

# Quick Start Guide



Shenzhen Creality3D Technology Co., Ltd.

## Safety Precautions

Please use the consumables recommended by the original manufacturer. Do not use other manufacturer's consumable at will, so as not to clog the nozzle. Do not attempt to use the machine in any way not described in the instructions for use, and avoid causing unexpected personal injury and property damage. Do not attempt to disassemble or modify the machine not described in this manual to prevent the printer from damage or other more serious safety incidents.

Please place the machine in a ventilated, cool, dry and dustless environment. Do not place this machine near flammable materials or high heat sources. Do not place the unit in high vibration or other unstable environments.

Use the power cord supplied with this machine. Do not plug or unplug the power plug while your hands are wet. Use a qualified three-hole socket with a ground wire. When using the plug, be sure to plug it fully into the power outlet. Do not intentionally pull or twist the distribution line of the machine excessively to prevent open circuit or short circuit.

Under the age of 10, do not use this machine without supervision by personnel to avoid personal injury. Always do product maintenance and regularly dust and lubricate the machine.

Use the remaining temperature of the nozzle promptly after printing to clean the consumables on the nozzle with the tool. Do not directly touch the nozzle with your hand. Periodically, in the event of a power failure, clean the printer with a dry cloth and wipe away dirt and sticky printed material. If you must use a damp cloth to clean, do not use flammable solvents do as to prevent flammable solvents from coming into contact with the printer.

## Specifications

Forming size: 300\*225\*320mm

Layer thickness: 0.1mm~0.4mm (optional)

Nozzle diameter: 0.4mm (Other aperture nozzles can be assembled)

Printing speed: <200 mm/s, recommended speed 50mm/s

Print material: 1.75MM newly improved PLA, support for common PLA, ABS, TPU, etc.

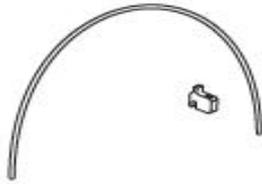
Support software format: STL, obj, gcode

Compatibility: Linux, Windows, and Mac

Applicable voltage: input 110V-220V, output 24V

Environmental requirements: 10-30°C, humidity 20-50%

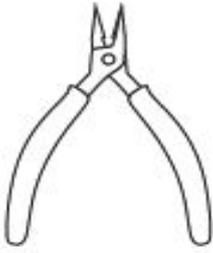
## 1 Included tools (not listed one by one)



