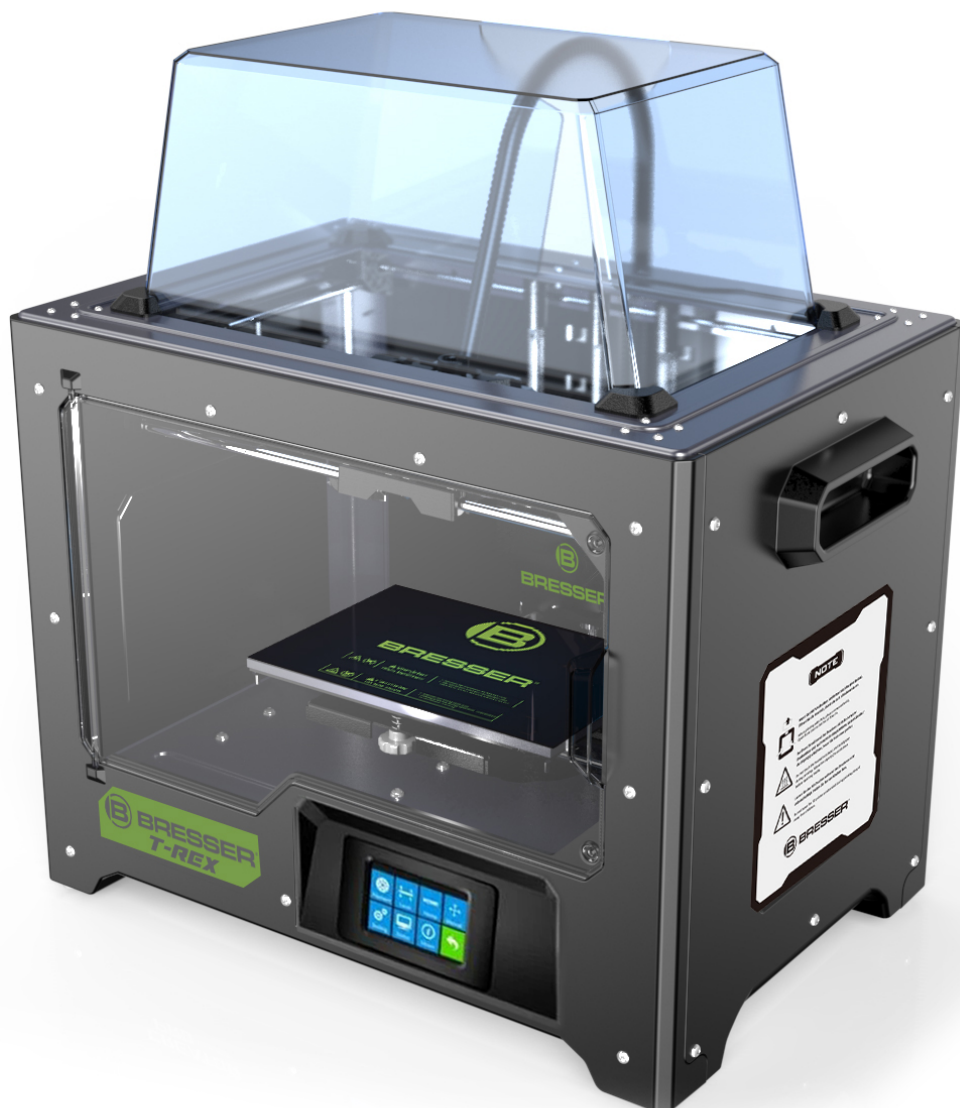




# ***T-REX*** **WIFI 3D Printer Twin Extruder**

Art. No. 2010500



## **Instruction Manual**

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# Introduction

Thank you for choosing the BRESSER T-REX Wifi 3D printer with Twin Extruder. We assure you that it has been produced according to the latest technology and safety standards. Each device is subjected to a detailed quality control before delivery, so that nothing stands in the way of trouble-free operation.

This manual is designed specifically for use with the BRESSER T-REX Wifi 3D printer with Twin Extruder. Even if you have experience using other equipment of this type or are familiar with 3D printing technology, it is still important to read this manual because it contains a lot of important information about the BRESSER RAPTOR Wifi 3D Printer that will help you expand your knowledge of 3D printing.

We also recommend the following documents for optimal print preparation:

(1) BRESSER T-REX Wifi 3D printer with Twin Extruder Quickstart Guide

The Quick Start Guide is included with the printer. The information it contains will help you start printing in no time.

(2) BRESSER T-REX Wifi 3D printer with Twin Extruder product page on the Internet

Visit the product page on the Internet at **[www.bresser.de/P2010500](http://www.bresser.de/P2010500)** for additional information, available updates or software for this printer and related accessories.

# General Information

## Important notes

- Please read this manual carefully before using the machine.
- This manual assumes that you are using the Windows 7 operating system to operate the 3D Printer.
- The latest version of the REXprint software is used.

This manual contains all the information required for setting up and operating the machine.

The User's Guide consists of the following parts: Introduction, General and Safety Information, Operation and Product Service.

## Please be prepared for service requests:

Art. No.: 2010500

Product name: BRESSER T-REX WIFI 3D Printer with Twin Extruder technology

Instruction manual:

Manual\_2010500\_Wifi-3D-Printer-Twin-Extruder-T-REX\_de\_BRESSER\_v012021a.docx

# Safety Instructions

## NOTE!

Familiarize yourself with this manual and read all the instructions it contains before you start setting up and operating the machine. Failure to heed warnings and instructions may result in personal injury, fire, and damage to the machine or other property.

**STRICTLY FOLLOW ALL SAFETY AND OTHER INSTRUCTIONS IN THIS MANUAL AT ALL TIMES!**

## Safety in the working environment

- ① Keep the workplace clean!
- ② Do not operate the 3D Printer if flammable liquids, gases or dust are present.
- ③ Keep children and untrained persons away from the 3D printer.

## Power supply safety

- ① Operate the 3D Printer only from a grounded power outlet. Do not modify the power plug of the 3D Printer.
- ② Do not operate the 3D Printer in a hazy or humid environment. Do not expose the 3D printer to direct sunlight.
- ③ Do not use the power cord for any purpose other than its intended use.
- ④ Do not operate the machine during a thunderstorm.
- ⑤ To prevent accidents, disconnect the power supply if you are not going to use the machine for a long period of time.

## Safety of persons

- ① Do not touch the nozzle or printing plate during printing.
- ② Do not touch the nozzle after printing is finished.
- ③ Wear suitable clothing. Do not wear loose clothing or loose-fitting jewellery. Be careful not to let your hair, clothing and gloves get near the moving parts.
- ④ Do not operate the machine if you are tired or under the influence of drugs, alcohol or medication.

## **Precautions**

- ① Do not leave the machine unattended for long periods of time.
- ② Do not make any changes to the unit.
- ③ Lower the pressure plate before inserting/removing filament. (The distance between nozzle and pressure plate should be at least 50 mm).
- ④ Operate the unit in a well ventilated environment.
- ⑤ Do not use the machine for unlawful purposes.
- ⑥ Do not use the machine to make containers for storing food.
- ⑦ Do not use the device to manufacture electrical equipment.
- ⑧ Do not put models in the mouth.
- ⑨ Do not remove the models with force.
- ⑩ Do not connect the machine with a network cable longer than 3 m.

## **Environmental conditions**

Temperature: Room temperature 15-30°C

Humidity: 20 %-70

## **Filament specifications**

Use filament only for the intended purpose! Use only the BRESSER filament or filament of the brands recognised by BRESSER!

## Filament storage

A certain degree of decay can be observed in all polymers over time. Only unpack the filament when you need it. The filament should be stored in a clean and dry environment and protected from sunlight.

## Legal notice

All information in this document can be extended or adapted without prior notice.

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A "Declaration of conformity" in accordance with the applicable directives and corresponding standards has been prepared by Bresser GmbH. The full text of the EC declaration of conformity is available at the following Internet address:

[www.bresser.de/download/2010600/CE/2010600\\_CE.pdf](http://www.bresser.de/download/2010600/CE/2010600_CE.pdf)

## EC DECLARATION OF CONFORMITY



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[www.bresser.de/download/2010600/UKCA/2010600\\_UKCA.pdf](http://www.bresser.de/download/2010600/UKCA/2010600_UKCA.pdf)

### **Bresser UK Ltd.**

Suite 3G, Eden House, Enterprise Way, Edenbridge, Kent TN8 6Hf, Great Britain





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# Chapter 1: 3D Printing Technology

3D printing transforms three-dimensional models into physical objects that you can touch and hold in your hand. This printing process is also known as additive manufacturing, because the 3D model is created by applying layers until the object is fully formed.

Fused Filament Fabrication (FFF) is the most common method of 3D printing and is also used by this 3D printer. In this printing method, a plastic, the filament, is melted at high temperature and applied to a printing surface. The filament solidifies during cooling, i.e. practically immediately after it leaves the nozzle. 3D objects are formed by applying the filament in several layers on top of each other.

## 1.1 Procedure

3D printing involves three steps:

1. Create or download a 3D model
2. Slicing and exporting the 3D model
3. Building the 3D model

### 1.1.1 Creation of a 3D model:

Currently there are three ways to create a 3D model:

- **Design from scratch** You can use free CAD (Computer-Aided Design) software such as 3DTADA, AutoCAD, SolidWorks, Pro-E or our own software Happy 3D to design your own 3D model.
- **3D scanner** As an alternative to creating a 3D model, you can also scan an object. A 3D scanner digitises a physical object by capturing the geometric data of the object and saving it in a file on the computer. It is also possible to use a mobile device as a 3D scanner using an app.
- **From the cloud** The most common method of obtaining a 3D model at present is to download a 3D model from a website where users can upload their own 3D models.

Example: [www.thingiverse.com](http://www.thingiverse.com)

### 1.1.2 Slicing and exporting a 3D model:

Slicer software is used to prepare 3D models for printing and convert them into instructions for the 3D printer. REXprint is the slicer software for this 3D printer. With REXprint, STL files can be converted into G or GX files for printing. These are then transferred to the 3D printer via USB cable, USB stick or W-LAN.

### **1.1.3 Structure of the 3D model**

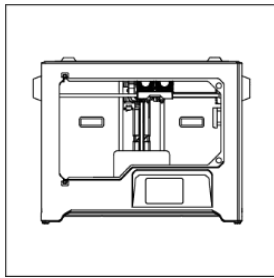
After the output file is sent to the 3D printer, the printer begins to transfer the 3D model into a physical object by applying layers of filament over each other.

# Chapter 2: Information on the 3D printer

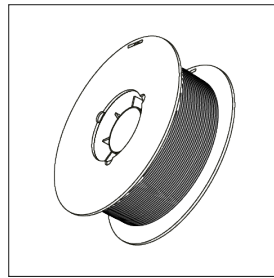
## 2.1 About the 3D printer

### 2.1.1 Package Contents

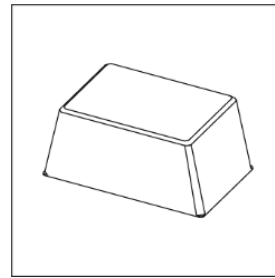
Please take an inventory of the package contents to ensure you have all the items listed below. If anything is missing or damaged, please contact BRESSER GmbH Customer Service for a replacement.



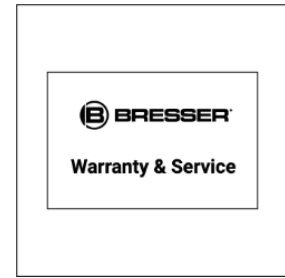
3D printer



Filament Spool (2x)



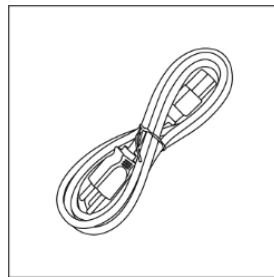
Top Cover



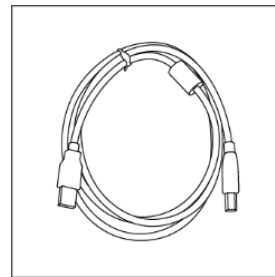
USB Cable



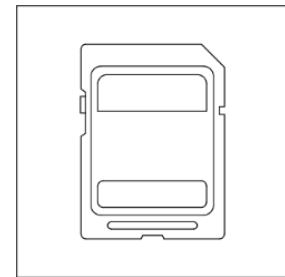
Quickstart Guide



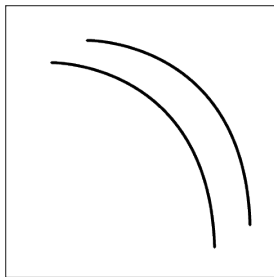
Power cable



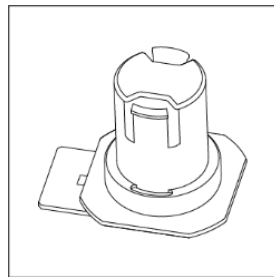
USB cable



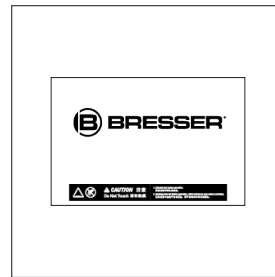
SD card



Guide tube (2x)



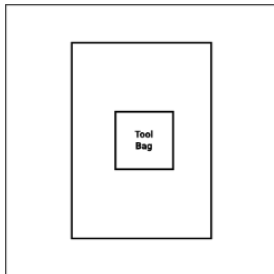
Spool holder



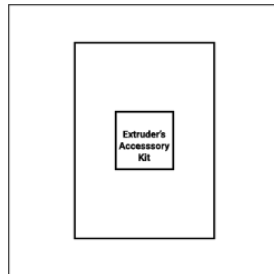
Build tape



Leveling card



Tool bag



Extruder accessory kit

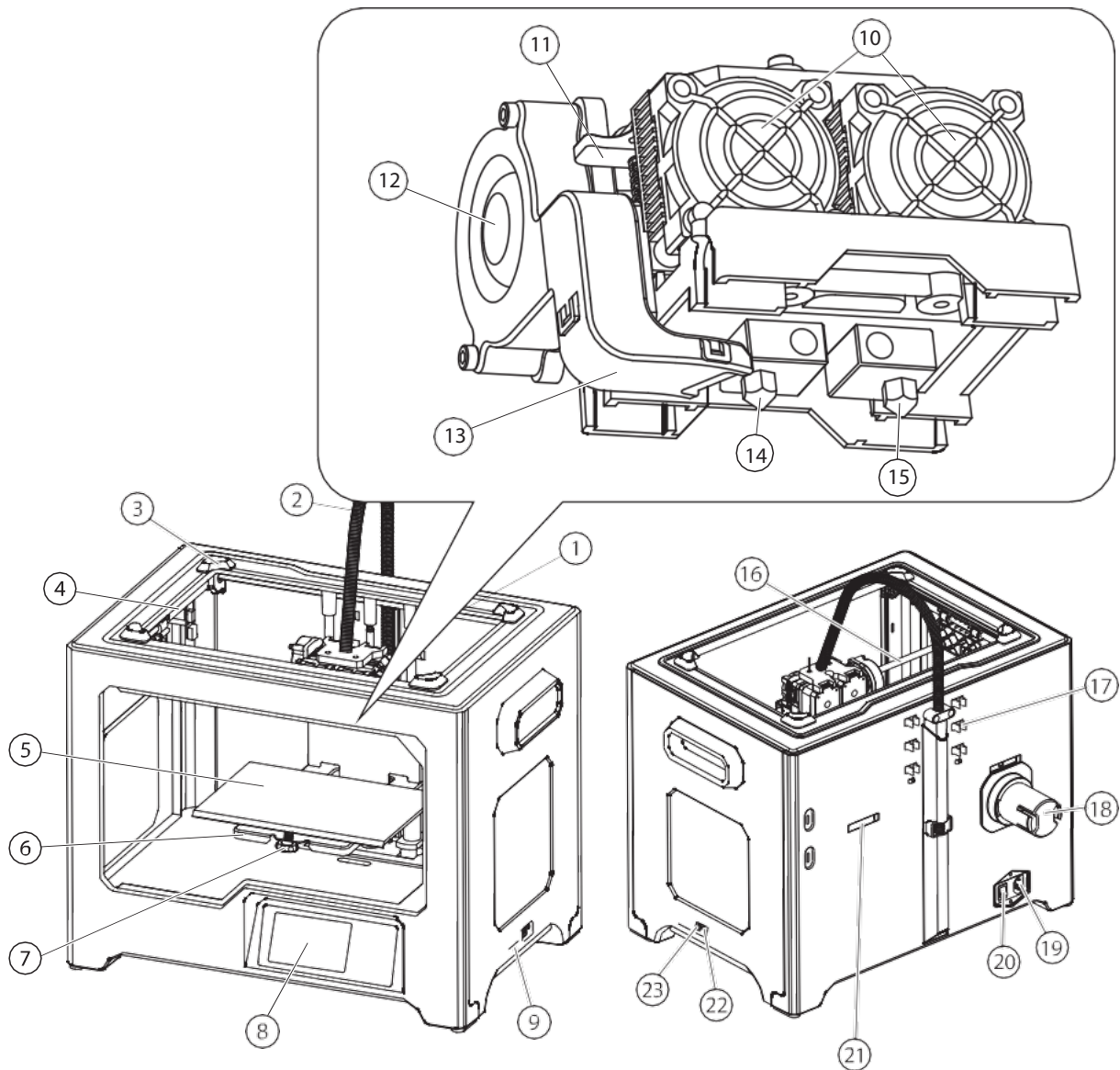
#### Tool bag including:

Allen wrench (2x), knob, M3x8 bolt (2x), PTFE tube (2x), grease, pin tool, wrench

#### Extruder's accessory kit including:

M3x8 bolt (2x), M3x6 bolt, turbofan baffle

## 2.1.2 Product overview



- |                         |                     |                                |                       |
|-------------------------|---------------------|--------------------------------|-----------------------|
| 1. Z-Axis Guide Rod     | 7. Leveling Knob    | 14. Left Nozzle                | 19. Power Input       |
| 2. Extruder Cable Bunch | 8. Touch Screen     | 15. Right Nozzle               | 20. Power Switch      |
| 3. Slot                 | 9. SD Card Slot     | 16. X-Axis Guide Rod           | 21. Spool Holder Slot |
| 4. Y-Axis Guide Rod     | 10. Cooling Fan     | 17. Filament Guide Tube Buckle | 22. Reset Button      |
| 5. Build Plate          | 11. Spring Presser  | 18. Spool Holder               | 23. USB Input         |
| 6. Build Platform       | 12. Turbofan        |                                |                       |
|                         | 13. Turbofan Baffle |                                |                       |

