

Newbie problems

When some axis do not move or the direction of movement is incorrect, check the wiring at each terminal or on the motherboard for correctness. (Appendix motherboard connection diagram)

一、 There is no problem when print with the SD card testing file. But something happened when print the other models, you can analyze the problems as below:

(1) Broken surface problem (errors occurred when previewing print path) Cura face correction option and Netfabb auto repair;

(2) Model drawing or hanging material



1. print temperature decreased 5-10

2. Increased retraction speed and length in Cura

3. material properties

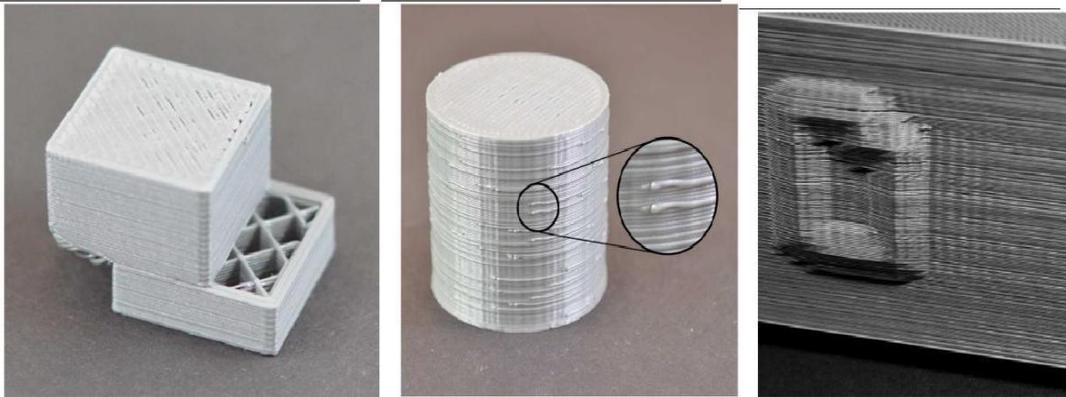
二、 Problems during the printing process

(一) The first layer and the first few layers

Consumables can not stick	Poor adhesion of the platform; Filament out is not very easy.	Poor platform adhesion: (1) The platform is too high or too low: the distance between the nozzle and the platform is too far, the material attachment area is too small, and the material is too late to be adhered by the nozzle; too close to the gap, the material cannot be extruded or the material is intermittent; (2) can be coated with masking glue or high temperature double-sided adhesive on the textured paper; (3) Adjust the leveling spring knob below the platform, and adjust the distance between the platform and the nozzle through the compression spring; (4) If the platform has reached the maximum of the leveling spring, adjust the position of the Z limit switch or remove the nozzle kit, loosen the red block screw, and adjust the upper and lower position of the red block;
Not filled	Platform is too low Insufficient feed Unsmooth discharge	
Edge warping	PLA edge warping: Platform is not adjusted; Use "Raft" when slicing	
Temp Error (min/max)	Thermistor not connected; Thermistor is broken (see Appendix for details)	
The fan on the motherboard did not work		(1) Make sure the fan is good; (2) Check if the wiring on the fan is correct and there is no looseness; (3) Adding the pedestal to the main board fan at the beginning of the slicing process does not work. It takes a while for the fan to work. Manually adjust the "fan speed" to the maximum. If it is not working, adjust the fan speed for more times or wait for a while.
Temperature does not go		(1) Check if the heating pipe connection or the heating pipe is

	<p>broken;</p> <p>(2) The LCD display shows with a wrong temperature, there is a problem with the thermistor, try replace another thermistor;</p>
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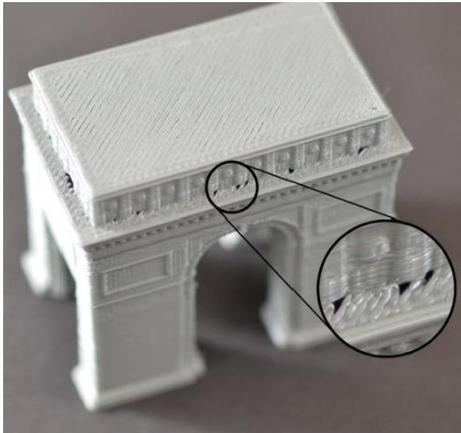
(二) During printing



