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R QIDI TECHNOLOGY MAX4

QIDI Max4 3D Printer User Manual

Model: MAX4

Introduction Safety Information What's in the Box Setup Operation Maintenance Troubleshooting Specifications Support

1. Introduction

The QIDI Max4 is an advanced 3D printer designed for high-speed and high-precision additive manufacturing. It features a large build volume, a heated chamber, and compatibility with a wide range of materials, including industrial-grade filaments. This manual provides essential information for the safe and efficient operation, setup, and maintenance of your QIDI Max4 3D printer.



Image 1.1: Overview of the QIDI Max4 3D Printer, highlighting its large size, fast speed, and professional quality.

2. Safety Information

Please read all safety instructions carefully before operating the QIDI Max4 3D printer to prevent injury or damage to the device. Keep this manual for future reference.

- Always operate the printer in a well-ventilated area.
- Do not touch the hotend or heated bed during operation or immediately after printing, as they can reach high temperatures.
- Keep hands and loose clothing away from moving parts.
- Ensure the printer is placed on a stable, level surface.
- Use only the power cord provided with the printer.
- Do not attempt to modify the printer or use non-approved parts.
- The printer features a flame-retardant chamber for enhanced safety.

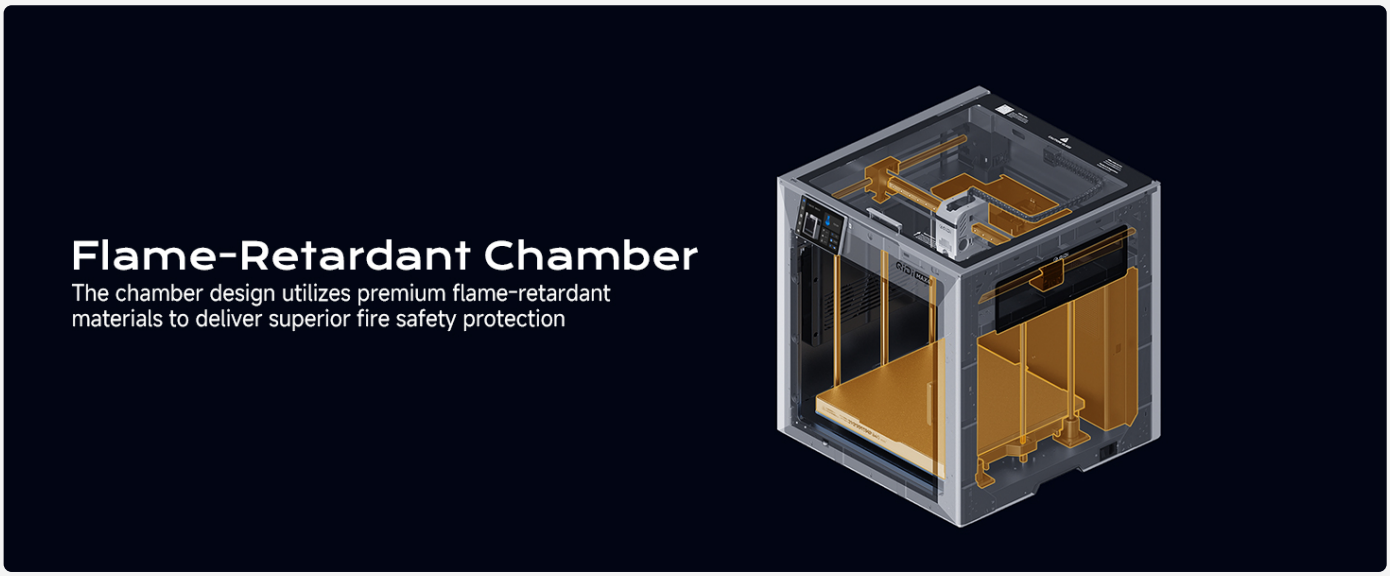

Image 2.1: Illustration of the printer's flame-retardant chamber design, emphasizing safety.

3. What's in the Box

Verify that all components are present upon unboxing:

- MAX4 3D Printer
- Camera
- USB2.0 Flash Drive
- Glue Stick
- Tool Kits
- Spare Parts Kits
- Holder Cover
- Filament Extension Bracket
- Extension Bracket Fixing Block
- Filament Spool Holder
- Quick Start Guide
- Power Cord
- Ethernet Cable



Image 3.1: Visual representation of the items included in the QIDI Max4 package.

