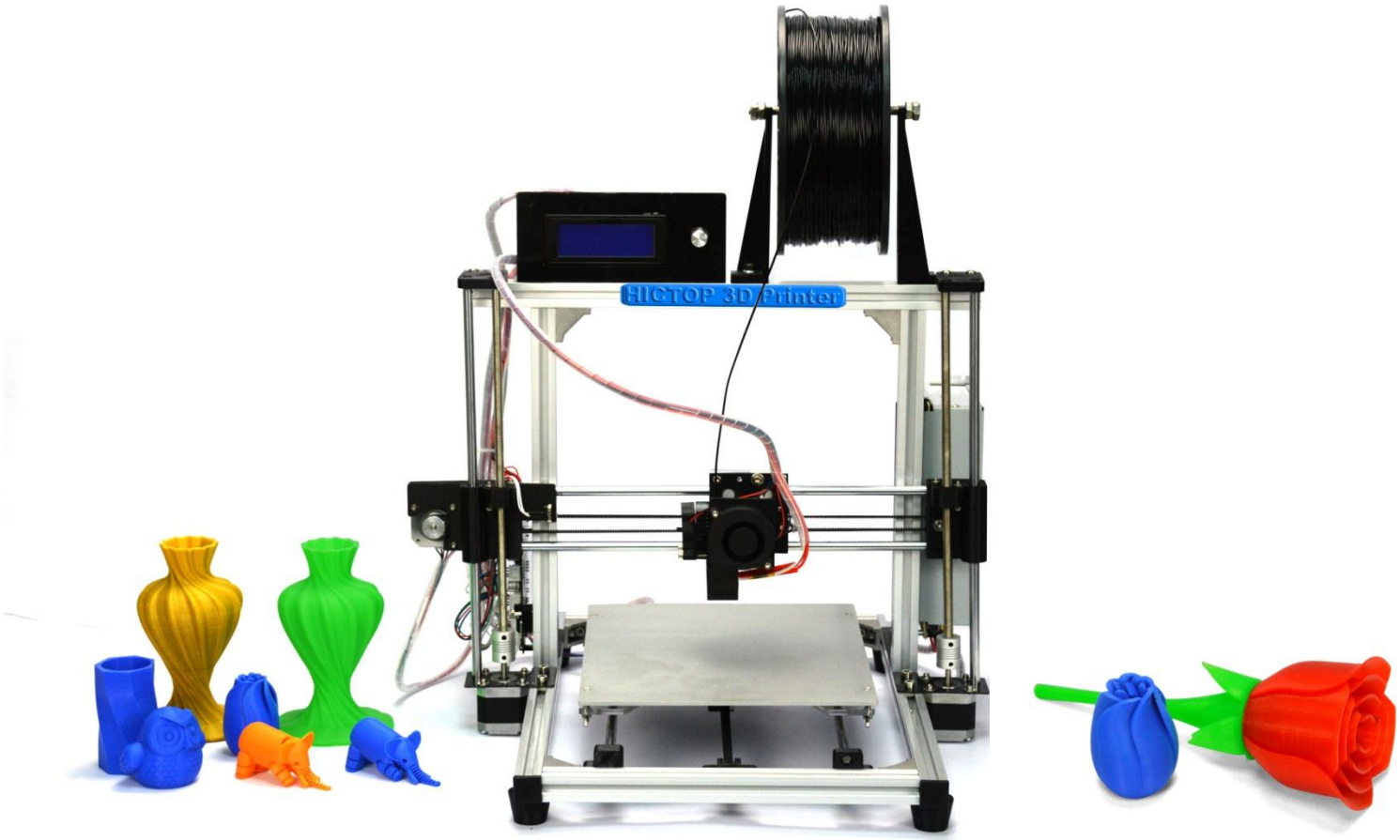
3D Printer Instruction



Please check the file FAQ in you have any question during printing.

Skype: ghj205

Tech Support: hic_technology@outlook.com

Instructional Videos: https://www.youtube.com/channel/UC9Udtwu2QGX6iml-meV6s_w

Catalogue

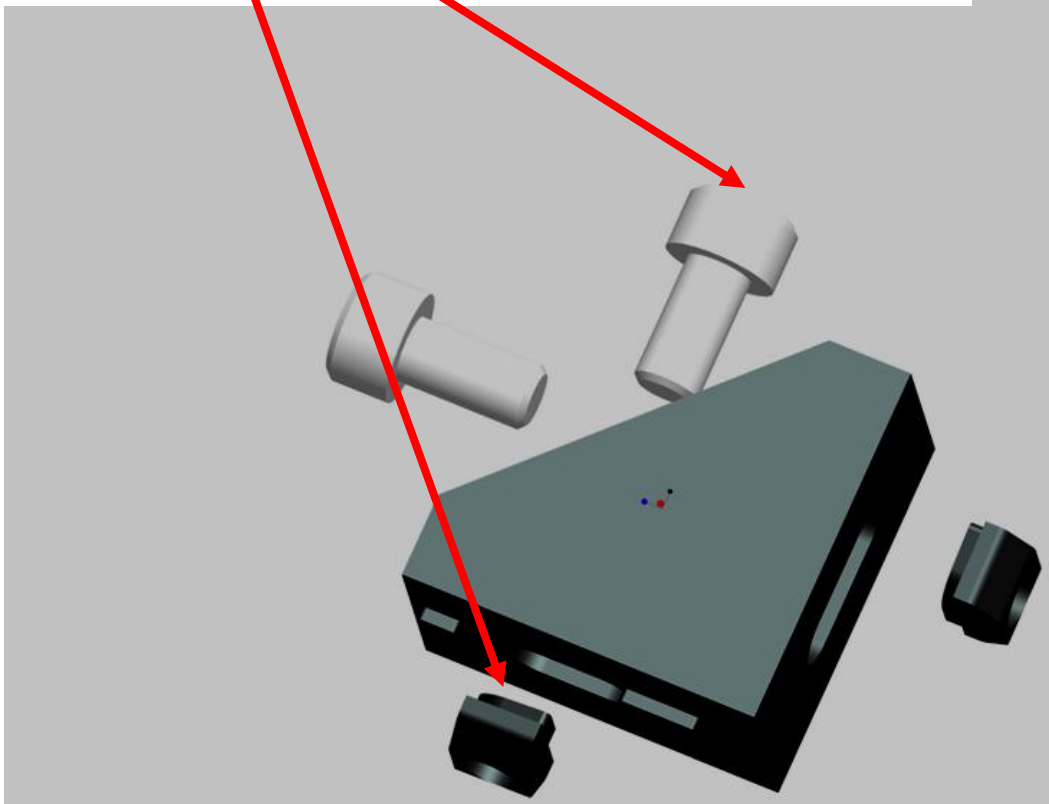
Checking package after opening

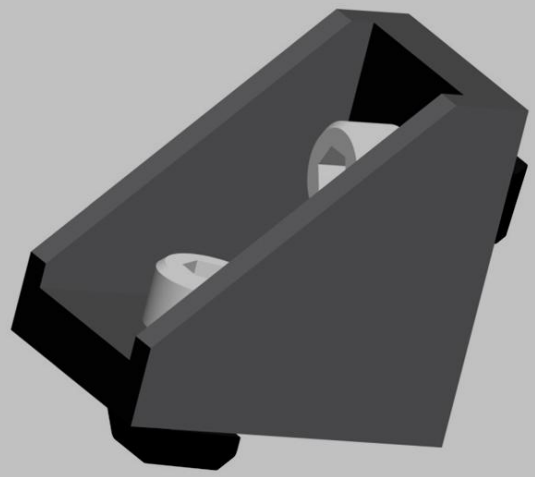
Y Axies Assembly

Attention：
1.Y axies belt clip must be fixed, not allowed loosen
2. Y axies belt pulley must be fixed, belt must be tight enough.
3. Make sure the base board moves smoothly when power off, otherwise it will cause Y axies losing step.

