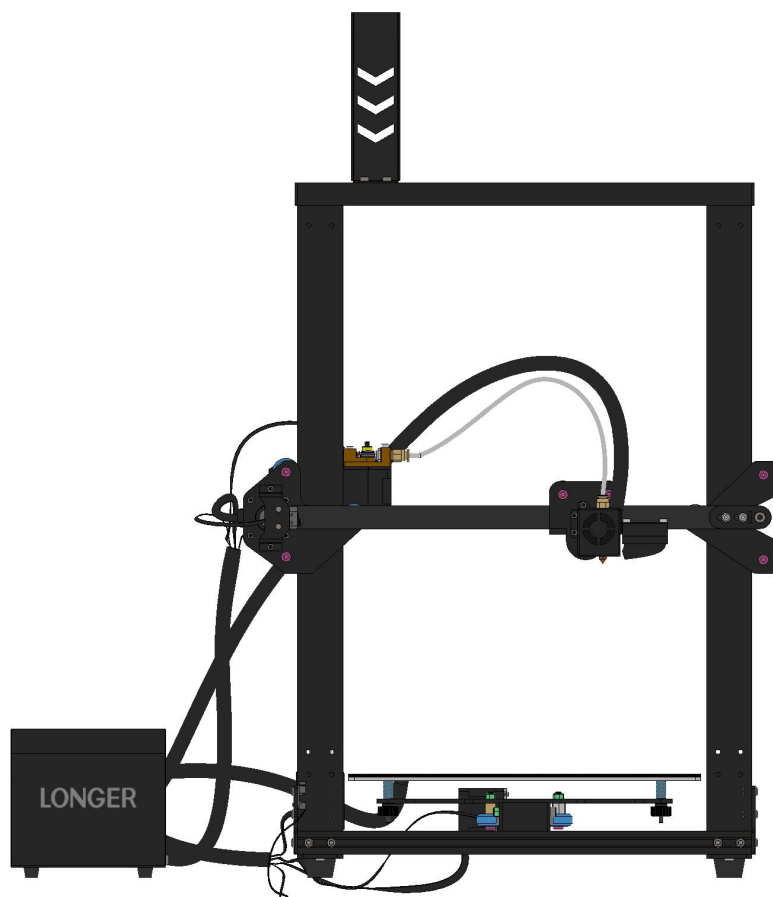


LK1 instruction manual

LONGER



catalog

A.	product information.....	2
(1)	Model parameter.....	2
(2)	Machine introduction.....	3
(3)	Nozzle module exploded view.....	3
(4)	Machine assembly.....	4
1.	Rack installation.....	4
2.	wiring.....	5
3.	Power regulation.....	1
4.	Pre-use inspection and leveling.....	1
5.	Leveling method.....	2
6.	Place filament, feed.....	3
B.	Machine operation.....	4
(1)	Machine control.....	4
(2)	Main interface.....	5
C.	Installation and use of Changlang 3D slicing software.....	6
(1)	Software installation.....	6
(2)	Model selection.....	7
(3)	Software usage introduction.....	8
(4)	Detailed software parameters.....	8
(5)	Export gcode format for printing.....	9
D.	Instructions for printing online.....	10
(1)	Printer connection.....	10
(2)	Software settings.....	10
(3)	Online printing.....	11
(4)	Professional settings.....	12
E.	Description of power failure and break detection function.....	13
(1)	Power failure.....	13
(2)	Broken material detection.....	13
F.	Machine Usage FAQ Guide.....	15
	Question 1: How to update the firmware?.....	15
	Question 2: What should I do if the machine does not discharge?	15
	Question 3: What should I do if the machine does not retreat when the material is returned?.....	16
	Question 4: What can I do if I can't power off?.....	16
	Question 5: When the machine is leveled, when the nozzle moves to the left, it can be leveled normally. When the nozzle moves to the right, it is found that the nozzle and the hot bed are far apart or very close. What should I do if the spring is adjusted to the limit position?	17
	Question 6: After the machine is heated, the spit is normal, but when the first time of printing, the silk falls on the platform and curls, and then after printing a few layers, what should I do if it is off the platform?.....	17

Safety Precautions

1) The temperature of the nozzle parts can reach 250° C during the operation of the machine. To ensure your safety, it is forbidden to touch the model and nozzle directly with your hand while the printer is printing or cooling.

2) During the operation of the machine, it is forbidden to reach into the machine to prevent pinching.

3) The working voltage is 110~220V AC voltage 50HZ AC. The three-pin socket must be grounded. Do not use other power sources to avoid damage to components or fire, electric shock and other accidents.

Note: Before powering on, please check whether the input voltage value of the switching power supply meets the voltage standard of the country or region.

4) When the machine is working continuously for ≥ 96 hours, it should be stopped for 1-3 hours.

Consumables

Consumables are not used after unpacking or for a long period of time after the print model is completed. The consumables should be taken out of the printer and sealed to prevent the consumables from being exposed to the air for a long time, causing moisture and affecting the print quality. At the same time, when the consumables are removed The front end of the consumable should be fixed on the tray to avoid consumables and affect the next print.

To use this printer, it is recommended to use the supplies provided by the company. At present, the quality of consumables sold in the retail market is uneven, and printing is prone to breakage.

Staggering and clogging the printer nozzle, etc., and irreversible damage to the heating components of the nozzle, the extrusion motor and the extrusion gear. The company will not guarantee the printer due to the use of consumables other than our company.

Environmental requirements

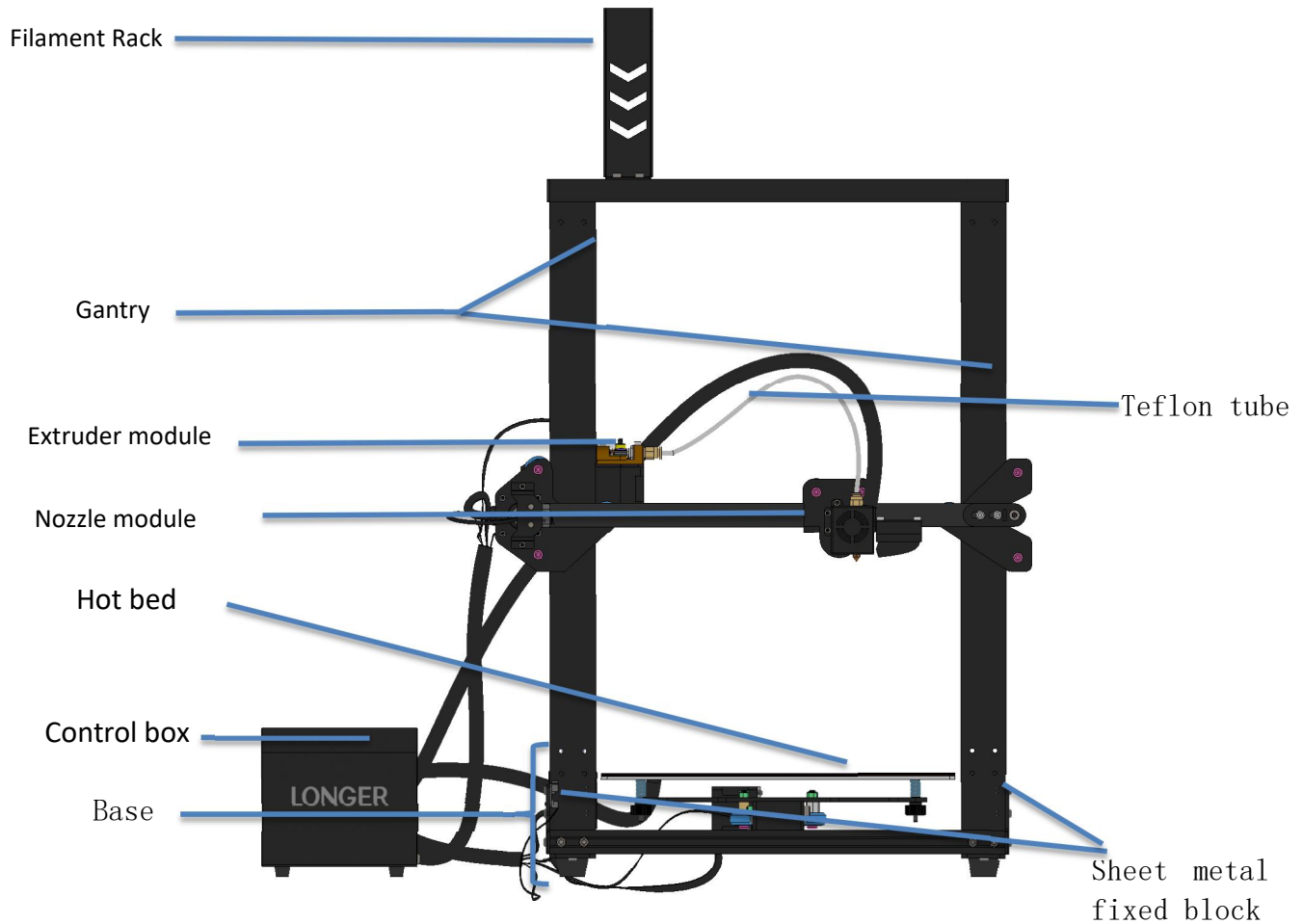
Temperature requirement: 10° C ~ 30° C, humidity requirement: 20%~50%, within this range, the 3D printer can work normally; beyond this range, this 3D printer will unable to achieve the best print results.

