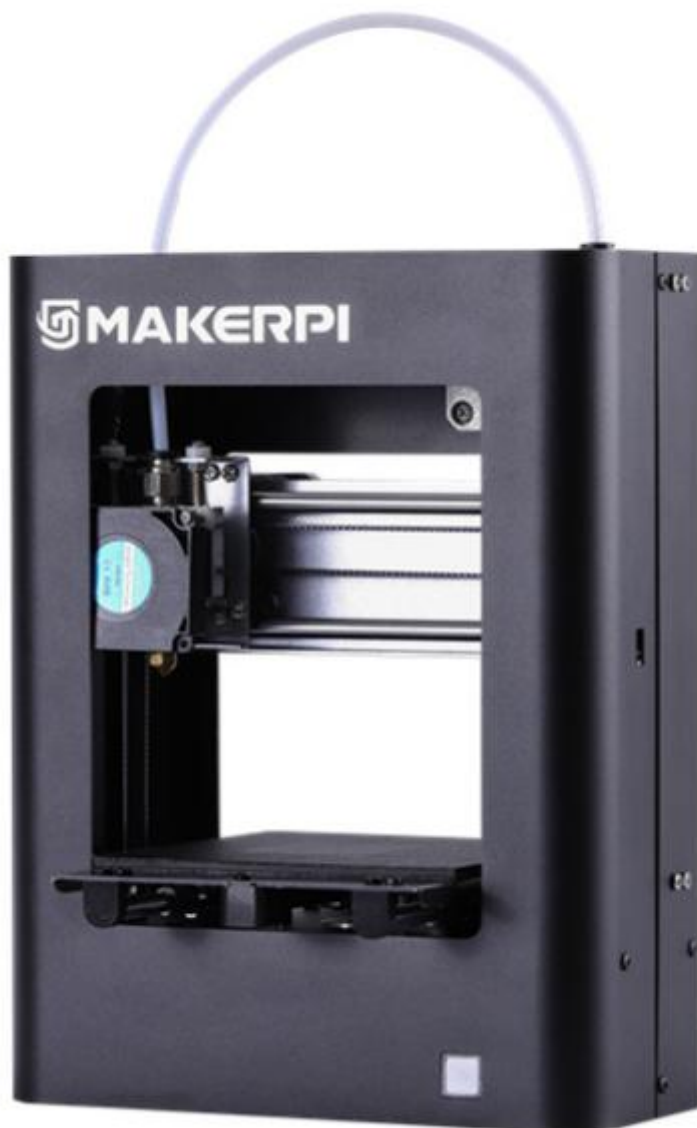


MakerPi M1

Quick Start Guide

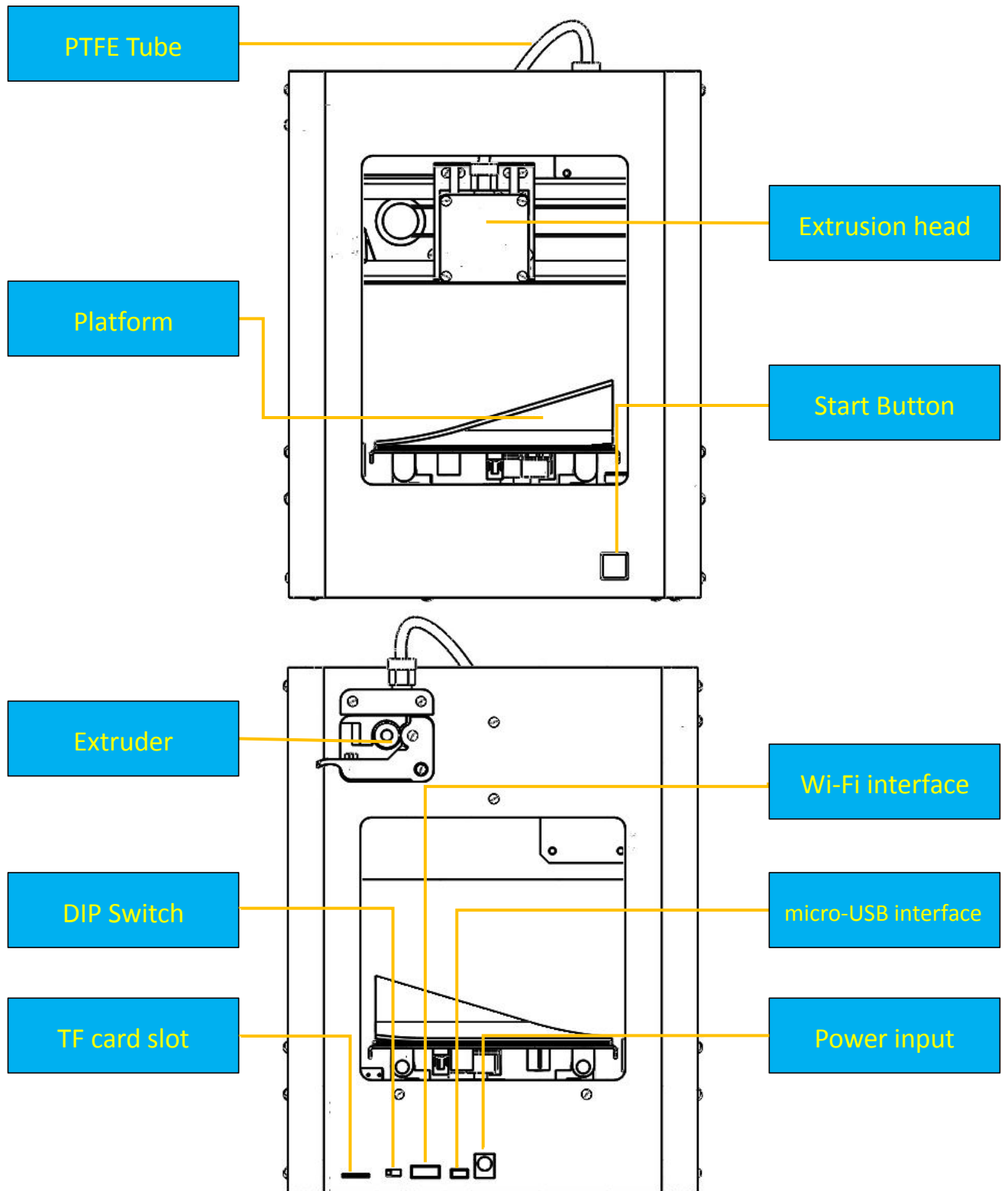


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Chapter 