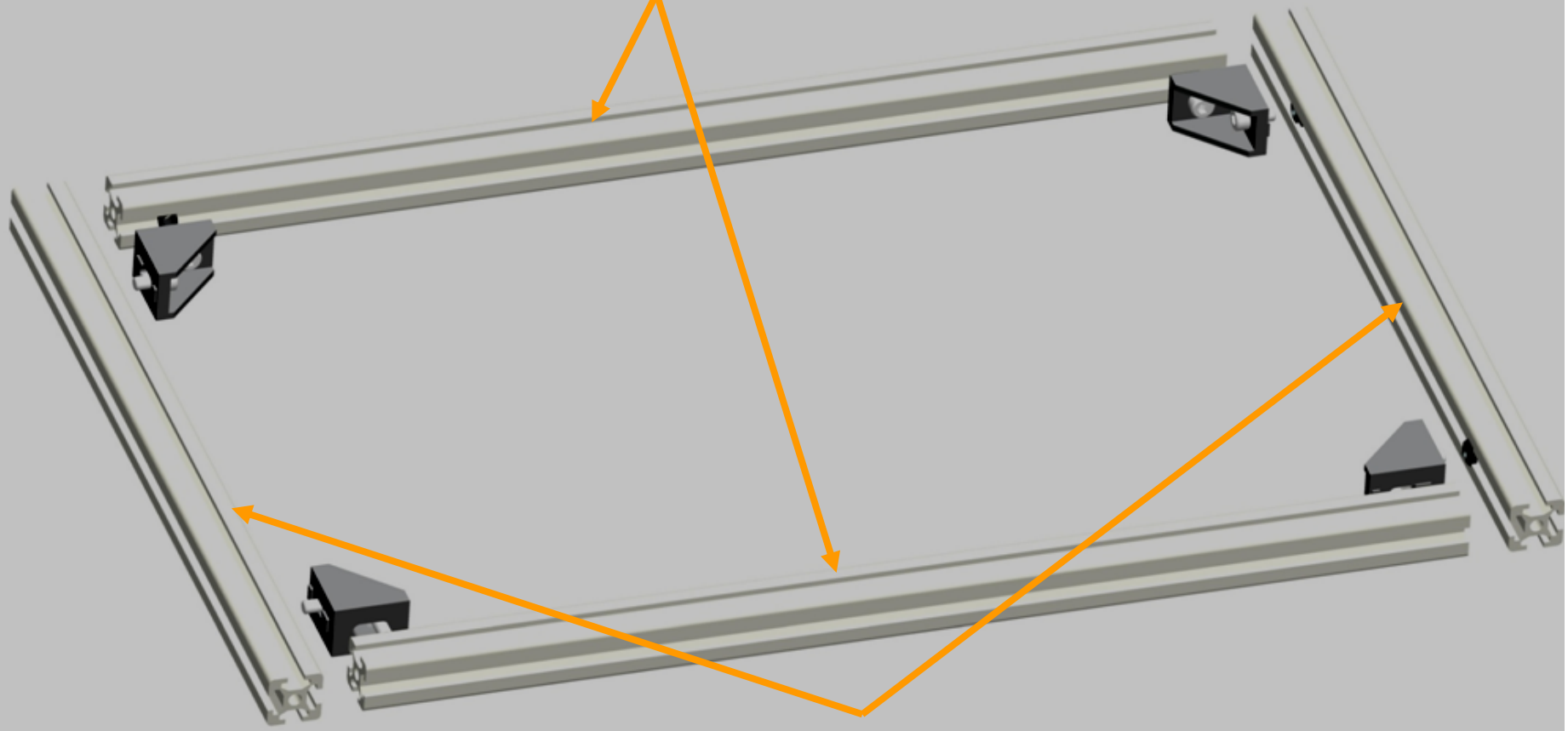
Step 1

Screw specification
1.M5*8
2.M5 nut

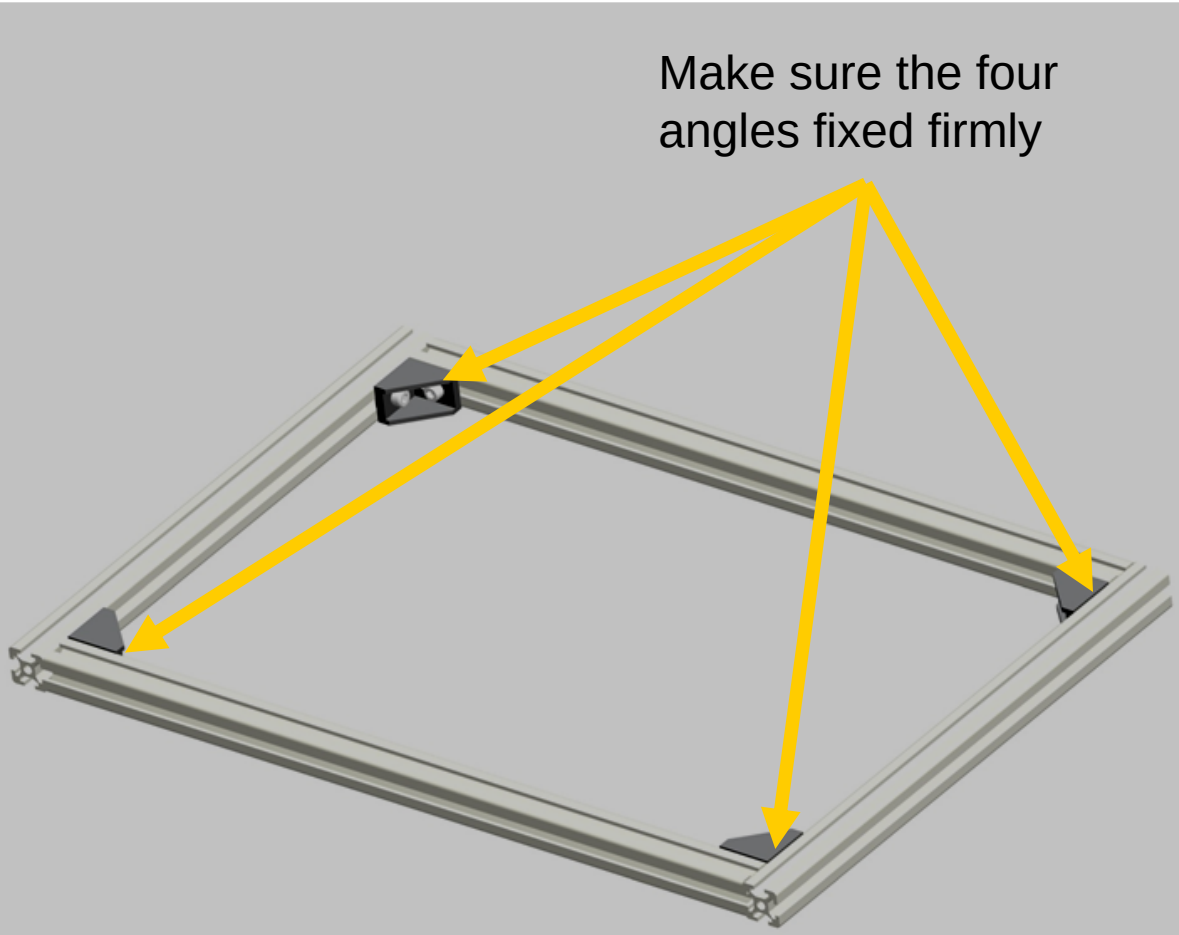


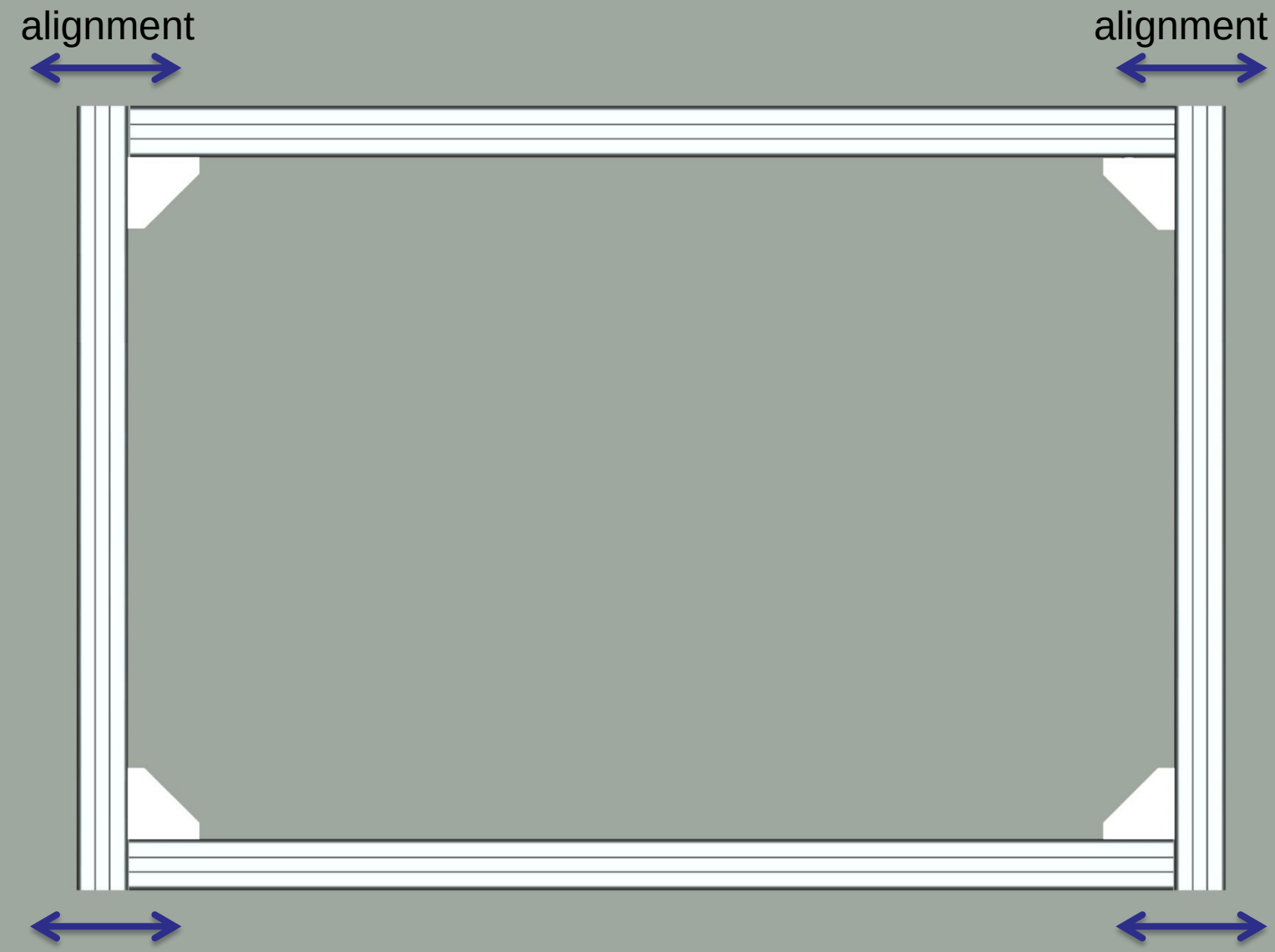


410mm aluminum frame



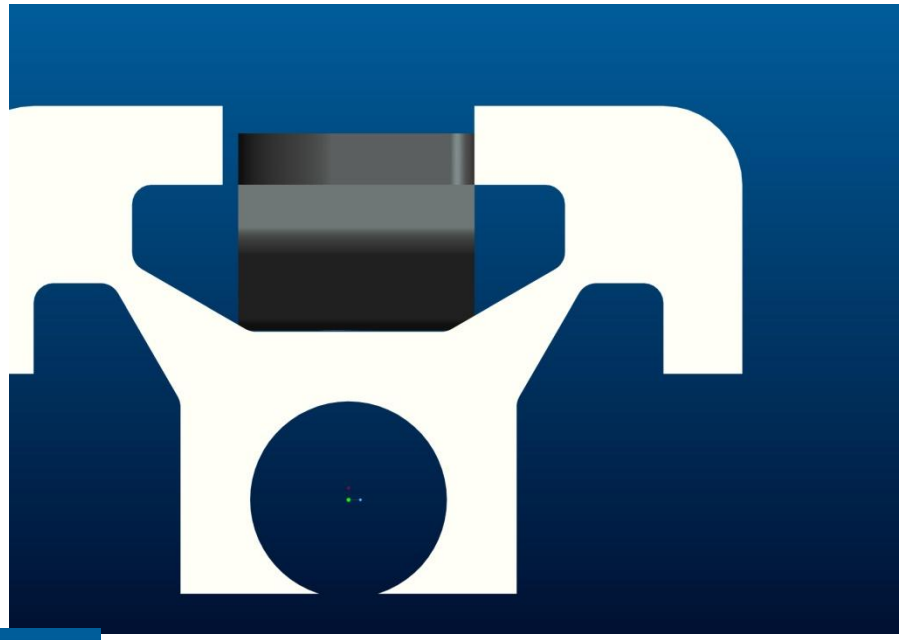
308mm aluminum frame


Make sure the four
angles fixed firmly


alignment
