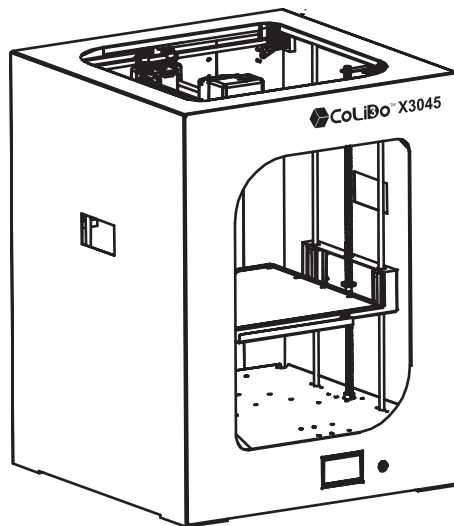


 **CoLiBo™ X3045**



Industrial 3D Printer

USER MANUAL



* Carefully and thoroughly read this manual before using



| | |
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This User Manual is designed to start your journey with CoLiDo X3045 3D Printer in the right direction.

In Chapter 1~5, you can learn the basics knowledge of CoLiDo X3045 3D Printer, how to unbox safely, how to assemble correctly.

In Chapter 6~9, you can learn how to calibrate the platform, printing, maintenance and troubleshooting.

PRINT-RITE welcome you to the world of CoLiDo X3045 3D Printer.

Following this manual will help you fully understand the Printer and make amazing products.

In this manual, Safety Alert Symbol will be marked in the start of safety message. The Safety Alert Symbol means potential safety hazards which will possibly harm you or others and cause product or property loss.

Safety Alert Symbol



WARNING: HOT SURFACE, DO NOT TOUCH

Desktop 3D Printer has high temperature when working. Make sure the Desktop 3D Printer cool down before touching inside.



WARNING: HAZARDOUS MOVING PARTS, KEEP FINGERS AND OTHER BODY PARTS AWAY

The moving parts of Desktop 3D Printer will possibly cause harm. Do not touch the Desktop 3D Printer inside when the printer is working.



WARNING: Make sure stand by CoLiDo Desktop 3D Printer when it working.



CAUTION: Be careful when using PRINT-RITE unapproved material, which may damage Printer and impact print quality.



CAUTION: Disconnect power plug from power socket during emergency.



CAUTION: Power socket must be located near the Printer and within reach.



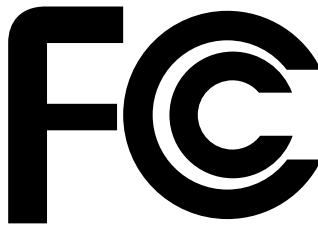
CAUTION: Place CoLiDo Desktop 3D Printer in well-ventilated area as it will melt plastic and emit plastic odor when printing.

Interference of Radio and Electromagnetism

The Printer has been tested and certified to comply with the restriction of FCC Part 15, which is related to Class B digital facility.

The restriction is designed to provide reasonable protection against harmful interference in residential area when install the Printer. The Printer will generate, apply and radiate Radio Frequency Energy. If the Printer is not installed and used in accordance with the manual, it may cause harmful interference to radio communications. However, there is no warranty to the interference if the Printer is installed in a special environment. If the Printer does cause harmful interference to the receiver of radio or television, which can be determined by turning on and turning off the Printer, the user is suggested to adopt below one or more methods to eliminate the interference:

1. Change the orientation and location of the receiving antenna.
2. Increase the distance between the Printer and the receiving device.
3. Connect the Printer and the receiving device separately with two power sockets in different power supply circuit.
4. Get help from the dealer of the Printer or an experienced radio/TV technician.



Printing

Print Technology: Fused Deposition
Modeling
Construction Dimension: 300*300*450mm
Layer Resolution Setting: 0.1~0.4mm
Positional Accuracy: XY: 0.011mm
Z: 0.0025mm
Filament: PLA/ABS
Filament Diameter: 1.75mm
Nozzle Diameter: 0.4mm

Mechanical

Frame: Steel
Platform: Coated Glass
XYZ Bearing: Steel
Stepper Motors:
1.8° step angle,
1/16 micro-stepping

Electrical

Storage Temperature: 0 °C ~ 32 °C [32 °F~ 90 °F]
Operating Temperature: 15 °C ~ 32 °C [60 °F~ 90 °F]
Power: 300W
Input Voltage: 110~240V 50/60HZ

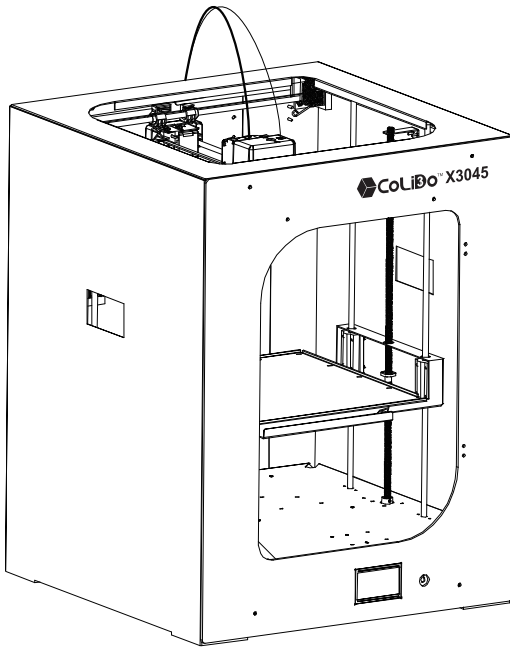
Dimension

Printer Size: 530*530*690MM
Package Size: 650*650*790MM
Net Weight: 35KG
Gross Weight: 40KG

Software

Software package: REPETIER-HOST
File Type: .STL, .GCODE
Operating System: WINDOWS 7, MAC OS, LINUX
Connection: USB, SD Card

CoLiDo X3045 3D Printer makes solid, three-dimensional objects by melting PRINT-RITE PLA/ABS filament. The designed 3D files are converted into CoLiDo command and sent to the Printer via SD Card or computer software “Repetier-Host” . Then, the printer head will heat up and melt the PRINT-RITE PLA/ABS filament and push it out from the nozzle to make a solid object layer by layer. This method is called Fused Deposition Modeling or FDM.



Take more time to unpack carefully and set up by following the user manual.

5.1 Unpack CoLiDo Printer



NOTE: Please use the printer in the room with normal temperature.



CAUTION: Carefully unpack and setup CoLiDo Printer.

- 1 Place printer package box on a dry and flat surface when opening.
- 2 Take out all accessories inside the Printer box.
Please refer to the Accessory Checklist at next page.

NOTE: In case there are any missing accessory, kindly email the Printer serial number, name and qty of missed accessory to 3Dsupport@utec.com.mo

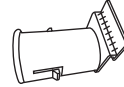
5.2 Accessory Checklist



PLA Filament 1PC (1kg)



Spool Holder 1PC



SD Card 1PC



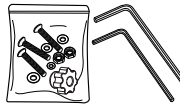
Power Cable 1PC



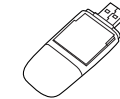
USB Cable 1PC



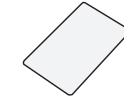
Tools 1 Set



SD Card Reader 1PC



Test Sheet 1PC



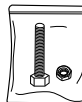
PLA Glass Platform 1PC



ABS Glass Platform 1PC



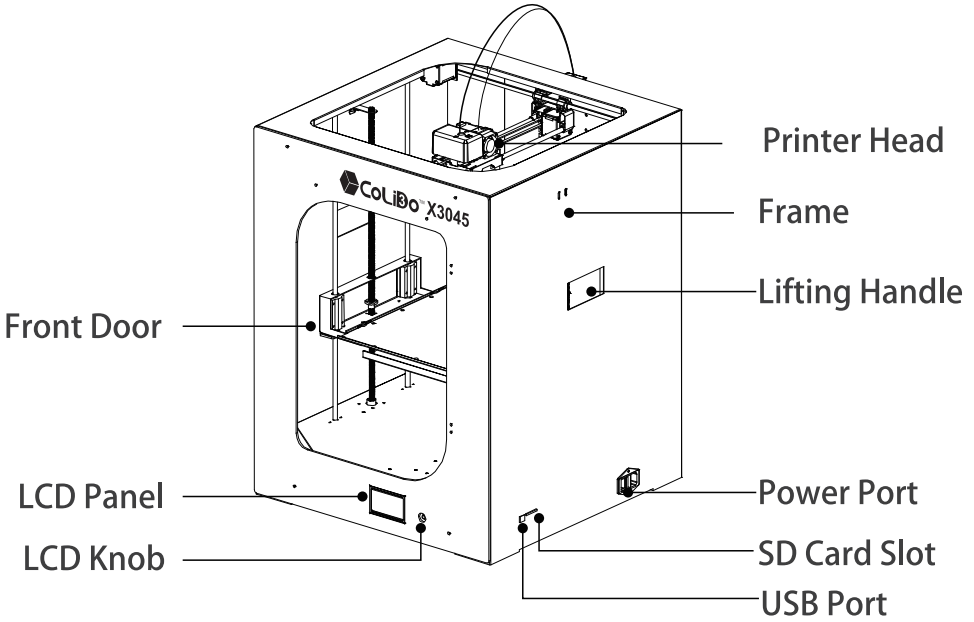
3D printed samples 1 Set



Nozzle Unit 1 Set (Spare Part)



5.3 CoLiDo X3045 3D Printer Structure Illustration



5.4 Take out CoLiDo Printer from packaging box



- 1 Carefully lift up the printer when taking it out of the box. Place the Printer on flat ground and carefully remove the package foam and bag of the Printer.



NOTE: Do not pull or twist the cable at any time.



NOTE: The printer is heavy, please take out the printer carefully.

- 2 CoLiDo Printer is unpacked. Please keep the packageing material in good shape. It will be re-used in the future to avoid unnecessary damage during transportation.

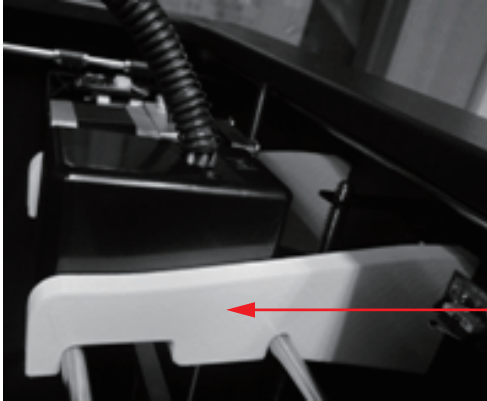


NOTE: Please keep the packaging box and packaging foam in good shape, it must be packed with original package when return the printer for maintenance or repair to avoid unnecessary damage during transportation.

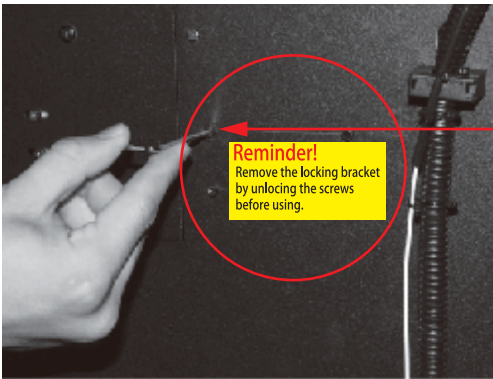
5.5 Unlock Printer Head and Heat Table



- 1 Remove the two locking brackets by unlocking the screws to release the printer head. (Use the Allen Key in the Accessory)



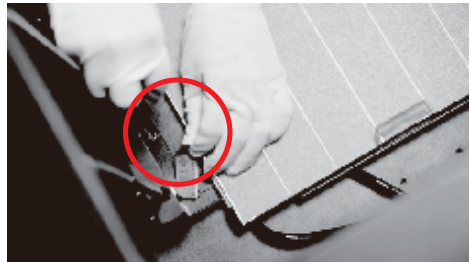
Locking bracket



Screws

Reminder!
Remove the locking bracket
by unlocing the screws
before using.

- 2 Remove 2pcs locking screws to release the Heat Table.



Remove the locking screw

5.6 Install Glass Platform

5.6.1 Power ON the printer

Connect the Power Cable to the Printer.



NOTE: Make sure printer switch is at “O” position.

- 1 Plug-in the power cable to AC power source.

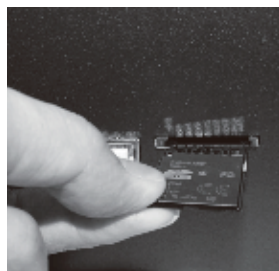
NOTE: The socket-outlet should be installed near the printer and should be accessible.



- 2 Properly insert the SD Card in SD Card slot. (SD card stores .gco files to print directly)



NOTE: Before inserting or removing SD Card, please turning off the printer to avoid damaging the SD Card.



- 3 Power on the printer by switching to “I” position as shown.

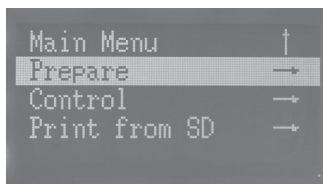
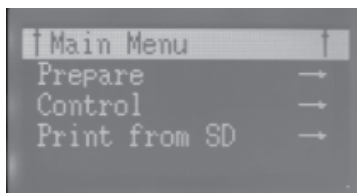


CAUTION: Only use the Power Cable included in the package. Power Supply Socket should be near to the Printer , such the power can be disconnected easily in case of emergency.

