da Vinci 1.0 Pro
User Manual

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The purpose of this user manual is to help users understand and use the da Vinci 1.0 Professional 3D printer correctly. It contains the operating instructions, maintenance information and application skills of the da Vinci 1.0 Professional 3D printer.

For the latest information about da Vinci 1.0 Professional 3D printer and XYZprinting products, please contact your sales representative or visit XYZprinting website: http://www.xyzprinting.com

Product Safety

● Safety and Compliance

Before you use, operate the product, change or remove any parts, components or materials of the product, or maintain the printer, please ensure that you carefully read this User Manual and the safety instructions described below, and strictly follow the instructions of such safety information.

The following warnings and attention notices are a best effort attempt to cover all scenarios; unfortunately it is not possible to do so in the case of performing maintenance procedures that are not described in this manual the burden of safety falls to the customer side.

● Important Safety Information

- Do not place the printer in humid or dusty environment such as bathrooms and high traffic areas.
- Do not place the printer on an unbalanced or unstable surface. Printer may fall or tumble causing harm and/or injury.
- Do not let children operate this device without adult supervision. Moving parts can cause serious injury.
- Please use the grounded power cord supplied with the printer to prevent a possible electrical shock.
- Insert and secure the power cord firmly for proper usage and to avoid potential electricity and fire dangers.
- Do not disassemble or replace the printer cover with none XYZprinting covers.
- Do not place any objects on top of the printer. Liquids and objects that fall into the printer can lead to printer damage or safety risks.
- Do not use flammable chemicals or alcohol wipes to clean this device.
- The process of heating the filament will produce a light non-toxic odor. Having a well ventilated area will ensure a more comfortable environment.
- Make sure to set the power switch to the off position and remove the power cord before transporting the device.
- Do not touch the interior of the print while printing as it may be hot and include moving parts.
- Some components of the printer are moving during operation. Do not attempt to touch or change anything inside before power off the printer.
- Do not attempt to service the printer beyond the instructions specified in this document. In the case of irrecoverable problem, contact XYZprinting service center or your sales representative.

● Trademarks

All trademarks and registered trademarks are the property of their respective owners.
Product Description

Product Overview

Levelness of the Print Bed may be susceptible to vibration during transportation, which may influence print quality. Please adjust the bed with reference to 「Print Bed Adjustment」before printing.

Accessory Checklist

- Quick Guide, Warranty Card
- Filament Cartridge
- Cartridge Locker
- USB Cable
- Software CD
- Side Cover Plate x2
- Bed Tape X 3pcs (The bed tape is reusable and it can be replaced when it’s worn)
- Power Cord
- Cleaning Brush
- Copper Brush
- Cleaning wire x 5
- Scraper
**Product Description**

**Open the box**  Note: Please removal all fixed materials before turning on the printer to prevent the machine from damage

1. Open the box and remove the accessories and the cushion
2. Use the grip to take off the machine
3. Remove all fixing tapes and the packing bag
4. Open the upper cover and remove foilles listed above
5. Remove 2 foams at the front of the cardboard
6. Remove the fixing styrofoam beside the bed
7. Remove fixing paperboard
8. Remove bottom screw and the fixing screw on the bottom of the bed
9. Be sure to remove the fixing foam from the axis
10. Be sure to remove the cable tie as illustrated below
11. Insert the bundled software CD into the computer and install the software according to instruction
12. Use the USB cable to connect the printer to PC. Connect the power cord to the printer then turn on the power switch

*Note: Please use the power cord provided by XYZprinting.*

**Important Safety Notes**

- Do not use the printer in dust rich, highly humid or outdoor environments.
- Do not use the printer on a soft or tilt table to prevent the machine from falling, which may result in damage or personal injury.
- Do not put your hand into the machine during operation to avoid collision risk due to movement of the machine or to avoid burn due to high temperature.
Notes and Description for Use of Maintenance Tools

- The following tools can be used only in an environment with guidance or monitoring by adult. Do not allow children to obtain maintenance tools in unfamiliar situations in order to avoid danger.
- Please make sure to maintain the printer as the bed is cooled.

