User manual of

# **ELEGOO 3D slicing software**

#### **INTRODUCTION**

Dear Friends,

Thank you very much for purchasing our 3D Printer. For optimum performance, safety and convenience, please read the instruction before DIY.

#### I. User Information

#### a. External Memory/Micro SD Capacity

From 2G to 32GB;

#### **b. SYSTEM REQUIREMENTS**

Support XP\Win7\Win8\MAC\Linux

Note: Because of 3D Printer are bare metal, you have to pay attention to electrical safety during use! And the power outlet must be three-hole grounded outlet!

#### 2. Safety Precautions

Before installing and using the machine, be sure to read the following. Do not attempt any user manual does not describe to use the machine to avoid personal injury and property damage accidents may cause.

#### 3. Select the proper placement

• The machine is suitable for placement in a ventilated, cool, dry and less dusty environments.

- Note that when using thermal printer surroundings, avoid placing on a thick carpet or against a wall.
- Do not place the machine near flammable materials or high heat.
- Do not place the unit in a larger vibration or other unstable environment.
- Do not pile heavy objects on the unit.

#### 4. Follow the standard use of power

- Use the power cord supplied with this unit.
- Refer to the "Installation" section of the machine performance parameters to select the appropriate 220V power supply.
- Do not plug the power cord when your hands are wet.

- Please use a plug, be sure to fully inserted into the power outlet.
- Do not deliberately pull, twist the machine over the distribution line, to avoid causing an open or short circuit.

#### 5. Note that in the printing process

- Do not use the machine without the supervision of staff.
- Printing process and print just completed, avoid touching the printer's internal structure and prints, to prevent burns.
- If occur when printing printer smoke, abnormal noise, immediately turn off the power switch, the printer stops working, and contact your purchaser.
- Often do product maintenance
- Do not attempt to use the method described in the manual does not disassemble or modify the machine to prevent damage to the printer or other more serious accidents.
- Regularly in case of power failure, the printer clean with a dry cloth, wipe the dust and bonding of printed materials. If you must use a damp cloth to clean, do not use flammable solvents, flammable solvents to prevent contact with the printer's internal circuitry result in a fire or electric shock.

#### **II. ELEGOO Installation and Setup**

#### 1. Slice software installation

a. Install the software

Click Setup	" ELEGOO_Cura_4.8.0	, pop-up installatio	on window, a	lways cl	ick Next to
complete the	installation.				
ELEGOO	Cura Setup		( <del>110</del> )		×
Choose In:	stall Location				
Choose the	e folder in which to install ELE	GOO Cura.			ELEGICO
Setup will i Browse an	nstall ELEGOO Cura in the foll d select another folder. Click l	owing <mark>folder. To install in a</mark> Next to continue.	a different fold	ler, dick	
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Choose which features of ELE	GOO Cura you want to install.			ELEGCO
Check the components you wa install. Click Install to start the	int to install and uncheck the components installation.	you dor	n't want I	o
Select components to install:	<ul> <li>ELEGOO Cura</li> <li>Install Visual Studio 2010 Redistribution</li> <li>Install Arduino Drivers</li> <li>Open stl files with Cura</li> <li>Open OBJ files with Cura</li> </ul>	Jtable		
Space required: 583.5MB				
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	Install			
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ELEGOO Cura Setup		<u></u>	
Installing			
Please wait while ELEGOO Cura is being installer	d.		ELEGCO
Extract: UltimakerRobot_support.stl			
Show details			
Nullsoft Install System v2.51			
	< Back	Next >	Cancel

wait for

Device Driver Installation Wizard



Next



Install



 Windows Security ×
 Would you like to install this device software?
 Name: Arduino USB Driver Publisher: Arduino LLC
 Always trust software from "Arduino LLC". Install Don't Install
 You should only install driver software from publishers you trust. How can l decide which device software is safe to install?