## 2.1.3 Device specifications

Model	BRESSER T-REX WIFI 3D Printer with Twin Extruder technology
Number of Extruders	2
Printing Technology	Fused Filament Fabrication (FFF)
Screen Type	3.5" color IPS touch screen
Build Area	227 x 148 x 150 mm
Layer Resolution	0.05 - 0.4 mm
Build Accuracy	±0.1-0.2mm
Positioning Accuracy	XY Axis: 0.011mm, Z Axis: 0.0025mm
Filament Diameter	1.75mm ±0.07mm
Filament Types	ABS, PLA, Conductive PLA, Flexible Filament
Nozzle Diameter	0.4mm
Build Speed	30~200 mm/sec
Software	RexPRINT
Supported Input Formats	3MF, .STL, .OBJ, .FPP, .BMP, .PNG, .JPG, .JPEG
Supported Output Formats	.G, .GX
Supported Operating Systems	Windows® XP and later (32-bit and 64-bit), Mac® OS X®, Linux®
Input Power	100V-240V~, 4.5A-2.5A, 47/63 Hz
Connectivity	USB cable, SD™ card, Wi-Fi®
Package Size	21.9" x 16.1" x 19.1" ( 556 x 408 x 484 mm )
Weight	41.4 lbs. (18.8 kg)

# Chapter 3: Getting started

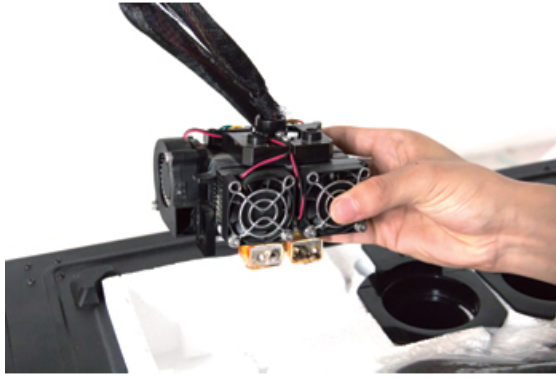
## 3.1 Unpacking



- ① Place the box on a flat, clean work surface. After opening the box, you will find two filament guide tubes, two Build Tape, a Leveling Card, and this User's Manual



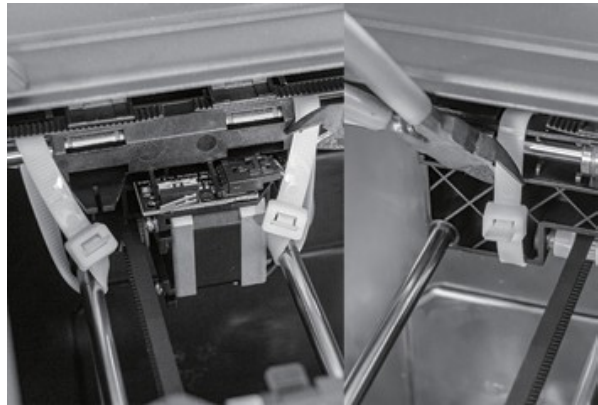
- ② Firmly grasp the two side handles, lift out from the carton and place it on a stable surface.
- ③ Remove the packing bag. And then remove the tape and plastic wrap



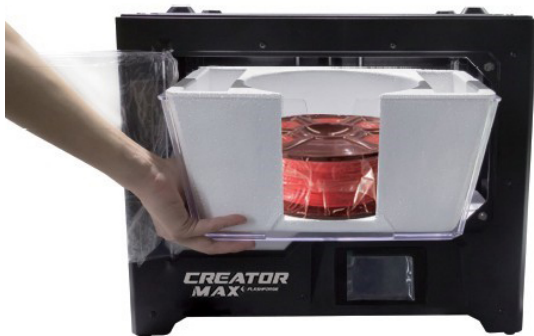
④ Take the dual extruder out and affix the extruder carefully because the extruder cable is short.



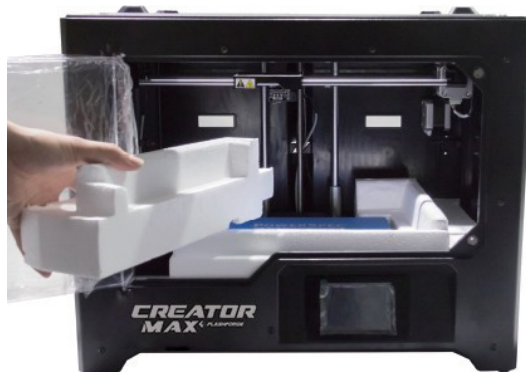
⑤ Remove the foam container. It should contain: power cable, USB cable, two spool holders, SD card, tool bag, extruder's accessory kit, one 1kg red pla filament.



⑥ Snip beltings on both sides of X-axis guide rod.



⑦ Remove lid.

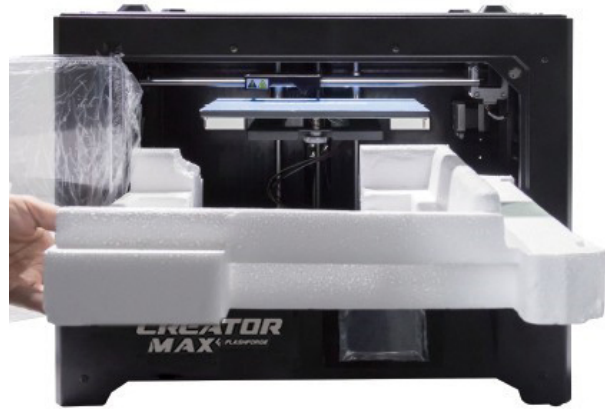


⑧ Remove side protective foam sheets from inside the printer.





- ⑨ Elevate the build plate to its limit with care



- ⑩ Take the bottom protective foam from the printer and then lower the build plate back.

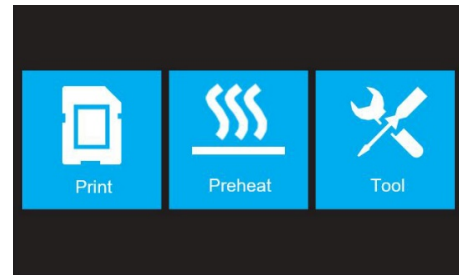
Congratulations, you have finished unpacking your 3D printer!

## 3.2 Main Menu System

### Top Menu

The Top Menu is displayed after the printer is connected to power and initialized.

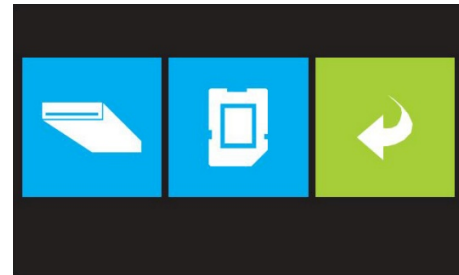
- Touch the Print button to enter the Print Menu.
- Touch the Preheat button to enter the Preheat Menu.
- Touch the Tools button to enter the Tools Menu.



### Print Menu

The Print Menu is displayed by touching the Print button from the Top Menu.

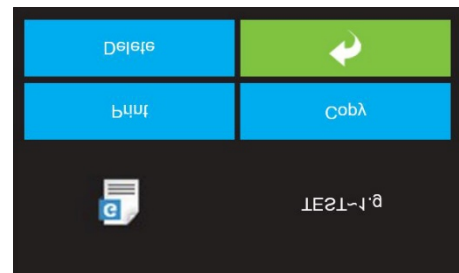
- Touch the Internal Memory button to read the print file from the internal memory.
- Touch the SD™ Card button to read the print file from the SD card.
- Touch the Back button to return to the previous menu.



### Print File Screen

The Print File Screen is displayed after selecting a print file from the internal memory or the SD™ card. The print filename is displayed.

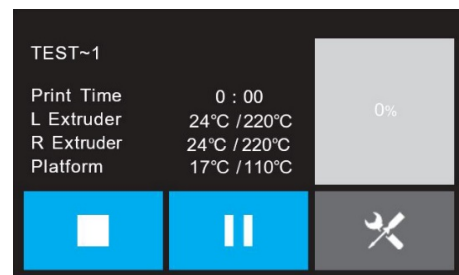
- Touch the File icon to display a list of available model files.
- Touch the Print button to begin printing the uploaded print file.
- Touch the Copy button to copy the uploaded print file.
- Touch the Delete button to delete the uploaded print file.
- Touch the Back button to return to the previous menu.



### Print Progress Screen

The Print Progress Screen is displayed while printing is in progress. It shows the print file name, the actual and target temperatures, and the print progress with the remaining time displayed.

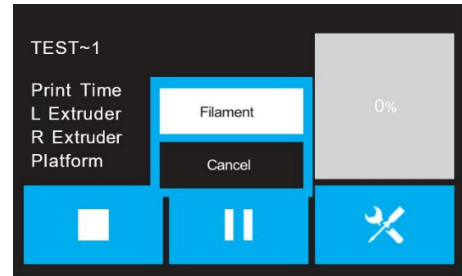
- Touch the Stop button to cancel the print in progress.
- Touch the Pause button to pause the print. Touch the Resume button to resume printing.
- Touch the Tools button to display the Print Tools Menu.



## Print Tools Menu

The Print Tools Menu is displayed by touching the Tools button on the Print Progress Screen.

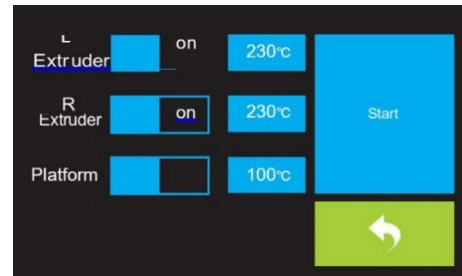
- Touch the Filament button to change filament during printing. Note that the print must be paused first.
- Touch the Camera button to turn the camera on or off.
- Touch the Cancel button to return to the Print Progress Screen.



## Preheat Menu

The Preheat Menu is displayed by touching the Preheat button on the Top Menu.

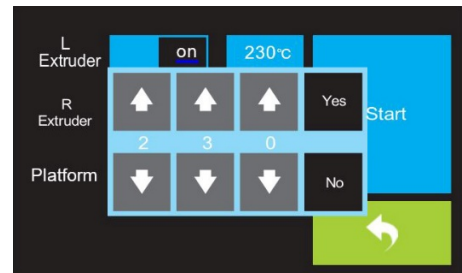
- Touch the slider buttons to turn extruder and platform heating on or off.
- Touch the target temperature buttons to set the preheat temperature. The default target print temperature for the extruders is 230°C and 100°C for the platform.
- Touch the Start button to start preheating the extruder(s) and/or platform.
- Touch the Back button to return to the previous menu.



## Preheat Temperature Screen

The Preheat Menu is displayed by touching the Preheat button on the Top Menu.

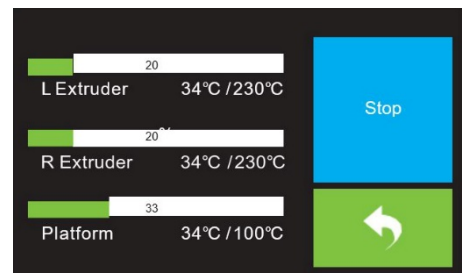
- Touch the slider buttons to turn extruder and platform heating on or off.
- Touch the target temperature buttons to set the preheat temperature. The default target print temperature for the extruders is 230°C and 100°C for the platform.
- Touch the Start button to start preheating the extruder(s) and/or platform.
- Touch the Back button to return to the previous menu.



## Preheating Screen

The Preheating Screen is displayed during the preheating process. It displays the preheating progress, as well as the actual and target temperatures of each element.

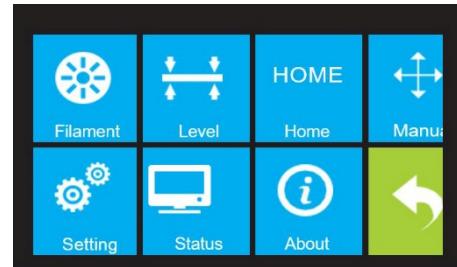
- Touch the Stop button to abort the preheating process.
- Touch the Back button to return to the previous menu.



## Tool Menu

The Tool Menu is displayed by touching the Tool button on the Top Menu.

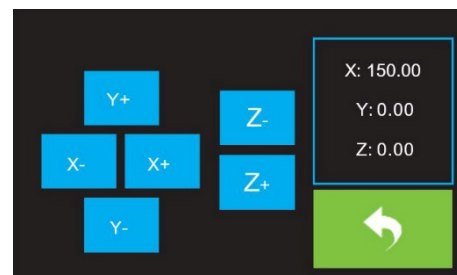
- Touch the Filament button to load or unload filament.
- Touch the Level button to level the build plate.
- Touch the Home button to move the extruder to the home position.
- Touch the Manual button to display the Manual Adjustment Screen.
- Touch the Setting button to display the Setting Menu.
- Touch the Status button to display the Printer Status Screen.
- Touch the About button to display About Screen.
- Touch the Back button to return to the previous menu.



## Manual Adjustment Screen

The Manual Adjustment Screen displays the X and Y positions of the extruder and the Z position of the build plate.

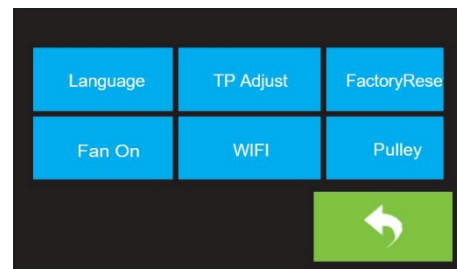
- Touch the X+ button to move the extruder to the right.
- Touch the X- button to move the extruder to the left.
- Touch the Y+ button to move the extruder towards the back of the printer.
- Touch the Y- button to move the extruder towards the front of the printer.
- Touch the Z+ button to raise the build plate.
- Touch the Z- button to lower the build plate.
- Touch the Back button to return to the previous menu.



## Setting Menu

The Setting Menu is displayed by touching the Setting button on the Tool Menu.

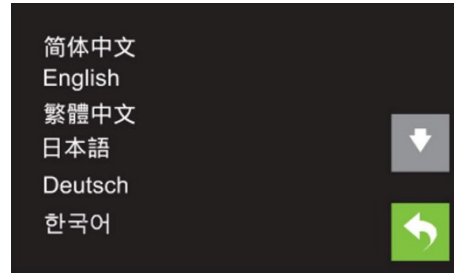
- Touch the Language button to select the language for the OSD Menu System.
- Touch the Fan button to turn the fan on or off.
- Touch the TP adjust to recalibrate the screen.
- Touch the WIFI button to display the WIFI Screen.
- Touch the Factory Reset button to reset the printer settings to their factory default values.
- Touch the Update button to update the firmware.
- Touch the Pulley button to display the Pulley Type Selection Screen.
- Touch the Back button to return to the previous menu.



## Language Menu

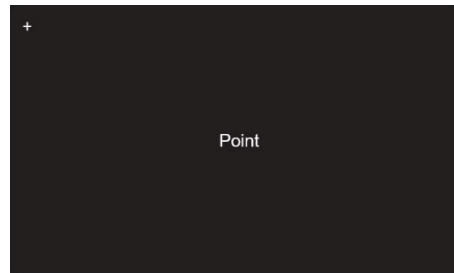
The Language Menu is displayed by touching the Language button in the Setting Menu.

- Touch the specific language name to set the OSD menu system to use that language.
- Touch Scroll down button to display the next page of languages.
- Touch Scroll Up button (not displayed) to display the previous page of languages.
- Touch the Back button to return to the previous screen.



## TP Adjust

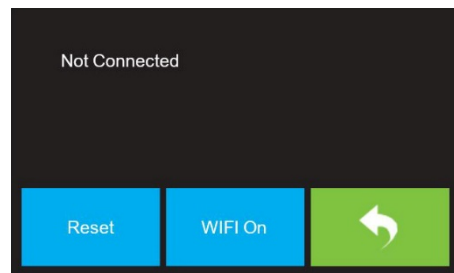
The TP Adjust is displayed by touching four point showed in the screen to recalibrate screen. Just follow and touch the plus sign.



## WIFI Screen

The WIFI Screen is displayed by touching the WIFI button on the Setting Menu.

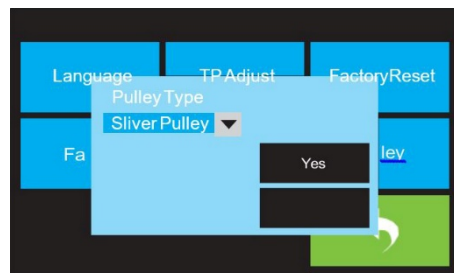
- Touch the Reset button to reset the Wi-Fi® radio.
- Touch the WIFI On button to turn the Wi-Fi radio on, release the Wi-Fi hotspot, and set the Wi-Fi on the computer.
- Touch the Back button to return to the previous menu.



## Pulley Type Selection Screen

The Pulley Type Selection Screen is displayed by touching the Pulley button on the Setting Menu.

- Touch the Down Arrow next to the currently selected pulley type to display a list of available pulley types. Touch the name of a pulley type to select it.
- Touch the Yes button to save changes to the selected pulley type.
- Touch the Cancel button to abort any changes to the selected pulley type.



## Status Screen

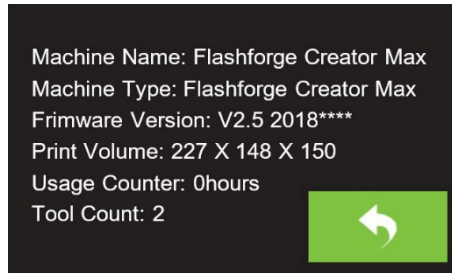
The Status Screen is displayed by touching the Status button on the Tool Menu. It displays the real-time status of the printer.

- Touch the Back button to return to the previous menu.

## About Screen

The About Screen is displayed by touching the About button on the Tool Menu. It displays basic information about the printer.

- Touch the Back button to return to the previous menu.

