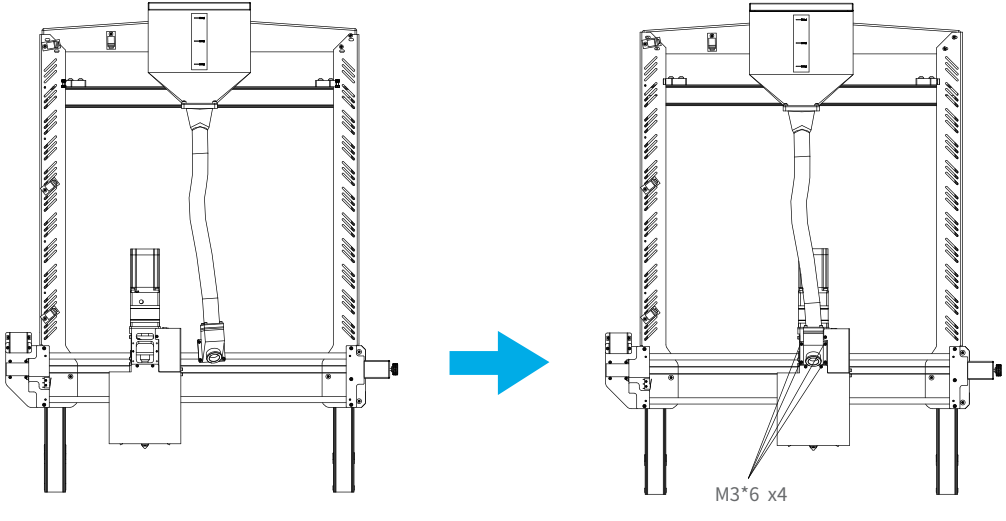
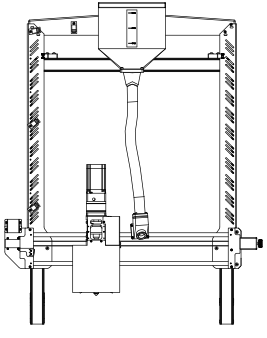
4. Install the feed tube 安装下料管

1 Take the No. 2 hexagonal wrench and use 4PCS-M3*6 hexagonal cylindrical head screws to fix the feed inlet assembly to the print head, as shown in the picture.
取2号内六角扳手，用4PCS-M3*6 内六角圆柱头螺丝把进料口组件固定到打印头上，如图所示位置。





