

Clay Printer Printing Operation

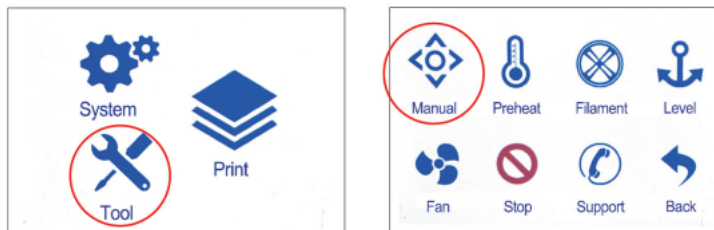
Suitable for - zcc3040 zcc4060 zcc5080 model

1. Power on - The circular start button on the right side distribution cabinet on the front of the device. (Fig. P-19)



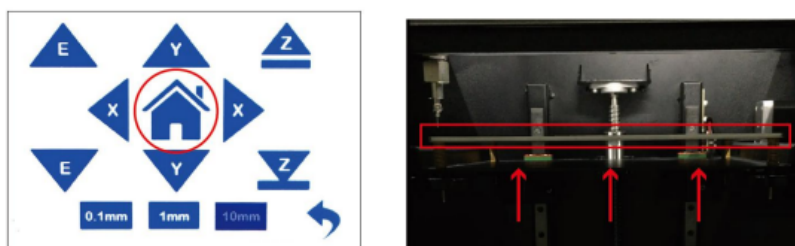
2. Adjust the printing platform.

- ①Click on the [Tools] - [Manual] icon in the control panel. (Fig. P-20)



(P-20)

- ②Click on the [House] icon to bring the printing platform back to its origin.(Fig. P-21)



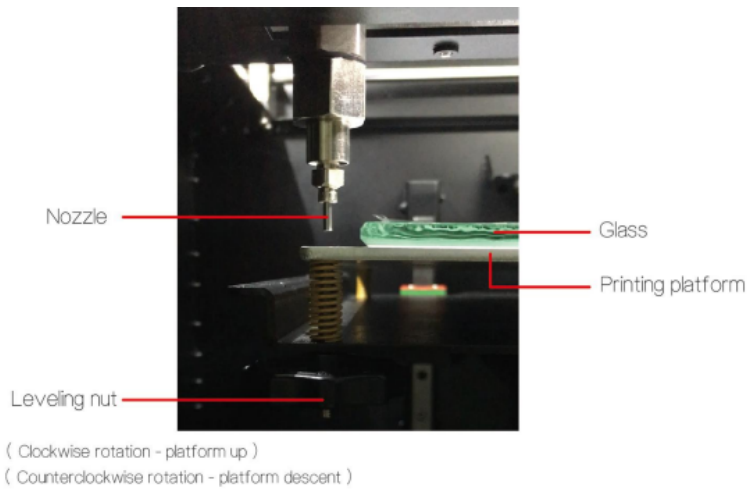
(P-21)

- ③After the platform returns to its original position, place the processed glass inside. (Fig. P-22)

***Due to bumps during transportation, the platform may experience displacement, causing it to be too close to the nozzle after returning to its original position, resulting in the inability to place the glass. If this situation occurs, please adjust the platform in the following way.**

- a、 Rotate the leveling nut below the platform counterclockwise to lower the platform. (Fig. P-22)
- b、 Four leveling nuts need to be adjusted to lower the platform position, so that the glass can be inserted.

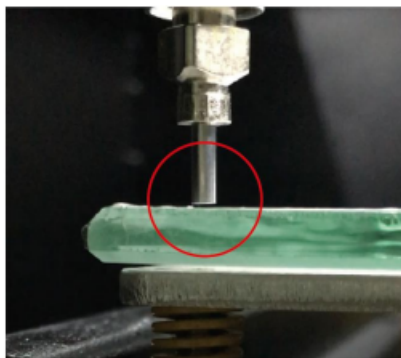
(Note: Clockwise rotation - platform up; Counterclockwise rotation - platform descent)



(P-22)

④ Fine tune the distance between the glass and the nozzle. (Fig. P-23)

- a. After inserting the glass, use the leveling nut (Fig. P-22) under the platform to adjust the distance between the nozzle and the glass.
- b. It is recommended to reserve a distance of about 1-2 A4 paper thicknesses.(Fig. P-24)

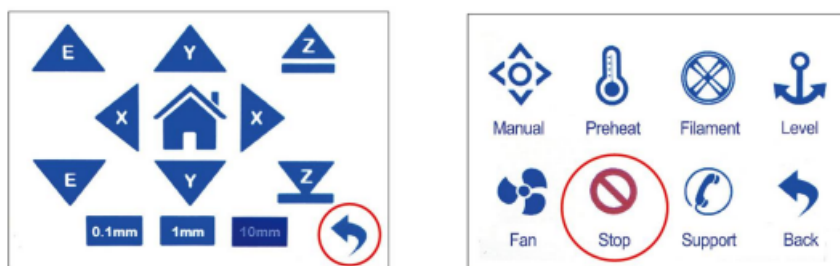


(P-23)



