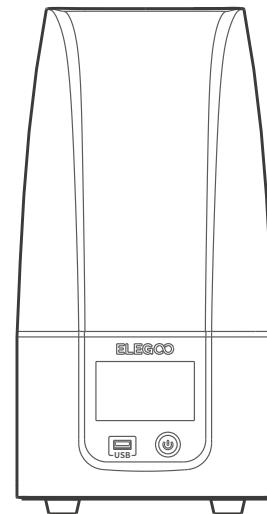


**ELEGOO**

# **Mars 4 Ultra**

## **3D Printer**

### **User Manual**



**Thank you for purchasing ELEGOO brand products.**

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After receiving the product, please confirm whether the equipment is intact and the accessories are complete. If there is any damage or missing, please timely contact us at [3dp@elegoo.com](mailto:3dp@elegoo.com). (To ensure the performance of each product, each product will undergo strict printing tests before leaving the factory. There may be some slight scratches when you receive the product, which is normal, please rest assured to use.)

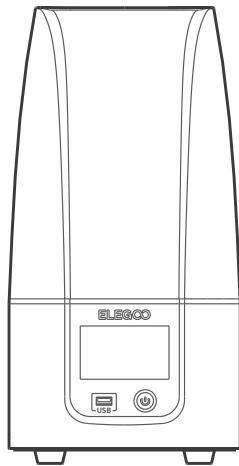
**ELEGOO**

## Notice:

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- Please keep the 3D printer and its accessories out of the reach of children.
- Please fill the resin tank no less than 1/3 of its volume, but do not exceed the MAX line position.
- Please place the printer in a dry environment and protect it from rain and moisture.
- If you run into an emergency during use, please turn off the power supply of the 3D printer first.
- Please use the printer indoors and avoid direct sunlight and a dusty environment.
- Please keep the original packaging box for 30 days for return/exchange (only ELEGOO original packaging boxes are accepted).
- Please use 95% (or higher) ethyl alcohol or isopropyl alcohol to wash your model unless you are using water washable resin.
- If the printing fails, you need to clean the excess cured resin in the resin tank and change the resin, otherwise, it may cause damage to your printer.
- When operating the 3D printer, please wear a mask and gloves to avoid direct skin contact with the photopolymer resin.
- When you use the 3D printer for the first time, please level the build platform according to the leveling tutorial before printing.
- If the release film in the resin tank is whitened, scratched, or has no elasticity, the printing failure rate is high, please replace the release film in time.
- If you have any problems with the printer, please contact us at [3dp@elegoo.com](mailto:3dp@elegoo.com). Please do not disassemble or modify ELEGOO 3D printers by yourself, otherwise, the warranty will expire.