1 Getting to know your MakerPi M1

1.1 Introduction of MakerPi M1

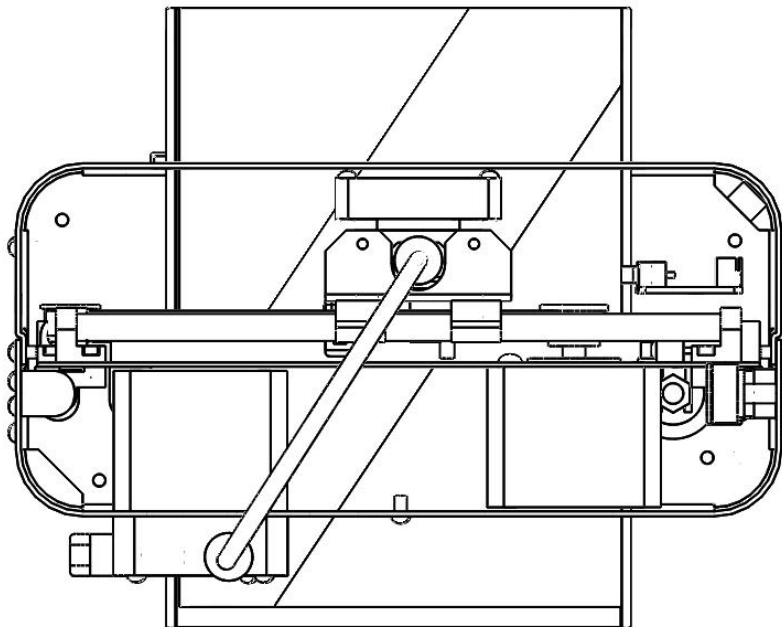
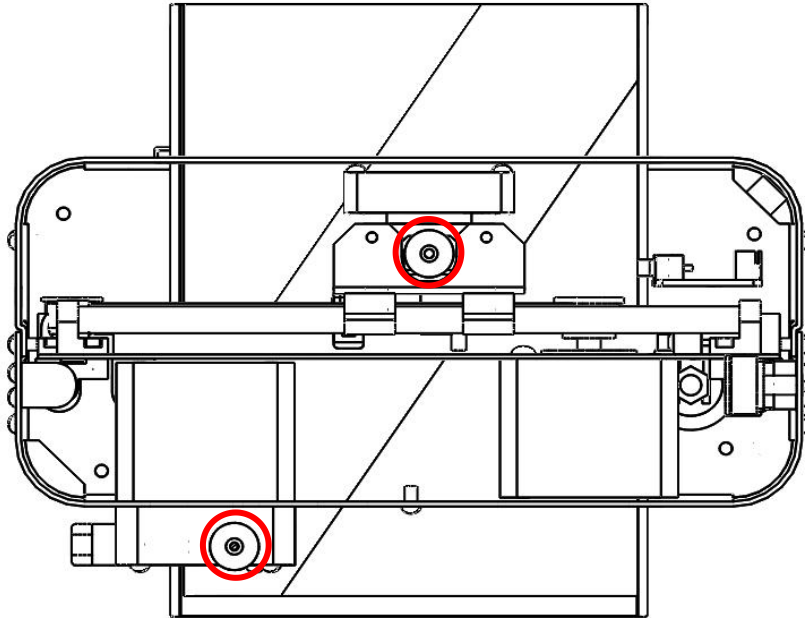