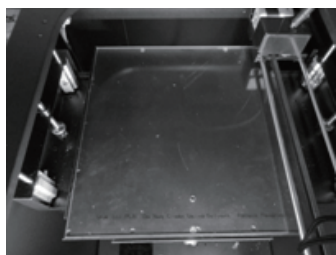
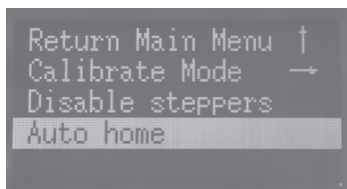
5.6 Install Glass Platform

5.6.2 Unpack Glass Platform

5.6.2.1 Push the knob to go to main menu, rotate the knob to select "Prepare"

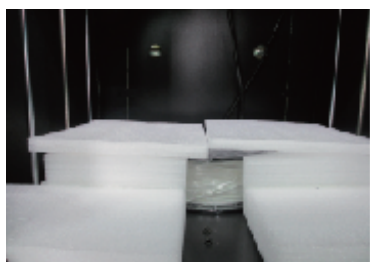


5.6.2.2 Push the knob to go to submenu, rotate the knob to select "Auto Home" and push the knob to confirm. Then, the heat table will be moved up to HOME position.



Please do not rotate the left/right Z screw rod to avoid the heat table unbalance.

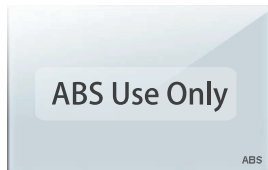
5.6.2.3 Remove the foam, get the glass platform package and the filament package under the heat table.



5.6 Install Glass Platform

5.6.3 Install Glass Platform

- 1 Get the two glass platforms from the package.
Select Glass Platform according to the selected filament material that will be used. The two platforms are coated Glass Platform which mark "PLA" or "ABS" to distinguish.

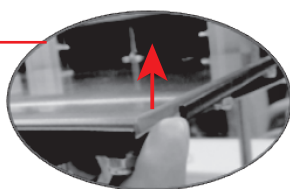
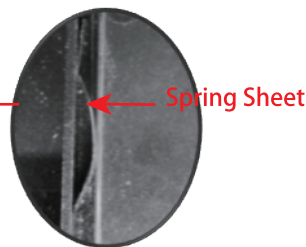
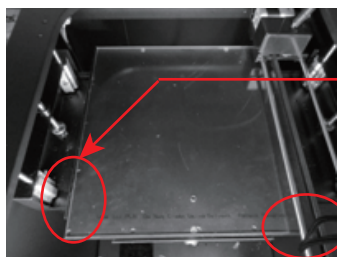


Glass Platform Orientation:
- Matted surface of Glass Platform must be on top when installing (The printed words must be facing top).

NOTE: Coated Glass Platform

1. Do not change the platform heating temperature setting to avoid the printed object not sticking on the platform. (PLA platform: 65~70°C, ABS platform: 100~110°C)
2. Clean the glass platform using lint-free cloth or wet tissue. Do not use alcohol or any cleaning chemical solution in cleaning the glass platform, it will damage the glass coating.
3. Please wait for the platform temperature to cooldown (25~30°C) before removing the printed object. Quickly removing the printed object will cause damage on the printed object and/or glass coating.

- 2 Install the Glass Platform to the Heat Table of the Printer and locked by the spring sheets in the Heat Table.



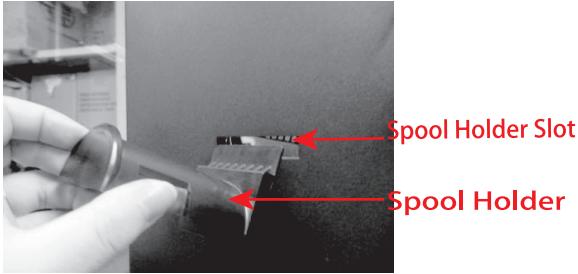
To uninstall the Glass Platform,
pull the right lower corner.

5.7 Install Filament

5.7.1 Take off the filament from packaging.

5.7.2 Insert Spool Holder into the Spool Holder Slot located at the back of the printer and push down to lock as shown below.

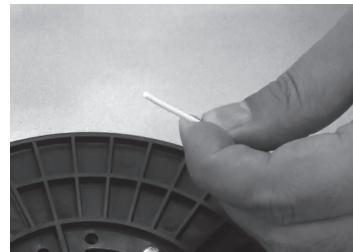
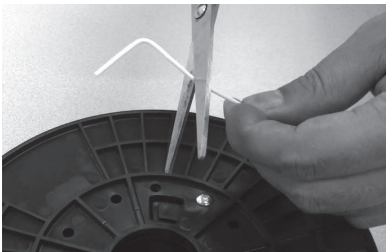
(Back view of the Printer)



5.7.3 Mount the filament spool on the Spool Holder and ensure that the filament can rotate counterclockwise direction freely.

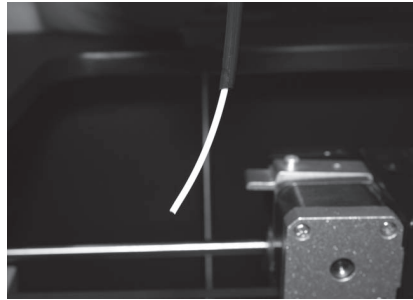
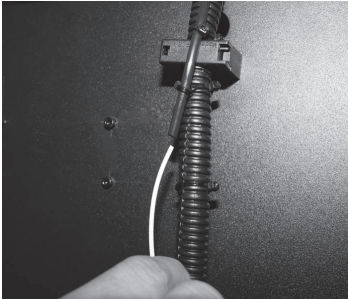


5.7.4 Pull PRINT-RITE Filament from the filament spool. Cut the filament tip using scissor (making flat as below picture) for easy installation.

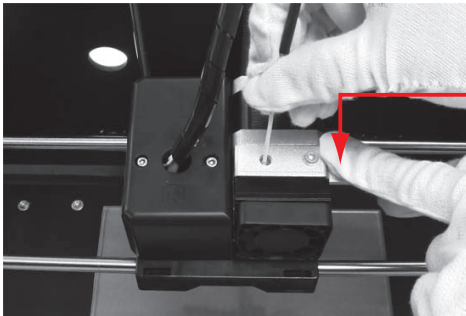


5.7 Install Filament

5.7.5 Insert the filament into the tube (see below picture) until it comes out from the other end of the tube.



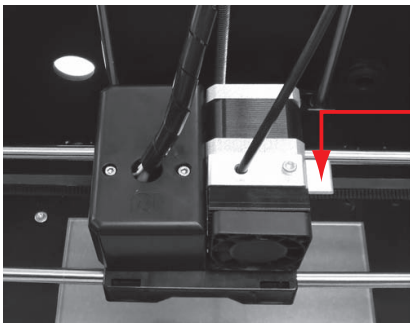
5.7.6 Push down the Printer Head arm. Insert the filament into the hole located on the top of Printer Head, push the filament until the tip of the filament is inserted into the nozzle receiving port.



Printer Hard arm

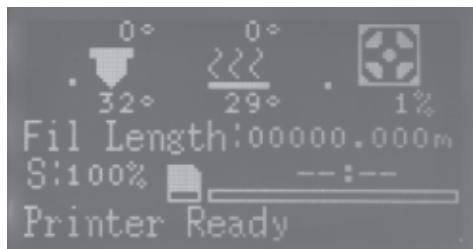
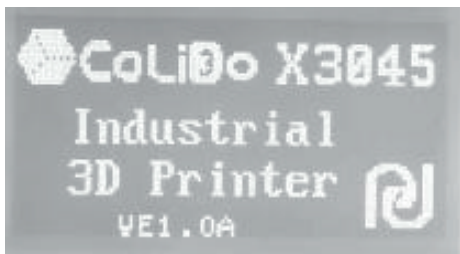


5.7.7 Release the Printer Head arm.



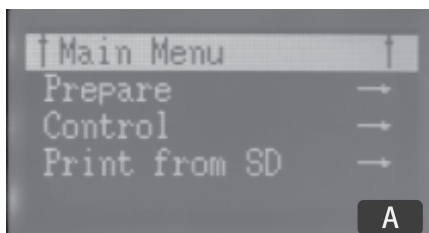
Printer Hard arm

Initial display of LCD Panel

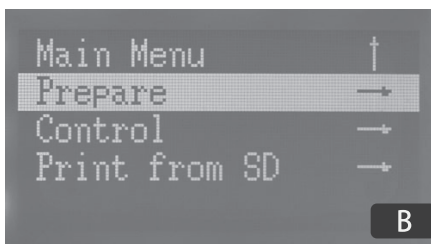


6.1 Main Menu

6.1.1 Push the knob to go to main menu and you can see four submenus (picture A).

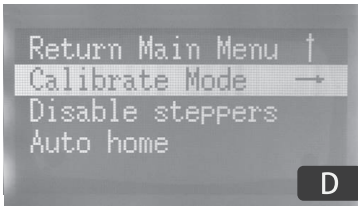


6.1.2 Rotate the knob and select "Prepare" (picture B), then push the knob to go to "Prepare" submenu. (picture C)



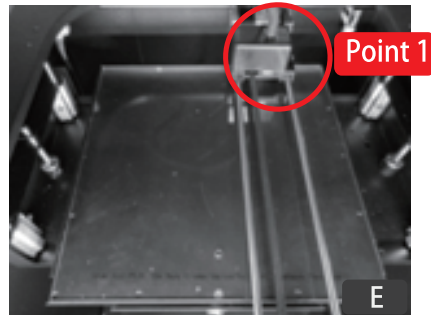
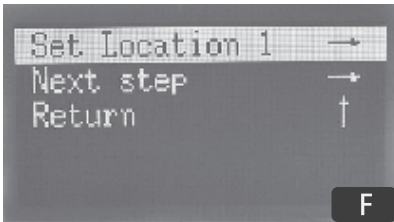
6.2 Calibrate Mode

6.2.1 Rotate the LCD knob and select “Calibrate Mode” (picture D), then push the LCD knob to start the calibration .



NOTE: “Calibrate Mode” is to guide user to operate the printer and to check the printer work well.

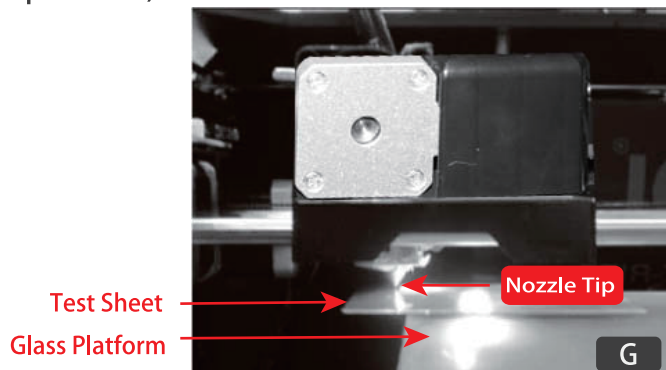
6.2.2 The platform will move up and the printer head will go to the 1st location Point 1 (picture E) and the LCD Display screen will show as picture F.



printer top view

6.2.3 Start to calibrate the table and nozzle.

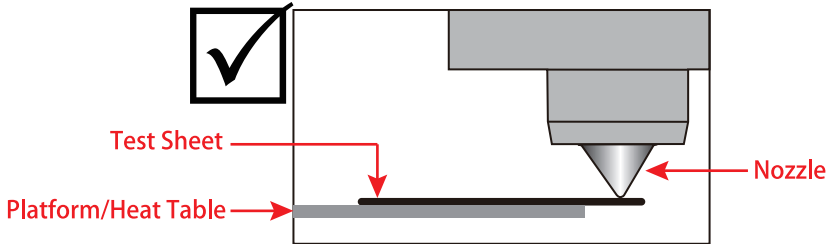
6.2.3.1 Use the test sheet to check the gap between the nozzle tip and the platform. (see picture G)



6.2 Calibrate Mode

6.2.3.2 Calibration Standard Condition:

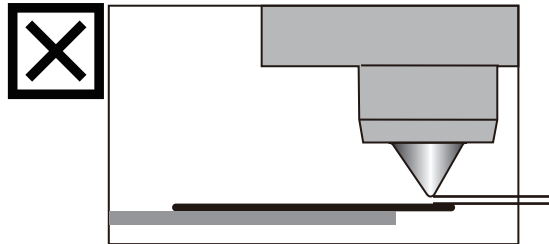
The test sheet must be lay down flat in the platform,
and the test sheet must be touching the nozzle tip.



Note: If the calibration standard condition is not met, platform level must be adjusted.

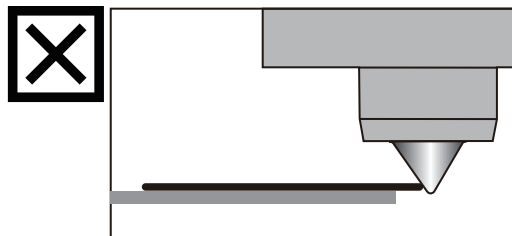
Condition 1: There is a gap between the nozzle tip and the test sheet.

Adjustment 1: Rotate the butterfly nut under the platform counterclockwise until the test sheet just touch the nozzle tip as standard condition.



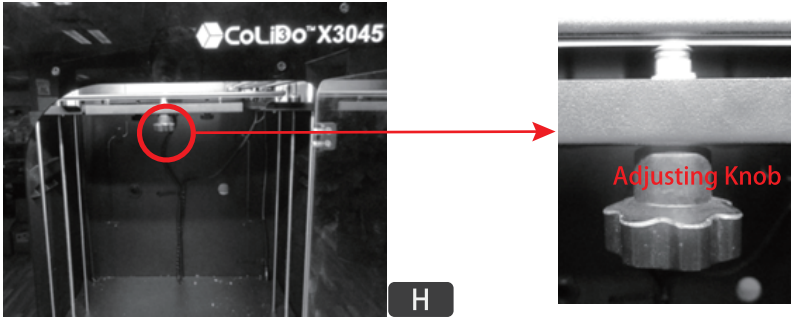
Condition 2: The test sheet is over the nozzle tip.

