

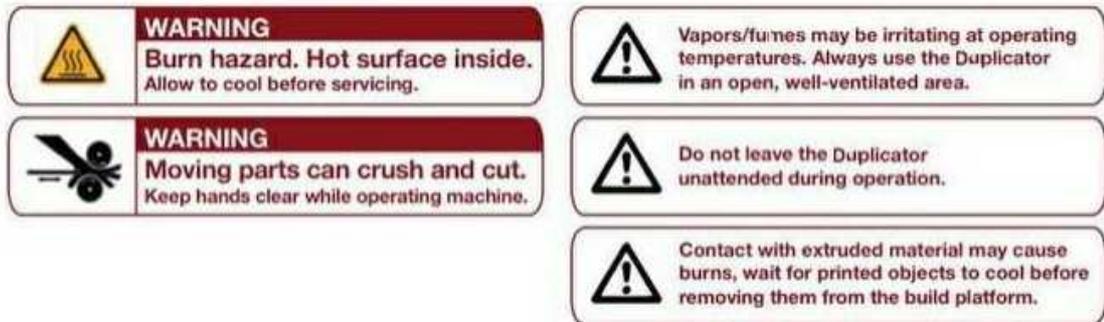
WANHAO i3 FRIST RUN EXPERIENCE



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Safety Information

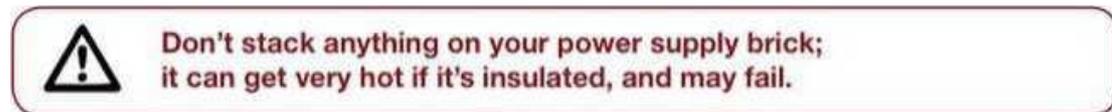
1.1 Caution: The Duplicator i3 generates high temperatures and includes moving parts that can cause injury. Never reach inside the Duplicator i3 while it is in operation, and allow time for the Duplicator i3 to cool down after operation.



The Duplicator i3 is sensitive to electrostatic discharge. Make sure you don't have a static charge on you by touching a grounded object before operating The Duplicator i3 or attempting any adjustments. If opening the Duplicator i3 for service, ensure that the power supply is turned off and the cord is disconnected.

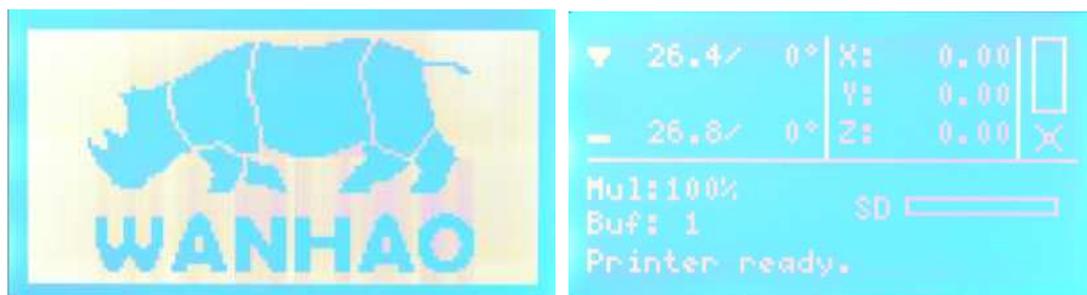
All set

First, make sure that you've completed all the steps in the Unboxing and Hardware Setup section: your Step extruder MK10 should be bolted in place, your filament spool amounted, and your spools of filament mounted on the spool holders. You can plug in your power supply now, too. 2.1



If everything is ready, then flip on the power button on the back of your Duplicator i3 and hold onto your hat. Not literally, though -- if this causes a large gust of wind, you should probably contact tech support at support@wanhao3dprinter.com.

The Duplicator i3 will now guide you through initial setup and your first print. You should see a WANHAO LOGO on the LCD screen. 2.2



There is one black aluminum button beside the LCD screen. Turn and push to navigate and make selections.