1.2 Notices

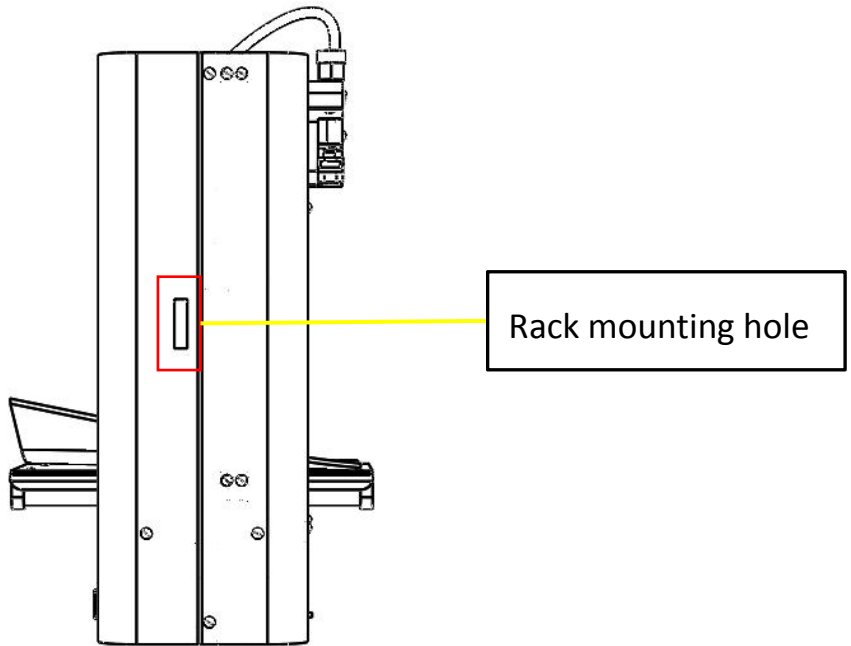
1. During the period of operation of the 3D printer and for a period of time after the end of printing, the temperature of the nozzle is as high as 200 °C or more. So do not touch the nozzle with your hand.
2. Please follow the instructions in the guide to operate the machine. If you have any questions, please contact the after-sales service.
3. If the printed model needs to be disassembled for support, please wear gloves to avoid being scratched by tools or supporting materials during disassembly.
4. During daily use, it is necessary to regularly clean and lubricate the cross slide optical axis of the 3D printer. Be careful not to drip onto the casing and belt when adding lubricant.
5. While reading this ‘ User Guide’ , Please combine with the actual operation of the 3d printer, it will be more conducive to your familiarity with the use of the machine.
6. Please take pictures or videos to reflect the problem more intuitively in the process of printing. And provide a photo of the machine number (label on the bottom of the back of the machine), then contact the after-sales.
7. Suggest to use the original filament.

Chapter 2 Preparation before Printing

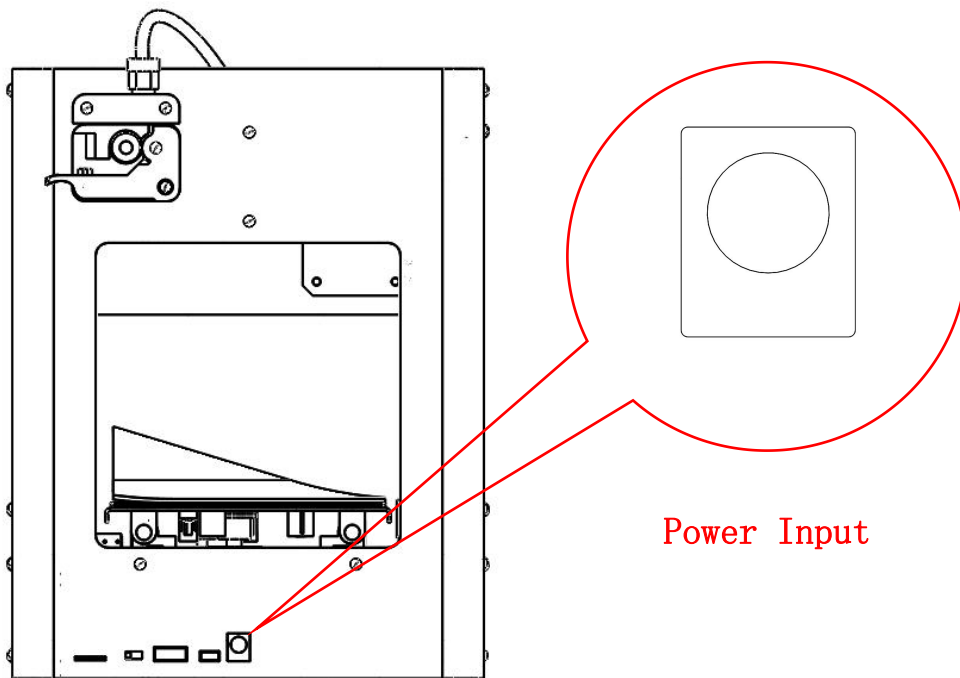
- Connect TPF E Tube to extruder and filament intake



- Hang the filament at the side of the 3d printer.



