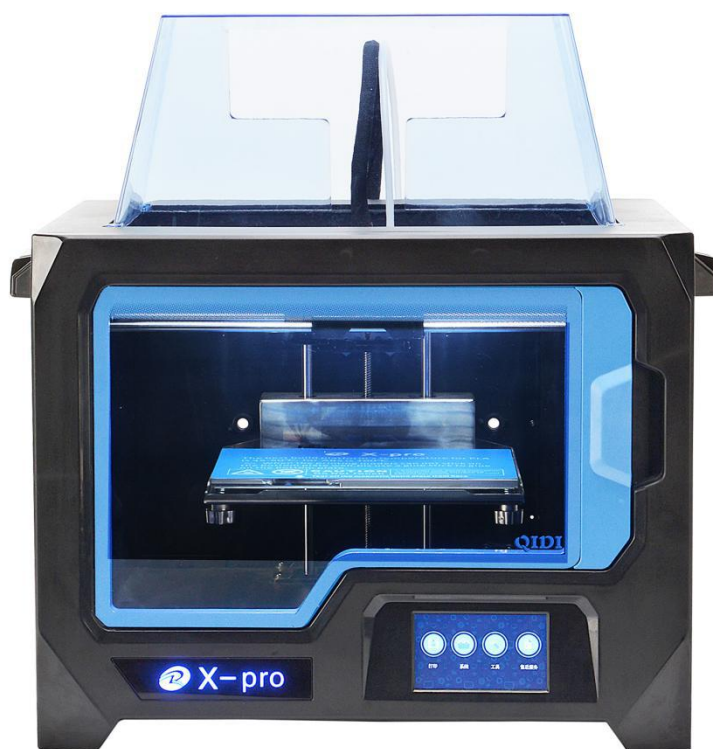


# X-pro Guide

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This guide only applies to the X-pro 3D printer.



# X-pro

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## Caution

1. Do not remove the wrapping from around the nozzle.
2. If you are printing with PLA filament, please remove the lid and open the front door and two side windows for extra ventilation for a better printing performance.

## Warning

1. High Temperatures! The build Plate may have been heated before, so make sure it has cooled down before working inside the printer.
2. Please keep loose clothes, jewellery and long hair away from all moving Parts.




## Slicer

The Slicer is on the USB Pen Drive supplied.

# Power supply setting

## STOP-READ FIRST

### **Caution**

-  For US customers:the power setting has been set for you to 115V.
-  For non-US customers:Determine the voltage in your location.Depending on the voltage in your area,you may have to switch the power setting from 115V to 230V before you plug in the power cable.
-  Failure to set the power supply setting correctly will damage the 3D printer electronics.

Tear off the warning sticker will see the switch!



## Customer Service Support:

Thank you for purchasing our QIDI Technology 3d printer.

If you are experiencing any problems with the printer,  
please feel free to contact us!

We will reply to you within **12 hours**.

If not, our company will offer you 2 nozzles and 2 pieces of  
blue platform sticker (PC Glue) for free as compensation.

### Contact:

E-mail: [judy@qd3dprinter.com](mailto:judy@qd3dprinter.com)  
[emily@qd3dprinter.com](mailto:emily@qd3dprinter.com)

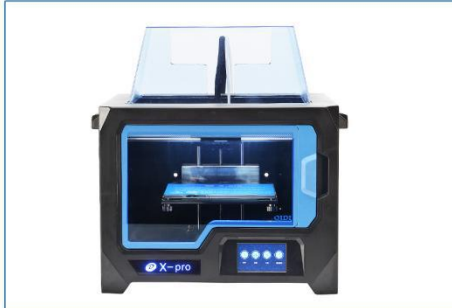
If you have any suggestion or complaints, please contact with  
this **E-mail address:**

CEO: Diqiang Xue (Reply within 24 hours.)  
E-mail: [616038502@qq.com](mailto:616038502@qq.com)

Thank you and regards,  
QiDi Technology Co., Ltd.

