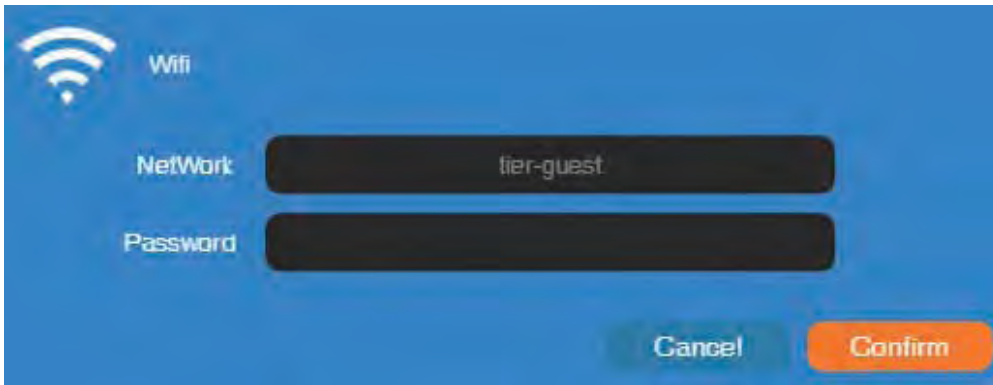


WiFi Setup (UP Studio)

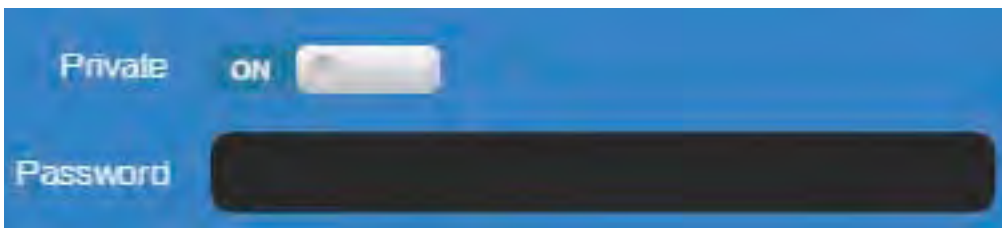
3\ Click network to choose an available network (user can also use touch screen panel to setup WIFI connection).



Choose your network from the drop down list.



4\ Input the password for the WIFI network.



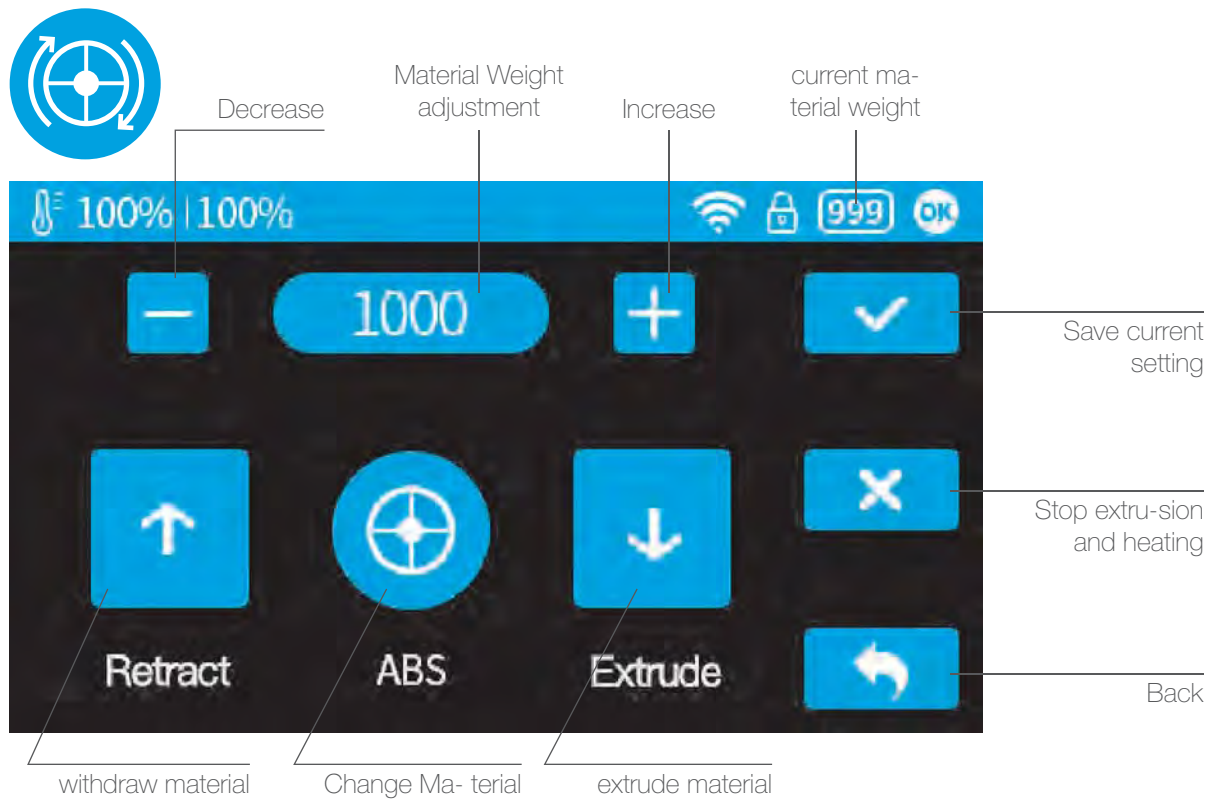
5\ If "Private" is set to ON, a private password could be optionally added to limit printer WIFI access to trusted users. Please note that the password is a weak protection that can be accessed and changed by anyone who can connect the machine through USB.

