# Contents

1、Connecting Power and Computers....3

1)、Connecting Power....3

2)、Connecting Computers....4

2、Install drivers....4

3、Pre-configurate the software and test....6

1)、Connect the software....7

2)、Test....10

4、Print Models....12

1)、Machine Adjustment....12

2)、Generate STL file to GCODE....17

3)、Printing....22

4)、Off-line printing....22

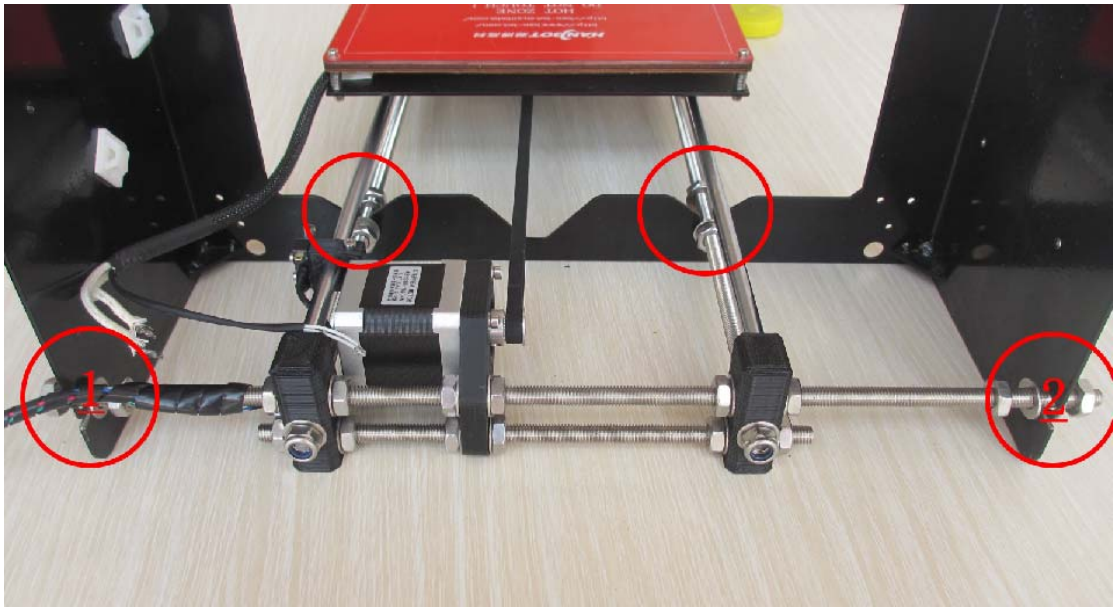
Websites....23

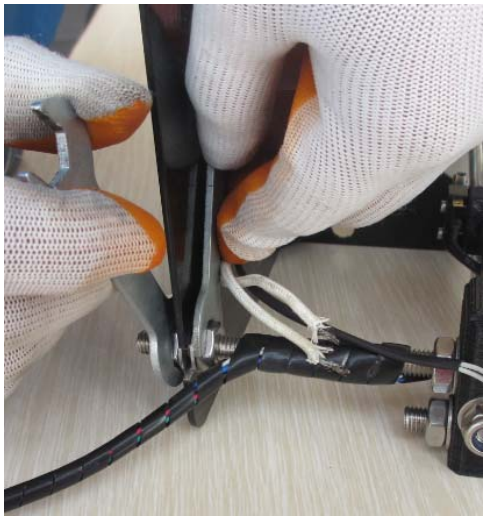
## Preparation before use:

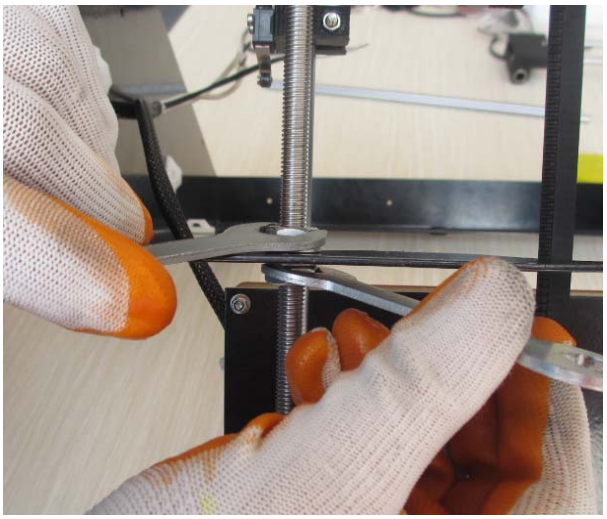
When you received our 3d printer and open the carton, please do simple assembly first:

Put the assembled Y axis to sheet metal frame,

Tighten the nuts marked in red circle, ATTENTION, the threaded rod at red circle 1 and 2 must be very close to the inner part of the slot



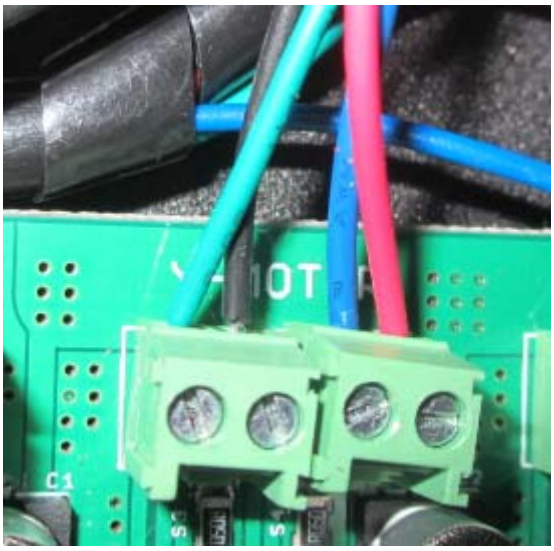





Then connect the wire to the PCB, we have stick the marks on the wire to demonstrate which port on the PCB the wire should be connected

You need connect 4 sets of wire, the Y motor, the Y stop, the BTEMP, and the HOTBED.

PS: when you connect the Y motor, the order of the wire should be green, black, blue, red, from up to down, refer to the below pictures



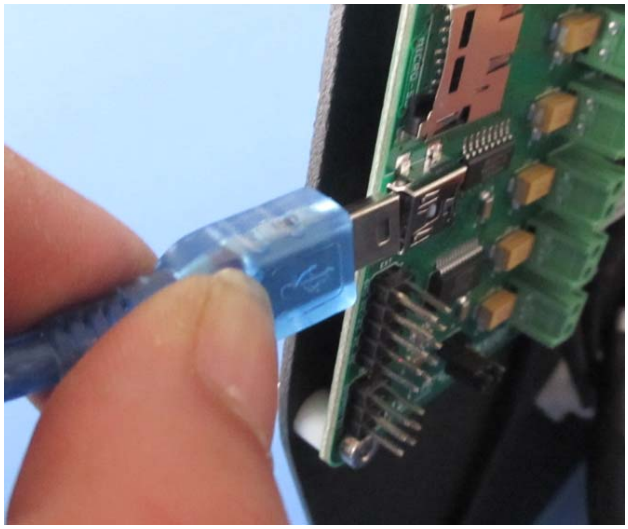
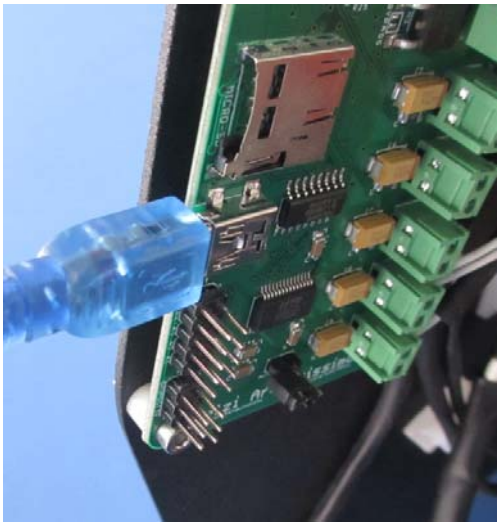

