



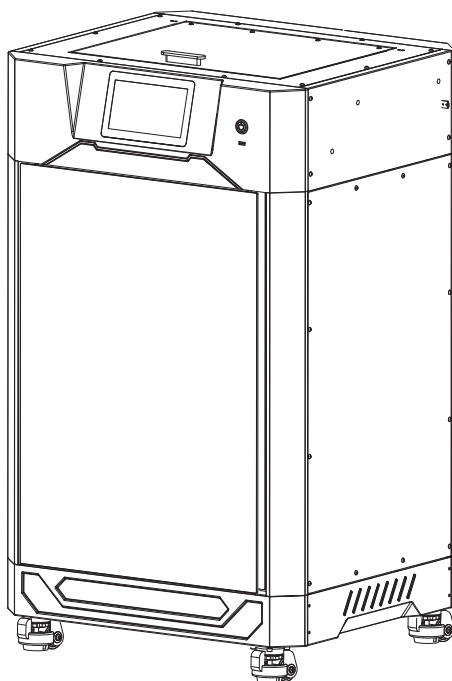
EN/CN-A02

Guider 3 Ultra / 引领者 3 Ultra

User Guide

≡ 用户使用手册 ≡

中文P39



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NOTICE

SAFETY NOTICE: PLEASE CAREFULLY READ AND STRICTLY FOLLOW ALL THE SAFETY WARNINGS AND NOTICES BELOW ALL THE TIME.

WORK ENVIRONMENT SAFETY

- ◆ Please keep the workspace clean and tidy.
- ◆ Please ensure the equipment operates away from combustible gases, liquids, and dust. High temperatures generated during operation may react with combustible gases, liquids, or airborne dust, potentially causing fires.
- ◆ Children and untrained individuals should not operate the equipment alone.

ELECTRICAL SAFETY

- ◆ Please properly ground the equipment. Do not modify the plug. Ungrounded equipment/improperly grounded equipment/modified plug will inevitably increase the risk of electric leakage.
- ◆ Avoid exposing the equipment to damp or direct sunlight environments. Humidity will increase the risk of electric leakage. Exposure to sunlight will accelerate the aging of plastic parts.
- ◆ Make sure to only use the power cord provided by Flashforge.
- ◆ Do not use the equipment during thunderstorms.
- ◆ Please turn off the equipment and unplug it if it is not in use for a long time.

PERSONAL SAFETY

- ◆ Do not touch the extruder, build plate, etc., during printing.
- ◆ Do not touch the extruder and build plate after finishing printing to avoid high temperature burns or mechanical damage.
- ◆ Do not wear scarves, masks, gloves, jewelry, or other objects that can easily get tangled into the equipment while operating it.
- ◆ Do not operate the equipment while you are tired or under the influence of drugs, alcohol or medication.

CAUTIONS

- ◆ Keep the inside of the equipment clean. Do not drop metal objects into the grooves at the bottom of the build plate.
- ◆ Please clean up filament debris in time. It is recommended to operate this outside the equipment.
- ◆ Any modification of the equipment by yourself will void the warranty.
- ◆ Please keep the distance between the extruder and build plate for at least 50mm
- ◆ during filament loading. Too-close distance may cause nozzle clogs.

- ◆ Please operate the equipment in a well-ventilated environment.
- ◆ Do not use the equipment for illegal activities.
- ◆ Do not use the equipment to make food storage containers.
- ◆ Do not place printed models into your mouth.

EQUIPMENT ENVIRONMENT REQUIREMENTS

- ◆ Room temperature: 15-30°C; Humidity: 20%-70%

EQUIPMENT PLACEMENT REQUIREMENTS

- ◆ The equipment must be placed in a dry and well-ventilated environment. A distance of at least 60cm must be reserved around the front, back, left and right sides of the equipment. Recommended storage temperature: 0-40°C

COMPATIBLE FILAMENT REQUIREMENTS

- ◆ When using this equipment, it's recommended to use Flashforge's filaments. If non-Flashforge filaments are used, there will be certain differences in material properties, and print parameters may need adjustments.

FILAMENT STORAGE REQUIREMENTS

- ◆ Please store filaments in a dry and dust-free environment after unpacking. It is recommended to use the matching filament dry box for storage.

LEGAL STATEMENT

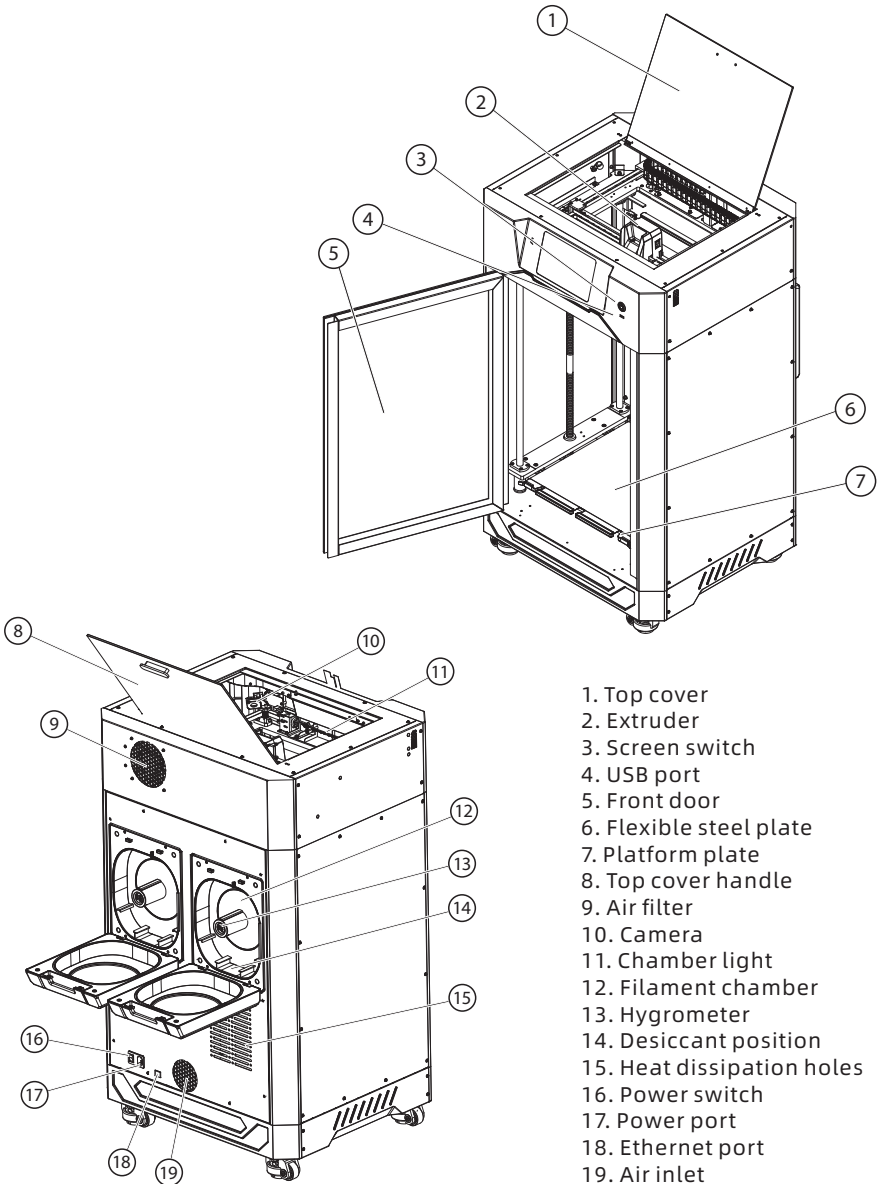
- ◆ Users are not authorized to make any modifications to this User Guide.
- ◆ Flashforge shall not be held responsible for any safety incidents resulting from the disassembly or modification of the equipment by the customer. No one is allowed to modify or translate this Guide without Flashforge's permission. This Guide is protected by copyright, and Flashforge reserves the right of the final interpretation of this Guide.
- ◆ First Edition (April 2023)
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Parameter

Equipment Name	Guider 3 Ultra
Extruder Quantity	2
Printing Precision	± 0.15mm or 0.002 mm/mm [the large values shall prevail]
Positioning Accuracy	X/Y-axis: 0.011mm / Z-axis: 0.0025mm
Layer Thickness	0.05 ~ 0.4mm
Build Volume	Single extrusion: 330x330x600mm Dual extrusion: 300x330x600mm
Nozzle Diameter	0.4mm[default] / 0.6/0.8mm [optional]
Nozzle Type	High-strength nozzle
Printing Speed	10 ~ 500mm/s
Maximum Extruder Temperature	350°C
Maximum Platform Temperature	120°C
Supported Filament	PLA/PETG/ASA/ABS/PC/PA/PLA-CF PETG-CF/PETG-GF/PA-CF/PA-GF
Power Supply	AC100-240V, 50-60Hz, 850W Max
Slicing Software	FlashPrint 5
Supported File Format	Input: 3MF/STL/OBJ/FPP/BMP/PNG/JPG/JPEG Output: GX/G/gcode
Connectivity	USB/Ethernet/Wi-Fi
Operating Temperature	15 ~ 30°C
Compatible Operating System	Win 7/8/10/11; Linux: Support version Ubuntu 20.04 or later; Mac OS: Support version 10.9 or later.
Compatible Slicing Software	Slic3r, Cura [requiring setup]
Smart Touch Screen	7-inch
Build Plate	Flexible steel plate platform
Net Weight	70kg
Equipment Dimensions	635x550x1070mm [LWH]
Required Space for Installation	≥1330*1330*1352mm

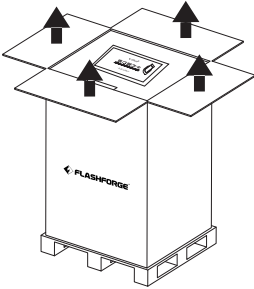
1. Equipment Introduction

1.1 Printer Components

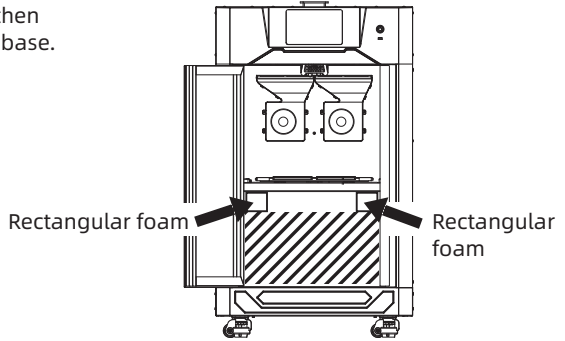


1.2 Unboxing

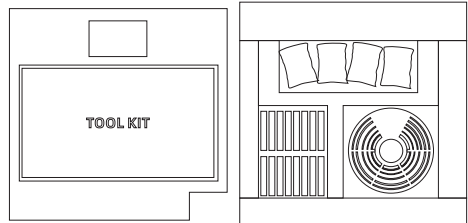
1. Open the top carton cover, and remove the top foam containing the power cord, user guide, USB flash drive, and after-sales service card. Take out the whole outer box from bottom to top and then move the machine off the wooden base.



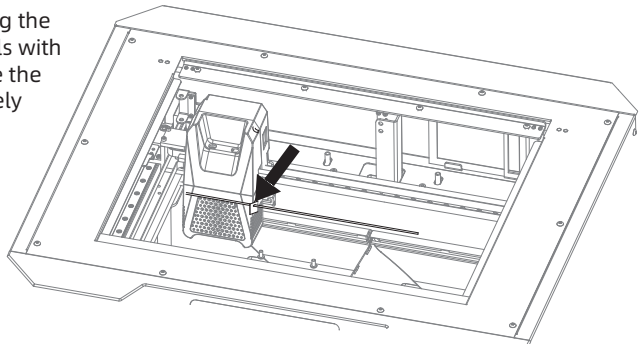
2. Open the front door. First remove (just pull out) the two pieces of rectangular foam below the platform.



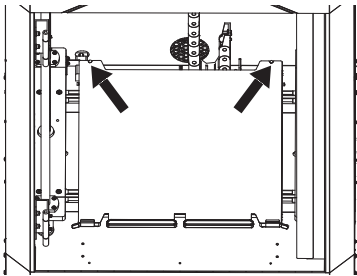
3. Then, remove the remaining foam below the platform, with two layers in total. The upper layer contains the tool kit. The lower layer contains the supplied filament, heat resistant gloves, and desiccant (for details, please refer to the packing list).



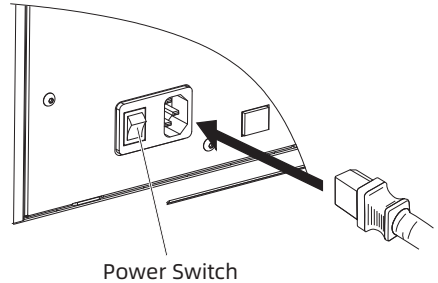
4. Cut the zip ties securing the extruder and guide rails with diagonal pliers. Ensure the extruder can move freely after ties are removed.



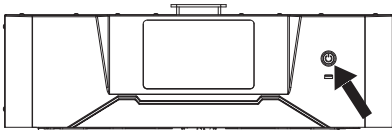
5. Check the flexible steel plate for proper installation within the rear limit. Ensure that the platform is mounted flat without pressing any foreign objects.



6. Connect the power cord to the socket and the printer. Press the power switch to start the machine.



7. Press the screen switch. A solid light indicates the touch screen is activated.




8. Upon the first startup, follow the on-screen guide to quickly adjust the printer to the ready-to-print state.




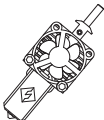

Note

When the printer is powered on for the first time, you can perform a printing test following the startup guide to confirm proper functionality.
Startup guide steps: Language selection - Leveling and calibration - Filament loading - Printer ready for printing - Test file printing - Printing completed.

If you skip any steps in this startup guide, you can still access the corresponding functions on the screen.

Note: To re-enter the startup guide, click the [] icon on the left side to go to the [Information] interface, click [Factory Reset] and select [Yes]. Then, after restarting the printer, you can access the startup guide again.

1.3 Packing List

			
3D Printer	Power Cable	Grease x 2	Glue
			
Brush	Scraper	Needle-nose Pliers	Diagonal Pliers
			
Straight Screwdriver	Unclogging Pin Tool	Allen Wrench Set	Elbow Tweezers
			
Nozzle Assembly x 2	Heat Resistant Gloves	Filament x 2	USB Disk
			
After-sales Service Card	Quick Start Guide	Fuse x 2	Desiccant x 12
			
Flexible Steel Build Plate			

2. Introduction to Basic Operation

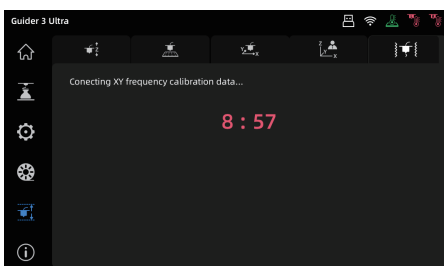
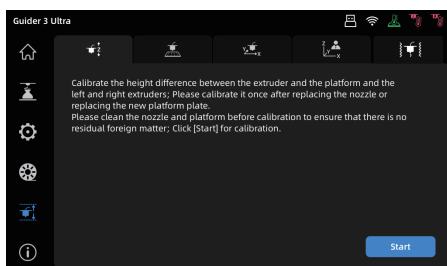
2.1 Equipment Calibration

Upon the first startup, please follow the on-screen instructions to perform automatic Z-axis calibration and platform leveling. Then, there is no need for calibration during regular printing. However, it is recommended to perform Z-axis calibration and platform leveling after the nozzle or platform is replaced.

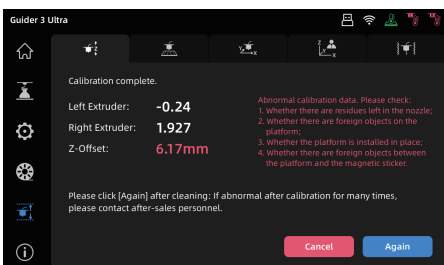
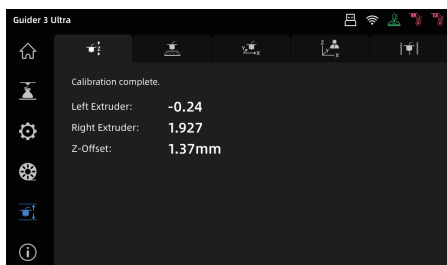
Note Before calibration and leveling, please clean the nozzle and platform to ensure there are no filament residues or foreign objects. Do not move or collide with the machine during calibration and leveling.

Follow these steps:

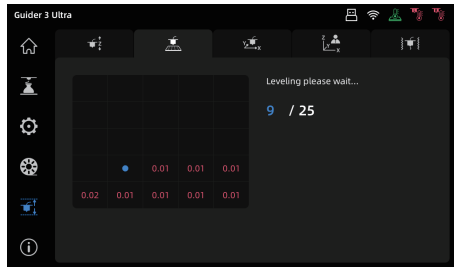
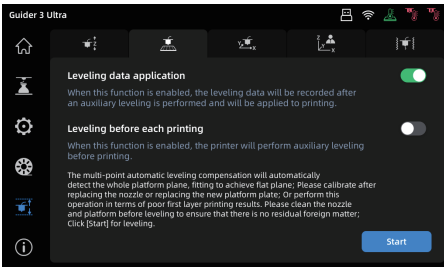
1. Upon entering the calibration interface, click the icon to access "Auto Z-axis Calibration". Click [Start], and it will automatically calibrate the Z-axis gap between the extruder and platform, as well as the height difference between the left and right nozzles.



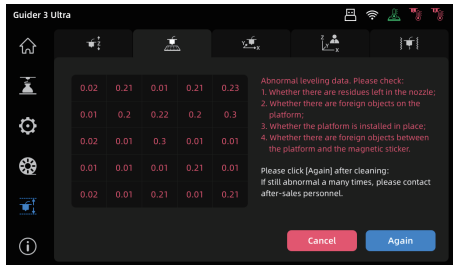
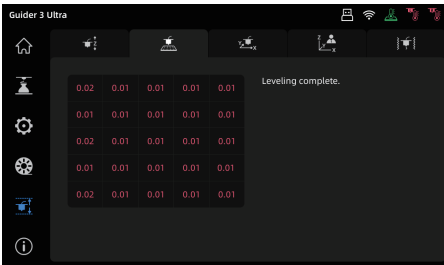
2. After automatic calibration, the printer will automatically save the calibration data. If there is any abnormal data, it will prompt you to recheck it. After confirming, click [Recalibration] for another automatic Z-axis calibration.



3. Once Z-axis calibration is completed, click the icon to enter the "Leveling" interface. Before leveling, you can choose to use the same leveling data for each print or perform automatic leveling before each print. After confirming, click [Leveling] to enter the leveling preparation interface. Ensure that the platform is properly installed and both the nozzle and platform are clean, then click [Start], and it will perform platform leveling automatically.