A. product information

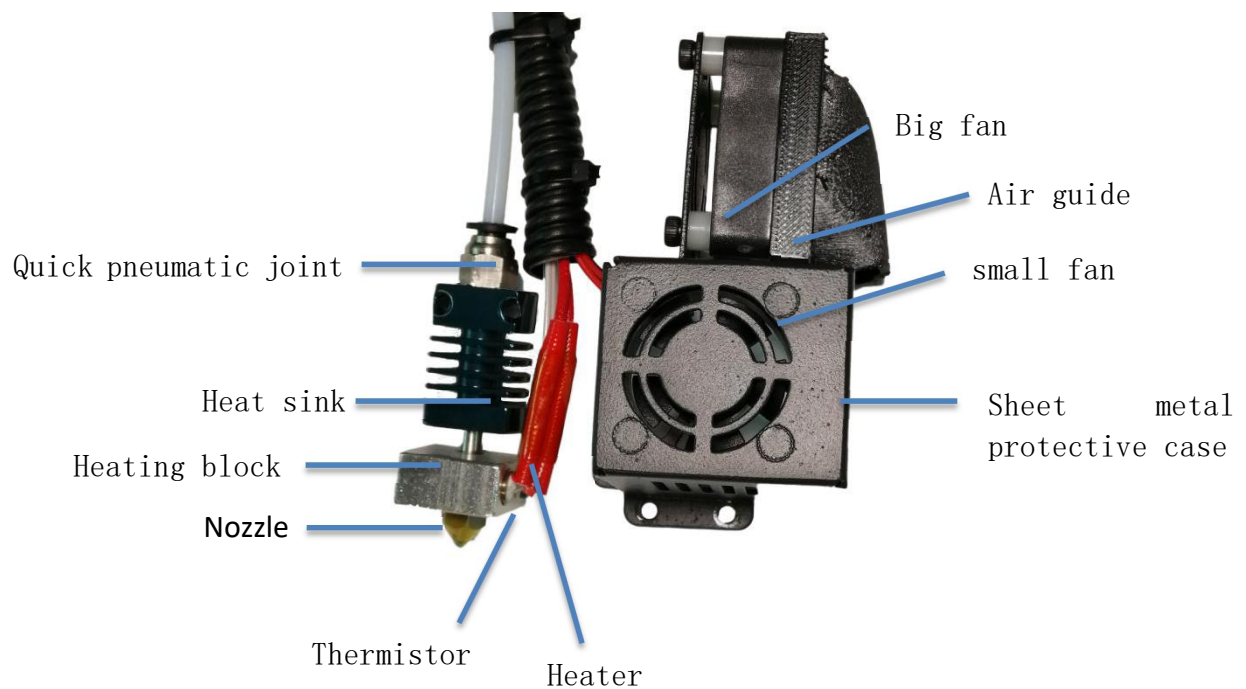
(1) Model parameter

Model parameter model	LK1	Machine size	470*575*610MM
Frame	Classic aluminum frame	Machine weight	10.6KG
Molding Process	FDM	Kit Package Size	635*518*290MM
Number of nozzles	1	Weight after packaging	14.2KG
Molding size	300*300*400MM	Power requirements	Output 24V
Layer thickness	0.1–0.4mm (adjustable)	Operating system	Windows, Linux, MAC
Memory card offline printing	Support TF card	Interface language	English
LCD screen	Yes	environmental requirements	Temperature 10–30 °C Humidity 20–50%
Printing speed	≤120mm/s (30–60mm/s recommended)	Nozzle temperature	Room temperature to 250° C
Nozzle diameter	0.4mm	hot bed	Yes
Slicing software	Cura, repetier-host	Support filament	PLA, ABS, wood
File format	STL, G-Code, OBJ	filament diameter	1.75mm
filament color	Multi-color optional		

(2) Machine introduction



(3) Nozzle module exploded view

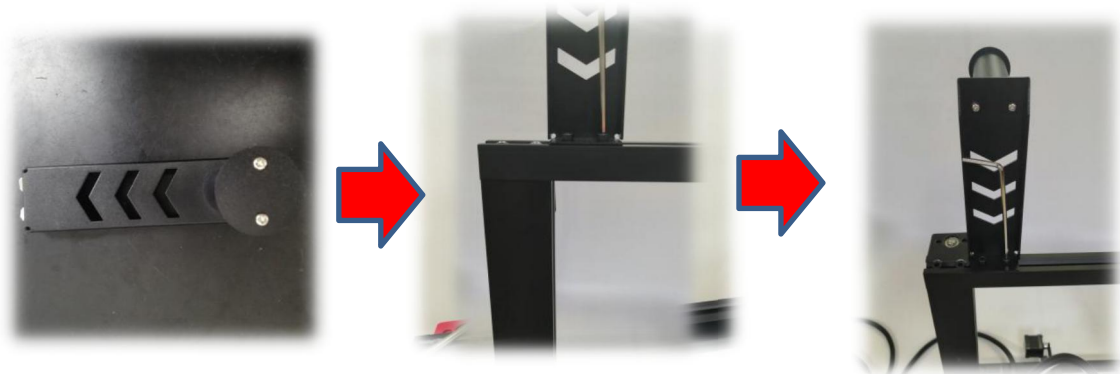


(4) Machine assembly

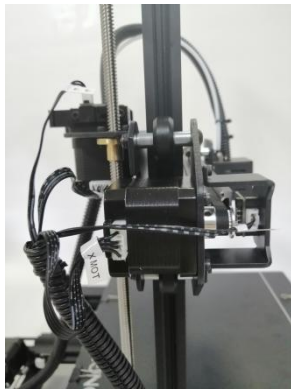
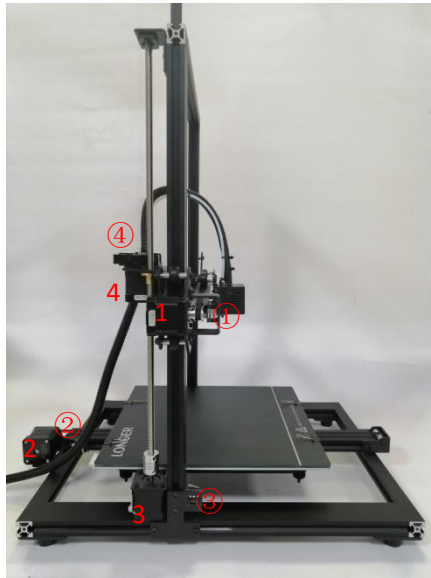


Gantry and base, M5*20 screw
limit block and profile, M4*18
screw

1. Rack installation



2.wiring



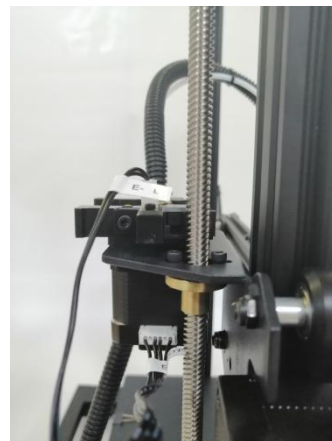
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3



