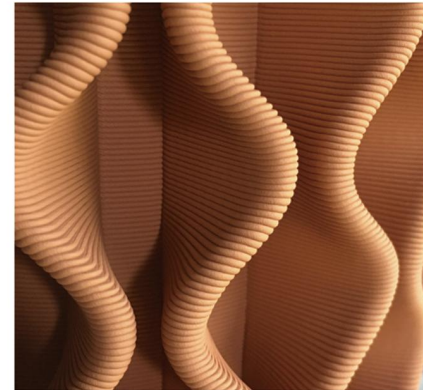


CERAMIC 3D PRINTER



INSTRUCTIONS

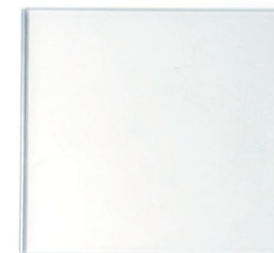
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Power line



Barrel



Glass



Cling film



Tube and
Air Compressor Tie-in



Spanner



Hex Wrench



Extruder



Regulating valve



Nozzle



Hex Screw



Card reader



SD card



(P-1)

1、 Check the appearance of the equipment for any damage. (Fig. P-1)



(P-2)

2、 Please use a 3mm hex wrench to remove the built-in handle and reinstall it on the outside. (Fig. P-2)



(P-3)



(P-4)

3、 Use (Fig. P-4) parts and tools to install the extruder assembly.

①Connect the air pipe inside the equipment to one end of the pressure regulating valve. (Fig. P-5)

②Fix the pressure regulating valve on the machine with M4×6mm screws and tighten it with a 3mm hex wrench. (Fig. P-6)



(P-5)



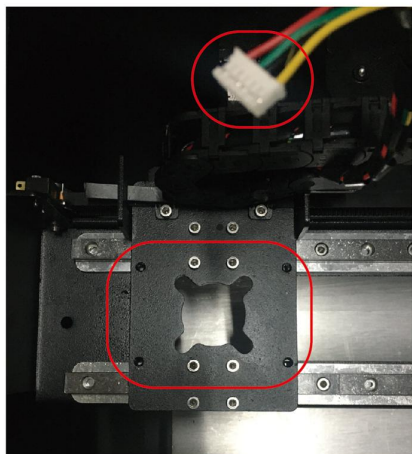
(P-6)



(P-7)

4. Use (Figure P-7) parts and tools to install the extruder assembly.

- ① Place the extruder into the fixed plate on the equipment slide. (Fig. P-8)
- ② Tighten and secure with screws, and insert the wires. (Fig. P-9)



(P-8)



(P-9)



(P-10)



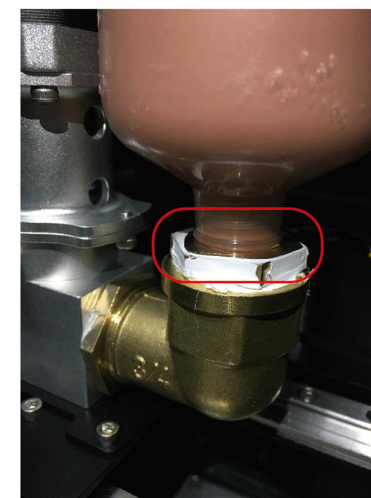
(P-11)

5. Install the material Barrel. (Fig. P-10)

- ① Rotate the mud filled material barrel into the feed port on the right side of the extruder. (Fig. P-12)
- ② Tighten the material barrel to prevent external air from entering and affecting the printing effect. (Fig. P-13)



(P-12)



(P-13)



(P-14)

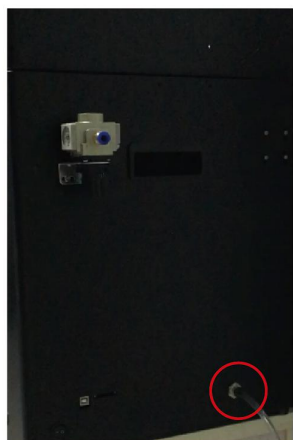


(P-15)

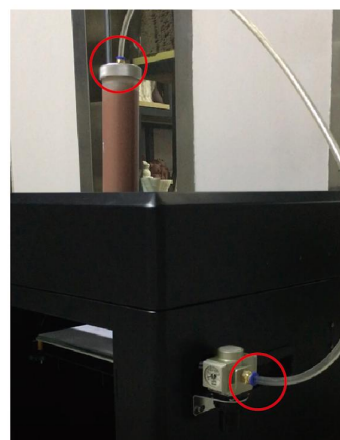
6. Connect the air pressure. (Fig. P-15) Operate while the air compressor is not running.