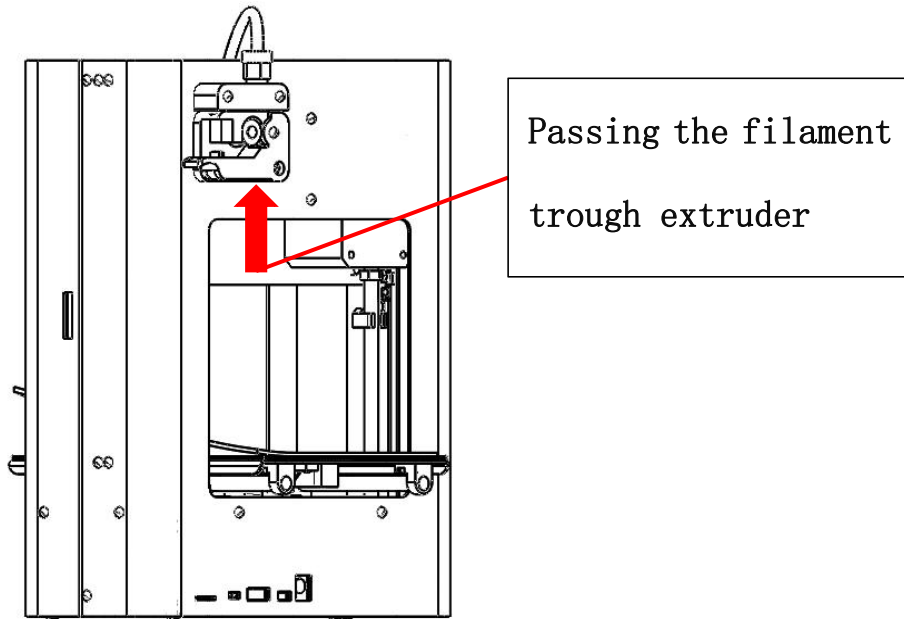
- Connect power supply to 3d printer



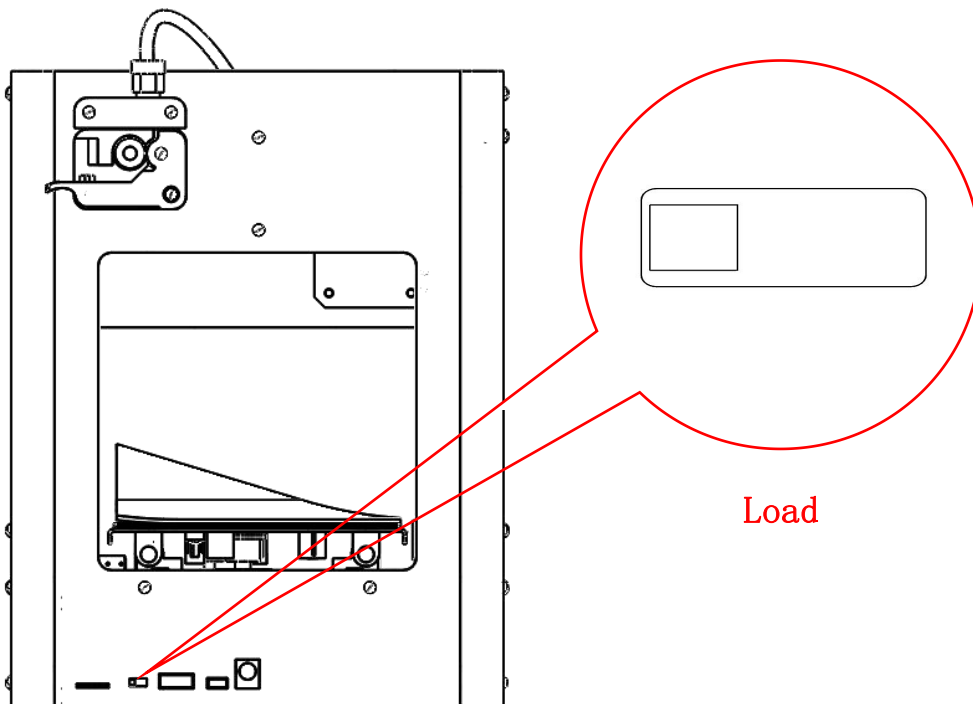
Chapter 3 Load & Unload

3.1 Load

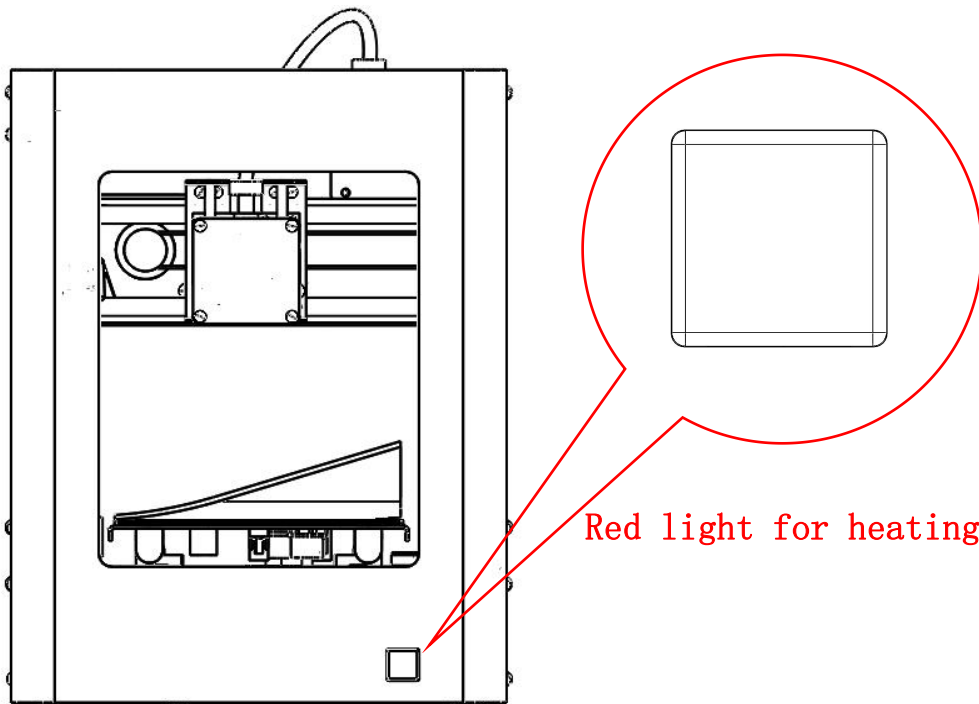
- Passing the filament trough extruder



- Toggle the switch to the left as the load (to the left is the load, the right is the unload, the middle is the stop).



