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R QIDI TECHNOLOGY Plus5-Combo

QIDI Plus5 Combo Multi-Color 3D Printer Instruction Manual

Model: Plus5-Combo | Brand: R QIDI TECHNOLOGY

1. Introduction

The QIDI Plus5 Combo is a high-performance multi-color 3D printer designed for large-scale and engineering-grade 3D printing. It features a substantial build volume of 320×320×300mm, a 370°C max extrusion temperature, and an actively heated 65°C chamber. The CoreXY precision motion system allows for high-speed printing up to 600mm/s. Integrated smart features like auto-leveling, AI camera monitoring, and remote control enhance the user experience. The optional QIDI BOX supports multi-material and multi-color printing with active filament drying.

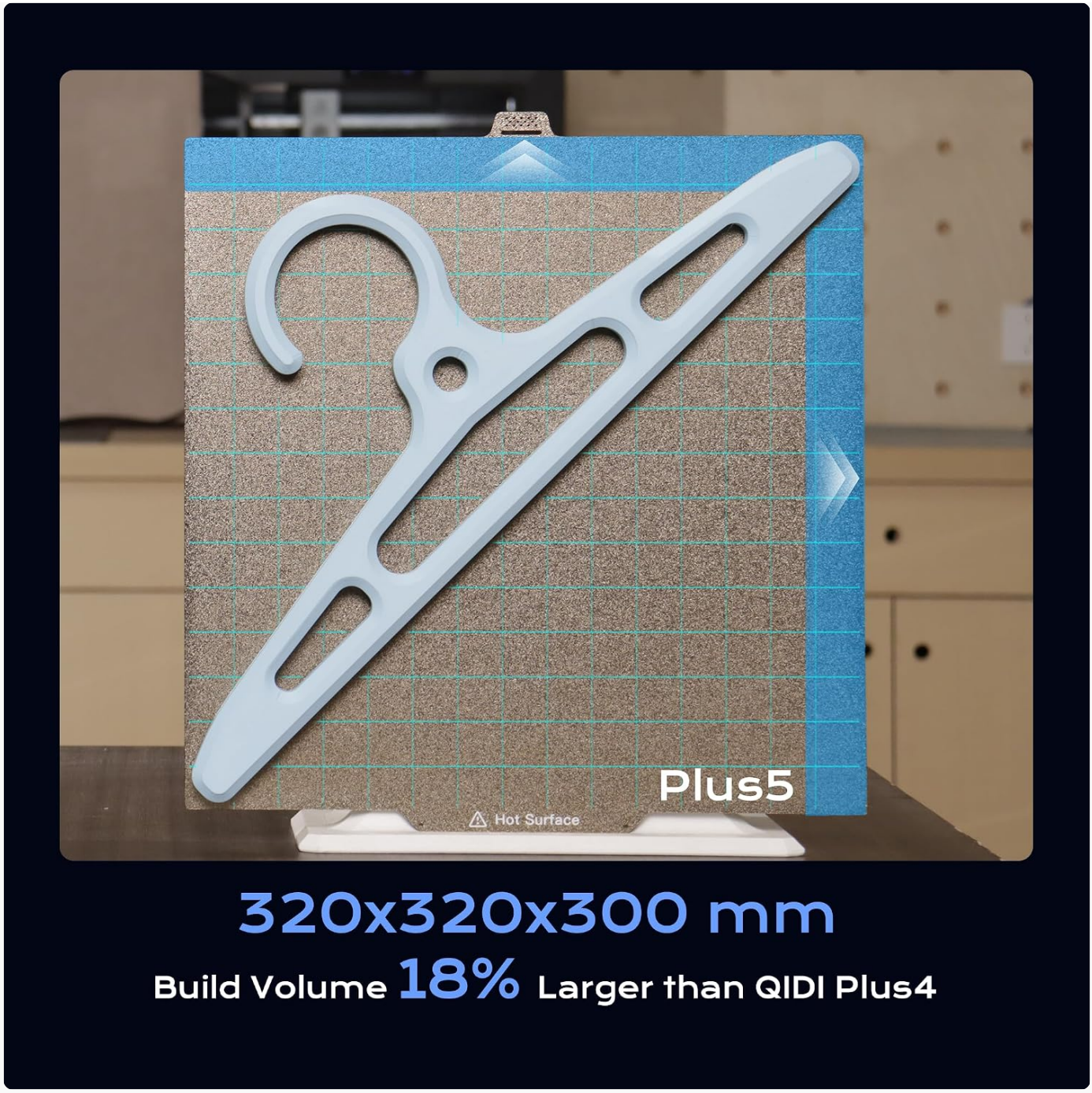

Image 1.1: Overview of the QIDI Plus5 Combo 3D Printer.