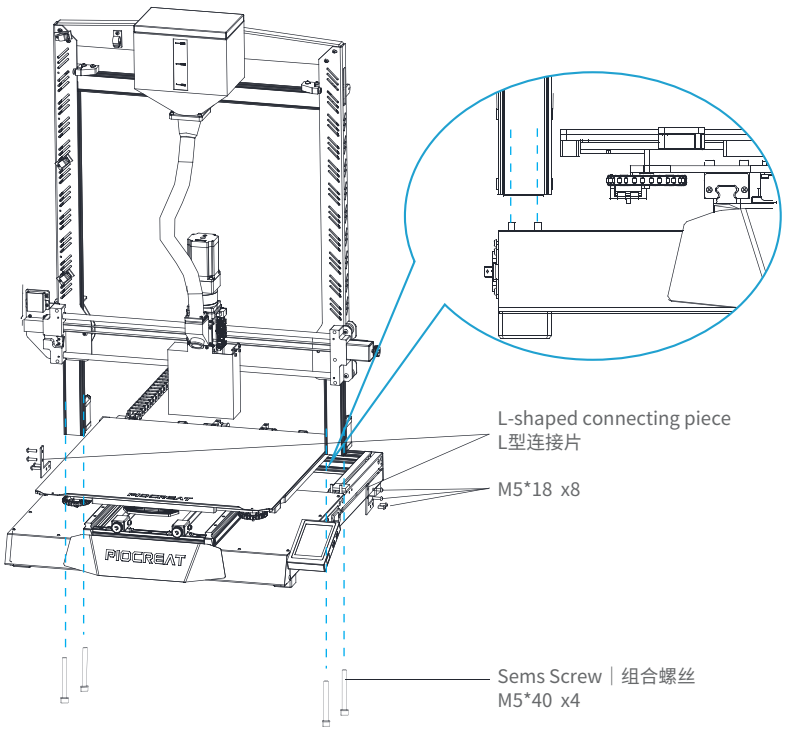
2 Gantry Frame | 龙门架 x1

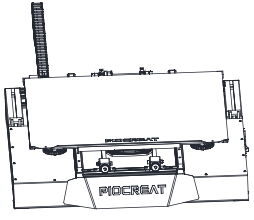
7 Sems Screw | 组合螺丝
M3*6 x4

4. Install the Gantry Frame 安装龙门架

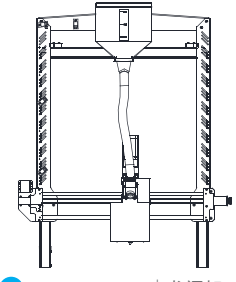
1 Take gantry + base, gantry profile on the base step position, assembly and lock according to the picture by 4PCS-M5*40 combination screw.
取龙门架+底座，龙门架型材对好底座台阶位置，通过4PCS-M5*40组合螺丝按图所示装配锁好。

2 Take 2PCS-L type connecting piece + 8PCS-M5*18 hexagonal flat round head screws and fix and lock them as shown in the picture.
取2PCS-L型连接片+8PCS-M5*18内六角平圆头螺丝进行如图所示，进行固定锁紧。

