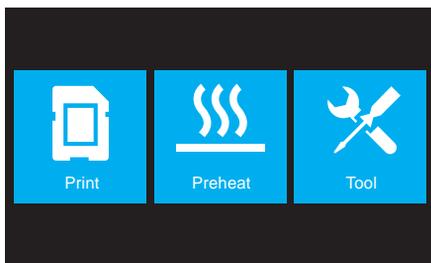
Congratulations, you have successfully loaded filament into your printer!

# Unloading Filament

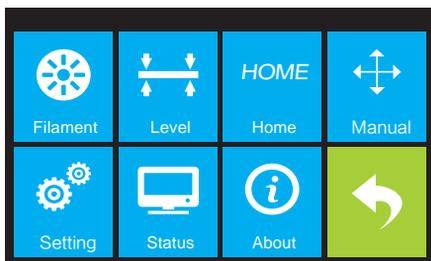
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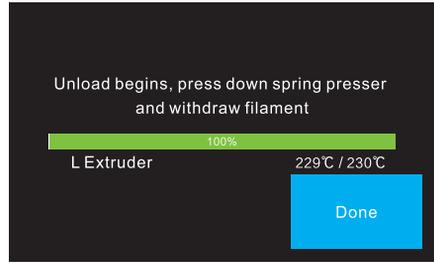
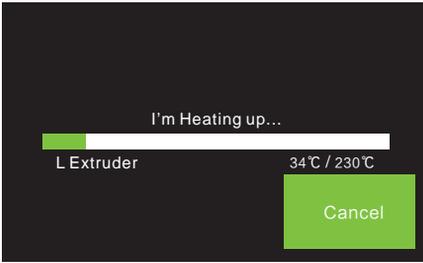
1. Remove the tube.



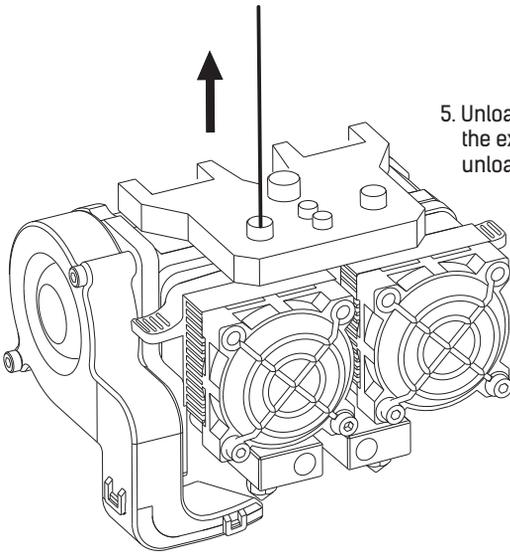
2. If it is not already powered on, flip the power switch to the ON position. Wait for the system to stabilize, then touch the Tool button on the Top Menu.



3. Touch the Filament button, then touch the Unload Left button.



4. Wait for the extruder to heat up to the target temperature. The extruder will alert you when it is at the target temperature.



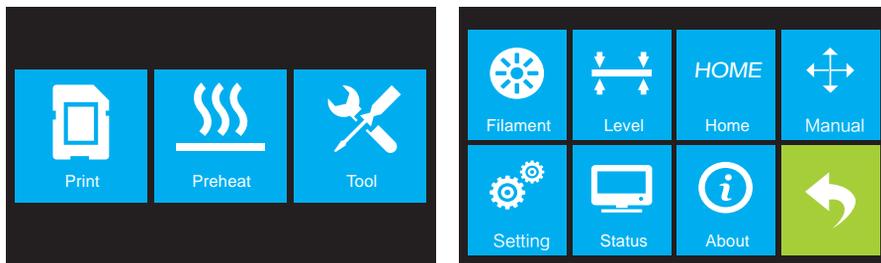
5. Unload the filament by gently guiding it out of the extruder, then touch the Done button to finish unloading.

# Build Plate Leveling

A properly leveled build plate is required for high-quality 3D prints. If you have any problems printing an object, you should first check whether the build plate is properly leveled or not. A general rule of thumb is to leave a gap that is the thickness of a piece of paper. However, for printing finer objects (150 microns and lower), use a feeler gauge to level the build plate as it requires a lesser gap between the nozzle and the build plate.

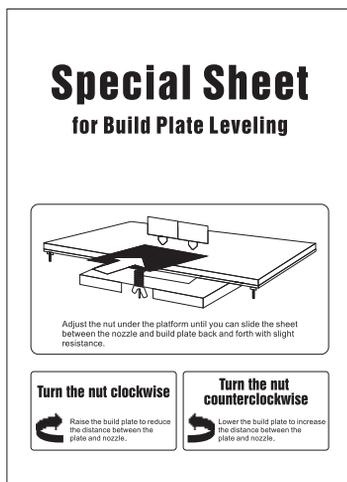
The Flashforge Creator Max uses a three-point leveling system for the build plate. At the bottom of the build plate, there is a spring-loaded knob in the front and two in the back. Tightening the knob will increase the gap between the build plate and the nozzle and loosening it will reduce the gap.

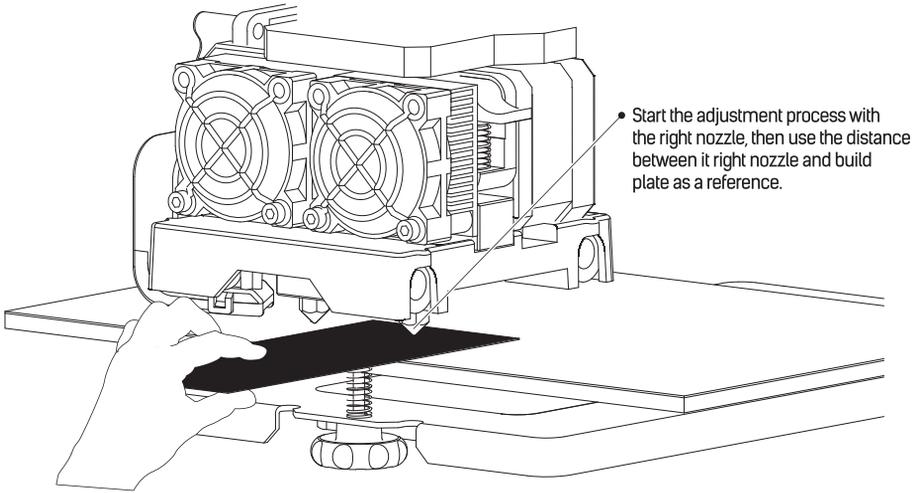
Perform the following steps to level the build plate.



1. If it is not already powered on, flip the power switch to the ON position. Wait for the system to stabilize. Touch the Tool button on the Top Menu, then touch the Level button on the Tool Menu. The extruder and build plate will move to the starting position.

2. Take out the Leveling Card.





3. Once the extruder and build plate stop moving, slide the Leveling Card continuously back and forth between the nozzles and the build plate, while simultaneously adjusting the knob just enough so that the card causes a slight friction.

Touch the Next button and wait for the extruder to move to the second position. Slide the card back and forth again and adjust the knob to create the same amount of friction as the previous step.

Touch the Next button again and repeat the same leveling steps.

