

# 3D PRINTER

USER MANUAL

**WEEDO**

成就非凡创意

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# Application Notices

## 1.1 About The Instruction Book

This instruction book contains 3D printer's installation, use, maintenance, common problems and other important information. Please read this instruction book carefully before use 3D printer. For 3D printer damage and other damages caused by violation of safety matters and operation procedures given in the instruction book, it will be borne by the user.

## 1.2 Safety Attentions

- 1、 In the printing or just after printing of 3D printers, as nozzle temperature reach up to 200°C, it is forbidden to touch the printing head directly at this moment.
- 2、 3D printer is equipped with active air filtration system; it can handle the most irritating gases emitted after heating of filaments in printing. But if printing is needed for long time, please use the printer under the well-ventilated environment.
- 3、 As 3D printer is complicated for its structure, if there is fault, please refer to the instruction book to eliminate the faults. If the fault still can't be solved, please contact the after-sales department of company. To the printer maintained by user without authorization, the company would not guarantee maintenance.
- 4、 As 3D printer is equipped with high voltage inside, it is forbidden to disassemble the printer by the non-professional staff. To any consequence caused by violation of this matter, it would be borne by users.
- 5、 Please use the electric wire to connect and USB data connecting line provided by company. Any printer's faults and other consequences caused by use connecting line or USB data connecting line provided by the third-party, it would be borne by users.
- 6、 When 3D printer power supply is connected, please insert the power cord into the flat three holes socket in compliance with international standard. It is not allowed to insert the power cord to the two holes socket. One line of ground wire in the power socket must be well grounded, and should not be suspended. The mechanic fault other accidents caused by that 3D printer is not well grounded, the company would not be responsible.

7、 The default input voltage of 3D imprinter is 220V. If 3D printer is used in the areas out of China mainland, please contact the company after-sales, the company technician staff would provide you solutions.

8、 When the accident power outage occurs at your area, please equip the UPS power supply of 3D printer.

## 1.3 Printing Consumable Items

Use the printer, please use the printing consumable items provided by the company. The printing consumable sold in the retail market is of different specifications and quality levels, it is very easy to block the printer nozzle and damage the nozzle and electrical machine. For the printer faults caused by use the consumables of third party, our company would not guarantee to repair.

## 1.4 Environmental Requirements

The 3D printer is applied with fully enclosed structure, strongly adaptive to the environment temperature, and can work normally in the 5°C to 40°C environment. If the environment temperature exceeds this range, the printing quality of finished product will be dropped accordingly.

After the printing consumable is opened with its package, if they are not used for a long time, please seal it by sealed package. Especially to the PLA consumables, it would absorb the moisture in the air to affect the quality of printing finished products after long time exposure to air.

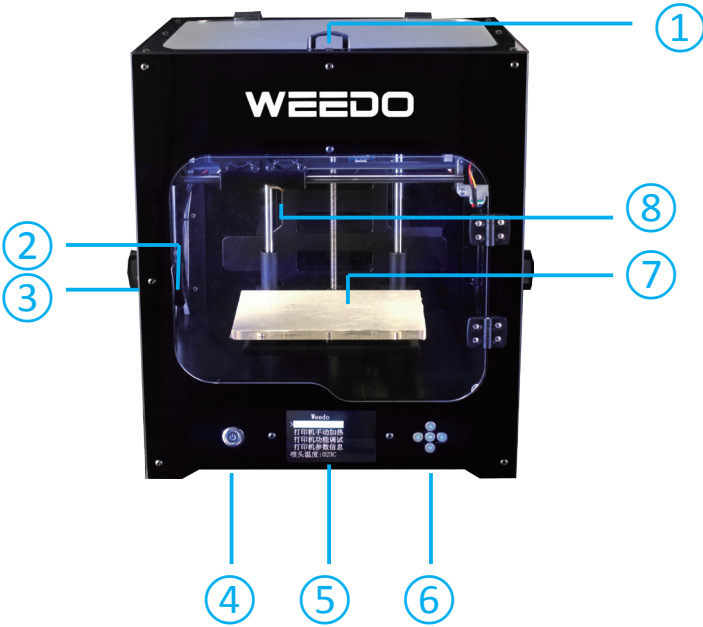


## Printer Brief Introduction

The printer is applied with FDM (Fused Deposition Modelin) theory, which performs the slicing conversion for the STL 3D model, and then prints out the real finished product one by one. The printer is of metal frame, fully closed structure, removable printing platform, active air filtration system and one series of innovative design, and is characterized of high printing speed, high quality finished products, easy maintenance, and supports the high strength connecting line printing.

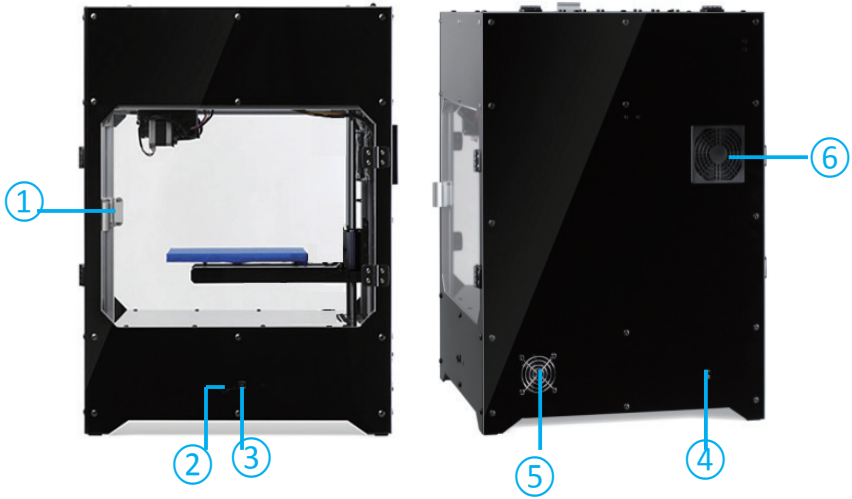
## 2.1 Appearance Introduction

The Front View of Printer



- ① Up Cover
- ② Front Doors
- ③ Left Side Door
- ④ Power Switch
- ⑤ LCD display screen
- ⑥ Control Panel
- ⑦ Removable Printing Platform
- ⑧ Printing Nozzle

The Right View and Back View of Printer



① Right Side Door

④ Power Socket

② SD Card Socket

⑤ Host Fan

③ USB Line Socket

⑥ Air Filtration Fan

## 2.2 Technical Parameters

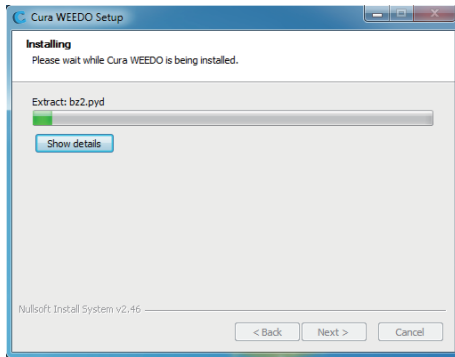
Printing Parameters		Machine Parameters	
Print Size	200*150*150mm	Display Screen Model	English
Layer Thickness	0.1~0.5mm	Machine Size	37.5*33*44.5mm
Nozzle Diameter	0.4mm	Machine Weight	14kg
Printing Resolution	0.1mm-0.2mm	Machine Color	Black
Printing Speed	20~150mm/s	Input Voltage	110v - 220V
Positional Accuracy	Z axis 0.0025mm	Maximum Power	120W
	XY axis 0.011mm	Filtration System	Three Layers of Mesh Filter
Consumable Parameters		Software Parameters	
Consumable Type	PLA/PLA Pro	Printing Software	Cura WEEDO Version / ReplicatorG WEEDO Version
Consumable Diameter	1.75mm	File Format	STL/GCODE
Consumable color	Optional for multi-colors	Operating System	Windows/Linux/MacOSX
		Printing Method	USB/SD Card

3

# Installation of Software

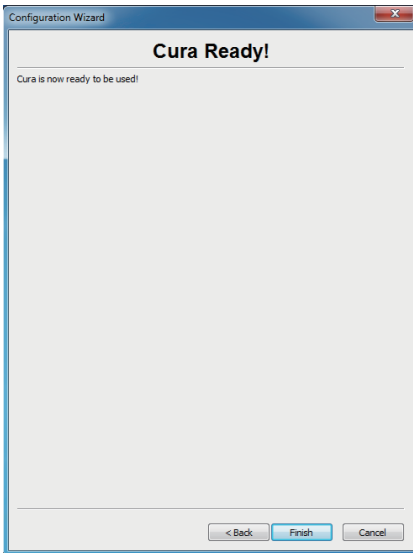
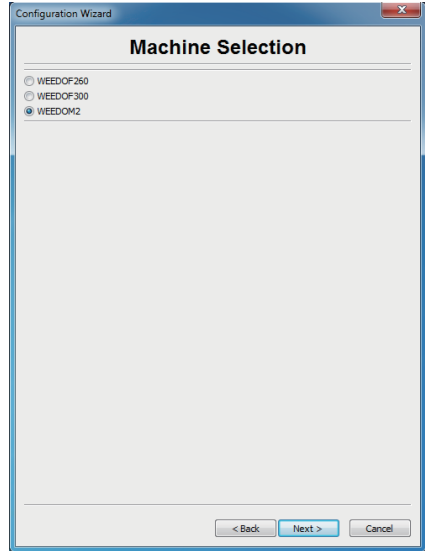
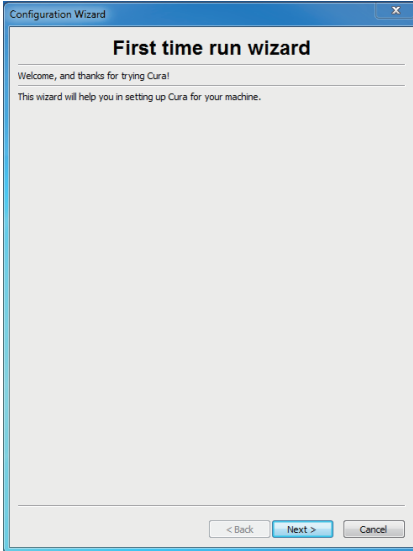
### 3.1. The Installation of Cura WEEDO

Run the software installation package, Cura-WEEDO, in the installation wizard window, click “installation”→“Next Step”→“Complete”. In the window of selection installation path window, please use the program default route.



