

FLASHFORGE 5M Adventurer 3D Printer



# FLASHFORGE 5M Adventurer 3D Printer User Guide

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**FLASHFORGE 5M Adventurer 3D Printer**



## Product Information

### Specifications:

- **Model:** Adventurer 5M
- **User Guide:** EN/CN-A03
- **Room Temperature:** 15-30°C
- **Humidity:** 20-70% RH
- **Compatible Filament:** Flash Forge's filaments recommended

## Product Usage Instructions

### Initial Setup

#### 1. Unboxing

When unboxing the printer, carefully remove all packaging materials and ensure that no components are damaged during the unboxing process.

#### 2. Packing List

Check the packing list to ensure all components mentioned are present in the package. Contact customer support if any items are missing.

#### 3. Installing the Spool Holder and Filament Guide Tube

Follow the provided instructions to install the spool holder and filament guide tube correctly to ensure smooth filament feeding during printing.

#### 4. Installing the Screen

Mount the screen as per the guidelines provided in the user manual to enable interaction with the printer's

interface.

## 5. Unlocking the Build Plate

Unlock the build plate by following the specified steps to prepare it for printing.

### First Print

Initiate your first print job by selecting a suitable model and following the printing instructions provided in the user manual.

### Software Introduction & Installation

Refer to the software installation section in the user guide to install the necessary software for operating the printer.

### Printing

### Filament Loading and Changing

Follow the detailed instructions for loading and changing filament to ensure proper material flow during printing.

### FAQ

- **Q: What should I do if the printer encounters a filament jam during printing?**

A: In case of a filament jam, stop the printing process immediately, allow the extruder to cool down, and carefully remove the jammed filament following the user manual's instructions.

- **Q: How often should I perform maintenance on the printer?**

A: Regular maintenance is essential for optimal printer performance. It is recommended to clean the build plate, check for filament residue regularly, and lubricate moving parts as per the maintenance guidelines provided in the user manual.

### Warning:

1. Please refer to this Guide for initial printer setup.
2. **Hot!** Avoid touching the heating nozzle in operation.
3. Moving parts in the printer may cause injuries. Do not wear gloves or other sources of entanglement in operation.

### Safety Notice

Do not power on the printer until installation is completed.

For more information, you can visit the Flashforge official website. [www.flashforge.com](http://www.flashforge.com) – [Support]



### NOTICE

**SAFETY NOTICE:**

PLEASE CAREFULLY READ AND STRICTLY FOLLOW ALL THE SAFETY WARNINGS AND NOTICES BELOW ALL THE TIME.

**Note:**

Each 3D printer undergoes printing tests before leaving the factory. Filament residue on the nozzle or slight scratches on the build plate are normal and do not affect usage.

**WORK ENVIRONMENT SAFETY**

- Please keep the workspace clean and tidy.
- Please ensure the equipment operates away from combustible gases, liquids, and dust. High temperatures generated during operation may react with combustible gases, liquids, or airborne dust, potentially causing fires.
- Children and untrained individuals should not operate the equipment alone.

**ELECTRICAL SAFETY**

- Please properly ground the equipment. Do not modify the plug. Ungrounded equipment/improperly grounded equipment/modified plug will inevitably increase the risk of electric leakage.
- Avoid exposing the equipment to damp or direct sunlight environments. Humidity will increase the risk of electric leakage. Exposure to sunlight will accelerate the aging of plastic parts.
- Make sure to only use the power cord provided by Flashforge.
- Do not use the equipment during thunderstorms.
- Please turn off the equipment and unplug it if it is not in use for a long time.

**PERSONAL SAFETY**

- Do not touch the extruder, build plate, etc., during printing.
- Do not touch the extruder and build plate after finishing printing to avoid high-temperature burns or mechanical damage.
- Do not wear scarves, masks, gloves, jewellery, or other objects that can easily get tangled in the equipment while operating it.
- Do not operate the equipment while you are tired or under the influence of drugs, alcohol or medication.

**CAUTIONS**

- Keep the inside of the equipment clean. Do not drop metal objects into the grooves at the bottom of the build plate.
- Please clean up filament debris in time. It is recommended to operate this outside the equipment.
- Any modification of the equipment by yourself will void the warranty.
- Please keep the distance between the extruder and the build plate at least 50mm during filament loading. Too close a distance may cause nozzle clogs.
- Please operate the equipment in a well-ventilated environment.
- Do not use the equipment for illegal activities.
- Do not use the equipment to make food storage containers.

- Do not place printed models into your mouth.

## **EQUIPMENT ENVIRONMENT REQUIREMENTS**

Room temperature: 15-30°C; Humidity: 20-70RH%

## **EQUIPMENT PLACEMENT REQUIREMENTS**

- The equipment must be placed in a dry and well-ventilated environment.
- A distance of at least 20cm must be reserved around the front, back, left and right sides of the equipment.

Recommended storage temperature: 0-40°C

## **COMPATIBLE FILAMENT REQUIREMENTS**

When using this equipment, it's recommended to use Flashforge's filaments. If non-Flashforge filaments are used, there will be certain differences in material properties, and print parameters may need adjustments.

## **FILAMENT STORAGE REQUIREMENTS**

Please store filaments in a dry and dust-free environment after unpacking. It is recommended to use the matching filament dry box for storage.

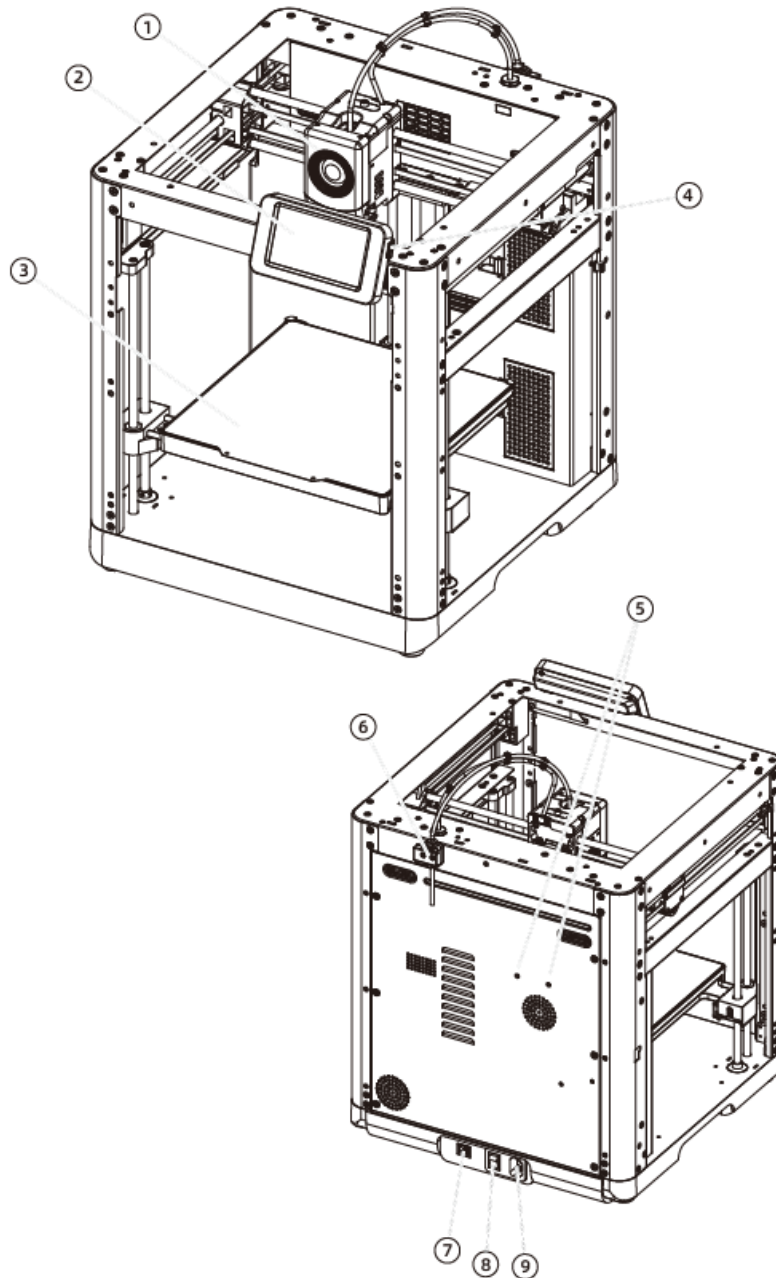
## **LEGAL STATEMENT**

- Users are not authorized to make any modifications to this User Guide.
- Flashforge shall not be held responsible for any safety incidents resulting from the disassembly or modification of the equipment by the customer. No one is allowed to modify or translate this Guide without Flashforge's permission.
- This Guide is protected by copyright, and Flashforge reserves the right of the final interpretation of this Guide.
- First Edition (September 2023)
- Copyright © 2023 Zhejiang Flashforge 3D Technology Co., Ltd. All Rights Reserved.

## **Equipment Introduction**

### **Printer Components**

1. Extruder
2. Touch Screen
3. Build Plate
4. USB Port
5. Screw Holes for Spool Holder
6. Filament Detection Sensor
7. Ethernet Input
8. Power Switch
9. Power Socket



## Printer Parameters

- Machine Name Adventurer 5M
- Extruder Quantity 1
- Printing Precision  $\pm 0.1\text{mm}$  [testing based on 100mm cubes]
- Positioning Accuracy X/Y-axis 0.0125mm, Z-axis 0.0025mm
- Layer Thickness 0.1-0.4mm
- Build Volume 220 x 220 x 220mm
- Nozzle Diameter 0.4mm default [0.6/0.8/0.25mm optional]
- Printing Speed 10-300mm/s
- Max Acceleration 20000mm/s<sup>2</sup>
- Max Travel Speed 600mm/s
- Max Extruder Temperature 280°C
- Supported Filament
  - PLA/\*PETG [0.4mm nozzle]

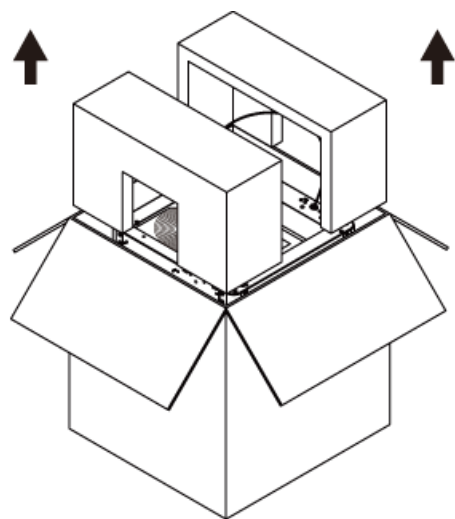
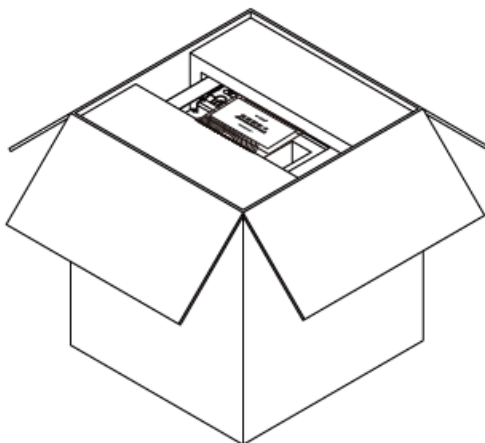
- TPU/PLA-CF/PETG-CF [0.6/0.8mm nozzle] **Note:** Materials marked with \* are recommended for printing.
- Power Supply Input: AC 100~120V/200~240V 50/60Hz 350W
- Device Size
  - **363 x 376 x 413mm**  
[excluding the display screen and spool holder]
  - **363 x 402 x 448mm**  
[including the display screen, excluding the spool holder]
- Net Weight 10.8kg
- Connectivity USB/Wi-Fi/Ethernet
- Operating Temperature 15-30°C
- Compatible Operating System
  - Windows 7/8/10/11; Linux: support version Ubuntu
  - 20.04 or later; Mac OS: support version 10.9 or later
- Slicing Software Orca-Flashforge
- Max Platform Temperature 110°C
- Filament Run-out Reminder ✓
- Power Loss Recovery ✓
- Smart Touch Screen 4.3-inch
- Build Plate PEI flexible steel plate

## Initial Setup

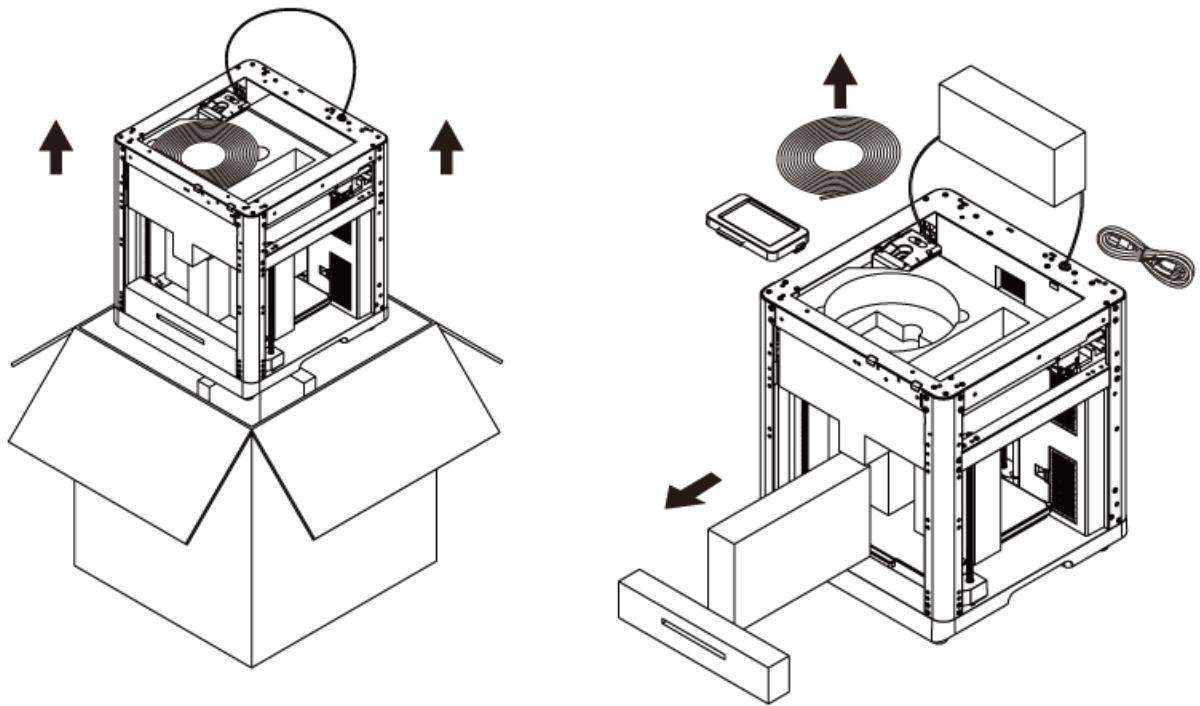
### Unboxing

**Safety Notice:** Do not power on the printer until installation is completed.

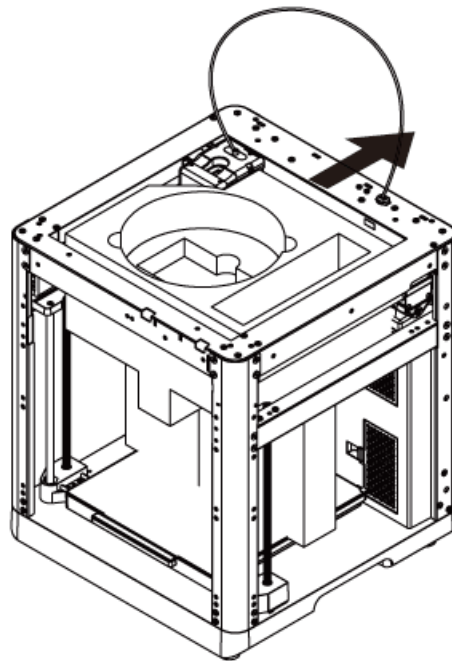
1. Open the box.
2. Remove the upper foam packaging, Quick Start Guide and After-sales Service Card.



3. Take out the machine, place it on a level workspace and remove the packaging bags and tapes.
4. Remove the filament, power cable, screen, and accessory box from the chamber protective foam. Remove the inner protective foam from the extruder.