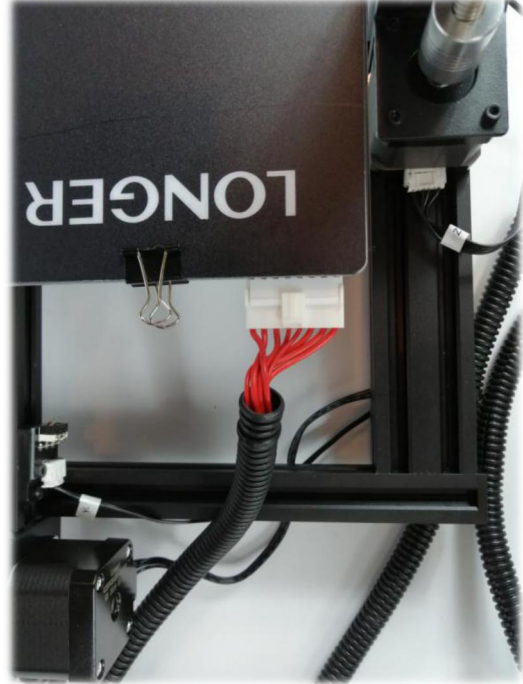
2



4

1: X-axis motor 2: Y-axis motor 3: Z-axis left motor 4: E-axis extrusion motor

① X-axis limit switch②: Y-axis limit switch③: Z-axis limit switch ④: E-axis break detection switch

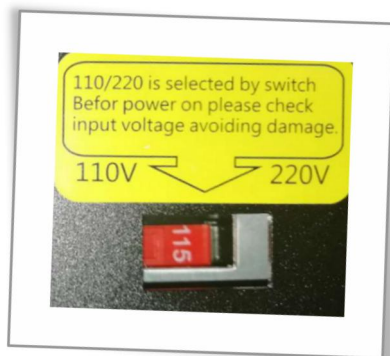


Note: For proper wiring, place the Y-axis motor and Y-axis limit switch cable under the base to prevent the moving parts from scratching the cable.

3. Power regulation



If the access voltage is 220V, please adjust the power supply in the control box to 220V, please be sure to confirm before powering on. Otherwise it will burn the power



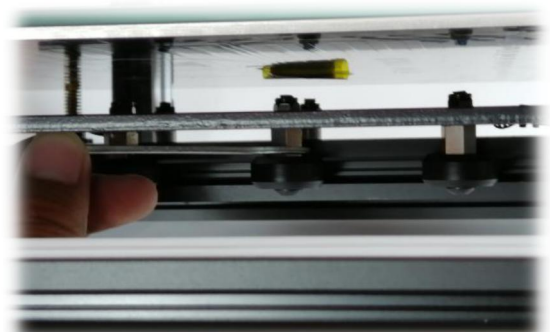
If the access voltage is 110V, please adjust the power supply in the control box to 110V, please be sure to confirm before powering on. Otherwise it will burn the power

4. Pre-use inspection and leveling



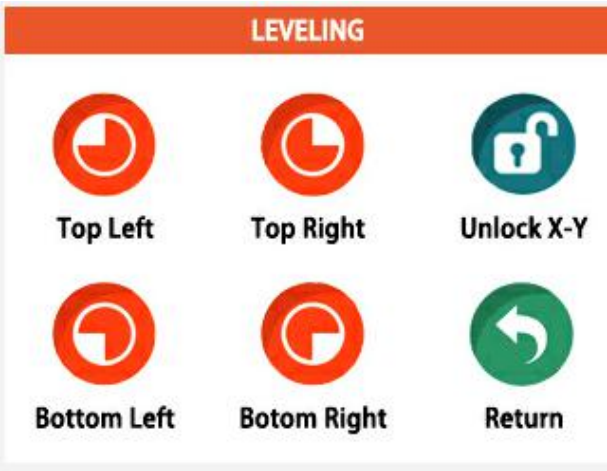
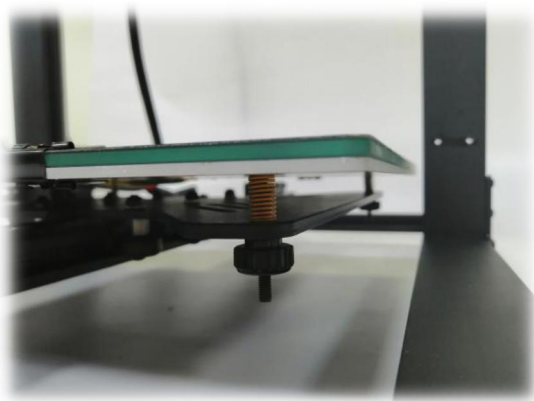
shake the hot bed and the nozzle by hand to see if there is any gap or sway. If there is any shaking, you can use an open-end wrench to screw the hexagonal sleeve on the corresponding pulley, which can adjust the tightness of the hot bed and the nozzle.

Tip: After the machine is assembled, please arrange the cable and move the three-axis motion by hand to see if it affects the movement and the jamming phenomenon.

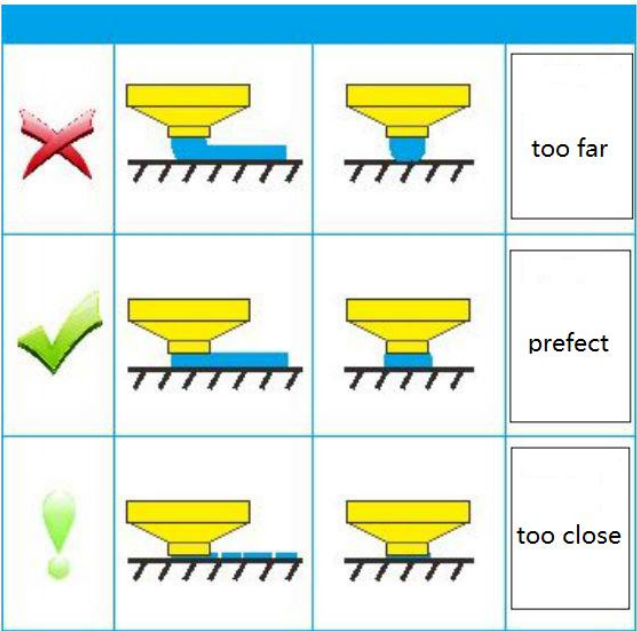


5. Leveling method

You can manually click the XY zero and Z zero in the Movement interface, then unlock, manually move the hot bed and the nozzle, and then adjust the leveling nut so that the distance from the nozzle to the hot bed is about one A4 paper thickness.

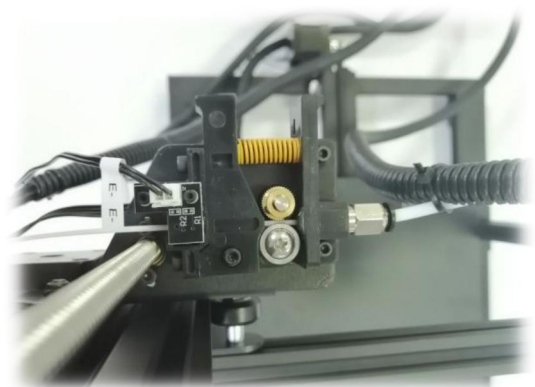
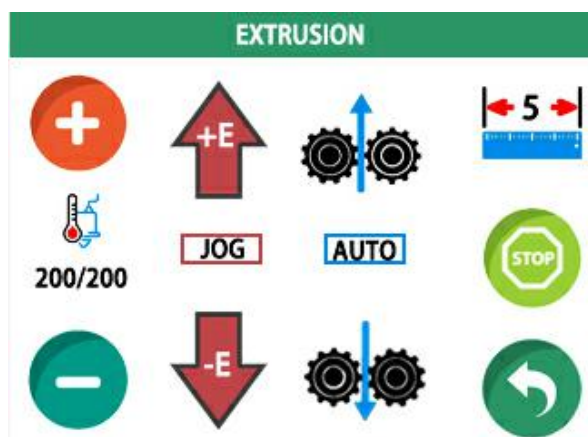


Turn on the machine, click the levelling button, click the four buttons in turn, the nozzle will move to the corresponding position correspondingly. After waiting to move to the corresponding position, you can manually adjust the hand nut to adjust the distance between the nozzle and the hot bed to approximately one A4. Thicken the paper, tighten the screw [tighten counterclockwise], and increase the distance between the heating plate and the nozzle. Loosen the screw [screw in the clockwise direction] and the heating plate will be close to the nozzle. Adjust the other three points in turn to complete the leveling.



