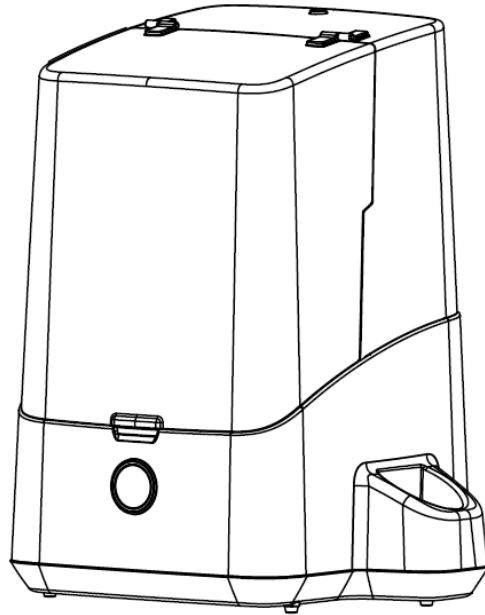# GETTING STARTED
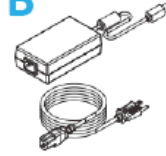
SLASH 3D printer quick start guide

UNIZ PRINTING SYSTEM

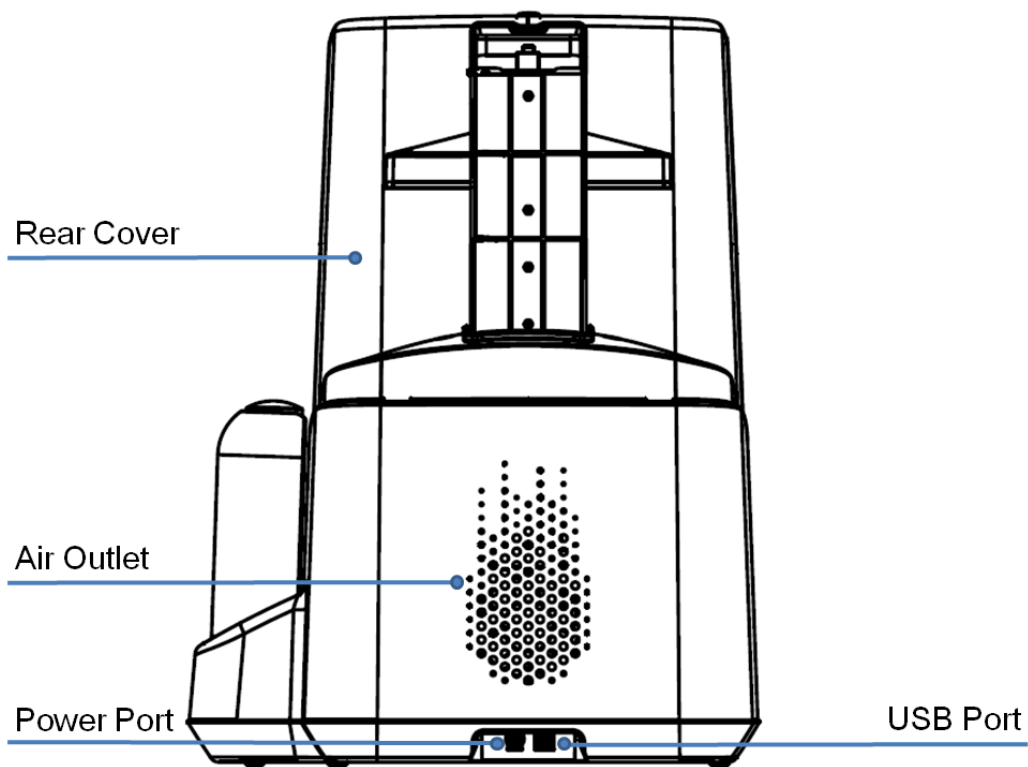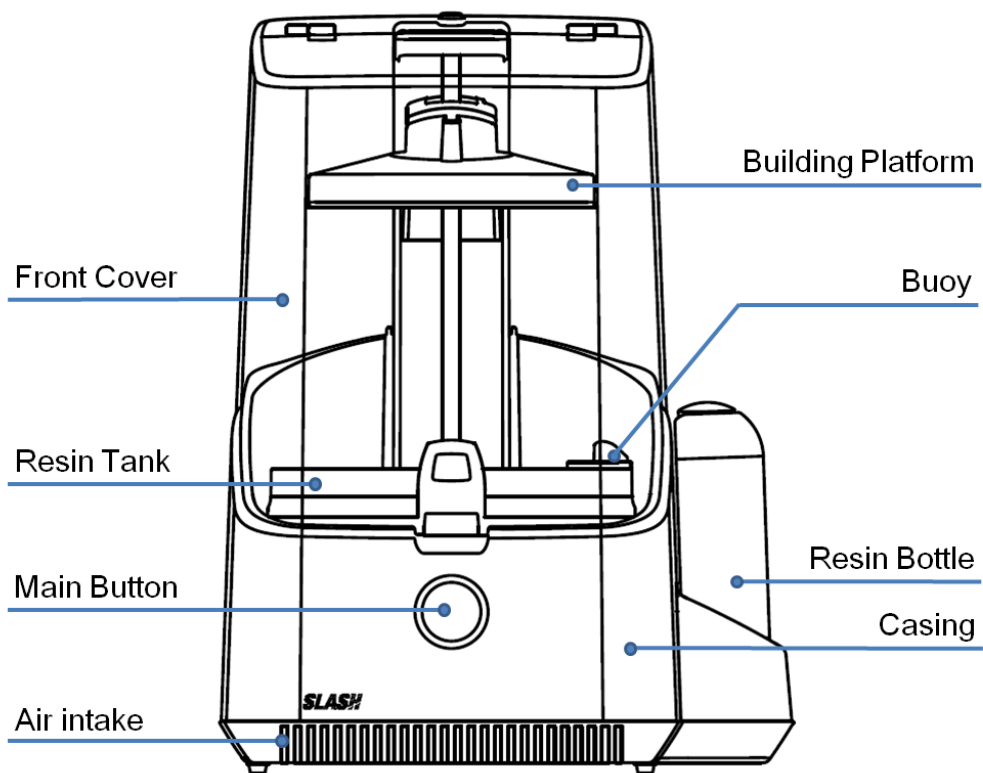A. SLASH 3D Printer