① Insert one end of the air hose connector into the air compressor and the other end into the right air inlet of the equipment. (Fig.P-16)

② Connect the pressure regulating valve and the material cylinder with another air pipe. (Fig. P-17)



(P-16)



(P-17)



(P-18)

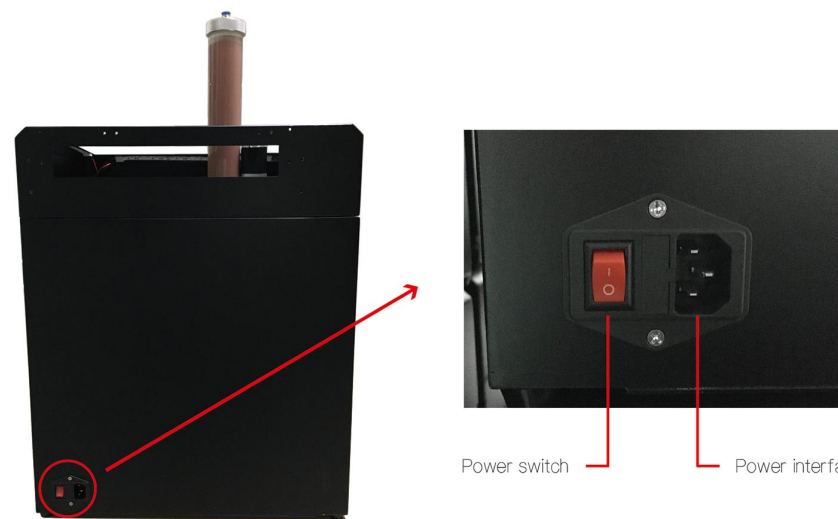


(P-19)

7. Connect to the power supply. (Fig. P-19)

① Insert the power cord into the power interface at the back of the device. (Fig. P-20)

② Turn on the power switch after inserting the wire. (Fig. P-20)



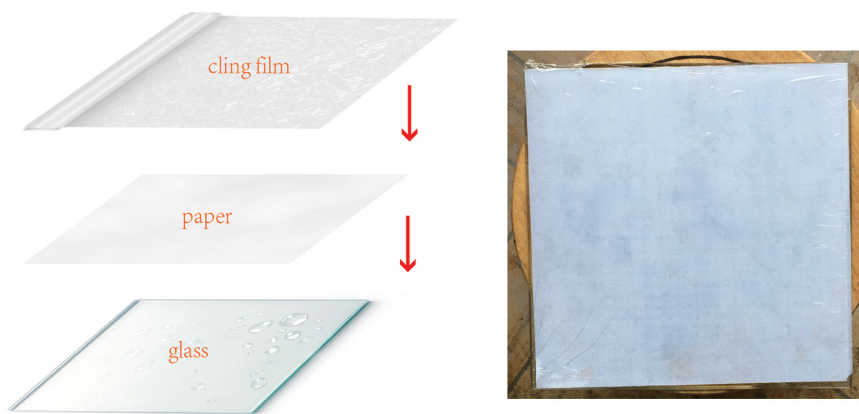
(P-20)



(P-21)

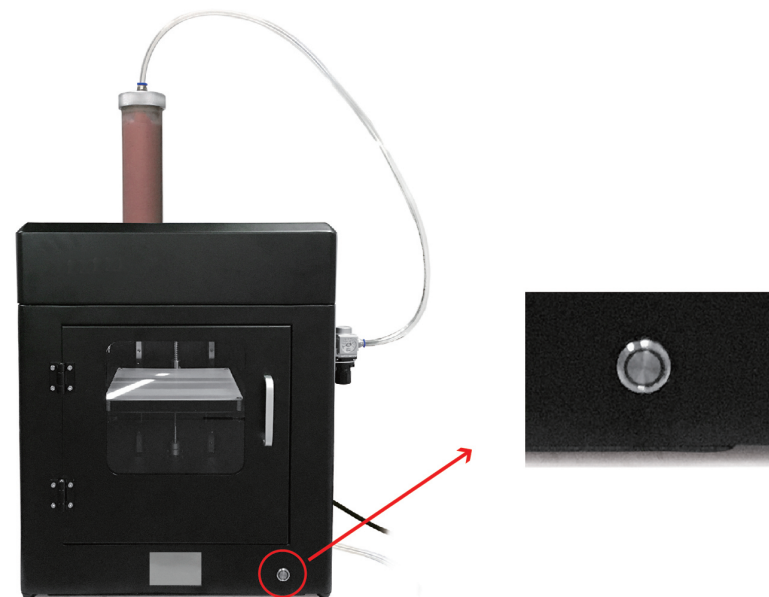
8、Print glass processing. (Fig. P-22)