- After print is finished and the print bed is cooled to room temperature, the printing object may be taken off with Scraper.
- In order to prevent print quality from impact due to residual and accumulated filament, which results in poor discharge, after long-term use of print nozzle, it is recommended to enable the “CLEAN NOZZLE” (nozzle cleaning) function of the printer every 25 hours of print to clear residuals with nozzle cleaning wire.
- Filament residuals produced during print may also attach onto nozzle and gear of print module to influence print quality, printer operation, as well as measurement result of bed. For such situation, please use cooper brush to clean the print module.

Maintenance and Service

If the printer is delivered for repair during warranty period, it is recommended to pack the machine with original packing materials before transportation. Therefore, please keep original packing materials. If other packing materials are used instead, the printer may be damaged during print process. In such situation, the XYZprinting has the right to charge repair fee.

Display and Control Panel

Direction Up / Decrease the value

Back to pervious menu / Adjust the value / Move to the preview item

Go to the next menu / Adjust the value / Move to the next item

Direction Down / Increase the value

Select / Confirm setting / Confirm and exit

Home menu
Installation and removal of filament, calibration of the printing bed and printing settings, including:

- **CHANGE CART**
- **HOME AXES**
- **Z OFFSET**
- **JOG MODE**
- **CALIBRATE**
- **BUILD SAMPLE**
- **CLEAN NOZZLE**

**CHANGE CART**

Load, unload filament and view the information about the filament. Using XYZprinting filament to ensure smooth operation of the machine is recommended.

Refer to P.13 for Load filament
Refer to P.15 for Unload filament

**HOME AXES**

Use the function to move the extruder to upper right corner of printing space and the print bed to the top.

Extruder homing:

Select “YES” to return the extruder to the preset position.

**Z OFFSET**

Use the function to adjust the print bed upwards and downwards, and the printing distance between the bed and printing module.
JOG MODE

Manually adjust the movement of X/Y/Z Axis for printer maintenance.

How to move the extruder:

1. Select a target to move:
   - Select “X-AXIS” to move extruder rightwards and leftwards
   - Select “Y-AXIS” to move extruder forwards and backwards
   - Select “Z-AXIS” to move the print bed

2. Adjust the distance
   - Use “UP” and “DOWN” buttons to select the moving distance. Then select “-” based on the desired distance and press the “TO THE LEFT” button or select “+” and press the “TO THE RIGHT” button to adjust the moving distance.
   - Press the “TO THE LEFT” button: The extruder will be adjusted rightwards/backwards or closer to the print bed.
   - Press the “TO THE RIGHT” button: The extruder will be adjusted leftwards/forwards or away from the print bed.

CALIBRATE

Use the function to adjust the print bed and make adjustment based on the reference value. The printing quality will be affected by the levelness of the print bed. If you want to confirm the levelness of the print bed, turn on the function to measure and check recommended adjustment.

BUILD SAMPLE

3 built-in samples are stored in the printer. You can learn to use the printer through building samples.

1. Stick the bed tape onto the print bed before printing
2) Select the built-in sample to be printed

BUILD SAMPLE  
▶ DEMO  
▶ KEY CHAIN  
▶ HEART

3) Select “YES” and press “OK”

KEY CHAIN  
START BUILDING?  
NO  
▶ YES

4) After completion of print, take off the print product. The print bed patch is reusable, replace the patch when it is worn out.

Note: Stick the bed tape onto the print bed before printing or apply some glue stick on the bed tape for objects with special structures to make the tape more adhesive and the object more difficult to remove.

LEVELNESS OF THE PRINT BED

Levelness of the Print Bed may be susceptible to vibration during transportation, which may influence print quality. Please adjust the bed with reference to “Print Bed Adjustment” before printing.