B. Power Cord

C. USB Cable

D. Extra Resin Bottle(s)

E. Clean Bottle

PRODUCT DESCRIPTION

Building Platform

Front Cover

Buoy

Resin Tank

Main Button

Resin Bottle

Casing

Air intake

SLASH

Rear Cover

Air Outlet

Power Port

USB Port

ACTION BUTTON COLOR GUIDE

Half circle alternating red
The printer is reseting its positon.

Green
STANDBY- The printer is connected and waits for a command.

Alternating red
The cleaning operation is in progress.

Blinking green
The print or the cleaning is completed.

Rapid run around green
The printer is receiving a print command.

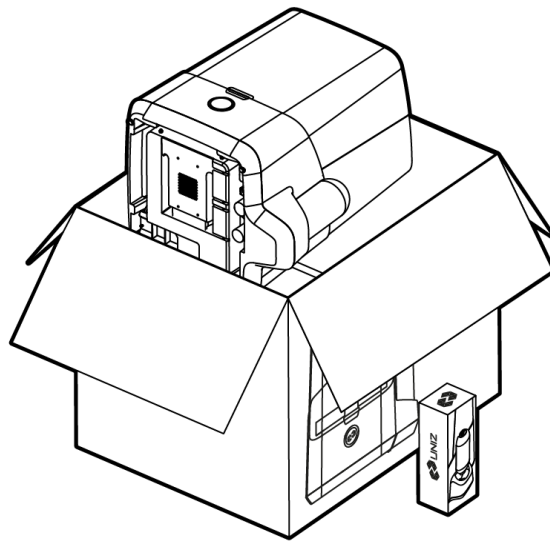**Progressing green**
The print is in progress.

