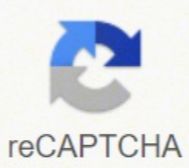




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Z Axis Stepper Motor 3. Position: Home All. Returns Extruder and bed to home position using stop switches • Home X / Y / Z. Returns specific axis to home position using stop switches • ... Carefully remove the cable tie that holds the Extruder in place Insert the Heated Print Bed lengthways between the legs of the Extruder Tower and align the bolt holes on each side. Never reach inside of the WANHAO 3D Printer while it is in operation, and allow time for the printer to cool down after operation. To gain access to this section you go to Expert > Open Expert Settings or on your keyboard press Control + E. As a general rule of thumb, the slower you go the better looking print you will get. Please visit www.wanhao3dprinter.com for details of filament types and parameters. Installation 1.5.3 Default Configuration The following settings show the default configuration values of the WANHAO 3D Printer. Creating a GCODE File using Cura 6.1 Installing Cura 6.2 Adding your WANHAO 3D Printer to Cura 6.3 Loading a 3D Design into Cura 6.4 Viewing and Positioning your 3D Model in Cura 6.5 Quick Print Settings 6.5.1 Exporting your GCODE File... The WANHAO 3D Printer is compatible with a broad range of filament types and is capable of printing 3D models ranging from small and simple to complex objects with moving parts. Only use quality WANHAO filaments as using generic filaments may damage your 3D Printer, affect the print quality and may void your warranty. It is highly recommended to orient your object so that it minimizes or eliminates the need for support. Z Cable Track 6. The WANHAO 3D Printer uses a 0.4mm nozzle. These PLA Alternatives require advanced knowledge of the 3D Printer. Extruder Cooling Fan AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2... Using Cura 6.6.3 Plugins Tab Plugins are custom settings which will alter your print at specific points. The slicing engine uses this value combined with your other settings to determine how quickly to feed filament into your Extruder. For our full range of filaments visit id.aliexpress.com/store/120824... 1.2 From 3D Design to Printed 3D Object: 1.3 Good 3D Printing Practices Installation 1.4 Unboxing and Assembly... Filament Cooling Fan Assembly 3. Print Bed Frame 8. 3D Printer and potentially void your warranty. Page 3 If you experience any issues with this product, or it's performance is not what you had expected, please contact us at WANHAO before returning the item to the store. The grid will be a checkerboard pattern in the X and Y direction. What types of filament can my 3D Printer Print? Product Overview Control Box 1. Introduction 1.3 Good 3D Printing Practices Please refer to these steps during every print to ensure the best quality. If at any time you feel your repair is being handled unsatisfactorily, you may escalate your complaint. Other filaments are available for purchase at id.aliexpress.com/store/120824 Diameter Ensure this is always set to match the filament diameter. A GCODE file provides the essential temperature settings and movement information for your WANHAO 3D Printer. Page 37 Using Cura Enable Retraction Retraction tells your printer to pull filament out of the Extruder upon travel moves. Once you click the rotate button, three circles will surround your model. Navigate to and select Position then select Home All. Retraction Retraction pulls filament out of your nozzle when it is not extruding to prevent your print head from dripping on your object. A number of 'Slicer' software exists, which convert a 3D model file into a series of 3D printable layers. Installation 1.5 Control Panel 1.5.1 Main Display Extruder Temperature: (Current °C / Set °C) Print Bed Temperature: (Current °C / Set °C) Extruder Co-ordinates: X, Y, and Z (mm) Mul: Displays current speed multiplier. Your WANHAO 3D Printer auto levelling system could be affected if you change this from the standard profiles. Nozzle Diameter: 0.4mm Print Speed: 10mm/s - 70mm/s Travel Speed: 10mm/s - 70mm/s Supported Print Materials: WANHAO Branded PLA, ABS, PVA, HIPS, Wood, Flex, Conductive Temperature Ambient Operating Temperature: 15°C - 30°C Operational Extruder Temperature: 170°C - 240°C Operational Print Bed Temperature: 30°C - 70°C... With the printer