Touch the Next button. The nozzle will move to the center of the build plate. Slide the card through to make sure there is a slight friction. Slowly adjust all screws by the same amount if there is no friction or too much friction.

Touch the Finish button to complete the leveling process.

# Flashprint Software

## Flashprint Software

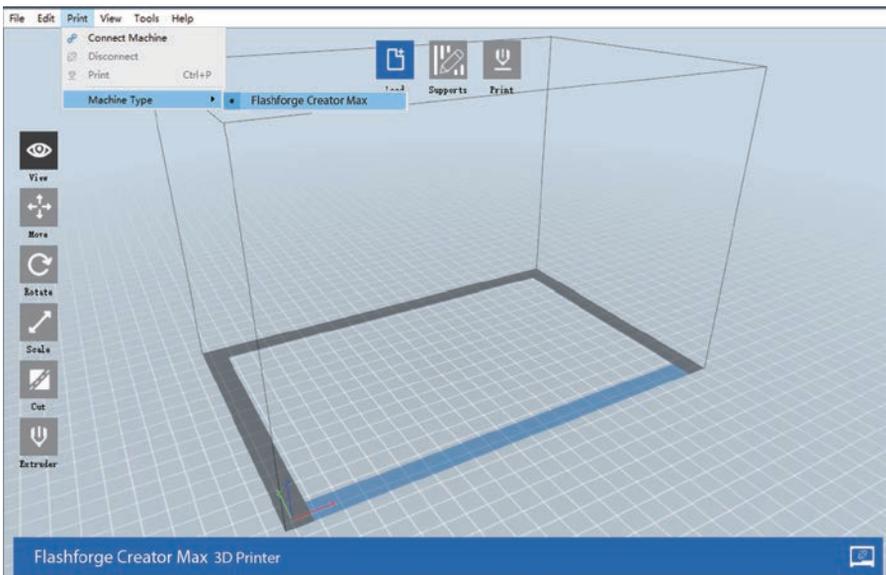
### Installation

Uncompress the copied RAR file, and complete the installation according to the provided instructions. Connect your 3D printer to your computer using the included USB cable, ensure that the printer is connected to your computer successfully. Start the software by selecting the shortcut on your computer's desktop or in the Start Menu.

**Note:** This software supports Windows XP/Win 7/Win8 32-bit and 64 bit, and Mac operating system.

### Initial Setup

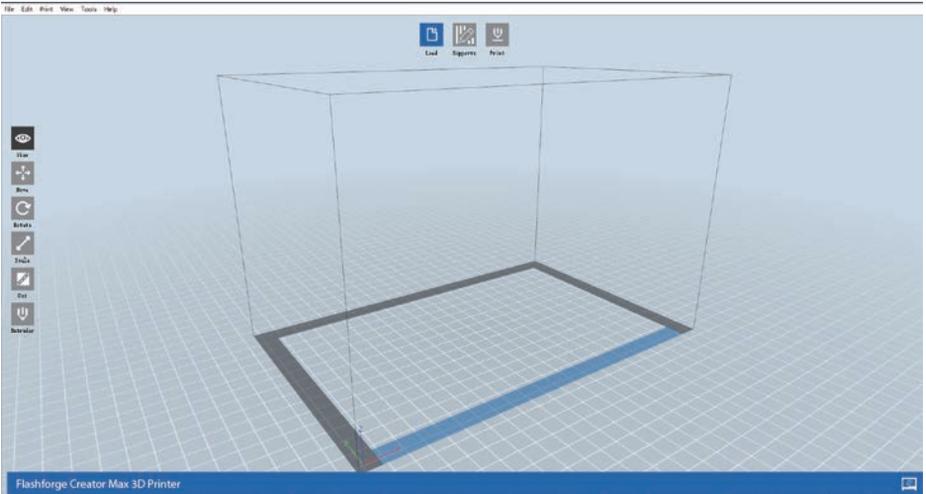
Once FlashPrint has been installed, double-click the application shortcut to start the program. If this is the first time the program has been run, you will be presented with a dialog asking you to select the Machine Type. Choose the Flashforge Creator Max entry.



You can also select the Machine Type from within the program by clicking **Print > Machine Type > Flashforge Creator Max**, as shown in the screenshot below.

## Main Interface Overview

The screenshot below shows the three main elements of the software - the Menus, the Icons, and the Build Plate.



The icons have the functions listed in the table below.



### Load

Loads a model or Gcode file. FlashPrint supports .STL, .OBJ, and .FPP model files. You can also load a .PNG, .JPG, .JPEG, or .BMP file and FlashPrint will generate a model from the image. See the Generating a Model section for details.



### Supports

Enters the Support Edit mode.



### Print

Prints directly from FlashPrint via a USB or wireless connection or exports a Gcode file to the SD™ card.



### View

Views the FlashPrint home screen from one of six viewing angles.



### Move

Moves the model around on the X/Y plane. Hold the SHIFT key then click to move the mode along the Z axis.



## Move

Moves the model around on the X/Y plane. Hold the SHIFT key then click to move the model along the Z axis.



## Scale

Scales the size of the model.



## Cut

Cuts the model into several parts.



## Extruder

Selects the right or left extruder for printing.

## Loading a File

FlashPrint supports six different ways to load a model or Gcode file, as outlined below.

- Click the Load icon on the main interface, then select the file.
- Drag and drop the file onto the main interface.
- Click File > Load File, then select the file.
- Click File > Load Examples to load one of the sample files.
- Click File > Recent Files, then select the file from the list of recently used files.
- Drag and drop the file onto the FlashPrint icon on the desktop to launch FlashPrint and load the file.

## Generating a Model

FlashPrint can generate a 3D model file from a .PNG, .JPG, .JPEG, or .BMP image file. When you load the image file, the following dialog box will be displayed, which allows you to set several model parameters.

**Shape:** Determines the basic shape of the model. You can select Plane, Tube, Canister, Lamp, or Seal basic shapes.

**Mode:** Selects whether the light or dark portions of the image will be the high points of the model.

**Maximum Thickness:** Sets the Z value of the model.

**Base Thickness:** Sets the minimum raft thickness. The default value is 0.5mm.

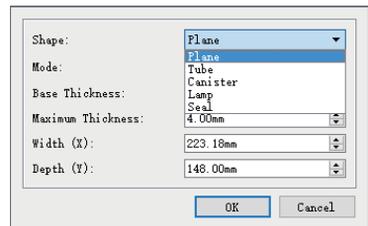
**Width:** Sets the X value of the model.

**Depth:** Sets the Y value of the model.

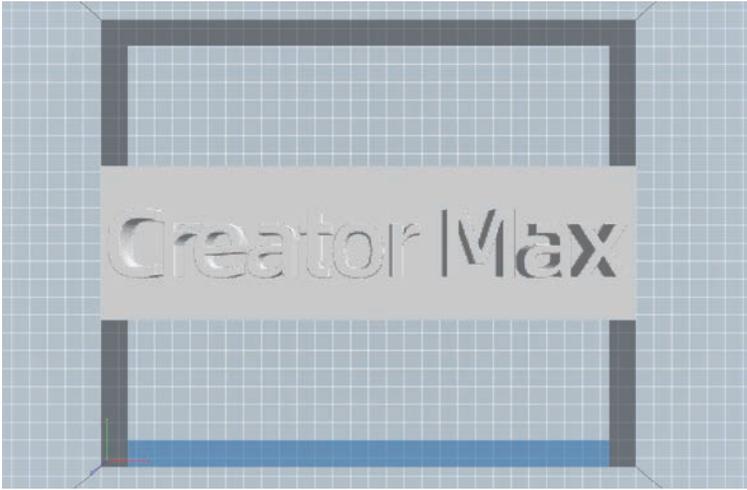
**Bottom Thickness:** Sets the thickness of the bottom of tube, canister, and lamp type models.

