FEIDER MACHINES

3D-PRINTER

X-PRINT

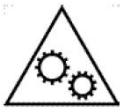
USER GUIDE

CAUTION: Read the instructions before using the machine!

CONTENTS

1. SAFETY INSTRUCTIONS

To avoid any unnecessary damage to the printer or individual injury, please always follow the safety instructions when assembling and using the machine.

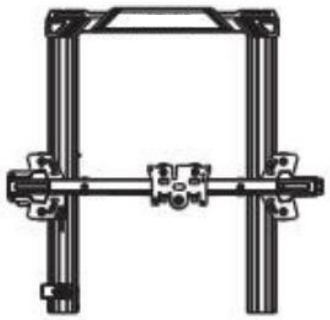
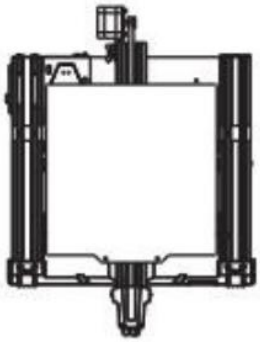
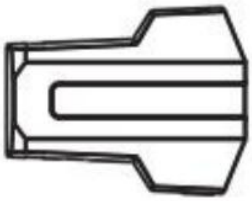
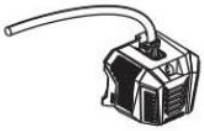
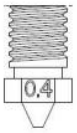
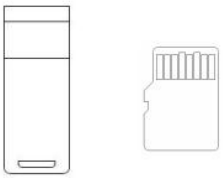
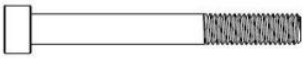
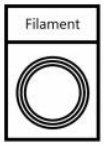
	Please contact our customer service first if you have any problem after receiving the products.
	Be cautious when using the scraper. Never direct the scraper towards your hand.
"ON" (power)	In case of emergency, please immediately cut off the power of 3D printer and contact the technical support.
 "OFF" (power)	
	3D printer includes high speed running parts that can cause injury. Keep body parts away from moving parts.
	3D printer generates high temperature. Do not reach the printing area during operation.
	It is recommended to use protection glasses when cleaning/sanding the printed models to avoid small particles in eyes.
	Keep the 3D printer and its accessories out of the reach of children.
	Vapors or fumes may be irritating at operating tem perature. Always use the 3D printer in an open and well ventilated area.
	3D printer must not be exposed to water or rain.
	3D printer is designed to be used within ambient temperature ranging 8ºC-40ºC, and humidity ranging 20%-50%. Working outside those limits may result in low quality printing
	Do not disassemble 3D printer, please contact technical support if you have any question.
	Alternating Current
	Protective earthing terminal. The apparatus should be connected to a mains socket outlet with a protective earthing connection.

CE	The product complies with the applicable European directives and an evaluation method of conformity for these
	WEEE symbol. Waste electrical products should not be disposed of with household waste. Please recycle where facilities exist. Check with your Local Authority or local store for recycling advice.
	For indoor use only

2. TECHNICAL SPECIFICATION

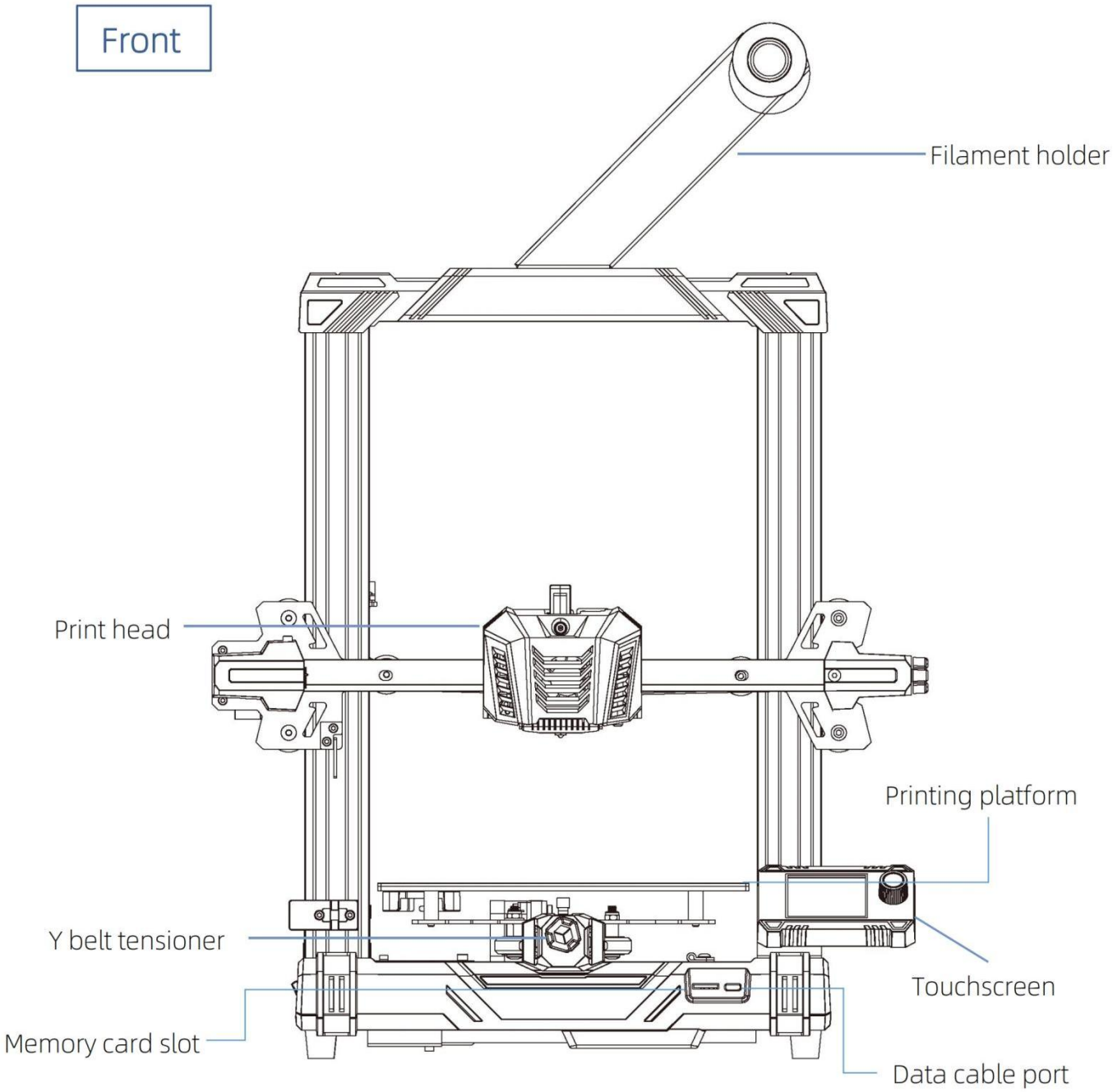
Printing	
Technology	FDM (Fused Deposition Modeling)
Build Size	220 mm(L) × 220 mm(W) × 250 mm(H)
Layer Thickness	0.05 - 0.3 mm
Positioning Accuracy	X / Y / Z 0.0125 / 0.0125 / 0.00125 mm
Extruder Quantity	Single
Nozzle Diameter	0.4 mm
Supported Materials	PLA, ABS, HIPS, TPU, Wood, etc
Recommended printing speed	60mm/s
Temperature	
Ambient Operating Temperature	8 °C - 40 °C
Operational Extruder Temperature	Max 260 °C 200 °C is suggested for PLA 230 °C is suggested for ABS 190 °C is suggested for TPU
Operational Print Bed Temperature	Max 110 °C 60 °C is suggested for PLA 80 °C is suggested for ABS 60 °C is suggested for TPU
Software	
Slicing Software	Cura, Simplify3D, Repetier-HOST
Software Input Formats	.STL, .OBJ, .JPG, .PNG
Software Output Formats	G Code
Connectivity	Memory card; Data cable (expert users only)
Electrical	
Power Input	230VAC, 50 Hz
Rated Power	400 W
Physical Dimensions	
Printer Dimensions	445 mm (L) × 443 mm (W) × 490 mm (H)
Net Weight	Approx. 7.4 kg

3. PACKING LIST

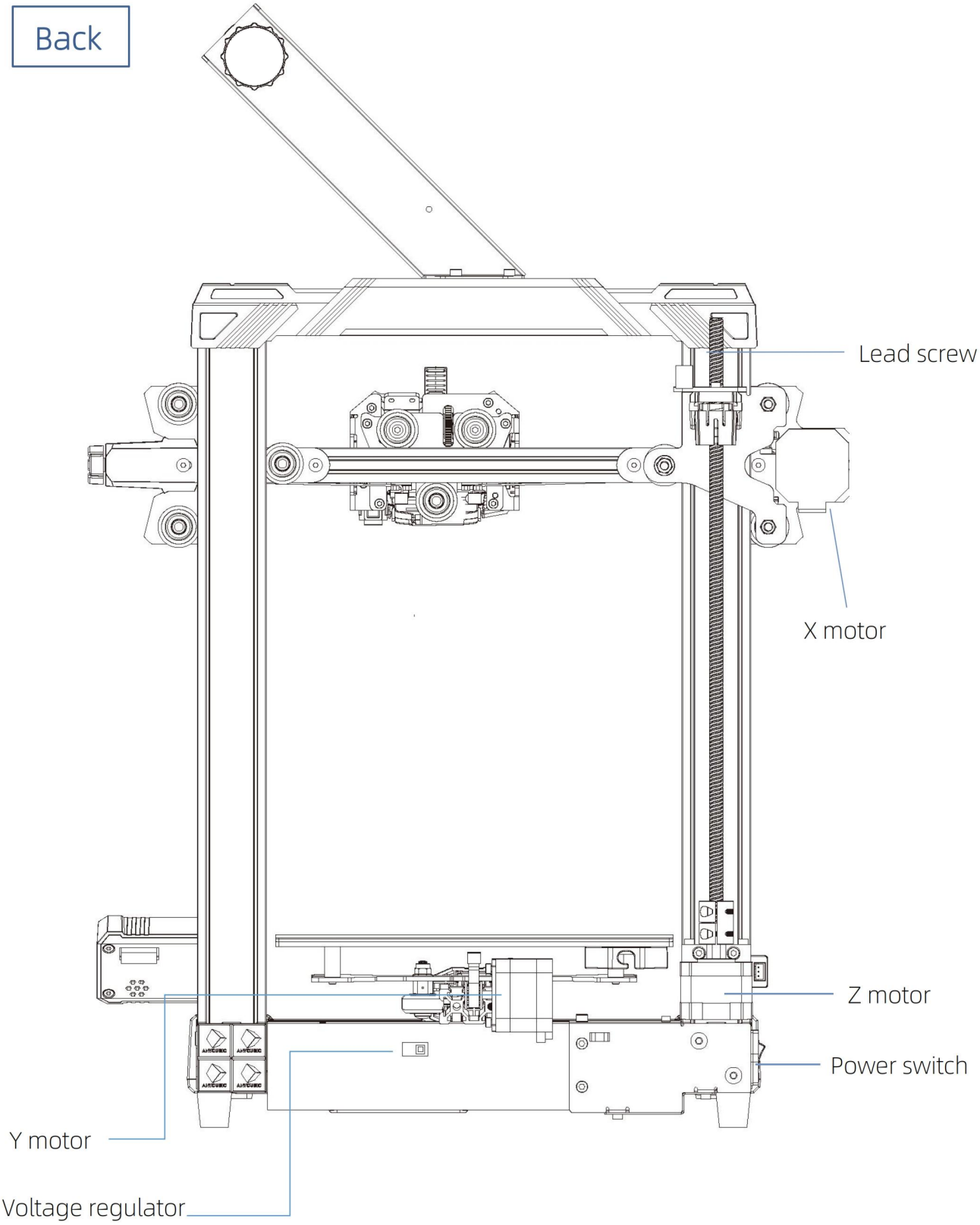
		
Frame	Base	X-axis limit switch kit
			
Touchscreen	Print Head	Filament Holder	M4 x 16 Screws (2PC)
			
M3 x 8 Screws (4PCS)	M4 x 6 Screws (2PCS)	Spare Nozzle	Card Reader Memory Card
			
M5 x 45 Screws (2PCS)	M5 x 25 Screws (2PCS)	Spring Washers (4PCS)	Filament For Test
		
Assembly Instruction	Power Cord	Tool Kit

* All pictures shown are for illustrative purposes only. The actual product may vary due to product optimization.

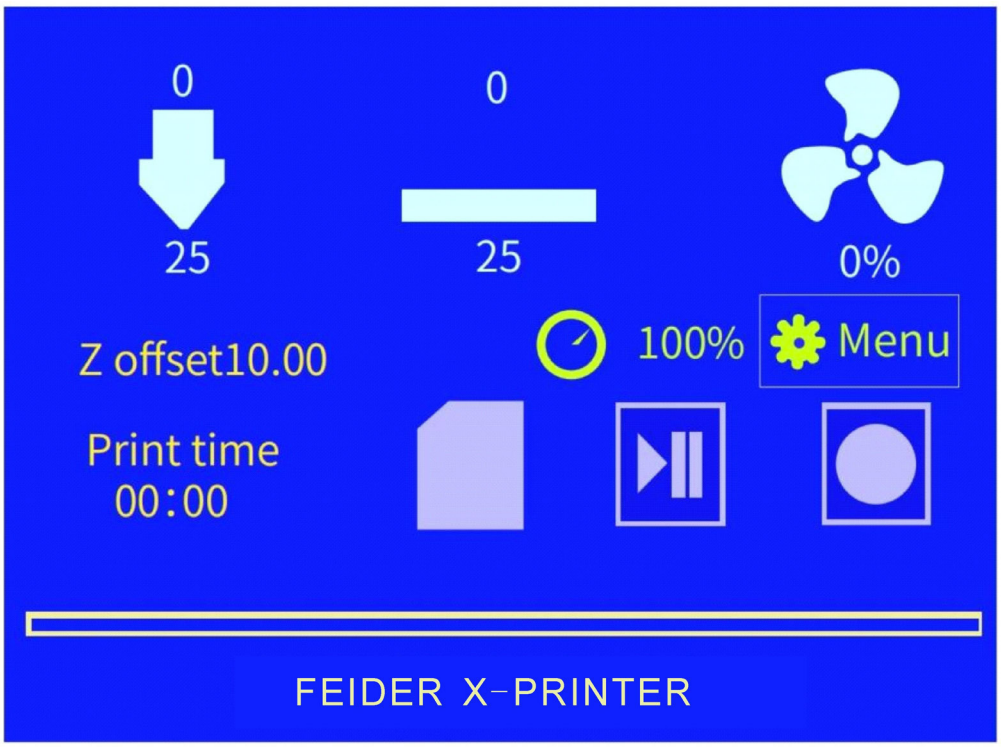
4. PRODUCT OVERVIEW

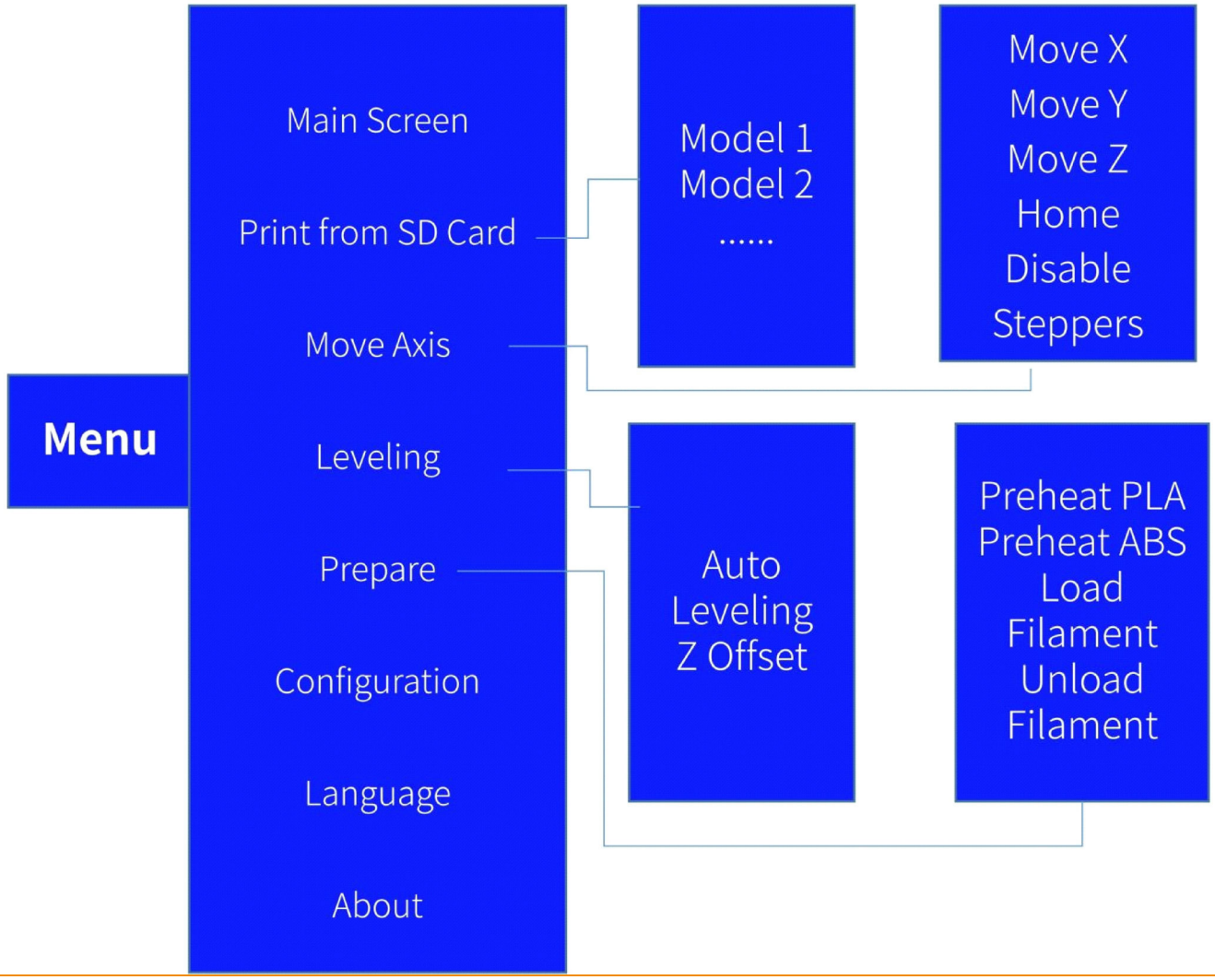


Back


Lead screw
X motor
Z motor
Power switch
Y motor
Voltage regulator

5. MENU DIRECTORY





6. INSTALLATION

1) For detailed installation procedures, refer to the installation instructions in the attachment.
2) Be cautious during assembly as some parts may have sharp edges.
3) It is suggested to use a flat desktop and place the parts in an orderly manner for quick assembly.
4) The color of some parts may be different from what in the manual, but the assembly is the same.
5) Firmware has been pre-uploaded to the motherboard. After completing the assembly, please level the platform and load the filament then you could start the first test print.