Note: Cura installation path is the root directory of Disc C

When it is first time to use Cura software, go to the guide interface, click “Next”, go into the computer model selection interface, select WEEDO M2, click “Next”, go to the ready interface, click “Finish”, the installation is completed.





Print the first model

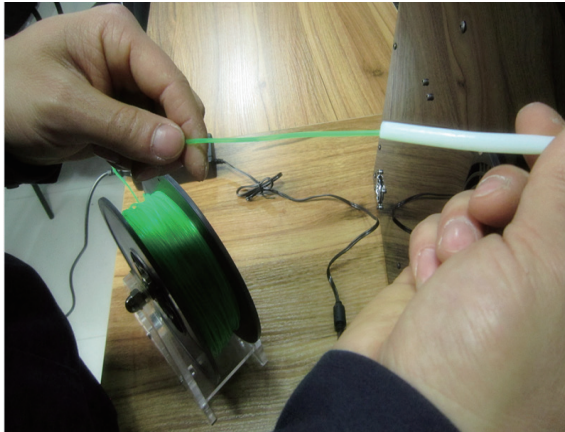
## 4.1. Linked with Power Supply

Take out the power cord from the accessories box, plug the male connector to the power socket and female connector to 24V wide contact of external power supply, and plug the 24V external power supply circular thin connector to the power supply input socket at the back of printer.

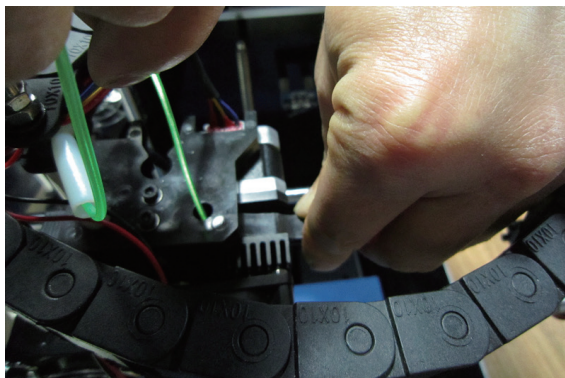


## 4.2. Assembly of Filament

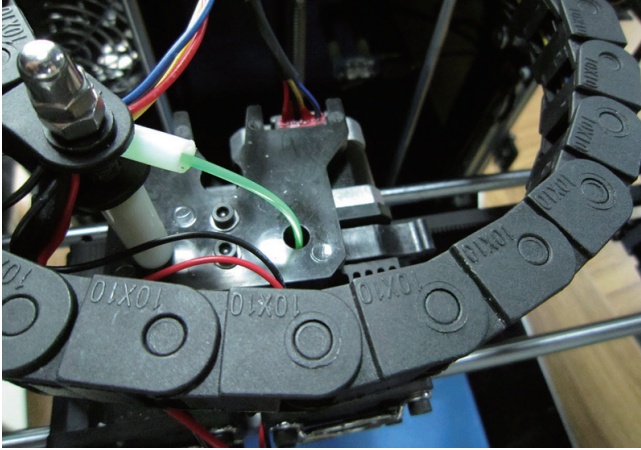
Take out the tray and rack, put the spindle of material rack on the tray and put all together to the material rack. Find out one end of filament from the material tray and sent it to the feed pipe at the back board of printer, until the filament thread out from another end of material pipe.



Open the cover plate on the printer; pull out the filament around 20cm from the material pipe. Break straight the end of filament, right hand presses down the handle of extruder, and left hand holds the filament and plug it into the feed inlet, insertion depth is about 5cm.

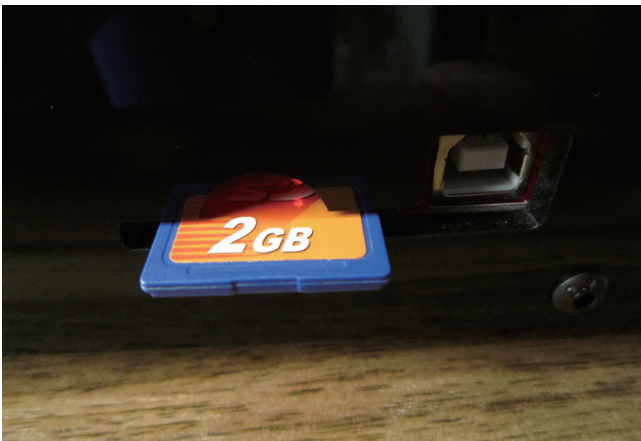


Stuff the excess material filament back to the feeding pipe, and then place the feeding pipe on the feeding hole.



### 4.3. Printing Preparation

Take out the SD memory card presented in accompany with printer, and plug it to the card slot.



Press down the power button at the rear panel, and start up the printer power supply.



## 4.4. Printing Model

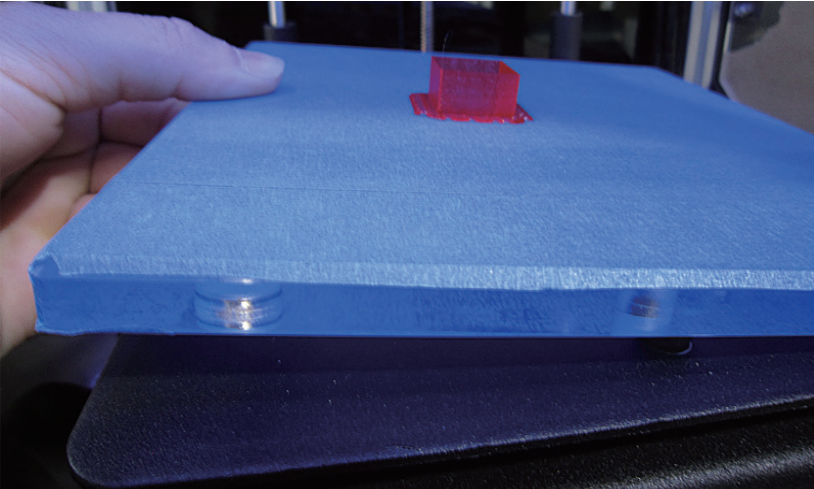
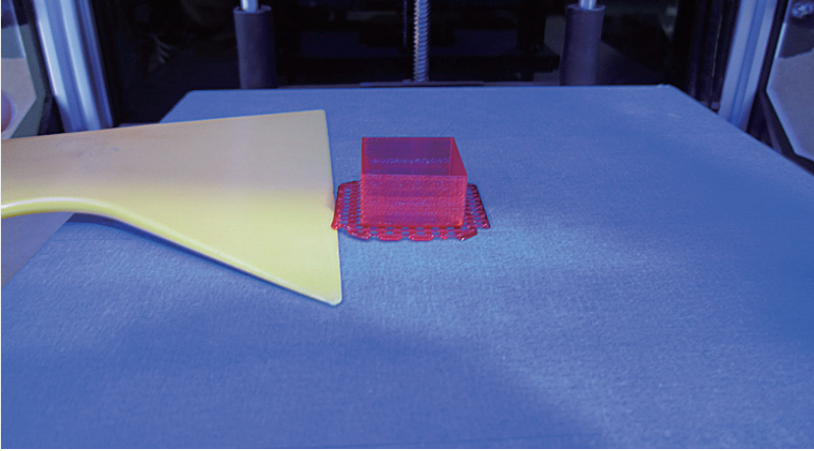
On the operation panel, choose “Print the files in the SD card”→”02\_ThinwallCub.x3g”, press OK button to start printing.

WEEDO M2  
»Print from SD  
Preheat  
Utilities  
Setting&Info  
Extruder :020C

SD Meun  
»02\_ThinwallCub. x3g  
yz50.x3g  
XTEST.x3g  
XYtest.x3g  
Extruder :020C

## 4.5. Removing Model

After model is completed with printing, it uses the presented plastic scraper in accompany with printer, to take it out along with the edge of model, or firstly disassemble the printing platform and take out model.