Print Size (W*D*H)	390*390*340mm	Printer Dimensions	558*578*612 mm
Package Dimensions	700*710*750mm	Gross Weight	Max4:49.5kg Max4 Combo:56kg
Net Weight	Max4: 40kg Max4 Combo: 46.5kg	Print Head Temperature	≤ 370°C
Included Build Plate Type	Dual-Sided Textured PEI Plate	Hot Bed Temperature	≤ 120°C
Max Speed of Tool Head	800mm/s	Acceleration	≤ 30000mm/s²
XY Structure	CoreXY, 1.5GT 10mm Width Belt FOC Closed-loop Stepper Motor	X/Y Axis	X: High Hardness Linear Guide Rail Y:12mm Linear Steel Shafts
ZAxis	Independent 2mm lead screw motors x2 12mm Linear Steel Shafts x4	Printing Platform	Aluminum Plate Silicone Heated Bed
Nozzle	Bimetal Nozzle	Nozzle Diameter	0.4mm (0.2/0.6/0.8mm Optional)
Extruder Gear	Direct Extruder Hardened Steel Dual Gears	Supported Filament	PLA, ABS, ASA, PETG, TPU, PA, PC,Carbon/ Glass Fiber Reinforced Polymer, etc.
Filament Diameter	1.75mm	Multi-Color Printing	Compatible with QIDI Box(Multi-color)

Image 3.2: Detailed illustration of the accessory package contents, including tools and spare parts.

4. Setup

4.1 Unboxing and Initial Inspection

Carefully remove the printer from its packaging. Inspect the printer for any visible damage. Remove all protective films and packaging materials from inside and outside the printer.

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Video 4.1: An unboxing guide for the QIDI Max4 Combo, demonstrating the initial setup steps and removal of packaging materials.

4.2 Preparing the Build Plate

The build plate comes with protective film. Remove this film before first use. Ensure the build plate is securely seated on the heated bed.