**Top Diameter:** Sets the diameter for the top of tube, canister, and lamp type models.

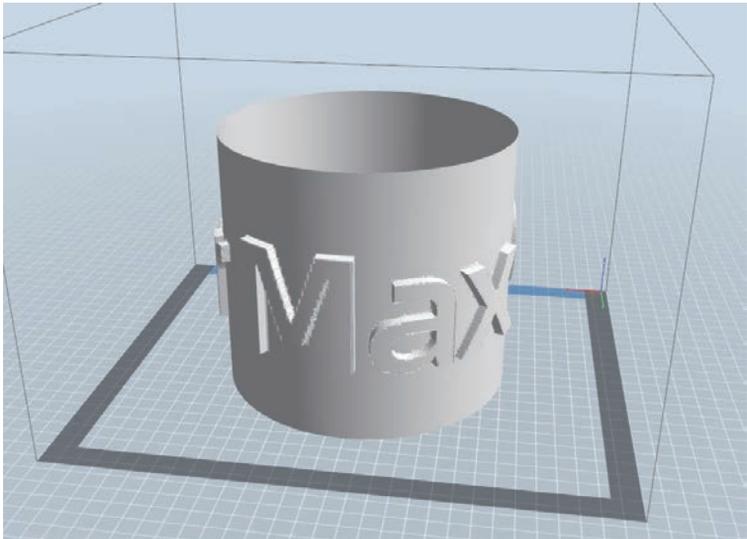
**Bottom Diameter:** Sets the diameter for the bottom of tube, canister, and lamp type models.



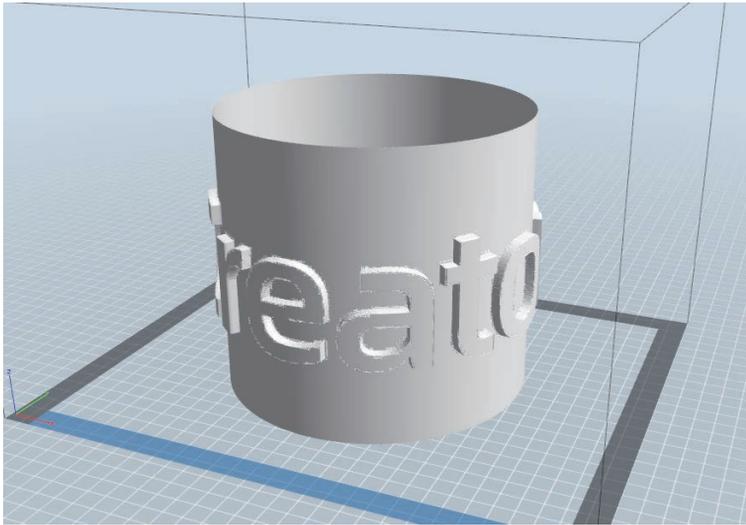
The following screenshots illustrate the five basic shapes.



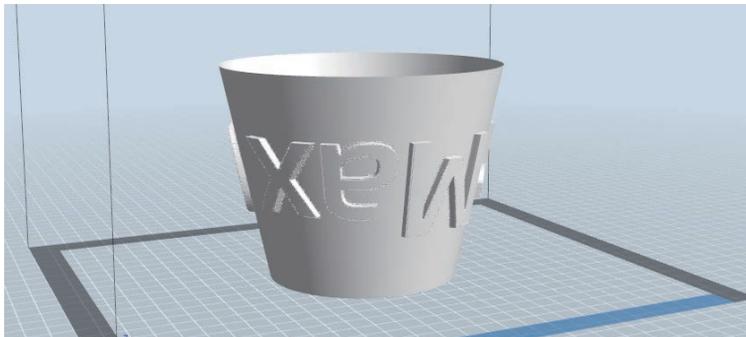
**Plane**



**Tube**



**Canister**



**Lamp**



**Seal**

## Changing Views

You can change the camera angle in relation to the model and build area using a variety of methods.

**Drag:** Click the View icon, then drag the camera using one of the following methods.

- Left click and hold, then move the mouse.
- Click and hold the mouse wheel, then scroll up or down.
- Hold down the SHIFT key, right click and hold, then move the mouse.

**Rotate:** Click the View icon, then rotate the camera using one of the following methods.

- Right click and hold, then move the mouse.
- Hold down the SHIFT key, left click and hold, then move the mouse.

**Scale:** Scroll the mouse wheel up or down to zoom the camera in or out.

**Set View:** You can select one of six preset camera angles using one of the following methods.

- Click the View menu, then select one of the six options from the drop-down list.
- Click the View icon, then click it again and a submenu will appear with six options for selection.

**Reset View:** You can reset the camera angle to the default using one of the following methods.

- Click the View menu, then select Home View.
- Click the View button, then click it again and a submenu will appear. Select the Reset option.

**Show Model Outline:** You can set FlashPrint to show the model outline highlighted in yellow.

To do so, click the View menu, then select the Show Model Outline option.

**Show Steep Overhang:** When the intersection angle between the model surface and a horizontal line is within the overhang threshold value, the surface has steep overhang and is shown in red when Show Steep Overhang is enabled. To enable or disable Show Steep Overhang, click the View menu, then select the Show Steep Overhang entry. The default threshold value is 45 degrees.

## Model Manipulation

You can manipulate the model using a variety of methods.

**Move:** Click on the model to select it. You can then move it around the build area in a variety of ways.

- To move the model horizontally in the X/Y plane, left click and hold on the model, then move the mouse.
- To move the model vertically in the Z plane, hold down the SHIFT key, the left click and hold on the model, then move the mouse.
- Click the Move button, then enter the distance value. Click Reset to reset the distance values.

**Note:** After moving the model, click Center > On Platform to ensure that the model is in the build area and in contact with the build platform.

**Rotate:** Click on the model to select it. You can then rotate the model in all three planes in a variety of ways.

- Click the Rotate icon and three mutually perpendicular rings will appear around the model. Click and hold on one ring and move the mouse to rotate the model in that plane.
- Click the Rotate icon, then manually enter rotation angle values. Click Reset to reset the rotation angle values.

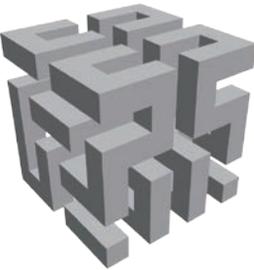
**Scale:** Click on the model to select it. You can then scale it in a variety of ways.