## 1、Connecting Power and Computers

### 1)、Connecting Power

Connecting the plug to the socket

## 2)、Connecting Computers

Connecting the machine and the computer with the USB wire,

## 2、Install drivers

Please copy the files in the SD cards to the computer for back-ups. Then could delete the

files, SD card would speciallized for off-line printing.

After successful connecting, computer will let us install the new hardware, cancel please.

**If your computer system is XP, please follows the below steps:**

STEP1- please install the DOTNETFX35 first, shut off the internet, the speed could be faster.

（PS: Win 7 or aboved version has that software）

STEP2- Find the automatically-installment program, double click 

to install the driver according to the wizard

PS: If the automatically-installment program don’t work under Win 7 or above version, please install the driver manually! The methods are all the same.

**Check whether the driver is installed successfully.**

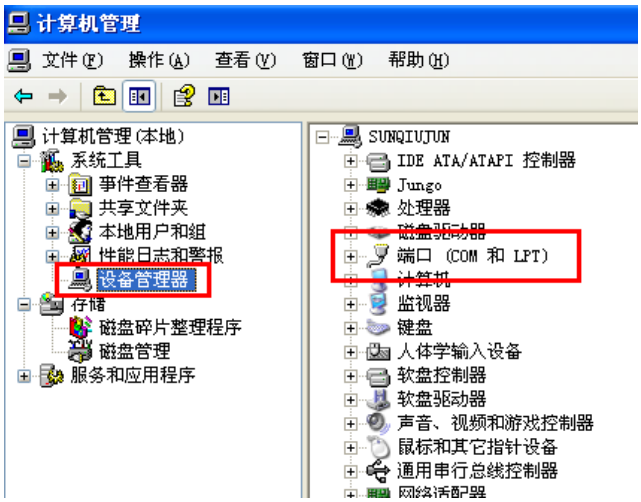
Take the USB out of the computer, and put it in again, the system will let install the new hardware again,

A: If you install the driver automatically, click next, system will install automatically, click OK at last.

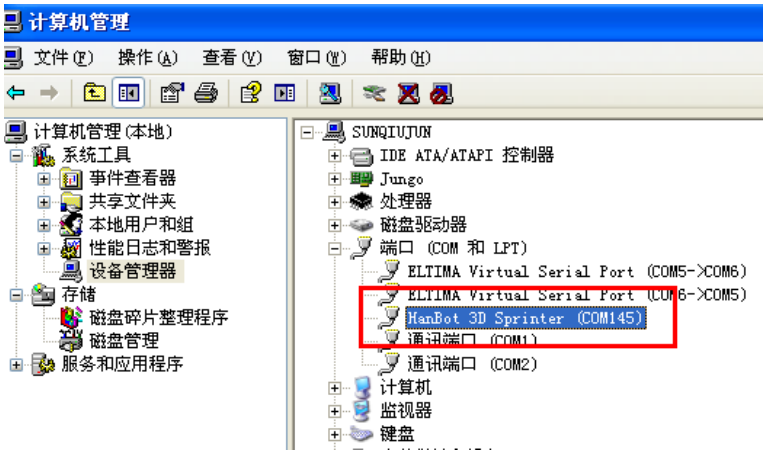
B: If you do it manually, choose” Install from the list or specific location”, then choose the catalogue of the driver, click install at last. (The same method as common driver manual installment).

Right click “My Computer”, choose “Management”, click “Device

Management", and refer to below pictures"




Find "Port", you install the driver successfully. Please kindly keep your PORT number （Every computer might have different port number）.

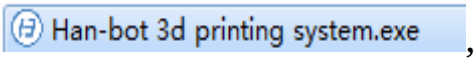



## 3、Pre-configurate the software and test

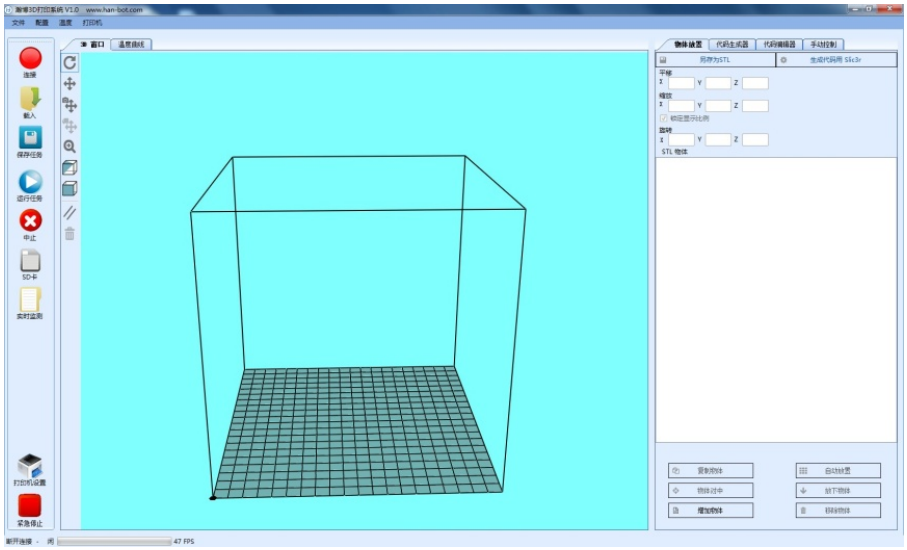
In the SD card, there is not only our company's own software, we also

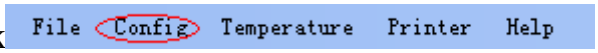
supply the CURA.

