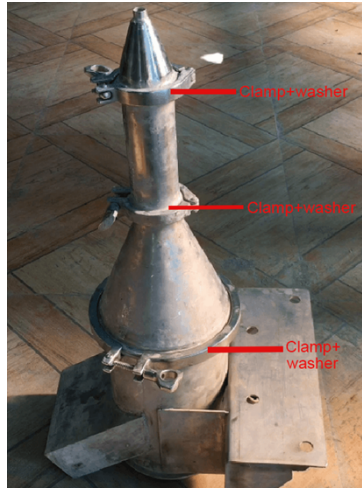


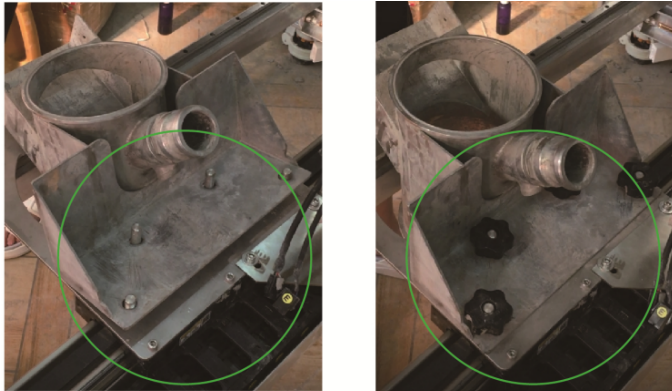
# ZCC 1215H/2020H Concrete 3D Printer

## ▼ Installation

1. Assemble the barrel part of the extruder. Place a washer at each connection point and secure it with a clamp. (Figure P-1) Clamp + Washer

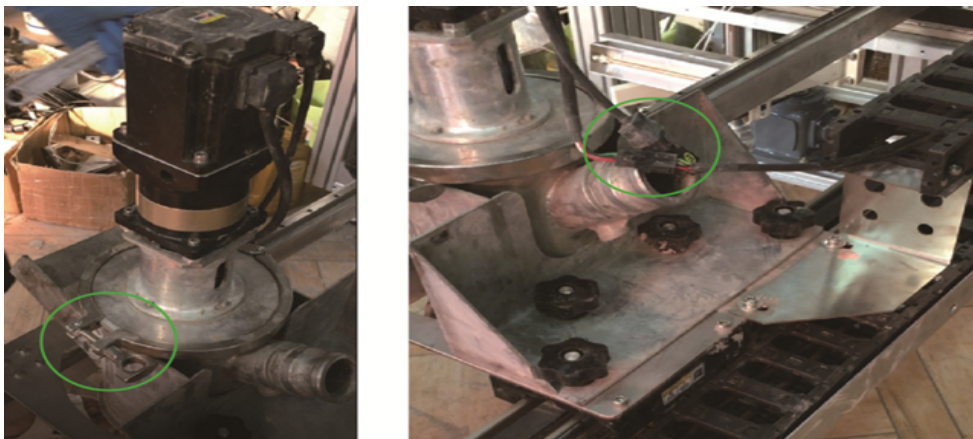


2. After assembly, place it on the mounting plate of the machine extruder, align the slots, and tighten the nuts for fixation. (Figure P-2)



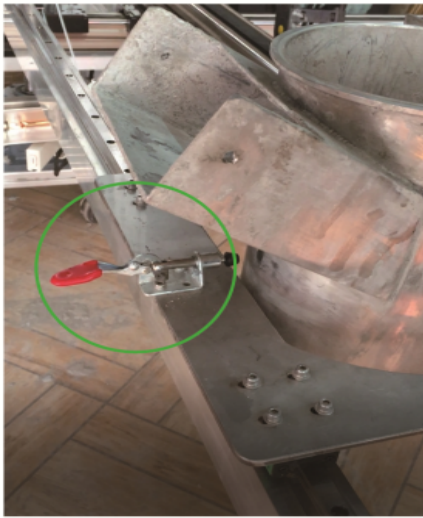
(P-2)