2. Setup Guide

The QIDI Plus5 Combo is designed for quick setup, allowing you to begin printing within approximately 10 minutes of unboxing. Follow the instructions below for initial assembly and calibration.

2.1 Unboxing and Initial Inspection

Carefully remove all components from the packaging. Verify that all items listed in the 'What's in the Box' section are present and undamaged. Refer to the unboxing video for a visual guide.

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Video 2.1: Official unboxing and initial setup guide for the QIDI Plus5 Combo 3D Printer.

2.2 Package Contents

Ensure all accessories are accounted for:

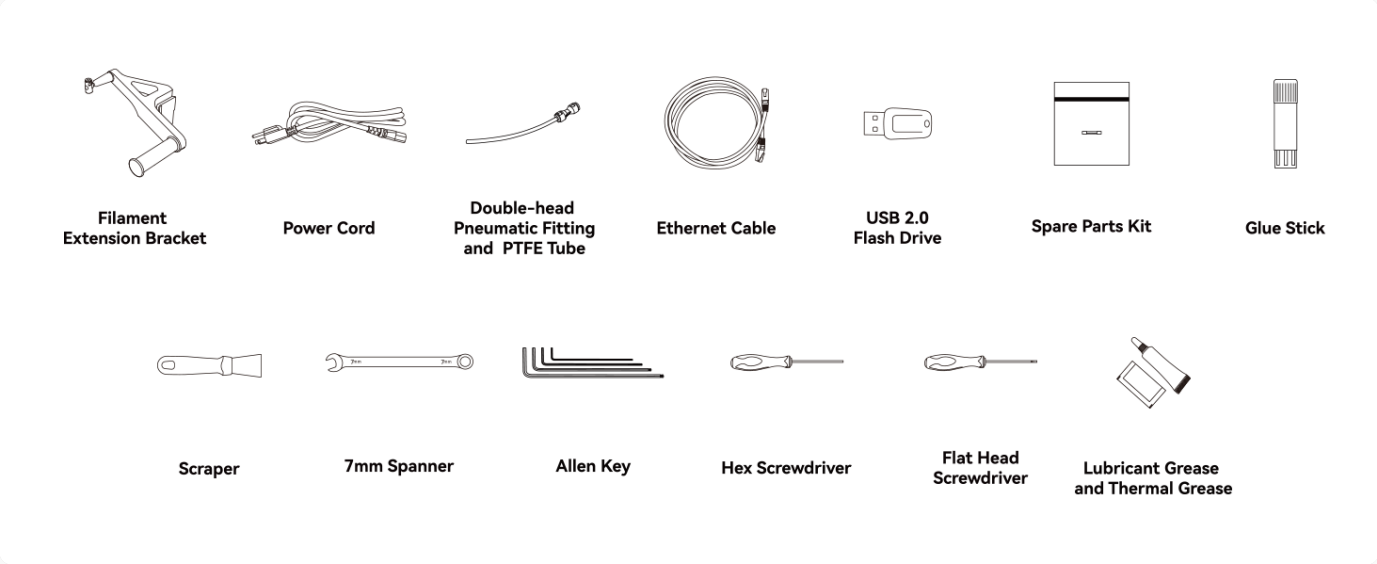

Image 2.2: Contents included with the QIDI Plus5 Combo 3D Printer.

- 3D Printer Body
- Filament Extension Bracket
- Power Cord
- Double-head Pneumatic Fitting and PTFE Tube
- Ethernet Cable
- USB 2.0 Flash Drive
- Spare Parts Kit
- Glue Stick
- Scraper
- 7mm Spanner
- Allen Key Set
- Hex Screwdriver
- Flat Head Screwdriver
- Lubricant Grease and Thermal Grease

2.3 Power Connection and Initial Boot-up

1. Connect the power cord to the printer and a suitable power outlet.
2. Turn on the printer using the main power switch.
3. Follow the on-screen prompts for initial calibration, which includes automatic bed leveling. This process typically takes 10-15 minutes.