## Packing List



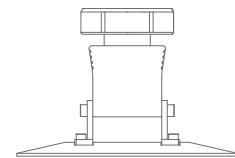
Mars 4 Ultra 3D Printer



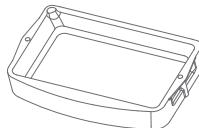
Wifi Antenna



USB Air Purifier



Build Platform



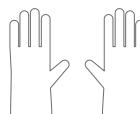
Resin Tank



U Disk



Mask



Gloves



Funnel



Backup Screws



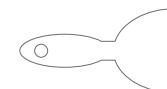
User Manual



Adapter

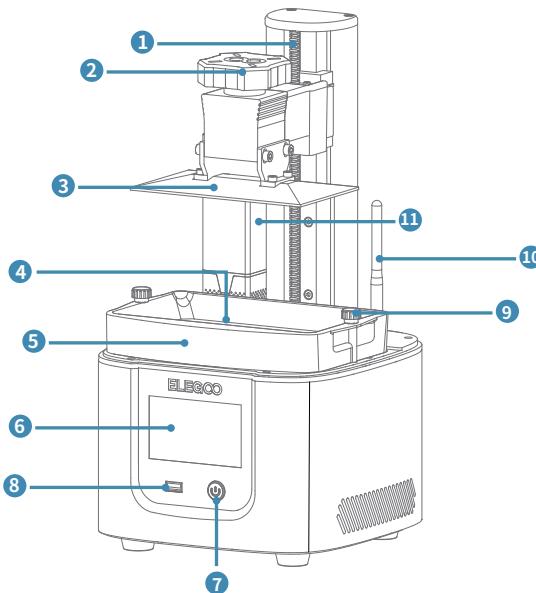


Tool Kit



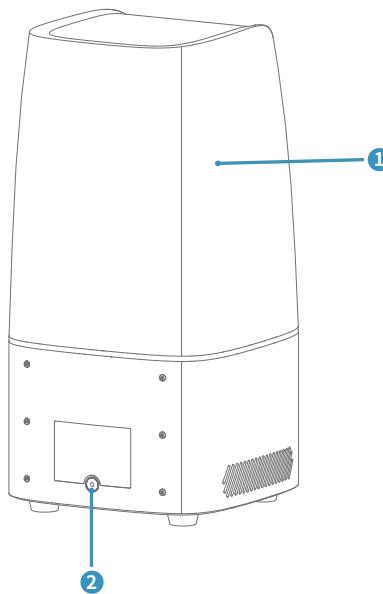
Scraper

## Printer Introduction



- ① Z Axis
- ② Screw Knob
- ③ Build Plate
- ④ LCD Display Screen
- ⑤ Resin Tank
- ⑥ Touch Screen
- ⑦ Switch
- ⑧ USB Interface
- ⑨ Screw Knob
- ⑩ WiFi Antenna
- ⑪ USB Air Purifier

## Printer Introduction



① Anti-UV Cover

② DC Socket

## 3D Printer Tech Specs

System: EL3D-4.0

Operation: 4.0-inch Capacitive Touch Screen

Slicer Software: Chitu Box & Voxeldance Tango

Connectivity: USB Interface & WiFi

### Printing Parameter

Technology: MSLA Stereolithography

Light Source: COB + Fresnel Collimating Lens (wavelength 405nm)

XY Resolution: 18\*18um (8520\*4320)

Z-axis Accuracy: 0.02mm

Layer Thickness: 0.01-0.2mm

Printing Speed: MAX 70mm/H

Power Requirements: 100-240V 50/60 Hz 24V 3A

### Printing Specification

Dimension: 227mm(L)\*227mm(W)\*443.5mm(H)

Build Volume: 153.36mm (L)\*77.76mm (W)\*165mm (H)

Package Size: 605mm(L)\*270mm(W)\*285mm(H)

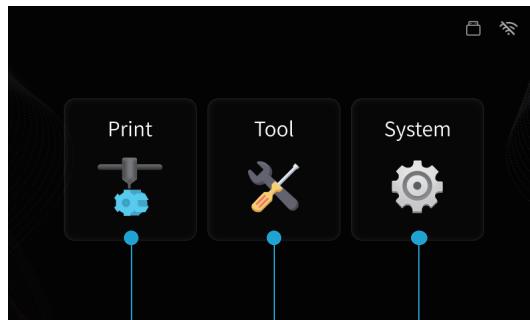
Gross Weight: 8.3KG

Net Weight: 6.5KG

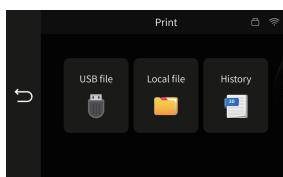
### Hardware Specification

## Operation Screen Introduction

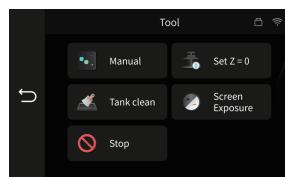
### Main Interface



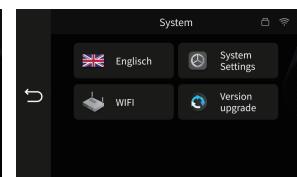
Print List



Tool List



System List



## Operation Screen Introduction

### Print List

**USB Files**

USB file list: ROOK.goo

U disk status icon: goo

Back to the main menu

**History Record**

History: ROOK.goo, ROOK.goo, ROOK.goo

Print status: Completed!, Error

History print time: 00:00:00, 00:00:00, 00:00:00

Cancel, Completed!, Error, 00:00:00, Cancel

Click to enter preview, and long press to enter edit mode.

