Lesser Alunar 3D Printers

R100-01

USER GUIDE

1. INTRODUCTION

Standard configuration

2. FEATURES

Technical parameters	
Brand	ALUNAR 3D PRINTER
Model	HB-R100
Structure	All metal framework material
Print head number	1
Molding technology	FDM
Print size	100*100*100 mm
Support off-line print	Micro SD card
Is there a display	Color touch screen
XY axis positioning accuracy	2.5 microns
Z axis positioning accuracy	11 microns
Print speed	200-500mm/s
Standard extrusion head specification	0.4mm
Extrusion head operating temperature	180 - 235 degree Celsius
Heating plate temperature	Not applicable
Printing materials	PLA
Printing materials diameter	1.75mm
Support file format	STL, G-code, OBJ
Operating system	XP, Win7,Mac OS , Linux
Recommended print software	Repetier-Host
Power supply / maximum power consumption	Input: AC 110V/ 220V 50/60Hz 350w
Working environment	Temp: 10-40 degree Celsius Humidity 20-50%
Machine size	450*350*250 mm
Machine weight	N.W: 4.5 kg G.W 6.5 kg
Packing list	2 *Print hot bed 1*4G SD card 1*Power Adapter 1*Blade 1*Tweezers 1*Pliers 1*Card Reader 1*USB Data cable 1*Filaments Bracket 1 Roll PLA filaments

PRINT MATERIALS

Printers can use two different types of print materials: PLA and ABS. Each material has unique benefits and you can guide your selection based on the properties your part requires.

PLA

This is a hard plastic that has a low environmental impact. It is derived from renewable, starch-based resources.

We recommend using PLA when printing extra-large parts on printer as it is a more stable print material.

PLA is the optimal support material for industrial ABS parts. PLA has the ability to dissolve away in caustic soda solutions supported by an ultra-sonic tank.

ABS

This is a well-known plastic known for its strength and industrial properties.

As a build material, ABS is good for both small and large parts.

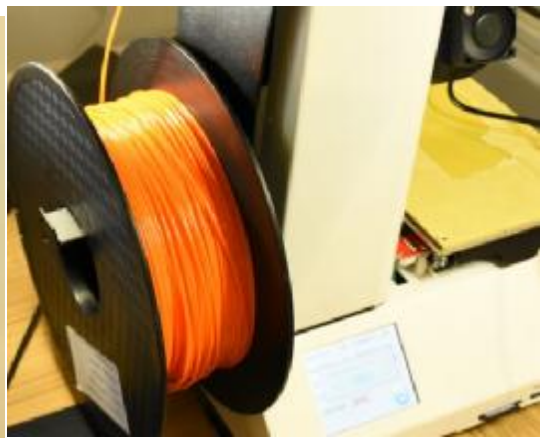
ABS works as an excellent support material for extra-large PLA parts.

