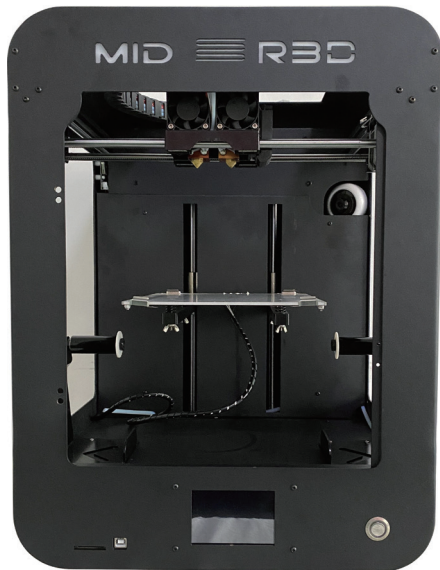


MID-Pro 3D Printer

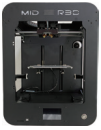
*Please read the Quick Operation Guide carefully before using the product and keep it in a safe place

Instruction



Packing List

After unpacking the product, please make sure that the 3D printer is intact and confirm whether the accessories are complete according to below list.



3d printerx1



PLA filamentx1



power cabledx1



Filament holderx1



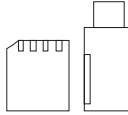
Door panelx4



Glass platformx1



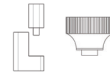
Spannerx3
tweezerx1



SD cardx1,
Card readerx1

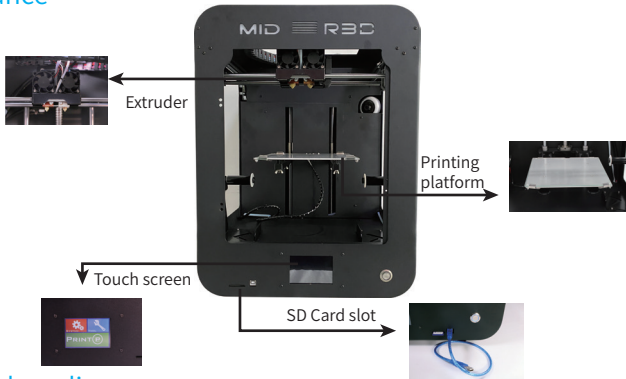


shovelx1



Door hingex2
Screws (M3*6) x8

Appearance

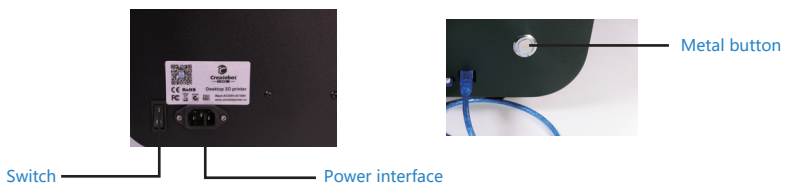


Required reading

Step 1-----

Turn on the printer

Plug the power cord into the power connector on the back of the machine and then into the socket. Press the power switch and the round metal button on the front of the machine. The startup interface is displayed normally, indicating that the 3D printer has started normally.



Step 2

Nozzle preheating

Click the Tools menu → click the preheat icon → choose preheat the heating plate or nozzle.

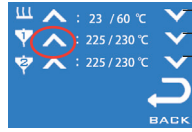
Example: Click the up arrow of print head 1 to preheat the print head. Click the up or down arrow multiple times to adjust the specified temperature. If you print PLA consumables, it can be adjusted to 210 ° C.



Home



Tools menu



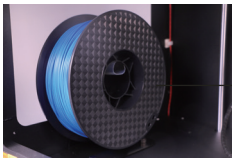
Heating menu

Preheating of heating plate
Nozzle 1 preheating
Nozzle 2 preheating

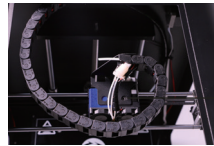
Step 3

Filament loading and unloading

Put the filament on the filament holder, pull the filament out, and insert them from the top inlet.



Filament



Feed port

This operation is required when the nozzle is preheated to 210 ° C. In the tools submenu, click the filament icon enter the submenu for loading and unloading filament. Click the down arrow marked with E1 to perform pre-extrusion of the filament. If it is observed that consumables are normally extruded from the nozzle, the extruder test steps are completed. Click the back icon to go to the home page.