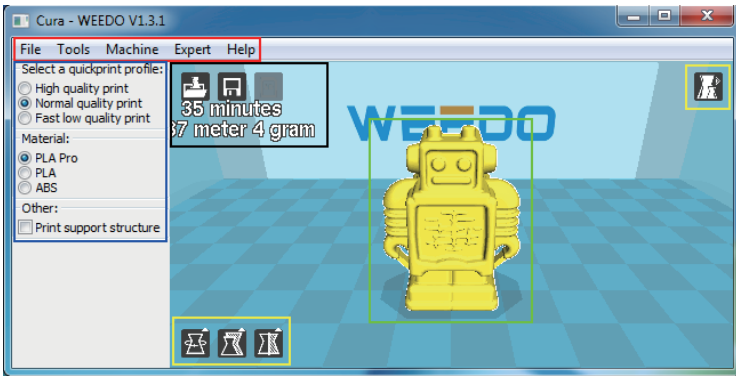




# Cura Software Detailed Introduction

## 5.1. Basic Interface

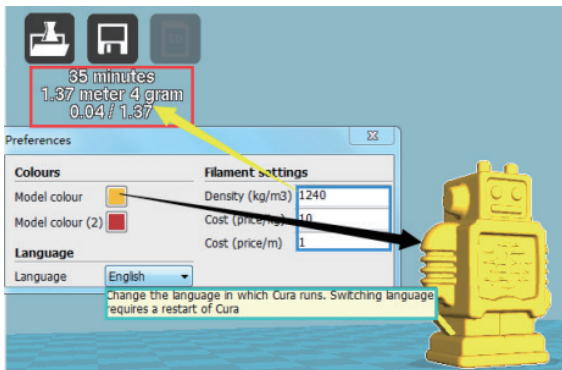
The figure below displays a typical interface of Cura



- ◆ Red Box is Menu Bar
- ◆ Blue Box is Printing Parameters Setting Bar
- ◆ Yellow Box is used to Adjust model, and to check model
- ◆ Black Box is the operation related to Printing, grey buttons displays it can't be used temporarily under the current condition.
- ◆ Green Box is Model Preview

### 5.1.1. The Preference Menu

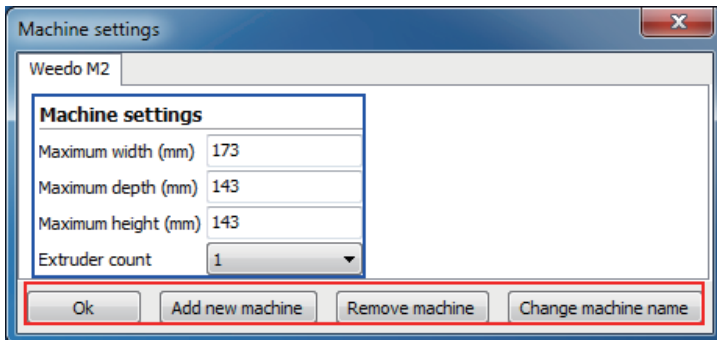
Click "File" on the menu bar → "Preference", enter the preference menu, as shown in figure below, it can perform the following setting:



Please note: After language is switched, it can be effective only after restart.

## 5.1.2. Machine Setting

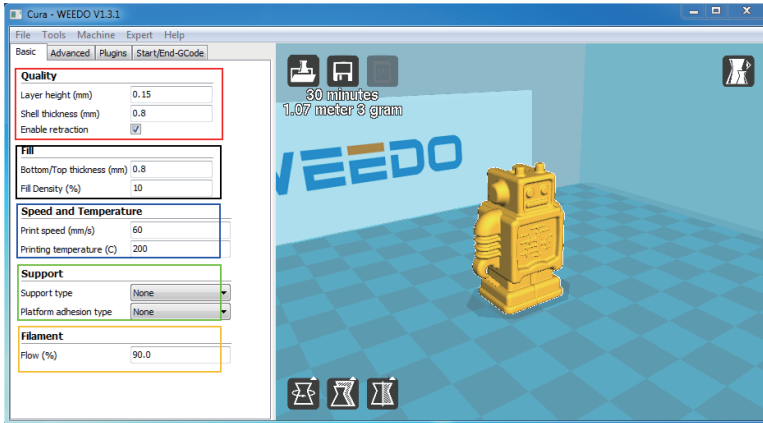
Click “Machine” on the menu bar → “Machine Setting”, enter to machine setting interface, as shown in figure below.



- ◆ Blue Box refers to the size of machine printing platform, we have already performed the preset according to your choice of model, please do not change these data.
- ◆ Red Box refers to the associated settings of machine, including adding new machine model you need, delete the machine model you don't need, also can modify the name of machine model, modification of machine model name would not change any parameters.

### 5.1.3. Printing Parameters Settings

Click“Advanced Setup”on the menu bar→“Switch to the complete setting model”,go into the complete setting interface, as shown in figure below.



◆ Red Box is Printing Quality Parameter.

Layer height: is the printing precision we usually refer to, and is generally chosen between 0.1 and 0.25, the smaller the data is, the higher the model precision is.

External shell layer thickness: the thickness of outermost surface can improve the surface quality, and is multiple of nozzle size (is also the multiple of 0.4)

◆ Black Box is Stuffing Parameters.

Bottom and top thickness: the thickness of model bottom layer and top layer, it is suggested to use the same parameter as the external shell.

Packed density: It refers to packed density of model. The interior of model is not completely packed, and it would not affect the surface quality, but affect the intensity only.

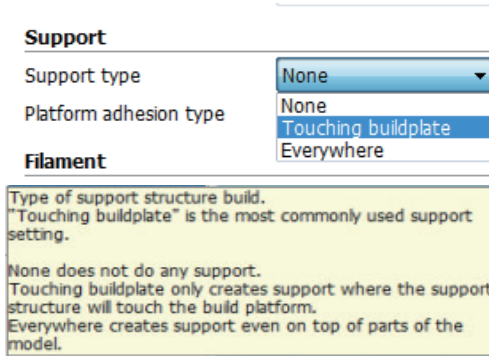
◆ Blue Box is Speed and Temperature Parameters

Printing speed: If the printing object is relatively small, please use the low speed.

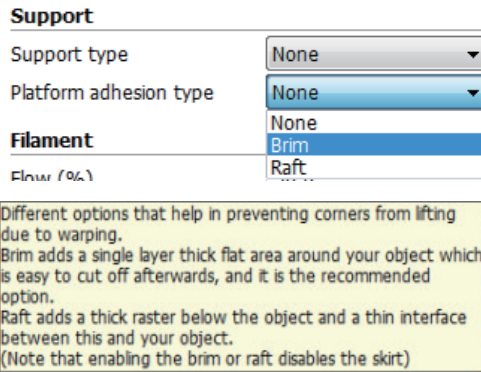
Printing temperature: it refers to the temperature of printing spray-head, the temperature to print the PLA/PLA pro consumables is 195-210 degree, and the temperature to print the ABS consumables is 230 degree.

◆ Green Box is Support Parameters

Support type: shown as figure below, “None” refers to not use the support, “Touching buildplate” is external support, “Everywhere” is complete support, the support type can be choose according to the model suspending in the air.



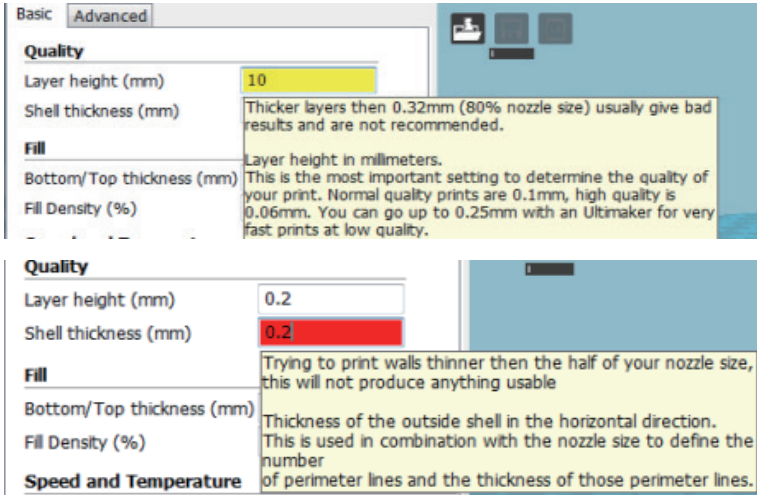
Printing platform adhesive base type: as shown in figure below, “None” refers to not used pad, “Brim” refers to edge pad, “Raft” refers to bottom gridding pad.



◆ Orange Box is the filament flow rate parameters

The filament rate parameter is generally 90%.

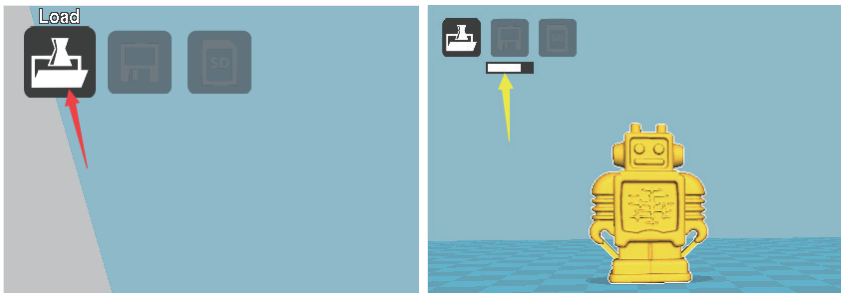
Please note: when it is wrong or ineffective for filling the parameters, software would use yellow and pink to provide indication, yellow refers to warning, red refers to error, it can be seen when the mouse hovers, as shown in figure below.



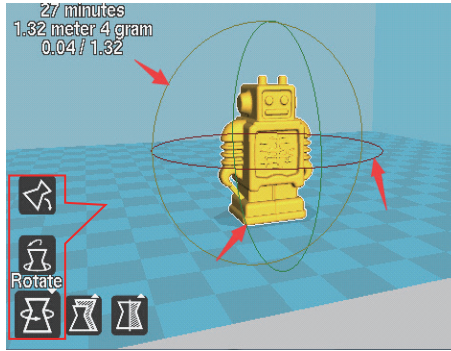
## 5.2. Model Conversion

### 5.2.1. Model Loading

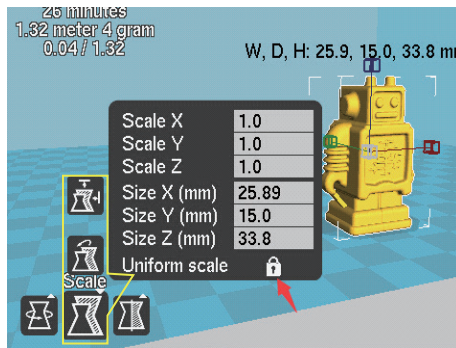
Open Cura software, as shown in figure below, click the loading button of “Load” of red arrow pointing on the interface, the model needed to print is choose in the pop-up window. Please note: Yellow arrow pointing is the progress bar, Cura section engine is always started, when model or parameter is changed, engine would re-start slicing. To the computer with low configuration, the frequent modification of parameter and changing model may cause the Caton phenomenon when the engine is started, the operation speed can’t be too fast.