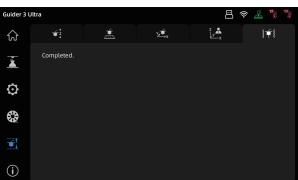
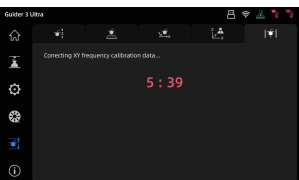
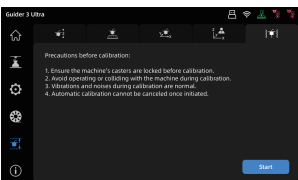


4. After leveling, if the values are normal, the printer will automatically save the leveling data. If there are any abnormalities, follow the on-screen instructions to recheck it. After confirming, click [Again] to perform leveling again.





Note Calibration interface and filament loading interface are inaccessible during printing.

5. The resonance compensation has been carried out before the printer leaves the factory and generally does not require further adjustment. If you spot ringing on a print, you can perform this operation. Before proceeding, please read the prompts on the resonance compensation interface to ensure a successful calibration. Click [Start], and it will automatically begin calibration. Vibration and slight noise during the calibration process are normal.



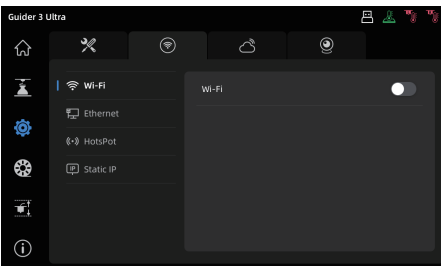
2.2 Network Connection



2.2.1 Wired Network Connection

1. Insert the network cable into the Ethernet port on the back of the printer.
2. Click the [] icon to enter the [Network] interface, select [Ethernet], and enable the Ethernet function.
3. If the [] icon appears at the top right corner of the screen, it indicates that the printer is successfully connected to the network.

2.2.2 Wireless Network Connection

Before connecting to a wireless network, the Wi-Fi function shall be enabled. Otherwise, it will result in wireless signal receiving failure.



1. Click the [] icon to enter the [Network] interface, and select [Wi-Fi].
2. Click to connect to the corresponding wireless network. If the [] icon appears at the top right corner of the screen, it indicates that the printer is successfully connected to the network.

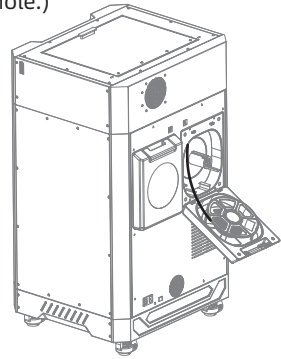
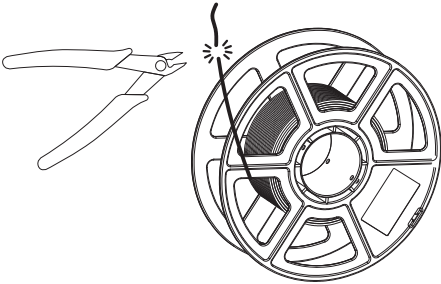
2.3 Filament Loading



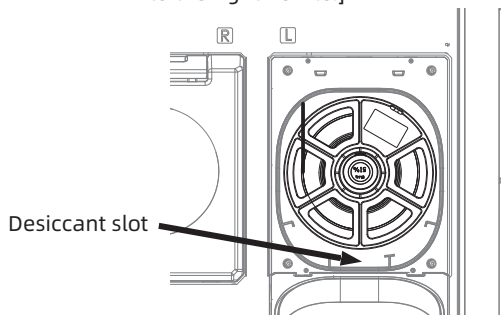
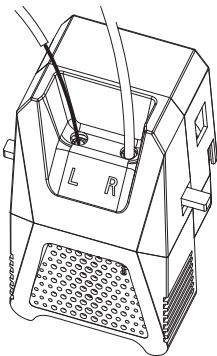
Note


When loading filament, please pay attention to the left and right corresponding labels on the extruder, filament guide tube, and filament chamber.

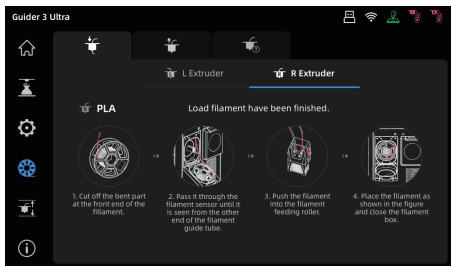
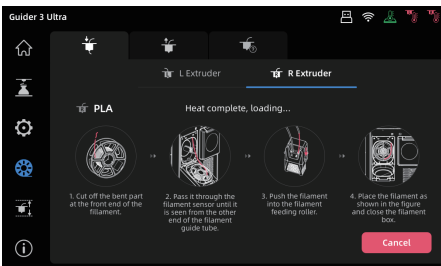
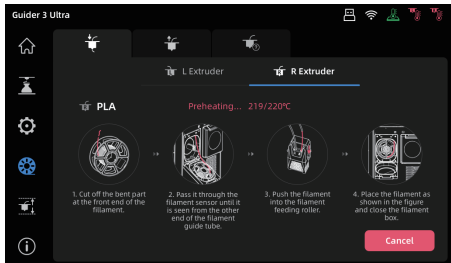
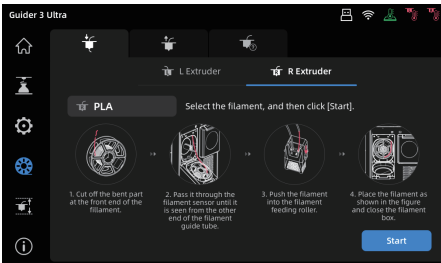
1. After unpacking the new filament, cut the bent end with diagonal pliers.
2. Open the filament chamber and manually pass the filament through the corresponding filament sensor until it is visible from the other end of the filament guide tube. (Note the label indicating the matching extruder and hole.)



3. Insert the filament extending from the guide tube into the corresponding filament inlet, and push it into the filament feeding roller until you feel some resistance; or press the filament feeding handle, push it into the feeding roller and secure it.
4. Finally, place the filament into the filament chamber, and you can put the desiccant provided with the printer into the slot. Close the cover. [Note: For smooth filament rotation, place the filament corresponding to the left nozzle in a clockwise direction and counter-clockwise for the filament corresponding to the right nozzle.]




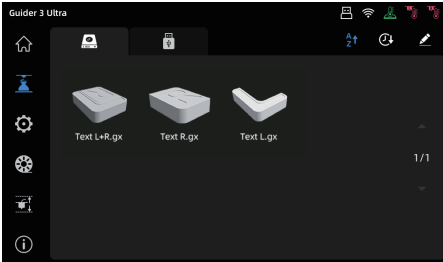
5. Click the [] icon, enter the [Filament loading] interface, select the corresponding extruder and material, and then click [Load].




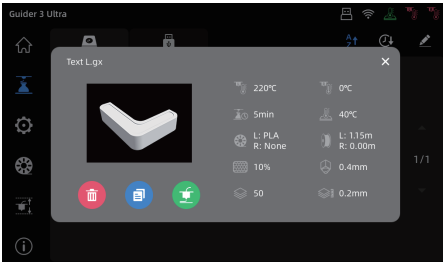
6. Successful filament extrusion from the nozzle indicates successful loading.

2.4 Test Model Printing

1. Click the [] icon on the left to enter the [Printing] interface. Inside the machine, there are three test models: Test L.gx (left-extruder printing test model), Test R.gx (right-extruder printing test model), and Test L+R.gx (dual-extruder printing test model).



2. Before printing, please ensure the nozzle corresponding to the test model is loaded with filament. Select the model file, and then click the [] icon to start printing.



Note

Please select the Test L.gx model for the printing test as the left extruder is the default extruder for loading filament during the startup guide. To print the Test R.gx (right-extruder printing test model) or Test L+R.gx (dual-extruder printing test model), first load filament for the corresponding extruder before starting the printing test. Please also perform XY offset calibration of the left and right nozzles before using dual-extruder printing for the first time, following the steps in Section 4.3 Dual-Extruder Printing Mode.

3. Introduction to User Interface

Note

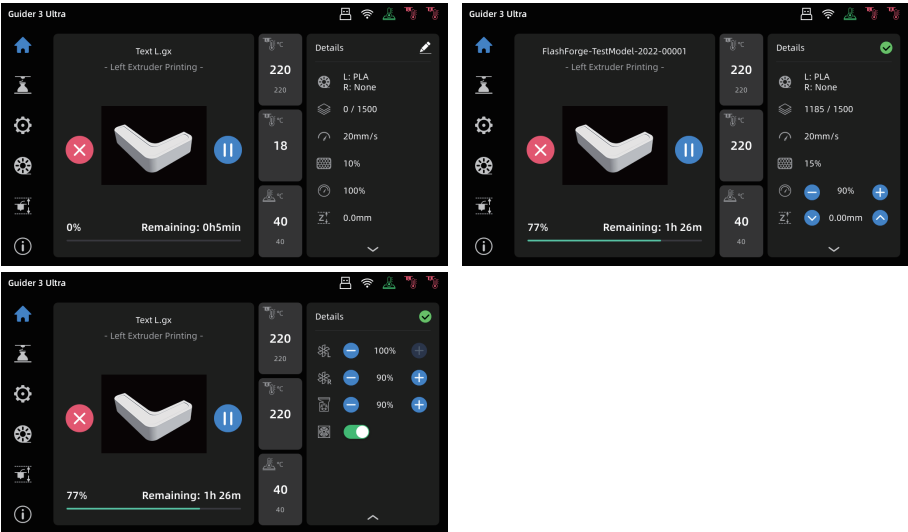
The interface layout may change whenever there is an upgrade of firmware. The following is only a brief overview of the functions.

3.1 Main Interface

Main interface when the printer is idle



Main interface during printing





Filament loading status



Number of layers



Real-time extruder moving speed



Infill percentage



Adjust the printing efficiency by percentage



Adjust the Z-axis distance between the extruder and platform



Adjust the speed of the left-nozzle model cooling fan



Adjust the speed of the right-nozzle model cooling fan




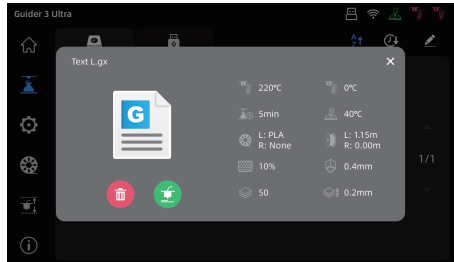
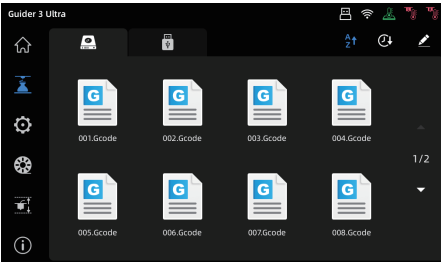
Adjust the speed of the auxiliary model cooling fan




Filter fan switch

3.2 Printing Interface

Click the [] icon on the left to enter the printing interface.



Click the model to be printed. In the pop-up box, click the [] icon to start printing.



[Local] List of local model files



[USB] List of model files on the USB flash drive



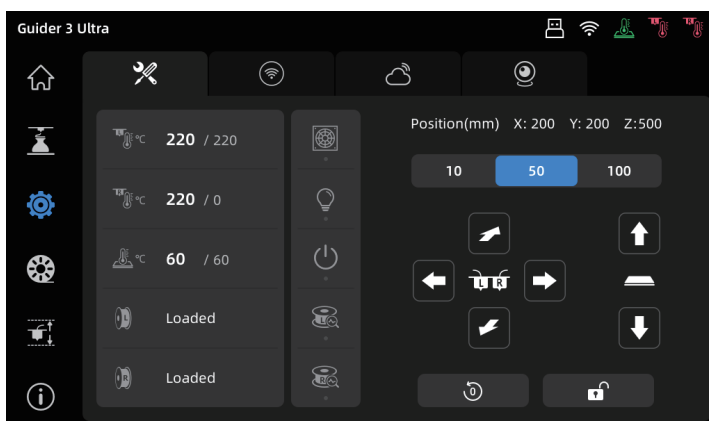
[Alphabetic order] Sort by the first letter of the file name







[Time order] Sort by the file modification time

3.3 Settings Interface












Click the [] icon on the left to enter the settings interface.




Top icons from left to right are:

-  [Move] Extruder; Platform; Chamber Preheating; Fan Settings; Manual XYZ-axis Movement; Chamber Light Switch;
-  [Network] Wireless Network, Wired Network, Hotspot;
-  [Cloud Platform] Connect to FlashCloud or Polar Cloud;
-  [Camera] Enable the camera and time-lapse video; View videos and photos.

Icons in the settings interface




- | | |
|---|--|
|  °C Left nozzle temperature setting |  Filter fan switch |
|  °C Right nozzle temperature setting |  Chamber light switch |
|  °C Platform temperature setting |  Auto shutdown switch |
|  Left-nozzle filament loading status |  Left-nozzle filament detection switch |
|  Right-nozzle filament loading status |  Right-nozzle filament detection switch |
|  Return the extruder/platform to its original position | |

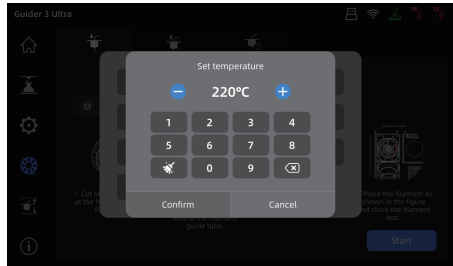
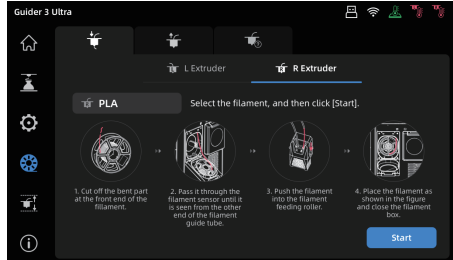
3.4 Filament Interface

Click the [] icon on the left to enter the filament interface.


During filament loading and unloading, users can choose the filament based on their needs. If the required filament is not listed in the interface, users can customize it and set the required temperature for loading. To change filament, you can follow the prompts in the nozzle cleaning interface for guidance.

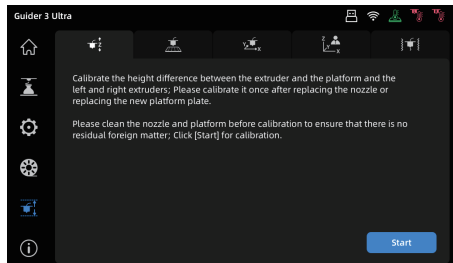
The filament interface includes:

-  Filament loading
-  Filament unloading
-  Filament changing guide








3.5 Leveling and Calibration Interface


Click the [] icon on the left to enter the leveling and calibration interface.

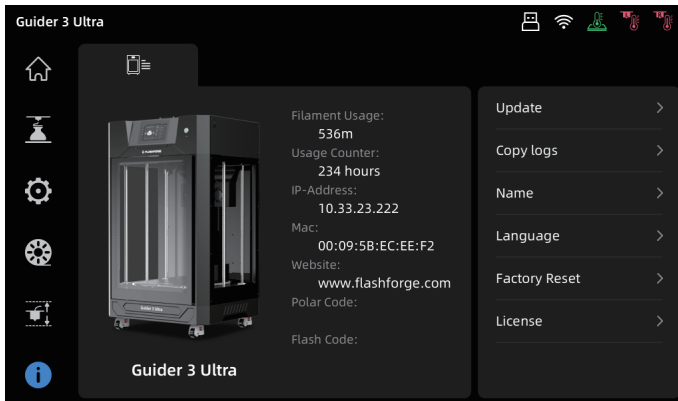


Extruder calibration and platform leveling can be carried out here. Top icons from left to right are:

-  [Auto Z-axis Calibration] Automatically calibrate the extruder's Z-axis travel and the height difference between the left and right nozzles;
-  [Auto Leveling] Automatic platform leveling;
-  [XY Offset] Calibrate the XY offset of the left and right nozzles;
-  [Expert Mode] Manually adjust the XYZ offset of the right extruder relative to the left extruder;
-  [Resonance Compensation] Conduct resonance measurements and perform automatic shaping corrections.

3.6 Information Interface

Click the [] icon on the left to enter the information interface.



- ◆ [Update] Firmware upgrade; You can upgrade the firmware to the latest version when it is connected to a wireless network.
- ◆ [Copy logs] Copy logs to a USB flash drive.
- ◆ [Name] Modify the printer name.
- ◆ [Language] Set the printer language.
- ◆ [Factory Reset] Restore all system settings to factory defaults.

4. Model Printing

4.1 Slicing Software Installation

Method 1: Find the FlashPrint software package on the USB flash drive and install the version that matches your system.

Method 2: Download the latest slicing software from the official English website at www.flashforge.com.

3D Printing Process:


Obtain the model file (in stl/obj/stp format) - Import the file into the slicing software - Slice it - Prepare the 3D printer for printing - Transfer the file to the printer for printing

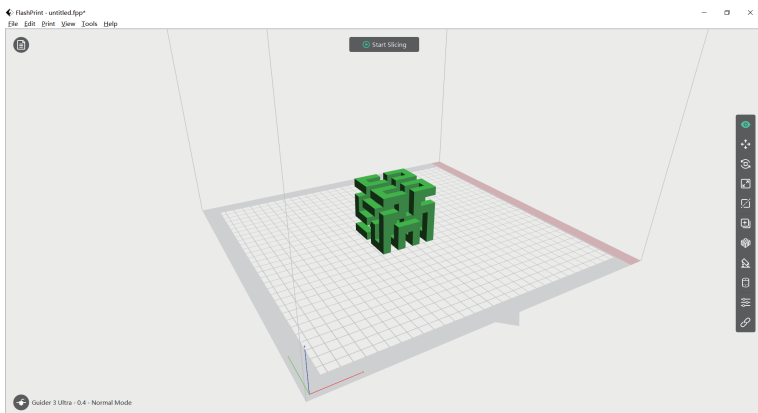
Note: You can find slicing software instructions in the software after installation.

4.2 Single-Extruder Printing Mode

Note

In the single-extruder printing mode, the left extruder is defined as the primary extruder by default. This is because the left extruder is fixed, while the right extruder is for raising and lowering. Models printed with the left extruder tend to have better performance than the right extruder. Before printing, please ensure that filament has been loaded and can be extruded properly. Refer to Section 2.3 for guidance if needed.

After opening the slicing software, select your printer type at the lower left corner. Then, import the model into the slicing software. You can make modifications to the model such as moving, rotating, or scaling it. Once the layout is set, click the [] icon, select the support type, and click [Auto Supports]. Return to the main interface, click [Start Slicing], select the corresponding printing material, and click [Slice] to generate the sliced file.