Tools submenu



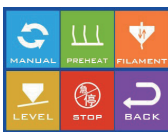
Loading and unloading submenu

Note: unless the filament run out of or need to print another color, there is no need to repeat the above three steps for each subsequent printing, just start the machine and choose the file to print.

Step 4

Axis test

Click the manual icon to enter the manual submenu, select 1mm or 10mm, and then click the arrow corresponding to XYZ to perform the axis movement test. Click the Home icon to return home. In addition, this function can also be used to make it easier to remove the model by lowering the Z-axis platform when the model is inconvenient.



Tools submenu



Manual submenu

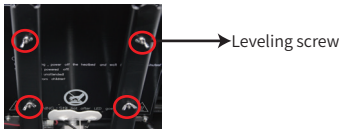


Home

Step 5

Platform adjustment

Place the sprayed side of the glass platform face up on the printing platform, and then fasten the buckle. Click the leveling button, place a piece of A4 paper between the platform and the print head, adjust the screws below the platform (about 45° each time), when the A4 paper can be pulled out and there is some resistance. When adjusting the middle point, you need to turn 4 screws at the same time for adjustment.



Step 6

Machine test

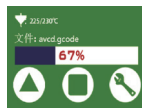
Click the print menu on the first page to enter the print file selection interface. After selecting the file, the printer will automatically heat up and print.



Home



File selection interface



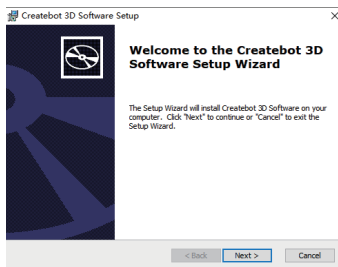
Print interface

Slice software installation

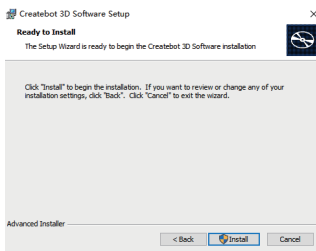
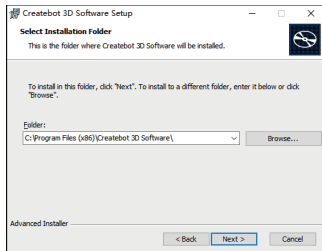
Copy the slicing software file from the SD card into your computer and double-click the file.



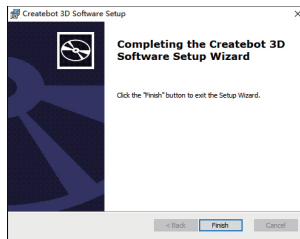
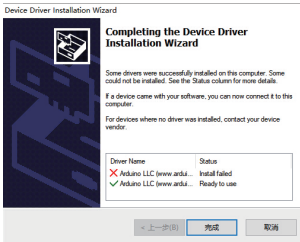
Slice Software



Select the installation path of the slicing software, choose Typical installation, then click Next, and click Install. The software is automatically installed to completion.

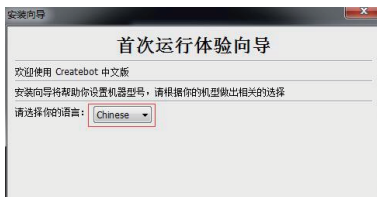


After the software is automatically installed, the installation completion interface pops up. Click the Finish button to end the slicing software installation.

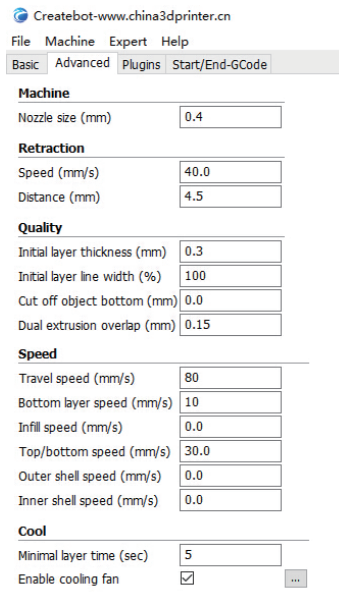
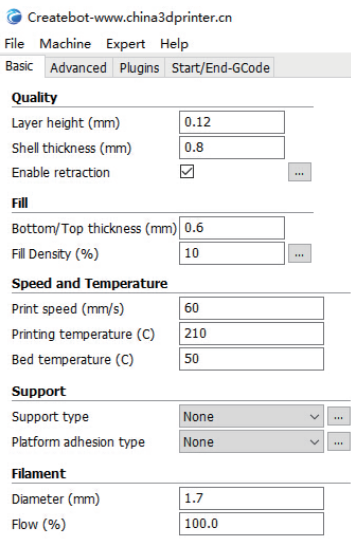


The first run slice parameter settings

Open the slice software, select language, choose the model of the printer you purchased (such as the purchase MID, please select MID), then click Next to complete the configuration.