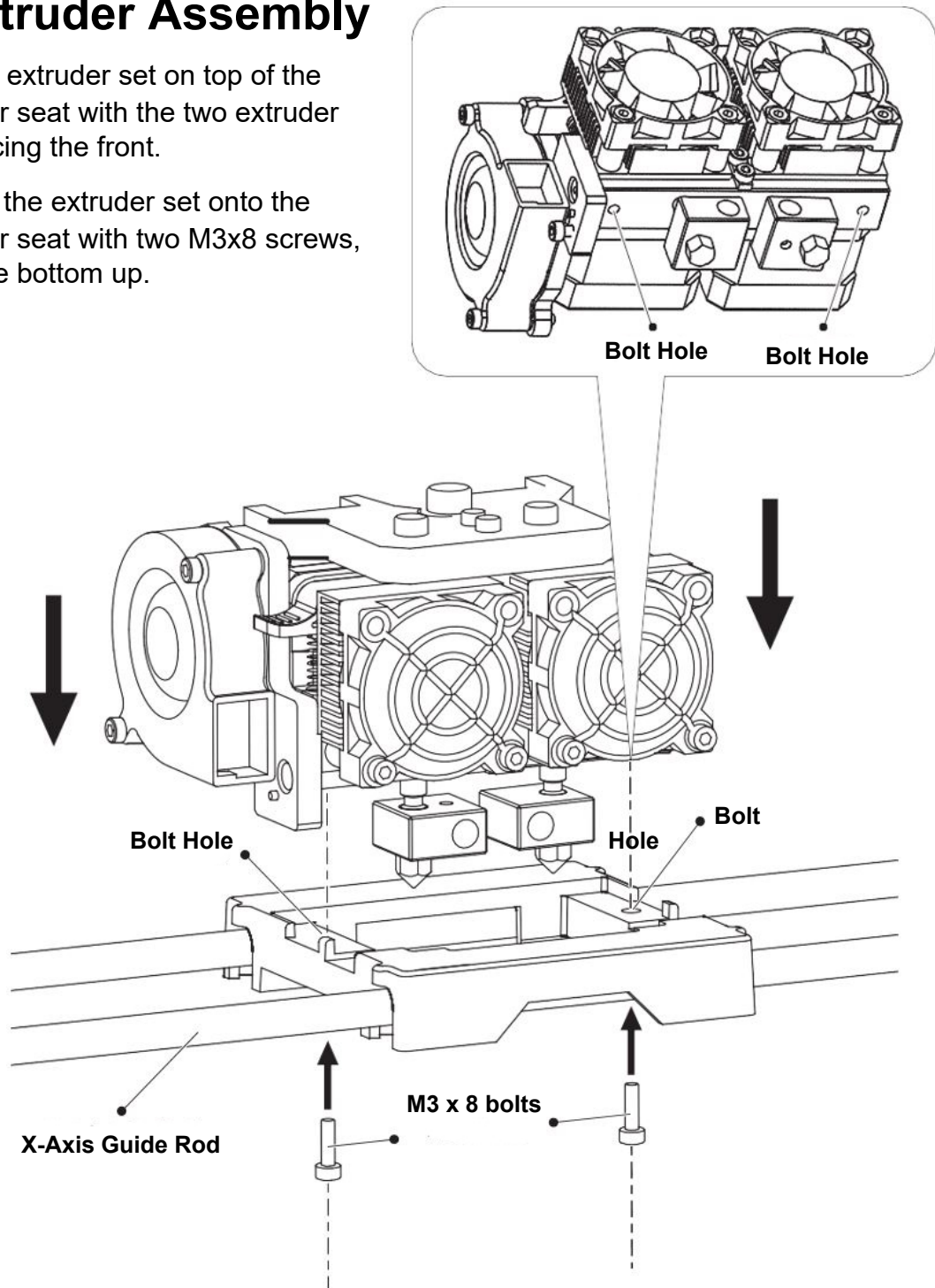


# Chapter 4: Hardware Assembly

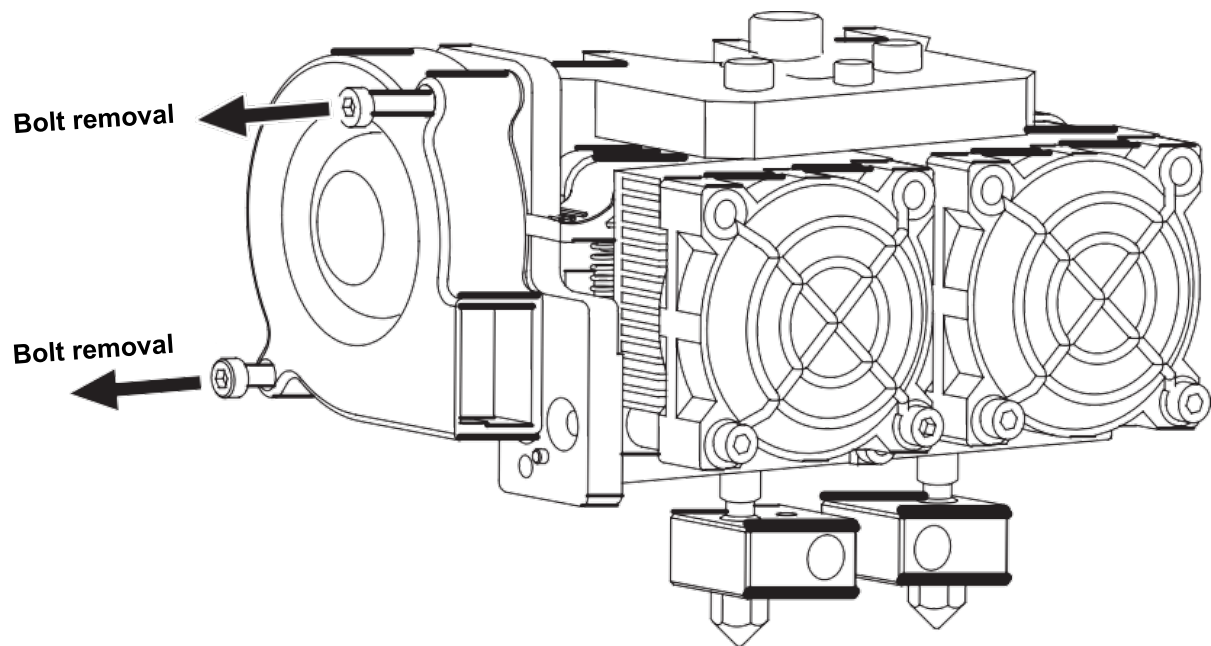
The printer comes pre-assembled and is almost ready to print. All you need to do is to set the appropriate voltage, mount the extruder set, and install the filament. It will only take about 5-10 minutes to setup the printer and prepare for your first 3D print!

## 4.1 Extruder Assembly

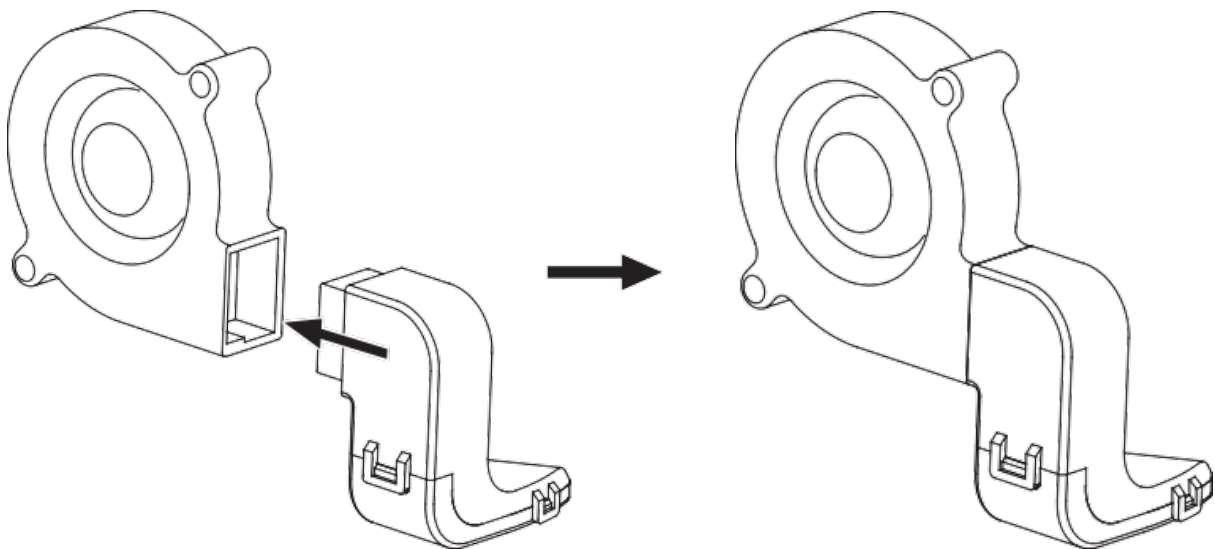
- ① Lay the extruder set on top of the extruder seat with the two extruder fans facing the front.
- ② Secure the extruder set onto the extruder seat with two M3x8 screws, from the bottom up.



## Turbofan Baffle Assembly



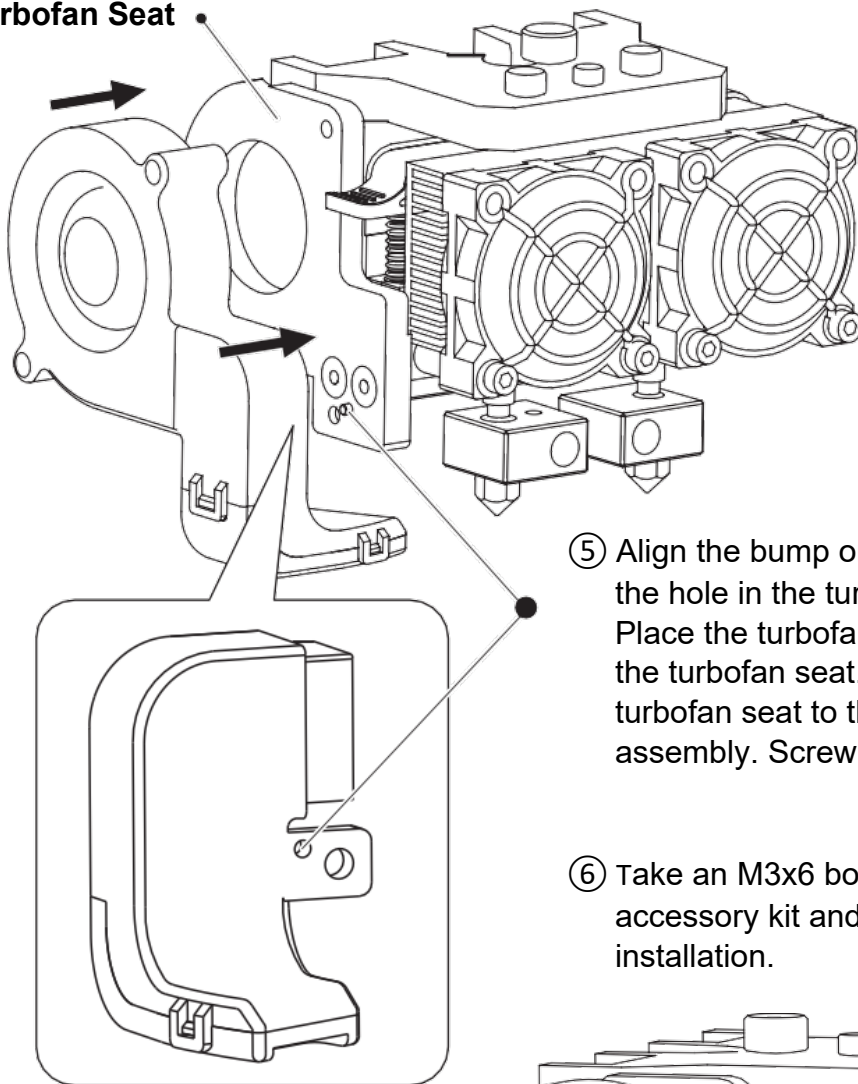
- ③ Use the M2.5 Allen wrench to unscrew the two turbofan bolts.



- ④ Take the turbofan baffle from the extruder's accessory kit and install it onto the turbofan.

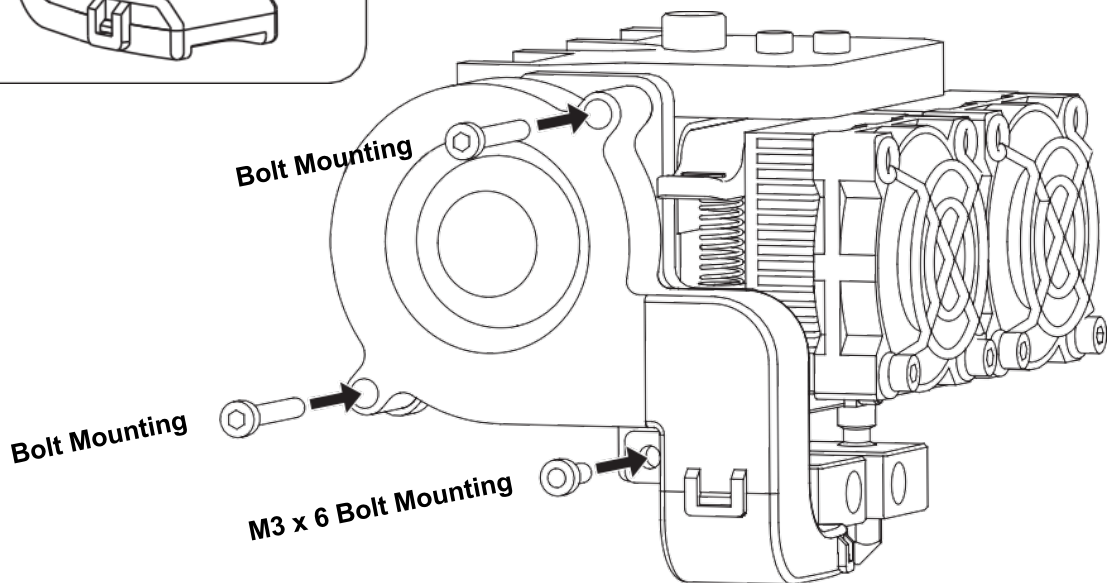


**Turbofan Seat**

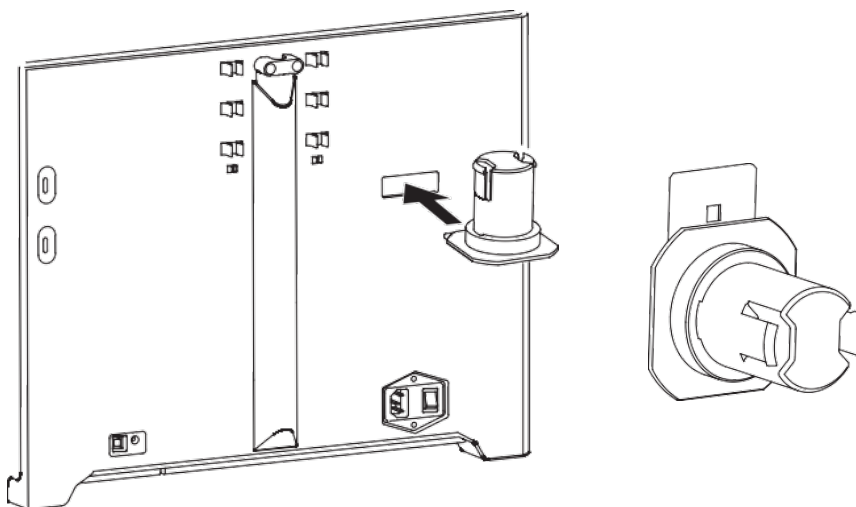


⑤ Align the bump on the turbofan seat to the hole in the turbofan sub-assembly. Place the turbofan sub-assembly beside the turbofan seat. Insert the bump on the turbofan seat to the turbofan sub-assembly. Screw in the two bolts.

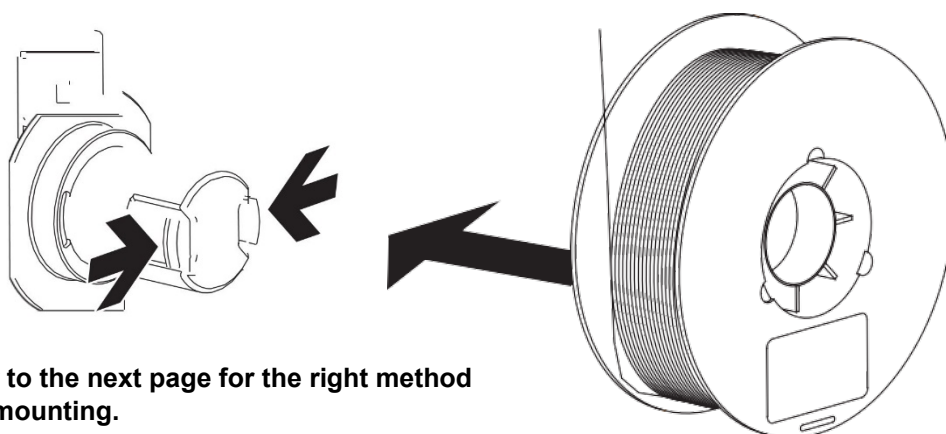
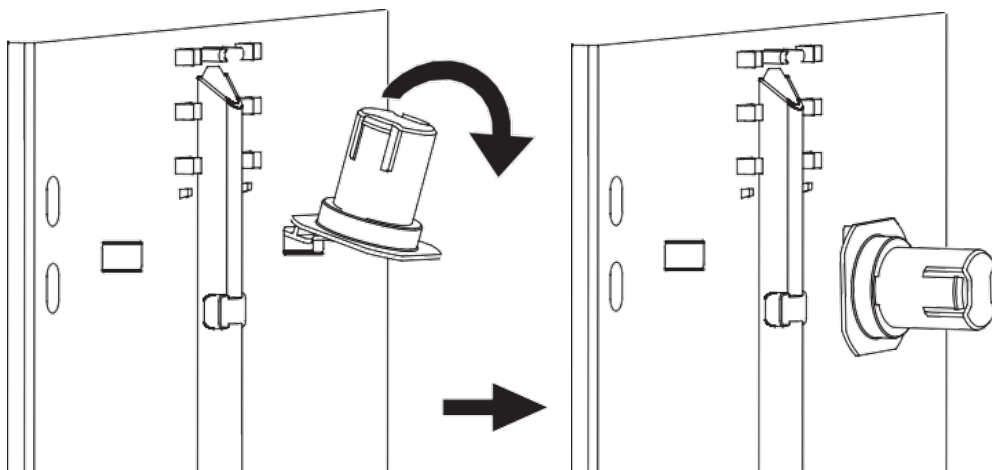
⑥ Take an M3x6 bolt from the extruder's accessory kit and complete the installation.



- ⑦ The next step goes to the installation of the spool holders. Install one on each side. To install a spool holder, level it and insert the end into one of the openings.