Install

Device Driver Installation Wizard	1		
	Completing the De Installation Wizard The drivers were successfully in: You can now connect your devi came with instructions, please re	stalled on this con ce to this compute ad them first.	<b>r</b> nputer. er. If your device
	Driver Name Adafruit Industries LLC ( Arduino Srl (www.arduin Arduino LLC (www.ardui	Status Ready to use Ready to use Ready to use	~
	< Back	Finish	Cancel
ELEGOO Cura Setup     Installation Complete     Setup was completed success	fully.		ELEQCO
Completed Show details			
ivulisoft Install System v2.51	< Back	Next >	Cancel

Next



# Finish



#### Get starts



Agree



Next



Next



Skip

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	orked printer	~
There is no	printer found over you	ur network.
Refresh	Add printer by IP	Add cloud pmteroubleshooting
Add a non-r	networked printer	<

## Add a printer



The selected machine model is a demonstration example, please select the model based on the actual machine received.

#### b. Language







You will need restart the application for these changes to have

effect.

# III. ELEGOO Setup.

#### a.Software parameter setting



b. Recommended parameter settings:

save to file/Online Printing

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							01.492	Q Search settings	=
Profiles	り 0.0	06 0.15	0.2	0.2	0.3	0.4	0.6	= Quality	~
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		-					l	Bottom Thickness 1.2	mm
Support							l	Bottom Layers 8	
							l	Horizontal Expansion 0	mm
		1					l	Z Seam Alignment の User Specified	~
Adresion		1					l	Seam Corner Preference Hide Seam	~
								Infill	
					115	Longes.	111110	iiii Material	~
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# IV: For in-depth study, refer to the following notes

Website : <u>www.elegoo.com</u>

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A Dual Extrusion

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### 1. Layer height



Explanation: Layer height in millimeters. This is most important setting to determine the quality of you print. Normal quality are 0.2mm, high quality is 0.15mm

### 2、Shell thickness



Explanation: Thickness of the outside shell in the horizontal direction. This is used in combination with the nozzle size to define the number of perimeter lines and the thickness of those perimeter lines.



### **3**、Enable retraction

Explanation: Retraction is for without letting the material flow out during printing, Otherwise it will affect printing surface.

# 4、 Bottom/Top thickness



Explanation: This control the thickness of the bottom and top layers, the amount of solid layers put down is calculated by the layer thickness and this value .Having this value a multiple of the layer thickness makes sense .And keep it near your wall thickness to make an evenly strong part.

# 5、Fill Density(%)





Explanation: For a solid part use 100%, for an empty part use 0%. A value around 20% is usually enough. It adjusts how strong the parts becomes.

# 6、Print speed (mm/s)



Explanation: Speed at which printing happens.

Suggest 50-80, according to what you print. Faster speed, worse

effect.

# 7. Print temperature(°C)

rint settings		
Profile Extra Coarse 0.6mm		*~
Q search settings		
Quality		<
🛽 Shell		<
🖾 Infill		<
Material		~
Default Printing Temperature	210	°C
Build Volume Temperature	P 0	°C
Printing Temperature	210	°C
Printing Temperature Initial Layer	210	°C
Initial Printing Temperature	200	°C
Final Printing Temperature	195	°C
Default Build Plate Temperature	P 55	°C
Build Plate Temperature	P 55	°C
Build Plate Temperature Initial Layer	P 55	°C
Flow	100	96
Wall Flow	100	96
Outer Wall Flow	100	96
Inner Wall(s) Flow	100	96
Top/Bottom Flow	100	96
Infill Flow	100	96
Skirt/Brim Flow	100	96
Support Flow	P 100	96
Prime Tower Flow	100	96
Initial Layer Flow	100	96

Explanation: Printing temperature used for printing . PLA :nozzle

is 190-220, generally 200; Bed is 45-50.

# 8、 Support type

Print settings	×
Profile Extra Coarse 0.6	mm 🛧 🗸
Q search settings	≡
P Quality	<
🛽 Shell	<
🖾 Infill	<
Material	<
O Speed	<
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Support	~
Generate Support	8 7 1
Support Placement	。 り Everywhere 🗸
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Support Pattern	& Everywhere
Support Wall Line Count	d <sup>o</sup> 0
Connect Support ZigZags	8° 🗸
Support Density	e 15 %
Support Line Distance	a <sup>e</sup> 2.6667 mm
Initial Layer Surt Line Dist	ance & 2.6667 mm

#### Support Placement

Adjusts the placement of the support structures. The placement can be set to touching build plate or everywhere. When set to everywhere the support structures will also be printed on the model.