Due to the time difference, if we could not reply in time, please understand!

## Kit Contents



3D Printer×1



Acrylic Covers×1



Power Cable×1



Screw Driver×1



User's Guide



USB Pen Drive ×1

**( Please read the Guide  
before you start to use  
the 3D printer. )**

## Kit Contents



Filament Guide Tube ×2



Spare Part Box ×1



Filament×2



Spool Holder×2

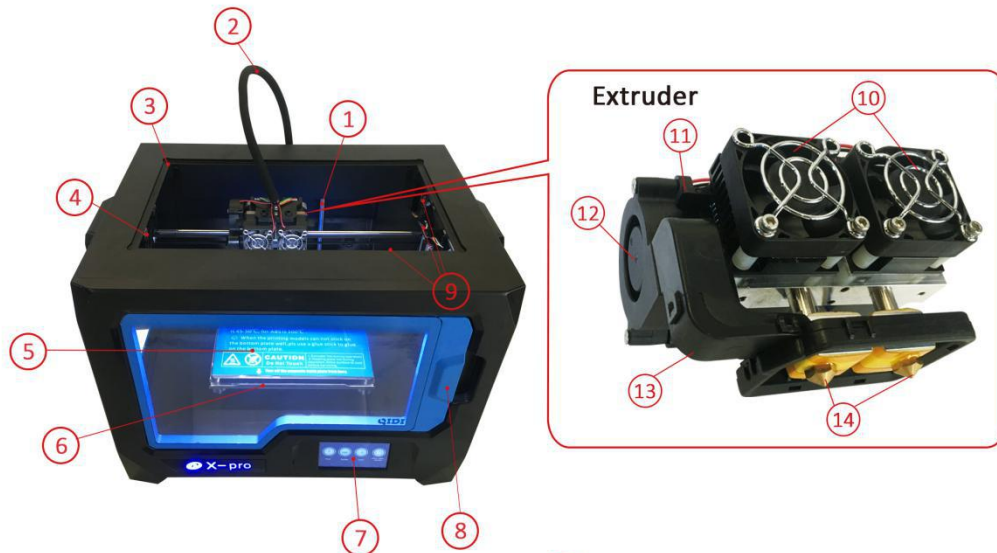


Turbofan Baffle×1

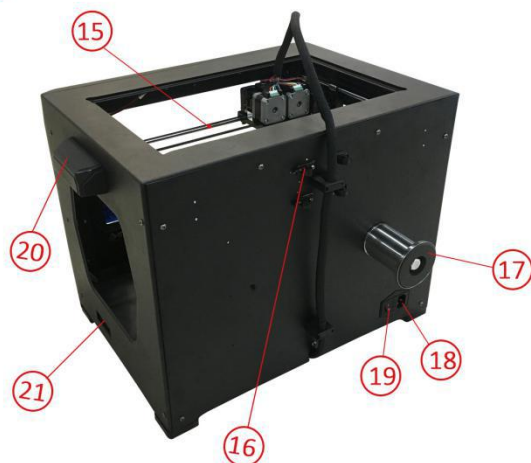


Scraper×1

## Getting To Know Your 3D Printer

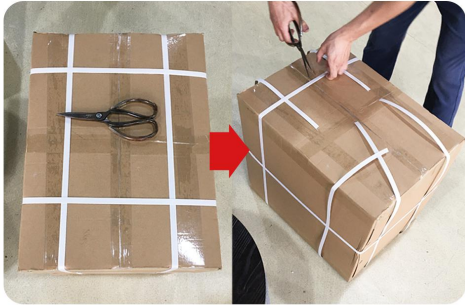


1. Z-Axis Guide Rod
2. Extruder Cable Bunch
3. Acrylic Cover Slot
4. Y-Axis Guide Rod
5. Build Plate
6. Build Platform
7. LCD Panel
8. Buttons
9. X、Y、Z-Axis Switch
10. Cooling Fan
11. Spring Presser
12. Turbofan
13. Turbofan Baffle
14. Nozzle
15. X-Axis Guide Rod