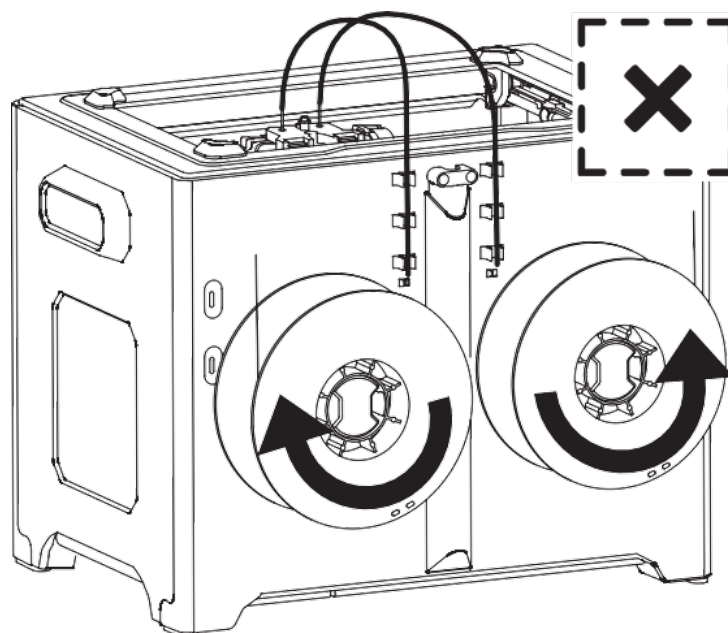
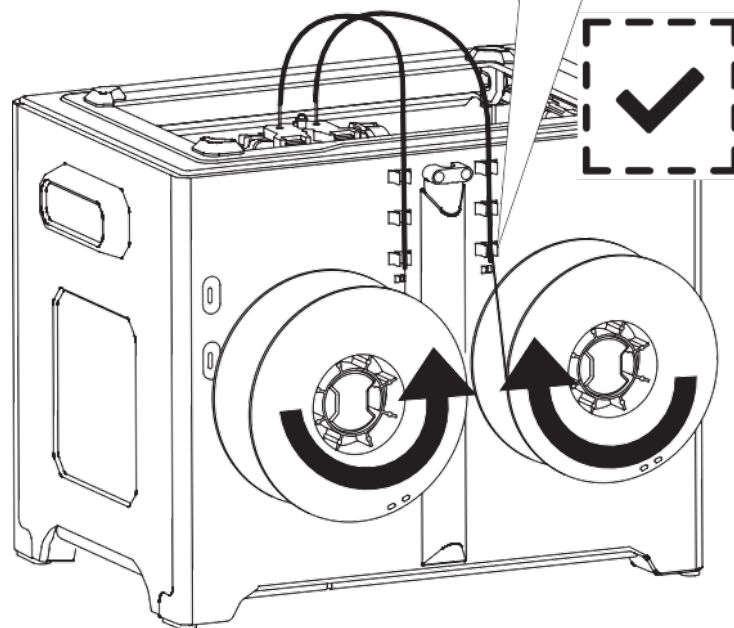
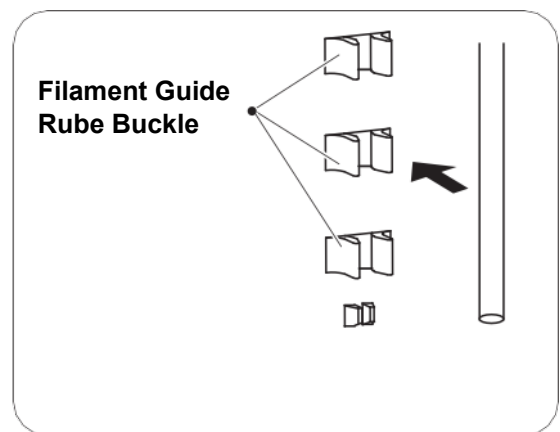


- ⑧ Turn down the spool holder to make the holder bottom cleave to the printer back.

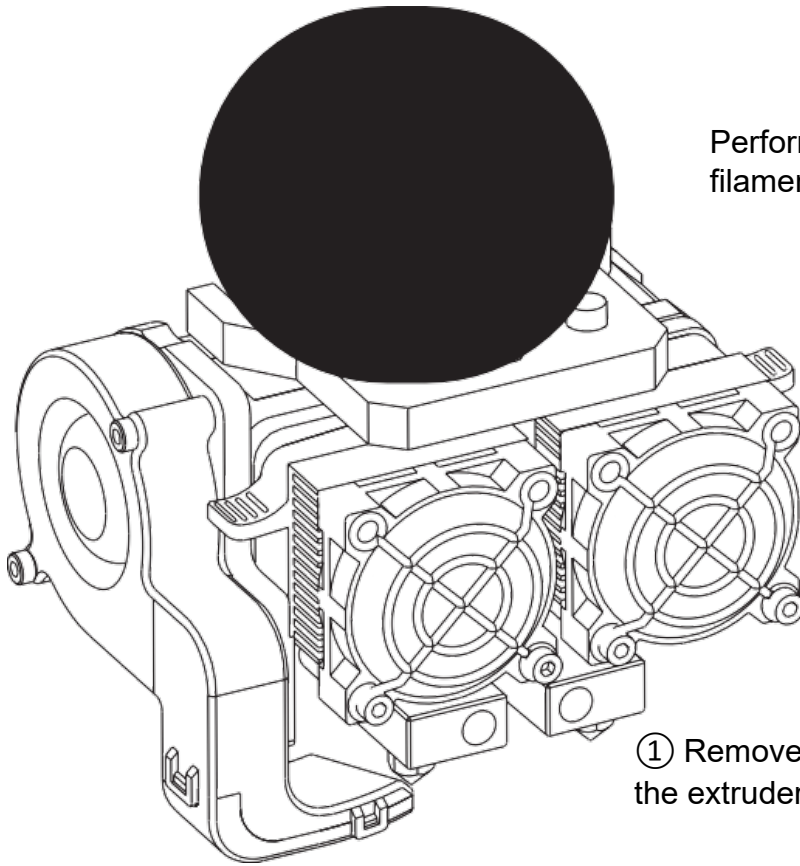


**Please refer to the next page for the right method of filament mounting.**

- ⑨ To lock the filament guide tube with R-shape buckles and insert another end to the filament intake. To avoid filament jams, always ensure that any filament spool you mount on the p feeds from the bottom of the spool toward the top. Filament mounted on the right spool holder when viewed from the back should always unspool clockwise and filament loaded onto the left spool holder should always unspool counterclockwise.

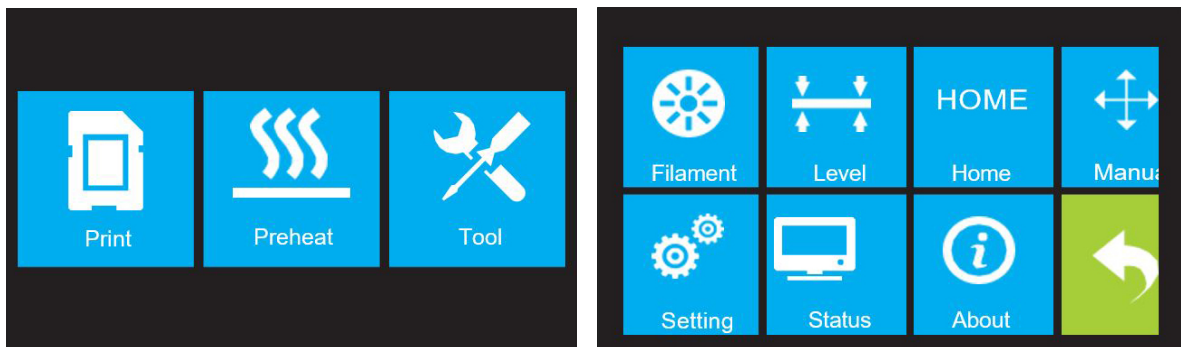


## 4.2 Loading Filament

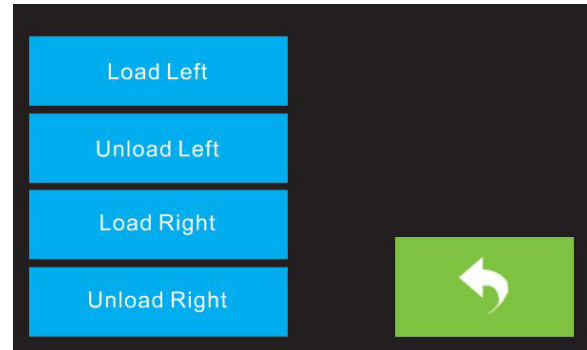
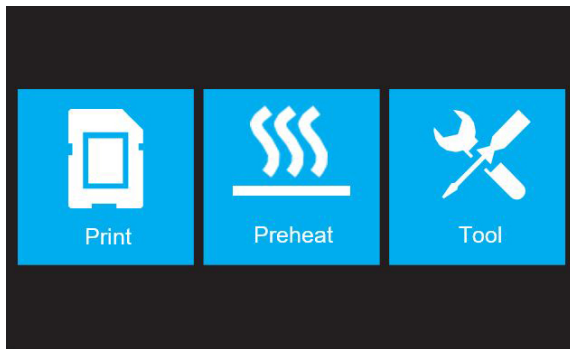


Perform the following steps to load filament into your 3D printer.

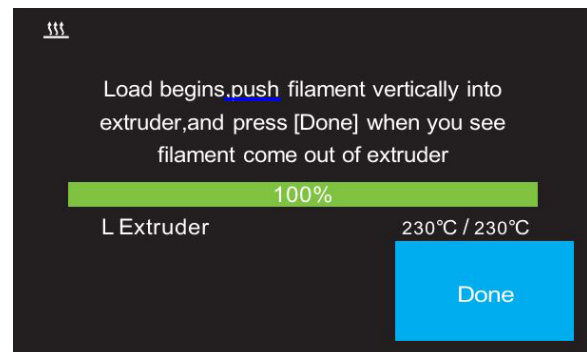
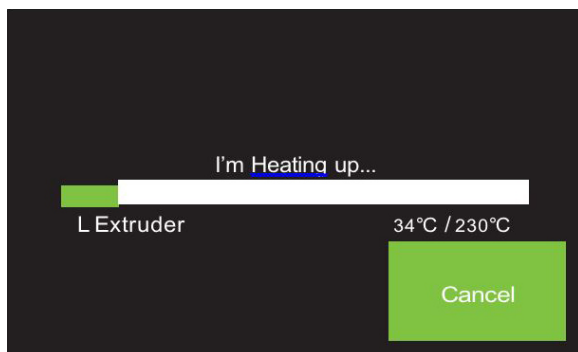
- ① Remove the filament guide tube from the extruder.



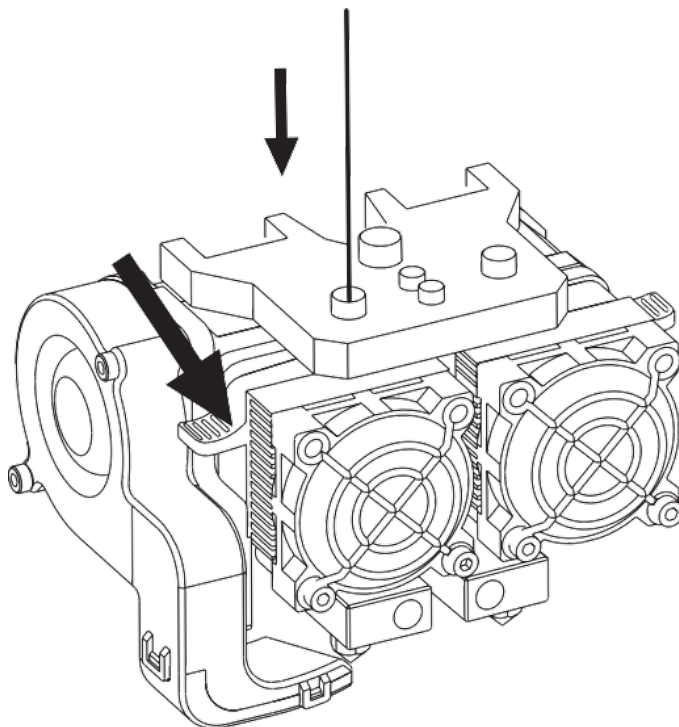
- ② If it is not already powered on, flip the power switch to the ON position. Wait for the system to stabilize, then touch the **Tool** button on the **Top Menu**.



- ③ Touch the Filament button, then touch the **Load Left** button.



- ④ Wait for the extruder to heat up to the target temperature. The extruder will alert you when it is at the target temperature.

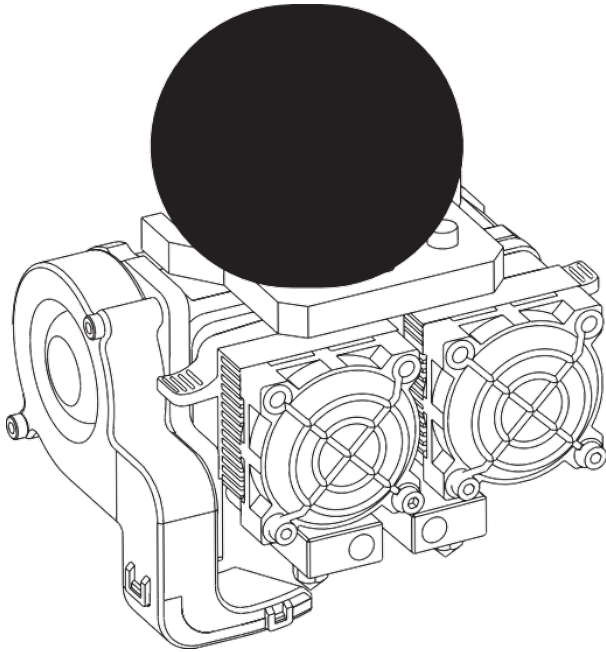


- ⑤ Load the filament by inserting it into the extruder at an upright angle. Filament will start to extrude out of the nozzle. Continue loading to ensure that the filament is extruding in a straight line. Refer to the troubleshooting section if the filament is extruding abnormally.

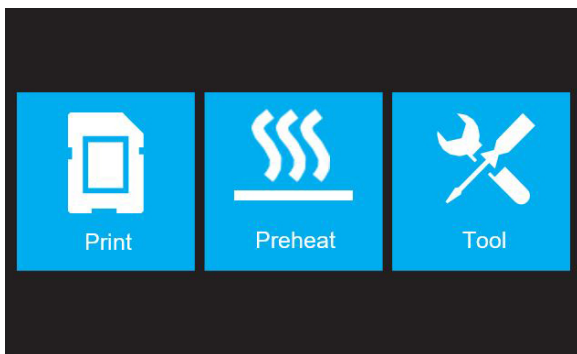
Touch the **Done** button to finish loading.

Congratulations, you have successfully loaded filament into your printer!

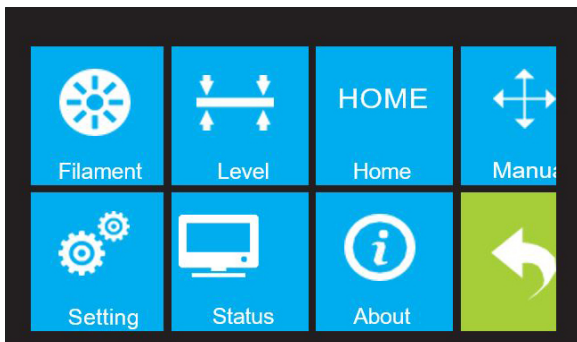
## 4.3 Unloading Filament



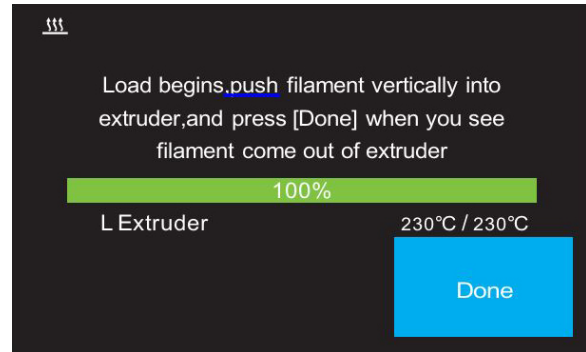
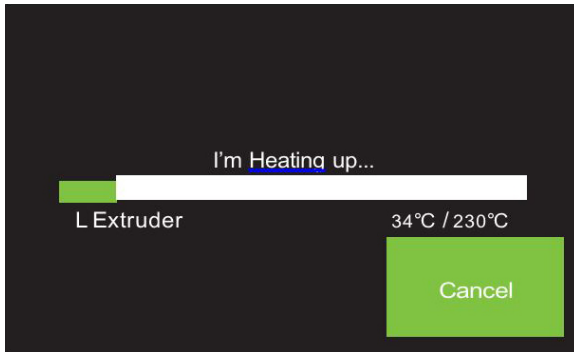
① Remove the tube.



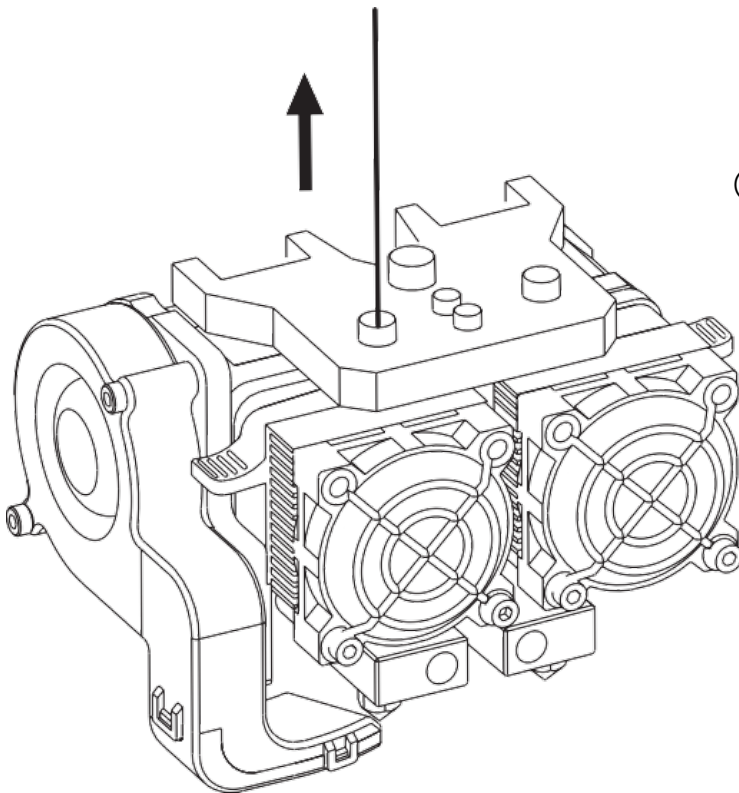
② If it is not already powered on, flip the power switch to the ON position. Wait for the system to stabilize, then touch the **Tool** button on the Top Menu.



③ Touch the **Filament** button, then touch the **Unload Left** button.



