User manual of

ELEGOO 3D slicing software

ELEGOO 3D Printer

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.

Website : www.elegoo.com

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- 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。
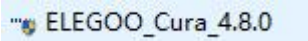
5. Note that in the printing process

- 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.

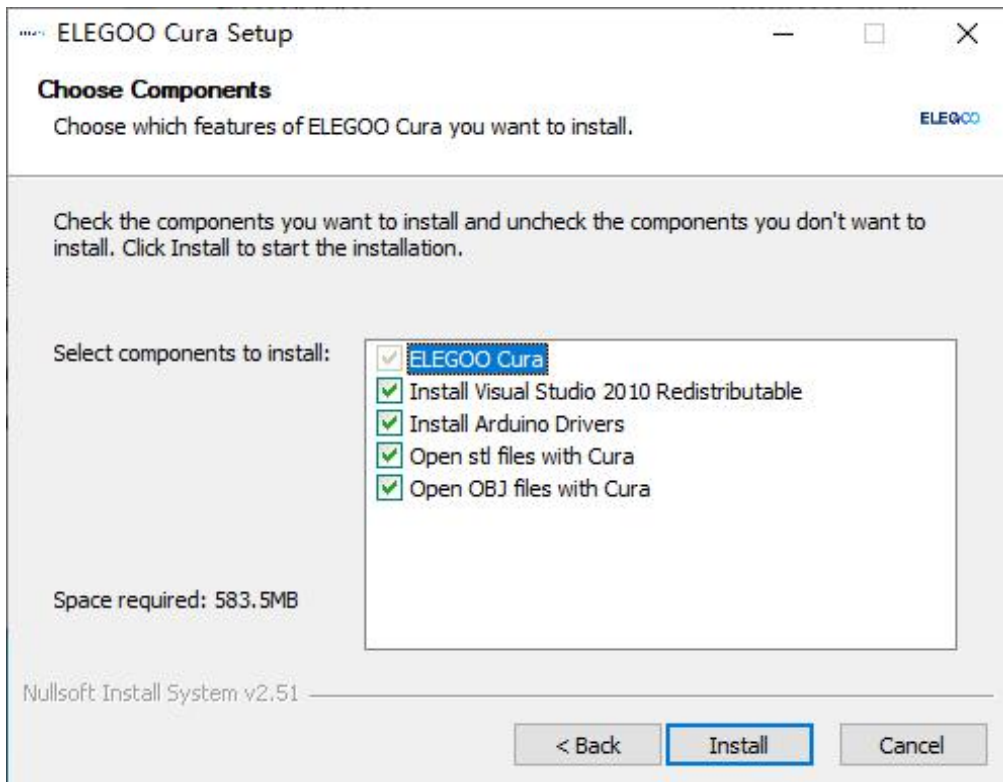# II. ELEGOO Installation and Setup

1. Slice software installation

a. Install the software

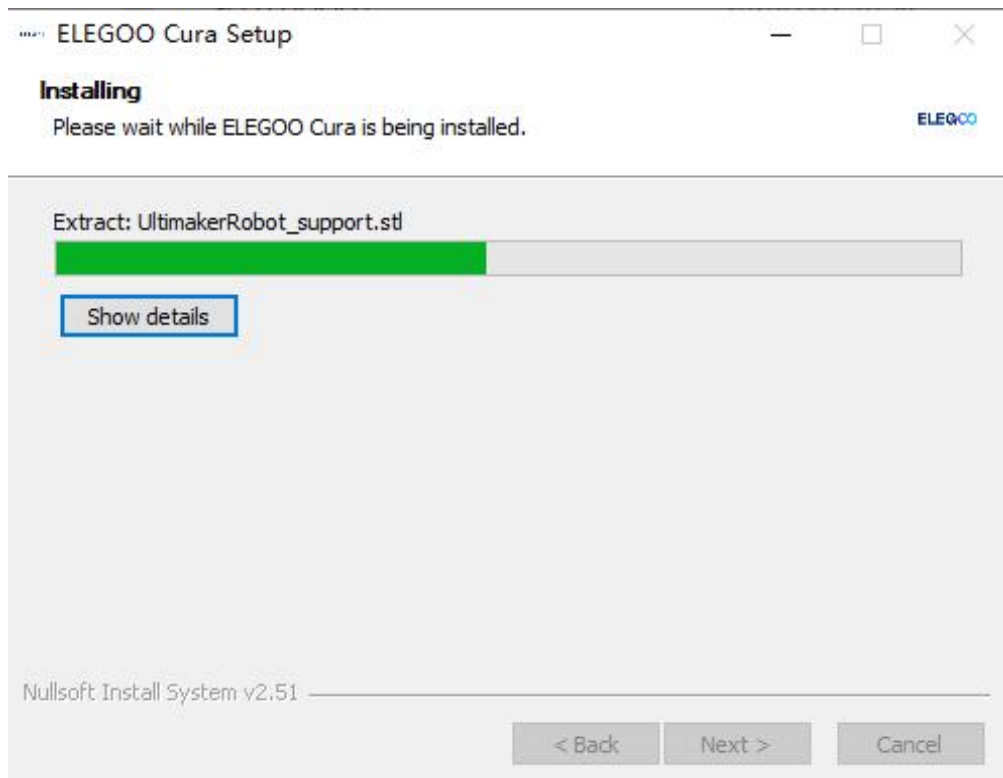Click Setup 　ELEGOO_Cura_4.8.0　, pop-up installation window, always click Next to complete the installation.
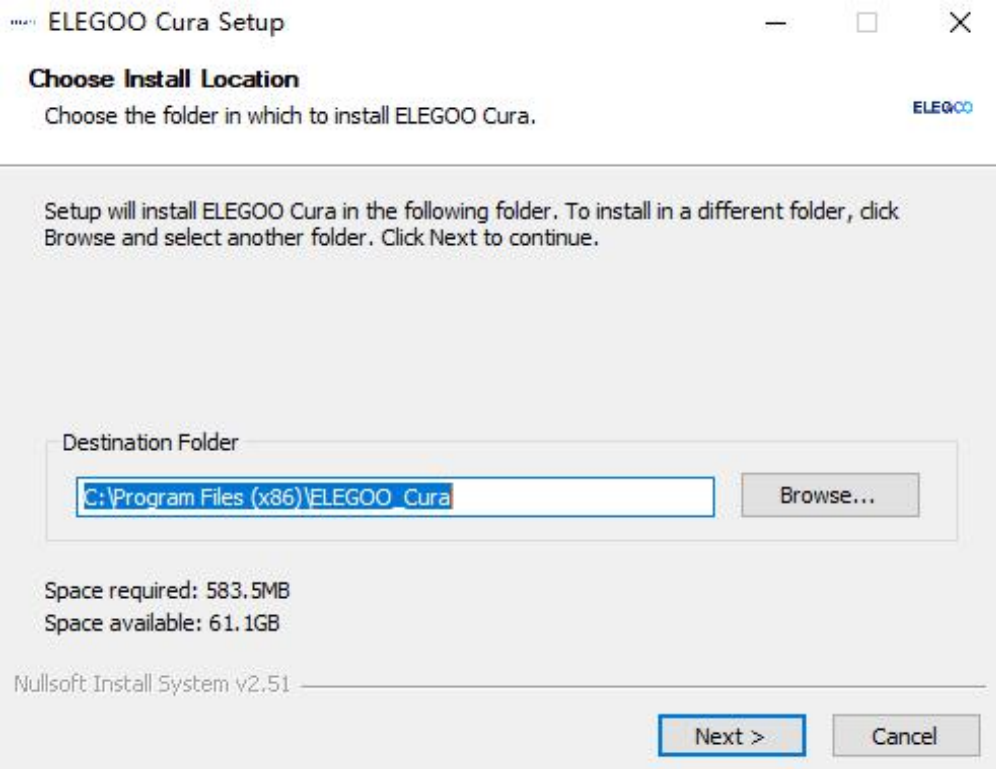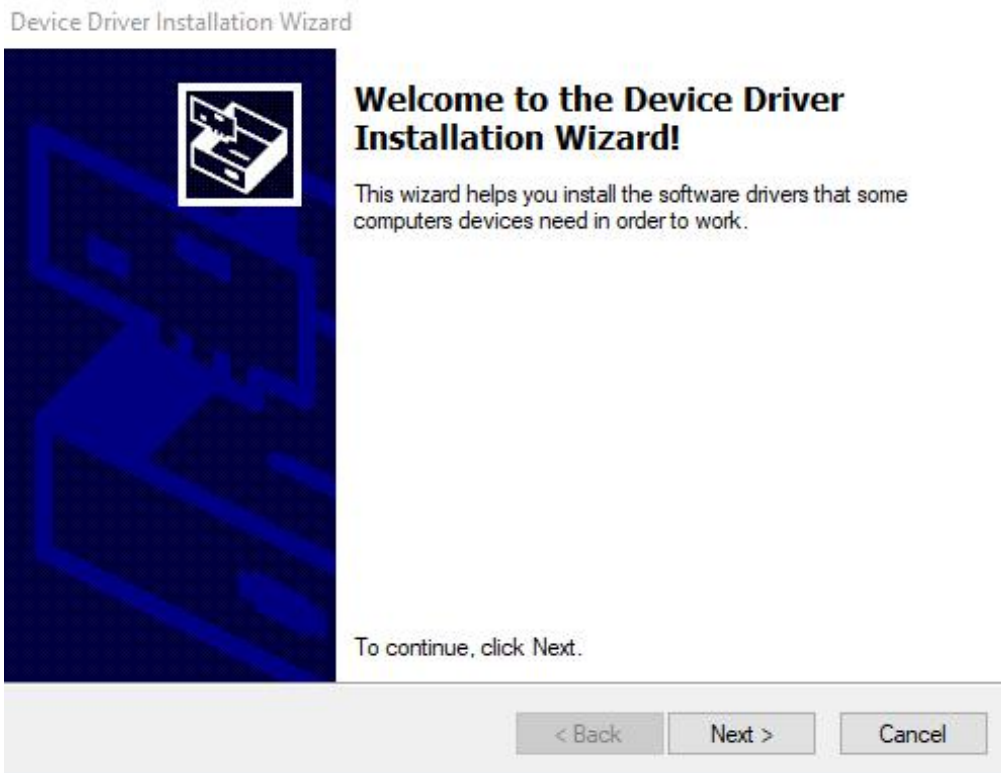