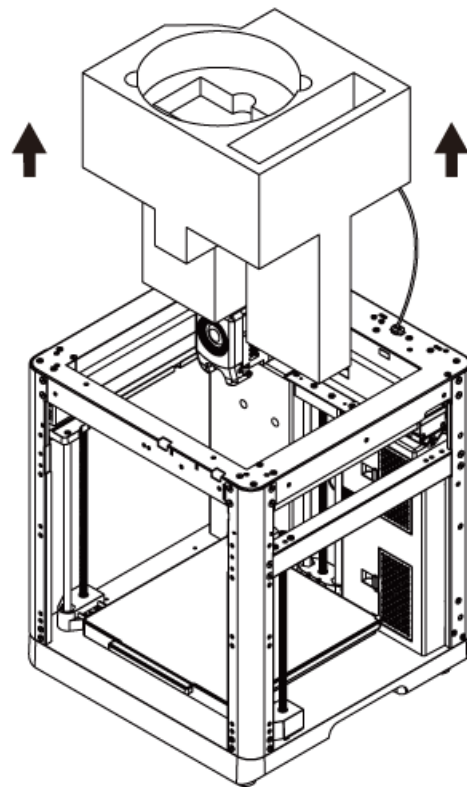


5. Move the chamber foam according to the arrow direction.



6. Remove the foam.



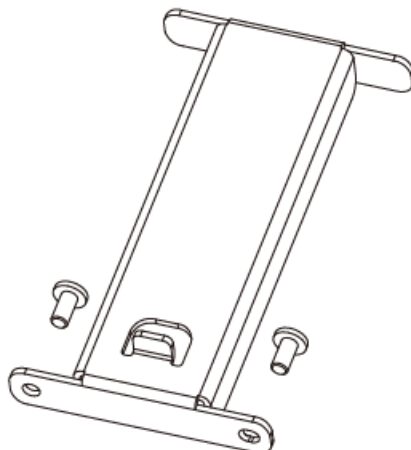


**Packing List**

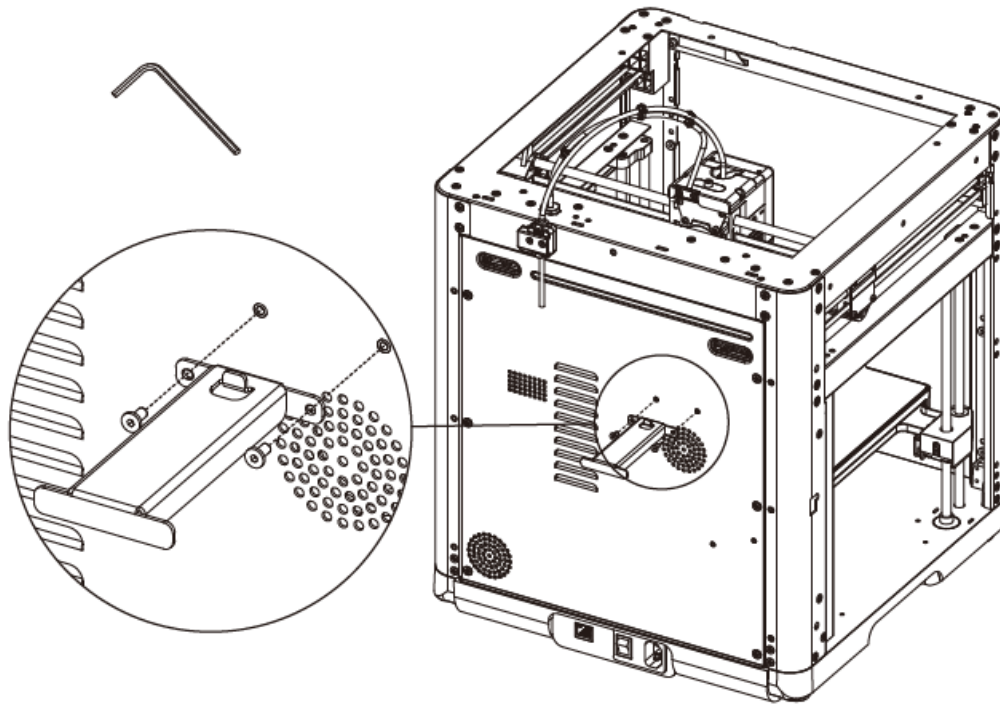


## Installing the Spool Holder and Filament Guide Tube

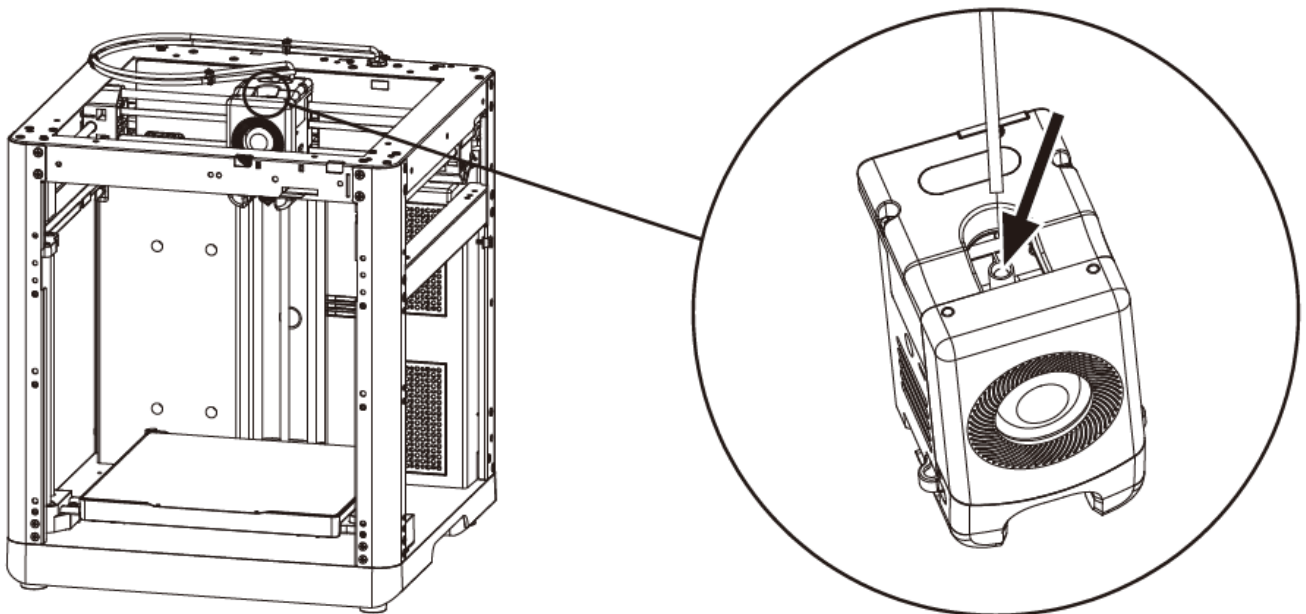
1. Take out the two screws and spool holder from the accessory box.



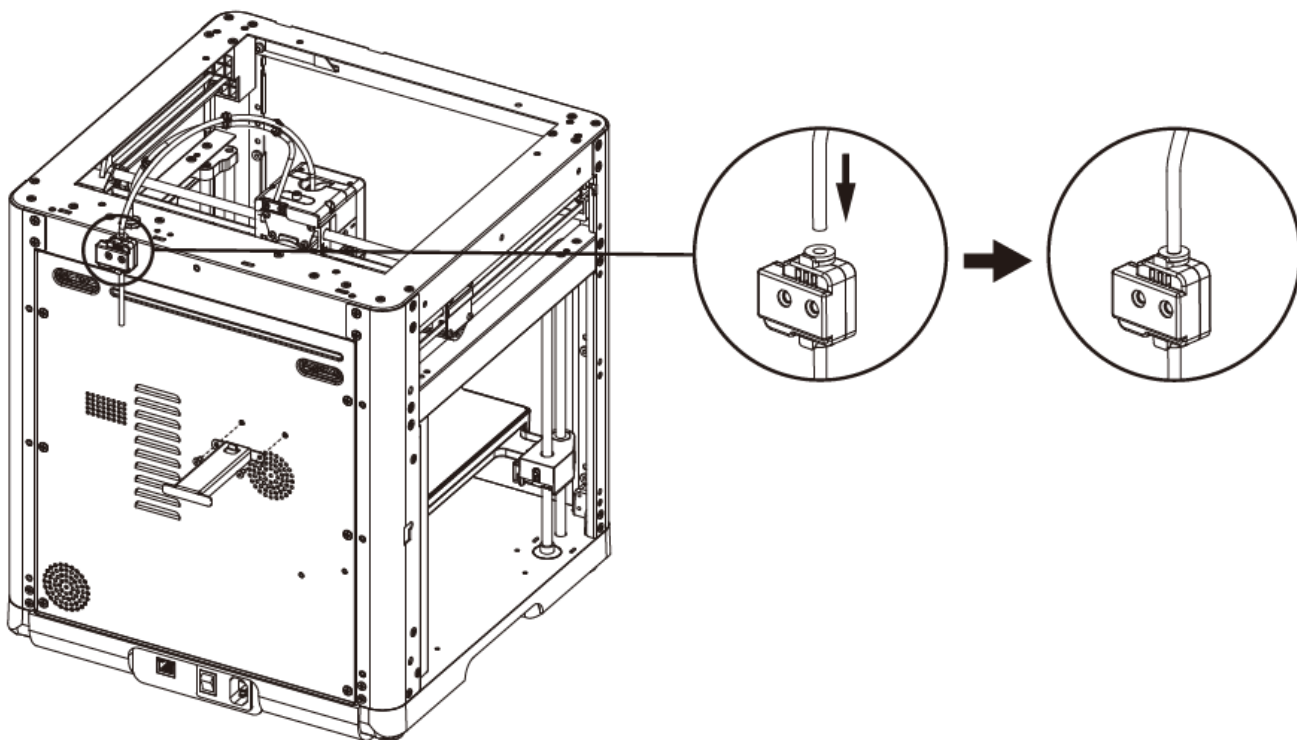
2. Install the spool holder at the position shown in the figure with the two screws. (Note: Please tighten them using a 2.0mm Allen wrench.)



3. Insert the filament guide tube into the extruder.



4. Insert the other end of the filament guide tube into the filament detection sensor.

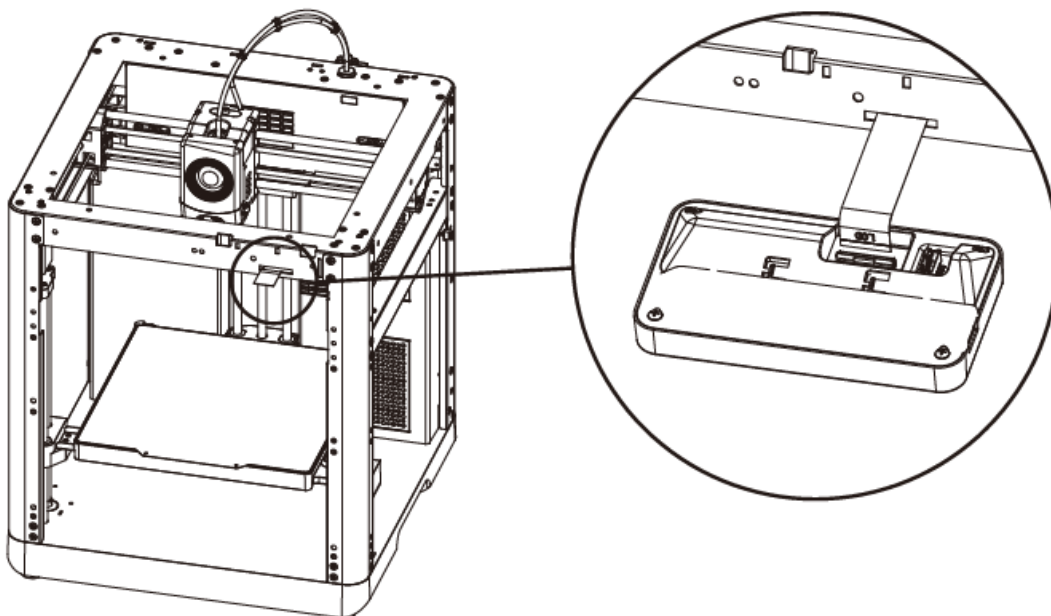


## Installing the Screen

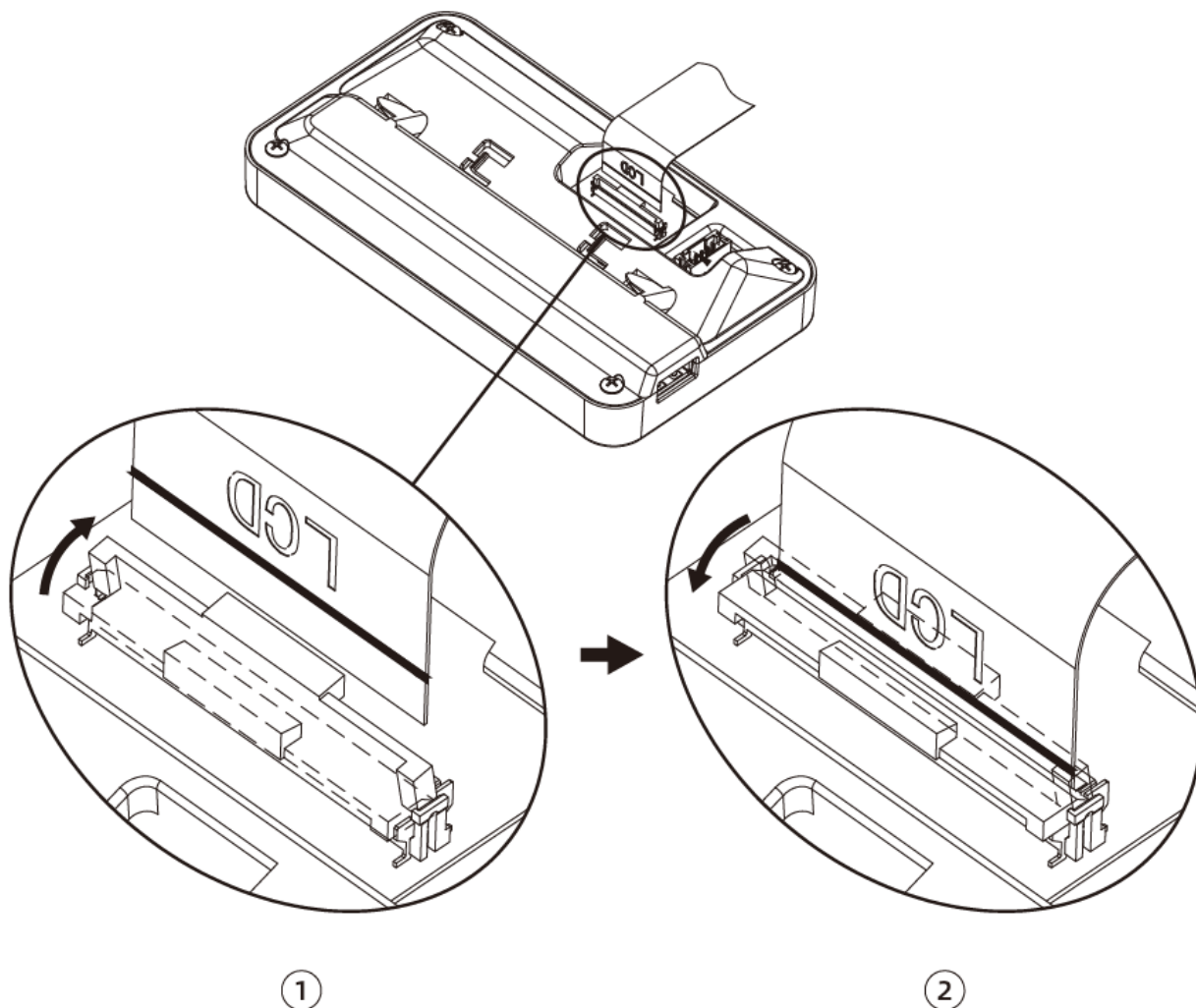
### Note

Before installation, please remove the tape from the screen cable. Tear it off gently to Note avoid damaging the cable.

