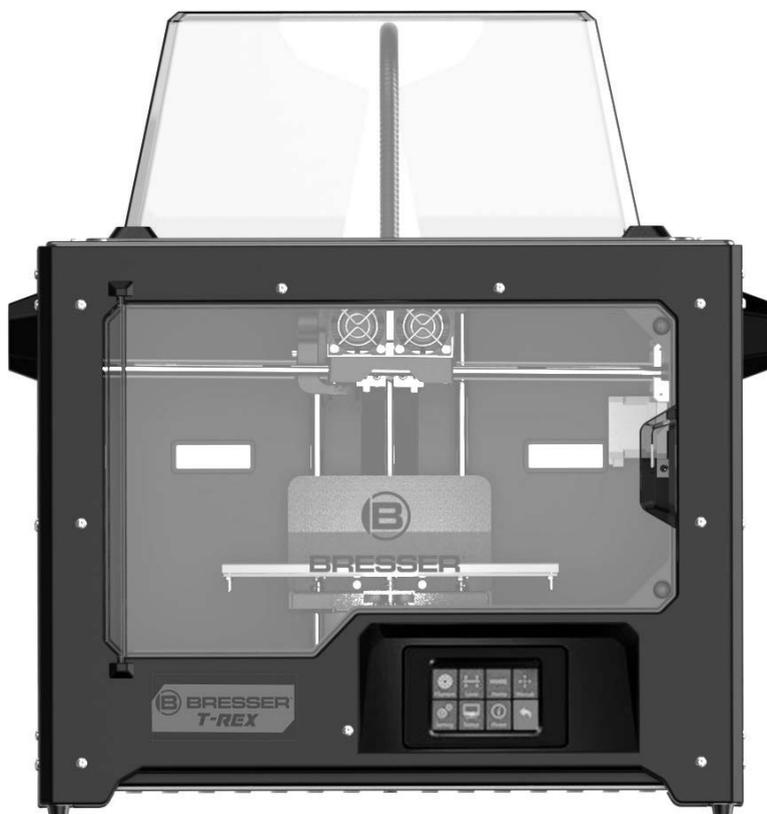


**B** **BRESSER®** **T-REX**

**3D printer**

Art. No. 2010500



## Quickstart Guide

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**⚠ WARNING!**

- Hot surfaces! Do not touch the heat nozzle and the construction platform in operation!
  - Danger! Moving parts in printer may cause injury. Do not wear gloves or other sources of entanglement in operation!
-

## More informationen, updates or software

Visit our website using the following QR code or weblink to find additional information, available updates or software for this product or related accessories:



[www.bresser.de/P2010500](http://www.bresser.de/P2010500)

## After Sales Support / Service

We offer an individual service for this product beyond the purchase. If you have any problems with the product, our support team will be happy to assist you.

**For a smooth process, please keep the following information handy for possible inquiries:**

- Warranty/Service card
- Article number and Product description
- Date of purchase and dealer

### Contact details:

e-Mail: **service.3d@bresser.de** (preferred communication)

Internet: **www.bresser.de/c/de/service**

Phone\*: **00 800 – 63 43 7000**

### Service hours:

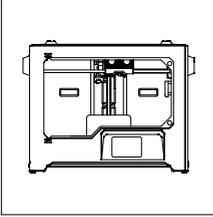
Monday to Friday (except national public holidays) 9:00 a.m. to 3:00 p.m. CET

\* free hotline throughout Europe

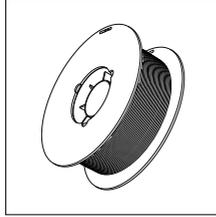
## Warranty

Please refer to the separate warranty & service card for any warranty information.

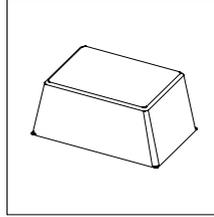
# Set contents



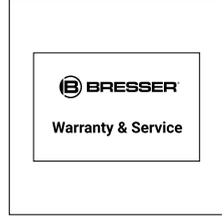
3D printer



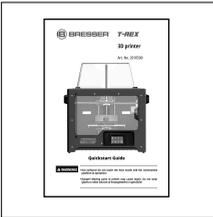
Filament spool (2x)



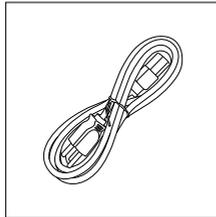
Top cover



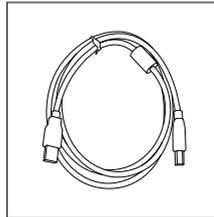
Service card



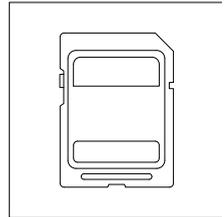
Quickstart guide



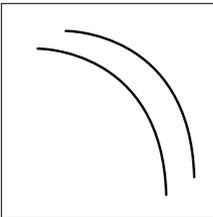
Power cable



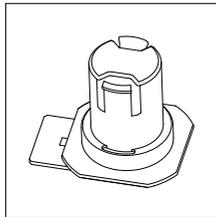
USB cable



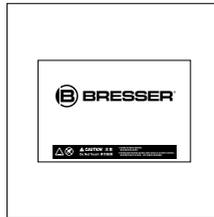
SD card



Guide tube (2x)



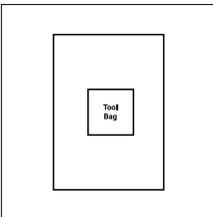
Spool holder (2x)



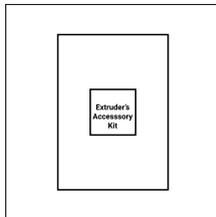
Build tape



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

# Unpacking

This 3D printer set was packed with care. Please follow the unpacking steps laid out below.