- ④ Wait for the extruder to heat up to the target temperature. The extruder will alert you when it is at the target temperature.



- ⑤ Unload the filament by gently guiding it out of the extruder, then touch the Done button to finish unloading.

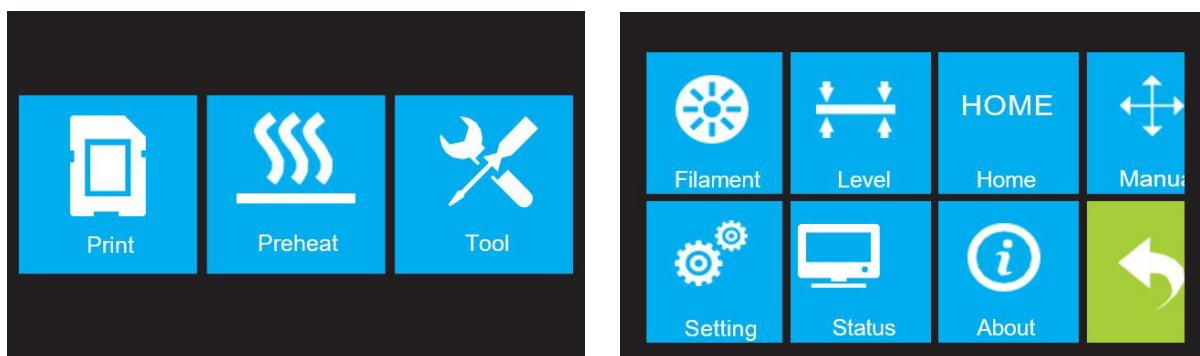
# Chapter 5: Build Plate Leveling

A properly leveled build plate is required for high-quality 3D prints. If you have any problems printing an object, you should first check whether the build plate is properly leveled or not.

A general rule of thumb is to leave a gap that is the thickness of a piece of paper. However, for printing finer objects (150 microns and lower), use a feeler gauge to level the build plate as it requires a lesser gap between the nozzle and the build plate.

The printer uses a three-point leveling system for the build plate. At the bottom of the build plate, there is a spring-loaded knob in the front and two in the back. Tightening the knob will increase the gap between the build plate and the nozzle and loosening it will reduce the gap.

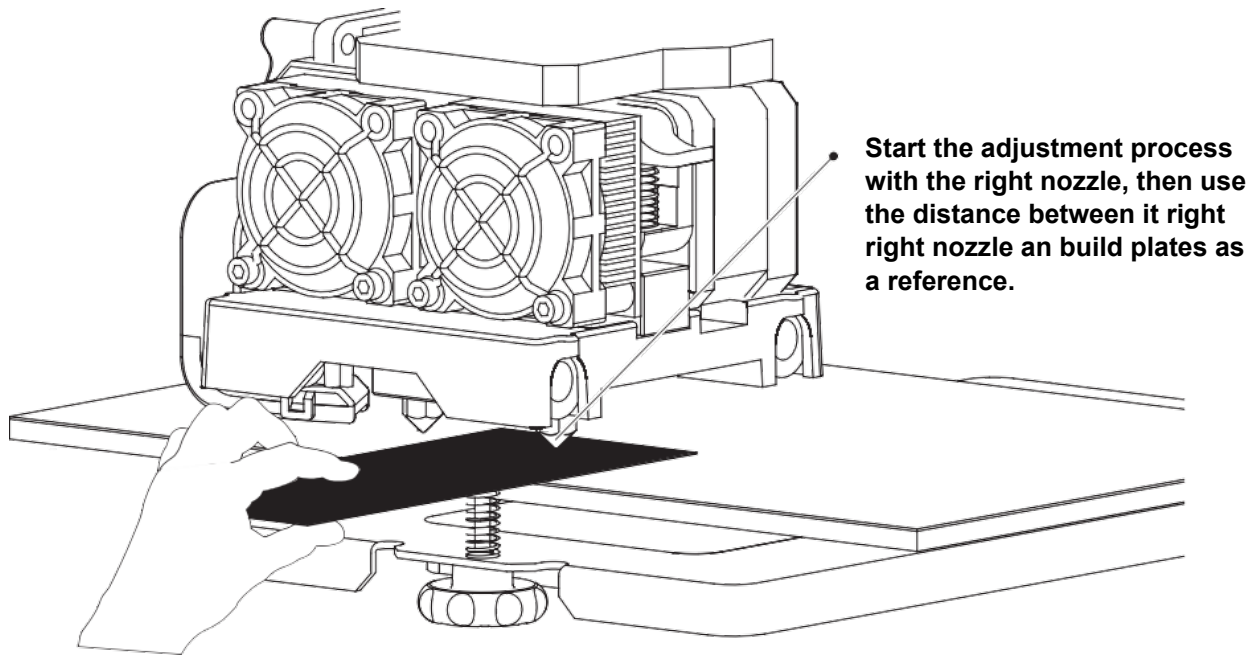
Perform the following steps to level the build plate.



- ① If it is not already powered on, flip the power switch to the ON position. Wait for the system to stabilize. Touch the **Tool** button on the Top Menu, then touch the **Level** button on the Tool Menu. The extruder and build plate will move to the starting position.
- ② Take out the Leveling Card.







- ③ Once the extruder and build plate stop moving, slide the Leveling Card continuously back and forth between the nozzles and the build plate, while simultaneously adjusting the knob just enough so that the card causes a slight friction.

Touch the **Next** button and wait for the extruder to move to the second position. Slide the card back and forth again and adjust the knob to create the same amount of friction as the previous step.

Touch the **Next** button again and repeat the same leveling steps.

Touch the **Next** button. The nozzle will move to the center of the build plate. Slide the card through to make sure there is a slight friction. Slowly adjust all screws by the same amount if there is no friction or too much friction.

Touch the **Finish** button to complete the leveling process.




# Chapter 6: Information on the software

## 6.1 Software installation

### 6.1.1 Procurement of the Software

#### Method 1: USB flash drive

The complete installation package is located on the USB stick that is included in the delivery:

 REXprint_3.7.1_win64	2016/1/8 8:48	Windows Install...	41,637 KB
 REXprint_3.7.1_win32	2016/1/8 8:48	Windows Install...	37,995 KB
 REXprint_3.7.1_mac	2016/1/8 8:47	压缩(zipped)文件...	16,599 KB

#### Method 2: Internet download

Go to the 3D printer product page on the Internet via the following link:

<http://www.bresser.de/P2010500>

The software packages can be found under the tab "Downloads" and can be downloaded from there.

### 6.1.2 Installing and setting up the software

#### Installation

Decompress the copied ZIP file, and complete the installation according to the provided instructions. Connect your 3D printer to your computer using the included USB cable, ensure that the printer is connected to your computer successfully. Start the software by selecting the shortcut on your computer's desktop or in the Start Menu.



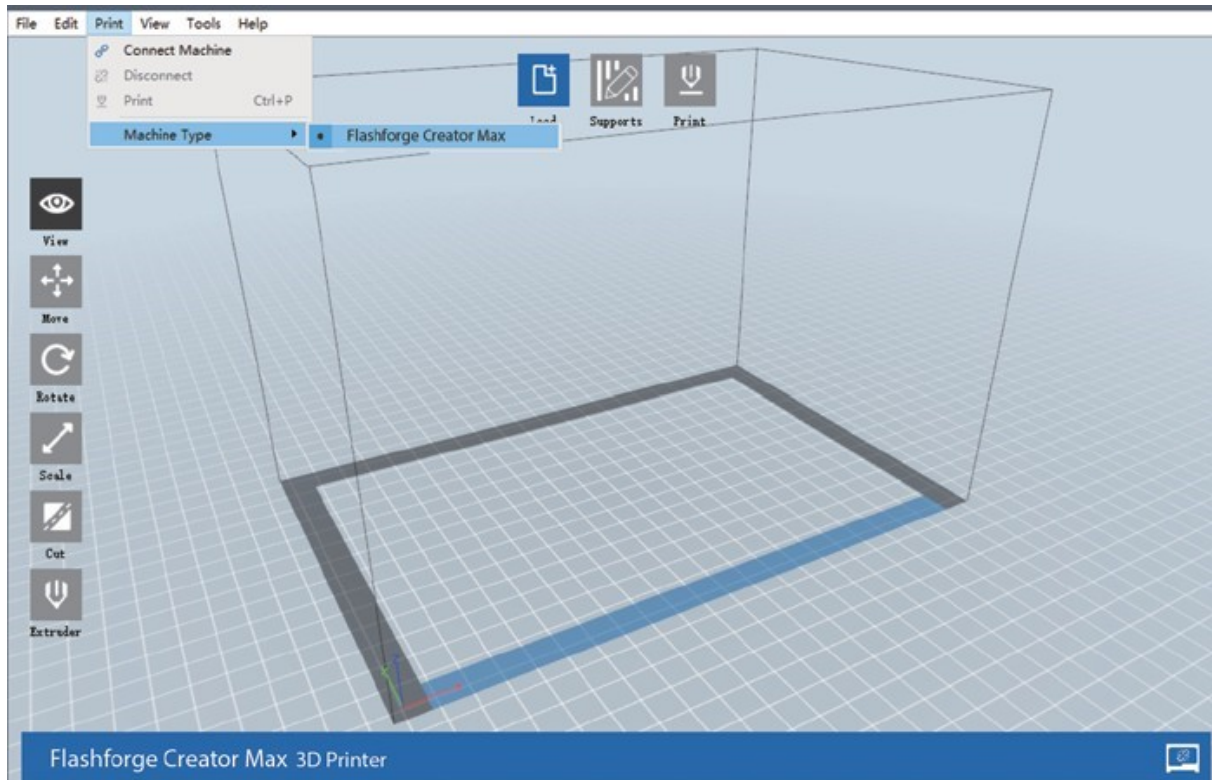
**Note:** This software supports Windows XP/Win 7/Win8 32-bit and 64 bit, and Mac operating system.

## 6.2 Getting started with REXprint

### 6.2.1 Selecting the type of device

Once REXprint has been installed, double-click the application shortcut to start the programme.

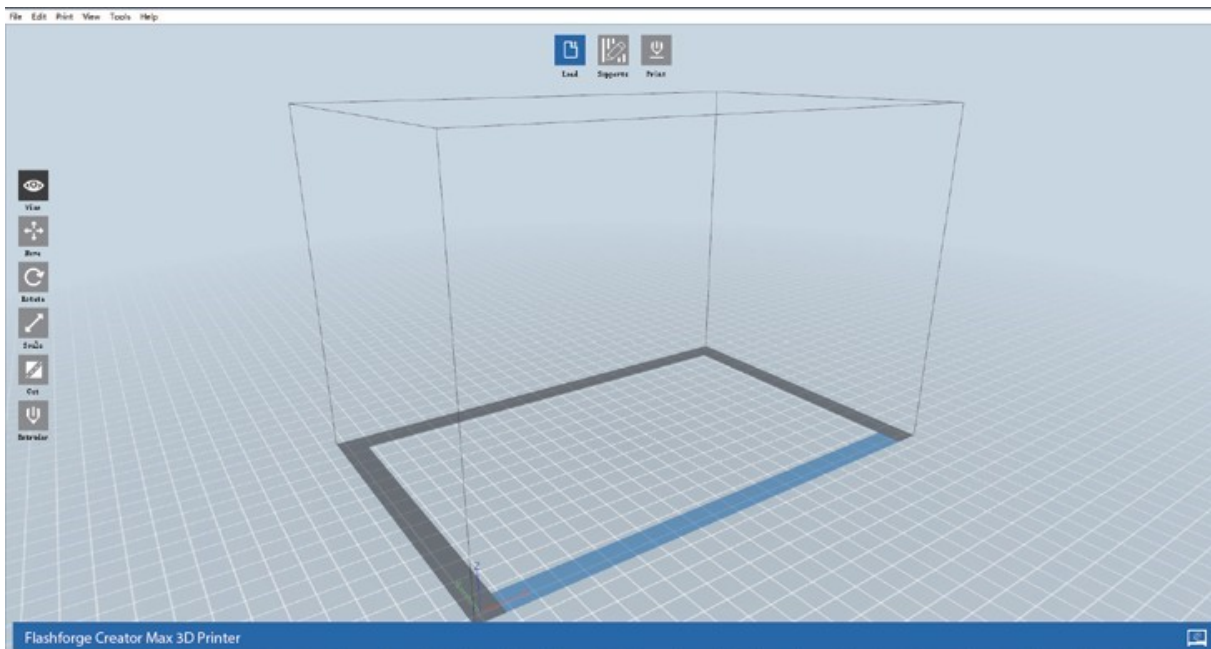
If this is the first time the programme has been run, you will be presented with a dialogue asking you to select the Machine Type. Choose the Flashforge Creator Max entry.



You can also select the Machine Type from within the programme by clicking **Print > Machine Type > T-REX**, as shown in the screenshot below.

## Main Interface Overview

The screenshot below shows the three main elements of the software - the Menu, the Icons, and the Build Plate.



The icons have the functions listed in the table below.



### Load

Loads a model or Gcode file. REXprint supports .STL, .OBJ, and .FPP model files.

You can also load a .PNG, .JPG, .JPEG, or .BMP file and REXprint will generate a model from the image. See the Generating a Model section for details.



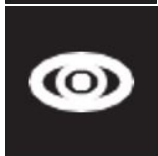
### Supports

Enters the Support Edit mode.



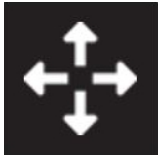
### Print

Prints directly from REXprint via a USB or wireless connection or exports a Gcode file to the SD™ card.



### View

Views the REXprint home screen from one of six viewing angles.



### Move

Moves the model around on the X/Y plane. Hold the SHIFT key then click to move the mode along the Z axis.



### Move

Moves the model around on the X/Y plane. Hold the SHIFT key then click to move the mode along the Z axis.



### Scale

Scales the size of the model.



### Cut

Cuts the model into several parts.



### Extruder

Selects the right or left extruder for printing.

## 6.2.2 Loading a File

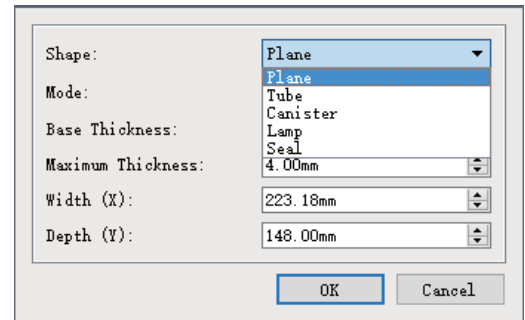
REXprint supports six different ways to load a model or Gcode file, as outlined below.

- Click the **Load** icon on the main interface, then select the file.
- Drag and drop the file onto the main interface.
- Click **File > Load File**, then select the file.
- Click **File > Load Examples** to load one of the sample files.
- Click **File > Recent Files**, then select the file from the list of recently used files.
- Drag and drop the file onto the REXprint icon on the desktop to launch REXprint and load the file.

## Generating a Model

RexPrint can generate a 3D model file from a .PNG, .JPG, .JPEG, or .BMP image file. When you load the image file, the following dialogue box will be displayed, which allows you to set several model parameters.

**Shape:** Determines the basic shape of the model. You can select Plane, Tube, Canister, Lamp, or Seal basic shapes.



**Mode:** Selects whether the light or dark portions of the image will be the high points of the model.

**Maximum Thickness:** Sets the Z value of the model.

**Base Thickness:** Sets the minimum raft thickness. The default value is 0.5mm.

**Width:** Sets the X value of the model.

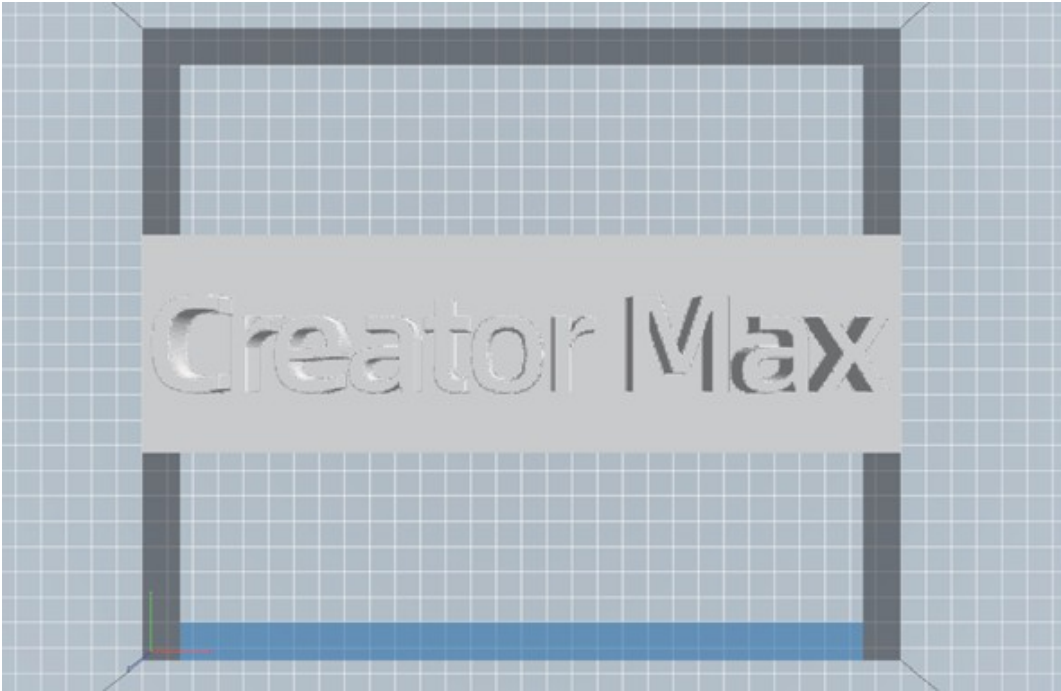
**Depth:** Sets the Y value of the model.