Print status

History print time

**USB Files**

USB file list: ROOK.goo

U disk status icon: goo

Select all, Copy, Deleted, Cancel

Copy the model to the local file

Insert U disk status icon

Click to enter model preview, and long press to enter edit mode

**Model Preview**

File information: ROOK.goo

USB file:USB file

Model preview: ROOK.goo

Deleted, Copy

Delete the current model

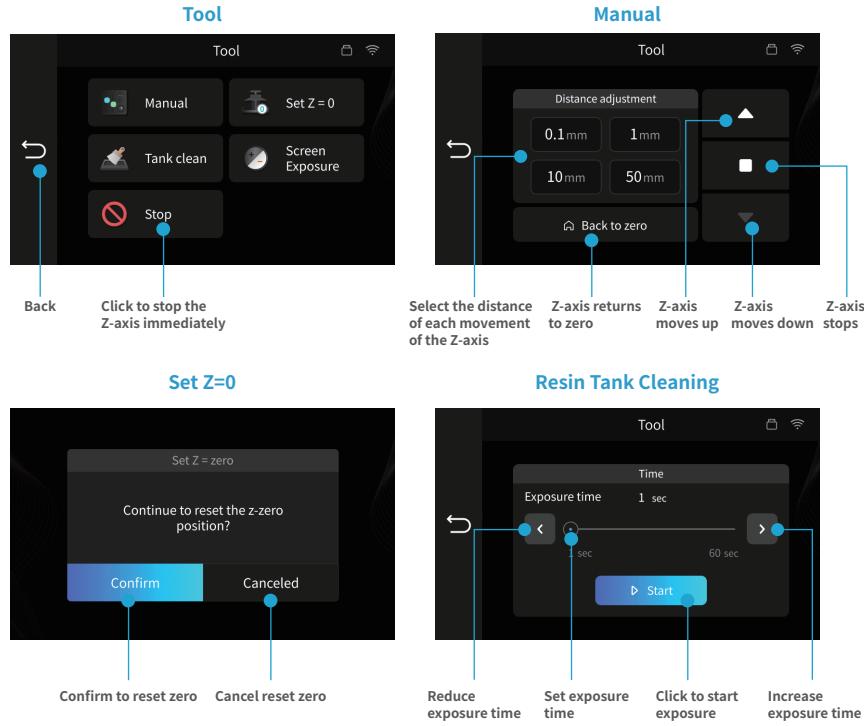
Copy the model to the local file

Print

Click to start printing

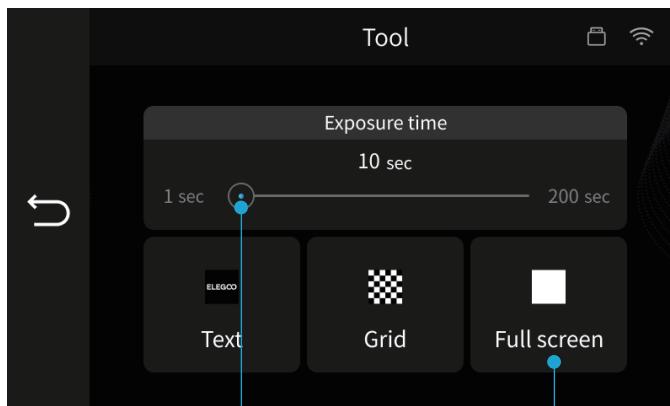
## Operation Screen Introduction

### Tool List



## Operation Screen Introduction

### Tool List

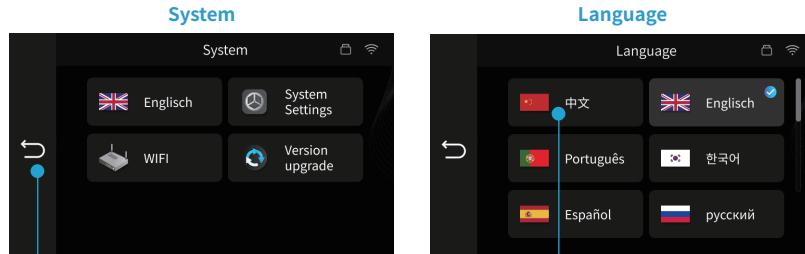


Set exposure time

Select exposure type

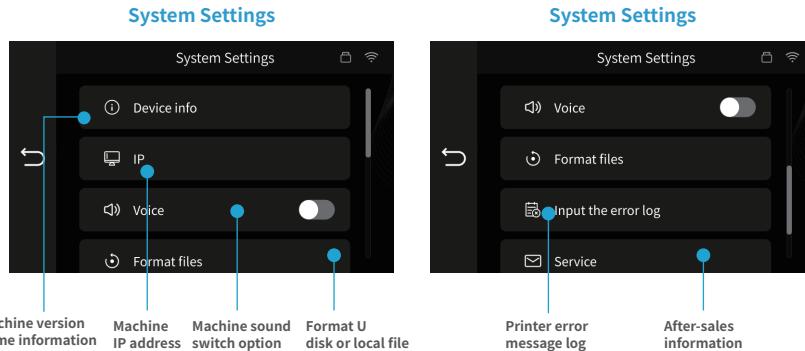
## Operation Screen Introduction

### System List



Back

Click to select a language



Machine version  
name information

Machine IP address

Machine sound  