initialised, press the Navigation Dial to enter the menu system Rotate the Dial until Position is highlighted, then press the Dial to select Rotate the Dial until Z. Please visit www.wanhao3dprinter.com/Video/i3 video/wanhao i3 unboxing 10.2 Connectivity Problems My 3D Printer isn't turning on Check that you have correctly inserted the power cable into the rear of the Control Box, the power cord is plugged into the mains outlet and that the Control Box power switch is on. This is most commonly used to prime the Extruder. This can be helpful for spotting issues before the print even starts. Y Axis Stepper Motor 2. X Belt Drive 6. Setup 3. Micro SD Port 5. Filament Spool Holder 2. If having any troubles when using the 3D printer, please refer to the troubleshooting guide below, or call customer support on 86-571-23290996 You can also visit Please visit www.wanhao3dprinter.com/Video/i3 video/wanhao i3 unboxing for support videos and advanced tutorials. Sanding will reduce these 'step' marks in the model. Page 41 Using Cura Outer Shell Speed (mm/s) This will be the outermost surface of the model. This is the most important setting, as it controls the speed of your print head on the visible layers. In order to prevent missed filament at the beginning of a print, we recommend you leave this setting on. Check that the motor is turning (using position menu). Servicing 7.3 Routine Component Check Motor Connectors Loose motor connections could cause a 3D print to fail. Tower Frame 4. Extruder Spring Lever 7. Normal This is the standard view and shows the solid outer surfaces of the model. A larger gap will make your part easier to remove, but will make the bottom of your print look worse. Surface Layers This will determine the number of layers that create the 'platform' of your raft. Product Overview Printer Front View 1. Navigate to, and select Quick Settings > Preheat PLA or Preheat ABS depending on the material. Z Rod AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2 support@wanhao3dprinter.com... This defines the number of vertical walls that comprise the outside of your model. Cura is a free Open Source slicer software released on the AGPLv3 license. X Rail 5. More plugins and information can be found here: CuraPlugin To activate one of these highlight the desired plugin and click the drop-down arrow directly below the Plugins box. Before Printing Ensure your GCODE file is correctly setup, filament diameter is set to 1.75mm and correct temperature settings for the material you are using (refer to table 3.1, page 27) Check all cables and connectors are connected Check that Heated Print Bed is level and approximately 0.1mm from the nozzle Check that Heated Print Bed is clean and dust free and nozzle does not have excess material... 9.1 Printing Problems Clicking sound from one of the stepper motors One of your stepper motors may not be connected properly. Axis Lubrication Regular lubrication of the X and Y Axis rods is important for the longevity and smooth running of your printer. Setup 2. This will usually occur when an object has an angle in relation to the Heated Print Bede between 0 to 45 degrees. You must have a support type in the 'Basic Settings; in order for these support settings to have an effect. This allows for precise positioning and/or speed control .stl A common file format for 3D Designs/Models USB Cable This cable allows communication between the WANHAO 3D Printer and a computer, using the USB port of the computer AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2 support@wanhao3dprinter.com... It is likely that we can resolve any problems for you via phone or email. Your WANHAO 3D Printer is equipped with a 0.4 mm nozzle. What you print is limited only by your imagination. Quick Guide Construct and Connect Place the Control Box, Extruder Tower and Heated Print Bed on a clean, level work space. Extruder Driving Motor 9. Servicing your 3D Printer 7.1 Replacing the Print Mat The WANHAO 3D Printer includes 2 x Print Mats. Contents Warranty Details Safety Instructions Parts List Technical Specifications Product Overview Printer Front View Printer Rear View Print Bed Control Box Quick Guide Construct and Connect Levelling the Bed Printing a File Introduction 1.1 What is 3D Printing? Product Overview Printer Rear View 1. RETRACTION Speed (mm/s) Page 40 This will