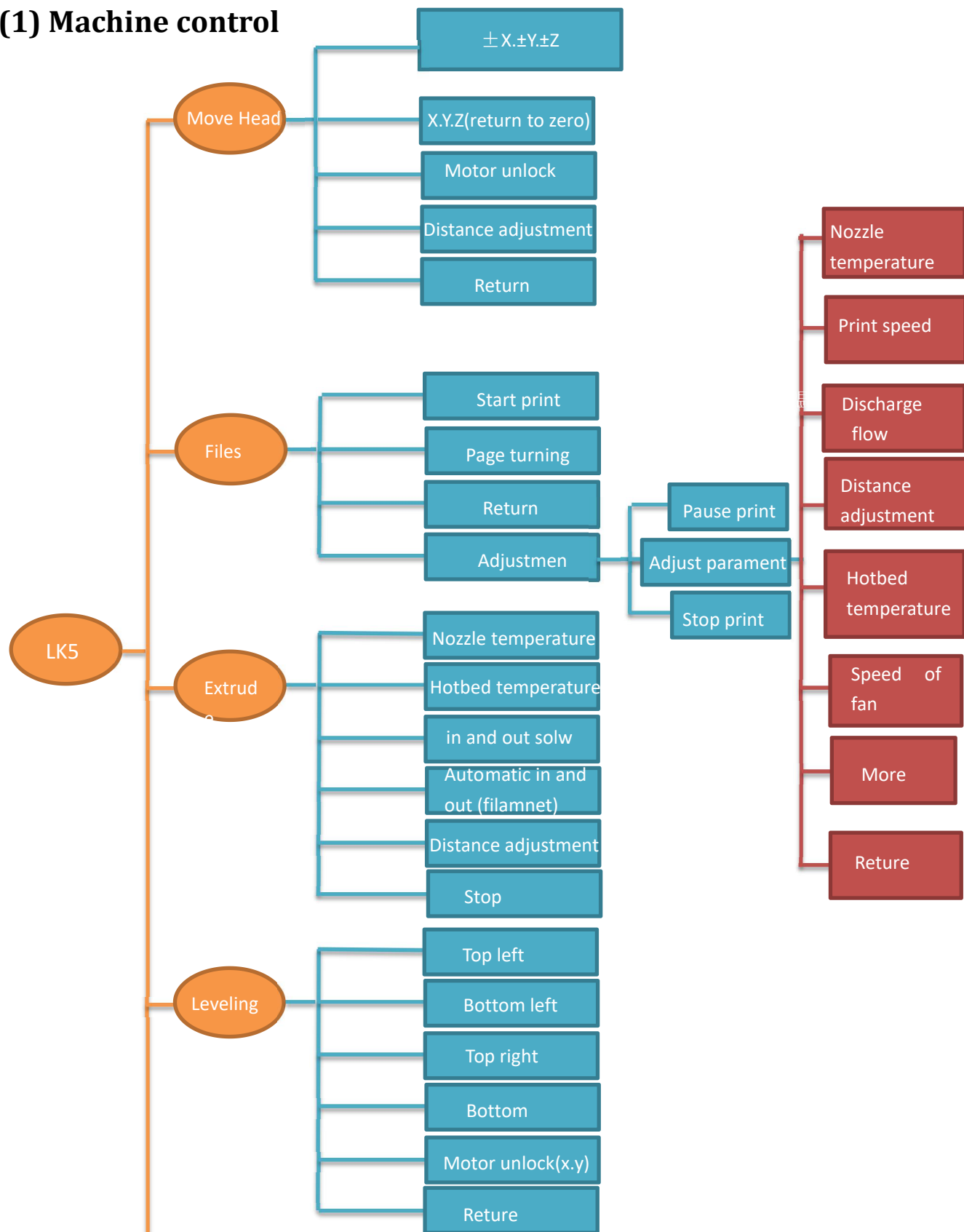
6. Place filament, feed

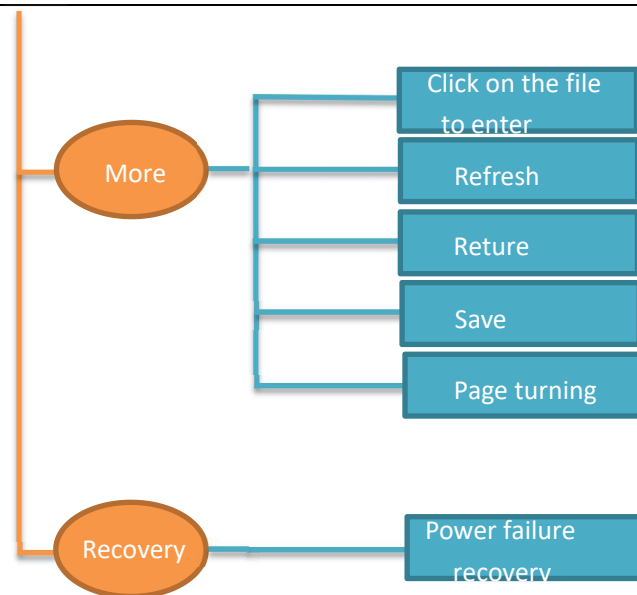
Click the E+ button, the temperature can be automatically set to 200 degrees, wait for the temperature to reach the target temperature, click, AUTO FEED IN button, sustainable feeding, at this time, the end of the consumables is sent to the feeding mechanism, waiting for the consumables to be extruded from the nozzle, click Stop the extrusion with the stop button in the middle. At this point, you can click the Files icon, click on the file, and print the file.