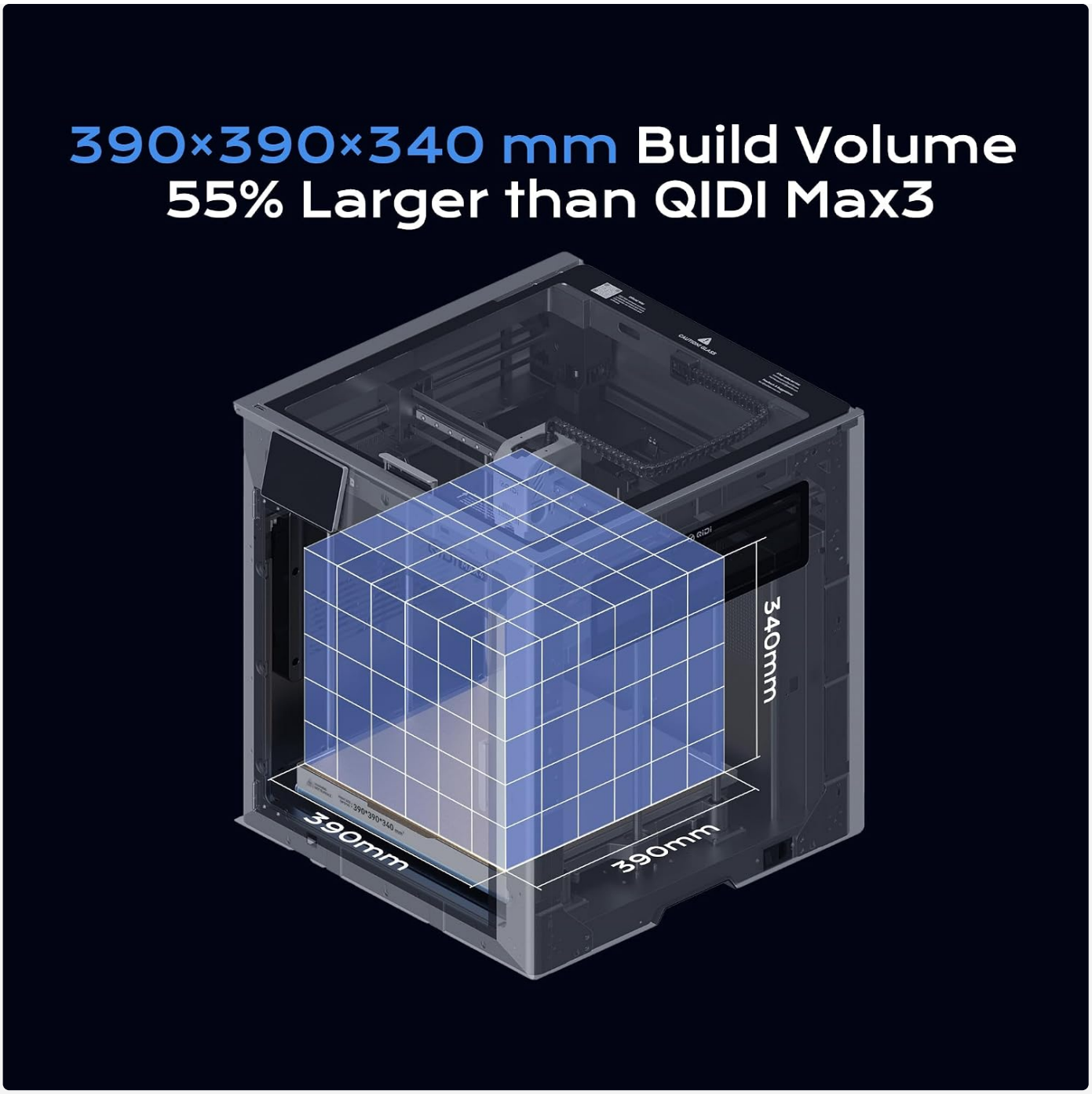

Image 4.1: The QIDI Max4 build plate, ready for printing after removing protective film.

4.3 Unlocking the Print Head

Locate and remove any shipping restraints or packaging around the print head (nozzle assembly) as indicated in the quick start guide. This typically involves cutting zip ties or removing foam inserts.

4.4 Power Connection

Connect the power cord to the printer and then to a suitable power outlet. Turn on the printer using the main power switch, usually located at the rear or side of the unit.

5. Operation

5.1 User Interface: 5-inch HD Touch Screen

The QIDI Max4 features a 5-inch HD touch screen with an optimized interface for intuitive control. Navigate through menus to access print settings, monitor progress, and control printer functions.



Image 5.1: The 5-inch HD touch screen displaying the user interface for printer control and monitoring.

5.2 Loading Filament

Follow the on-screen instructions or refer to the quick start guide for loading filament. Ensure the filament is correctly fed into the extruder. The printer supports 1.75mm filament diameter.

5.3 Starting a Print

Prepare your 3D model using QIDI Studio or another compatible slicing software. Transfer the G-code file to the printer via USB or network connection. Select the file from the touch screen and initiate the print. The printer features an auto-leveling system for precise first layers.