3. Install the (motor + screw) part of the extruder, place a washer at the joint, and use a clamp to lock the upper and lower parts together. Connect the two motor wires on the motor to the wires in the drag chain. (Figure P-3)



(P-3)

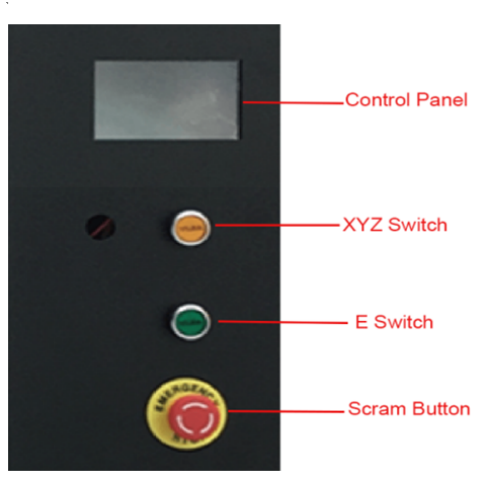
4. Fasten the quick clamp in front of the extruder mounting plate to fix the material barrel.  
(Figure P-4)



(P-4)

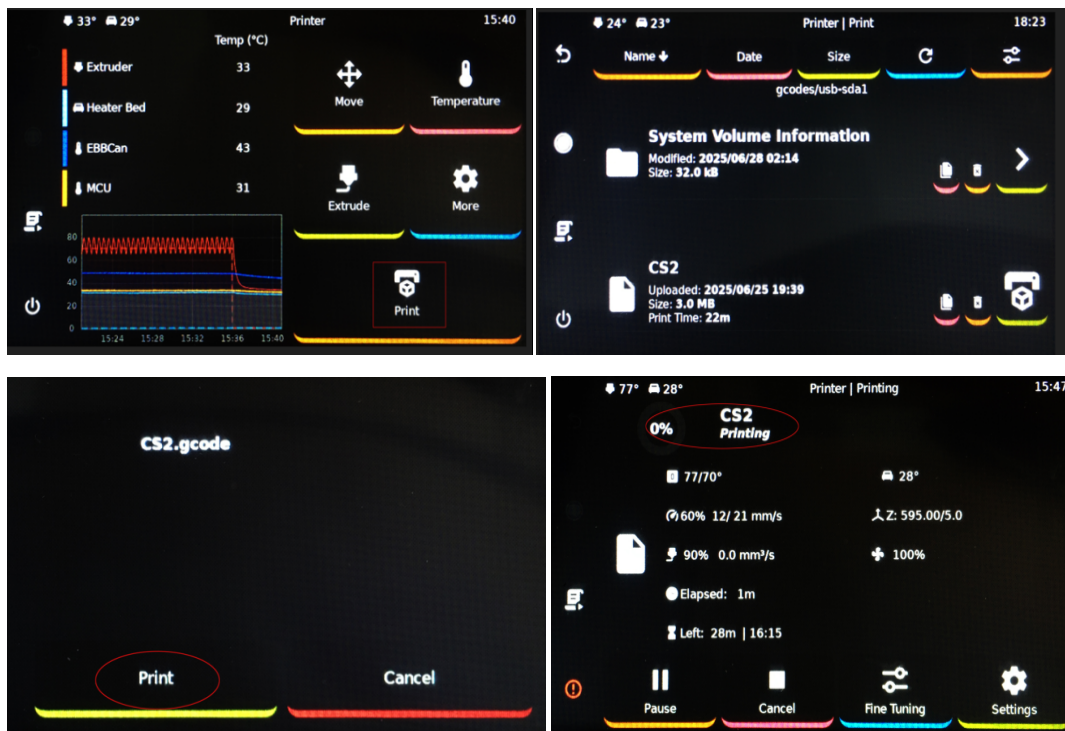
# ▼ Printing Operation

1. Apply power to start the equipment (Figure P-5)



2. In Control Panel, click [Print] and select the filename to be printed (Figure P-6)

\* To print documents, insert a USB drive or connect the device to a computer via wireless network for file transfer