- ①First, lay the glass flat on the table and sprinkle a small amount of water;
- ②Lay the paper flat on the glass;
- ③Finally, attach a layer of cling film and flatten it, making sure that the size of the paper and cling film does not exceed that of the glass.



(P-22)

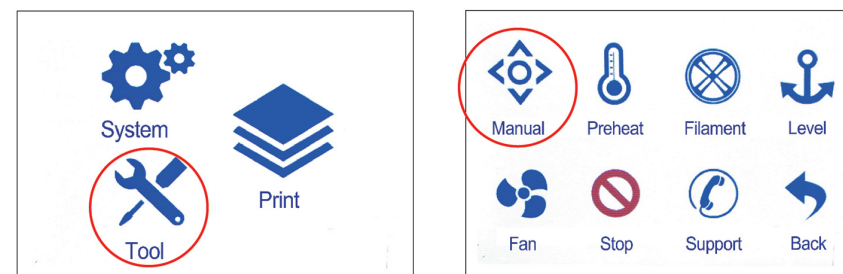
- 1、Power on - Press the circular start button in the lower right corner of the front of the device. (Fig. P-23)



(P-23)

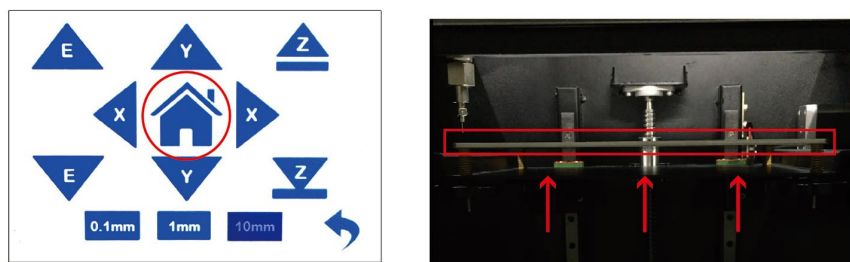
2、Adjust the printing platform.

- ①Click on the [Tools] - [Manual] icon in the control panel. (Fig. P-24)



(P-24)

②Click on the [House] icon to bring the printing platform back to its origin.(Fig. P-25)

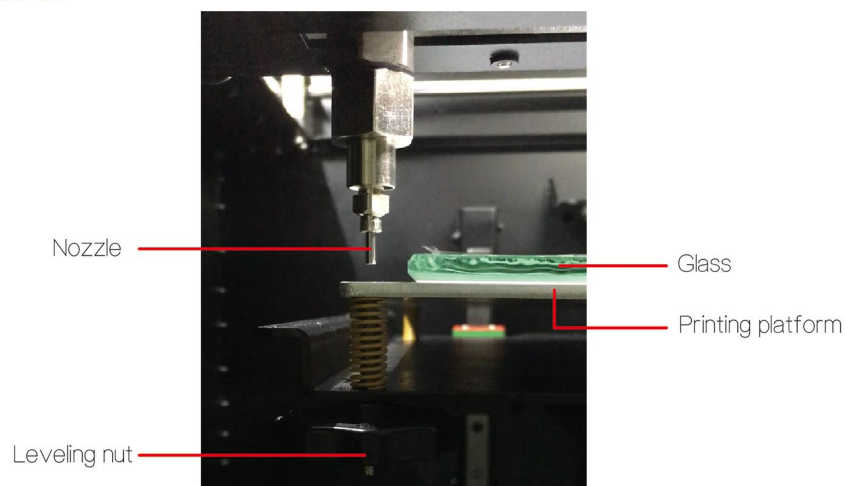


(P-25)

③After the platform returns to its original position, place the processed glass inside. (Fig. P-26)

*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-26)
- b、 Four leveling nuts need to be adjusted to lower the platform position, so that the glass can be inserted.