Adjustment 2: Rotate the butterfly nut under the platform clockwise until the test sheet can just touch the nozzle tip as standard condition.

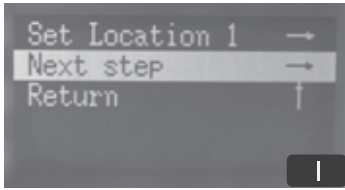


6.2 Calibrate Mode

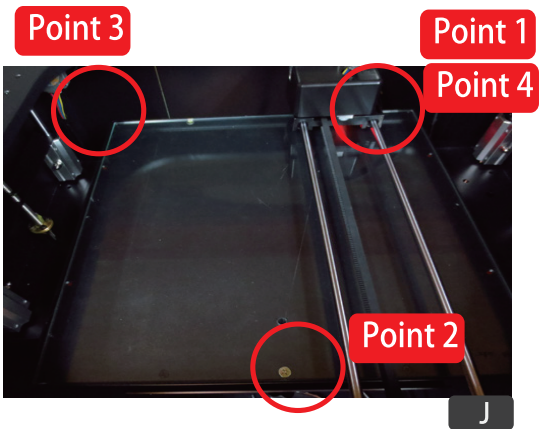
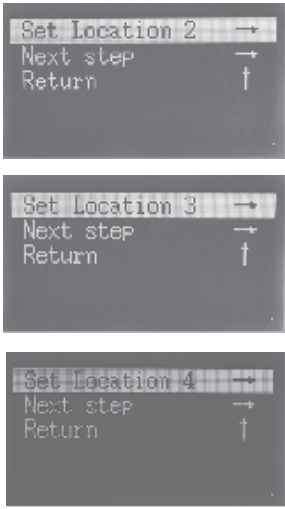
The adjusting knob location as picture H (total 3PCS).



6.2.4 After rotate the adjusting knob to meet the Calibration Standard Condition, rotate the LCD knob to select “Next Step” as picture J, then press the LCD knob to next point to calibrate.

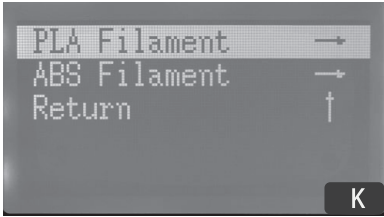


6.2.5. Follow 6.2.3 procedure to calibrate point 2,3 and 4 as picture J (Point1 is same to Point4).

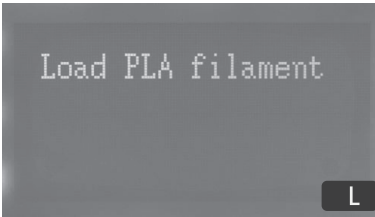


6.3 Nozzle & Filament Test

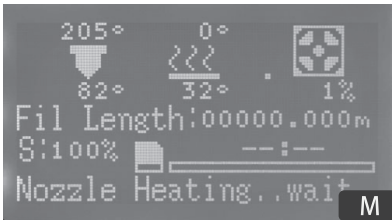
6.3.1 After calibration, the screen will show Picture K, push the LCD knob to select the filament you are using.



6.3.2 The screen will show Picture L, make sure the filament is inserted into the printer head correctly.

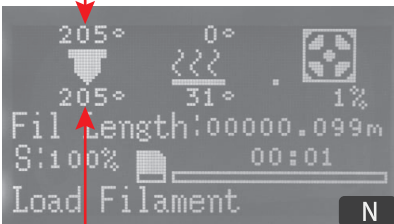


6.3.3 The nozzle will start to heat up as picture M. Once the nozzle actual temperature reach the setting temperature as picture N, the filament will auto load into the nozzle and flow out from the nozzle.



NOTE: the setting temperature for PLA and ABS is different as below. Incorrect temperature setting will result to printer damage.

Nozzle Setting Temperature



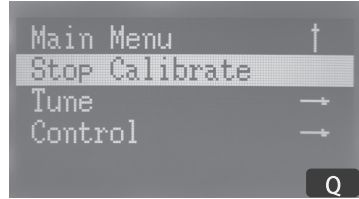
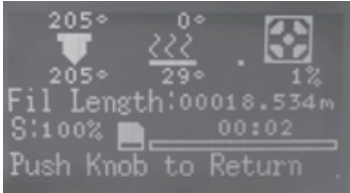
| Filament | Nozzle Setting Temperature |
|----------|----------------------------|
| PLA | 205°C |
| ABS | 220°C |

Nozzle Actual Temperature

6.3 Nozzle & Filament Test

6.3.3 Check the melted filament flow condition base on below instruction.

- If good condition as picture O, the printer will go ahead to test printing.
- If no good condition as picture P, push the LCD knob to show screen as picture Q and select "Stop Calibrate" to return to main menu.



Good condition:

The melted filament flow out smoothly and continuously from the nozzle.



No Good condition:

The melted filament do not flow out smoothly and continuously from the nozzle.



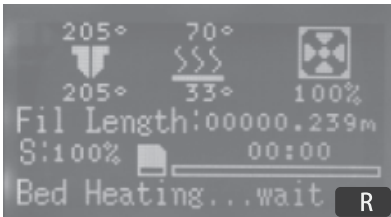
Note: If the filament flowing is in No Good condition, check the following.

- Nozzle Temperature - must be the equal to the set temperature and according to the filament material melting temperature.
- Nozzle Cleanliness - No Clogging by refer to troubleshoot clogged nozzle label on the side of the printer.
- Filament Insertion on the receiving port correctly.

If problem still occur kindly email
3Dsupport@utec.com.mo

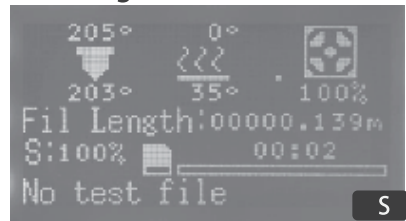
6.4 Print test with SD Card

6.4.1 After nozzle and filament inspection, the screen will show as below picture R. The printer will start to heat up the platform a few minutes.

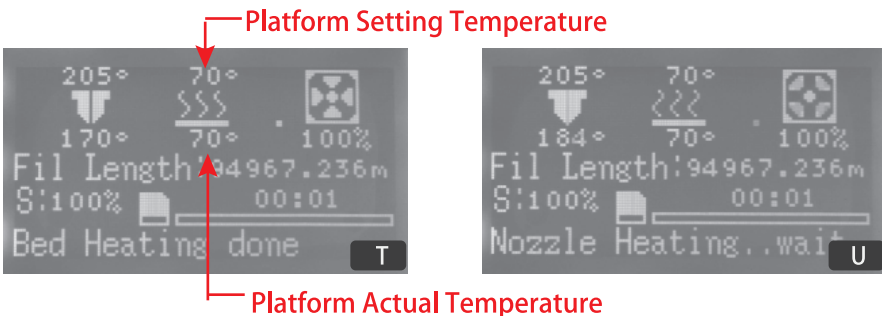


NOTE: If screen shows no test file such as picture S, means that the test file cannot be found in SD card. Check the following.

1. Check if the SD Card is inserted into the SD card slot well.
2. Check if the test file is saved in the SD Card. The test file name will be updated based on the shipped printer, (For example: PXT2.gco for PLA filament and AXT2.gco for ABS filament)



6.4.2 Once the platform temperature reaches the setting temperature as picture T, the nozzle will heat up next as picture U.



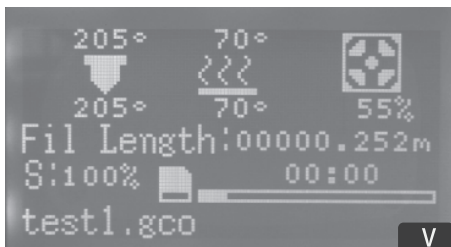
NOTE:

The platform setting temperature for PLA and ABS is different. Incorrect temperature setting will result in the object sticking on the platform.

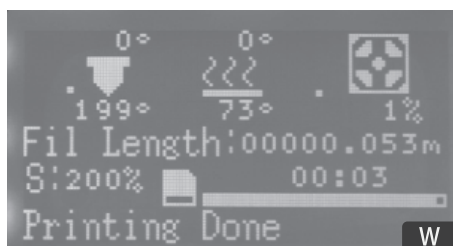
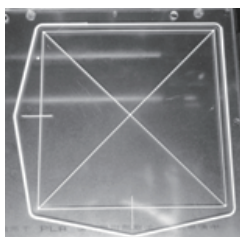
| Filament | Nozzle Setting | Platform Setting Temperature |
|----------|----------------|------------------------------|
| PLA | 205°C | 65~70°C |
| ABS | 220°C | 100~110°C |

6.4 Print test with SD Card

6.4.3 Once the nozzle temperature reach the setting temperatuer (Picture V), the heating is done and the printer start to print the test file.

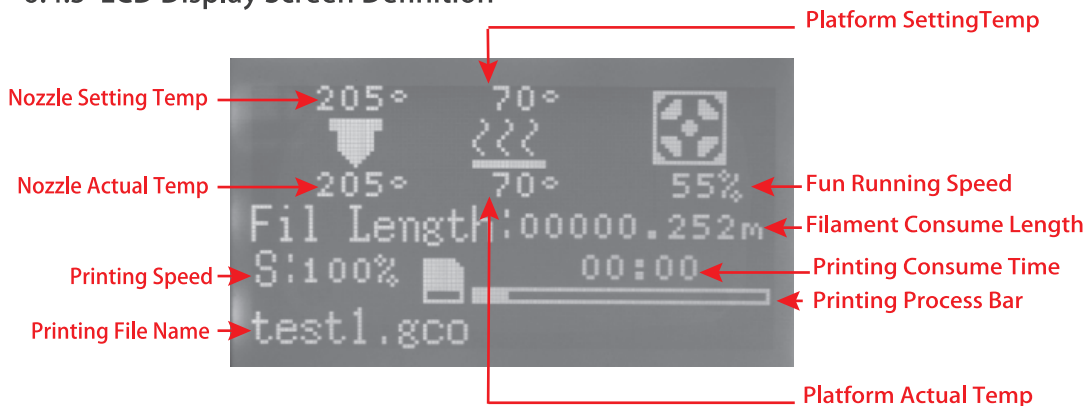


6.4.4 Finish printing the test file, the LCD Display will show as picture W. The platform and the nozzle will start to cooldown.

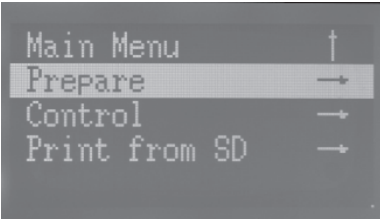


NOTE: Please wait for few minutes to cooldown the platform before removing the printed object.

6.4.5 LCD Display Screen Definition

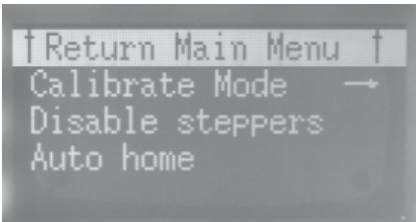


6.5 Prepare Menu

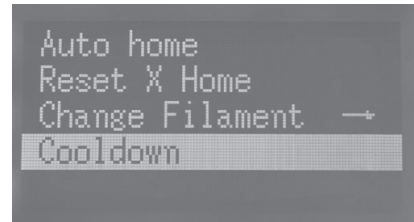


There are 6 submenus under “Prepare” as below picture I~II:

- 1、 Calibrate Mode → Printer calibration and test (Refer to 6.1~6.4)。
- 2、 Disable Steppers→Unlock all motors, can move the position of the platform and the printer head manually.
- 3、 Auto Home→Printer Head will go to initial position.
- 4、 Reset X Home→Printer Head return to X initial position. Y, Z position will not change.
- 5、 Change Filament →Load or unload filament (Refer to 6.6)
- 6、 Cooldown→Cool down the temperature of the platform and the nozzle to normal temperature.



I



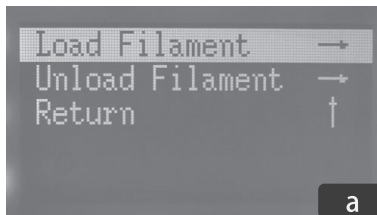
II

6.6 Change Filament

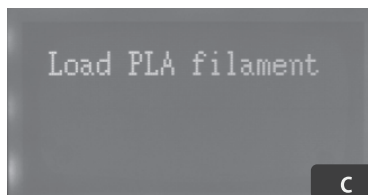
“Prepare” - “Change Filament” has two submenus: (as picture a)

Load Filament

Unload Filament



6.6.1. Select “Load Filament” and proceed as below picture b~f.



a. Select the filament material you are using

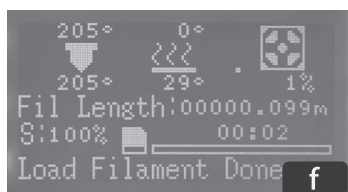
b. Insert the filament to the hole of the printer head



c. Heating up nozzle temperature to the setting temperature

d. Once reach the setting temperature, The filament will be semi-auto loaded into the nozzle and flow out.

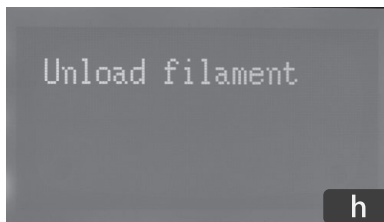
Check the filament flowing condition by refer to 6.3.3.



e. Finish the filament loading

6.6 Change Filament

6.6.2. Select “Unload Filament” and proceed as below picture g~k.



a. Heating up the nozzle temperature to setting temperature as picture i.