CHANGE NOZZLE

UTILITIES  
BUILD SAMPLE  
▶ CHANGE NOZZLE  
▶ CLEAN NOZZLE

CHANGE NOZZLE  
ARE YOU SURE?  
NO  
▶ YES

TURN OFF POWER  
AND THEN CHANGE NOZZLE MODULE

Turn off the printer after the printing device and print bed automatically move to their positions and change the printing module.
Regular cleaning of the print nozzle facilitates to not only extending service life of the printer, but also improves print quality. Enable "CLEAN NOZZLE" (nozzle cleaning) function. Clean the nozzle after the nozzle is heated up, the bed has been lowered and the extruder has been moved to the front end, and "READY FOR CLEAN" is displayed on screen.

1. Clean the detecting pin with Copper Brush
Filament residues produced during printing may become attached to the nozzle and gear of print module to influence print quality, operation of the printer, and measurement result of the bed. If such a situation is encountered, please use a copper brush to clean the print module by brushing off residue and dirt on the detecting pin.

2. Clean Nozzle with Nozzle Cleaning Wire
With increased print frequency, the carbon accumulation and dirt in the nozzle might affect print quality. Thus, we recommend you to clean nozzle for every 25 hours of print. Please clamp the nozzle cleaning wire with needle-nosed pliers to insert it into the opening of the nozzle carefully for cleaning.

3. Wipe Measurement Points
After the bed is lowered, please switch off power to cool the bed, followed by wiping 3 measurement points with damp cloth.
The basic settings of the machine, functions, selection and adjustment of printing values, including:

- USER FILAMENT
- BUZZER
- AUTO HEAT
- LANGUAGE
- ENERGY SAVE
- RESTORE DEFAULT

The user can customize the temperature of the extruder, print bed and unload filament based on the requirements of filament and designing objects.

Refer to P.15 for Temperature Setting

Buzzer is turned on by default, you can select “OFF” and press “OK” to change the setting.

When “AUTO HEAT” is turned on, the printer heats up the extruder and the print bed after powered on. This helps to shorten the idle time that is necessary to heat up the printer before printing.

We suggest setting the language shown on the printer screen before use. The user can switch among English, Japanese, French, German, Italian and Spanish. English is the preset language. For other languages: Use “UP” and “DOWN” buttons to select the desired language and press “OK” to change setting.
ENERGY SAVE

LED luminaries are installed in the printing chamber. To save energy consumed, the lighting will go off after idling for 3 minutes (shown as 03M on the display) by default.

Select "06M" (for auto off after 6 minutes) or "OFF" (for never turn off the LED) and press "OK" to change the setting.

RESTORE DEFAULT

All settings can be reset to factory default with a few clicks.

Select "YES" and press "OK" to reset all settings.

INFO

The firmware and printer statistical information, including:
- STATISTICS
- SYSTEM VERSION
- CARTRIDGE STATS
- WIFI INFO
- HELP

Show the accumulated printing time and the last printing time. If you want to exit, press "OK".

SYSTEM VERSION

Show the version information of the current firmware. We suggest upgrading printer firmware to the latest version to ensure steady quality. To check whether latest version of firmware is available, use XYZware. If you want to exit, press "OK".
CARTRIDGE STATS
Show the remaining amount of filament (such as “REMAINING” for length information), volume of spool, color of filament and material information. Press to skip the page and press “OK” to exit.

INFO
SYSTEM VERSION
CARTRIDGE STATS
WIFI INFO

CARTRIDGE STATS
REMAINING 240m
CAPACITY 240m

COLOR
RED

MATERIAL
ABS

WIFI INFO
It shows the current situation of the WiFi connection of the printer. Refer to P.14 for “XYZware for Pro” WiFi Setting

INFO
CARTRIDGE STATS
WIFI INFO
HELP

INFO
SYSTEM VERSION
WIFI INFO

WIFI INFO
SSID
XYZ
IP ADDRESS
192.168.40.38
PRINTER NAME
xyzprinting
WIRELESS VER.
5.1.5

HELP
You may go to the website for the latest information, product documents, tutorial video and more. If you want to exit, press OK.