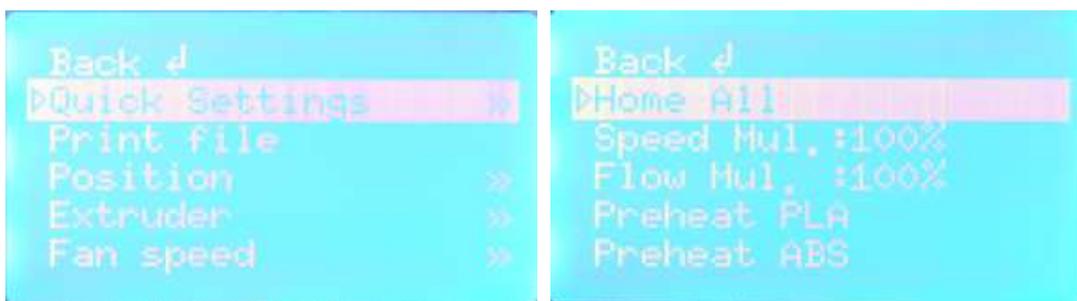
Then this guide will help you to level the platform, load filament, and start a test print.

Follow the following instructions to set up your Duplicator i3 for the first time! And remember, if anything goes wrong, or things aren't happening the way this guide says they should, check out the Troubleshooting page or get in touch with Support.

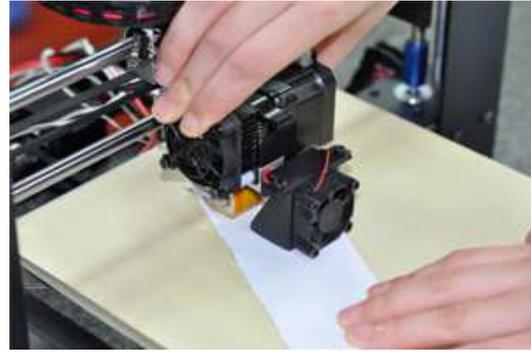
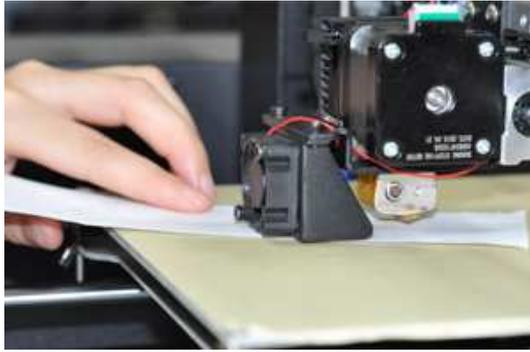
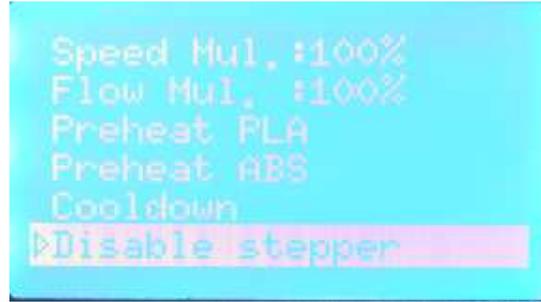
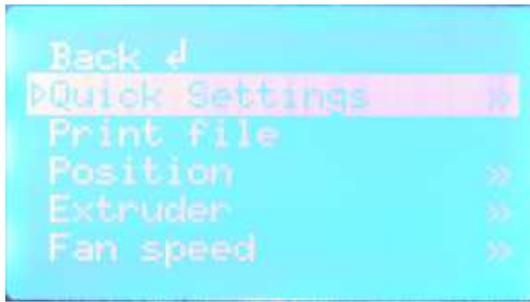
Leveling Your Platform

Pay close attention: leveling your platform is very important to print quality!

First navigate to **Quick Setting---Home All**. The extruder should move to left bottom side of printer.



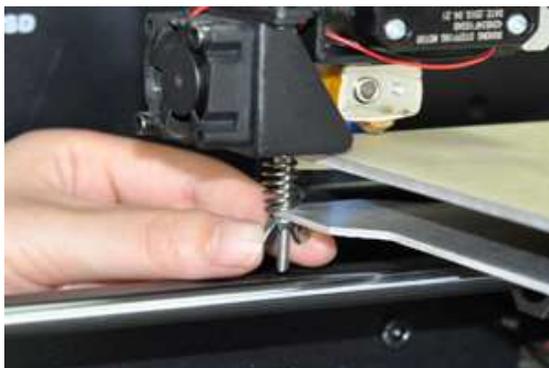
Navigate to **Quick setting---Disable stepper**. Then there's no power on every motor. So you are able to move the extruder on X axis freely. And the printing platform can move on Y axis freely too. By hand move the extruder to different positions over the build platform, while adjusting the spacing between the extruder nozzle and platform with the knobs under the platform and a sheet of paper placed between the platform and nozzle.



