Assembly Instruction

1. Filament bracket assembly:
   (1) Accessories, T-shaped nut installation:
   (2) Filament bracket installation:

2. Gantry assembly:
   (1) Remove the fixing block of the Z-axis screw:
   (2) Slide the corner connector with the square nut from the bottom of the rail:
   (3) Tighten the screw clockwise to fix the corner connector:
(4) Slightly loosen the eccentric nut of the base support plate and the hand can turn the V wheel:

(5) Re-tighten the eccentric nut in the opposite direction, rotate the V wheel by hand, and adjust the eccentric nut until the wheel can grasp the guide rail:

(6) Adjust the other 3 eccentric nuts in the same way, first loosen a little and then re-tighten!

(7) Slide the two square nuts of the base to the front end and put gantry to the base:

(8) Pass the M5*30 screws through the base mounting block and align it with the fixing hole at the bottom of the gantry:
(9) Tighten the screws clockwise: (the other side is the same)

(10) Slide the base square nut to the bottom of the corner connector mounting hole and align them, counterclockwise to loosen the corner fixing screw:

(11) Slide the corner connectors to the bottom to align the mounting holes with the square nut and place the corner connectors fixing screws:

(12) Tighten the 2 corner connectors fixing screws clockwise:
3. Wires connection:
(1) X motor/Endstop wire:

(2) Y motor/Endstop wire:

(3) Z1 motor/Endstop wire:

(4) Z2 motor/Endstop wire:

(5) Filament runout detection wire:
(6) Extruder installation: (Notice: Please check if the temperature measurement line of the extruder has fallen off before installation !!!)

(7) Fix the extruder on the mounting plate with 3 M4*8 screws:

(8) Pass the cable tie through the fixing hole, move the extruder to the furthest right, and make the extruder wire harnesses into the fixing block groove:
4. Start-up test:

① The chassis is available in two voltage options, 110V and 220V. The default voltage is 220V. Before turning on the power, please turn the voltage selection switch to the corresponding position according to the voltage of the local area:

(Please choose the appropriate voltage before turning on the power, otherwise the power supply will be damaged!)

② Connect the power supply line, open the control switch:
① The LCD display is displayed normally, check whether extruder and the temperature measurement of the hot bed is normal:

④ Check if the extruder cooling fan is working properly:
   (Notice: Only when the extruder cooling fan works normally, can be heated and printed, otherwise the throat pipe will be blocked)

5. Home test:
   ① “Info screen” Press the knob, rotate and select “Prepare” into the sub-menu, choose “Auto home”, click:

② XYZ return to the origin in turn normally, and the three axes will return to the origin position(lower-left corner), as follows:

6. Heating test:
   ① “Info screen” Press the knob, rotate and select “Prepare” into the sub-menu, choose “Preheat PLA”, click:

② In sub-menu choose “Preheat PLA” and click. The heating is normal if the temperature of the
extruder and hot bed is rising.

(Notice: The temperature is very high when the extruder and hot bed is heating, so please do not touch them! )

7. Leveling heated bed

(1) X-axis guide height adjustment:
   ① “Info screen” Press the knob, rotate and select “Prepare” into the sub-menu, choose “X Height adjustment”, click:
   ② The Z axis is automatically raised by 10mm. The distance between the two ends of the X-axis guide rail and the base is measured by the print piece. The height of the X-axis guide rail is adjusted by rotating the Z-axis blue coupling so that the X-axis guide can just touch the print piece.

(2) Leveling heated bed:
   ① “Info screen” Press the knob, rotate and select “Prepare” into the sub-menu, choose “Manual Bed Leveling”, click:
   ② The printer will perform the homing firstly, and then the extruder moves to the left-front of the heated bed to the first adjustment point:
① Adjust the hand screw nut under the platform so that the nozzle just touches the heated bed. You can use A4 paper to assist leveling and drag A4 paper so that the nozzle can just scratch on A4 paper. Click the knob and the extruder moves to the next adjustment point in turn.

② Repeat this operation for 1 or 2 times

⑤ After the leveling is completed, move the extruder to the 4 corners of the heated bed and visually check the distance between the nozzle and the heated bed:

⑥ Make sure the hot bed is leveled, select the "Back" menu on the display and return:
Notice !!!

- Before printing, please check if the belts and pulleys/carriage are loose, it’s easy to fix the problem please refer to Doc: “14. Belts & Eccentric nuts fasten Solution”.

- Please refer to assemble and using videos on Youtube:
  - Assembly Instruction video: https://youtu.be/NmvO0mEAKpA
  - Start printing video: https://youtu.be/lBoOcQa4ta0

- Detailed Instruction files and software in the SD card, or download from here: https://drive.google.com/open?id=1wC1SzMuXJph1lk1qzMcLKlsBYjPXMQM

- Amazon customers please contact after-sale service: adimlab@gmail.com
  Facebook group: ADIMLab 3D Printer