## ⚠ CAUTION!

• Remove the package and take out accessories carefully! Do not use force!



1. Open the box and remove the top foam shape.



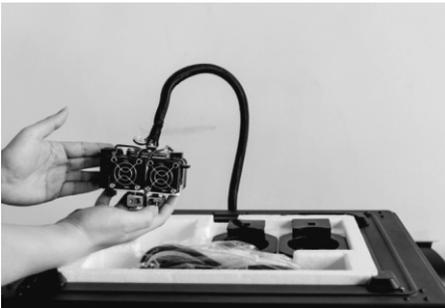
2. The foam contains: guide tubes (2x), SD card, build tape (2x), leveling card, service card, quickstart guide



3. Firmly grasp the two sides handles of the 3D printer. Lift it out of the carton and place it on a stable surface.



4. Remove the plastic bag. Then remove the protecting tape and plastic wrap from the front door.



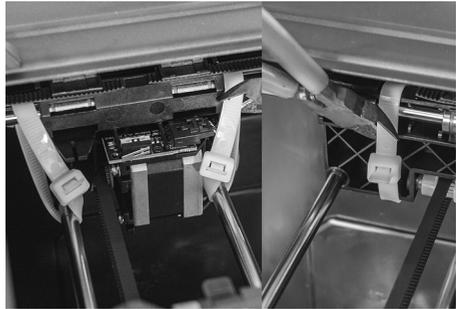
5. Take the dual extruder out of the foam shape. Carefully place it near the printer. Take care of the extruder cable bunch which is short.



6. Remove the foam shape from the printer.



7. Take the remaining accessories out of the foam: power cable, USB cable, spool holder (2x), tool bag and extruder's accessory kit.



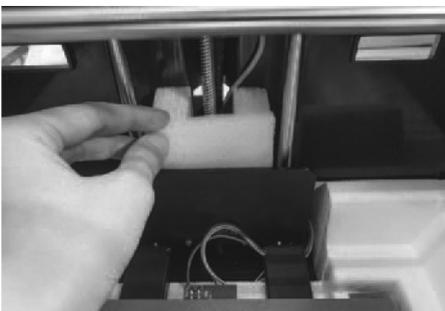
8. Use a scissors to cut off the three ties on both sides of X-axis guide rail and remove them.



9. Slide the X-axis guide rail to the very back by hand.



10. Open the door, remove the reversed top cover and take the filament out of it.

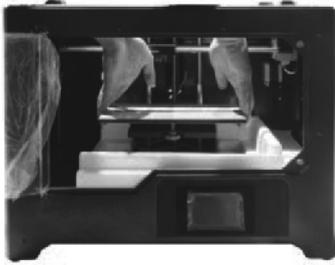


11. Find the vertical plastic board at the back of the build plate. Take out the foam blocks behind the board.

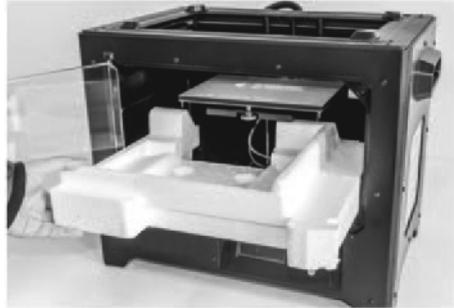


12. Remove the side foam piece.

## Unpacking



13. Carefully lift up the build plate to its limit by hand.

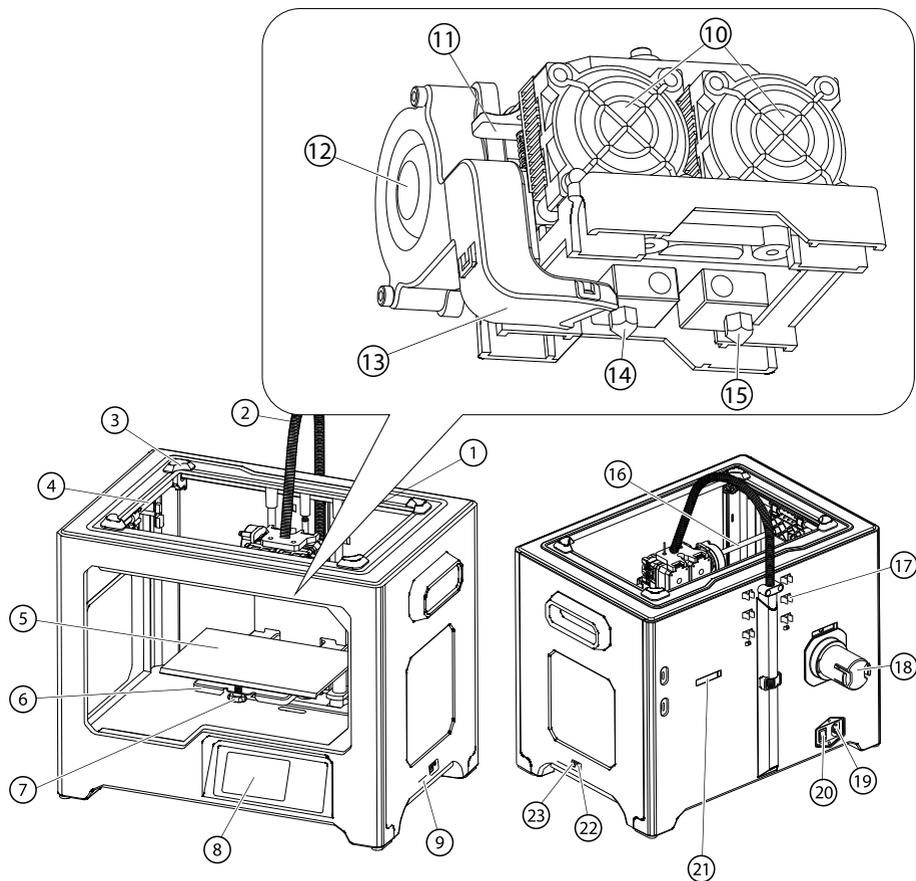


14. Remove the foam block under the build plate.



15. Unpacking is completed.  
It is recommended to keep the packaging material for further transportation or storage.

## Parts overview



- 1. Z-axis guide rail
- 2. Extruder cable bunch
- 3. Slot
- 4. Y-axis guide rail
- 5. Build plate
- 6. Build platform
- 7. Leveling knob
- 8. Touchscreen