16. Filament Guide Tube Buckle
17. Spool Holder
18. Power Switch
19. Power Input
20. Handles
21. USB pen drive input

## Unpacking



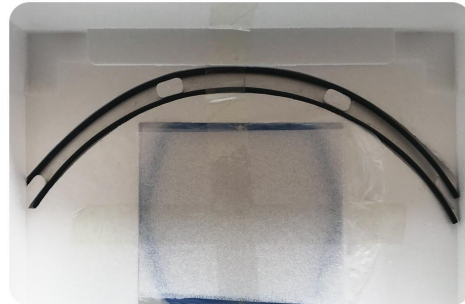
**1.**Place the box on the floor with a clean flat surface.Cut off the outer box packing belt.



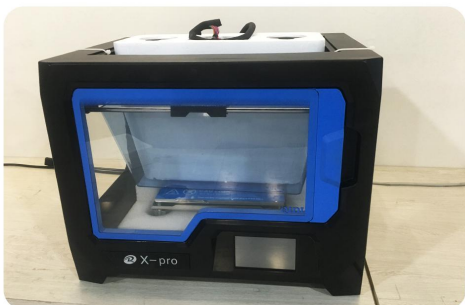
**2.**Take the top foam sheet out.



**3.** Firmly grasp the two side handles of QIDI TECH I 3D Printer. Lift it out from the carton and place it on a stable surface.



**4.**Take out the acrylic cover accessories from the bottom of the box.



**5.**Remove the packing material.

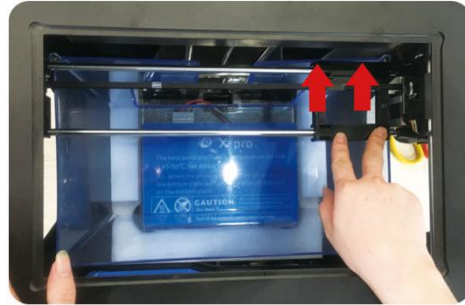


**6.**Cut off the packing belt.

## Unpacking



**7.** Please take out the extruder and put it on a flat surface, then remove the foam box.



**8.** Push the X-axis backwards.



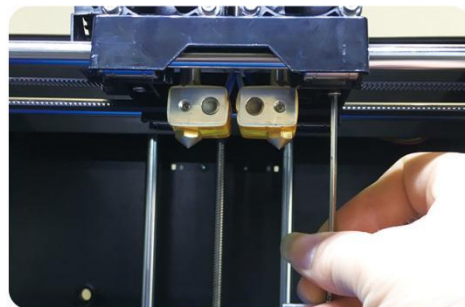
**9.** Take out the printer's cover.



**10.** Lift the platform with two hands.

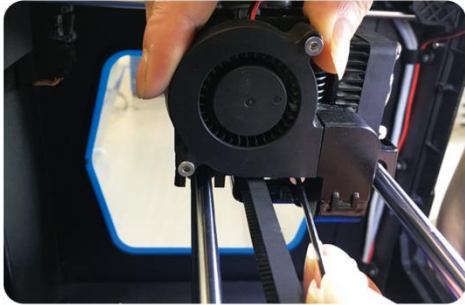


**11.** Take out the foam, the glue stick is in the center of the foam.



**12.** Install the dual extruder, tighten the screws.

## Unpacking

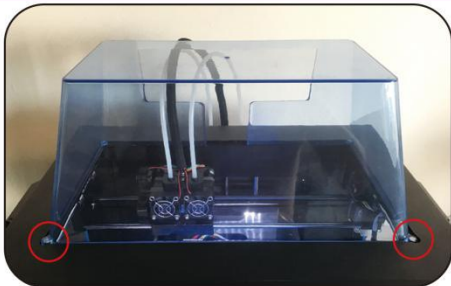


13. Install the turbofan mouth piece.

14. Congratulations! You've finished the unpacking process. (Tip: Save your printer packaging for future transportation and storage. )