- Click the Scale icon, then hold the button and move the mouse to change the scale. The corresponding values will display near the model.
- Click the Scale icon, then enter scales values for the X, Y, and Z axes.
- Click the Scale icon, then click the Maximum button to get the largest size possible for the build area.
- Click the Scale icon, then click the Reset button to reset the size of the model.

Note that if the Uniform Scaling radio button is enabled, it will scale the model in proportion when changing any size value.

**Cut:** Click the model to select it, then double-click the Cut icon to set the cut plane in a variety of ways.

- Left click and drag the cursor across the model to set the cut angle.



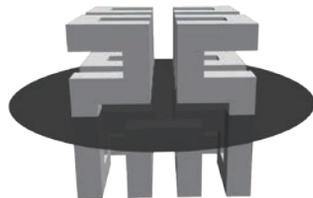
- Select the X Plane option to cut the model vertically.



- Select the Y Plane option to cut the model vertically.

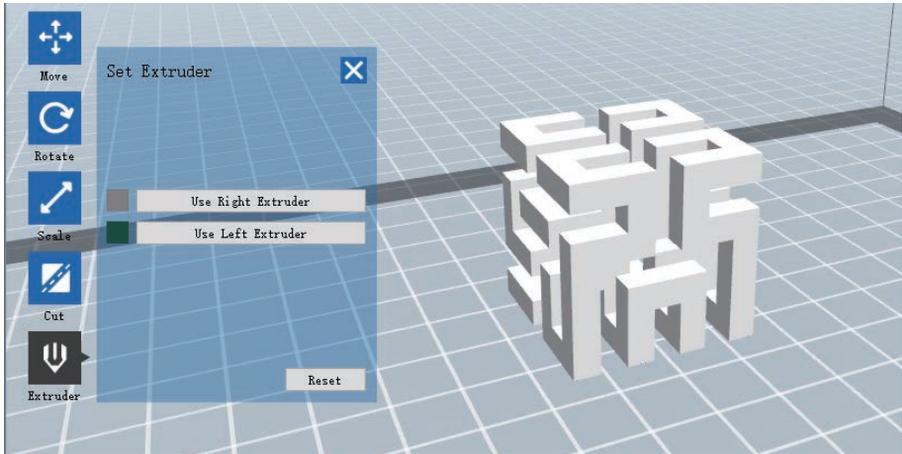


- Select the Z Plane option to cut the model horizontally.



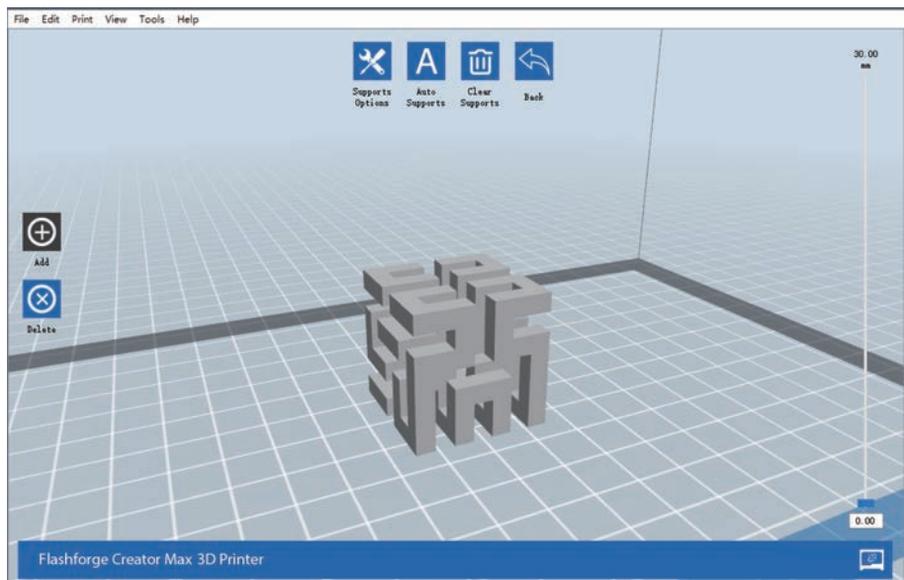
## Extruder

Double-click the Extruder icon to select the left and/or right extruder for printing.

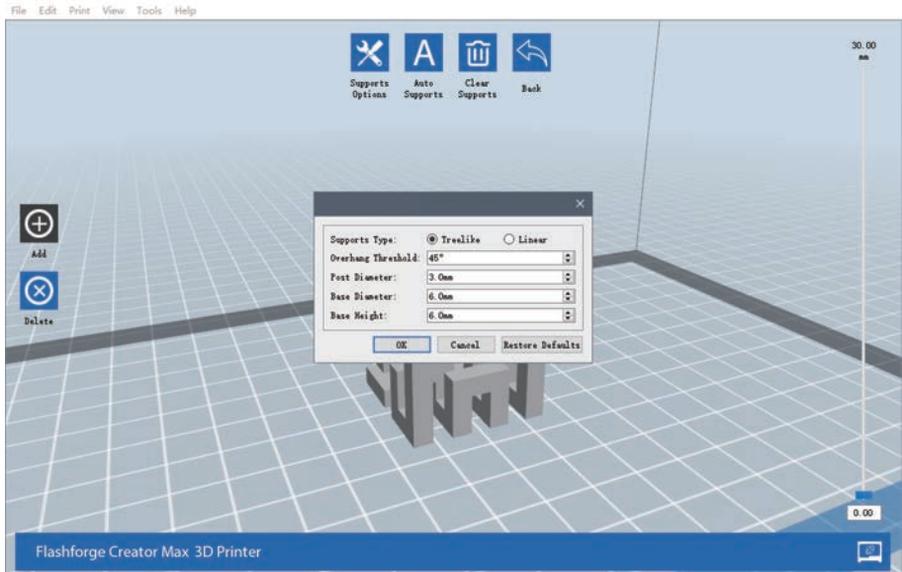


## Supports

Because 3D printing is an additive process, each layer of filament needs a base to be built on. The printer can gradually increase the layer size, so long as the overhang angle is less than about 45 degrees. Otherwise, you need to create support elements to serve as the base for adding additional layers. To edit the supports, click the Edit menu, then select the Supports entry. Alternatively, click the Supports icon. Click the Back button when finished editing the supports.



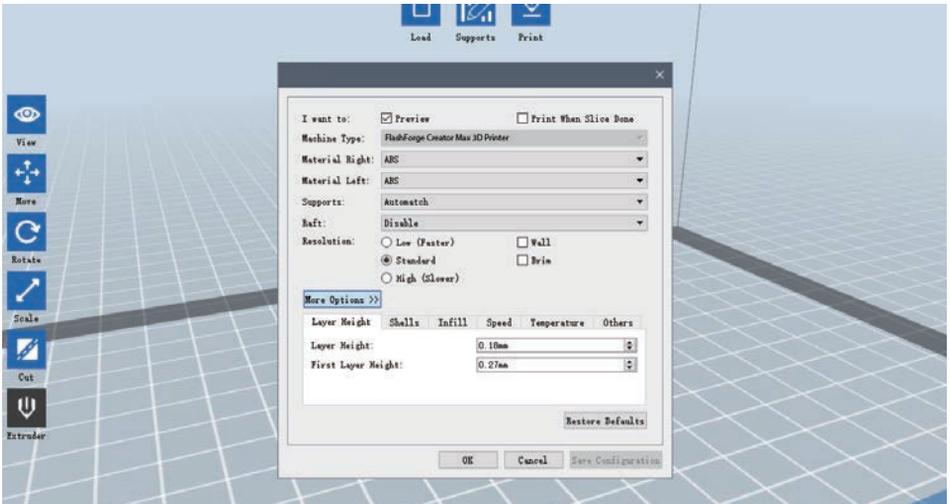
**Support Options:** Click the Support Options button to display the Support Options dialog. You can select Treelike or Linear supports. Treelike supports are built at angles, while Linear supports are linear, vertical supports for the overhanging elements. When you click the OK button, the software will generate the appropriate support structures. If the model already has supports, the software will judge whether the existing supports need to be deleted or not on the basis of the type of existing support, and display the corresponding prompt to let you make the choice.