switch option

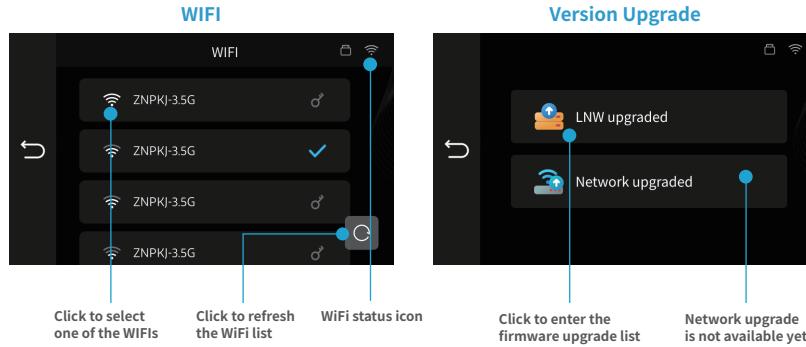
Format U  
disk or local file

Printer error  
message log

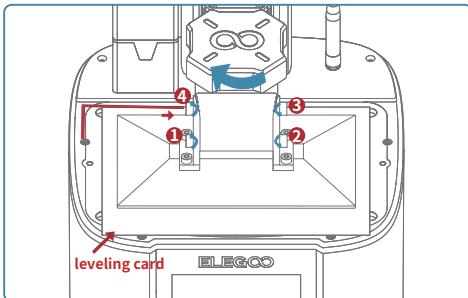
After-sales  
information

## Operation Screen Introduction

### System List

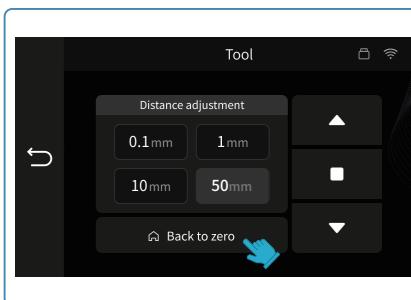


## Leveling

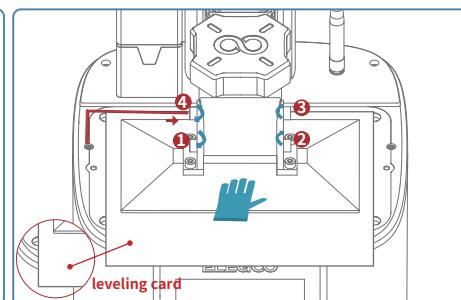


(Picture 1)

1. Remove the resin tank, lock the screw knob (5) of the build plate, and then loosen the 4 fixing screws (1 3 2 4) of the build plate until the build plate can move freely. (See Picture 1)



(Picture2)

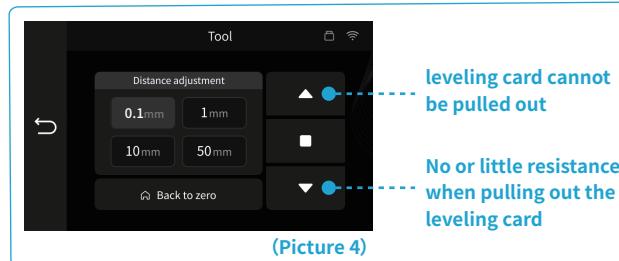


(Picture 3)

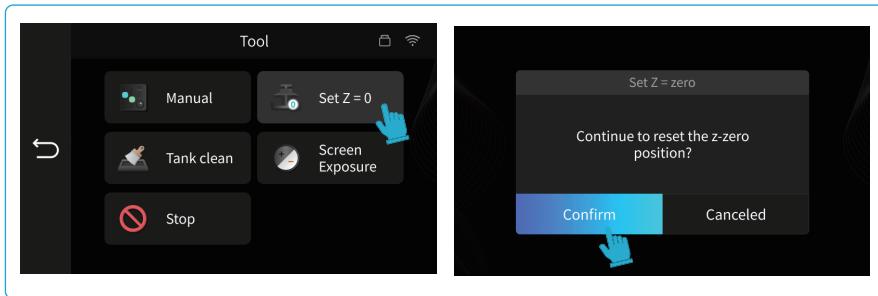
2. Place a leveling card between the build plate and the LCD screen, then click "Move Z axis to zero" (See Picture 2). After the printer stops moving, press the top of the build plate with one hand, and lock the 4 fixing screws (1 3 2 4) with the other hand. (See Picture 3)