alignment
alignment
alignment

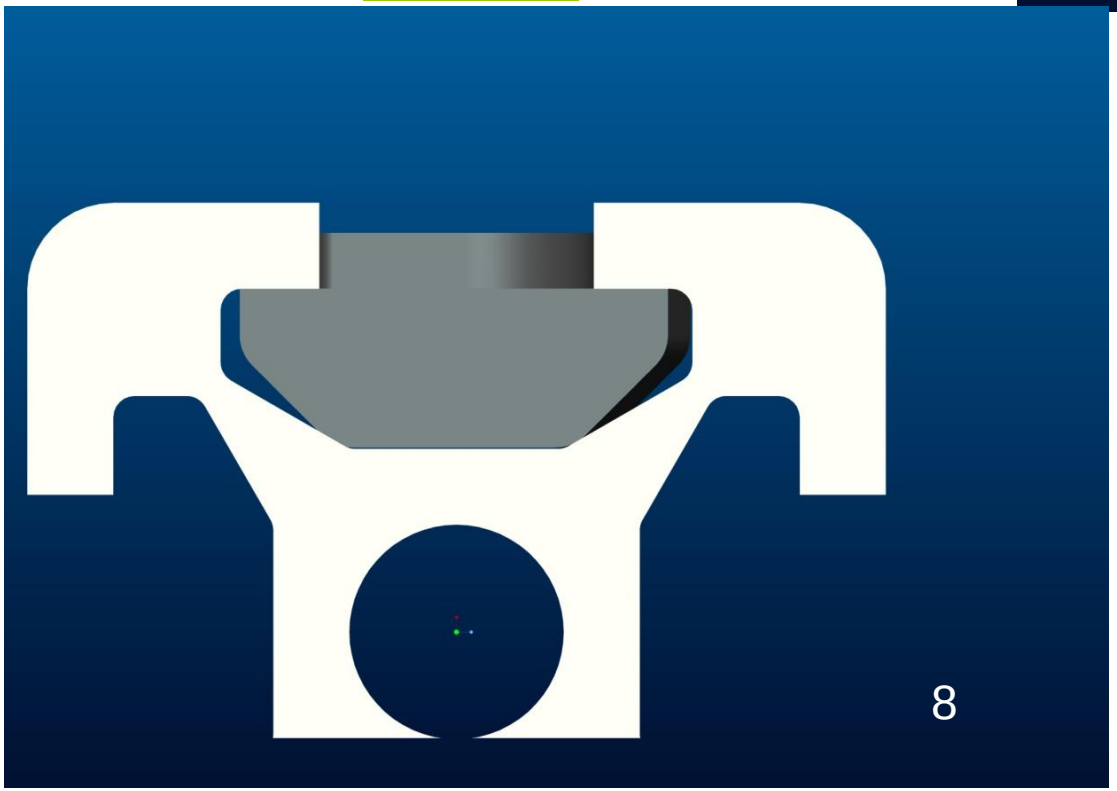

alignment
alignment

Pay attention to the screw's direction after it is locked



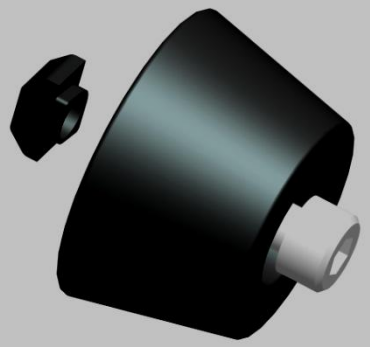
wrong

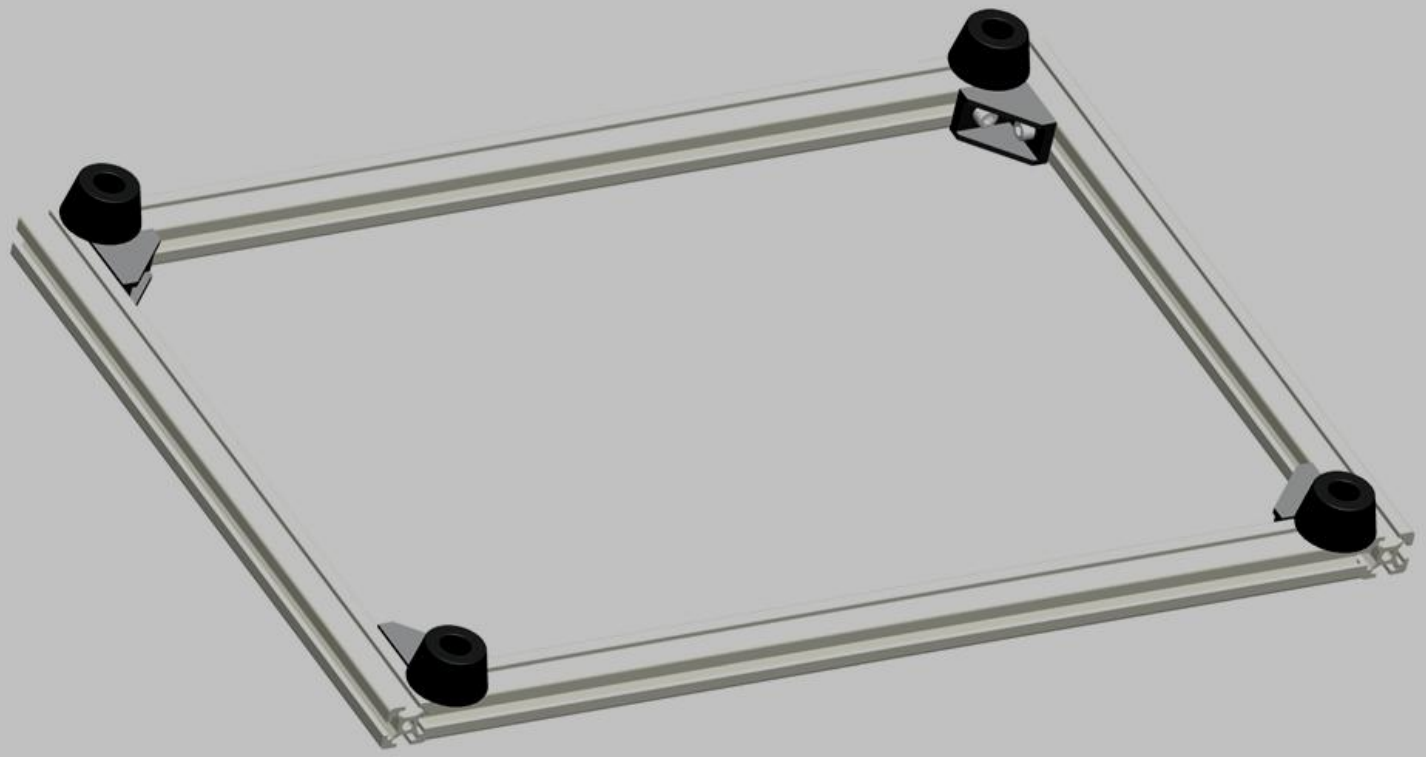
correct



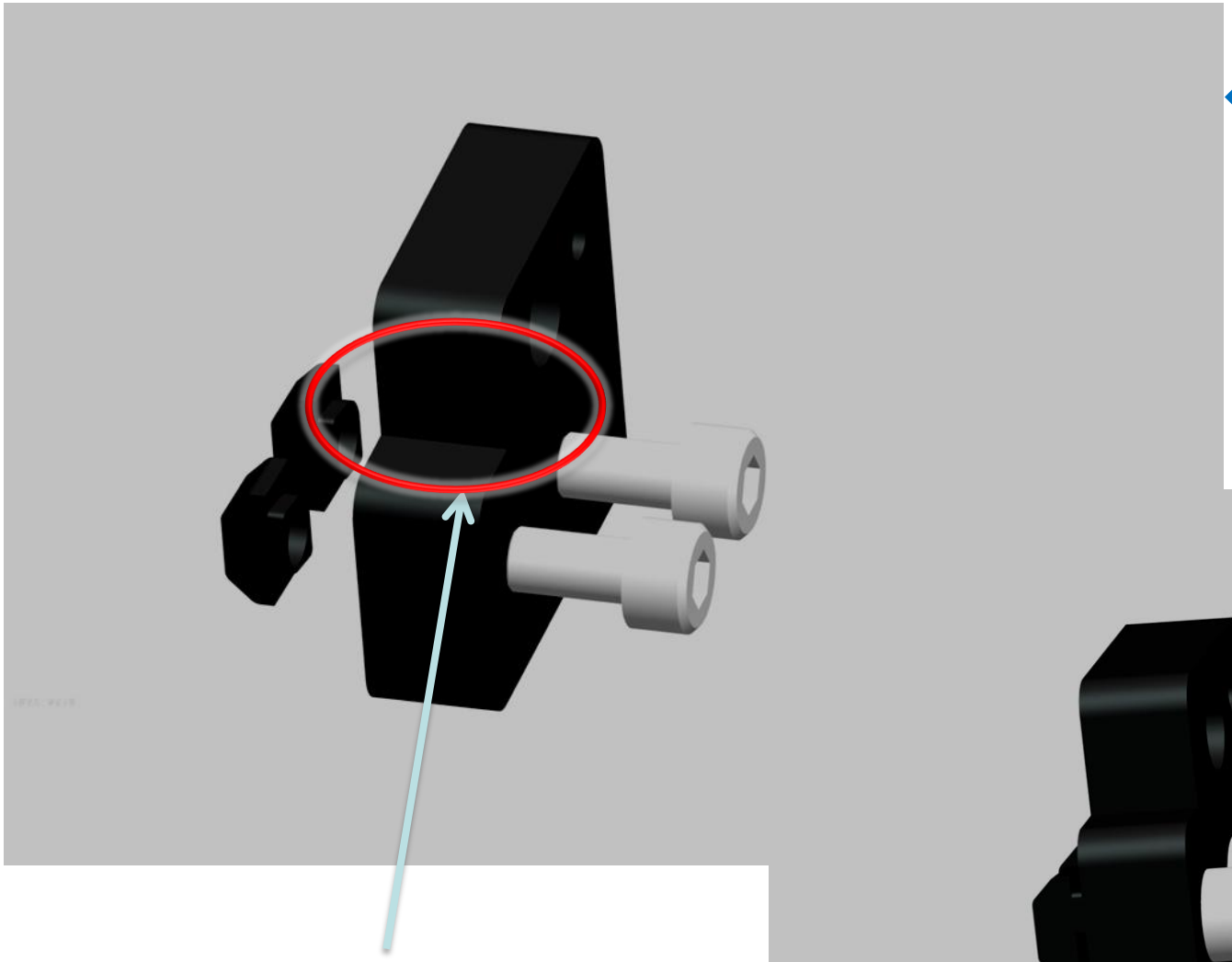
Step 2

foundation	4pcs