6\ Printer Tab

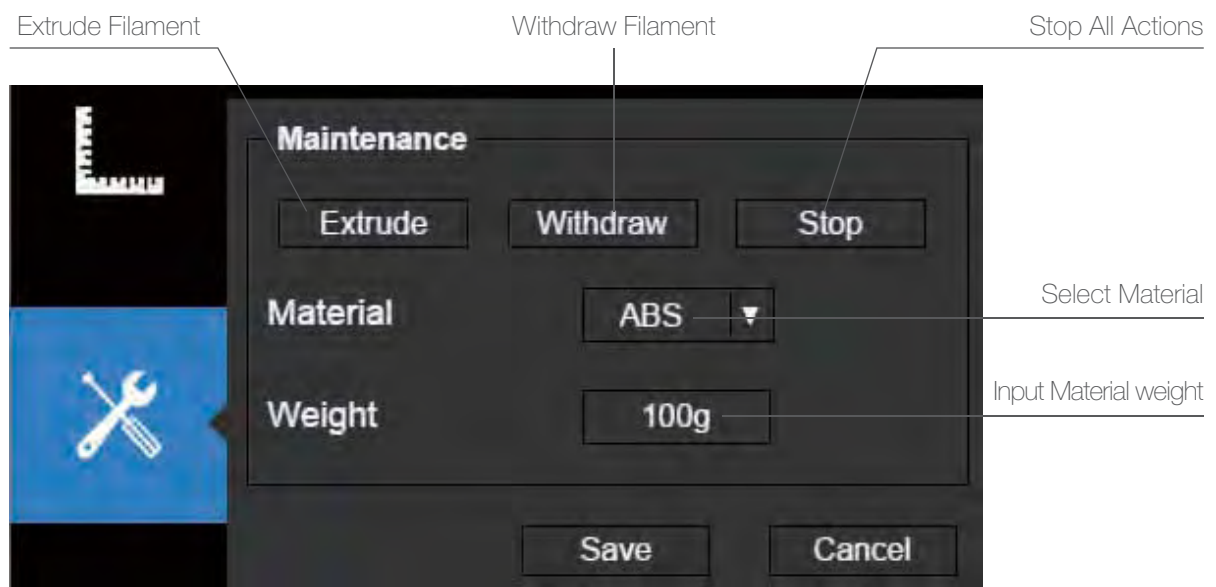


Disconnect USB and choose available printers on the network to operate through WIFI.

Set Materials (Touch Screen)

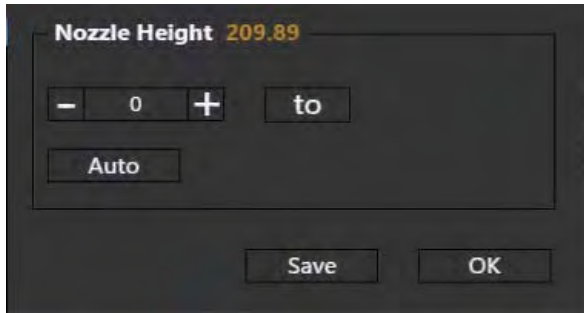


Set Materials (UP Studio)



Set Nozzle Height (UP Studio)

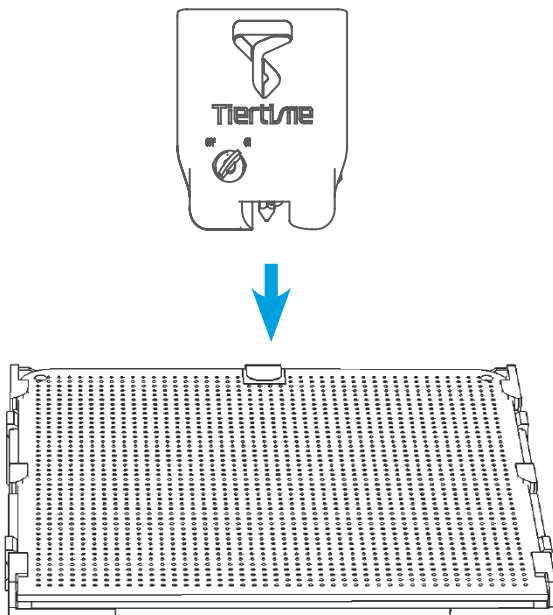
For setting nozzle height with touch screen please refer to page 16.



Open the Calibration panel

At the Nozzle Height section, click "Auto" will initiate the automatic nozzle height detection process.

Clicking +/- button will move the platform up and down, or user could input a specific value at the text field and click "To" button the move the platform to a specific height. Click save will replace nozzle height value with current platform height.



During nozzle height detection, the print head nozzle will touch the thin metal sheet on the detector to make measurement.

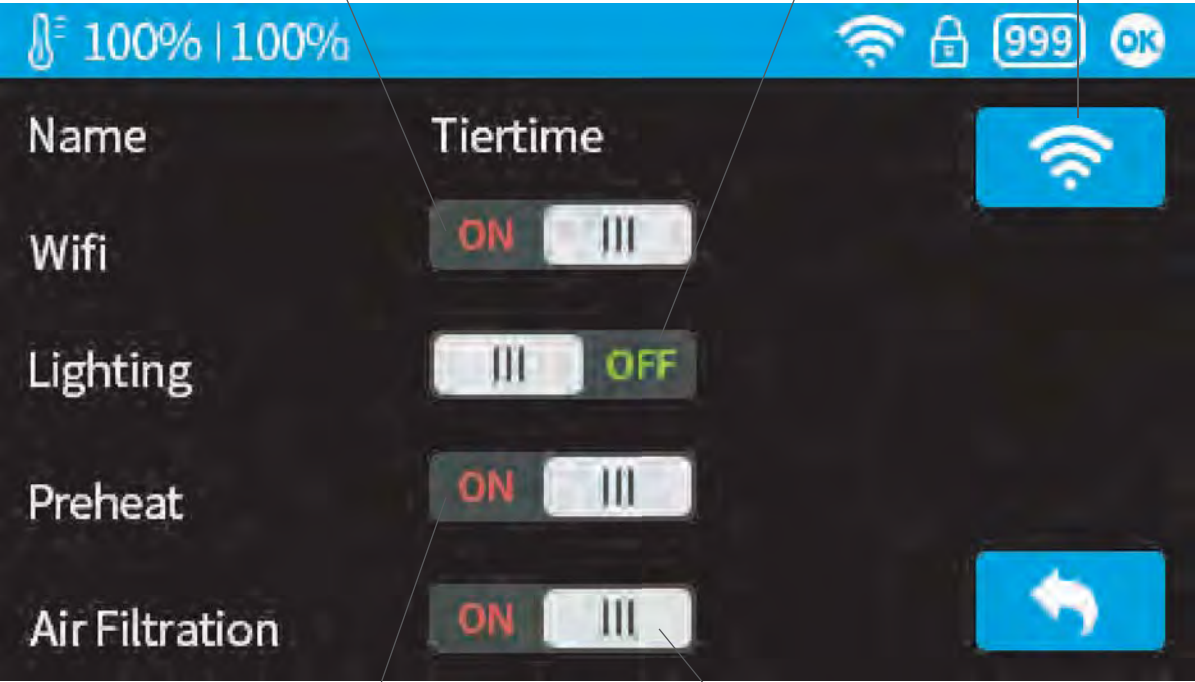
Machine Configuration



WiFi switch, if switched off the WiFi setting button will not appear.