control how thick your first printed layer height is printed onto the Heated Print Bed. Finishing 8.3 Sanding Though Fused Filament Fabrication (FFF) is capable of producing high quality objects straight out of the machine, the layer lines will be visible. Filament The WANHAO 3D Printer uses high quality PLA and ABS filaments. You've successfully setup your WANHAO 3D Printer AFTER SALES SUPPORT... Adjust at your own risk. Page 47 Using Cura Airgap This will define the distance between your raft and your print. Printing Mat 5. Line Count This will define the number of loops the Skirt creates around the outside of your object. Travel moves are when your print head moves from one area of the print, to another without laying down filament. Parts List 1 x WANHAO 3D Printer 1 x USB Cable 2 x Cable Ties (Control Box, Extruder Tower, 1 x 4GB MicroSD Card 1 x 10m PLA Filament Heated Print Bed) 1 x Scraper 2 x Print Bed Mats... Page 33 Using Cura Rotate The Rotate button will give you the ability to orient your model in along all three axes. Heated Print Bed Assembly 7. Please be assured though, refurbished parts or replacements are only used where they meet WANHAO's stringent quality specifications. Page 17 Quick Guide You can now select one of our pre-loaded files below by navigating to, and selecting the file name: Unicorn M3 Thumbscrew Vase WANHAOBox File Name: 26x34x15mm 50x50x100mm 47x19x51mm 19x19x44mm Size (LxWxH): 100% Infill: 0.2mm 0.1mm 0.1mm 0.2mm Resolution: 50min 6min... Levelling the Heated Print Bed It is important to ensure the Heated Print Bed is level and set to approximately 0.1mm distance prior to printing. Default value is 100% Buf: Displays current GCODE steps in the buffer Message Display: Printer Ready: Printer is initiated and awaiting input • ... Y Stop (Micro Switch) 4. Page 34 Using Cura View Mode This mode allows you to view your model in a variety of different ways. Page 45 Using Cura Support You define how your support material is generated here. NOTE: Only use WANHAO Filament with your 3D Printer, using other filaments may damage your 3D Printer and may void your warranty. Power Switch AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2 support@wanhao3dprinter.com... Servicing 7. If motor turns but belt does not, you will need to tighten the gear motor gear nut. Levelling Wing Nut 6. Quick Guide Printing a File IMPORTANT NOTE. Levelling the bed is an extremely important step and if it is not done correctly every time, your prints will fail or be of poor quality Turn on the 3D Printer, using the switch on the back of the Control Box. FFF works on an 'additive'... Page 44 Using Cura Skirt Skirt creates a line around the outside of your object. CAUTION: The WANHAO 3D Printer generates high temperatures and includes moving parts that can cause injury. Z Drive Screw 8. Page 38 Using Cura SUPPORT Support Type Some models will require support material in order to print properly. Appendix References Some of the 3D Models used in this manual and other included materials were sourced from the below: AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2 support@wanhao3dprinter.com... The two that come pre-loaded with Cura are Tweak at Z, and Pause at Height. Introduction 1.1 What is 3D Printing? We've set these to provide optimal quality for your 3D printed models, however, if you wish to adjust these settings, we recommend this to be done by only highly experienced users, as print quality and 3D Printer durability may be affected. We recommend keeping this set to multiples of your nozzle width. Using Cura 6.2 Install CURA WANHAO edition onto your computer Double click the file: CURA WANHAO_15.04.EXE Follow the instruction and click install and next. Ensure that safety goggles and a mask are worn for protection Starting with 100 grit sandpaper, carefully sand your 3D object using small, circular motions NOTE: PLA is less resistant to high temperatures caused by sanding. Navigate to and select SD Card > Mount Card > Print File Navigate to your desired GCODE File, then press the Dial to commence printing Your WANHAO 3D Printer will now heat up the Extruder and Heated Print Bed before printing your 3D object NOTE: If selecting 'Print File'... Y Belt Drive 3. The WANHAO 3D Printer includes a 10 metre sample of PLA to be used in your first print. Z Stop (Micro Switch) 