INFO
CARTRIDGE STATS
WIFI INFO
HELP

HELP
www.xyzprinting.com
Install and Load Filament

**UTILITIES > CHANGE CART > LOAD FILAMENT**

- **Install Filament Cartridge from XYZprinting**
- **Install Compatible filament**
- **Hang the spool on the filament spool holder prepared by yourself**
- **Remove the cartridge from the cartridge slot if any to use your own filament**
- **Remove the filament stopper and tape and install the filament cartridge into the empty slot**
- **Place and push to click the cartridge locker**

**Note**: Before pushing the filament into the guide hole, please cut the tip of the filament off at a 45° and Straighten the line.

**Activate LOAD FILAMENT function on the control panel**

- **To use XYZprinting filament and apply the recommended temperature settings,**
  - **USE XYZPRINTING CARTRIDGE NOW? > YES**
  - **A. Wait for the extruder to heat up**
  - **B. As the temperature reaches operating setting the printer loads automatically the filament, and filament loading is completed**
  - **C. Check if the filament flows out from the nozzle. If the filament has flowed out, please press “OK” to complete the loading process**

- **To adjust the temperature settings manually, select "NO"**
  - **USE XYZPRINTING CARTRIDGE NOW? > NO**
  - **See the section “Temperature Setting” for detailed instructions. After adjusting the temperature of each item, press "OK" to back to the item list. When setup the preference for all items, select “APPLY SETTING” on the top to save and apply the settings. Please note that operating temperature can also be set by select “SETTING” > “USER FILAMENT” and "YES" from the control panel.**

**Remarks**: The temperature setting in this procedure is applicable only to 3D Builder application software developed by Microsoft. For more information about 3D Builder, please visit the Microsoft website.

**Filament loading is completed**

**Note**: Before pushing the filament into the guide hole, please cut the tip of the filament off at a 45°
Functional operations and descriptions

Print Bed Adjustment

Before first printing, please calibrate the bed to guarantee an appropriate levelness of the bed for printing.

● UTILITIES > CALIBRATE

After the printer is heated up to an appropriate temperature, the distances between measurement points on bed edge (1) - (4) and probes are measured automatically to determine levelness of the bed.

If the automatic detection function determines that there is no need to adjust levelness of the bed, “PERFECT” will be displayed on screen. At this moment, press ”NO” to exit. If it displays that the bed has to be adjusted from the detection result, an adjustment prompt will be displayed.

● Calibration Instruction

There are three white 4-step knobs under the bed. Each step of turning indicates 90 degrees of rotation, and 4 steps of flick indicate a complete circle of rotation of the knob as shown in the messages on screen. Press “OK” key to continue viewing adjustment instructions.

Knobs corresponding to this procedure

Turning direction
Number of turning steps (each step indicates 1 tick/90 degrees of rotation)
After flicking knob in accordance with prompt, press “OK” key to continue

After flicking the knobs in accordance with instruction, the printer will detect the levelness of the bed again. As “PERFECT” is displayed form the detection result, print may be started.

If the measurement point of the bed is stained or the bed is too high or too low, wrong measurement will occur and the warning of “CALIBRATE FAIL” will be shown on the screen. Please adjust the print bed.
Functional operations and descriptions

Unloading Filament

● UTILITIES > CHANGE CART > UNLOAD FILAMENT

In unloading filament, activating the filament unloading function on the control panel of the printer
1. Wait for the extruder to heat up to operating temperature and unload the filament.
2. As “PULLOUT FILAMENT” is displayed on the screen, press the release arm and pull out the filament.