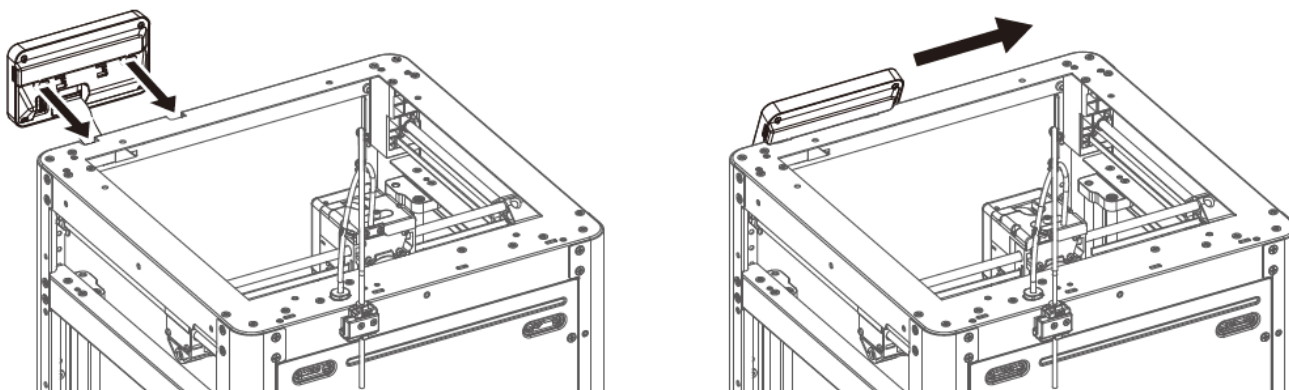
1. As shown in the picture, insert the screen cable into the screen connector.



- Lift the buckle on the screen's cable socket to the indicated position (Fig. ①), then insert the screen cable into the socket connector. Note: Ensure proper insertion and check the alignment of the indicator line with the socket.
- Press down the buckle on the cable socket to the indicated position according to the arrow direction (Fig. ②).



2. Insert the buckle on the back of the screen into the printer's slot, and push the screen according to the arrow direction to lock it in place.

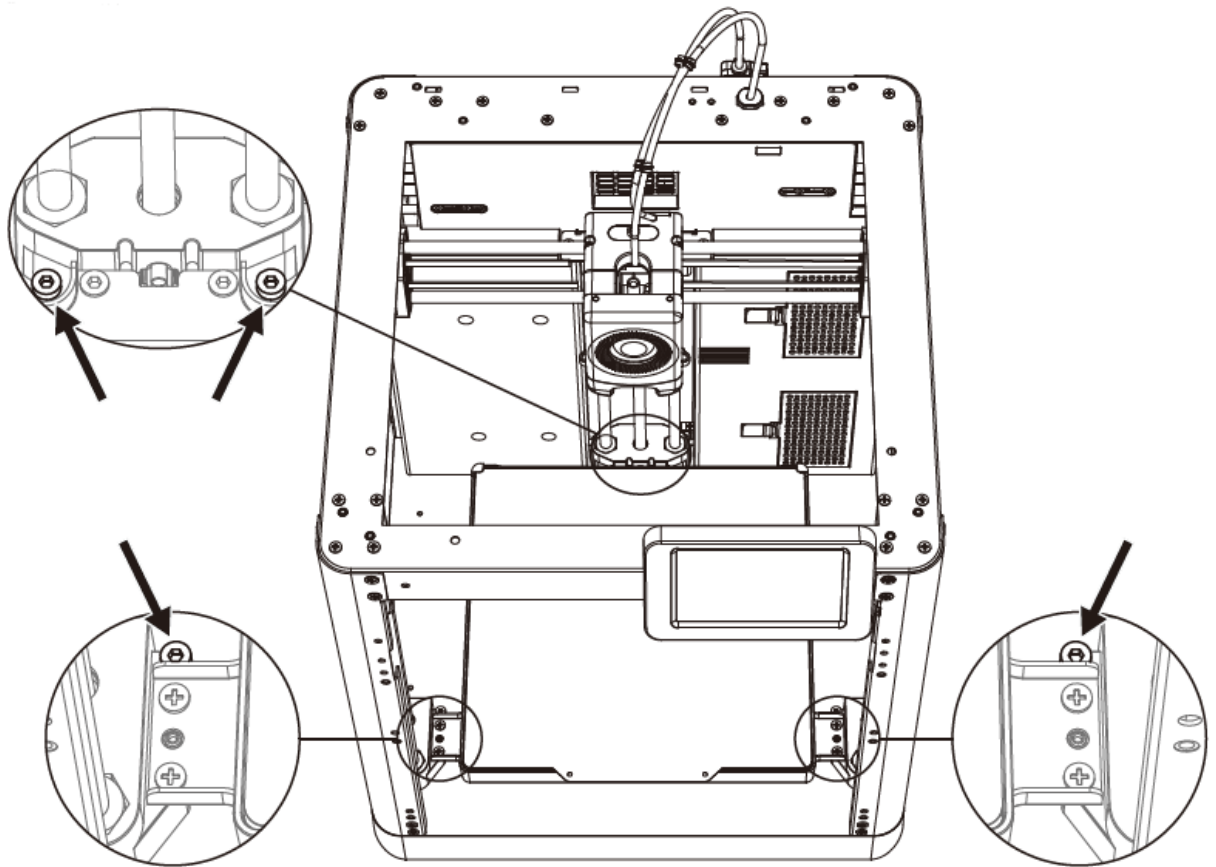


## Unlocking the Build Plate

### Note

Please ensure the platform has been cleared up!

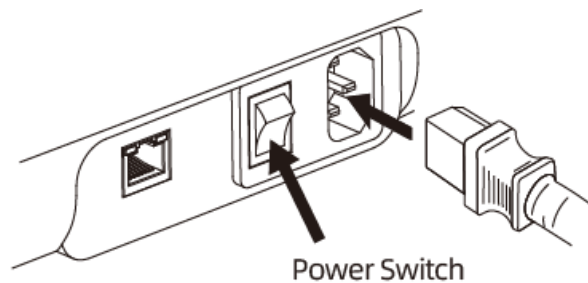
Please use a 2.0mm Allen wrench to remove four screws which lock the build plate (as indicated by the arrow).



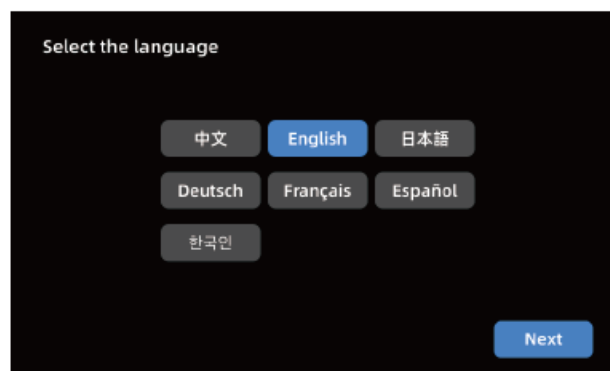
### First Print

The interface layout may change whenever there is an upgrade of firmware.

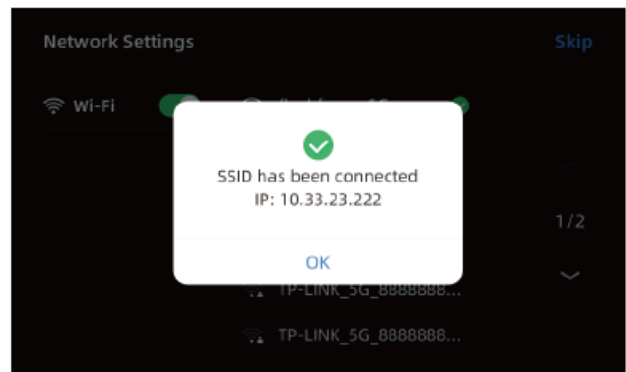
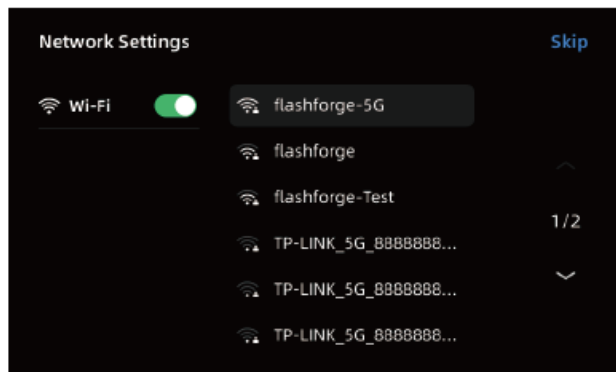
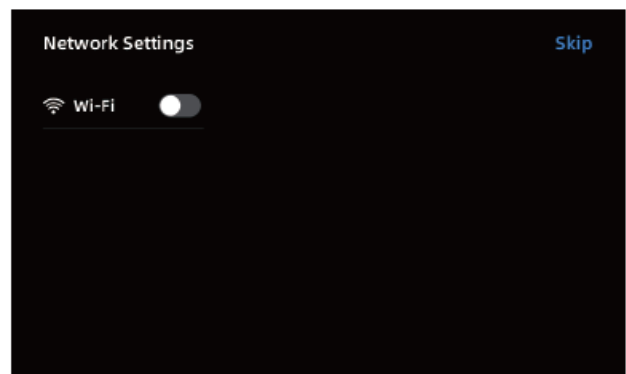
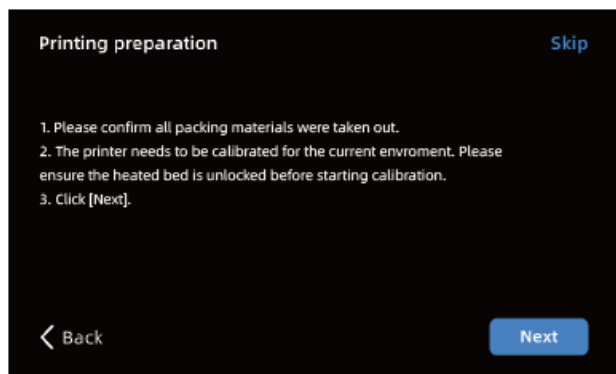
1. Power on the printer, turn on the power switch and wait for the screen to respond.



2. Following the guide on the screen, select the language.

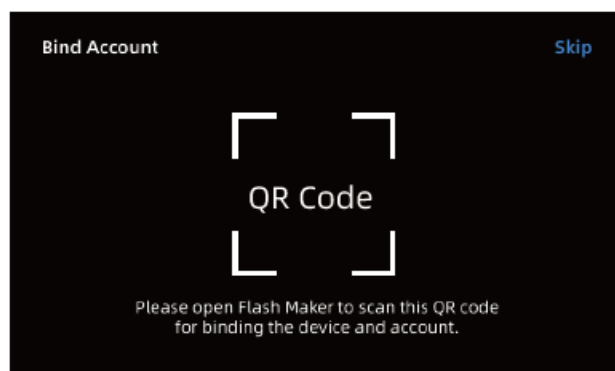


3. Turn on the Wi-Fi switch and connect to the network following the instructions. A successful connection notification will pop up once connected.



4. Bind the printer following the instructions. (Note: If skipped, binding can still be done later on the printer; see Page 17.)

- After clicking [OK], the QR code page will appear.

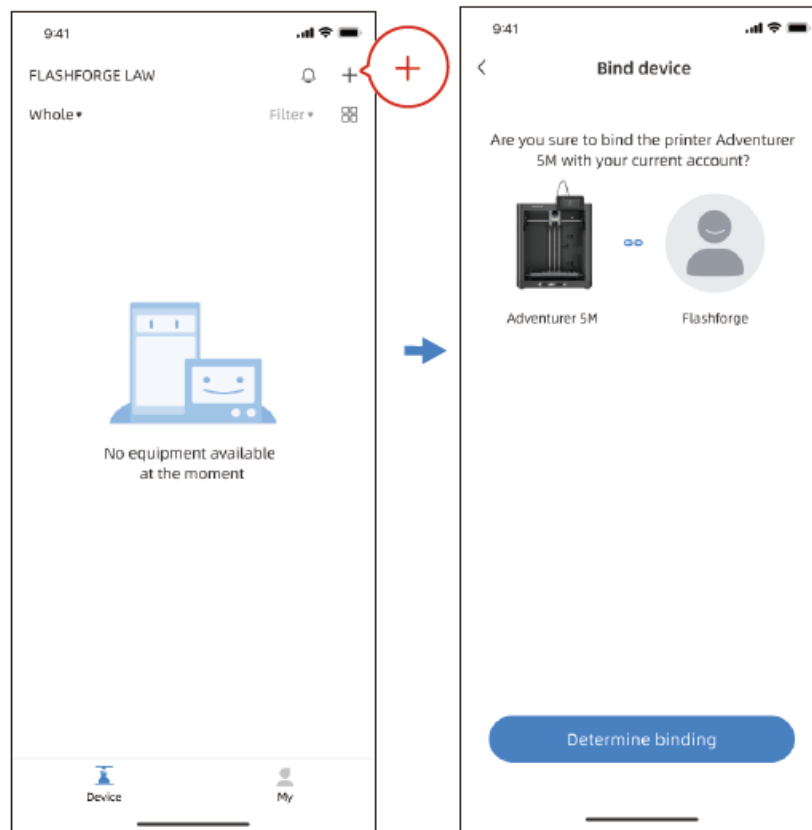


- Download Flash Maker by scanning the QR code (see right) or from the app store, register your Flashforge account, and log in.



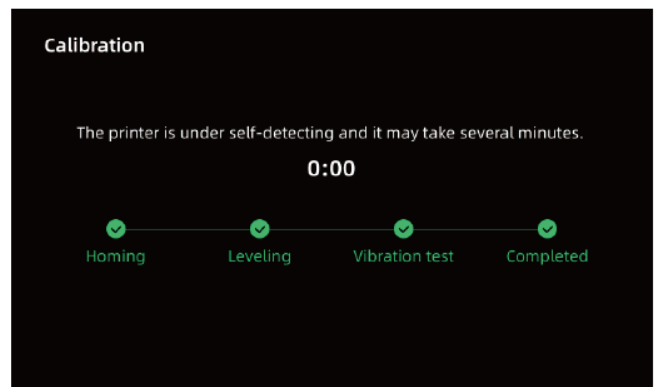
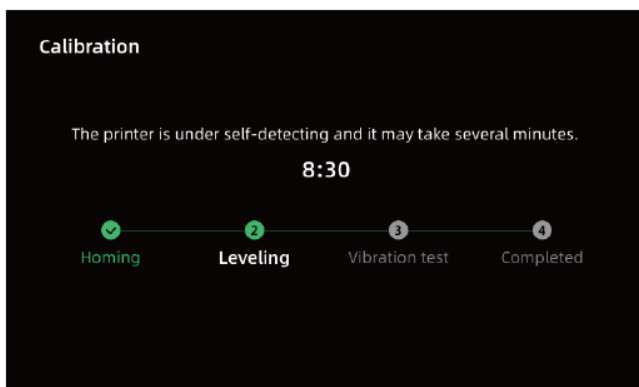
- Use Flash Maker to scan the QR code on the printer screen to bind the printer to your account. (Note: Default printer name and location are set upon leaving the factory; after completing the startup, you can customize the printer name and location in the settings.)



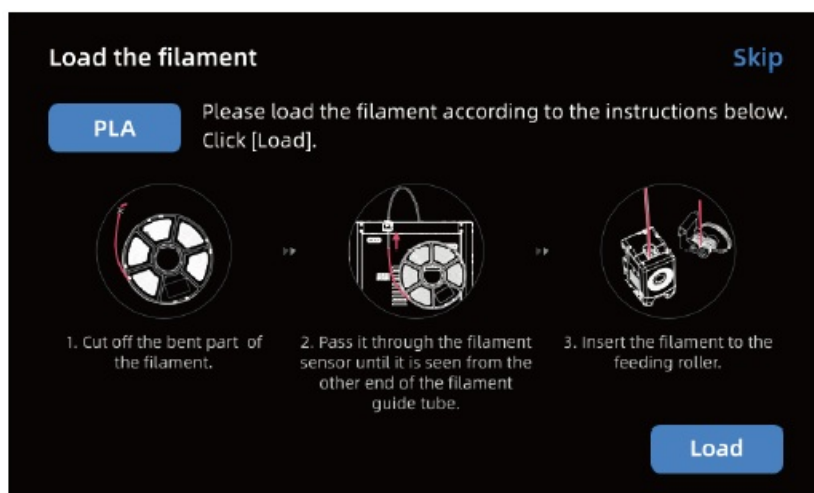


5. Click [Next] and the machine will perform the first calibration. Vibrations and noise during calibration are normal.

(Note: Please keep the machine on a stable surface and do not move it during calibration.)