Note: Every unit of the printer has been inspected and tested for printing. Therefore, in some cases, there might be very small marks left on the print head or on the heated bed. Those will not affect the printing quality and those mean the printer has been tested for the quality. If there are some tiny scratches on the aluminum beams or slight unevenness on the platform, it is normal and won't affect the printing quality. Thank you very much for your kind understanding

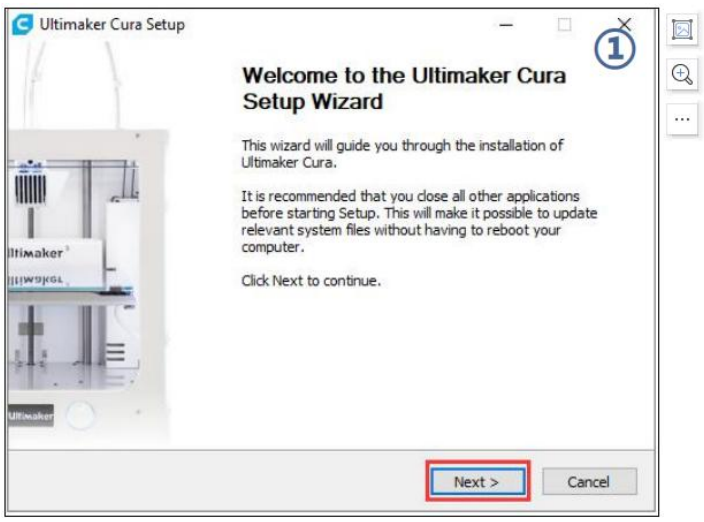
7. INTRODUCTION TO SLICING SOFTWARE

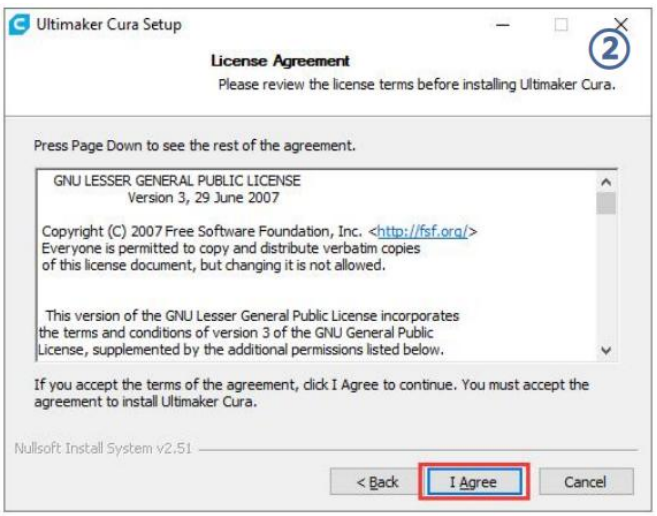
3D printer reads GCode file and prints. It is necessary to convert 3D files (such as stl file) into GCode files for machine to recognize. Software that convert 3D files into GCode files is called slicing software.
Introduction of slicing software:

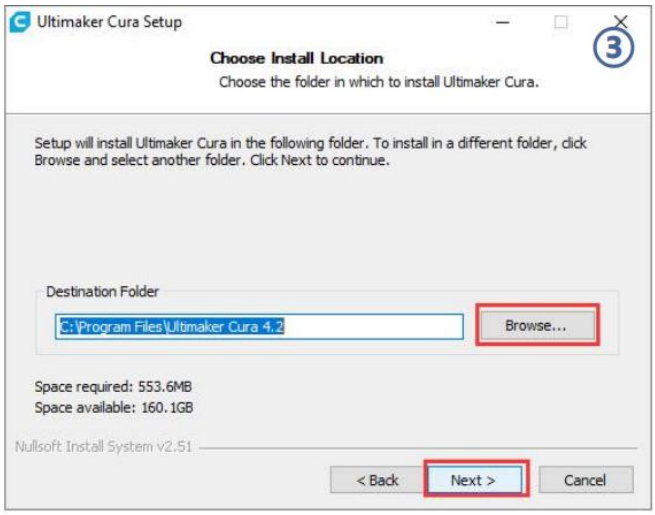
1) Cura Installation
2) Machine Settings
3) Import the Configuration File
4) Manipulate 3D model in Cura
5) Slice and Preview
6) Print Offline and Online

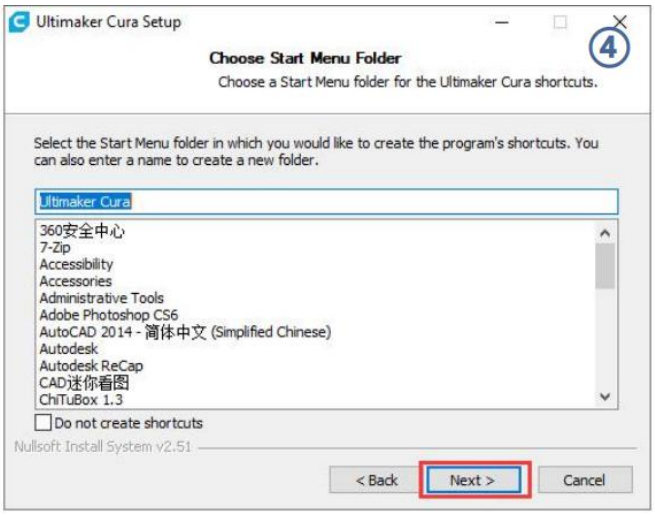
CURA INSTALLATION

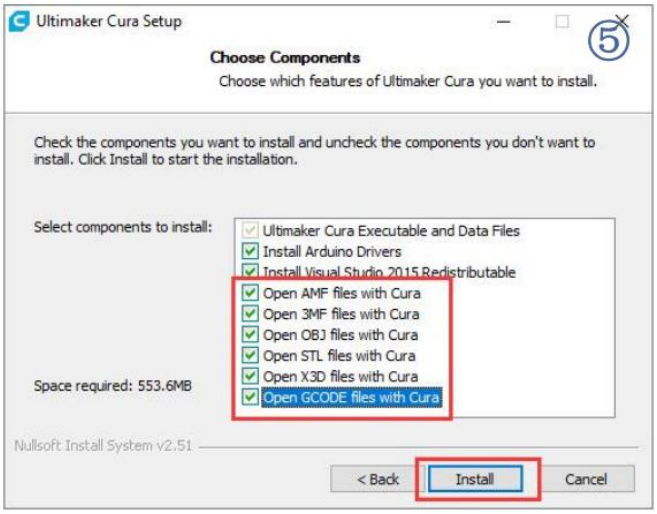
Double click **Ultimaker_Cura-4.12.0-win64**, and follow the steps as shown below.
* Ultimaker Cura 4.12.0 is used for example here, please refer to the memory card for the actual version.
* File path: Memory card → "Files_ English_FEIDER X-PRINTER" → "Cura" → "Windows" or "Mac

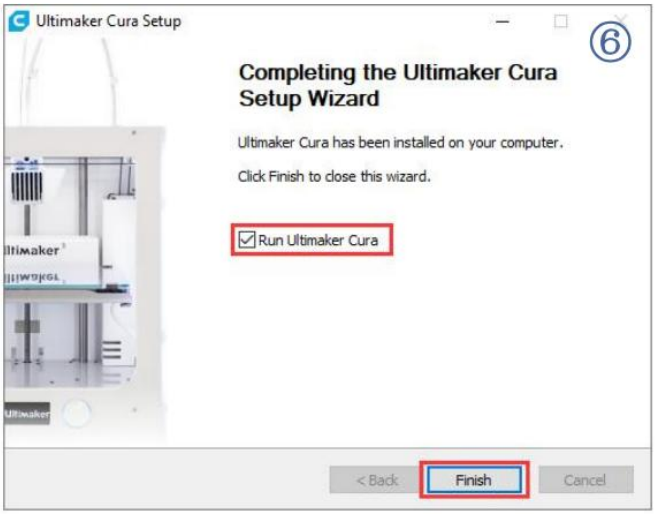




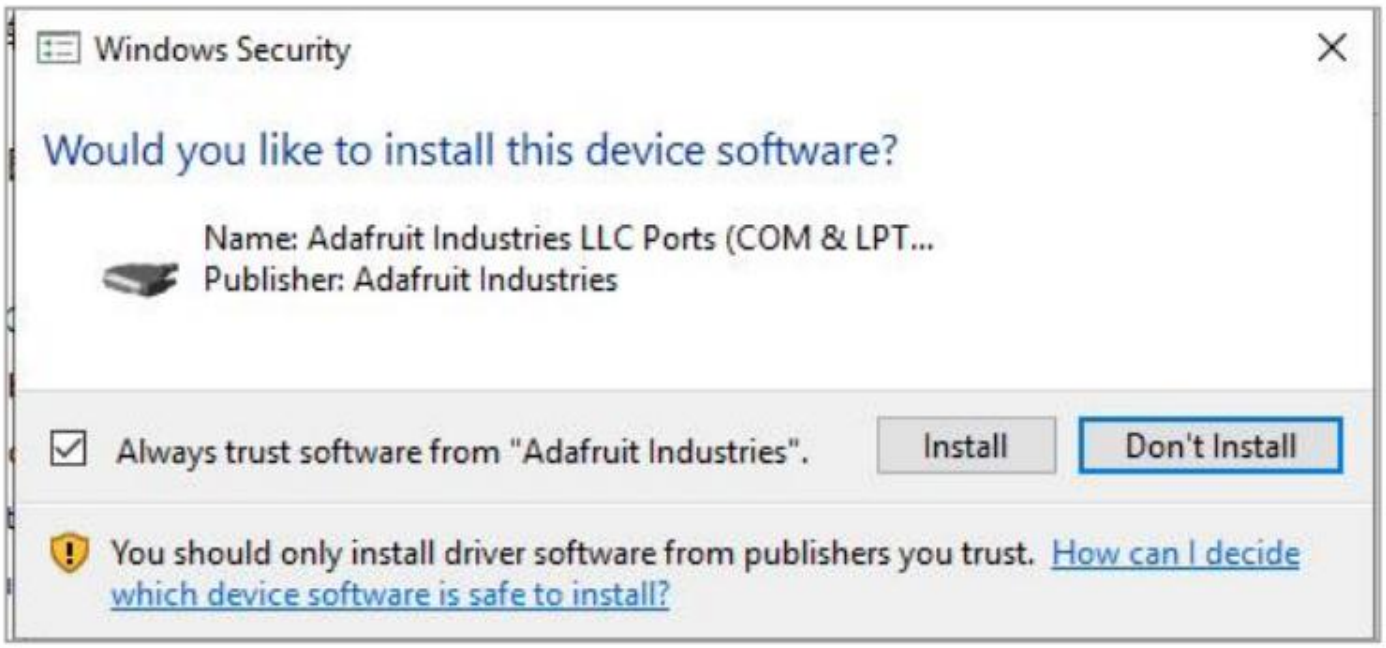






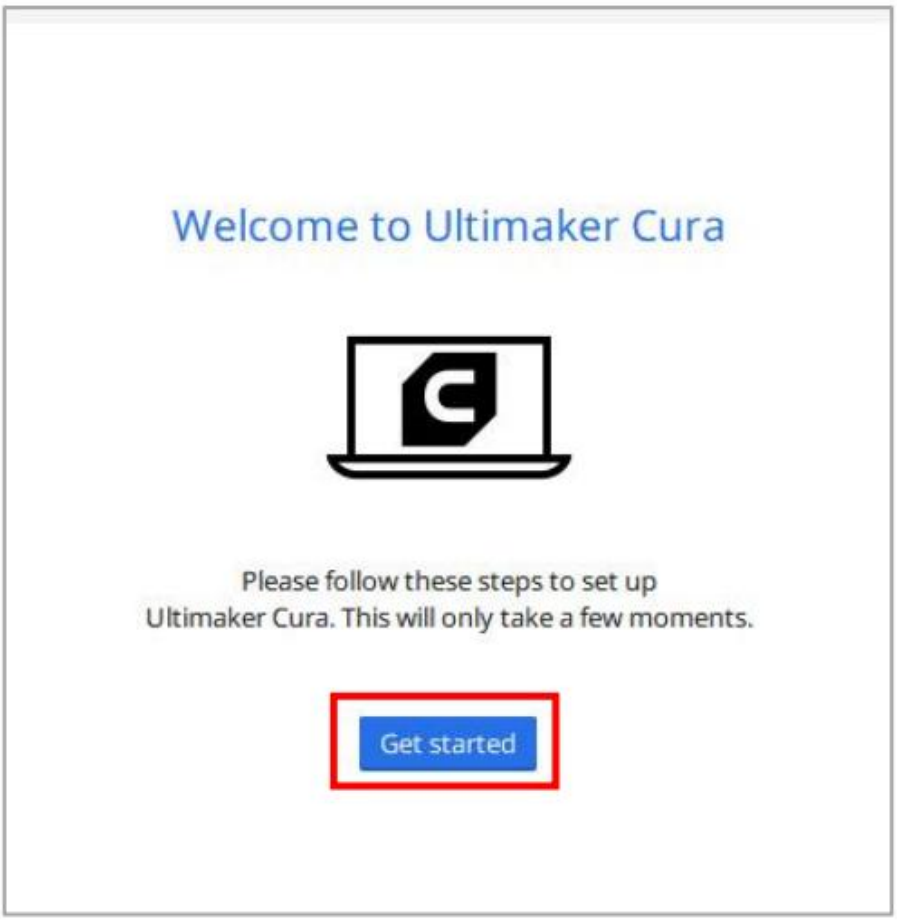


* Printing online requires the installation of a driver, as shown below. If you don't print online, you don't need to install it.



MACHINE SETTINGS

Upon completion of installation, the first launch of the software will display the following welcome screen. Click **Get started** to start the machine settings.



② What's new in Ultimaker Cura

4.12.0

Orthographic view.
When preparing prints, professional users wanted more control over the 3D view type, so this version introduces an orthographic view, which is the same view type used by most professional CAD software packages. Find the orthographic view in View > Camera view > Orthographic, and compare the dimensions of your model to your CAD design with ease.