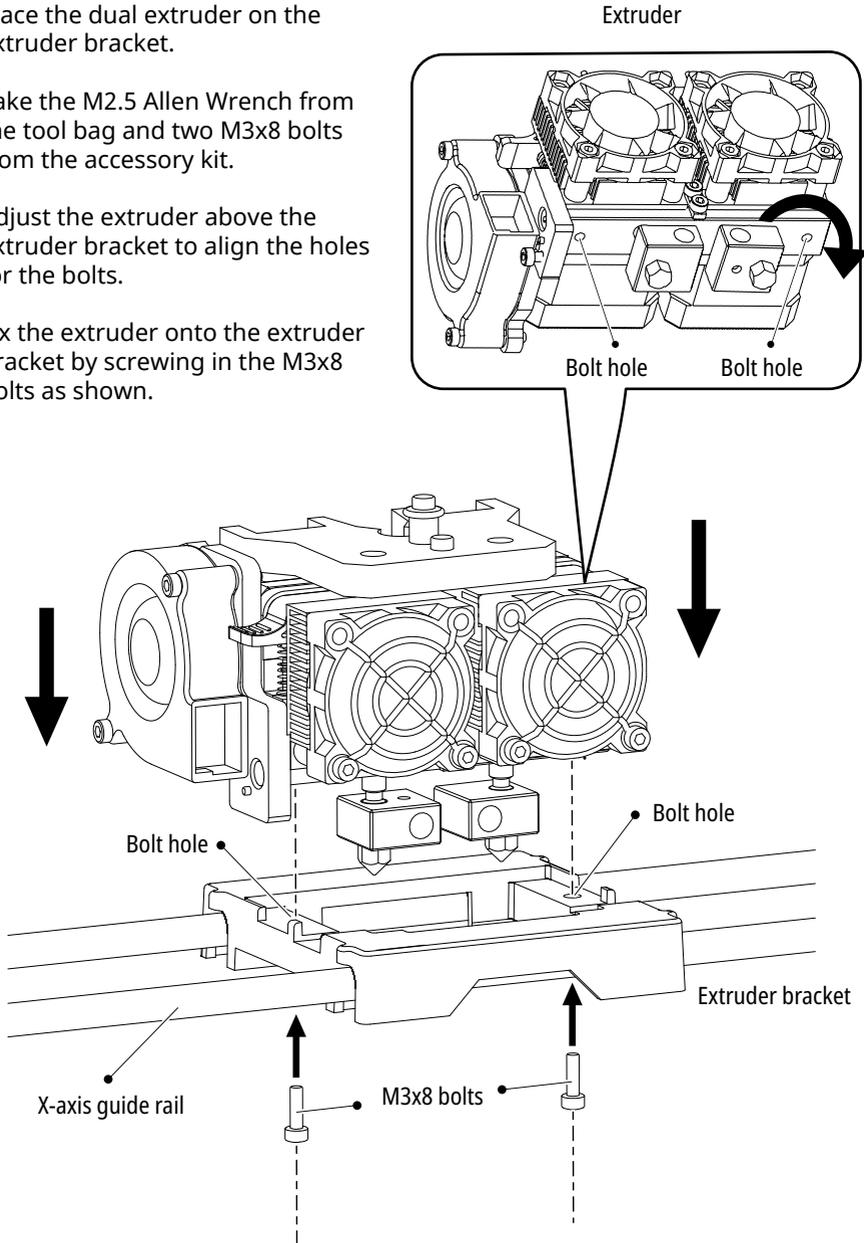
- 9. SD card slot
- 10. Cooling fan
- 11. Spring presser
- 12. Turbofan
- 13. Turbofan baffle
- 14. Left nozzle
- 15. Right nozzle
- 16. X-axis guide rail

- 17. Guide tube buckle
- 18. Spool holder
- 19. Power input
- 20. Power switch
- 21. Spool holder slot
- 22. Reset button
- 23. USB input