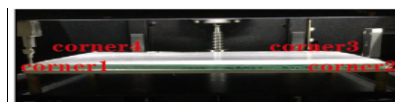
(P-24)

c. After completion, click on the [Back] icon in the bottom right corner of the control panel, and then click on the [Stop] icon (Fig. P-25)



(P-25)

d. After clicking the [Emergency Stop] icon, follow the adjustment method in steps a and b above to manually push the extruder to the other three corners of the glass and adjust the distance



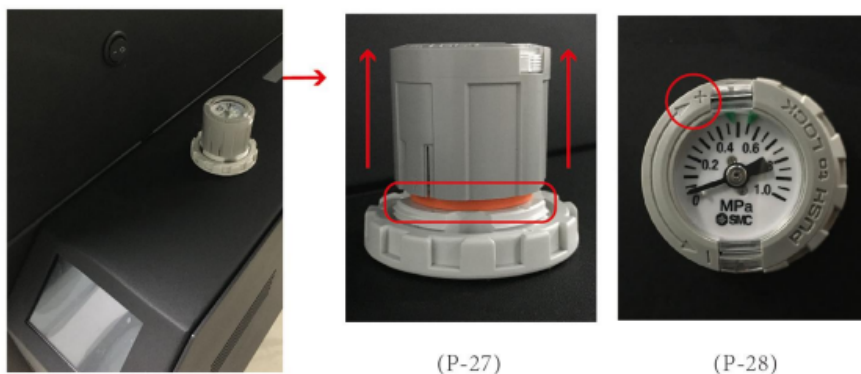
(P-26)

between the glass and the nozzle in sequence.(Fig. P-26)

3. Check the mud discharge of the extruder.

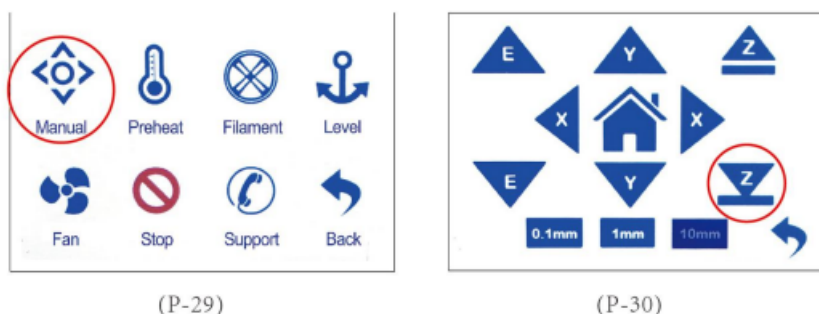
① Increase air pressure - Pull up the pressure regulating valve knob upwards until the orange part is exposed.(Fig. P-27)

② After exposing the orange part, rotate the knob in the direction of [+] to increase the air pressure (Fig. P-28), and the general adjustment range is [0.45-0.6MPa]

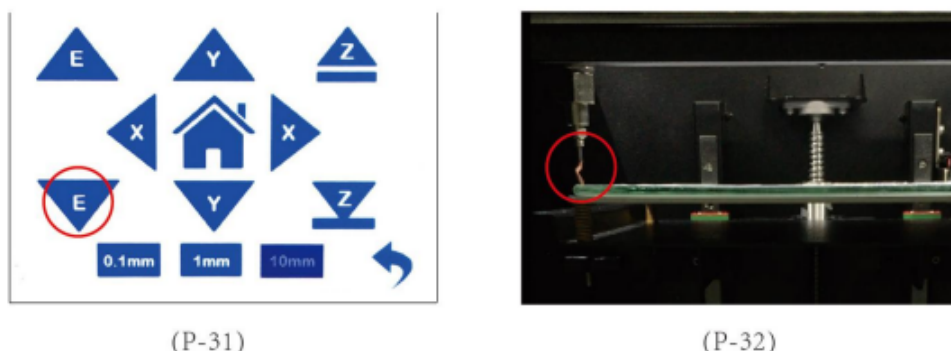


③ Click the [Manual] icon in the control panel. (Fig. P-29)