3. Operating Instructions

3.1 Printing with Advanced Materials

The Plus5 Combo is engineered to handle high-performance filaments such as PPS-CF, PPA-CF, PC, and Nylon. It features a 370°C max extrusion temperature and an actively heated 65°C chamber to minimize warping and ensure strong layer adhesion for durable, heat-resistant functional parts.



Image 3.1: The 370°C hot end enables printing with advanced engineering filaments.

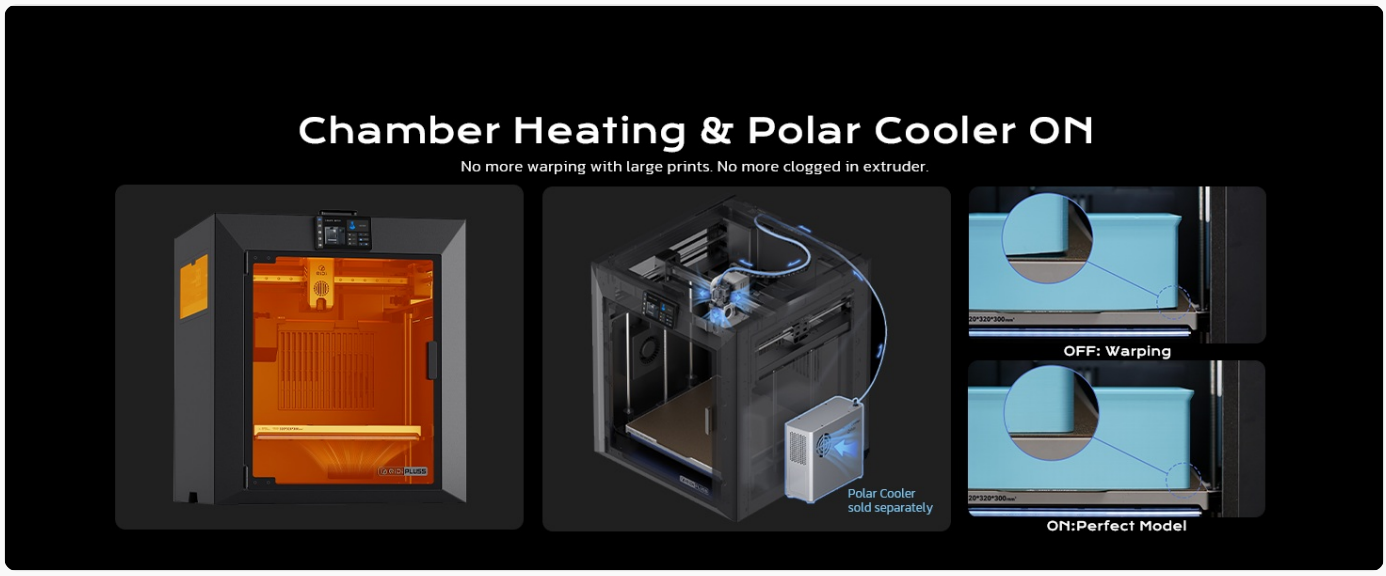

Image 3.2: Active chamber heating and optional Polar Cooler prevent warping and clogs.

3.2 Multi-Color and Multi-Material Printing (with QIDI BOX)

The optional QIDI BOX allows for up to 16-color multi-material printing. It features built-in active drying technology to maintain low humidity, preventing common issues like stringing and weakened layer adhesion. The system is compatible with PLA, ABS, PETG, TPU, PA, PC, and carbon/glass-fiber composites.



Image 3.3: The QIDI BOX enables seamless multi-color and multi-material printing.

3.3 Smart Print Management

- **Automatic Bed Leveling:** Ensures a perfect first layer every time.