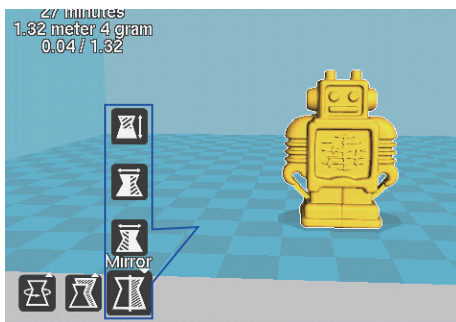
### 5.2.2. Model Adjustment



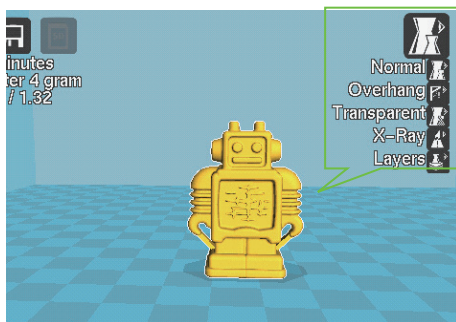
Red Box is **Model Rotation Setting**. Click the rotation button, and then hold the left key of mouse, and drag the ring shape edge frame around the model to adjust the model, it can perform rotation adjustment to the model from three directions of “X, Y, Z”.



Yellow Box is **Model Zoom Setting**. Click on the zoom button, and pop up model zoom scale and model size dialogue window. In the item of “Scale”, it inputs the proportion factor needed with zoom to adjust the model size. When the icon “” red arrow pointing is at the lock-out state, any direction zoom would perform the zoom to the model entity; When the icon “” is at the open state, it can perform the single direction zoom to the model.



Blue box is [model mirror image](#), click the mirror image button, three buttons would pop up and they represent the mirror images of three directions of Z, Y, X respectively.

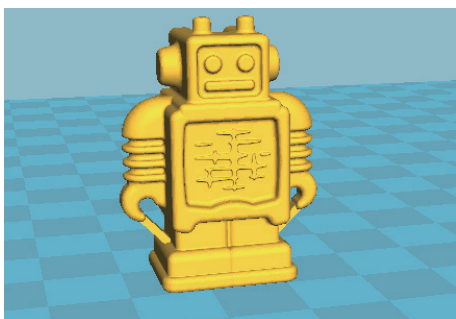


Green Box is [Check Mode Option](#)

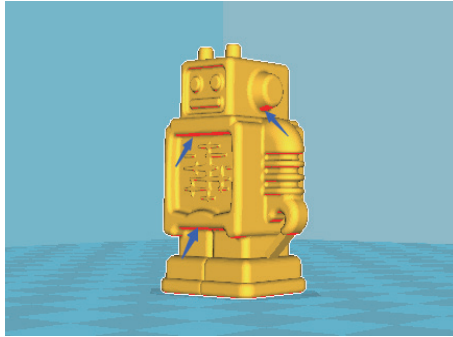


Click the button , five modes buttons, respectively:

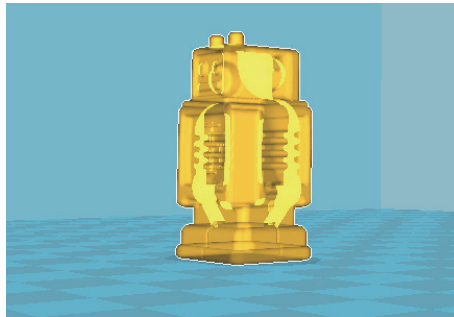
“Normal” is normal mode, show the model appearance only, which is default mode



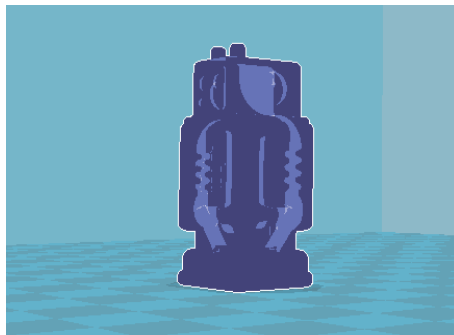
“Overhang” refers to overhang mode, and would indicate the overhang part of model, these part may hang down in the absence of support. The red area pointed by blue arrow is as shown in figure below.



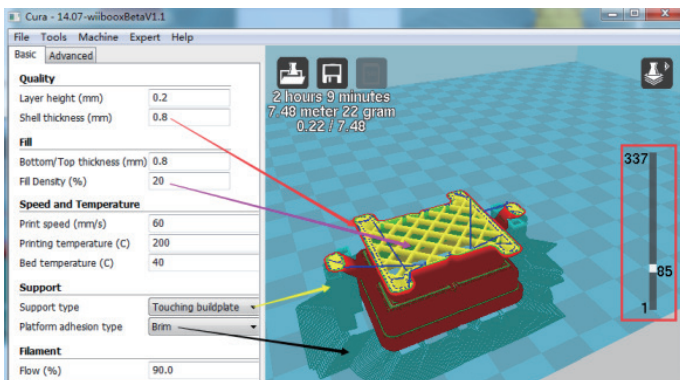
“Transparent” refers to transparent mode, and can watch the internal structure of model.



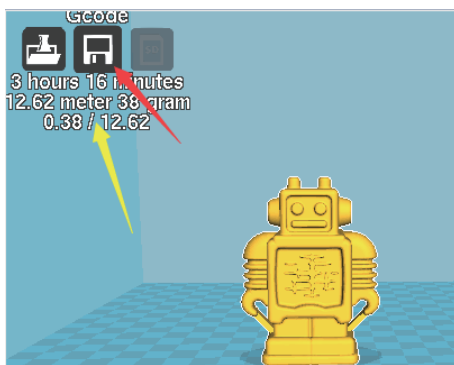
“X-Ray” refers to X ray mode, and is similar to the transparent mode, but ignore the surface.



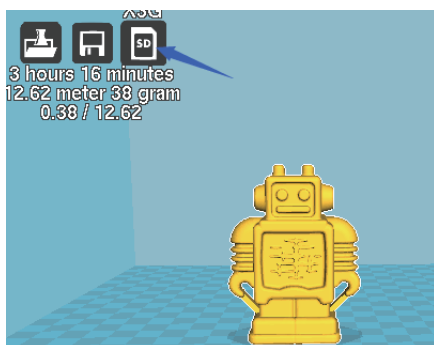
“Layers” refers to layered mode, and can watch the movement path of spray-head and support structure, as shown in figure below:




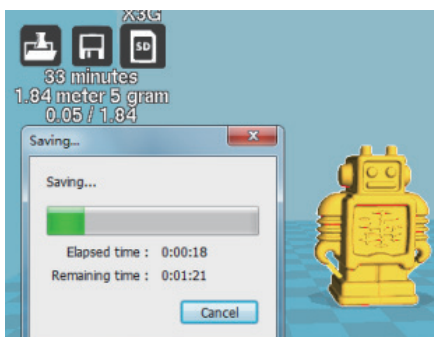
### 5.2.3. Generation of Gcode Code and X3G File



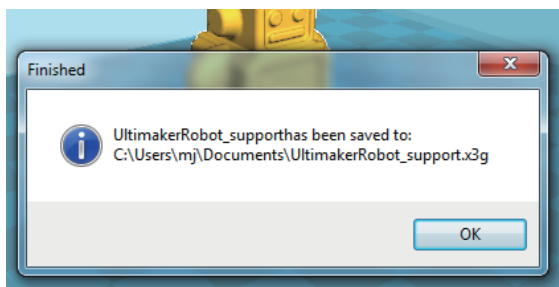
Yellow arrow refers to the data which is result of model conversion, including printing the time-consuming and filament use volume. If the cost of filament is set, it would display the model cost. At this moment, the button of save can be used, and click the button the red arrow points, to geneGcode code.



When the model generates code of Gcode, the icon blue arrow points  is changed from grey to white, and it indicates the button can be used, and clicks the button to generate X3G file.



When x3g file is generated, it would pop up the progress bar as shown in figure above.



After x3g file is completed with save, it would pop up the indication as shown in figure above, namely it is x3g file storage path.



## Operation Panel Setting

There is SD card slot at the right side of 3D printer, which can directly print the model file on the SD card and LCD and control key can perform the filament-replacement, debugging and other operation on the operation panel of machine.

## 6.1. Operation Panel Introduction



3D Printer's operation panel is composed of LCD display screen and five dimension buttons. In the case of unconnected with computer, it can perform each item of printing operation through operation panel.

Five dimension key is composed of five keys of Up, Down, Left, Right, and OK, the common functions of buttons are as follows:

Up button: In the menu operation, the cursor rolls upward; in the setting operation, it chooses parameter of last item.

Down button: In the menu operation, the cursor rolls downward; in the setting operation, it chooses the parameter of next item.

