LIGHT-CURING 3D PRINTER

User Manual

3D Printer software
Machine Operation Procedure
Notice

Dah Hsian Seetoo Library Maker space

● 3D Printer software

1. Importing Files into CHITUBOX Software

2. Adjust parameters.

   Stick to the original default values; do not adjust them arbitrarily if you are unfamiliar with their meanings.

3. Please remember to incorporate a supportive base on the button the model design to prevent difficulties in removing printed objects from the print bed.

4.. Save the file to a USB flash drive.

● Machine Operation Procedure

1. Insert the USB flash drive into the computer on the right side of the printer.

2. Turn on the red power button on the right side.

3. Open a browser, then enter the IP address displayed on the machine in the address bar.

4. Choose the file you want to print or add a new file.

5. While waiting for the machine reading the file, you can pour resin into the tank. Please note that do not exceed half of the tank's height.

   Before pouring, please shake the resin evenly to avoid poor molding. Then use a filter to the resin. If the resin is already in the tank, stir it thoroughly before printing.

6. Start printing.

7. While the printing is complete, use a soft scraper to remove the printed model.

Do not use a metal scraper to remove the model to avoid from damaging the print bed.

8. After confirming that the machine is idle, turn off the main power of the machine.

9. Remove the resin tank and the upper print platform (metal adhesive surface).

10. Use a soft scraper to clean the resin tank and print bed. Pour any remaining resin back into the sealed container.

11. Soak the model in alcohol to remove surface residues. For complex structures, repeat this process 2-3 times. Do not soak for too long each time to avoid model cracking.

12. Immerse the model in rubbing alcohol to remove surface residue. If the structure is complex, repeat this process 2-3 times, ensuring that each soaking period is not excessively long to prevent the model from cracking.

13. Place the model in a cool and shaded area to air-dry for at least 30 minutes.

14. Further dry the model using an X-ray dryer. Both the drying and X-ray exposure periods should be set for 30 minutes each.

15. After air-drying, remove the model supports.

16.

- **Notice**：

1. In the 'Print Settings' page, you can pause and stop printing.

2. If there may not be enough resin during printing process, please refill resin to the

3. If resin splashes onto the machine, please wipe it off immediately.

4. If it is necessary to remove the resin tank, it is strongly recommended to power off the machine before proceeding with the removal.

5. Molding dimensions: Below 190*120*200 mm

6. **Please note:** Scaling the model may alter the thickness and strength of the finished product.