M5*12	4pcs
M5 nut	4pcs



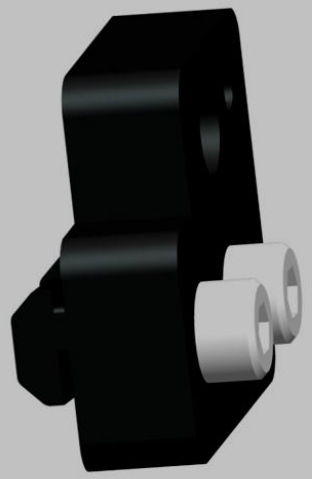


Step 3

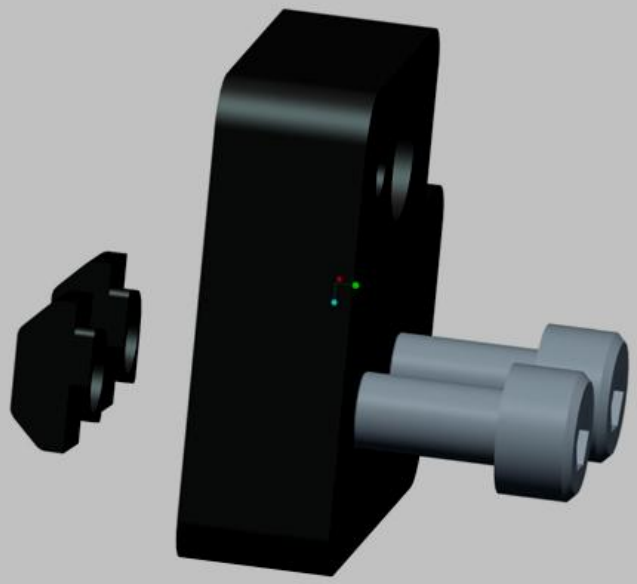


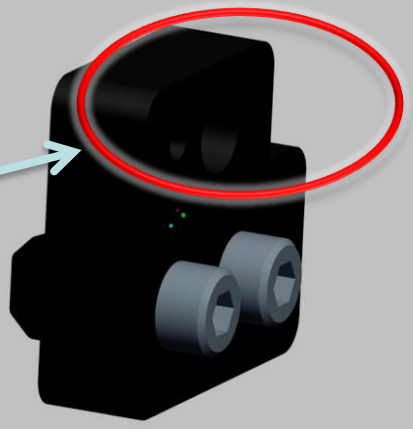
Notice the direction

M5*12 2pcs
M5 nut 2pcs
2 groups in total



M5*12 2pcs
M5 nut 2 pcs
2 groups in total



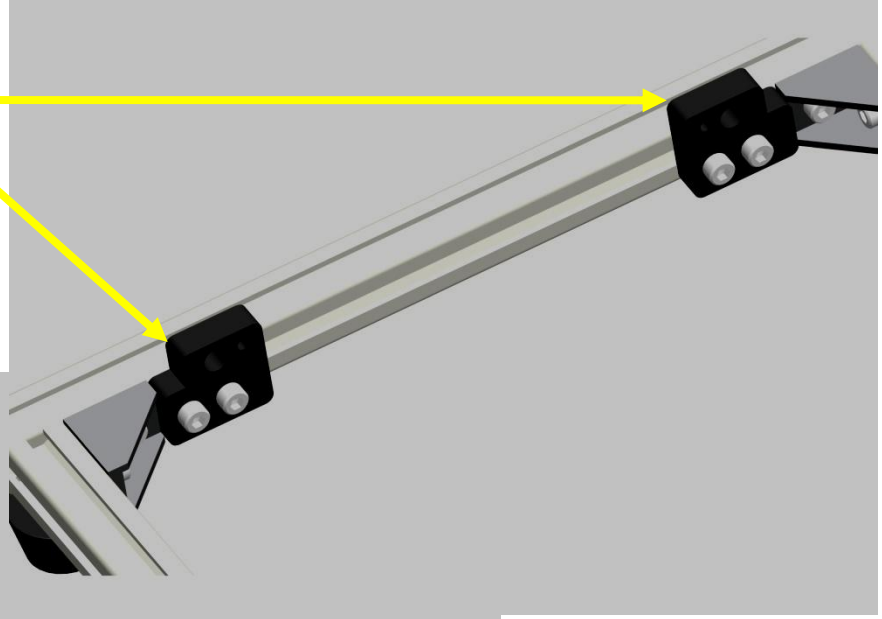


