

1. Connect the machine to the electricity supply.



2.Plug one end of USB cable into Computer



3. Plug another end into machine

The firmware is optimized by my company, and then loaded on mainboard, please do not upgrade the firmware by yourself.

After the USB cable plugged, the USB driver will auto-install on Win7 system, as picture below

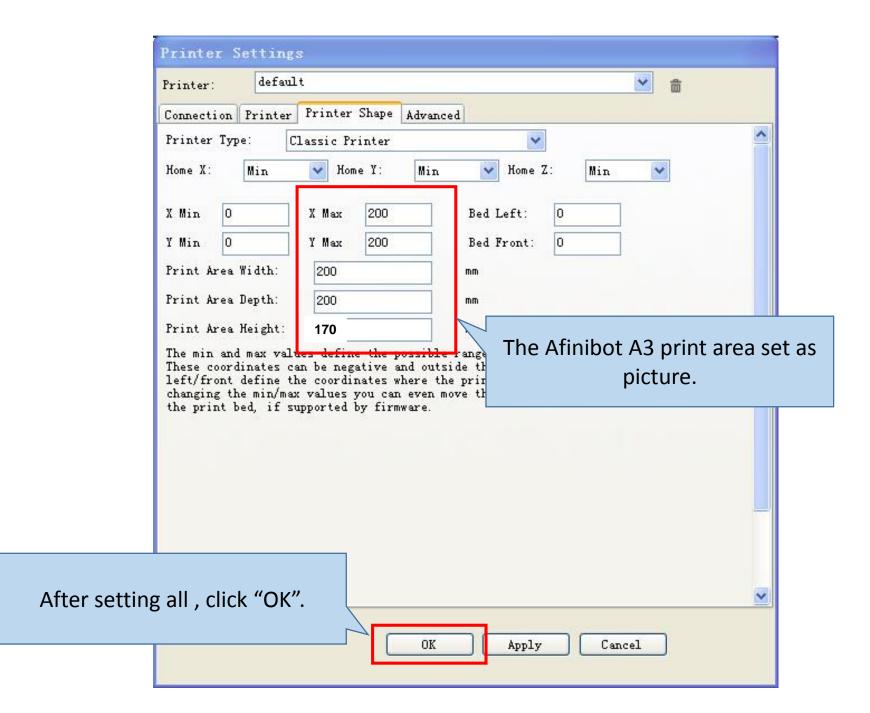
3 驱动程序软件安装	
正在安装设备驱动程序软件	
USB Serial Converter V可以使用 USB Serial Port O正在搜索 Windows Update	1. System prompted the USB
从 Windows Update 获得设备驱动程序软件可能需要一些时间。 跳过从 Windows Update 获得驱动程序软件	driver is installing
关闭(C)	



Repetier-Host VO.95F	n de la companya de 🔳 🗃 🔀
File View Config Temperature Printer Tools Help	
Connect Load Save Job Run Job Kill Job SD Card Toggle Log Show Filament Hide Travel	Printer Settings
3D View Temperature Curve	Object Placement Slicer G-Code Editor Manual Control
C	
	Name Click here to set the printer Mesh Co
	Translation X Y Z
	Scale X Y Z
	Rotation X Y Z
	Cut Objects Position
	Inclination
	Azimuth
Show in Log: Commands OInfos OWarnings OErrors OACK OAuto Scroll Clear Log 🕐 11:46:50.531 OpenGL renderer: ATI Mobility Radeon X1600	Copy
11:46:50.531 Using fast VBOs for rendering is possible	
Disconnected - Idle 1611 FPS	