## Leveling

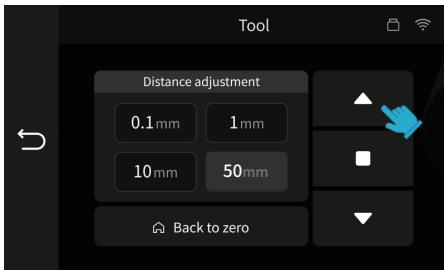
3. Pull the leveling card. If you find there is a slight resistance during this process, you can go directly to step 5. (Note: If there is no resistance when pulling out the leveling card, please click the Z-axis "down" button (in steps of 0.1mm) until there is a slight resistance to pull the leveling card. If there is too much resistance or the leveling card cannot move, please click the Z-axis "up" button (in steps of 0.1mm) until there is slight resistance to pull the leveling card.) (See Picture 4)



4. After completing the above operations, back to the previous menu, and click "Set Z=0", then a confirmation pop-up window will appear in the interface, click "Confirm" to complete the setting. At this time, the current Z-axis position is reset to the new initial height of the first printing layer. (See Picture 5)

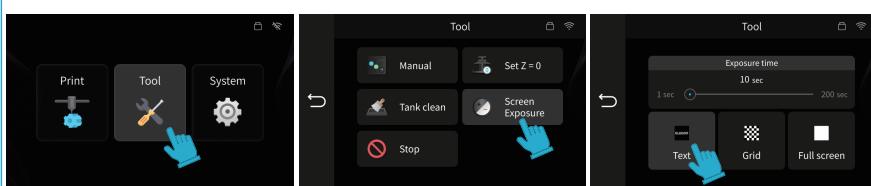


## Leveling



(Picture 6)

5.Click back to the "Manual" page, and click the Z-axis "up" button to raise the Z-axis by a certain distance. (about 100mm)  
(See Picture 6)



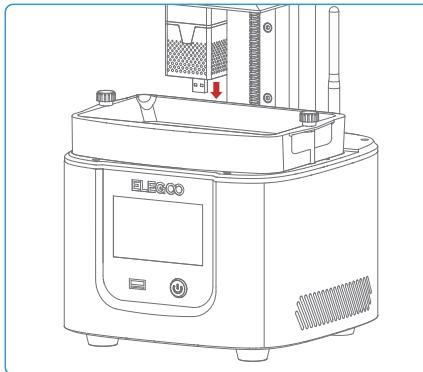
(Picture 7)

6.Take away the leveling card, and click the "Tool" - "Exposure" - "Text" buttons to test the LCD screen and LED light source. If the LCD can display "ELEGOO TECHNOLOGY www.elegoo.com", then the 3D printer works perfectly. At this time, the leveling is completed, install the resin tank and ready for printing. (See Picture 7)

## Test Printing

### 1. Model Printing

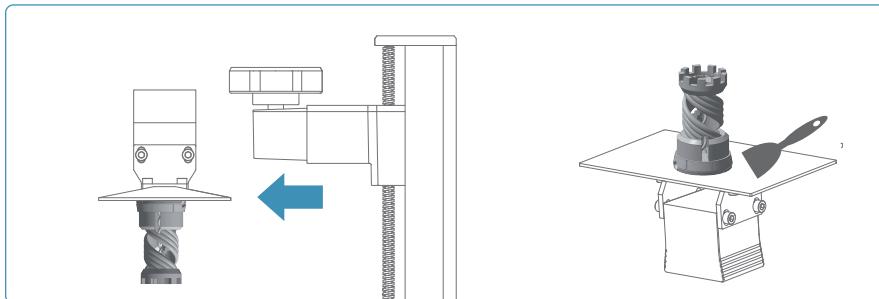
Plug the USB air purifier into the USB port (See Picture 8), then slowly add resin to the resin tank (do not exceed the MAX line height). Cover the printer and then insert the U disk into the printer and select the pre-sliced test model for printing.