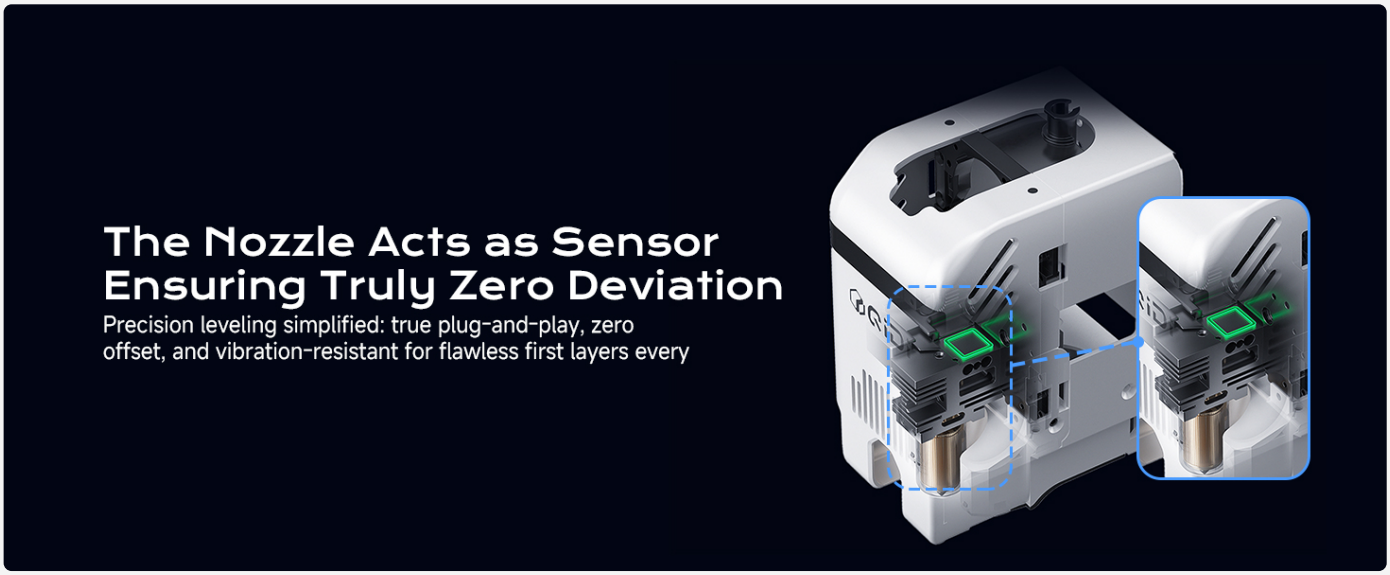

Image 5.2: The nozzle acts as a sensor for precision leveling, ensuring zero deviation and flawless first layers.

5.4 Monitoring Prints with AI Camera

The built-in AI camera actively monitors the printing process. It can detect common printing abnormalities, such as spaghetti-like failures, and automatically pause the print to prevent material waste and potential damage.

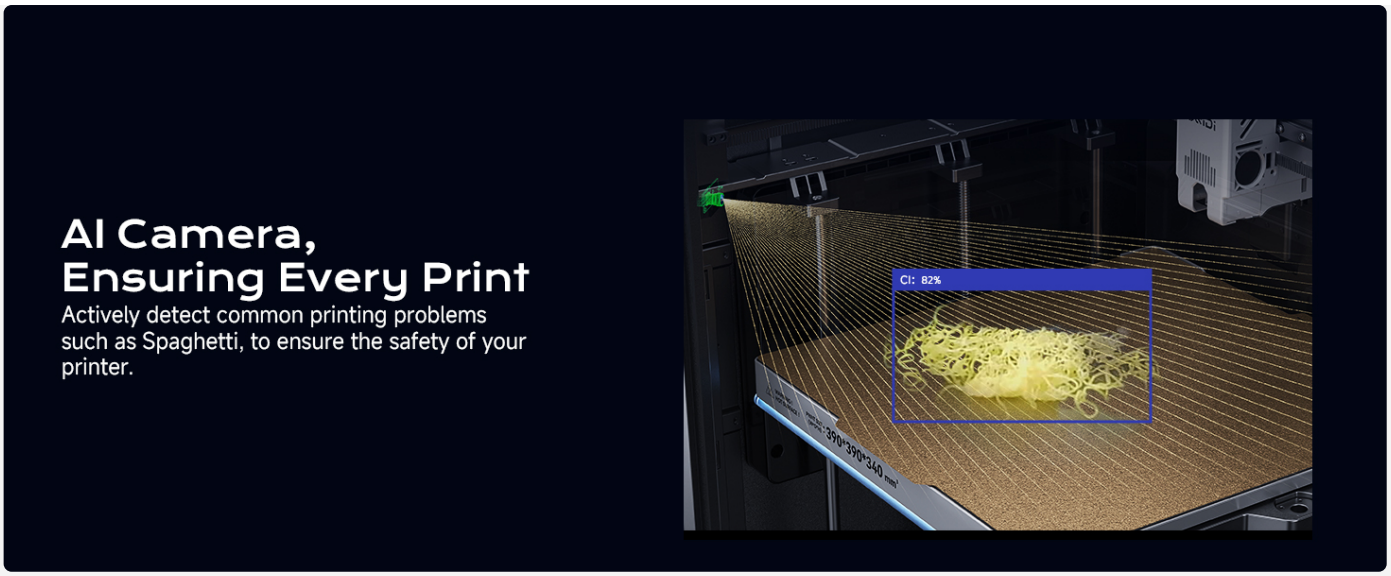

Image 5.3: The AI camera actively detecting a printing anomaly, such as a spaghetti failure, to ensure print safety.