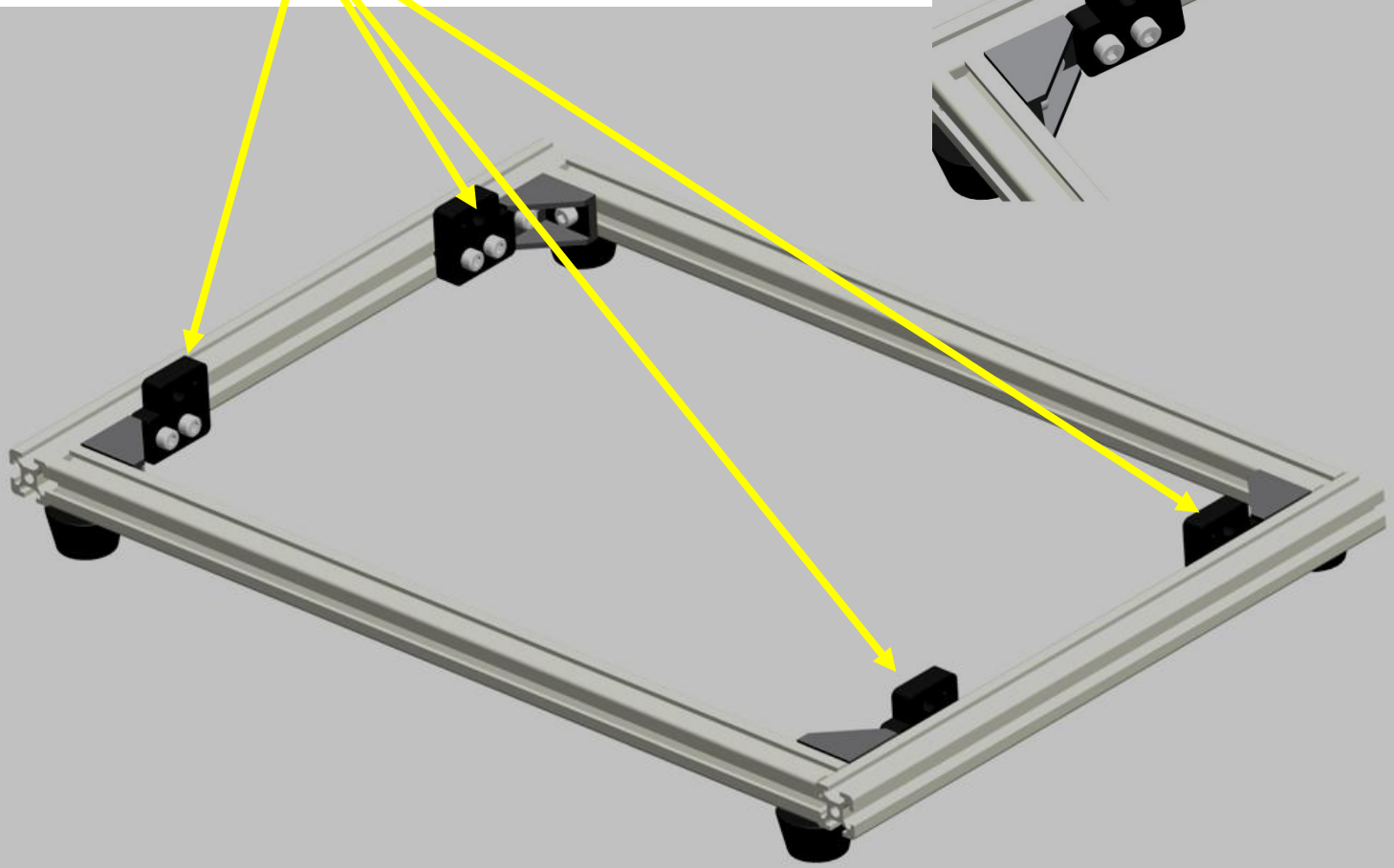
Notice the direction

Step 4

Pay attention
to directions

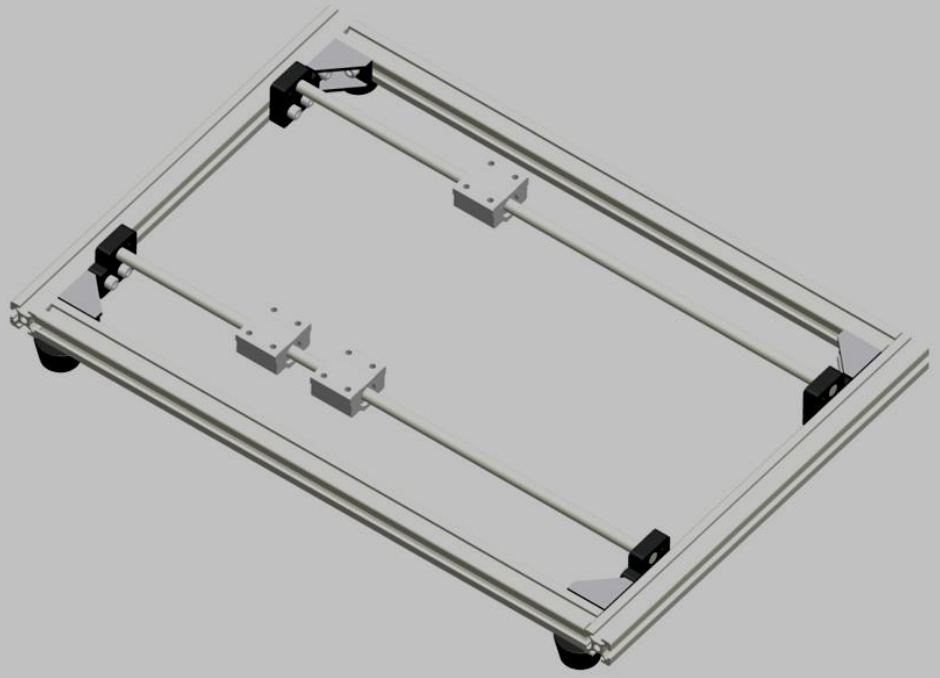
There are
four places

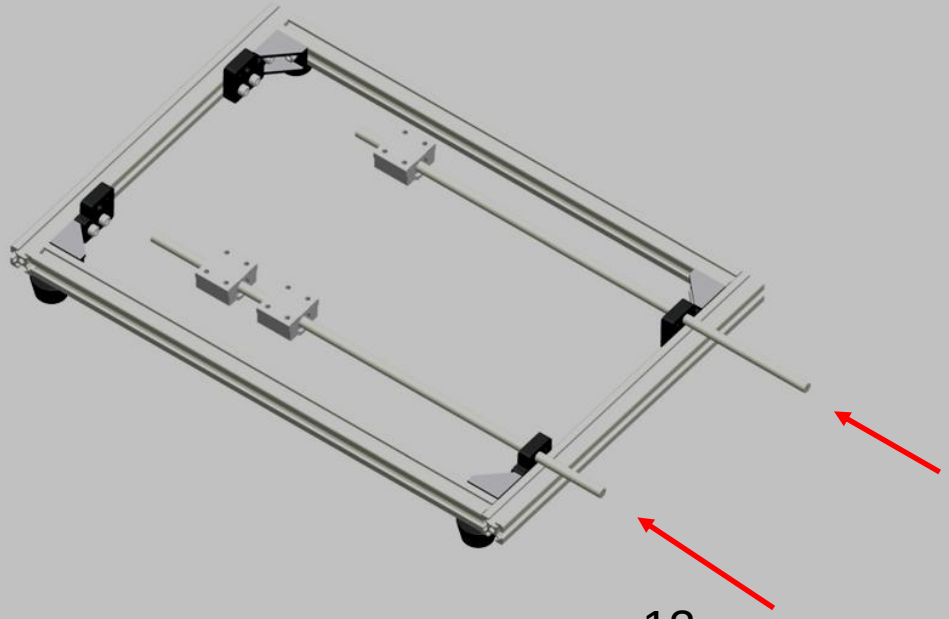




Step 5

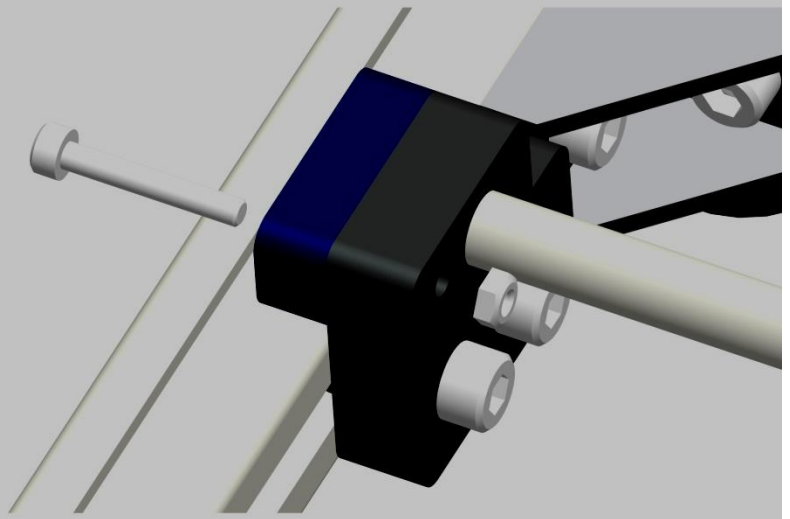
8*410mm polished rod 2pcs
Box type linear bearing 3pcs