**Bottom Thickness:** Sets the thickness of the bottom of tube, canister, and lamp type models.

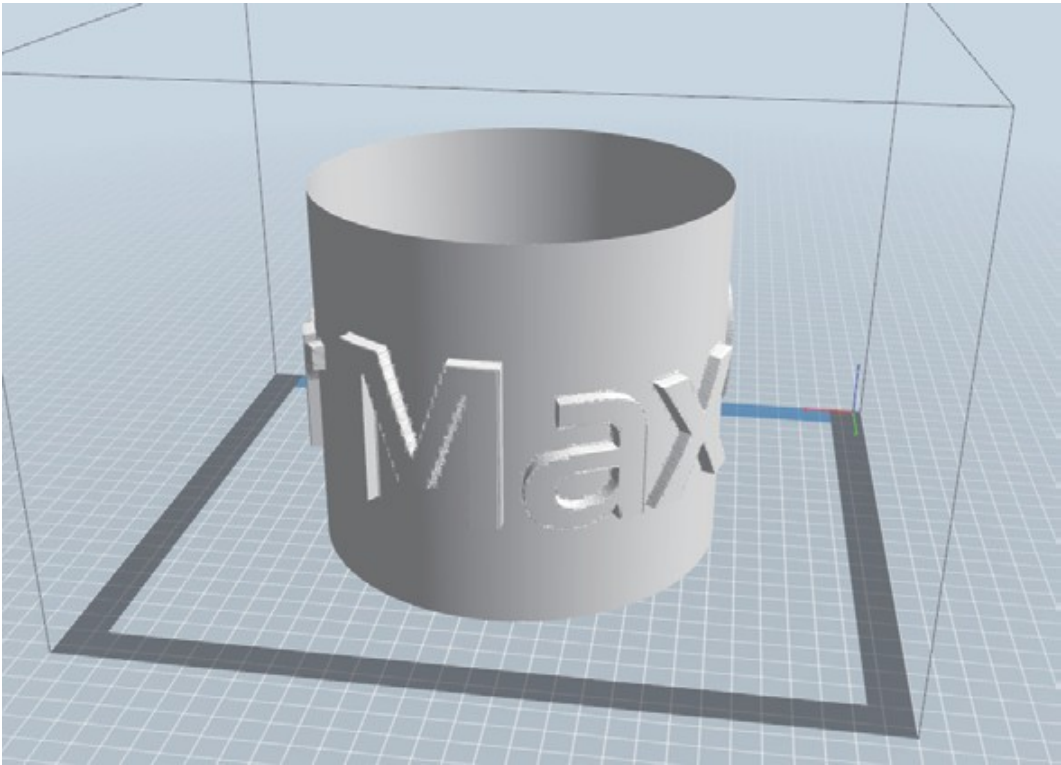
**Top Diametre:** Sets the diametre for the top of tube, canister, and lamp type models.

**Bottom Diametre:** Sets the diametre for the bottom of tube, canister, and lamp type models. The following screenshots illustrate the five basic shapes.

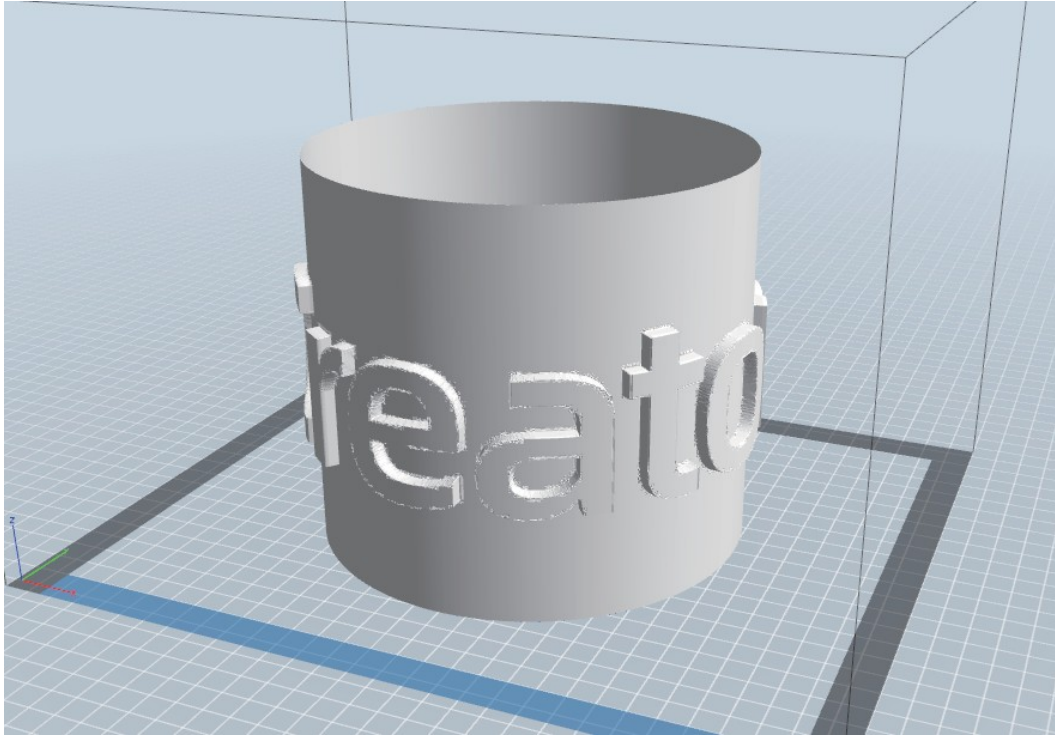
The following screenshots illustrate the five basic shapes.



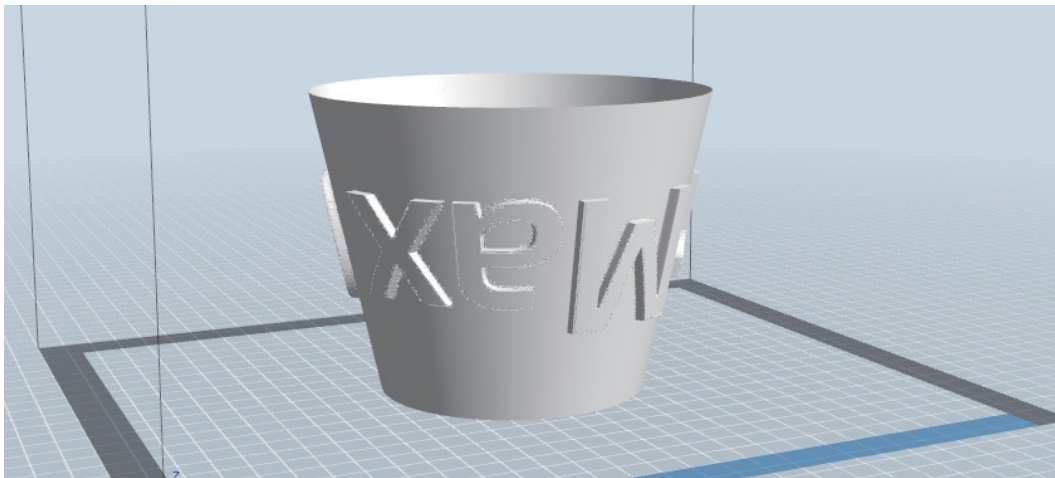
**Plane**



**Tube**



**Canister**



**Lamp**







**Seal**

## 6.2.4 Changing Views

You can change the camera angle in relation to the model and build area using a variety of methods.

**Drag:** Click the View icon  , then drag the camera using one of the following methods.


- Left click and hold, then move the mouse.
- Click and hold the mouse wheel, then scroll up or down.
- Hold down the SHIFT key, right click and hold, then move the mouse.

**Rotate:** Click the View icon  , then rotate the camera using one of the following methods.

- Right click and hold, then move the mouse.
- Hold down the SHIFT key, left click and hold, then move the mouse.

**Scale:** Scroll the mouse wheel up or down to zoom the camera in or out.

**Set View:** You can select one of six preset camera angles using one of the following methods.

- Click the **View** menu, then select one of the six options from the drop-down list.
- Click the View icon  , then click it again and a submenu will appear with six options for selection.

**Reset View:** You can reset the camera angle to the default using one of the following methods.

- Click the **View** menu, then select Home View.
- Click the **View button**, then click it again and a submenu will appear. Select the Reset option.

**Show Model Outline:** You can set RexPrint to show the model outline highlighted in yellow. To do so, click the View menu, then select the Show Model Outline option.

**Show Steep Overhang:** When the intersection angle between the model surface and a horizontal line is within the overhang threshold value, the surface has steep overhang and is shown in red when Show Steep Overhang is enabled. To enable or disable Show Steep Overhang, click the View menu, then select the Show Steep Overhang entry. The default threshold value is 45 degrees.

## 6.2.5 Model Manipulation

You can manipulate the model using a variety of methods.

**Move:** Click on the model to select it. You can then move it around the build area in a variety of ways.

- To move the model horizontally in the X/Y plane, left click and hold on the model, then move the mouse.
- To move the model vertically in the Z plane, hold down the SHIFT key, the left click and hold on the model, then move the mouse.
- Click the Move button, then enter the distance value. Click Reset to reset the distance values.

**Note:** After moving the model, click centre > On Platform to ensure that the model is in the build area and in contact with the build platform.

**Rotate:** Click on the model to select it. You can then rotate the model in all three planes in a variety of ways.

- Click the **Rotate icon** and three mutually perpendicular rings will appear around the model. Click and hold on one ring and move the mouse to rotate the model in that plane.
- Click the **Rotate icon**, then manually enter rotation angle values. Click Reset to reset the rotation angle values.

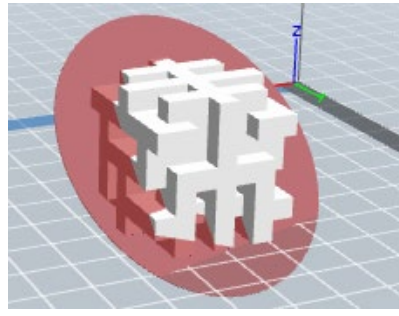
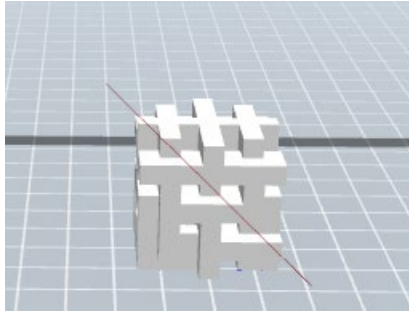
**Scale:** Click on the model to select it. You can then scale it in a variety of ways.

- Click the **Scale icon**, then hold the button and move the mouse to change the scale. The corresponding values will display near the model.
- Click the **Scale icon**, then enter scales values for the X, Y, and Z axes.
- Click the **Scale icon**, then click the Maximum button to get the largest size possible for the build area.
- Click the **Scale icon**, then click the **Reset** button to reset the size of the model.

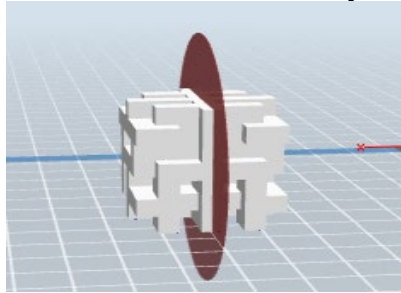
**Note that if the Uniform Scaling radio button is enabled, it will scale the model in proportion when changing any size value.**

**Cut:** Click the model to select it, then double-click the Cut icon to set the cut plane in a variety of ways.

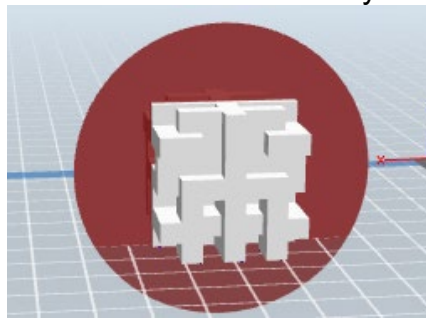
- Left click and drag the cursor across the model to set the cut angle.



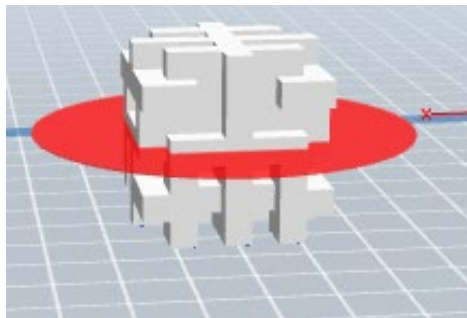
- Select the X Plane option to cut the model vertically.



- Select the Y Plane option to cut the model vertically.

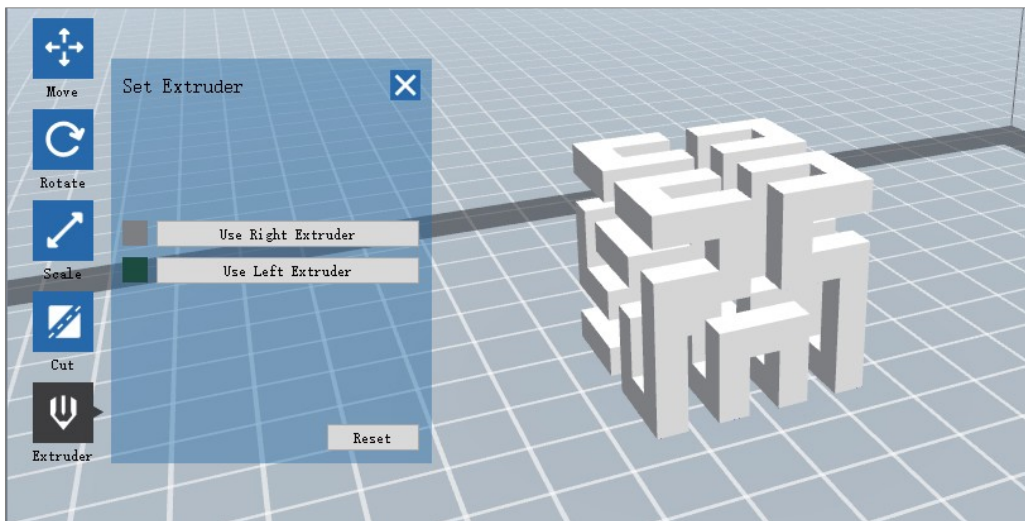


- Select the Z Plane option to cut the model horizontally



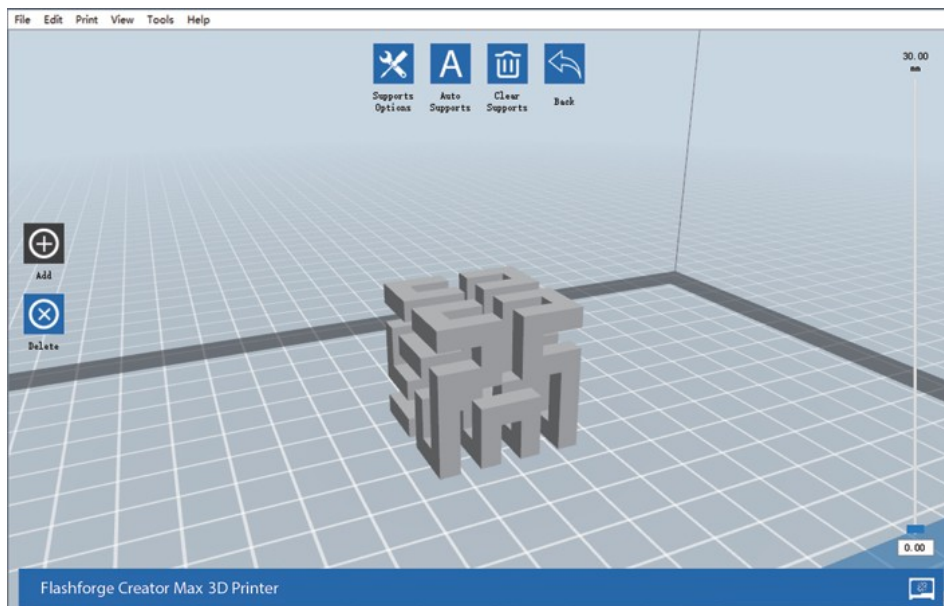
## Extruder

Double-click the **Extruder icon** to select the left and/or right extruder for printing.



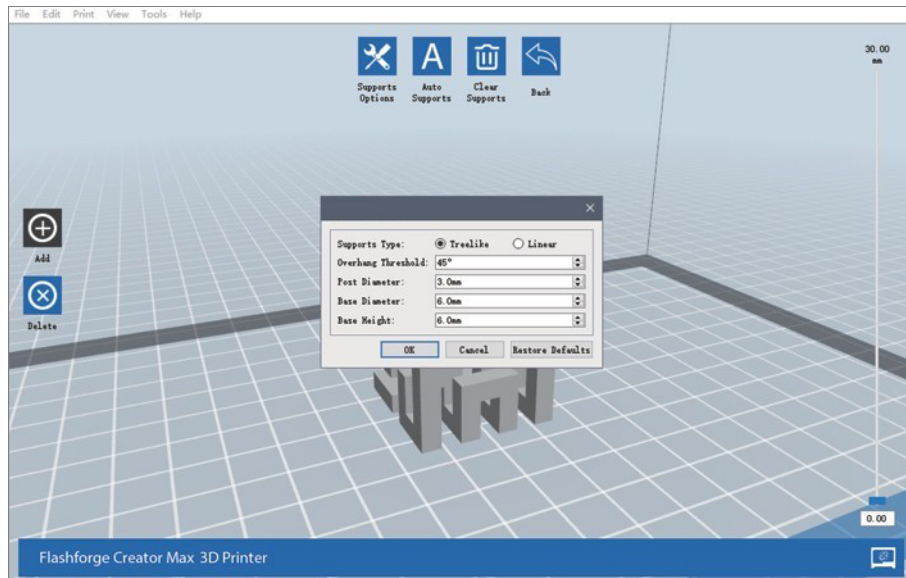
## Supports

Because 3D printing is an additive process, each layer of filament needs a base to be built on. The printer can gradually increase the layer size, as long as the overhang angle is less than about 45 degrees. Otherwise, you need to create support elements to serve as the base for adding additional layers. To edit the supports, click the **Edit menu**, then select the **Supports entry**. Alternatively, click the **Supports icon**. Click the **Back button** when finished editing the supports.



**Support Options:** Click the **Support Options button** to display the Support Options dialogue.

You can select Treelike or Linear supports. Treelike supports are built at angles, while Linear supports are linear, vertical supports for the overhanging elements. When you click the OK button, the software will generate the appropriate support structures. If the model already has supports, the software will judge whether the existing supports need to be deleted or not on the basis of the type of existing support, and display the corresponding prompt to let you make the choice



**Auto Supports:** Click the **Auto Supports** button to allow the software to judge where supports are needed and will generate corresponding treelike or linear supports. If the model already has supports, the software will delete them and new supports will be generated.

