

User's Manual (SL-300)

Safety Instructions:
Please view following matters before using the 3D Pen

- 1.Please pay attention to electricity safety when operating!Do not use this product near bathtub, hand wash basin , bathroom or other place with water, otherwise it may cause death because of electric shock ! Please unplug the power supply in time after using.
- 2.This pen tip may cause burns after heating, please do not touch pen tip or any part near it.
- 3.This product is suitable for over five-year old children and adults. Children should use this product under adults’ supervision.
- 4.This product is not water-proof or breaking-proof. It is forbidden to use the pen tip to stick any hard objects. It is also forbidden to insert any other objects into the loading port or into pen tip.
- 5.Consumable filament for this product : SL-300 PLA & ABS; Filament diameter 1.75 ±0.02mm. Please use original filament. It might cause damage to the product if choose non-original filament.
- 6.When using this product at the first time, it’s normal that a little smoke comes out from the nozzle, which won’t affect the product using.
- 7.After finishing using this product, please ensure to unload the filament and cut off power supply.
- 8.All of the products will pass qualified testing before delivery, so it’s normal if there are a few filaments left in the nozzle. Please feel free to use.
- 9.In order to ensure continuous using, it is recommended to cut off power supply to stop for ten minutes after one-hour continuous using , then back to use.

Warranty:

One year since delivery date, in the situation of nature damage but not man-made. Damages caused by non-original filament or not following user’s instruction are outside the scope of free warranty.

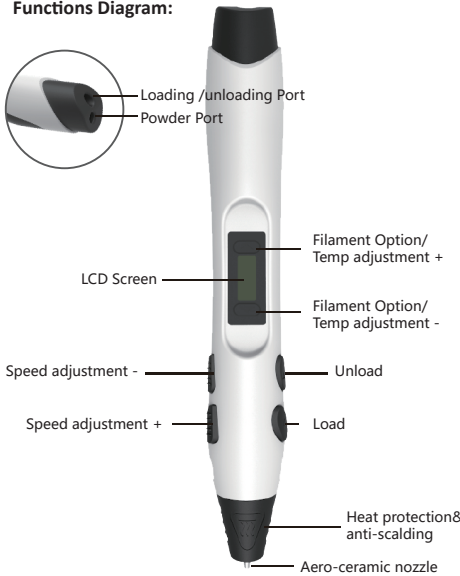
In the Box:

3D Pen	1
Power Adapter	1
Filament	PLA 3m×2
DCSV USB Cable	1
Instruction	1
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Specification and Parameters:

spec/parameter	SL-300	
N.W	55g	
Size	175 (L) ×24 (W) ×28 (H) mm	
Extra power input	DC 5V、 2A	
Adapter input	AC100V～240V 50/60HZ 0.35A	
Power input	DC 5V ± 0.25V	
Consumable filament	PLA/ABS 1.75±0.02mm	
Working temp	PLA 160℃～180℃	ABS 180℃～210℃
Working condition	10℃～35℃/relative humidity: ≤85%	
Unloading mode	click/double click	

Functions Diagram:



Filament End Tip:



Operation Instructions:

- 1.Power on
Use the 3D Pen data cable to connect with DC 5V 2A extra power or power adapter. When words show on LCD screen, it means power on.
- 2.Filament Selection/ Preheating
①Click “Filament Option” key to select PLA or ABS according to the filament you are going to use.
②Click “Load” key, the red light is on, it means the device is preheating. (Preheating time is around 70-100s) The preheating temperature will be showed on LCD screen. When the red light turns to green, it means preheating is over.
- 3.Load Filament
When the light turns from red to green, it means preheating is finished. Now you can select one of the two ways below to feed in the filament: (Attention the filament: PLA、 ABS)
A:Click “Load ” key.
B:Double click “Load” key and press it constantly
When the motor starts to work, feed your filament into “Filament loading port”. Once the filament was extruded from nozzle, you can start drawing.
(Click “Load”key,the motor will unload the filament about 2mins. If there is no clicking operation when the pen is working, it will enter into sleep mode automatically every 8mins. If you want to continue using, just click the “Load”key.)

Trouble Shooting:

Please follow the below instructions if any defect happened. If still could not solve the problem, please contact with the distributor whom you bought the 3D Pen from.

Defect phenomenon	Causes	Solutions
LCD screen is off	Adapter breakdown	Change the adapter
	USB cable breakdown	Change USB cable
Red & green indicator light is flashing	low-powered adapter	Change the adapter
	Low-powered power bank	Change the power bank
No filament comes out from nozzle tip	Too little filament comes out	Increase the speed of extruding filament
	Low temperature	Increase the temperature
	Slip on the gear	Unload the filament then load with new filament
	Filament loading failed	Unload the filament and make Sure the end of the filament is flat
	Poor contact on the nozzle	Take apart the nozzle and re-install again
	Extruding filament with bubbles	Decrease the temperature
	Blocked nozzle	Increase the temperature and speed to squeeze the remaining filament out
Defaults in use of PLA mode	ABS filament remains in the pen	Re-connect the 3d pen again, and turn into ABS mode
	Unstable filament flow	in the highest temperature, then load the PLA filament
	Blocked nozzle	until the PLA filament comes out from nozzle
ERR displayed on the screen	Temperature is too high for PLA mode	Unplug and cool down the pen for about 3 minutes then plug the pen
	Nozzle is loose	Take apart the nozzle and re-install

⚠ SPECIAL NOTICE

Item	Filament Replacement
Mode	SL-300
Steps	ABS →PLA
1	Unload ABS
2	Feed the “PLA” filament into “Filament loading port”. Click“Load” key to clean the nozzle for 2-3 minutes.
3	Unplug DC 5V power line and cool down the nozzle for 3-5 minutes.
4	Re-connected the power supply, click the “Filament Option” keys (at both ends of LCD screen). You can see “PLA”,“ABS”, “PCL” on LCD screen. Please choose “PLA” mode.
5	Click “Load”key, red light indicator is on, it means the device starts preheating(around 70 s). LCD screen will display increasing working temperature. When the red light indicator turns into green, it means preheating is over. It’s time to load PLA filament.
6	For next steps ,please kindly refer to the “Operation Instructions” step 3- 6.

Instructions for temperature adjustment

Due to filaments’ different melting point with different colors, in order to improve the quality of creation, please follow below suggestions:

- 1.In use of PLA or ABS, if the filament is “cracking”, it means the temperature is too high, please try to decrease the temperature by 8-15℃ using “Temp adjustment-”key .
- 2.In use of PLA or ABS, if there are too many bubbles, it means the temperature is too high, please try to decrease the temperature by 3-8℃ using “ Temp adjustment-”key .
- 3.In use of PLA or ABS, if the extruded material is in dull color , it means the temperature is too low, please try to increase the temperature by 5-10℃ using “Temp Adjustment+”key .
- 4.In use of PLA material, if the extruded material is runny to drip, it means the temperature is too high, please try to decrease the temperature by 10-15℃ using “ Temp adjustment-”key .
- 5.The normal extruded material should be smooth, mellow without bubbles(little bubbles are OK).

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