## The Installation Of The Acrylic Cover

### Top Acrylic Cover Installation



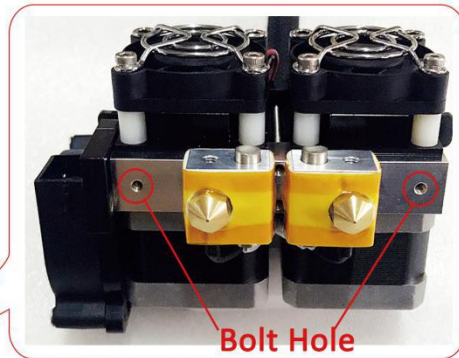
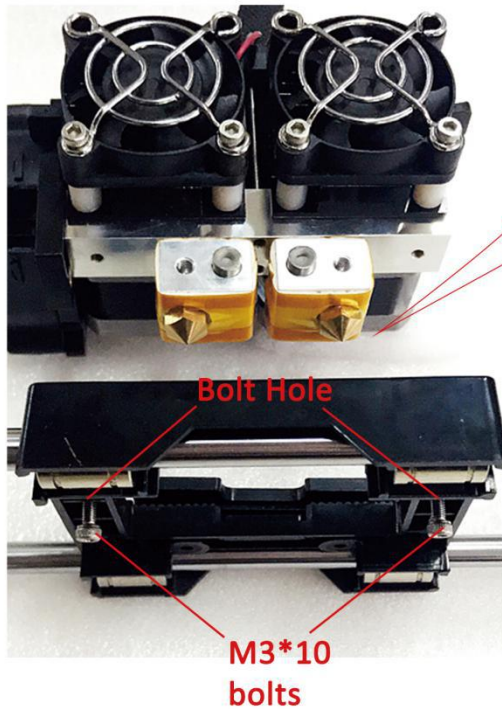
The acrylic cover only need to put in the top of the printer's slot.

### Side Windows Installation



The side windows have magnets in them, so please match the correct side window to the correct side for perfect fit.

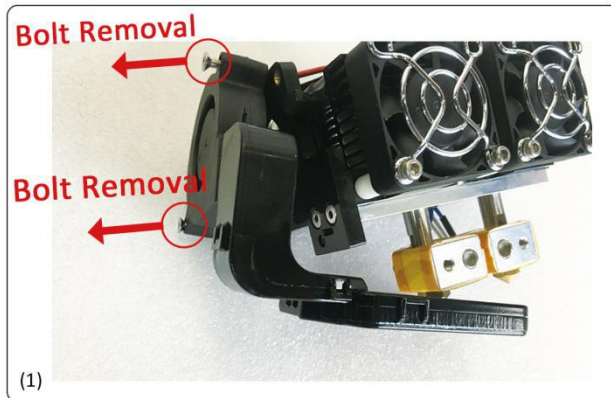
## Extruder Assembly



### Extruder Assembly

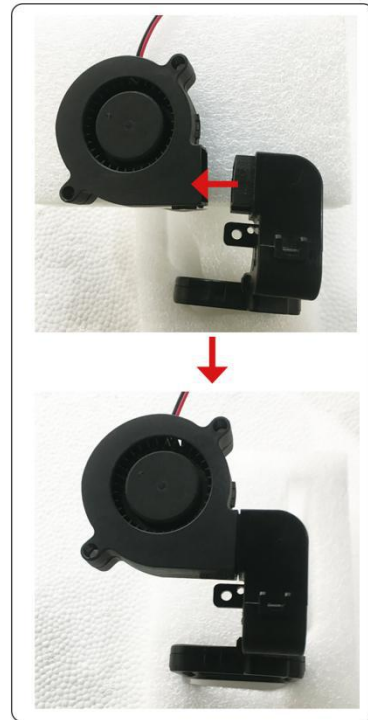
- (1) Place the dual extruder on the extruder seat. (As shown in the left picture)
- (2) Take the M2.5 Allen Wrench from the tool bag and remove two screws from the extruder.
- (3) Adjust the extruder location to align the bolt holes.
- (4) Secure the extruder onto the extruder seat by screwing the M3\*10 bolts in.