Printer Settings				
Printer: default		×		
Connection Printer F	rinter Shape Advanced			
Connector: Serial	Connection 🛛 👻			
Port:	COM13	Refresh Ports		
Baud Rate:	115200	1		Select the USB serial
Transfer Protocol:	Autodetect 💌			
Reset on Connect	Disabled	*		rt ,Different 3D printer
Reset on Emergency	Send emergency command and m	econnect 🛛 💌	show	vs different port number
Receive Cache Size:	127			
	From Arduino 1 on the receiving cache wa	is reduced from 127 to 63 bytes!	2. T	he Baud Rate is 115200
🔲 Use Ping-Pong Co	mmunication (Send only after o	ık)		Г
are stored with eve	s always correspond to the se ry OK or apply. To create a n ess apply. The new printer st	ew printer, just enter a n	.ew	
	-	•	· · · · ·	nt click "My computer"- ort", find the number.)
	OK .	Apply Cancel		

Printer: default			✓	
Connection Printer Printer Sha	pe Advanced			
Travel Feed Rate:	4800	[mm/min]		
Z-Axis Feed Rate:	100	[mm/min]		
Default Extruder Temperature:	200	° C		
Default Heated Bed Temperature	: 55	• c		
Number of Extruder:	1		•	iture according to
🕑 Check Extruder & Bed Temper	ature		material <i>i</i>	ABS or PLA.
Check every 3 seconds. Park Position: X: Send ETA to printer display Go to Park Position after Jo Disable Extruder after Job/H Disable Heated Bed after Job Disable Motors after Job/Kil	5111 /Kill	Z-Min O	ABS extru Heated be PLA extru	e Temp.: ider: 230°C ed: 80~90°C ider: 200°C ed: 55~60°C
Add to comp. Printing Time 8	[%]			
	OK C	Apply (Cancel	



View Config Temperature Printer Tools Help Load Save Job Run Job Kill Job SD Card Toggle Log Show Filament Hide Travel		Printer Settings	Emerge	ncy St
ew Temperature Curve	Object Placement Slicer G-Code Editor Manual Control			
	🖴 🗢 🗠 🎟 💠 🔸 🖏 🛔 i			
Step 1: Load a print object	Name	Mesh	Co	
	20mm_box_pillar.stl	✓	~	盦
				>
	Translation X 100 Y 100 Z 0			
	Scale X 1 Y 1 Z 1			
	Rotation X O Y O Z O			
	-Object Analysis			_
	Deep Analysis	Original - Modified		
	Modified:	No		
	Manifold:	Yes		
	Intersecting triangles: Normals:	Not tested Oriented		
	Loop Edges:	0		
	Highly Connected Edges:	0		
	Points:	398		
	Edges: Faces:	1188 792		
	Shells:	1		
	Cut Objects			
	Position			—
· · · · · · · · · · · · · · · · · · ·				
n Log: OCommands OInfos OWarnings OErrors OACK OAuto Scroll 🕋 Clear Log	Сору			
2:46.906 Object is manifold. 2:46.906 Analysing finished.				