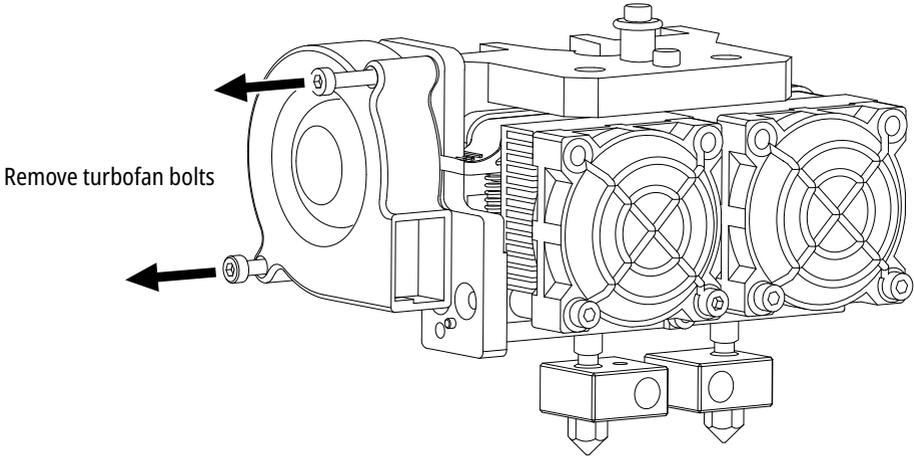
# Installation

## Assembling the extruder

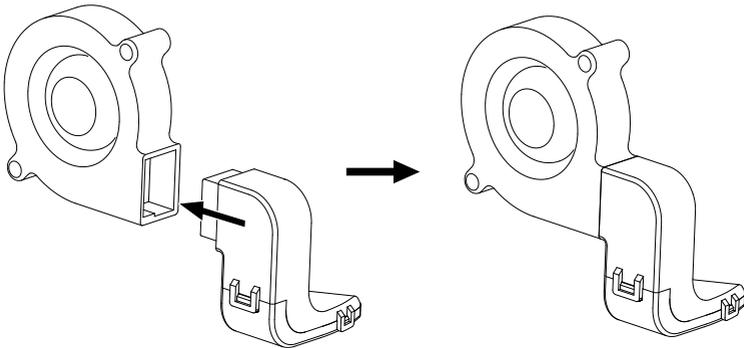
1. Place the dual extruder on the extruder bracket.
2. Take the M2.5 Allen Wrench from the tool bag and two M3x8 bolts from the accessory kit.
3. Adjust the extruder above the extruder bracket to align the holes for the bolts.
4. Fix the extruder onto the extruder bracket by screwing in the M3x8 bolts as shown.



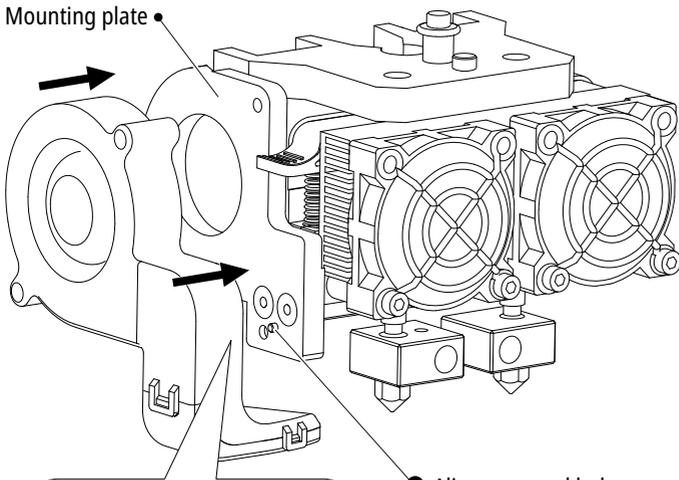
## Assembling the turbofan baffle



1. Use the M2.5 Allen wrench to remove the turbofan bolts.

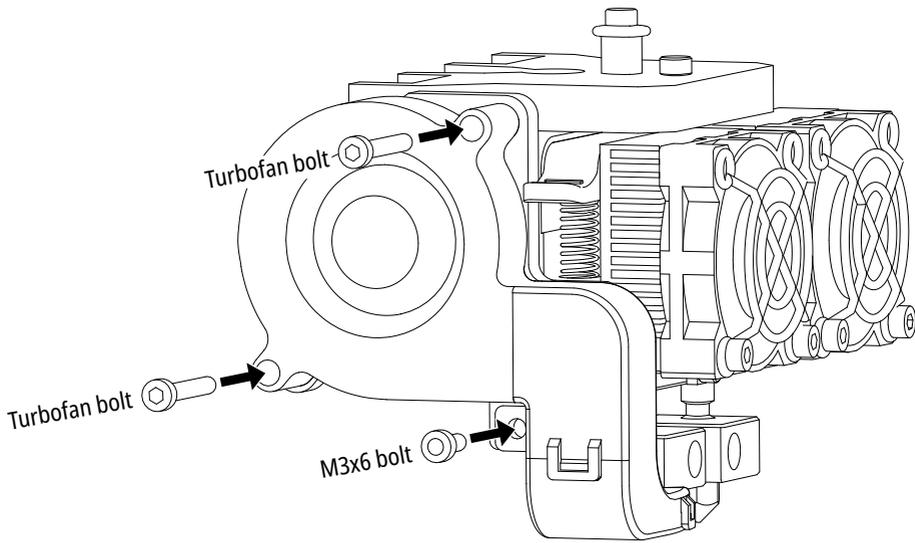
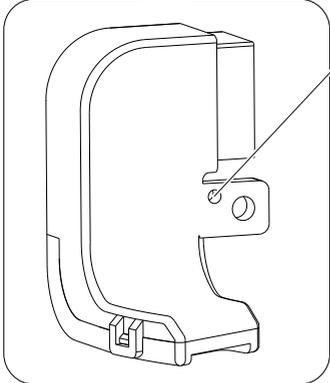


2. Take the turbofan baffle from the extruder's accessory kit.
3. Insert the baffle into the slot at the turbofan as shown.