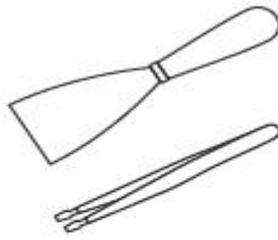
Material Guide



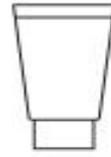
Material Spool



Pliers



Spatula  
&  
Tweezers



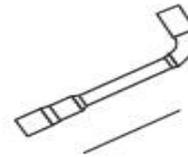
Service Grease



Cutting Knife  
&  
Scalpel



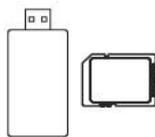
Allen Keys



Nozzle Key  
&  
Nozzle Needle



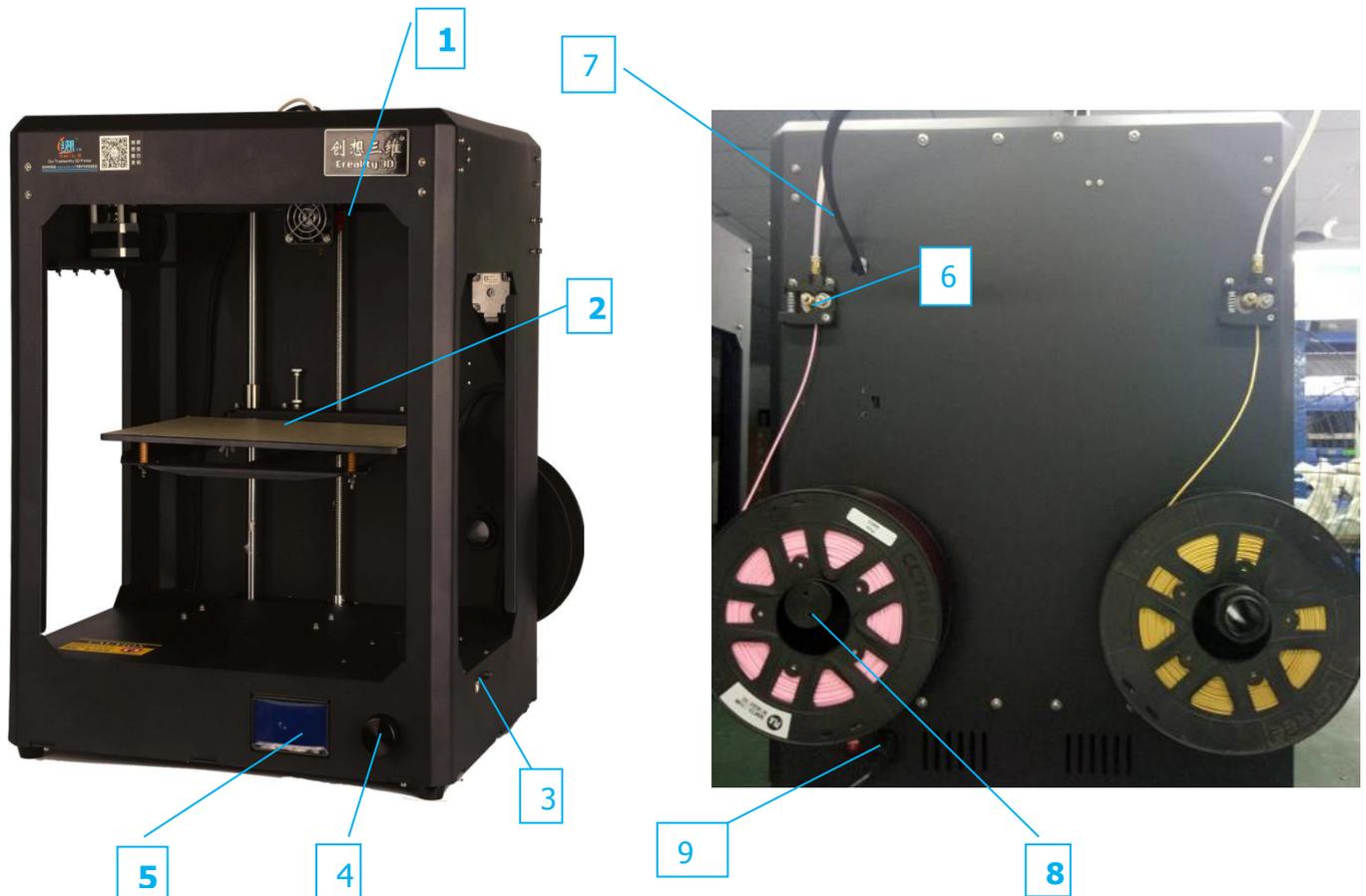
Power Cable



SD Card &  
SD Card  
Reader

Warning: After taking out the device, cut off the cable tie that holds the polished rod.

## 2. Parts introduction



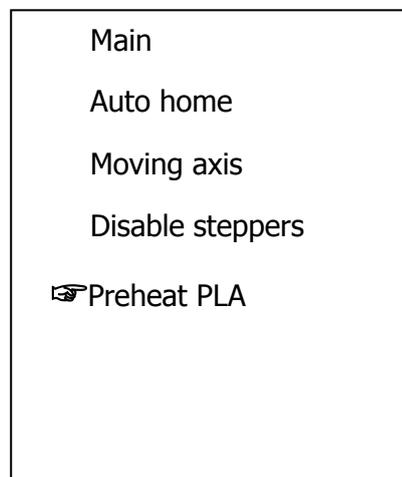
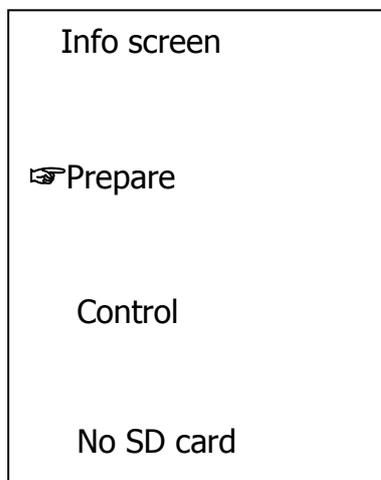
1. Nozzle and cooling fan    2. Print platform  
3. SD card slot and USB interface    4. Control knob  
5. LCD Display    6. Extruder    7. Teflon tube  
8. Material racks and trays    9. Switch and power socket