Object list.
Easily identify corresponding filenames and models with this new popup list. Click a model in the viewport and its filename will highlight, or click a filename in the list and the corresponding model will highlight. The open or hidden state

Next

③ Help us to improve Ultimaker Cura

Ultimaker Cura collects anonymous data to improve print quality and user experience, including:

Machine types

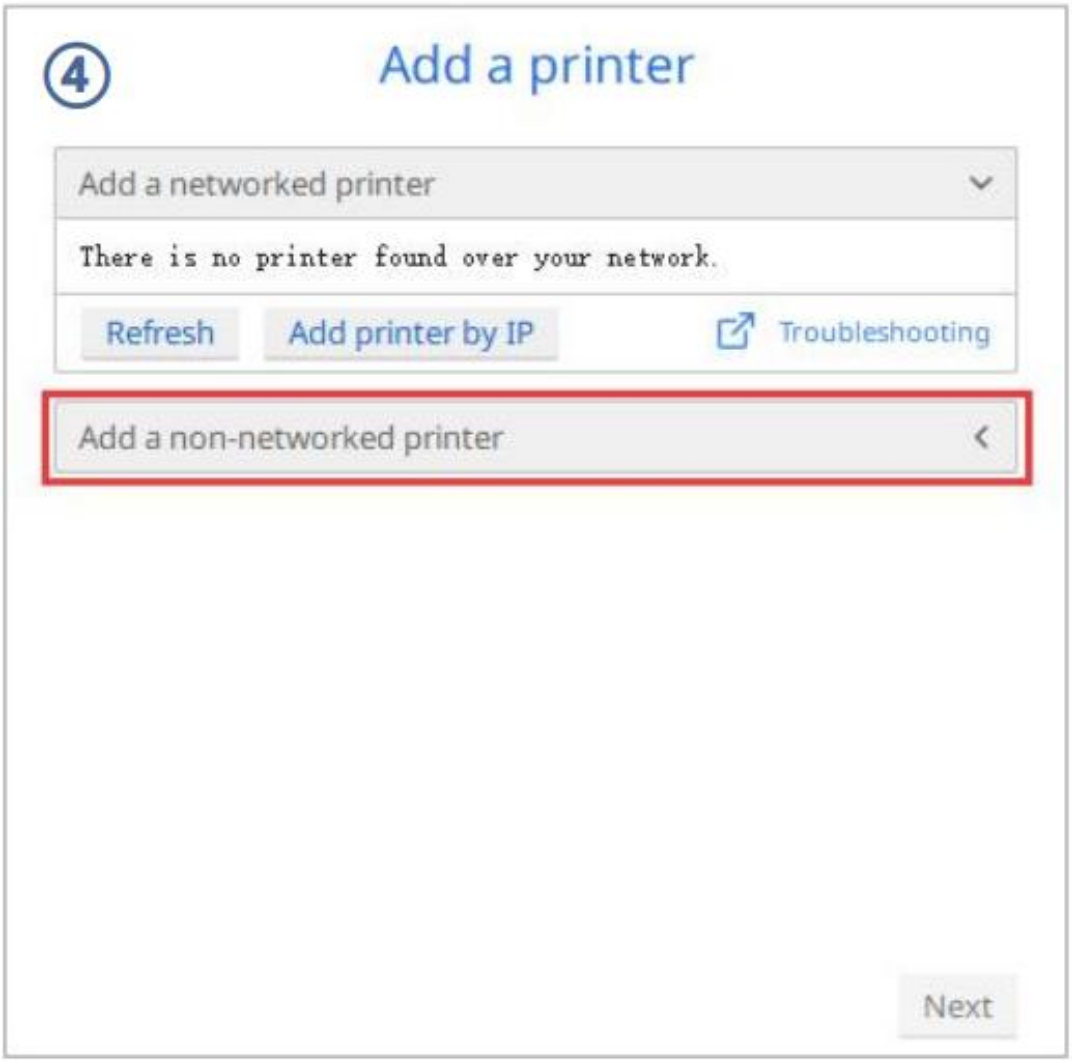
Material usage

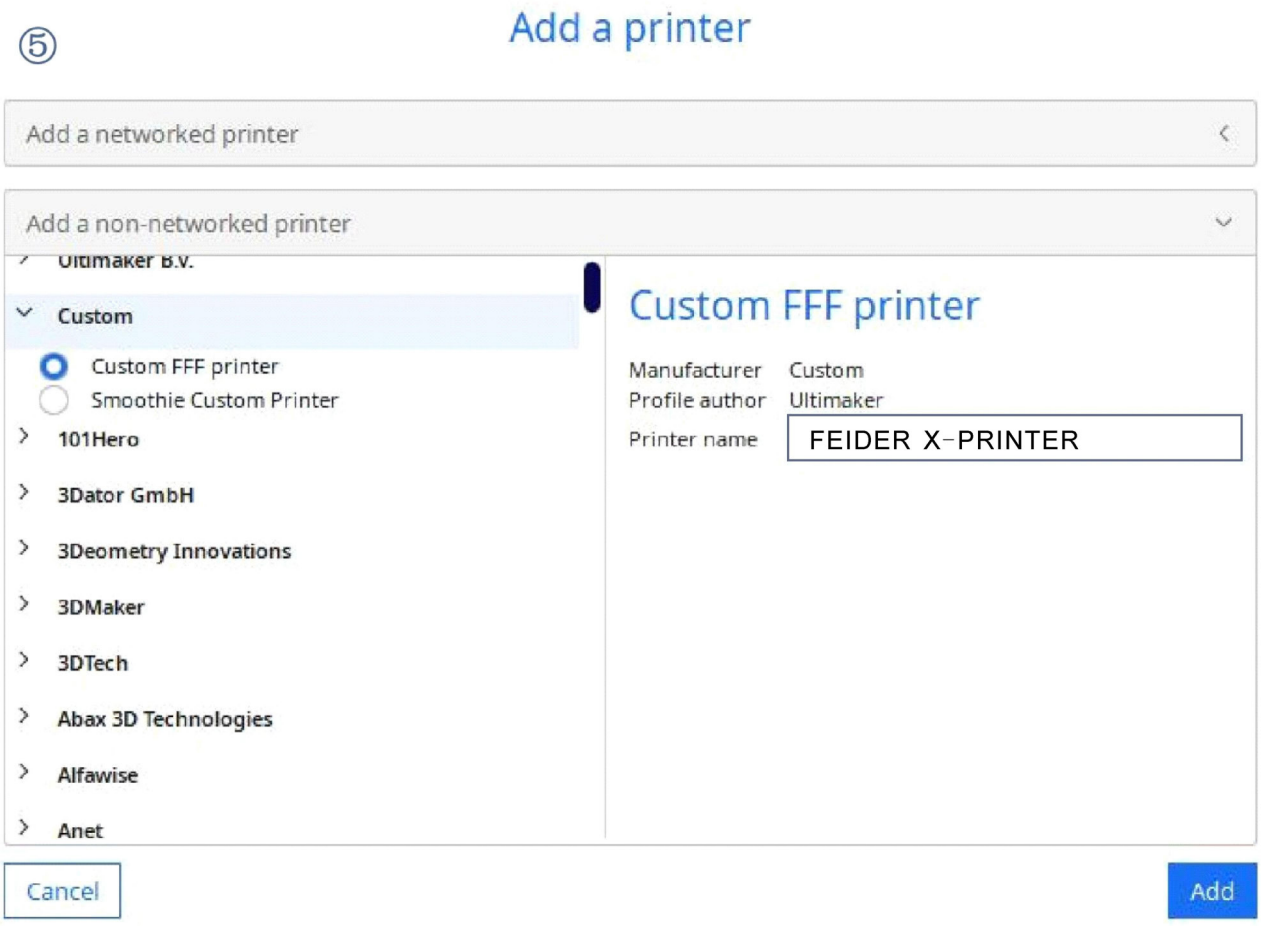
Number of slices

Print settings

Data collected by Ultimaker Cura will not contain any personal information. More information

Next


④
Add a printer
Add a networked printer
There is no printer found over your network.
Refresh
Add printer by IP
Troubleshooting
Add a non-networked printer
Next


⑤
Add a printer
Add a networked printer
Add a non-networked printer
Ultimaker B.V.
Custom
Custom FFF printer
Smoothie Custom Printer
101Hero
3Dator GmbH
3Deometry Innovations
3DMaker
3DTech
Abax 3D Technologies
Alfawise
Anet
Custom FFF printer
Manufacturer Custom
Profile author Ultimaker
Printer name FEIDER X-PRINTER
Cancel
Add

Machine Settings

FEIDER X-PRINTER

⑥

Printer | Extruder 1

Printer Settings

X (Width)	222.0	mm
Y (Depth)	222.0	mm
Z (Height)	250.0	mm
Build plate shape	Rectangular	
Origin at center	☐	
Heated bed	☑	
Heated build volume	☐	
G-code flavor	Marlin	

Printhead Settings

X min	-20	mm
Y min	-10	mm
X max	10	mm
Y max	10	mm
Gantry Height	250.0	mm
Number of Extruders	1	
Apply Extruder offsets to GCode	☑	

Start G-code

```
G28 ;Home
G1 Z15.0 F6000 ;Move the platform down 15m
```

End G-code

```
G28 X0 Y0
M84
```

Next

⑦

Machine Settings

Printer | Extruder 1

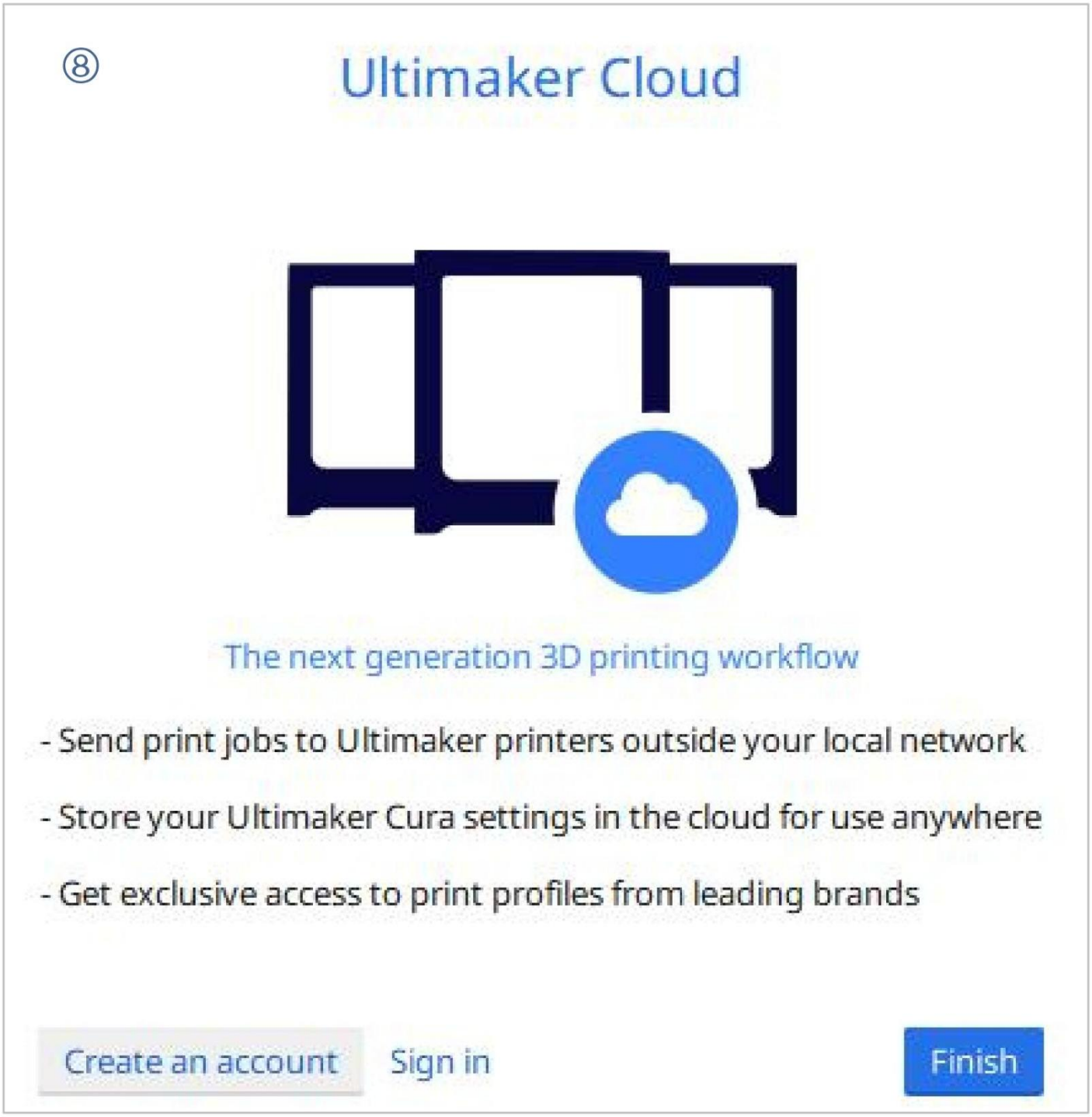
Nozzle Settings

Nozzle size	0.4	mm
Compatible material diameter	1.75	mm
Nozzle offset X	0.0	mm
Nozzle offset Y	0.0	mm
Cooling Fan Number	0	