## 1)、Connect the software

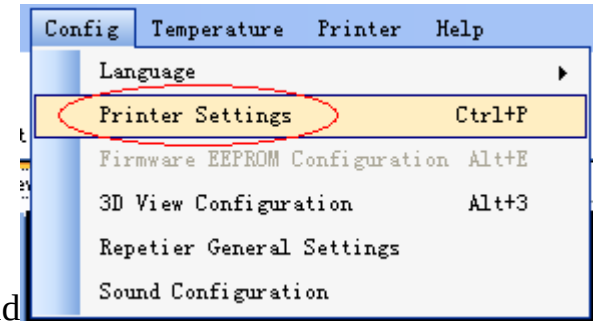
Double click 

, Our printing system will come out.:



Click 

,

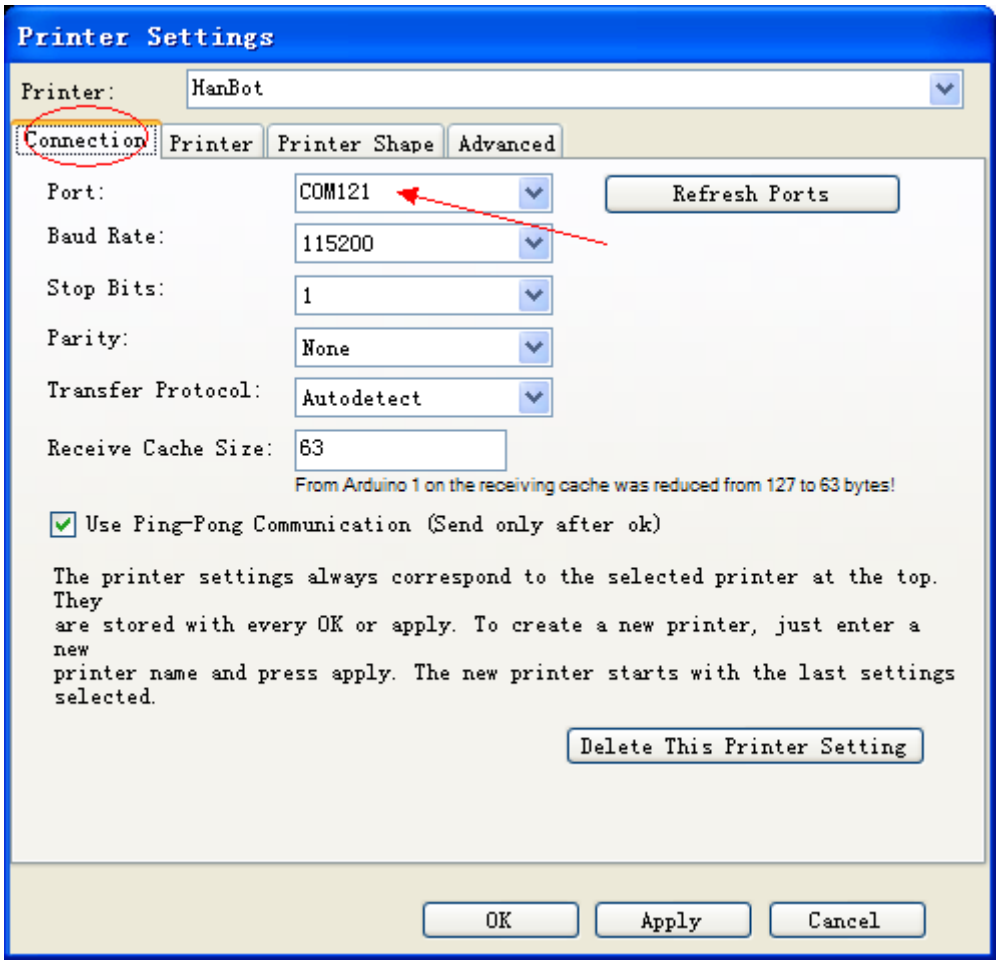
find 

,

Click it, you will see the window below,

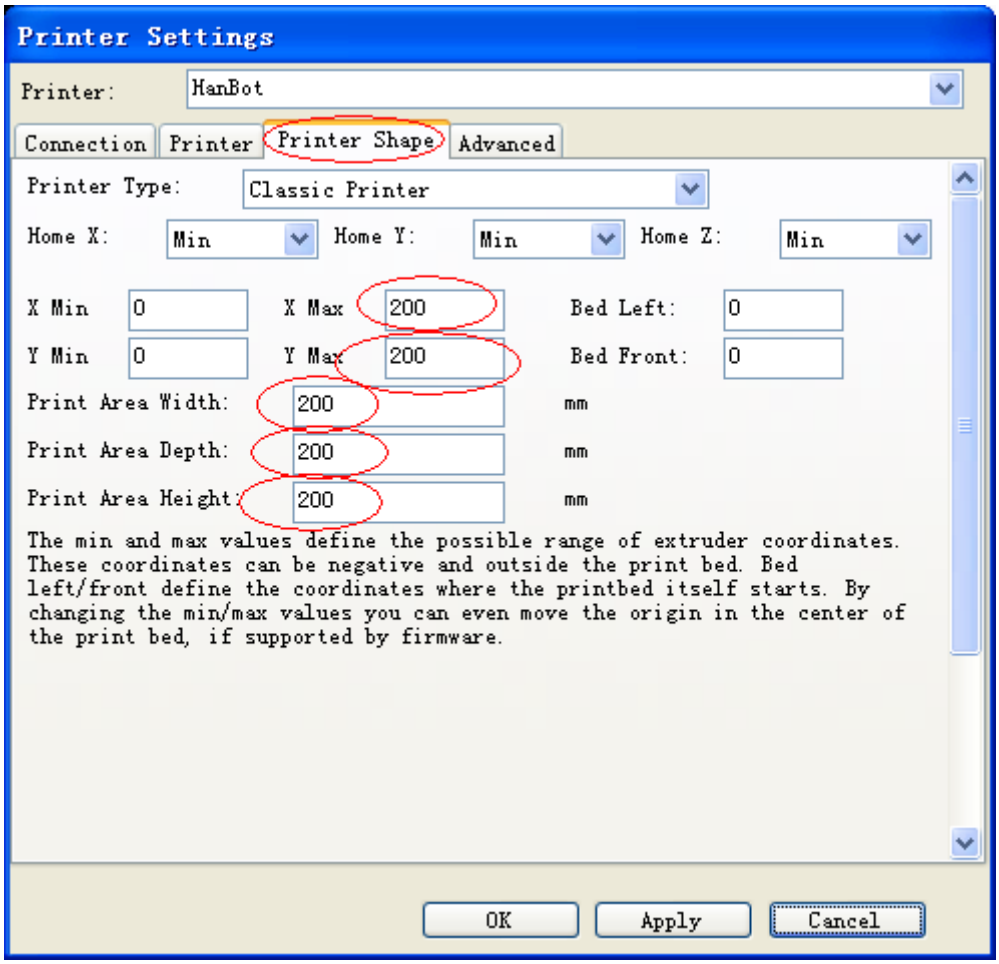
**Setting the CONNECTING first**, still remember your port? Use yours. Suggested that set other parameter as the picture below, especially the Baud Rate must be