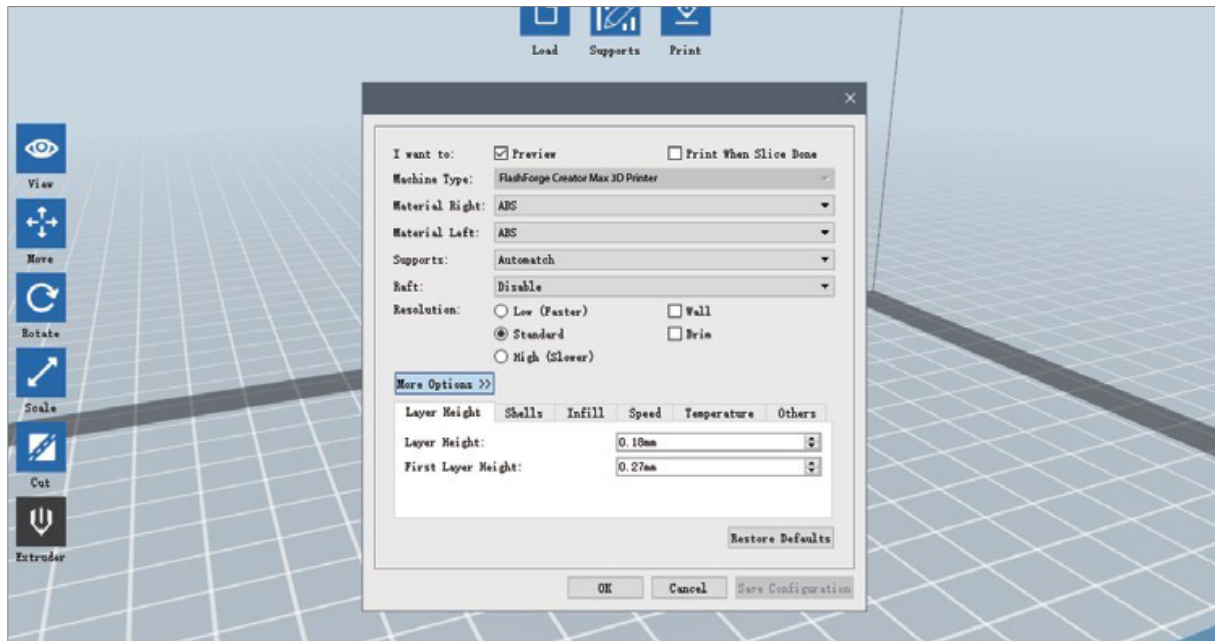
**Add Supports:** Click the **Add** button to manually generate supports. Move the cursor to the position where a support is needed, left click to choose the starting point, then while holding down the mouse button, drag the mouse to the termination point. The supports preview will be displayed with the support highlighted. If the support surface doesn't need support or the support column angle is too large, the support will not be generated.

**Clear Supports:** Click the **Clear Supports** button to remove all existing supports. If you change your mind, click the **Undo** option or press **CTRL+Z**.

**Delete Supports:** Click the **Delete Supports** button to remove individual supports. Click the cursor on the support you want to remove to highlight support, then click the left mouse button to delete the highlighted support.

## 6.2.6 Printing a Model

Click the **Print icon** on the main interface to slice the model and print the resulting Gcode file, either directly from REXprint or by first exporting it to the SD™ card.



**Preview:** Check the **Preview** box to preview the model before slicing and printing.

**Print When Slice Done:** Check the **Print When Slice Done** box to start the print as soon as the slice is completed.

**Material Type:** Select the filament type in use.

**Supports:** Enable or disable the creation of supports.

**Raft:** Enable or disable a **Raft**, which is several layers of material on the build plate to help with model adhesion.

**Wall:** Check the **Wall** box to help clear leaking filament from a second extruder during dual colour printing.

**Brim:** Check the **Brim** box to print a ring of filament around the model to help prevent warping and assist with bed adhesion.

**Resolution:** For ABS and PLA printing, you can choose **Low**, **Standard**, or **High** resolution.

For PLA printing, you can also choose **Hyper**. The higher the resolution, the smoother the model surface, but at a corresponding cost in print speed.

**More Options:** Click the **More Options** button to reveal tabs with additional options.

**Layer:** Click the **Layer** tab to reveal the layer options.

- **Layer Height:** Sets the thickness of each layer. The thinner the layer, the smoother the model surface, but at a corresponding cost in print speed.
- **First Layer Height:** Sets the thickness of the first layer of the model, which affects how well the model adheres to the build plate. The maximum thickness is 0.4mm and the default value is usually sufficient.

**Shell:** Click the Shell tab to reveal the shell options.

- **Perimeter Shells:** Sets the number of perimeter shells. The maximum value is 10.
- **Top Solid Layers:** Sets the number of solid layers at the top of the model. The maximum value is 30 and the minimum is 1.
- **Bottom Solid Layers:** Sets the number of solid layers at the bottom of the model. The maximum value is 30 and the minimum is 1.

**Infill:** Click the **Infill** tab to reveal the infill options. Infill is the structure that is printed inside the model. Infill directly affects the strength of the printed mode.

- **Fill Density:** Sets the fill density in 5% increments. A 100% density results in a solid model, while a 0% density results in no infill.
- **Fill Pattern:** Allows you to select the shape of the infill structure. You can select **Line**, **Hexagon**, or **Triangle**.
- **Combine Infill:** You can select the layers for combining according to the layer thickness. The combined thickness should not exceed 0.4mm. **The Every N Layers** option is for all infill, while the **Every N Inner Layers** affects only the inner infills, which generally save print time.

**Speed:** Click the **Speed** tab to reveal the speed settings.

- **Print Speed:** Determines the speed that the extruder moves while printing filament. It can be set from 10 to 200 mm/sec in 10mm/sec increments. The slower the speed, the higher quality the resulting printed models. For PLA printing, 80mm/sec is recommended.
- **Travel Speed:** Determines the speed that the extruder moves while moving from place to place and not actively printing filament. It can be set from 10 to 200 mm/sec in 10mm/sec increments. The slower the speed, the higher quality the resulting printed models. For PLA printing, 100mm/sec is recommended.

**Temperature:** Click the **Temperature** tab to reveal the temperature options.

- **Right Extruder:** Sets the operating temperature of the extruder from 0 to 248°C, in 5°C increments. Set the temperature according to the type of filament being printed.
- **Platform:** Sets the operating temperature of the build platform from 0 to 120°C, in 5° increments. Set the temperature according to the type of filament being printed.

**Others:** Click the **Others** tab to reveal additional options.

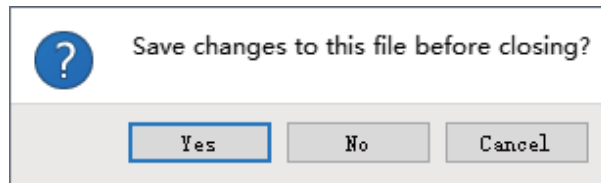


- **Pause At Heights:** Sets the height at which the print will automatically be paused. This is usually done to allow you to change filament at one or points. Click the Edit button to set the pause point(s). The print can be paused anywhere from 1 to 59.9 mm.

## 6.2.6 File Menu

The **File Menu** contains the following options.

**New Project:** Click **File > New Project** or press **CTRL+N** to create a new, blank project. A project saves in one place all the models in the scene, including positions, supports, and settings. If there are any unsaved changes to a previously loaded project, you will be prompted to save the changes.



**Save Project:** Click **File > Save Project** or press **CTRL+S** to save the current project. Projects files have a .FPP suffix.

**Load File:** Click **File > Load File** or press **CTRL+O** to load a model, Gcode, or project file.

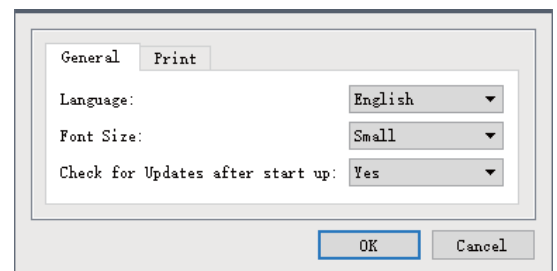
**Save As:** Click **File > Save As** to save the project or model file.

**Examples:** Click **File > Examples** to load one of four built-in sample models.

**Recent Files:** Click **File > Recent** Files to choose from a list of recently loaded files.

**Preferences:** Click **File > Preferences** to set several General and Print preferences.

- **Language:** Allows you to select the language used in REXprint.
- **Font Size:** Allows you to set the size of the font used in REXprint. You can select **Small, Medium, or Large**.
- **Check for Updates after start up:** Determines whether REXprint will automatically check for the existence of software or driver updates.
- **Auto layout newly-imported model:** Determines whether the software will automatically adjust the position of a model immediately after it is loaded.
- **Printing Window Type:** Allows you to choose the Basic (default) print dialogue or the Expert dialogue, with many more individual settings.



**Quit:** Click **File > Quit** or press **ALT+F4** to exit REXprint. If there are any unsaved changes to your project or model, you will be prompted to save the changes.

## 6.2.6 Edit Menu

The **Edit Menu** contains the following options.

- Undo:** Click **Edit > Undo** or press **CTRL+Z** to undo the last change. In most cases, you can undo multiple changes, one at a time.
- Redo:** Click **Edit > Redo** or press **CTRL+Y** to redo the last change that was undone. In most cases, you can redo multiple undos.
- Empty Undo Stack:** Click **Edit > Empty Undo Stack** to clear the software's memory of recent undos. This has the same effect as saving and reloading the project or model file.
- Select All:** Click **Edit > Select All** or press **CTRL+A** to select all models in the scene. Duplicate: Click **Edit > Duplicate** or press **CTRL+V** to copy the selected model(s). Delete: Click **Edit > Delete** or press the **Del** key to delete the selected model(s).
- Auto Layout All:** Click **Edit > Auto Layout All** to automatically arrange the model(s) on the build platform. You will be prompted to set the distance between models, which can be from 1.0 to 50.0 mm.
- Mirror Model:** Click **Edit > Mirror Model** to mirror the selected model(s) in the X, Y, or Z planes.
- Repair Models:** Click **Edit > Repair Models** to correct any errors in the selected model(s).
- Supports:** Click **Edit > Supports** to enter **Support Edit** mode.

## 6.2.7 View Menu

The **View Menu** contains the following options.

- Home View:** Sets the camera to the default position.
- Top View:** Sets the camera to look directly down onto the build area.  
**Bottom View:** Sets the camera to look directly up towards the build area. **Left View:** Sets the camera to look at the build area from the left.
- Right View:** Sets the camera to look at the build area from the right.  
**Front View:** Sets the camera to look at the build area from

the front. Back View: Sets the camera to look at the build area from the rear. Show Model Outline: Puts a yellow outline around the model.

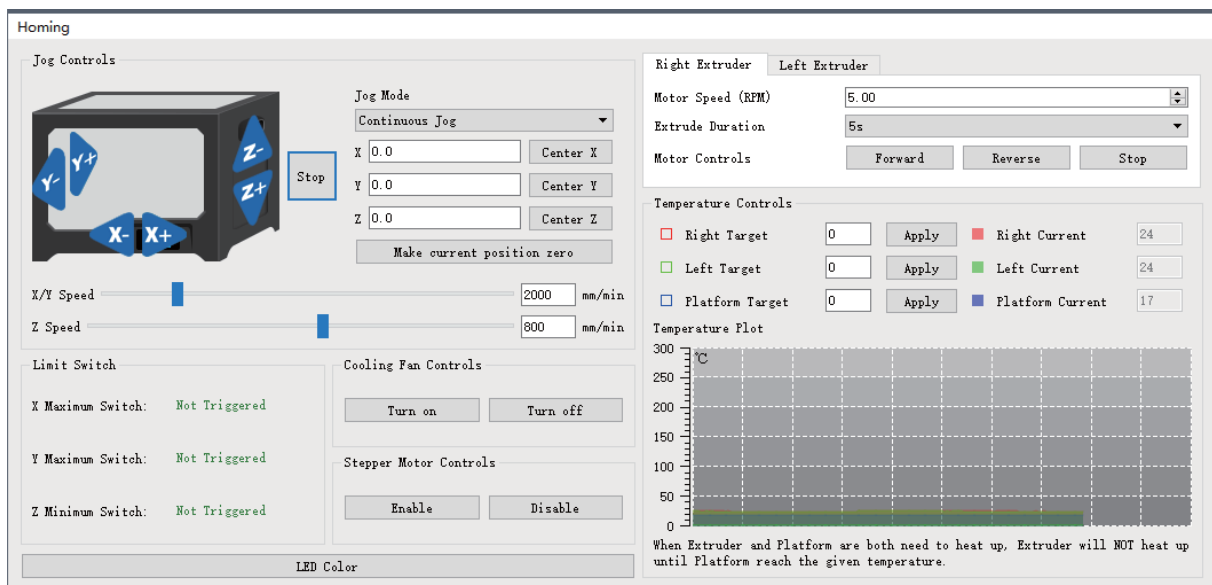
**Show Steep Overhang:** Highlights in red those portions of the model that require supports.

## 6.2.8 Tools Menu

The **Tools Menu** contains the following options.

**Control Panel:** Click **Tools > Control Panel** to modify the printer's settings from within REXprint.

Note that if you are not connected to the printer, you will be prompted to do so before the Control Panel can be displayed.



- **Jog Mode:** The Jog Mode section allows you to select the distance that the extruder and build plate move with each mouse click.
- **Six Blue Arrow Buttons:** The buttons allow you to manually move the extruder and build plate. The amount they will move with each click of the mouse is determined by the Jog Mode settings.
- **Stop:** Click the Stop button to abort any current movement.
- **XYZ Coordinates:** Displays the current position of the extruder and build plate. You cannot edit the displayed values.
- **Make Current Position Zero:** Click the **Make Current Position Zero** button to set the zero position for the three axes.
- **Centre XYZ:** Click a **Centre** button to move the extruder or build plate to the zero position for that axis.
- **Set X/Y Speed:** Sets the speed at which the extruder moves.
- **Set Z Speed:** Sets the speed at which the build plate moves.
- **Limit Switch:** Displays the status of the limit switches on each axis. If the extruder or build plate are not moved to its maximum positions, the status will show **Not Triggered** in green. If the extruder or build plate has been moved to its maximum position, the status will show **Triggered** in red.
- **Stepper Motor Controls:** Click the **Enable** button to lock the stepper motor so that it does

- not allow movement. Click **Disable** to unlock the stepper motor so the extruder and build plate can be manually moved.
- **LED Color:** Allows you to set the LED color of the printer.
- **Motor Speed (RPM):** Controls the speed of the filament feed wheel.
- **Forward:** Feeds filament to the extruder.
- **Reverse:** Unloads filament from the extruder.
- **Stop:** Stops motor movement when feeding or unloading filament.
- **Temperature Control:** Allows you to set the target extruder or platform temperature. Click the **Apply** button to start heating.

**Update Firmware:** Allows you to update the printer's firmware.

**On Board Preferences:** Allows you to check the printer's name.

**Machine Information:** Displays information about the printer, including the firmware version.

## 6.2.9 Help Menu

The **Help Menu** contains the following options.

**First Run Wizard:** Re-runs the wizard that automatically runs the first time REXprint is run.

**Help Contents:** Allows you to read the help files.

**Feedback:** Allows you to submit feedback.

**Check For Updates:** Checks for REXprint updates.

**About REXprint:** Displays REXprint version information.

## 6.2.10 Connecting the Printer

There are three ways of connecting the REXprint software with the printer - a wired USB connection or a wireless Wi-Fi® connection in AP mode or STA (Station) mode.

### USB Connection

Perform the following steps to connect your PC to the printer using a wired USB connection.

1. Plug one end of the included USB cable into the USB port on the printer, then plug the other end into an available USB port on your computer.
2. Power on the printer and your computer, then start the REXprint software.
3. Click **Print > Connect Machine**.
4. Set the Connection Mode to USB and set the Select Machine option to the printer. When the printer does not appear in the Select Machine list, click the Rescan button.

If it still does not appear, reinstall the driver software.

## Wi-Fi Connection

Perform the following steps to connect your PC to the printer using a Wi-Fi® connection. Note that printing from an SD™ card is disabled when Wi-Fi is enabled.

1. Power on the printer and your computer.
2. On the printer, select **Tool > Setting > WIFI > WIFI ON**.
3. Open your computer's wireless network settings and scan for available Wi-Fi® signals.
4. Open your internet browser. Type 10.10.100.254 and press the Enter key on your keyboard.
5. Enter the username and password to login. The default username and password are both admin. The control panel will appear after successful login.
6. Click the WiFi Set tab on the left, then set the WiFi Work Mode to AP mode or STA mode, then click Restart to make the changes take effect.

The screenshot shows a control panel interface with a blue background. On the left, there is a vertical menu with the following items: 'Sys status' (highlighted with a blue bar), 'WiFi Set', 'Trans Set', 'Reload Reset', and 'About FF'. The main content area is divided into two sections: 'Sys status' and 'wifi Status'. Each section contains a table of system parameters.

Sys status	
Sys run time	0 days 00:09:06
module MAC	D8:B0:4C:D0:38:4E
module MID	USR-C322
module ver	1.14.13

wifi Status	
wifi mode	Access Point
AP IP	10.10.100.254
AP channel	6
AP ssid	Flashforge Creator Max 3DPrinter
AP secure	Open



**AP mode** configures the printer's Wi-Fi® radio to act as a Wi-Fi Hotspot/Access Point (AP).

You then set your computer's network settings to directly connect to the printer's Wi-Fi AP, rather than your regular Wi-Fi AP. **STA mode** configures the printer's Wi-Fi® radio to connect to your regular Wi-Fi AP. In STA mode you do not need to change your computer's network settings and can continue to use your Wi-Fi AP, as normal.

If you choose to use **AP mode**, you can set the network name (Flashforge Creator Max) and password of the hotspot. If you don't want to use a password, enter **NONE**. Click the **Save** button and restart it. Connect your PC to the network (the name you set). Open REXprint, then click

**Print > Connect Machine**. Select **Wi-Fi** as the **Connect Mode** and enter the IP Address, as shown on the REXprint's screen. Click **Connect**.

**WiFi Mode Select**  
Wifi Work Mode: AP mode

**AP mode**  
Network Name(SSID) (1-32 bytes): Flashforge Creator Max  
Password(8-63 bytes), NONE is Open: NONE  
IP address: 10.10.100.254  
Mask:   
Save

**STA mode**  
Router SSID(Note: case sensitive): USR-C322  
STA Password, Set NONE is Open: NONE  
DHCP auto get IP: Enable  
Save

3D Connect Machine

Connect Mode: Wi-Fi Connect

IP Address (port): 10 . 10 . 100 . 254 : 8899

If you choose to use **STA mode**, input the SSID and password of your existing Wi-Fi® connection. If your Wi-Fi connection does not use a password, enter **NONE** into

the password field. Then click the **Save** button and restart it. Restart the printer, then open the **WiFi Screen**.

