

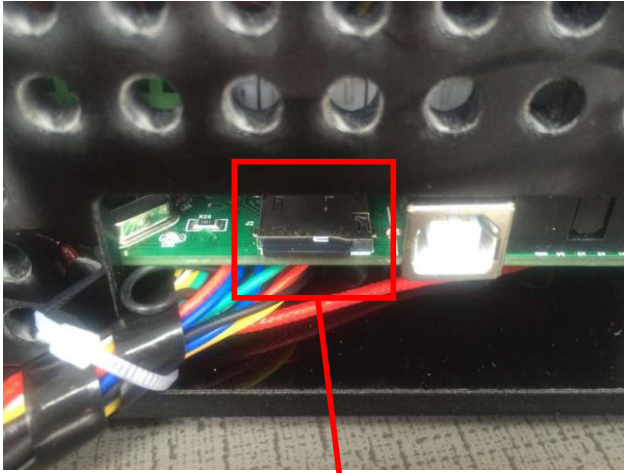
Tronxy 3D Printer X3

Operating Instruction

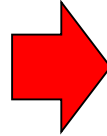


Preparatory Work

Turn on the power after micro SD card insert, then you can control the machine using key-press and the LCD display, as picture below:



Micro SD card slot is at the back of the electronic box, near the USB Interfaces.



Plug in adaptor after Micro SD card is inserted.

LCD screen and Key-press function instruction

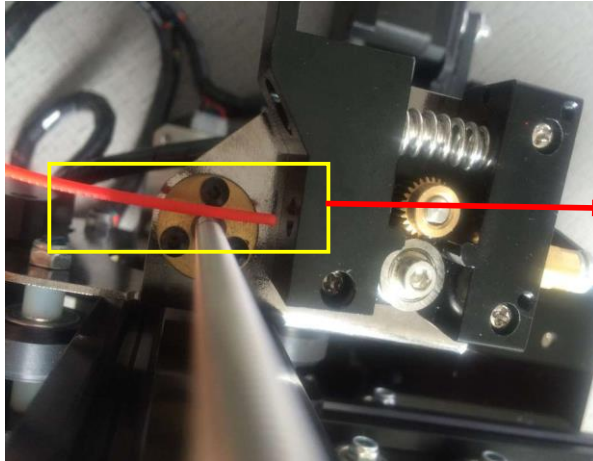


Key-press Name	Key-press Function	Remark
Left	Back To Previous Menu	
Right	Go to next menu/Enter key	
Up	Menu Up / Add	
Down	Menu Down / Minus	
Middle	Start menu	

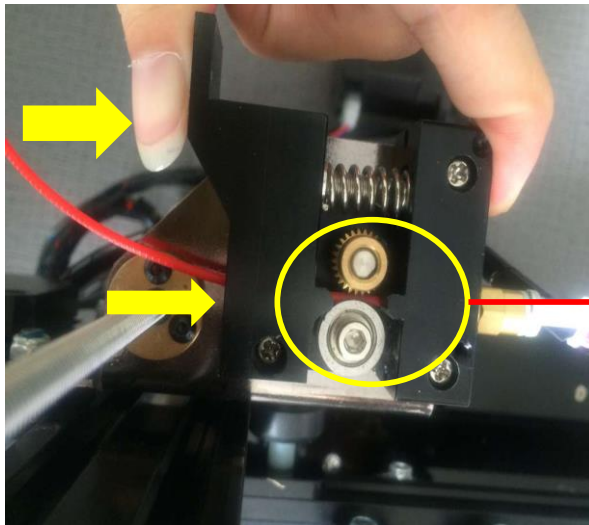
Loading & Unloading PLA

Loading PLA :

- 1, Press menu button, select 'Preheat PLA', then Right key to confirm.
- 2, Take the filament and then straighten one end after Temp. up to 190 degrees.
- 3, Press the extrusion clip, feed the filament into the hole.
- 4, Run the filament along the teflon tube until the filament comes out from the nozzle.



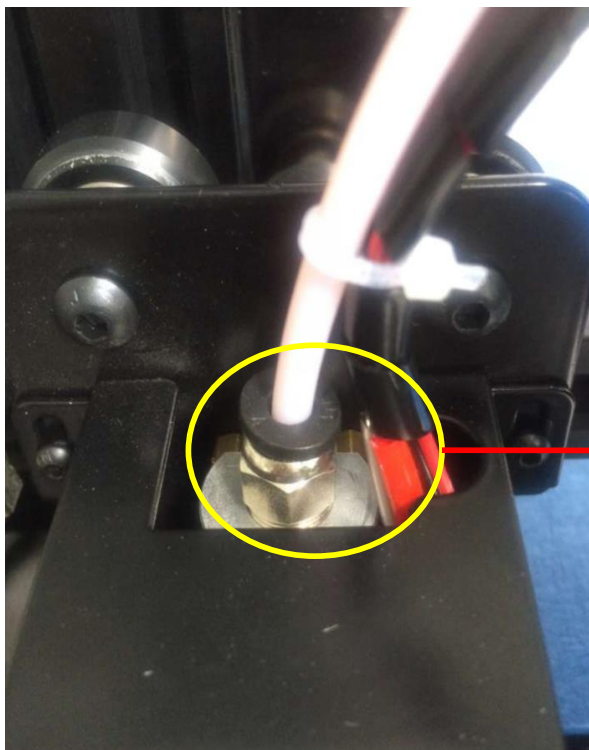
Straighten one end of the filament



Feed the filament into the hole

Unloading PLA :

- 1, As in the above, Press menu button, select 'Preheat PLA', then Right key to confirm.
- 2, Press the extrusion clip, pull out the filament from the nozzle after Temp. up to 190 degrees



Until the filament into the nozzle through here

Level Instruction

In order to better printing , we also need to level the print bed or the filament may not adhere to the bed that result in poor printing quality and can not print.