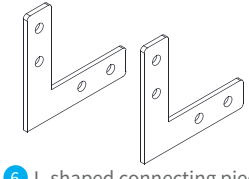




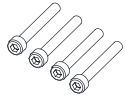
1 Base Frame｜底座 x1



2 Gantry Frame｜龙门架 x1



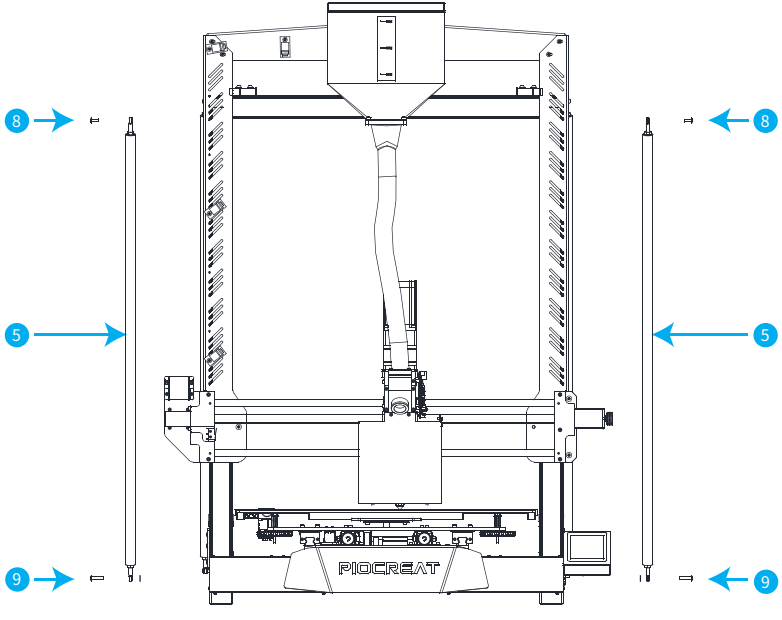
6 L-shaped connecting piece
|L型连接片 x2

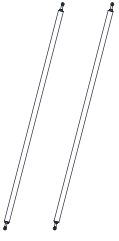


7 Sems Screw｜组合螺丝
M5*40 x4

8 Hexagon flat round head screws｜内六角平圆头螺丝
M5*18 x8

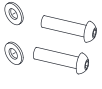
4. Install the Pull Rod 安装两侧拉杆





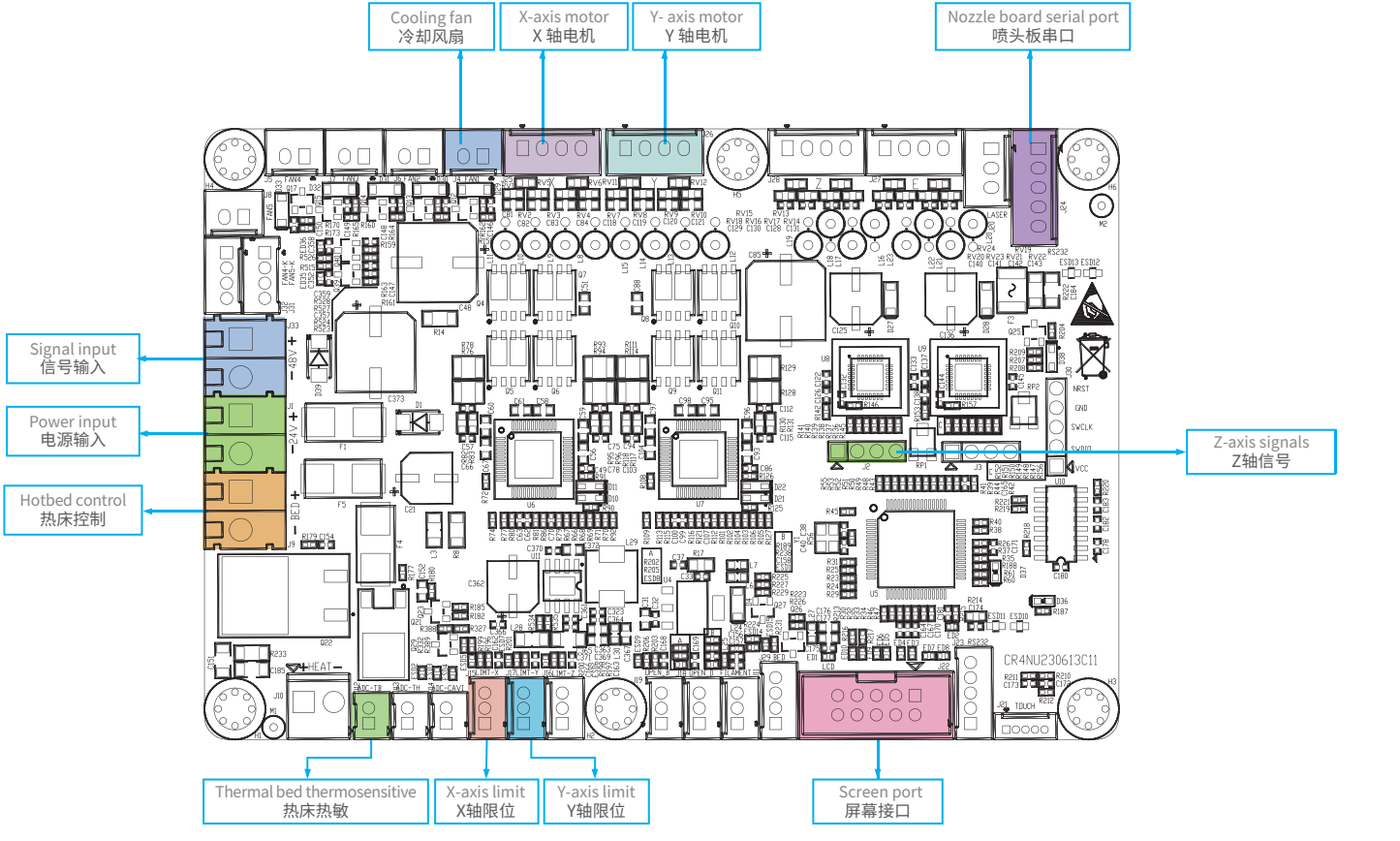
5 Pull rods｜拉杆 x2

8 Hexagon flat round head screws
｜内六角平圆头螺丝 M5*12 x2

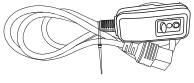


9 Hexagon flat round head screws
｜内六角平圆头螺丝 M5*20 x2
M5 Flat pad｜M5平垫 x2

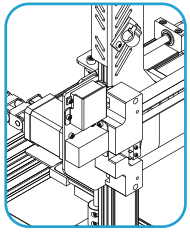
5. Circuit Wiring 电路接线