(Picture 8)

### 2. Model Processing

After the printing is completed, wait until the resin on the build plate stops dripping, then loosen the screw knob of the build plate to remove it, and remove the model with a scraper. You can use ELEGOO's cleaning and curing machine to post-process the model. (See Picture 9)



(Picture 9)

# Software Installation and Setup

The printer can install and use Chitu Box and Voxeldance Tango slicing software in the USB flash drive, here we take Chitu Box as an example.

## 1. Install Chitu Box

Select the right version of slicing software on the USB flash drive and install it on your computer.

## 2. How to Use Chitu Box

After the installation is complete, run the Chitu Box software. Click "File-Open File", then open your 3D model file (.stl type). By left-clicking on the model and using the options on the left menu, you can control and change the viewing angle, size, and position of the model.

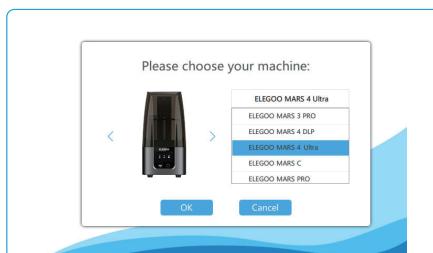
### Other Operations:

- 1) Long press the left button and drag the model to the position you want.
- 2) Scroll the mouse wheel to zoom in or zoom out the model.
- 3) Long press the right mouse button to view the different perspectives of the model.

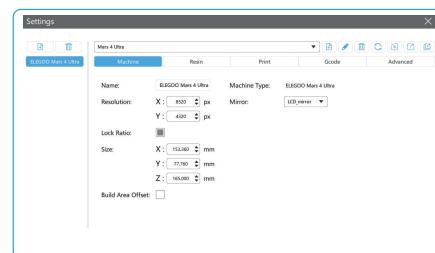
## 3. Chitu Box Setting

### 3.1 Machine Configuration Parameters

Click "Parameter Settings" and select ELEGOO Mars 4 Ultra as your default printer. (See Picture 10)



(Picture 10)



(Picture 11)

### 3.2 Build Volume

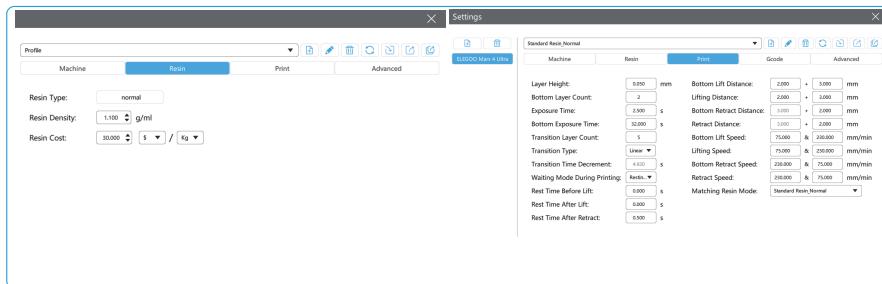
You don't need to change the default parameters (See Picture 11), and X indicates the maximum print size in the X-axis direction, and so on.

## Software Installation and Setup

### 3.3 Resin Parameter (See Picture 12)

**Resin Density:** 1.1g/ml

**Resin Cost:** You can input the real price of the resin you purchased, and the slicing software can calculate the resin costs for each model you print.



(Picture 12)

### 3.4 Parameters (See Picture 12)

**Layer Height:** The thickness of each printed layer, the recommended height is 0.05mm, but you can set it from 0.01-0.2mm. The higher thickness you set, the longer the exposure time will be required for each layer.

**Bottom Layer Count:** The set number of initial printing layers. If the number of bottom layers is n, the exposure time of the first n layers is the exposure time of the bottom layer. The default setting is 2.

**Exposure Time:** The exposure time for normal printing layers. The default exposure time is 2.5s, the thicker the print layer setting, the longer the time required.

**Bottom Exposure Time:** The setting of bottom layer exposure time. Properly increasing the bottom layer exposure time can help to increase the bonding strength between the printed model and the printing platform, and the default setting is 32s.

**Transition Layers:** The number of transition layers after the bottom layers for a tighter bonding between layers. Except for the exposure time, other parameters of the transition layer are the same as the normal layer.

## Software Installation and Setup

**Transition Type:** Set the transition type of exposure time when transitioning from bottom layers to normal layers, the default is linear transition.