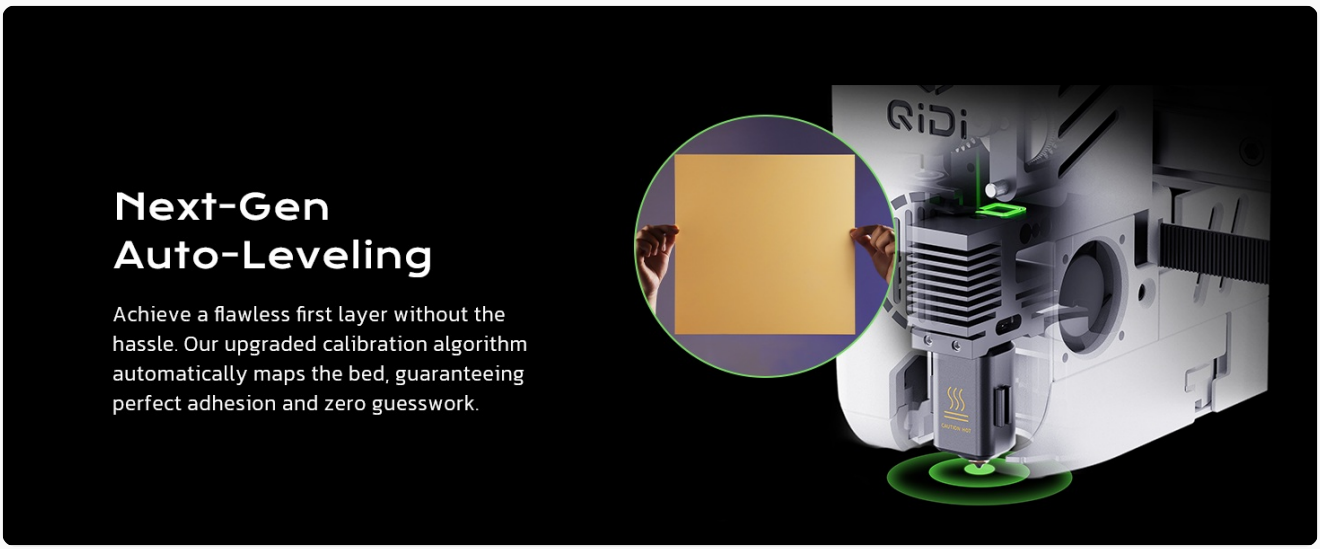

Image 3.4: The auto-leveling system ensures optimal bed adhesion.

- **AI-Powered Camera Monitoring:** Allows remote monitoring and fault detection. During batch production, failed individual parts can be skipped without pausing the entire print.

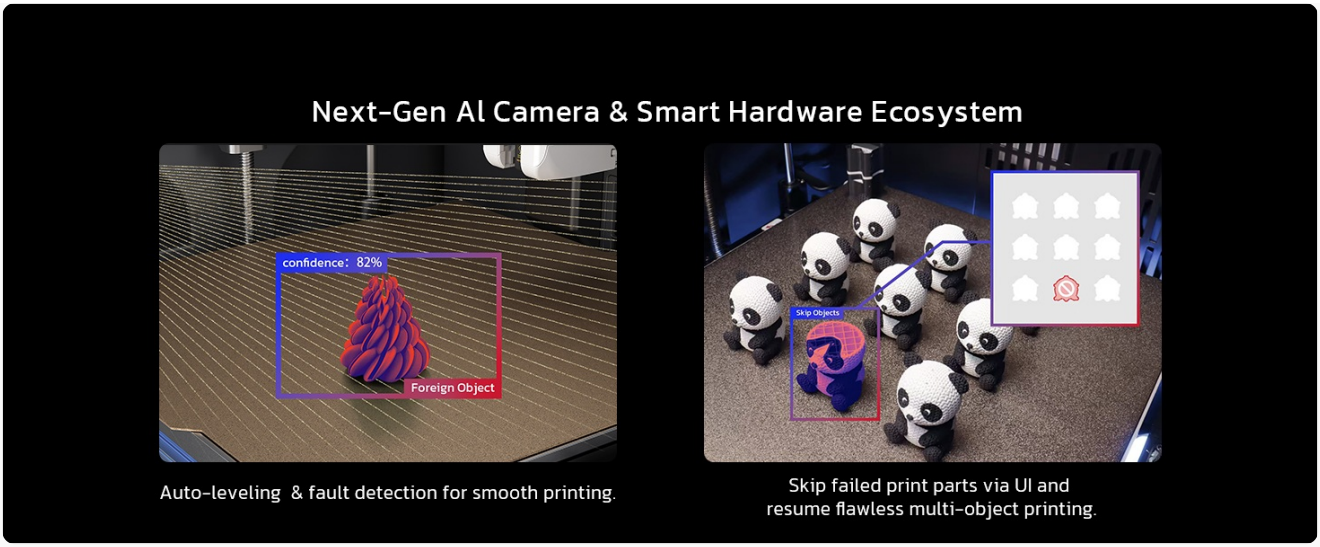

Image 3.5: AI camera for monitoring and fault detection.