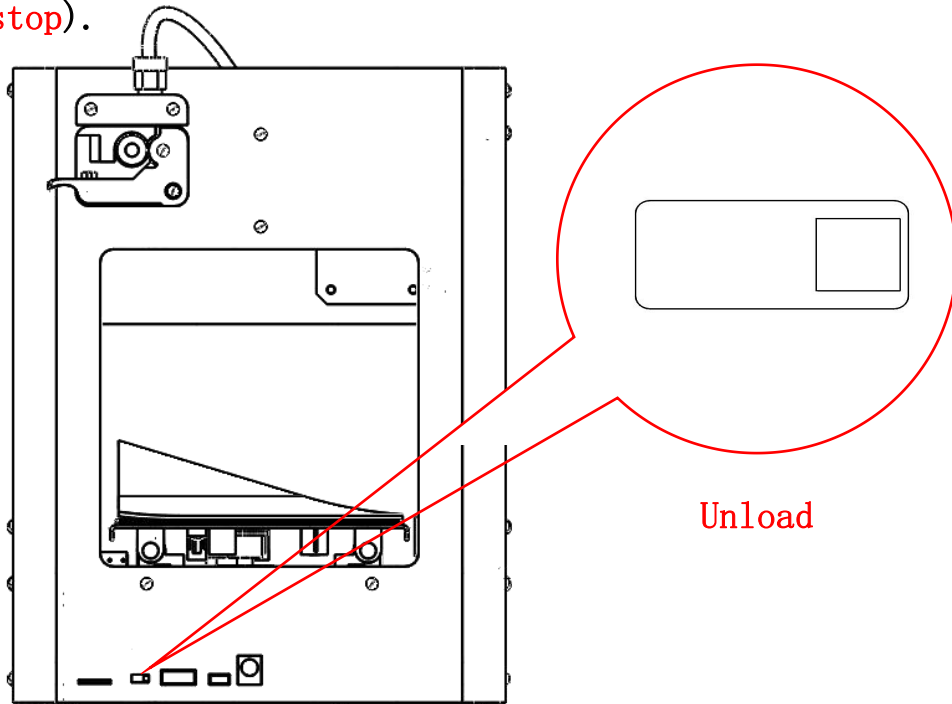
- The printer nozzle begins to heating while red light, the green light is always on, the printer nozzle is heated, and the printer begins to load.



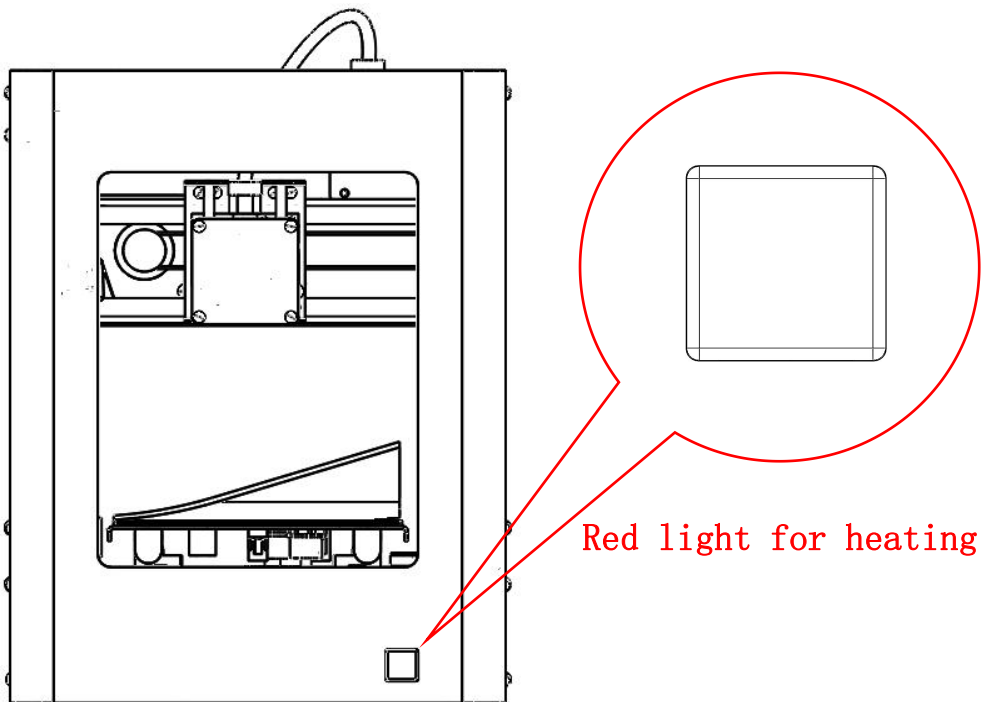
- The " Start Button " is twinkling with green color while standby and printing. Click the button to pause print when it is printing. And relick it that can restore to printing.
- Long-time press the machine to stop printing, The machine will auto home.

3.2 Unload

- Toggle the switch to the right as the unload (to the left is the load, the right is the unload, the middle is the stop).