## Turbofan Baffle Assembly



### Turbofan Baffle Assembly

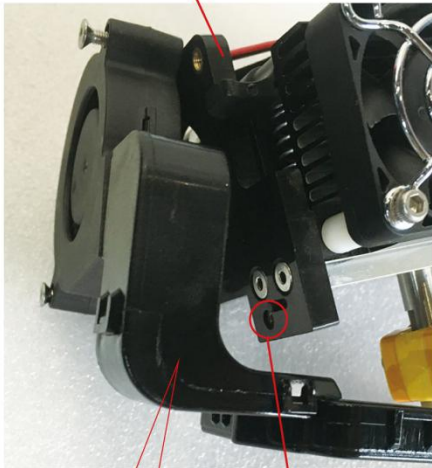
- (1) Use the Allen Wrench to remove two turbofan bolts. (As shown in the picture above)
- (2) Take the turbofan baffle from the extruder's accessory kit.
- (3) Install the turbofan baffle to the turbofan. (As shown in the top-right picture)



**Caution:** During installation, please take care of the turbofan cable.

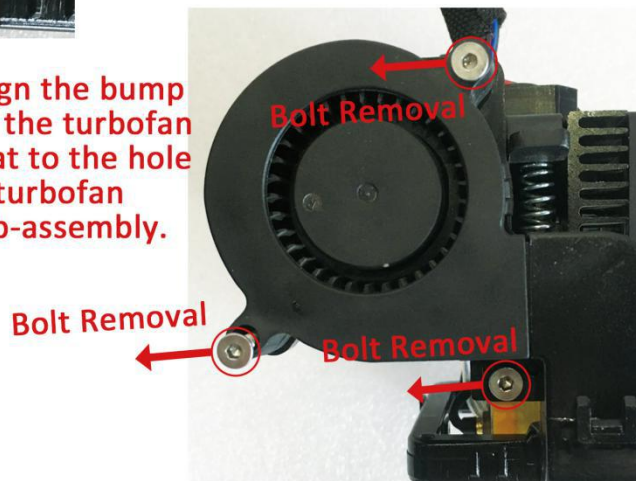
## Turbofan Baffle Assembly

**Turbofan Seat**



**Align the bump on the turbofan seat to the hole in turbofan sub-assembly.**

- (1) Place the turbofan sub-assembly besides the turbofan seat.
- (2) Insert the bump on the turbofan seat to the turbofan sub-assembly.
- (3) Screw the two bolts in.
- (4) Take out the M3X8 screw from the turbofan mouth piece bag, then install the screw on the position as the picture shows.



**Refer to the video in folder "7".**

1.QIDI TECH X-PRO 3D Printer Start-...	2017
2.3D Slicer	2017
3.Test file	2017
4.wifi setting video	2017
5.Breakpoint printing video	2017
6.TPU Extruder Device	2017
7.How to install the turbofan	2017

## Filament spool holder

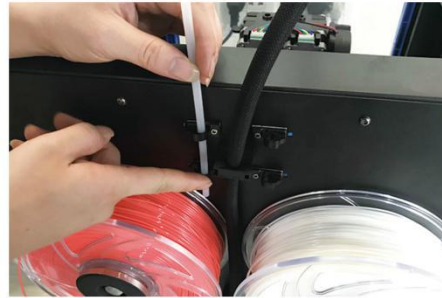
Insert the filament spool holder,  
tighten it in clockwise direction.