Yellow
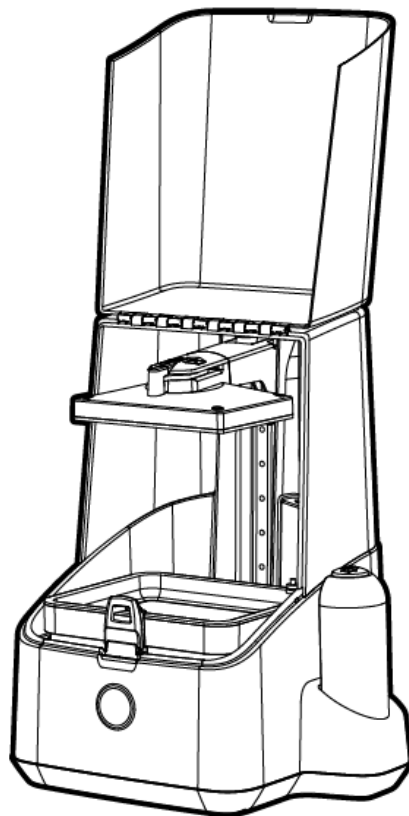Hold to reset the lowest position of Building Platform.

Blinking red
PAUSE-The printer is waiting for you.
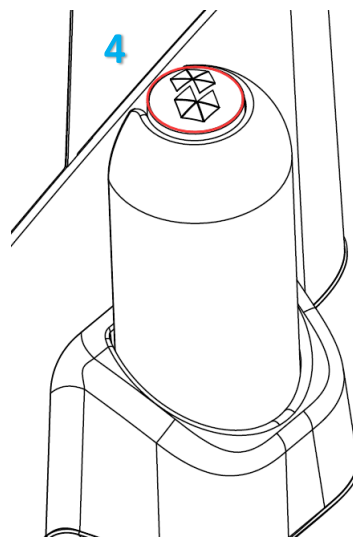
① UNPACK YOUR SYSTEM

② SET-UP YOUR PRINTER

minimum
clearance
861mm

⚠ Put SLASH on a flat horizontal platform.

③ LOAD THE RESIN

1. Remove rigid cap.

2. Puncture the rubber cap with the needle and push it all the way down into the bottle holder.

3. Pull the plug (small) on top to open the vent.

4. Put rigid cap at the opposite side of bottle
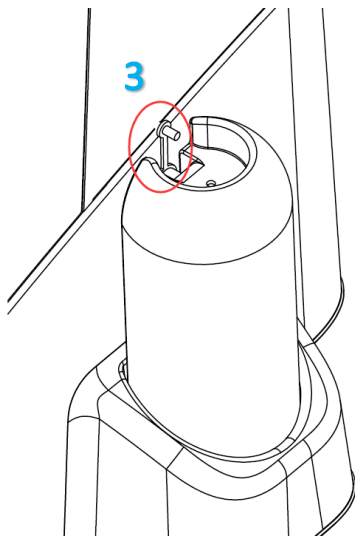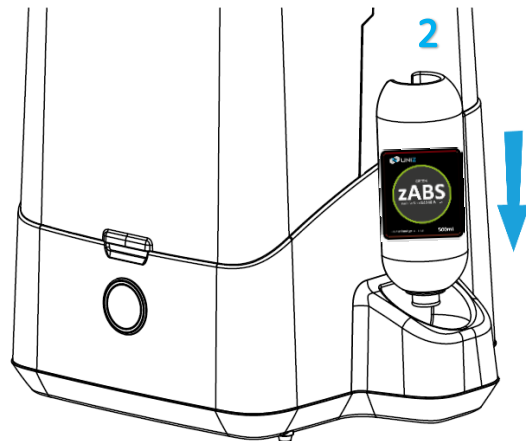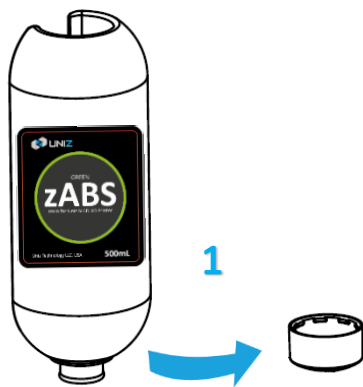
⚠️ Do not remove the rubber cap at any time.
Never fill the resin tray manually; the pump will do this for you.
Beware of the sharp Needle.

