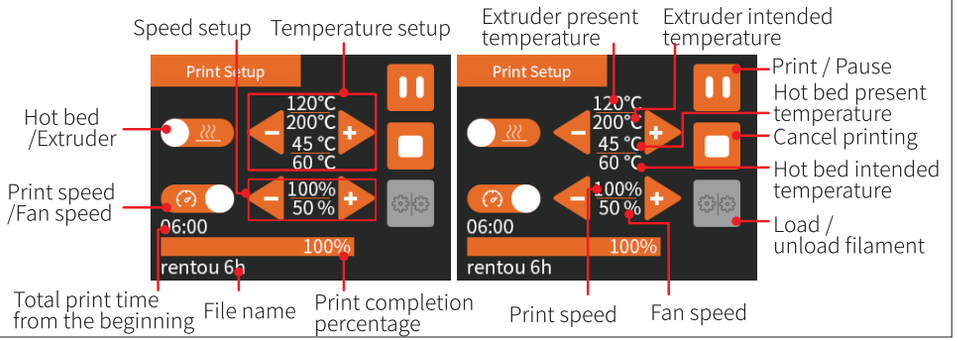
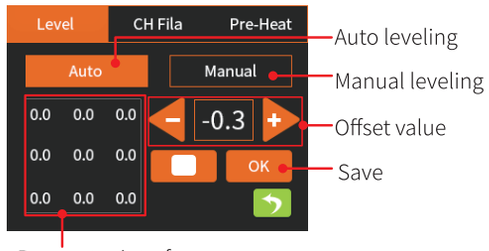
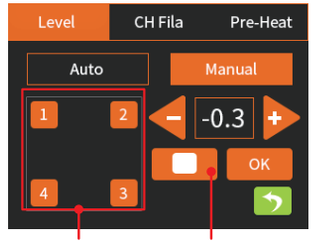
Print Setup



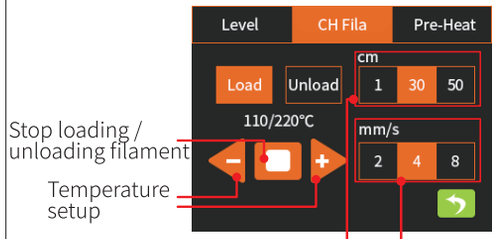
Auto Leveling



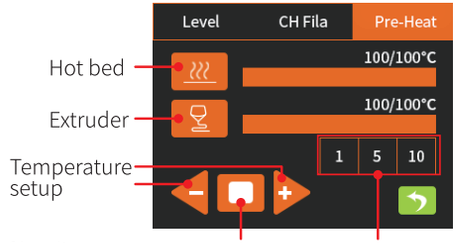
Manual Leveling



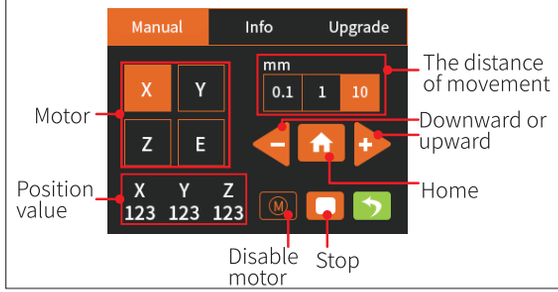
CH Fila



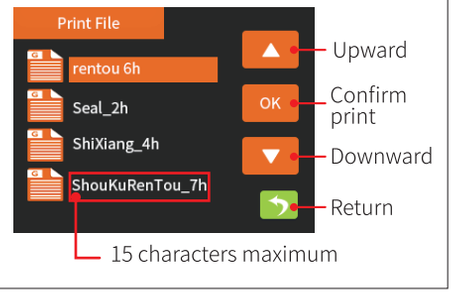
Pre-Heat



Manual

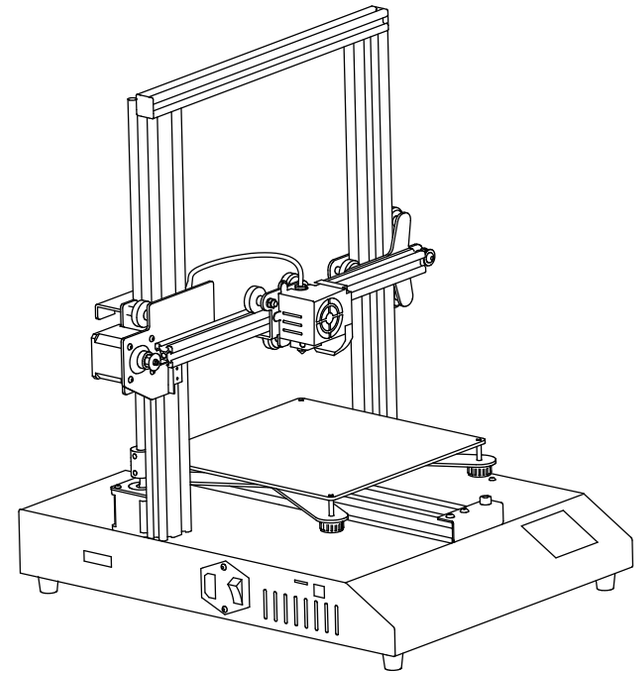


Print File



ET Collection

User Manual



Thank you for choosing Anet 3D printer.