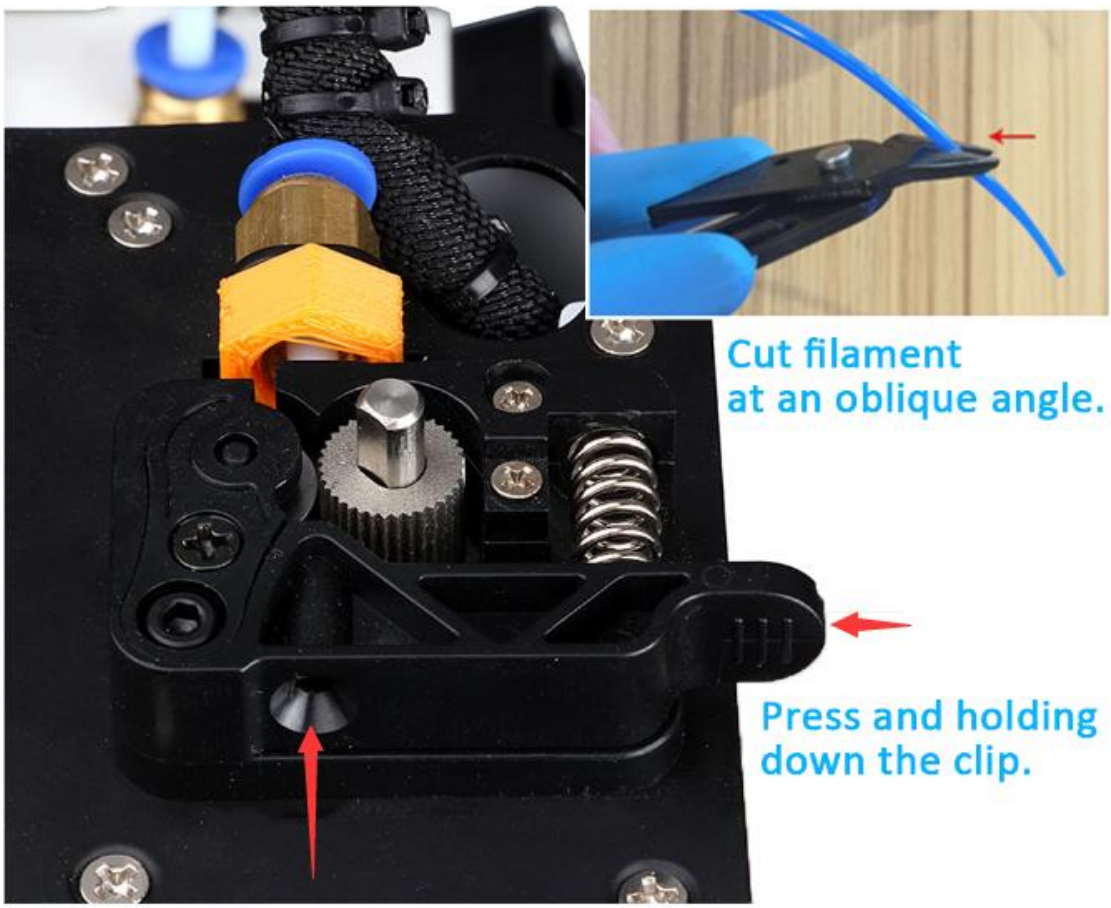
3. UNPACKING & INSTALLING

3.1 Unpacking

A. Unpacking the item, and put the printer on a level table. 4 bottom knobs will help to fine-adjust.
B. Connect the Filament Bracket, and put the PLA on it.
C. Put one print plate on the bed. Connect the power cable and press the switch to start.
D. Cut filament at an oblique angle. Press and holding down the clip. Plug in the filament through tube to the nozzle.