**Wait After Cure:** The time difference between the end of the exposure and the start of the build platform moving away from the exposure surface, the default setting is 0 seconds.

**The Quiescent Time After Lifting:** The time difference between the build platform starts to standstill and starts to return after the build platform lift, the default setting is 0 seconds.

**The Quiescent Time After Retract:** After the build platform moves to the printing surface, the time difference between the build platform starting to stationary and starting to exposure, the default setting is 0.5 seconds.

**Bottom Lifting Distance:** During the bottom printing process, the distance that the build platform moves away from the printing surface each time, the default setting is 2+3mm.

**Lifting Distance:** In the normal layer printing process, the distance that the build platform moves away from the printing surface each time, the default setting is 2+3mm.

**Bottom Retract Distance:** During the bottom printing process, the retract distance of the build platform, please do not change if not necessary.

**Retract Distance:** In the normal layer printing process, the retract distance of the build platform, please do not change if not necessary.

**Bottom Lift Speed:** During the bottom printing process, the moving speed of the build platform away from the printing surface each time, the default setting is 75+230mm/min.

**Lifting Speed:** In the normal layer printing process, the moving speed of the build platform away from the printing surface each time; the default setting is 75+230mm/min.

**Bottom Retract Speed:** During the bottom printing process, the moving speed of the build platform is close to the printing surface; the default setting is 230+75mm/min.

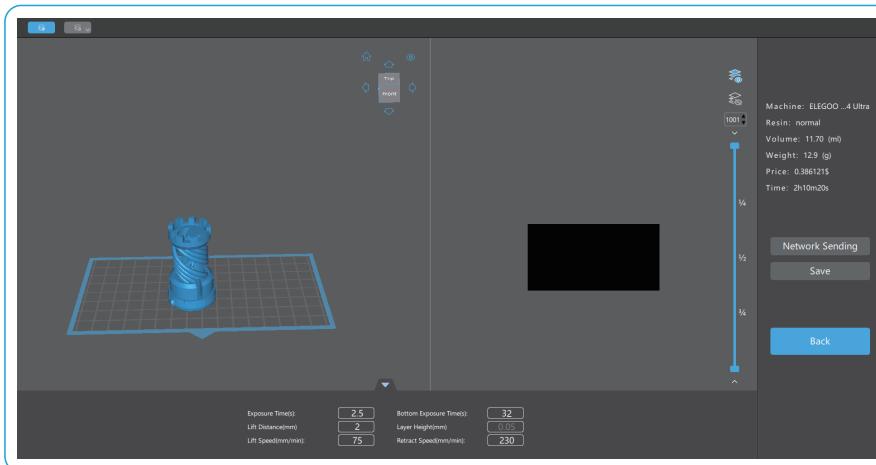
**Retract Speed:** In the normal layer printing, the moving speed of the build platform is close to the printing surface; the default setting is 230+75mm/min.

**Matching resin mode:** The machine is preset with three slice parameter modes with different speeds for resin printing. According to the resin and printing speed requirements, choose appropriate printing modes. The "Standard Resin\_Normal Speed" mode is selected by default.

## Software Installation and Setup

### 4. Save the Model

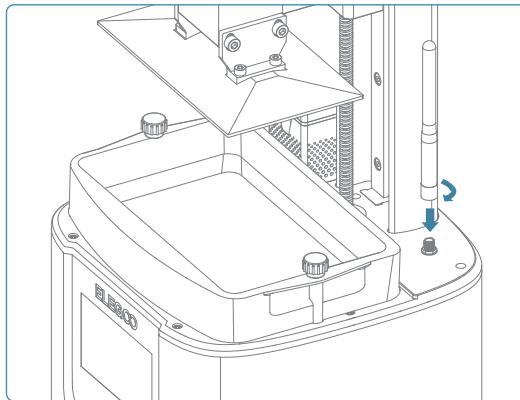
After setting up all the parameters, click "Slice", and once it's done, click "Save" to export the sliced file and copy it to U Disk; then insert the U disk into your printer, and start printing. (See Picture 13)



(Picture 13)

## WiFi Module Instructions

1. First, make sure the WiFi antenna is connected. Connect the WiFi antenna by screwing it clockwise to the right port of the machine to connect to the network. (See Picture 14)



(Picture 14)