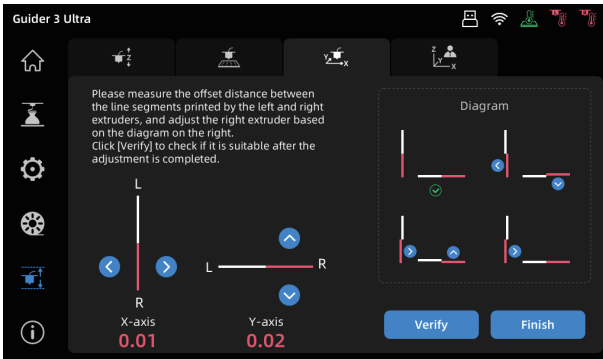


4.3 Dual-Extruder Printing Mode

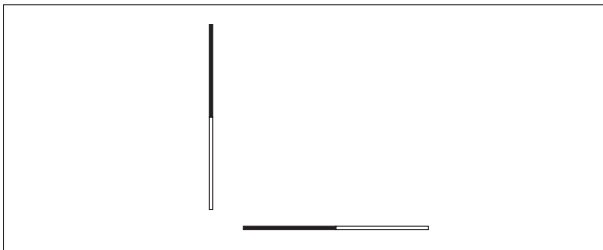
Note


For the first dual-extruder printing, please perform XY offset calibration of the left and right nozzles to align the right nozzle with the left one. Before calibrating, load filaments into both the left and right extruders and ensure they can extrude filament properly (refer to Section 2.3). During dual-extruder printing, it's recommended to use the left extruder for printing the model and the right extruder for printing the support structures, as explained in the [Note] in Section 4.2.

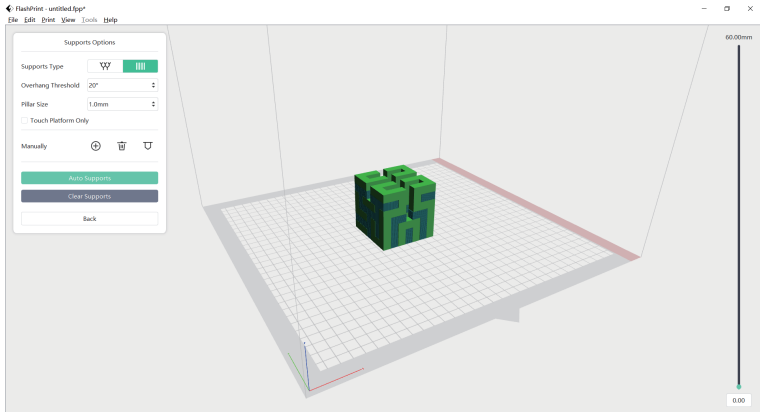
1. Enter the leveling and calibration interface and click the [XY] icon to access the [XY Offset] interface. After clicking [Start], the printer will automatically heat up, and when it reaches the target temperature, both left and right nozzles will print a test line in the XY direction.
2. After printing is completed, measure the deviation distance between the two lines in the same direction using a ruler. Compare the printed test lines with the on-screen examples. Adjust the right nozzle's XY offset following the instructions.




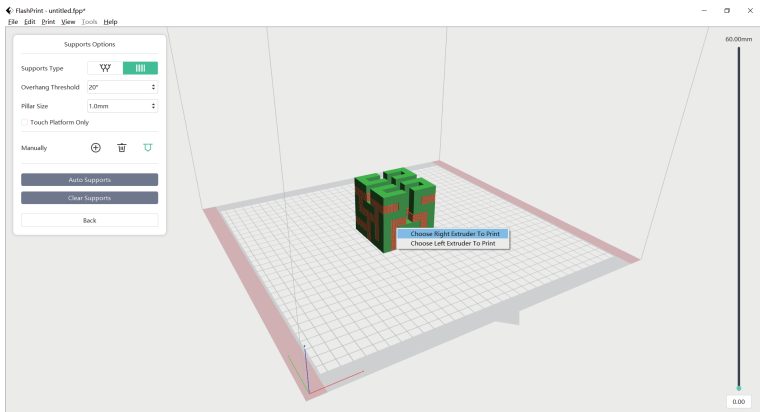
3. After adjusting is completed, click [Verify] to print the test lines again. If there is still any deviation, please repeat the above Step 2. When the actual printed lines are like the figure below, it indicates that the XY offset values of the left and right nozzles are within a reasonable range. Click [Finish] to save the data.



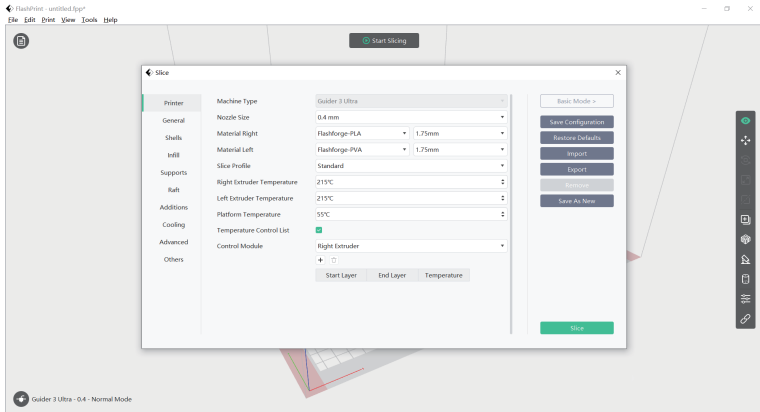
- Once the XY offset calibration is completed, you can start dual-extruder printing.
- Open FlashPrint, load the model, click the  icon, and then select the support type.
- Click [Auto Supports].



- Click the  icon, left-click the support, press "Ctrl+A" to select all supports, and then right-click to choose a specific extruder for printing supports. Once selected, click [Back].



8. Click [Start Slicing] to enter the parameter configuration page.



9. Choose the material configuration (for example, use the right extruder to print PLA model and the left extruder to print PVA supports).

10. Click [Slice] to generate the sliced file.



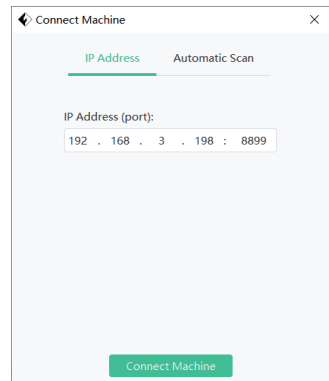
Note

When printing with dual extruders, it's recommended to add walls or a wiping tower to clear any filament oozing from the idle nozzle. For further printing configurations, you can click [Help] and select [Help Contents] to learn more.

4.4 File Transfer via Network

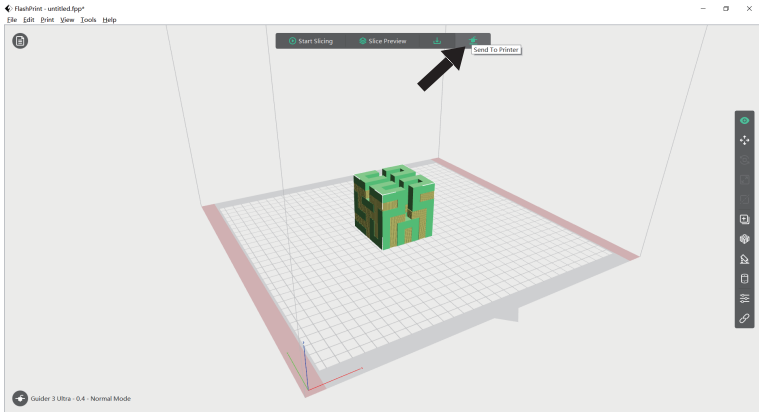
1. After connecting to the network, open FlashPrint. Click the icon at the lower left corner, select [Machine Type], select [Guider 3 Ultra], and then click [Print] - [Connect Machine].

2. In the pop-up box, select the connection method: enter the printer's IP address or use automatic scanning. The IP address can be viewed in the information interface of the printer. Once entered, click [Connect Machine]. If the connection is successful, the [Multi-Machine Control] interface will pop up, allowing you to check the printer's connection status.



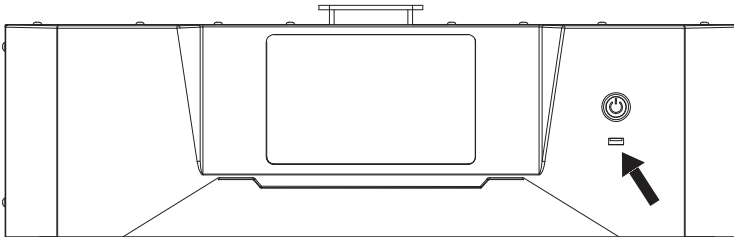
3. After slicing is completed, click [Send To Printer]. The printer will begin preheating, and then automatically start printing after it is ready.

Note: The printer and the computer must be connected to the same network. Otherwise, connection will fail.



4.5 File Transfer via USB

1. The printer supports printing via USB. Save the sliced file (*.g/*.gx/*.gcode format) to a USB flash drive.
2. Insert the USB flash drive into the printer's USB port.

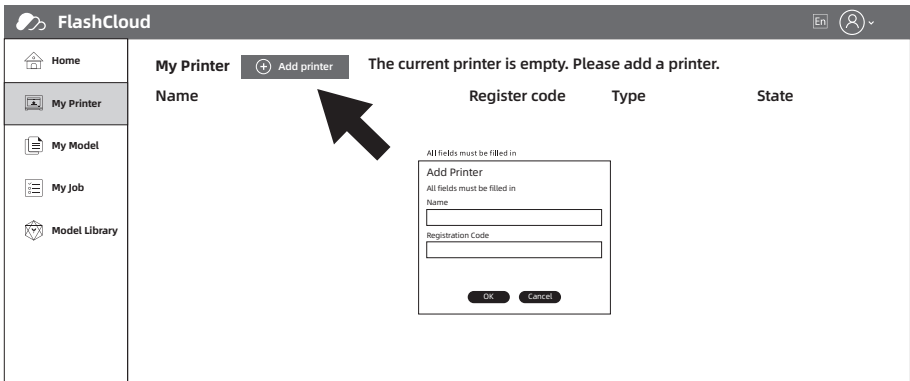


3. Access the [Printing] interface, click the [USB] icon to enter the USB drive file interface, and select the corresponding file for printing.

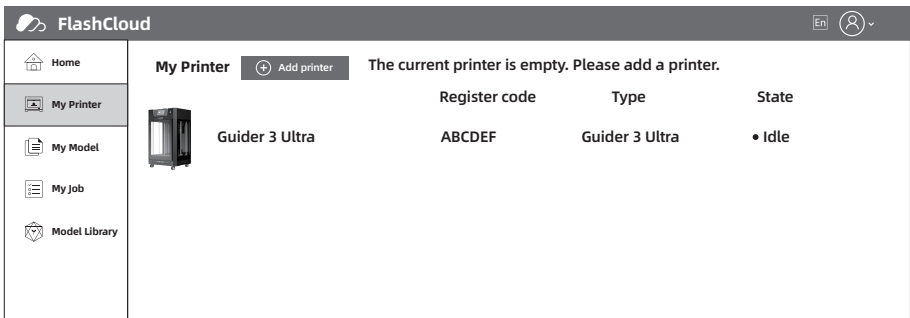
4.6 Cloud Printing

Printing via FlashCloud

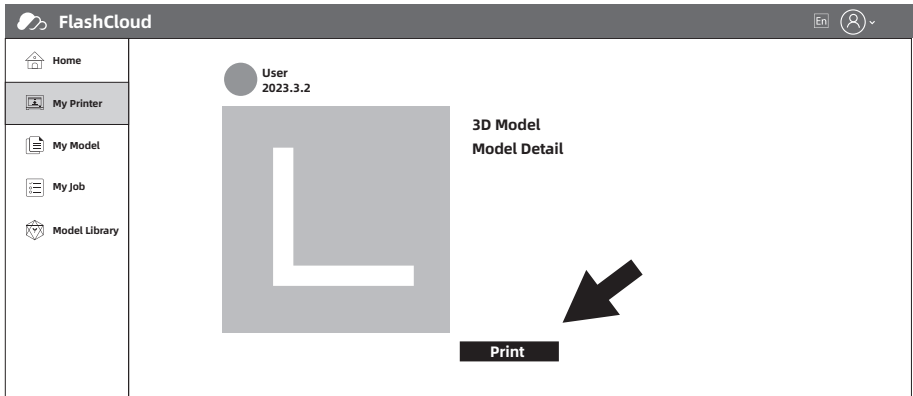
1. Open the FlashCloud website and register an account. After email activation, you can log in and use. FlashCloud: <https://cloud.sz3dp.com>



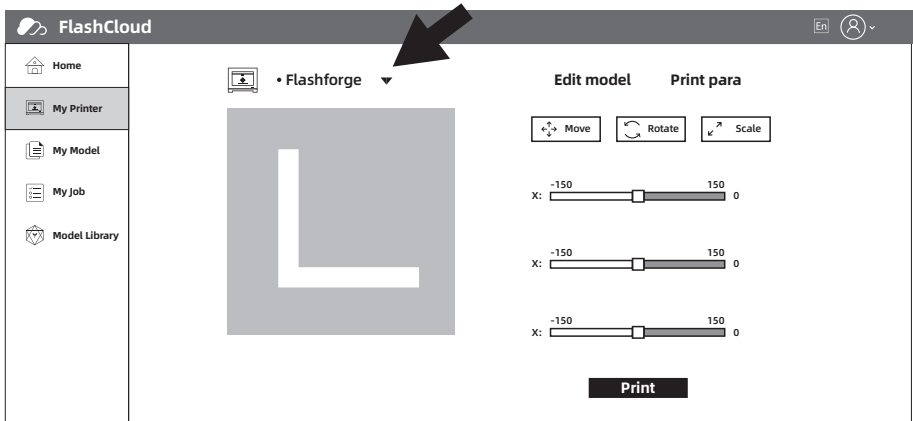
2. Click [My Printer] - [Add Printer].
On the Add Printer page, enter the registration code (cloud registration code) and name the printer. After clicking [OK], the information will appear on the printer's FlashCloud interface.



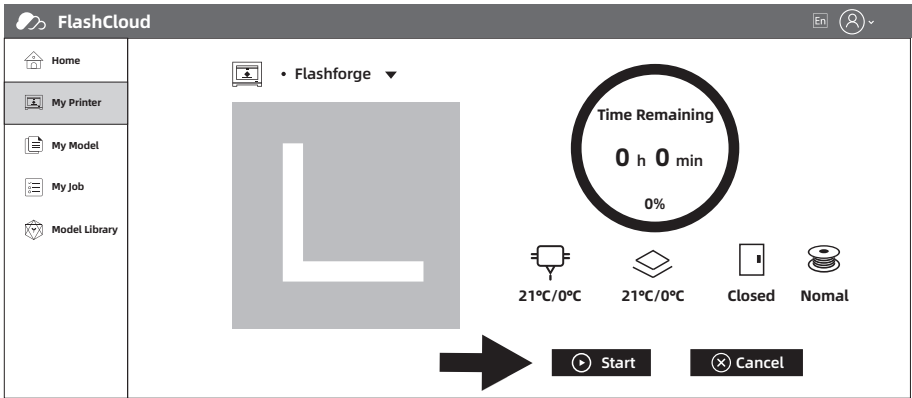
3. Select a model from the Model Library or upload your own model (STL file), and then click [Print] to access the model editing interface.



4. The drop-down menu for the printer name allows you to select the printer for performing this print job. (The printer must be added to My Printer).

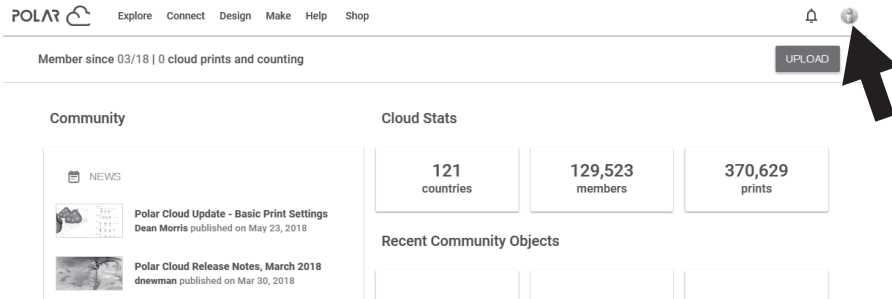


5. Finally, click [Start], and the selected printer will automatically start the print job.



Printing via Polar Cloud

1. Open the Polar Cloud website and register an account.
Polar Cloud: <https://polar3d.com>



2. After logging in, click the icon at the top right corner, click [Settings], and find the PIN Code in the page.

Location

Biography

Website URL
<http://www.example.com/profile>

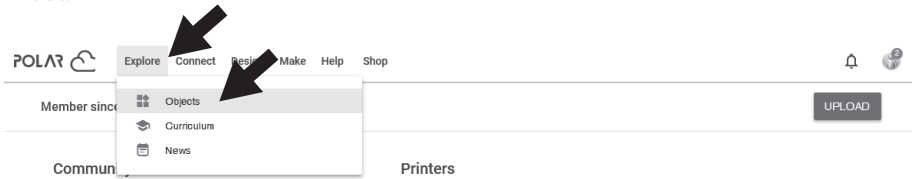
Email

+ADD Email

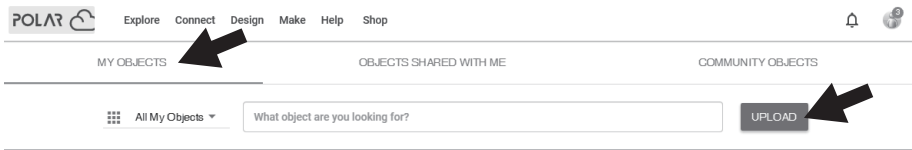
PIN Code

XXXX

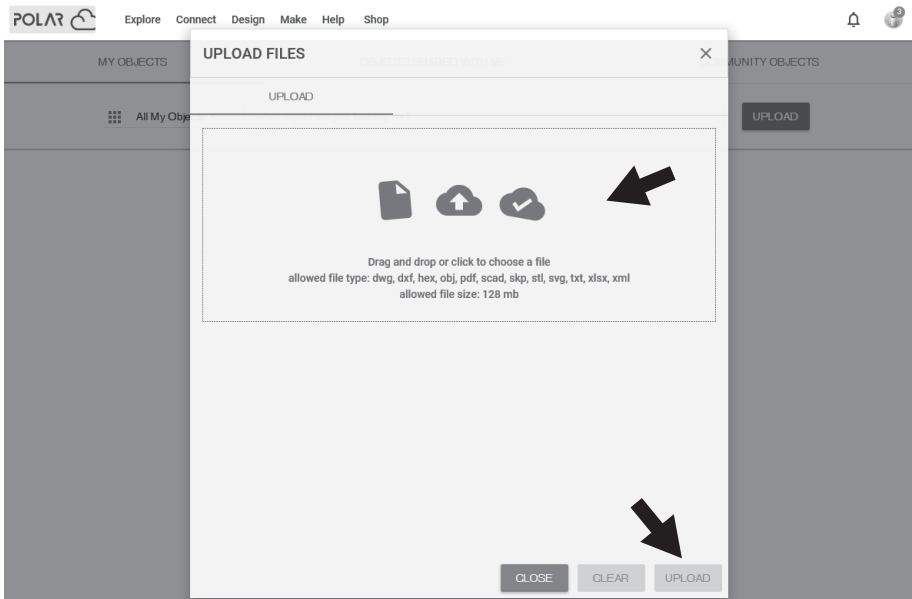
3. After connecting Guider 3 Ultra to the network, enter the cloud platform interface (click the Settings icon -> Cloud Platform icon). Turn on the Polar Cloud switch (it should display green). Enter the account and PIN code, and then click [Save].
4. Once the connection is completed, you can view the printer's information on the home page of Polar Cloud.
5. Click [Explore] in the top menu bar, and then select [Objects] from the drop-down list.