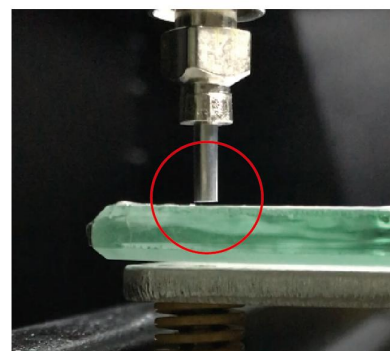


(Clockwise rotation - platform up)
(Counterclockwise rotation - platform descent)

(P-26)

④Fine tune the distance between the glass and the nozzle.(Fig. P-27)

- a、 After inserting the glass, use the leveling nut (Fig. P-26) 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-28)

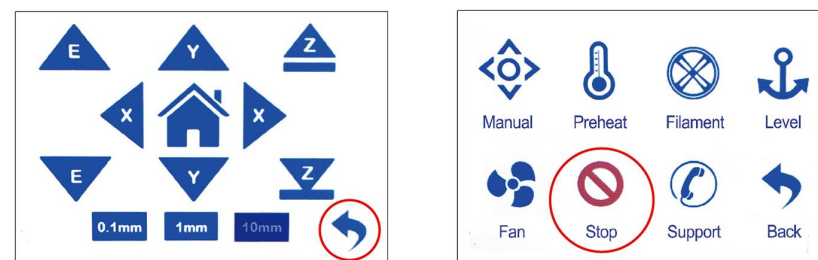


(P-27)



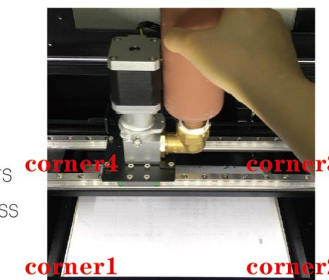
(P-28)

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-29)



(P-29)

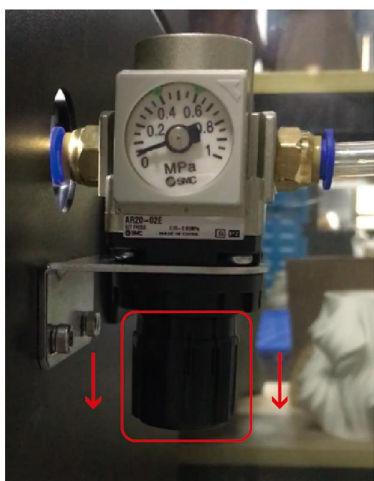
d、 After clicking the [Emergency Stop] icon, follow the adjustment method in steps a and b above to manually push the extruder to the other three corners of the glass and adjust the distance between the glass and the nozzle in sequence. (Fig. P-30)



(P-30)

3. Check the mud discharge of the extruder.

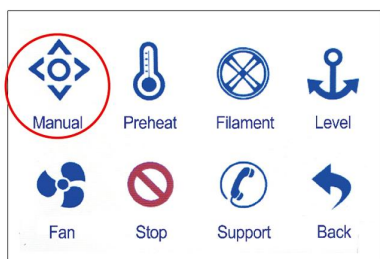
- ① Increase air pressure - pull down the pressure regulating valve knob until the orange part is exposed. (Fig. P-31)
- ② Then rotate counterclockwise to increase air pressure (clockwise - decrease pressure), with a general adjustment range of 0.45-0.6MPa. (Fig. P-31)



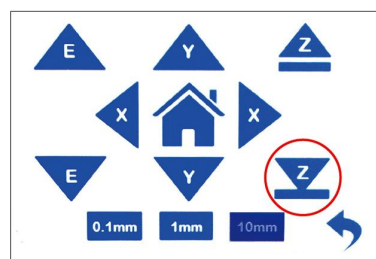
(P-31)



- ③ Click the [Manual] icon in the control panel. (Fig. P-32)
- 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-33)

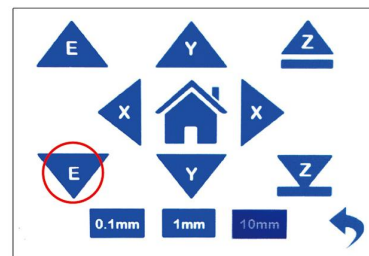


(P-32)