internal lighting switch

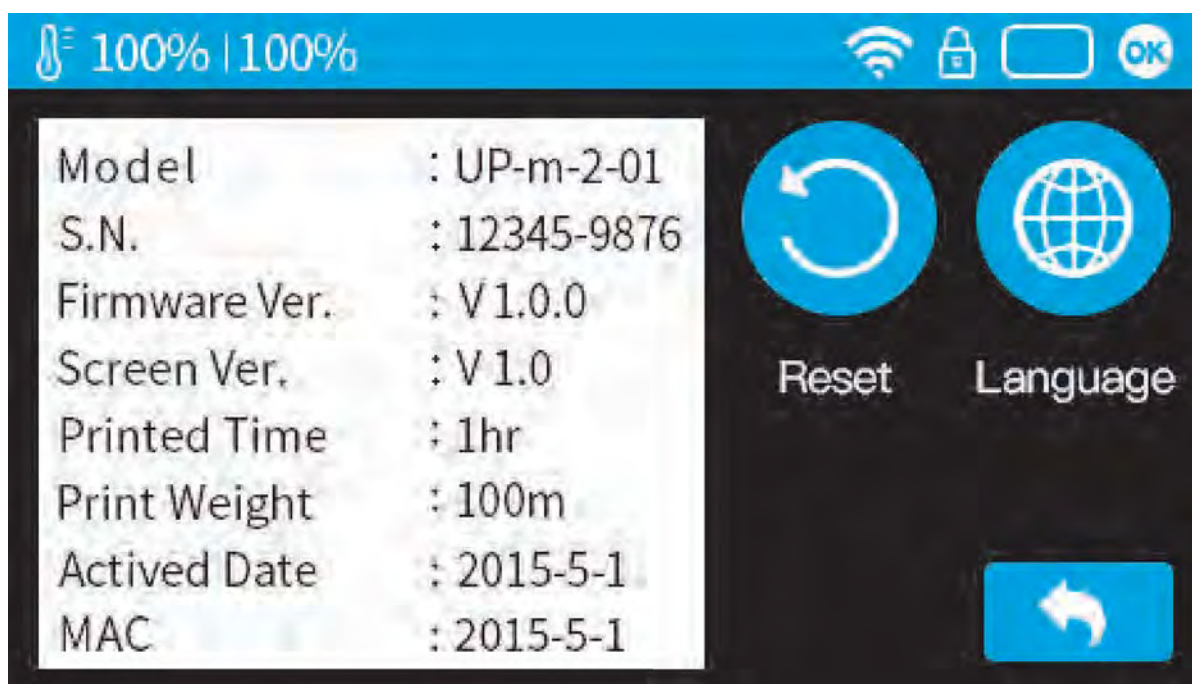
WiFi setting button



Peheat switch, when turned on, for every print job, the printer will first preheat 15min before proceed to printing.

Turn on or off the internal air filtration.

Language and Factory Reset



Model: current machine model

S.N.: machine serial number

Firmware Ver.: shows current firmware version **Print Time:** total print time count

Print Weight: total print weight count

Activated Date: the date of printer activation **MAC:** mac address of printer

Reset: revert to factory setting. This will change some machine setting to default; remove total printed time and weight data.

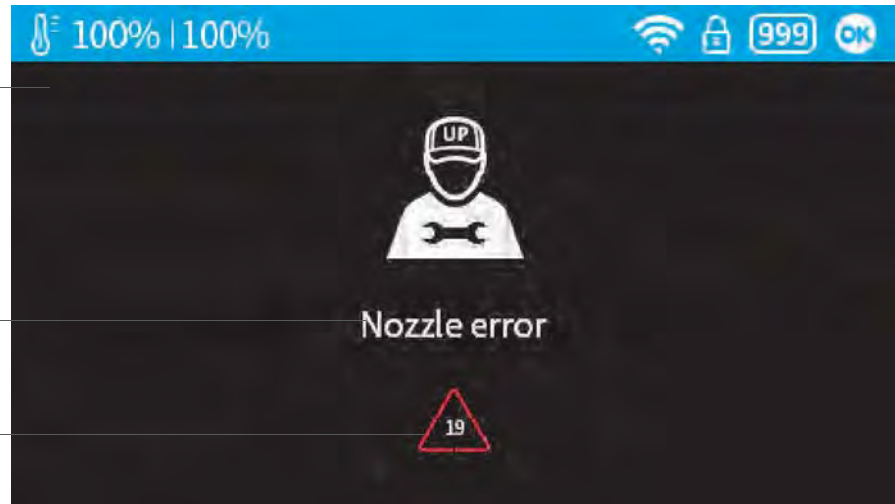
Language: choose language. Current available language: Chinese simplified, Chinese Traditional, Korean, Japanese, French, Germany, English

Error Prompts

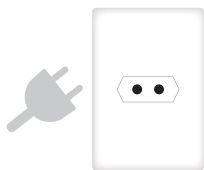
Suggested solution,
in this case:
Contact support

Error Message

Error code



Other possible error prompt:



Unplug printer and restart



reinitialize the printer

Rotating Models (UP Studio)

Choose the model and Click rotate button.

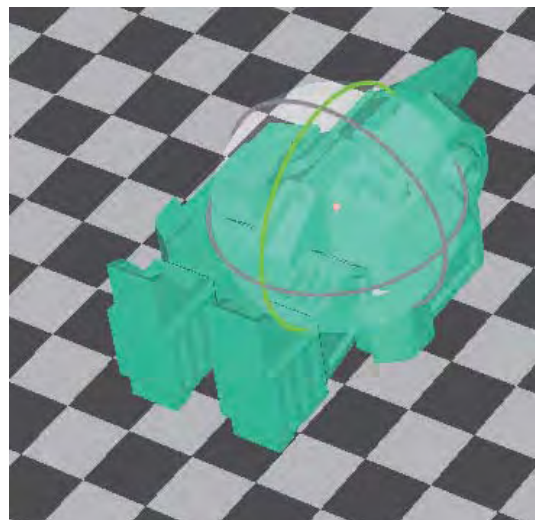


Choose rotation axis

User could input a specific value or choose a preset value for rotation.