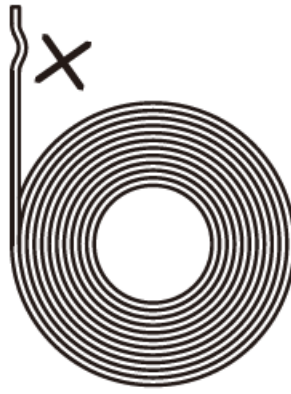


6. Load filament following the on-screen startup boot:

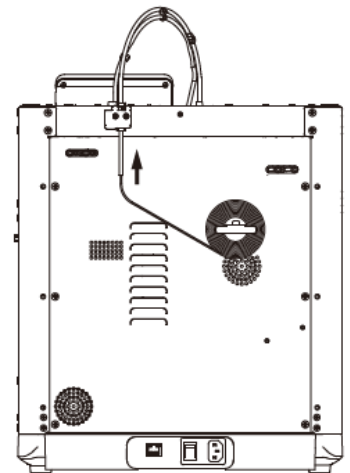
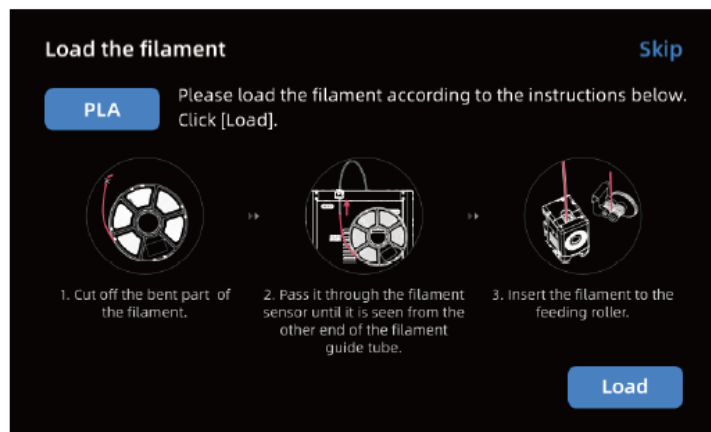


- Cut off the bent part of the filament end.

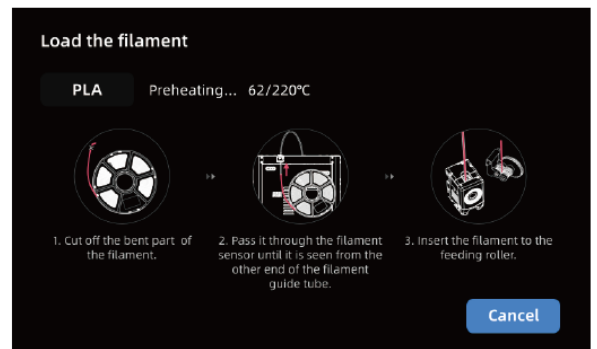
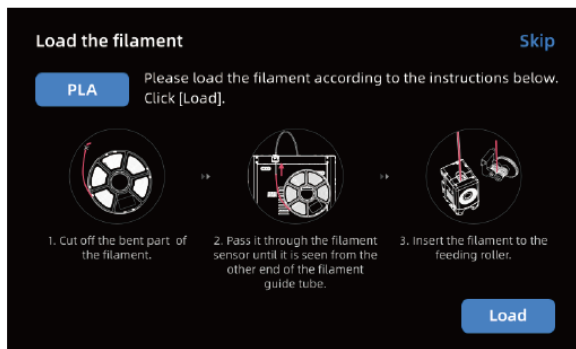




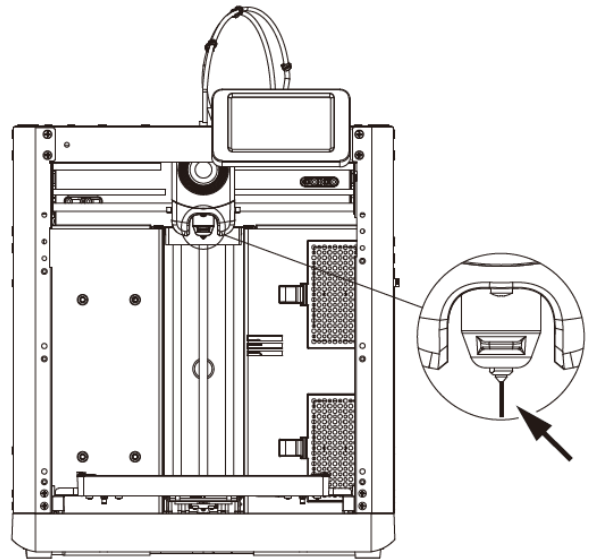
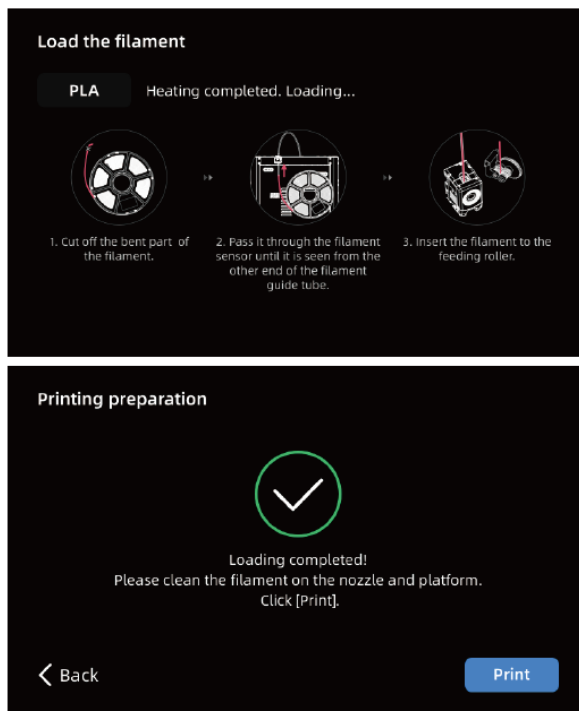
- Hang the filament on the spool holder. Pass it through the filament sensor until it's seen from the other end of the filament guide tube. Push it forward to the feed roller, until it can not go further. (Please use PLA filament for the first print on initial setup).



1. Click [Load] and select [PLA] for the first print.
2. Wait for the extruder to heat up.



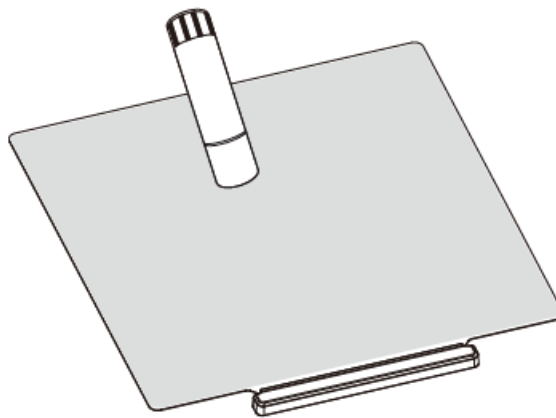
3. Feeding will begin after heating. Successful filament extrusion from the nozzle indicates successful loading. Lastly, confirm the filament guide tube is properly inserted.



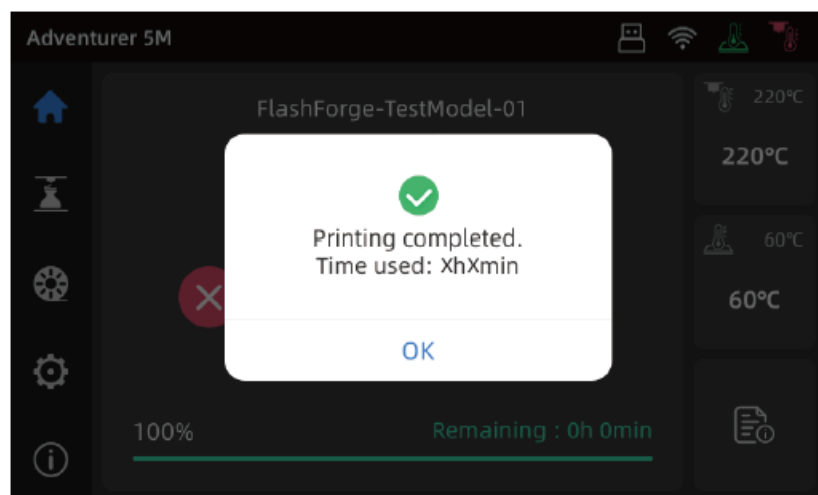
### Note

If no filament is extruded, manually insert the filament into the inlet and click [Back] to retry. Feel for filament movement until it is extruded.

7. Please clear the filament residues on the nozzle and platform. Users must apply glue to the platform to improve adhesion for the first print.



8. Click [Print] and the machine starts printing the built-in file (configured for PLA material).



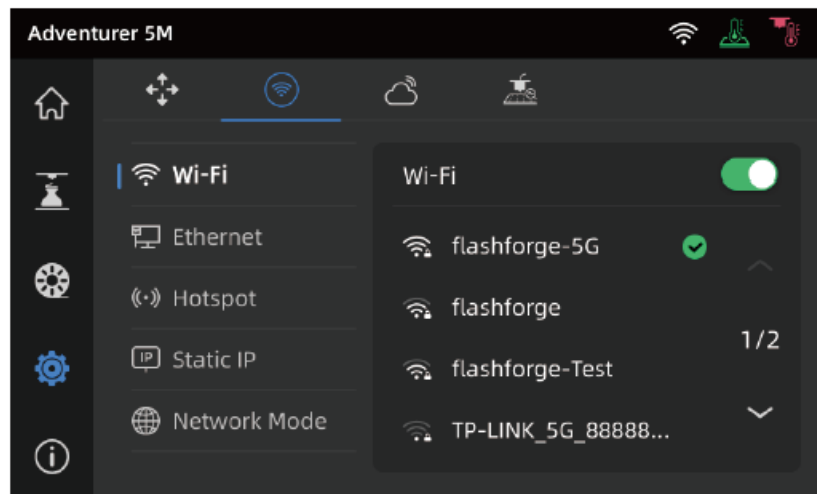
## Software Introduction & Installation

### Flash Maker Instructions

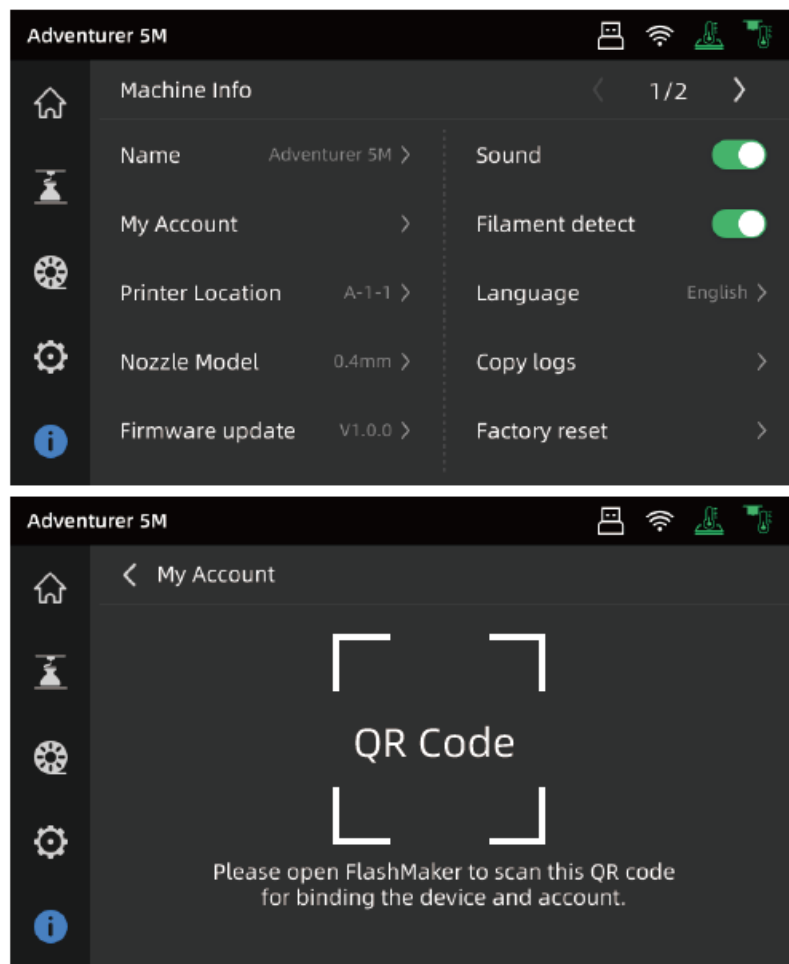
1. Download Flash Maker by scanning the QR code (see below) or from the app store, register your Flashforge account, and log in.



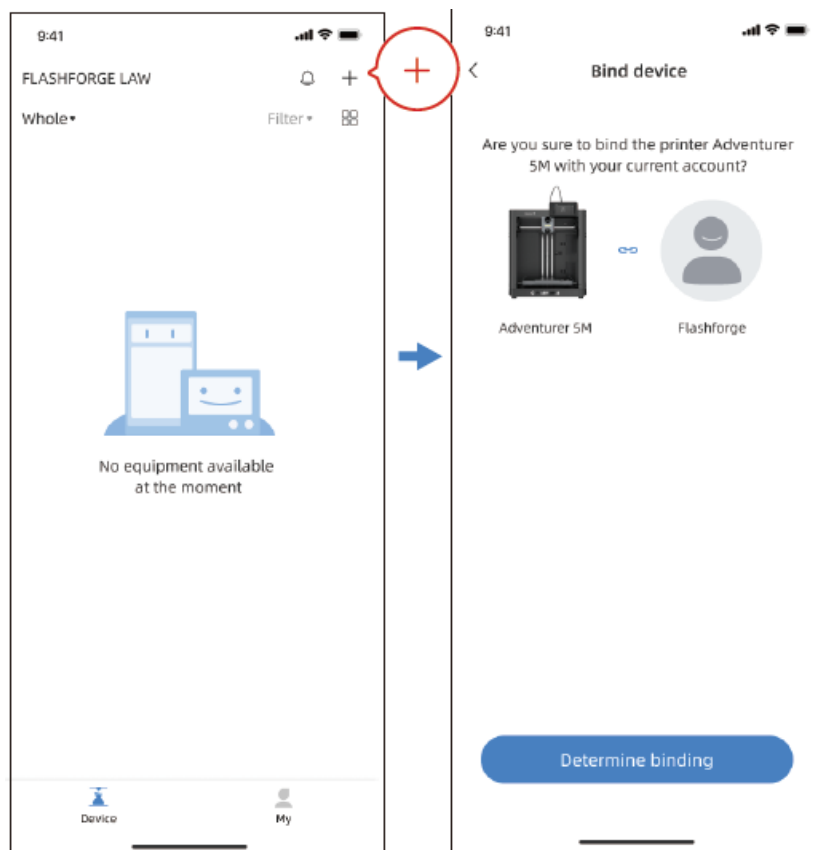
2. Click [⚙️] – [📶], and then turn on the Wi-Fi switch to connect to the network.



3. Click [ ⓘ ] to enter the information interface, and then click [My Account] to access the printer's QR code.



4. Use Flash Maker to scan the QR code on the printer screen to bind the printer to your account.



#### NOTE:

1. By default, the device name is set to “Adventurer 5M”, and its location is set to “Group A” upon factory settings.

- You can modify the name and location on the printer's information interface as needed.
2. Real-time monitoring is only accessible when a camera is installed and the feature is enabled.
  3. The APP does not support a connection in the LAN-only mode.