Put On The Print Bed
Connect Power Cable

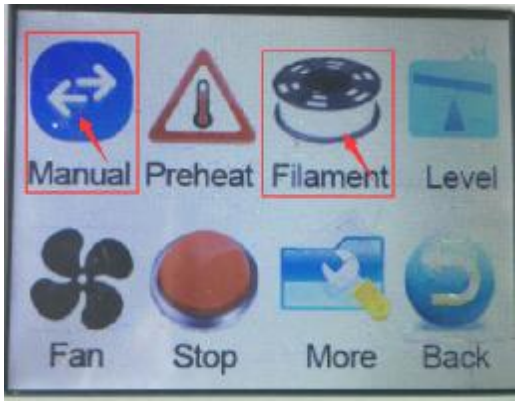


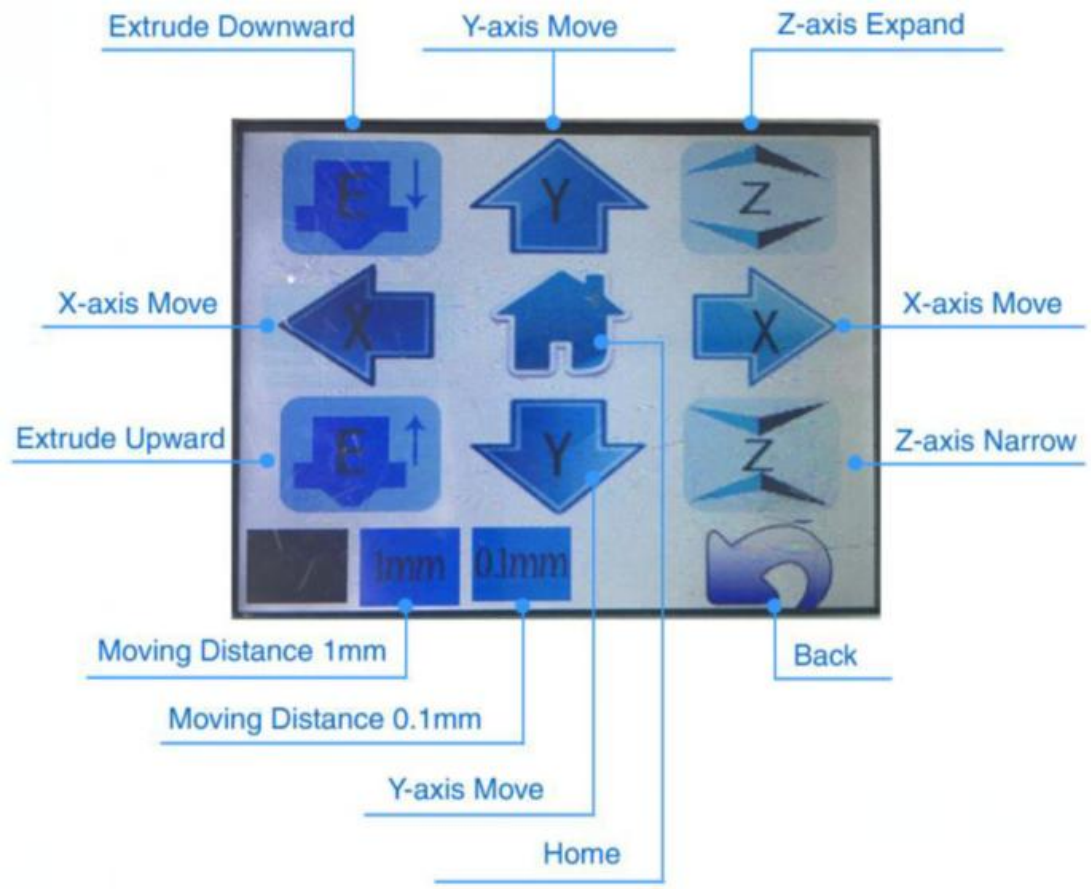


Plug in the filament through tube to the nozzle

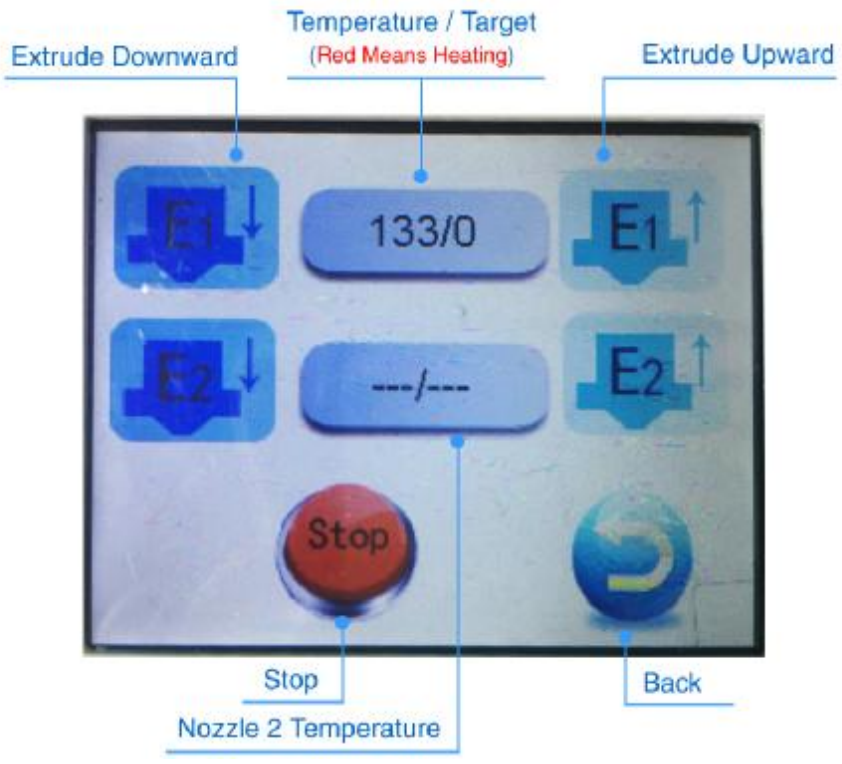
3.2 Level and Filament

A. Choose “TOOL”----“Manual”, Press Home and wait until printer finish auto-tuning with buzzing. Adjust Z- axis distance between the nozzle and plate to 10-15mm.





B. Choose "Filament", Press temperature in the middle of the first line to preheat the nozzle. Red means heating; Black means normal.

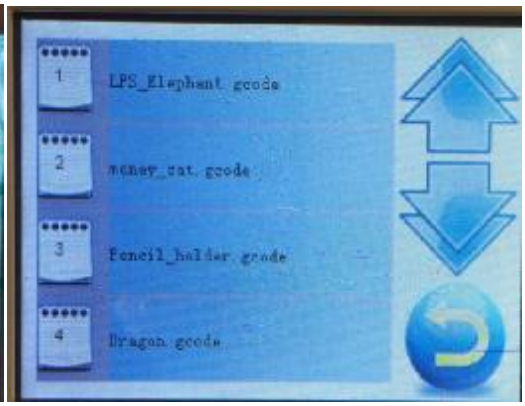


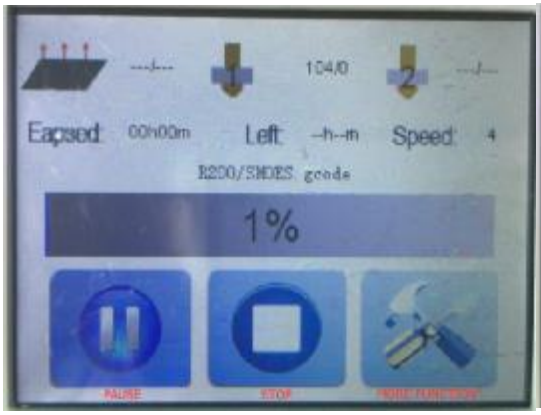
C. After temperature is getting to 220/220, press "E1↓" and Stop until PLA is extruded. Clean the plant and nozzle, then you can enjoy your printing.