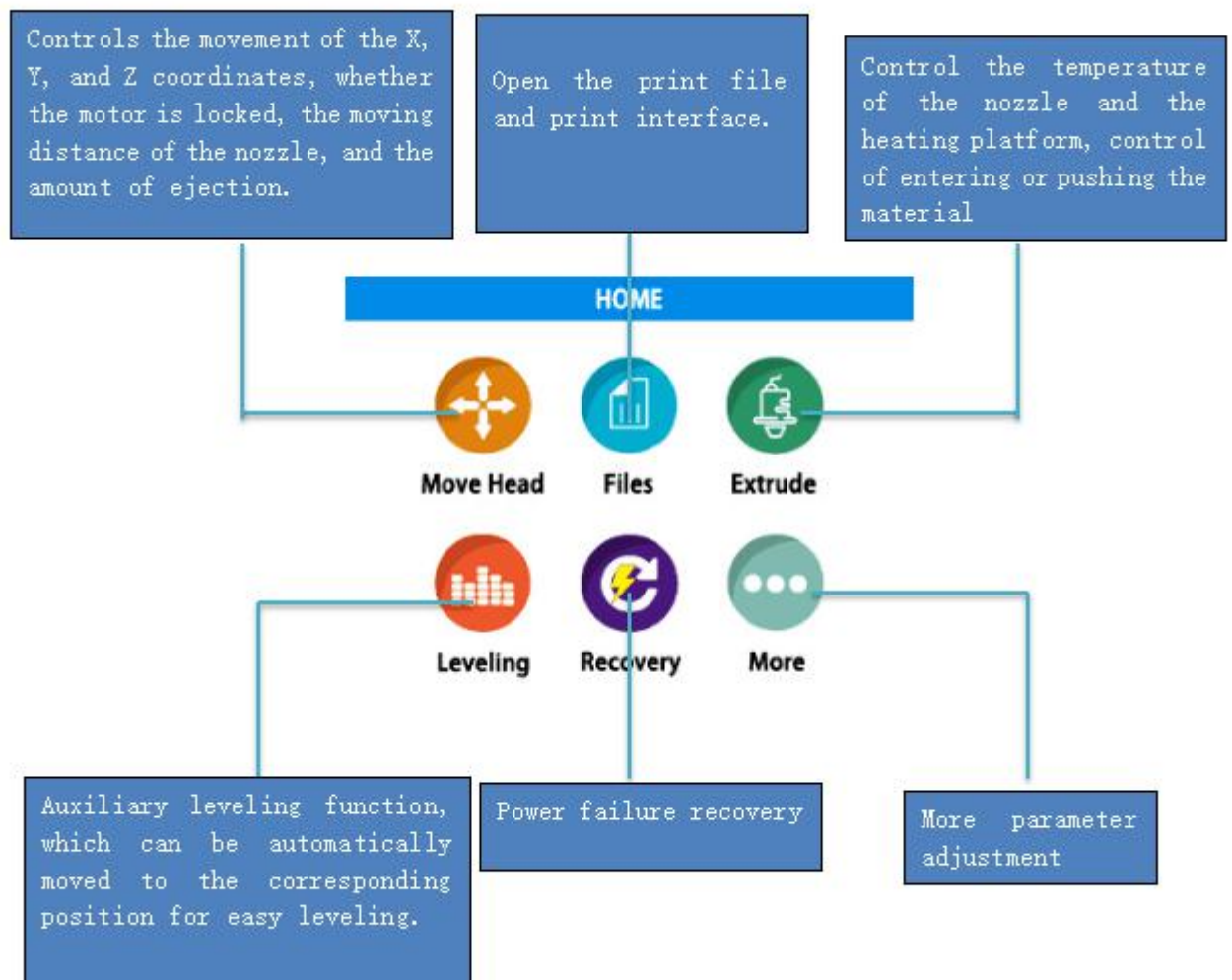
B. Machine operation

(1) Machine control





(2) Main interface

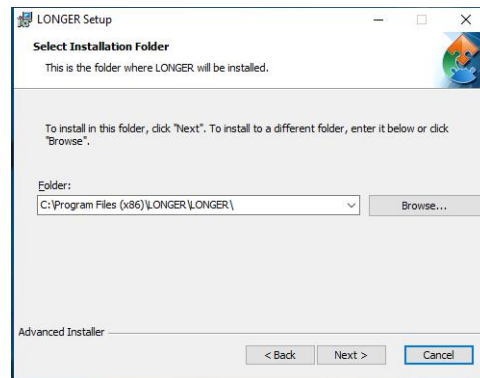


C. Installation and use of Changlang 3D slicing software

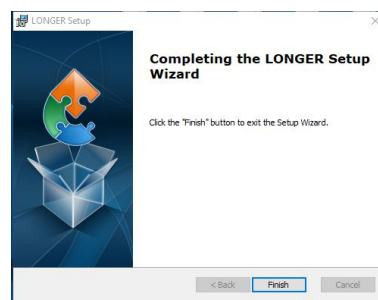
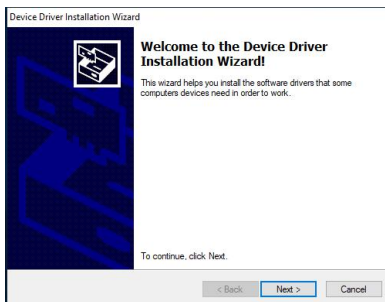
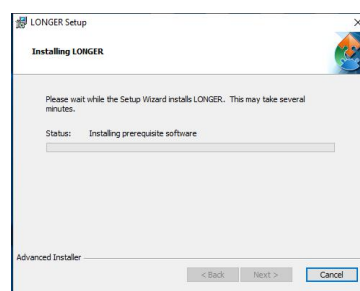
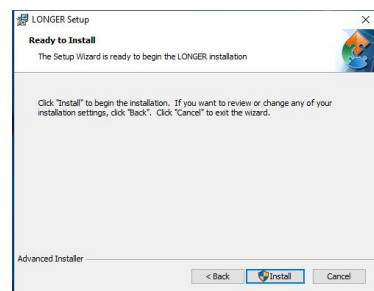
(1) Software installation

名称	修改日期	类型	大小
 LONGER 3D Slicer	2019/11/29 17:38	Windows Install...	32,785 KB

Double-click the LONGER 3D Slicer to enter the installation guide page

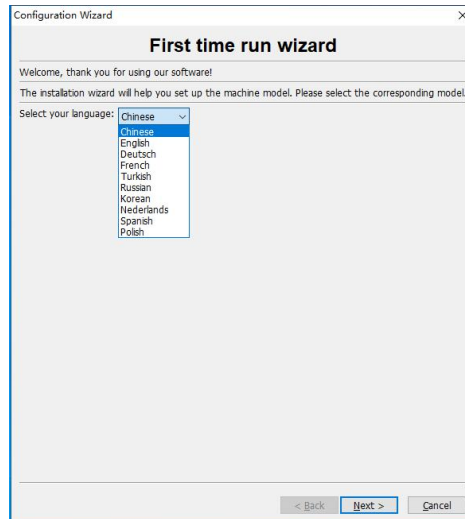
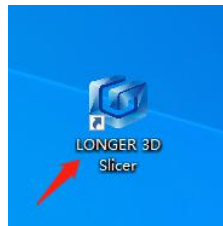


Click to enter the next step, **select the default C drive for installation, otherwise the software will not open normally**

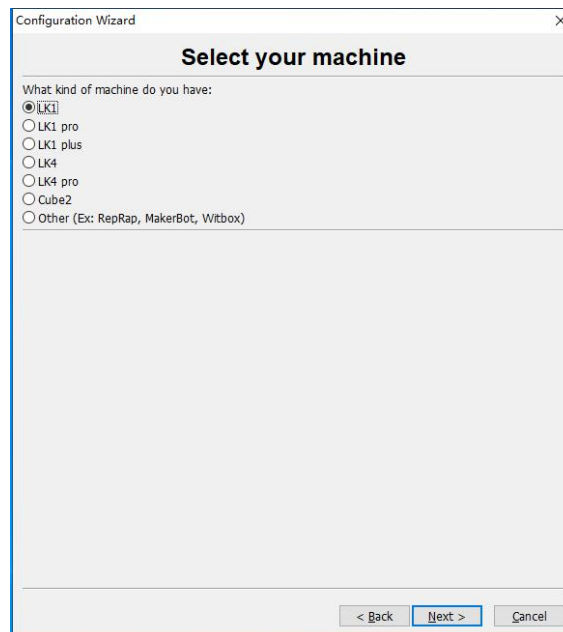


Follow the software installation guide reminder and click Next to complete the installation.

(2) Model selection

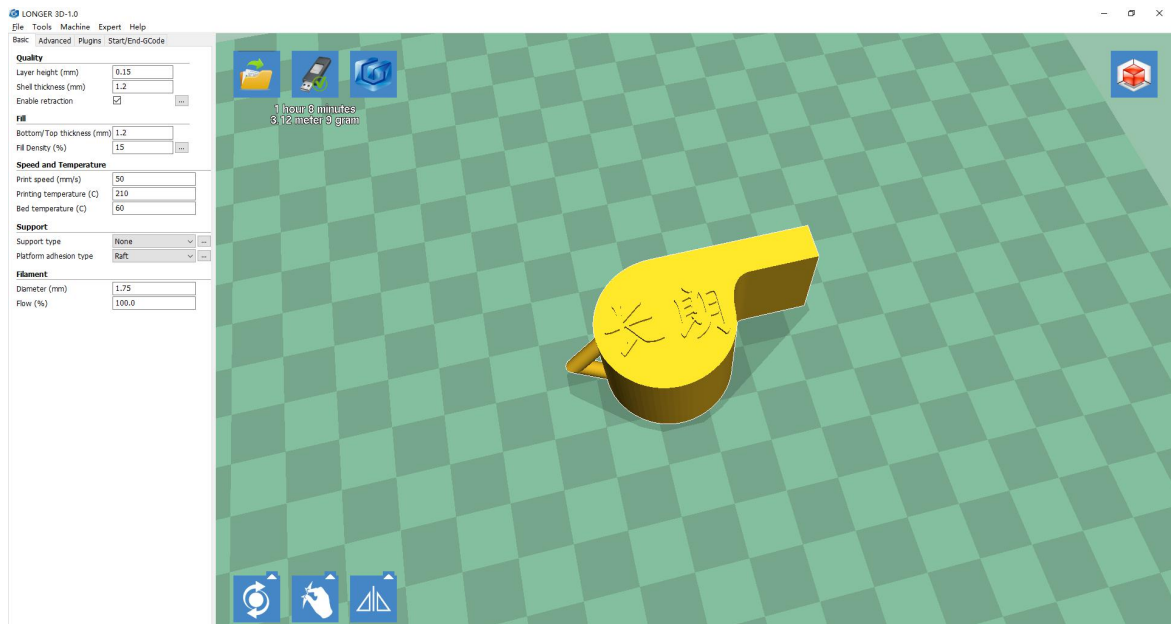


Open the software and choose the language you want



According to the model of the machine purchased, select the corresponding model. Incorrect selection will cause the machine parameters to be incorrect and the printer will not work properly. If it is a machine of another brand, you can also choose other models for related settings or use it.