④ LIGHT IT UP

    1. Plug in USB cable and connect to your computer.

    2. Plug in power cord and turn on.
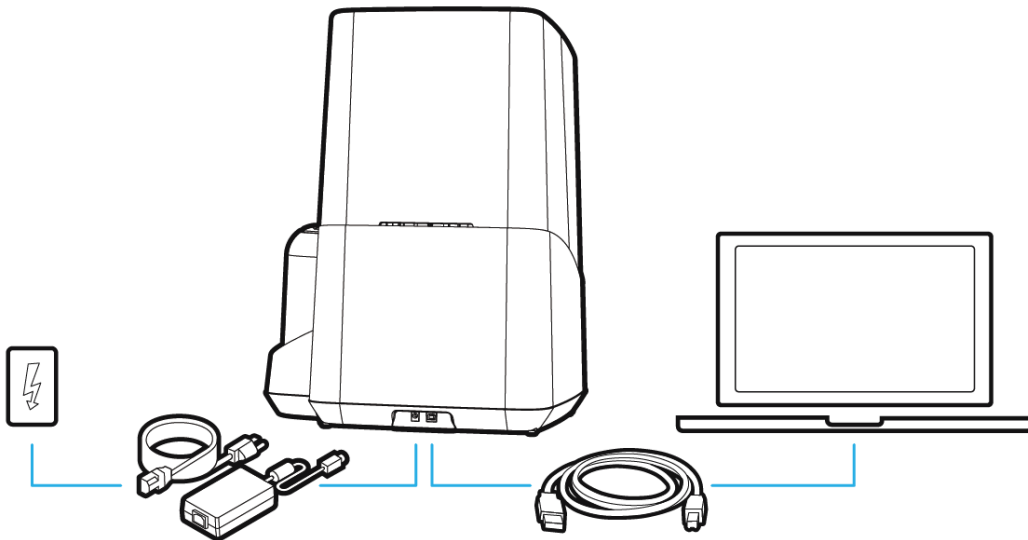
⑤ USING THE SOFTWARE *

1. Double click the icon on the desktop of computer. (Please keep USB connection at this time)

Uniz
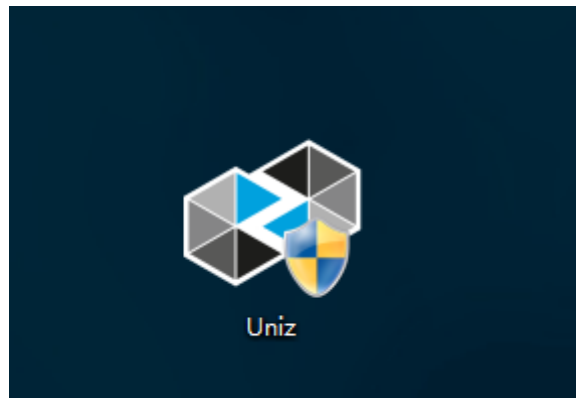
* Please refer to the "Software manual" for more details.