Next

ELEGOO 3D Printer

Install

wait for

ELEGOO 3D Printer

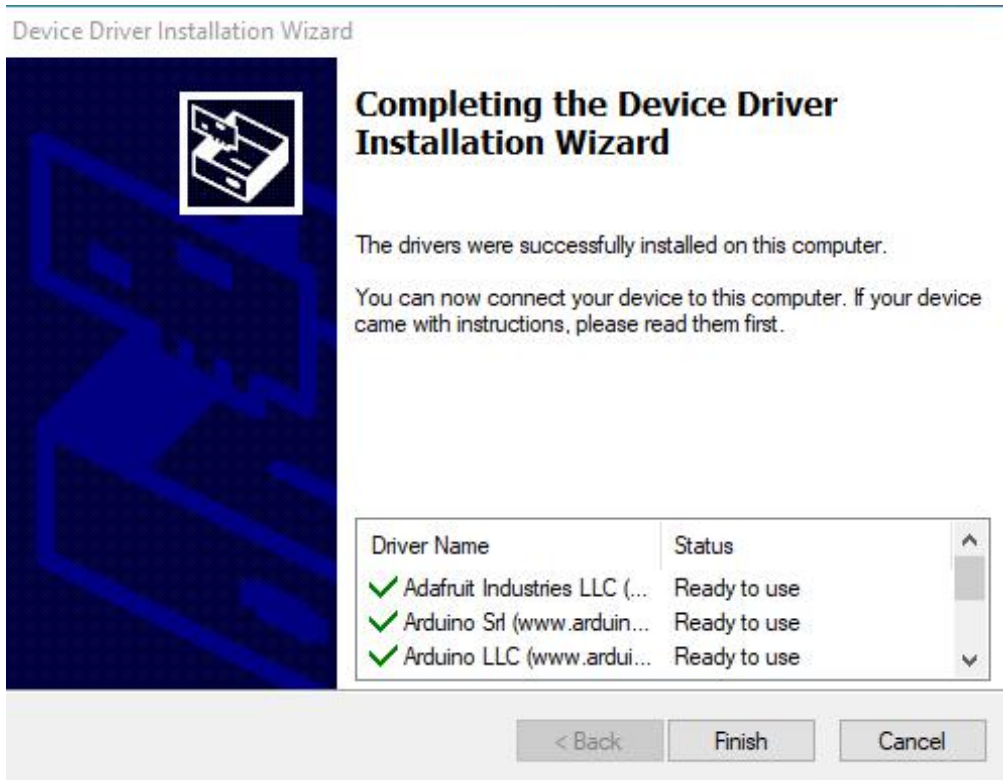**Next**

Install

4

ELEGOO 3D Printer

5
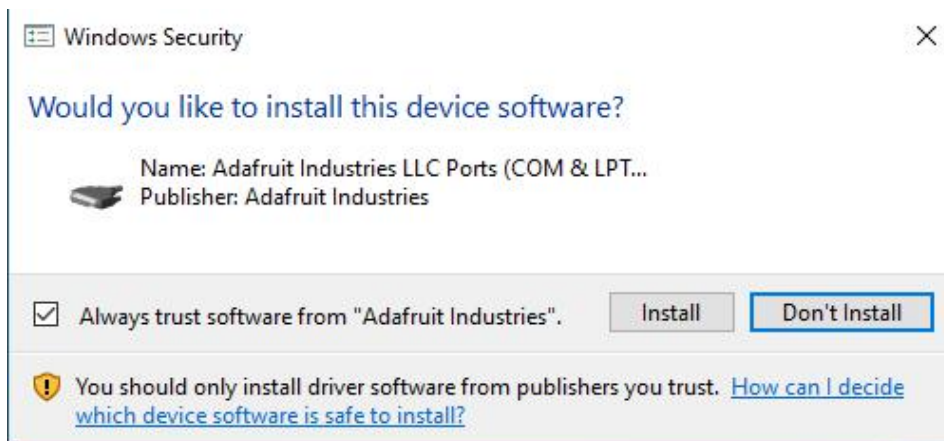
Install

Install

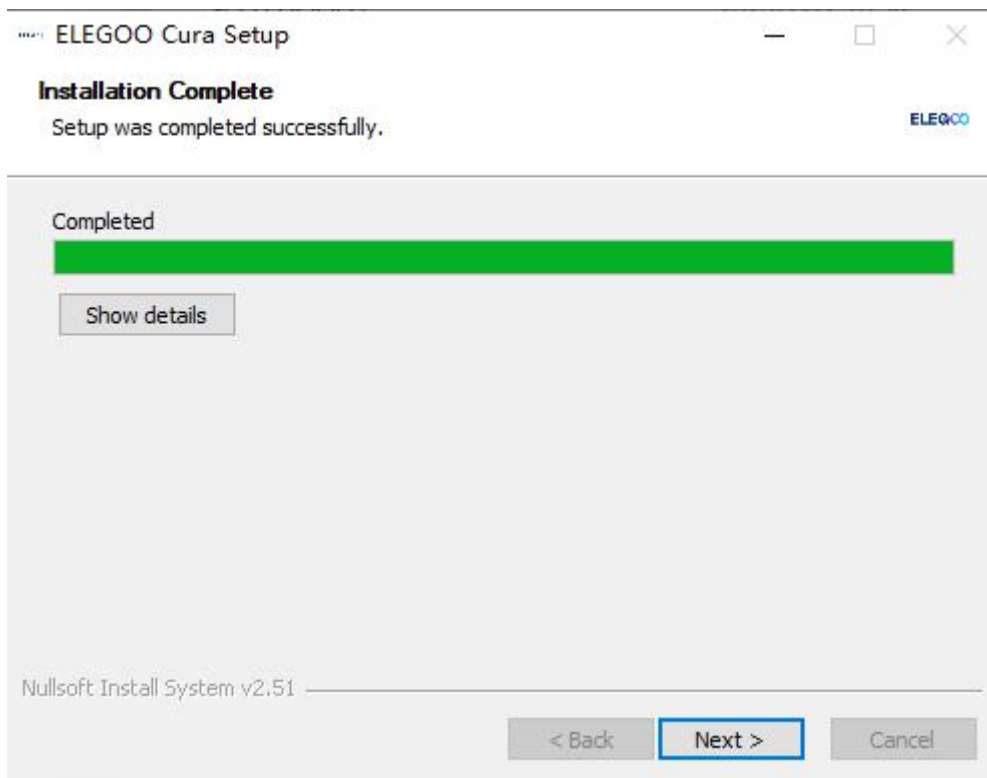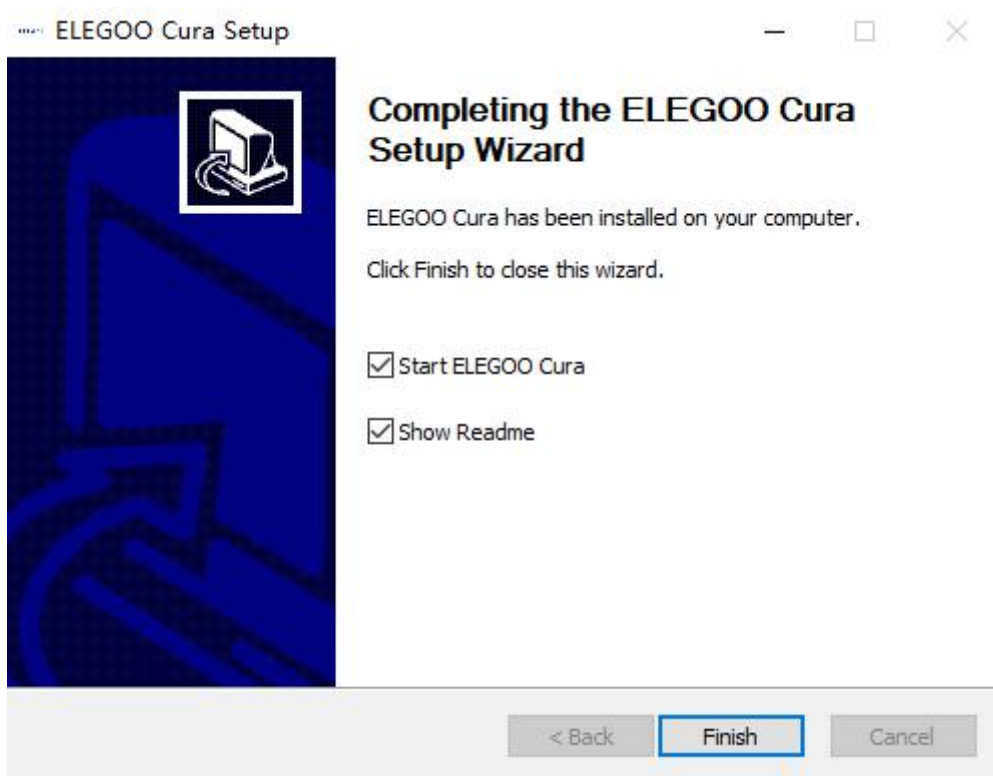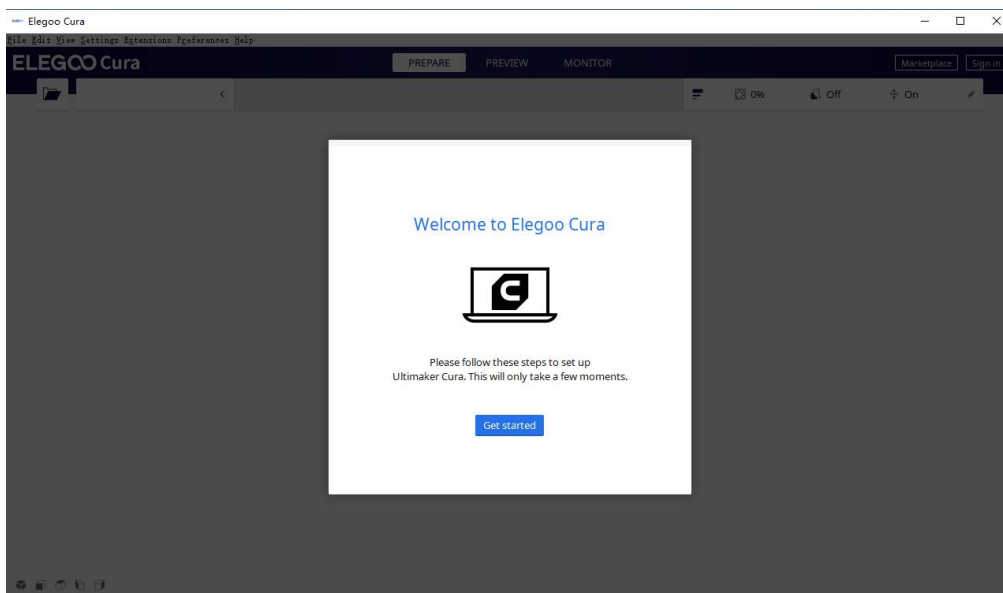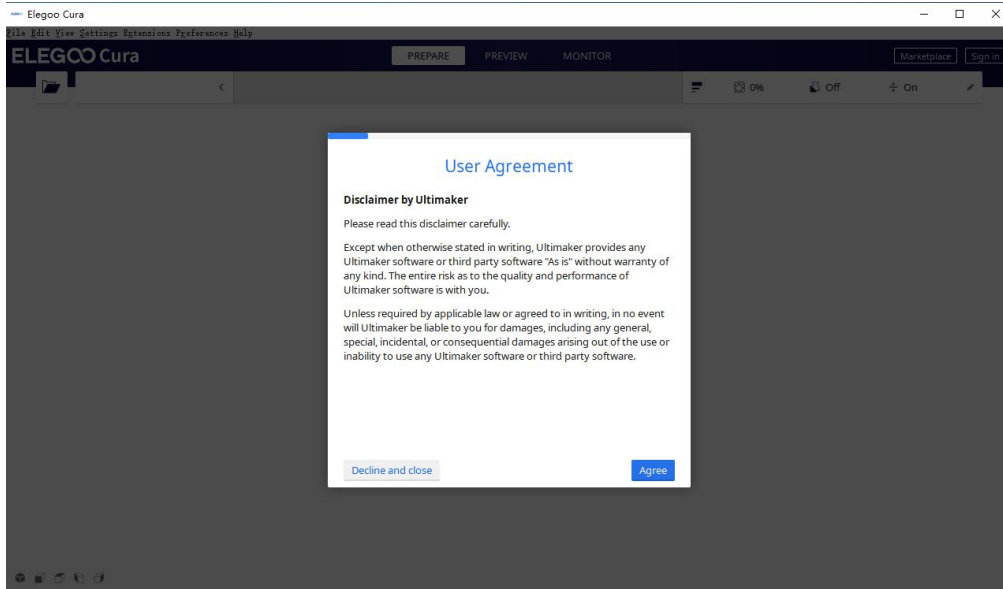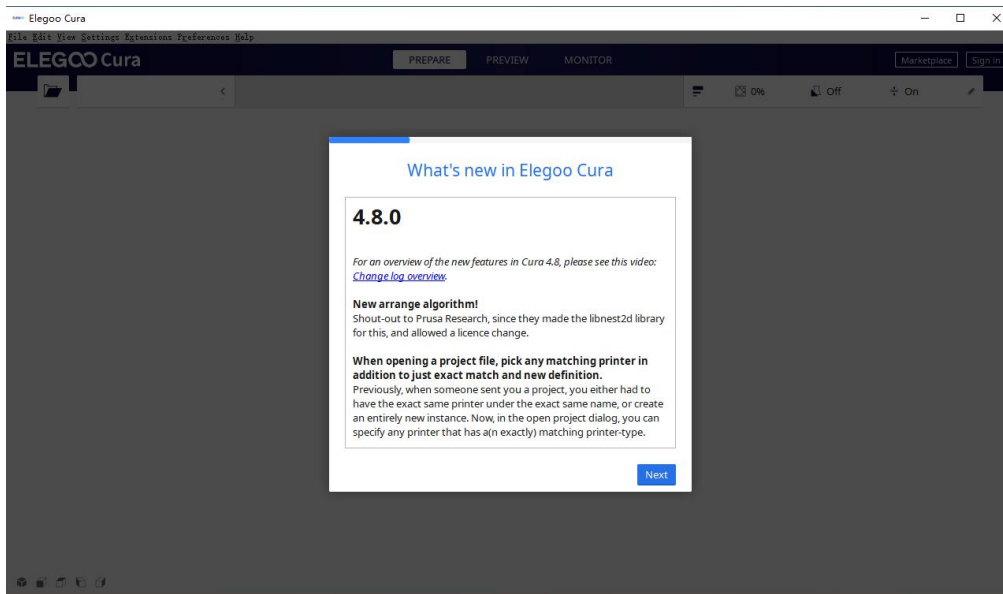# ELEGOO 3D Printer