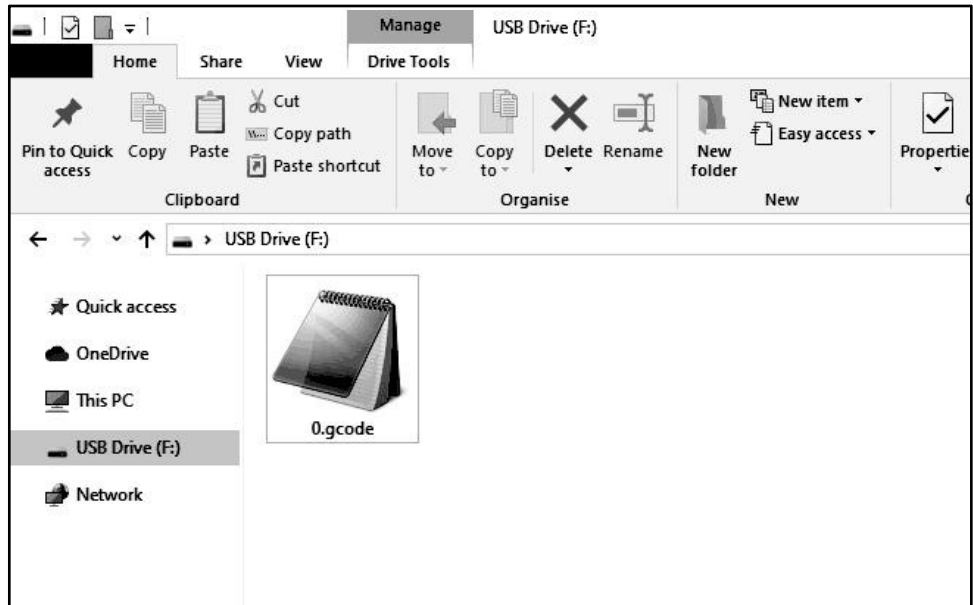


- The printer nozzle begins to heating while red light. The printer nozzle is heated while green light is always on, and the printer begins to unload.

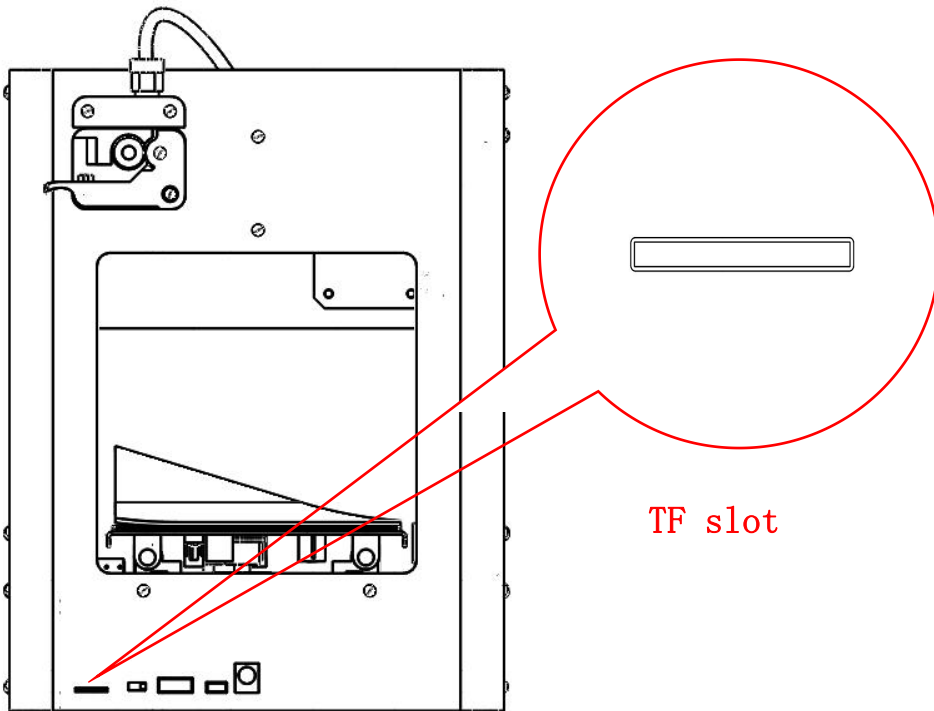


Chapter 4 Printing

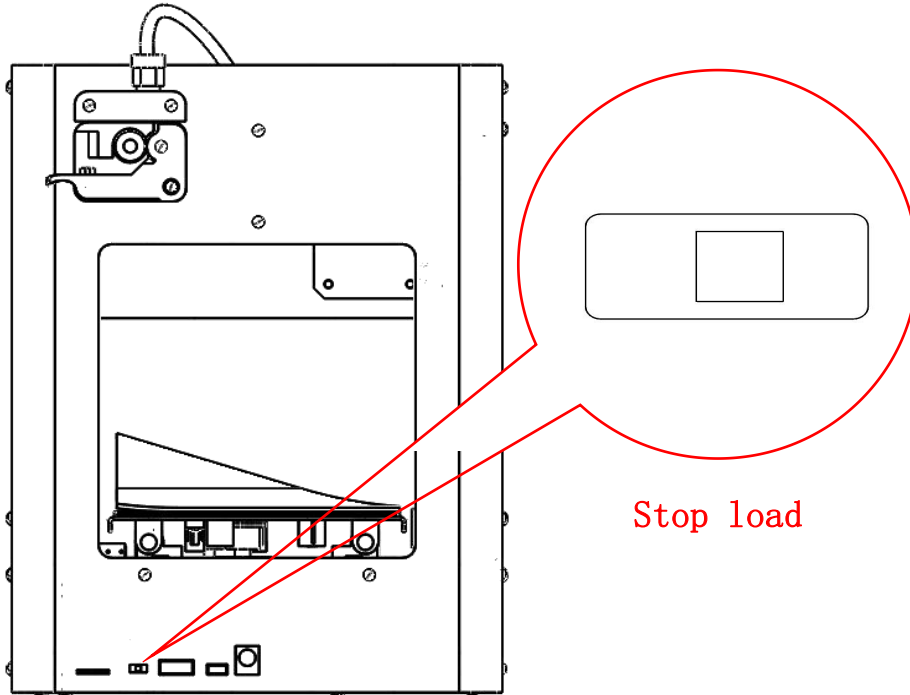
- Please rename your printing file as 0.gcode, save in the TF Card.