Alternatively, user could use the rotation guide to rotate model in real time by hold and drag with mouse.



Scaling Models (UP Studio)



Choose the model and Click rotate button.

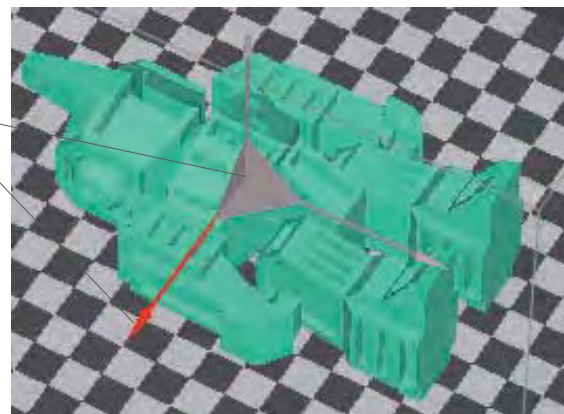
By default the scaling is in all axes.
User could also choose a specific axis for scaling.

User could input a specific scaling
factor or choose a preset value



Click MM or INCH to con- vert models to
sizes of corresponding units.

Alternatively, user could use the scaling guide
on the model. User could scale
in a specific axis or scale in all directions
by hold and drag with mouse.



Move Model (UP Studio)



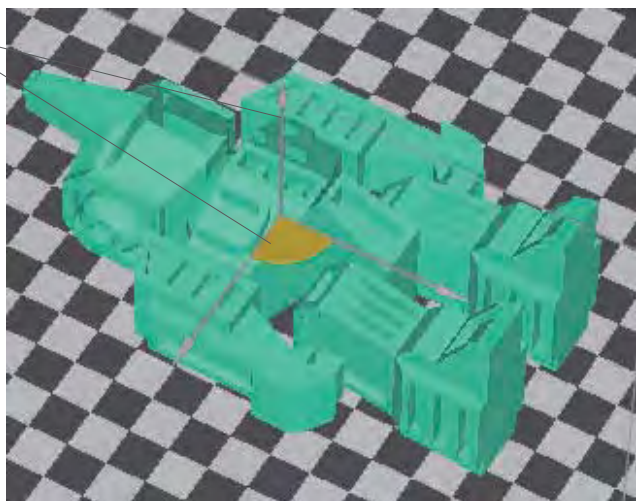
Choose the model and click the Move button.

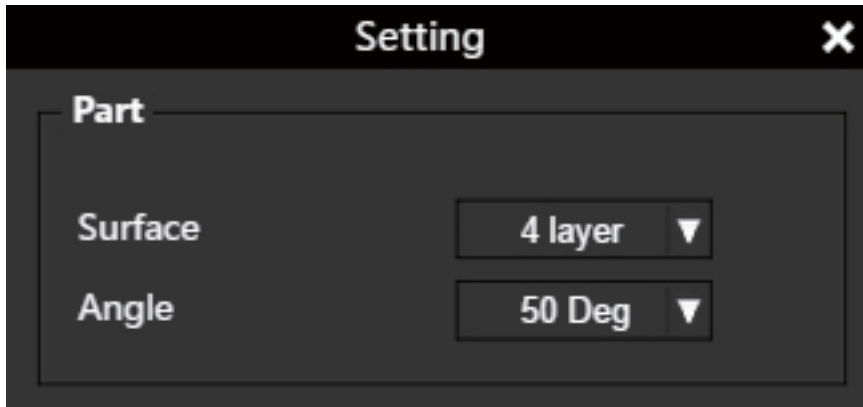
Choose the the direction of movement

User could input a specific value or choose a preset value for distance of movement.



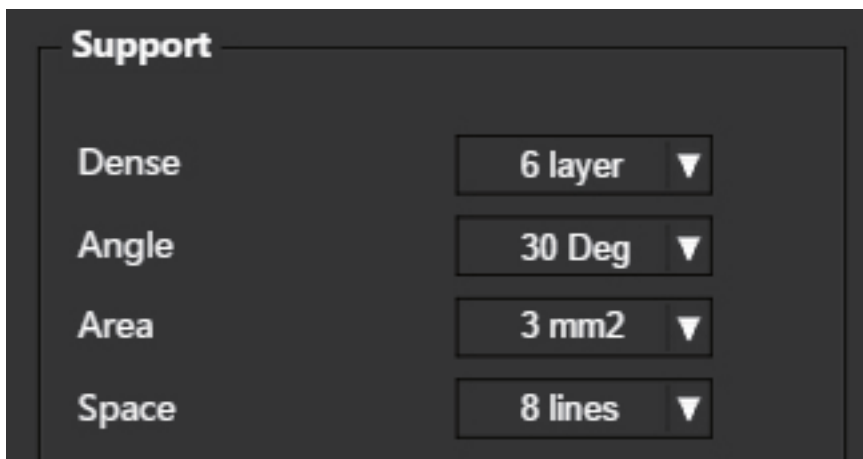
Alternatively, user could use the translational guide on the model to move on the X-Y plane or a single direction by hold and drag with mouse.





Surface: the number layers at the sealing the top and the bottom of the printed object.

Angle: This determine at which angle the Surface layers start to be printed.

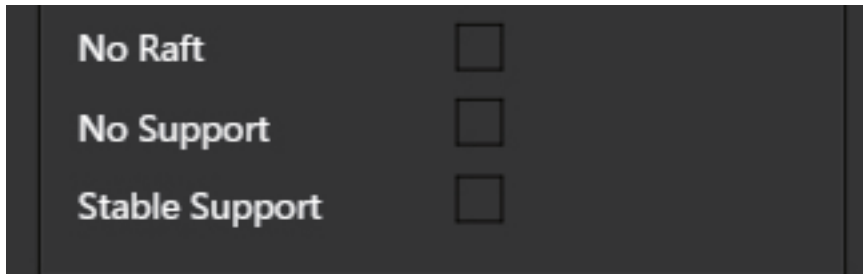


Dense: Choose the number of dense layers between support and supported surfaces.