## 3. Hardware installation

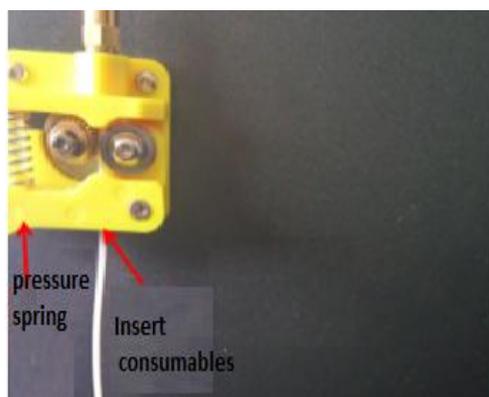
- 1 connect power
- 2 Install the material rack
- 3 Load the consumable reel. When feeding, the reel should rotate clockwise. The consumables should pass through the guide pipe to the nozzle (after the new reel is loaded, the bent portion at the first end of the line should be subtracted to ensure that the front of the consumable is straight).

## 4. Filling materials

1. Enter the main menu, click "Prepare", select "Preheat PLA". Wait until the temperature reaches the preset temperature then start loading consumables.



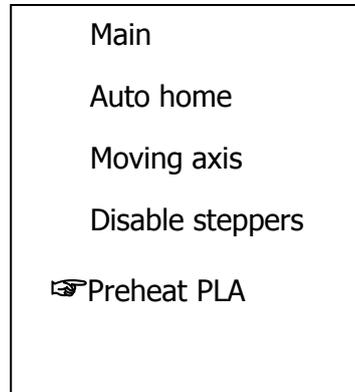
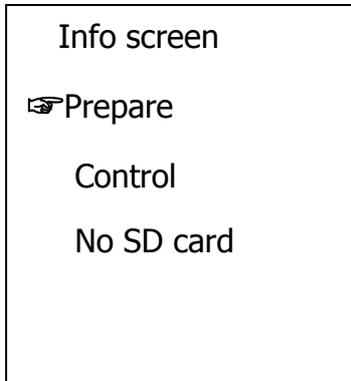
2. Feeding, when the nozzle temperature reaches the preset number, press the extrusion spring to send the consumables to the nozzle to spit out the material.



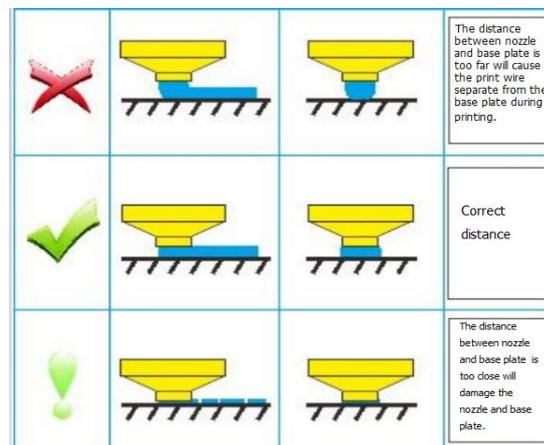
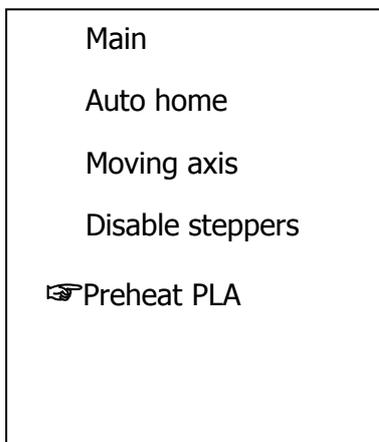
Note: The nozzles need to be preheated to above 185°C regardless of loading and unloading. Otherwise, the nozzles will be easily damaged.

## 5. Leveling the platform

1. Press the control knob to select "Prepare" -> "Auto home"



2. When each axis auto-home, the nozzle cannot be moved. Press the knob to select "Prepare" -> "disable steppers". Manually move the nozzle to the four corners and middle position of the platform, passing through the platform. The knob adjusts the distance between the nozzle and the platform so that the two are almost in contact. When the nozzle is moved, there are slight scratches on the textured paper.