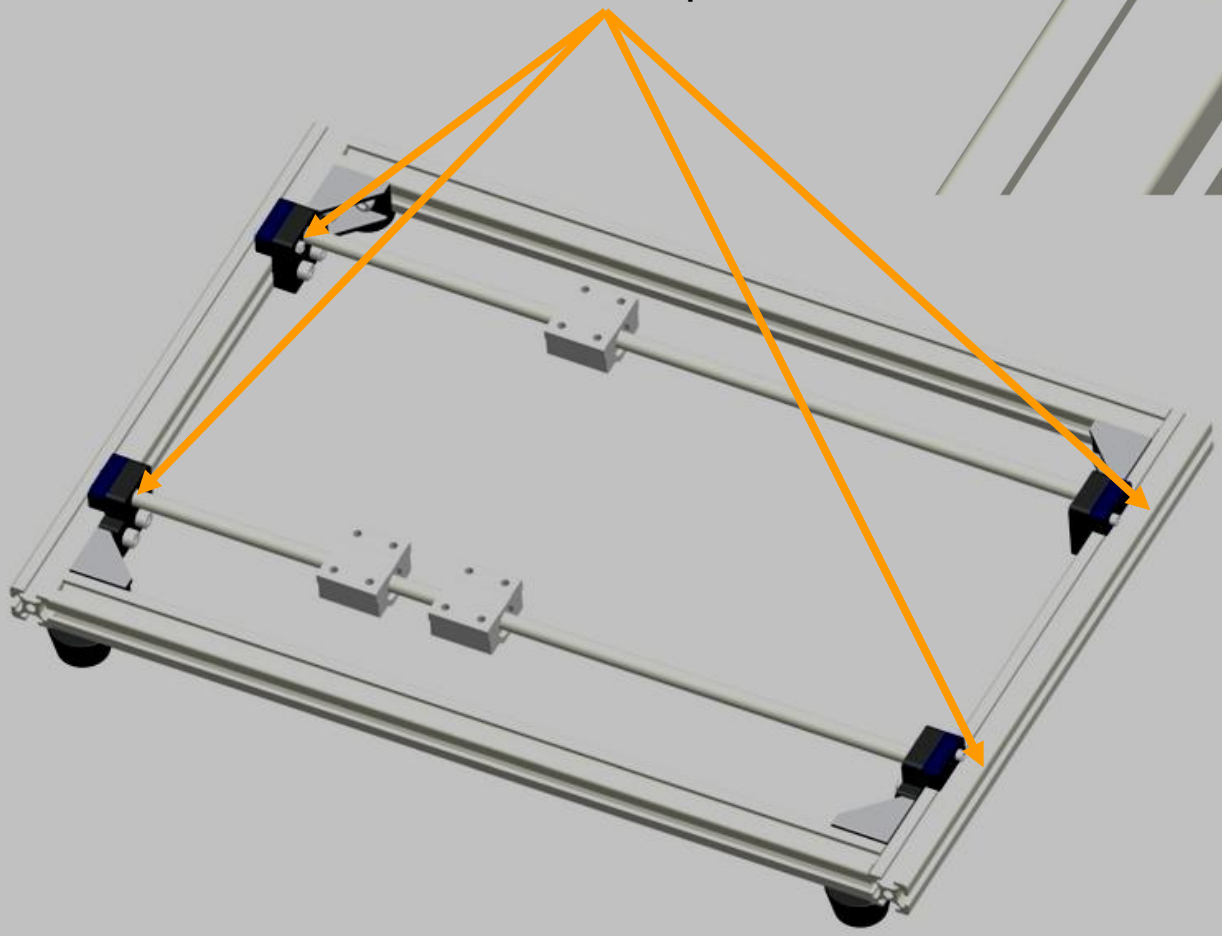


Step 6

M3*20	4pcs
M3 nut	4pcs

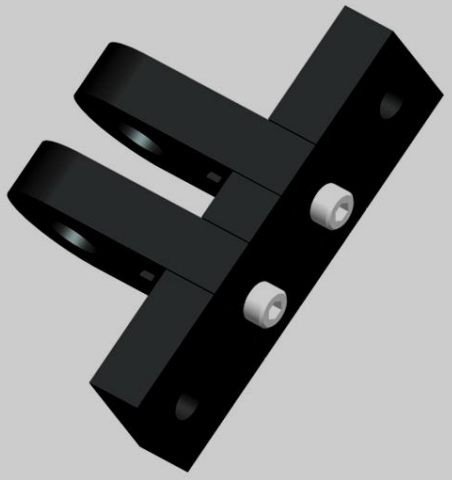


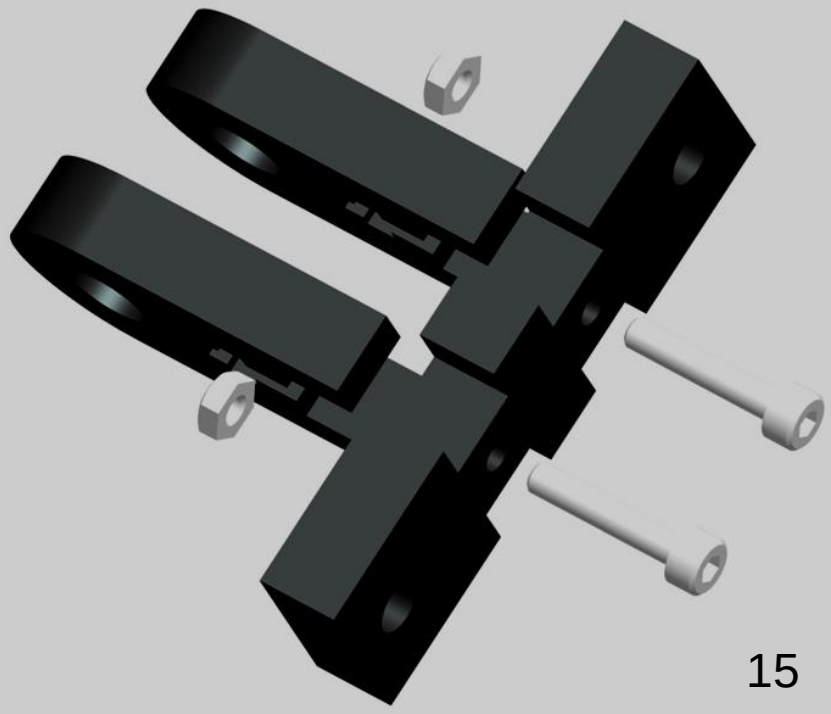
There are four places



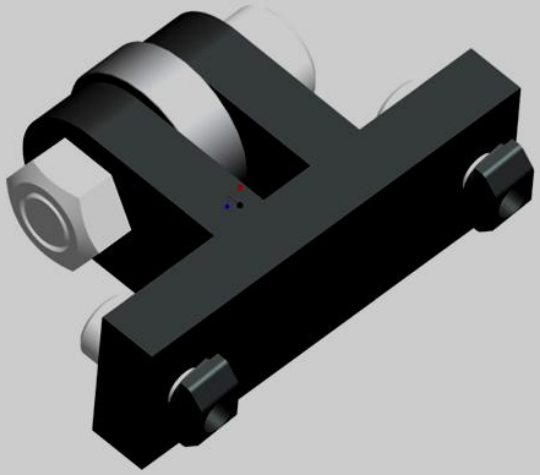
Step 7

M3*16 2pcs
M3 nut 2pcs

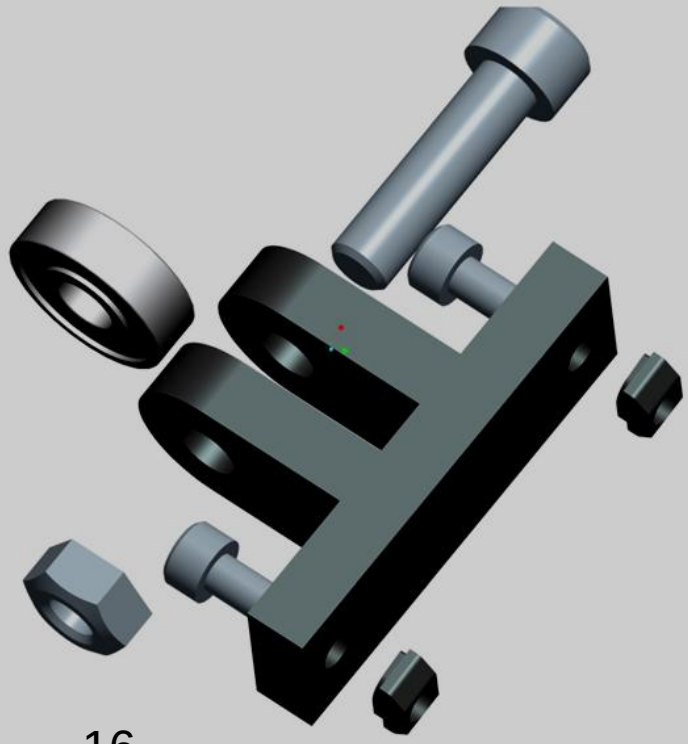




Step 8

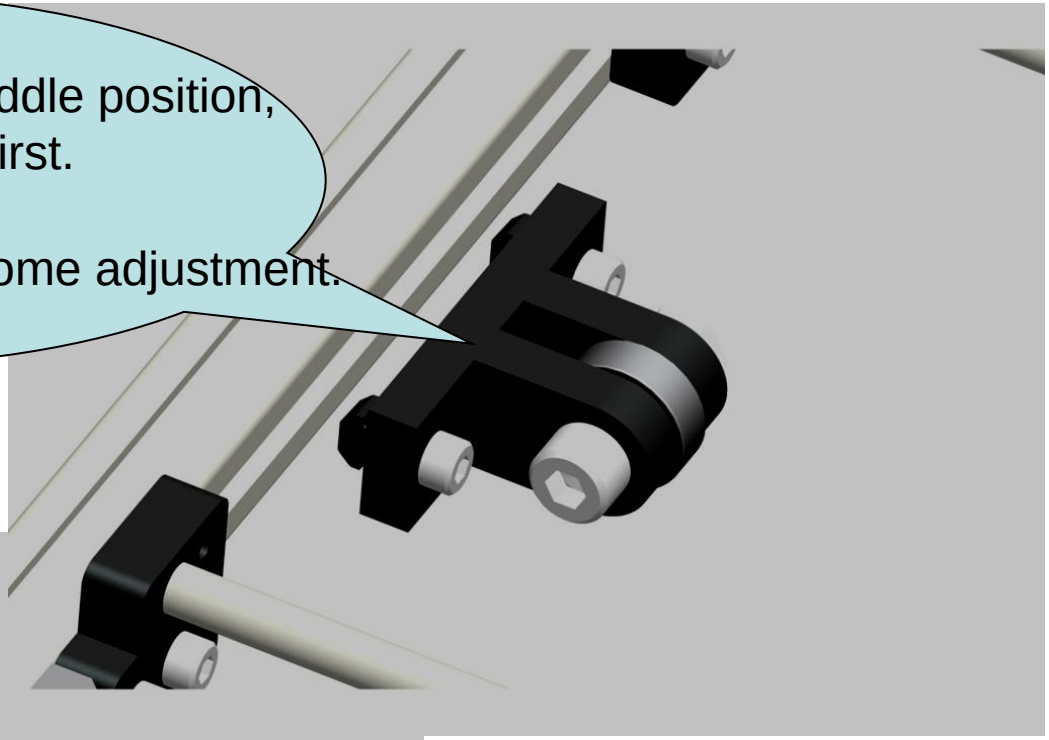


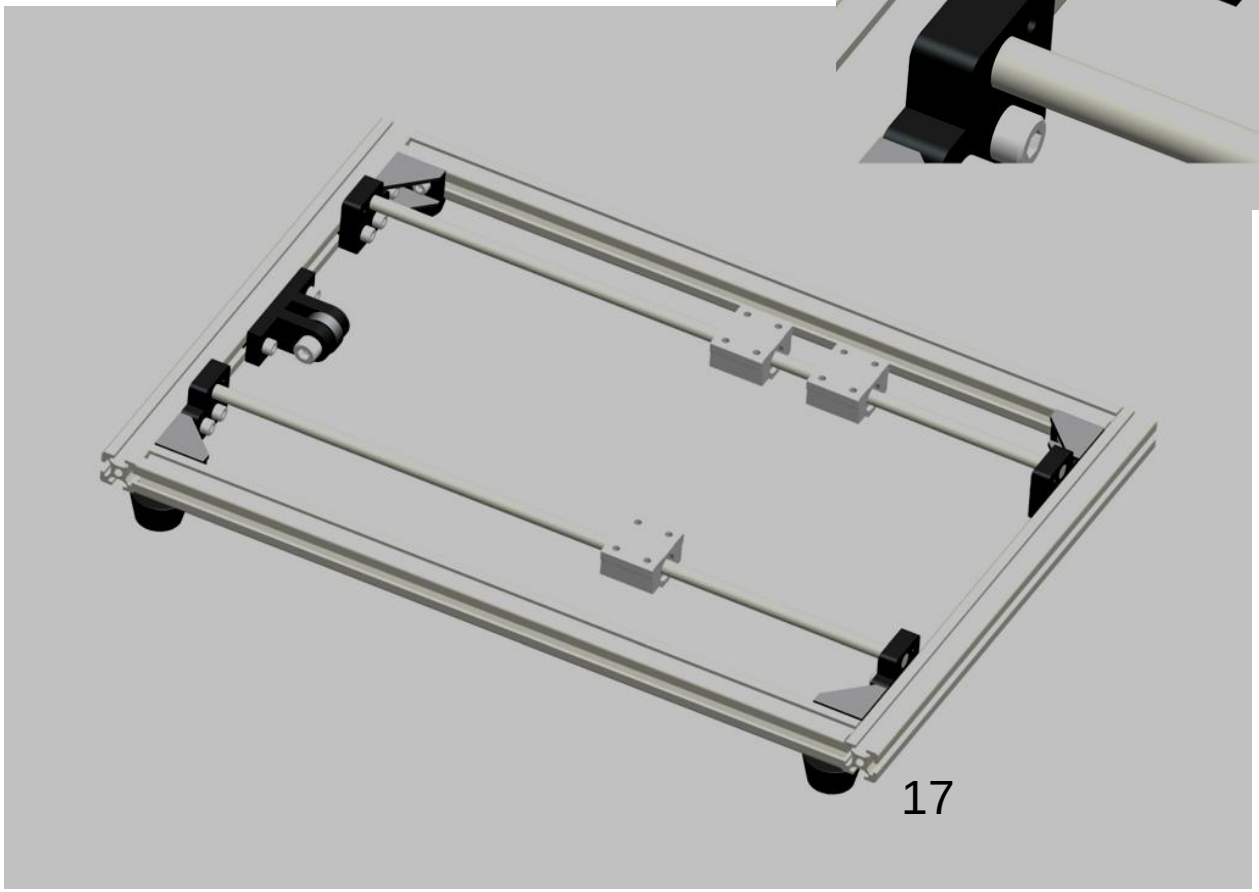
M8*30	1pcs
M8 nut	1pcs
M5*12	2pcs
M5 nut	2pcs
608 bearing	1pcs