2. Using Cura 6.6.5 Expert Settings Expert settings will give you more specific options for your retraction, skirt, active cooling, infill, support, brim, raft, and special settings. This section defines how the brim is formed when brim is activated in 'Basic Settings'. Additional Print Mats are available for purchase from id.aliexpress.com/store/120824 Remove the current Print Mat by slowly peeling from one corner... Navigation Dial 4. Fused Filament Fabrication (FFF) is one of the most common technologies used by 3D Printers to achieve this. Installation 1.4 Unboxing and Assembly Your WANHAO 3D Printer is packed tightly and carefully -- take your time unpacking it. If you have a wide line spacing, you may want to increase this number to ensure a solid platform. Brim Line Amount This will determine the distance the brim will cover around the outside of your object. Setup 3.3 Removing Filament: With the printer initialised, press the Navigation Dial to enter the menu system. Material Selection Choose your desired filament. Power Socket 2. Overhang Overhang mode shows where your model may need support material. Page 22 3D Printer, using the switch on the back of the Control Box Wait for the printer to initialise, with 'Printer Ready' shown at the bottom of the LCD. It's a good habit to routinely check for any damage to the connectors or the black cables. X, Y, Z axis stop micro switch prior to the next step Using the switch on the back of the Control Box, turn on the WANHAO 3D Printer. This is only one layer thick, and can be easily removed post-print. Having a larger initial layer height will help prevent your part from popping off the plate. Once initialised, press the Navigation Dial to enter the menu system. The red circle will allow you to rotate around the Z axis. The benefits conferred by this warranty are in addition to all rights and remedies in respect of the product that the consumer has under the China laws. 3D Printing is a process whereby a real object is created from a 3D Design. To view a step by step video of the Unboxing and Assembly, visit www.wanhao3dprinter.com/Video/i3 video/wanhao i3 unboxing Place the Control Box, Extruder Tower and Heated Print Bed on a clean, level work space. Page 1 3D Printer I3 V2 Model : Duplicator I3 V2 I N S T R U C T I O N M A N U A L... Finishing Techniques 8.1 Useful Tools/Equipment • Safety Goggles • Mask • Long-nose Pliers • Wire cutters • Sandpaper (100,200,300,400,500,600 Grit) • Medium, fine and extra fine sanding sponges • Acrylic based primer spray paint • Acrylic based spray paint (colour of your choice) • ... Page 19 3D models ranging from simple to complex. The WANHAO 3D Printer accepts various types of filaments including PLA, ABS, PVA, HIPS and specialty filaments such as wood, flexible, luminous and conductive. AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2 support@wanhao3dprinter.com... Nozzle Size (mm) This defines your nozzle size. Once initiated, press the Dial to enter the menu system. Structure Type You can choose between a 'Grid' or a 'Line' pattern for your support material. Page 46 Using Cura Brim Brim circles the base of the print while making contact, helping adhere the print to the Heated Print Bed. Page 55 DC motors that move in discrete steps. 6.3 Loading a 3D Design into Cura Clear the platform using File >... In case you purchase from WANHAO distributor, your warranty shall be covered by distributor's Warranty and honored by WANHAO distributor too. Extruder 7. Page 24 Installation Print File: If an SD Card is mounted, files can be quickly accessed here. X Cable Track 4. X Stop (Micro Switch) 8. The software has already embedded all the basic settings for your Wanhao i3. Finishing 8. Mini USB Port 6. Product Overview Printer Bed 1. Extra filament including multiple colours and types are available from the online store at id.aliexpress.com/store/120824... LCD Display 3. Wait for the 3D printer to automatically return to the home screen, after approximately 15-30 seconds. Page 7 Using Cura 6. X Axis Stepper Motor 5. We recommend keeping this on for all filament types, and adjusting the retraction length and speed for the specific filament. Y Rail AFTER SALES SUPPORT 86-571-23290996 Model : Duplicator I3 V2 support@wanhao3dprinter.com...

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