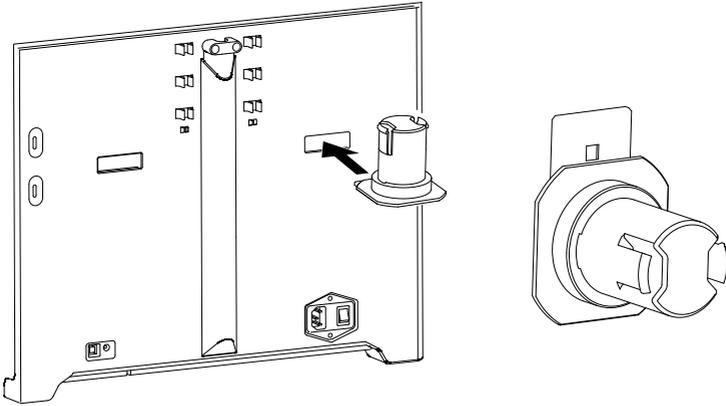


● Align nose and hole

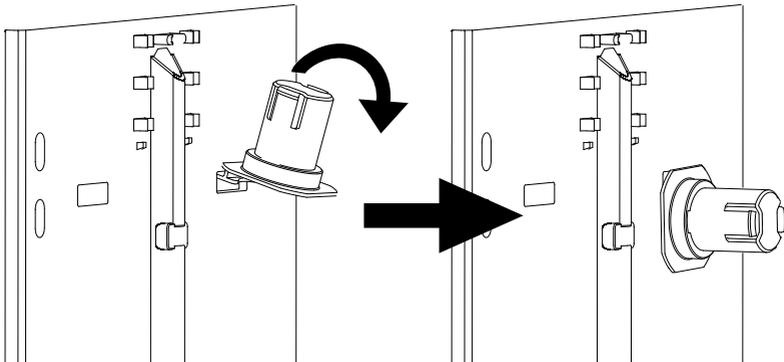
1. Align the hole in the baffle and the nose at the extruder's mounting plate.
2. Place the turbofan with the attached baffle besides the mounting plate to align the nose and the hole.
3. Attach the turbofan with the baffle to the mounting plate.
3. Reinsert the the two turbofan bolts and fasten them.
4. Take a M3x6 bolt from the accessory kit and complete installation as shown on the illustration below.



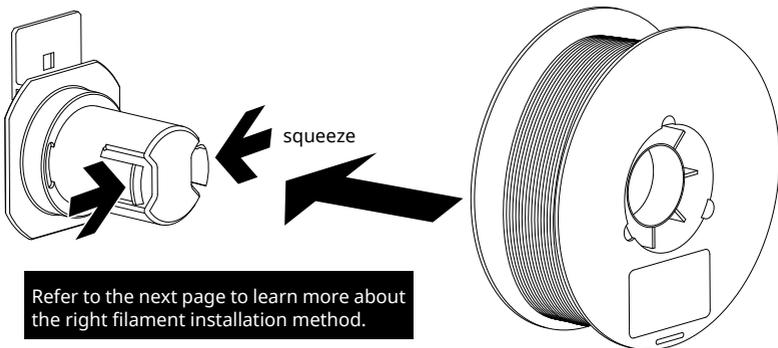
## Installing guide tube and filament



1. Level the pool holder and insert it with its plate facing forward into the corresponding opening at the printer's backside.