Affects

Support Bottom Distance

※ Cooling			<
Support			~
Generate Support &	5	~	
Support Placement ಕ	5	Touching Buil	~
Support Overhang Angle	°,	50	n
Support Pattern	0°	Zig Zag	4
Support Wall Line Count	P	0	
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Support Density	do.	15	96
Support Line Distance	00	2.6667 m	m
Initial Layer Surt Line Distance	0°	2.6667 m	Im
Support Infill Line Direction	00	0	
Enable Support Brim	ø		
Support Brim Width	0 <sup>0</sup>	8.0 m	m



# **9** Platform adhesion type



different options that help in preventing corners from lifting due to warping

# V: Printing Way<sup>1</sup>

### a:Memory Card Offline Printing

Offline printing is one way to use the storage card for printing, do not need computer, it is easy to use and operate, we advise users to choose offline printing.



**Click slice** 



Click Save to File



Select the path in the pop-up window and write the file name, Insert the storage card, Copy the file to storage card.



#### **b:** On line Printing

Online printing need to connect computer to the 3D printer by data cable. The printer cannot be powered off in the printing process, and the computer cannot sleep or go screensaver, or the data transmission will be failure, it is inconvenient to use, we do not advise users to choose this way.

It is recommended to turn off the anti-virus software before installing the driver to prevent the accidental and cause the installation to fail.

The driver installation method is as follows: Open the profile of the TF card to select the path \ Software and Software Driver Folder \ Software Driver Folder \ CH340G USB Driver Folder \ Double-click the [DRVSETUP64] file to run it and click to install it.

Name	Date modified	Туре	Size
CH341PT.DLL	11/13/2020 1:49 PM	Application exten	7 KB
CH341S64.SYS	11/13/2020 1:49 PM	System file	57 KB
CH341S98.SYS	11/13/2020 1:49 PM	System file	20 KB
ch341SER	11/13/2020 1:49 PM	Security Catalog	10 KB
CH341SER	11/13/2020 1:49 PM	Setup Information	6 KB
CH341SER.SYS	11/13/2020 1:49 PM	System file	39 KB
CH341SER.VXD	11/13/2020 1:49 PM	Virtual device driver	20 KB
😼 DRVSETUP64	11/13/2020 1:49 PM	Application	42 KB
🛃 SETUP	11/13/2020 1:49 PM	Application	82 KB

<b>Device Driver Ins</b>		
Select INF File :	CH341SER.INF	~
INSTALL	WCH.CN	
UNINSTALL	[11/04/2011, 3.3.2011.11	
HELP		
DriverSetup(X64)	tall / Uninstall	×
DriverSetup(X64) Device Driver Inst Select INF File :	tall / UnInstall CH341 SER.INF	~
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DriverSetup(X64) Device Driver Inst Select INF File : DriverSetup The c	tall / UnInstall CH341SER.INF	×××

- $1_{\sim}$  Connecting computer to the printer by USB cable.

Elegoo Cura Eile Edit Yiev Settings Extensions Preferences Help			= L X
ELEGOO Cura	PREPARE PREVIEW MONITOR		Marketplace Sign in
Elegoo cura	PREVARE PREVIEW MONITOR LEGGOO NEPTUNE2 ( Temperat Moving	ELEGOO NEPTUNE 2 COM3 Extruder 1 Build plate Printer control Jog Distance @ Send G-code @ Active print Job Name Printeng Time	Marketplace         Sign in           200 °C         pro           200 °C         Pro-heat           60 °C         Pro-heat           XY         Z           XY         Z           XY         Z           XY         Z           XY         Z
			Pause Abort Print

We can click on the gray ring on the window to control the motion of the XYZE axis. "0.1, 1, 10, 100" are the each amount of motion. The text box in the lower right corner can be input G code to control. If you are not familiar with it, please do not change anything. Click "Print" to start printing. Please be careful during printing to avoid printing failure.



**Click Print via USB** 

### Wait for preheating and start printing.

\*If you cannot connect properly, please install the

corresponding driver or download the third-party driver

software.