5.5 Material Compatibility and Heated Chamber

The QIDI Max4 supports a wide range of materials, including PLA, ABS, ASA, PETG, TPU, PA, PC, and carbon/glass fiber-reinforced polymers. It features a 40mm³/s high-flow hotend with a hardened steel nozzle capable of reaching 370°C. The 65°C active heated chamber and optional Polar Cooler system create optimal conditions for high-temperature materials like ABS-CF, PC, and PPS-CF, reducing warping and improving layer adhesion.



Image 5.4: The hotend capable of heating up to 370°C, featuring a ceramic throat and new heat dissipation module to reduce clogging.



Image 5.5: The 3rd generation heated chamber, capable of reaching up to 65°C, which helps eliminate warping and boosts layer adhesion.

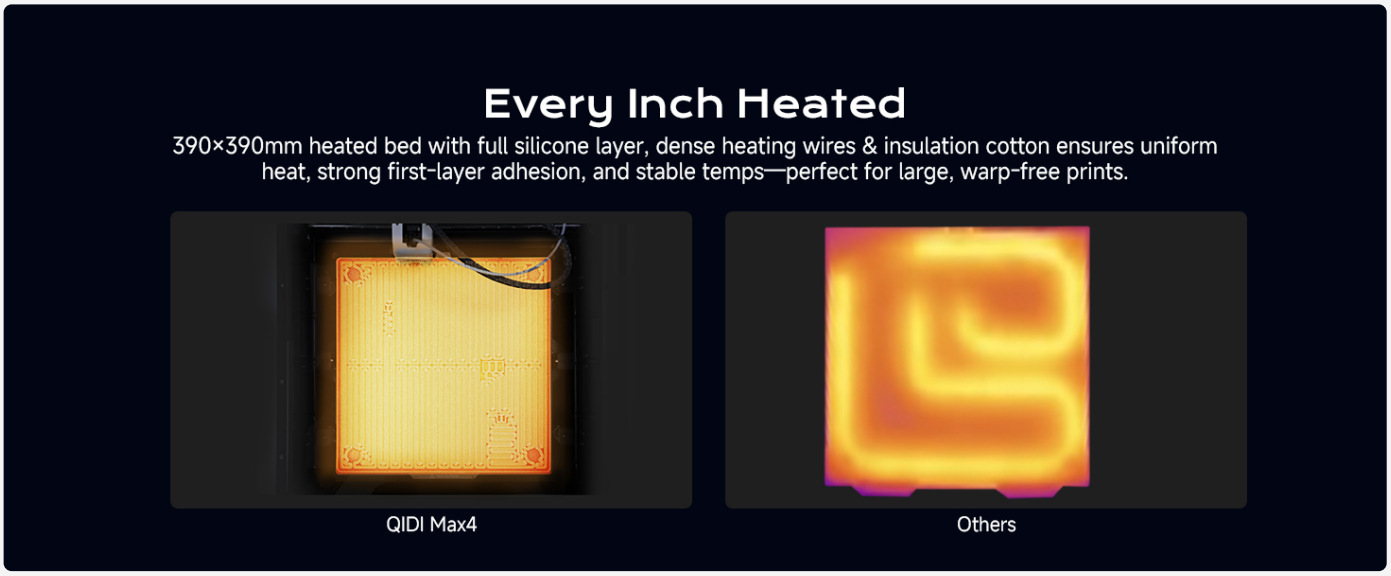

Image 5.6: Comparison showing the QIDI Max4's evenly heated build plate versus others, ensuring uniform heat distribution.

5.6 Multi-Color Printing with QIDI BOX (Optional)

The QIDI Max4 can be seamlessly connected with the QIDI BOX (sold separately) to enable 16-color and multi-material printing. The QIDI BOX also provides intelligent filament management, including real-time filament level monitoring and automatic pausing when filament runs out.



Image 5.7: The QIDI BOX system, enabling multi-color and multi-material printing with intelligent filament management.

6. Maintenance

6.1 Cleaning the Printer

Regularly clean the build plate with isopropyl alcohol to ensure good adhesion. Use the provided scraper and brush to remove any print debris from the printer's interior and moving parts. The smooth base design facilitates easy cleaning.