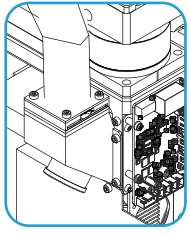


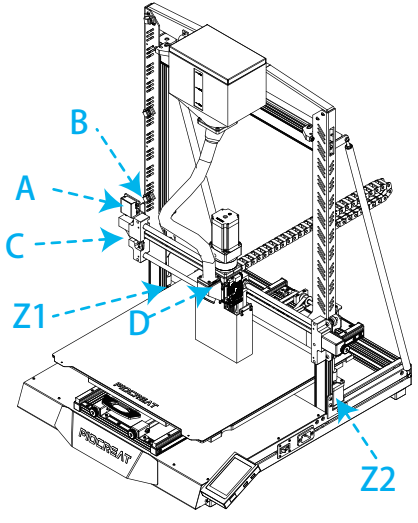
6. Cable Connection 设备接线

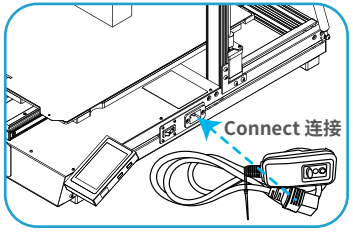


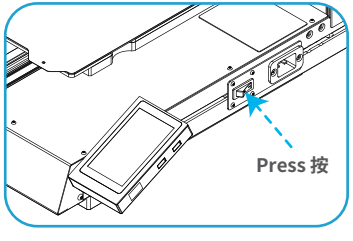
4 Power Cord | 电源线 x 1











Caution/警告

- Do not connect or disconnect the cables when the machine is powered on.

  当机器通电时，请勿连接或断开连接线。

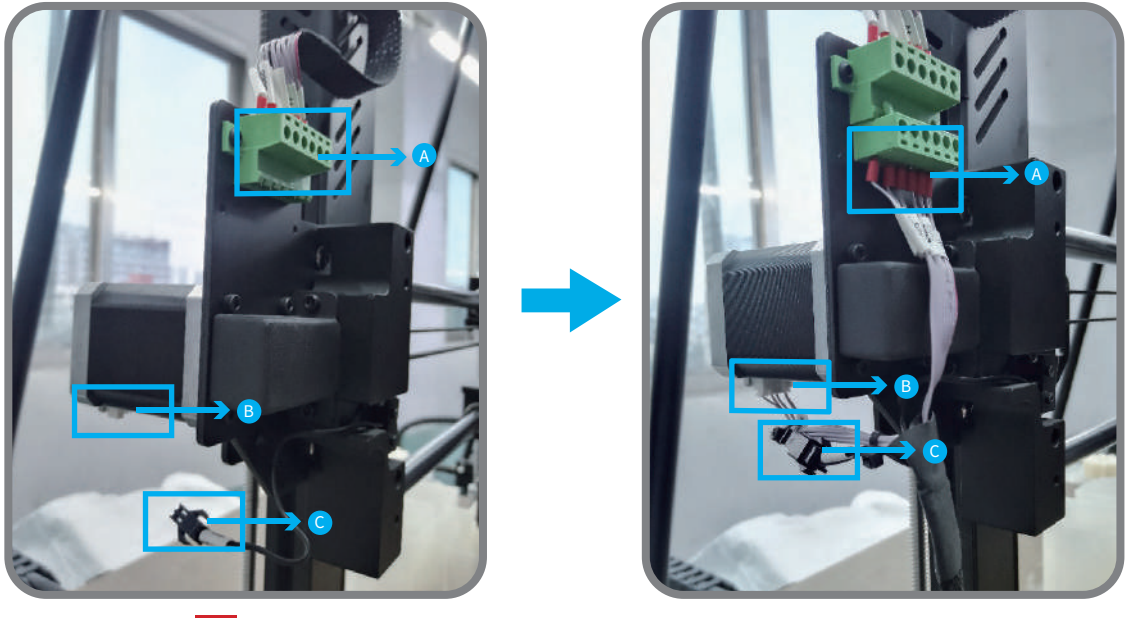
A、6pin plug-in terminal block (nozzle board serial port cable + nozzle board power cable)
6pin对插式接线端子(喷头板串口线+喷头板电源线)
B、X-axis motor X轴电机
C、X-axis limit switch X轴限位开关
D、Material breakage detection line port 断料检测线端口
E、Connect it to the power cord and turn on the power 连接电源线，打开电源
F、Press the power button and wait the display screen to start 按下开关按钮，等待显示屏启动