2. Load a model (*.stl).
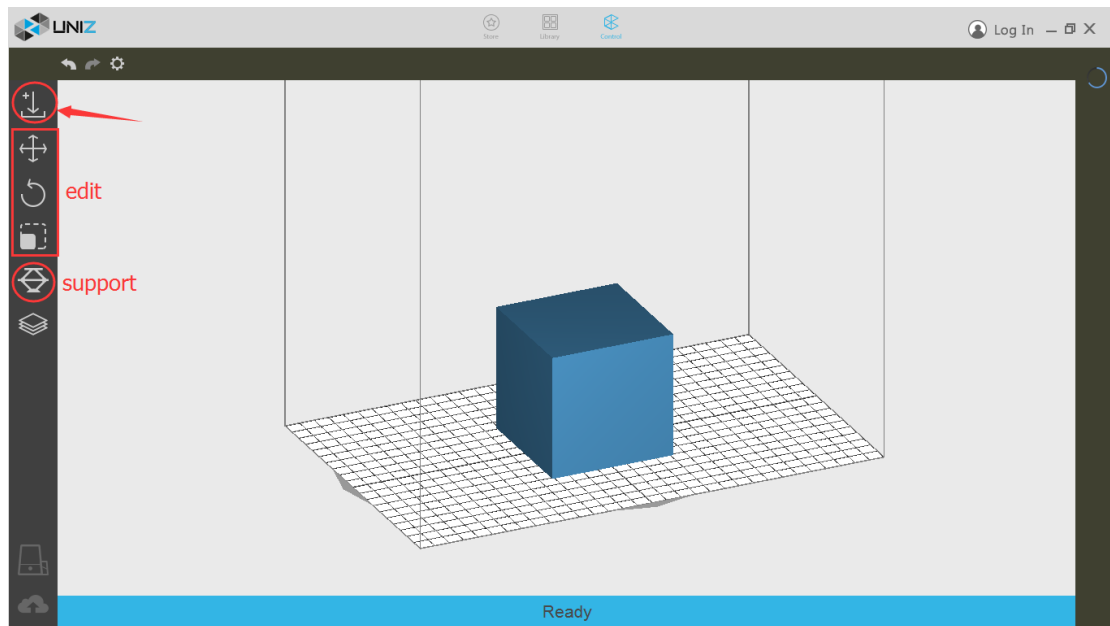
3. Start slicing.

a. Click the "SLICE" button;

b. Click the sliding bar on the right to choose slicing parameter;

c. Define parameters of different zones;

d. Start slicing (check the box to skip verify process).