- Auto Supports:** Click the **Auto Supports** button to allow the software to judge where supports are needed and will generate corresponding treelike or linear supports. If the model already has supports, the software will delete them and new supports will be generated.
- Add Supports:** Click the **Add** button to manually generate supports. Move the cursor to the position where a support is needed, left click to choose the starting point, then while holding down the mouse button, drag the mouse to the termination point. The supports preview will be displayed with the support highlighted. If the support surface doesn't need support or the support column angle is too large, the support will not be generated.
- Clear Supports:** Click the **Clear Supports** button to remove all existing supports. If you change your mind, click the **Undo** option or press **CTRL+Z**.
- Delete Supports:** Click the **Delete Supports** button to remove individual supports. Click the cursor on the support you want to remove to highlight support, then click the left mouse button to delete the highlighted support.

## Printing a Model

Click the Print icon on the main interface to slice the model and print the resulting Gcode file, either directly from FlashPrint or by first exporting it to the SD™ card.



**Preview:** Check the **Preview** box to preview the model before slicing and printing.

**Print When Slice Done:** Check the **Print When Slice Done** box to start the print as soon as the slice is completed.

**Material Type:** Select the filament type in use.

**Supports:** Enable or disable the creation of supports.

**Raft:** Enables or disable a **Raft**, which is several layers of material on the build plate to help with model adhesion.

**Wall:** Check the **Wall** box to help clear leaking filament from a second extruder during dual color printing.

**Brim:** Check the **Brim** box to print a ring of filament around the model to help prevent warping and assist with bed adhesion.

**Resolution:** For ABS and PLA printing, you can choose **Low**, **Standard**, or **High** resolution.

For PLA printing, you can also choose **Hyper**. The higher the resolution, the smoother the model surface, but at a corresponding cost in print speed.

**More Options:** Click the **More Options** button to reveal tabs with additional options.

**Layer:** Click the **Layer** tab to reveal the layer options.

- **Layer Height:** Sets the thickness of each layer. The thinner the layer, the smoother the model surface, but at a corresponding cost in print speed.
- **First Layer Height:** Sets the thickness of the first layer of the model, which affects how well the model adheres to the build plate. The maximum thickness is 0.4mm and the default value is usually sufficient.

**Shell:** Click the **Shell** tab to reveal the shell options.

- **Perimeter Shells:** Sets the number of perimeter shells. The maximum value is 10.
- **Top Solid Layers:** Sets the number of solid layers at the top of the model. The maximum value is 30 and the minimum is 1.
- **Bottom Solid Layers:** Sets the number of solid layers at the bottom of the model. The maximum value is 30 and the minimum is 1.

**Infill:** Click the **Infill** tab to reveal the infill options. Infill is the structure that is printed inside the model. Infill directly affects the strength of the printed model.

- **Fill Density:** Sets the fill density in 5% increments. A 100% density results in a solid model, while a 0% density results in no infill.
- **Fill Pattern:** Allows you to select the shape of the infill structure. You can select **Line**, **Hexagon**, or **Triangle**.
- **Combine Infill:** You can select the layers for combining according to the layer thickness. The combined thickness should not exceed 0.4mm. The **Every N Layers** option is for all infill, while the **Every N Inner Layers** affects only the inner infills, which generally save print time.

**Speed:** Click the **Speed** tab to reveal the speed settings.

- **Print Speed:** Determines the speed that the extruder moves while printing filament. It can be set from 10 to 200 mm/sec in 10mm/sec increments. The slower the speed, the higher quality the resulting printed models. For PLA printing, 80mm/sec is recommended.
- **Travel Speed:** Determines the speed that the extruder moves while moving from place to place and not actively printing filament. It can be set from 10 to 200 mm/sec in 10mm/sec increments. The slower the speed, the higher quality the resulting printed models. For PLA printing, 100mm/sec is recommended.

**Temperature:** Click the **Temperature** tab to reveal the temperature options.

- **Right Extruder:** Sets the operating temperature of the extruder from 0 to 248°C, in 5°C increments. Set the temperature according to the type of filament being printed.
- **Platform:** Sets the operating temperature of the build platform from 0 to 120°C, in 5° increments. Set the temperature according to the type of filament being printed.

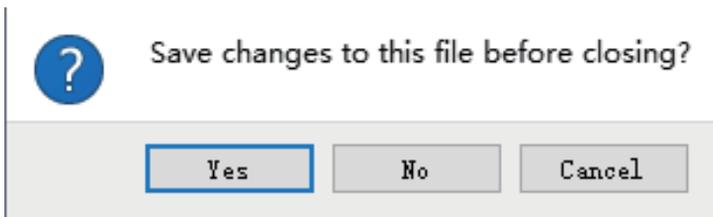
**Others:** Click the **Others** tab to reveal additional options.

- **Pause At Heights:** Sets the height at which the print will automatically be paused. This is usually done to allow you to change filament at one or points. Click the Edit button to set the pause point(s). The print can be paused anywhere from 1 to 59.9 mm.

## File Menu

The **File Menu** contains the following options.

**New Project:** Click **File > New Project** or press **CTRL+N** to create a new, blank project. A project saves in one place all the models in the scene, including positions, supports, and settings. If there are any unsaved changes to a previously loaded project, you will be prompted to save the changes.



**Save Project:** Click **File > Save Project** or press **CTRL+S** to save the current project. Projects files have a .FPP suffix.

**Load File:** Click **File > Load File** or press **CTRL+O** to load a model, Gcode, or project file.

**Save As:** Click **File > Save As** to save the project or model file.

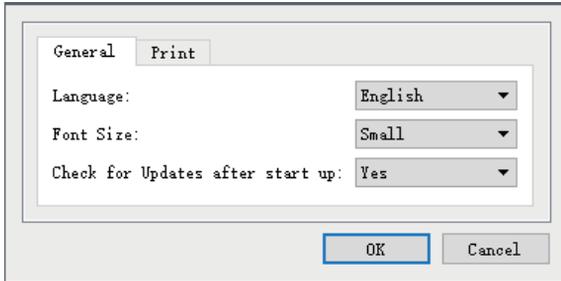
**Examples:** Click **File > Examples** to load one of four built-in sample models.