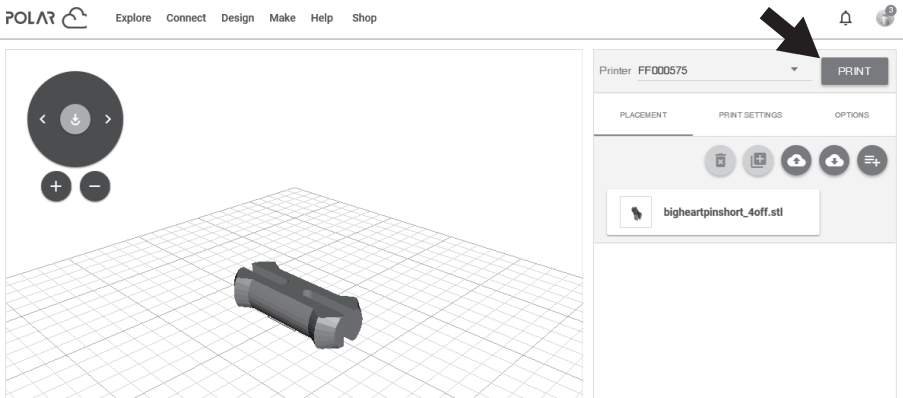
6. Click [MY OBJECTS], and then click [UPLOAD] to upload a model.



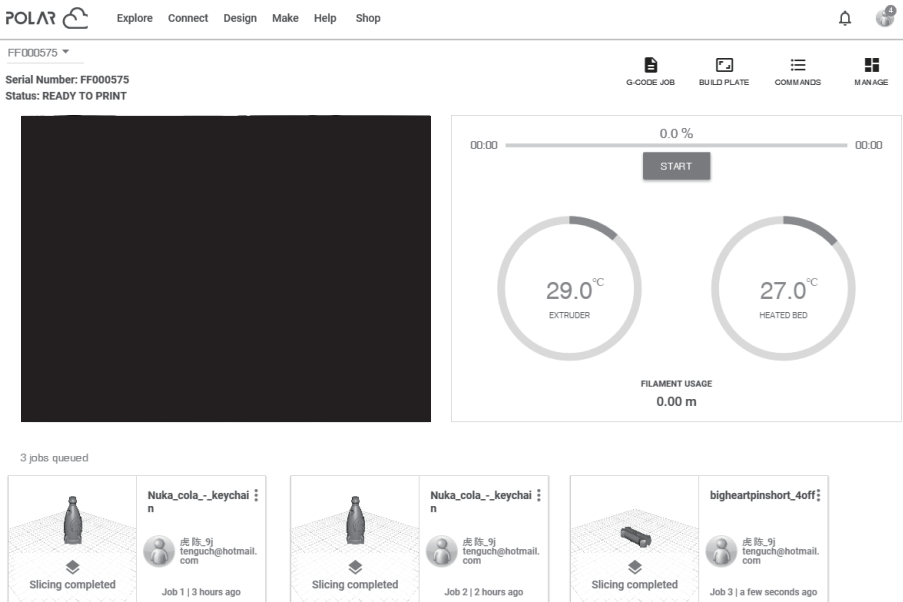
7. Drag and drop the model file to be uploaded into the box area or click the box area to select a model for upload. Then, click [UPLOAD].



8. Click [PRINT].

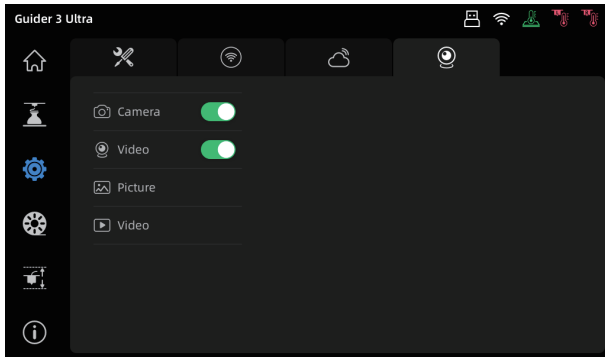


9. Click [START], and the printer will begin downloading the cloud task and start printing once the download is completed.



4.7 Camera Connection

1. Turn on the camera switch. Click the [⚙️] icon, access the [Camera] interface, and enable both [Camera] and [Video] functions.

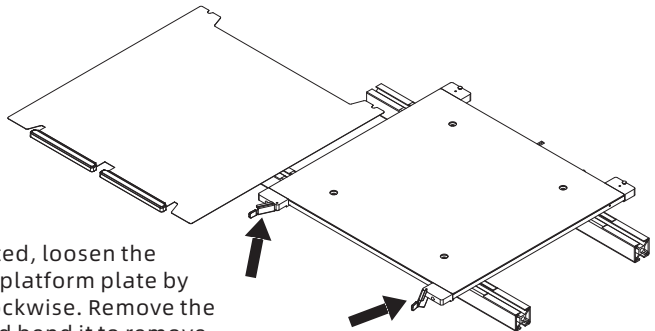


2. When the printer is connected to FlashPrint, you can watch real-time videos via FlashPrint's [Multi-Machine Control]. The camera function is also available in FlashCloud and Polar Cloud.

4.8 Model Removal After Printing

Warning

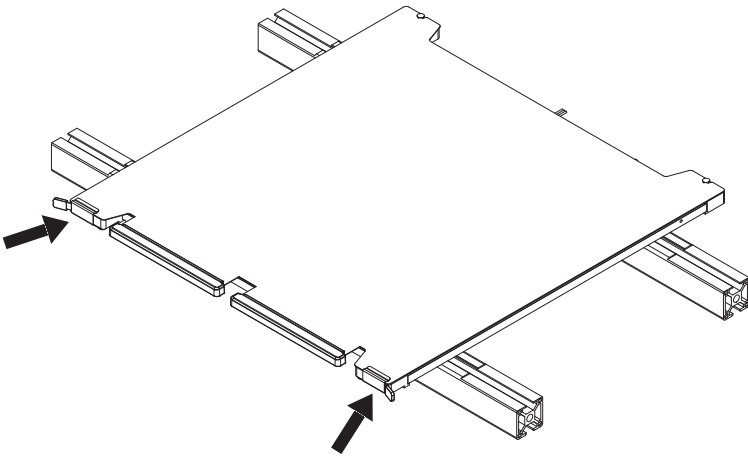
When removing a model from the build plate, please wait for it to cool down. Check the temperature icon on the top status bar of the screen: a green icon indicates the platform is below 50°C, safe for operating this. Consider using gloves when removing the model and be cautious of the high temperature.



After printing is completed, loosen the two front latches on the platform plate by turning them counterclockwise. Remove the entire platform plate and bend it to remove the model.

To install the platform plate back, follow these steps:

1. Put the rear end of the flexible steel plate against the positioning blocks on the left and right edges of the platform; Make sure to insert it into the inside of the slots.
2. Close the latches until the flexible steel plate is securely fixed.



5. Maintenance

Note

The interface layout may change whenever there is an upgrade of firmware. The following is only a brief overview of the functions.

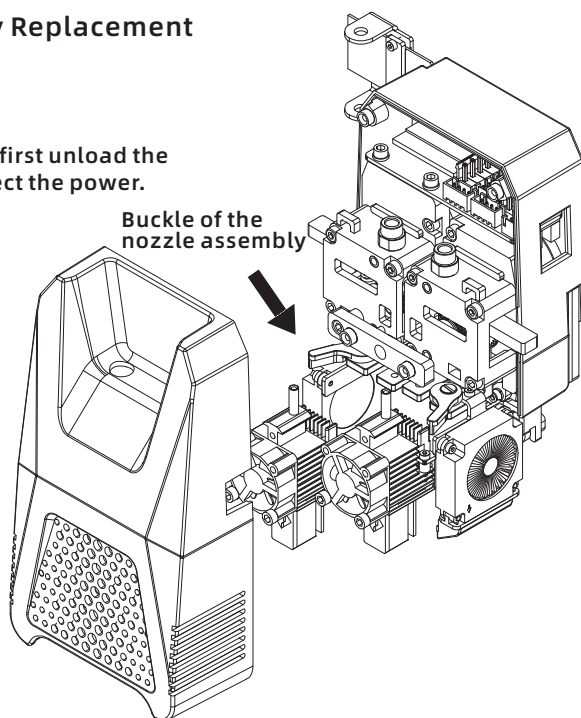
5.1 Extruder Maintenance

5.1.1 Nozzle Assembly Replacement

Note

Before operating it, please first unload the filament and then disconnect the power.

1. Open the front cover of the extruder.
2. Toggle the buckle of the nozzle assembly and remove the nozzle assembly.
3. Install the new nozzle assembly and secure it by fastening the buckle of the nozzle assembly.



5.1.2 Clogged Nozzle Cleaning

Method 1: Preheat the nozzle to the temperature of the used filament, remove the filament guide tube, press the handle, pull out the filament, and insert the unclogging pin tool into the nozzle to extruder filament inside.

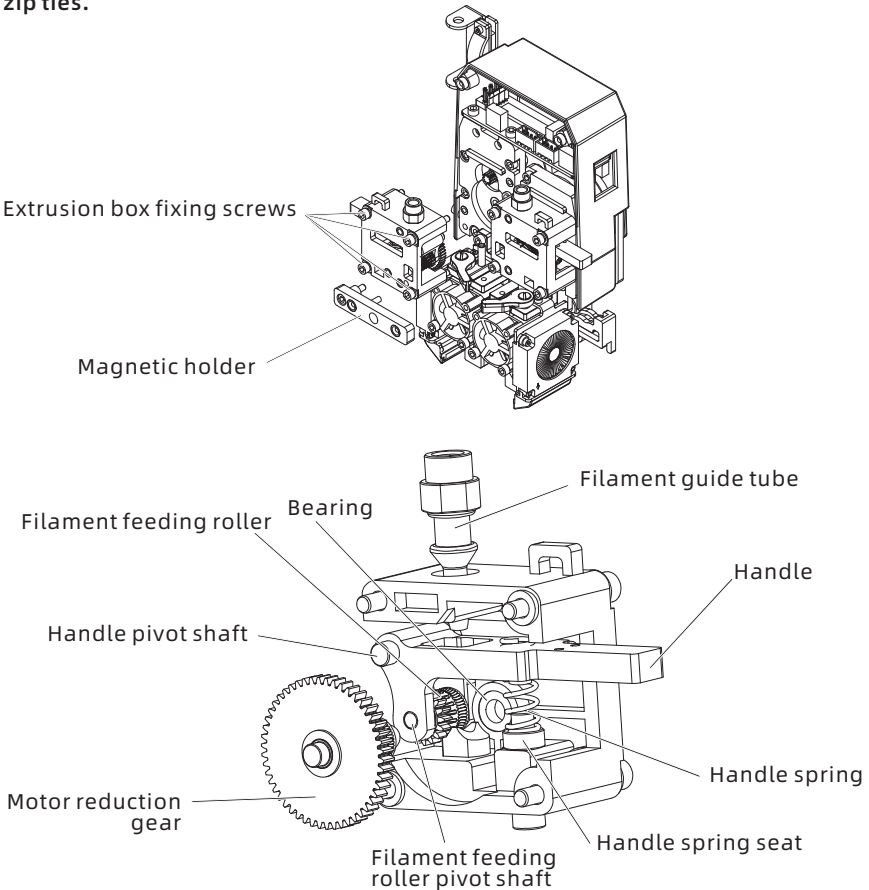
Method 2: If Method 1 doesn't work, refer to the nozzle assembly replacement method to replace the nozzle assembly.

Note

If filament is stuck and cannot be removed from the extrusion box, you can disassemble the extrusion box and remove the filament.

Here are the steps:

Cut the zip ties on the extrusion box. Remove the two screws on the magnetic holder and the four screws that fix the extrusion box. Pull the extrusion box out (if necessary, remove the hot end as well by unscrewing the handle). Once the stuck filament inside the extrusion box is removed, reinstall the extrusion box (see the diagram below for extrusion box components). When installing the extrusion box, you can first remove the nozzle assembly, align the bearing with the extrusion box base, press the handle to insert the handle pivot shaft into the corresponding hole, and finally tighten the extrusion box fixing screws. Reinstall the magnetic holder, tighten the screws, and secure the wiring harness with new zip ties.



5.2 Platform Flatness Calibration

Users typically do not need to perform this operation. When various calibrations or automatic leveling compensation are ineffective, it may be that the previously installed platform flatness has been destroyed. In this case, initial platform leveling is required.

Note

You can contact Flashforge's customer support for remote calibration assistance.

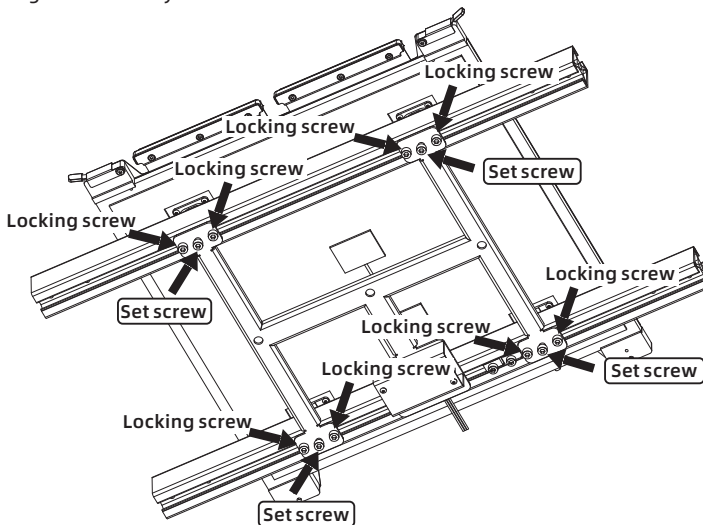
Please operate as follows: There are four leveling points in total.



Note

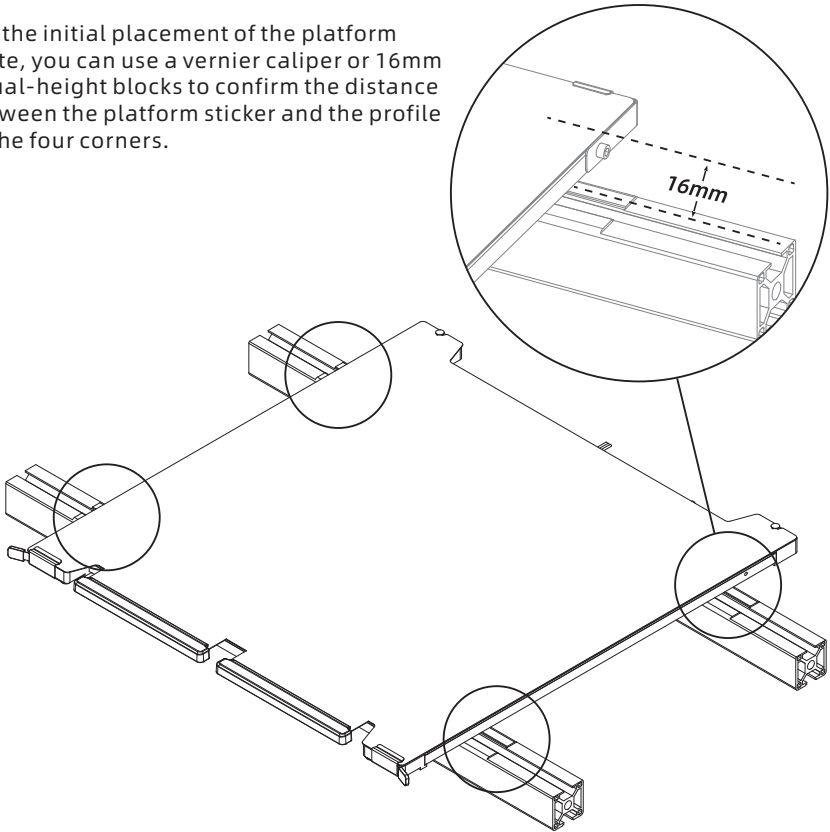
Please proceed with caution or consult a professional engineer for guidance.

1. Adjust the platform height for the appropriate viewing position.
2. Ensure that the strain gauge wires at the bottom of the platform are not pressed too tight.
3. Tighten the M5 screws next to the four set screws (during tightening, make sure to tighten both sides simultaneously; do not tighten one side completely before tightening the other).
4. Ensure that the distance between the flexible steel plate sticker surface and the profile surface is 16mm (by manually turning the four set screws at the bottom), ensuring consistency at all four corners.



After placing the platform plate and setting the 16mm distance, adjust the platform flatness by turning the four screws in the middle. Once the flatness is adjusted, lock it in place by tightening the locking screws next to the middle set screws. While tightening the locking screws, make sure to turn both sides simultaneously and avoid tightening one side before the other.

For the initial placement of the platform plate, you can use a vernier caliper or 16mm equal-height blocks to confirm the distance between the platform sticker and the profile at the four corners.



6. Q&A

Q1: Is calibration required after nozzle replacement?

Yes.

//

Q2: What to do if the extruder moves but doesn't extrude filament at the beginning of printing after clicking the model for printing?

1. Observe the filament guide tube to check if filament has entered the nozzle. If not, please click [Load] until filament comes out.
 2. Check if the nozzle is clogged. If so, please refer to Section 5.1.2 for the solution.
- //

Q3: What to do if the nozzle position is too high (far from the platform) or too low (hitting the platform) during printing? How to level it?

Please refer to Section 2.1 Equipment Calibration for the solution.

//

Q4: Can filaments from other brands be used?

Yes. You can use filaments from other brands, but certain parameter adjustments are required due to slight temperature differences in different filaments.

//

Q5: Can the printer shut down automatically after printing is completed?

Yes. This function can be enabled in the [Settings] interface.

//

Q6: Is it safe to print with ABS material?

ABS can release toxic gases during heating. It is recommended to use the HEPA air filter during or after printing. If conditions permit, consider printing in a well-ventilated area. It is recommended to print non-toxic materials such as PLA in children's activity places.

//

Q7: What to do if the printed model warps or doesn't adhere well?

Method 1: Increasing the platform temperature can improve the adhesion between the platform and the model.

Method 2: Adding a raft during model slicing can alleviate the issue.

Method 3: Apply glue.

Method 4: If the distance between the nozzle and platform is too large, reduce it accordingly using the extruder calibration in the expert mode or the leveling and calibration function.

Method 5: Check if the platform is level. The leveling and calibration function can be used. It is recommended to complete the full auto-leveling process.

Q8: Is it necessary to add a raft when printing models?