e. It will start to print when slice finished if you pitch on this.
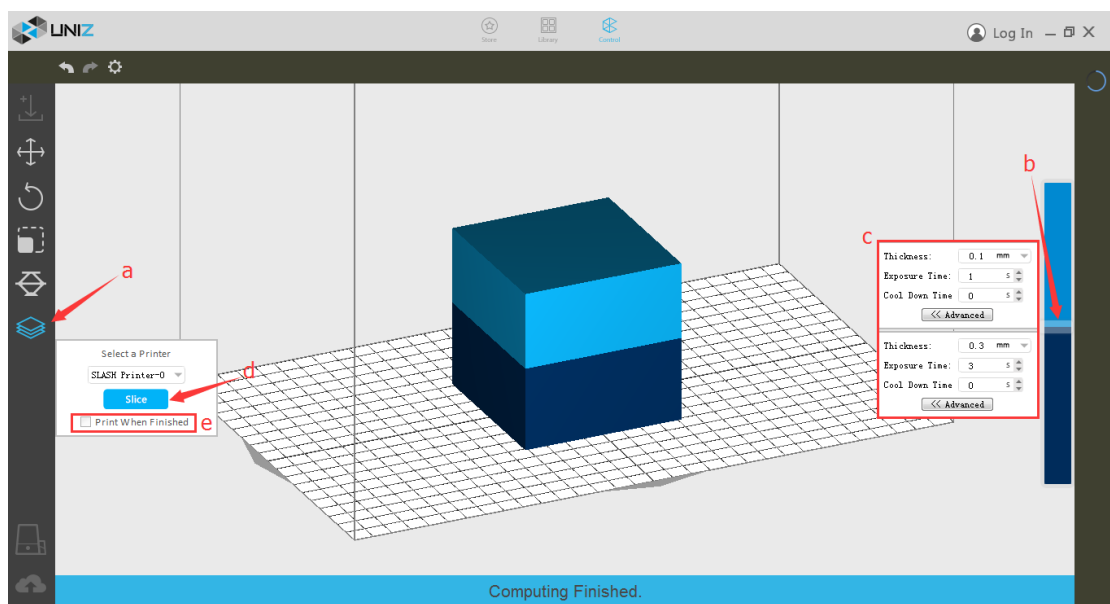
4. Print.
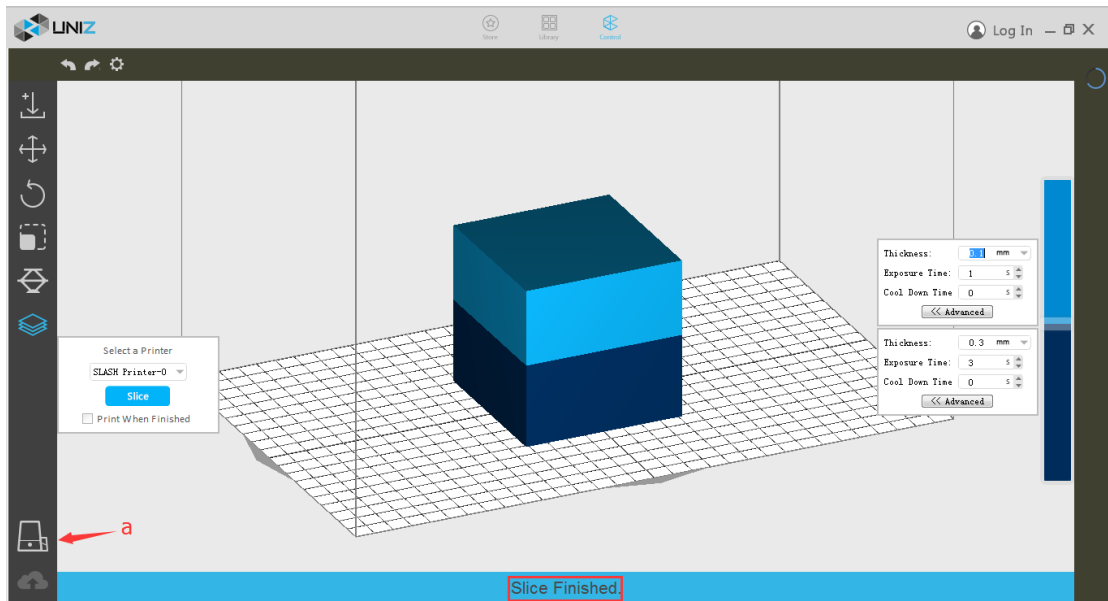
a. When slicing is finished, click "print" to send data to SLASH and
   start to print.