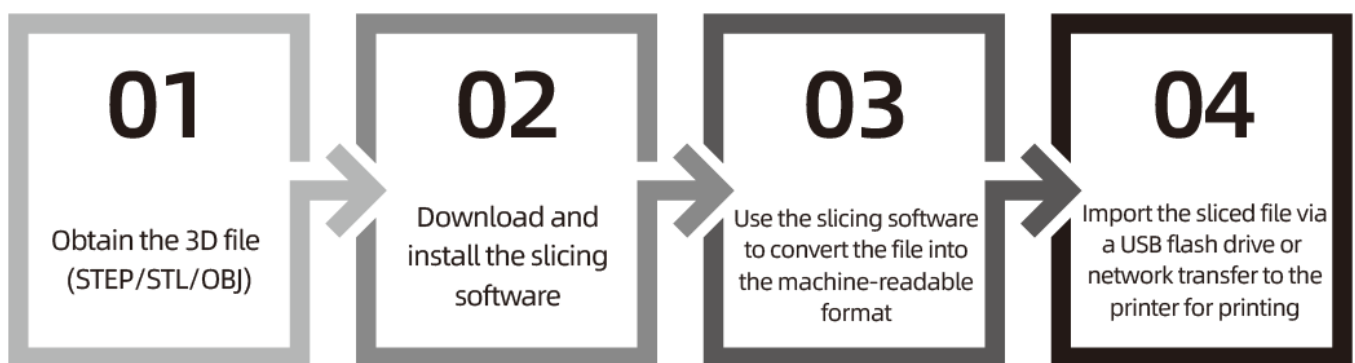
## Slicing Software Instructions for Adventurer 5M Series

### Note

Before reading the brief instructions, please ensure you have reviewed the Quick Start Guide and completed the first print.

Before printing 3D model files, you need to configure slicing presets for the corresponding printer. Recommended slicing software: Orca-Flashforge/OrcaSlicer.

### Pre-printing Steps:



### Orca-Flashforge

The steps are illustrated for one machine type.

Orca-Flashforge is a slicing software developed based on OrcaSlicer, with custom features tailored for the Adventurer 5M series.

### Download Instructions:

- Download the latest slicing software from: <https://www.flashforge.com/download-center>.
- Find the Orca-Flashforge installation package on the USB flash drive and install the version that matches your system.

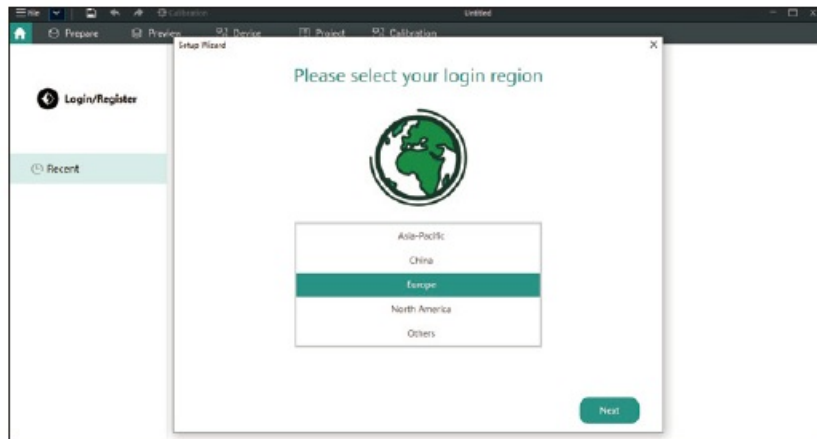
1. Open the installed Orca-Flashforge.



### 2. Setup Wizard:

Follow the setup wizard prompts for selecting your region, machine type, and materials.

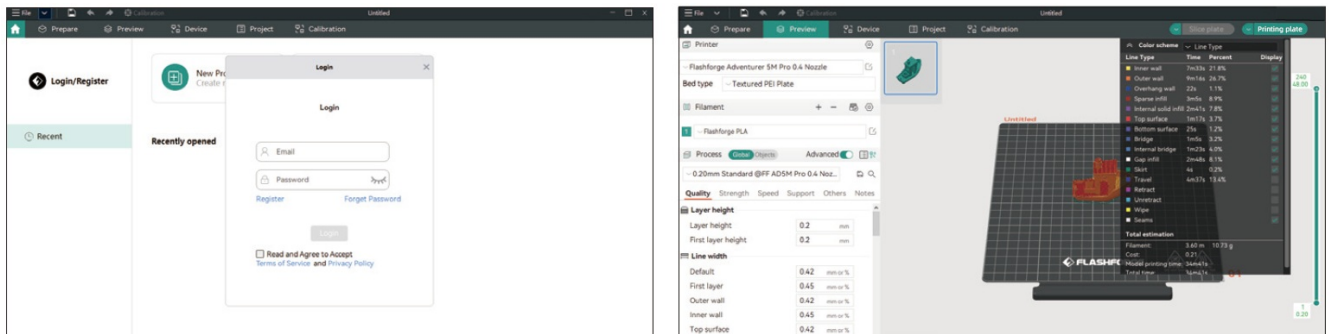
(Note: You can select all machine types and material types in the list for later slicing options.)



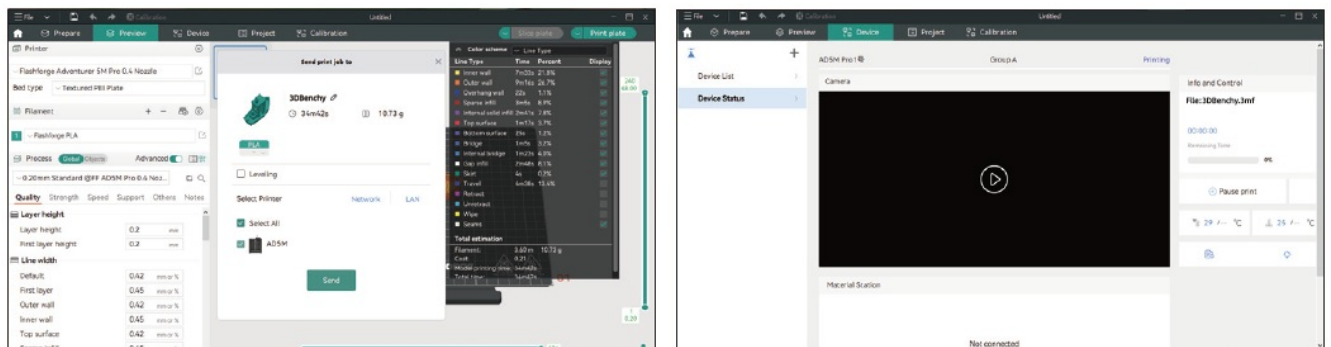
### 3. Account Login/Register:

Log in to Orca-Flashforge using your Flashforge account. If you don't have an account, register one using your mobile phone number. (Note: Flash Maker and Orca-Flashforge share the same account.)

4. Create or open a project for slicing. You can select the machine type, material, and recommended parameters in the printer, filament, and process bars.



5. After slicing, select the printer and send it for printing.
6. You can remotely monitor the printing progress and pause/stop printing when necessary on the device interface. (Note: Real-time monitoring is only available with a camera installed and activated.)



### OrcaSlicer Download Instructions:

1. Download the latest slicing software from: <https://github.com/SoftFever/OrcaSlicer/releases>.
2. Download from the official Flashforge Download Center (<https://www.flashforge.com/download-center>).

**Note:** Please download slicing software version 1.8.0 or later.


### Tip:

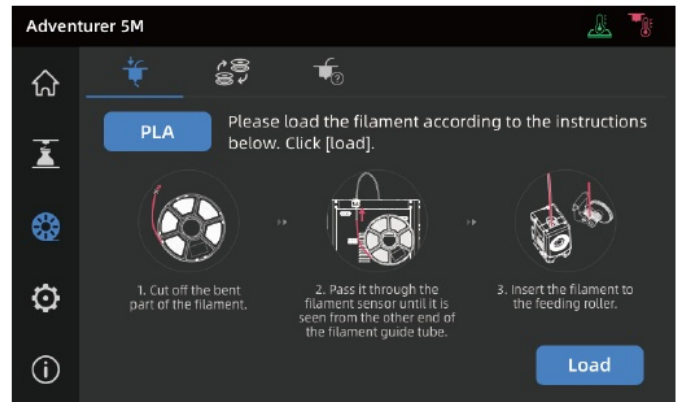
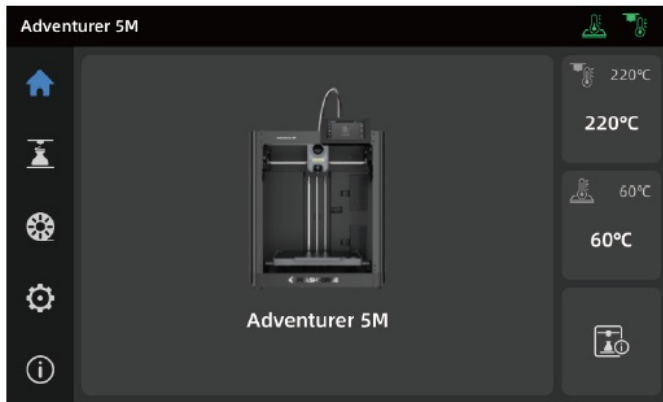
For details and tutorials on software usage, please refer to Flashforge Wiki. (<https://wiki.flashforge.com/en/home>).

### Printing



## Filament Loading and Changing

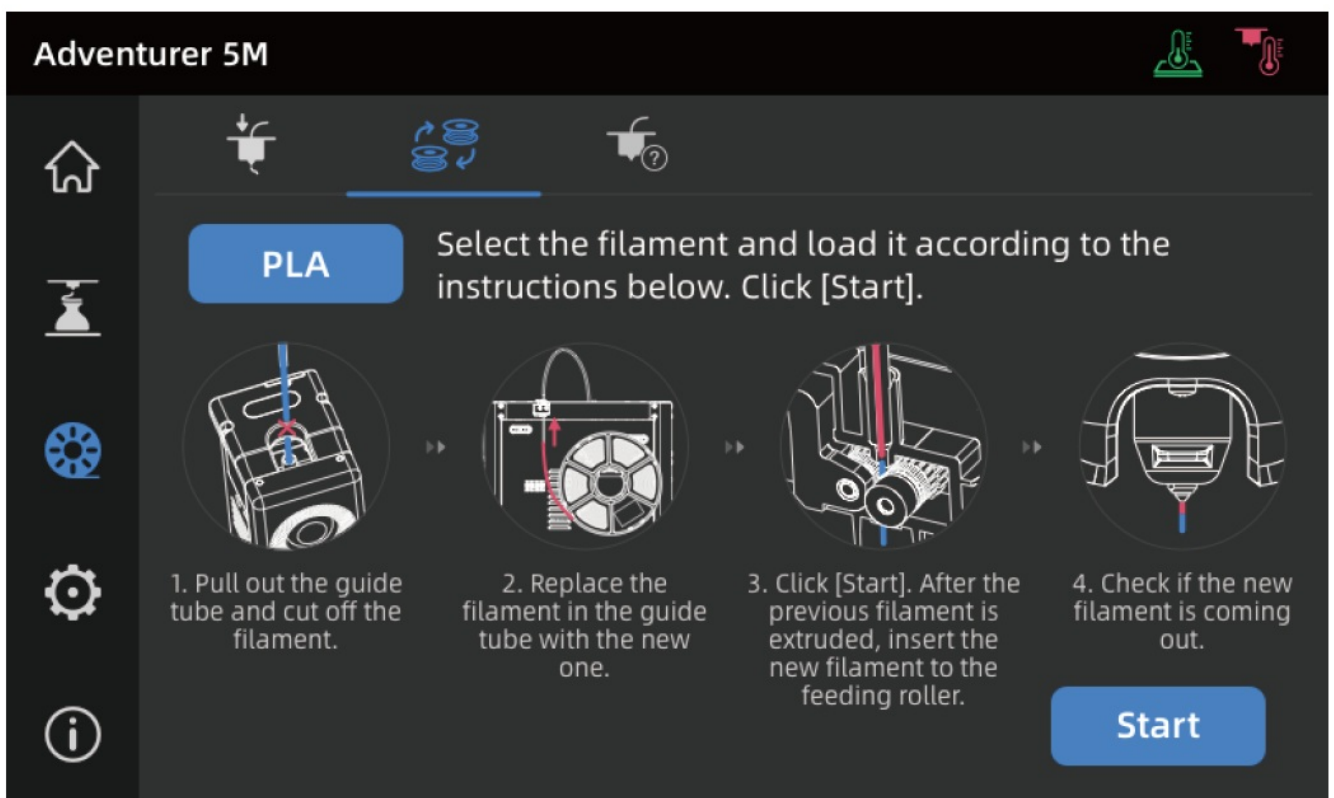
### Filament Loading

Click [  ] to enter the filament loading interface and follow the on-screen instructions to complete filament loading.

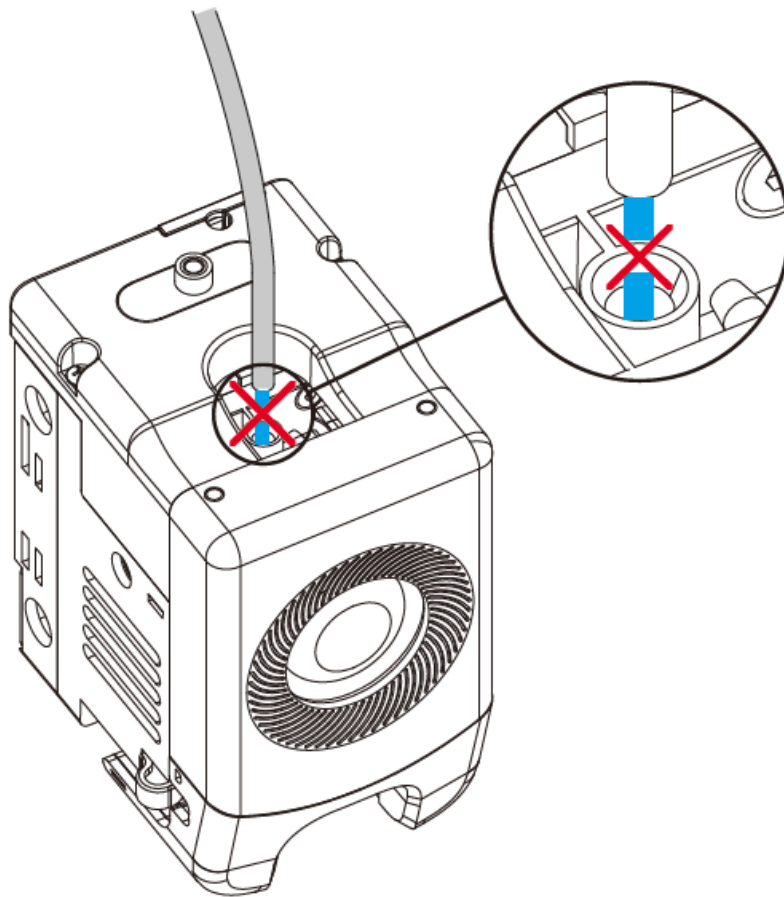


### Filament Changing

1. Click [  ] – [  ], and follow on-screen instructions to complete filament changing.

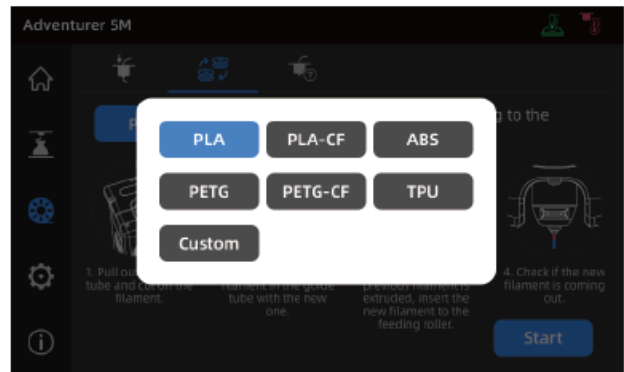
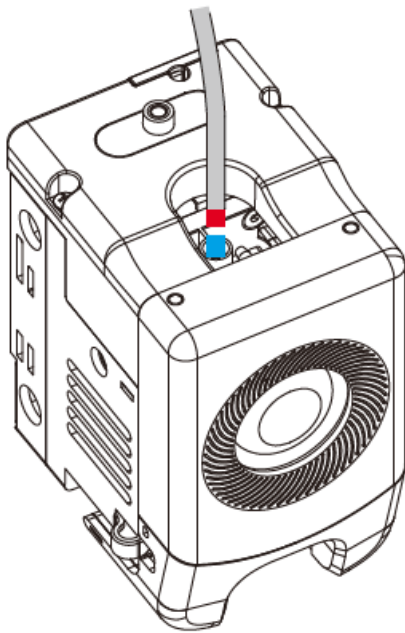
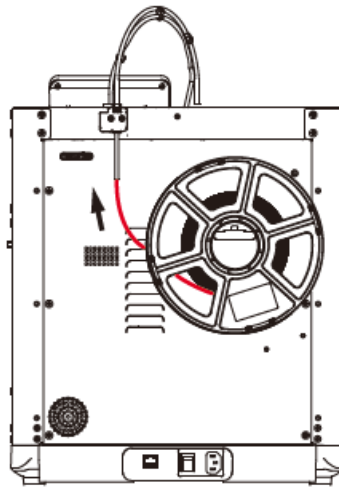
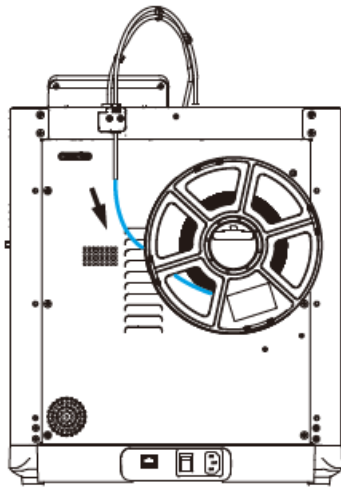