Not necessarily. Adding a raft results in more filament extrusion and higher print success rate. With a heated build plate, it enhances the adhesion between the model and the platform, which makes the model adhere to the platform well during printing, and also increases the print success rate.



Q9: What to do if print files can not be found and the screen displays only folders after inserting the USB flash drive?

The USB flash drive format is incorrect. The printer supports the FAT32 file system. Please format the USB flash drive to FAT32.



Q10: What to do with the Wi-Fi connection failure?

1. Please check if the Wi-Fi name contains special characters. If so, modify it and try again.
2. Please check if the password contains special characters. If so, modify it and try again.



Q11: Firmware update precaution.

Do not power off the printer or disconnect from the network during firmware download or update to prevent update failures.



Q12: Why is the boot screen white?

If the startup sound can be heard, please replace the screen or cable. If not, please contact our after-sales personnel.



Q13: Is the battery used for the hygrometer in the filament chamber supplied? What is the battery model?

The battery needs to be purchased by yourself.
 Model: LR44, 1.5V
 Size: 11.6*5.1 mm
 Compatible model: AG13/A76/L1154

7. Help and Support

Flashforge's professional after-sales service personnel and salesmen are on standby for you at any time and are ready to help you with any problem you may have with the printer. If the issues or questions are not covered in this User Guide, you can seek for solutions on our official website or contact us by phone.

There are instructions and solutions to common issues that can be found on our official website. Many questions are answered at Flashforge's English official website - www.flashforge.com.

Flashforge's after-sales service team can be reached by phone from 8:00 AM to 5:00 PM, from Monday to Saturday. In case you contact us during off-duty time, your inquiry will be answered the next working day immediately. We apologize for any inconvenience this may cause.

////////////////////////////////////

Note

Changing different filaments may leave minor impurities in the nozzle, leading to clogs. As this can be solved by just unclogging it, it's not owing to a quality issue. If you encounter this problem during use, please contact customer support and follow their guidance for unclogging.

////////////////////////////////////

After-sales Service Tel: 400-886-6023

E-mail: support@flashforge.com

Address: No. 518 Xianyuan Road, Wucheng District, Jinhua City, Zhejiang Province, China

Note

Please provide the product serial number which can be found on the barcode at the back of the printer when contacting customer support.



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注意事项

安全提示：请确保认真阅读以下安全提示

工作环境安全

- ◆ 请保证打印机的工作台面干净整洁。
- ◆ 请保证打印机工作时远离可燃性气体、液体及灰尘。设备运行产生的高温有可能会与空气中的粉尘、液体、可燃性气体反应引发火灾。
- ◆ 儿童及未经培训的人员请勿单独操作设备。

用电操作安全

- ◆ 请务必将设备接地；切勿改装设备的插头。未接地 / 未正确接地 / 改装插头必然会增加漏电风险。
- ◆ 请勿将设备暴露在潮湿或烈日的环境中。潮湿的环境会增加漏电的风险 / 暴晒会加速塑件老化。
- ◆ 请勿滥用电源线，务必使用闪铸科技提供的电源线。
- ◆ 切勿在雷雨天气使用设备。
- ◆ 如长时间不使用设备，请关闭设备并拔下电源线插头。

个人操作安全

- ◆ 在设备运行时，请勿触碰喷头、平台等位置！
- ◆ 请勿触碰喷头与平台，以免高温烫伤或机械损伤！
- ◆ 在操作设备时，请勿穿戴围巾、口罩、手套、珠宝装饰等容易卷入设备的物件！
- ◆ 请勿在饮酒、服药之后操作设备！

设备使用提示

- ◆ 保持设备内部整洁，切勿将金属物体掉入打印平台底部的滑槽内！
- ◆ 请及时清理丝料碎屑，建议在设备外进行操作！
- ◆ 自行对设备进行任何改装将不再享有保修权利！
- ◆ 请在设备进丝操作时，喷头和平台的距离至少保持50mm的距离。距离过近，有可能会造成喷头堵塞。
- ◆ 请在通风的环境下操作设备！
- ◆ 请勿利用该设备进行违法犯罪的活动！
- ◆ 请勿利用该设备制作食物储存类产品！
- ◆ 请勿将打印模型放入口腔！

设备运行环境要求

- ◆ 室内温度在15-30度为宜；湿度在20%-70%为宜

设备放置要求

- ◆ 设备需要被放置于干燥通风的环境中。设备前后左右四周必须预留至少60cm的空间距离。存储温度在0-40℃为宜。

设备兼容耗材要求

- ◆ 在使用该设备时，建议使用闪铸科技的耗材。如使用非闪铸科技的耗材，材料特性有一定差异，打印参数可能需要调整。

耗材存储要求

- ◆ 耗材拆封后请保持耗材的储存环境干燥及无尘，建议使用配套干燥盒存储。

法律申明

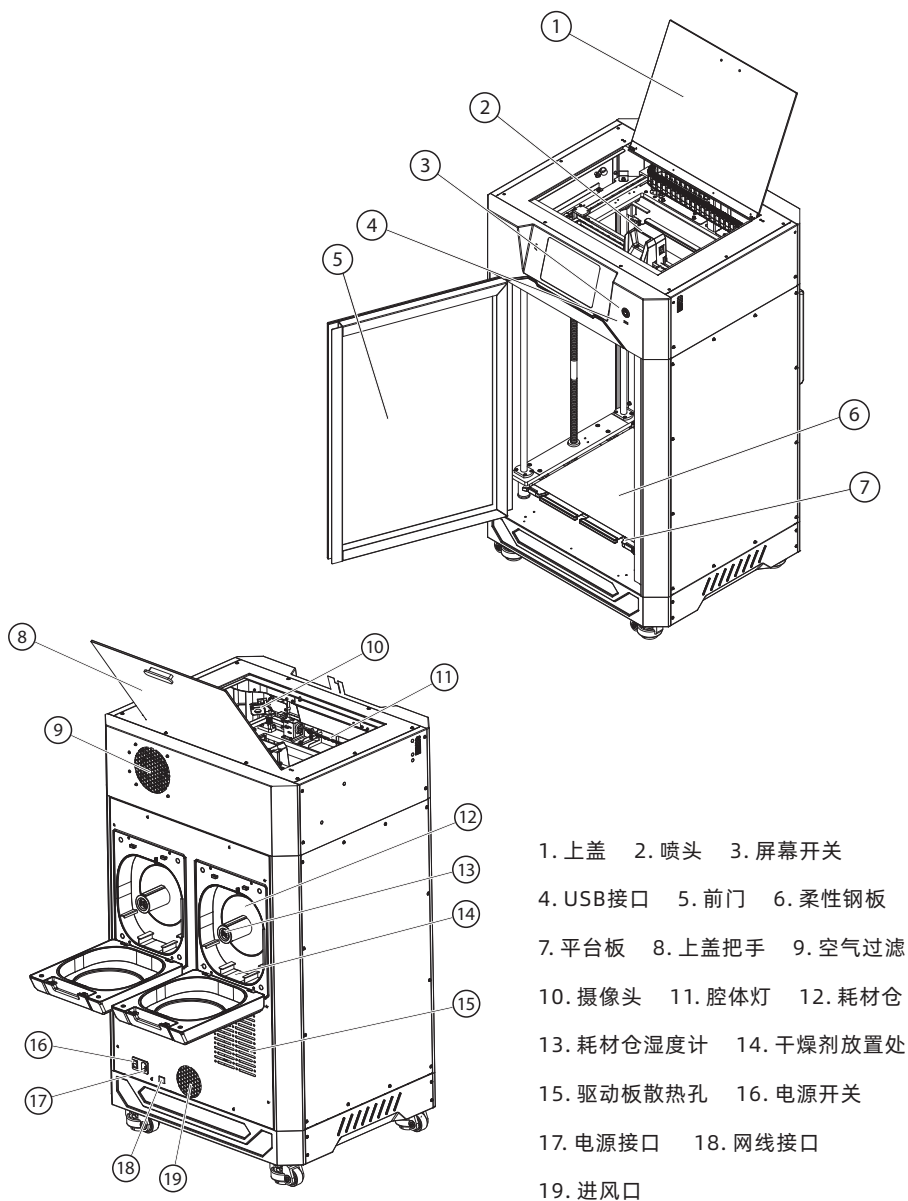
- ◆ 用户无权对此使用手册进行任何修改。
- ◆ 客户若自行拆装或改造设备造成任何安全事故，闪铸科技概不负责。未经闪铸科技允许，任何人不得对该手册进行修改或翻译。本手册受版权保护，闪铸科技对本手册保留最终解释权。
- ◆ 第一版（2023年4月）
@Copyright 2022 浙江闪铸三维科技有限公司版权所有

设备参数

设备名称	引领者 3 Ultra
喷头数量	2
打印精度	± 0.15mm 或 0.002 mm/mm [以较大值为准]
定位精度	X/Y轴: 0.011mm Z轴: 0.0025mm
层厚度	0.05 ~ 0.4mm
打印尺寸	单喷头 330x330x600mm; 双喷头 300x330x600mm
喷嘴口径	默认0.4mm [可选0.6/0.8mm]
喷嘴类型	高强喷嘴
打印速度	10 ~ 500mm/s
最高喷头温度	350°C
平台最高温度	120°C
支持耗材类型	PLA/PETG/ASA/ABS/PC/PA/PLA-CF PETG-CF/PETG-GF/PA-CF/PA-GF
电 源	AC100-240V, 50-60Hz, 850W Max
切片软件	FlashPrint 5
输入/输出文件类型	输入: 3MF/STL/OBJ/FPP/BMP/PNG JPG/JPEG 文件; 输出: GX/G 文件/ gcode
打印连接方式	U盘/以太网/Wi-Fi
工作温度	15 ~ 30°C
兼容的操作系统	Win7/8/10/11, Linux 支持 Ubuntu 20.04 及以上版本, Mac os 支持 10.9 及以上版本
兼容的切片软件	Slic3r, Cura [需设置]
智能触控液晶屏	7 英寸
打印平台	柔性钢板平台
设备净重	70kg
设备尺寸	635x550x1070mm [长宽高]
装机空间要求	≥1330*1330*1352mm

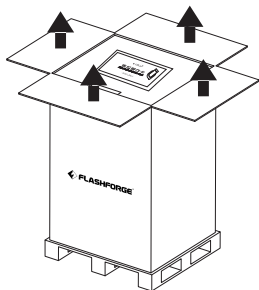
第一章：设备简介

1.1 整机介绍

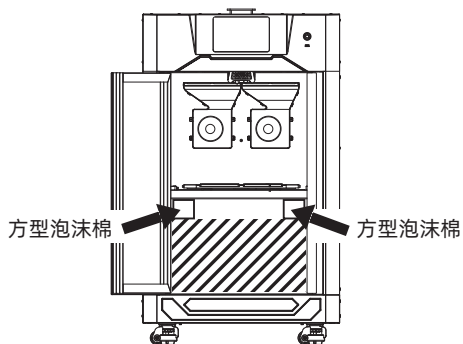


1.2 机器开箱

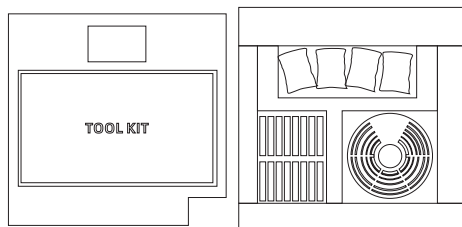
1. 拆开顶部纸盖后，取出机器顶部泡沫，内有电源线、用户手册、U盘和售后服务卡。再
从下往上将整个外箱取出，然后将机器搬离
木制底座。



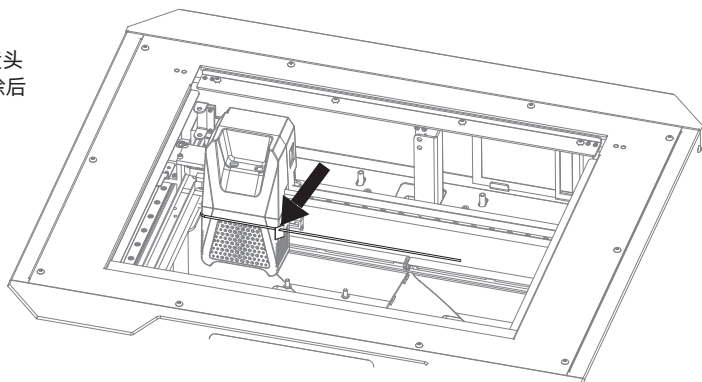
2. 打开设备前门，首先取出（拉出即可）平台
下方最上面的两根方型泡沫棉。



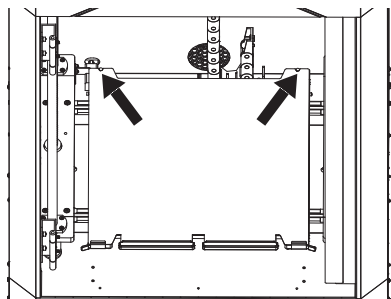
3. 随后取出平台下方的其余泡沫棉，共2层，
上层为工具配件包；下层为附赠耗材、高
温手套、干燥剂。（详细参考装箱清单）。



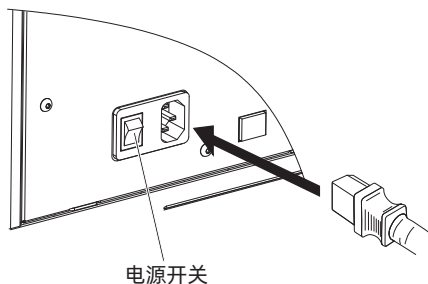
4. 使用斜口钳减去固定喷头
和导轨上的扎带。移除后
能正常移动喷头即可。



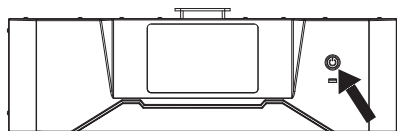
5. 检查机器平台柔性钢板是否安装到位，是否已安装在后方限位内。确保平台安装平整，没有压到任何异物。



6. 将电源线连接插座与设备，轻触电源开关按钮，启动机器。




7. 按下屏幕开关，按钮灯长亮表示已开启触控屏。



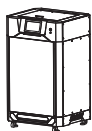
8. 首次开机将进入开机引导界面，按引导提示操作可使打印机快速调整至打印就绪状态。



提示

设备首次开机可按开机引导进行一次设备打印测试确认，用于确认设备能正常运行。
开进引导步骤如下：确认机器语言 - 校准和调平设备 - 装载丝料 - 设备准备就绪 - 测试文件打印 - 打印完成；若跳过了该开机引导中的步骤，仍可以在屏幕中选择对应的功能项进行操作。
备注：需再次进入开机引导可以点击触控屏左侧的  图标进入[信息]界面，点击[恢复出厂设置]，选择[是]，重启设备后即可重新进入开机引导界面。

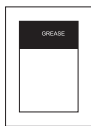
1.3 装箱清单



3D打印机



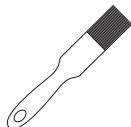
电源线



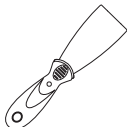
润滑脂 x 2



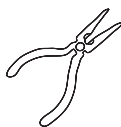
水洗胶



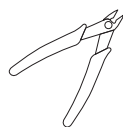
毛刷



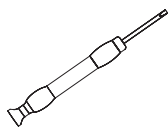
铲刀



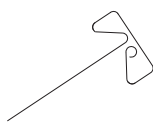
尖嘴钳



斜口钳



一字螺丝刀



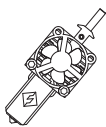
通针



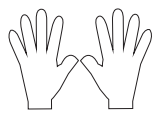
内六角扳手套装



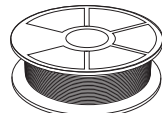
弯头镊子



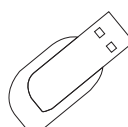
喷嘴组件 x 2



隔热手套



3D打印耗材



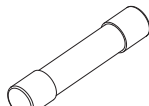
U盘



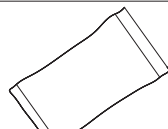
售后服务卡



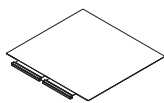
快速启动指南



保险丝 x 2



干燥剂 x 12



柔性钢板平台

第二章：基础操作介绍

2.1 校准设备

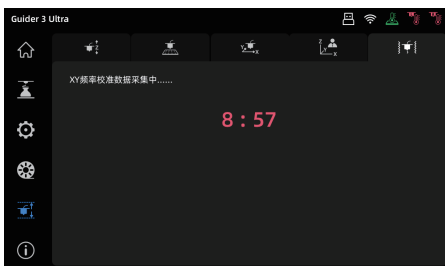
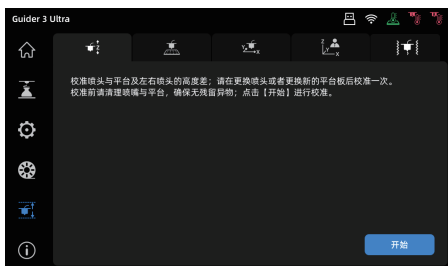
首次开机进入开机引导，将会引导操作进行自动Z轴校准和平台调平，请根据界面指示操作。平时打印无需再执行校准和调平操作。如果您更换了喷头或者平台板后建议做一次Z轴校准和平台调平。

注意事项

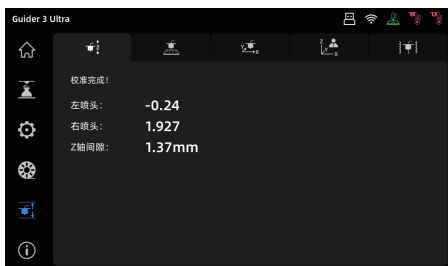
校准和调平前请先清理喷嘴和平台板，确保无残留丝料或异物。设备进行校准调平时请不要移动或碰撞机器。

按如下顺序进行操作：

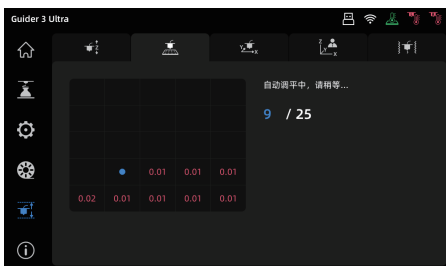
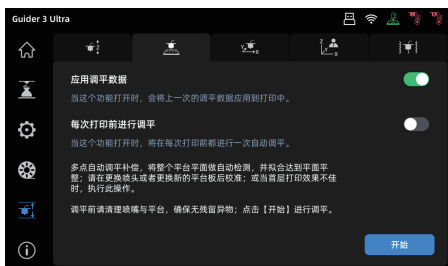
1. 进入校准界面后，在触控屏上点击图标 进入“自动Z轴校准”，点击[开始]，打印机会自动校准喷头与平台的Z轴间距以及左右喷嘴的高度差。