6. Equipment Wiring 设备接线

1 Connect the plug-in terminal block, as shown in the picture A position interface.
连接对插式接线端子插头，如图示A位置接口。

2 Connect the X-axis motor, as shown in the picture B position interface.
连接X轴电机，如图示B位置接口。

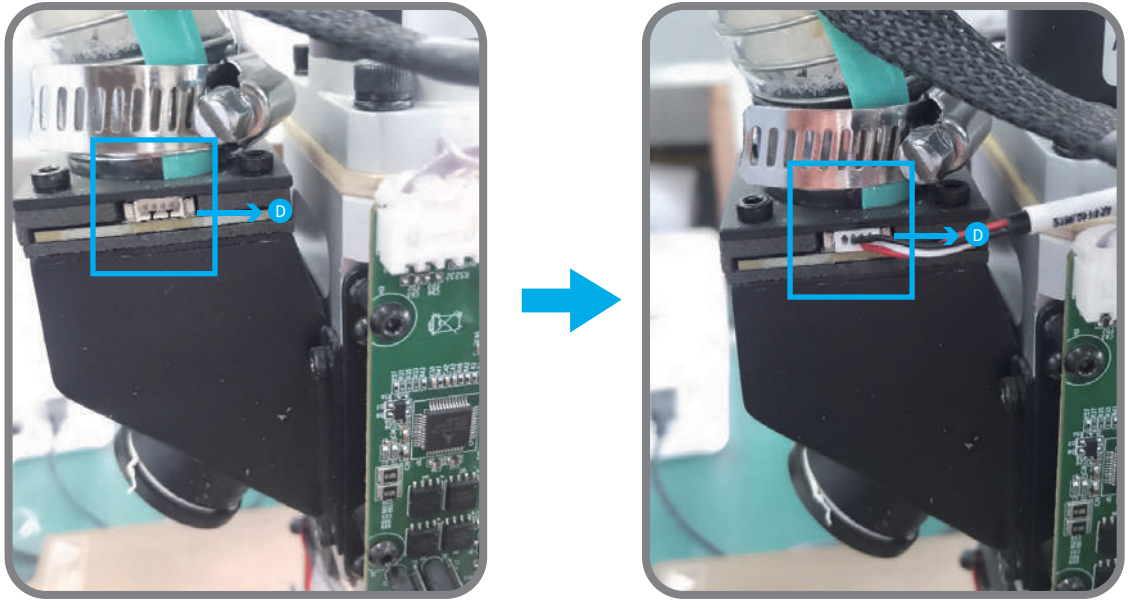
3 Connect the X-axis limit switch adapter terminal male, as shown in the picture C position interface.
连接X轴限位开关转接端子公头，如图示C位置接口



● Note: Do not plug and unplug the motor cable with power on, otherwise the motor will be damaged.
注意：不能带电拔插电机线，否则会损坏电机。

6. Equipment Wiring 设备接线

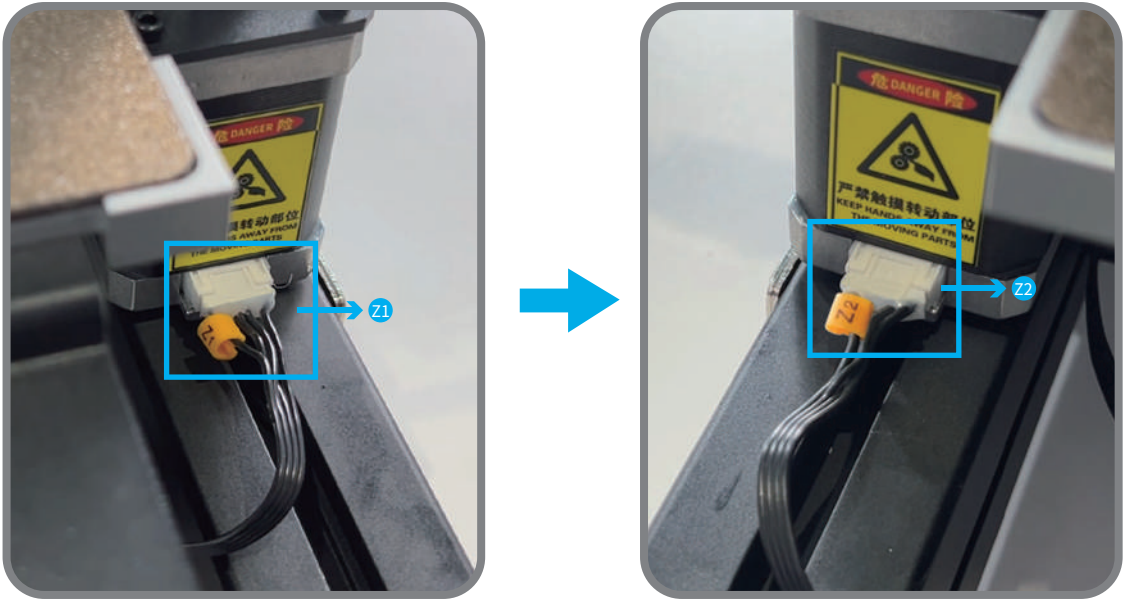
Insert the material breakage detection line terminal into the material breakage detection switch port, as shown in the picture at position F.
将断料检测线端子插入断料检测开关端口，如图示F位置接口。