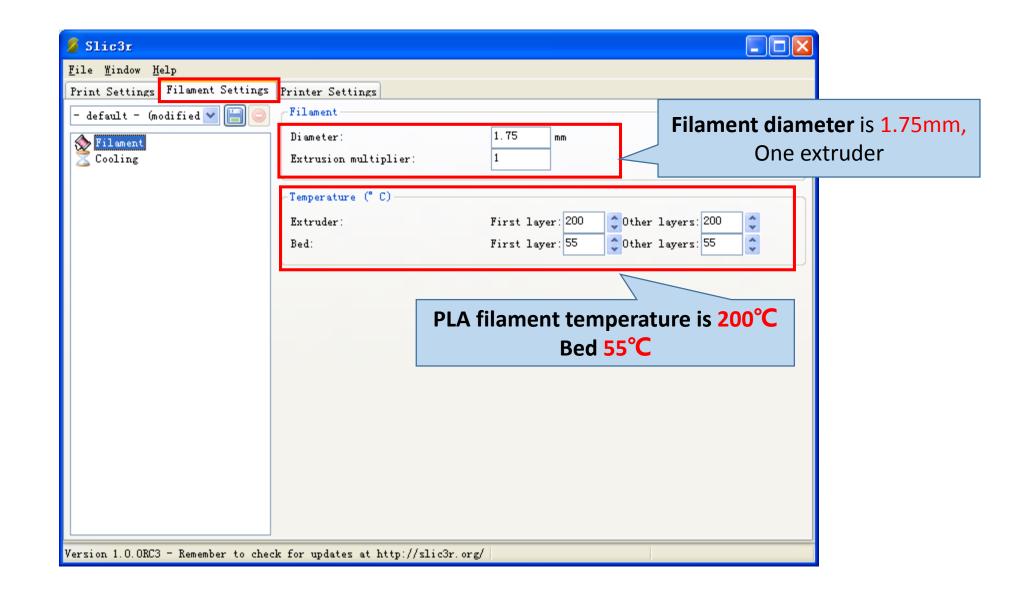
🔣 Repetier-Host VO.95F - 20mm_box_pillar.stl	
File View Config Temperature Printer Tools Help	
Connect Load Save Job Run Job Kill Job SD Card Toggle Log Show Filament Hide Travel	Printer Settings Emergency Stop
3D View Temperature Curve	Object Placement Slicer G-Code Editor Manual Control
30 View Temperature Curve	Object Placement Slicer G-Code Editor Manual Control Slicer G-Code Editor Manual Control Slicer: SlicOr Slicer: SlicOr Print Setting: Simple Mode Printer Filame Step 2: Select SlicOr, and Extrudy then click Configure Extrudy Extrudy Then click Configure Extrudy Extrudy I PLA2-FanKeepon Override SlicOr Settings Copy Print Settings to Override Enable Support Enable Support Enable Cooling Layer Height: 0.3 mm Infill Density 6% Infill Pattern: honeycomb
	Solid Infill Patter rectilinear Slic3r is separate, external program, which can be started separately. For further informations, please visit the following webpage: http://www.slic3r.org
Show in Log: Commands Infos Warnings Errors ACK Auto Scroll Clear Log Co 11:22:46.906 Object is manifold. 11:22:46.906 Analysing finished.	ру Уру
Disconnected - Idle 1173 FPS	

R/ Rep	etier-Host VO.95F - 20mm_box	x_pillar.stl				🔳 🖻 🗾
File	View Config Temperature Printe	er Tools Help				
U Connect	- Dad - Save Job Run Job - Kill	Job SD Card Toggle Log Show Fil	ament Hide Travel			Printer Settings Emergency Stop
3D View	Temperature Curve			Object Placement S	licer G-Code Editor Manual Contr	0]
C ↔ ∰	Slic3r File <u>Window Help</u> Print Settings Filament Settings - default - (modified v)	Layer height			ice with Slic3r	Kill Slicing
Ŧ	Layers and perimeters	Layer height: First layer height:	0.2 mm 0.2 mm or %			🙆 Configure
Q	Speed Skirt and brim				imple Mode	
	🛄 Support material 🥽 Notes	Vertical shells Perimeters (minimum):	3		imple Mode	
A	🚡 Output options	Spiral vase:				
	₩ultiple Extruders Advanced	-Horizontal shells			imple Mode LA2-FanKeepon	<u>∼</u>
		Solid layers:	Top: 3 🗘 Bottom: 3	\$	LA2-FanKeepon	
	Step 3: Set parameters	Quality (slower slicing) Extra perimeters if needed: Avoid crossing perimeters: Start perimeters at: Detect thin walls:	✓ □ Concave points: Non-overha ✓ ✓	ang points:	ettings ttings to Override	
		Detect bridging perimeters: Advanced Randomize starting points: External perimeters first:			meters	6% 45°
	Version 1.0.0RC3 - Remember to check	k for updates at http://slic3r.or	re/	setting	g system	. For further informations, please visit the following
11:22:	Log: Commands Infos Wa 46.906 Object is manifold. 46.906 Analysing finished.	arnings OErrors OACK (Auto Scroll 🕋 Clear Log	Copy Copy		
Disconne	ected - Idle	1078 FPS				