*115200.*



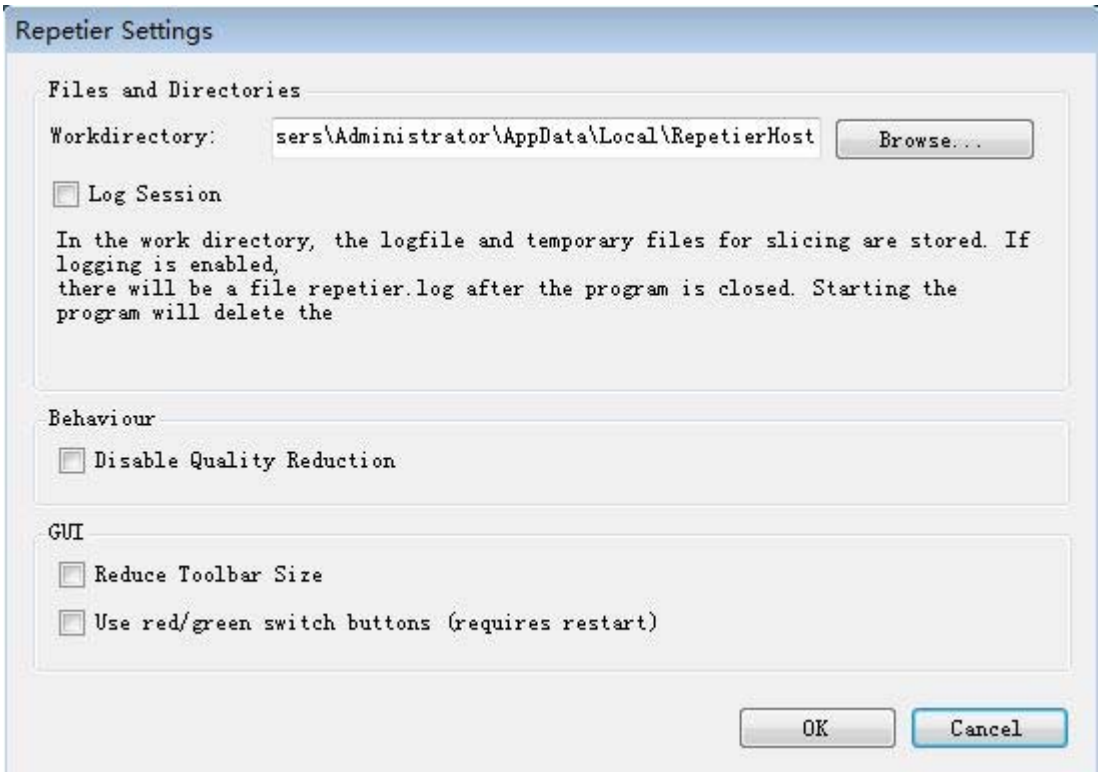

**Setting the PRINTER**, Attention please, the temperature is important, ABS, please set 230°C and 110°C, if you print PLA, please set 185°C and 55°C to 80°C,(We use ABS for this manual, so our temperature is 230 and 110°C.)

**Setting the PRINTER CONFIGURATION**. Our PRUSAI i3 build size is 200*200*200MM, so change the number to 200 in the market form, the other could be the same as below picture,




Then, click 


PS: In the “Repetier General Settings”, the workdirectory must be English, otherwise the GCODE cannot be generated. Refer to below picture




## 2)、Test

click 

, If connecting successfully, the software will show 


## Test the Moving control and the end-stop

Click “Homing” button  , After that, move the X/Y/Z axis to check the movement.

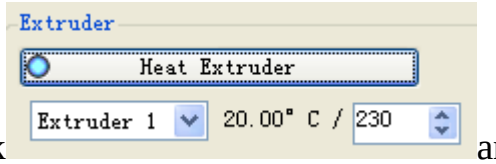
- X homing, Y/Z is the same. After click, the axis will home.

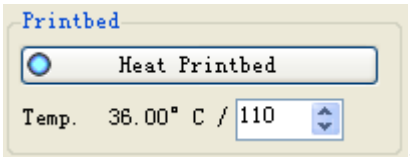
 - After click, the 3 axis will home at the same time.

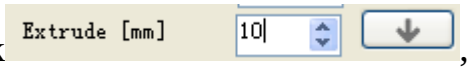
PS: If the machine is not homed, it could only move in Unilateral area; if you are not familiar with the machine, the move distance could not too far.

**Check the temperature-test and heat system (Extrusion and heat bed )**

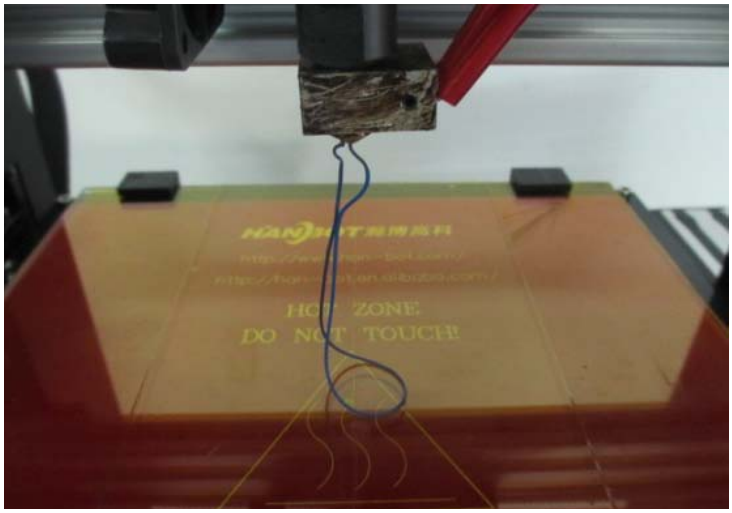
If not heated, the number of temperature will be the same as ambient.

Click 

and 

, the temperature will rise up. When the extruder temperature rise to 230(If PLA, the temperature could be 190), click 

, check whether the filament is extruded fluently. Refer to the below picture:



**Check the fan**

Adjust the fan output to 100%, then click 

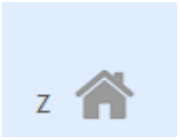
, check whether the fan works well.

PS：When heat the bed, shut off the fan.

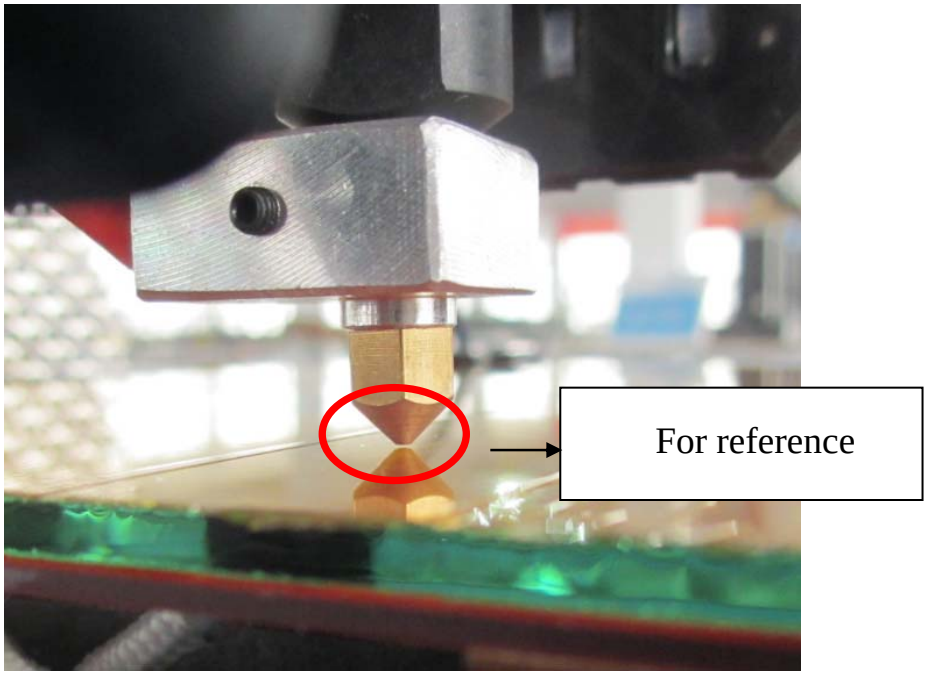
# 4、Print Models

## 1)、Machine Adjustment

Actually, every Prusa I3 is well adjusted. But during the shipping, there could be some error because of the hit or other aspects. So before printing, please check whether the heat bed is flat or not again and whether the height between the heat bed and nozzle is OK.