⑥ POST PRINT

1. Clean the bottom of Building Platform (Wipe off any uncured
   resin).
2. Rotate the lock arm.
3. Take it off.
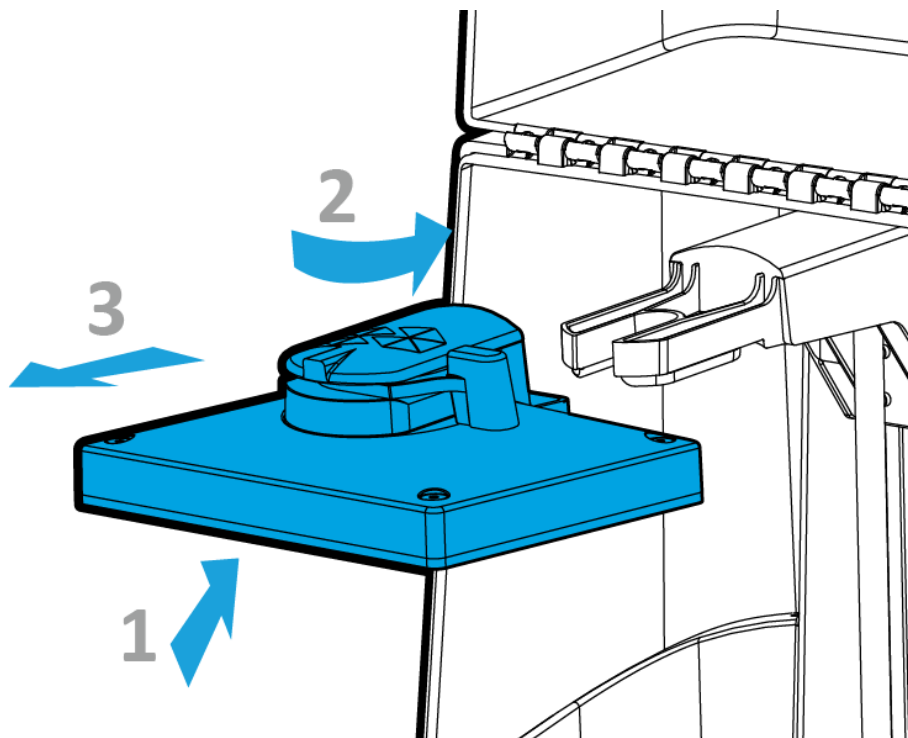
4. Shovel the model off from Building Platform with a scrapper.
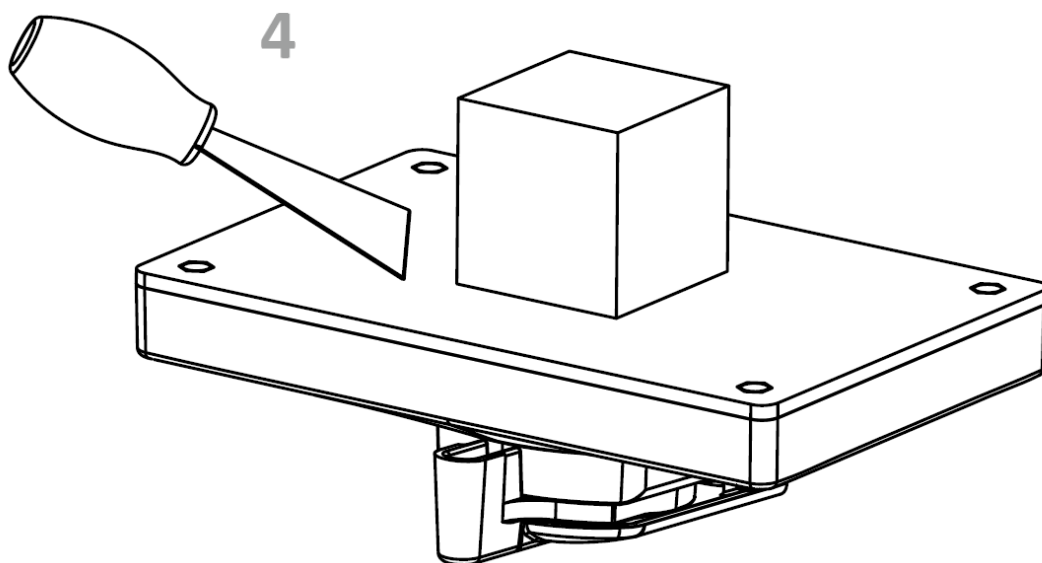
⚠ Watch out for the scrapper, and don't hurt your hand!