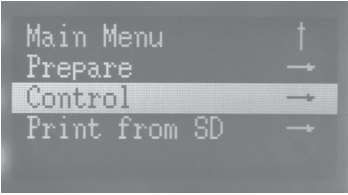
b. Once the temperature reach the setting temperature as below picture g, the filament will be semi-auto unload from the nozzle.



c. Once the LCD display will show screen as below picture k, finish the filament unloading and gently pull out the filament from the nozzle.

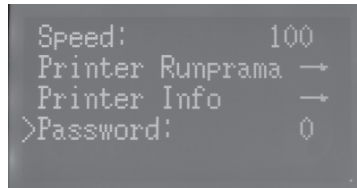
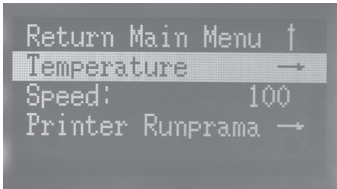


6.7 Control Menu

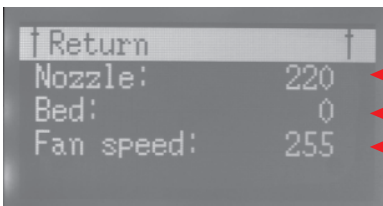


There are 5 submenus under “Control” :

- 1、 Temperature →to adjust temperature.
- 2、 Speed: 100%→to adjust print speed.
- 3、 Printer Runprama →to refer to printer running info.
- 4、 Printer Info →to refer to printer basic information.
- 5、 Password→Manufactory set. Forbit user to adjust.

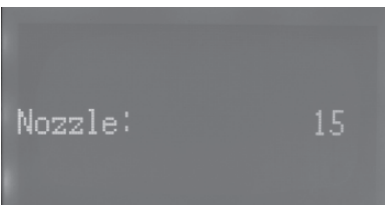


6.7.1 Temperature menu can set up below parameter:



- ← Set up the nozzle setting temperature (0~260)
- ← Set up the platform setting temperature (0~135)
- ← Set up the Fan speed. (0~255)

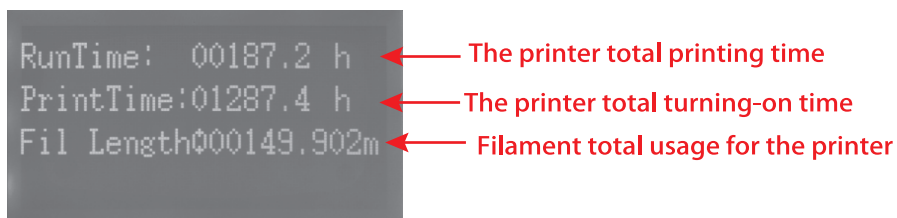
Setting method: Rotate the knob to select the parameter that you want to adjust and push the knob to confirm. Then rotate the knob to adjust the setting you want and push the knob to confirm the number. The parameter will be run to the system.



6.7 Control Menu

6.7.2 “Print Speed” is to adjust the printing speed during printing. It can be adjusted base on actual condition. The number increases, the printer speed also increases. The number can be set from 10% to 200% and the default speed is 100%.

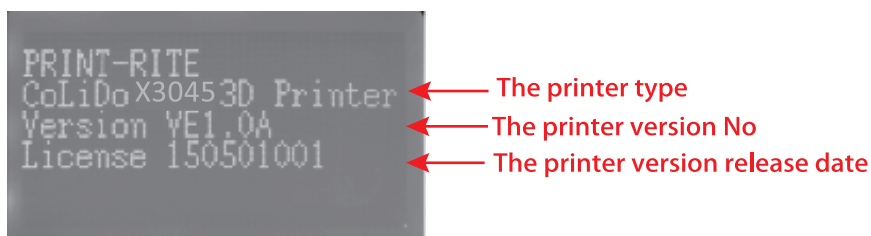
6.7.3 “Printer Runprama” menu as below.



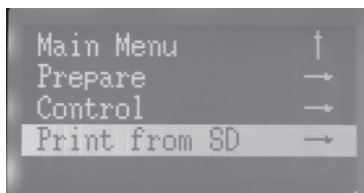
6.7.4 “Printer Info” menu as below.

It is to show the printer basic information such as Printer type, Version No and License No.

The actual Version No and License No will be depend on the shipped printer.



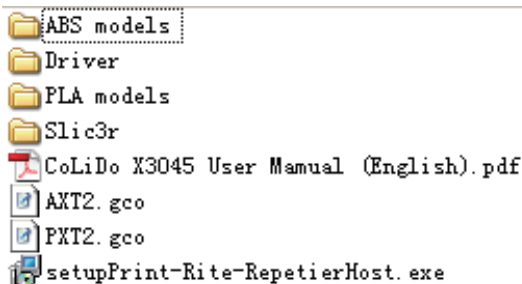
6.8 Print from SD Menu



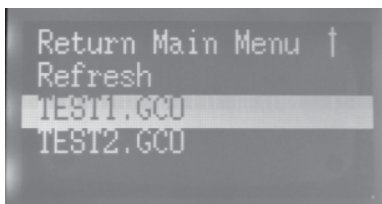
“Print from SD Card” is to select the print file from SD Card to print.

6.8.1 The default documents when out of factory is:

(it will be updated depend on the shipped printer)

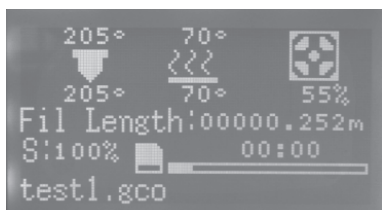


6.8.2 Rotate the knob to select the print file that you want to print (.GCO file) and push the knob to confirm to start to print the file.



A

Select the print file that you want to print



B

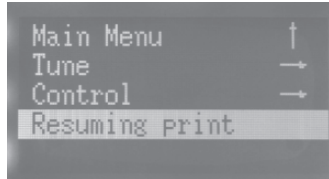
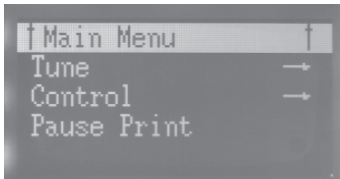
Once the platform temperature and the nozzle temperature reach the setting temperature, the printer start to print.

NOTE: The printer just can read the G-code (GCO). You can print .GCO file with SD Card directly. Otherwise, you can convert .STL file to .GCO file using software REPETIER-HOST, then save the GCO in SD card to print directly or connect REPETIER-HOST in the computer to print through USB cable .

6.8 Print from SD Menu

6.8.3 Pause Printing Feature:

1. Push LCD knob and rotate to select “Pause Print” ;
2. Push LCD knob and rotate to select “Resuming print” to resume print.

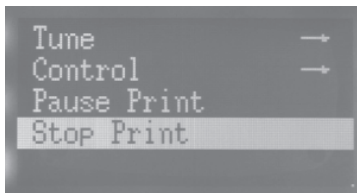


NOTE: When pause printing, the printer head will go to home position and be locked. The nozzle and the platform temperature will keep on.

- a. Please clear up the remained filament outside the nozzle tip before resume printing.
- b. If resume printing after pause long time, please make sure the nozzle no clogged by pressing the printer head arm and pushing the filament into the nozzle until the filament flow out smoothly.

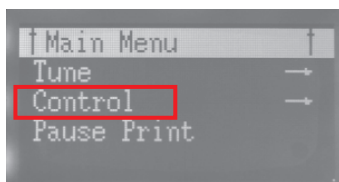
6.8.4 Stop Printing Feature:

1. Push LCD knob and rotaet to select “Stop Print” ;
2. Once stop, the printer head will go to home postion. the nozzle and the platform temperature will cooldown. The printing cannot be resumed.



6.8.5. Adjust Printing settings Feature:

During printing, rotate the LCD knob and rotate to select “Control” . You can adjust the setting temperature, speed or review the printer information. (Refer to 6.7)



If you want to print files from computer, you need install REPETIER-HOST.
Computer Operation System: WINDOWS 7, MAC OS, LINUX

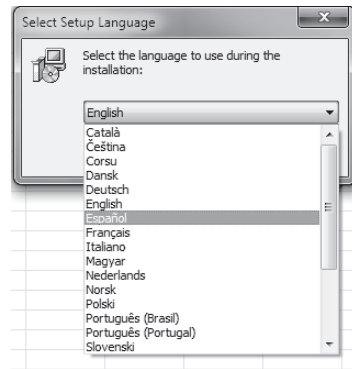


REPETIER-HOST is a software which is used to slice the 3D models (.GCO or .STL) and command CoLiDo Printer to print.

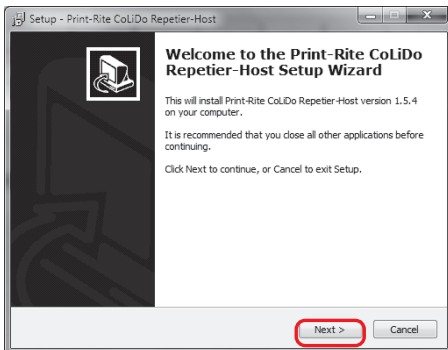
7.1 Install REPETIER-HOST (WINDOWS)

- 1 Find “setupColido-RepetierHost_1_5_5.exe” in SD Card, double click to start.

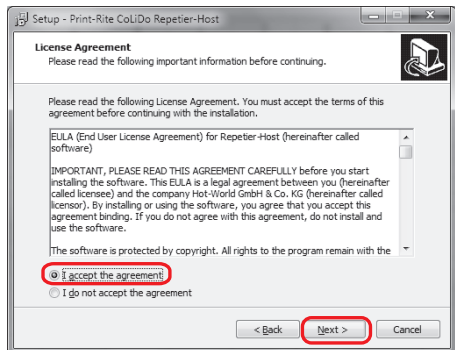
Select Setup Language to use during the installation.



- 2 Start to install. (You will be asked “Do you want to allow the following program to make changes to this computer?” ,please click “Yes” to continue installation.



Click “Next”

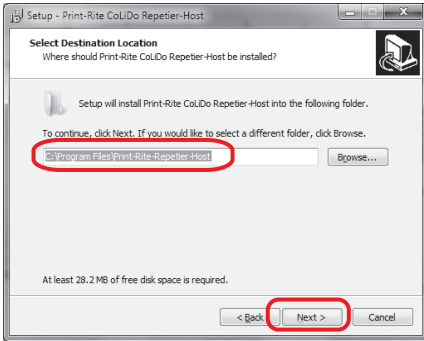


Click “I accept the agreement” ,
Click “Next”

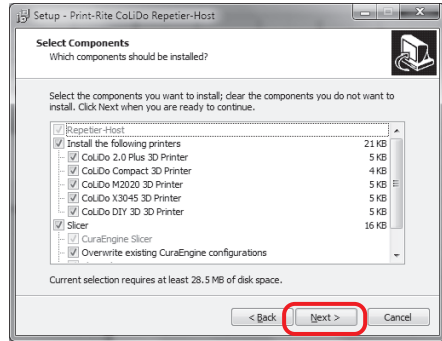
7.1 Install REPETIERHOST (Cont.)



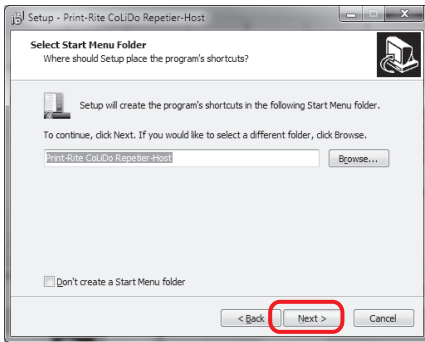
3 Select a destination to save the software and select the components should be installed, then click “Next” and “Install” .



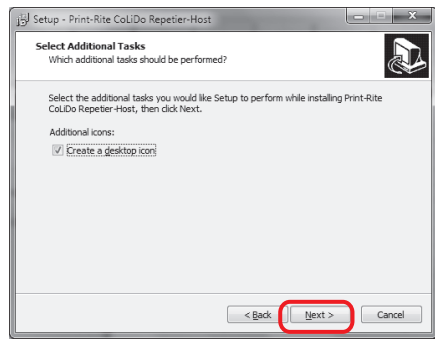
Click “Next”



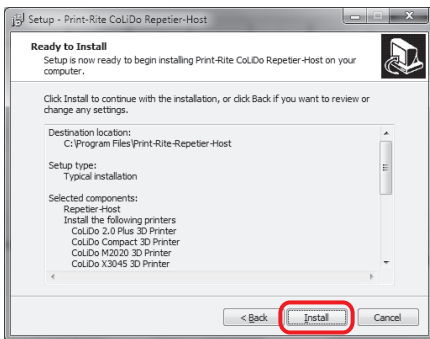
Click “Next”



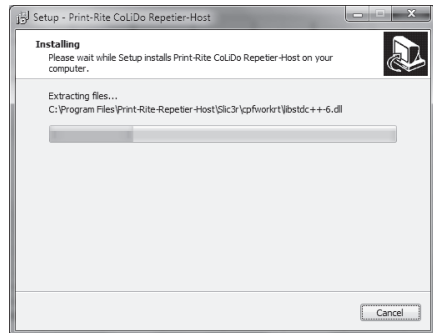
Click “Next”



Click “Create a desktop icon”
Click “Next”



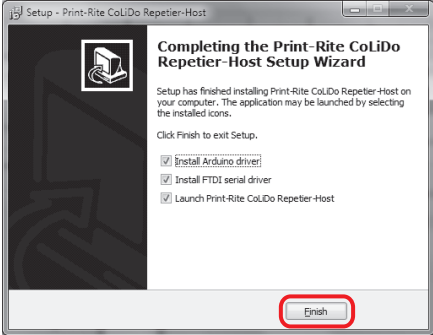
Click “Install”



if antivirus message appear, please allow the operation timely.