Read this User Manual carefully and thoroughly before operating the printer for the first time.

Take good care of this User Manual.

Shenzhen Anet Technology Co., Ltd.

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Email: anet@anet3d.com

V1.2

Control Guide

Printing Process for the First Print

Check the power supply. (pic 1) - Plug the power cable into an electrical outlet. (pic 1) - Turn on the printer. (pic 1) - Home the printing head. - Leveling. - Load filament. (pic 8) - Slice STL file. - Insert the SD card. (pic 2) - Printing. - Remove the model. - Power off.

Regular Printing Process

Attach the power supply. (pic 1) - Turn on the printer. (pic 1) - Load filament. (pic 8) - Slice STL file. - Insert the SD card. (pic 2) - Printing. - Remove the model. - Power off.

1.Home Printing Head

Click【Setting – Manual – Home】to home the printing head to the highest place.

2.Auto Leveling(Use Auto Leveling or Manual Leveling)

①【Setting – Manual – Home】.
②Rotate the 4 leveling knobs (pic 7) until the distance between the 4 points and the nozzle is almost the same. Ro tate the knob anticlockwise to tighten. Rotate the knob clockwise to loose.
③Remove the residuary filament on the extruder nozzle. Connect and install the leveling switch. (pic 4, 5, 6) The connection cable of leveling switch is on the extruder. (pic 4)
④Click【Prepare – Leveling – Auto Leveling】on the touch screen. The printer would finish auto leveling in 4-6 minutes.
⑤Offset leveling : Set offset leveling value to adjust the thickness of the leveling switch and its impact on the printing. Usually take -0.3mm as the offset value. If you set "-" value, the nozzle will begin printing closer to your build plate. If you set "+"value, the nozzle will begin printing farer to your build plate. Click【OK】to save the offset value. Check out the images on the right to see a successful first layer and two unsuccessful ones. (pic 10)

3.Manual Leveling(Use Auto Leveling or Manual Leveling)

①Click【Setting – Manual – Home】,Click【Prepare – Leveling – Manual】on the touch screen, then select the point from【1 2 3 4】for leveling and the nozzle would move above the point that selected.
②Horizontally observe the distance between the build plate and nozzle. Use【-】【+】to set leveling value to adjust the distance between the build plate and nozzle. When there are one or two points of the 4 adjustment points that not leveled, you need to have an adjustment by turning the build plate leveling screws. (pic 7) If needed, step ① and step ② should be repeated until final leveling is done. Check out the images on the right to see a successful first layer and two unsuccessful ones. (pic 10)
③If you set "-" value, the nozzle will begin printing closer to your build platform. If you set "+"value, the nozzle will begin printing farer to your build platform. The maximum offset value is ±10mm.

4.Load Filament

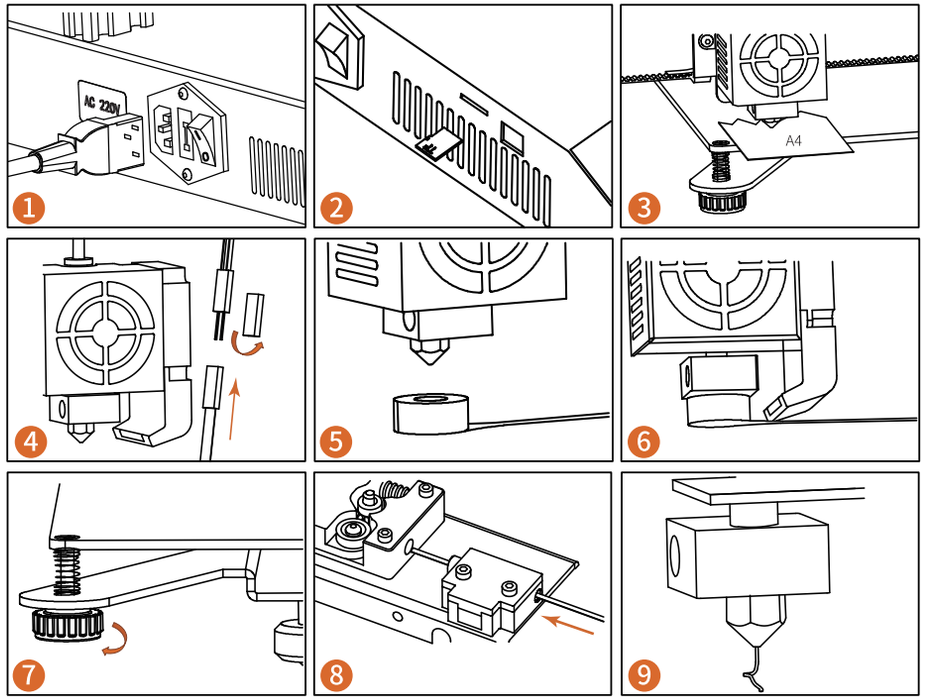
①Get a roll of Anet 1.75mm filament, recommend PLA filament.
②Neatly trim the end of the filament and feed the filament through the filament detector and to the extruder. (pic 8)
③Load Filament: Click【Prepare – Filament – Load】,the printer will begin to load the filament once the extruder reached the temperature. If the printer works properly, you' ll find an evenly extruded filament coming out of the nozzle. (pic 9) If no filament coming out from the extruder, please click load button again.
④Unload Filament: Click【Prepare – Filament – Unload】,the printer will begin to unload the filament until all the filament was unloaded once the extruder reached the temperature.