**Recent Files:** Click **File > Recent** Files to choose from a list of recently loaded files.

**Preferences:** Click **File > Preferences** to set several General and Print preferences.

- **Language:** Allows you to select the language used in FlashPrint.
- **Font Size:** Allows you to set the size of the font used in FlashPrint. You can select **Small, Medium, or Large.**
- **Check for Updates after start up:** Determines whether FlashPrint will automatically check for the existence of software or driver updates.
- **Auto layout newly-imported model:** Determines whether the software will automatically adjust the position of a model immediately after it is loaded.
- **Printing Window Type:** Allows you to choose the Basic (default) print dialog or the Expert dialog, with many more individual settings.

**Quit:** Click **File > Quit** or press **ALT+F4** to exit FlashPrint. If there are any unsaved changes to your project or model, you will be prompted to save the changes.



## Edit Menu

The **Edit Menu** contains the following options.

**Undo:** Click **Edit > Undo** or press **CTRL+Z** to undo the last change. In most cases, you can undo multiple changes, one at a time.

**Redo:** Click **Edit > Redo** or press **CTRL+Y** to redo the last change that was undone. In most cases, you can redo multiple undos.

**Empty Undo Stack:** Click **Edit > Empty Undo Stack** to clear the software's memory of recent undos. This has the same effect as saving and reloading the project or model file.

**Select All:** Click **Edit > Select All** or press **CTRL+A** to select all models in the scene.

**Duplicate:** Click **Edit > Duplicate** or press **CTRL+V** to copy the selected model(s).

**Delete:** Click **Edit > Delete** or press the **Del** key to delete the selected model(s).

**Auto Layout All:** Click **Edit > Auto Layout All** to automatically arrange the model(s) on the build platform. You will be prompted to set the distance between models, which can be from 1.0 to 50.0 mm.

**Mirror Model:** Click **Edit > Mirror Model** to mirror the selected model(s) in the X, Y, or Z planes.

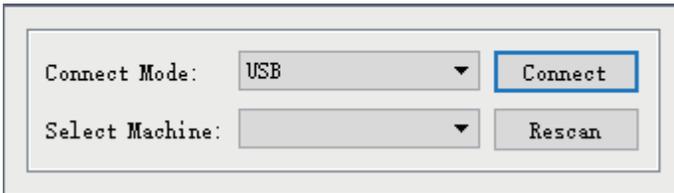
**Repair Models:** Click **Edit > Repair Models** to correct any errors in the selected model(s).

**Supports:** Click **Edit > Supports** to enter **Support Edit** mode.

## Print Menu

The **Print Menu** contains the following options.

**Connect Machine:** Click **Print > Connect Machine** to establish a USB or Wi-Fi® connection to the printer. This option is not available if the printer is already connected.



**Disconnect:** Click **Print > Disconnect** to break a connection with the printer. This option is not available if there is no connection with the printer.

**Print:** Click **Print > Print** or press **CTRL+P** to open the print dialog.

**Machine Type:** Click **Print > Machine Type**. Allows you to select the specific model of 3D printer to use with FlashPrint. This printer is the **Flashforge Creator Max 3D Printer**.

## View Menu

The **View Menu** contains the following options.

**Home View:** Sets the camera to the default position.

**Top View:** Sets the camera to look directly down onto the build area.

**Bottom View:** Sets the camera to look directly up towards the build area.

**Left View:** Sets the camera to look at the build area from the left.

**Right View:** Sets the camera to look at the build area from the right.

**Front View:** Sets the camera to look at the build area from the front.

**Back View:** Sets the camera to look at the build area from the rear.

**Show Model Outline:** Puts a yellow outline around the model.

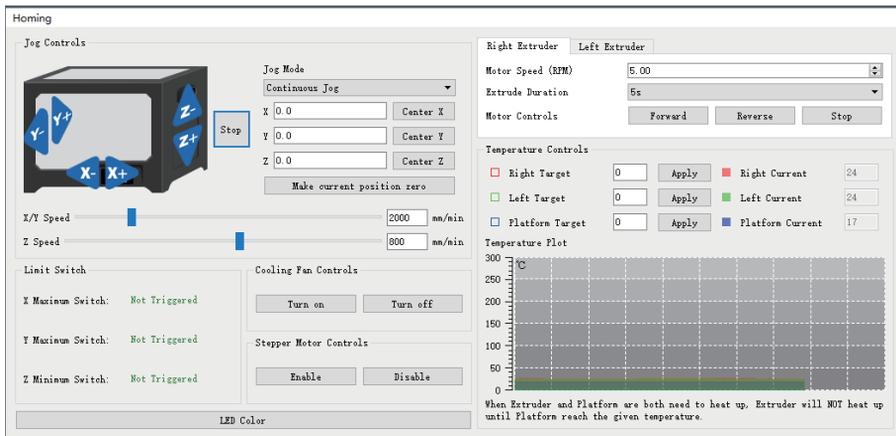
**Show Steep Overhang:** Highlights in red those portions of the model that requires supports.

## Tools Menu

The **Tools Menu** contains the following options.

**Control Panel:** Click **Tools > Control Panel** to modify the printer's settings from within FlashPrint.

Note that if you are not connected to the printer, you will be prompted to do so before the Control Panel can be displayed.



- **Jog Mode:** The Jog Mode section allows you to select the distance that the extruder and build plate move with each mouse click.
- **Six Blue Arrow Buttons:** The buttons allow you to manually move the extruder and build plate. The amount they will move with each click of the mouse is determined by the Jog Mode settings.
- **Stop:** Click the Stop button to abort any current movement.
- **XYZ Coordinates:** Displays the current position of the extruder and build plate. You cannot edit the displayed values.
- **Make Current Position Zero:** Click the **Make Current Position Zero** button to set the zero position for the three axes.
- **Center XYZ:** Click a **Center** button to move the extruder or build plate to the zero position for that axis.
- **Set X/Y Speed:** Sets the speed at which the extruder moves.
- **Set Z Speed:** Sets the speed at which the build plate moves.
- **Limit Switch:** Displays the status of the limit switches on each axis. If the extruder or build plate are not moved to its maximum positions, the status will show **Not Triggered** in green. If the extruder or build plate has been moved to its maximum position, the status will show **Triggered** in red.
- **Stepper Motor Controls:** Click the **Enable** button to lock the stepper motor so that it does not allow movement. Click **Disable** to unlock the stepper motor so the extruder and build plate can be manually moved.
- **LED Color:** Allows you to set the LED color of the printer.
- **Motor Speed (RPM):** Controls the speed of the filament feed wheel.

- **Forward:** Feeds filament to the extruder.
- **Reverse:** Unloads filament from the extruder.
- **Stop:** Stops motor movement when feeding or unloading filament.
- **Temperature Control:** Allows you to set the target extruder or platform temperature.  
Click the **Apply** button to start heating.

**Update Firmware:** Allows you to update the printer's firmware.

**On Board Preferences:** Allows you to check the printer's name.

**Machine Information:** Displays information about the printer, including the firmware version.

## Help Menu

The **Help Menu** contains the following options.