2. Pull out the filament guide tube as shown, and cut the filament.

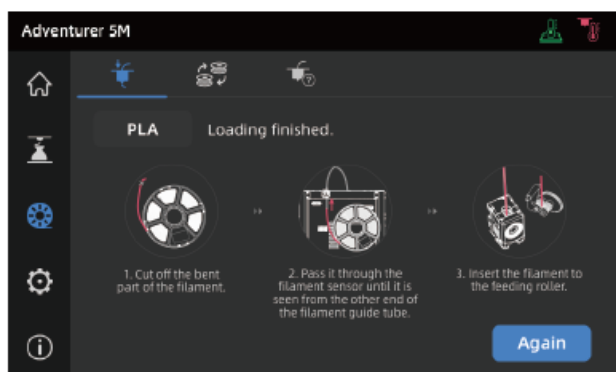
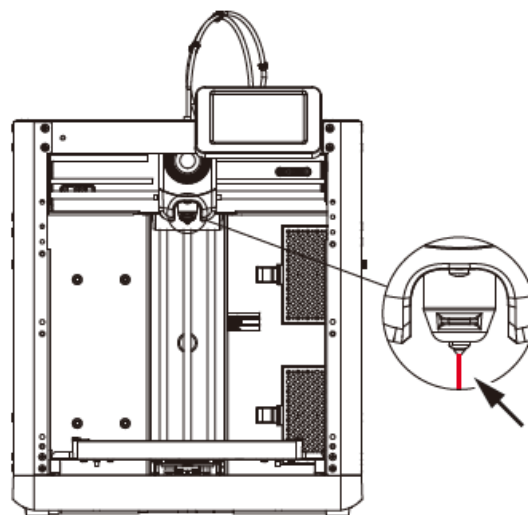
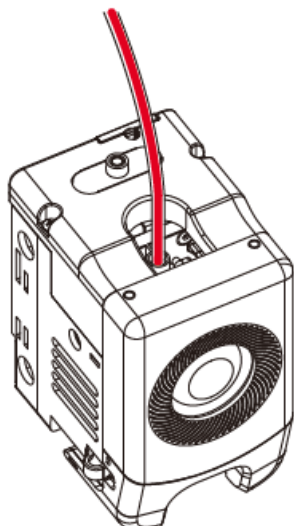
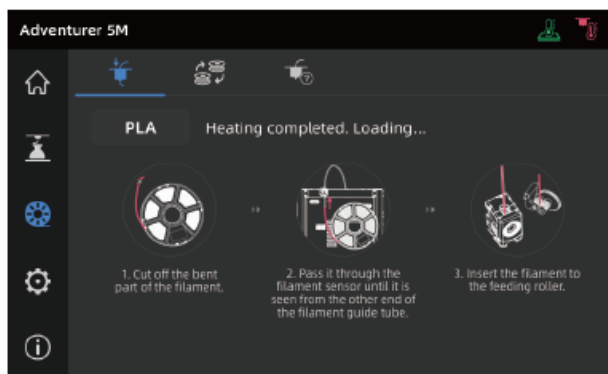
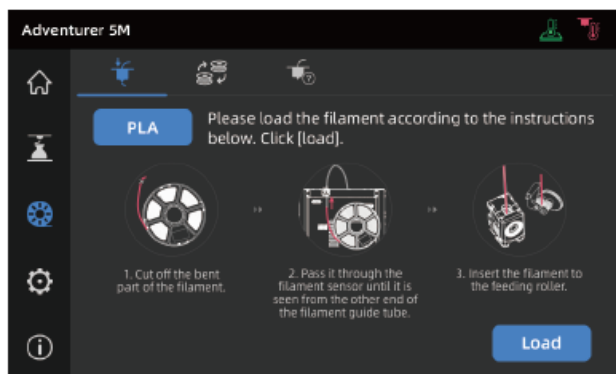


3. Pull out the cut filament, and insert the new filament into the filament guide tube. If the material type is changed, click [PLA] to select the corresponding material type.








4. Click [Start], wait for the extruder to heat up and filament feeding will begin. When you see the previous filament is extruded, insert the new filament and observe its flow and the extrusion. If the new filament smoothly comes out of the nozzle, the filament change is successful. If not, hold the filament by hand, insert it into the inlet, and click [Again] to retry. Feel for filament movement until it is extruded. After successful loading, insert the filament guide tube into the inlet.

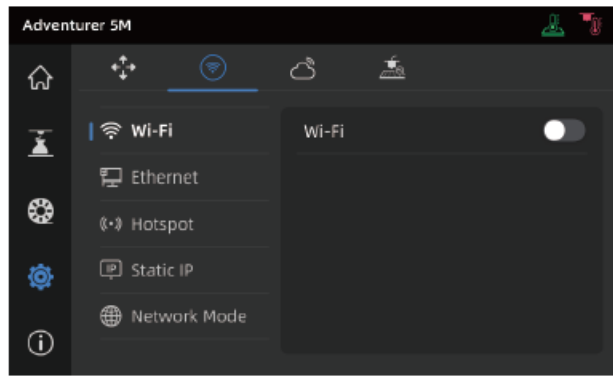


## Note


1. If the previous filament roll is completely used up and there is no filament in the guide tube, you can proceed with the loading process directly.
2. When changing the filament, try to clear out the old filament using the new filament.
3. You can click [  ] to view the nozzle usage guide on the screen.

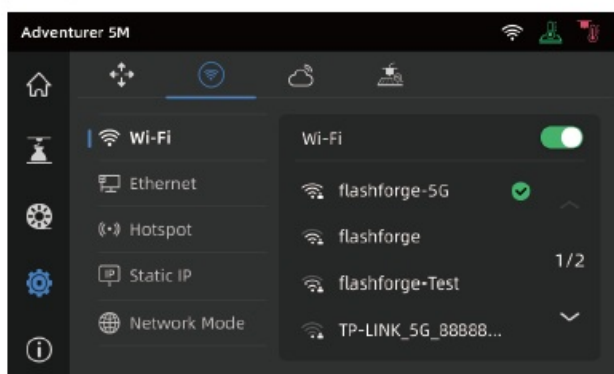
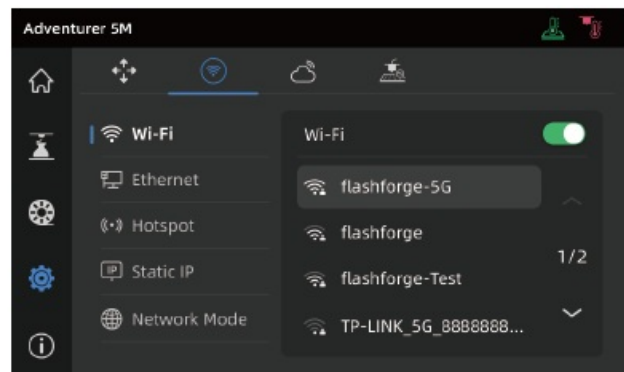
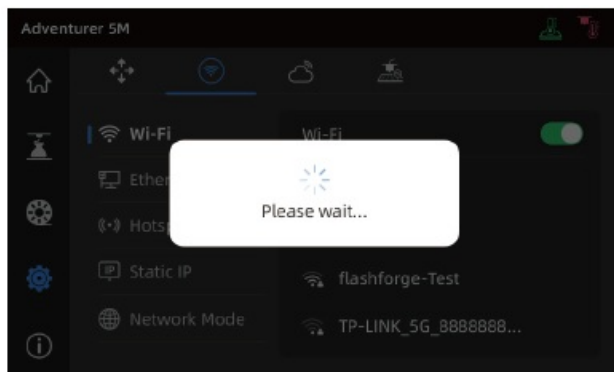
## Network Connection

Click [  ] – [  ] to enter the network connection interface.




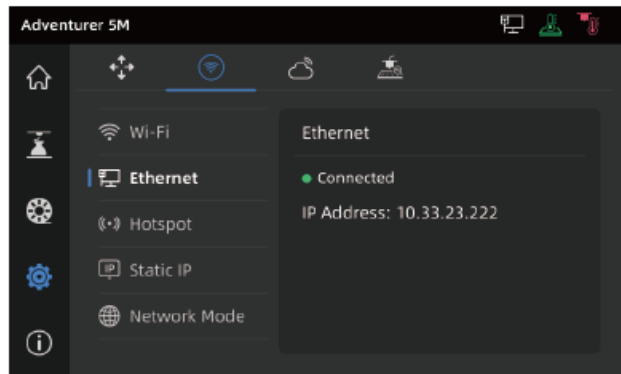
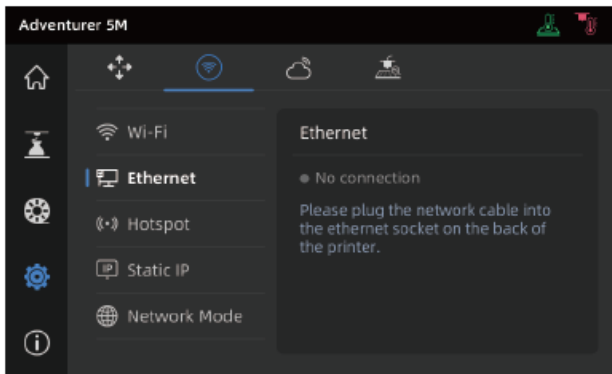
### Wireless Network Connection

Turn on the Wi-Fi switch, and tap to connect to the corresponding wireless network. Once connected successfully, the network will be marked, and an [  ] icon will appear at the top right corner of the screen.



### Wired Network Connection

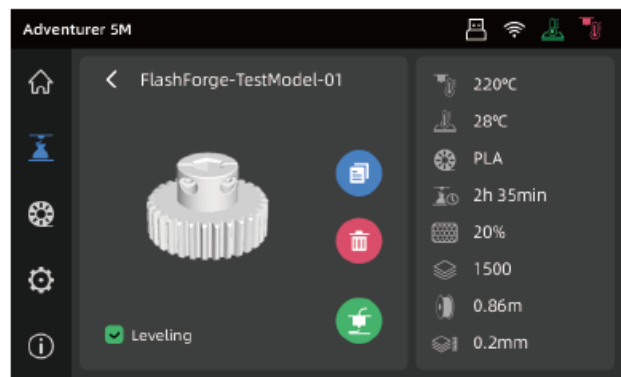
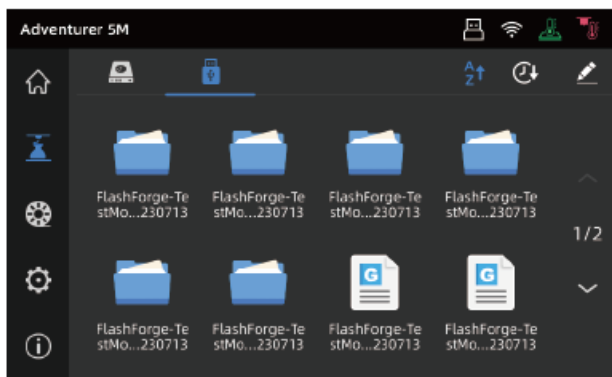
1. Select [Ethernet] and plug the network cable into the Ethernet port on the back of the printer following on-screen instructions.
2. Once connected successfully, it will display as [Connected], and an [  ] icon will appear at the top right corner of the screen.



## Printing Methods

### Printing via USB

The printer supports printing via USB. Save the sliced file to a USB flash drive, insert it into the printer, and select the corresponding file to start printing.

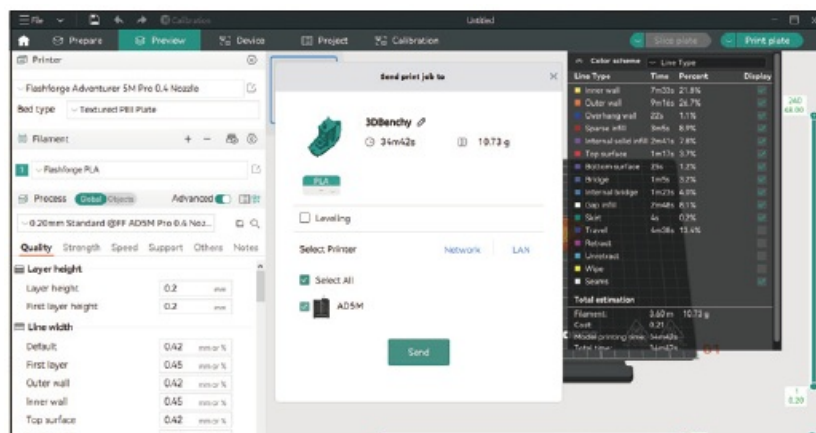


### Printing via Wi-Fi transfer

After successfully connecting the printer to the network, open Orca-Flashforge. After finishing slicing, click [Print plate] in the menu, and select the connected Adventurer 5M to send the print job.

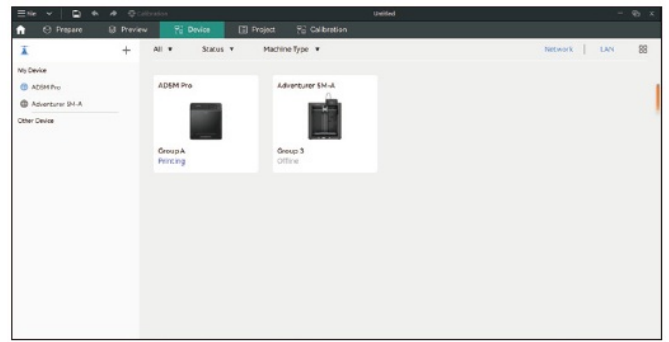
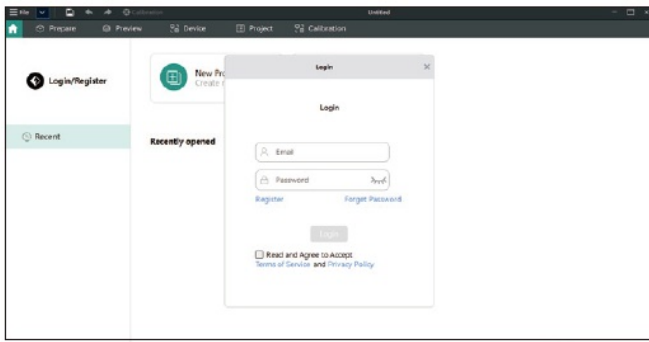
### Note

The printer and the computer must be connected to the same network. There are two modes for printer connection: WAN Mode and LAN Only Mode.