Step 9

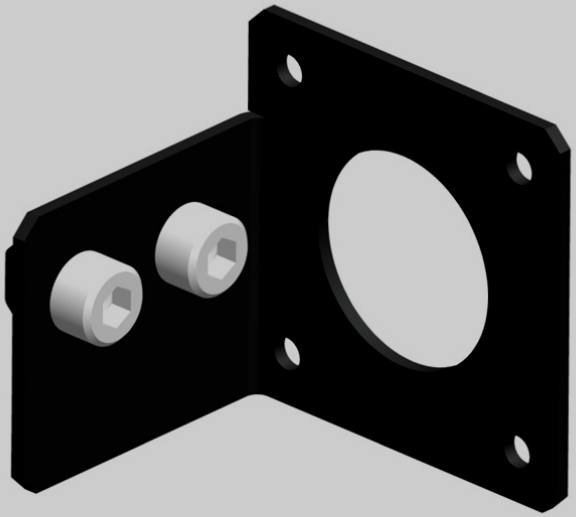
it is generally in the middle position,
and it needn't lock at first.
While fixing the belt,
it will be locked after some adjustment.

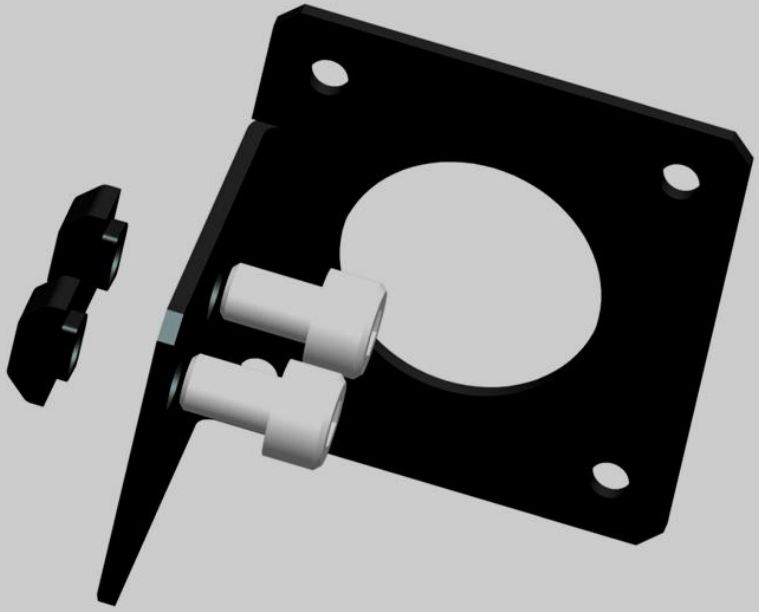




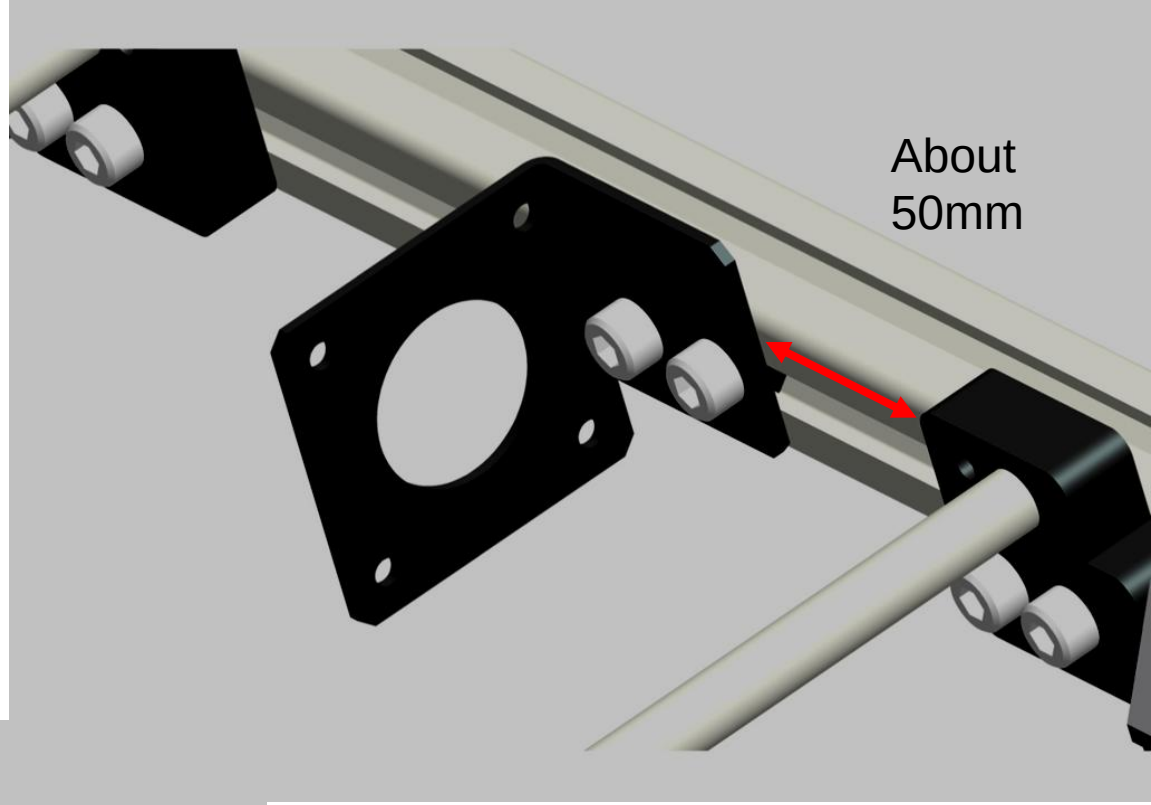
Step 10

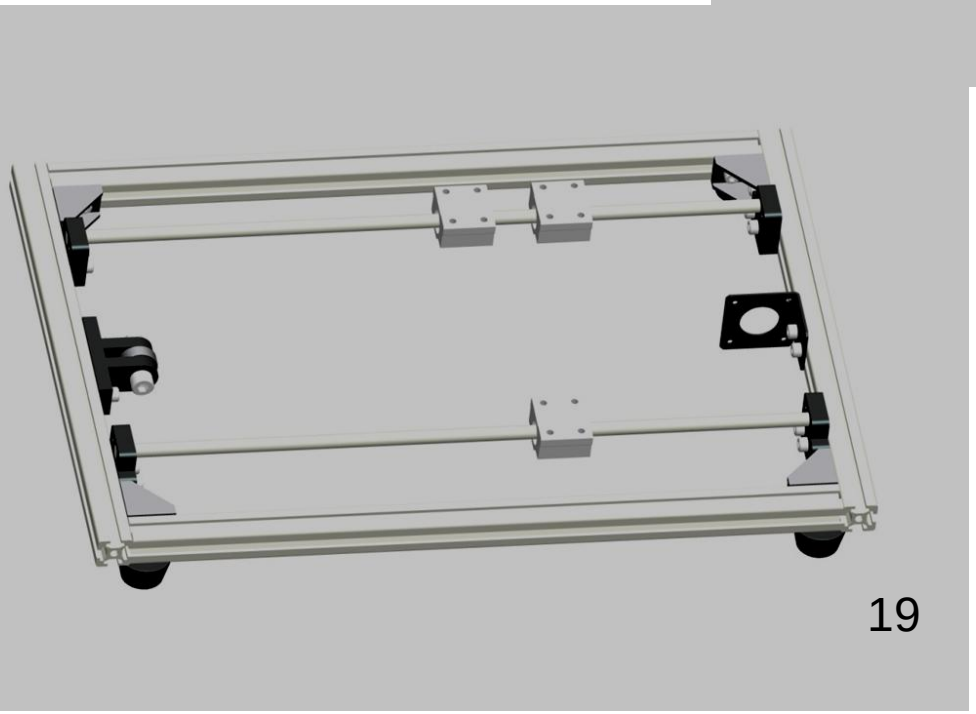