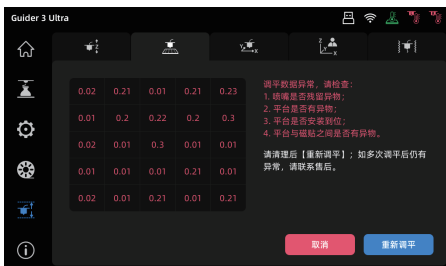
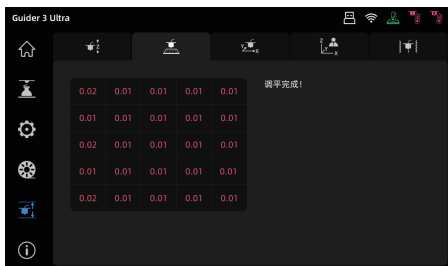
2. 自动校准完成后设备会自动保存校准数据，如果数据有异常设备会提示您重新检查设备，确认后点击按钮[重新校准]设备会再次进行自动Z轴校准。



3. Z轴校准完毕后，点击图标 进入“调平”界面，调平前可以选择使用同一个调平数据应用到每次打印的过程中，或者每次打印模型前都进行一次自动调平。确认后点击[调平]按钮，进入调平准备界面，确认好平台板已安装到位并且喷嘴和平台板都清理干净后点击[开始]，设备会自动进行平台调平。



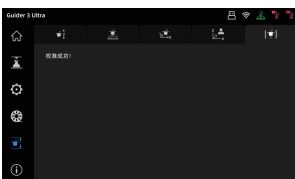
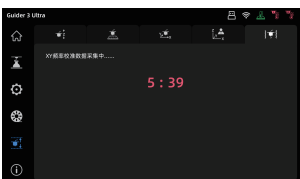
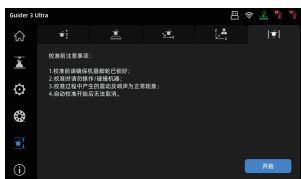
4. 调平结束后如数值无异常，设备会自动保存此次调平数据，如有异常可以按界面的提示信息重新检查设备，确认后点击[重新调平]，设备会再次进行调平工作。



提示



设备在打印过程中无法进入校准界面和进丝界面。

5. 喷头共振补偿功能在设备出厂前已经做过校准，一般情况下无需再次进行操作。当您发现模型打印完成后表面有振纹的情况下可进行一次操作，操作前请先阅读共振补偿界面的提示，以保证校准可以正常完成。点击[开始]按钮后，设备会自动进行校准，校准过程中产生震动及轻微响声为正常现象。



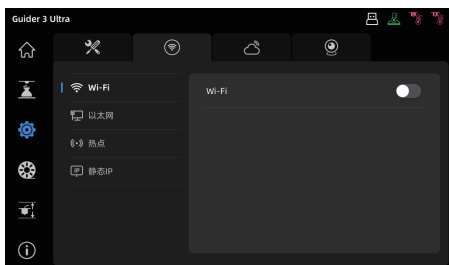
2.2 网络连接



2.2.1 有线网络连接

1. 将网线插入设备背部的网线接口。
2. 在屏幕上点击图标  [设置] - 进入[网络]界面，选择以太网，开启以太网功能。
3. 若屏幕右上角出现  图标，则表明设备已经成功连接网络。

2.2.2 无线网络连接

连接无线网络前，需要开启Wi-Fi功能，否则将无法收到无线信号。

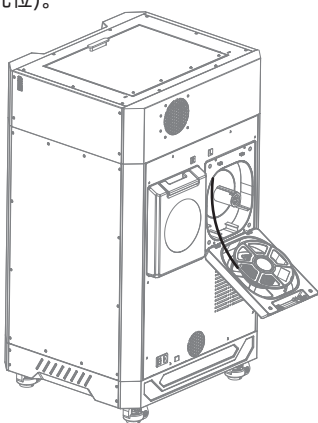
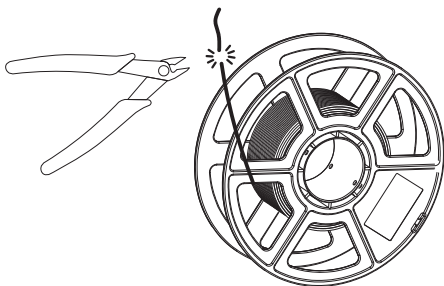


1. 在屏幕上点击图标  [设置] - 进入[网络]界面，选择无线网络。
2. 点击连接对应无线网络，若屏幕右上角出现  图标，则表明设备已经成功连接网络。

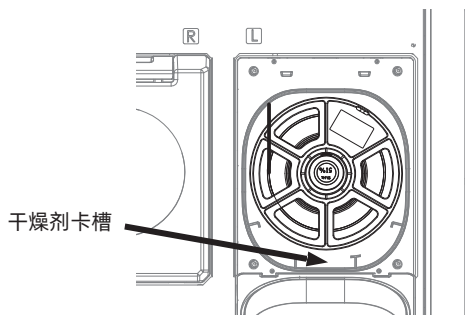
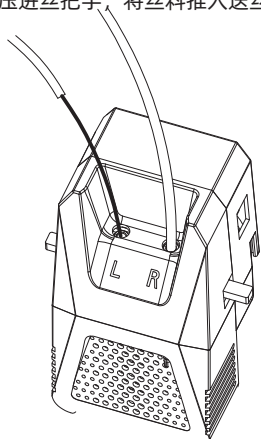
2.3 安装丝料


注意事项 装载丝料时，请注意喷头、导丝管和耗材舱上左、右对应的标贴提示。

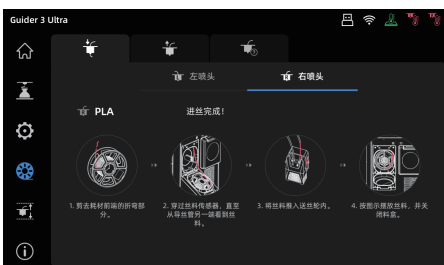
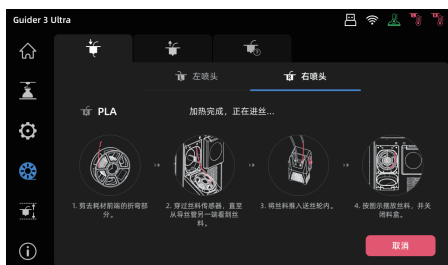
1. 新耗材拆包后，用斜口钳剪去耗材前端的折弯部分。
2. 打开耗材舱，手动将丝料穿过舱内上方对应的丝料传感器，直至从导丝管另一端看到丝料。(注意标贴提示对应的喷头和孔位)。



3. 将喷头端导丝管延伸出的丝料，插入对应进丝口，推入送丝轮内，感受到一定阻力时即可，或按压进丝把手，将丝料推入送丝轮内卡住。
4. 最后将丝料放入耗材舱，此处可将随机附赠的干燥剂放在料仓下方的卡槽内。关上料舱盖子。[注：为方便耗材转动顺畅，对应左喷嘴的丝料放置时按顺时针方向捋顺丝料，对应右喷嘴的丝料放置时按逆时针方向捋顺丝料]




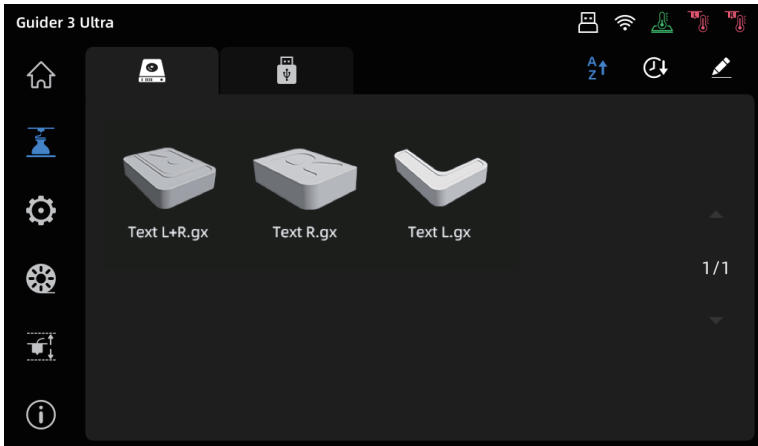
5. 在屏幕上点击[ 丝料], 进入[进丝]界面, 选择准备进丝的喷头和对应的材料, 点开始进丝, 界面如下。




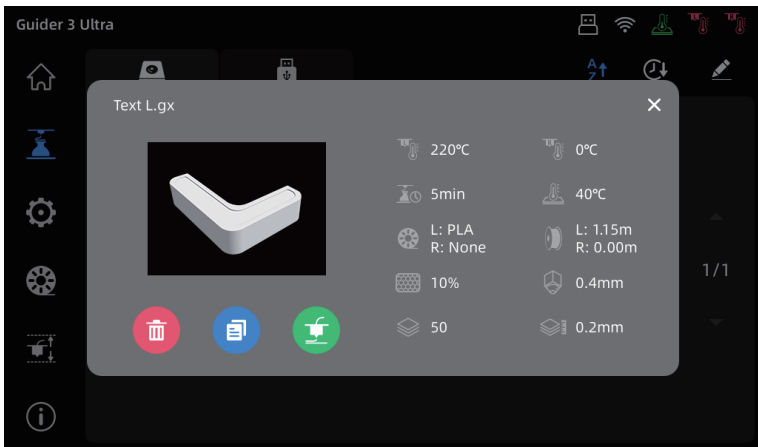
6. 当喷嘴开始吐出丝料, 即为进丝完成。

2.4 测试模型打印

1. 在触控屏左侧点击  图标进入打印界面，机器设备内会有三个测试模型，分别是Test L.gx(左喷头测试模型)、Test R.gx（右喷头测试模型）、Test L+R.gx(双头打印测试模型)。



2. 打印前先确认准备测试的模型对应的喷嘴已装载丝料，然后选择模型文件，再点击  图标即可开始打印。



注意事项

开机引导默认是左喷头加载丝料，所以请选择Test L.gx(左喷头测试模型)进行打印测试。如需打印Test R.gx（右喷头测试模型）和Test L+R.gx(双喷头测试模型)，请先将对应的喷头加载丝料后再进行测试，并且在首次使用双喷头打印前，先进行一次左右喷嘴XY轴偏移值校准，参考步骤4.3双头打印。

第三章：设备操控界面简介

注意事项

因固件会不定期升级，UI界面请以实际显示页面为准，以下仅为功能简介。

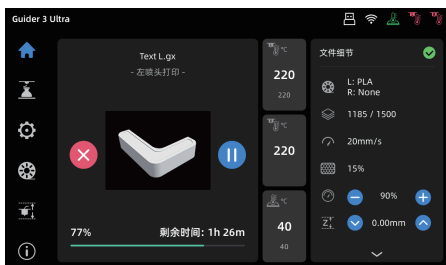
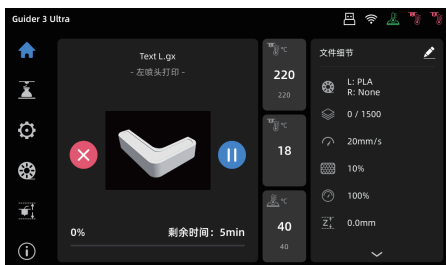
3.1 主界面











机器闲置时主界面显示状态信息

- 主页
- 打印
- 设置
- 丝料
- 校准
- 信息




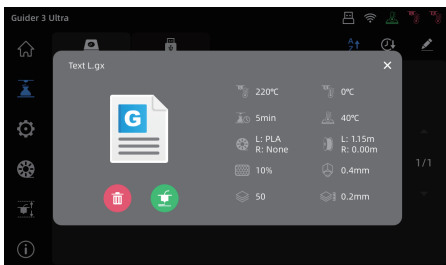
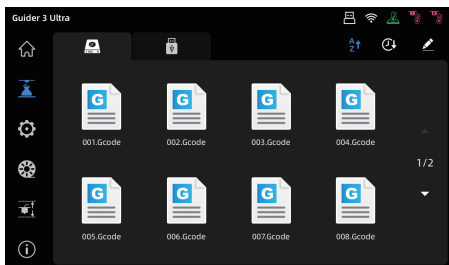
机器打印时主界面显示模型打印状态信息





-  丝料加载状态
-  调整左喷嘴模型冷却风扇速率
-  模型分层层数
-  调整右喷嘴模型冷却风扇速率
-  喷头实时的移动速度
-  调整模型辅助散热风扇速率
-  模型内部填充率
-  空气过滤风扇开关
-  百分率调整打印效率
-  调整喷头和平台间的Z轴距离

3.2 打印界面


点击左侧  图标进入打印界面。



点击要打印的模型。在弹出框点击  图标开始打印。

 [本地] 本地模型打印文件列表

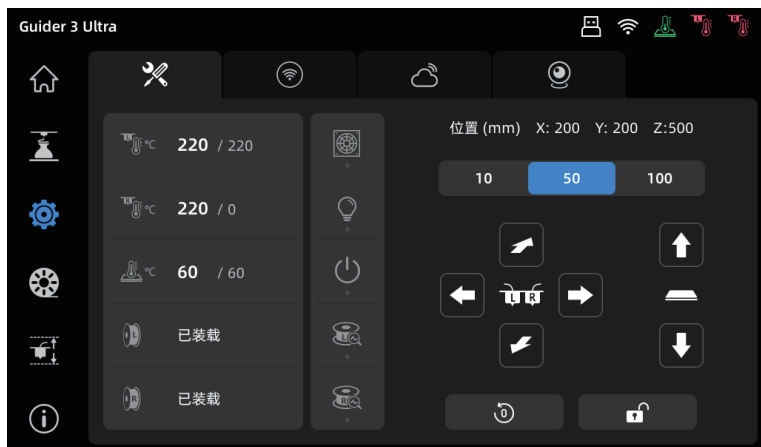
 [字母排序] 按文件首字母进行排序

 [U盘] U盘内模型打印文件列表





 [时间排序] 按文件修改时间进行排序

3.3 设置界面

点击左侧  图标进入设置界面。



顶部图标从左到右依次是：

-  [移动]喷头、平台、腔体预热，风扇设置，手动移动设备XYZ轴，腔体灯开关
-  [网络]无线网络，有线网络，热点
-  [云平台]连接闪铸云、Polar平台
-  [摄像头]打开摄像头与延时视频、查看视频和照片

工具页面图标




- | | |
|---|---|
|  左喷嘴温度设置 |  空气过滤风扇开关 |
|  右喷嘴温度设置 |  腔体灯开关 |
|  平台温度设置 |  打印完成后自动关机开关 |
|  左喷嘴丝料加载状态 |  左喷嘴丝料检测开关 |
|  右喷嘴丝料加载状态 |  右喷嘴丝料检测开关 |
|  喷头和平台回到初始位置 | |

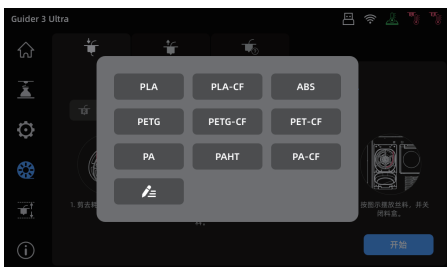
3.4 丝料界面

点击左侧  图标进入丝料界面。


进丝与退丝时，用户可根据实际需要安装的丝料进行选择，若界面中无当前所需的丝料，用户可以自定义丝料，设置进丝时所需的温度。如需更换耗材，可以参考喷头清洗界面提示进行操作。

丝料界面包含：

-  进丝操作界面
-  退丝操作界面
-  耗材更换帮助界面








3.5 调平校准界面

点击左侧  图标进入调平校准界面。



在校准界面中可进行喷头校准和平台调平，图标从左到右依次是：

-  [Z轴自动校准] 自动校准喷头Z轴行程和左右喷嘴的高度差；
-  [自动调平] 自动调平平台；
-  [XY轴校准] 左右喷嘴XY轴偏移校准；
-  [专家模式] 手动调整右喷头相对左喷头XYZ轴的偏移值。
-  [共振补偿] 对喷头进行共振测量和自动整形校正。

3.6 信息界面

点击左侧  图标进入信息界面。



- ◆ [升级]固件升级，可在无线网络连接时，升级到设备最新的固件。
- ◆ [拷贝日志]将日志拷贝到U盘。
- ◆ [打印机名称]修改机器名称。
- ◆ [语言]设置打印机系统语言。
- ◆ [恢复出厂设置]将系统中的各项设置恢复到出厂状态

第四章：打印模型

4.1 切片软件安装

方法一：在U盘中找到 FlashPrint 软件安装包，选择对应的系统版本进行安装。

方法二：从中文官方网站 www.sz3dp.com 下载最新的切片软件。

3D 打印过程：


获取模型文件 (stl/obj/stp 格式) - 文件导入切片软件-使用切片软件进行切片 - 设备准备就绪-文件传输至打印机打印。

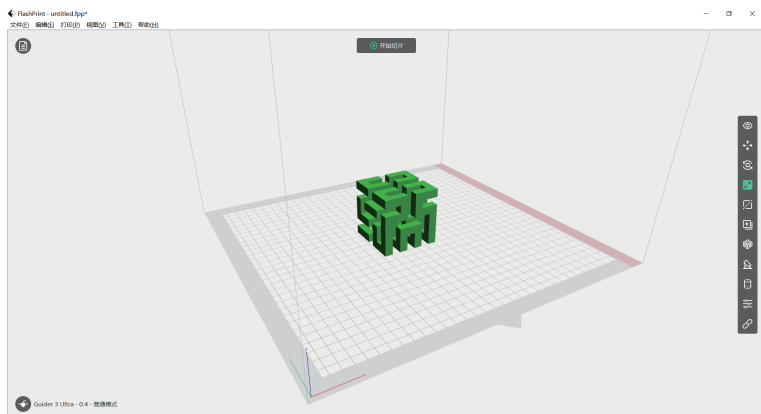
注：可在安装切片软件后，在切片软件中查看切片软件的使用说明。

4.2 单头模式打印

注意事项

单头模式打印默认使用左喷头打印，因为左喷头是固定头，右喷头是升降头，左喷头打印模型会优于右喷头。打印前，请先确认喷头已加载丝料，并可正常挤出耗材，可参考2.3。


打开切片软件后，请在左下角选择您所使用的打印机机型，然后在切片软件中导入模型。用户可对模型进行移动、旋转、缩放等修改；设置好摆放方式后在软件界面点击  [支撑]图标，选择支撑类型，点击自动支撑。返回到主界面再点击[开始切片]，选择对应的打印材料后点击[切片]生成切片文件。