Sys status  
**WiFi Set**  
Trans Set  
Reload Reset  
About FF

### WiFi Mode Select

Wifi Work Mode

### AP mode

Network Name(SSID) (1-32 bytes)

Password(8-63 bytes), NONE is Open

IP address

Mask

### STA mode

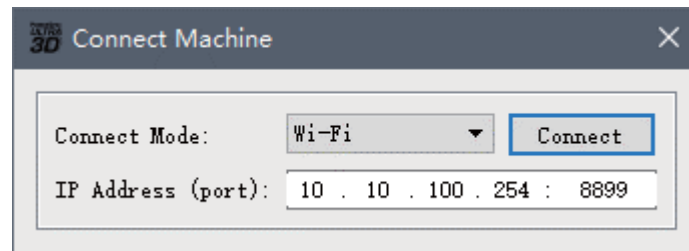
Router SSID(Note: case sensitive)

STA Password, Set NONE is Open

DHCP auto get IP

 SSID: Market Department  
Signal Strength: 100  
IP Address: 192.168.1.119:8899  
Subnet Mask: 255.255.255.0  
Default Gateway: 192.168.1.1

Turn on the Printer again and connect your computer to the network. Open REXprint, then click **Print > Connect Machine**. Select **Wi-Fi** as the **Connect Mode** and enter the IP Address, as shown on the printer's screen. Click **Connect**.

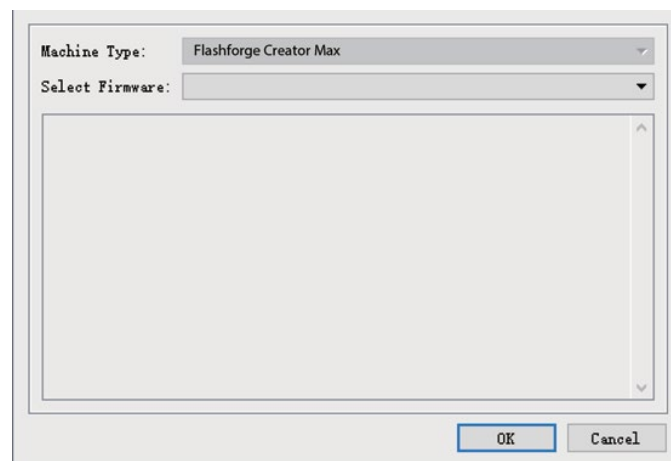


If you want to switch between AP and STA modes, touch the **Reset** button on the **WIFI Screen**.

## 6.2.11 Updating the Firmware

Each time you start REXprint, it will automatically detects and downloads the up-to-date firmware. If an update is available, a dialogue box will appear to remind you of the update. Perform the following steps to update the firmware.

- ① Click **Tools > Update** firmware. You must sever any existing connection with the printer before updating. If a connection exists, it will prompt you to cut the connection. Click the **Yes** button to cut the connection.
- ② Choose the corresponding printer type and firmware version, then click **OK** in the firmware update dialogue. After confirming that there is no printer connection, the software will automatically update the firmware.



- ③ Reboot the printer and wait 4-5 seconds until the update progress bar is displayed. When the update is finished, it will return to the **Top Menu**.
- ④ Touch the **Tool** button, then touch **About** to check that the version is correct.

Machine Name: Flashforge Creator Max  
Machine Type: Flashforge Creator Max  
3DPrinter  
Firmware Version: V2.5 2018\*\*\*\*  
Print Volume: 227 X 148 X 150  
Usage Counter: 0hours  
Tool Count: 2



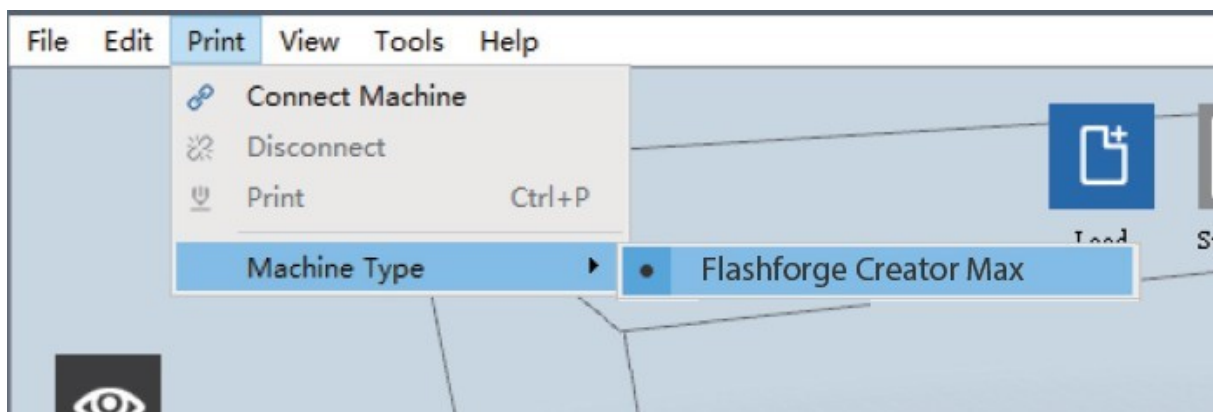
## 6.2.12 Printing

There are two basic modes of printing: single extrusion and dual extrusion. With single extrusion printing, you can choose which print head to use for making the print. Dual extrusion printing is useful if you want to print with two colours or print complex models that require supporting material.

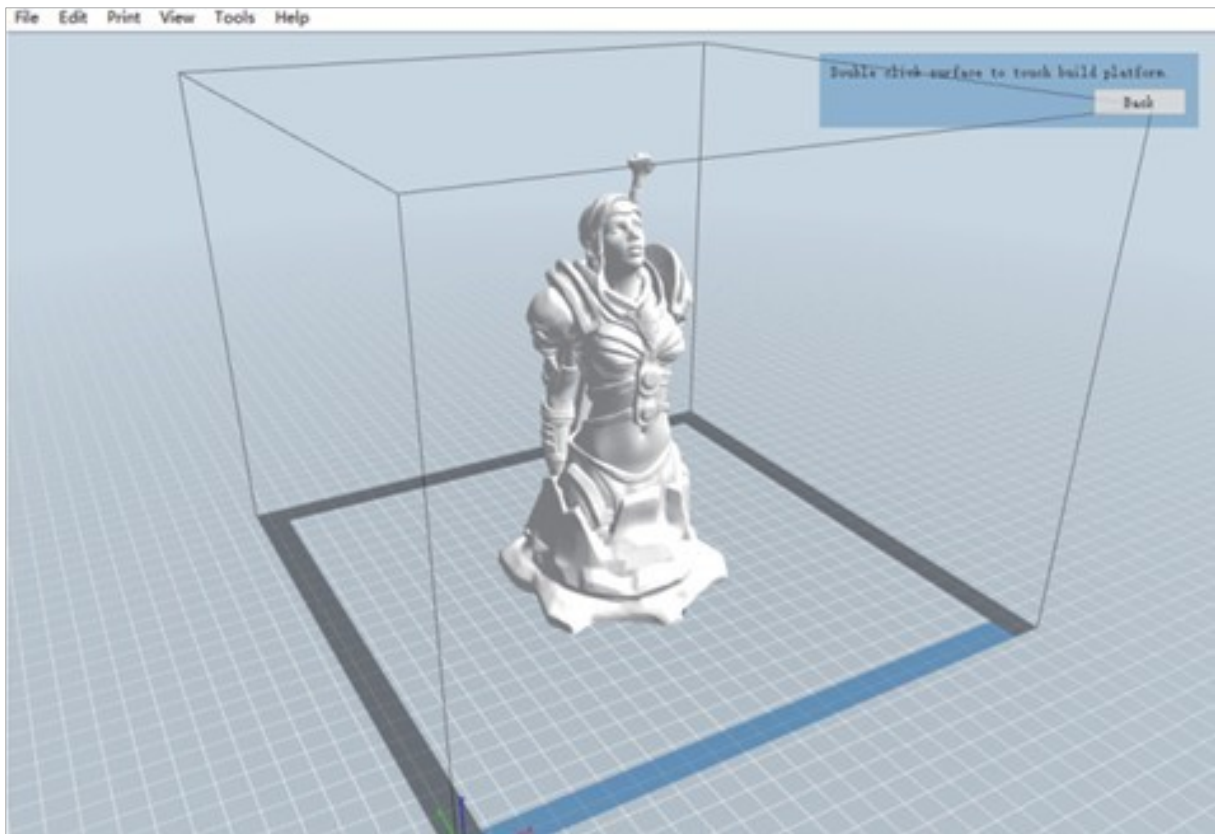
Perform the following steps to print a model on the printer from a Gcode file saved to the SD™ card.

### Generating Gcode

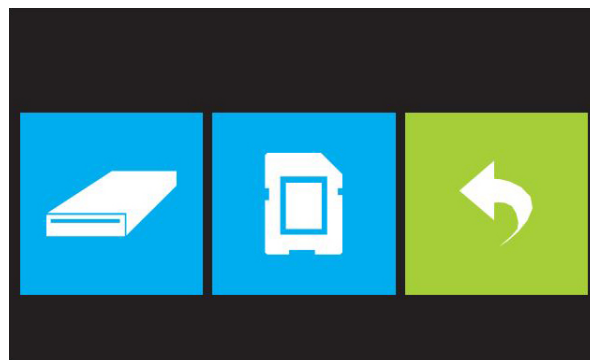
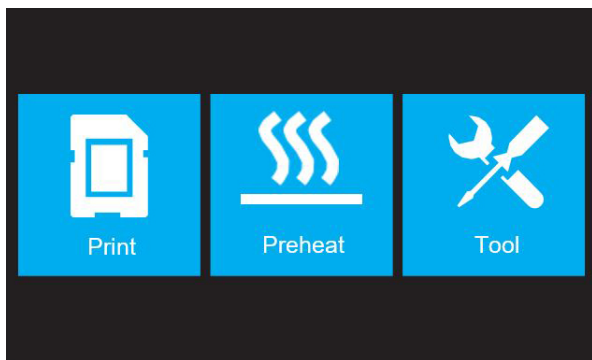
- ① Plug the included SD™ card into an SD card reader on your computer.
- ② Double-click the REXprint shortcut to launch the software.
- ③ Click Print > Machine Type and select the Flashforge Creator Max 3D Printer entry.



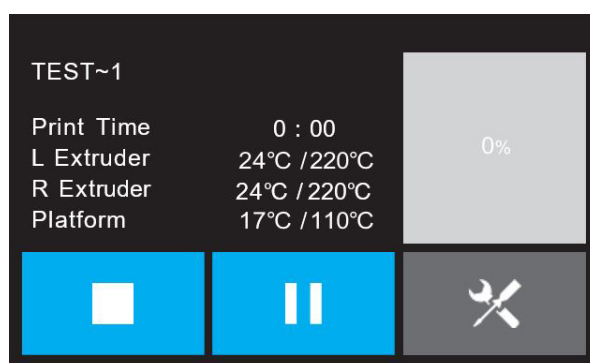
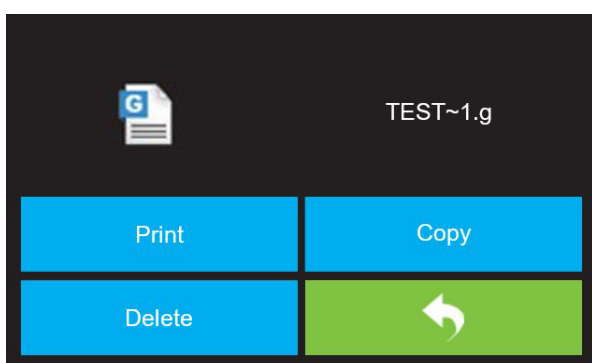
- ④ Click the Load icon to load a .STL model file. The model will display within the build area.
- ⑤ Double-click the Move icon, then click the On the Platform and Center buttons to ensure the model is in contact with the centre of the build platform



- ⑥ Click the **Print** icon, then change the settings as appropriate for your filament type and model.
  - **Preview:** Check the **Preview** box if you want to preview the model after slicing is done.
  - **Print When Slice Done:** Because we are printing from the SD™ card, uncheck this box to save the Gcode file to the SD card.
  - **Machine Type:** Select **Flashforge Creator Max 3D Printer**.
  - **Material Right:** Select the type of filament you are using.
  - **Material Left:** Select the type of filament you are using.
  - **Supports:** If your model has overhanging elements, enable the **Supports** option.
  - **Raft:** It is recommended to enable the **Raft** option.
  - **Resolution:** It is recommended to select the **Standard** option.
  - **More Options:** It is recommended to leave them at the default values.
- ⑦ Click **OK** to save the Gcode file to the SD™ card. You can rename the file as desired and save it as either a **.g** or **.gx** file. Files with a **.gx** extension can be previewed, while **.g** files cannot.
- ⑧ Eject the SD™ card, then plug it into the SD card slot on the printer.
- ⑨ Power on the printer.
- ⑩ Ensure that the build plate is leveled and that filament is loaded.
- ⑪ Touch the **Print** button on the printer display.
- ⑫ Touch the **SD card** button, then locate and load your model file.



- ⑬ Touch the **Print** button to begin printing. The printer will begin heating the extruder and/or platform, then will begin printing once the target temperatures are reached. Touch the **Stop** button at any time to cancel the print. Touch the Pause button to **pause** the print.



# Chapter 7: Warranty and service

## Warranty

The warranty period for this device is 5 years and begins on the day of purchase.

Please keep the proof of purchase (receipt/invoice) carefully as proof of purchase.

During the warranty period, defective units will be accepted by the local dealer or, if necessary, sent in directly by you. In any case, the shipment must be at your expense. In case of a warranty claim, the postage costs will be refunded. You will then receive a new or repaired device back free of charge. The decision whether to repair or exchange the device is up to us.

Excluded from this guarantee are accessories/components such as mounting plates and foils, acrylic glass/plastic elements, USB/removable storage media, filaments and coils, adhesives, resins/greases, vessels and containers, tools etc.

The guarantee expires if defects in the object of purchase are due to the following circumstances:

- improper use
- negligent or intentional damage through own fault and/or unauthorised third parties
- Repairs or alterations carried out by third parties without our order
- Changes or damage due to force majeure (storms, hail, fire, power failure, lightning, Flooding, snow damage, frost and other impacts of animals, etc.)

The guarantee also expires if a damaged and/or illegible or incomplete sales receipt is presented.

The rights arising from the guarantee exist independently of the statutory warranty claims.

**The guarantor is BRESSER GmbH, Gutenbergstr. 2, 46414 Rhede, Germany.**

After the warranty period has expired, you also have the possibility to send a defective device for repair. Repairs after the warranty period are subject to a charge. You will receive a cost estimate from us before the repair is carried out.

### ***In case of a return please note the following:***

Make sure that the article is sent carefully packed. If possible, use the original packaging. Fill out the Service Form and enclose it with the proof of purchase.

## Service

You can contact the BRESSER service team if you have problems with the 3D printer. If questions or problems are not covered in this manual, you can look for solutions on our official website or contact us by phone.

Our Knowledge Base provides solutions and instructions for frequently occurring problems. It is recommended that you search for a solution there first, as the most common questions are answered there.

<http://www.bresser.de>

Email: [service.3d-printer@bresser.de](mailto:service.3d-printer@bresser.de)

You can reach the BRESSER service team by phone or e-mail from Monday to Saturday, 8:30-15:30 (CET). If you contact us outside these business hours, we will answer your request on the following working day.

**Note:** Due to different filaments the extruder can be blocked. This is not a quality problem and is outside the range of 400 hours of operation. If this problem occurs, please contact customer service and carry out cleaning according to the instructions provided there.







## Service

**DE AT CH BE**

Bei Fragen zum Produkt und eventuellen Reklamationen nehmen Sie bitte zunächst mit dem Service-Center Kontakt auf, vorzugsweise per E-Mail.

E-Mail: [service@bresser.de](mailto:service@bresser.de)  
Telefon\*: +49 2872 80 74 210

### **BRESSER GmbH**

Kundenservice  
Gutenbergstr. 2  
46414 Rhede  
Deutschland

\*Lokale Rufnummer in Deutschland (Die Höhe der Gebühren je Telefonat ist abhängig vom Tarif Ihres Telefonanbieters); Anrufe aus dem Ausland sind mit höheren Kosten verbunden.

**GB IE**

Please contact the service centre first for any questions regarding the product or claims, preferably by e-mail.

E-Mail: [service@bresseruk.com](mailto:service@bresseruk.com)  
Telephone\*: +44 1342 837 098

### **BRESSER UK Ltd.**

Suite 3G, Eden House  
Enterprise Way  
Edenbridge, Kent TN8 6HF  
United Kingdom

\*Number charged at local rates in the UK (the amount you will be charged per phone call will depend on the tariff of your phone provider); calls from abroad will involve higher costs.

**FR BE**

Si vous avez des questions concernant ce produit ou en cas de réclamations, veuillez prendre contact avec notre centre de services (de préférence via e-mail).

E-Mail: [sav@bresser.fr](mailto:sav@bresser.fr)  
Téléphone\*: 00 800 6343 7000

### **BRESSER France SARL**

Pôle d'Activités de Nicopolis  
314 Avenue des Chênes Verts  
83170 Brignoles  
France

\*Prix d'un appel local depuis la France ou Belgique

**NL BE**

Als u met betrekking tot het product vragen of eventuele klachten heeft kunt u contact opnemen met het service centrum (bij voorkeur per e-mail).

E-Mail: [info@bresserbenelux.nl](mailto:info@bresserbenelux.nl)  
Telefoon\*: +31 528 23 24 76

### **BRESSER Benelux**

Smirnoffstraat 8  
7903 AX Hoogeveen  
The Netherlands

\*Het telefoonnummer wordt in het Nederland tegen lokaal tarief in rekening gebracht. Het bedrag dat u per gesprek in rekening gebracht zal worden, is afhankelijk van het tarief van uw telefoon provider; gesprekken vanuit het buitenland zullen hogere kosten met zich meebrengen.

**ES IT PT**

Si desea formular alguna pregunta sobre el producto o alguna eventual reclamación, le rogamos que se ponga en contacto con el centro de servicio técnico (de preferencia por e-mail).

E-Mail: [servicio.iberia@bresser-iberia.es](mailto:servicio.iberia@bresser-iberia.es)  
Teléfono\*: +34 91 67972 69

### **BRESSER Iberia SLU**

c/Valdemorillo,1 Nave B  
P.I. Ventorro del Cano  
28925 Alcorcón Madrid  
España

\*Número local de España (el importe de cada llamada telefónica dependen de las tarifas de los distribuidores); Las llamadas des del extranjero están ligadas a costes suplementarios..

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**Bresser GmbH**  
Gutenbergstraße 2  
46414 Rhede · Germany  
[www.bresser.de](http://www.bresser.de)

    @BresserEurope