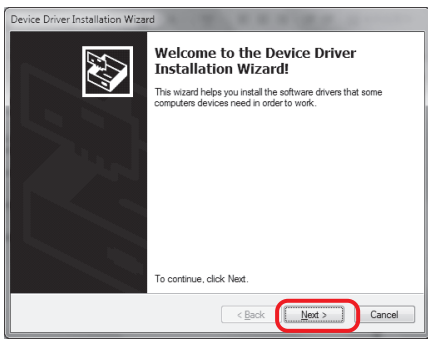
7.1 Install REPETIER-HOST (Cont.)

4 Click “Install Arduino driver” , “Install FTDI serial driver” and “Launch Print-Rite CoLiDo Repetier-Host” and then click “Finish” .

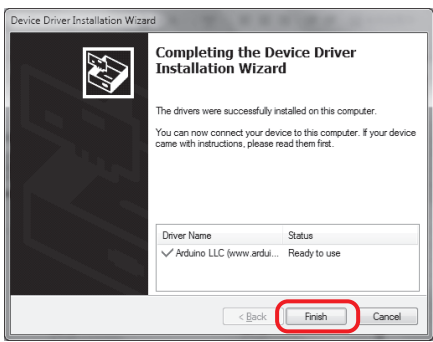
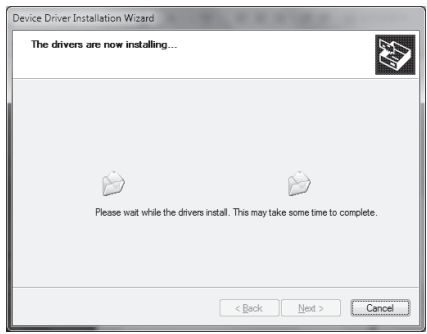


Click “Finish”

5 Install Arduino drivers.



Click “Next”

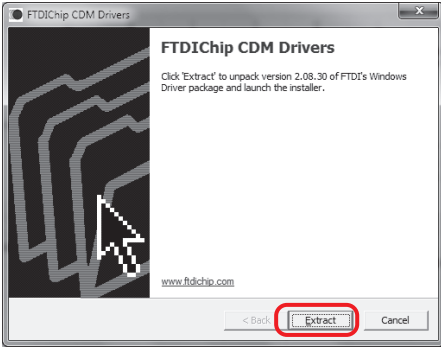


Click “Finish”

7.1 Install REPETIER-HOST (Cont.)



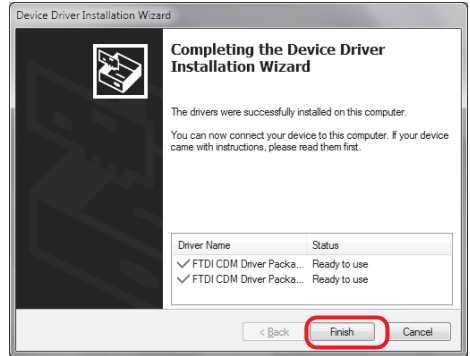
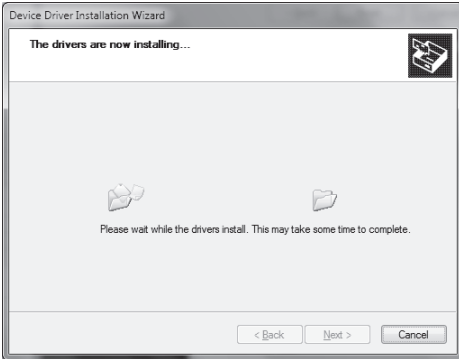
6 Install FTDI Drivers.



Click "Extract"



Click "Next"

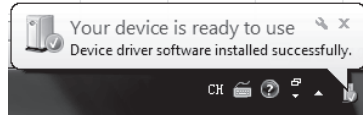
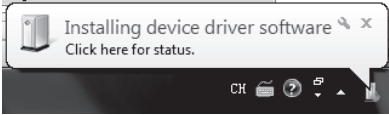


Click "Finish"

7.2 REPETIER-HOST Setup

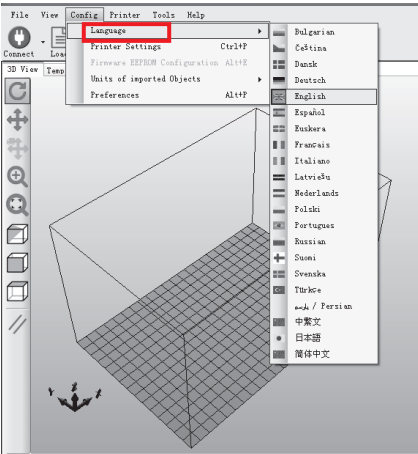
Connect the printer to the computer using USB Cable and Turn ON the printer.

When the computer is the first time connecting the printer, there is connection reminder at the right bottom of the computer.



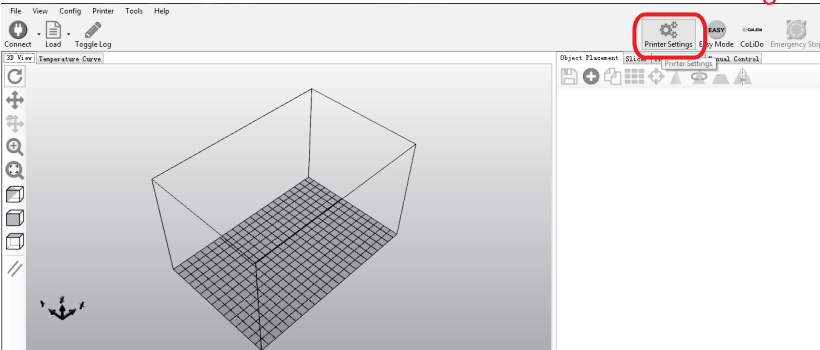
1 double click  to go into “Repetier - Host” software.

2 Select language you want in the software, “Config” - “Language” .



3 click “Printer Settings” .

Printer Settings



7.2 REPETIER-HOST Setup (Cont.)

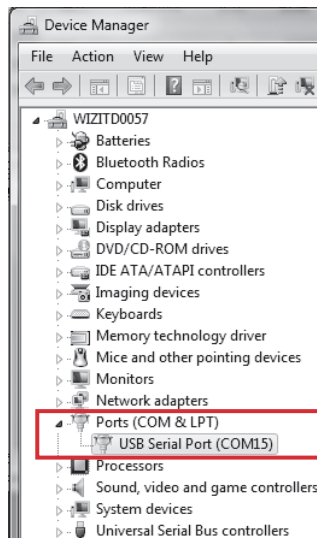
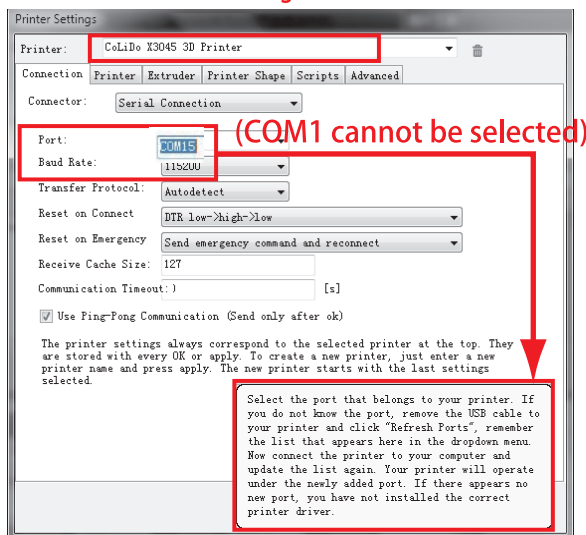
4 Printer Settings as below.

Connection: Select Printer: CoLiDo X3045 3D Printer; Baud rate: 115200.

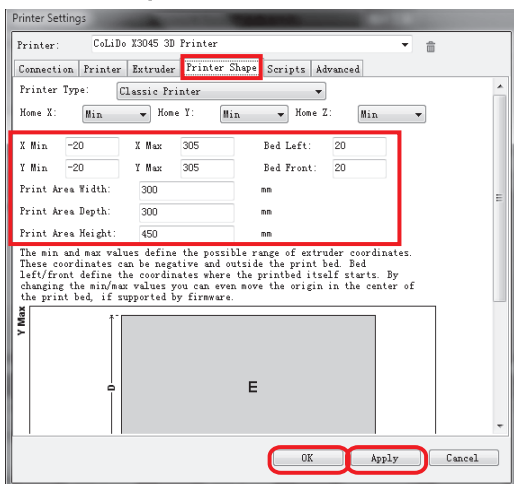
Select the correct Port COMx such the printer can connect with the Repetier.

NOTE: COMx dependant on different computer or 3D printer you are using.

Different 3D printer has different COMx, which can be located and matched with COMx in Device Manager as below.

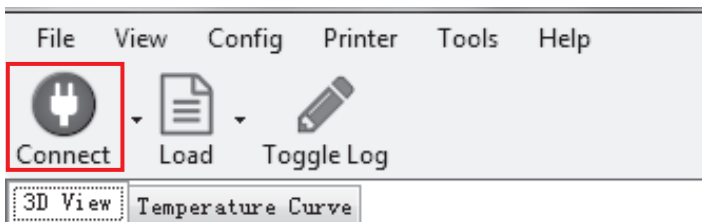


Printer Shape: as below data. After checked, click "Apply" and "OK" .

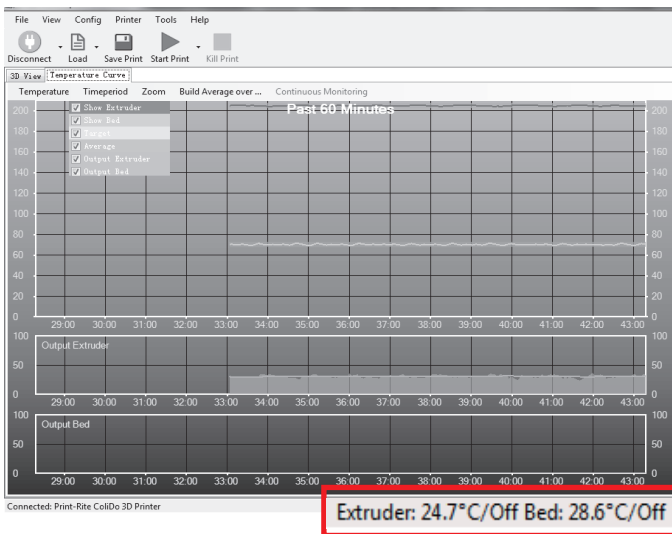


7.2 REPETIER-HOST Setup (Cont.)

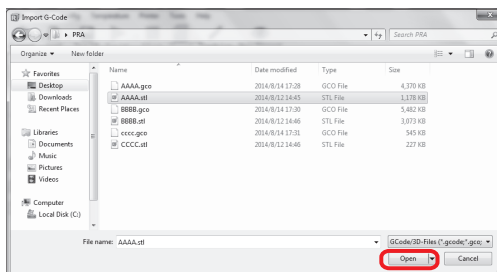
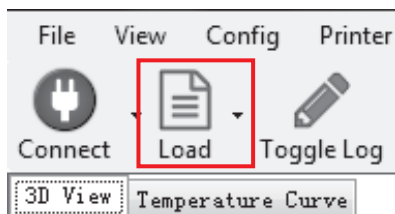
- 5 Click "Connect" .



NOTE: After the printer is really connected with the Repetier software, the actual extruder and bed temperature of the printer will be shown in the bottom of the Repetier software. Also, the Temperature Curve is moving.

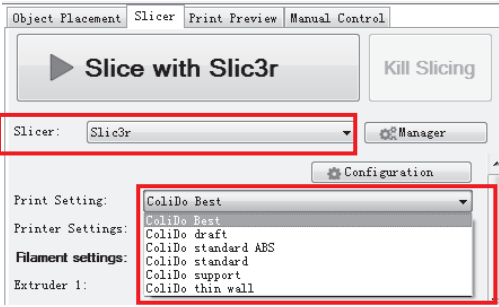


- 6 Click "Load" , select the print file that you want to print and click "Open" .
Note: The print file should be with .GCO or .STL format.



7.3 Print with Repetier-Host (Cont.)

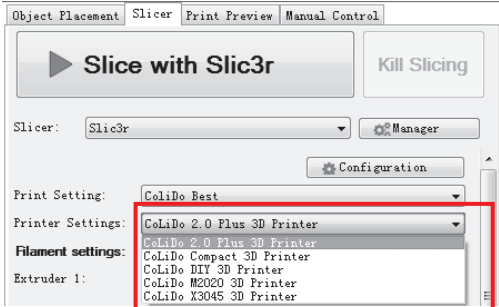
7 Select the print effect that you want to print, select PLA or ABS filament that you are using. Then click “Slice with Slic3r” to generate G-code.