Angle: Determine the angle which support and dense layer to generated.

Area: Determine the minimal area of surface that will be supported, area less than this vaule will not be supported.

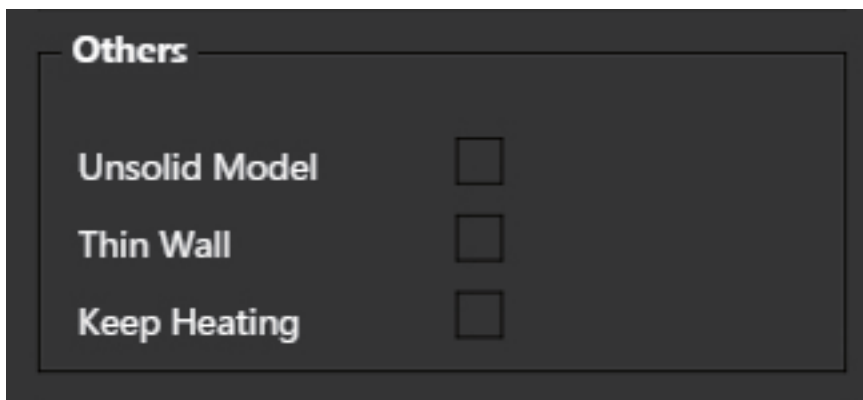
Space: Determine how desne the support will be, the larger the value the less dense of the support.



No Raft: print without raft.

No Support: print without support

Stable Support: Support structure will be stronger but less easy to be removed.

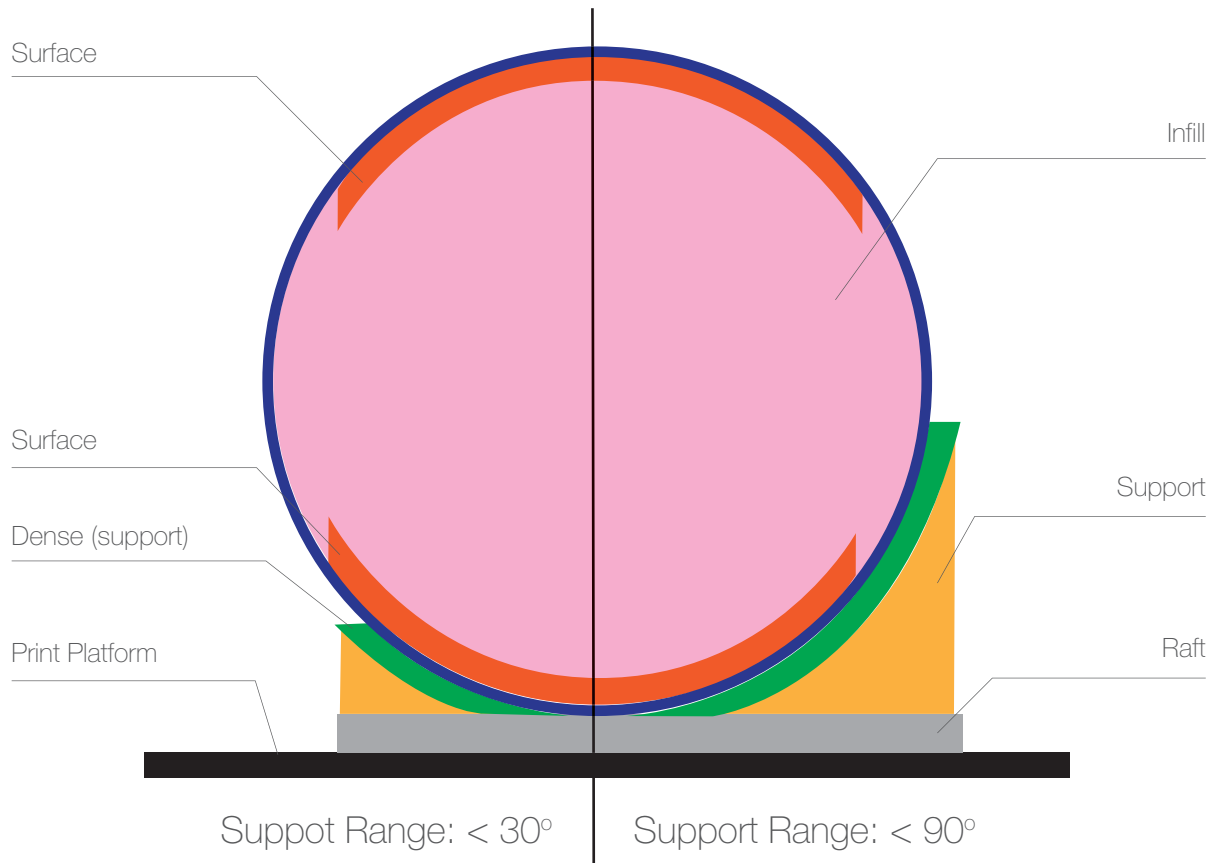


Unsolide Model: The software will autofix nonsolid models

Thin Wall: The Software will detect wall thickness that is too thin to print and expand the feature to a printable size.

Keep Heating: The platform will be heated after print job is completed.

Printing Parameters



Dense: Solid support structure ensures that the surface being supported retains its shape and surface finish.

Infill: The inner structure of the printed object. The density of the infill can be adjusted.

Raft: The thick structure that assists with the adhesion of the object to the platform.

Surface: The top and bottom layers of the printed object.

Printer Info



Printer info will be displayed by clicking the small button on the top left hand corner of the connected printer icon. Information including printer type, serial number and firmware version will be displayed. User could also set a custom name for the printer at the name field.

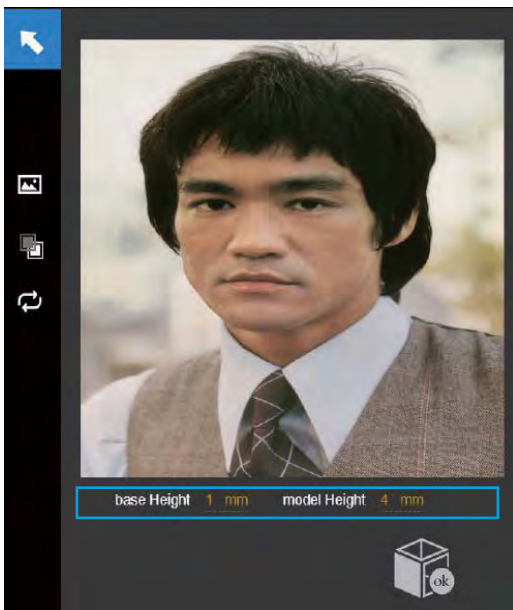
Software Version and Update



Check Auto Update to allow the software to inform user the latest version.