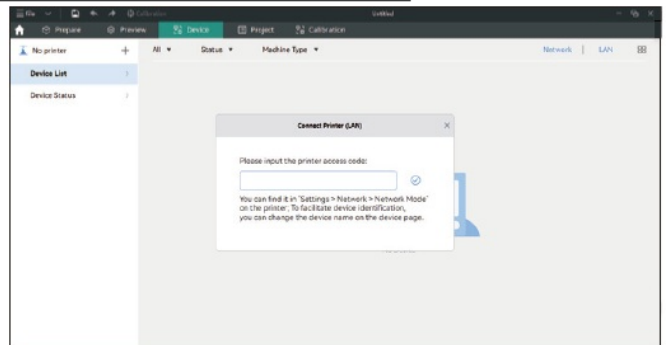
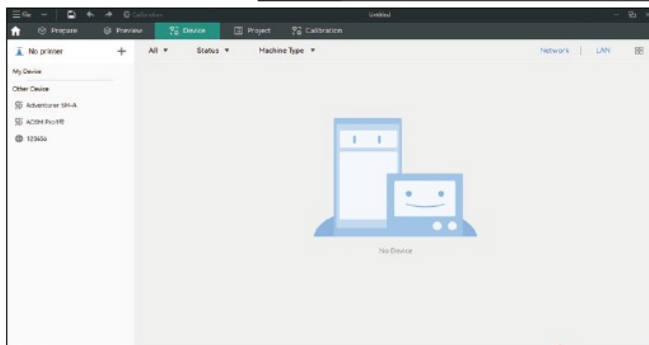
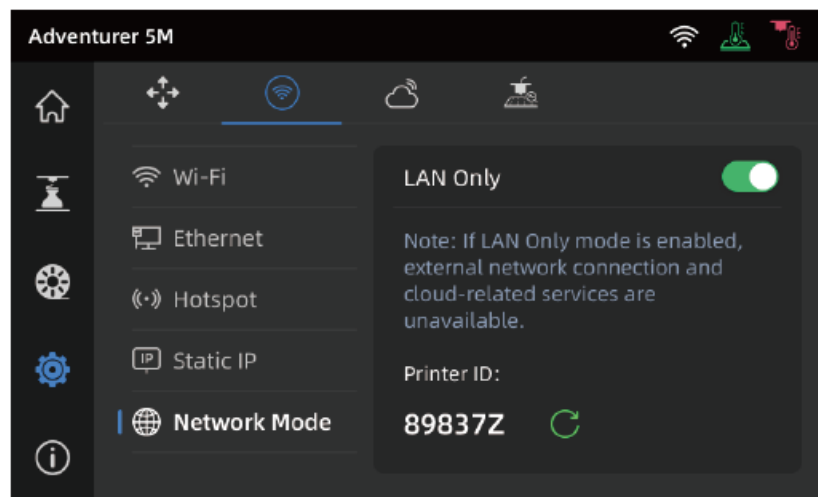
- **WAN Mode:**

Please log in/register your Flashforge account before connecting to the printer. Click [+] on the device page to open the search list and select the desired machine.



## • LAN Only Mode:

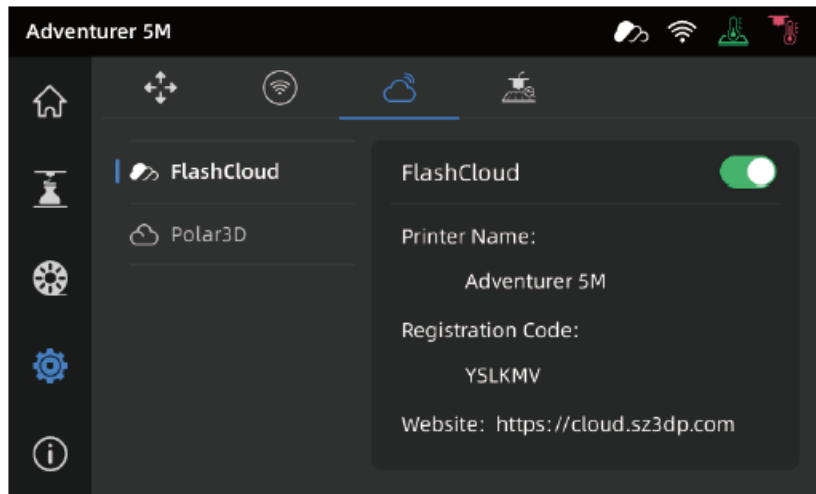
Enable [LAN Only] via [Network Mode]. In the slicing software, click [+] on the device page to find the corresponding printer. Select the printer and enter the Printer ID displayed on the printer to complete the connection.



## Printing via Cloud

## Printing via FlashCloud

1. Click [  [  ] on the FlashCloud switch, and view the registration code.



2. Open the FlashCloud website and register an account. After email activation, you can log in and use it.

FlashCloud: <https://cloud.sz3dp.com/>.

3. Click [My Printer] – [Add Printer]. On the Add Printer page, enter the registration code (cloud registration code) and name the printer. After clicking [OK], the information will appear on the printer's FlashCloud interface.



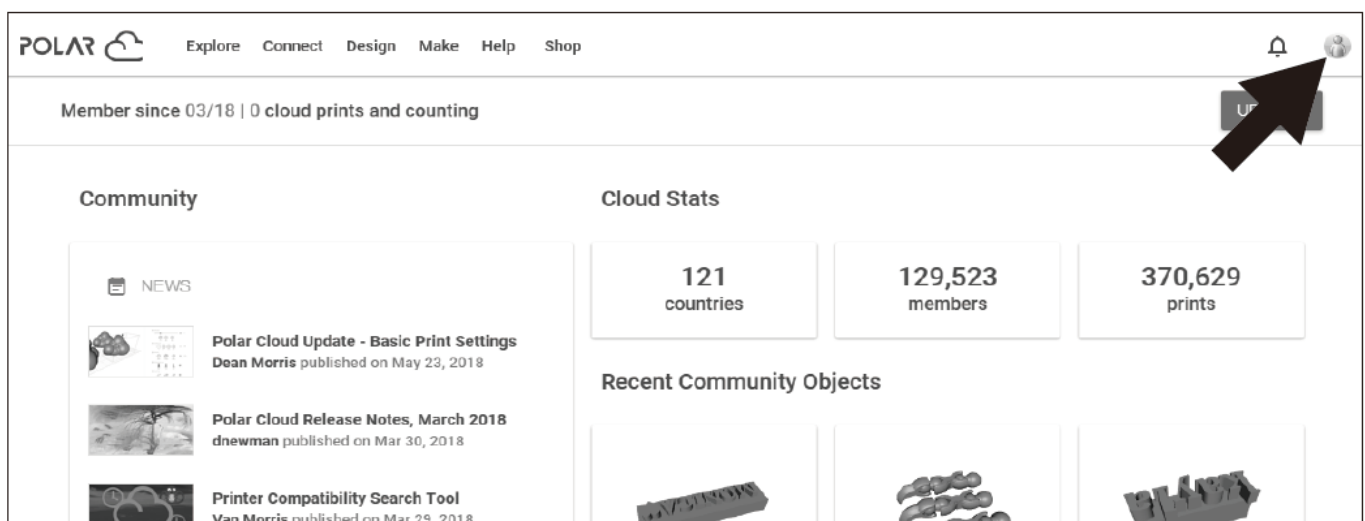
## Printing via Polar Cloud

Open the Polar Cloud website and register an account. Polar Cloud: <https://polar3d.com>.

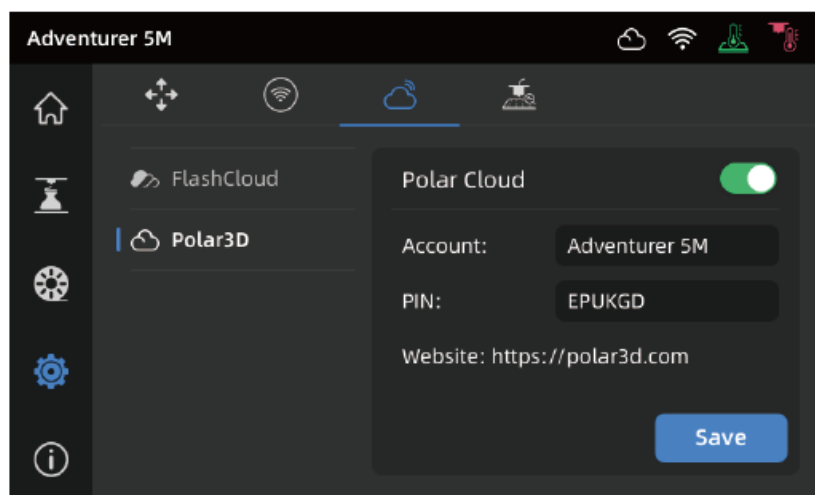
### Note:

Polar Cloud service may not be available outside the United States.

After logging in, click the icon at the top right corner, click [Settings], and click [PIN Code] in the menu to find the PIN code.



After connecting the Adventurer 5M to the network, simply turn on the Polar Cloud switch and enter your account and PIN code.



## Model Removal After Printing

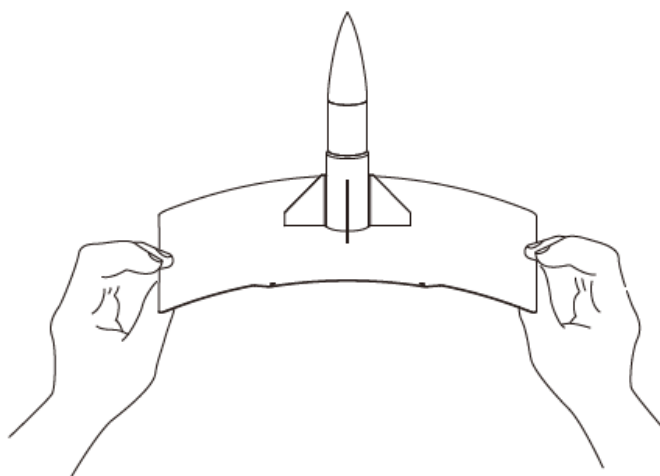
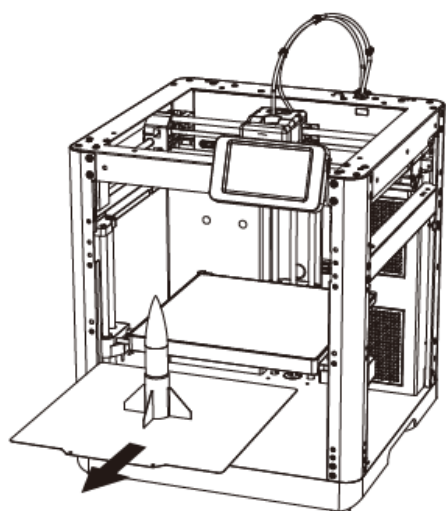
### Note

When printing is completed, the nozzle and build plate may still be at a high temperature. It is recommended to allow them to cool down before removing the model.

After printing is completed, directly take out the flexible steel plate and bend the platform to remove the model. Ensure there is no residual filament on the platform before the next print.

### Tips on Model Removal:

1. Please take the platform plate outside the printer for model removal to prevent model debris from accumulating inside the printer. It's recommended to keep the chamber clean.
2. For models printed with TPU or other flexible materials, it is recommended to use a scraper for removal, which ensures you can remove the flexible model from the bed without causing damage.



## Introduction to Auxiliary Functions

### Note

The interface layout may change whenever there is an upgrade of firmware.

## Leveling and Calibration

- During the first startup, equipment calibration will be performed. During subsequent use, choose levelling or vibration compensation as needed.



### When to perform levelling:

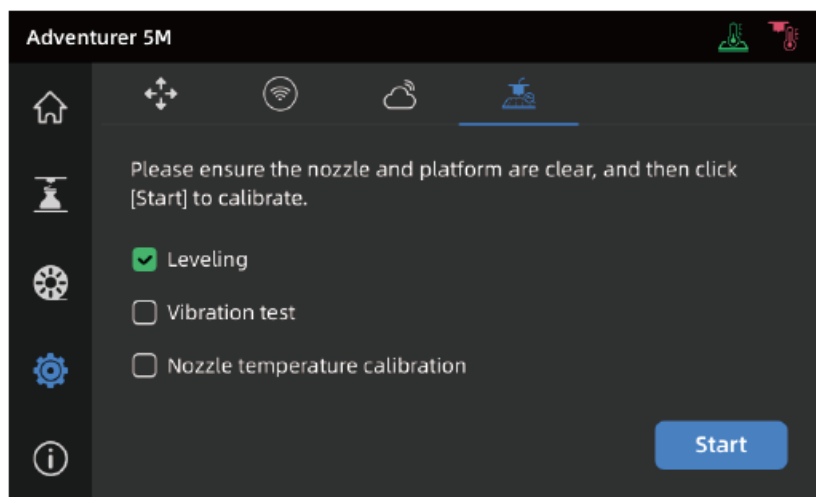
- If continuously printing with PLA material, perform automatic levelling once with no need to do so before each print. However, performing levelling can inevitably improve the printing success rate;
- When switching between different materials (e.g., from PLA to ABS), please perform levelling before each print;
- If the platform-nozzle distance is too far (poor adhesion) or too close (no filament extrusion), please perform automatic levelling;
- After replacing the build plate or nozzle, please perform automatic levelling.

### When to perform vibration compensation:

- When there is noticeable ghosting and ringing on 3D prints;
- After adjusting the tension of the synchronous belt;
- When the printer has been unused for a long time and is now being restarted.

### Instructions:

- Click [  ] – [  ] to enter the levelling and calibration interface. Choose [Leveling] or [Vibration test], click [Start], and the printer will automatically perform the corresponding operation.
- (Note: Before calibration, ensure there are no foreign objects on the platform or at the nozzle tip.)



Note on when to perform PID calibration: This can be performed after replacing the nozzle or when the nozzle temperature is abnormal.

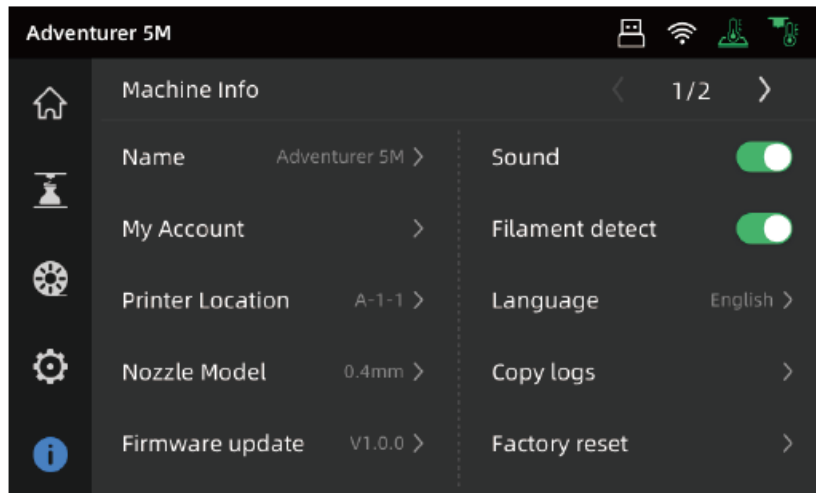
### Other Function Settings

In the information interface, you can enable or disable sound and filament detection, and perform firmware updates.

- When [Filament detect] is enabled, the printer will stop printing if the filament runs out mid-print.



- When connected to a wireless network, click [Firmware update] to view the current version, check for updates, and perform online firmware updates.
- Printer Name and Location: Users can customize the name and location as desired.



## Maintenance

### Suggestions on Platform Plate Usage

1. Powder-coated PEI plate requires glue and is suitable for printing PLA/PETG/PLA-CF/PETG-CF/ ABS/ASA. TPU printing does not require glue. This plate comes with a printer.
2. PEI film plate is suitable for printing PLA/TPU without glue. For PETG, it's recommended to use glue. This plate can be purchased separately.
3. PC sticker platform plate is suitable for printing PC/ABS/ASA. This plate can be purchased separately.
4. After applying glue to the platform plate, it can be cleaned with water.
5. If the platform plate gets oily, it can be cleaned with dish detergent.
6. If the platform plate deforms significantly after long-term use, it's recommended to replace it with a new one.