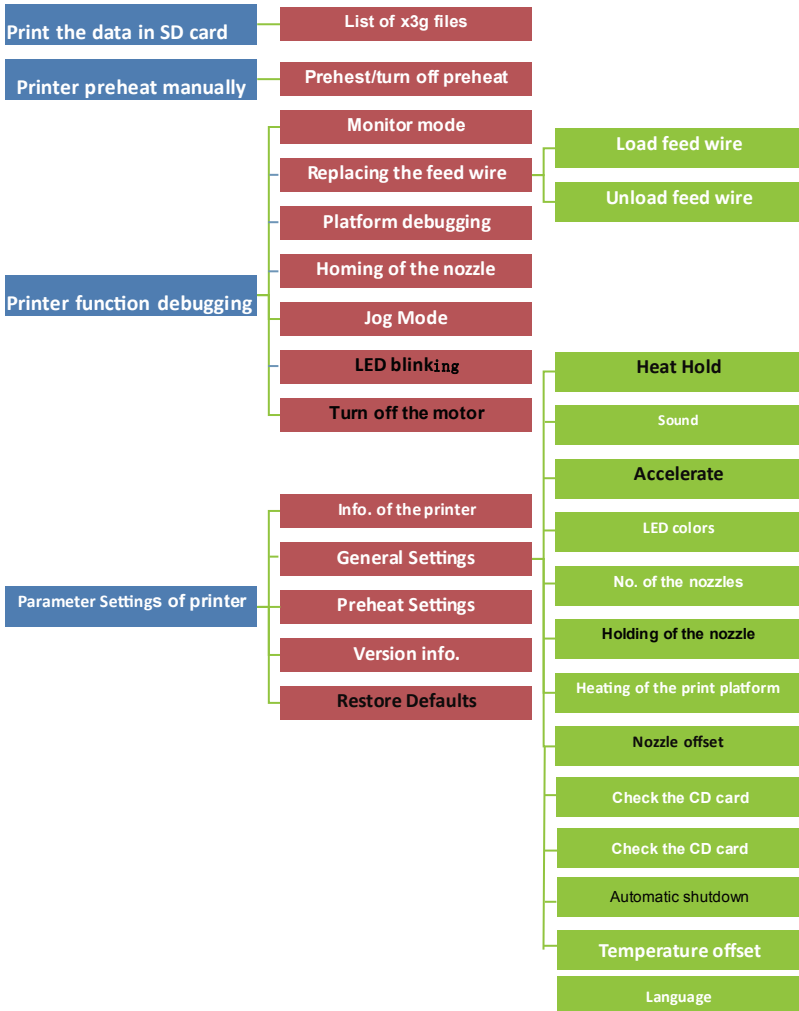
Left button: In the menu operation, return to last story of menu; in the jog mode, it switches the operation shaft.

Right button: In the jog mode, it switches the operation shaft.

OK button: In the menu operation, it enters next layer menu; in the setting operation, it enters and returns setting parameter; in the jog mode, it returns jog mode.

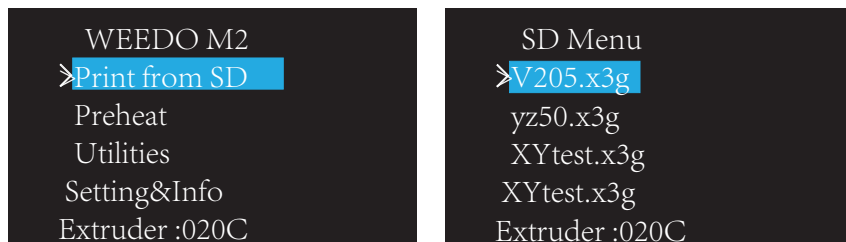
## 6.2. Operation Panel Menu

The menu tree of control panel is shown as figure below, the menu is divided for three layers (menu structure may be adjusted according to the firmware upgrade), the far left side is the start menu, right side is its sub-menu. When button OK is pressed, it can enter to the sub-menu of certain menu item. When left button is pressed, it returns to last layer menu. Black font menu item is the prohibited use item in the figure.



## 6.3. The Common Operation on the Operation Panel

### 6.3.1. Printing Files of the SD Card



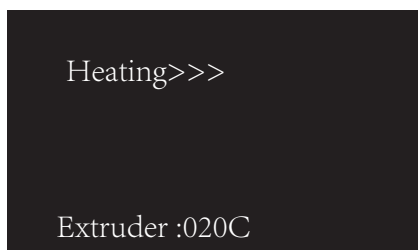
In the start menu, choose the first item of “Printing Files of SD Card”, enter to the SD Card file list. The list is displayed with x3g format file in the SD card root directory in the way of reverse chronological order. Use up and down buttons to choose the files needed to print, and then press button “OK” to start printing.

Please note, the file name can't be used with Chinese, file name length can't exceed 20 characters, and otherwise the machine can't identify or display messy code.

### 6.3.2. Printer Warm-up

In the start menu, choose the second item “Printer Manual Heating”, enter to printer warm-up interface. In this interface, there is spray-head warm-up item and platform warm-up item. Press the up and down buttons to move cursor to choose warm-up item, press button of OK to switch ON/OFF state, and then choose “Start Heating”, the platform temperature is firstly raised to the setting temperature by printer, and then the spray-head temperature is raised to the setting temperature. [The setting temperature of warm-up can be altered in the setting options](#)



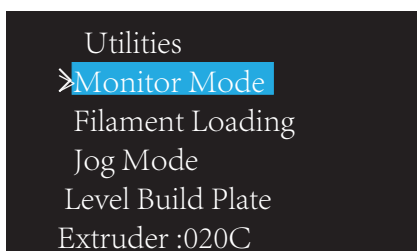


After printer starts heating, LCD would display the real temperature of spray-head and printing platform. At this moment, if it needs to perform other operation, it can press the left button to return start menu, and heating process will continue at the backstage. If it needs to end the printer warm-up, it can enter to warm-up menu and choose “Stop Heating” to stop heating.

### 6.3.3. Debugging of Printer Function

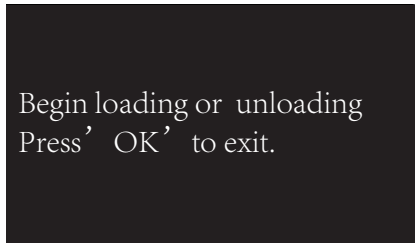
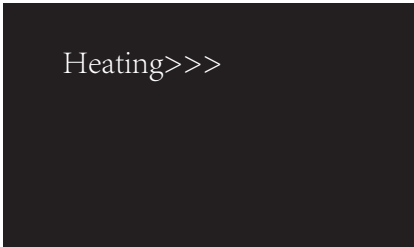
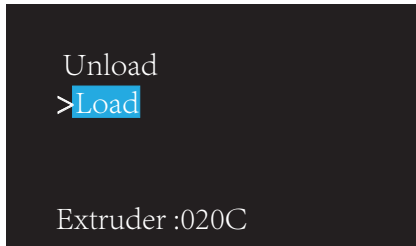
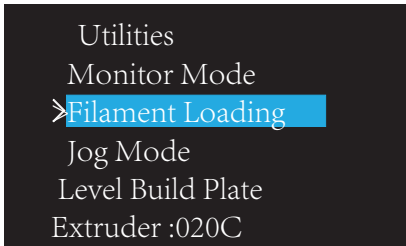
#### Printer Temperature

In the start menu, choose the third item “Printer Function Debugging”, enter to the secondary menu, choose the first item “Monitoring Mode”, and enter the real monitoring interface of printer temperature. Press the left button to return the last layer of menu.



#### Filament Replacement

In the start menu, choose the third item “Printer Function Debugging”, enter to the secondary menu, choose the second item “Filament Replacement”, and enter the manual filament replacement interface.

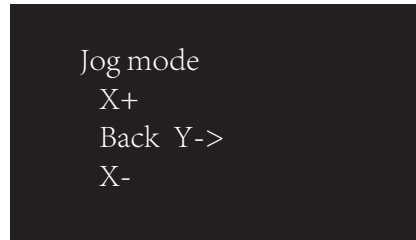
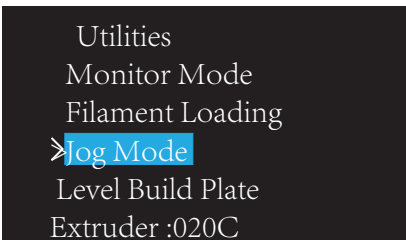


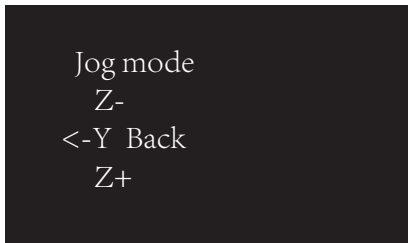
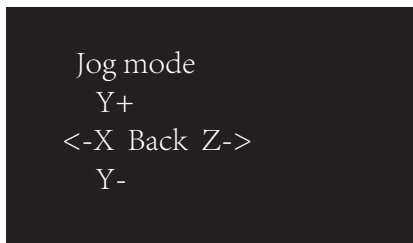
Choose “Nozzle Filament Return”, press button OK to enter to filament return program. Nozzle is heated to preset temperature, and then start nozzle motor to return filament back. If it needs to end filament return program, press down the left button and choose “Yes”.

Choose “Nozzle Filament Entry”, press button OK to enter to filament entry program. Nozzle is heated to preset temperature, and then start nozzle motor to enter the filament forward. If it needs to end filament entry program, press down the left button and choose “Yes”

### Printer Jog Debugging

In the start menu, choose the third item “Printer Function Debugging”, enter to the secondary menu, choose the third item “Jog Mode”, and enter printer jog debugging interface.