(3) Software usage introduction



3D printer supports gcode format files, so you need to import the STL format model into Changlang 3D slicing software for slicing operation. To print a fine model, you need to have a deep understanding of the slicing software that controls the print path. Print out the various models you want, and set each parameter of the machine to the parameter bar to pop up the corresponding explanation.

(4) Detailed software parameters

Layer thickness: 0.1 ~ 0.4mm, high accuracy of 0.1mm, long printing time, generally 0.2mm, low accuracy of 0.4mm, short printing time.

Wall thickness: set to 0.4mm is very thin, generally set to 1.2 high, it will be firm, and printing time will increase.

Turn on rollback: The purpose of thread withdrawal is to prevent the silk from leaking out when printing quickly, otherwise it will affect the appearance.

Bottom / Top Thickness: To make the top print more perfect, the bottom is flat.

Fill density: If the intensity is not very high, 20% is fine; if the intensity is high, increase it, and the printing time will increase.

Printing speed: Generally set between 30-100, the higher the speed, the lower the accuracy.

Printing temperature: depending on the material, it is generally 190 ~ 210 degrees.

Support types: divided into semi-supported and full-supported. Models that have suspensions relative to the structure usually require additional support, but the surface will be relatively unsightly after removing the support.

Adhesion platform: "None" adds nothing; the "bottom edge" edge increases the bottom area; the "bottom mesh" base makes the model adhere more firmly. In order to make the model stick to the base better, add a base plate or edge. It is best to add a base and edge to the model with a small base area.

Diameter: 1.75mm Flow: 100%

Nozzle aperture: 0.4mm.

Retraction speed: the speed of retraction when printing the model.

Retracted length: The length of the material withdrawn, generally 4.5 ~ 8mm.

Initial layer thickness: Print the thickness of the first layer, which is the default.

Initial layer line width: 100% will be thicker and denser, just default.

Bottom Cut: The length of the bottom cut of the model.

Two extrusion overlaps: 0.15mm. By default.

Idling speed: The moving speed of the nozzle when it does not squeeze consumables.

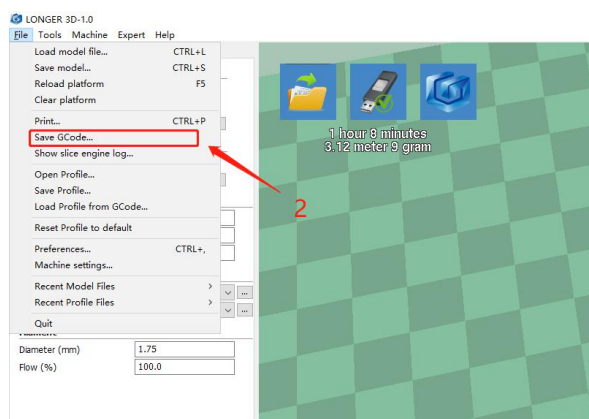
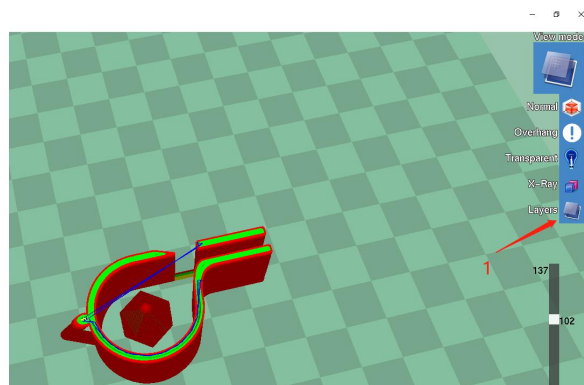
Bottom speed: The speed of printing the first layer. The slower speed is that the model is better attached to the bottom surface.

Filling speed / top / bottom speed / shell speed / inner wall speed: The default is 0, which is the same as the printing speed.

Minimum print time for each layer: The default is sufficient.

Turn on fan cooling: Turn on the nozzle cooling fan.

(5) Export gcode format for printing



After setting the parameters such as whether to add support according to different models, first adjust the model preview mode into a layer preview format to see if there are broken surfaces and path errors. After checking that it is correct, import the gcode file into the TF card, and then insert the printer Card slot.

D. Instructions for printing online

Changlang 3D printers support online printing operations, but because the computer sends instructions continuously for a long time, there are many different settings on the personal computer (some computers will set the energy-saving mode or the screen mode, etc.) and the computer will freeze if it runs. The interruption fails, and online printing is generally not recommended.

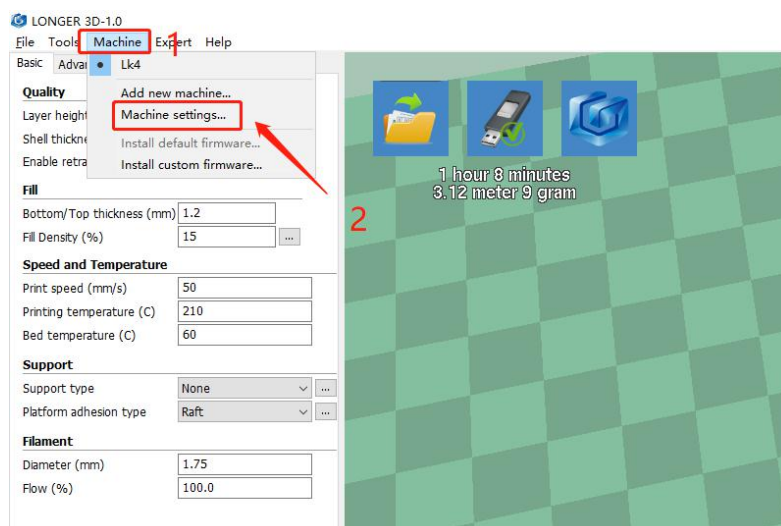
TF card offline printing is a very stable and mature printing method, and it does not occupy the computer. It is recommended to choose offline printing as much as possible. If you need to know more about the printer, you can print online according to the following steps.

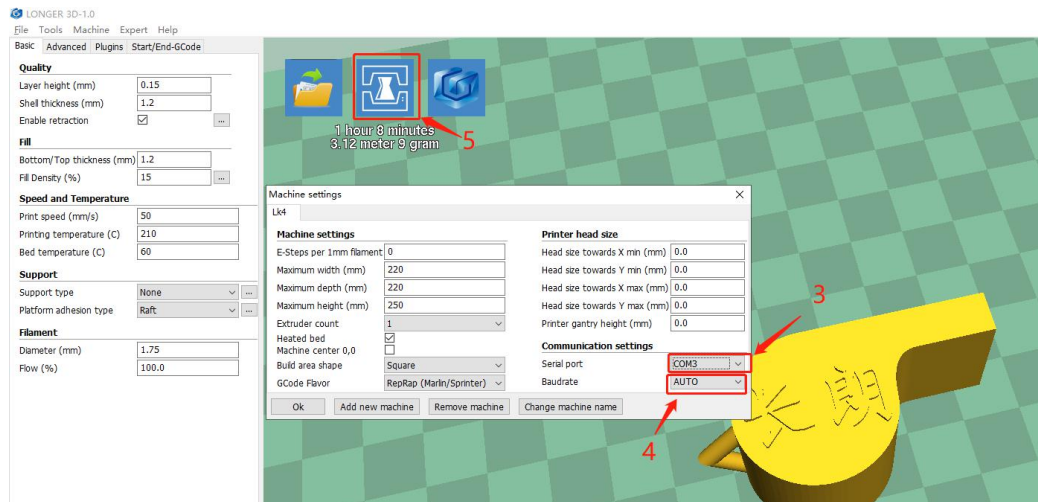
(1) Printer connection



Prepare a data cable with one end connected to the printer serial port and one end to the computer USB port. Plug in the power cord and turn on the switch.