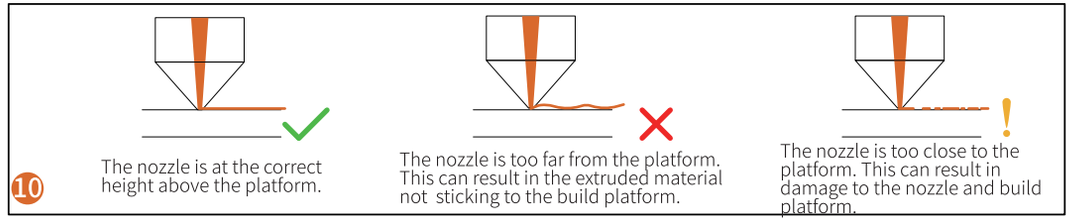
5.Print

①Save the print file on the TF card. You could get more information and guide on our official website www.anet3d.com and the supplied flash drive on slice software.
②Insert the TF card into the slot on the left side of the printer.(pic 2)
③Select the file you wish to print on the touch screen. Click【Print – Select - OK】 and then the print will begin.

6. In Print Job

- If you need to change filament, pause loading or unloading filament, stop print, set extruder temperature, set build plate temperature, set print speed, set fan speed, etc. in print jobs, you could process on the【Print】interface.
- If you need to change filament, please first stop the print job, and change filament on the【Filament】interface. You could refer to the steps of Load Filament.
- When the print has finished, wait for the build plate to cool down and grab the print from the build plate.
- Turn off the printer. If you would not have another print in a short time, please click【Prepare - Filament – Unload】to pull out the remaining filament before turn off the printer.





Notice

- Any emergencies, please first turn off the power of the printer.
- Please do not touch the nozzle or hot bed while operating the bed leveling to avoid burns or person injury.
- The value will be automatically used for next printing. No need to level before every print job.
- Remove any debris from the build plate before leveling, as that may cause incorrect leveling and machine damage.
- Please make sure the temperature of the nozzle below 50°C before operate leveling switch.
- Remove the residuary filament on the extruder nozzle. Residuary filament on extruder would impact leveling results.
- Horizontally observe the distance between the build plate and nozzle after leveling, make sure there is a small gap between the tip of the nozzle and the top of the build plate for you to place a piece of A4 paper in between of them. Slide the paper back and forth, but with some friction.(pic 3)
- The printer do not support soft filament.
- Do not use filament that has absorbed too much moisture that may cause the clogging of the nozzle.
- It may cause the machine damage if the switch broken, the connects do not connected, unreasonable offset leveling value, or the nozzle to hit the bed. (pic 4)
- Turn off the printer and take the plug out. If you would not have another print in a short time or not before the machine. In case any circuit fault or accident.
- Save slice files in the root of the TF card instead of folders.
- Do not switch off/on the plug with wet hands to avoid electrical shocks.
- Before plugging the power cable into the outlet, make sure the power cable and the plug has no breakage. If there' s any breakage, please request replacement by professionals to avoid risks.
- Before plugging the power cable into the outlet, make sure that the power supply voltage in the outlet matches the required value provided on the nameplate of the printer.
- Do not plug the power cable into an electrical outlet before the printer was fully assembled. Cut power off before remove the printer.
- Do not save other files except for print files on the TF card in any case impact the print work of the machine.
- There's noise between the rods and the axis during the use of the new machine, oil with lubricant can reduce the nois in some degree.
- It may have residuary filament on the extruder nozzle because of the test in the factory. There's a new nozzle for replacement in the supplement package.
- The printer need time to pause / stop the print after receiving the command of the【Pause Print】and【Stop Print】. The time various from different print jobs.
- You could get more information on our official website about printer set up, usage and maintenance.
- Users would not receive prior notification of the amendment of functions or structures of the printer. The actual product shall govern.
- Shenzhen Anet Technology Co. Ltd. reserves the right of final interpretation on any typo or misunderstanding on this user manual.