Extruder Start G-code

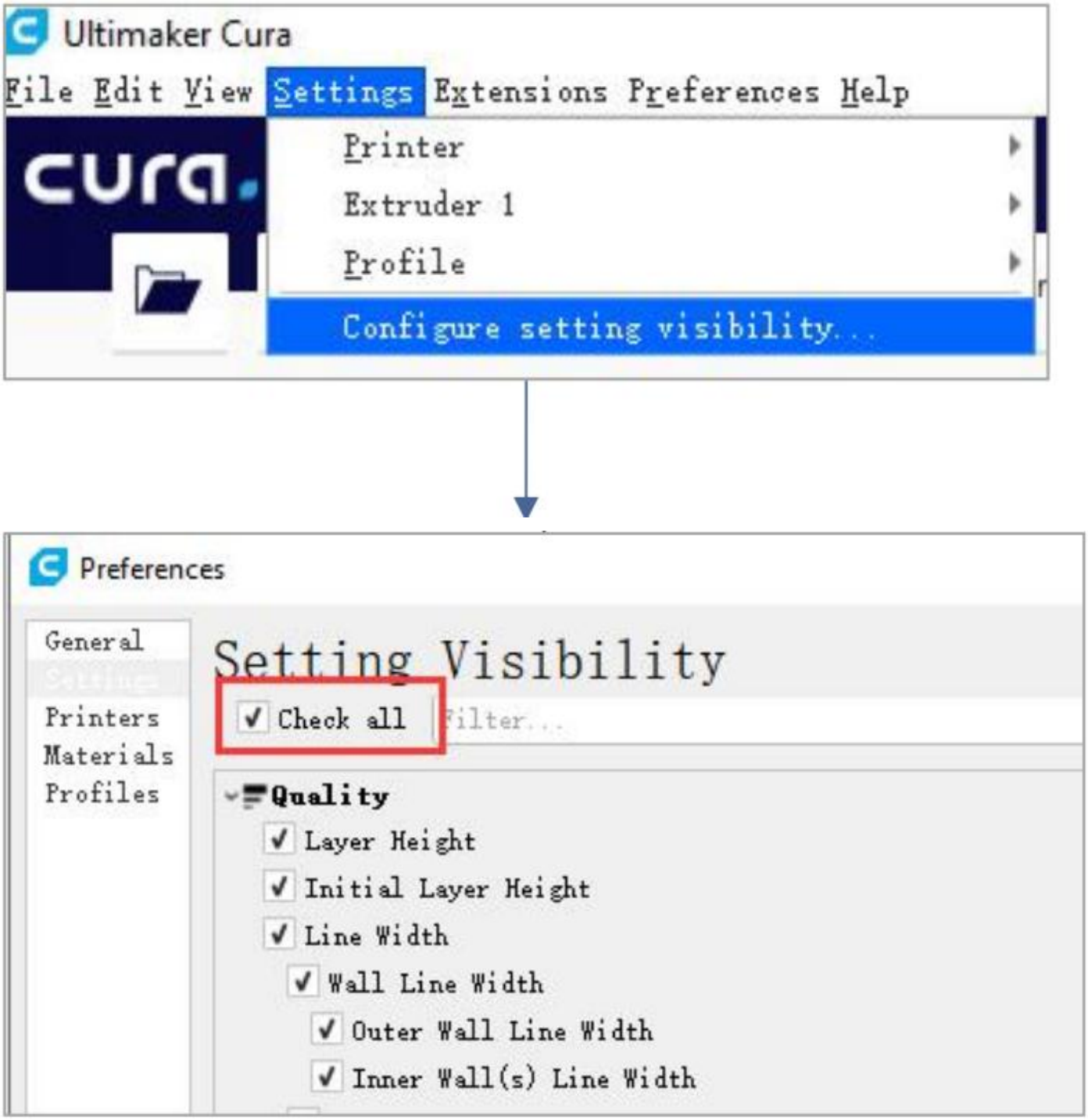
Extruder End G-code

Next



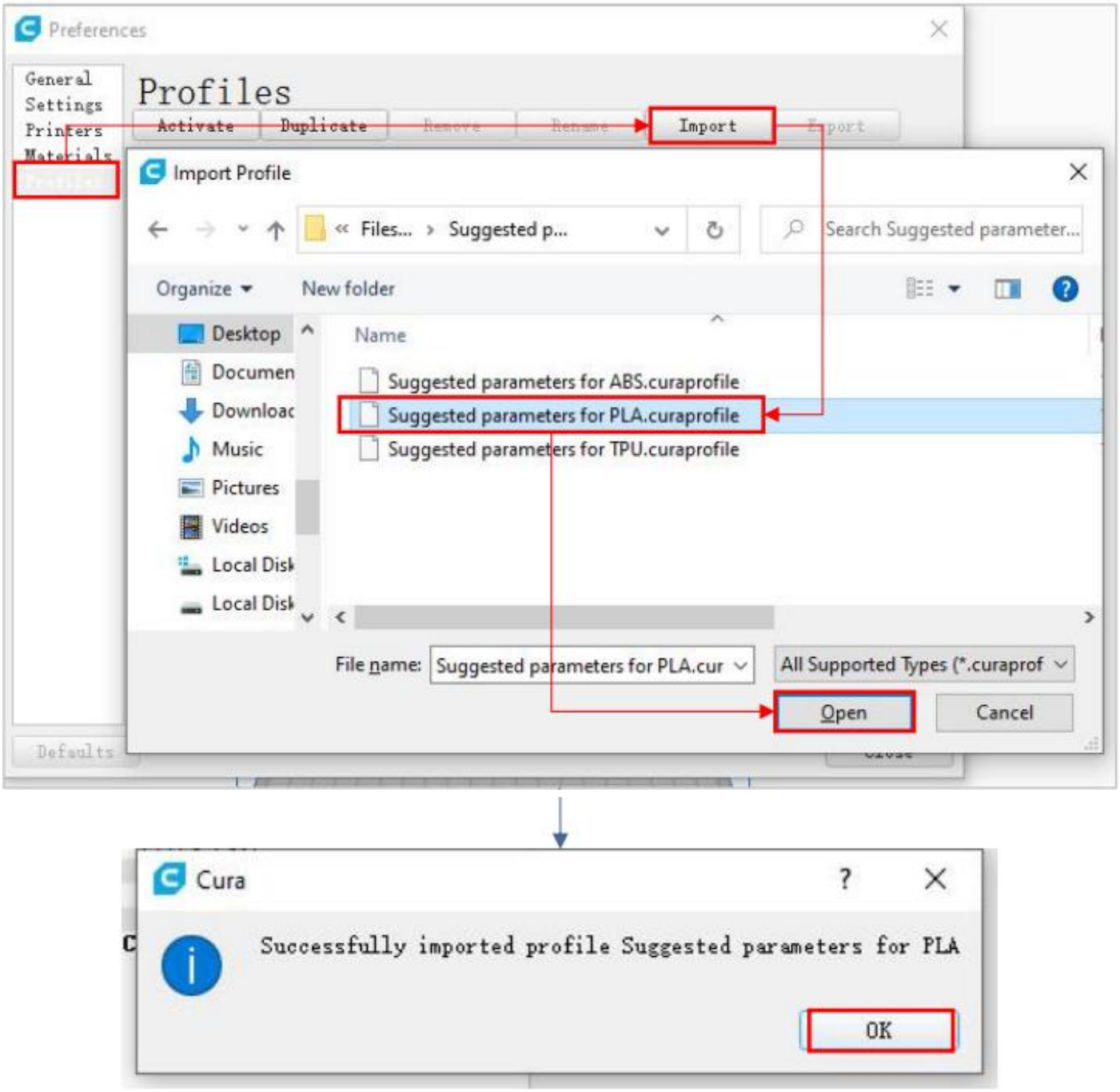
IMPORT THE CONFIGURATION FILE

After continuous testing, we provided users the suggested printing parameters of different filaments for FEIDER X-PRINTER, and the user could directly import the parameter files to the software.
(1) Click **Settings** → **Configure setting visibility...**, and then tick **Check all** box to make all settings visible.



(2) In the same interface opened in Step (1), click **Profiles** on the left side. Then click **Import** button to import the desired print profile.

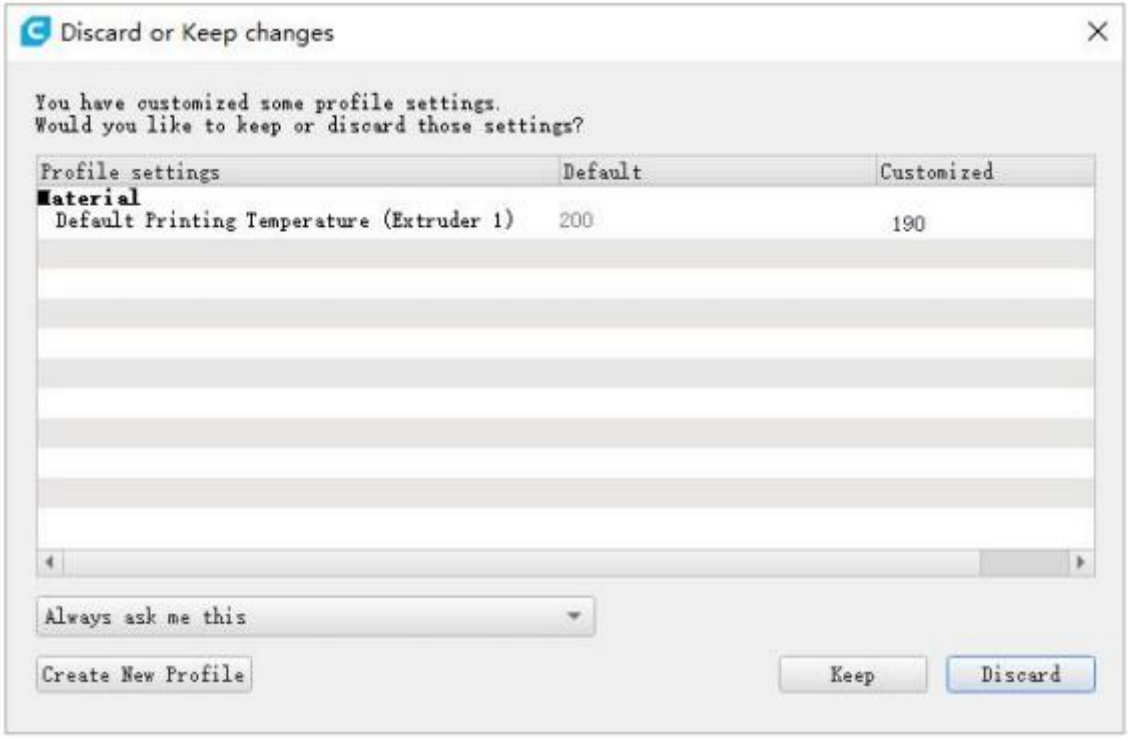
* Choose different parameter profiles according to different filament types.
* The provided profiles only match Cura 4.12.0.
* Profile path: Memory card → "Files _ English _FEIDER X-PRINTER" → “Suggested Parameters Profiles”



(3) Select the profile that you just imported, and then click the **Activate** button

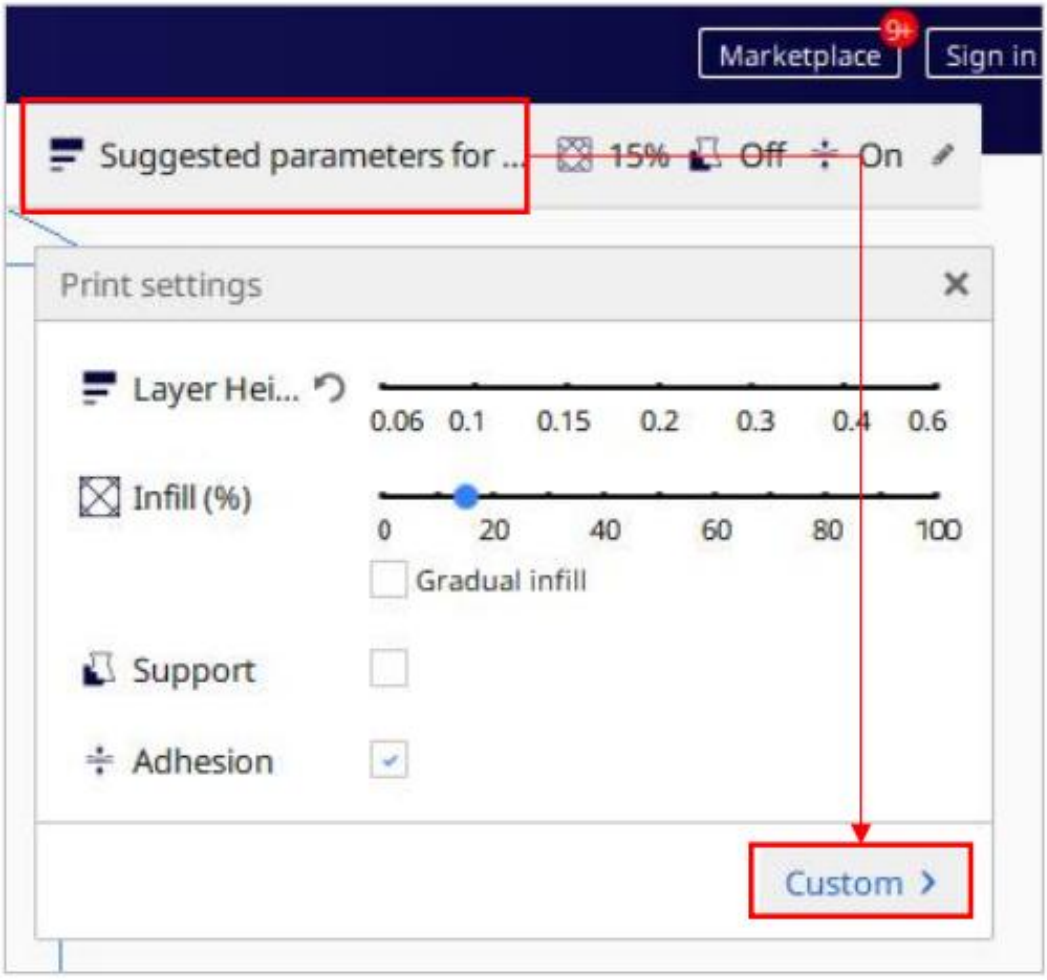
* Note: An interface may pop up after clicking the **Activate** button. If so, please check

the values of listed parameters. You can click **Keep** to keep the custom values or click **Discard** to enable the values in the profile.

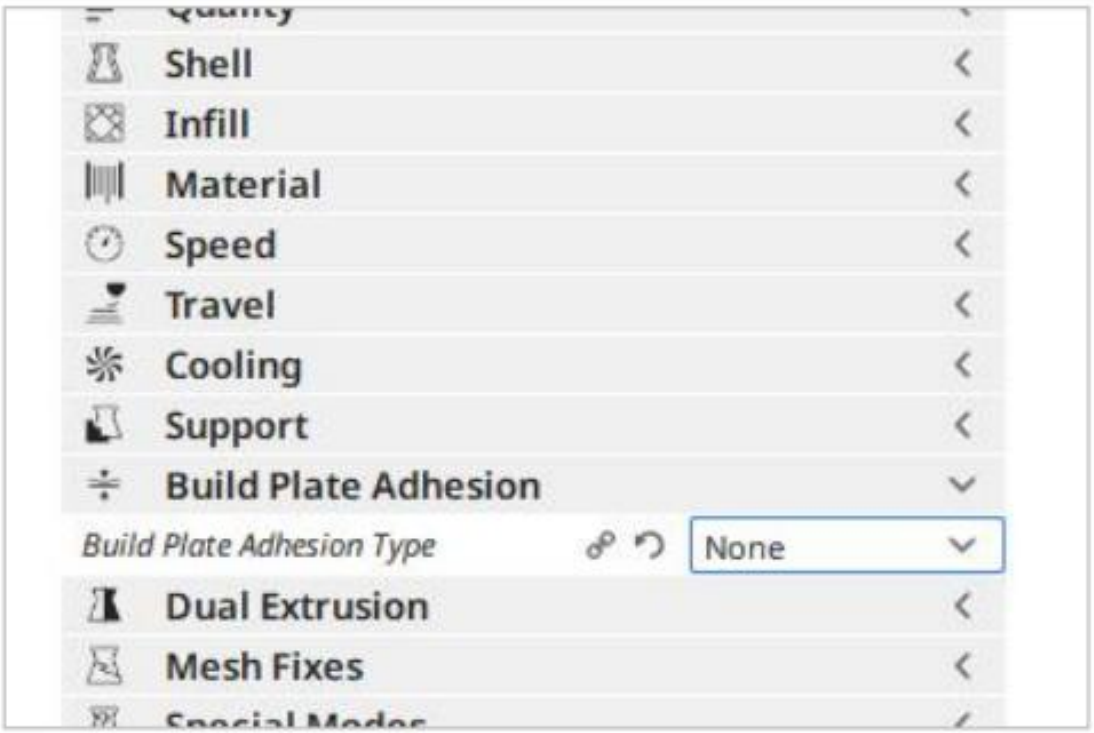


Supplementary Explanation

1) You can customize some parameters after importing the profile, but we still recommend that you use the parameters in the profile that we provided.

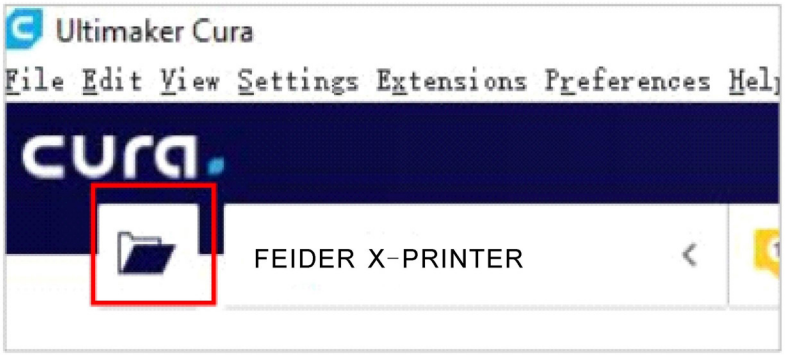


2) The parameter **Build Plate Adhesion** → **Build Plate Adhesion** Type needs to be set to “None” when you print the maximum size model.

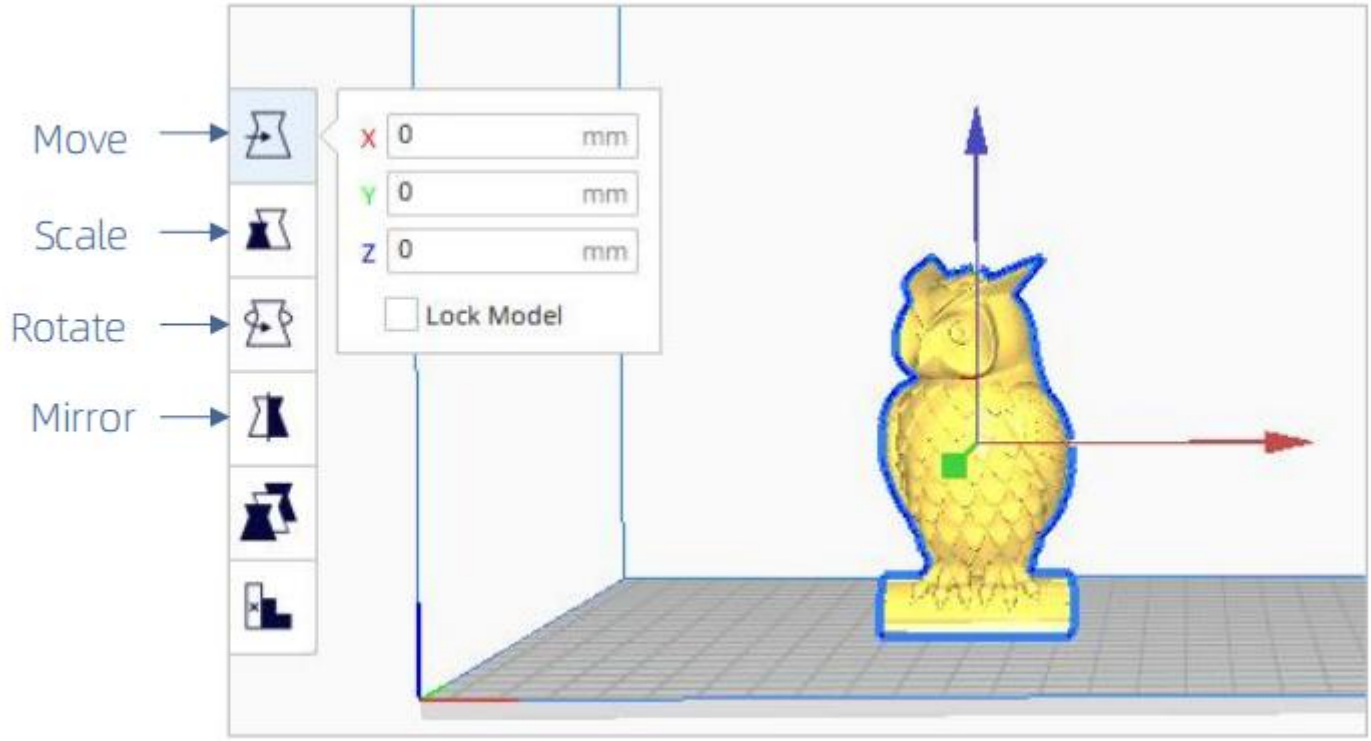


MANIPULATE 3D MODEL IN CURA

(1) Click the open file button in the top left corner to import the model file or directly drag the file into the software.