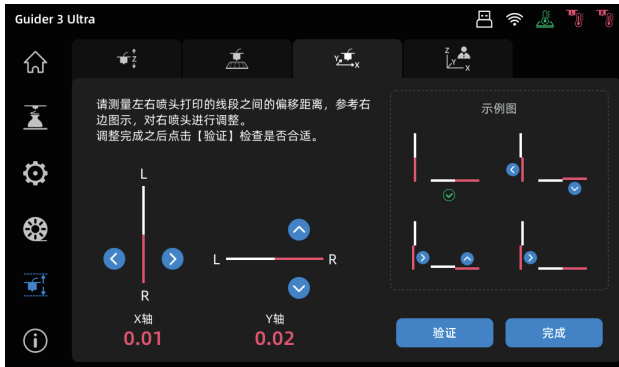


4.3 双头模式打印

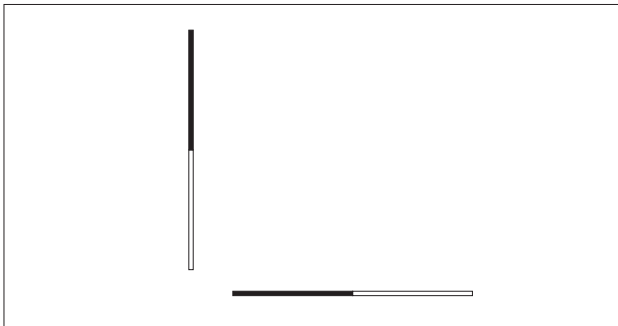
注意事项


如果是首次进行双头模式打印，请进行一次左右喷嘴XY轴偏移值校准，该步骤的目的是校准右喷嘴的XY间距从而与左喷嘴对齐。在校准操作前，请先将您的左右喷头各加载一卷耗材，并且确保左右喷嘴能够正常挤出耗材，可参考2.3。双头异支撑打印时，建议选择左喷头打印模型部分，右喷头打印支撑部分，原因参考单头打印的[注意]说明。

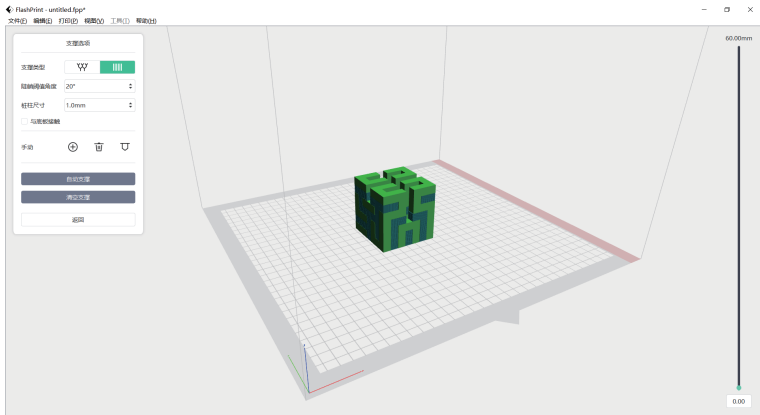
1. 进入校准调平界面，在触控屏上点击图标，进入[XY轴校准]界面，点击[开始]后，打印机会自动加温，到达目标温度后左右喷嘴会在XY方向上各打印一条测试线。
2. 打印完成后，可以用尺子测量实际打印同方向两条线的偏差距离。将打印的测试线与屏幕上的示例进行比较。对照示例的提示进行右喷嘴XY间距的调整。




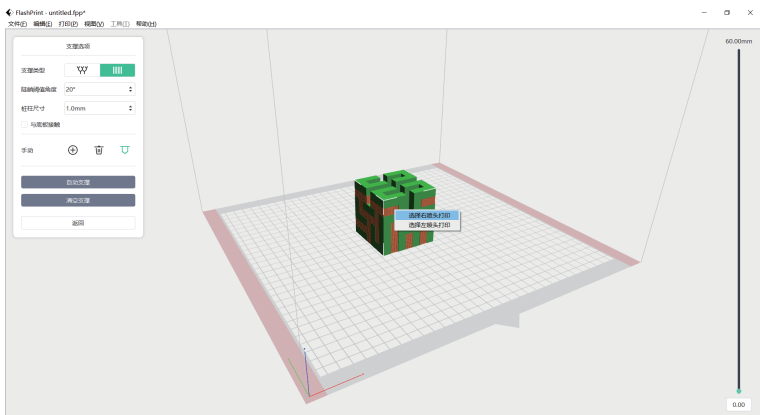
3. 调整完后点击[验证]按钮再次打印测试线，如果还存在偏移情况，请重新执行步骤“4.3-2”的操作。当实际打印线如下图所示，说明左右喷嘴XYZ方向偏移值在合理的范围内点击[完成]保存数据。



4. 左右喷嘴XY轴偏移值校准完成后，即可开始双头模式打印。
5. 打开FlashPrint软件后载入模型，在软件界面点击  [支撑]图标，选择支撑类型。
6. 点击[自动支撑]。



7. 选择  图标，鼠标左键点击支撑，按“Ctrl+A”全选支撑，再按鼠标右键可以选择需要用来打印支撑材料的喷头，选好后点击[返回]。



8. 点击界面上方的[开始切片], 进入参数配置页面。



9. 选择配置材料 (例如使用右喷头打印PLA模型, 使用左喷头打印PVA支撑)。

10. 点击[切片], 生成切片文件。

注意事项

双喷头打印模型时时建议添加围墙或者擦嘴塔, 以刮除空闲喷嘴的漏丝。更多打印配置可点击[帮助]-选择[帮助文档]查看。

4.4 文件传输：网络传输

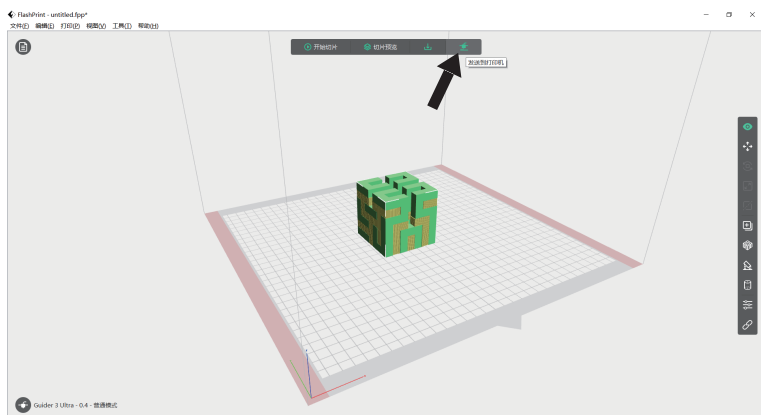
1. 连接网络后, 打开FlashPrint切片软件, 点击界面左下角图标选择[机器类型], 选择 [Guider 3 Ultra]机型, 然后点击[打印] - [连接机器]。

2. 在弹出的对话框中, 连接方式选择IP端口一栏中填入打印机的IP地址或自动扫描。IP地址可以在机器的信息界面查看。输入完成点击连接。连接成功直接弹出 [多机控制]界面, 可查看打印机连接状态。



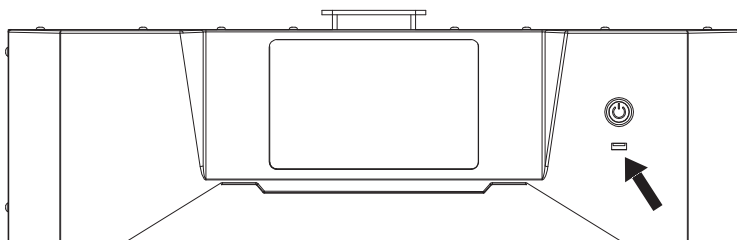
3. 模型切片完成后点击[发送至打印机]。打印机开始进行预热等准备工作，准备完成后自动开始打印。

提示：打印机连接的网络和电脑连接的网络必须在同一个网段中，否则连接不成功。



4.5 文件传输：USB传输

1. 设备也可通过U盘打印。将切片好的文件 (*.g/*.gx/*.gcode格式) 保存至U盘。
2. 将U盘插入设备USB接口。



3. 进入[打印]界面，在触控屏上点击图标  进入U盘文件界面，选择对应的文件即可打印。

4.6 云打印

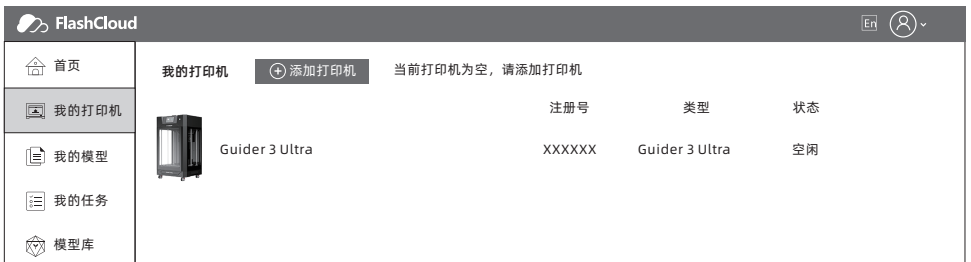
闪铸云打印

1. 打开闪铸云网站，注册账号，经过邮箱激活后，即可登录使用。
闪铸云：<https://cloud.sz3dp.com>

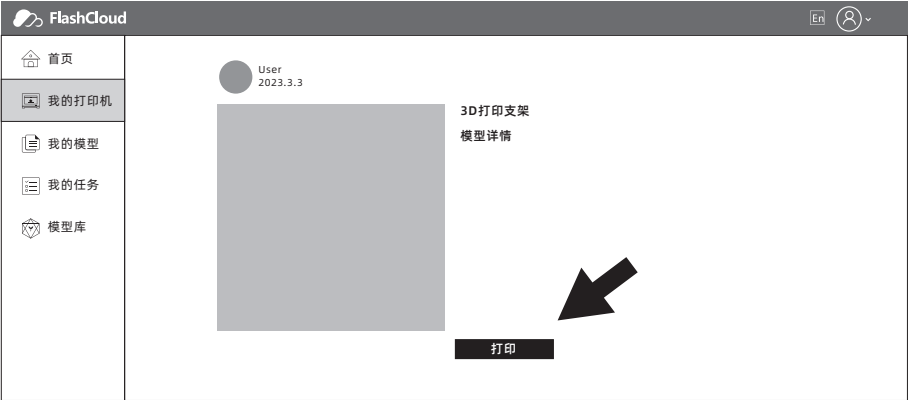


2. 点击 [我的打印机] - [添加打印机]。

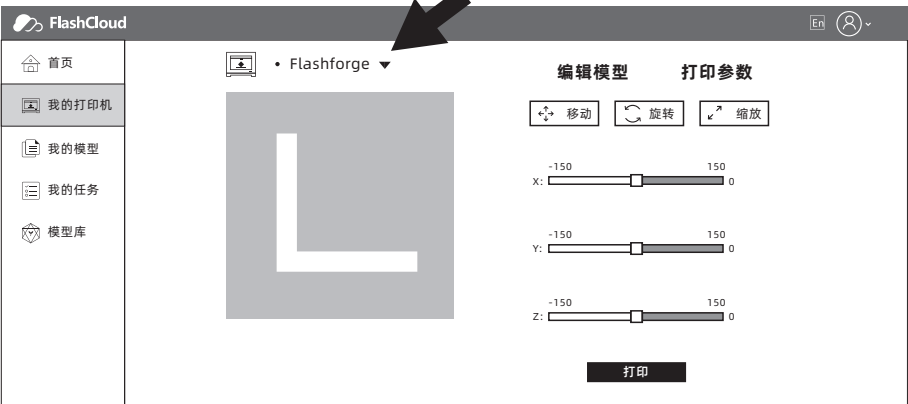
在添加打印机页面填写注册号[云注册码]，为打印机起个名字，点击确定后，这些信息会出现在打印机的闪铸云界面。



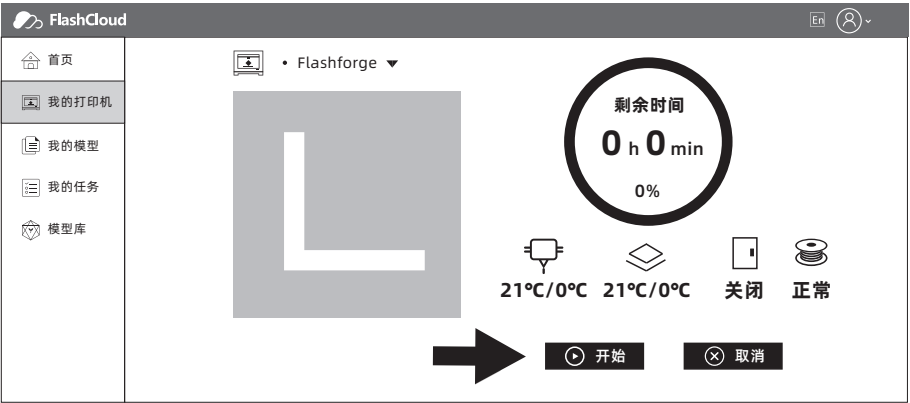
3. 在模型库中选择一个模型，或上传自己的模型文件（STL文件），点击打印进入模型简易编辑界面。



4. 在打印机名称的下拉菜单中，可以选择希望执行本次打印任务的打印机。（打印机必须被添加进我的打印机）。

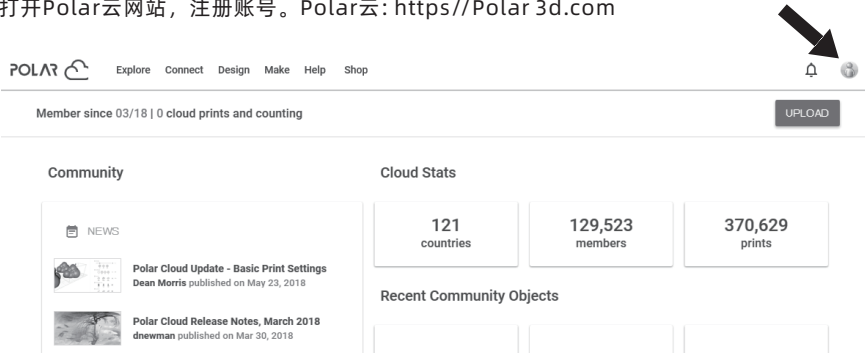


5. 最后点击开始，被选中的打印机会自动开始执行本次打印操作。



Polar云打印

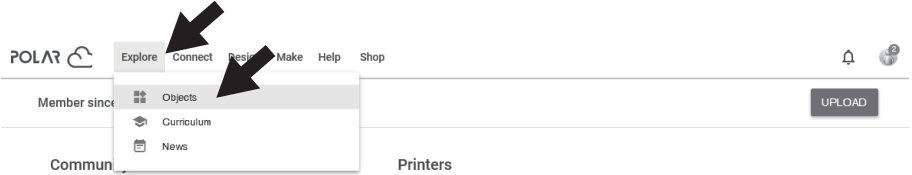
1. 打开Polar云网站，注册账号。Polar云: <https://Polar 3d.com>



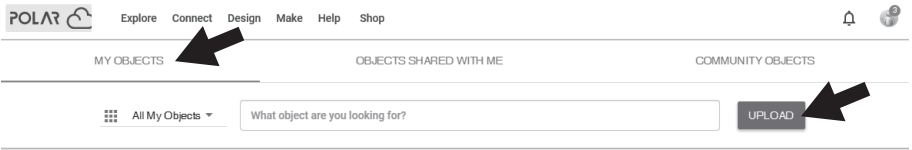
2. 登录后，点击右上角头像图标，点击[Settings]，在页面下方找到PIN Code一栏，显示的数字就是PIN码。

Location	_____
Biography	_____
Website URL	http://www.example.com/profile
Email	_____
+ADD Email	_____
PIN Code	XXXX

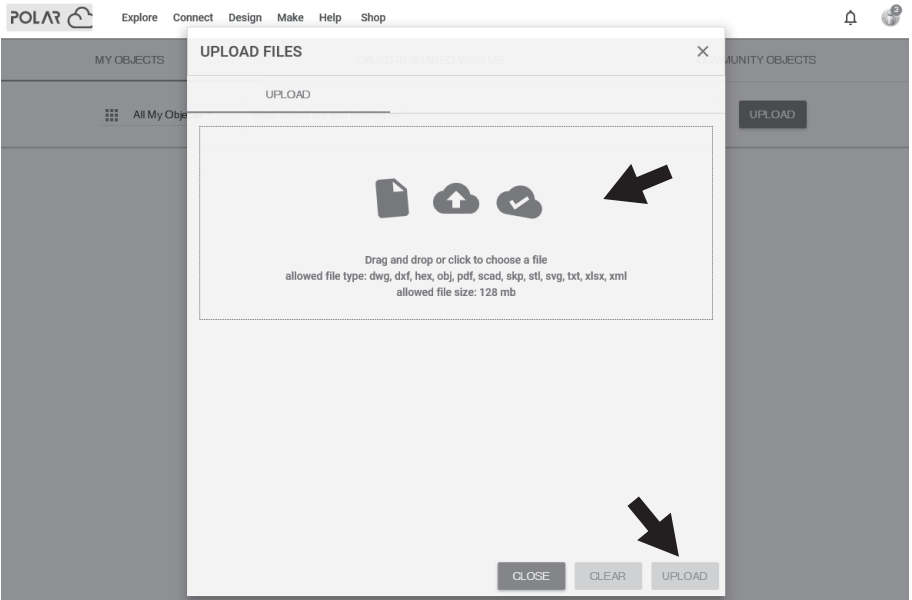
3. 将Guider 3 Ultra连接网络后，进入云平台界面（点击设置->云平台），打开Polar云开关（Polar云打开后开关应显示为绿色）。在下方的账号和PIN码栏中分别填入之前注册Polar云时填写的账号与之前查询得到的PIN码，点击保存。
4. 连接完成后，在Polar云网站首页就可以看到打印机的信息。
5. 在网站首页上方的菜单栏中点击[Explore]，选择下拉列表中的[Objects]。



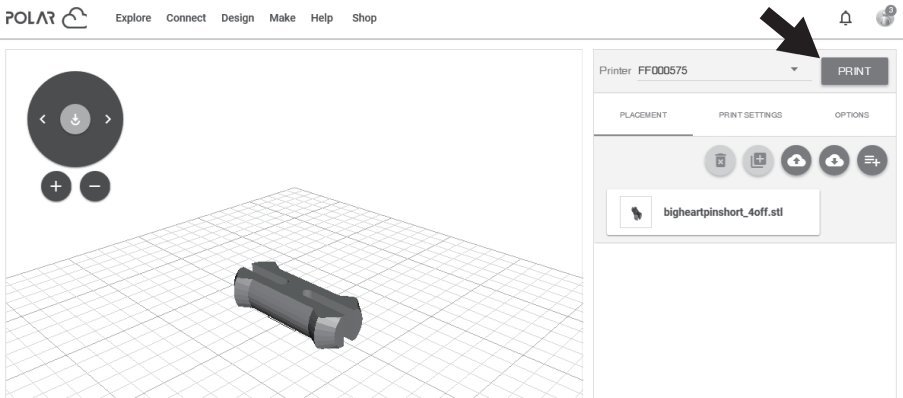
6. 点击[MY OBJECTS], 然后点击[UPLOAD]上传模型。



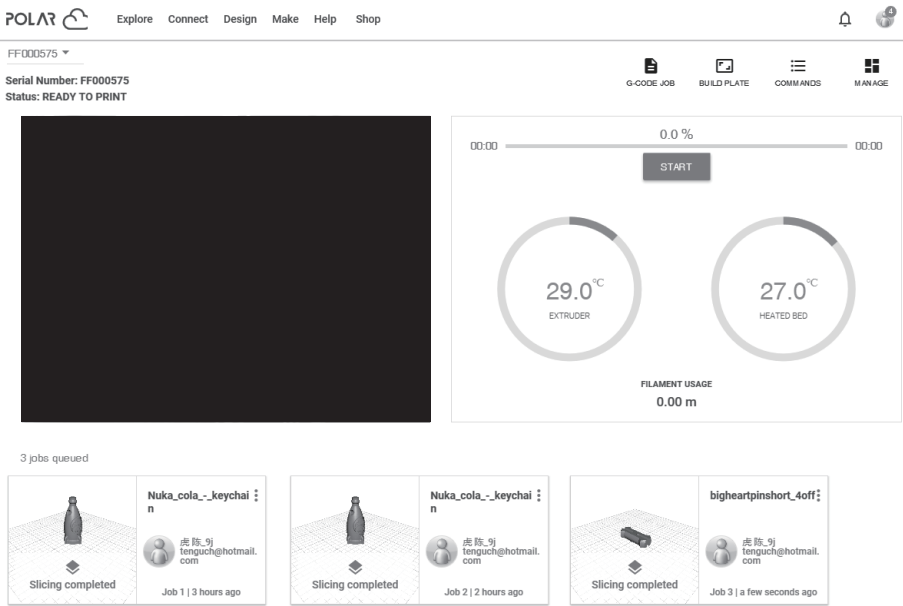
7. 将需要上传的模型文件拖拽至框型区域或点击框型区域后选择上传模型，然后点击 [UPLOAD] 上传。