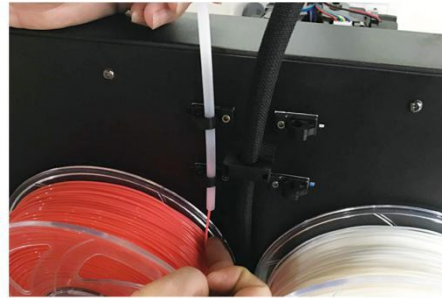
## Filament guide tubes

*Tools Needed:None*

Step 1: Filament guides should be secured in filament guide holders on the back of the 3d printer.



Step 2: Insert the filament in the filament guide tube.





Step 3: After insert the filament into the extruder. Insert the filament guide into the extruder's cap

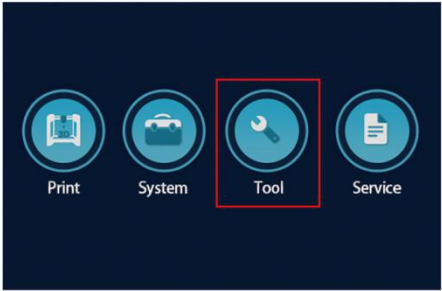

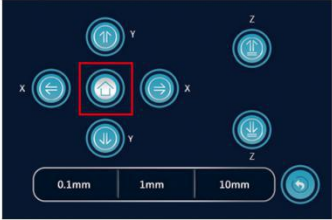




NOTE:Make sure you provide enough slack in the filament guides so they can move with the extruder.

## Display screen operator interface

 <p>Print System Tool Service</p>	<p>a. Click “System” icon.</p>
 <p>Info About Language TPAdjust Factory Sound LED Light Back</p>	<p>① Language: Multiple languages are available. ② Sound: The sounds can be adjusted. ③ LED Light: The LED light can be turned on / turned off.</p>

## Display screen operator interface

	<p>b. Click” Tool” icon.</p>
	<p>① Manual: User can move the X,Y,Z axis separately, click the “house” icon which on the center, the axis will move to home position.</p> 
<p>② Internet: Click on this Icon,the network and Wi-Fi setting can be opened.</p> 	<p>③ Click the icons to check if the three fans work properly.</p> 

## Adjust the build platform

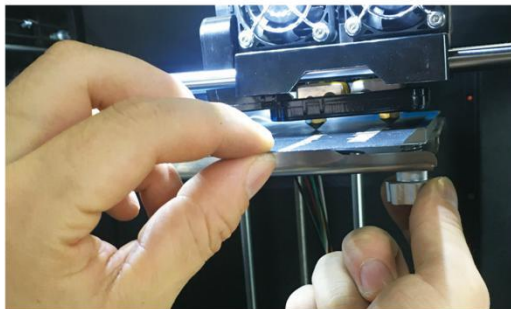
Step 1: Select “Tool” first, then select “Leveling” on the screen.



Step 2: Waiting for the extruders to the specified location. Carefully move the extruders to the left front corner of the print platform. Check the distance between the build platform and the extruder by using the leveling paper.

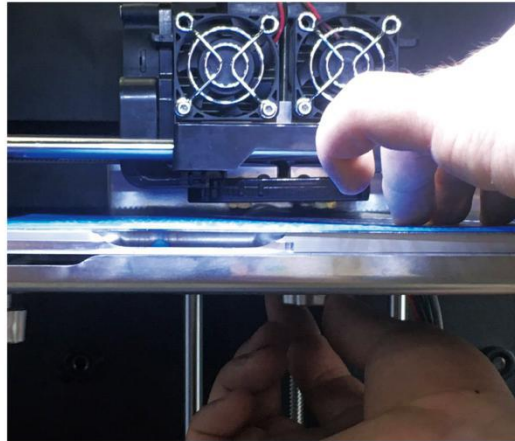


Step 3: Carefully move the extruders to the right front corner of the print platform. Check the distance between the build platform and the extruder by using the leveling paper.