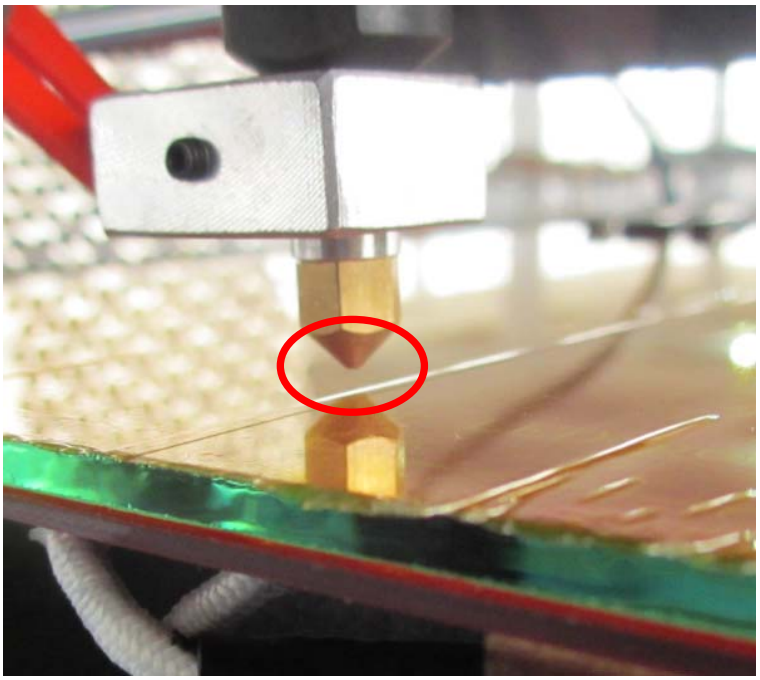
Choose 4 corners of the heat bed, choose one first, Click 

，homing Z axis，check whether the distance between the heat bed the nozzle is almost the same as the below picture,



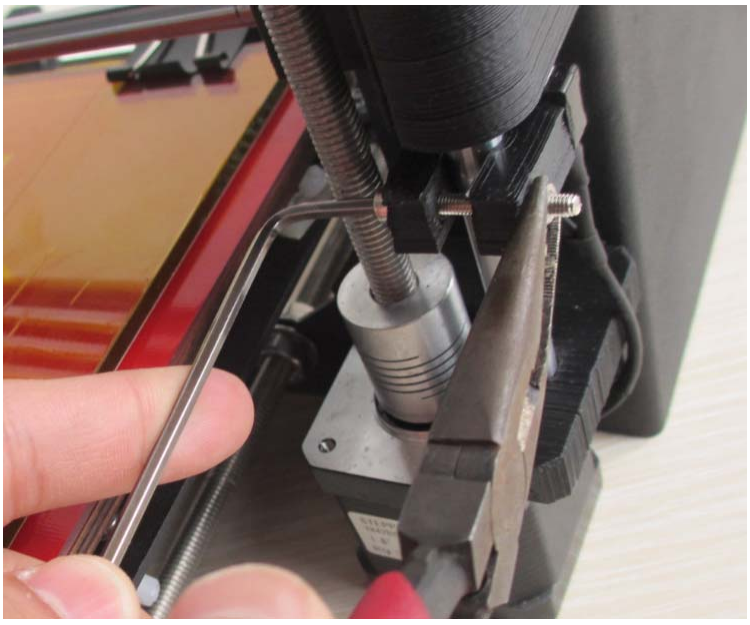

If the distance of the four corners is almost the same as reference, and there is not big difference, we don’t need to adjust the machine.

**But, If the distance is too large as the below picture**

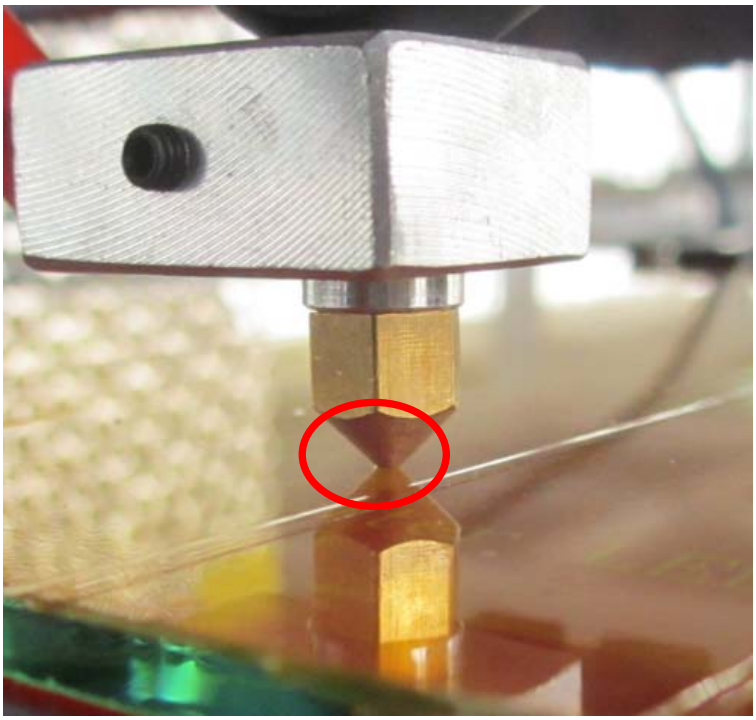


Please loose the Z end-stop holder first, and lower down the holder a little bit, click 

again, check the distance, if still too large, lower down again until the distance is almost the same as the reference picture, then fix the holder.