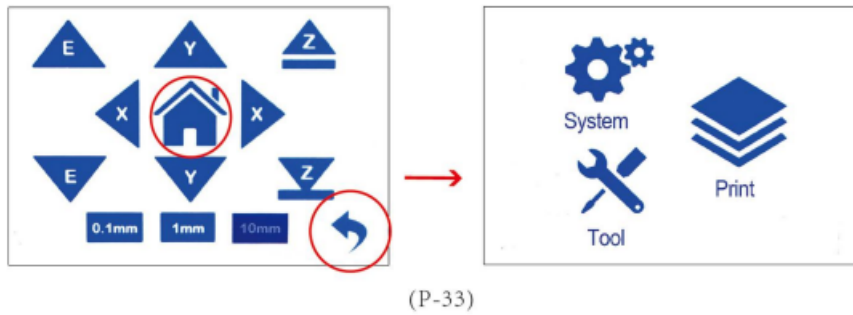
④ Then click on the downward [Z] icon to lower the platform to a certain height for easy observation of the mud situation. (Fig. P-30)



⑤ After the platform descends, click on the downward [E] icon (Fig. P-31) in the control panel. If it is the first time to use it, click a few more times to observe whether the nozzle emits mud smoothly.(Fig. P-32)



⑥ There is no problem with mud discharge. After removing the excluded mud, click on the [House] icon in the control panel to return the platform to its original position, and then continue to click on the [Back] icon to return to the main interface. (Fig. P-33)



*In case of inability to squeeze out mud or low mud output:

- a. Attempt to increase air pressure (adjustment range not exceeding 0.6MPa);
- b. Check if each air pipe connection is properly inserted to avoid air leakage;
- c. Check if there are any foreign objects blocking the inside of the extruder;
- d. Check if the mud used is too dry and replace it with a harder mud.

4. Insert and remove the SD card. (Some machines use USB drives.)

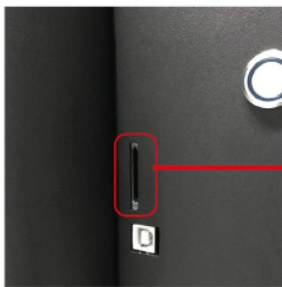
①The card slot is located on the power distribution cabinet on the right side of the machine.

(Fig. P-34)

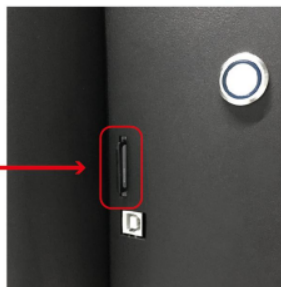
②Place the side with the chip facing upwards into the card slot and gently press inward.

(Fig. P-35)

③When removing a memory card, first press the card inward and wait for it to pop out before removing it.



(P-34)



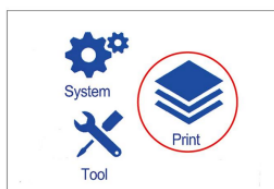
(P-35)

5. Printing

①Click on the [Print] icon in the control panel. (Fig. P-36)

②Click on the model name that needs to be printed. (Fig. P-37)

(There is a printed model in SD)



(P-36)



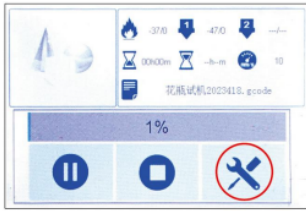
(P-37)

③Click on the second [Start] icon on the right to start printing. (Fig. P-38)



(P-38)

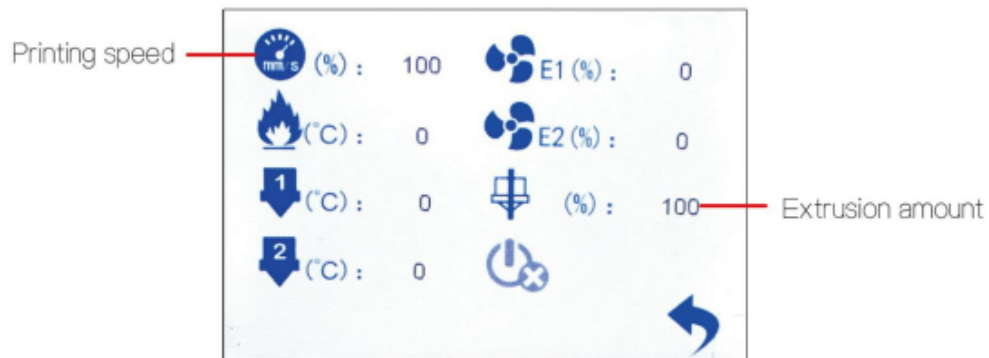
④ You can adjust the printing parameters at any time by observing the printing situation. Click on the first | Settings | icon in the lower right corner of the control panel.(Fig.P-39)



(P-39)

⑤ Adjust the amount of mud and printing speed according to the printing situation.(Fig. P-40)

- The printing speed of models with excessive hanging angles should not be too fast.



(P-40)