Finish

Next

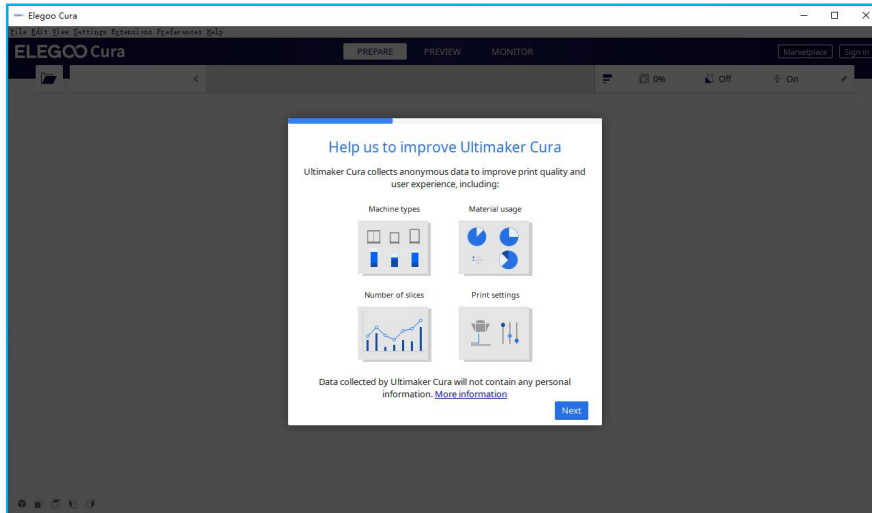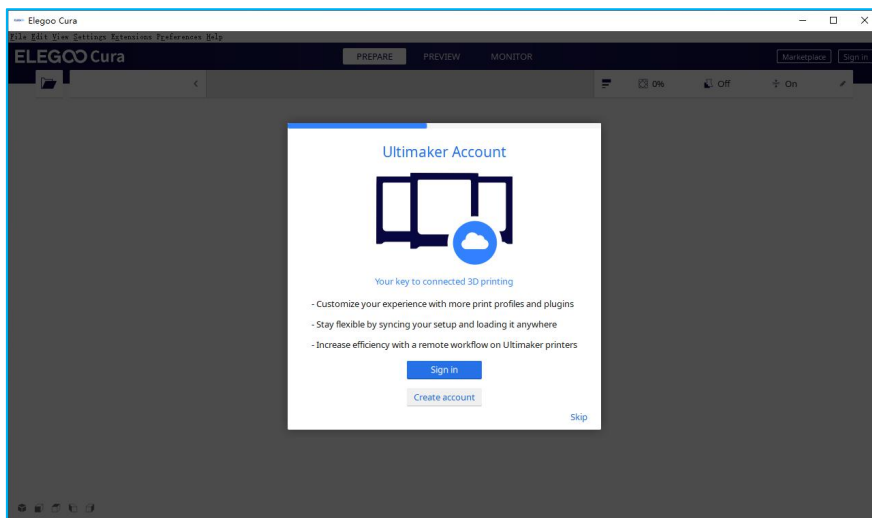# ELEGOO 3D Printer

Finish

Get starts

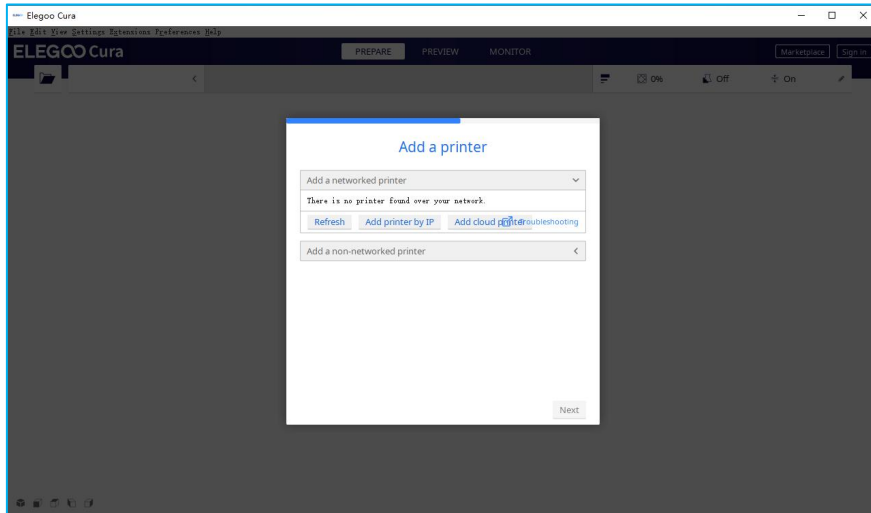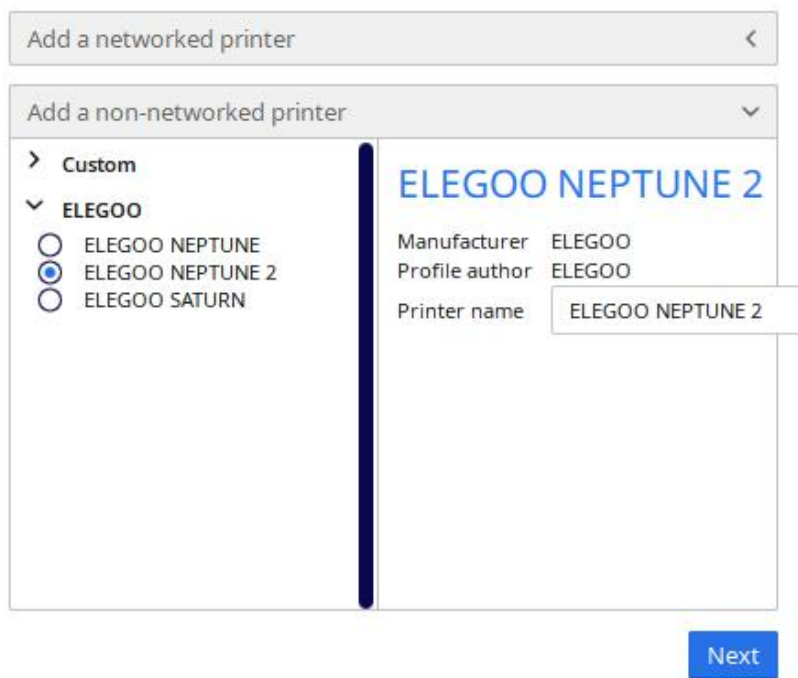# ELEGOO 3D Printer