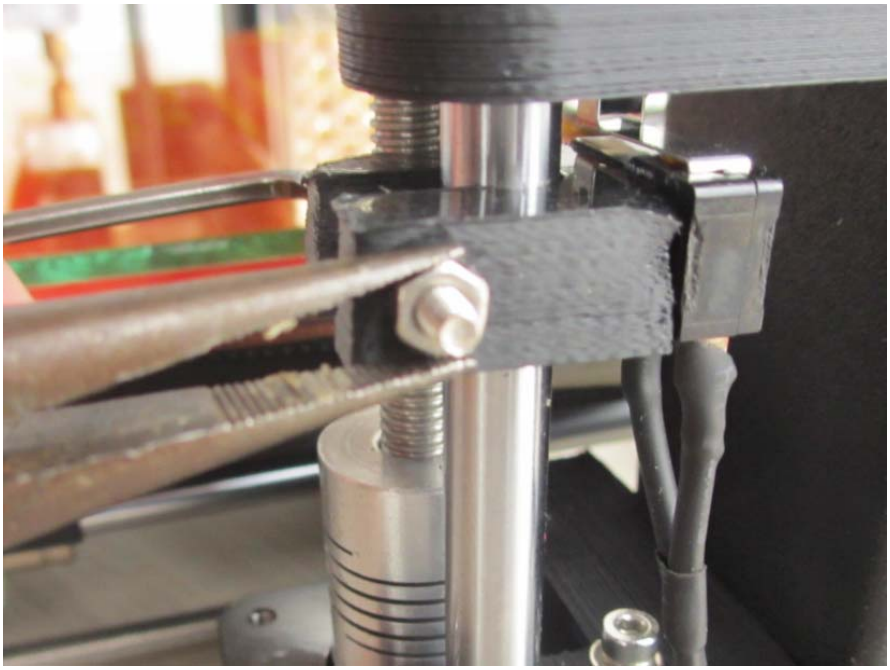


**If the distance is too small as the below picture:**

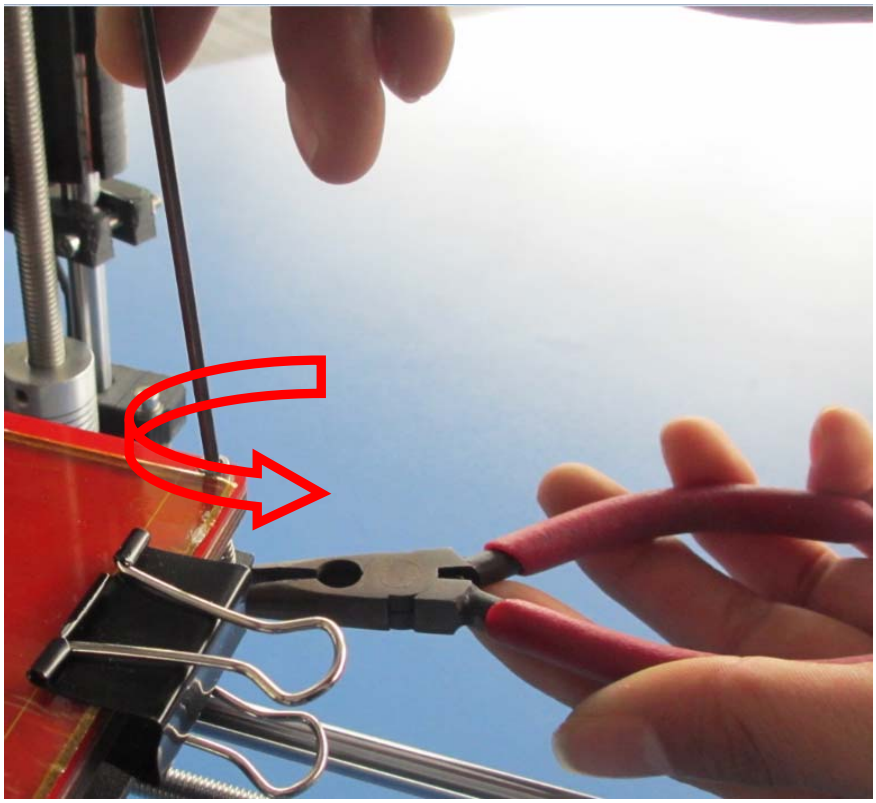


Please loose the Z end-stop holder first and move up the holder a little bit, click 

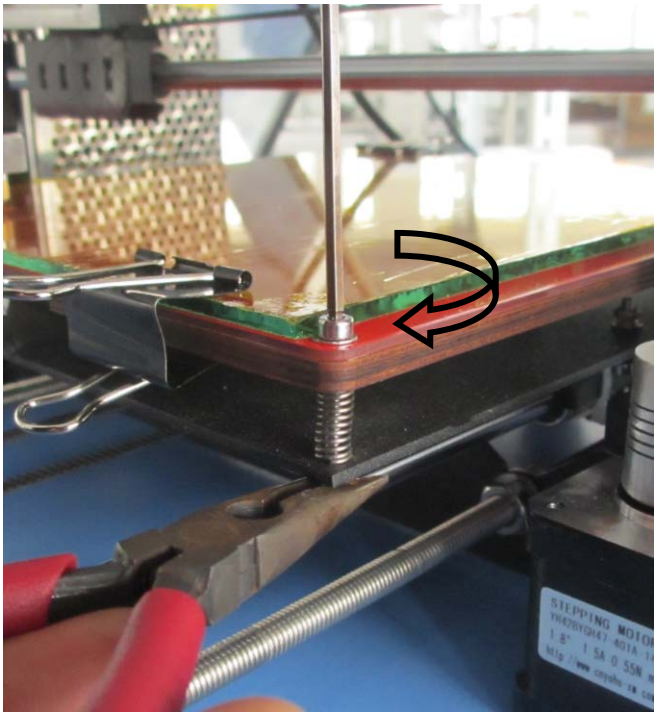
again, check the distance, if still too small, move up again until the distance is almost the same as the reference picture, then fix the holder.



After adjust one corner, don’t forget to adjust the other 3 corners, during adjust the other 3 corners, there is no need to adjust the Z end-stop, we could set the screws on the heat bed, if the distance is too large, use the needle-nose pliers the fix the nut,, use M2.5 hex key to loosen the screw counterclockwise as the below picture, when you are doing that, check the distance, reach to the suggested distance is OK



If the distance is too small, we could use the needle-nose pliers the fix the nut, use M2.5 hex key to fix the screw clockwise as the below picture, when you are doing that, check the distance, reach to the suggested distance is OK



Here we have a good printing experience to share with everyone:

After the adjustment, there will some deviation; we have good and easy method to solve the problem:

When machine is printing the first layer, if the distance is too large, we could twist the 2 couplings counterclockwise simultaneously a little bit, until the distance reach to the reference,


if the distance is too small, we could twist the 2 couplings clockwise simultaneously a little bit, until the distance reach to the reference,


## 2)、Generate STL file to GCODE

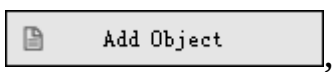
Our 3d printer support STL and Gcode file. And the it need the GCODE at last, the quality of the GCODE will influence the precision. To generate the high-quality GCODE, please handle the slicing configuration well.

If you have already turned on the software, please shut it down. 


Find “Slicing Configuration”, open it, double click” Double click and run”, then press “Enter” button, then the slicing configuration well be set as our company’s default. You can also change the settings according to your own demand.

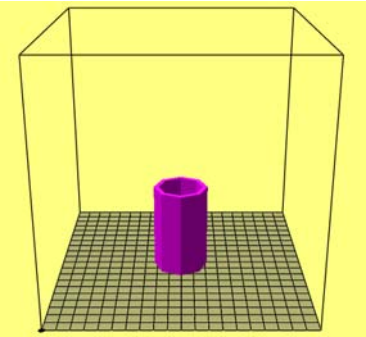
### Load Model

Open the software, in 

, click 

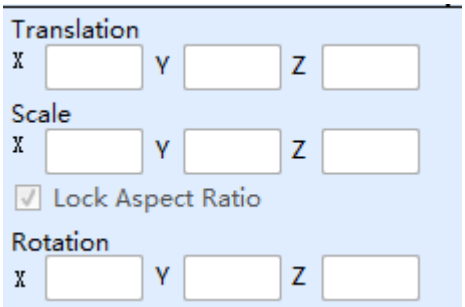
, choose the STL you want to print.