Note:

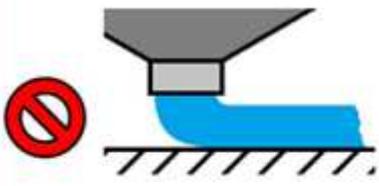
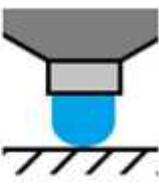
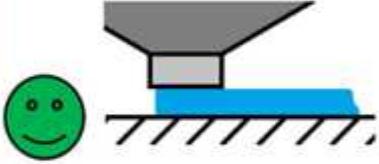
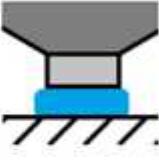
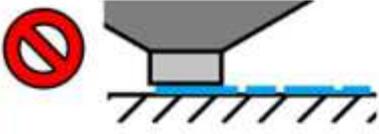
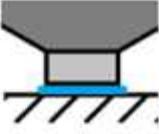
To level the build plate, you must adjust the four knobs which under the build platform. These four knobs lower and raise the build plate.

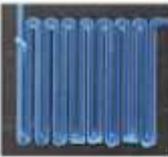
- Tightening the knobs [turning them to the right] moves the build plate away from the extruder nozzle.
- Loosening the knobs [turning them to the left] moves the build plate closer to the extruder nozzle.



- The distance between the extruder nozzle and the build plate should be about the thickness of the A4 paper. It's about .12 mm thick, and should work great. If you haven't got the Support card on hand, a sticky note works well, too.

Here is reference chart for correct distance between nozzle and platform.

SIDE VIEW	END VIEW	COMMENTS
		<p>NOZZLE TOO HIGH: Not enough pressure on the filament into the bed, therefore small contact area between filament and bed. Raft may detach in mid print.</p>
		<p>OK: Filament pushed into the bed slightly to maximise surface area contact with bed, but still maintain extrusion flow.</p>
		<p>NOZZLE TOO LOW: Not enough clearance for the filament to be extruded, damaging either the extruder or the bed.</p>

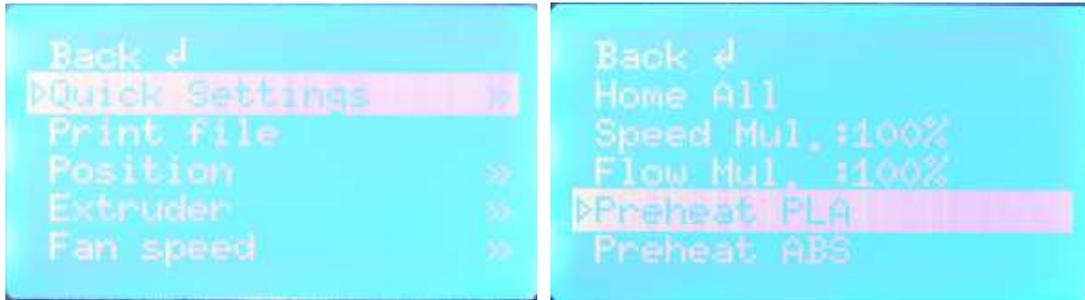
	RAFT	MAGNIFICATION	NOTES
			NOZZLE TOO HIGH: Wavy tracks, or tracks narrower than 1.2 mm (use vernier callipers to check).
			
			
			
			
			NOZZLE TOO LOW: Tracks sides pushed over neighbouring tracks.

When you're done, The Duplicator i3 nozzle height is OK. 3.5

If your platform is too low, your prints might not stick to the surface, and if it's too high, the nozzles could tear the Wanhao Masking tape on the platform surface. If you're having trouble, or if you just need to level your platform again, you can always get back to the leveling Build Plate

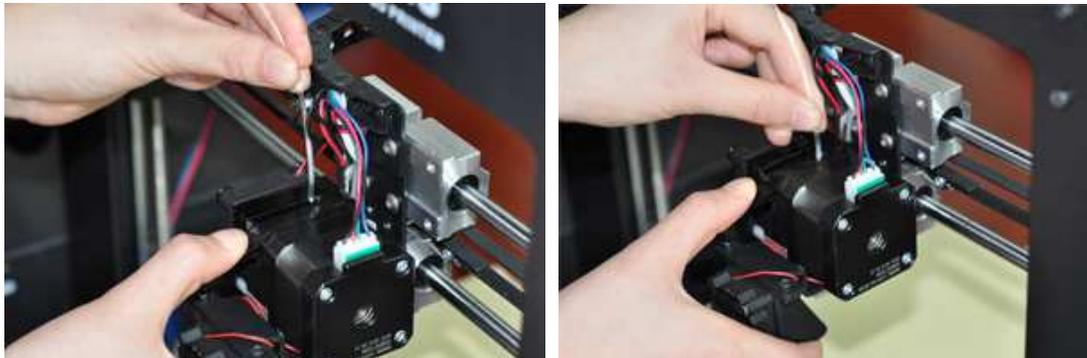
Loading Filament

4.1 The first step of filament loading is to cut the filament tip as sharp as possible. And navigate to Quick Settings—Preheat PLA. The printer will start heating the extruder until the target temperature met.