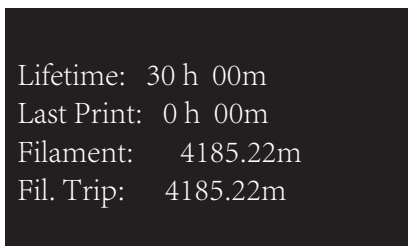
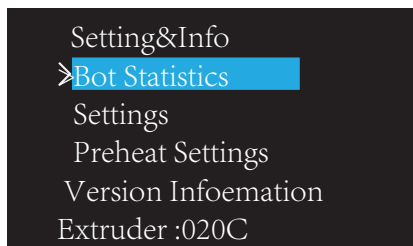


The jog debugging interface is divided for three screens, which are corresponding to shaft X, Y and Z, and are switched through left and right buttons. In each shaft debugging interface, pressing up and down buttons can control the two-ways operation of printer shaft motor. Press button OK can return last layer of menu.

### 6.3.4. Printer Parameter Information

#### View Accumulative Running Time

In the start menu, choose the forth item “Printer Parameter Information”, enter to the secondary menu, choose the first item “printer information”, and enter printer running time statistic interface. Here, it would display accumulative printing time, the last time printing time consuming, filament use length and others.



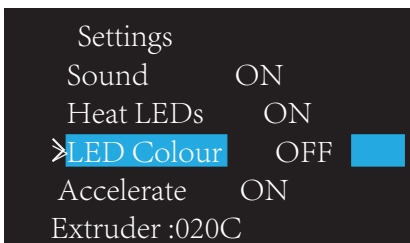
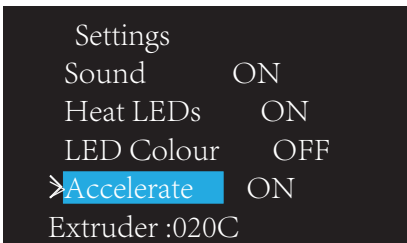
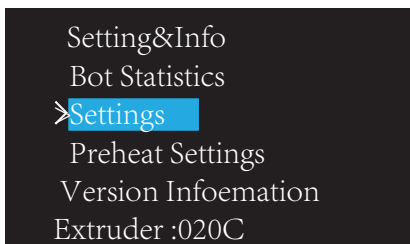
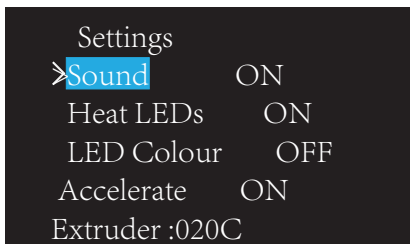
### Temperature Offset Setting

When the real printing temperature doesn't match with the setting temperature, it can adjust the printing temperature through "Temperature Offset". In the start menu, choose the forth item "Printer Parameter Information", enter to the secondary menu, choose the second item "General Settings", and enter the third level of menu, choose "Temperature Offset", press button OK to choose this item, press up and down buttons to modify the temperature offset value. The larger the value is, the lower the real printing temperature is; When value decreases, the real printing temperature rises. Return to the previous menu, please press button OK→Left button.



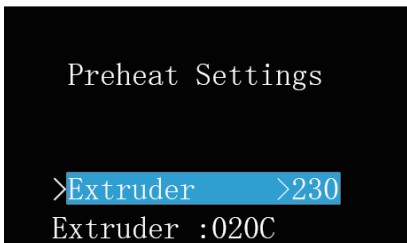
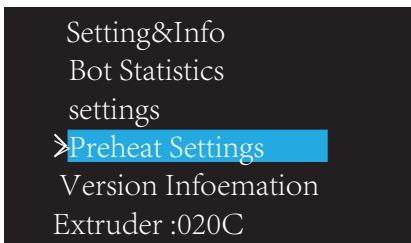
### Common Used Printing Parameter Settings

In the start menu, choose the forth item "Printer Parameter Information", enter to the secondary menu, choose the second item "General Settings", and enter the printer parameter setting interface. For the common used items such as "Voice", "LED Color", "Accelerate" and others, they are set with default On state; for baseboard heating, it is set with default Off state. If it appears such conditions as no voice, LED light bar can't be turn on, printing resistance becomes large, spray-head move slowly, nozzle doesn't reach the pre-set temperature and can't produce filament and print, and others, it should check whether the relevant parameter setting is at the normal state.



Preheating Temperature Settings

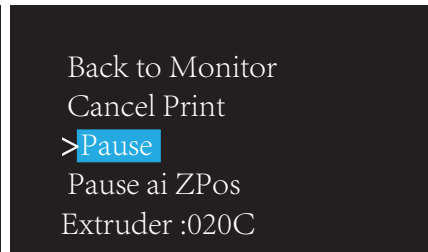
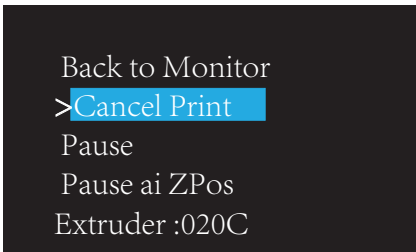
In the start menu, choose the forth item “Printer Parameter Information”, enter to the secondary menu, choose the third item “Preheating Settings”, and enter the preheating temperature setting interface, In this interface can set nozzle/platform preheating temperature. Press button OK to choose spray heat or platform, press up and down buttons to adjust the temperature. Return to the previous menu, please press button OK→Left button.



### 6.3.5. The Common Used Parameter Setting in Printing

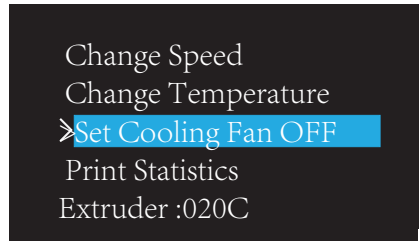
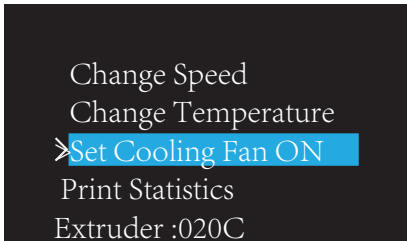
#### Cancel Printing/Pause Printing

Press the left button of operation board, it would pop up option menu, turn down, and choose “Cancel Printing” or “Pause”.



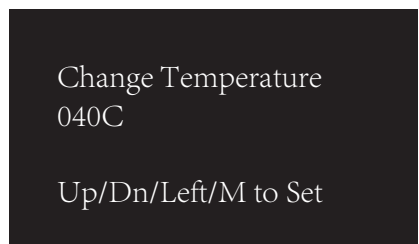
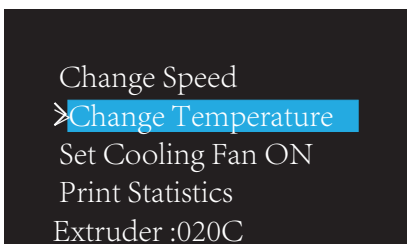
#### Start/Close Fan at Left Side of Nozzle

Press the left button of operation board, it would pop up option menu, turn down, and choose “Start Fan” or “Close Fan”.



#### Modification of Printing Nozzle Temperature

Press the left button of operation board, it would pop up option menu, turn down, and choose “Temperature Reset”, and enter to printing nozzle temperature reset interface, press up and down buttons to adjust temperature, press left button to return to the printing interface.



### Modification of Printing Speed

Press the left button of operation board, it would pop up option menu, turn down, and choose "Speed Reset", and enter to printing speed reset interface, press up and down buttons to adjust temperature, the over quick printing speed would damage the printer, please use caution to speed up function. Press left button to return to the printing interface.



### 6.3.6. The Forbidden Use Instructions

Before delivery, each 3D printer has already been performed with debugging and optimization, some instructions of 3D printer control panel would cover the running parameters optimized in the printer storage. Therefore users are not suggested to run the following instructions by its own. If equipment can't work normally as the following instructions are run carelessly, please contact our after-sales.

- Ditto print
- Hot Suspended
- Heat LEDS
- Accelerate
- Nozzle Maintaining
- Nozzle Offset



## Daily Repair and Maintenance

3D Printer needs to perform the regular maintenance, as well as some daily maintenance, in order to ensure the printer can maintain the high performance to run stably.

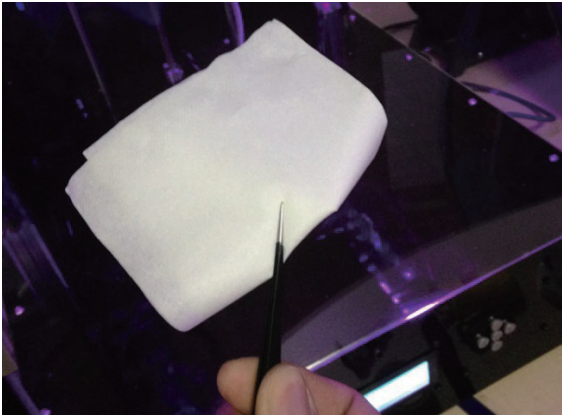
## 7.1. Printer Daily Maintenance Guide

The daily maintenance mainly contains: clean printer nozzle, replace the printer platform sticker and tape, printer platform regular check and leveling, replace air filtration core, optical shaft and screw rod maintenance and others.

### 7.1.1. Cleaning Printing Nozzle

In the process of 3D printing, the part of consumable debris and dust particles is likely to accumulate around the printing nozzle. As time goes on, these accumulative materials can lead to that printing precision becomes poor or nozzle is block and others. Therefore, before printing for each time, it needs to observe whether the nozzle is blocked and perform the cleaning.

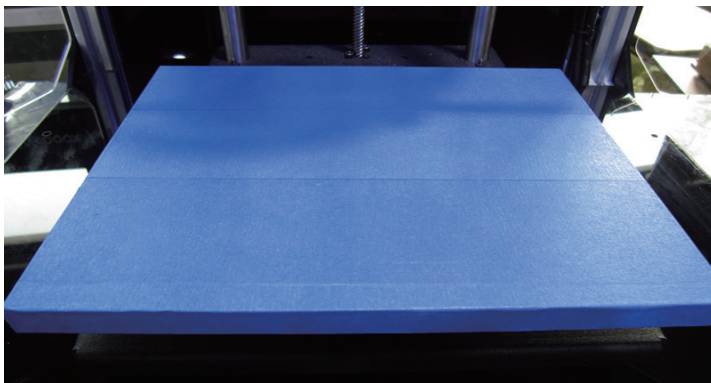
Maintenance method: The printing nozzle is usually cleaned by tweezers, and the impurities around nozzle are wiped out by the cleaning cloth.