● Note: Do not plug and unplug the motor cable with power on, otherwise the motor will be damaged.
注意：不能带电拔插电机线，否则会损坏电机。

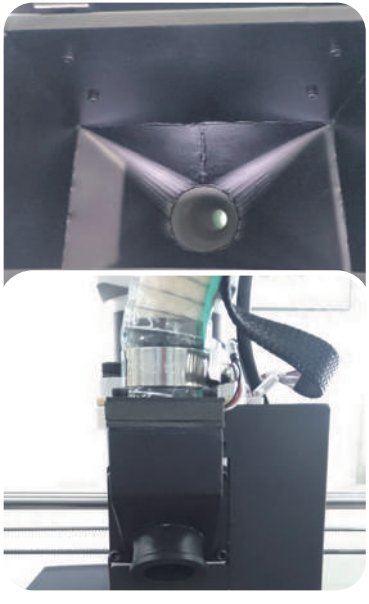
6. Equipment Wiring 设备接线

Insert the wires marked with the Z1/Z2 motor wire numbers into the corresponding Z-axis motors.
分别将标有Z1/Z2电机线号的线插入对应位置的Z轴电机即可。



● Note: Do not plug and unplug the motor cable with power on, otherwise the motor will be damaged.
注意：不能带电拔插电机线，否则会损坏电机。

7. Load Filament 装载原材料



1 Check whether the feeding tube is connected properly.
检查下料管是否都连接好。

2 The pellet (diameter 1.0~5.0mm) material is loaded into the feeding barrel.
将颗粒（直径1.0~5.0mm）原料装入下料漏斗中。

3 Fill with material and cover with barrel cover.
料装满后盖上漏斗盖。

8. Z-axis Offset Z轴补偿

Select **Z-axis offset**, wait for the nozzle movement to complete, select the **moving distance**, and adjust the **Z-axis compensation value** up and down so that the height from the nozzle to the platform is almost the thickness of A4 paper (0.08-0.1mm). Click **OK** to save the Z-axis compensation value when completed.
选择 **Z轴补偿**，等待喷头移动完成后，选择 **移动距离**，上下调整 **Z轴补偿值**，使喷嘴到平台的高度差不多是A4纸的厚度(0.08-0.1mm)，完成后点击 **确定** 保存Z轴配置。

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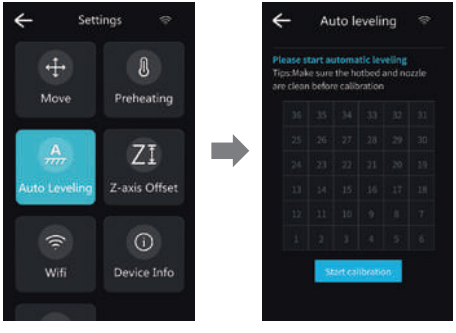
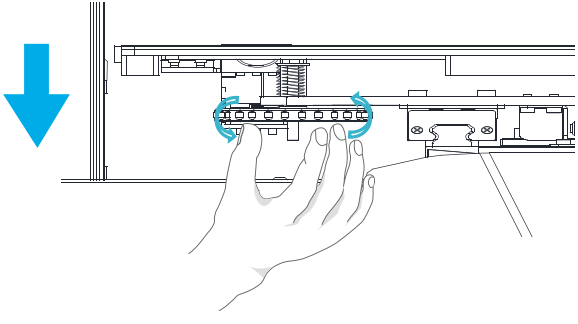
Note: The current interface is for reference only. Due to the continuous upgrade of functions, the actual version of the software/firmware UI shall prevail.
注意:当前界面仅供参考,由于功能不断升级,实际以最新版本软件/固件UI为准。