⑦ ENJOY!

How to Clean the Resin System

1. Push the plug (small) in to close the vent.

2. Take the Resin Bottle off and put it on the desk.

3. Remove rigid cap of Clean Bottle.

4. Puncture the rubber cap with the needle and push it all the way down into the bottle holder.

5. Pull the plug (small) on top to open the vent.

6. Click the 'FILL' to flush the resin system with alcohol.

7. Push the plug (small) in to close the vent.

8. Take the Clean Bottle off and put it on the desk.

9. Click the 'FILL' to drain alcohol in the resin system.
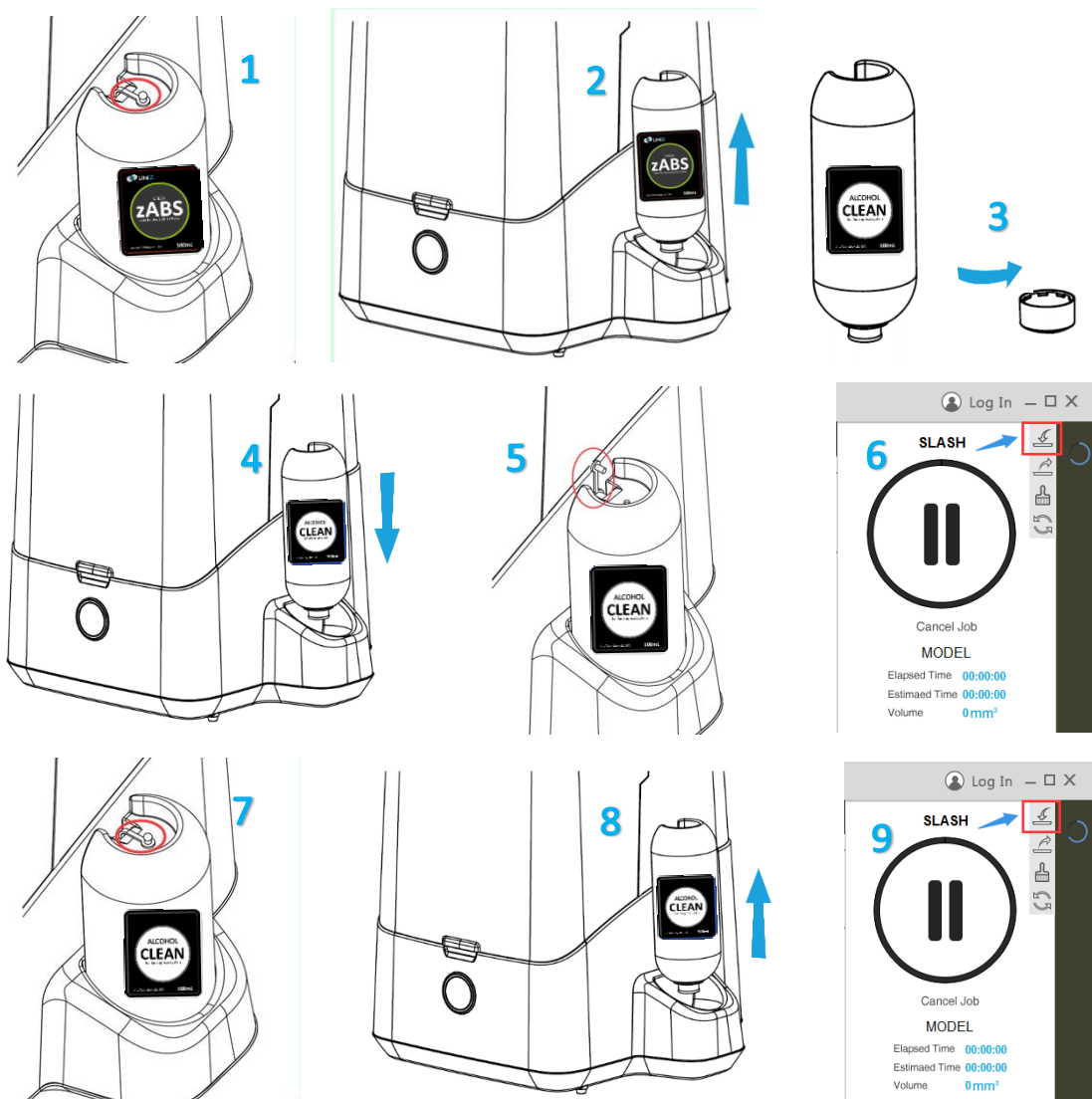
CAUTION

1. Please place the printer on a horizontal flat surface.

2. Always wipe the build platform clean before removing it from the printer.

3. Double check the build platform and bottom of resin tank (vat) for debris to prevent damage to the LCD module.

4. Before printing, make sure build platform and resin tank (vat) are locked in place.

5. Due to the smaller size of the current buoy, it is recommended to withdraw some resin (can be controlled manually in the software) before each printing to prevent resin from overflow. This will be fixed in the final product with the appropriate size buoy implemented.

6. Please restrain from using pause function too frequently, this will cause layer marks and sometime failed prints.

7. Make sure the orange cover is closed all the way (this will be controlled by magnetic lock sensor in final product). Keep away from intensive light and heat sources.

8. Keep the air inlet and vent holes clear.

9. Always clean the buoy module when cleaning the resin tank (vat).

10. Keep the buoy module away from excessive heat to prevent deform and malfunctioning of the resin control system. ;

DECLARATION

1. Due to refractive index mismatch of the prototype printer, the printed parts will have distinctive 'water marks' which will not be present in the final product.

2. Some parts (Build platform with ARM, several locking mechanisms) doesn't have perfect fit due to the prototype silicone molding process. These will be in perfect fit in the final product.

3. Since the temperature control module is still being implemented, the current noise level is maintained at 65dB for maximum cooling effectiveness. Noise control switch will be added to the final product（55dB）.

FCC STATEMENT :

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.
Warning: 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 and can radiate radio frequency energy and, if not
installed and used in accordance with the 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.

FCC Radiation Exposure Statement

This equipment complies with FCC radiation exposure limits set forth for an uncontrolled
environment. This equipment should be installed and operated with minimum distance
20cm between the radiator & your body