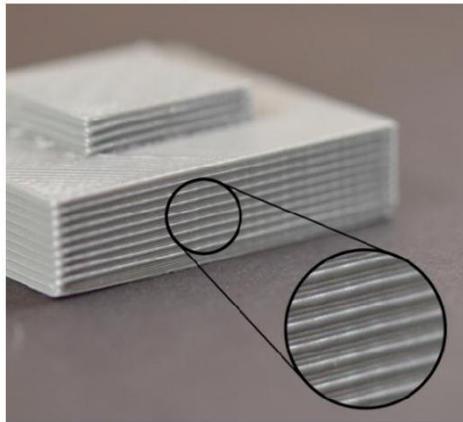
Transfer/displacement (X or Y direction)	<p>(1) Check whether the motor synchronous wheel is tight and the belt is tight;</p> <p>(2) Wrong slice model, re-sliced and printed;</p> <p>(3) Model problem Re-slicing or dislocation, change the previous successful model, if it is normal, repair the model;</p> <p>(4) Motherboard problems The above problems cannot solve the problem of misalignment, and the most common problem is that any model that prints is at the same height misalignment and replaces the motherboard.</p>
Spots and scars on the surface	<p>Increase the speed and length of retraction in the slicing software;</p> <p>change the flow and reduce the temperature 5-10°C</p>
Vibration and fret	<p>(1) The printing speed is too fast, the recommended speed is 50mm/s</p> <p>(2) Check the anti-backlash nut and Z-axis, grease the Z-axis properly</p>

Pause printing	(1) LCD appears wait for turn off the enabled plug-ins in the slice software Cura ; (2)the temperature of the mother board is too high, causing the printer stop printing, make sure the fan of the mother board works during printing.
Dead / garbled	Change the motherboard
Printing model is not robust	(1) Improper setting of parameters during slicing (2) whether the extruder gear is properly installed and locked (3) nozzle plug to clean the nozzle
Filament out is not very easy, intermittent, extruder gear rebound and "click" sound (see appendix for details)	Clear the nozzle and adjust the temperature of the PLA to 220° Video: http://pan.baidu.com/s/1c2s0lq?qq-pf-to=pcqq.c2c

(三) finish printing



Holes



Side linear texture

<p>Holes and gaps in the corners or holes in the top layer</p>	<p>(1) Adjustment of wall thickness When the distance is less than the diameter of the nozzle, the models cannot be filled and they are empty. Adjust the wall thickness or adjust the fill density at this time;</p> <p>(2) Insufficient number of top-level Increase the thickness of the top layer in the slicing software;</p>
<p>Side linear texture</p>	<p>(1) Printing Platform Rocking</p> <p>(2) The Z axis screw is not installed correctly or the Z axis is not straight</p> <p>(3) The three axes are loose, check the tightness of each shaft installation</p>
<p>Prints out the surface of the model</p>	<p>(1) The nozzle temperature is too high, the filament melts too fast and the flow build-up overflows to print the outer layer;</p> <p>(2) The flow of consumables is too large. The slicing software has consumables flow settings. The general default value is 100%. Reduced to 80% printing;</p> <p>(3) There is no set error for the consumptive material limitation. Consumables are limited in the slicing software. The default value of each open source software is not always the same. There are two types of consumables on the market: 1.75mm and 3.00mm. The use of 1.75mm consumables is limited to the software. : The "1.75", 3.00mm consumables are limited to "3.00" in software.</p>

Z axis slide up and down not very smoothly	(1) Adjust the 2 screws of the anti-backlash nut to change the tightness of the anti-backlash nut or re-install the anti-backlash nut; (2) Z-axis lubricated or Z-axis bent
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—、the nozzle is shaking