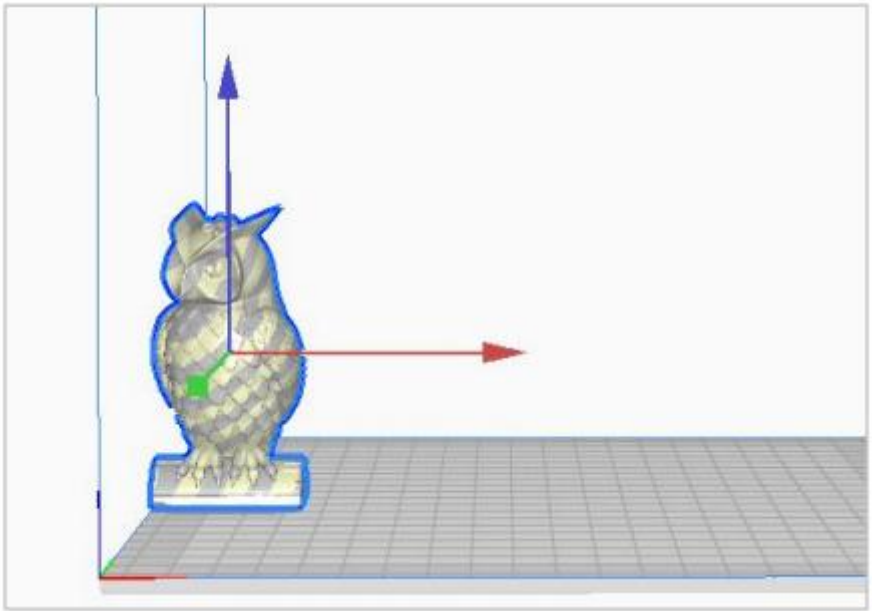
(2) Left click the model to activate the adjustment tool on the left side of the interface.
Choose one of the adjustment tool, and then click and drag the controls on the model to adjust it



The model name: owl
The author of the model: etotheipi

Other operations:
① Press the mouse wheel and move the mouse to move the platform.
② Scroll the mouse wheel to zoom in and out the platform.
③ Right click and move the mouse to change the viewing angle.

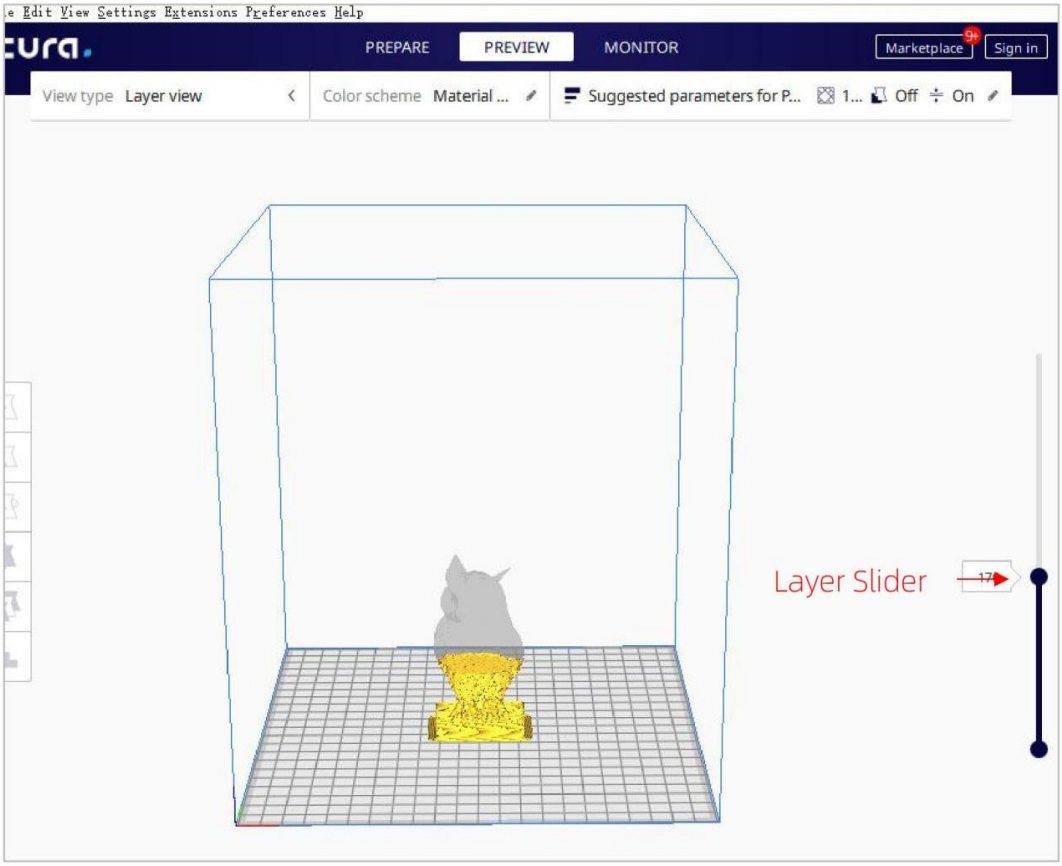
* Note: When moving the model, make sure that the model is in the printable area.
The color of the model in the following figure indicates that the model is out of print range



SLICE AND PREVIEW

Now that the configuration and print settings are in place, it's time to slice the model.
Click **Slice** button in the bottom right corner. When the process completes, it will immediately show a **Preview** button, click it to go to the preview stage.

Use the layer slider and simulation view to check important parts of your 3D slice.

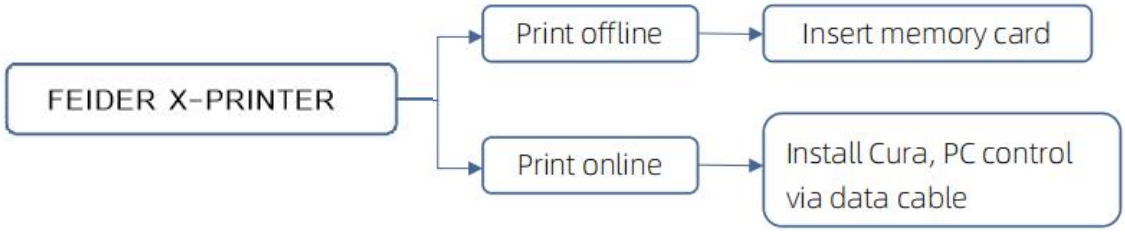


PRINT OFFLINE AND ONLINE

There are two operational modes for FEIDER X-PRINTER: print offline and print online.

• **Print offline:** Insert memory card into the memory card slot, click on the Home Menu “Print” to enter the file list, and print a selected file (GCode files ONLY).

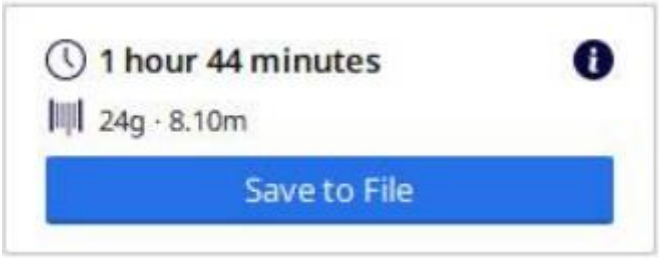
• **Print online:** Install CH340 driver to bridge PC and machine, and install Cura for slicing and control the machine to print via data cable.



It is suggested to use **Print Offline** mode to minimize the noisy signal via data cable.

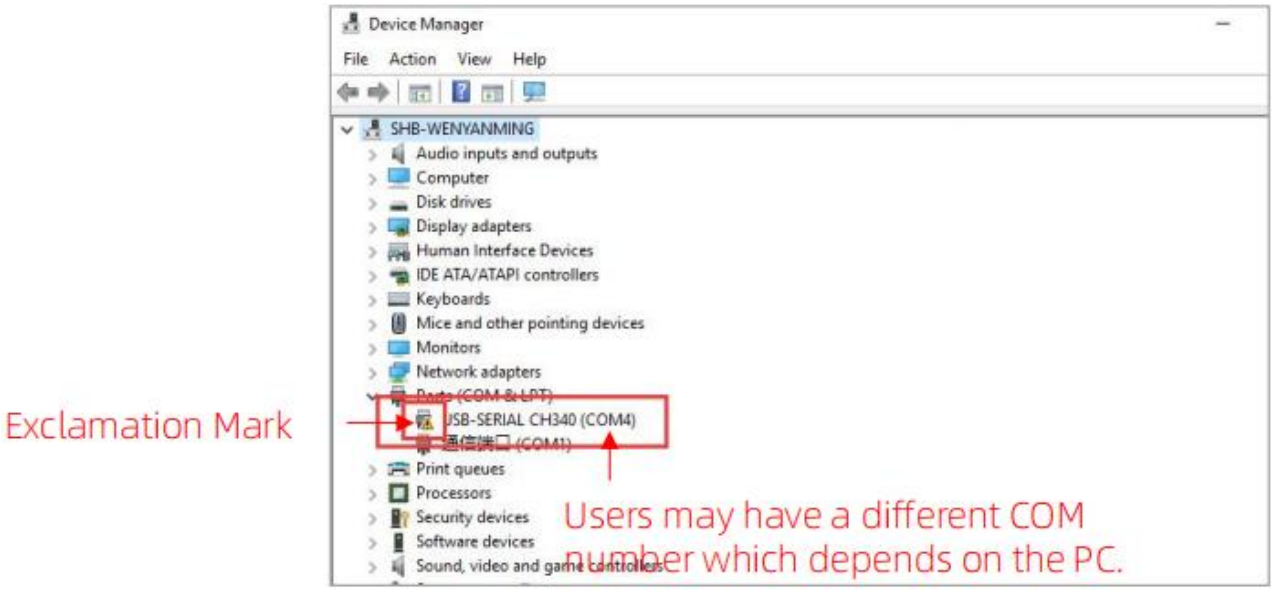
- **Print offline (Recommended)**

After slicing, click **Save to File** in the bottom right corner. Save the GCode file to the memory card, and then insert the memory card to the printer and control via the touch screen for offline printing.
* GCode file name should only contain English letters, underscore and space. File name contains special characters could not be recognized by the printer. In order to let the printer better recognize the GCode file in the memory card, you need to back up all the files in the memory card to the computer, and keep the memory card only for the GCode file. Please save all the GCode files in root directory of the memory card.



- Print online

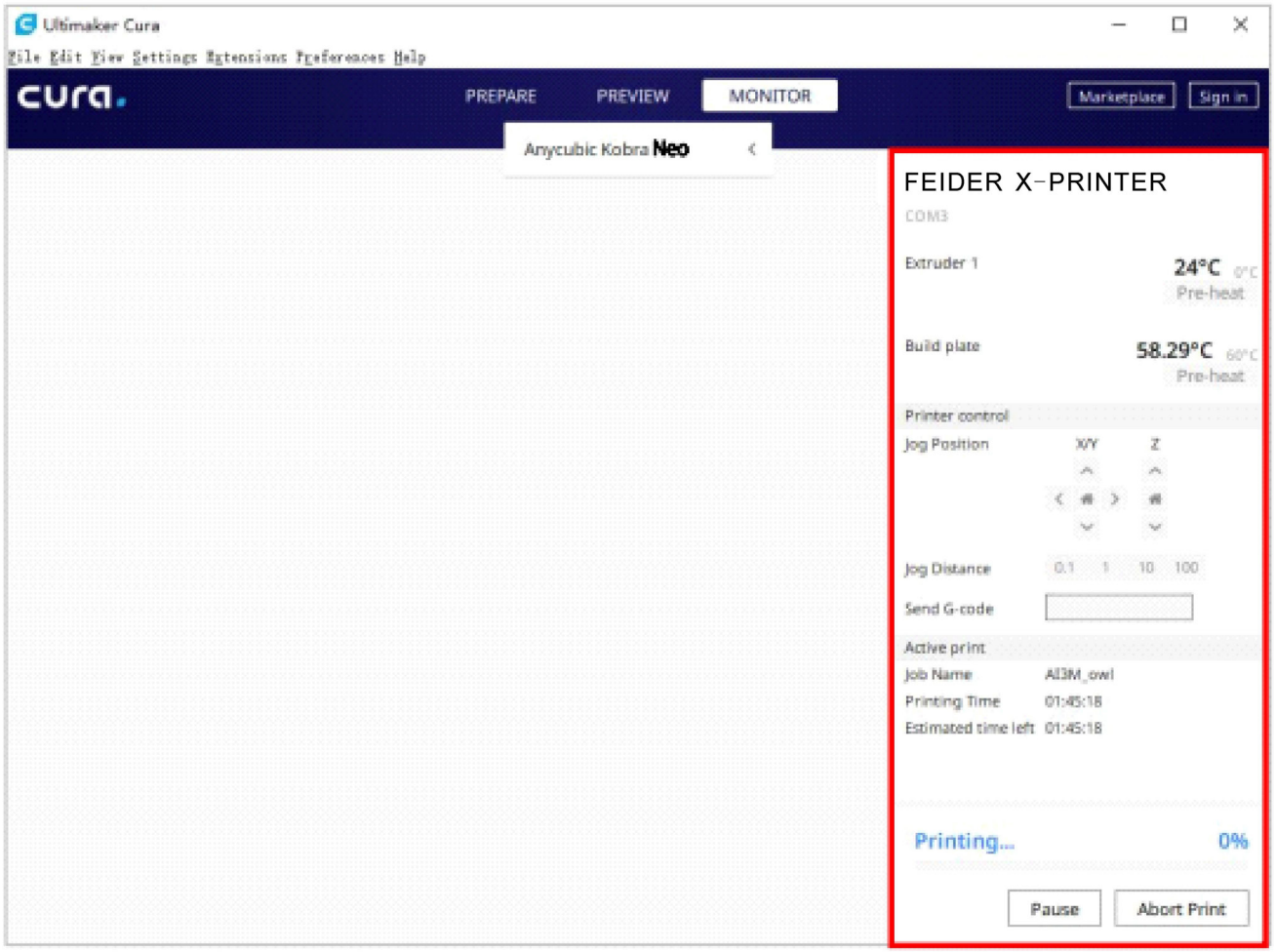
Printing online requires the installation of a driver. And you can control the printer through Cura after connecting the data cable.
(1) Turn on the machine, connect the printer (data cable port) and your PC via data cable. The driver may not be installed automatically, so it is required to check that.
Right-mouse click “This PC” → “Properties” → “Device manager”, if there is an exclamation mark as shown below, then it needs to be installed manually.
* FEIDER X-PRINTER uses CH340 chip for communication.
* CH340 driver file path: “Files_English_FEIDER X-PRINTER” → “Driver_CH341”.
There are two versions, Windows and Mac version. (* CH341 driver file is suitable for CH340 chip)



(2) Here we take Windows PC system for example. Double click “CH341SerSetup.exe” and follow the wizard to install it. **If the driver has installed automatically in step (1), skip this step.**
* After the installation is completed, refer to the method in step (1) to see if the driver has been identified (no exclamation mark).

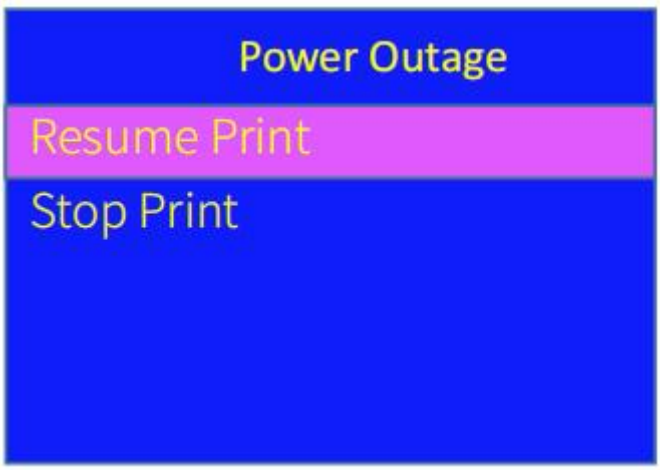
(3) After slicing, click **Print via USB** in the bottom right corner to go to the monitor stage. After waiting for about ten seconds, the operation panel will be displayed on the right side of the interface. And the printing platform will be heated up for printing.

* If the printer is not connected properly, the Monitor interface will be blank. Please plug the data cable to connect again.
* In the process of printing, do not plug the data cable, or it will interrupt the printing.
* In case of abnormal sound during the printing process, you can directly turn off the power of the machine. Please check the Troubleshooting chapter for more detail or contact Customer Service.



8. RESUME FROM OUTAGE

In case of a power loss during printing, the machine will automatically save the printing status. After restarting, you will see the interface shown below, please click
"Resume Print" to continue your printing or “Stop Prin” to cancel it.



9. MAINTENANCE

It is necessary to perform routine maintenance to the 3D printer to achieve consistent and quality results.

Some maintenance suggestions are shown as below:

1) Clean the nozzle with a needle under preheating conditions. If the filament residue in the nozzle could not be cleared 100%, please replace the nozzle.
2) Regularly add lubricating oil to smooth rods, linear bearings, lead screws, brass nuts, etc. It can minimize the wear-out failure of those moving parts.
3) Regularly clean the filament residue and dirt on the nozzle, platform, guide rail, motor, fan, etc.
4) Pay attention to the wear conditions of the D-shape wheels. Although they could be used for long time, please replace the D-shape wheels if they have been wore-out.
5) After finishing a printing, clean the printing platform to ensure the adhesion of the bottom layer of the model for next printing.
6) Check the belts regularly and tighten them if necessary.