Temperature Setting

● SETTINGS > USER FILAMENT

The user may customize nozzle temperature, print bed temperature and filament unloading temperature in accordance with requirements of different filaments and design objects:

Select the item for temperature setting

1. **A Nozzle**
   - Press “OK” to enter temperature setting for nozzle
   - Temperature Customization:
     - NOZZLE: 210℃
     - Use “left key”, “right key” to select the digit (single, tens, hundreds) for the temperature to be adjusted.
     - Use “up key”, “down key” to adjust the value. The up key is for increasing value, and the down key is for decreasing value.
     - Press “OK” key to apply setting.

2. **B Print Bed**
   - Press “OK” to enter temperature setting for print bed
   - Temperature elevation range of the print bed: 0℃ ~ 90℃

3. **C Filament Unloading**
   - Press “OK” to enter temperature setting for filament unloading
   - Temperature elevation range of the extruder in unloading: 170℃ ~ 240℃

**Remarks:** The temperature setting in this procedure is applicable only to 3D Builder application software developed by Microsoft. For more information about 3D Builder, please visit the Microsoft website.

- If the temperature for print bed is specified as 40℃, room temperature printing will be enabled and the print bed will not be heated.
- Excessively low extruder temperature may result in poor filament feeding, result in poor filament feeding that prevents proper extrusion of the filament through the nozzle. Hence, please adjust the operating temperature of the extruder first.
Transfer print file through computer software "XYZware for Pro"

Connect the printer and the computer with USB cable and install "XYZware for Pro" in the computer to transfer print file.

"XYZware for Pro" may run in Windows 7 and above and Mac OS 10.8 and above operating systems. You may install it with the attached original vendor CD or download the installation file from the XYZprinting official website. For more information, please visit the official website: http://www.xyzprinting.com/

- Basic Operation Flow

After opening the software, click "Import" to select the model file you desire to print and load it. The user may change relevant settings through "File Conversion" function to satisfy adjustment of print speed and effect.

After edition and adjustment, "Print" may be click to export object, and start to print after the file has undergone slicing process.

For messages about version updates, operation instructions and technical support, please visit the XYZprinting official website: http://www.xyzprinting.com/ to obtain more detailed information.
WiFi Connection

The printer supports Wi-Fi connection printing. Install "XYZware for Pro", and activate Wi-Fi setting of the printer in accordance with the following instruction to switch the printer to wireless control mode, such that the print file may be subsequently transferred wirelessly.

● Preparation Prior to Setting
1. The network print function is provided mainly for Intranet application. Please set the printer and the computer in the same domain, that is, link them to the same wireless base station (Access Point).
2. Before linking the printer, settings would be adjusted for the connected wireless base station. For detailed setting way, please refer to the operation instruction of the product or original vendor relevant information.
3. Channel Width may be set to 20 MHz for use of wireless print function. Please refer to original vendor operating instruction of wireless base station to understand adjustment way.
4. Please keep the wireless network function in the on state.
5. The machine supports the following link security modes. Public key information would be requested to enter in setting printer connection.

- WEP
- WPA
- WPA2

● Wi-Fi Settings

1. Please use a USB cable to link the computer and the printer, and open XYZware for Pro.

Click the "Printer Monitoring" function icon on the lower right corner on the screen, open "Printer Monitoring" window, click "My Printer" > "Scan" to enter the page for printer search, and click "Wireless Network Settings" to enter the page for wireless print settings.

2. Channel Width may be set to 20 MHz for use of wireless print function. Please refer to original vendor operating instruction of wireless base station to understand adjustment way.

3. The machine supports the following link security modes. Public key information would be requested to enter in setting printer connection.
WiFi Connection

3. Please enter printer name (either English or numeric name), press "Scan" function to obtain wireless base station information with dropdown menu, and select the name of the wireless network you desire to connect.

4. After successful connection, Wi-Fi name will be displayed on screen of the printer.

5. At this moment, USB cable may be taken off to continue the print process.

6. If connection is to be disconnected, please connect USB back between the computer and the printer, and open XYZware for Pro again.