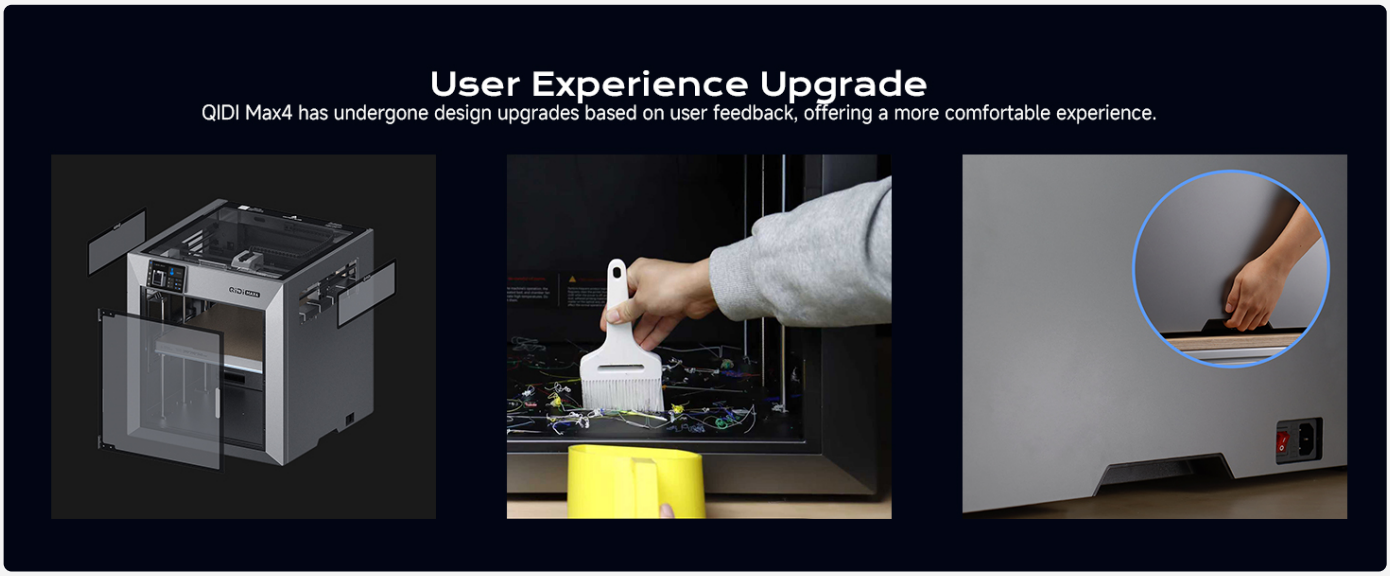

Image 6.1: Demonstrates the ease of cleaning the printer's interior and the bottom handle design for movement.

6.2 Reducing Clogging

The QIDI Max4 is designed to reduce clogging by up to 90% through its hotend design and active chamber heating. For optimal performance, ensure proper filament storage and periodically inspect the nozzle for wear or blockages.