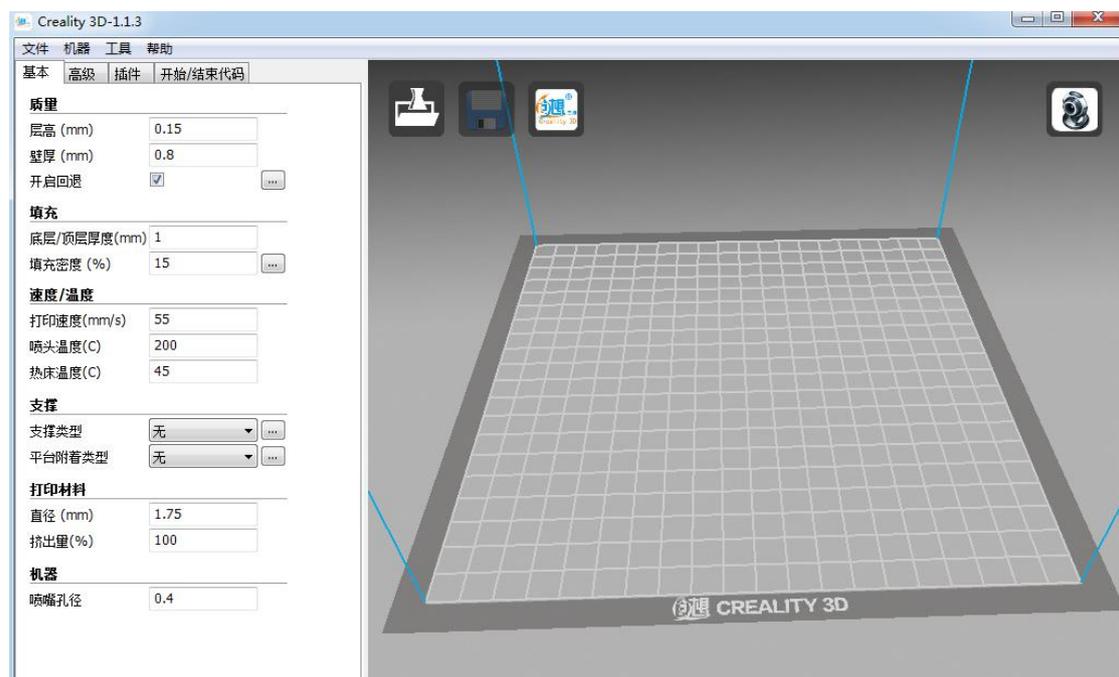
Turning the knob clockwise means reducing the distance between the nozzle and the platform, so that the two are closer; rotating the knob counterclockwise means increasing the distance between the nozzle and the platform, so that the two are far away.

Remember to lightly tighten / loosen the screws. Adjust them by rotating a few degrees.

## 6. install software

Copy the software installation package from the SD card to your computer and double-click to install the software. Refer to the software description for details.

2cura切片软件驱动程序	2016/8/17 15:51	文件夹	
sw3d_1.1.3	2016/12/30 15:57	Windows Install...	36,693 KB
创想切片软件	2016/8/22 10:41	媒体文件(.mp4)	308,281 KB
切片软件介绍	2016/11/20 15:41	看图王 PDF 文件	2,163 KB

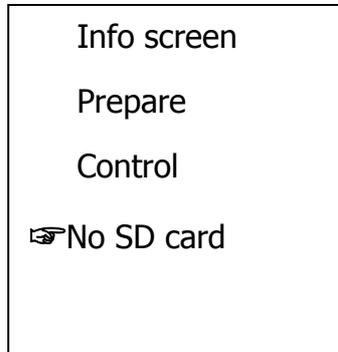


## 7. First print

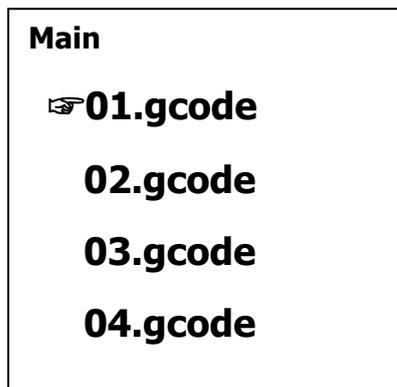
Insert the SD card containing the print data (gcode format file recognized by the printer) into the printer. Flatten the textured paper on the platform. Before printing,

you need to adjust the platform. The print data should be stored in the SD card home directory. The saved file name cannot have Chinese and special symbols.

1. Select "SD Card Print" in the main menu.



2. select the file you want to print



3. Wait for the printer to warm up, the nozzle and hot bed reach the preset number, and the printer starts printing.

4. Use a blade to carefully remove the model from the platform after printing, taking care not to damage the print platform.