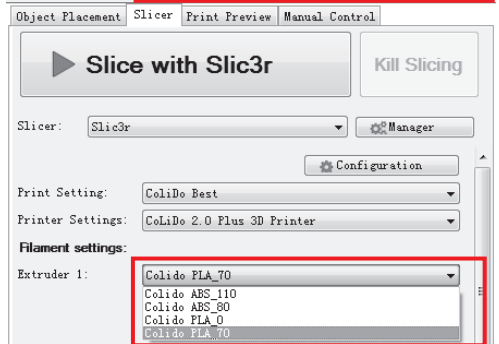
Step1: Select “Slic3r”

Step 2: Select the effect that you want to print

- CoLiDo Best - For small object
- CoLiDo standard - For big object
- CoLiDo standard ABS - For ABS material object
- CoLiDo draft - For fast printing
- CoLiDo support - For the model adding support
- CoLiDo thin wall - For the thickness lower 2mm thin wall object

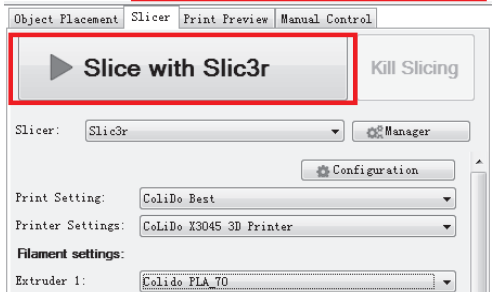


Step 3: Select printer type “CoLiDo X3045 3D Printer” you are using



Step 4: Select Extruder base on the PLA/ABS filament you are using and the platform required temperature

- CoLiDo ABS_110
 - For ABS Filament with platform temp 110°C
- CoLiDo ABS_80
 - For ABS Filament with platform temp 80°C
- CoLiDo PLA_0
 - For ABS Filament with platform temp 0°C
- CoLiDo PLA_70
 - For PLA Filament with platform temp 70°C

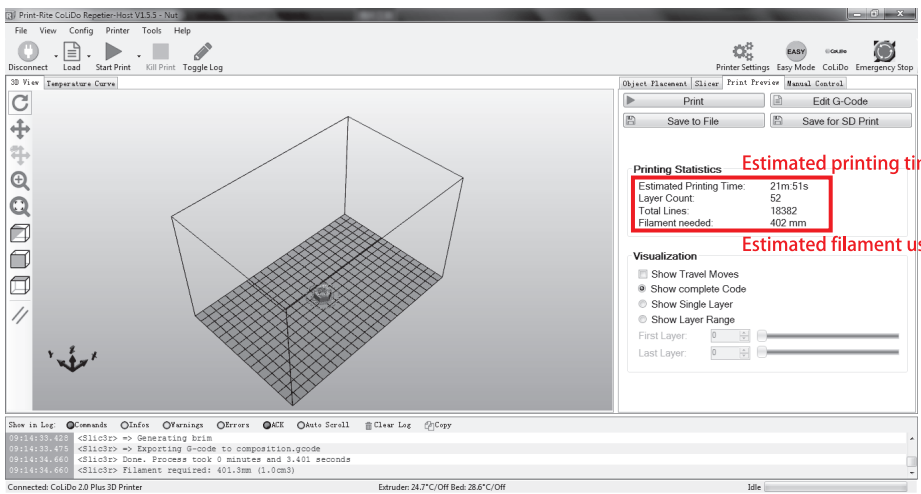


Step 5: Click “Slice with Slic3r” to slice the file to generate g-code

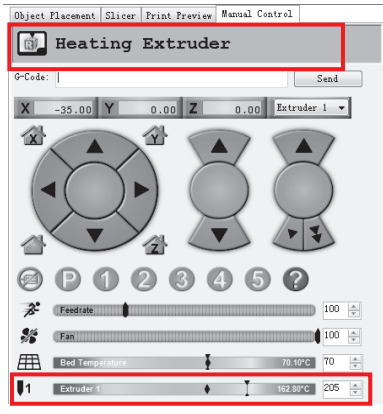
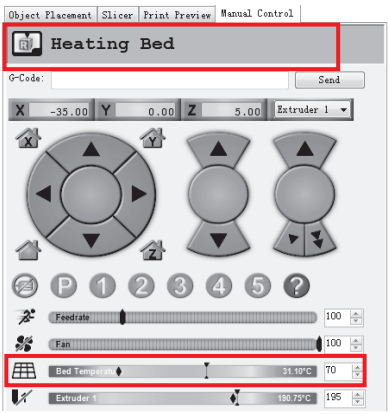
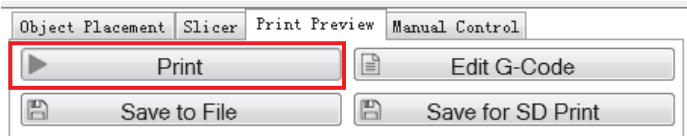


7.3 Print with Repetier-Host (Cont.)

- 8 After slice, you can see the estimated printing time and filament usage. Also, you can see the printed shape of the object in the “3D View” .



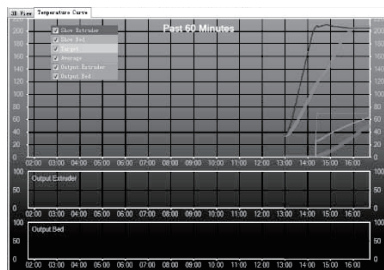
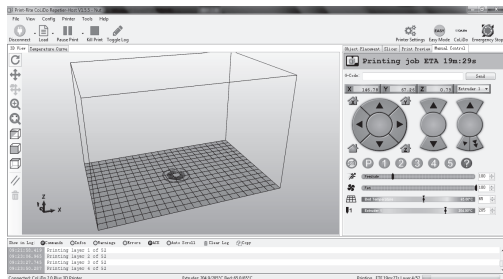
- 9 Click “Print” , start to print.
Once the platform and the nozzle actual temperature reach the setting temperature, the printer will start to print.



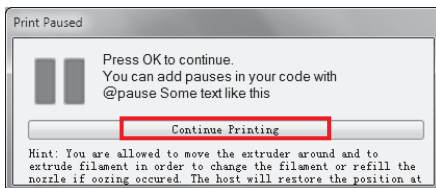
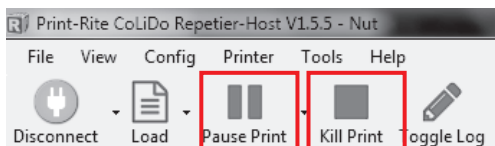
7.3 Print with Repetier-Host(Cont.)

10 Printing.

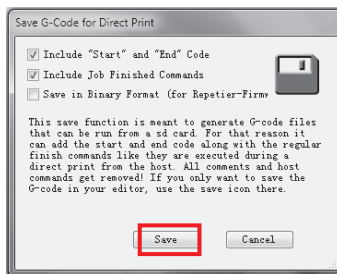
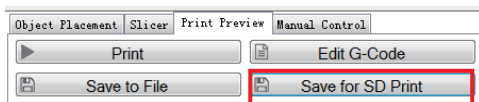
1. You can see the printing track from “3D View” ;
You can see temperature go up/down from “Temperature Curve” .



2. You can click “Pause Print” and “Continue Printing” to pause/resume printing.
You can click “Kill print” to stop the printing and cannot be resumed.



- 11 If want to print the file using SD Card, you can click “Save for SD Print” after slice, to save the GCO file in the computer or SD Card.



NOTE: The saved file name just can be English words, number, underline, blank space.

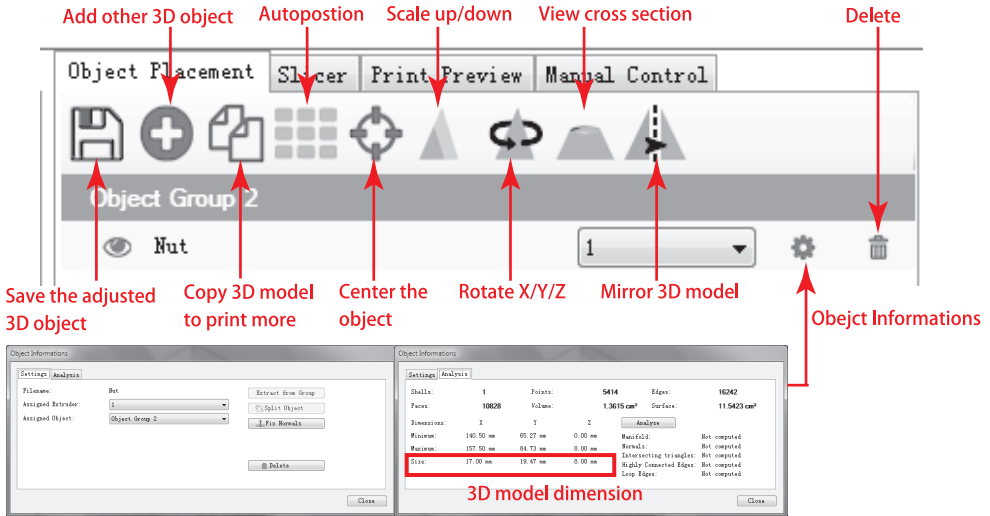
12 Finish Print.



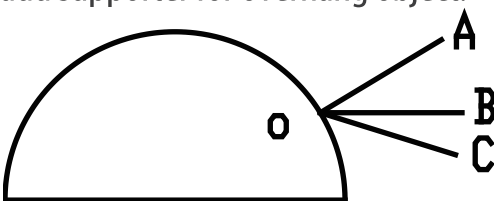
Caution: Please wait for a few minutes to cooldown before remove the printed object.

7.4 Repetier-Host Basic 3D Printing

- 3D object can be adjusted such as scale down/up X/Y/Z, rotate X/Y/Z, copy, mirror, autoposition and split before slice. After adjusting the object, It is better to click “Center Object” .



- For 3D printing layer by layer base on FDM process, we suggest printing the model with OA structure. If printing the model with OB or OC structure (Call Overhang Printing), the parallel or downward layer will fall down on the model or on the platform due to no supporter to the layer. So, you need add supporter for overhang object.



Remark:

- OA – the structure is upward to stretch
- OB – the structure is parallel to stretch
- OC – the structure is downward to stretch

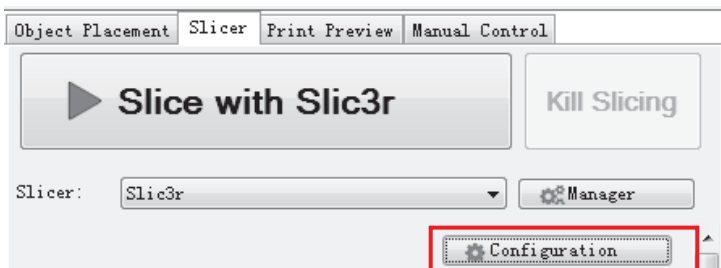
- The 3D model must be closed surface or line to print base on FDM process. If below message appears, it is better to repair the object before printing. Recommend repair website: <https://netfabb.azurewebsites.net>.

The object is not manifold. This essentially means, that it is not watertight. This normally causes problems during slicing, resulting in unwanted results. We strongly advice to repair the file. One free repair service is: <https://netfabb.azurewebsites.net>

7.5 Repetier-Host Advanced 3D Printing

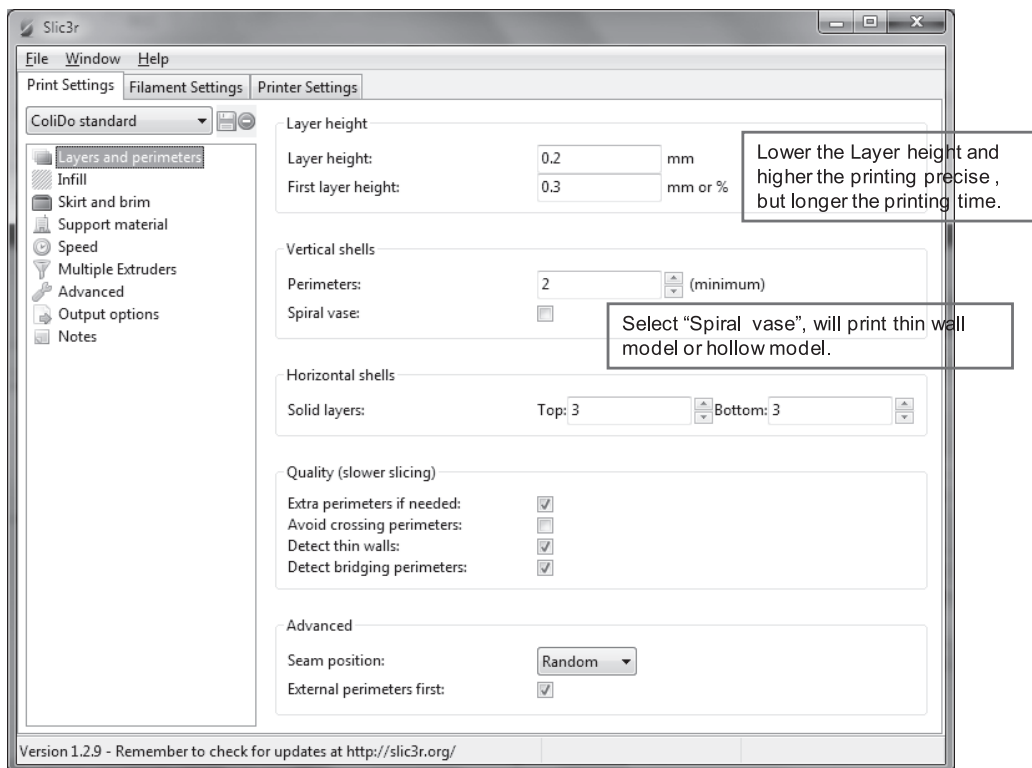
7.5.1 Slic3r settings

For printing setting, you can click “Configuration” to review or have your customized “Print/Filament/Printer Settings” in Slic3r for advanced user.