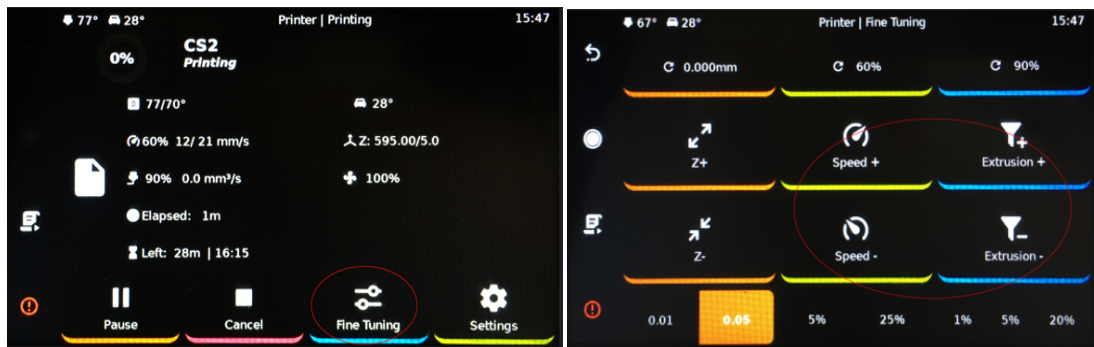
3. Add the clay into the extruder (manual feeding or pump unit feeding optional) and monitor the printing process. (Figure P-7)



Manual feeding

Pump unit feeding

4. During printing, parameters can be adjusted in real-time based on print status. Select [Fine-tune] to adjust [Extrusion Rate] + [Print Speed] settings. (Refer to Figure P-8)



5. When the clay strip can be extruded continuously, stop printing. After cleaning the clay on the platform, follow the above steps to restart formal printing. (Figure P-9)

\* Intermittent extrusion indicates potential insufficient clay in the extruder. Maintain clay supply until continuous flow resumes.

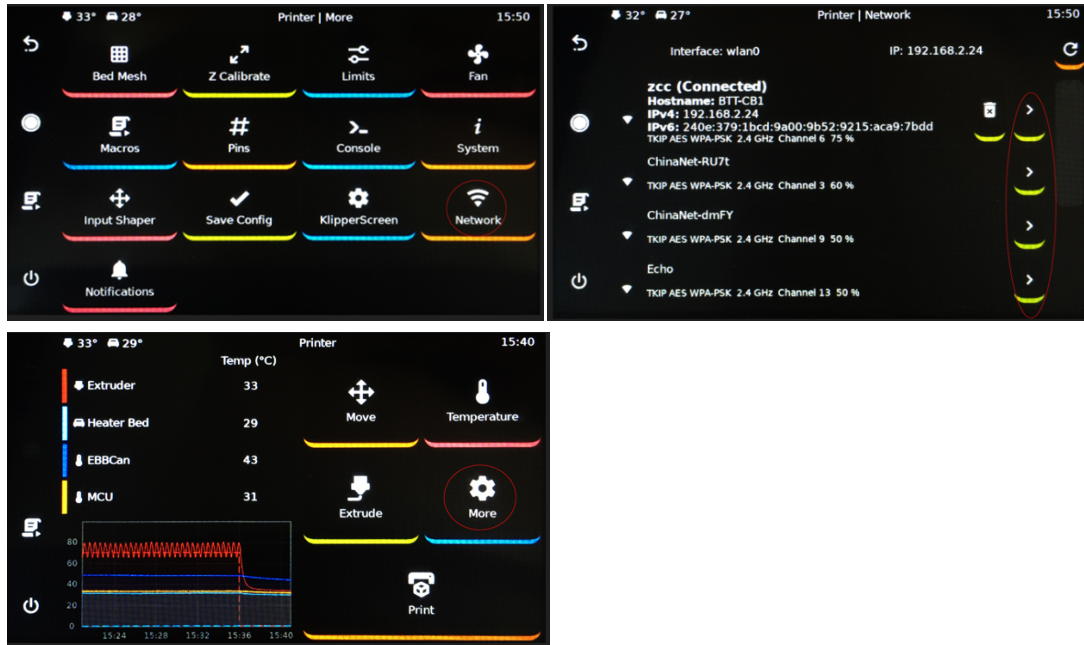
\* If the clay strips do not form properly, please adjust the material formula.