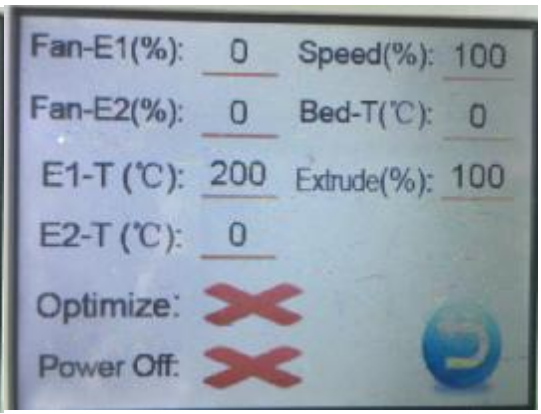
3.3 Printing from SD Card

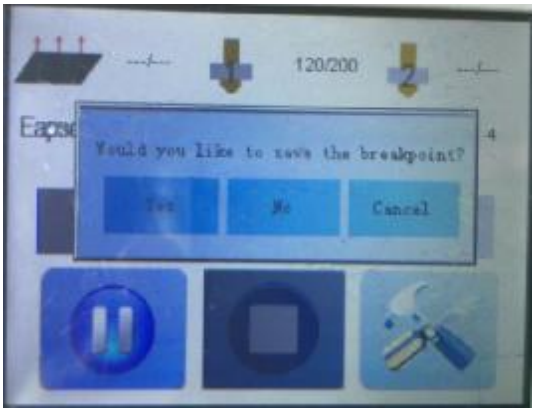
Insert the SD card (there should be some .gcode files in SD card).

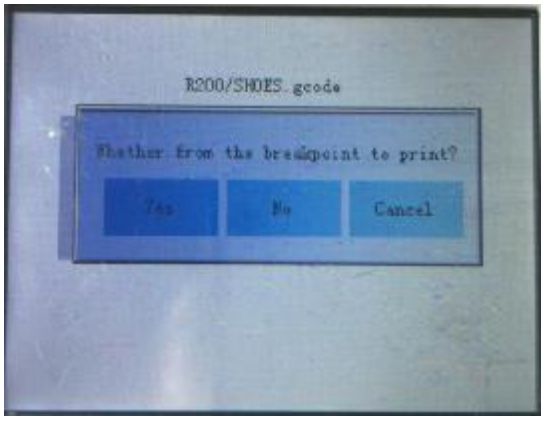
Back to Start Screen, press PRINT" PRINT", choose .gcode files that you want to print. Press "Yes" to confirm. You can **"**Pause**"** or **"**Stop**"** printing. More parameter can be adjusted in **"**More Function", such as printing speed, extrude etc. If you stop printing, you can choose to save the breakpoint, and print from the breakpoint to continue.











Notice: Please make sure the distance between the nozzle and plate is suitable (as the thickness of 2 A4 paper). Otherwise, the filament cannot stick or stick too tightly to take off.

4. Menu Instructions

4.1 System

Info: Display the parameters of each shaft and the temperature of the nozzle.
About: motherboard information, system ID, version number, and sound on/off.

中/EN: language switching between Chinese and English.

Default: Restore factory settings.
TP Adjust: to adjust touch point, the calibration can be carried out when touch failure.
WIFI: support WIFI online printing, but not included in the default configuration.
Back: Return to start screen.

4.2 TOOL

Manual: manually adjust the position and distance. Manual cannot be selected during printing.
Preheat: to preheat the nozzle, which can be used to manually extrude downward or upward.
Filament: to Load or unload Filament, nozzle should be preheated before.
Level: to adjust the distance between the printing plate and the nozzle. Press "NEXT" to adjust 4 level points, Screw the adjusting nut according to the distance until the four points leveling.
Fan: to adjust the fan speed of the nozzle and motherboard cooling.
Stop: press if wrong operation, the machine will stop moving.
More: spare port, used for the development of new function, now defined as laser engraving port which is currently in development
Back: return to start screen.

4.3 Print

Press and choose ".gcode" file to start printing.

5. Install Software

Please view another DOC file "Cura15.04 Guide".

6. Print Quality Troubleshooting Guide

Please view another DOC file "Print Quality Troubleshooting Guide".

7. Contact Us

For more details and questions about Alunar 3D Prints, please contact us.

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