**First Run Wizard:** Re-runs the wizard that automatically runs the first time FlashPrint is run.

**Help Contents:** Allows you to read the help files.

**Feedback:** Allows you to submit feedback.

**Check For Updates:** Checks for FlashPrint updates.

**About FlashPrint:** Displays FlashPrint version information.

## Connecting the Printer

There are three ways of connecting the FlashPrint software with the printer – a wired USB connection or a wireless Wi-Fi® connection in AP mode or STA (Station) mode.

### USB Connection

Perform the following steps to connect your PC to the printer using a wired USB connection.

1. Plug one end of the included USB cable into the USB port on the printer, then plug the other end into an available USB port on your computer.
2. Power on the printer and your computer, then start the FlashPrint software.
3. Click **Print > Connect Machine**.
4. Set the Connection Mode to USB and set the Select Machine option to the printer. Flashforge Creator Max the printer does not appear in the Select Machine list, click the Rescan button. If it still does not appear, reinstall the driver software.

## Wi-Fi Connection

Perform the following steps to connect your PC to the printer using a Wi-Fi® connection. Note that printing from an SD™ card is disabled when Wi-Fi is enabled.

1. Power on the printer and your computer.
2. On the printer, select **Tool > Setting > WIFI > WIFI ON**.
3. Open your computer's wireless network settings and scan for available Wi-Fi® signals.
4. Open your internet browser. Type 10.10.100.254 and press the Enter key on your keyboard. Enter the username and password to login. The default username and password are both admin. The control panel will appear after successful login.
5. Click the WiFi Set tab on the left, then set the WiFi Work Mode to AP mode or STA mode, then click Restart to make the changes take effect.

The screenshot shows a printer's control panel with a blue background. On the left, there is a vertical menu with the following items: Sys status (highlighted in blue), WiFi Set, Trans Set, Reload Reset, and About FF. The main area displays two sections: 'Sys status' and 'wifi Status'. Each section contains a table of system information.

Sys status	
Sys run time	0 days 00:09:06
module MAC	D8:B0:4C:D0:38:4E
module MID	USR-C322
module ver	1.14.13

wifi Status	
wifi mode	Access Point
AP IP	10.10.100.254
AP channel	6
AP ssid	Flashforge Creator Max 3DPrinter
AP secure	Open

**AP mode** configures the printer's Wi-Fi® radio to act as a Wi-Fi Hotspot/Access Point (AP). You then set your computer's network settings to directly connect to the printer's Wi-Fi AP, rather than your regular Wi-Fi AP. **STA mode** configures the printer's Wi-Fi® radio to connect to your regular Wi-Fi AP. In STA mode you do not need to change your computer's network settings and can continue to use your Wi-Fi AP, as normal.

If you choose to use **AP mode**, you can set the network name (Flashforge Creator Max) and password of the hotspot. If you don't want to use a password, enter **NONE**. Click the **Save** button and restart it. Connect your PC to the network (the name you set). Open FlashPrint, then click **Print > Connect Machine**. Select **Wi-Fi** as the **Connect Mode** and enter the IP Address, as shown on the Flashforge Creator Max's screen. Click **Connect**.

Sys status

WiFi Set

Trans Set

Reload Reset

About FF

### WiFi Mode Select

Wifi Work Mode AP mode

---

#### AP mode

Network Name(SSID) (1-32 bytes) Flashforge Creator Max

Password(8-63 bytes), NONE is Open NONE

IP address 10.10.100.254

Mask 255.255.255.0

Save

---

#### STA mode

Router SSID(Note: case sensitive) USR-C322

STA Password, Set NONE is Open NONE

DHCP auto get IP Enable

Save

**3D** Connect Machine ✕

---

Connect Mode: Wi-Fi ▼ Connect

IP Address (port): 10 . 10 . 100 . 254 : 8899

If you choose you use **STA mode**, input the SSID and password of your existing Wi-Fi® connection. If your Wi-Fi connection does not use a password, enter **NONE** into the password field. Then click the **Save** button and restart it. Restart the Flashforge Creator Max printer, then open the **WiFi Screen**.

Sys status  
WiFi Set  
Trans Set  
Reload Reset  
About FF

### WiFi Mode Select

Wifi Work Mode

### AP mode

Network Name(SSID) (1-32 bytes)

Password(8-63 bytes), NONE is Open

IP address

Mask

### STA mode

Router SSID(Note: case sensitive)

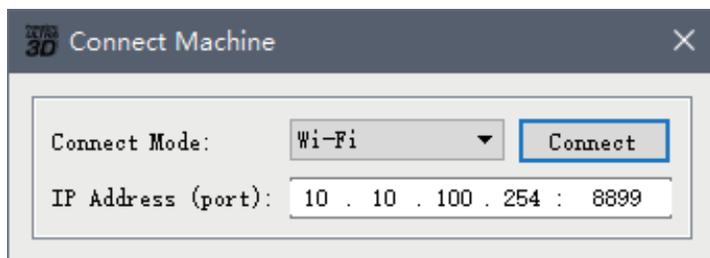
STA Password, Set NONE is Open

DHCP auto get IP



SSID: Market Department  
Signal Strength: 100  
IP Address: 192.168.1.119:8899  
Subnet Mask: 255.255.255.0  
Default Gateway: 192.168.1.1

Turn on the Flashforge Creator Max again and connect your computer to the network. Open FlashPrint, then click **Print > Connect Machine**. Select **Wi-Fi** as the **Connect Mode** and enter the IP Address, as shown on the Flashforge Creator Max's screen. Click **Connect**.

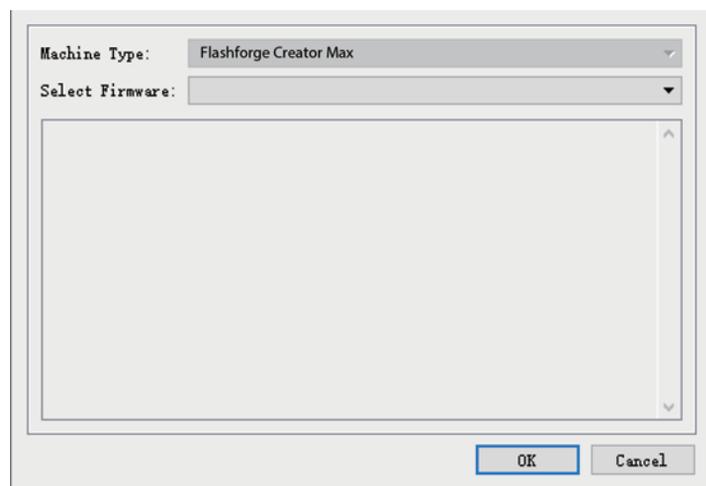


If you want to switch between AP and STA modes, touch the **Reset** button on the **WIFI Screen**.

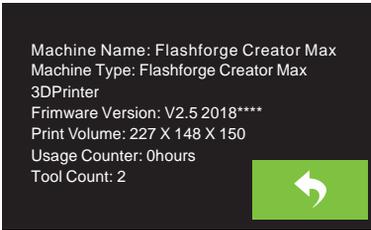
## Updating the Firmware

Each time you start FlashPrint, it will automatically detect and download the up-to-date firmware. If an update is available, a dialog box will appear to remind you of the update. Perform the following steps to update the firmware.