### Suggestions on Nozzle Usage

1. Please use one nozzle for the same type of material to avoid clogs and extend nozzle lifespan, especially when working with fibre-reinforced materials and PETG. Please avoid mixing them with other materials.
2. When switching to a different material with the same nozzle, if the new material's printing temperature is lower, adjust the setting to a higher temperature for filament extrusion to purge old filament from the nozzle.
3. When switching to a different material with a higher printing temperature, just load the new filament.
4. To clean residual filament inside the nozzle, you can perform multiple filament loading or manually clear any remaining filament using the unclogging pin tool.
5. After replacing the nozzle, please perform levelling again.

### General Maintenance

1. Please apply lubricating oil to the guide rails after 200 hours of printing.
2. Please replace the filter cotton every 300 hours of printing or when it appears darker in colour.
3. Please clean the filament residue inside the equipment chamber in time.

## Q&A

### Q1. How to unclog the nozzle?

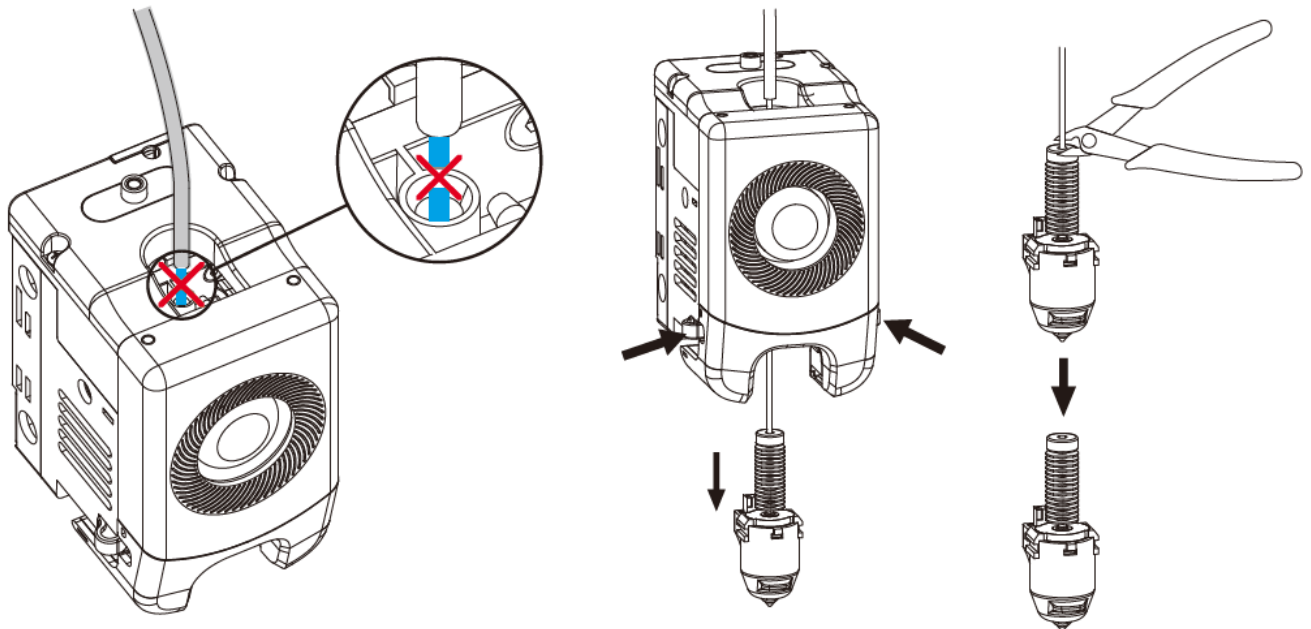
- **Method 1:** Click [Load] and heat the nozzle to the printing temperature of the used filament. After heating, remove the filament guide tube, and check if the filament is bent or filament tip is not smooth. If so, trim and insert the guide tube and filament into the nozzle, then click [Load] and check.
- **Method 2:** If Method 1 doesn't work, use the unclogging pin tool.
- **Method 3:** If Method 2 doesn't work, please replace the nozzle.

### Q2. How to replace the nozzle?

#### Note

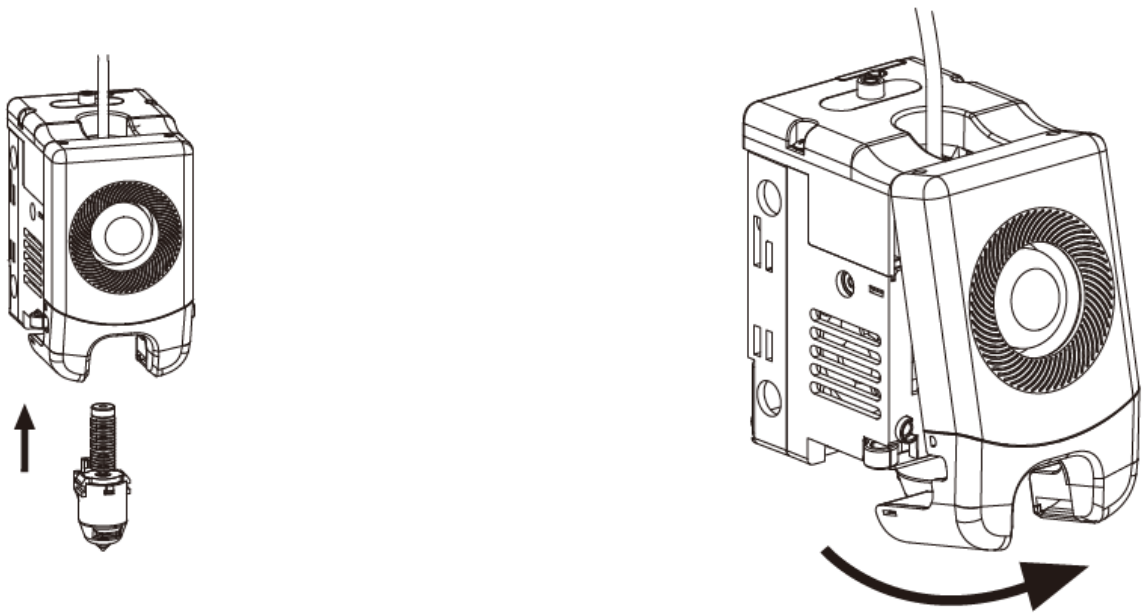
Please power off the printer before replacing the nozzle!

1. Remove the filament guide tube and cut the filament.
2. Press the left and right buckles and remove the nozzle. Trim the filament along the nozzle top.



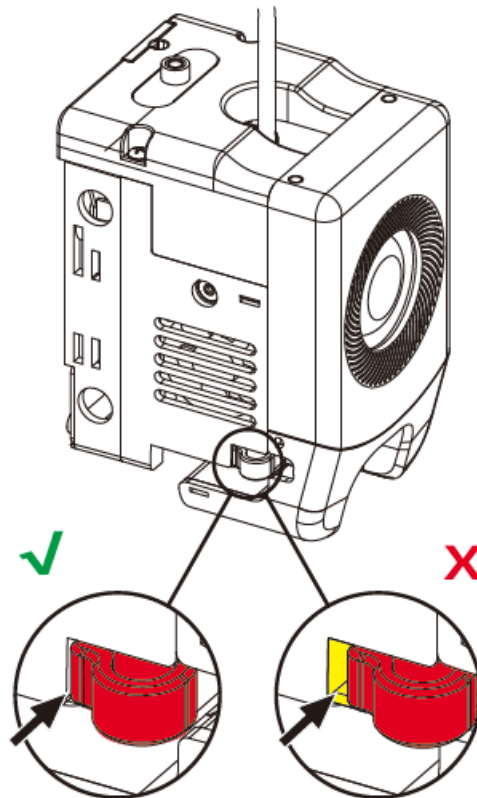
3. Insert the new nozzle into the extruder and you can hear a “click” sound indicating the buckle position has changed. Ensure that the nozzle slot aligns flush with the bottom of the extruder.

**Note:** If you have trouble aligning the nozzle, you can press the buckles during installation or remove the front cover of the extruder (grab the lower part of the front cover with your hand and lift it upward slightly) to check the position.

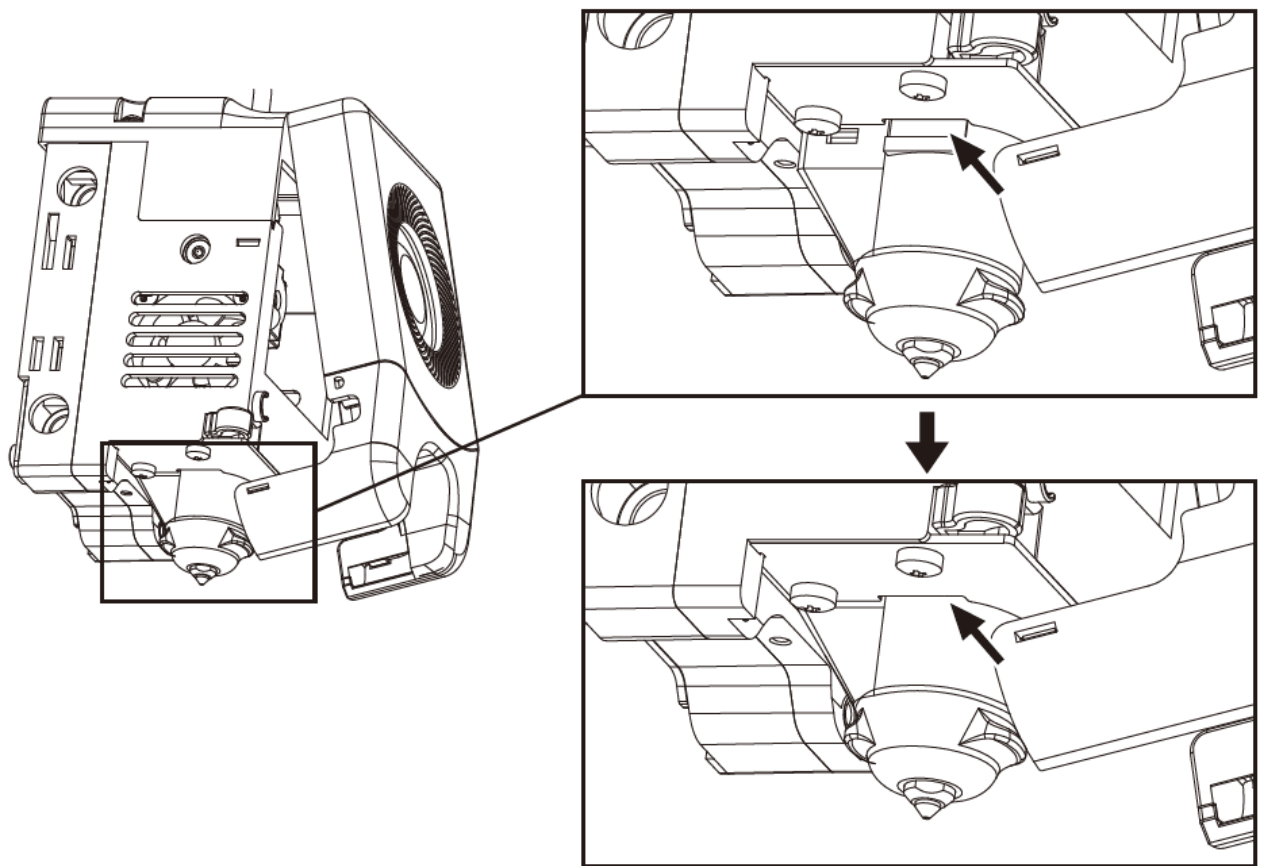



Whether it is installed in place is judged as follows:

1. Ensure the nozzle is pressed to the bottom firmly during installation.
2. Check if it is properly installed:
  - Check the red buckle positions on the left and right.



- Check if the nozzle slot is flush with the bottom of the extruder (if your view is obstructed, you can remove the front cover of the extruder to observe).



3. Power up the printer, click [  ] to enter the loading interface, and follow the on-screen instructions to complete filament loading. Filament coming out of the new nozzle smoothly indicates a successful nozzle replacement.

#### **Is levelling required after nozzle replacement?**

Yes. It is recommended to perform automatic leveling to ensure high print quality as slight errors may occur during nozzle installation. The equipment defaults to the levelling operation before each print.

#### **Q4. What to do if the extruder moves but doesn't extrude filament at the beginning of printing after clicking the model for printing?**

1. Observe the filament guide tube to check if the filament has entered the nozzle. If not, please click [Load] until the filament comes out.
2. Check if the nozzle is clogged. If so, please refer to the solution of Q1.

#### **Q5. What to do if the nozzle position is too high (far from the platform) or too low (hitting the platform) during printing? How to level it?**

Please check if the platform is properly installed and there is no excessive residue on the nozzle. If these issues exist, address them first. Then, go to the settings interface, select the leveling option, and perform automatic leveling or enable automatic leveling before printing.

#### **Q6. Can filaments from other brands be used?**

Yes. You can use filaments from other brands, but certain parameter adjustments are required due to slight temperature differences in different filaments.

#### **Q7. Is it safe to print with ABS material?**

ABS can release toxic gases during heating. If conditions permit, consider printing in a well-ventilated area. It is recommended to print non-toxic materials such as PLA in children's activity places.

#### **Q8. What to do if the printed model warps or doesn't adhere well?**

- **Method 1:** Increasing the platform temperature can improve the adhesion between the platform and the model.
- **Method 2:** Adding a brim during model slicing can alleviate the issue.
- **Method 3:** Apply glue.
- **Method 4:** Clean the platform to remove any oil or dirt.
- **Method 5:** Check if the platform is level. The levelling and calibration functions can be used.

#### **Q9. What to do if print files can not be found and the screen displays only folders after inserting the USB flash drive?**

The USB flash drive format is incorrect. The printer supports the FAT32 file system. Please format the USB flash drive to FAT32.

#### **Q10. What to do with the Wi-Fi connection failure?**

1. Please check if the Wi-Fi name contains special characters. If so, modify it and try again.
2. Please check if the password contains special characters. If so, modify it and try again.

#### **Q11. Firmware update precaution**

Do not power off the printer or disconnect from the network during firmware download or update to prevent update failures.

#### **Q12. Why is the boot screen white?**

If the startup sound can be heard, please replace the screen or cable. If not, please contact our after-sales personnel.

### **Help and Support**

- Flashforge's professional after-sales service personnel and salesmen are on standby for you at any time and are ready to help you with any problem you may have with the printer. If the issues or questions are not covered in this User Guide, you can seek solutions on our official website or contact us by phone.
- There are instructions and solutions to common issues that can be found on our official website. Many questions are answered at Flashforge's English official website – [www.flashforge.com](http://www.flashforge.com).
- The Flashforge after-sales service team can be reached by phone from 8:00 AM to 5:00 PM, from Monday to Saturday. In case you contact us during off-duty time, your inquiry will be answered the next working day immediately. We apologize for any inconvenience this may cause.

#### **Note**

Changing different filaments may leave minor impurities in the nozzle, leading to clogs. As this can be solved by just unclogging it, it's not owing to a quality issue. If you encounter this problem during use, please contact customer support and follow their guidance for unclogging.

- **After-sales Service Tel:** [400-886-6023](tel:400-886-6023)
- **E-mail:** [support@flashforge.com](mailto:support@flashforge.com)
- **Address:** 3rd Floor, Building 2, No. 8 South Daxing Street, Tangxia Town, Dongguan City, Guangdong Province

**Note:** Please provide the product serial number which can be found on the barcode at the back of the printer when contacting customer support.




## Follow Us



**Zhejiang Flashforge 3D Technology Co., Ltd.**


- **Address:** 3rd Floor, Building 2, No. 8 South Daxing Street, Tangxia Town, Dongguan City, Guangdong Province
- **Service Hotline:** +86 579 82273989
- [support@flashforge.com](mailto:support@flashforge.com).

## Documents / Resources

	<p><a href="#">FLASHFORGE 5M Adventurer 3D Printer</a> [pdf] User Guide 5M Adventurer 3D Printer, 5M, Adventurer 3D Printer, 3D Printer, Printer</p>
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## References

- [Flashforge® Official Store](#)
- [- 3d - 3d](#)
- [Flashforge 3D Cloud Login](#)
- [Releases · SoftFever/OrcaSlicer · GitHub](#)
- [Polar Cloud: 3D Printing Cloud Software](#)
- [Home | Flashforge Wiki](#)
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-  - [3d](#) - [3d](#)
- [User Manual](#)

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