- **Remote Control via Mobile App:** Prepare models remotely and send print jobs with one tap.

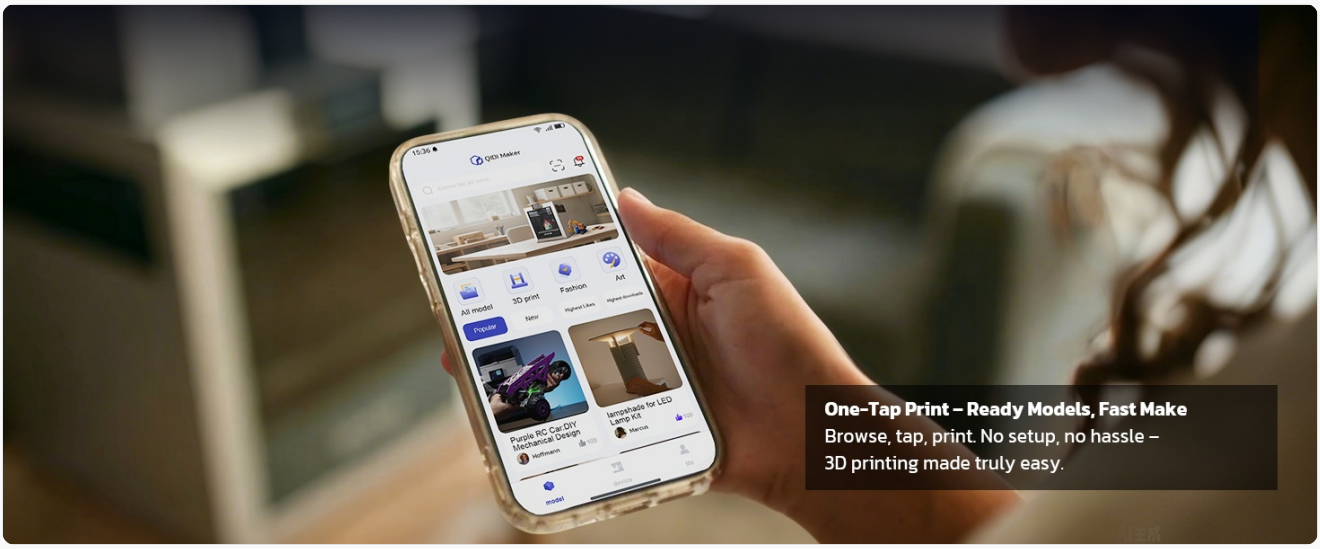

Image 3.6: Mobile app interface for one-tap printing.

- **RGB Status Light:** Provides clear visual feedback on printer status.

3.4 High-Speed and Precision Printing

The rigid CoreXY structure, combined with X-axis linear guide rails and 9mm timing belts, ensures stable, low-vibration printing at speeds up to 600mm/s and 20,000mm/s² acceleration, resulting in rapid prototyping and premium surface finish quality.



Image 3.7: X-axis linear guide rails and 9mm 1.5GT belt for enhanced motion precision.

4. Maintenance

4.1 Air Filtration System

The printer includes a 3-in-1 air filtration system to ensure a cleaner printing environment. Regularly check and replace the filter cartridge as needed to maintain optimal air quality.



Image 4.1: The 3-layer filter cartridge for air circulation and purification.

4.2 General Cleaning and Care

- **Build Plate:** Periodically wash the build plate with soap and water to ensure proper adhesion.
- **Interior:** Use a soft brush or cloth to clean the interior of the printer, especially around the print bed and motion system, to remove any filament debris.
- **Lubrication:** Apply lubricant grease to moving parts as recommended in the detailed maintenance guide (refer to the USB flash drive for full documentation).

5. Troubleshooting Common Issues

- **Warping:** Ensure the heated chamber is active (65°C) when printing with materials prone to warping. For optimal results, consider using the optional Polar Cooler.
- **Nozzle Clogs:** If using PLA, ensure the top cover is open to prevent heat creep, especially if not using the Polar Cooler. For high-temperature filaments, the active toolhead cooling helps prevent clogs.
- **Poor First Layer Adhesion:** Re-run the automatic bed leveling process. Clean the build plate thoroughly. Ensure the heated bed is reaching the correct temperature (up to 120°C).

