SUNLU™

FilaDryer S1

3D PRINTING-MATE

Drying while printing to improve your 3D model.

EN / DE / FR / IT / ES / JP / KO

MADE IN CHINA
Email: jk@sunlugw.com
Web:www.sunlugw.com
Add:NO.A13, 4/F NO.10th Keji One RD,Tangjiawan Town Zhuhai, China.

RoHS FC CE

EN

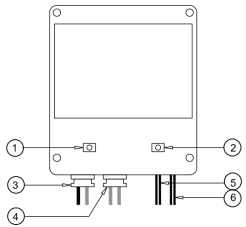
Note: read this document before using the filament dryer

- Pay attention to electrical safety during operation, otherwise electrical shock, fire, or damage may occur. Do not use this product near water, such as in bathrooms, near water heaters, or in extremely humid locations.
- Only use the original power adapter, or an equivalent adapter with an output of 24V at 2A to ensure effective operation.
- When drying consumables, do not place the product on temperature-sensitive objects.
- During operation do not touch the heatsink inside the box, there is a risk of scalding or burns.
- Place the two rollers in the box before operating the dryer.
- When not using this product, switch off the power for safety reasons.
- Keep out of the reach of children, otherwise injury might occur.
- Rotating the filament during the drying process will ensure a more thorough and evenly dried result.
- To avoid heat loss ensure the upper cover is in place during operation.
- During operation open the box as infrequently as possible to prevent moist air from entering and affecting the drying process.
- Keep filament tightly wound to the roll while drying to prevent it coming into contact with the heatsink. Risk of burning or damage.
- If there is a fault with the product, disconnect the power adapter from the filament dryer and the electrical socket then contact the after-sales support team.

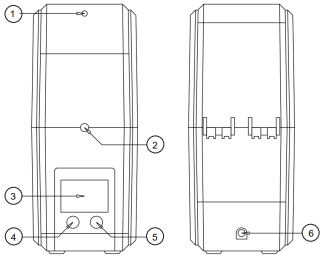
Product specifications:

Product size	271 (L) X100 (W) X 237 (H) mm
Maximum capacity	φ210 * 85 (H) mm
Net weight	996g (including power adapter)
Working environment	a) Environment temperature: 20 ℃ ~ 35 ℃. b) Relative humidity: ≤ 90%.
Temperature setting range	35 ℃ ~ 55 ℃
Power adapter specifications	a) Input specifications: AC 100V ~ 240V, 50 / 60Hz. b) Output specifications: DC: 24V ± 1.2V, 2A.
Standby power	0.05W
Maximum working current	1.8A
Maximum working power	48W
Dual temperature probes to measure the temperature of the cabinet and heating plate	
2-inch LCD display screen, displaying temperature and time	
Suitable for filament diameters: 1.75mm / 2.85mm / 3.00mm	

Product function diagram:



① Left button
② Right button
③ Power Input
④ Heater inlet (right 3)
⑤ Heating element temperature probe(right 2)
⑥ Enclosure temperature probe (right 1)



① Filament outlet ② Filament outlet ③ Display area
④ Left button ⑤ Right button ⑥ DC power socket

Operating instructions:

1. Turn on the power:
Plug the 24V / 2A power adapter that comes with this product into a commercial power outlet, and then connect the DC cable to the DC power socket of the drying cabinet. Before the dryer is connected to the power supply, without any key operation, the dryer is in a standby state (no heating).

2. Filament loading:
Put the tightly wound filaments into the dryer, pull the thread out from the outlet of the dryer, close the upper cover and press any left or right button, then the dryer will enter into a working state. The dryer heats the filaments according to the default setting (50 ℃, 6 hours).

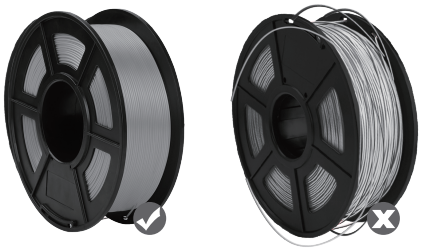
3. Personality settings:
A. Temperature addition and subtraction: The user can adjust the temperature of the dryer according to factors such as the material of the filaments, the ambient temperature, and humidity. When it is in a working state, short press the left button to decrease the temperature, and short press the right button to increase the temperature. When the setting is complete, stop for about 3 seconds,
the dryer is automatically saved, and switch to the actual temperature interface. Temperature adjustment range: 35 ℃ ~ 55 ℃. The measured temperature is displayed as PV, and the set temperature is displayed as SV.
B. Drying timing: The default continuous drying time is 6 hours when the dryer is turned on, and the drying time can also be set manually. Setting method: Under the working state of the drying box, long press the left button for about 3 seconds to enter the drying timing function, which is displayed as SV Time XXH. Short press the left button to decrease the time, short press the right button to increase the time; each time short press the button, the time increases or decreases by 1 hour; The setting range is 0 ~ 24 hours. After setting, press and hold the left button for about 3 seconds to exit the time setting state and enter the heating working state. When the countdown is completed, the dryer stops working and enters the sleep standby state (Note: When setting to 0 hours, when the exit is confirmed, the dryer immediately enters the sleep standby state; in the standby state, press the left button or right button to enter the working state, The default time of dryer is 6 hours).
C. Countdown time check: When the drying box is in working state, long press the left button for about 3 seconds, you can check the remaining time of the countdown; long press the left button again for about 3 seconds, when exiting the view time state, enter the heating working state.

Tips for best results:

1.For best results dry your filament before and during printing. For long print operations drying during the printing process will produce more consistent print results.
2.When the ambient temperature is low the dryer will take longer to reach the set temperature, extend the drying time by 1 hour.
3.Drying time and temperature for common materials refer to following table:

Material	PLA / PLA+/ PLA Silk/PLA luminous/PLA Carbon Fiber	Wood	PVB	ABS/ABS+	HIPS	PC	PA/PVA	ASA	PETG	TPU	PMMA
Baking Temp (℃)	45-50			50-55					48-52		47-51
Time (h)	3-6										

4. It's necessary to wind the filament tightly instead of a loose state, as shown in the following figure:



Troubleshooting:

If you encounter the following issues during use, please try the troubleshooting method in the table below. If the fault still cannot be eliminated, please contact the place of purchase for troubleshooting.

Fault phenomenon	Cause of issue	Troubleshooting method
LCD screen does not display normally	Power adapter failure	Replace the power adapter
The temperature does not rise	Power adapter power is below specification	Replace the power adapter (24V/2A)
	The lid of the dryer enclosure is not closed	Close the top cover of the filament dryer
Fault code ER1	Poor temperature probe contact	Reconnect the heating element temperature probe (right 2)
Fault code ER2	Poor contact of cabinet temperature probe	Reconnect the enclosure temperature probe (right 1)
Fault code ER3	Poor contact of heating terminal	Reconnect the heating cable (right 3)

After-sales service:

Warranty:
Limited warranty for one year where the product has failed under normal operation as shown in this manual. The warranty does not cover user damage, modification, or 3rd party power supplies.