### 7.1.2. Replacing Printer Platform 3M Sticker

Check whether the blue 3M sticker surface is worn and uneven on the printing platform, if sticker is worn, it must be replaced, and ensure model can firmly be pasted on the printing platform.

Maintenance method: firstly find out a roll of tape sticker presented in accompany printer on the accessories box.



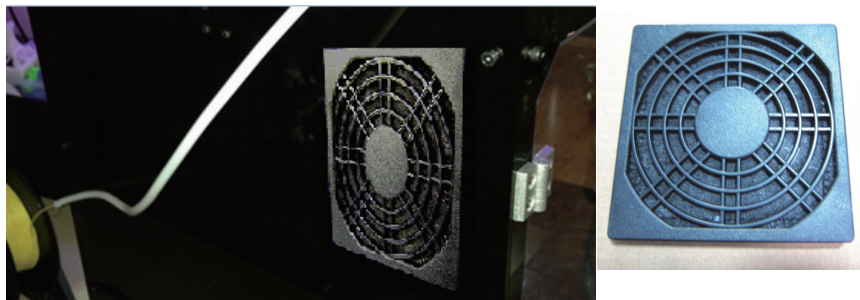
Tear out tape sticker on the printing platform from the bottom of left side, strip slowly, don't leave any residuals, and then paste the new stickers. Note that it doesn't leave gap between the stickers.

### 7.1.3. Replacing Air Filtration Core Components

The air filtration core components are suggested to be replaced after use 500 hours, otherwise it would lead to dust filtration effect greatly reduced.

Maintenance Method:

Firstly, use strength to take out the fan cover board entirely at the right side of printer, and then find out one filtration core component cover board from the list box in accompany with printer and install it directly.

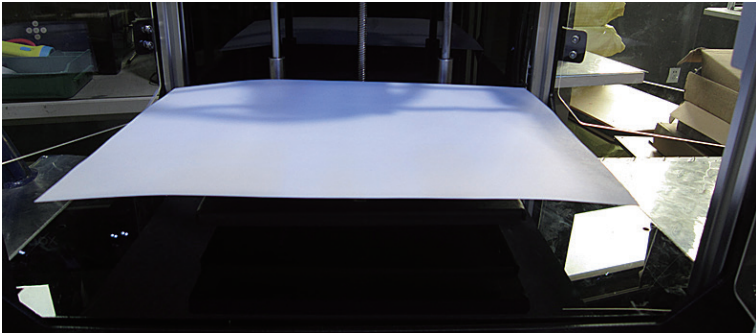


### 7.1.4. Printing Platform Regular Check and Leveling

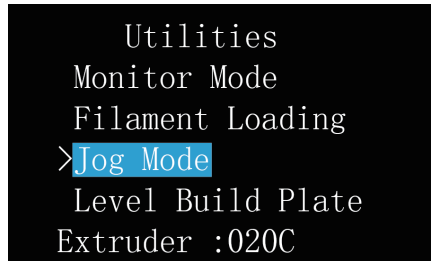
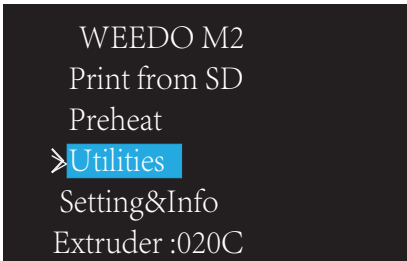
It is very important to perform the regular check and leveling on the printing platform, and the level of printing platform would play severe impact the model's molding.

Leveling Method:

Please place a piece of white A4 paper on the printing platform.



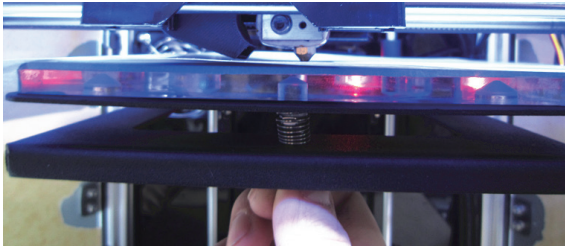
In operation panel, choose "Printer Function Debugging" to enter next menu, choose "Platform Leveling".



At this moment, printer would enter to the interface like below, meanwhile, printer nozzle moves to the fixed point, starts to adjust one nut at the front of bottom of platform, and adjust the gap between platforms and nozzle until the A4 paper can just slide between platform and nozzle. Well control the gap, neither too loose nor too tight. After well adjusted, press button "OK", to enter next step.

Homing axis X/Y

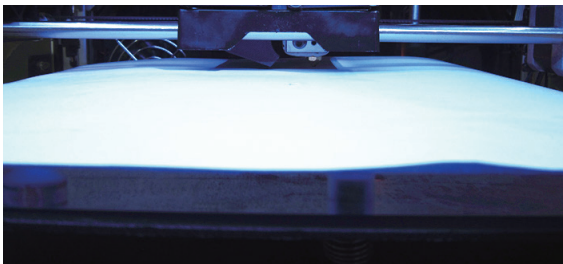
Adjust front one thumb  
nuts until nozzles touch,  
press OK



Skip step 2 and step 3, adjust the gap between printing platform and nozzle according to the step 4, step 5, step 6 and step 7 in turn.

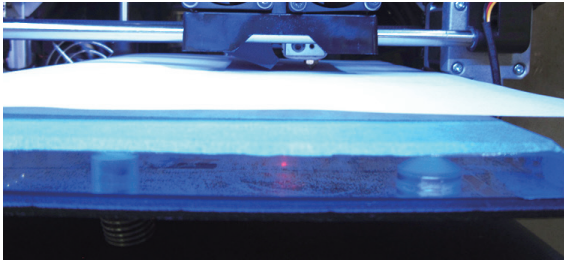
Adjust two nuts at the back of platform bottom part in synchronization; adjust the gap between platforms and nozzle, until A4 paper has slight frictional resistance in sliding. After well adjusted, press button "OK" to enter next step.

Adjust back two thumb  
nuts until nozzles touch,  
press OK



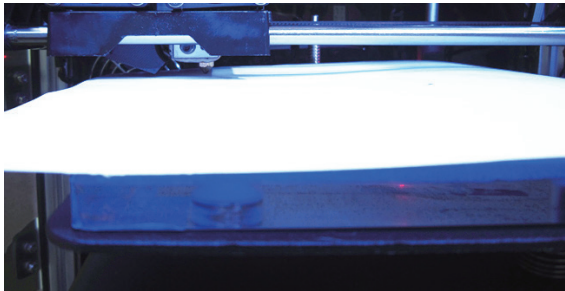
Adjust one nut at the right side of back of platform bottom n, adjust the gap between platforms and nozzle, until A4 paper has slight frictional resistance in sliding. After well adjusted, press button "OK" to enter next step.

Adjust right one thumb  
nuts until nozzles touch  
press OK



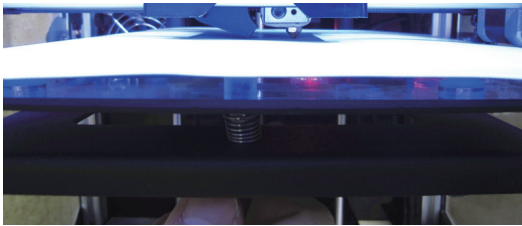
Adjust one nut at the left side of back of platform bottom n, adjust the gap between platforms and spray head, until A4 paper has slight frictional resistance in sliding. After well adjusted, press button "OK" to enter next step.

Adjust left one thumb  
nuts until nozzles touch,  
press OK



Adjust three nuts at the bottom of platform in synchronization, adjust the gap between platforms and spray head, until A4 paper has slight frictional resistance in sliding. After well adjusted, press button "OK" to enter next step.

Finished, Press OK



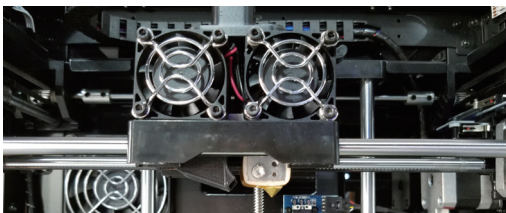
After adjustment is completed, if feel it is not appropriate to the gap between platform and nozzle, please re-calibrate each position.

Calibration Complete Press  
To Continue

### 7.1.5. Optical Shaft and Screw Rod Maintenance

In the process of using printer, the two directions of X and Y depends on the precise guide rail and shaft X screw rod to ensure stable and precise rectilinear motion. After add silicon grease lubrication, it can reduce the friction and lower the wear of mechanical moving parts, thus it must be performed with regular maintenance. It is suggested to perform once maintenance after use 1000 hours.

Maintenance method: take out the lubrication silicon grease from the accessories box in accompany with printer, and evenly paint them on the screw rod and optical shaft, and then start the equipment to make each shaft perform full trip for about several times and to make the silicon lubrication grease even distributed on the surface of each shaft.