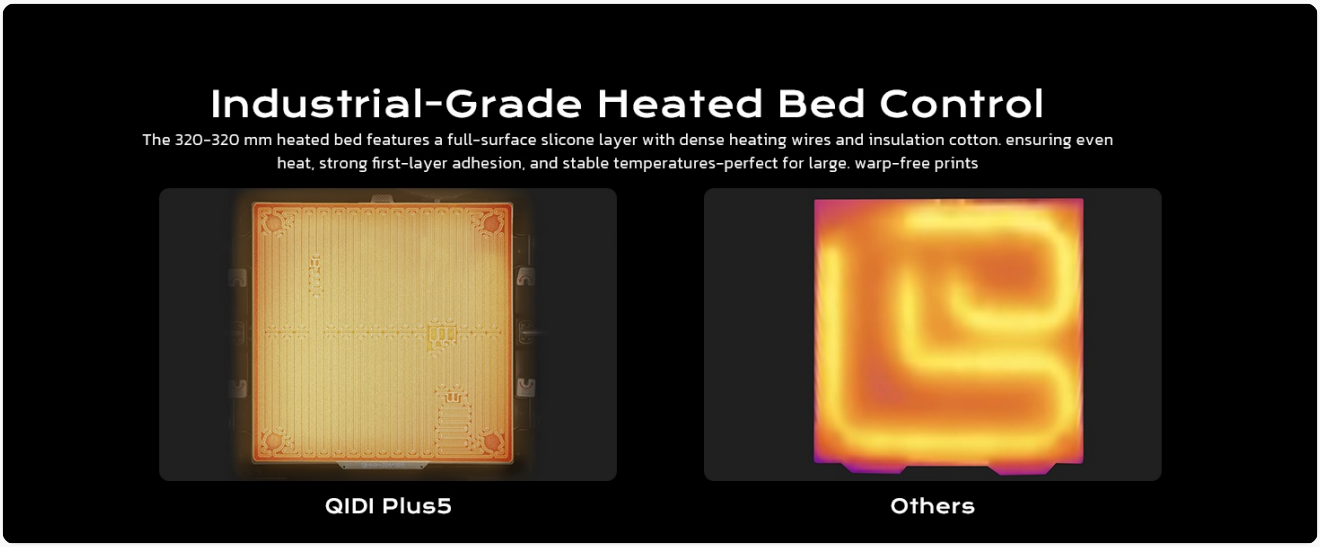

Image 5.1: The heated bed ensures uniform temperature for strong first-layer adhesion.

- **QIDI BOX Communication Issues:** If the QIDI BOX experiences software bugs or communication loss, check physical connections and consult the technical support team. Ensure the QIDI BOX firmware is up to date.
- **Filament Moisture Issues:** Utilize the active drying technology within the QIDI BOX. If not using the QIDI BOX, store filaments in a dry environment.

6. Technical Specifications

QIDI Plus5 Combo Specifications

Feature	Specification	Feature	Specification
Print Size (W*D*H)	320*320*300 mm	Printer Dimensions	500*488*558 mm
Package Dimensions	620*630*700mm	Gross Weight	37.8kg
Net Weight	Plus5: 29kg, Plus5 Combo: 36kg	Print Head Temperature	≤ 370°C
Printing Plate	Double-sided PEI Magnetic Build Plate	Hot Bed Temperature	≤ 120°C
Max Speed of Tool Head	600mm/s	Acceleration	≤ 20000mm/s²
XY Structure	CoreXY, 9mm Width 1.5GT Belt	X Axis	High Hardness Linear Guide Rail
Z Axis	Dual Independent Lead Screw Motors	Printing Platform	Aluminum Plate Silicone Heated Bed Status RGB LED
Nozzle	Bimetal Nozzle	Nozzle Diameter	0.4mm (0.2/0.6/0.8mm Optional)
Extruder Gear	Direct Extruder Hardened Steel 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)

7. Warranty and Support

QIDI TECHNOLOGY provides lifetime technical support for the Plus5 Combo 3D Printer. For any technical assistance, troubleshooting, or warranty inquiries, please contact QIDI's customer support team. Detailed contact information can be found on the official R QIDI TECHNOLOGY website or through the provided documentation on the USB flash drive.

You can also visit the official R QIDI TECHNOLOGY Store for more information and resources.

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