2. Turn down the pool holder to make the holder bottom cleave to the printer's backside.

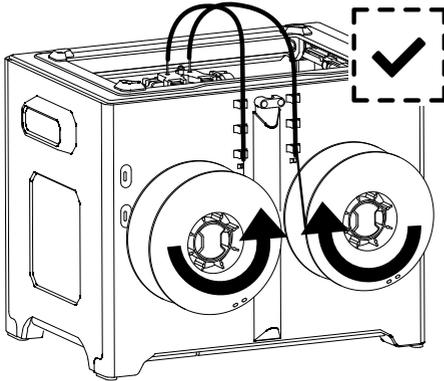


3. Squeeze the pool holder top and put the filament spool onto the holder.

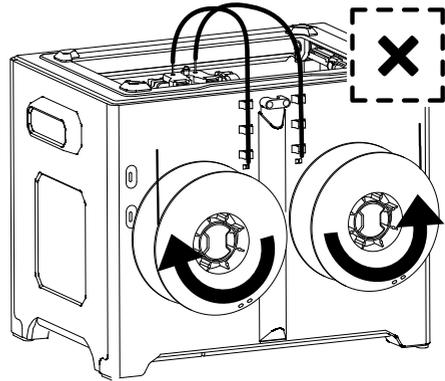
## Important tips

1. The filament spool must be oriented correctly (see below illustrations)

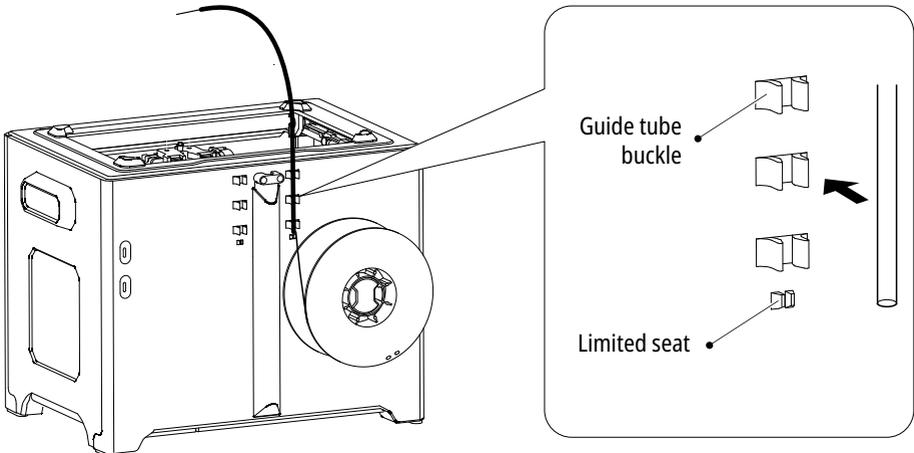
### Correct installation



### Wrong installation

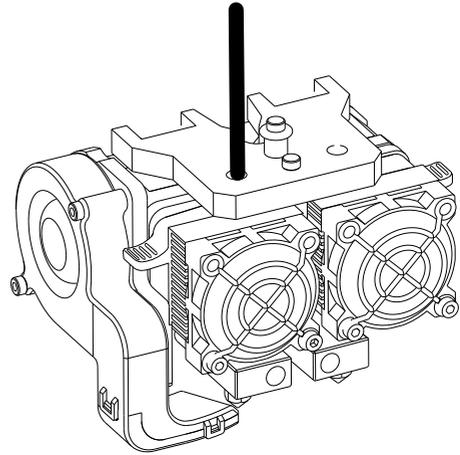
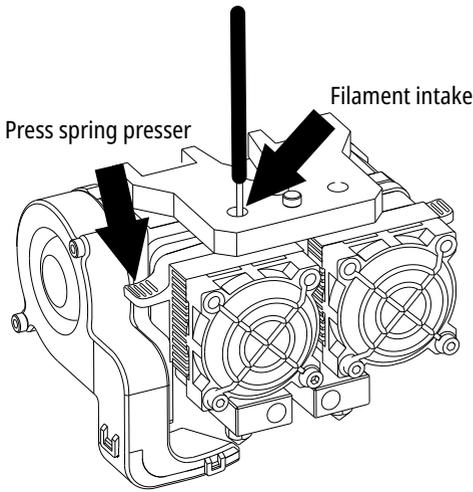


**NOTE:** Pay attention to extend the guide tube to the inside of the spool to prevent the filament from being wrapped outside the spool.  
Make sure that the two filament strands are installed in crossed position.



2. Install PLA filament on the right side of the printer, and put filament through guide tube.

3. Lock filament guide tube into fixed buckles and guide tube bottom should not be over limited seat.



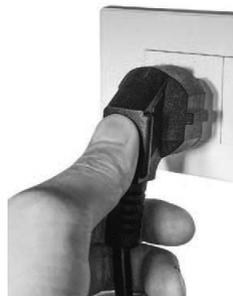
4. After the guide tube fixation is completed, press the left spring presser of the extruder, put the filament vertically into the left filament intake from the other end of the guide tube.

5. After filament is inserted into the filament intake, insert the guide tube into the intake to fix .

## Power supply



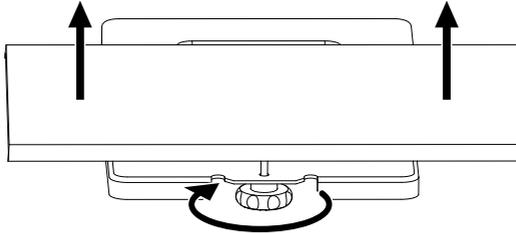
1. Take the power cable and plug it into the printer's power input.



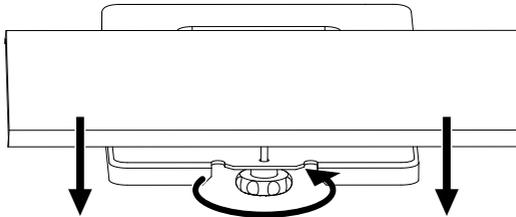
2. Plug the other end of power cable into socket. Move the power switch to position 'I' to turn the printer on.

# Leveling

## Using the thumb screw



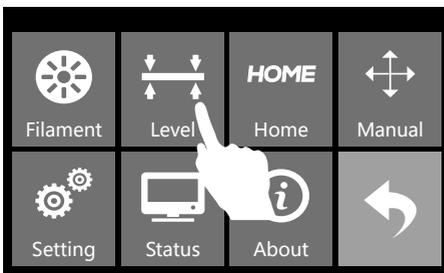
Rotating the thumb screw clockwise will lift up the build plate and for that reducing the distance to the nozzle.



Rotating the thumb screw counterclockwise will lower the build plate and for that expanding the distance to the nozzle.

## Leveling process

**IMPORTANT NOTE:** This needs to be done to avoid scratches to the build plate by the extruder!  
Leveling would affect printing effects directly, if the printing result is unsatisfactory, run leveling process again!



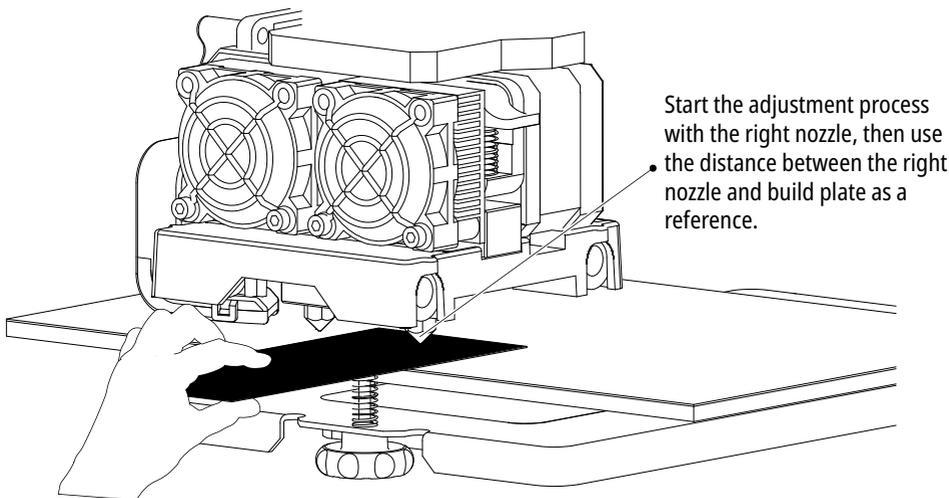
Please adjust the front thumb screw under Platform when stop.

Next



3. Tap [Tools] > [Level].

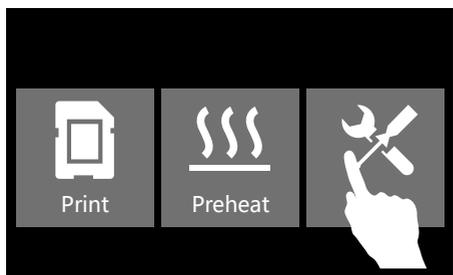
4. Extruder starts to move to the first leveling point. When moving stops, level the first leveling point .