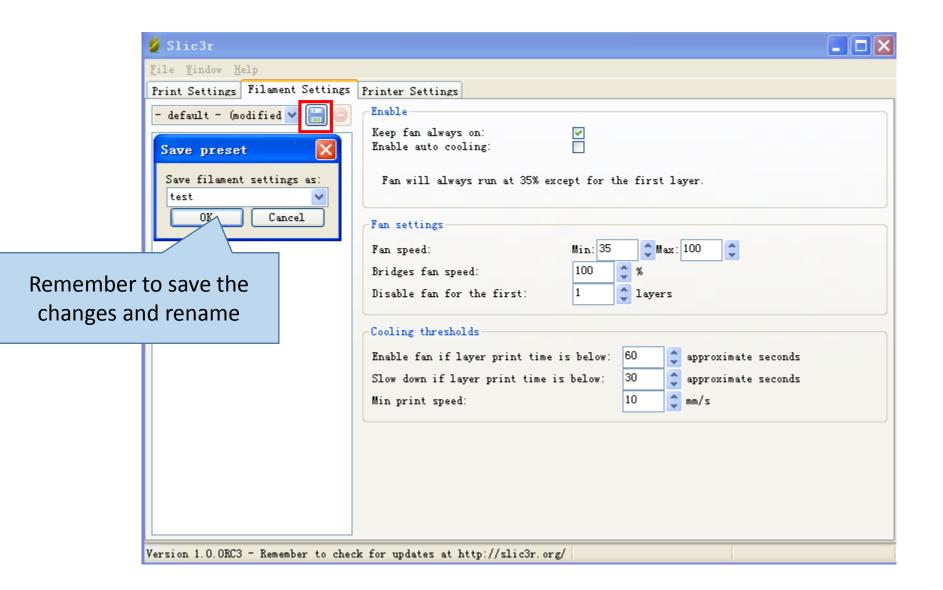
💋 Slic3r				
<u>F</u> ile <u>W</u> indow <u>H</u> elp				
Print Settings Filament Settings	Printer Settings			
- default - (modified 🕶 🔚 🔤	Layer height]	
Layers and perimeters	Layer height:	0.2 mm		
Infill O Speed	First layer height:	0.2 mm or %	Layer heig	ht can be 0.1mm to
Skirt and brim	Vertical shells		0.4mm	i, usually <mark>0.2mm</mark>
🥃 Notes	Perimeters (minimum):	3	First layer he	eight should be less or
Output options Multiple Extruders	Spiral vase:		-	ther layer height.
dvanced 🥟	-Horizontal shells			
	Solid layers:	Top: 3 🗘 Bottom: 3 🗘		
	Quality (slower slicing)			
	Extra perimeters if needed:			
	Avoid crossing perimeters: Start perimeters at:	Concave points: Non-overhang p	oints:	
	Detect thin walls: Detect bridging perimeters:	V		
	Advanced			
	Randomize starting points: External perimeters first:			
Version 1.0.0RC3 - Remember to chec	ck for updates at http://slic3r.or	re/		

💋 Slic3r				
<u>F</u> ile <u>W</u> indow <u>H</u> elp				
Print Settings Filament Settings	Printer Settings			
- default - (modified 💙 📔 🔵	[Infill			
Layers and perimeters	Fill density:	0.4		
Infill	Fill pattern:	rectilinear	~	
🕑 Speed	Top/bottom fill pattern:	rectilinear	~	
💼 Skirt and brim 鳸 Support material				
June Support material	Reducing printing time		Dancity of into	rnal infill
Output options	Combine infill every:	1 🛟 layers	Density of inte	
🍸 Multiple Extruders 🎤 Advanced	Only infill where needed:		expressed in the	e range 0-1
			(default:	0.4)
	Advanced		(actual)	0,
	Solid infill every:	0 🛟 layers		
	Fill angle:	45 🛟 °		
	Solid infill threshold area:	70 mm²		
	Only retract when crossing perimeters:			
	Infill before perimeters:			
Version 1.0.0RC3 - Remember to chec	k for updates at http://slic3r.or	e/		