9. Level Platform 调平平台

1 Select **Auto Leveling** to automatically level. 选择 **自动调平**，即可自动调平。
2 If the automatic leveling data differs greatly (1mm), please correct the platform by adjusting the black knob under the platform. If the data is a negative value, it s hould be adjusted clockwise. If it is a positive value, it should be adjusted counterclockwise. After the adjustment is completed, automatically level it again to check the flatness of the platform. If the difference is still large, repeat the above operations;
若自动调平数据差异较大(1mm)，请通过调整平台下方**黑色旋钮**矫正平台，如果数据为负值，则应顺时针调整，如果为正值，则逆时针调整。调整完成后并再次**自动调平**检验平台平整度，若差异依然较大，需重复以上操作；

EN





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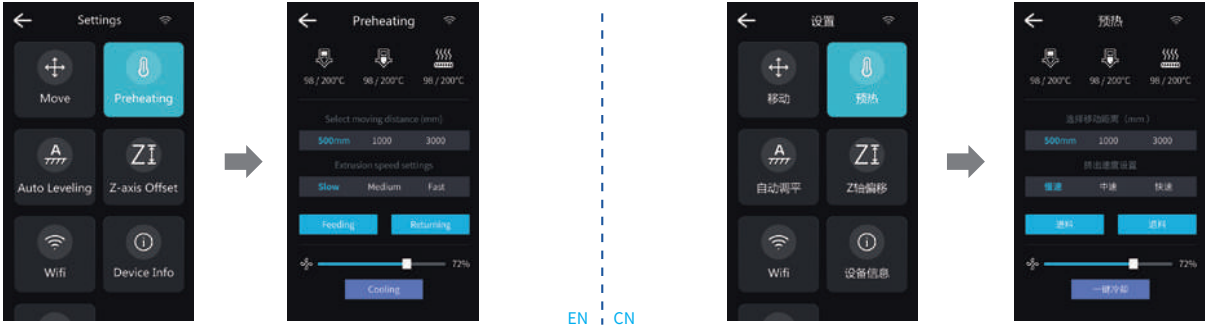
Do not beat the feeding tube or press the glass platform in the leveling process;
调平过程中不要拍打下料管或者按压打印平台；

Note: The current interface is for reference only. Due to the continuous upgrade of functions, the actual version of the software/firmware UI shall prevail.
注意:当前界面仅供参考,由于功能不断升级,实际以最新版本软件/固件UI为准。

10. Preheat Settings 预热设置

1 For the first printing, you need to extrude material in advance. Click Preheat and then click the nozzle preheat icon to set the corresponding preheating temperatures for the upper part of the nozzle and the lower part of the nozzle according to different materials.Wait for the nozzle to heat up to the predetermined temperature, select the extrusion distance and extrusion speed, and click Feed until the material is extruded smoothly before normal printing operations can be performed.
第一次打印需要提前挤料，点击**预热**再点击**喷头预热**图标，根据不同材料设置相应的喷头上段与喷嘴下段预热温度，等待喷头加热达到预定温度，选择**挤出距离**和**挤出速度**点击**进料**，直至有材料顺利挤出后可进行正常打印操作。
2 Click Preheat, click the platform preheat icon, set the corresponding platform preheat temperature according to different materials, and preheat the platform in advance before printing.
点击**平台预热**图标，根据不同材料设置相应的平台预热温度，打印前提前预热平台。



Note: The current interface is for reference only. Due to the continuous upgrade of functions, the actual version of the software/firmware UI shall prevail.
注意:当前界面仅供参考,由于功能不断升级,实际以最新版本软件/固件UI为准。