Click add picture button and select a picture.



The Base height determine the thickness of a flat layer that will hold the picture.

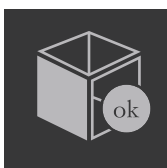
Model Height determine the contrast of the finally print.



The convert negative button will reverse the pixel intensity so that user could choose the picture to be protruding from or sunken into the base.



Update 3D model button. This button will convert the modified picture on the left to a 3D rendering on the right.



OK button send the 3D rendering to the 3D printing interface for printing.

Printing Techniques

Ensure accurate nozzle height. If the nozzle height value is too low, it will cause warping; if it is too high, it will crash the nozzle into the platform, causing damage and clogging. You can manually fine-tune the nozzle height value in the "Calibration" panels. You can try to adjust the nozzle height value plus or minus 0.1 –0.2mm from the base on previous re- sults.

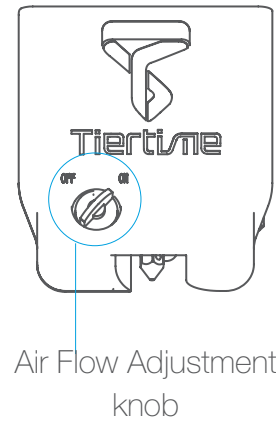
Calibrate the printing platform well. An unlevelled platform usually causes warping.

Allow enough time for sufficient pre-heating. Please use the 3D Print – Preheat function. A well preheat- ed platform is essential for printing large objects without warping.

The airflow on print head is adjustable, turn the air flow adjustment knob to change the amount of cooling of printed object. When printing in PLA, turn the lever counterclockwise to direct the airflow to the nozzle. This will cool the PLA as soon as it is extrud- ed and improve print quality. When printing large object using ABS, turn the lever clockwise to direct the airflow away from nozzle to slow down the cool- ing and to prevent warping. Users could experiment with different amount of cooling to achieve optimal result.

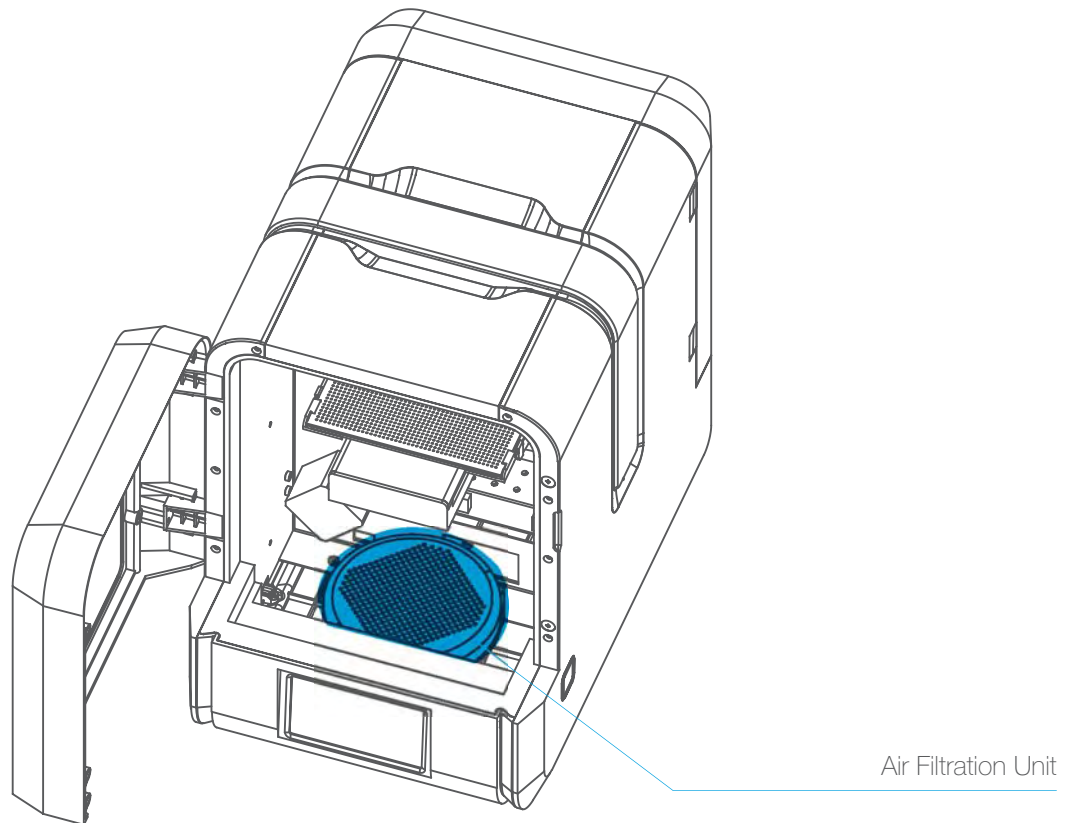
Printing with no raft. It is highly recommended to use raft for normal printing as it improves adhesion and is required for leveling compensation. It is turned on by default, but you can turn it off in the "Print Pre- view" panel if you desire to.

Printing with no support. It is possible to print with- out supporting structures. You can turn off support



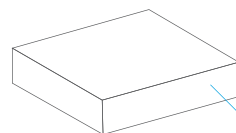
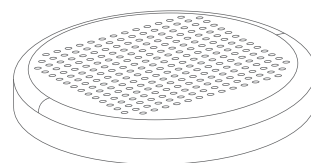
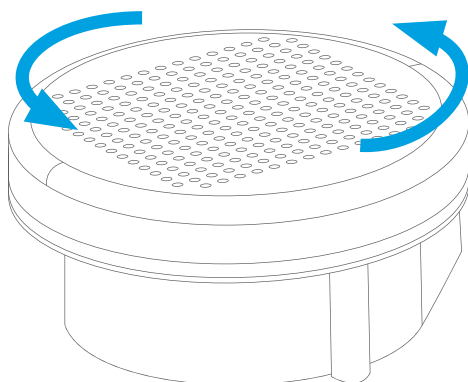
Printer Maintenance - Air Filter Replacement

Change air filter for air filtration unit. It is recommended to change the filter for every 300 hours of usage or 6 months.