10. TROUBLESHOOTING

1. Motor shaking or abnormal sound

① The motor cable are not connected properly. Please Check each connection and then inspect the cable routing for any faults.
② Drive current is too large / small (please contact customer service).
③ The motor is damaged.
④ The motor driving wheel is loose.
⑤ The belt is loose, please check the belt tension at each position of X/Y/Z. And whether the belt is slippery during motor movement or not.

2. File not printing or memory card failure

① Remove the memory card and insert into PC. Open the GCode files using text editor (eg. Notepad), and inspect if GCode is readable or not. If file contains of multiple “ÿÿÿ” symbol, then file has been corrupted. Try reformatting the memory card to FAT32 format and reloading the GCode file.
② Memory card is not readable, ensure file name does not contain special characters or Change memory card.
③ Touch screen freeze, reboot the machine and try again.

3. No extrusion or extrusion motor knocking

① Filaments tangled on spool or the Teflon tube is out of shape. Please straighten out the filaments and Teflon tube, and pull the filaments to observe whether the resistance is normal.
② Ensure that the nozzle temperature has been set to match the filament. (PLA is generally set at 190-210 ° C, and ABS set at 230-240 ° C)
③ Nozzle clogged. Please try to briefly heat the print head to a temperature higher than 230°C and manually push the filament into the extruder. You can also clean it with 0.4mm nozzle cleaning needle. If it doesn’t work, you may need to replace it.
④ Not enough cooling for the hotend.
⑤ The printer has been working above the maximum speed for a long time, please reduce the speed.
⑥ Check whether the extruder is normal and whether the friction force of the extruder to the filament is sufficient. Try to tighten or clean the extruder wheel.

4. Filament leaking

① Nozzle, heating block or throat tube is not tightened properly, try to fix/replace it after cooling or contact customer service.

5. Layer shifting

① Print head moves too fast, please slow down the print speed.
② Check the belts and driving wheels and ensure they are properly installed.
③ Drive current is too small.

6. No sticking to the bed

① The nozzle is too far from the platform, please try to re-level; at the same time set the "initial layer thickness" to 0.2 in Cura, and set the "initial layer line width"
(for example, set to 150) to improve the first layer adhesion.
② Print too fast at the bottom layer speed, reduce it to ~20mm/s.
③ Ensure that the print platform is clean.
④ Add a brim or raft to the model in slicing software.

7. Freezing screen

① Please check if the soft cable above the screen is loose.
② Inspect if the touchscreen has been pressed by something.
③ Check if screen has cracks, if so, please contact our after sale service via official website

8. T0 sensor abnormal

① Check the wiring of the hotend and ensure a good connection.
② Check if there is any pins bent inside the connector.

9. Print head move abnormal

① The setting of machine type in slicing software is wrong. Please see page 16 to check the right setting.

10. Print stopped halfway

① Use print offline mode (memory card) instead of print online via data cable.
② Check if the GCode file is corrupted.
② Delete plugins in the GCode file.
③ The quality of the memory card is unstable. Try changing another brand memory card.
④ The power supply voltage is unstable. Please print again when the voltage is stable.

11. Some of the structure of the model cannot be printed

① If your model includes overhangs or bridges, you may need to add support on the model or adjust the angle of the model in the slicing software. It is recommended to preview the print layer to check the printability of the model.

12. Drawing is more serious

① The retraction distance is insufficient. It should be set larger in the slicing software.
② The retraction speed is too slow. It should be set a bit faster in the slicing software.
③ The printing temperature is too high, which causes the fluidity and viscosity of the filament to be strong. The printing temperature needs to be set a little lower.

13. Nozzle is too low or too high when printing

① Nozzle is too close to the platform, resulting in insufficient extrusion of filament. Click “Settings” → “Z offset +” to rise the nozzle.
② Nozzle is too high and the gap is large, which lead to poor adhesion of filament to the platform. Click “Settings” → “Z offset -” to lower the nozzle.

ATTENTION

- 3D printer generates high temperature. DO NOT reach inside of the printer during operation. Contact with extruded materials may cause burns. Ensure no flammable materials around the equipment during operation.
- Use high temperature resistant gloves when operating the product.

- This equipment is not suitable for use in locations where children are likely to be present. Only used by instructed person and skilled person.
- The fuse rating for the printer is 250V 10A. Never replace the fuse with one of a higher amperage, otherwise it may cause fire.
- The socket-outlet shall be easily accessible.
- Please use the emergency stop switch in emergency situations

11. DISPOSAL AND RECYCLING

Electrical products should not be disposed of together with household waste. Please recycle at the collection point provided for this purpose. Please consult the local government or distributor for recycling advice. Proper handling of old equipment helps to protect the environment and health.

12. DECLARATION OF CONFORMITY

CE

BUILDER SAS

32, rue Aristide Bergès - ZI 31270 Cugnaux - France, déclare que,
Product: 3D-PRINTER
Model: X-PRINT
Serial number: 20230701901-20230703130

Is in conformity with the essential requirements and other relevant provisions of the applicable European Directives, based on the application of European harmonized standards. Any unauthorized modification of the apparatus voids this declaration.

European Directives
RoHS directive 2011/65/EU + (EU) 2015/863
Directive Machine 2006/42/EC
Directive EMC 2014/30/EU
Directive LVD 2014/35/EU

European harmonized standards
EN 55032:2015/A11:2020, EN 55035:2017/A11: 2020
EN IEC 61000-3-2:2019/A1:2021, EN 61000-3-3:2013/A2:2021
IEC 62321-1:2013, IEC 62321-2:2021,
IEC 62321-3-1:2013, IEC 62321-5:2013,
IEC 62321-4:2013+AMD1:2017 CSV,
IEC 62321-6:2015, IEC 62321-7-1:2015,
IEC 62321-7-2:2017,IEC 62321-8:2017
EN 60204-1: 2018
EN ISO 12100: 2010
EN 62368-1:2014+A11:2017

Cugnaux, 13/03/2023

Philippe MARIE / PDG
Responsible of the technical file: M. Olivier Patriarc
This declaration of conformity is issued under the sole responsibility of the manufacturer.

13. WARRANTY

The manufacturer guarantees the product against defects in material and workmanship for a period of 2 years from the date of the original purchase. The warranty only applies if the product is for household use. The warranty does not cover breakdowns due to normal wear and tear.

The manufacturer agrees to replace parts identified as defective by the designated distributor. The manufacturer does not accept responsibility for the replacement of the machine, in whole or in part, and/or ensuing damage.

The warranty does not cover breakdowns due to:

insufficient maintenance.
abnormal assembly, adjustment or operations of the product.
parts subject to normal wear and tear.

The warranty does not extend to:

shipping and packaging costs.
using the tool for a purpose other than that for which it was designed.
the use and maintenance of the machine done in a manner not described in the user manual.

Due to our policy of continuous product improvement, we reserve the right to alter or change specifications without notice. Consequently, the product may be different from the information contained therein, but a modification will be undertaken without notice if it is recognized as an improvement of the preceding characteristic.

READ THE MANUAL CAREFULLY BEFORE USING THE MACHINE.

When ordering spare parts, please indicate the part number or code, you can find this in the spare parts list in this manual. Keep the purchase receipt; without it, the warranty is invalid. To help you with your product, we invite you to contact us by phone or via our website:

+33 (0)9.70.75.30.30
https://services.swap-europe.com/contact

You must create a "ticket" via the web platform.

Register or create your account.
Indicate the reference of the tool.
Choose the subject of your request.
Describe your problem.
Attach these files: invoice or sales receipt, photo of the identification plate (serial number), photo of the part you need (for example: pins on the transformer plug which are broken).

14. PRODUCT FAILURE

WHAT TO DO IF MY MACHINE BREAKS DOWN?

If you bought your product in a store:

- Make sure that your machine is complete with all accessories supplied, and clean! If this is not the case, the repairer will refuse the machine.
- Go to the store with the complete machine and with the receipt or invoice.

If you bought your product on a website:

- Make sure that your machine is complete with all accessories supplied, and clean! If this is not the case, the repairer will refuse the machine.
- Create a SWAP-Europe service ticket on the site: https://services.swap-europe.com When making the request on SWAP-Europe, you must attach the invoice and the photo of the nameplate (serial number).

Contact the repair station to make sure it is available before dropping off the machine.

Go to the repair station with the complete machine packed, accompanied by the purchase invoice and the station support sheet downloadable after the service request is completed on the SWAP-Europe site

Please keep your original packaging to allow for after-sales service returns or pack your machine with a similar cardboard box of the same dimensions.

For any question concerning our after-sales service you can make a request on our website https://services.swap-europe.com

Our hotline remains available at +33 (9) 70 75 30 30.

15. WARRANTY EXCLUSIONS

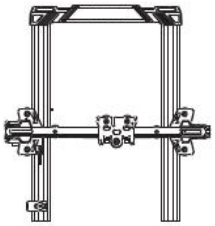
THE WARRANTY DOES NOT COVER:

- Start-up and setting up of the product.
- Damage resulting from normal wear and tear of the product.
- Damage resulting from improper use of the product.
- Damage resulting from assembly or start-up not in accordance with the user manual.
- Breakdowns related to carburetion beyond 90 days and fouling of carburetors.
- Periodic and standard maintenance events.
- Actions of modification and dismantling that directly void the warranty.
- Products whose original authentication marking (brand, serial number) has been degraded, altered or withdrawn.
- Replacement of consumables.
- The use of non-original parts.
- Breakage of parts following impacts or projections.
- Accessories breakdowns.
- Defects and their consequences linked to any external cause.
- Loss of components and loss due to insufficient screwing.
- Cutting components and any damage related to the loosening of parts.
- Overload or overheating.
- Poor power supply quality: faulty voltage, voltage error, etc.
- Damages resulting from the deprivation of enjoyment of the product during the time necessary for repairs and more generally the costs related to the immobilization of the product.
- The costs of a second opinion established by a third party following an estimate by a SWAP-Europe repair station
- The use of a product which would show a defect or a breakage which was not the subject of an immediate report and/or repair with the services of SWAP-Europe.
- Deterioration linked to transport and storage*.
- Launchers beyond 90 days.
- Oil, petrol, grease.
- Damages related to the use of non-compliant fuels or lubricants.

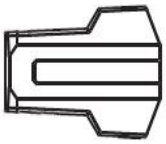
* In accordance with transport legislation, damage related to transport must be declared to carriers within 48 hours maximum after observation by registered letter with acknowledgement of receipt.
This document is a supplement to your notice, a non-exhaustive list.
Attention: all orders must be checked in the presence of the delivery person. In case of refusal by the delivery person, it you must simply refuse the delivery and notify your refusal.
Reminder: the reserves do not exclude the notification by registered letter with acknowledgement within 72 hours.
Information:
Thermal devices must be wintered each season (service available on the SWAP-Europe site). Batteries must be charged before being stored.

Assembly Instruction

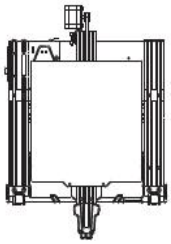
1. Packing list



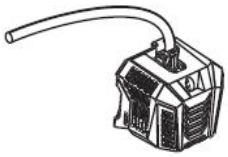
Frame



X-axis limit switch kit



Printer base



Print head

M3X8 screw*4

M4X6 screw*2

M4X16 screw*2

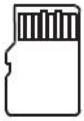
M5X25 screw*2

M5X45 screw*2

Spring washer*4

Filament holder

Screen kit



Memory card

Card reader

Spare nozzle

Tool kit

Power cord

Filament

*Note：The components above are for references only. The actual product may vary.

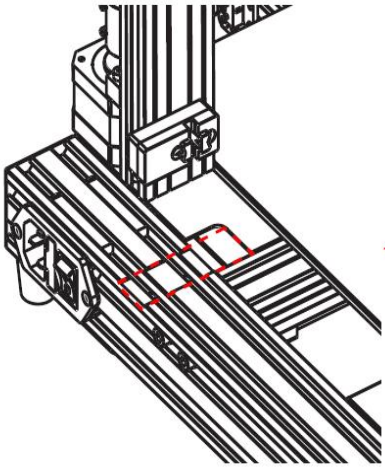
2. Installation

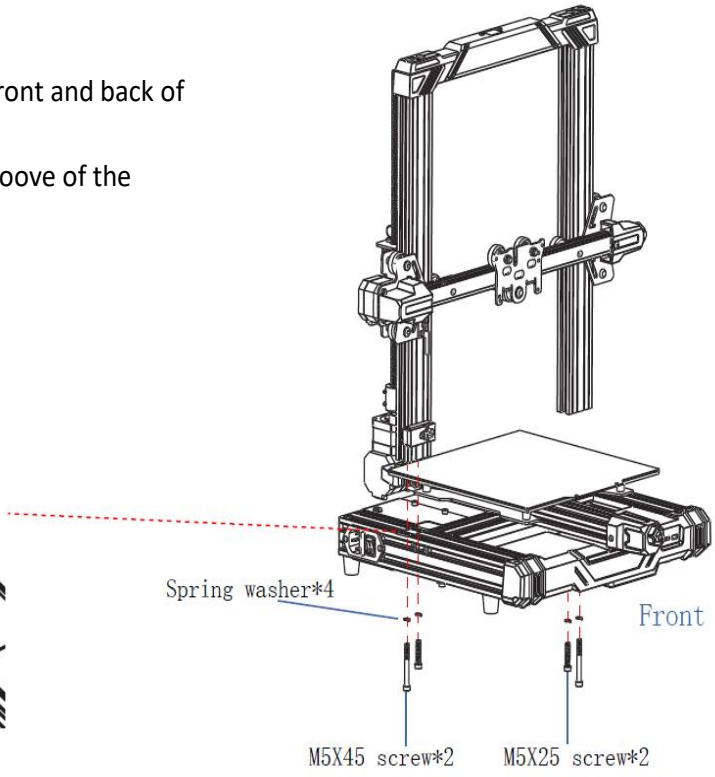
- **Install frame**

Note：

1）When installing, pay attention to the front and back of the profile shown in the figure.

2）The Z-axis profile is aligned with the groove of the aluminum profile of the base.



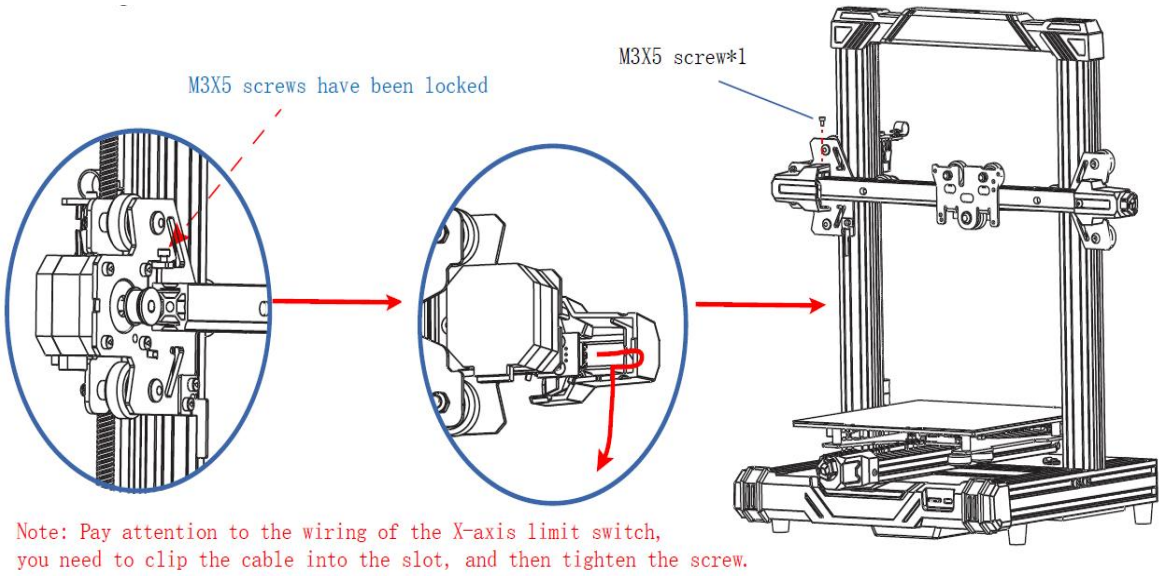


- **Install the X-axis limit switch**

Steps：

1) First, unscrew the screw locked on the left bracket of the X-axis. (The position shown in the figure.)