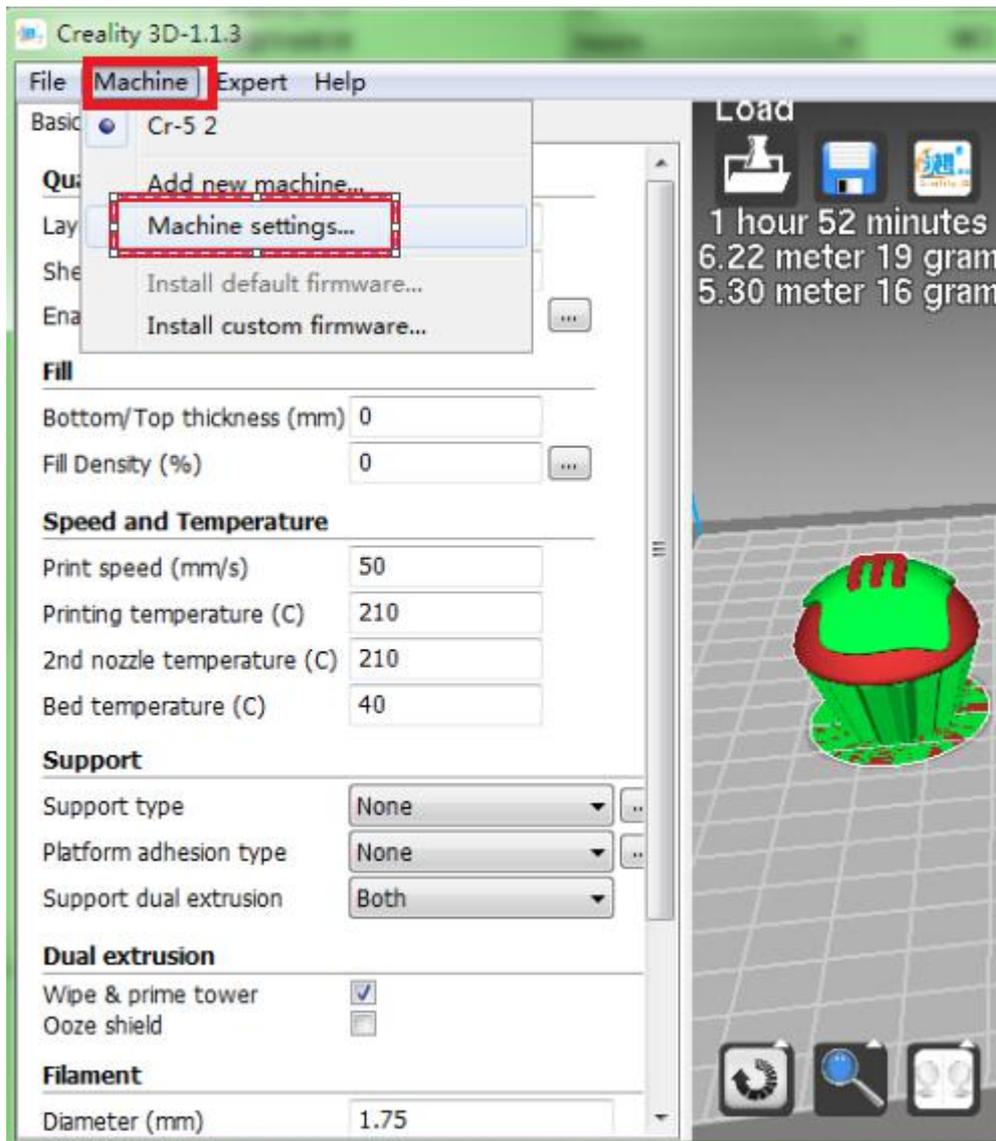
When the pulley at the nozzle shakes, loosen the X-axis synchronous wheel and take off the belt, guide tube and nozzle kit, loosen the fan cover screw, adjust the lock pulley nut, and then set it on the X axis to see if it is not shaking.