It is recommended to configure the slice according to the following parameter map. In special cases, please adjust the parameters according to the actual situation. The 3D printer slicing software is simple to use. If you don't understand the parameters, please move the mouse cursor to each parameter name to display detailed parameter introduction. New users are advised to learn more about each parameter.



Note:

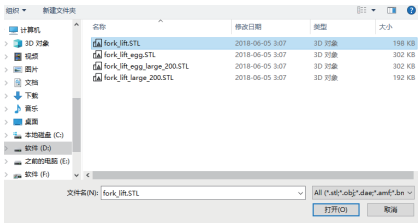
1. The density is the filling of the model. The higher the density, the more the filling. The general setting is between 10-20%. The filling structure is grid-like.
2. When setting the print speed, combining the size and difficulty of the model, generally set it to 20-60mm / s, the difficulty of the model is larger or the size of the single side of the model is less than 3cm, and the print speed is generally 10-30mm / s. Character modeling, mesh modeling, etc.
3. When selecting the support type, you can judge whether it is necessary to add “local support” , “all support” or “none” by observing the model or slice interface, but in principle, try to avoid or reduce the support. You can achieve this by rotating the model. The purpose of avoiding or reducing support.
4. When selecting the platform attachment type, the "edge" or "mesh" can be appropriately added according to the size of the contact surface between the model and the platform and the height of the model.

Import model fine-tuning

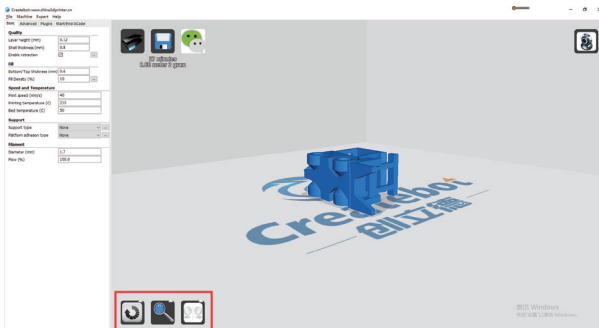
1. Click on the red marker.



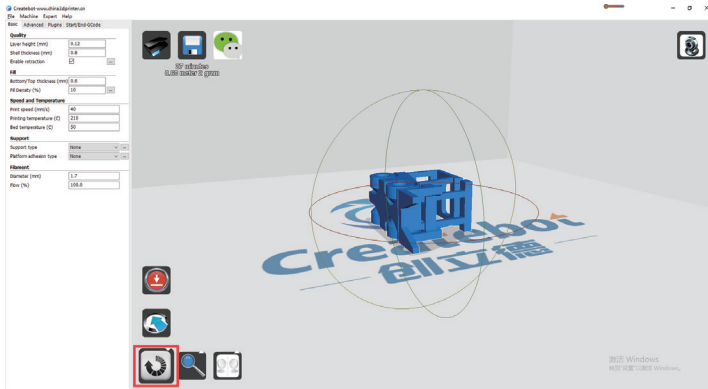
2. Select the file in STL format and click open.



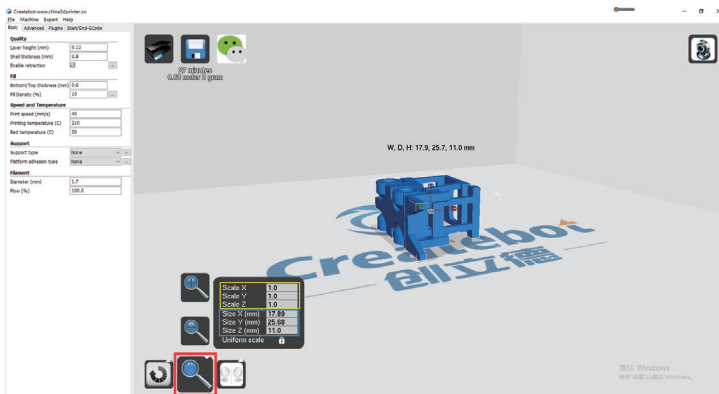
3. Click on the model and the red box icon appears.