The right picture shows the sample.



## Models Mangement

You could see “Translation”, “Rotation”, “Scale” in the right part of the software,




“Translation”- change the position

“Scale”- Change the size

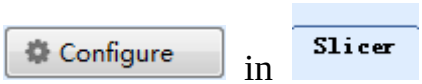
“Rotation”- the angle of the model.

There are “Center Objects”, “Copy Objects” buttons, in the down part, you could try these functions.

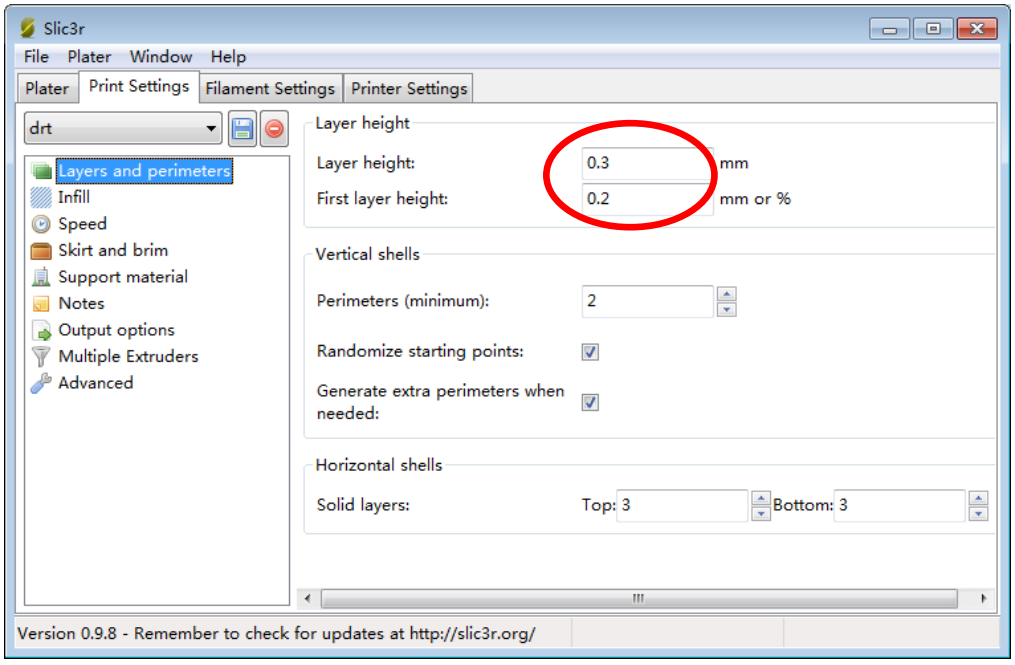
## Generating Gcode

If you print ABS, choose DRT2(ABS), If PLA, choose DRT2(PLA)

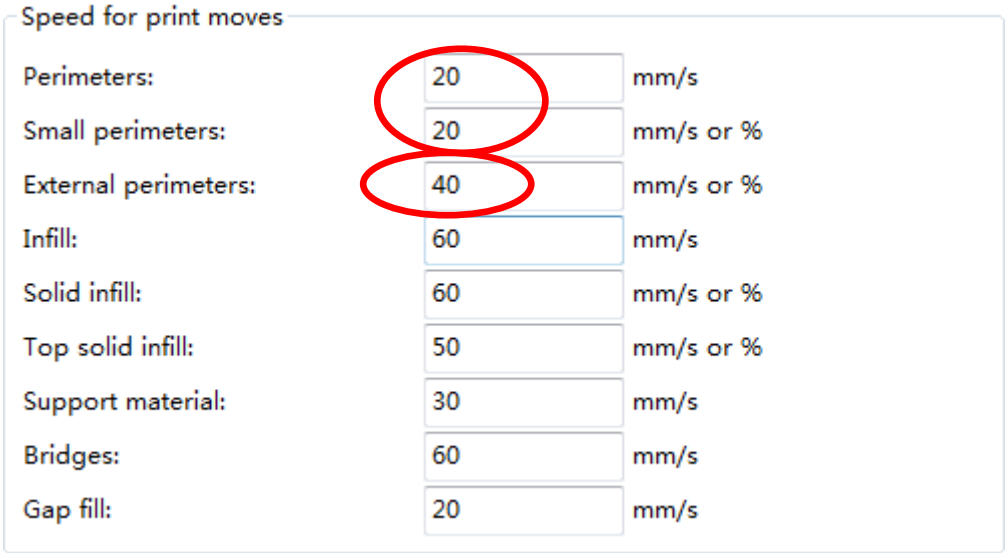
If you want to change the settings, please refer to below pictures after click,