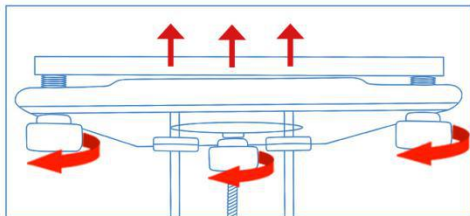


## Adjust the build platform

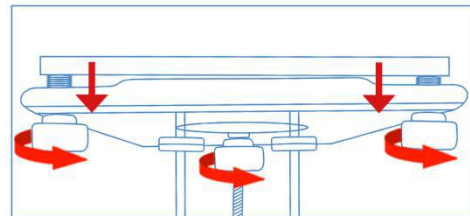
Step 4: Carefully move the extruders to the center back of the print platform. Check the distance between the build platform and the extruder by using the leveling paper.



**NOTE:** The distance shall be similar to the thickness of the leveling paper. Before the first printing, please level the build platform for several times to ensure the build platform has been leveled well.

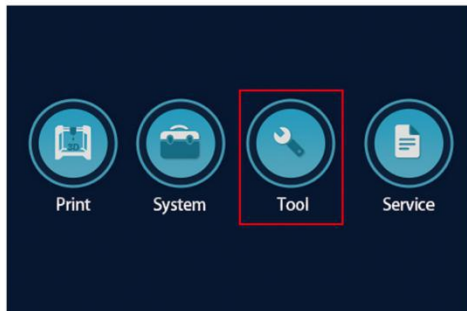


**Turn the knob clockwise**  
Raise the build plate to reduce the distance between the nozzle and build plate.



**Turn the knob anticlockwise**  
Lower the build plate to increase the distance between the nozzle and build plate.

## Loading Filament



1. Click "Tool" icon.



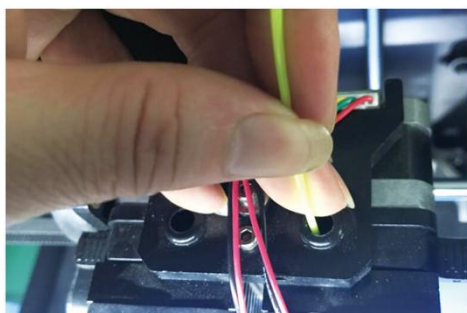
2. Click "filament" icon.



3. Click on the number and when the colour changes to red, it shows the temperature is rising.



4. When the temperature reaches to 220, click icon.



5. Press down slowly on the filament, while waiting for the filament to flow out of the extruder.

## Unload the filament

When the user is exchanging the filament, the user needs to use the unload function as described below:



1. Click "Tool" icon.



2. Click "filament" icon.



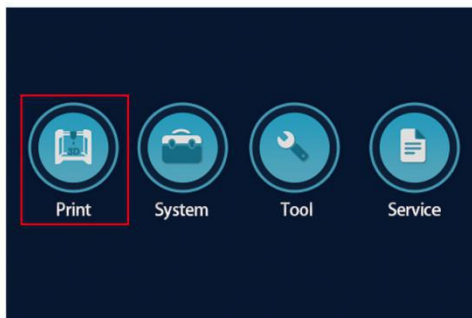
3. Wait for the temperature to reach 220°C, and then click the down icon ①. When the filament starts to come out of the extruder click on the stop icon ②.



4. Click on the Up icon and the filament will start to unload, pull the filament out as fast as possible.

## First printing

The user can print the right nozzle PLA test file “xiaogao.gcode” after the user has finished leveling the build platform and has loaded the filament.