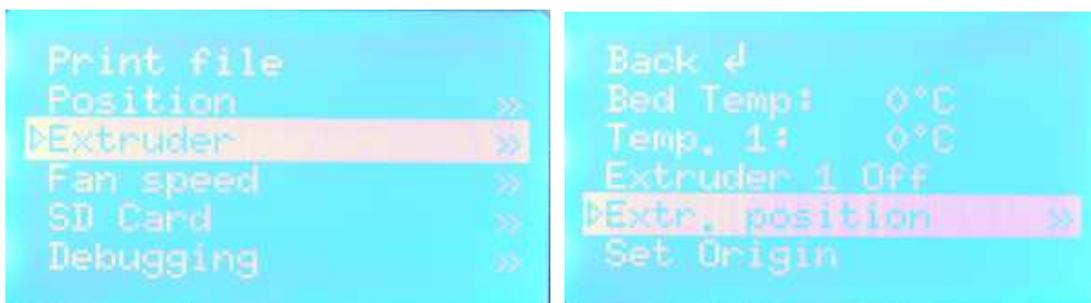


4.2 Make sure to push the extruder spring lever down to open the filament route to the heating chamber.

4.3 Meanwhile insert the filament into the filament hole until the very end of extruder. Then release the lever and you can feel that the filament is grasped by the extruder tightly.



4.4 Navigate to Extruder—Extr.position. Turn the button clock wise to load the filament.

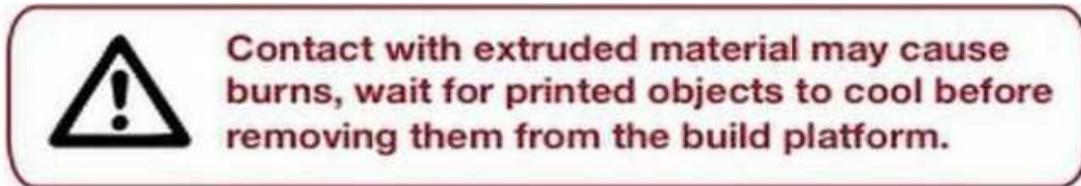


Make sure that the filament loads up from the upper side of spool, so you don't get jams during printing. After you've fed the filament through, stop twist the **Black Button**. The machine will Stop extruding.

IMPORTANT NOTICE

You'll have to wait for a few minutes for them to heat up. Be careful not to touch the bottom of the Step exstruder while it's heating -- it gets up to about 220° C, which is hot and can burn you!

4.6 - 4.7



Once the nozzle is at temperature, you can load filament.

You'll have to use some force, but as long as you're holding only the filament, you can't hurt your Duplicator i3.

Maintain pressure on the filament, and release the spring lever and after a few moments you should feel the motor pulling it in. Then you'll see some plastic start to come out the nozzle. When that happens, you can stop turning the black Button. Don't be surprised if you don't see the color you expected -- there's probably still a bit of plastic inside the extruder left over from the testing process.

After The Duplicator i3 is done extruding, wait a moment for the extruded plastic to cool down before you pull it away. You can discard the plastic in your normal garbage, or recycle it, if your recycling system can handle PLA. Don't leave plastic clinging to the extruder nozzle -- if you do, newly extruded plastic might stick to the nozzle instead of the build platform.

The Duplicator i3 will give you a couple of chances at this before continuing. If you don't get it quite right the first time, you can load filament by pressing the spring lever and inserting the filament.

Your First Print

Now your Duplicator i3 is ready, if you're ready to print. 5.1 Make sure your **Micro SD card** is in the Micro SD card slot at the right side of The Duplicator i3 control box. Then, if you've successfully leveled your platform and loaded filament into your extruder, answer yes! The Duplicator i3 will drop you into the "Print from SD" menu. Select one of the prints we pre-loaded onto the SD card and watch The Duplicator i3 go to work!



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