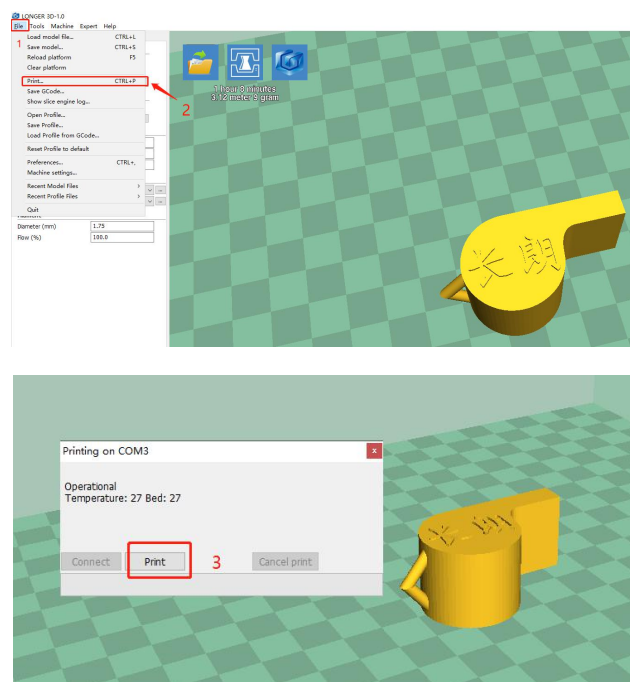
(2) Software settings





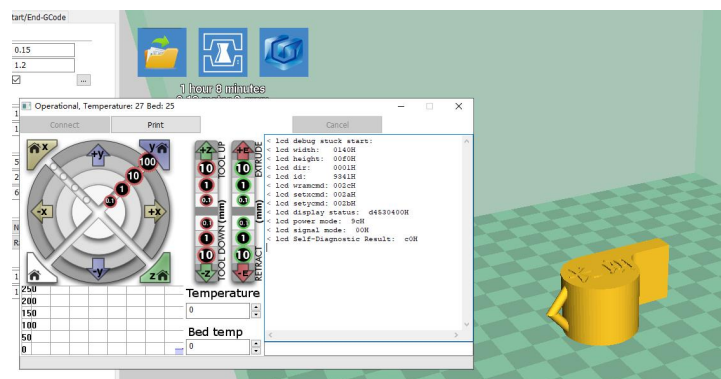
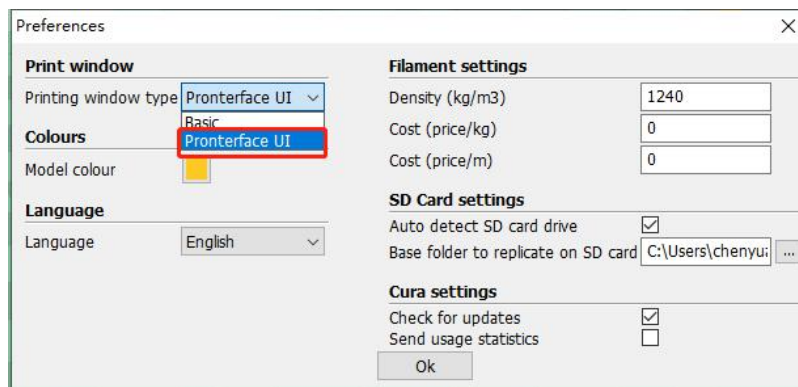
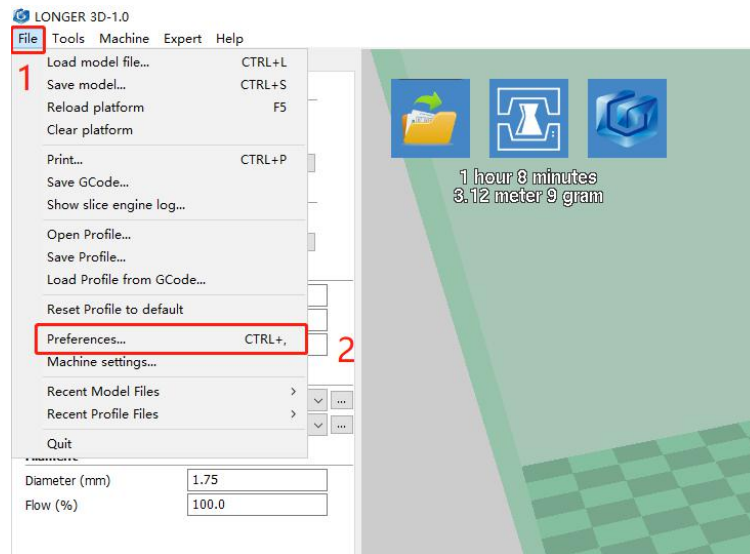
Open the Changlang 3D slicing software. The first step is to turn on the model. The second step is to open the model settings. The third step is to select the serial port number displayed by each computer. Generally, the larger serial port is selected. Normally select "AUTO" for the special rate. If you still cannot connect normally, select 115200. After the port is selected correctly in step 5, the original U disk icon will change to a printer icon. At this time, the printer is connected.

(3) Online printing



After slicing the model to be printed, open the file in the first step and directly select the print in the second step. If the printer is connected at this time, the print status bar will pop up. If there is no connection, the save gcode code will pop up. In the third step, click print. At that time, the temperature of the hot bed and the temperature of the print head will rise to the set temperature, and then printing will start.

(4) Professional settings



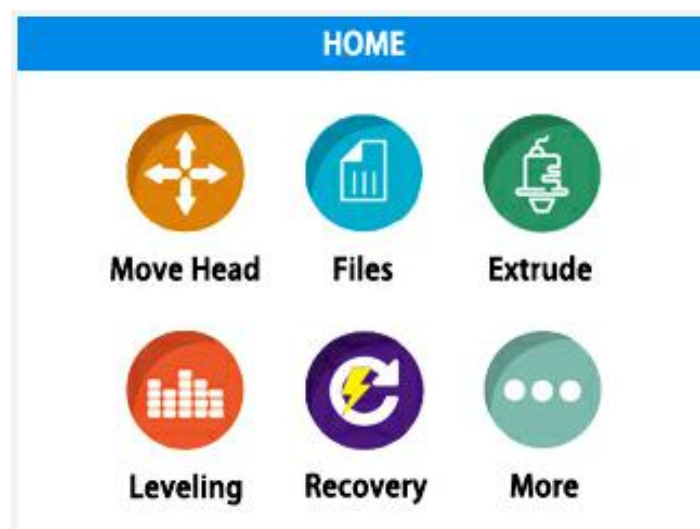
If you want to print a more professional page online, you can set it by the following steps. Select file in the first step, select parameter settings in the second step, and change the print window settings in the third step to professional. Then start printing the page online and it will become a professional page, you can send G codes, you can control the movement of each axis. If non-professionals use it with caution, it is generally not recommended.

E. Description of power failure and break detection function.

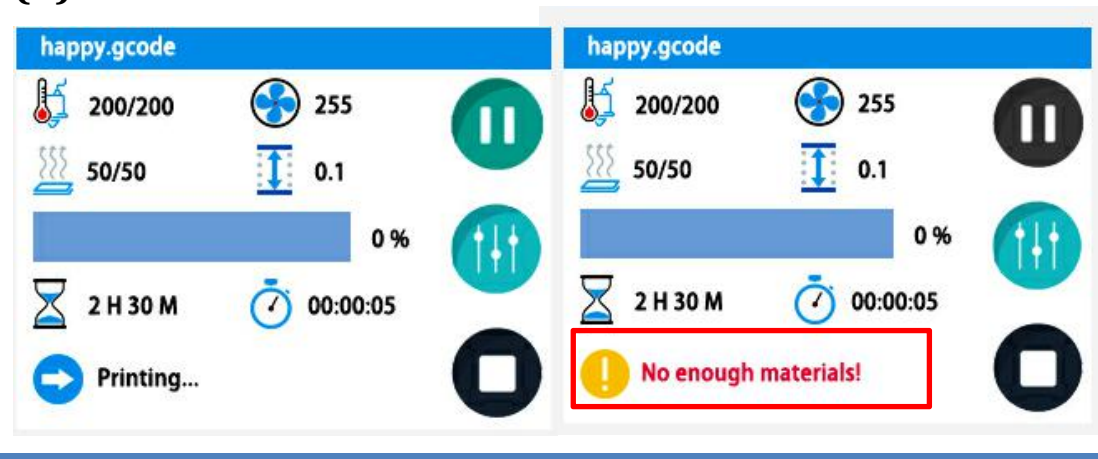
(1) Power failure



When printing for a period of time and the height of the print exceeds 0.5mm, the power-off icon will be displayed. At this time, the power is turned back on, and the icon can be clicked. After waiting for the temperature to rise, normal printing can be resumed.