Agree

Next

ELEGOO 3D Printer

Next

Skip
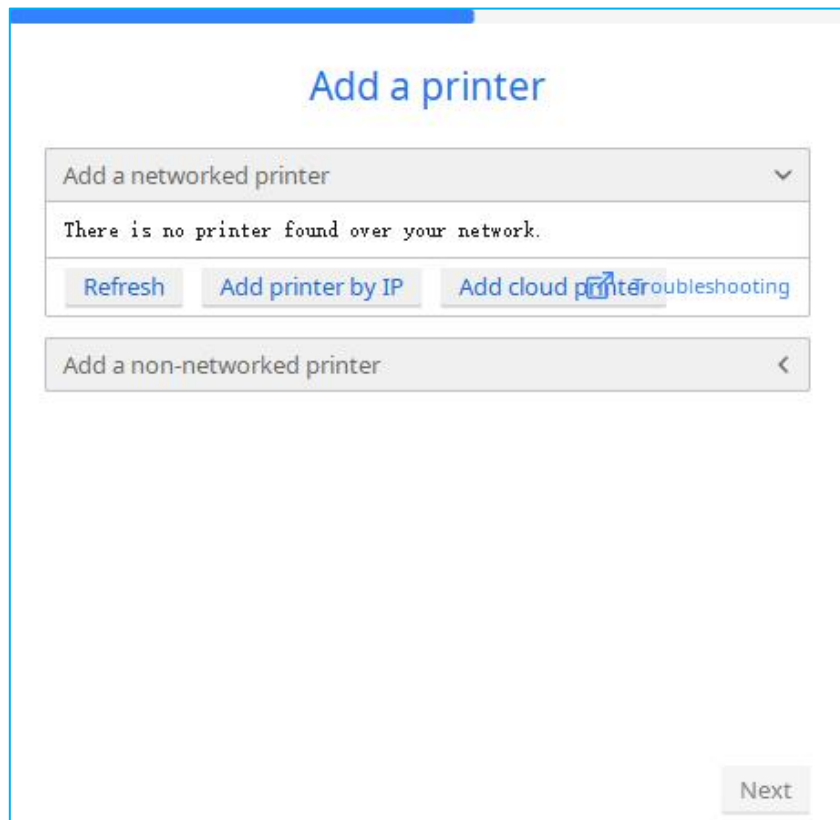
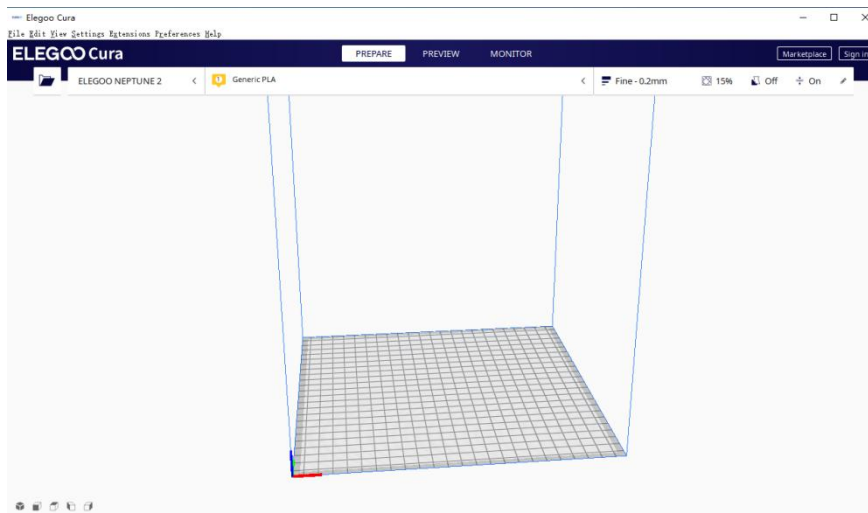# ELEGOO 3D Printer

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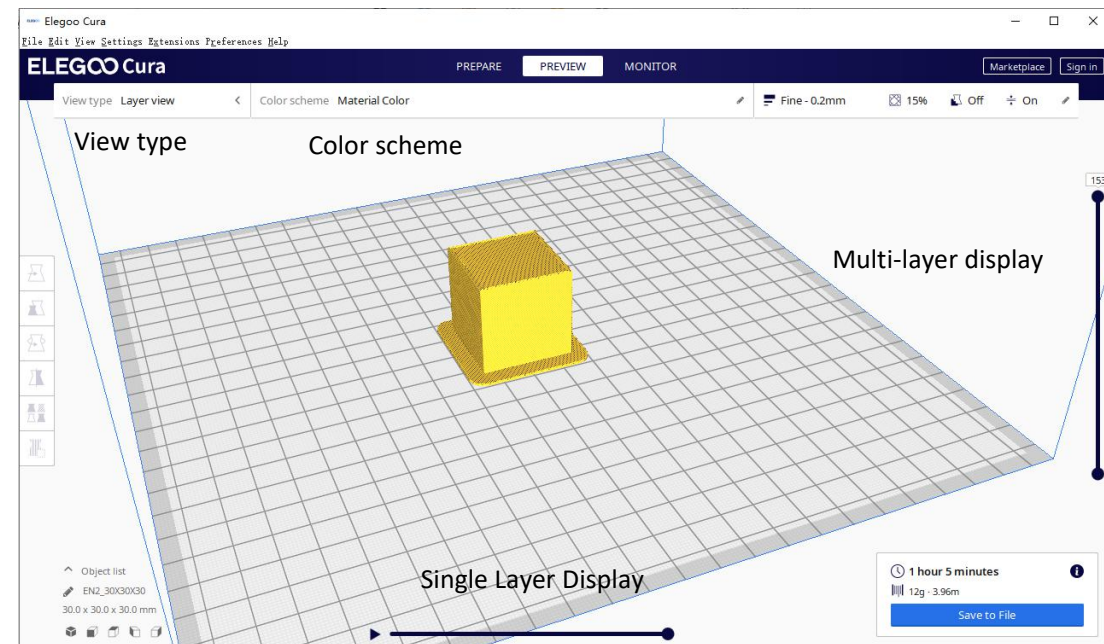
b. Language

Preferences→Configure Cura→Language→Close

▲ **You will need restart the application for these changes to have effect.**

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III. ELEGOO Setup.

a.Software parameter setting

Preset printers · material · Print settings · Move · Zoom · Rotate · Mirror image · Model setting · Support structure · interception · Right mouse button

View type · Color scheme · Multi-layer display · Single Layer Display · save to file/Online Printing
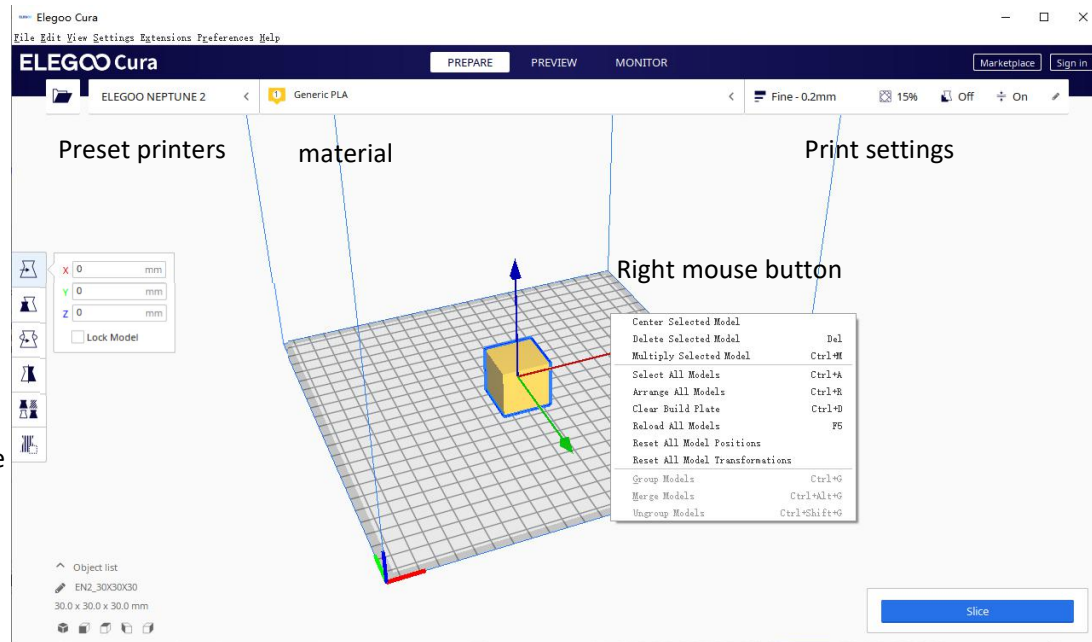
b. Recommended parameter settings:

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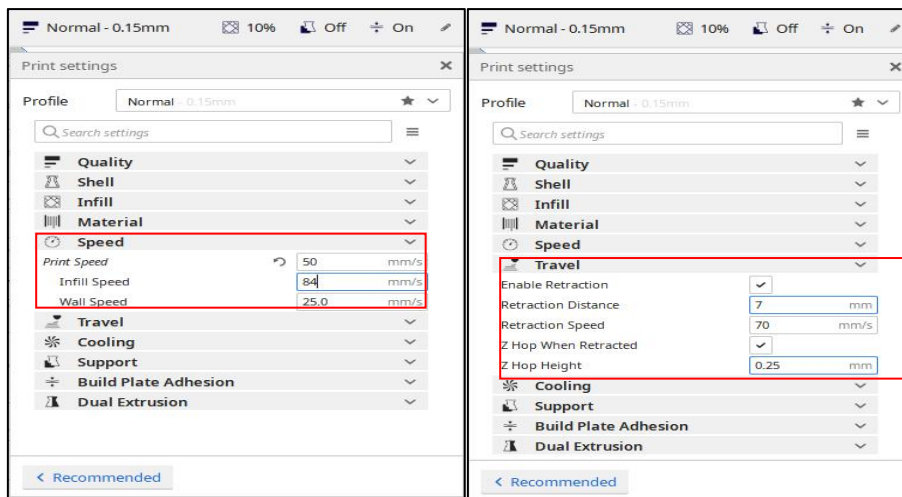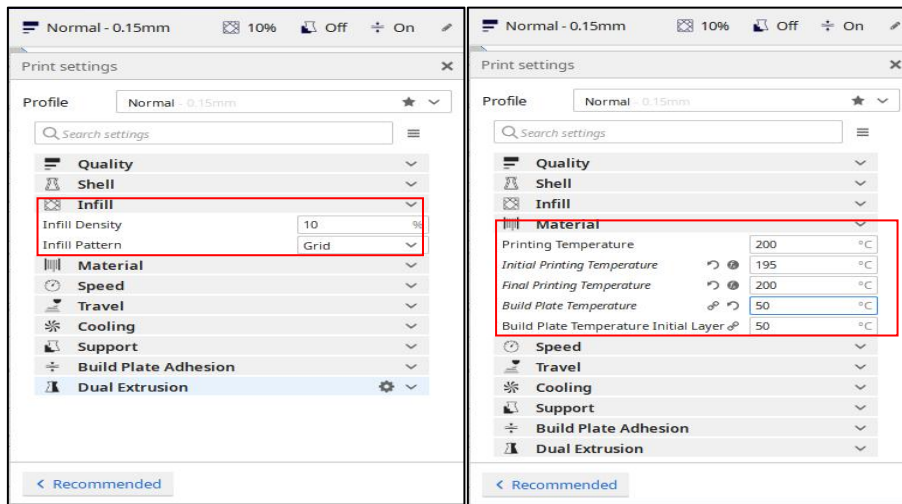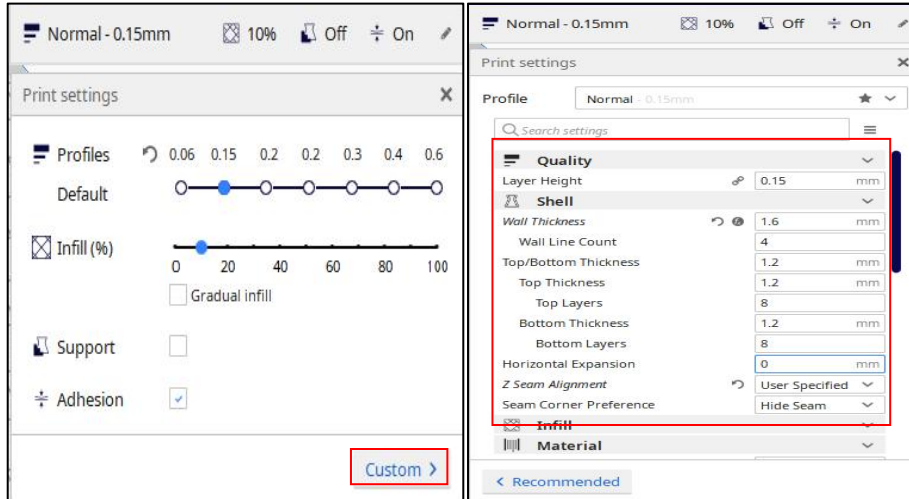
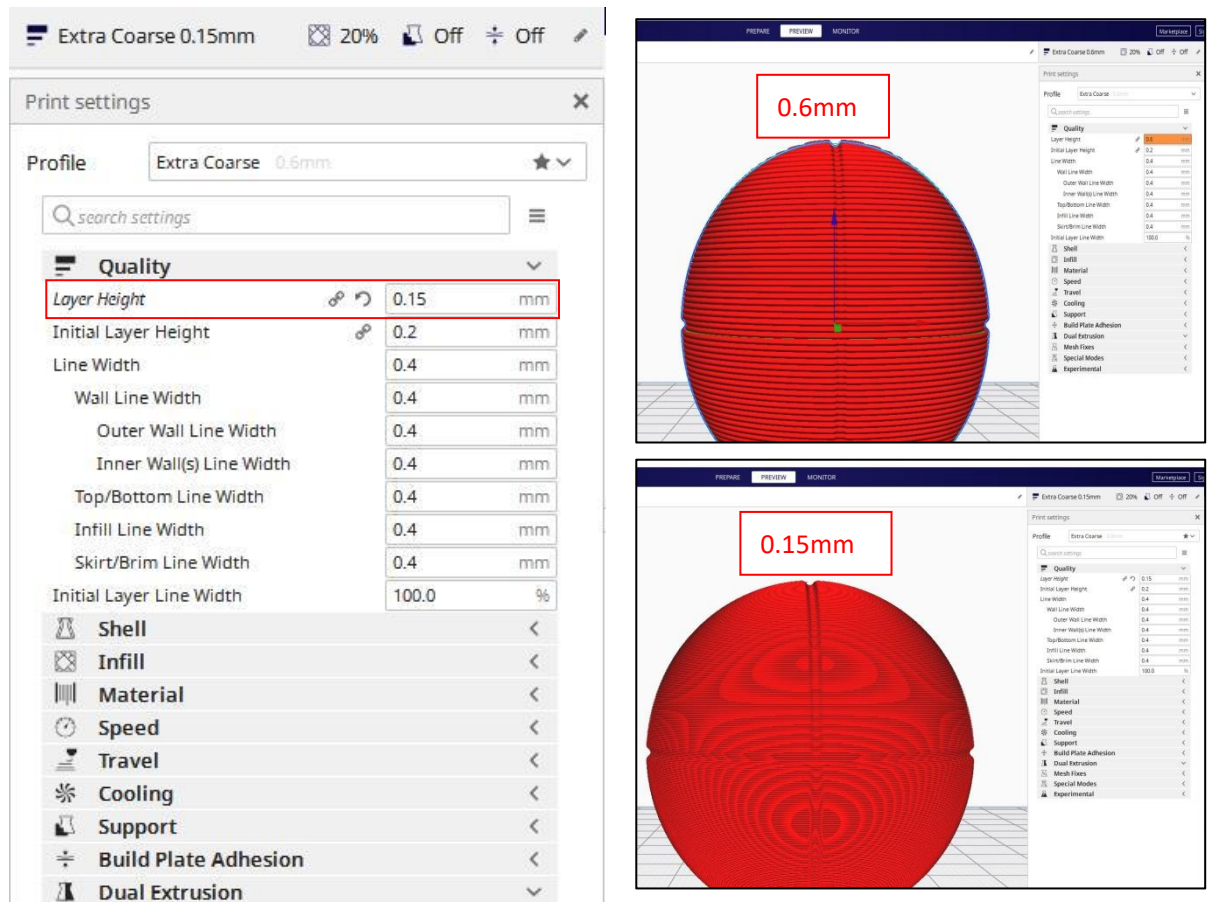## IV: For in-depth study, refer to the following notes
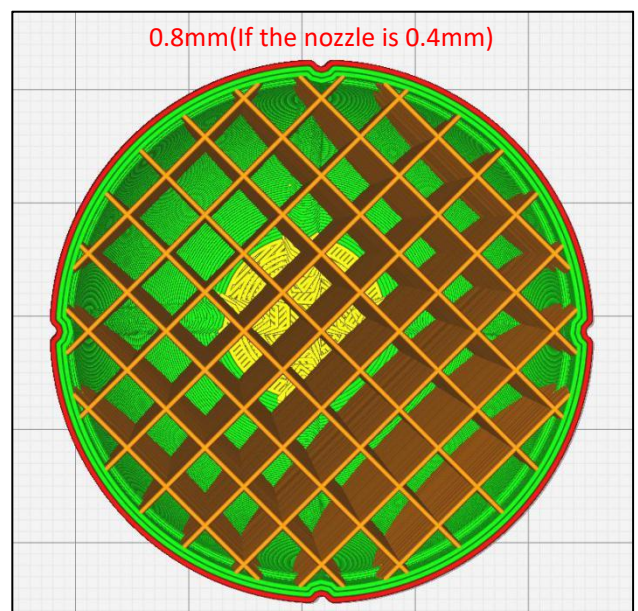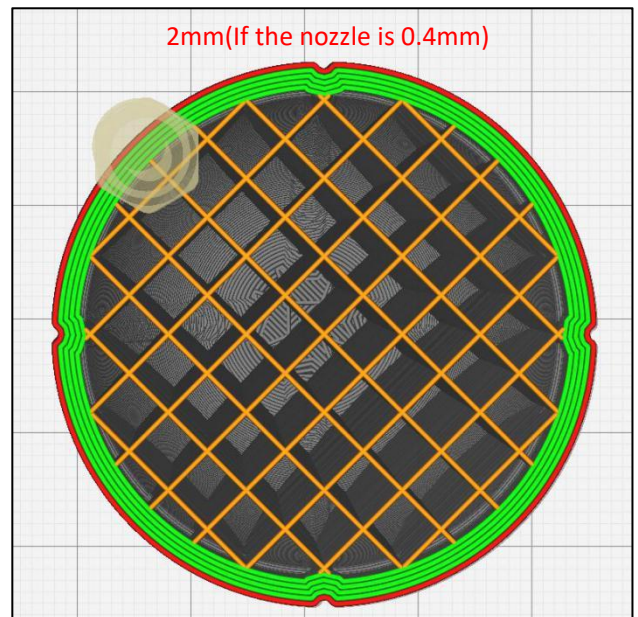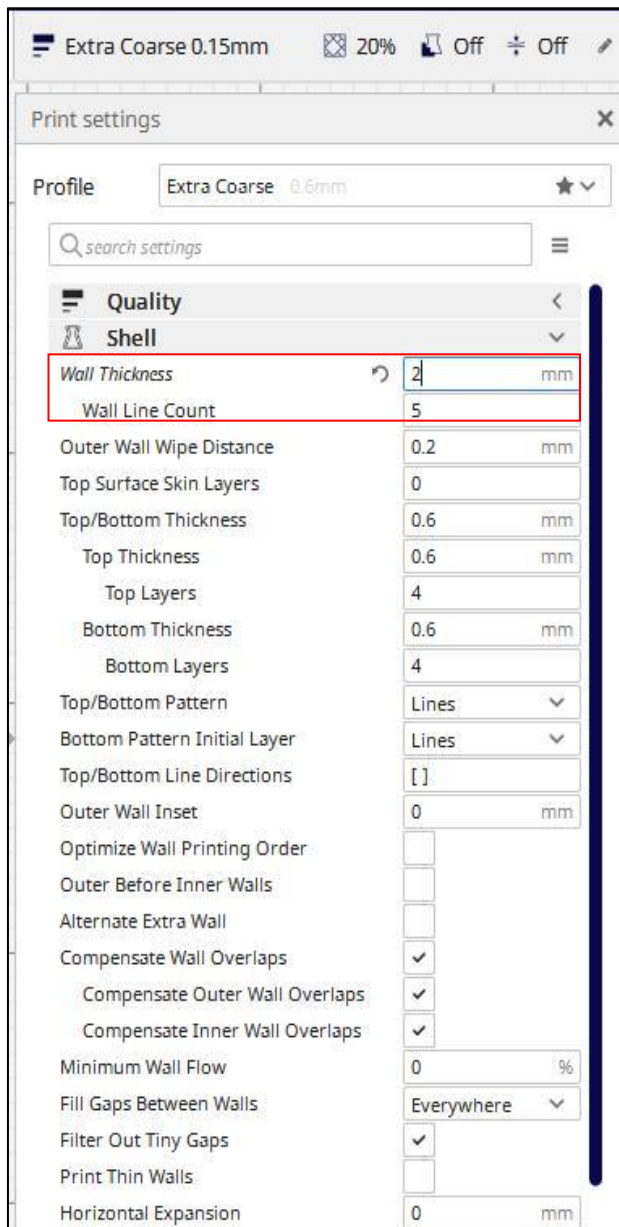
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1、Layer height

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

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| Extra Coarse 0.15mm | 20% | Off | Off | ✎ |

Print settings ✕

| Profile | Extra Coarse 0.6mm | ★ ⌄ |

🔍 search settings ☰

▦ **Quality**	‹
🔻 **Shell**	⌄
Wall Thickness ↺	2	mm
Wall Line Count	5	
Outer Wall Wipe Distance	0.2	mm
Top Surface Skin Layers	0	
Top/Bottom Thickness	0.6	mm
Top Thickness	0.6	mm
Top Layers	4	
Bottom Thickness	0.6	mm
Bottom Layers	4	
Top/Bottom Pattern	Lines ⌄	
Bottom Pattern Initial Layer	Lines ⌄	
Top/Bottom Line Directions	[ ]	
Outer Wall Inset	0	mm
Optimize Wall Printing Order	☐	
Outer Before Inner Walls	☐	
Alternate Extra Wall	☐	
Compensate Wall Overlaps	✓	
Compensate Outer Wall Overlaps	✓	
Compensate Inner Wall Overlaps	✓	
Minimum Wall Flow	0	%
Fill Gaps Between Walls	Everywhere ⌄	
Filter Out Tiny Gaps	✓	
Print Thin Walls	☐	
Horizontal Expansion	0	mm

2mm(If the nozzle is 0.4mm)

0.8mm(If the nozzle is 0.4mm)