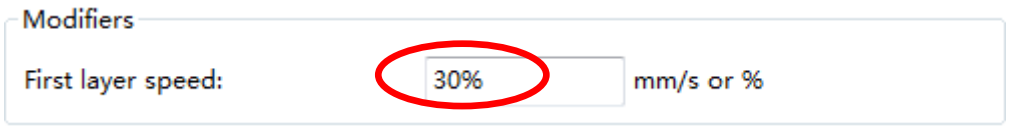

in



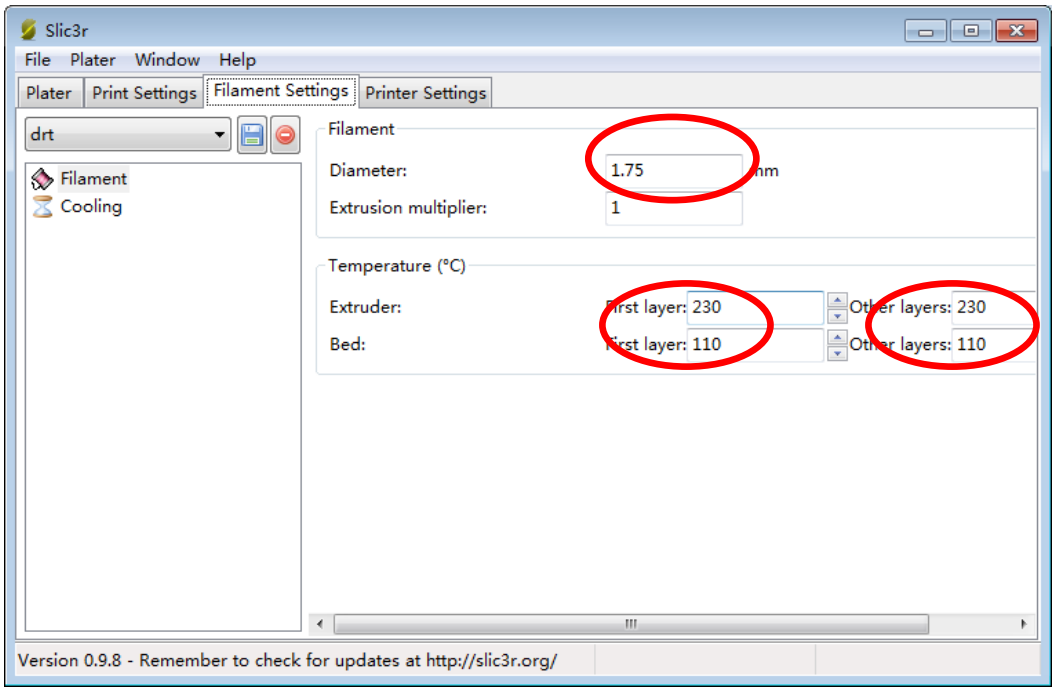

Layer height is suggested 0.3mm, first layer height 0.2mm



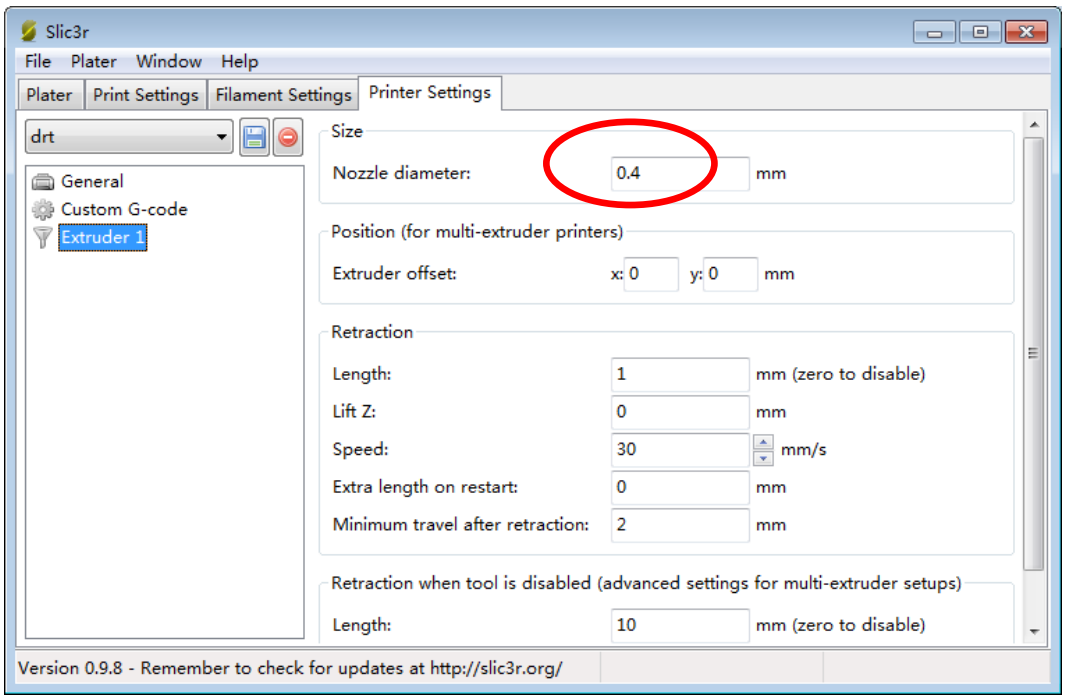

Perimeters speed suggested 20, small perimeters suggested 20, external perimeters suggested 40.




First layer speed suggested 30%, if too fast, the parts could be warping.

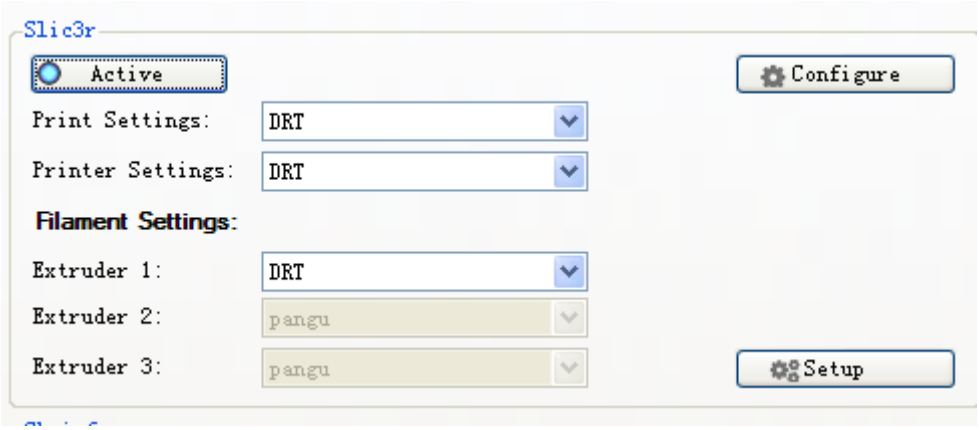



Filament diameter 1.75, extrusion multiplier 1, extruder temperature 230, bed 110(because we are printing ABS)

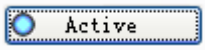
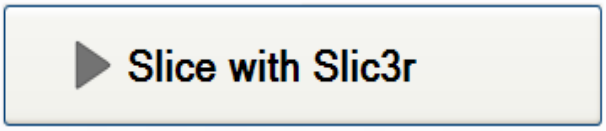



Nozzle diameter 0.4

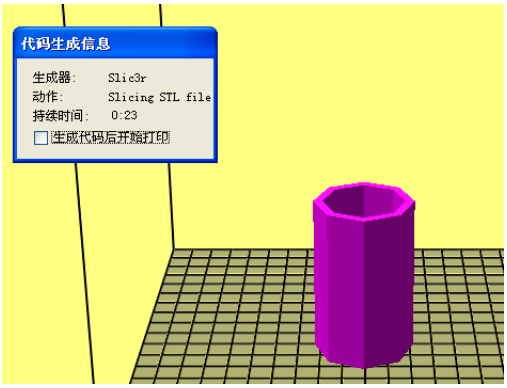
After every change, we must click  to save, remember the save name.



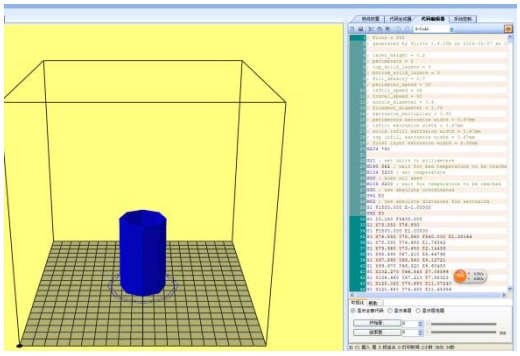

Choose the saved configuration as the above picture,(I save the name as DRT) Now your setting is done.

Click  then Click  ,



Gcode is being generated as the right picture 



Gcode is generated 

### 3)、Printing

After connecting the machine with computer, click 

, when the temperature rise to the setted, the machine will work.

PS：The first layer is very important, it is better that leave the machine after its successful printing.

### 4)、Off-line printing

Off-line printing is better, especially for big models costing more time. After the GCODE is generated, click ”Save” button and save it to SD card, the save name could only be in English or Arabic numbers After saved, please refer to the “LCD Control Systems” for more details.

# Websites

Any question, please visit our websites.

Website：http://www.han-bot.com/

Forum：http://www.han-bot.com/bbs/forum.php?mod=forumdisplay&fid=36

Alibaba：http://han-bot.en.alibaba.com/