(2) Broken material detection

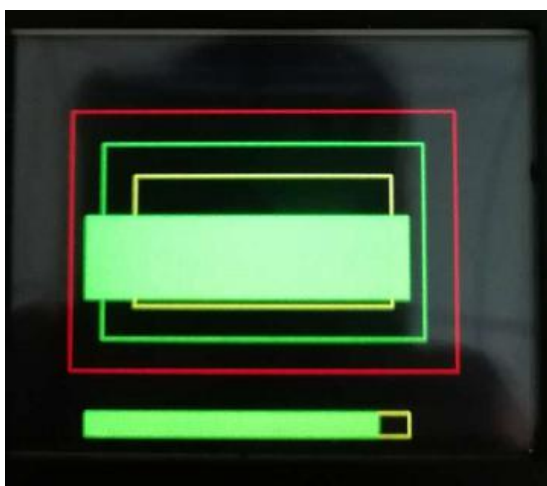


At this point, pull the Teflon tube out of the extruder end, remove the material, refill the consumables to the nozzle, and click the Recovery button to resume printing.

F. Machine Usage FAQ Guide

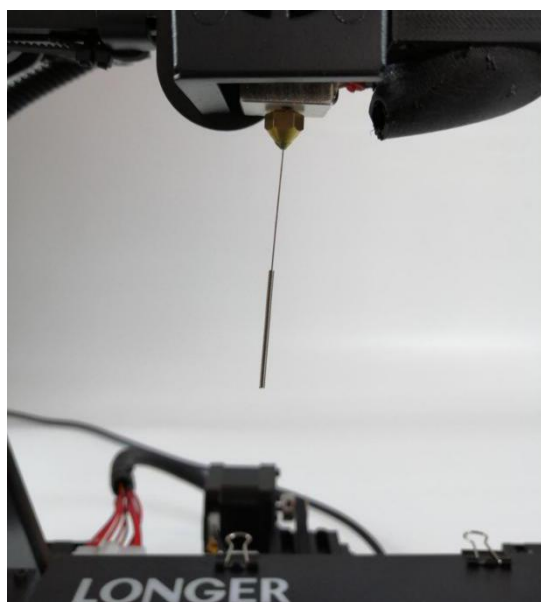
Question 1: How to update the firmware?

1. Copy these two files to the SD card



2. Then restart the machine and wait for the machine progress bar to complete before the firmware is refreshed.
3. **Then the user needs to delete the two files in the SD card to be used normally**, otherwise the firmware will be refreshed every time the phone is turned on.。

Question 2: What should I do if the machine does not discharge?

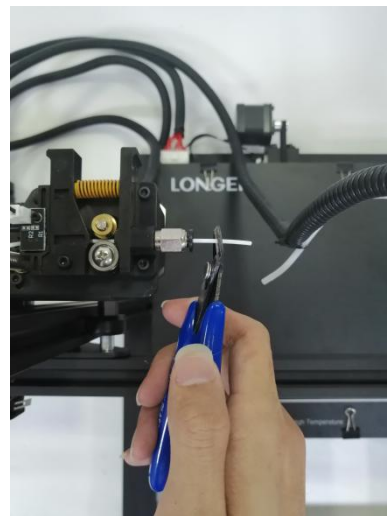


1. After the machine nozzle is heated, the consumables are normally fed into the feeding mechanism by hand, and then passed through the Teflon tube to enter the nozzle.
2. When it is found that the gear of the feeding mechanism emits a "beep" sound, it can first check whether the consumables are wound, causing the extrusion mechanism to pull the material.
- 3 If this is not the reason, raise the machine nozzle and use the 0.4mm needle in the toolbox to insert it from below the copper nozzle and rotate while inserting.
4. Under normal circumstances, this needle can be used to open the copper nozzle, so that the feed is smooth. The reason for this blocking is generally that there are impurities in the consumables, which leads to plugging.

Question 3: What should I do if the machine does not retreat when the material is returned?



1. Before returning the material, please heat the nozzle first, and then withdraw the consumables as soon as possible. If you can't pump it, you can re-feed the material with the advanced material, and melt the extruded block formed at the end of the consumable in the nozzle.



2. When withdrawing the consumables, before the end of the consumables reaches the pneumatic joint, we will usually pull the Teflon directly from the Teflon and cut the end of the consumables.



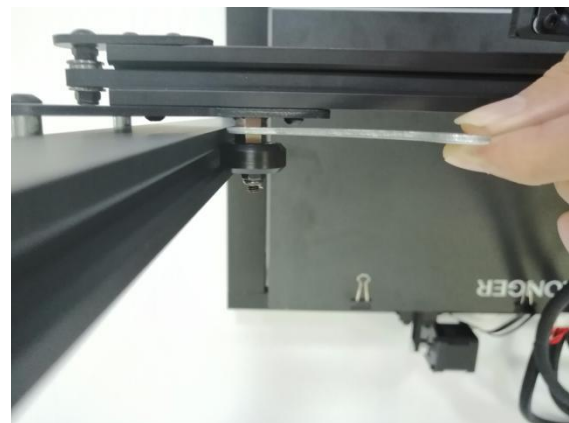
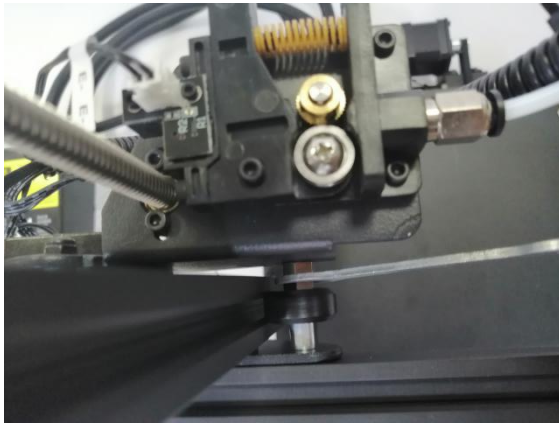
3. Because the end of the consumables in the nozzle will be deformed by heat, if the end deformed consumables are directly pulled out, it may get stuck to the pneumatic joint or the limit switch that damages the broken material detection (the limit switch for the broken material detection is single) Towards).

Question 4: What can I do if I can't power off?

If the power is suddenly turned off when the part is first printed, the machine will not save the print data. Unless the height of the print exceeds 0.5mm, the power failure will be supported. If the height is less than 0.5mm, it is recommended to reprint directly.

Question 5: When the machine is leveled, when the nozzle moves to the left, it can be leveled normally. When the nozzle moves to the right, it is found that the nozzle and the hot bed are far apart or very close. What should I do if the spring is adjusted to the limit position?

If this happens, the X-axis beam is generally loose. At this time, the hex socket on the right side of the machine can be adjusted with a wrench to adjust the tightness



Question 6: After the machine is heated, the spit is normal, but when the first time of printing, the silk falls on the platform and curls, and then after printing a few layers, what should I do if it is off the platform?

1. After the user gets the 3D printer, if the leveling is found to be curled on the first layer of silk, it feels like it is gently falling on the platform. It can be judged that the leveling is not adjusted, and the nozzle is too high from the hot bed. ,
2. At this point we need to re-level, the quality of the leveling can largely determine the success rate of the part printing.
3. In addition, in order to ensure good contact between the model and the platform, we can set the larger plane of the model face down when slicing, and can also be set in the slicing software to add Raft to the model, which can make the model stick to the platform. Firm.