File Window Help Print Settings File window Help Print Settings I default - (modified) Save preset Save print settings as: test Cancel Save print settings as: Cancel Combine infill every: 1<1 area 1 ayers Only infill where needed:	
Image: state of the	
Save preset Save print settings as: test OK Cancel Fill density: Output Output Cancel Top/bottom fill pattern: rectilinear Top/bottom fill every: Only infill where needed: Advanced Advanced	
Save preset Save print settings as: test OK Cancel Fill pattern: Top/bottom fill pattern: Remember to save the changes and rename Advanced	
Save print settings as: test OK Cancel Fill pattern: Top/bottom fill pattern: Tectilinear Top/bottom fill pattern:	
test Image: Cancel OK Cancel Combine infill every: 1 Image: Combine infill where needed: Image: Combine infill where needed: Advanced Advanced	
OK Cancel Combine Image: Combine infill every: Combine Image: Combine infill every: Combine Image: Combine infill every: Only Image: Combine infill every: Combine Image: Combine infill every:	
changes and rename	
Solid infill every: U 📮 layers	
Fill angle: 45 🗘 "	
Solid infill threshold area: 70 mm ²	
Only retract when crossing perimeters:	
Infill before perimeters:	
Version 1.0.0RC3 - Remember to check for updates at http://slic3r.org/	



💋 Slic3r				
<u>F</u> ile <u>W</u> indow <u>H</u> elp				
Print Settings Filament Settings	Printer Settings			
- default - (modified V 🔚 💿	Enable Keep fan always on: Enable auto cooling: Fan will always run at 35% except for Fan settings			
	Fan speed: Min: 35 Bridges fan speed: 100 Disable fan for the first: 1		t " <mark>keep</mark> fan alw	vays on"
	Cooling thresholds Enable fan if layer print time is below: Slow down if layer print time is below: Min print speed:	60 🗘 approximate 30 🗘 approximate 10 🗘 mm/s		
Version 1.0.0RC3 - Remember to chec	ck for updates at http://slic3r.org/			