Select the wrong slicing software machine type

When the model selection is wrong after installing the software, how to set it? First select the machine settings

Then choose to add the machine type, according to the instructions below, and finally modify the parameters such as the print size according to the type of the machine you purchased.

(1) Click "machine" to select "Machine settings";



(2) select to add the machine type

Machine settings

Cr-5 2

Machine settings

E-Steps per 1mm filament	0
Maximum width (mm)	300
Maximum depth (mm)	225
Maximum height (mm)	320
Extruder count	2
Heated bed	<input checked="" type="checkbox"/>
Machine center 0,0	<input type="checkbox"/>
Build area shape	Square
GCode Flavor	RepRap (Marlin/Sprinter)

Extruder 2

Offset X	0.0
Offset Y	0.0

Printer head size

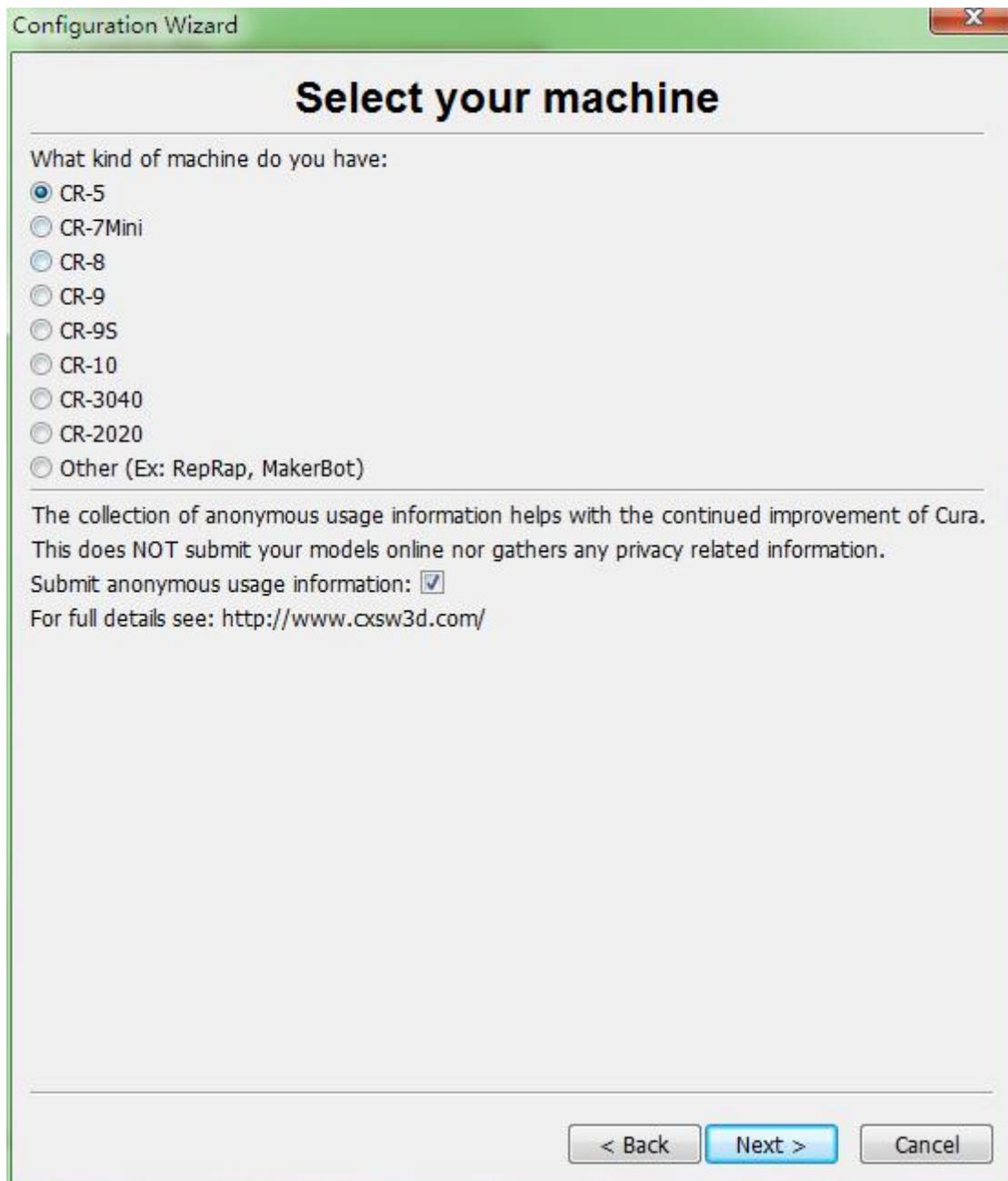
Head size towards X min (mm)	0
Head size towards Y min (mm)	0
Head size towards X max (mm)	0
Head size towards Y max (mm)	0
Printer gantry height (mm)	0