1. Click **Tools > Update firmware**. You must sever any existing connection with the printer before updating. If a connection exists, it will prompt you to cut the connection. Click the **Yes** button to cut the connection.
2. Choose the corresponding printer type and firmware version, then click **OK** in the firmware update dialog. After confirming that there is no printer connection, the software will automatically update the firmware.



3. Reboot the printer and wait 4-5 seconds until the update progress bar is displayed.  
When the update is finished, it will return to the **Top Menu**.
4. Touch the **Tool** button, then touch **About** to check that the version is correct.



## Printing

There are two basic modes of printing: single extrusion and dual extrusion. With single extrusion printing, you can choose which print head to use for making the print. Dual extrusion printing is useful if you want to print with two color or print complex models that require supporting material.

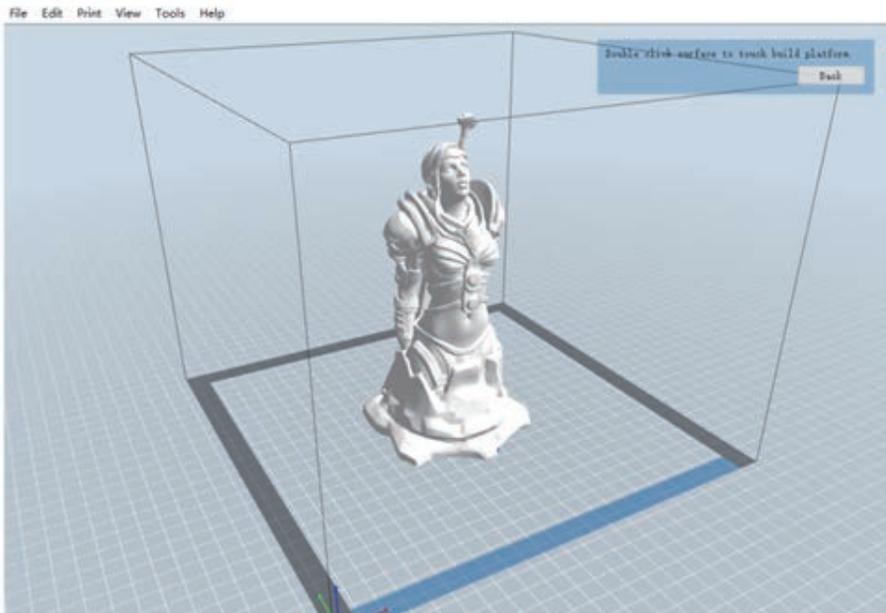
Perform the following steps to print a model on the printer from a Gcode file saved to the SD™ card.

## Generating Gcode

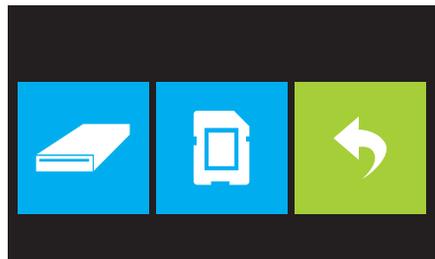
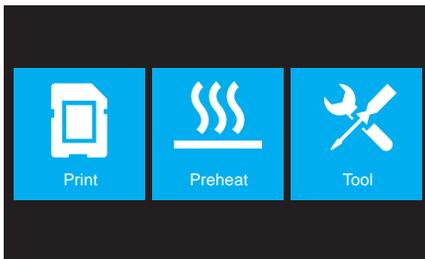
1. Plug the included SD™ card into an SD card reader on your computer.
2. Double-click the FlashPrint shortcut to launch the software.
3. Click Print > Machine Type and select the Flashforge Creator Max 3D Printer entry.



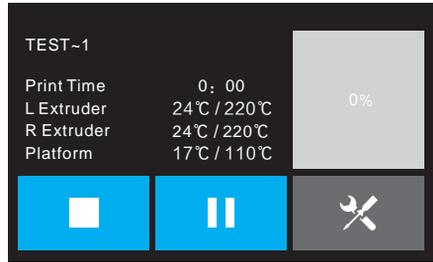
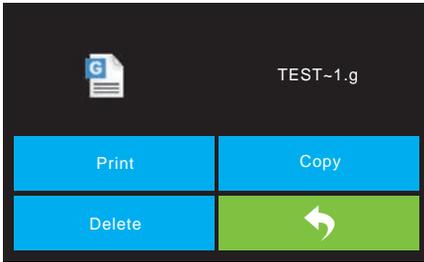
4. Click the Load icon to load a .STL model file. The model will display within the build area.
5. Double-click the Move icon, then click the On the Platform and Center buttons to ensure the model is in contact with the center of the build platform.



6. Click the **Print** icon, then change the settings as appropriate for your filament type and model.
  - **Preview:** Check the **Preview** box if you want to preview the model after slicing is done.
  - **Print When Slice Done:** Because we are printing from the SD™ card, uncheck this box to save the Gcode file to the SD card.
  - **Machine Type:** Select **Flashforge Creator Max 3D Printer**.
  - **Material Right:** Select the type of filament you are using.
  - **Material Left:** Select the type of filament you are using.
  - **Supports:** If your model has overhanging elements, enable the **Supports** option.
  - **Raft:** It is recommended to enable the **Raft** option.
  - **Resolution:** It is recommended to select the **Standard** option.
  - **More Options:** It is recommended to leave them at the default values.
7. Click **OK** to save the Gcode file to the SD™ card. You can rename the file as desired and save it as either a **.g** or **.gx** file. Files with a **.gx** extension can be previewed, while **.g** files cannot.
8. Eject the SD™ card, then plug it into the SD card slot on the printer.
9. Power on the printer.
10. Ensure that the build plate is leveled and that filament is loaded.
11. Touch the **Print** button on the printer display.
12. Touch the **SD card** button, then locate and load your model file.



13. Touch the **Print** button to begin printing. The printer will begin heating the extruder and/or platform, then will begin printing once the target temperatures are reached. Touch the **Stop** button at any time to cancel the print. Touch the **Pause** button to **pause** the print.



## SPECIFICATIONS

Printer Name	Flashforge Creator Max
Number of Extruders	2
Print Technology	Fused Filament Fabrication (FFF)
Screen Type	3.5" color IPS touch screen
Build Area	227 x 148 x 150 mm
Layer Resolution	0.05 - 0.4 mm
Build Accuracy	±0.1-0.2mm
Positioning Accuracy	XY Axis: 0.011mm, Z Axis: 0.0025mm
Filament Diameter	1.75mm ±0.07mm
Filament Types	ABS, PLA, Conductive PLA, Flexible Filament
Nozzle Diameter	0.4mm
Build Speed	30~200 mm/sec
Software	FlashPrint
Supported Input Formats	3MF, .STL, .OBJ, .FPP, .BMP, .PNG, .JPG, .JPEG
Supported Output Formats	.G, .GX
Supported Operating Systems	Windows® XP and later (32-bit and 64-bit), Mac® OS X®, Linux®
Input Power	100V~240V~, 4.5A~2.5A, 47/63 Hz
Connectivity	USB cable, SD™ card, Wi-Fi®
Package Size	21.9" x 16.1" x 19.1" ( 556 x 408 x 484 mm )
G.W.	41.4 lbs. ( 18.8 kg)