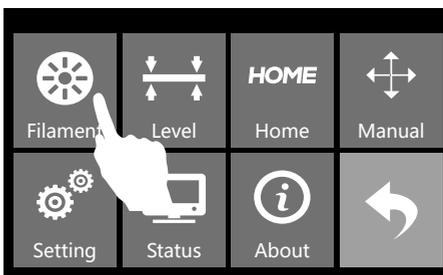
5. Take leveling card out, on the basis of right side extruder, put leveling card between right nozzle and build plate. Slide leveling card back and forth and adjust thumb screw in the meantime.
  - If you can move leveling card easily, please rotate thumb screw clockwise to reduce the distance between build plate and nozzle. Otherwise, rotate thumb screw anticlockwise to increase the distance between build plate and nozzle.
  - If you feel slight friction sensitivity when moving leveling card, the distance between extruder and leveling card is proper, thus adjustment completed.
6. After the first leveling point completed, tap [Next]. The extruder will move to the second leveling point. Adopt same method to adjust. After three leveling points (above thumb screw of three leveling points) completed all, leveling completed. Tap [Finish] to end leveling process, tap return arrow to go back to home screen.
7. Press build plate slowly to printer bottom.

# Loading/Unloading filament

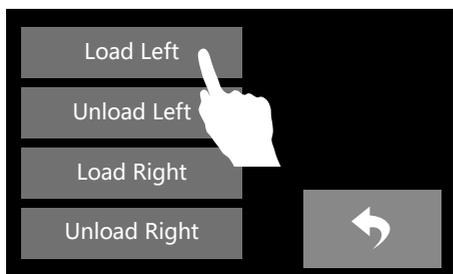
## Loading filament



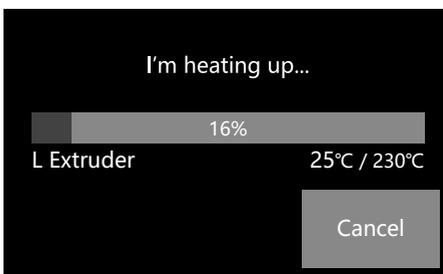
1. Tap [Tools].



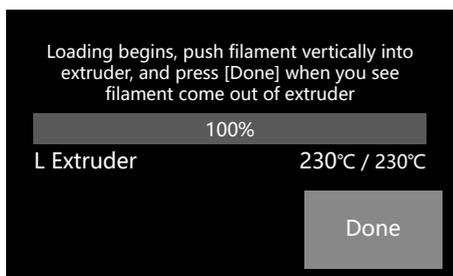
2. Tap [Filament].



3. Tap [Load Left] (or [Load Right]).



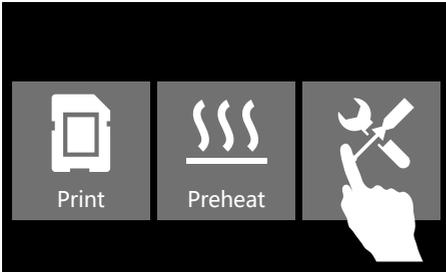
4. Extruder starts heating up.



5. Once heated, filament will be drawn through the extruder. Continue extruding until the extruder provides a steady flow of filament. Tap [Done], go back. Tap return arrow to go back to home screen.

## Unloading filament

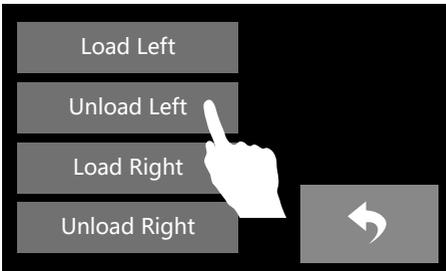
**ATTENTION!** If the extruder is not able to unload over a longer time, check if the filament is correctly inserted into the bottom of the extruder.



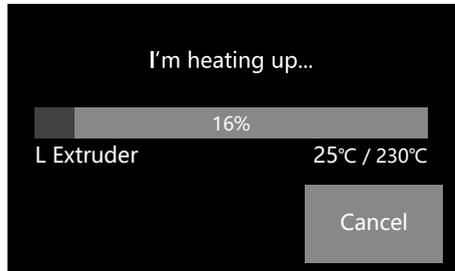
1. Tap [Tools].



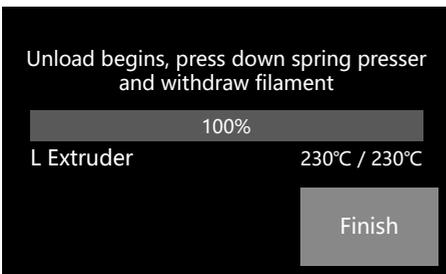
2. Tap [Filament].



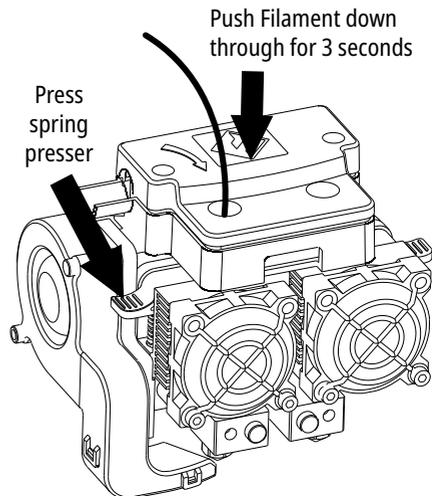
3. Tap [Unload Left] (or [Unload Right]).