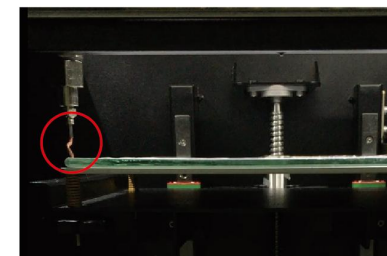


(P-33)

- ⑤ After the platform descends, click on the downward 【 E 】 icon (Fig. P-34) 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-35)

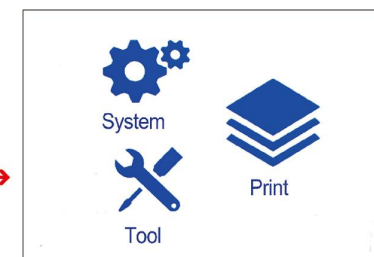
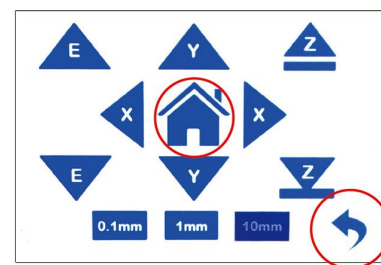


(P-34)



(P-35)

- 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. (图P-36)



(P-36)

*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.

- ①The card slot is located below the right side of the machine.(Fig. P-37)
- ②Place the side with the chip facing upwards into the card slot and gently press inward. (Fig. P-38)
- ③When removing a memory card, first press the card inward and wait for it to pop out before removing it.



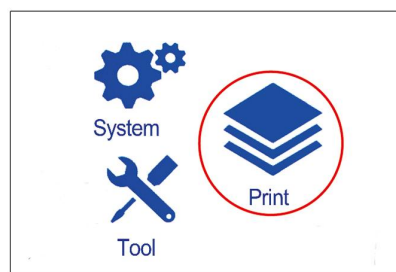
(P-37)



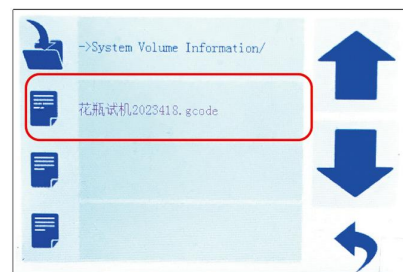
(P-38)

5. Printing.

- ①Click on the [Print] icon in the control panel. (Fig. P-39)
- ②Click on the model name that needs to be printed. (Fig. P-40)
(there is a printed model in SD)

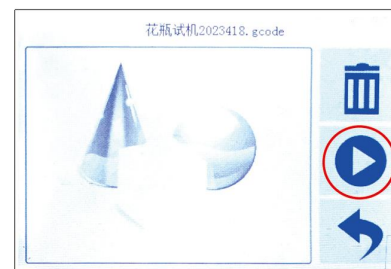


(P-39)



(P-40)

- ③Click on the second [Start] icon on the right to start printing. (Fig. P-41)

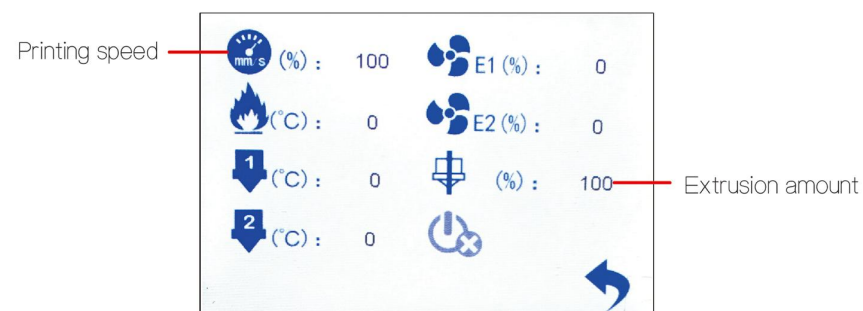


(P-41)



(P-42)

- ④You 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-42)



(P-43)

- ⑤Adjust the amount of mud and printing speed according to the printing situation. (Fig. P-43)

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

clay



(P-44)



(P-45)



(P-46)

1、 Take small pieces of mud and put them into the material barrel. (Fig. P-44)

2、 On a flat floor or tabletop, tap the material barrel up and down to expel air, making the mud more compact and fitting better with the wall of the material barrel. (Fig. P-45)