Communication settings

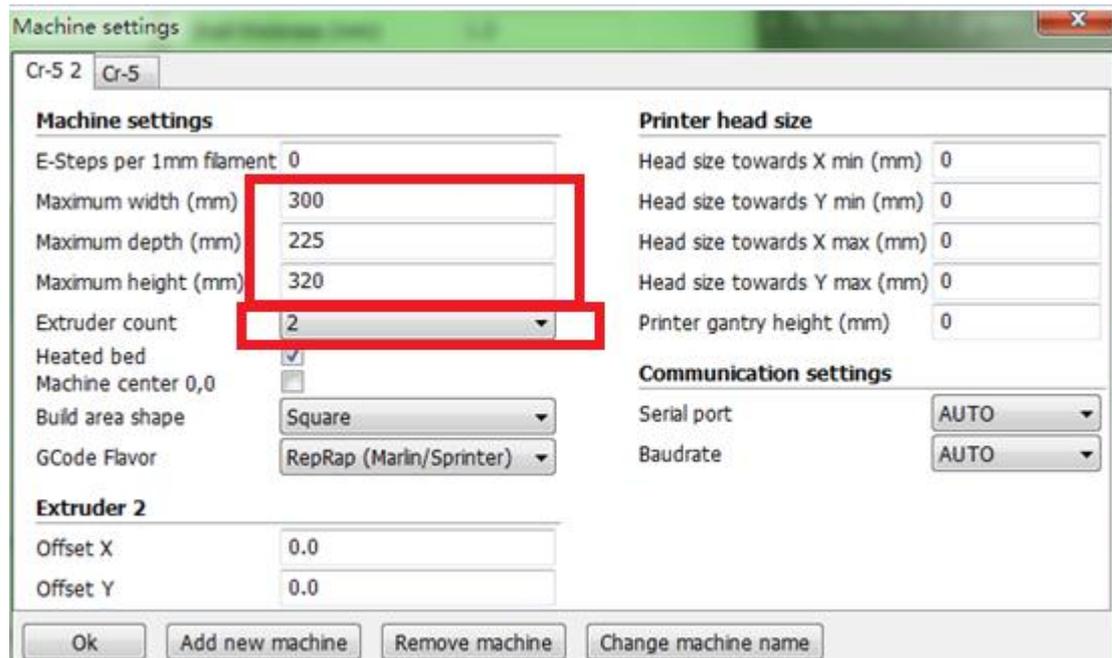
Serial port	AUTO
Baudrate	AUTO

Ok Add new machine Remove machine Change machine name

(3) set the machine type



(4) Machine type setting - Set the print size and corresponding parameters according to your machine model.



Reference parameter settings

The reference parameters of the CR-7 and CR-8 are the same, but CR-7 does not have a hot bed temperature setting. The recommended temperature of the soft rubber is 215-230 (different filament, the temperature is different)