1. Click “Print” icon.



2. The user has to find the “xiaogao.gcode” file and click on it to enter into the print screen.



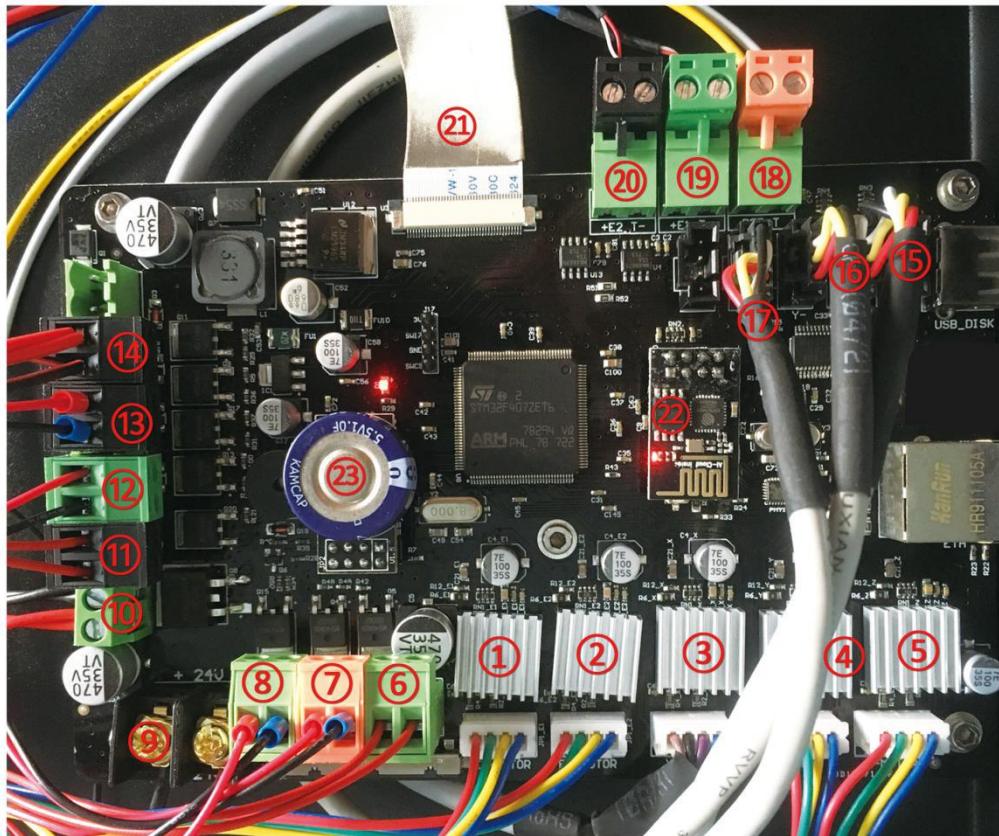
3. Click the icon ,start to print.



4. In the pop-up interface, user can see the progress.

**Friendly Reminder : When printing the large size model, the thermal barrier shrinkage of the model may cause the build plate to warp up, please use the clips.**





- |                                   |  |
|-----------------------------------|--|
| 1. Motor Cable of Right Extruder  | 13. Left Extruder Fan Cable                |
| 2. Motor Cable of Left Extruder   | 14. LED Light Cable                        |
| 3. Motor Cable of X axis          | 15. Limit switch cable of Z axis           |
| 4. Motor Cable of Y axis          | 16. Limit Switch Cable Of Y Axis           |
| 5. Motor Cable of Z axis          | 17. Limit Switch Cable Of X Axis           |
| 6. Heating Pipe of Right Extruder | 18. Heat Bed Temperature Measurement Cable |
| 7. Turbofan Cable                 | 19. Thermocouple Of Right Extruder         |
| 8. Right Extruder Fan Cable       | 20. Thermocouple Of Left Extruder          |
| 9. Power cable                    | 21. Screen Cable                           |
| 10. Heat Bed Heating Cable        | 22. Wifi Module                            |
| 11. Heating Pipe of Left Extruder | 23. Breakpoint Printing Module             |
| 12. Bottom Fan Cable              |  |