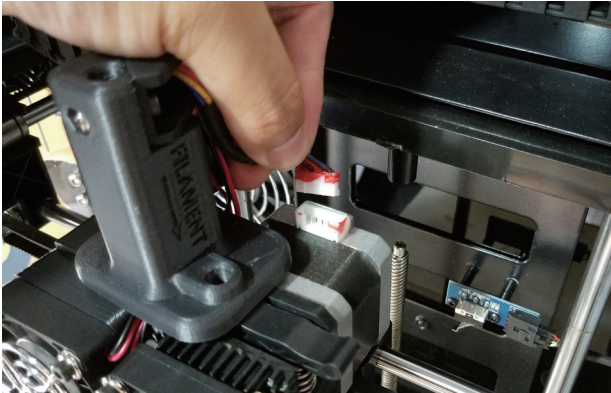


## 7.2. Printing Nozzle Maintenance and Replacement

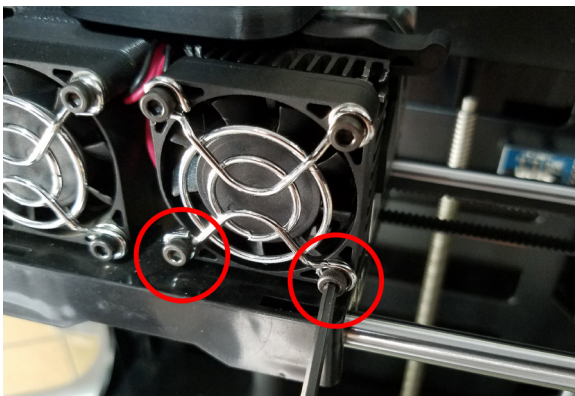
After printer has been used for a long time, as feed gear continues to convey and rub the filament, on the gear would be pasted with filament powder, which leads to gear becomes weak in holding power and affect the transmission effect. Regular disassembly and cleaning nozzle components can maintain the machine work smoothly. It is suggested that it should be performed with nozzle component cleaning after print 500 hours.

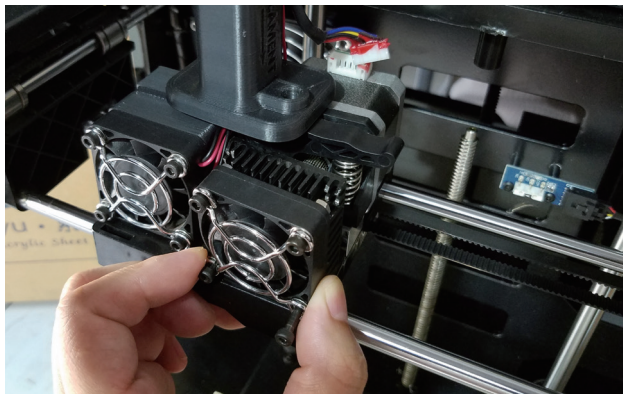
### 7.2.1. Cleaning Nozzle and Motor Gear

When the shutdown is ensure, open the door board of printer and pull out the plug of connecting line from the nozzle motor.

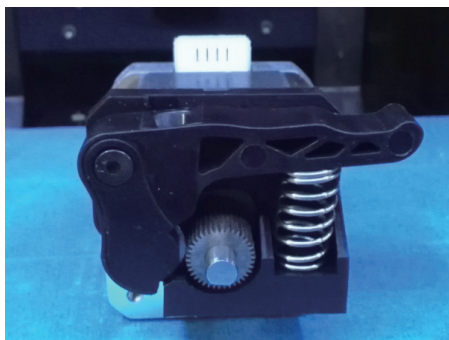


Completely unscrew the two hexagon socket head cap screw at right side, and take out fan and cooling fan.





Then, take out the whole motor and feed gear from right back side



The filament debris on the motor gear is performed with cleaning by tweezers, and installed is performed according reverse procedures after cleaning.  
Note: Finally plug in the motor connection line.

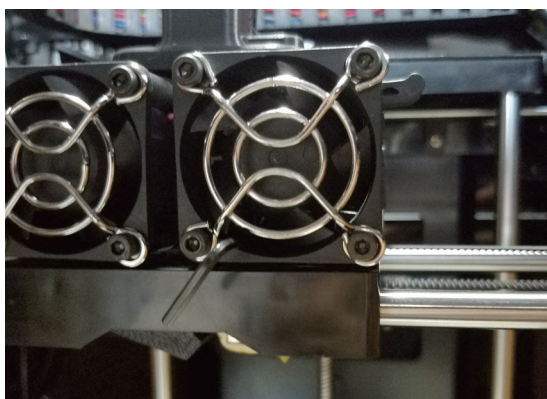
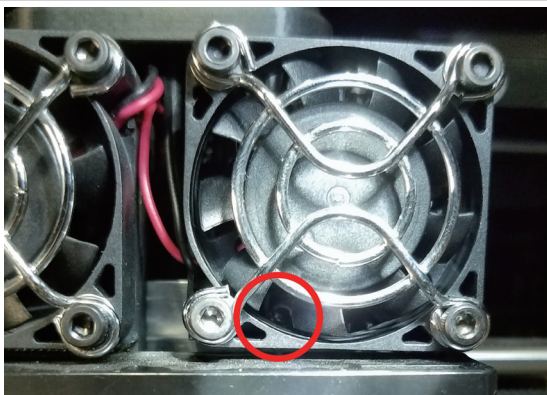
### 7.2.2. Replacing Printing Nozzle

When the operation is inappropriate or the filament materials is not selected properly, they would cause nozzle blockage. In the necessary cases, it needs to perform the nozzle replacement.

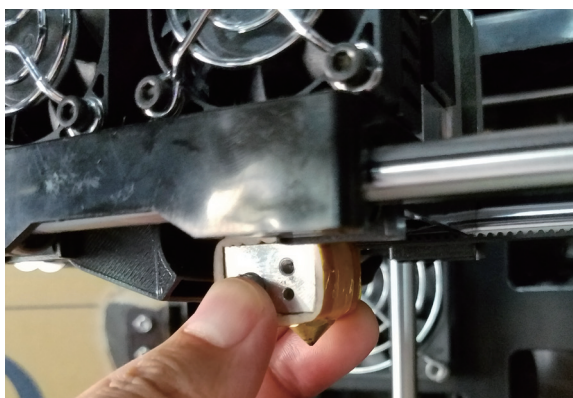
**Disassembly Procedure:**

The component of nozzle is fixed by a screw behind the fan.

Use 2.0mm hex wrench to loosen the screw, through the blade gap fan.



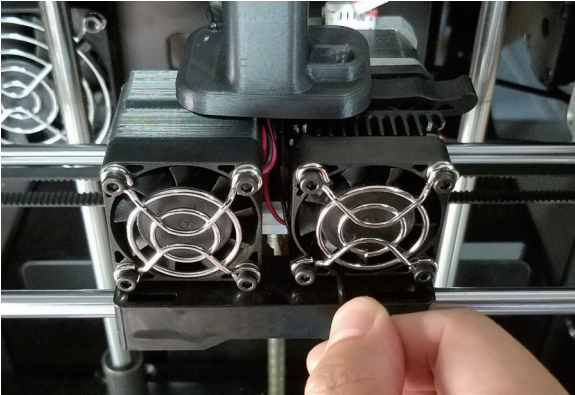
Take out the whole component of nozzle from the bottom and pull out the connecting line plug of nozzle.



The process of nozzle disassembly is over.

### The Installation Process of New Nozzle Components:

The throat pipe part of new nozzle is inserted into the aluminum block from the bottom, the top of throat pipe closely contacts with the bottom of motor gear ;and then screw down the screw of fixed throat pipe.



The whole process is over. After the nozzle is replaced, it can start printing model only after the printer platform is recalibrated.



# Frequently Asked Questions and Troubleshooting (FAQ)

**Q**

1.Should the filament replacement operation be run for operating the printer each time?

**A**

The filament replacement operation should not be run for startup of printer each time, but only be used in the filament replacement.

**Q**

2.After the model is completed with printing, can it be taken down the model by hand immediately?

**A**

Please do not get model by hand immediately, please wait the model cooling for a moment, and gently shovel away the model by scraper; be attention not to shovel the blue 3M sticker on the printing platform to bad.

**Q**

3.Power indicator light is bad, how do we do?

**A**

Please check whether the front side and back side of power switch have already been opened, and whether the power cord is well connected.

**Q**

4.The printed model bottom is unstable for pasted, or model is moved, how do we deal?

**A**

Please check whether it is correct for temperature set for printing platform, and whether the printing platform has already reached the setting temperature.

If the printing platform temperature is correct, please check whether the printing platform (printing platform) is flat, adjust the printing platform.

**Q**

5.The printing nozzle is blocked or can't come out flagellation, how do we deal?

**A**

Please check whether the filament consumables is used up on the feeding rack,

1) The filament materials are used up, which shows the filament material is left in the printer nozzle. Please disassemble the fan above the printing nozzle, and take off the printing nozzle and then heat the printer nozzle to 230°C, use plier to pull out the filament section carefully. Shut down the printer and re-install it after the printing nozzle cools down.

2) The filament materials are used up, which shows the printing nozzle is blocked. Please disassemble the fan on the top of printing nozzle, and check whether the feed gear is twined with filaments. If there is twined filament, it cuts off the filament at the top of aluminum block and removes the printing nozzle, and then heat the printing nozzle to 230°C, Use plier to pull out the filament section, and take away the extruder, clean the filament and debris in the feed gear, shut down the printer, and install the extruder and printer nozzle; if there is no twined filament, please heat the printer nozzle to 230°C, press down the handles of extruders, manually input the wire, slightly use strength to push the wire down, push out the filaments left in the printing nozzle, and then return the wire manually, repeat several times, until the printing nozzle is completely cleaned.



Please be carefully to dredge the printing nozzle, in order to avoid scalding.



If the printing nozzle can't be dredged, please contact our company for replacement of printing nozzle. The printing nozzle is replaced; it can start to work until the printing platform is needed to adjust to flat once again.



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