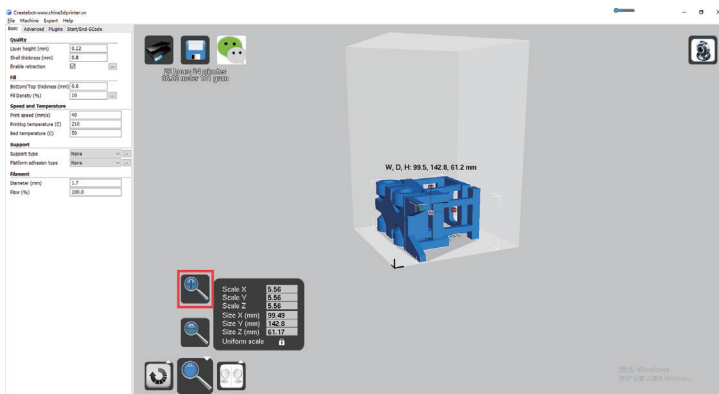
4. Click the rotate button, click and drag the arc around the model, and rotate it to the position you want.



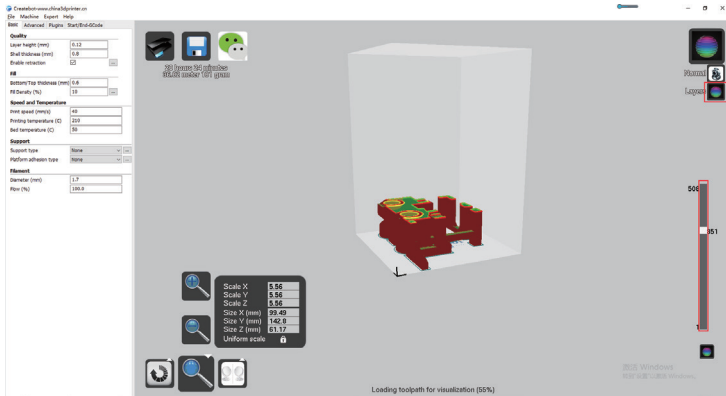
5. Enlarge or shrink the model, click the red box mark button to enter the corresponding scale in the yellow box and press enter to confirm; Example: reduce half of input 0.5, zoom in 2 times input 2. You can also enter the final size directly in the blue box.



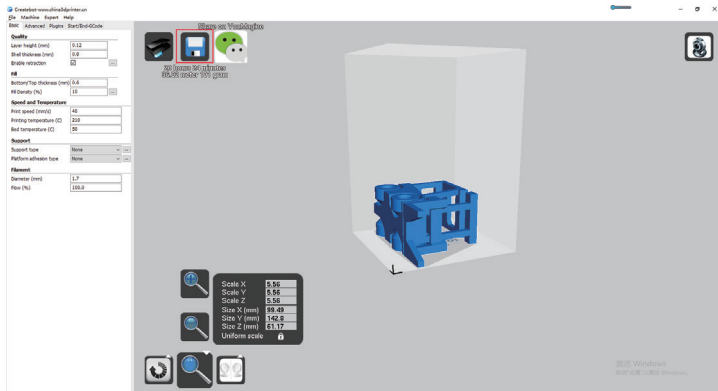
6. Click the red button to enlarge the model directly to the maximum printing size of the machine.



7. Click the Layers icon to display the slicing effect of the model. You can observe from the long box that the model is piled up by 290 Layers. By dragging a small white square, you can observe the slicing effect of each layer. Click the Normal icon to return to the Normal effect.



8. When the progress bar in the red area is loaded and displays the time required for printing and the length of consumables required, you can click the save button to export the gcode file.



9. Save the exported gcode file to the SD card and insert the SD card into the slot in the front of the machine.

名称	修改日期	类型	大小
fork_lift.gcode	2020-01-11 14:18	GCODE 文件	14,586 KB
fork_lift.STL	2018-06-05 3:07	3D 对象	198 KB
fork_lift_egg.STL	2018-06-05 3:07	3D 对象	302 KB
fork_lift_egg_large_200.STL	2018-06-05 3:07	3D 对象	302 KB
fork_lift_large_200.STL	2018-06-05 3:07	3D 对象	192 KB