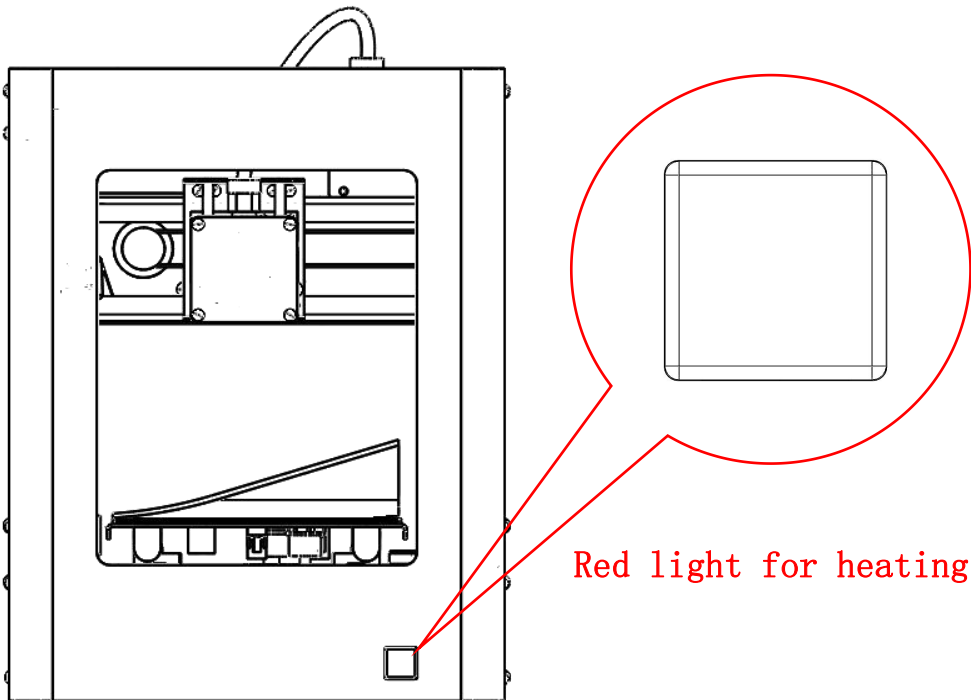
- Then insert the TF Card.



- Please make sure the DIP switch is in the middle position.



- Click the front print button to automatically recognize the print file and start printing (wait for the nozzle to heat up and the M1 starts printing)



Chapter 5 Analysis of Common Problems

1. When using the machine, the metal shell on the surface of the machine may be electrostatically charged and will not cause any impact on the human body. The solution can be done by grounding the metal of the machine housing.

2. During the printing process, the printing platform is scraped somewhere, please make sure there is no foreign matter under the PVC magnetic sticker.

3. If the filament can not come out normal as following reasons:

3.1 Temperature does not reach the optimum melting point of filament. Temperature can be adjusted appropriately.

3.2 Filaments can't be supplied. After cutting out the filaments, readjust the filaments and reprint them.

3.3 The filaments purchased are too large, to change a better filament as 1.75mm

3.4 The nozzle might be damaged due to various reasons, please contact customer service.

4. shifted.

4.1 Light shaft dust is too much friction, you can use paper towels or cloth plus alcohol

Wipe to remove dust from the oil.

4.2 Check all the synchronous wheels on the optical axis and the motor to see if there is looseness and tighten loosely.

4.3 Some customers' original pictures are scanned, and the scanned parts have not been well processed, resulting in cura generating Gcode not printing properly. So the scanned parts must be processed well.

4.4 The nozzle is forcibly blocked in the middle of printing. The first moving nozzle cannot be touched by hand during printing. Secondly, if the model map prints the uppermost layer with the negative distortion, the next time the printing will repeat the increase of the engraving, a certain degree of hardening of the anomaly will prevent the nozzle from moving normally, causing the motor to lose position and cause misalignment.

4.5 The voltage is unstable. When printing misalignment, observe whether it is a high-power electric appliance such as an air conditioner. When some of the electric appliances are turned off, the printing is misplaced. If there is, the printing power supply plus the voltage stabilizing device.

4.6 If all of the above are normal, you can slow down the printing speed and try again.

4.7 Manually move the XY axis to check the XY axis operation

4.8 Problem of motherboard. The above problems can not solve the misplacement, and the most common is to print any model with the same height misalignment, considering the motherboard problem

5. The nozzle does not come out, it is not necessarily the problem of nozzle clogging. If the maintenance is done in a normal position, the consumables used are relatively stable, and the plug is usually rarely blocked. It is very likely that some of the following factors may cause the wire to be fed normally. So users can try the following:

5.1 Loading the extrusion gear card, the load is not smooth

5.2 Whether the loading is normal (eg: the tray is stuck)

5.3 Disassemble the extrusion gear, clean the gear, and check the degree of gear wear.

5.4 The PLA print nozzle temperature is 190–220, and the ABS print nozzle temperature is 210–230. The printing temperature required for the consumables fluctuates. If the wire is not smooth, you can try to increase the printing temperature (such as 200 to 205 or 210 printing) and try to increase the temperature by 5–10 degrees.