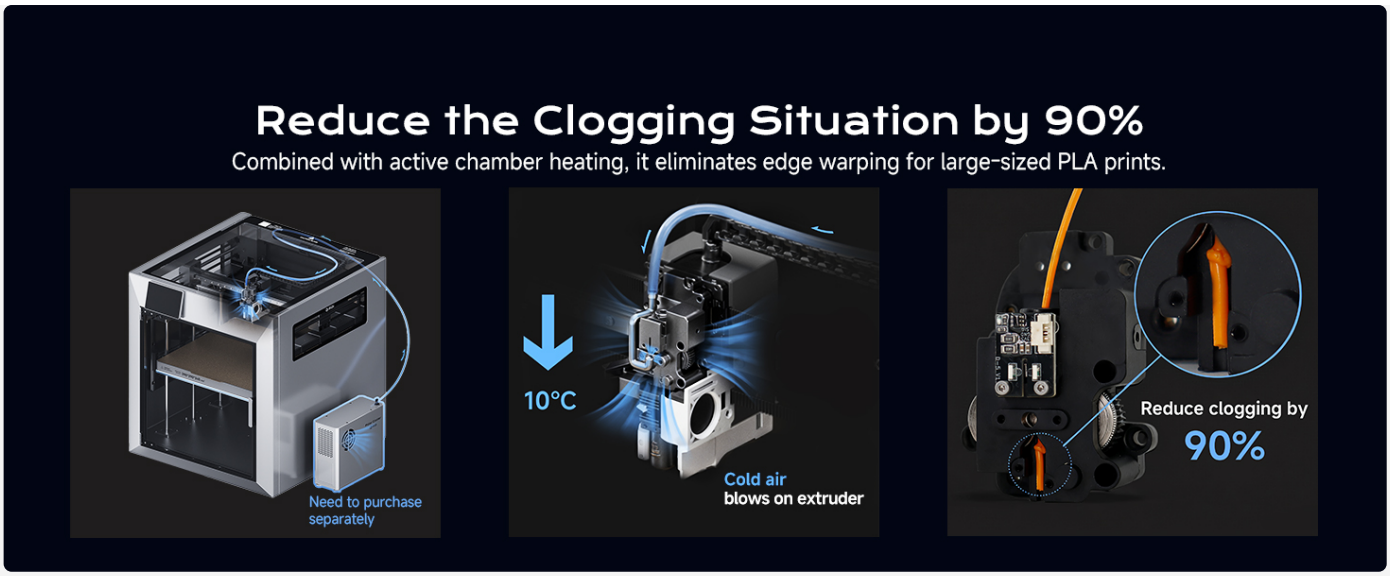

Image 6.2: Illustration of the printer's system to reduce clogging, including cold air blowing on the extruder and active chamber heating.

6.3 Triple Filtration System

The printer is equipped with a triple filtration system designed to capture 99.5% of dust and particles, contributing to a healthier printing environment. Periodically check and replace the filter elements as needed to maintain efficiency.



Image 6.3: Diagram of the triple filtration system, highlighting its components for air purification.

7. Troubleshooting

This section addresses common issues you might encounter during operation.

7.1 Print Abnormalities

If the AI camera detects a printing abnormality (e.g., spaghetti-like failures), the printer will automatically pause. Inspect the print, clear any issues, and resume or restart the print as necessary. Ensure your model is properly sliced and supported.

7.2 Layer Alignment Issues

The QIDI Max4 utilizes 2mm lead screws and anti-backlash nuts on the Z-axis, along with closed-loop motors on X/Y axes

and a 1.5GT custom belt, to ensure high precision and stability. If you experience layer shifting or poor alignment, check for loose belts, obstructions in the movement path, or incorrect slicing settings.



Image 7.1: Illustration of the Z-axis mechanism with a 2mm lead screw and anti-backlash nut for precise layer alignment.



Image 7.2: The new 1.5GT custom belt with higher tooth density for smoother, more precise motion and reduced vibration artifacts.

8. Specifications

Feature	Detail
Print Size (W*D*H)	390*390*340mm
Printer Dimensions	558*578*612 mm
Net Weight	Max4 40Kg
Print Head Temperature	≤ 370°C
Included Build Plate Type	Dual-Sided Textured PEI Plate
Hot Bed Temperature	≤ 120°C
Max Speed of Tool Head	800mm/s

Feature	Detail
Acceleration	≤ 30000mm/s²
XY Structure	CoreXY, 1.5GT 10mm Width Belt, FOC Closed-loop Stepper Motor
X/Y Axis	X: High Hardness Linear Guide Rail, Y: 12mm Linear Steel Shafts
Z Axis	Independent 2mm lead screw motors x2, 12mm Linear Steel Shafts x4
Printing Platform	Aluminum Plate Silicone Heated Bed
Nozzle	Bimetal Nozzle
Nozzle Diameter	0.4mm (0.2/0.6/0.8mm Optional)
Extruder Gear	Direct Extruder, Hardened Steel Dual Gears
Supported Filament	PLA, ABS, ASA, PETG, TPU, PA, PC, Carbon/Glass-Fiber Reinforced Polymer, etc.
Filament Diameter	1.75mm
Multi-Color Printing	Compatible with QIDI Box (Multi-color)

9. Support & Warranty

For technical assistance, troubleshooting, or warranty inquiries, please contact R QIDI TECHNOLOGY customer support. Refer to the official R QIDI TECHNOLOGY website for the most up-to-date contact information and support resources. The product typically includes a 30-day easy return policy. Specific warranty terms may vary and are detailed in the product documentation or on the manufacturer's website.

Manufacturer: Zhejiang QIDI TECHNOLOGY CO.,LTD

Brand: R QIDI TECHNOLOGY

Online Support: Visit the R QIDI TECHNOLOGY Store on Amazon

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