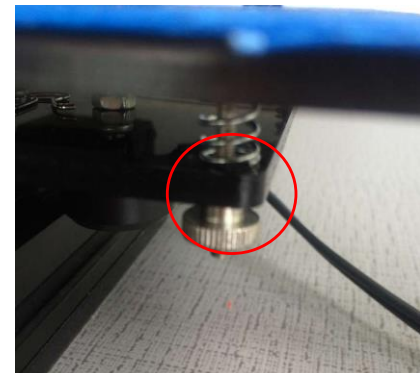
1	Please clean the nozzle to make sure there are no remained material before leveling.
2	Turn on the power, press the menu button , select ‘ Quick setting ’ , then select ‘ Home all ’ , the printer start homing. (Figure 1)
3	After Home all , press menu button to select ‘ Disable stepper ’, then you can move the axis manually. (Figure 2)
4	Move the extruder and platform manually, observe the distance between nozzle and four corners of the platform and to assure the same distance of them . If higher or lower , please adjust the thumb nuts below the bed frame.
5	Note: You can put one A4 paper between the nozzle and platform, pulling the paper backwards and forwards, if it happens to have a little bit of resistance, that is well spaced.



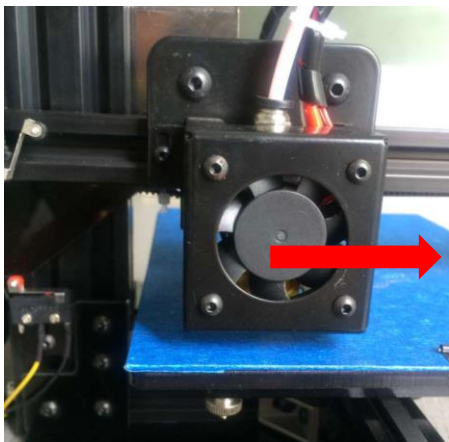
Figure 1



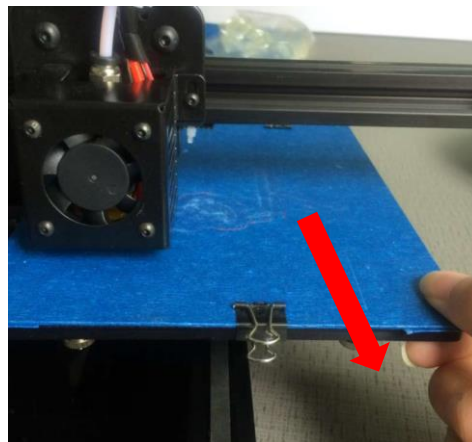
Figure 2



Adjust the thumb nut



Move extruder



Move platform



Observe distance



Observe distance

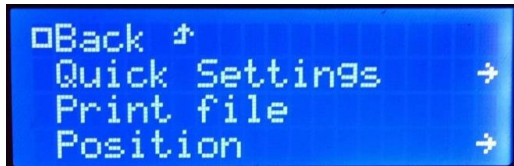
Off-line Printing

Operate the printer with the key-press and LCD screen after print bed is leveled, as shown below:



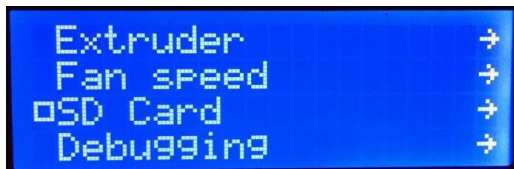
36.7/ 0°
Z: 0.00 Buf: 0
Mul: 100 Flow: 100
Printer ready.

You will see the '**monitoring interface**' first after power on



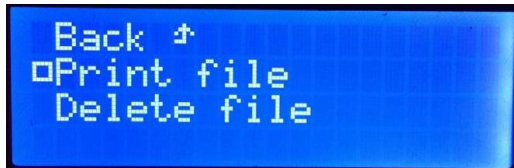
Back ↑
Quick Settings →
Print file
Position →

Press menu button go into '**menu screen**'.



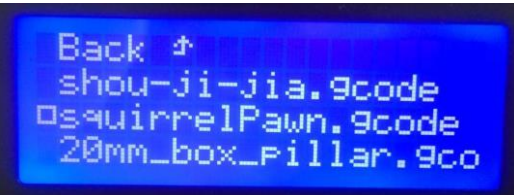
Extruder →
Fan speed →
SD Card →
Debugging →

Press Down key after into menu, then you will see '**SD card**'



Back ↑
Print file
Delete file

Press Right key and select '**SD card**', and then press Right key select '**Print file**'.



Back ↑
shou-ji-jia.gcode
squirrelPawn.gcode
20mm_box_Pillar.gco

Select a **Gcode file** which you want to print, then press Right key to start print.



200.0/200°
Z: 0.60 Buf: 16
Mul: 100 Flow: 100
Printing... 2%

You'll see the monitor interface when printing, it shows Nozzle temperature, and the printing completion rate.



Back ↑
Pause Print
Stop Print

If want to '**Pause Print**' or '**Stop Print**', Press Manu key ,select '**SD card**',then the screen will appear the interface as left picture . Select Pause or Stop , press Right key to confirm.