Product Specification

<table>
<thead>
<tr>
<th>Print Technology</th>
<th>Fuse Filament Fabrication (FFF)</th>
<th>Weight</th>
<th>26 KG</th>
</tr>
</thead>
<tbody>
<tr>
<td>Print Dimension</td>
<td>20 x 20 x 20 cm</td>
<td>Print Material</td>
<td>ABS / PLA</td>
</tr>
<tr>
<td>Print Resolution</td>
<td>0.1 / 0.2 / 0.3 / 0.4 mm</td>
<td>Filament Diameter</td>
<td>1.75 mm</td>
</tr>
<tr>
<td>Display Screen</td>
<td>2.6 inch LCM</td>
<td>Nozzle Diameter</td>
<td>0.4 mm</td>
</tr>
<tr>
<td>Connection Method</td>
<td>USB 2.0 / WiFi</td>
<td>Operating System</td>
<td>Win 7 and above</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>Mac OSX 10.8 and above</td>
</tr>
<tr>
<td>Print Software</td>
<td>XYZware for Pro</td>
<td>File Format</td>
<td>3w / stl</td>
</tr>
</tbody>
</table>
1. The mobile device needs to support wireless printing.
2. Install XYZprinting App from Android or iOS system.

Print From A Mobile Application

1. The mobile device needs to support wireless printing.
2. Install XYZprinting App from Android or iOS system.
Please register an account at XYZprinting official website before logging in.

After log in, you will see "most popular", "new" and "printable" three folders for you to choose.

Select the object you want to print.

Select the printer and confirm the printer information, tap "Confirm to print", the file will be sent to the printer and ready to print.

Note:
1. Ensure the mobile device and the printer are connected on the same wireless network.
2. Transferring a print file over a wireless network may take more time than transferring a print file from a USB mass storage device.
3. When a .3w file with incompatible slicing is selected, the message of “Printer Type does not match” will be displayed. We suggest selecting other files or downloading .stl to slice before printing.

*The printable file is .3w format which can print from App directly. Some prints are .stl files that need to export into .3w format via XYZware before printing. If the file requires payment, please follow the payment instruction.
As the printer encounters issues, please refer to the following troubleshooting instruction to fix the issues. If the issue cannot be removed, please contact customer service center.

Error message and Action
In the event of problems, related service code will be shown on the printer screen and/or software interface. Please refer to the description table of the service code for preliminary examination.