8. 点击[PRINT]。

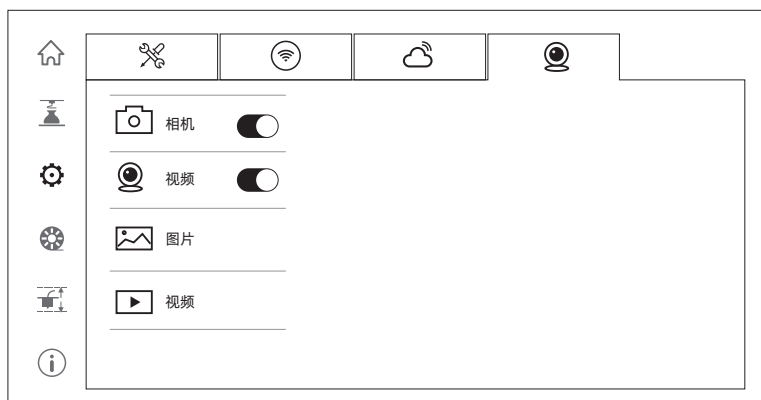


9. 点击[START], 打印机开始云任务下载, 下载完成后开始打印。



4.7 摄像头连接查看

1. 打开摄像头开关，在触控屏上点击图标  [设置] - 进入[摄像头]界面，将[相机]和[视频]功能打开。



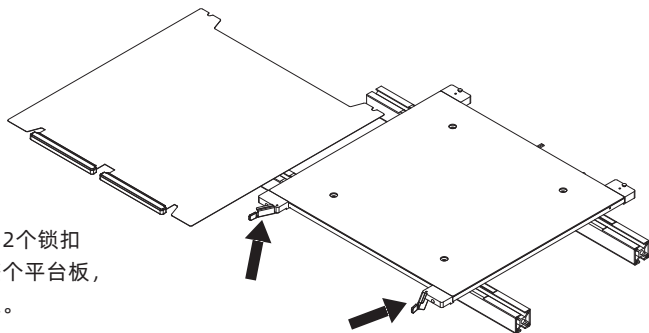
2. 设备与FlashPrint连接后可以在FlashPrint-[多机控制]中查看到实时视频画面。在闪铸云和Polar云也可使用摄像头的功能。

4.8 打印后模型移除

警告

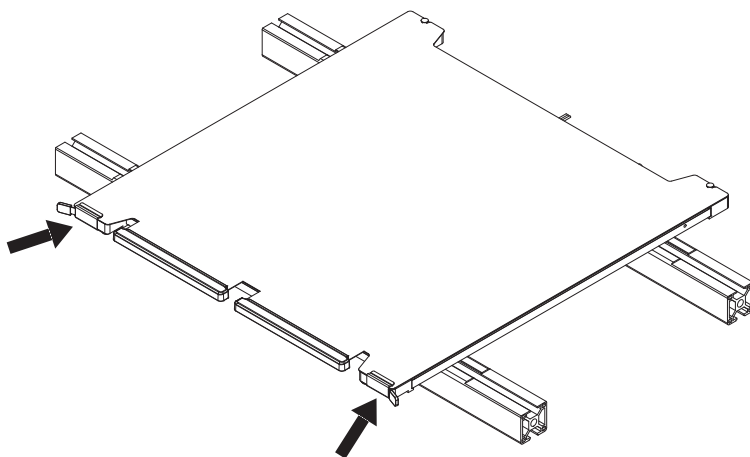
从打印平台上移除模型时，请注意需要等待平台冷却后再操作。此时可查看屏幕顶部状态栏温度图标来确认平台温度，绿色图标表示平台温度低于50°C，可进行安全操作。移除模型时可以使用配套手套，同时务必注意设备高温。

打印完成后，将平台板前部2个锁扣逆时针转动至松动，取出整个平台板，将平台板折弯即可取下模型。



取下模型重新将平台板放回设备，操作如下：

1. 将柔性钢板后端顶住平台左右边缘的定位块；注意要插入卡槽内侧。
2. 合上锁扣直至固定住柔性钢板。



第五章：维护

注意事项

因固件会不定期升级，UI界面请以实际显示页面为准，以下仅为功能简介。

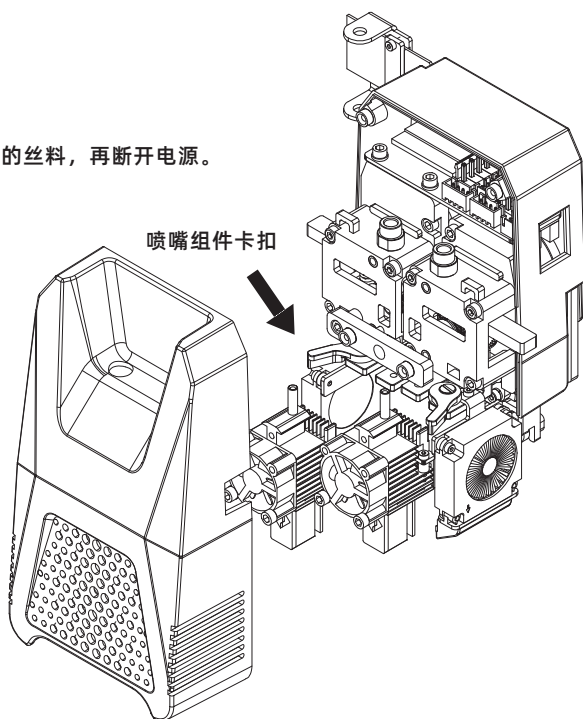
5.1 喷头维护

5.1.1 喷嘴组件更换

注意事项

操作喷头前，需先退出喷头内的丝料，再断开电源。

1. 打开磁吸式的喷头前盖。
2. 拨动喷嘴组件卡扣，取出喷嘴组件。
3. 将新的喷嘴组件安装上去，扣紧喷嘴组件卡扣。



5.1.2 喷头堵头清理

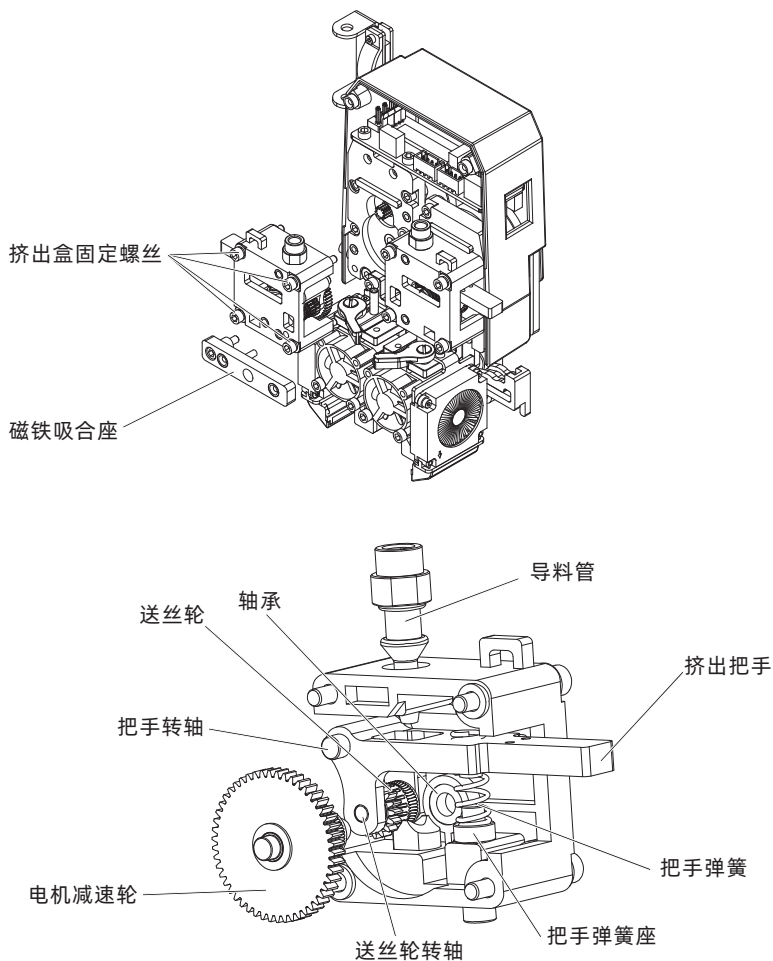
方法一：预热喷头，喷头加热至所使用材料温度，拔出导丝管，按压把手，拔出丝料，将通针插入喷嘴内部进行疏通。

方法二：方法一操作无效，参考喷嘴组件拆装方式更换喷嘴组件。

提示

如遇到丝料卡挤出盒取不出，可以拆卸挤出盒取出丝料。

操作如下：剪去挤出盒上的扎带，将磁铁吸合座上的螺两个螺丝和固定挤出盒的四个螺丝拧下，往外拉出挤出盒(必要时拧开热端把手将热端一起拆下)。将挤出盒里面的卡料取出后重新安装挤出盒(下图为挤出盒零件示意图)。注意安装挤出盒时，可以先拆掉喷嘴组件，将轴承先对准挤出盒基座再按压把手使把手转轴插入对应孔，最后拧上挤出盒固定螺丝，重新安装上挤出盒磁铁吸合座并拧上螺丝，最后取新的轧带将线束固定好即可。



5.2 平台平面度校准

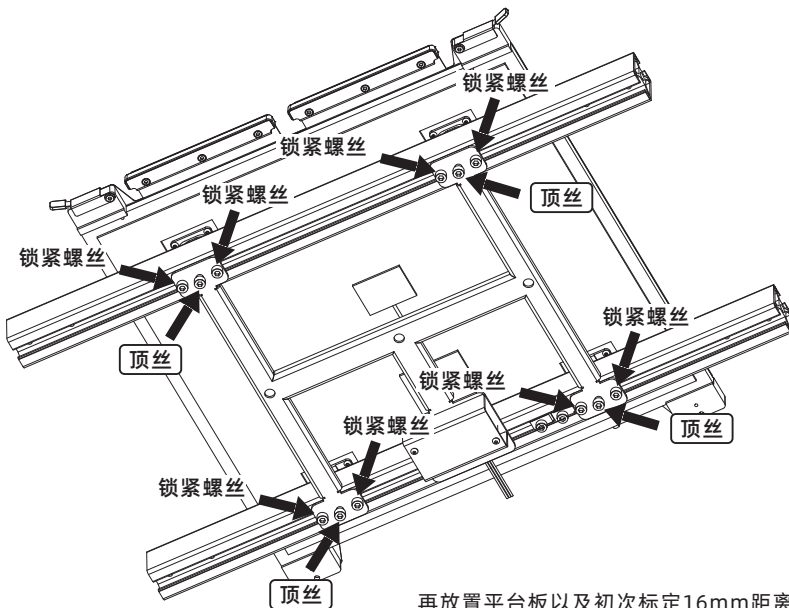
用户一般无需进行此操作，当设备平面度经过各种校准或者自动调平补偿无效的时候，可能是平台安装的平面度已受到破坏，此时需要进行初始的平台调平。

特别提示 此操作可联系闪铸科技售后人员，进行远程协助校准。

操作如下：总计调平点位置4个。

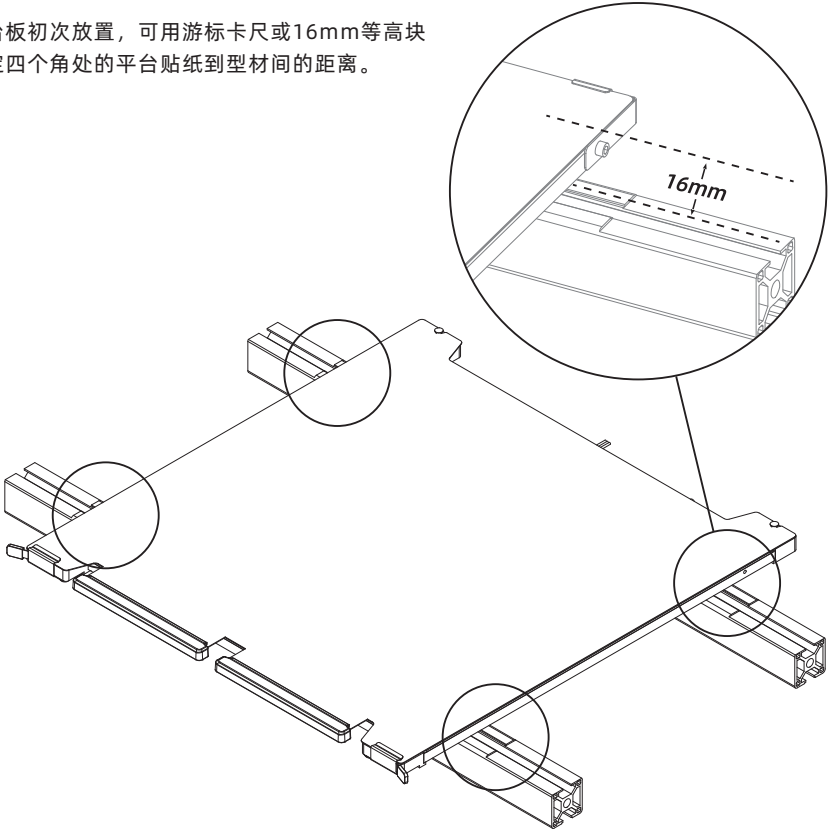
注意事项 此步骤请谨慎操作，或可联系专业工程师指导。

1. 通过移动平台高度调整到合适的视野位置；
2. 检查平台底部应变片线不被压死；
3. 锁紧四个顶丝旁边的M5螺丝(锁紧过程中需要两边同时锁紧，请勿单边拧死后在拧另一次)；
4. 标定柔性钢板贴纸面到型材面之间的距离为16mm(通过手拧底部四个顶丝)，四个角都一致。



再放置平台板以及初次标定16mm距离后，通过拧中间四个螺丝来调整平台平整度，待平整度调整完后，锁紧中间顶丝旁的锁紧螺丝来锁紧，拧锁紧螺丝过程中必须两边同时拧，不可单边拧紧后再拧另一边。

平台板初次放置，可用游标卡尺或16mm等高块
标定四个角处的平台贴纸到型材间的距离。



第六章：Q&A

Q1：更换喷嘴后需要校准设备吗？

需要。

Q2：点击打印模型，喷头运动，但打印一开始就没有出丝怎么办？

1. 观察导丝管，确认丝料是否已进入喷头，若无，请再点击进丝按钮，直至丝料从喷头中吐出；
2. 查看喷头是否堵头，若是，解决方案请查看5.1.2。

Q3：打印时发现喷嘴与平台相对位置过高[远离平台]或过低[顶到平台]怎么办？如何调平？

解决方案查看2.1-校准设备。

Q4：可以使用其他品牌的丝料吗？

可以使用其他品牌丝料，但由于不同材料参数温度略有区别，需要经过参数调整配置。

Q5：产品打印完成后可以自动关机吗？

可以。在[设置]页面中打开该功能即可。

Q6：打印ABS材料安全吗？

ABS在加热过程中会释放有毒气体，建议打印时或打印后开启HEPA空气过滤器进行过滤。如条件允许，建议将设备置放在开阔环境下打印。儿童活动场所建议打印PLA无毒材料。

Q7：打印模型发生翘边或粘不牢现象怎么办？

方案1：增加平台温度可有效缓解此问题，高温可增加平台与模型的粘附力。

方案2：模型切片时选择添加底板可有效缓解此问题。

方案3：涂抹胶水。

方案4：喷嘴与平台的间隙过大，可相应减小间隙，使用喷头校准专家模式或调平校准功能进行间隙调整。

方案5：确认平台是否放平。可使用调平校准功能，建议执行完全流程的自动调平。

Q8: 打印模型时必须增加底板吗?

不一定。打印底板时出丝量较多，打印成功率较高。在底板加热的条件下，模型与平台板的粘附性增加，使模型打印时能很好的粘附在平台上，同样也能增加打印成功率。



Q9: 插入U盘后找不到打印文件，屏幕显示全为文件夹怎么办?

U盘格式不正确，设备支持FAT32格式的文件系统，请将U盘格式化成FAT32格式。



Q10: Wi-Fi连接不上怎么办?

- 1. 请检查Wi-Fi名称是否含有特殊字符，如果有，请修改之后再次尝试；
- 2. 请检查密码是否含有特殊字符，如果有，请修改之后再次尝试。



Q11: 更新固件注意事项。

请不要在下载或更新固件时断电断网，防止更新失败。



Q12: 为什么开机屏幕白屏?

如果听到开机声音，请更换屏幕或者排线；否则请联系售后人员。



Q13: 耗材舱湿度计使用的电池是否配置? 型号多少?

电池需自己购买，型号LR44，1.5V，尺寸11.6*5.1mm。
兼容型号：AG13/A76/L1154。

第七章：帮助与支持

闪铸专业的售后服务人员及业务员随时为您待命，非常乐意为您解决在您使用过程中遇到的任何问题。如果您无法从用户手册中找到答案，您可以进入我们的官方网站来搜索问题的解决方案，或者通过电话联系我们。

在我们的官网中可以找到一些常见问题的说明和解决方法。您的许多问题都可以在闪铸科技中文官方网站www.sz3dp.com得到解决。

您可以在周一到周六上午8:00到下午5:00通过电话来联系闪铸售后团队，为您解决问题。如果您在下班时间联系我们，闪铸将在下一个工作日的第一时间给您反馈。若造成不便，我们万分抱歉。

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提示

由于更换不同的丝料，会有少量杂质残留在喷头中造成喷头堵塞，疏通后即可，不属于质量问题。若用户使用时存在该问题，请联系售后，并在售后的指导下完成疏通工作。

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售后服务热线：400-886-6023

邮箱：support@flashforge.com

公司地址：浙江省金华市婺城区仙源路518号

提示：联系售后时，需提供产品序列号，即打印机背部的条形码





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