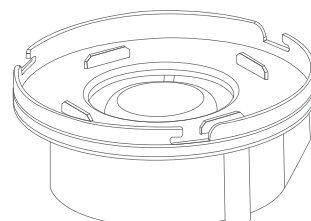


Front View

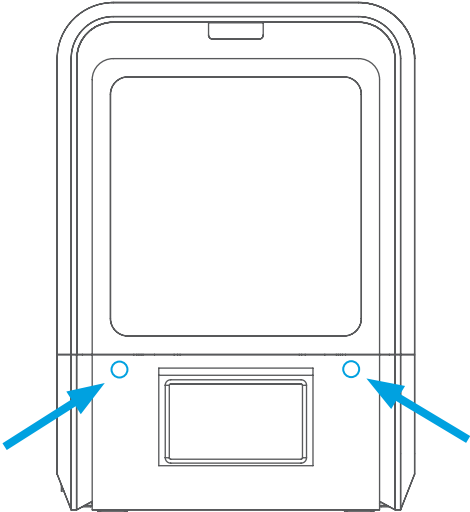
Turn anti-clockwise to open the cap.



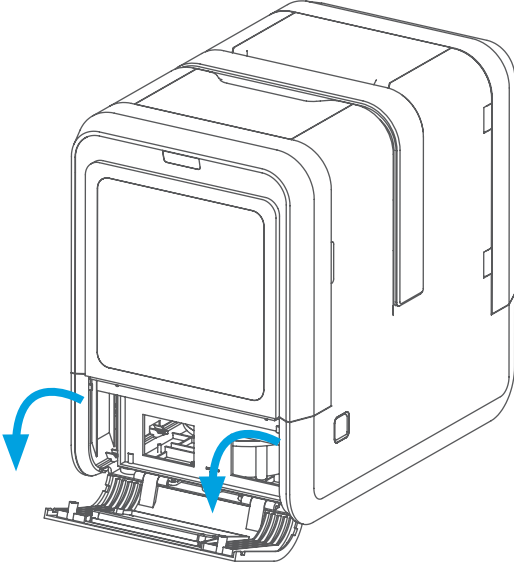
HEPA-Filter



Printer Maintenance - Touch Screen

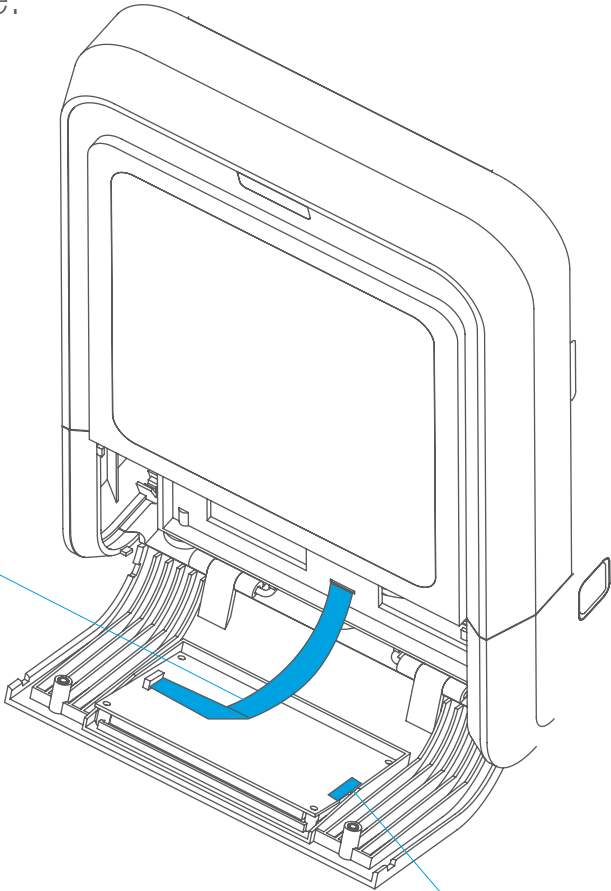


Remove the 2 screws on front plate.



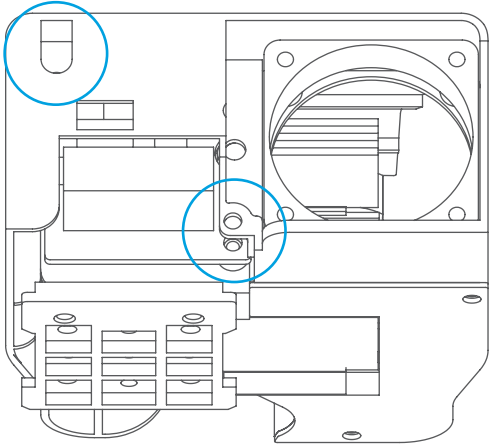
Open the front plate.

FFC cable of LCD touch screen.

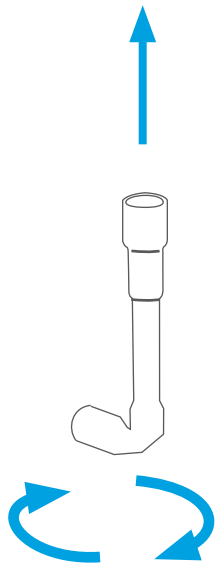
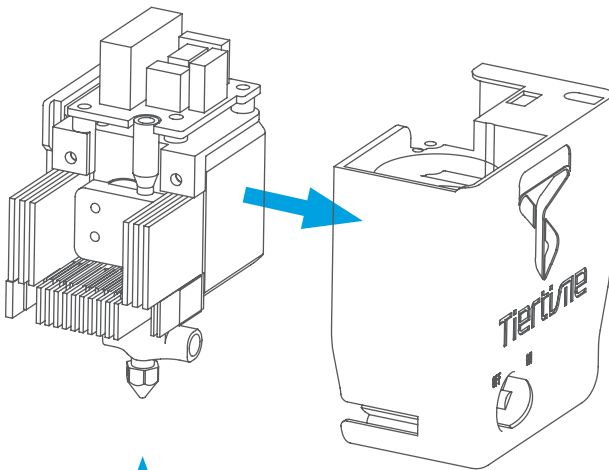


Micro SD card of LCD touch screen.