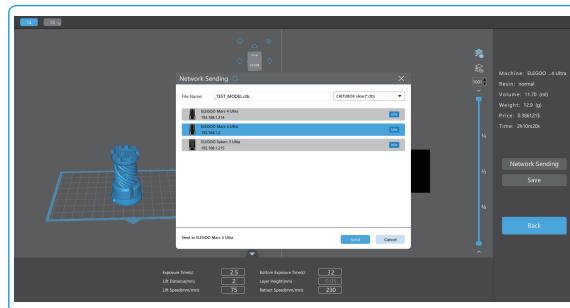
Once the WiFi antenna is installed, click "Settings" - "WiFi" to enable WiFi connection, the machine will automatically search for available networks. Select the WiFi you want to connect to, enter the password, and click "Confirm" to connect to WiFi. (See Picture 15)



(Picture 15)

## WiFi Module Instructions

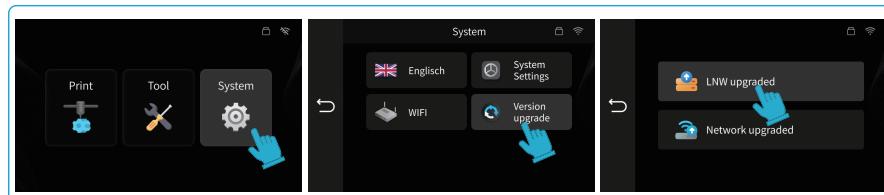
2. Then make sure that the computer with the slicing software installed is connected to the same WiFi as the printer. After the model is sliced, click the "Network Sending" and the software will automatically search for the printer, select the printer by the printer name and IP address, click "Send" and the sliced file will be automatically transferred to the printer, and you can start printing once the transfer is completed. (See Picture 16)



(Picture 16)

### 3. Firmware Upgrade

(1) For the local upgrade, download the firmware file to the U disk in advance. After the printer is inserted into the U disk, click "System" and then click "Version Upgrade" to select "LNU Upgrade". The firmware version that can be upgraded will be displayed on the page. Click on the firmware to upgrade. (See Picture 17)



(2) Network upgrade is not available yet, please stay tuned.

(Picture 17)

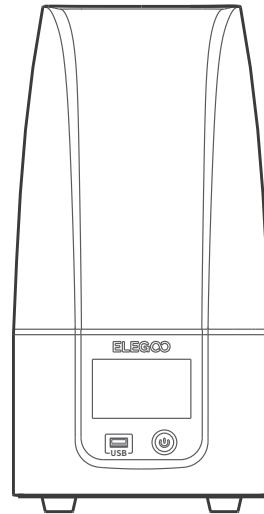
## Machine Maintenance

- Please do not use sharp or pointy tools to scrape the resin tank to avoid damaging the release liner film.
- Please clean up the resin tank before changing the resin to another color.
- Before and after printing, clean the build plate with paper towels or alcohol to ensure that there are no bumps or burrs on the build plate.
- Before each printing, daily check the exterior of the machine and all mechanical parts for any obvious damage, defects, or abnormalities.
- Try to keep the printing environment at 25-30 degrees Celsius when printing, and ventilate the printing room as much as possible to facilitate heat dissipation of the machine and resin odor volatilization.
- If the Z-axis keeps making friction noise, please add some lubricant to the lead screw. Please check and apply lubricant grease at least every 2-3 months, and increase the frequency of application as the printing frequency increases.
- If you don't use the printer in the next 48 hours, please pour the remaining resin from the resin tank back into the resin bottle and seal it well. If there is any residue, please use a filter to filter it out.
- Check the condition of the release film before each printing, and observe whether the release film is loose, whether there are scratches or severe whitening on the surface, and if so, replace it in time. The release film is a vulnerable part, please replace it at least once every 1-2 months, and increase the replacement frequency as the printing frequency increases.
- Please be careful when removing the printing platform to prevent damaging the LCD screen. The service life of the screen is about 2000+ hours and will decrease with increasing printing frequency. Do a good job of daily screen cleaning, and unplug the machine in time after printing. If there is a screen exposure problem or service life has seriously affected the print quality, please replace the screen in time.

## **Warranty Statement**

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1. From the date of purchase, ELEGOO printer is entitled to a 1-year free warranty service, except for consumables of the LCD screen and the release film.
2. The LCD screen enjoys a 6-month free warranty service.
3. The free warranty does NOT include problems caused by self-disassembly and improper use, and wear and tear of the machine housing, etc.



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