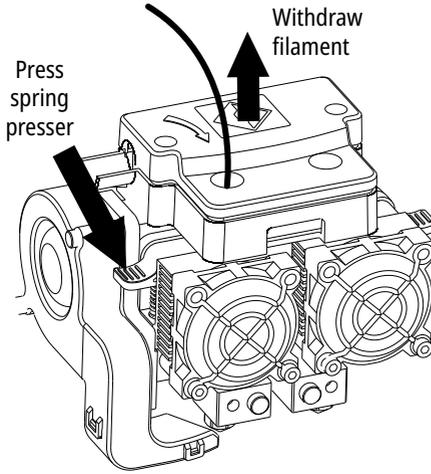
4. Extruder starts heating up.



5. When heating up to target temperature, press spring presser and push filament down through for 3 seconds, until you see steady filament coming out from nozzle.

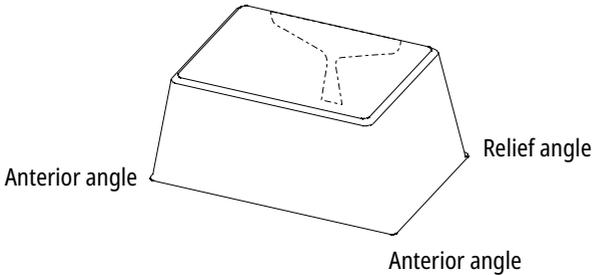


## Unloading filament



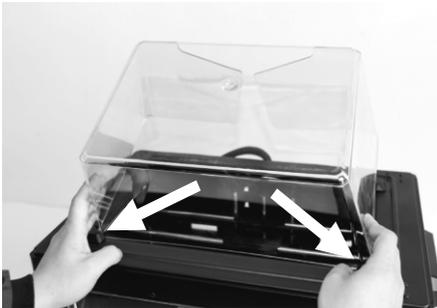
6. When filament is coming out of the nozzle, quickly pull out the filament vertically and release spring presser. Tap [Finish] to finish unloading. Tap return arrow to go back to home screen.

## Assembling/Disassembling top cover

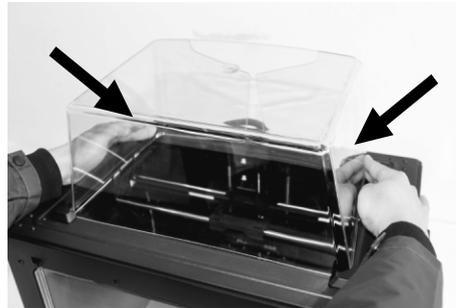


### NOTE:

Install the top cover when printing ABS. Remove the top cover when printing PLA.



1. Place the two anterior angles of the top cover into the corresponding front slots.



2. Slightly squeeze the two relief angles to place them into the corresponding rear slots.

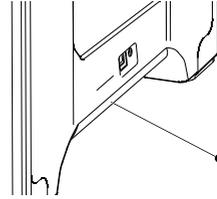
3. To remove the top cover, squeeze the relief angles to remove them from the slots.

# First print

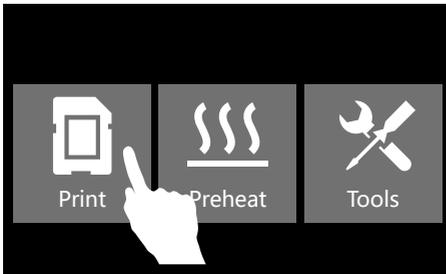
**NOTE:** Ensure that the build plate has been leveled correctly before you start printing. Ensure that the filament has been loaded in an appropriate approach.

## USEFUL TIPS:

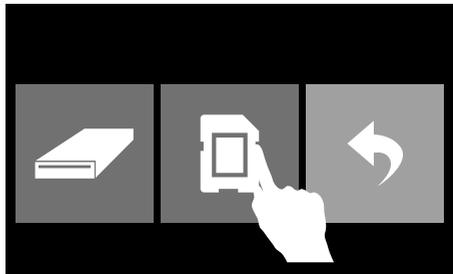
- Load the filament for a while to extrude all the melted filament you printed last time out of the extruder.
- When printing ABS, install top cover and close the front door. When printing PLA, remove top cover and open the front door.
- Let the nozzle cooling down! Then clean the extruder before printing.
- Do not leave the printer unattended during operation.



1. Insert SD card into SD card slot on the right side of the printer.



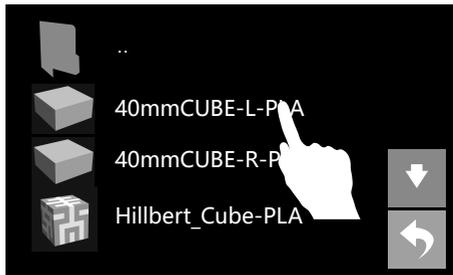
2. Tap [Print].



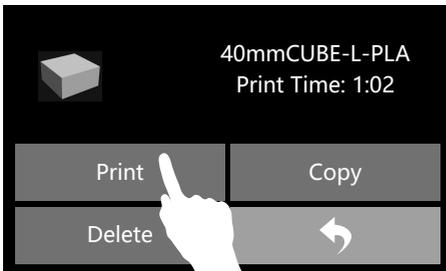
3. Tap [SD card].



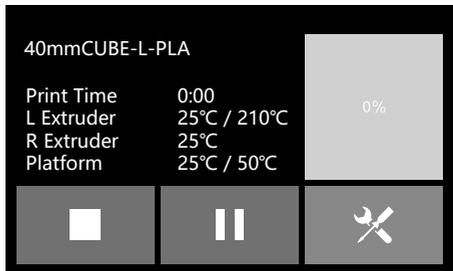
4. Tap [Test Files].



5. Choose [40mmCUBE-L-PLA].



6. Tap [Print].



7. The extruder starts heating up. Once heating up is finished, the printer will start to print.



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