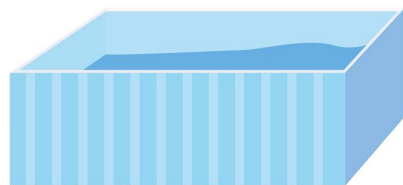
**The presence of bubbles in the mud can affect the printing effect and easily lead to uneven and non discharge of mud.*

3、 Repeat the above steps to load the mud to about 80% of the barrel, insert the piston, and tighten the material cover. (Fig. P-47)

**If the mud is not immediately used after being loaded, it can be stored in a water tank for moisture retention to prevent the mud from losing water and drying out.*

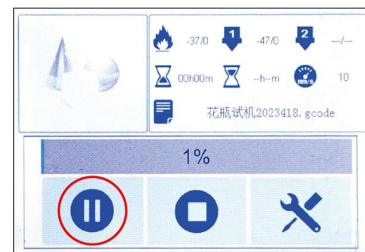


(P-47)

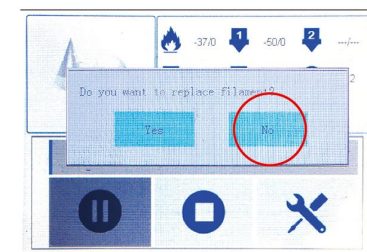


1、 Click on the first [Pause] icon in the bottom left of the control panel.(Fig. P-48)

2、 Click [No] in the new pop-up window. (Fig. P-49)



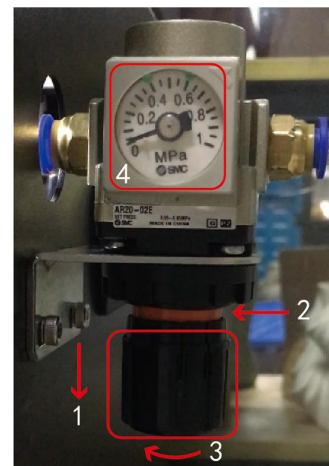
(P-48)



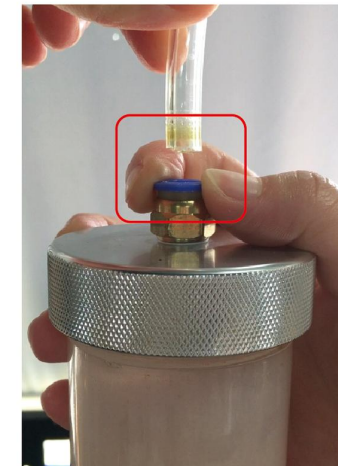
(P-49)

3、 Pull down the pressure regulating valve knob, expose the orange part, and then rotate the knob clockwise to release pressure to 0mpa. (Fig. P-50)

4、 Press the blue interface on the material cover and pull out the air pipe.(Fig. P-51)



(P-50)



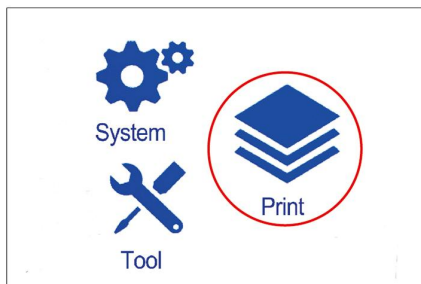
(P-51)

4、 After replacing the material cylinder, reconnect the air pipe, increase the pressure, and click on the first [Start] icon in the bottom left of the control panel to continue printing. (Fig. P-52)



(P-52)

1. If there is an unexpected power outage during printing, restart the device after the power is restored.
2. Click on the [Print] icon in the control panel. (Fig. P-53)



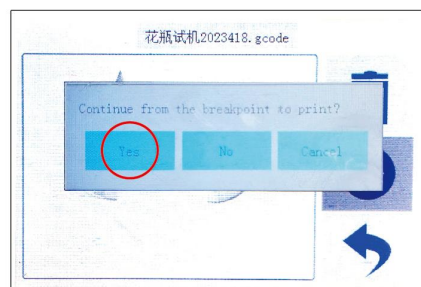
(P-53)

3. Select the model that was being printed before the power outage. (Fig. P-54)



(P-54)

4. 在Select [Yes] in the new pop-up window to continue printing from the point of power outage interruption. (Fig. P-55)



(P-55)

*If there is no printing for a long time in the later stage, the material barrel and extruder should be cleaned in a timely manner after the current printing work is completed.