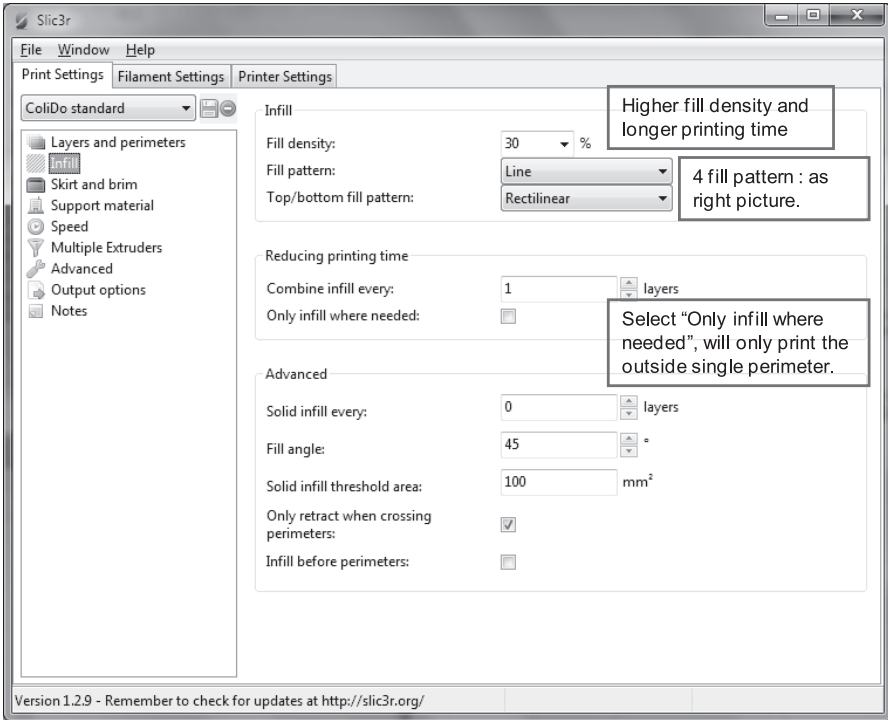


7.5.1.1 Print Settings (For example “CoLiDo standard”)

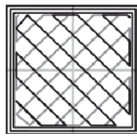
a. Layers and perimeters



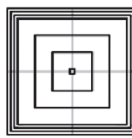
b. Infill



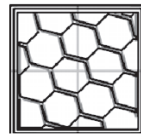
Line



Rectilinear

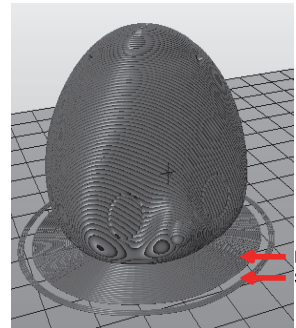
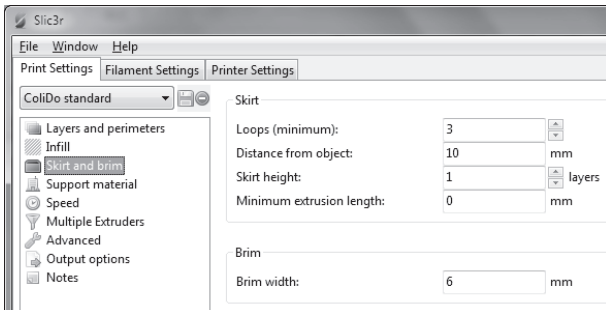


Concentric

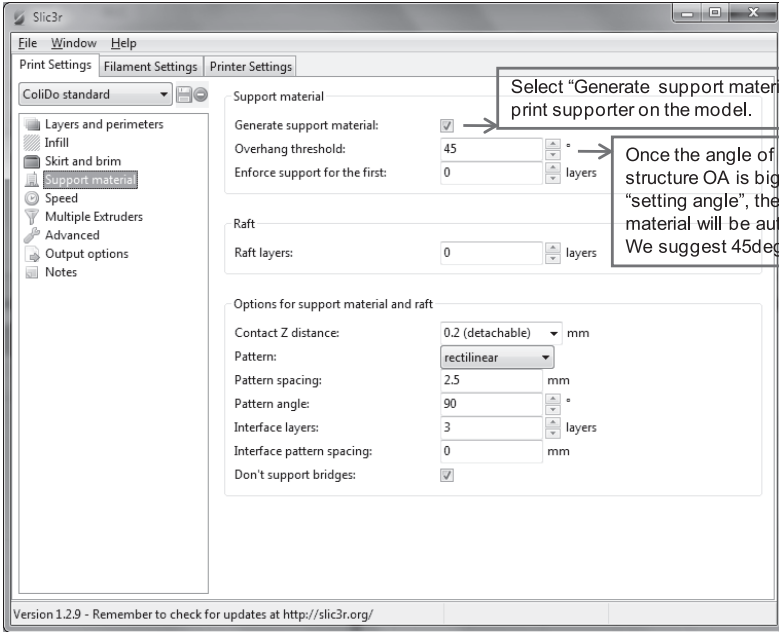


Honeycomb

c. Skirt and brim



d. Support Material



Support Material Pattern:



Rectilinear

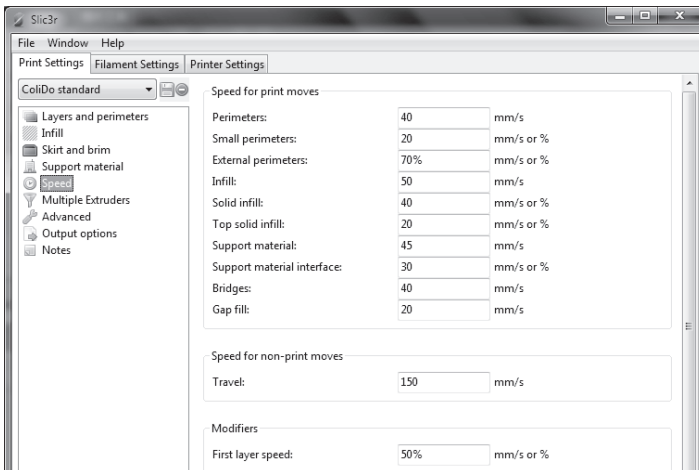


Rectilinear Grid



Honeycomb

e. Speed

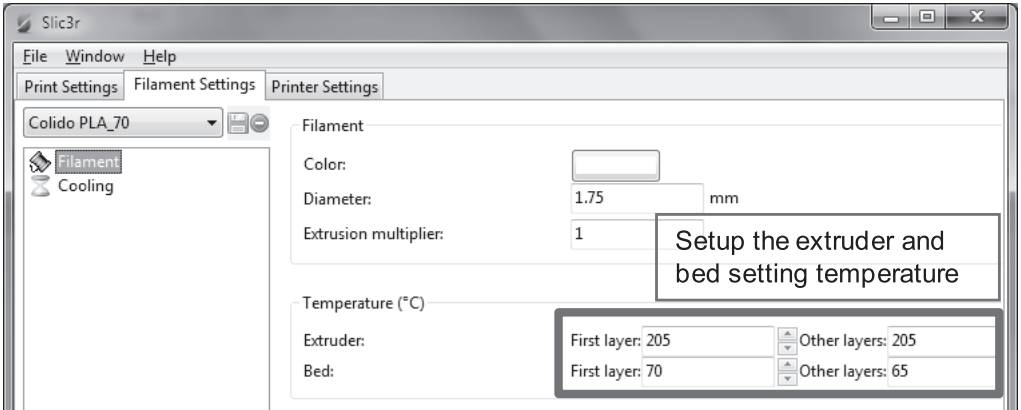


7.5 Repetier-Host Advanced 3D Printing



7.5.1.2 Filament Settings (For example “CoLiDo PLA_70”)

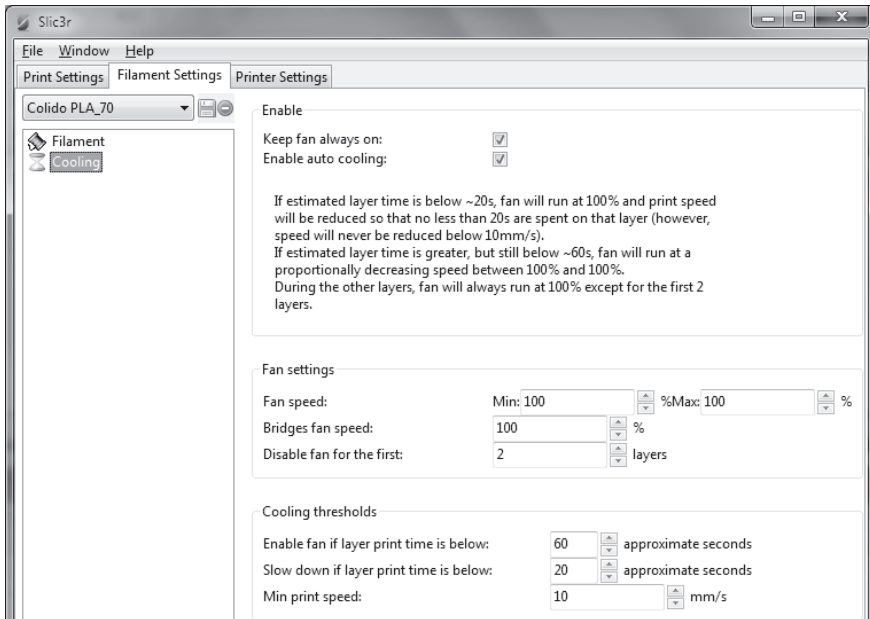
a. Filament



NOTE:

To revise the temperature, need click the up/down narrow instead of revise the number directly.

b. Cooling



7.5 Repetier-Host Advanced 3D Printing

7.5.1.3 Printer Settings

a. General

The screenshot shows the Slic3r interface with the 'Printer Settings' tab selected. The 'General' sub-tab is active. The settings are as follows:

- Size: Nozzle diameter: 0.4 mm
- Position (for multi-extruder printers): Extruder offset: x: 0 mm, y: 0 mm
- Retraction: Length: 3 mm (zero to disable), Lift Z: 0 mm, Speed: 40 mm/s, Extra length on restart: -0.01 mm, Minimum travel after retraction: 2 mm, Retract on layer change: , Wipe while retracting:
- Retraction when tool is disabled (advanced settings for multi-extruder setups): Length: 10 mm (zero to disable), Extra length on restart: 0.5 mm

A callout box points to the 'Lift Z' field with the text: "When printing many objects at the same time, revise the 'Lift Z' from '0' to '2-5' to avoid the nozzle cross the object.."

b. Custom G-code

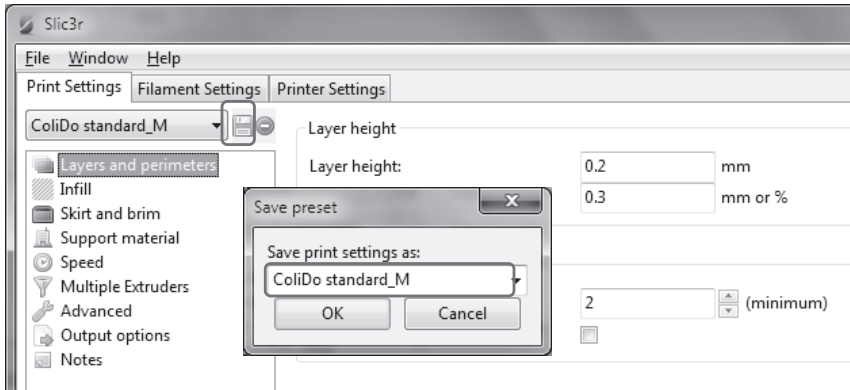
The screenshot shows the Slic3r interface with the 'Printer Settings' tab selected. The 'Custom G-code' sub-tab is active. The settings are as follows:

- Start G-code: G28 ; home all axes, G1 Z5 F200 ; lift nozzle. A callout box labeled "Action before printing." is positioned below the text.
- End G-code: G91;, G1 Z2.0;, G90;, M104 S0 ; turn off temperature, M140 S0 ; set bed target temp, G28 X0 ; home X axis, M84 ; disable motors, G1 Z140 F200;. A callout box labeled "Action after printing." is positioned below the text.
- Before layer change G-code: (empty)

7.5 Repetier-Host Advanced 3D Printing

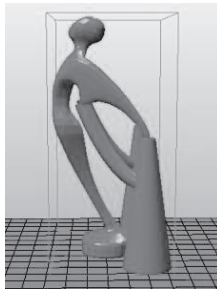
7.5.1.4 Save the settings

If you want to save the revised settings, click “Save” and have customized name. Then you can select customized name/settings when you slice.



7.5.2 Other Skills

- a. Design supporter on the 3D model to avoid overhang structure (the supporter can be easily removed.)

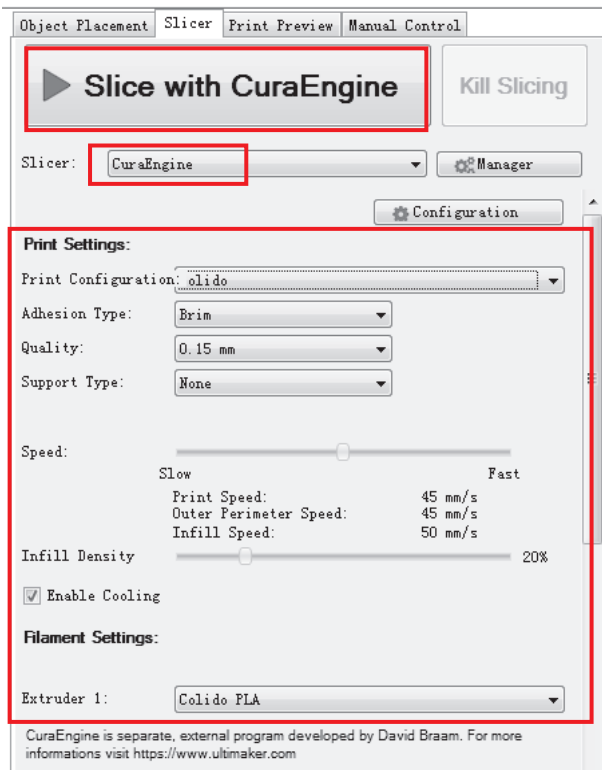


- b. When printing the hollowed-out object, it is better to lower the nozzle temperature by 5~10 degrees to avoid silky threads.
- c. If the object is bigger than the printer printing area, it is better to divide the object in several parts to print, then assemble together.
If the object is smaller, it will easy moving on the platform and offset, it is better to copy printing several objects at one time.
- d. The printing environment has minor impact on the filament sticking condition.
If cold printing environment, it is better to increase the nozzle temperature 5~10°C and vice versa.