Note: Do not preheat the nozzle for a long time, otherwise it will lead to two problems: 1 it may easy to burn the Supplies head and cause congestion if the nozzle heat for a long time.

2 if the nozzle heat prematurely, it may cause the firmware always waiting the command of "nozzle heating completed "

nozzle heating prematurely, may cause the firmware has been waiting for "nozzle heating completed " so that you cannot enter "start print" .

## 8. common problems

phenomenon	reason	way
The first layer is not sticky or can not spit out	This is the most common and simplest problem, that is, you have not properly leveled the printing platform.	If the distance between the platform and the nozzle is too high or too low, pre-printing will fail, so be sure to adjust the distance between the platform and the nozzle before printing.
Model drawing or material sagging	The retraction function is not turned on or the length of the retraction is small. In the non-printing movement, the consumable in the nozzle will leak out due to the effect of gravity, forming a filament.	<ol style="list-style-type: none"> <li>1. Appropriately increase the "back pumping speed" and "pulling distance" in the software;</li> <li>2. Lower the temperature properly. When the temperature decreases, you must also make sure that you are slowly printing to prevent crushing.</li> </ol>
Edge warping	As the plastic keep the temperature that above the hot bed, the material will maintains plasticity. Since the new layer of plastic is placed on the semi-solid material behind the plastic, the contraction force causes the underlying layer to shrink. Continue until the print reaches a height where	<p>PLA will need you keep your hot bed temperature around 50°C, this is a good temperature to maintain the bed's adhesion and not be too hot.</p> <ol style="list-style-type: none"> <li>2. The "bottom edge" and "bottom grid" built into the slicing software can help prevent warping.</li> <li>3.the warping side will allow the platform and the nozzle to be closer to the side; you can apply high-temperature double-sided</li> </ol>

	the heat of the hot bed no longer remains above this temperature and the next layer keeps the print layer turned into a solid.	adhesive on the hot bed, apply PVP solid adhesive on the textured paper, and apply 3M stickers.
Less filament out or plugging	Extruded gears will bounce back and have a buzzing sound. If skipping does not occur, the extruder will grind the wire as it feeds into the wire, cutting off the severely worn parts of the wire. <b>The use of inferior consumables can also lead to plugging.</b>	1. First adjust the nozzle temperature to 220-235, then use the small needle to clear the nozzle to clear the nozzle up and down, through the control of the extruder to feed inside; 2. If it will plug, replace a new nozzle, temperature 210, use a vise to clamp the fixed block, the nozzle sleeve to cover the nozzle, rotate the nozzle clockwise (when not rotating, try not to loosen the heating block, if loose then remember to tighten.)

## 9. Warranty and Maintenance

One year warranty with the machine, warranty time of some parts is different, manufacturers provide free maintenance, only charge for the replacement parts. If the machine is sent back to factory to maintain during the warranty period, the return shipping costs are the responsibility of the customer. Due to human factors (falling, throwing), improper use of the product or other causes of product failure or damage, all maintenance costs are borne by the customer.

name	warranty time
The whole machine	One year

nozzle	Three months
--------	--------------

Maintenance: 1 After the machine has finished printing for a long time, allow the machine to rest for a few hours before continuing to print. Do not pay attention to dust and moisture for a long time. The machine will not print for a long time. Please withdraw the consumables.

2 Lubricate the polished rod and Z-axis of the machine after long-term use. Grease is in the tool box.

Attachment : LCD screen annotation

Menu options	function	Instructions
Info screen		Check the nozzle and hot bed temperature, print progress,etc.
prepare	Main	
	Disable steppers	The XY axis can be manually moved after the motor turns off.
	Auto-home	Return to the origin of the machine
	Pre-heat PLA	Pre-heat PLA
	Pre-heat ABS	Pre-heat ABS
	Change filament	Load and upload
	Cool down	Turn off heating
	Moving axis	Move the X Y Z axis through the rotary knob. There are 3 options, which are stepping 10MM/1MM/0.1MM
control	Back	This selection is generally not used, parameters are not recommended to modify
	Temperature	
	Restore failsafe	
SD card print		Select .gcode file from SD

		card for printing
Ready will become adjust during printing	Speed	No special case, it is not recommended to adjust in printing
	Nozzle temperature	
	Hot bed temperature	
	Fan speed	
	Extrusion speed	