1. Storage and cleaning of material barrels.

①After printing is completed, cut off the power supply, release the pressure through the pressure regulating valve, and then remove the material cylinder from the extruder unit.

②If there is a lot of mud remaining, the entire material barrel can be soaked in a water tank for storage and continued use next time.

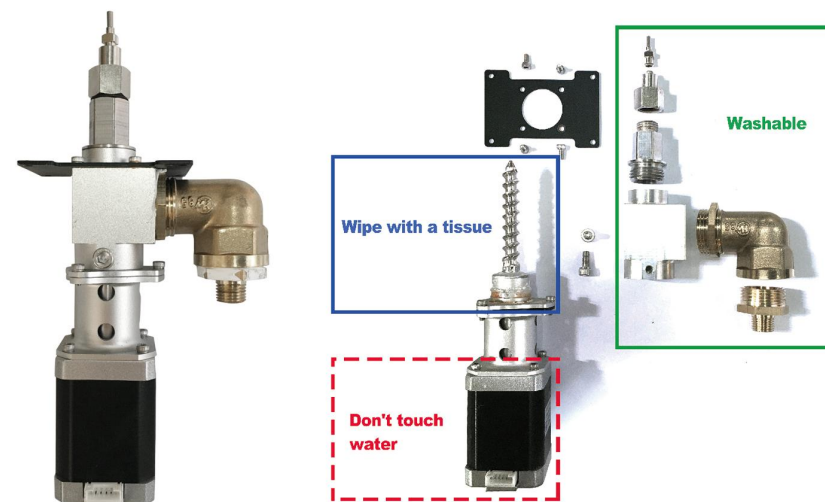
③If there is less remaining clay it is recommended to clean it directly.

- a. Remove the metal cover ;
- b. Invert the material cylinder and tap it down on a flat tabletop or ground to remove the piston ;
- c. Cleaning tools such as brushes can be used to clean the inner wall of the material barrel.

2. Clean the extruder components.

①Pull out the motor connection wire and use a 2.5mm hex wrench to remove the extruder from the slide rail.

②Disassemble the extruder and clean the internal mud, taking care not to touch the motor part with water. (Fig. P-56)



(P-56)

3、 Other precautions.

- ① Do not place the device in a damp environment ;
- ② The equipment should be placed on a flat desktop for operation ;
- ③ After printing, the device power should be disconnected and the pressure should be relieved ;
- ④ Clean the equipment promptly and keep it clean after printing is completed ;
- ⑤ Unused mud should be sealed and stored for moisture retention ;
- ⑥ To avoid model deformation, do not touch the model, moving platform, glass etc. with your hands during printing or shortly after printing is completed ;
- ⑦ Regularly oil the slide rails and screw rods.



Q: Printing does not output material.

- A:**
- ① Check if there is any blockage inside the extruder ;
 - ② Increase air pressure (maximum not exceeding 0.6MPa) ;
 - ③ Increase the extrusion amount appropriately when printing ;
 - ④ Check if the trachea is properly inserted;
 - ⑤ Check the humidity of the mud to see if it is too hard.

Q: Mud appears intermittently during printing.

- A:**
- ① Check if the mud is kneaded evenly ;
 - ② Is there any residual air or bubbles inside the barrel ;
 - ③ Increase the extrusion amount appropriately when printing ;
 - ④ Suggest replacing the mud with a new one.

Q: When regulating the pressure valve, there is no change in the dial.

- A:**
- ① Check if the air compressor is working ;
 - ② Before adjusting, pull down the knob and expose the orange part before turning the knob to adjust the air pressure.

Q: The first layer height is too high during printing.

- A:**
- ① Perform leveling operation by clicking on the [Tool] - [Manual] icon in the control panel ;
 - ② Then click on the [House] icon in the control panel to bring the platform back to its origin ;
 - ③ After returning to the origin of the platform, click the [Back] icon on the control panel to go to the previous interface, and then click the [Stop] icon ;
 - ④ Push the extruder manually to the four corners corresponding to the glass on the platform, observe the distance between the nozzle and the glass, and adjust the [Leveling Nut] below the platform in order to raise or lower the platform. It is recommended to reserve a distance of about 1-2 A4 paper thicknesses.