<table>
<thead>
<tr>
<th>Service Code</th>
<th>Symptom</th>
<th>Action</th>
</tr>
</thead>
<tbody>
<tr>
<td>0003 (software)</td>
<td>Print bed heating problem</td>
<td>Confirm whether the heater works normally and whether the sensor and heating rod are installed correctly or work normally. Problems may occur when the printer works under 25 °C. Please move the printer to the environment at proper temperature.</td>
</tr>
<tr>
<td>0007 (software)</td>
<td>&quot;UNIDENTIFIED CARTRIDGE&quot; shown on the printer screen indicates filament chip anomaly.</td>
<td>Reinstall or replace the filament cartridge.</td>
</tr>
<tr>
<td>0008 (software)</td>
<td>&quot;UNIDENTIFIED CARTRIDGE&quot; shown on the printer screen indicates filament chip anomaly.</td>
<td>Reinstall or replace the filament cartridge.</td>
</tr>
<tr>
<td>0010</td>
<td>Print bed heating problem</td>
<td>Confirm whether the heater works normally and whether the sensor and heating rod are installed correctly or work normally. Problems may occur when the printer works under 25 °C. Please move the printer to the environment at proper temperature.</td>
</tr>
<tr>
<td>0011</td>
<td>Extruder heating problem</td>
<td>Confirm whether the nozzle works normally and whether the sensor and heating rod are installed correctly or work normally. Problems may occur when the printer works under 25 °C. Please move the printer to the environment at proper temperature.</td>
</tr>
<tr>
<td>0013</td>
<td>Print bed heating problem</td>
<td>Confirm whether the heater works normally and whether the sensor and heating rod are installed correctly or work normally. Problems may occur when the printer works under 25 °C. Please move the printer to the environment at proper temperature.</td>
</tr>
<tr>
<td>0014</td>
<td>Extruder heating problem</td>
<td>Confirm whether the nozzle works normally and whether the sensor and heating rod are installed correctly or work normally. Problems may occur when the printer works under 25 °C. Please move the printer to the environment at proper temperature.</td>
</tr>
<tr>
<td>0028 (software)</td>
<td>NO CARTRIDGE (Filament is not installed correctly.)</td>
<td>Reload or replace the filament</td>
</tr>
<tr>
<td>0029 (software)</td>
<td>CARTRIDGE EMPTY</td>
<td>Replace filament immediately</td>
</tr>
<tr>
<td>0030</td>
<td>X-axis movement abnormalities</td>
<td>Check motor/sensor connections. Check sensor position.</td>
</tr>
<tr>
<td>0031</td>
<td>Y-axis movement abnormalities</td>
<td>Check motor/sensor connections. Check sensor position.</td>
</tr>
<tr>
<td>0032</td>
<td>Z-axis movement abnormalities</td>
<td>Check motor/sensor connections. Check sensor position.</td>
</tr>
<tr>
<td>0050</td>
<td>Internal storage error</td>
<td>Reboot the printer</td>
</tr>
<tr>
<td>0051</td>
<td>Flash ram access error</td>
<td>Reboot the printer</td>
</tr>
<tr>
<td>0052</td>
<td>Nozzle internal memory error</td>
<td>Please contact our Customer Service center</td>
</tr>
</tbody>
</table>
Support Details

### Error Status

<table>
<thead>
<tr>
<th>Error Status</th>
<th>Recommended Process Ways</th>
</tr>
</thead>
<tbody>
<tr>
<td>Printer is busy</td>
<td>Try again after current task is completed, and examine the information displayed on screen of the printer</td>
</tr>
<tr>
<td>Firmware of the printer cannot be updated</td>
<td>Check internet connection / Update firmware later</td>
</tr>
<tr>
<td>Nozzle is dogged</td>
<td>Unload the filament to clean the nozzle, and then reload the filament</td>
</tr>
<tr>
<td>Filament cannot be loaded</td>
<td>Unload and reload the filament</td>
</tr>
<tr>
<td>NO CARTRIDGE</td>
<td>Reload or replace the filament</td>
</tr>
<tr>
<td>Filament is not installed correctly</td>
<td>Replace filament immediately</td>
</tr>
<tr>
<td>CARTRIDGE EMPTY</td>
<td>Replace filament immediately</td>
</tr>
<tr>
<td>FILAMENT LOW</td>
<td>Replace filament if necessary</td>
</tr>
<tr>
<td>FILAMENT END</td>
<td>Replace filament immediately</td>
</tr>
</tbody>
</table>

### Maintenance and Service

Keep original packaging material in the event of sending your unit back for repair during the warranty period. If other packing materials are used instead, the printer may be damaged during the transportation process. In such situation, the XYZprinting the right to charge repair fee.

### Federal Communications Commission (FCC) Statement

You are cautioned that changes or modifications not expressly approved by the part responsible for compliance could void the user’s authority to operate the equipment.

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

XYZprinting is not responsible for any radio or television interference caused by using other than recommended cables and connectors or by unauthorized changes or modifications to this equipment. Unauthorized changes or modifications could void the user’s authority to operate the equipment.

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

This device complies with FCC radiation exposure limits set forth for an uncontrolled environment and it also complies with Part 15 of the FCC RF Rules. This equipment must be installed and operated in accordance with provided instructions and the antenna(s) used for this transmitter must be installed to provide a separation distance of at least 20 cm from all persons and must not be co-located or operating in conjunction with any other antenna or transmitter. End-users and installers must be provided with antenna installation instructions and consider removing the no-collocation statement.