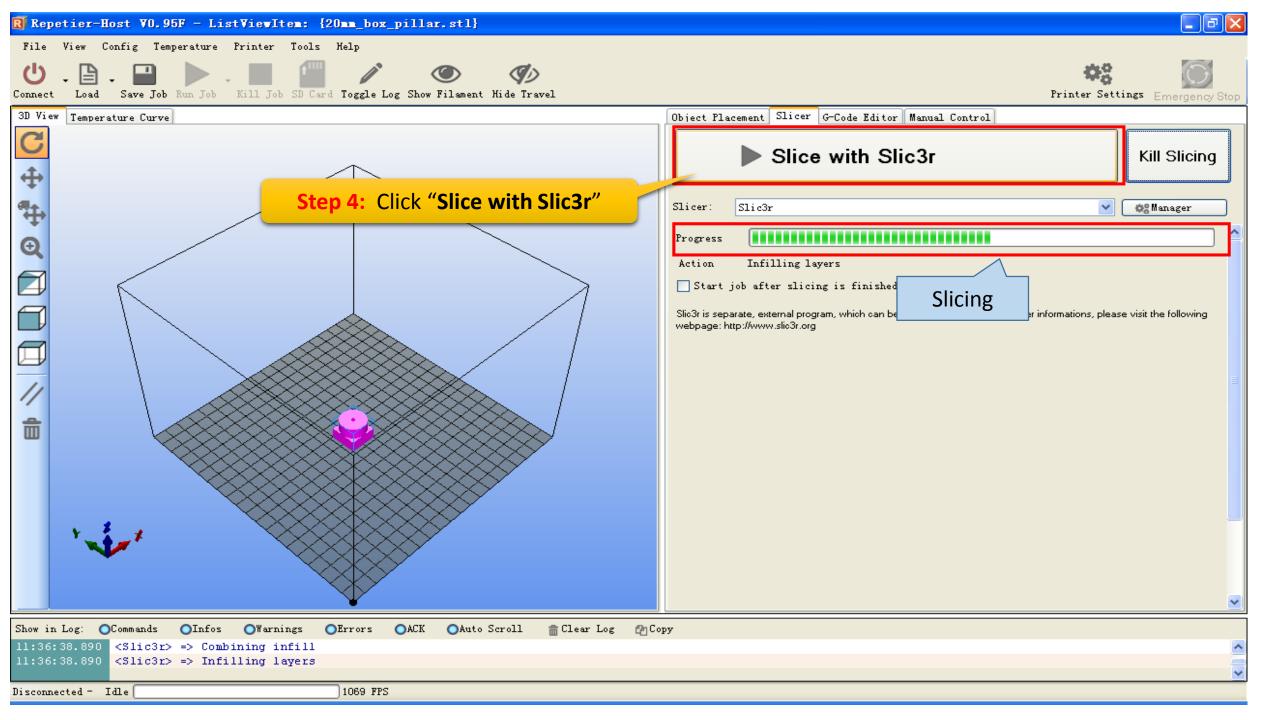
💋 Slic3r	
<u>F</u> ile <u>W</u> indow <u>H</u> elp	
Print Settings Filament Settings	Printer Settings
- default - (modified 💙 📄 🥯 General Custom G-code Y Extruder 1	Bed size: x: 220 y: 220 mm Print center: x: 200 y: 200 mm Z offset: 0 mm
	Firmware The print size is G-code flavor: RepRap (Marlin/Sprinter) Use relative E distances: 200*200*170mm, you can set as picture
	Capabilities Extruders: 1
	Advanced Use firmware retraction: Vibration limit: 0 Hz

💋 Slic3r				
Tile Window Help				
Print Settings Filament Settings	Printer Settings			
- default - (modified 🕶 🔚 🔵	Size			
General	Nozzle diameter:	0.4 mm		
Custom G-code	<			
ү Extruder 1	Position (for multi-extruder printers) The nozzle diamet			
	Extruder offset:	x:0 y:0 mm	0.4mm	
	Retraction			
	Length:	1 mm (zero to disable)		
	Lift Z:	0 mm		
	Speed:	30 🗘 mm/s		
	Extra length on restart:	0 mm		
	Minimum travel after retraction:	2 mm		
	Retract on layer change:			
	Wipe while retracting:			
	Retraction when tool is disabled	(advanced settings for m	ulti-extruder setups)	
	Length:	10 mm (zero to d	isable)	
	Extra length on restart:	0 mm		
ersion 1.0.0RC3 - Remember to chec	k for updates at http://slic3r.org/			

💋 Slic3r				
<u>F</u> ile <u>W</u> indow <u>H</u> elp				
Print Settings Filament	Settings Printer Settings			
- default - (modified 💙	Size-			
Save preset	Nozzle diameter: 0.4 mm			
Save printer settings a	Position (for multi-extruder printers)			
test OK Cancel	Extruder offset: x:0 y:0 mm			
	Retraction			
	Length: 1 mm (zero to disable)			
Remember to save the	Lift Z: 0 mm			
changes and rename	Speed: 30 🗘 mm/s			
	Extra length on restart: 0 mm			
	Minimum travel after retraction: 2 mm			
	Retract on layer change:			
	Wipe while retracting:			
	Retraction when tool is disabled (advanced settings for multi-extruder setups)			
	Length: 10 mm (zero to disable)			
	Extra length on restart: 0 mm			
Version 1.0.ORC3 - Remember to check for updates at http://slic3r.org/				