## Wireless print setting

1. Connect the equipment to a wireless network. Upon system startup, navigate to Control Panel → [More Settings] → [Network].

\* To print from the computer end, connect the device and the computer to the same wireless network. (Figure P-9)

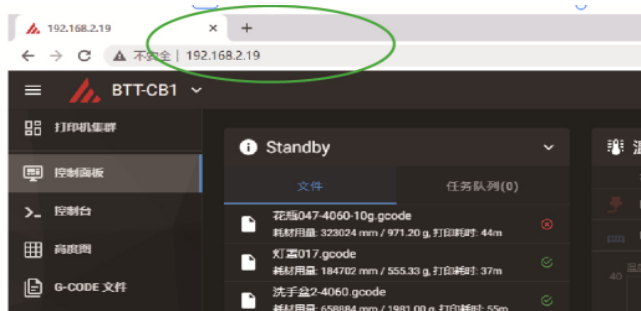


2. Please note that on the interface for selecting the connection network, there is the IP address of the current device. This will be needed when operating on the computer side. Please pay attention to it. (Figure P-10)



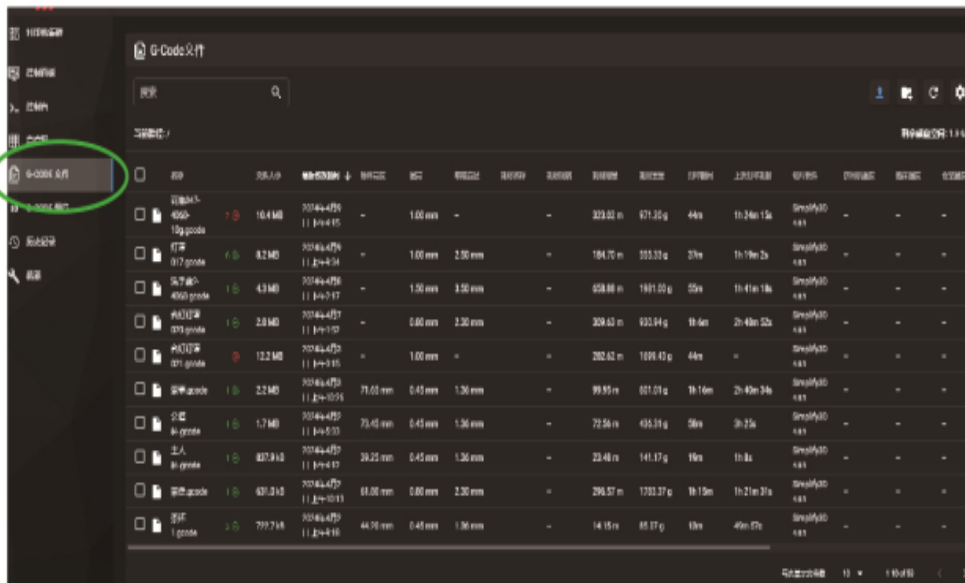
(P-10)

3. Enter the device's IP address in the browser of the computer to access it. (Figure P-11)



(P-11)

- Access the [G-CODE] interface in the left menu bar and upload the target model file for printing. (Figure P-12)



(P-12)

- On the [Control Panel] interface, it can also make real-time adjustments to the parameters during the printing process. (Figure P-13)



(P-13)