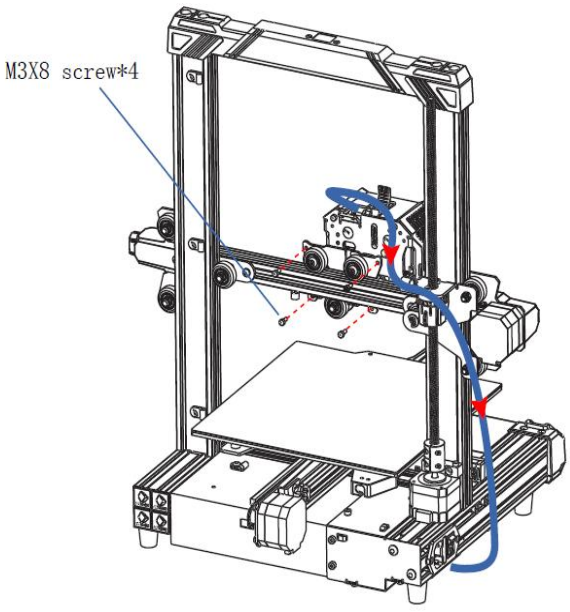
2) Install the X-axis limit switch module on the left bracket of the X-axis, and re-tighten the unscrewed screws.



- **Install print head**

Note:

1) Pay attention to the wiring of the print head, as shown by the blue line.

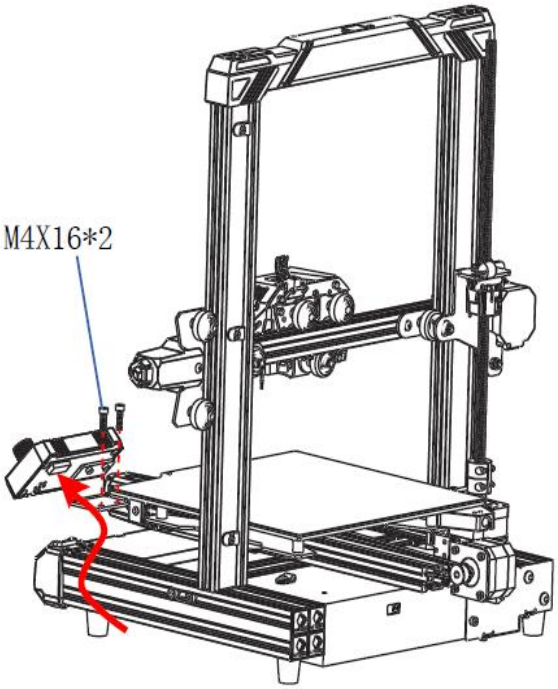


- **Install touchscreen**

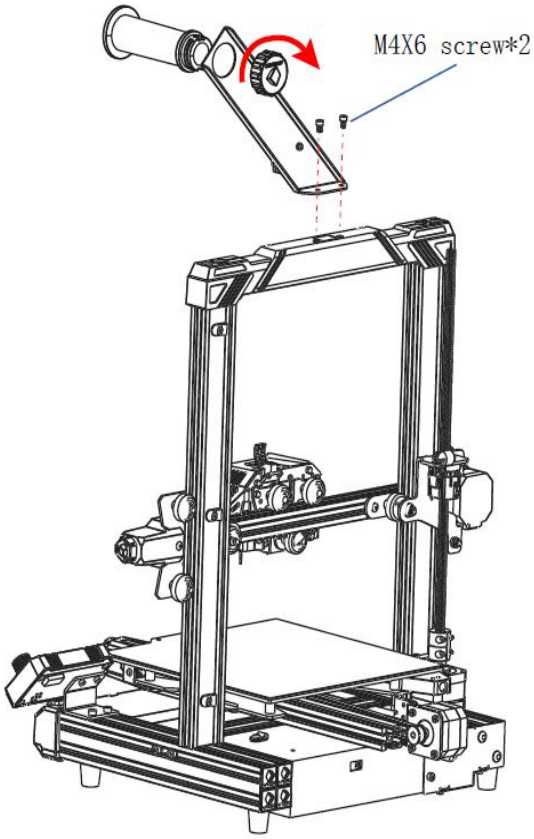
Steps：

1）Use screws to mount the screen and base together.

2）Connect the display screen kit with screen cable.



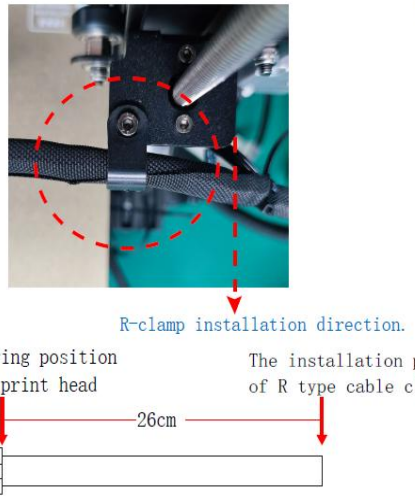
- **Install the rack**

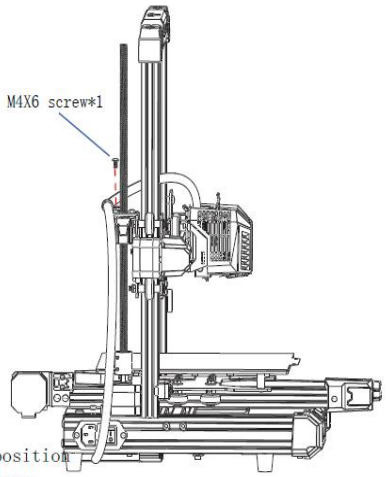


- **Secure the cable**

Steps：

1）Move the print head to the end, then secure the print head harness into the bracket with an R cable clamp and one M4 screw**.**

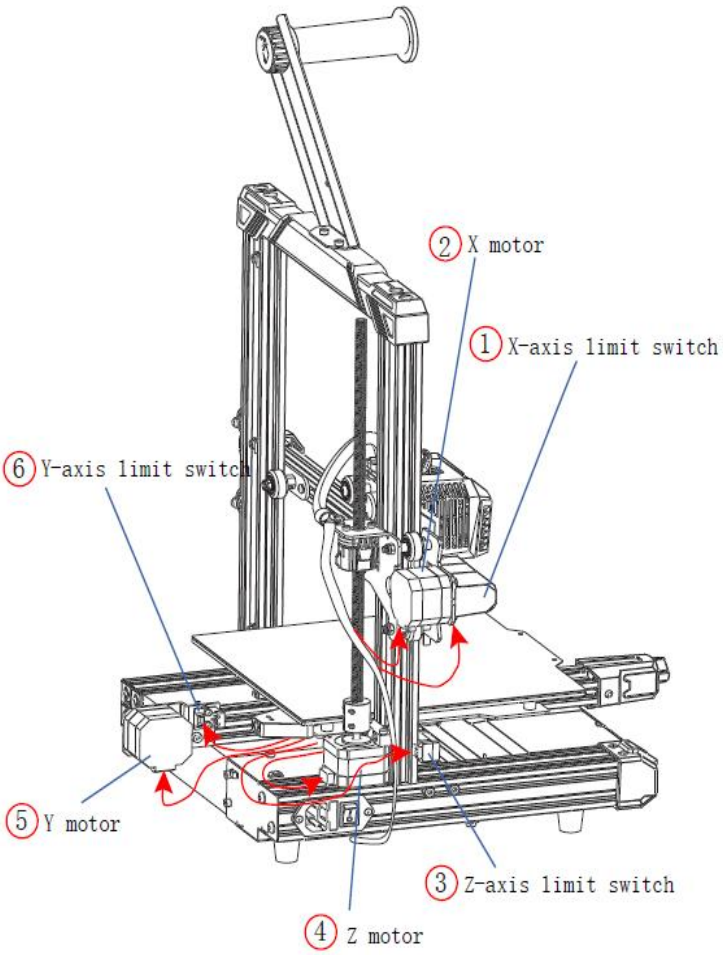




Pay attention to the fixed position of the print head harness. If the length shown above is less than 26cm, the print head harness may become loose or damaged after long-term use.

- **Wire connection**

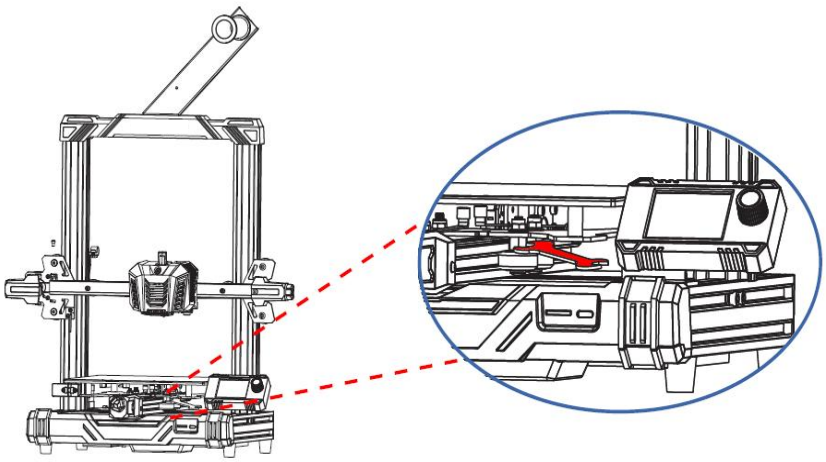
Note：
Connect the cables at the corresponding positions marked on the diagram. There are 6 connections in total.



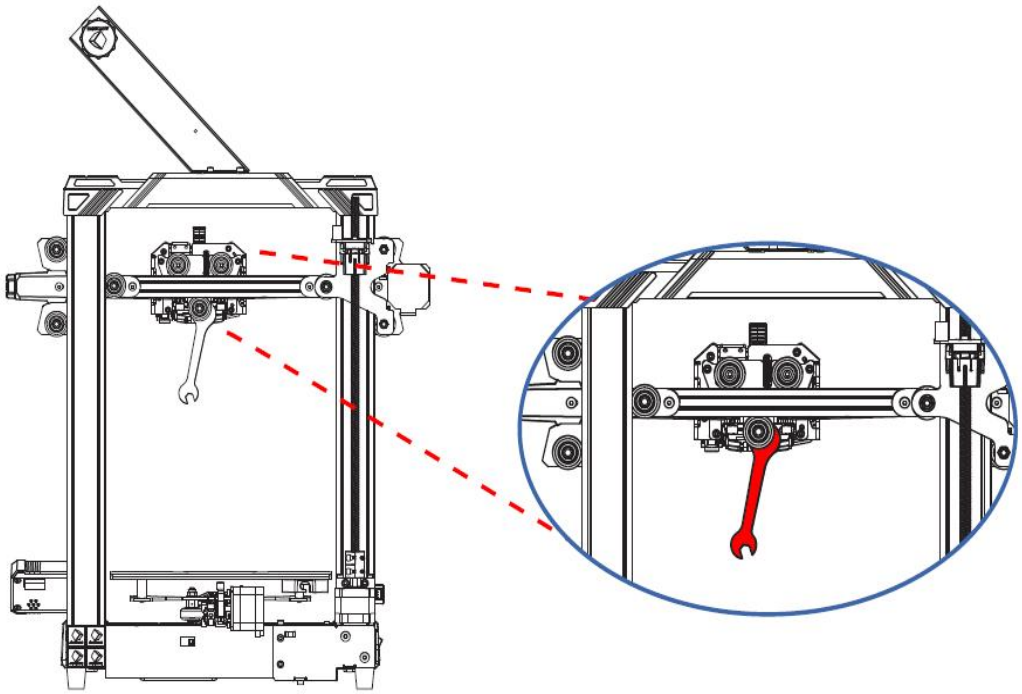
3. Check before use

- D-shape wheels

1）Y axis: Shake the printing platform manually. If it wobbles, tighten the two wheels by rotating eccentric nuts with an open-end wrench until the platform does not wobble and moves smoothly along Y axis.

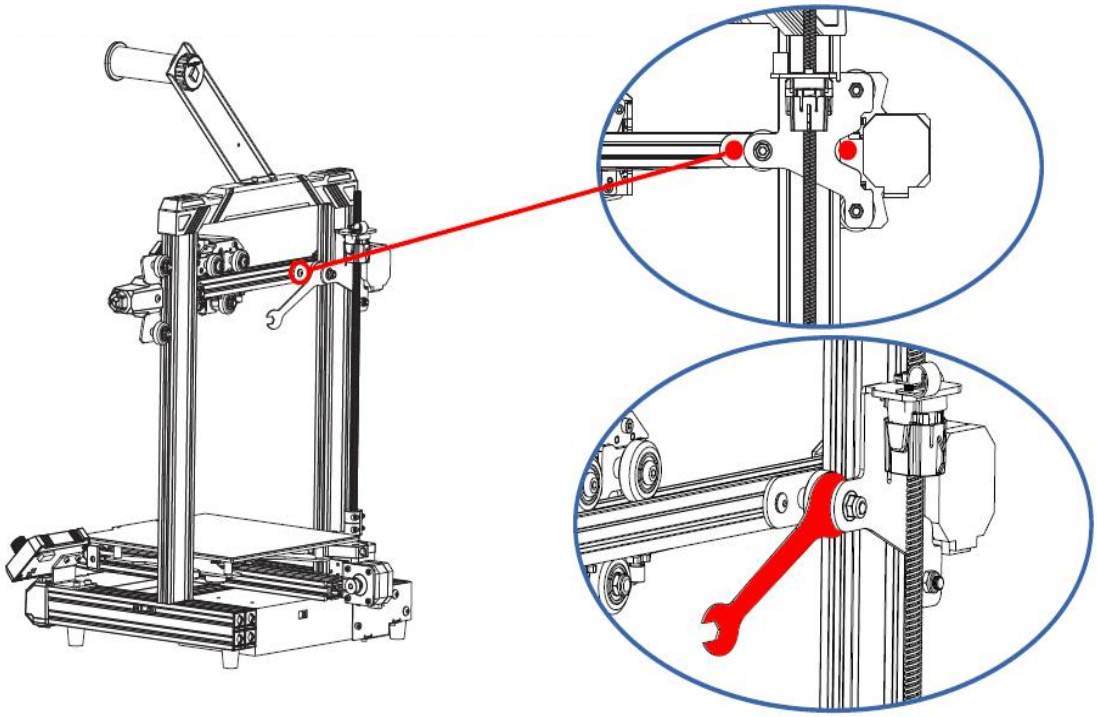


2） X axis: Shake the print head manually. If it wobbles, tighten the wheel by rotating the eccentric nut with an open-end wrench until the print head does not wobble and moves smoothly along X axis.



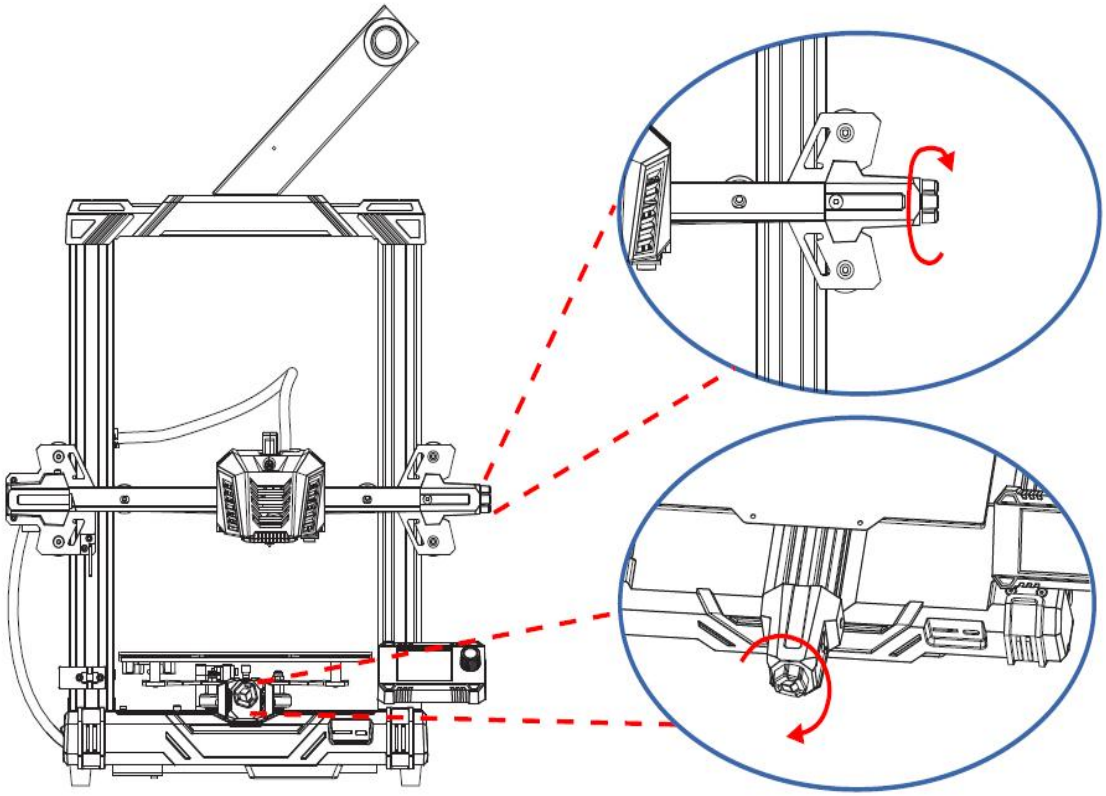
3） Z axis: Try to turn the Z-axis wheels without forcing them. If the wheels turn freely, refer to steps below to adjust the tension of the wheels.

