



FDM 3D PRINTER

User Manual

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Notice

Dah Hsian Seetoo Library Maker space

● 3D Printer software :

1. Import the file into the PING Slicer V1.4 software for printing.
2. Choose PING+ (single-material printer) or DUAL+ (dual-material printer) based on your requirements.
3. Adjust parameters ***** If you are unfamiliar with the parameter meanings, please use default setting values; If you wish to understand the setting better, please consult the counter. For dual-material printing; During dual-material printing, it is recommended to open the dual-material optimization mode.*****
4. Save the file in SD card.

● Machine Operation Procedure :

1. Insert the SD card into the 3D printer.
2. Turn on the machine by the red power button on the right side.
3. Choose your PLA filament.
4. Trim the front end of the PLA in to a sharp angle and hang it on the machine.
5. Pass the PLA through the throat tube. Please check the direction by the arrow on the material breakage detector.
6. Click on the panel 'Electrical Control'(電機控制)→ 'Control'(周邊控制) → Click on the nozzle and heated bed icons to turn on the power.
7. After reaching the set temperature, click on 'Continuous'(連續) →click the 'Down arrow icon'(向下箭頭) then the printer will then push the PLA material into the nozzle."
8. 3D printer will start eject PLA material. Check if the ejecting process is stable, and click 'Continuous'(連續) to stop feeding.
9. Check the printing platform is smooth, if not, ask for the service counter.
10. Click 'Start Printing'(開始列印) and select the file.
11. While the printing completed, use a scraper to detach the model from the platform.
12. Clean the print platform.

13. Click on the panel 'Electrical Control'(電機控制)→'Control'(周邊控制) →click on 'Continuous'(連續) →click the 'Up arrow icon'(向上箭頭)
14. Wait for the temperature rising; the machine will eject PLA material.
15. Turn off the power and return the PLA material.

● **NOTICE :**

1. If you need to replace PLA material, please request assistance from the service counter. Do not attempt to retract or feed materials on your own.
2. Printing consumable material : PLA (diameter 1.75mm).
3. File format : STL 、 OBJ 、 AMF