🖉 Slic3r			
<u>F</u> ile <u>W</u> indow <u>H</u> elp			
Print Settings Filament Settings	Printer Settings		
test V Extruder 1	Size and coordinates Bed size: Print center: Z offset:	x: 220 y: 220 mm x: 200 y: 200 mm 0 mm	Turn off the window after saving
	Firmware G-code flavor: Use relative E distances:	RepRap (Marlin/Sprinter	/Repetier) 💌
	Capabilities Extruders:	1	
	Advanced Use firmware retraction: Vibration limit:	0 Hz	

🔣 Repetier-Host VO.95F - 20mm_box_pillar.stl					
File View Config Temperature Printer Tools Help					
Connect Load Save Job Run Job - Kill Job SD Card Toggle Log Show Filament Hide Travel	Printer Settings Emergency Stop				
3D View Temperature Curve	Object Placement Slicer G-Code Editor Manual Control				
C ↓	Slice with Slic3r				
	Slicer: Slic3r				
	Print Setting: test				
	Printer Settings: test				
	Filament settings:				
	Extruder 1:				
	Extruder 2: PLA2-FanKeepon				
	Extruder 3: PLA2-FanKeepon				
time to the second seco	ep 4: Select the parameters which you set and named from slic3r				
	Infill Density 6%				
	Infill Angle 45°				
	Infill Pattern: honeycomb				
	Solid Infill Patter rectilinear 👻				
	Slic3r is separate, external program, which can be started separately. For further informations, please visit the following webpage: http://www.slic3r.org				
Show in Log: 💽Commands 💽Infos 🗨 Warnings 💽 Errors 🔿 ACK 🔿 Auto Scroll 🍵 Clear Log 🖓 Copy					
11:22:46.906 Object is manifold. 11:22:46.906 Analysing finished.					
Disconnected - Idle 1447 FPS					



R Repetier-Host VO.95F - ListViewItem: {20mm_box_pillar.stl}						
File View Config Temperature Printer Tools Help						
Connect Load Save Job Run Job Kill Job SD Card Toggle Log Show Filament Hide Travel	Printer Settings Emergency Sta					
3D View Temperature Curve	Object Placement Slicer G-Code Editor Manual Control					
C	🕒 🔛 🔀 🔁 🖒 🖸 🕼 🕞 🖉 🗸 🗸					
You can click here and save the gcode file Micro SD card Please refer to the file < <how to off-line print >> to study how to print a model using a micro-SD Card.</how 	<pre>1; generated by Slic3r 1.0.0RC3 on 2014-08-25 at 11:36:40 2; 3; layer_height = 0.2 4; perimeters = 3 5; top_solid_layers = 3 6; bottom_solid_layers = 3 7; fill_density = 0.4 8; perimeter_speed = 30 9; infill_speed = 60 10; travel_speed = 130 11; nozzle_diameter = 0.4 12; filament_diameter = 1.75 13; extrusion_multiplier = 1 14; perimeters extrusion width = 0.40mm 15; infill extrusion width = 0.67mm 16; solid infill extrusion width = 0.67mm 17; top infill extrusion width = 0.67mm 18; first layer extrusion width = 0.40mm 19 20 G21; set units to millimeters 21 M104 S200; set temperature Visualization Halp 9 Show complete Code O Show Single Layer O Show Layer Range 9 First Layer: 1 100 Ri C1 Insert Layer 0 Extruder 0 Frinting Time:22m:50s </pre>					
Show in Log: Commands OInfos OWarnings OErrors OACK OAuto Scroll 💼 Clear Log 🖓 Copy						
11:36:41.406 <slic3r> Done. Process took 0 minutes and 5.234 seconds 11:36:41.406 <slic3r> Filament required: 1849.2mm (4.4cm3)</slic3r></slic3r>						
Disconnected - Idle 790 FPS						