7.5 Repetier-Host Advanced 3D Printing

7.5.3 CuraEngine

It is another slicer software to convert 3D model to g-code.

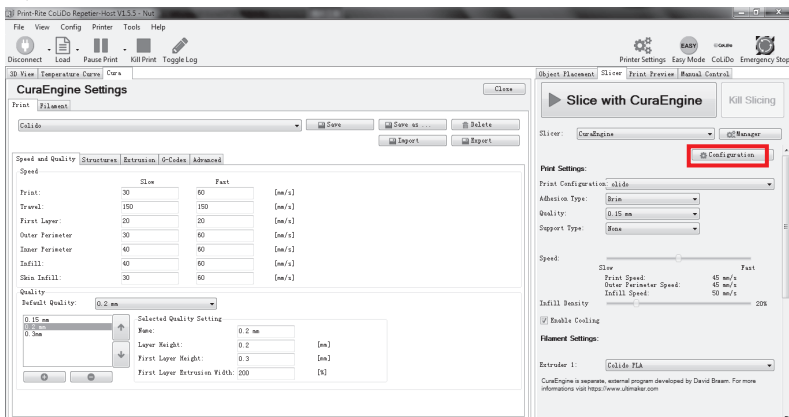


Step1: Select "CuraEngine" ;

Step2: Select "Print Settings" and "Filament Settings" ;

Step3: Click "Slice with CuraEngine" .

If you want to view or customize CuraEngine settings, click "Configuration" .

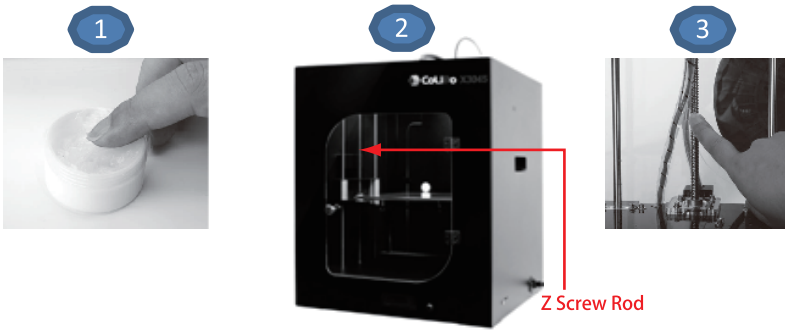


Lubricate the Z-axis Screw Rod and the X,Y Rods

After printing around 50 hours, you should lubricate the Z-axis screw rod and the X,Y Rods.

To lubricate Z-axis screw rod, please follow up below process:

1. Prepare the lubricate (own by customer) such as SKF Bearing Grease .
2. Slowly rotate the two Z screw rods (Left and Right) to move up/down the platform of the 3D Printer.
3. Use a clean, lint-free cloth to spread the grease onto the top/bottom of the Z-axis screw rod.
4. Make sure the grease cover the inside of the Z-axis screw rod.



To lubricate X, Y Rods, please follow up below process:

1. There are 2pcs X Rods and 4pcs Y Rods on the printer as below picture.
2. Apply small amount of the grease directly onto the exposed area of the Rods and manually move the printer head forward/backward and left/right to spread the grease. Too much lubricate will cause the printer head moving blocked.



| Consumable (Filament) | |
|--|---|
| ? Question | 🔧 Solution |
| What is the PLA/ABS default setting temperature? | 1. PLA: Nozzle temperature is 205°C, Platform temperature is 65~70°C; 2. ABS: Nozzle temperature is 220°C, Platform temperature is 100~110°C. |
| How to store the filament when the printer will be out of use for a long period of time? | If you do not use the filament for a long time, keep your filament spool or cartridge in a closed plastic bag to avoid the filament absorbing moisture. |
| How about the length of 1000g and 500g PLA/ABS filament? | 1. 1000g: PLA 330~340m, ABS 390~400m; 2. 500g: PLA 160~170m, ABS 190~200m. |
| Can Prinrite filament be compatible with other 3D printer? | Yes, Prinrite filament is compatible with other FDM 3D printer, such as Makerbot, Afinia, Reprap, UP!, etc. The filament diameter should be 1.75mm. |
| 3D Printer | |
| ? Question | 🔧 Solution |
| Does the printer support offline printing? | Support offline printing by using SD card. |
| How long will it take to print an object? | The required time depends on the object size and resolution level. The higher the resolution level, the slower the printing speed. The printer is configured with different print settings: Best, Standard, draft. After you select the printing setting to slice, the Repetier software will show the needed time. |
| How to fix the clogged nozzle? | 1. Refer to chapter 6.6, once the nozzle reaches the setting temperature, please press the printer head arm and at the same time pull on the filament to extract it from the nozzle. 2. Refer to the label on the printer, clean the nozzle using longer Allen Key in the accessory. 3. Disassemble the printer head by unlocking the screws on the Fan, clean the blocked filament inside the nozzle. |
| Can I adjust the parameter during printing? | For new users, we do not suggest adjusting parameters during printing. For advanced users, you can push the knob to select "Control" to adjust Nozzle or Bed temperature and printing speed during printing. |
| How can I know if the printer is properly working? | Refer to chapter 6.2~6.4 in the user manual, print one of the test files in the SD Card supplied with the printer. (For example: PCT1.gco for PLA filament, ACT1.gco for ABS filament) |
| The filament cannot come out from the nozzle during printing? | 1. The platform may be too close to the nozzle tip, which will prevent the filament from extruding from the nozzle. Please select "Prepare"->"Calibrate Mode" of the LCD screen to re-calibrate the platform. (refer to chapter 6.2 in the user manual) 2. Remove the filament from the printer head (refer to chapter 6.6 in the user manual), cut the filament tip flat, make a length of filament straight and re-load it into the printer head. Make sure that the filament is properly inserted into the nozzle receiving port. 3. Disassemble the printer head, check the gear which is pulling the filament into the nozzle. If there is a presence of filament powder residue, clean the gear with a brush. Check also if the gear tooth is damaged. If yes, replace the gear with a new one. |
| The printer makes a clicking noise when printing? | 1. The filament is not properly inserted into the nozzle. Please unload the filament, cut the end of the filament flat and re-load it into the printer head. (refer to chapter 5.8) 2. It may be a short length of filament blocked in the nozzle from the last time it printed. Refer to chapter 6.6 in the user manual, heat the nozzle and push the blocked filament into the nozzle tip by loading new filament, the blocked filament will be melted out. |
| The filament cannot be removed from the printer head? | 1. Check if the nozzle's actual temperature reaches the setting temperature; 2. Refer to chapter 6.6 in the user manual, when the nozzle's actual temperature reaches the setting temperature, press the printer head arm and push a bit of filament into the nozzle until the filament comes out from the nozzle, then pull the filament out quickly. |
| The printed sample sticks to the platform too tightly and cannot be removed? | 1. Please wait a few minutes for the platform and the printed samples to cool down, then remove the printed sample. 2. If the printed samples still stick to the platform tightly, please carefully remove them using a scalpel. |

| 3D Printer | |
|--|--|
| ? Question | 🔧 Solution |
| The printed object cannot stick to the platform? | <ol style="list-style-type: none"> 1. Make the temperature setting correct. PLA, nozzle temperature is 205°C, platform temperature is 70°C; ABS: nozzle temperature is 220°C, platform temperature is 110°C. Make sure the selected setting is matched with the material you are using. 2. Re-calibrate the platform to meet "calibration standard condition" (The test sheet must be lay down flat in the platform and the test sheet must be touching the nozzle tip). 3. Make sure that the glass platform you are using is correct base on the filament material. No dust, oil or damage coating on the glass platform. If yes, please clean up using lint-free cloth or replace the platform. |
| The printer cannot read the files on SD card and cannot start to print with SD Card? | <ol style="list-style-type: none"> 1. Turn off the printer and turn on again the printer. 2. If the printer still cannot read the file, please check if the files saved in SD card in .GCO format and correct file name (English word, number, underline, blank space). If the file is not .GCO format, please convert it to .GCO format through Repetier-Host software. (refer to chapter 7.3 in user manual). 3. Please double check if the SD card insert into the SD card slot well. If not, please re-insert. |
| How to clean the excess filament around the nozzle? | Preheat up the nozzle to 220°C by rotate LCD knob to select "Control" - "Temperature" - "Nozzle" . Once the nozzle actual temperature reaches the setting temperature 220°C, clean the nozzle using the lint-free cloth or tissue. |
| Need pause/resume during printing? | <ol style="list-style-type: none"> 1. During printing with SD Card, push the LCD knob and rotate it to select "Pause print"; Then push LCD knob and rotate it to select "Resuming print" . NOTE: Please be more patient after selecting "Pause print", the printer need ~30s to buffer. 2. During printing with Repetier control, click "Pause Job" and then click "Continue Printing" . |
| Need stop during printing? | <ol style="list-style-type: none"> 1. During printing with SD Card, push the LCD knob and rotate it to select "Stop print". Once stop, the printing cannot be resumed. The printer head will go to home position and the nozzle & bed temperature will cooldown. NOTE: Please be more patience after selecting "Stop print", the printer need ~30s to buffer. 2. During printing with Repetier control, click "Kill Job" . The printer head will stop moving and the nozzle & bed temperature will cooldown. 3. If the printing still not stop after above, please turn off the printer, wait ~10s and turn it back on. Then push the LCD knob and select "Prepare"- "Auto Home" so the printer head go to home position. |
| Download files from 3D model website cannot be printed well? | <ol style="list-style-type: none"> 1. Refer to chapter 7.2 & 7.3 in user manual, re-setup Repetier-Host and select correct filament material to print. 2. The printed object will have different printing effect with different filament material. For example, if the object cannot be printed well with ABS filament, you can test to print with PLA filament. 3. Check if the object shape is closed drawing, if it need scale up/down, rotating, adding supporter, etc to meet FDM process by refer to 7.5. If Repetier-Host shows warning message when load the object, it is better to repair the object through the website: https://netfabb.azurewebsites.net |
| The STL file cannot be sliced to gco file in Repeater software? | <p>When load STL file to Repetier software, the object will show all dark blue color in the 3D view window, it means that the file can be sliced.</p> <ol style="list-style-type: none"> 1. If the object show some red and some green, it mean the object has unclosed line or surface and cannot be sliced. Also, Repetier-Host will show warning message to suggest repairing the object. 2. If the object is not touch with he printing area or exceed the printing area, please click "📍" place in the middle, or click "▲" to scale down and then place in center. |
| How to set parameters for the 3D printer to insert them in Repetier/Slic3r software? | <ol style="list-style-type: none"> 1. The Repetier-Host software of the printer has standard settings for selecting to use directly. 2. For the advanced user, click "Configuration" to revise the parameters. Refer to 7.5 in user manual for detail. |

3D Printer

| ? Question | 🔧 Solution |
|--|---|
| How much the printing speed? | The printer printing speed is 20~120mm/s. |
| Repetier-Host software cannot connect to 3D printer though the software installed correctly? | <ol style="list-style-type: none"> 1. Ensure the printer connect to computer with USB cable and turn on; 2. Refer to chapter 7.2 , make sure that the selection of COM port in printer setting is right. The port should be the last one when turn on the printer and matched with COM port in Device Manager. Once connected, the Temperature Curve will be moving. NOTE: "COM1" cannot be used. |
| The printed object easy to warp when printing? | <ol style="list-style-type: none"> 1. Adjust the adjusting knob to have the nozzle tip more close to the platform. 2. The contact area of the object to the platform is too small, use Repetier software to add brim before slicing: Click "Configure" - "Brim" , add the Brim width with "8~10mm" . 3. Add the nozzle temperature higher 5~10°C. 4. Maybe have a cover to cover the top of the printer when printing ABS to avoid the heat dissipation too fast. |
| How to evaluate if the filament enough or not to print the object? | After convert STL file to GCO file in Repetier-Host software, customer can see the needed filament usage (Length) of printing the object . Customer can evaluate the actual filament length is enough to meet the needed filament length. |
| How to clean the coating glass platform if the remain filament stick on it? | <ol style="list-style-type: none"> 1. Clean the glass platform using lint-free cloth or wet tissue. Do not use alcohol or any cleaning chemical solution in cleaning the glass platform, it will damage the glass coating. 2. If still cannot clean the remain filament on the glass platform, please replace a new one. |
| How to download Repetier for Mac OS or Linux? | Go to website Repetier.com to free download the Repetier software for operation system Mac OS or Linux. |
| How to get free 3D modeling software? | Website to download free 3D modeling software: http://www.hongkiat.com/blog/25-free-3d-modelling-applications-you-should-not-miss/ |
| How to get free 3D model to print? | <ol style="list-style-type: none"> 1. Use 3D modelling software such as UG, 3DMAX and above free software to design your 3D model file and save as STL format. 2. Use scanner to scan 3D model . We recommend scanner "Structure Sensor" which need work with APPLE IPAD. 3. Download 3D model from Website: http://www.thingiverse.com http://www.hongkiat.com/blog/download-free-stl-3d-models/ http://www.hongkiat.com/blog/60-excellent-free-3d-model-websites/ |

If you need more assistance, kindly please contact with us:

Email: 3Dsupport@utec.com.mo