6. What parts of the 3D printer should be routinely maintained?

First, before starting the 3D printer printing every day, you should carefully check whether the nozzle is blocked or damaged, whether the connection lines of each part are normal, whether the motor bearings and guide rails are short of oil, and whether the platform is calibrated. If there is any retentate in the nozzle, it should be cleaned up immediately. If the part is damaged or aged, it should be replaced in time. Regularly add lubricating oil to the moving parts, and the nut should be tightened if it is loose.

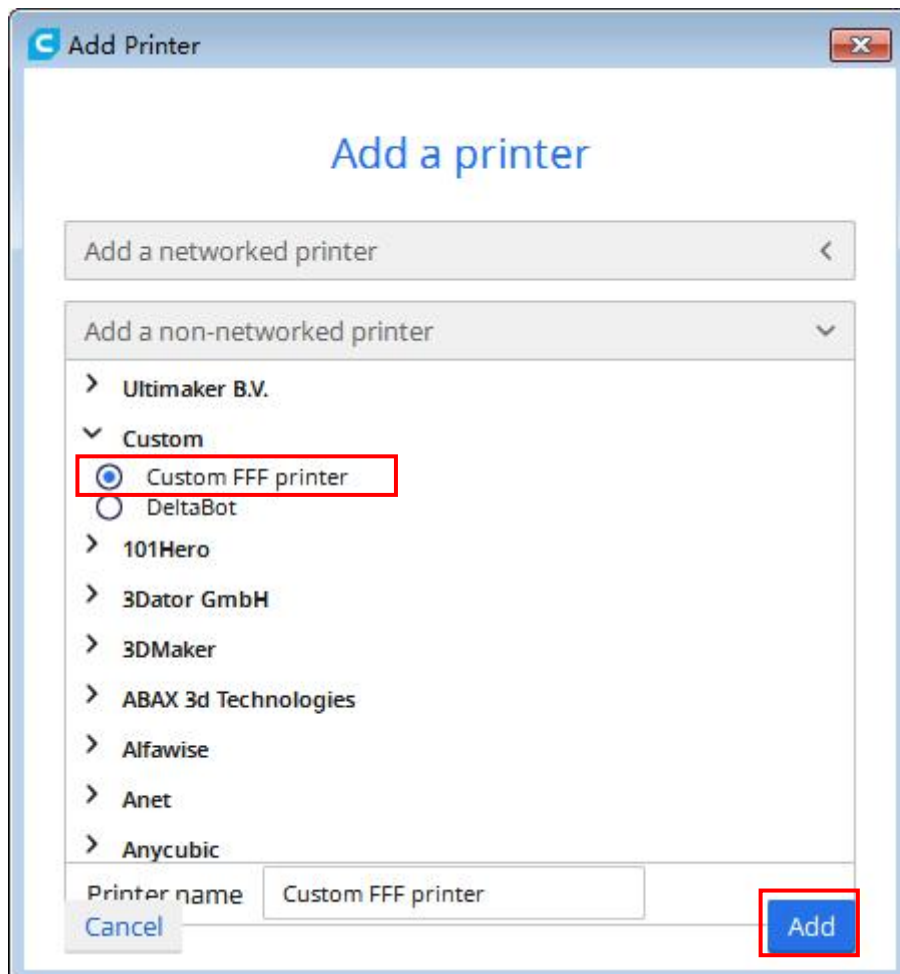
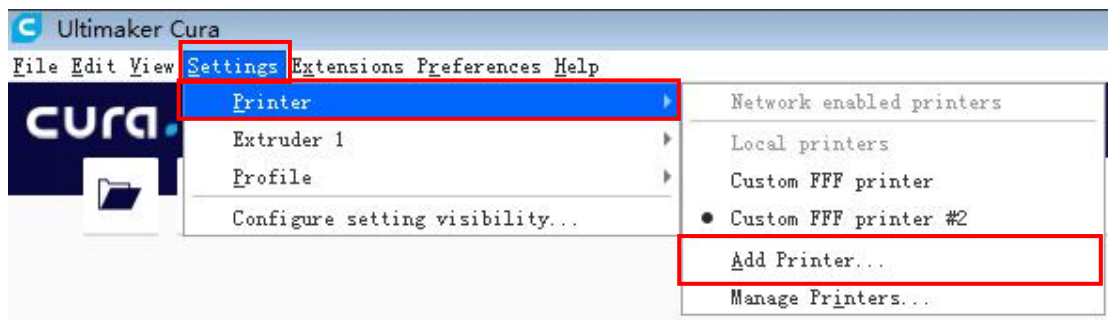
Secondly, during the printing process of the 3D printer, the parameter settings should not exceed the limit of the device. Otherwise, the qualified product cannot be printed. If the temperature is too high or the load is too large, the device may be damaged. There is also a place where something is wrong during the printing process. If necessary, stop the machine. Do not let the device continue to work if you want to reprint because of the downtime.

Finally, clean the work after printing is complete. The dirt on the nozzles, platforms, guide rails, motors, fans, etc. of the 3D printer should be cleaned up. Do not accumulate for a long time and cause the last bad cleaning.

Annex: It is recommended to use our MakerPi's slicing software. If you use any other software to cause machine damage, and the consequences will be borne by yourself.

Please refer to change parameters and commands as follows, if you use others' software settings.

- Model setting



- Parameter setting