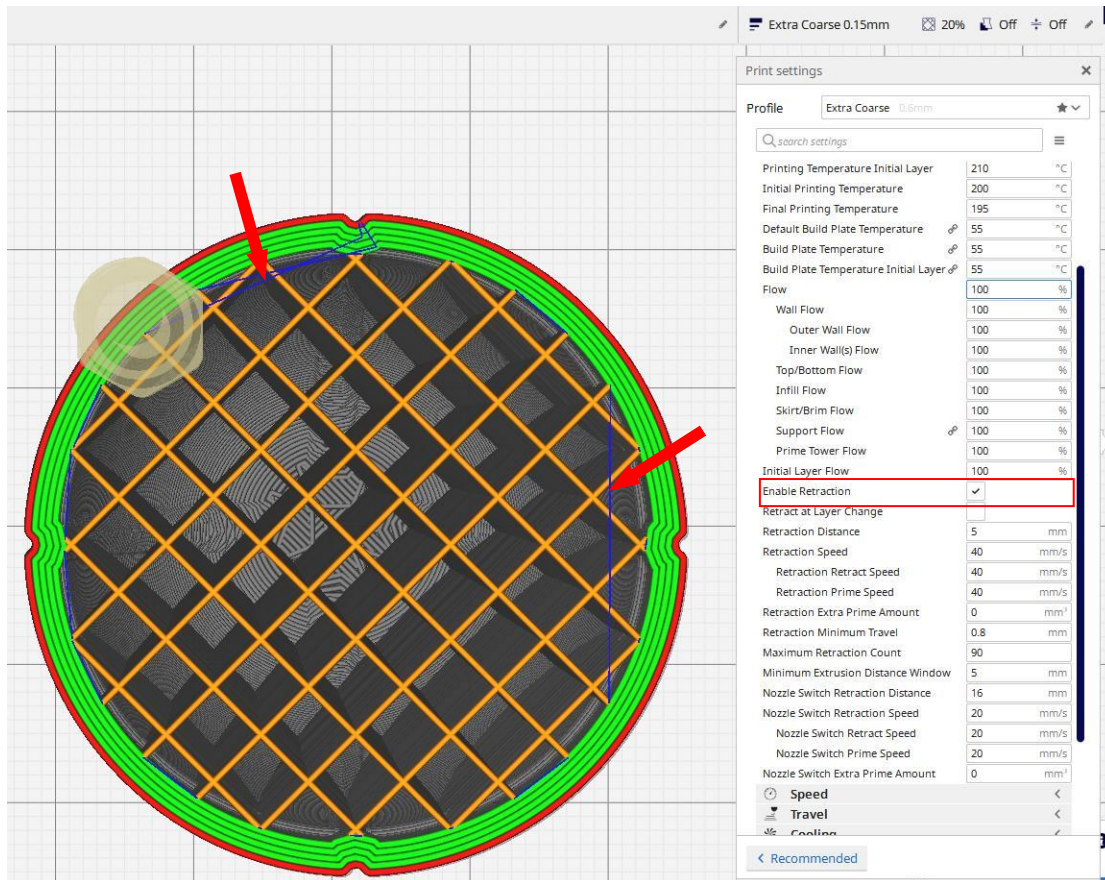**Explanation：Thickness of the outside shell in the horizontal direction. This is used in combination with the nozzle size to define the number of perimeter lines and the thickness of those perimeter lines.**
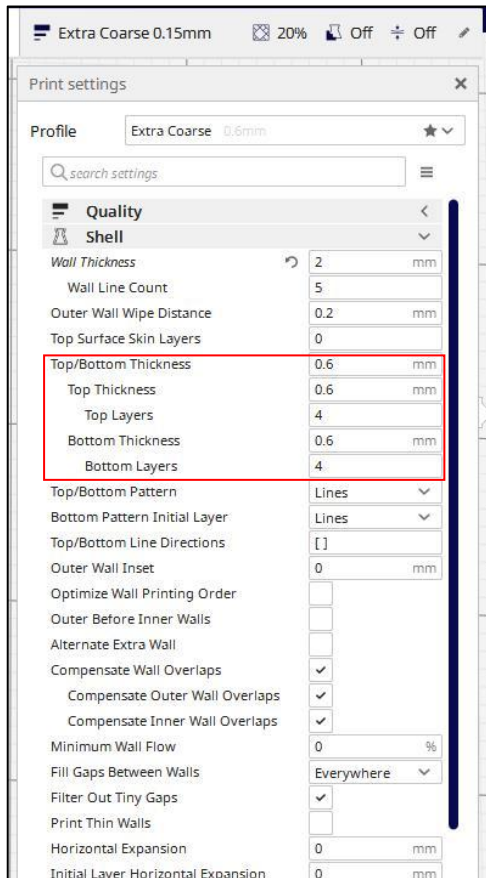
3、Enable retraction

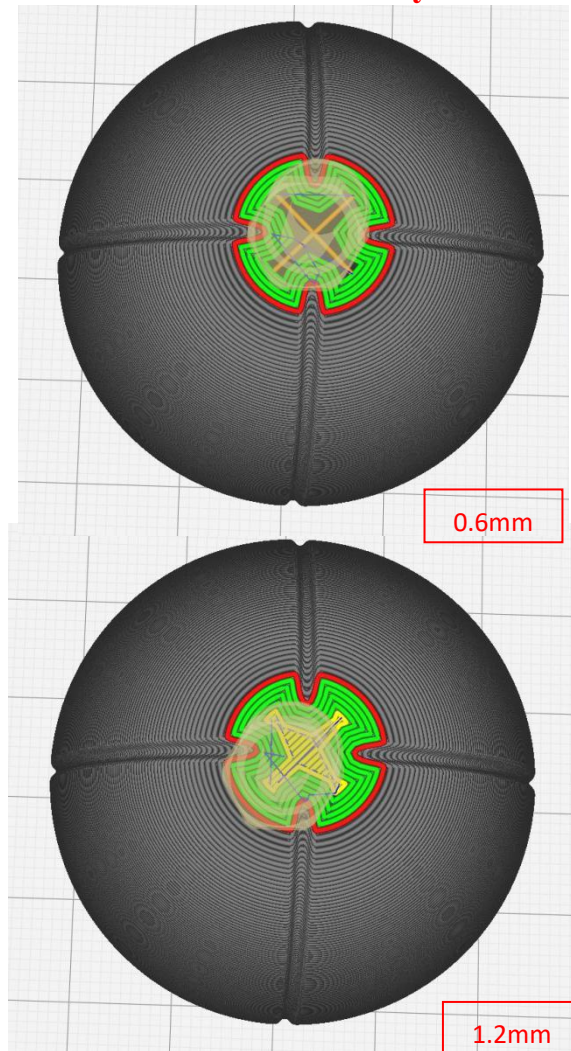Explanation：Retraction is for without letting the material flow out during printing, Otherwise it will affect printing surface.

4、Bottom/Top thickness

Under the same layers
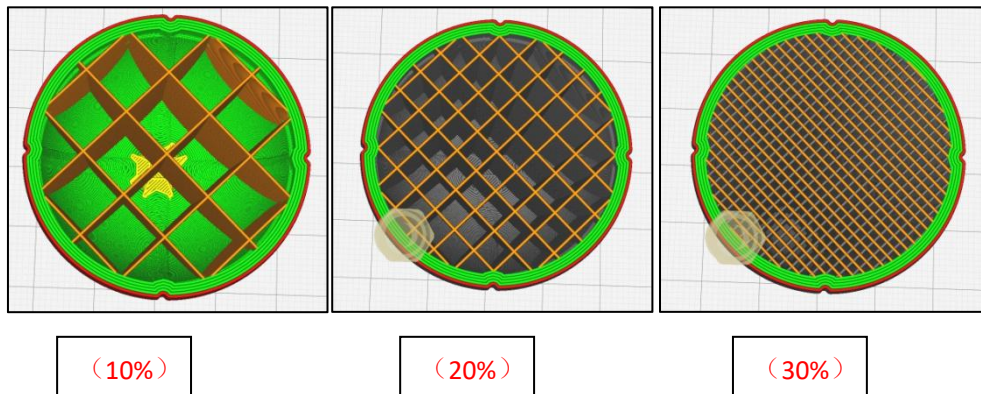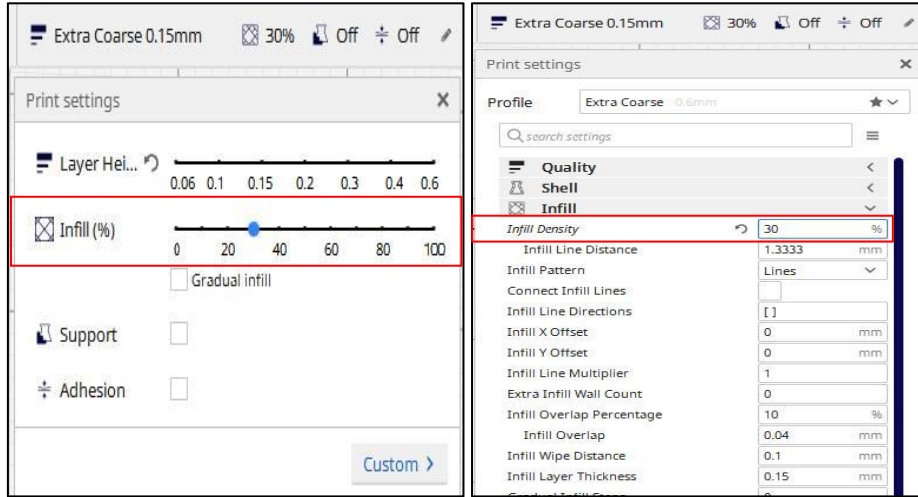