Print Head Maintenance



The printhead cover could be removed after unscrew 2 bolts.

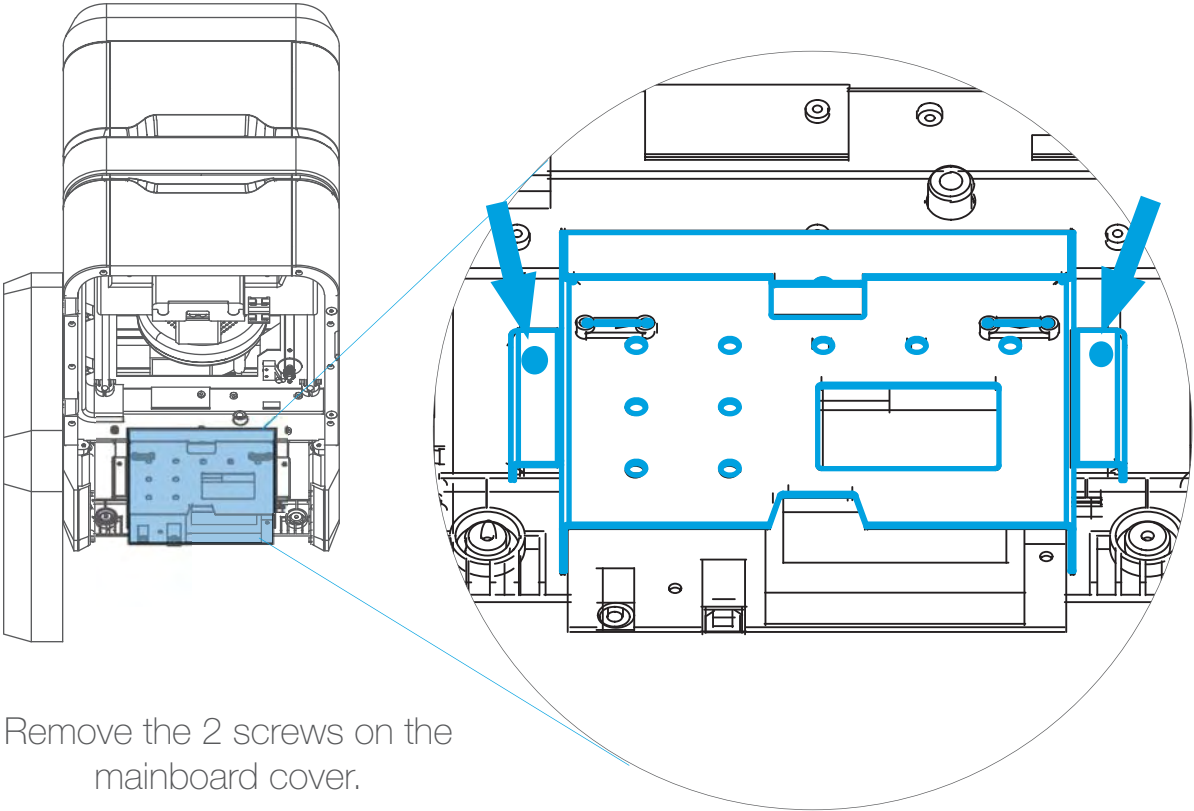


Heat up the nozzle to printing temperature by using the extrude function in maintenance interface.

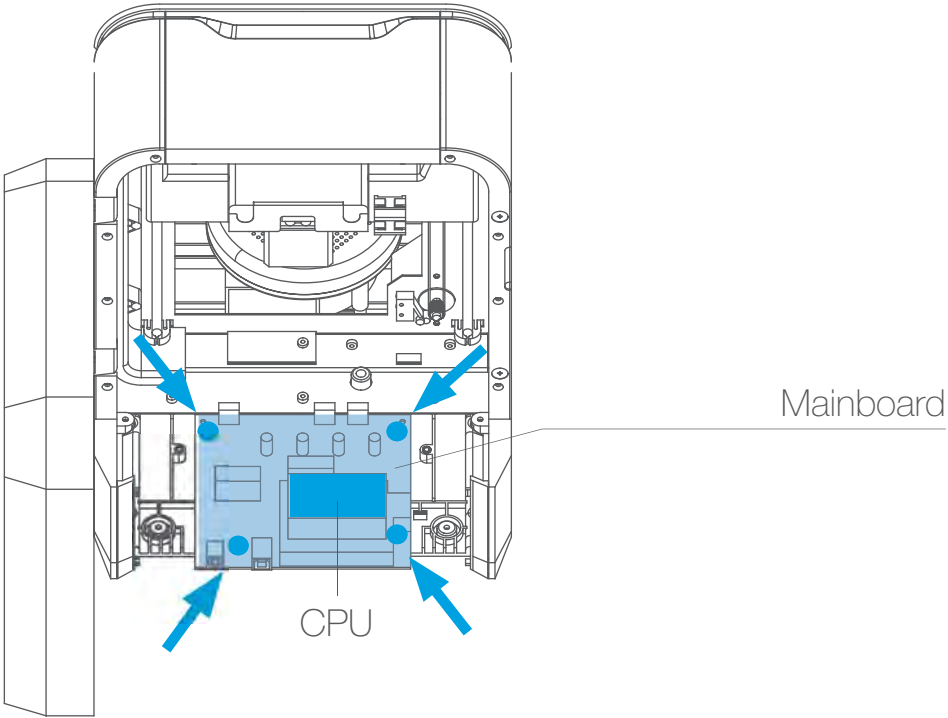
Nozzle could be removed by using the nozzle wrench provided.

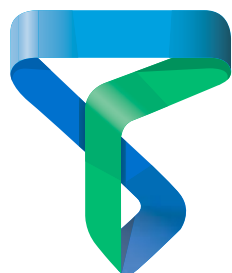
User does not need to remove printhead cover in order to remove nozzle.

Printer Maintenance - remove motherboard cover



Remove the 2 screws on the mainboard cover.





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Tel:010 6433 8663-601/010 6433 8663-805

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

NOTE: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

The distance between user and products should be no less than 20cm