1. Loosen the two screws shown.
2. Rotating the eccentric nuts with an open-end wrench until the wheels no longer turn freely and move smoothly along Z axis.
3. Tighten the screws after adjusting the wheels.



4）Belts

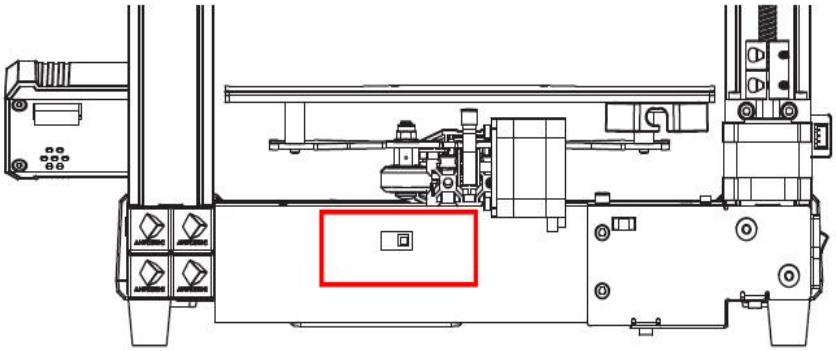
Please tighten the belt tensioners if the belts are loose.



4. Leveling

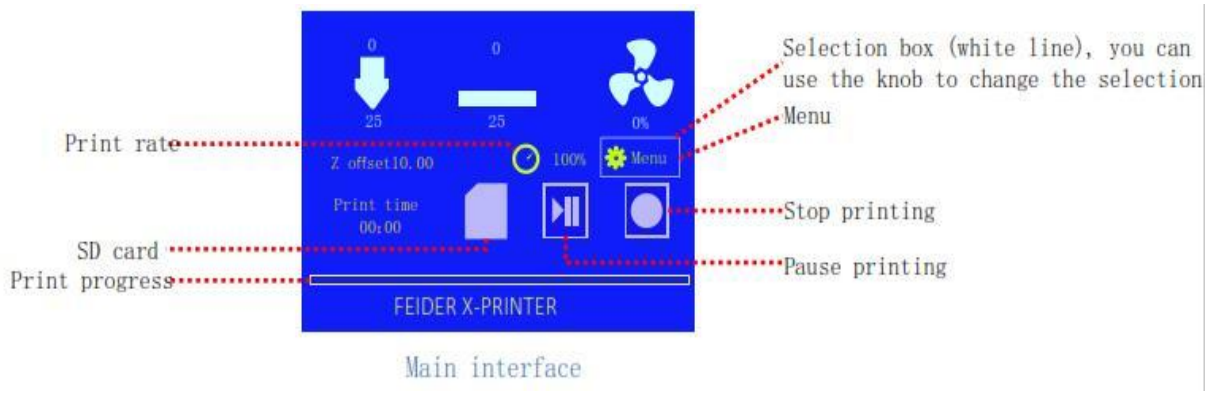
- Select the correct voltage mode according to your local voltage ratings (~110V or ~220V) before plugging in. The red switch is inside the power supply casing and 220V is a default setting.

Please adjust to the appropriate voltage range.



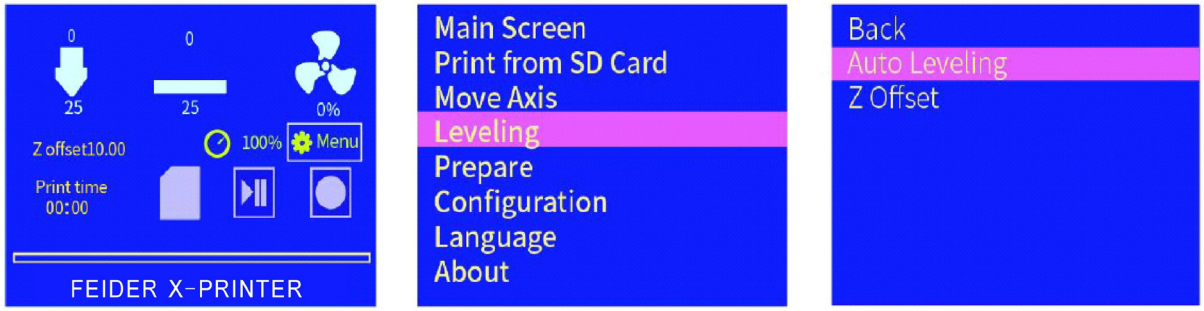
In some cases, 220V labeled as "230", 110V labeled as"115".

- After power on, the machine screen will enter the information interface.



Main interface

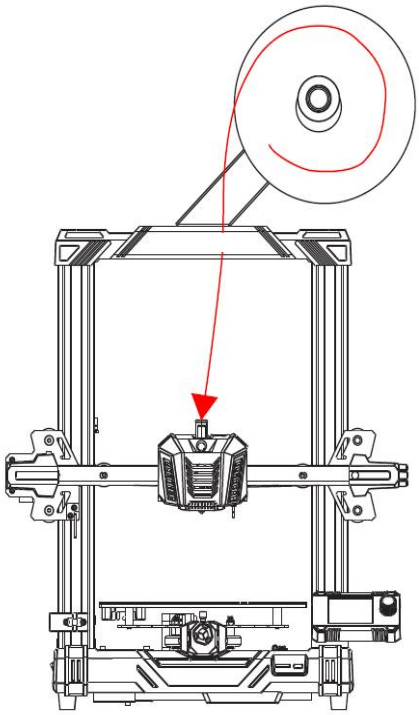
- Use the knob to select Menu on the setting page, then select Leveling, and then select Auto Leveling, the machine will enter the automatic leveling state.
  Platform Warm Up - Begin Leveling - End Leveling



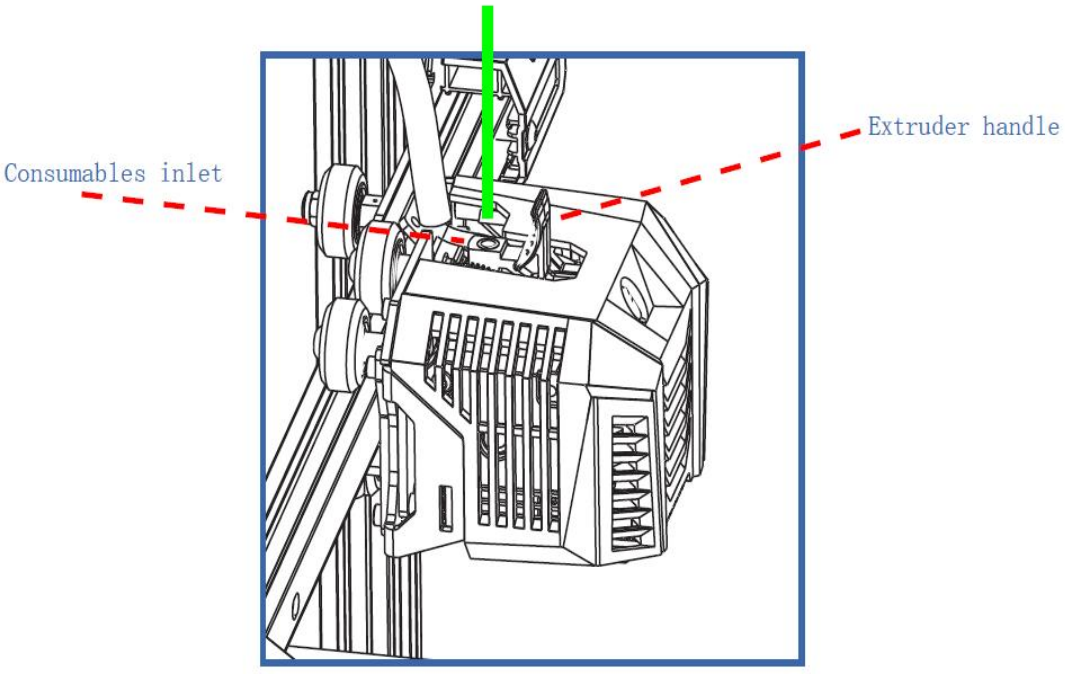
Note：Before leveling, please ensure that the platform and nozzle are clean and free of foreign to avoid affecting the leveling effect.

- Cut and straighten the end of filament, then place the filament spool on the filament holder. Note the direction of the filament.

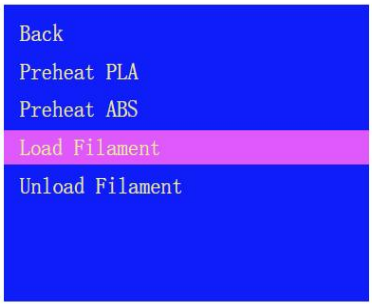
Cut the end of the filament at a 45 degree angle before inserting.

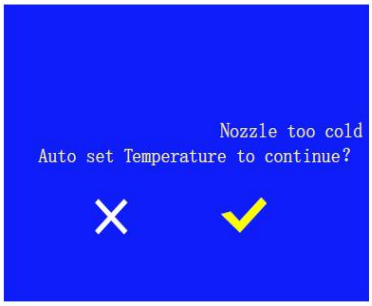


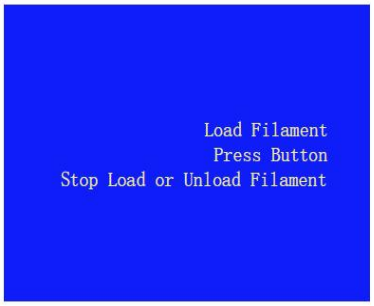
- Press the extruder handle to insert the filament into the print head consumables inlet.



- Use the knob to select Menu on the setting page, then select Prepare, and then select Load Filament. The machine will enter the nozzle heating state. After the heating is completed, the machine will automatically enter the filament feeding state. After the filament are extruded smoothly, press the button to stop feeding and then clean up the nozzle residue.

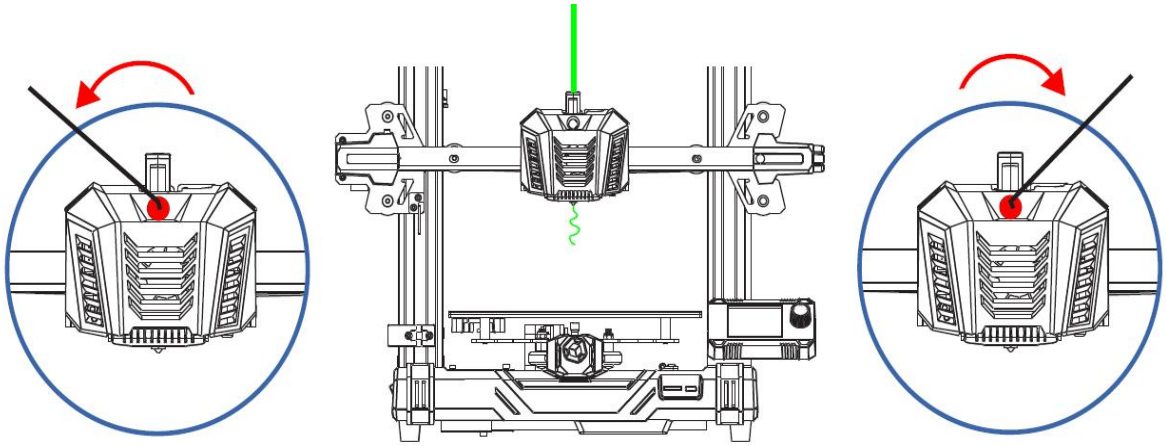






Supplement:

During feeding, if the extruded filament is not smooth or too thin, please adjust the extrusion by rotating the screw as shown below.



If the filament is not extruded or extrusion is not smooth, please increase the extrusion force by tightening the screw.

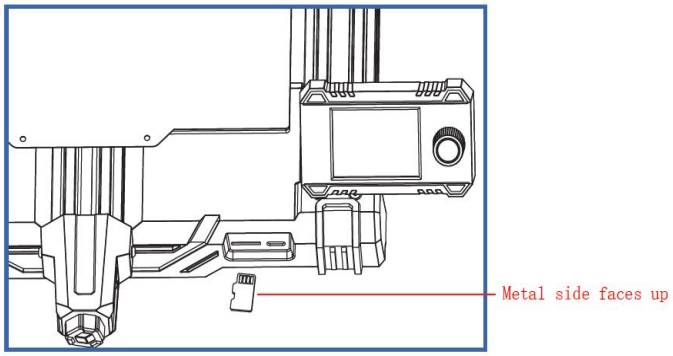
If the extruded filament is too thin, please reduce the extrusion force by loosening the screw.

- Z axis compensation adjustment

Steps：

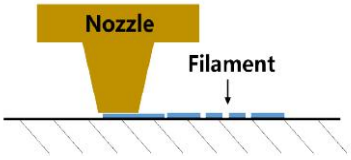
1） Insert the included memory card into the memory card slot at the base.

(Tip: To eject the SD card, please press it.)

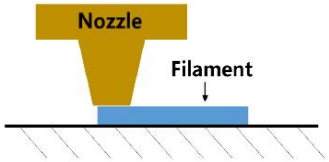


2）Select Menu on the main interface of the screen, and then select Print to enter the file list. Select the corresponding model, and then press the knob.

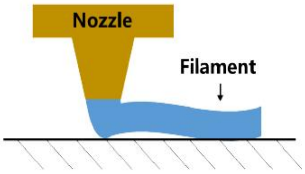
3) Printer starts printing when temperature reaches target value. (Note: The nozzle will start heating after the heated bed reaches target temperature.)
4) There might be three kinds of results for the first or second layer of the test print. Please fine-tune the height of the Z axis according to the adhesion between the filament and the platform.



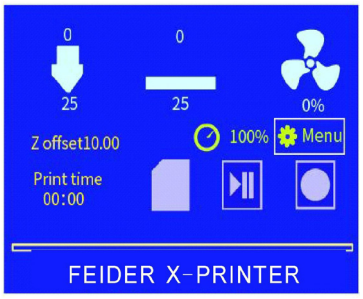
① Nozzle is too close to the platform, resulting in insufficient extrusion of filament.

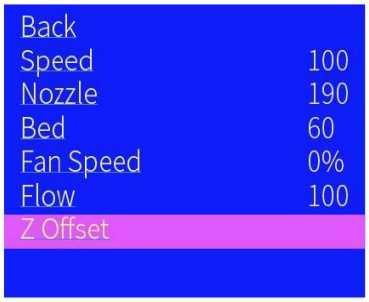


② Proper distance between nozzle and Platform will achieve the best printing effect.



③ Nozzle is too high and the gap is large, which leads to poor adhesion of filament to the platform.





If this is the case ① please click "Menu" → "Z Offset", turn the knob on the screen to the right (+)  to raise the height of the print head, and press the knob to save.
If this is the case ③ please click "Menu" → "Z Offset", turn the knob on the screen to the left(-)  lower the height of the print head, and press the knob to save.
5) Adjust the Z-axis compensation to effect 2, and fine-tune the subsequent printing according to the actual situation.

5. Printing

* After the above debugging is completed, please remove the residue on the hot bed and nozzle, and then you can start printing normally. If there is an abnormal situation during the debugging process that cannot be solved, please contact customer service for assistance.

* GCode file name should only contain English letters, underscore and space. File names containing special characters will not be recognized by the printer.

* In order to let the printer better recognize the GCode file in the memory card, you need to up all the files in the memory card to the computer, and keep the memory card only for the GCode file. Please save all the GCode files in root directory of the memory card.

Steps：

1) Insert the included memory card into the memory card slot at the base.
(Tip: To eject the SD card, please press it.)

2) Select the corresponding model, and then press the knob. After the nozzle of the print head and the hot bed are heated to the target temperature, the machine automatically enters the printing
3) Bad results may occur when printing the first layer, please adjust the Z-axis compensation value according to different printing effects.
4) The nozzle and heated bed are still in high temperature when printing finishes. Make sure to for nozzle and heated bed to cool down before removing the model from the printing platform.

Note:
Refer to the full user manual in the memory card for online printing and offline printing.

6. Model Slicing and Software Use
   1) For model slicing and software use, please refer to the tutorial file on the memory card.
7. Removing filament

Steps:

1) Use the knob to select Menu on the setting page, then select Prepare, and then select Unload Filament.
2) The machine will enter the heating state, after heating, the machine will automatically enter the unloading filament state.
3) After the filament pops up, press the knob to stop discharging the filament.

8. Attention
   1) FEIDER 3D printer includes moving parts that may cause injury.
   2) FEIDER 3D printer must not be exposed to water or rain.
   3) FEIDER 3D printer generates high temperature. DO NOT touch the printing area during operation. Contact with extruded materials may cause burns.
   4) Use high temperature resistant gloves when operating the product.
   5) In case of emergency, please immediately cut off the power of the printer and contact the technical support.
   6) This equipment is not suitable for use in locations where children are likely to be present.
   7) The fuse rating for the printer is 250V 10A. Never replace the fuse with one of a higher amperage, otherwise it may cause fire.
   8) The socket-outlet should be easily accessible.
   9) If there are some tiny scratches on the aluminum beams or slight unevenness on the platform, normal and won't affect the printing quality.

FEIDER MACHINES

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Made in China in 2023