0.6mm

1.2mm

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(％)
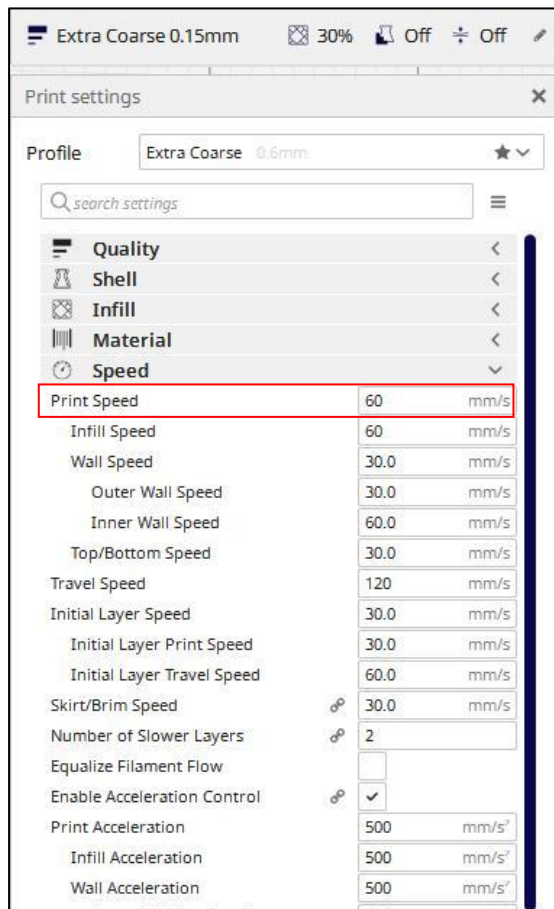

| （10%） | （20%） | （30%） |

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.
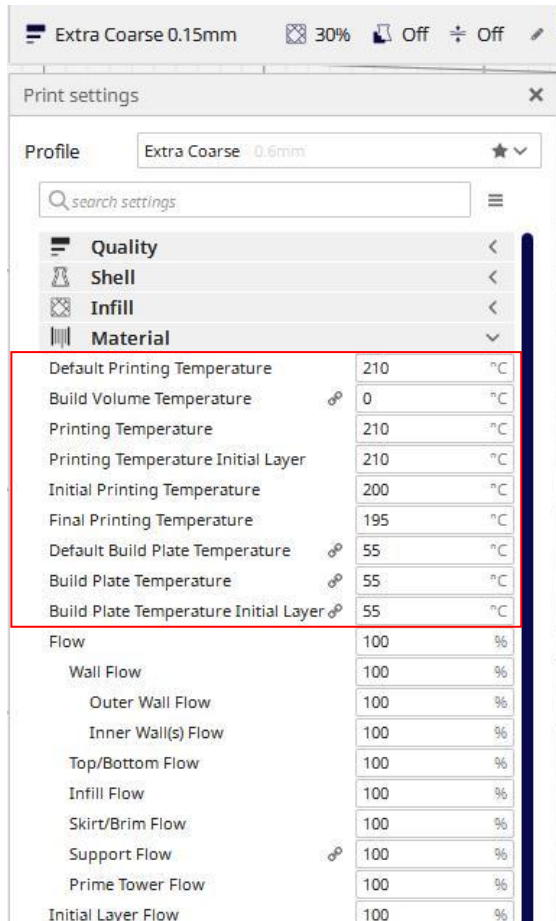
6、Print speed（mm/s）

Explanation：Speed at which printing happens .

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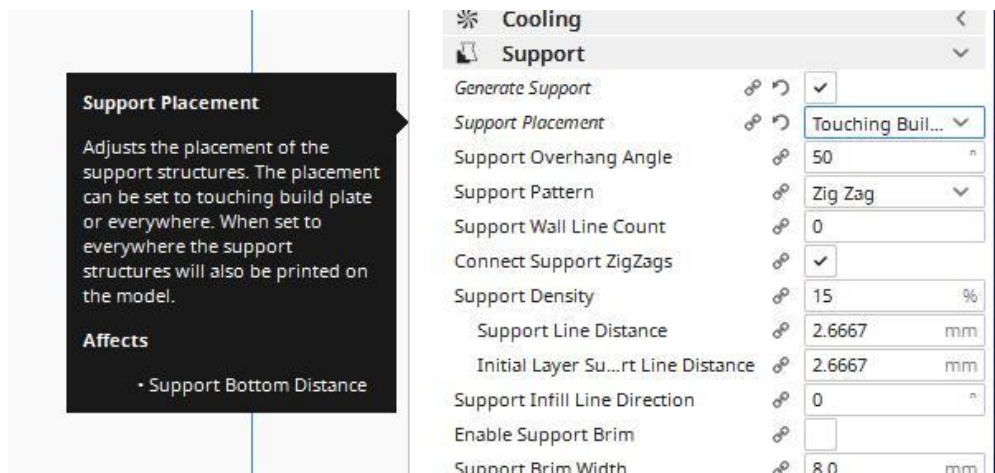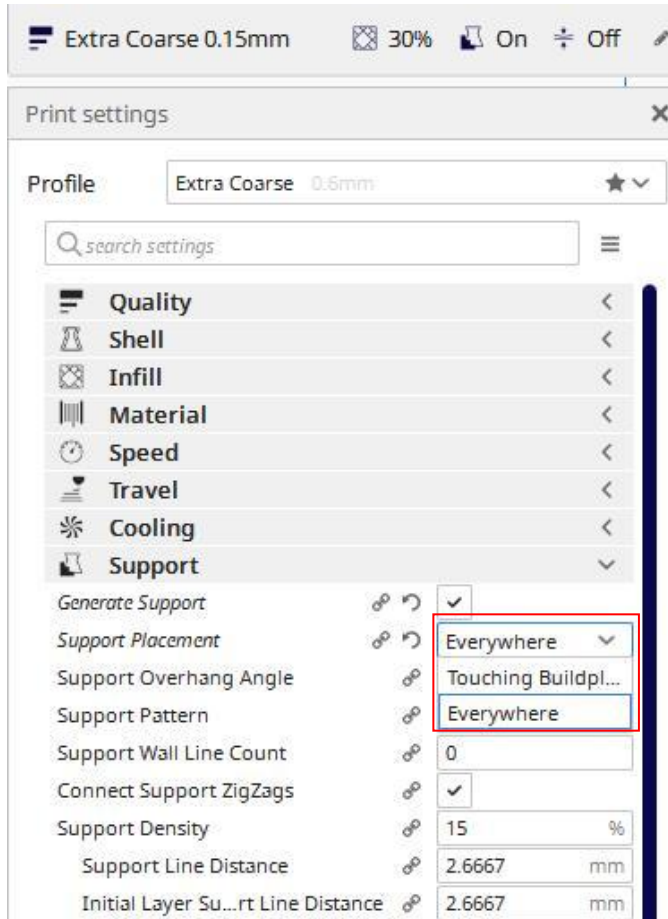
effect.

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7、Print temperature(℃)

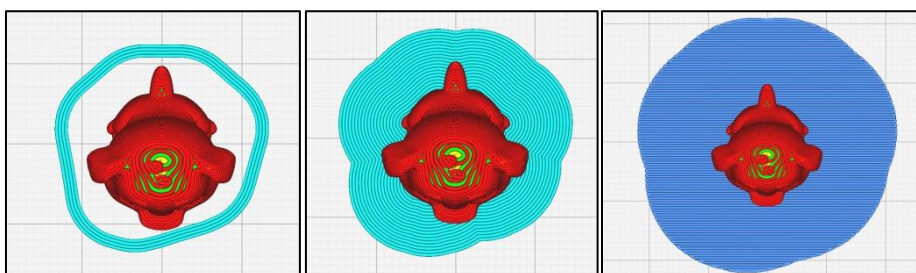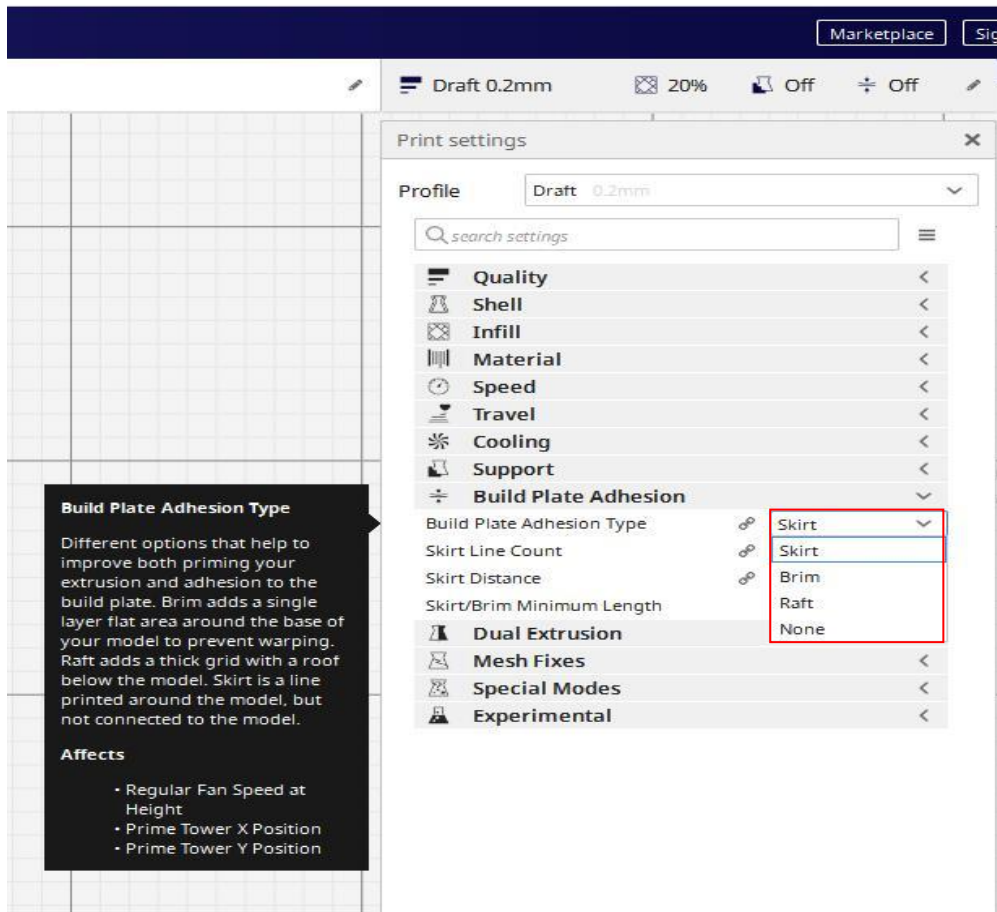Explanation：Printing temperature used for printing . PLA :nozzle is 190-220,generally 200;Bed is 45-50.

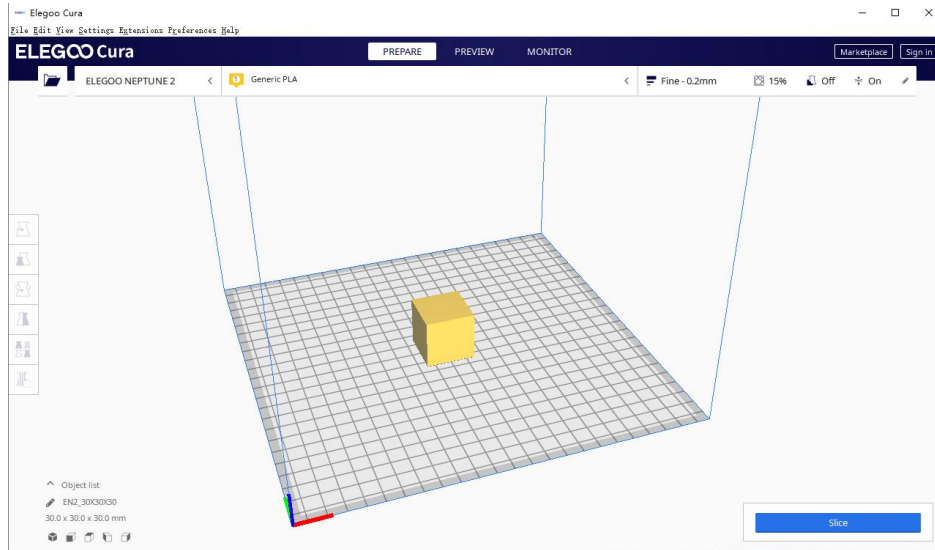## 8、Support type

9、Platform adhesion type

different options that help in preventing corners from lifting due to warping
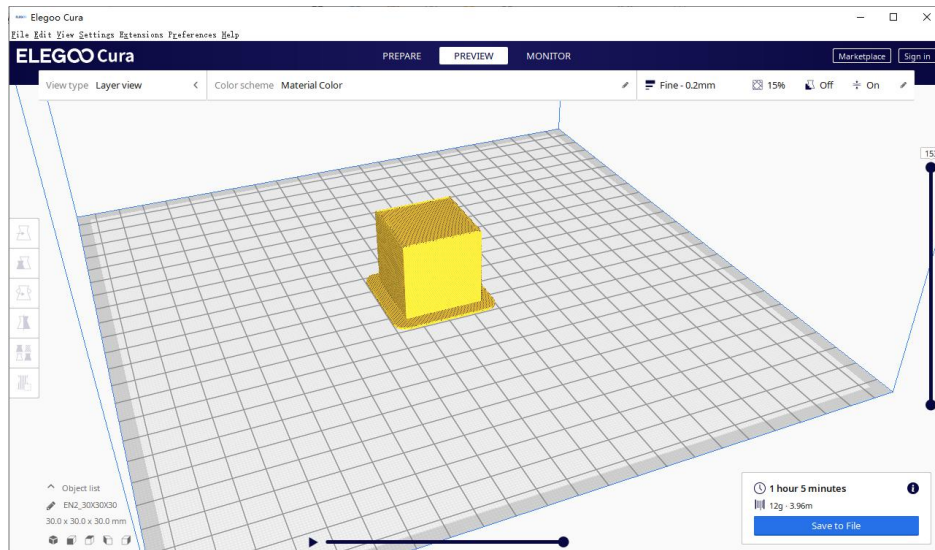
V: Printing Way[1]

a:Memory Card Offline Printing

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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.
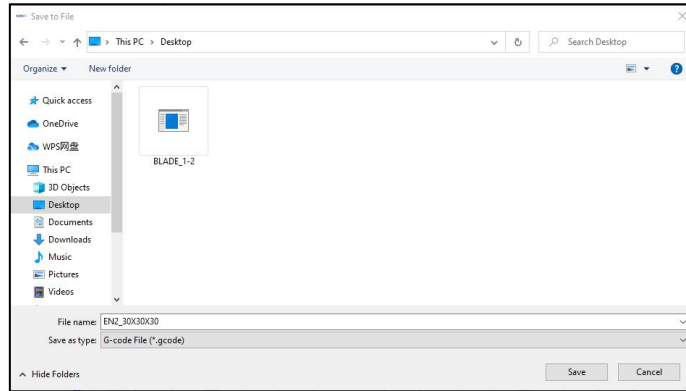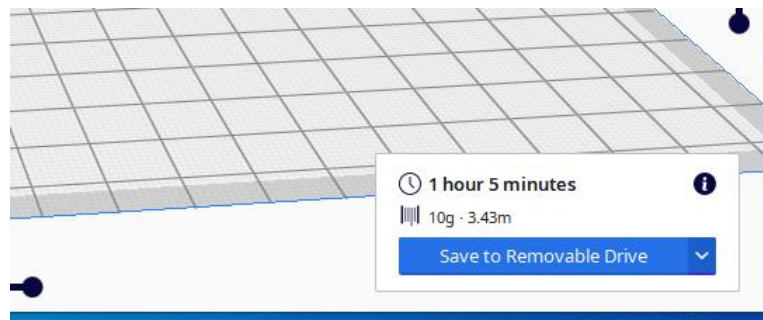

Click slice

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	Type	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

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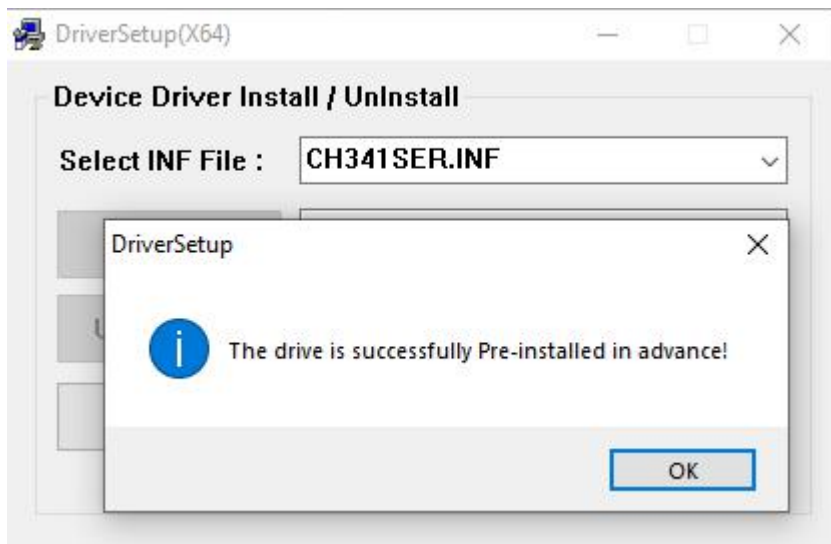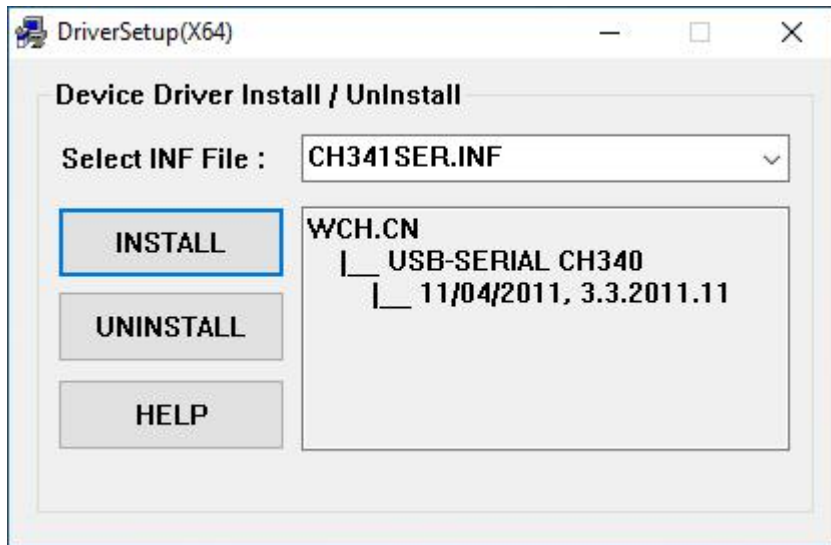

1、Connecting computer to the printer by USB cable.

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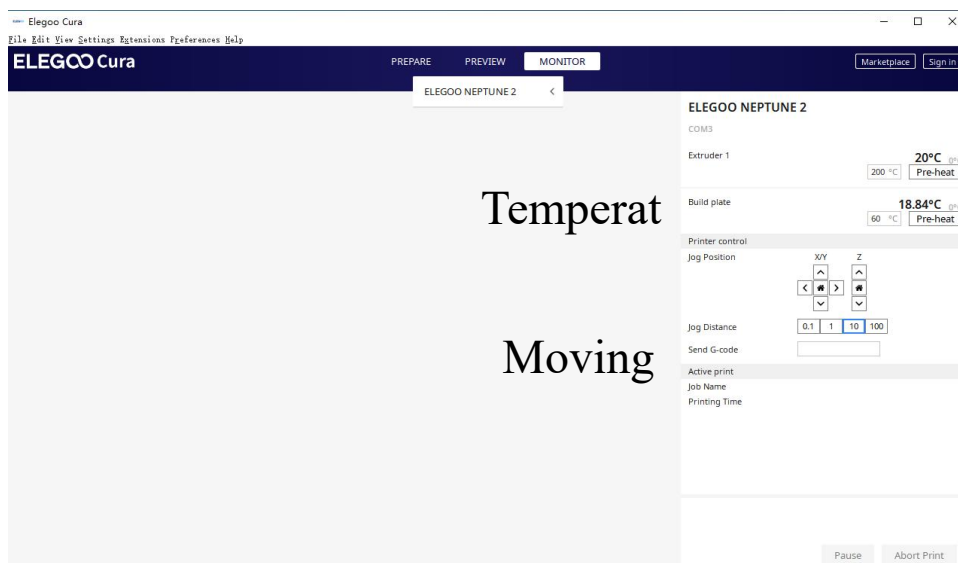
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We can click on the gray ring on the window to control the motion of the XYZE axis. "0.1, 1, 10, 100" are the each amount of motion. The text box in the lower right corner can be input G code to control. If you are not familiar with it, please do not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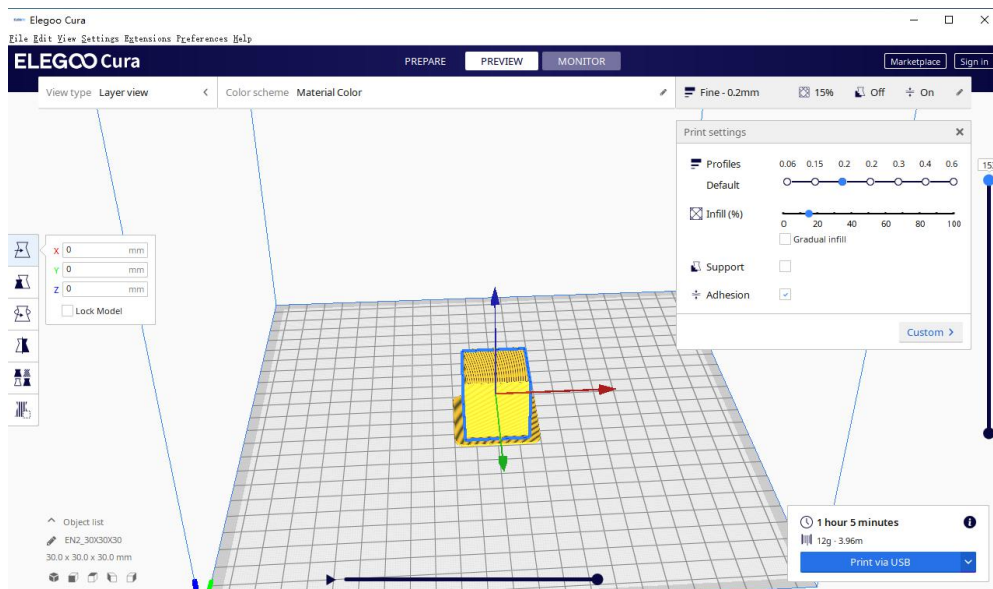
Click Print via USB

Wait for preheating and start printing.

*If you cannot connect properly, please install the corresponding driver or download the third-party driver software.