M5*8 2pcs
M5 nut 2pcs





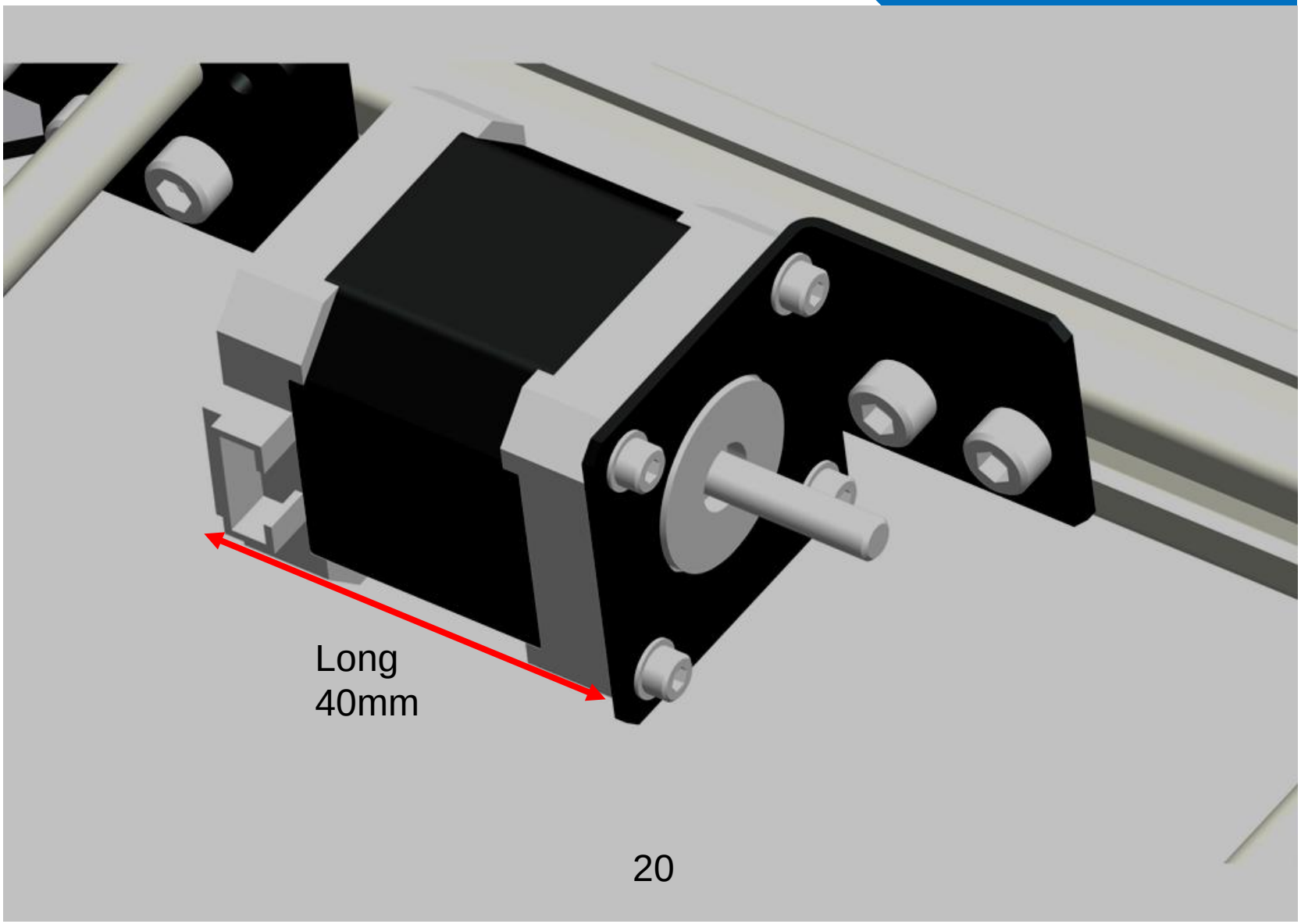
Step 11





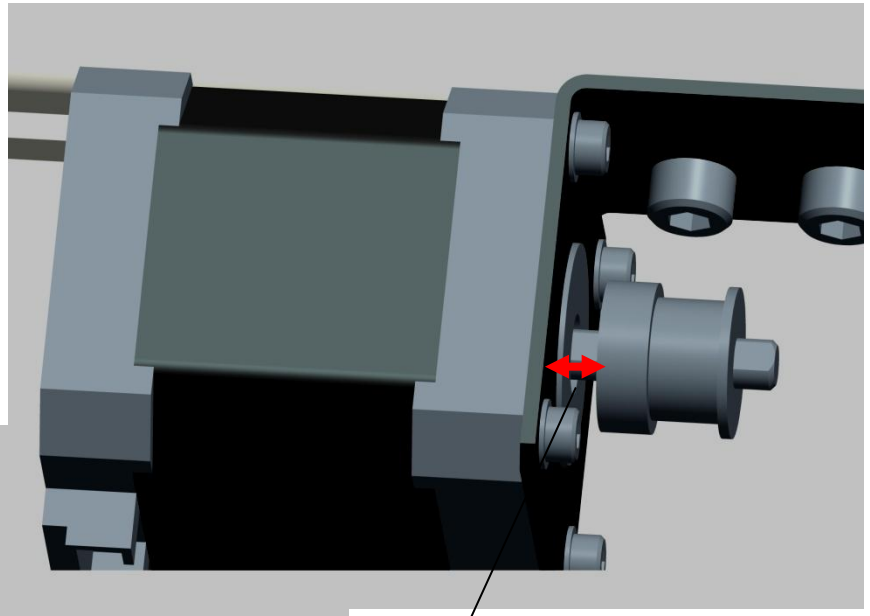
Step 12

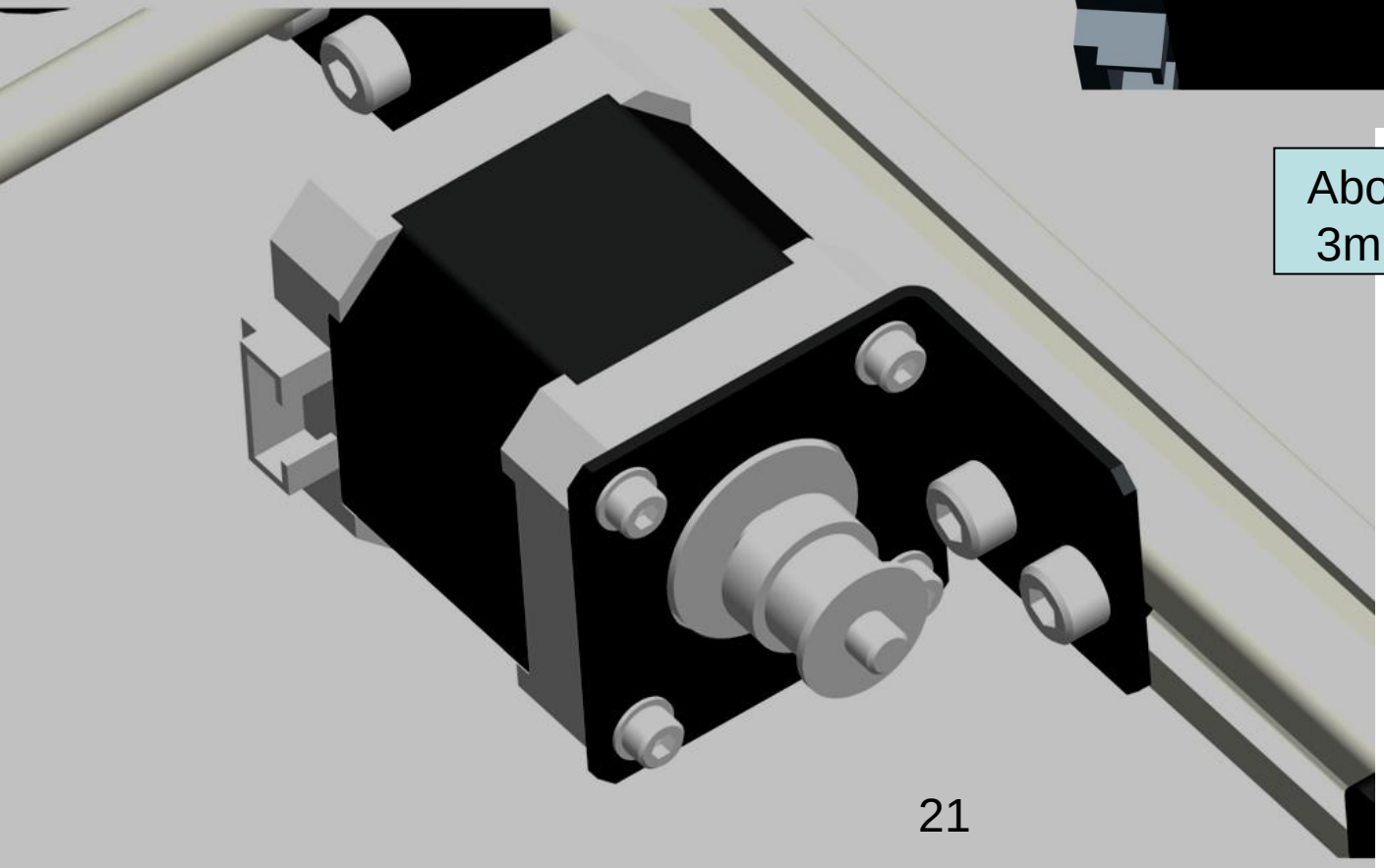
40mm motor	1pcs
M3*5	4pcs



Step 13

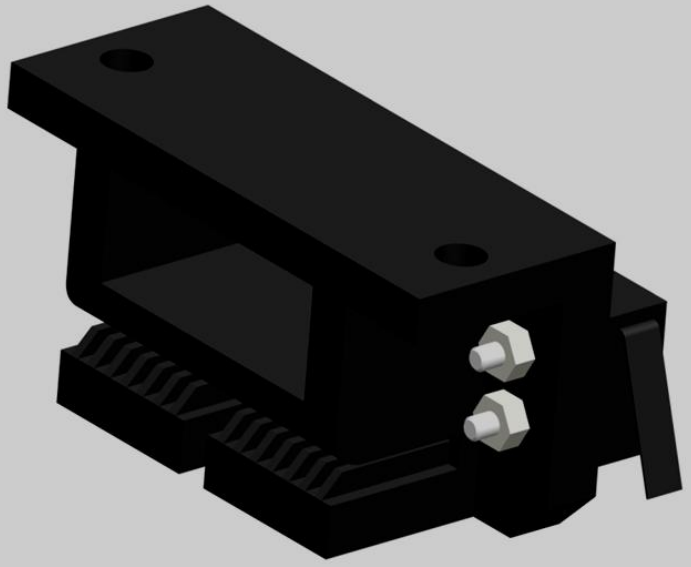
Synchronous belt pulley 1pcs

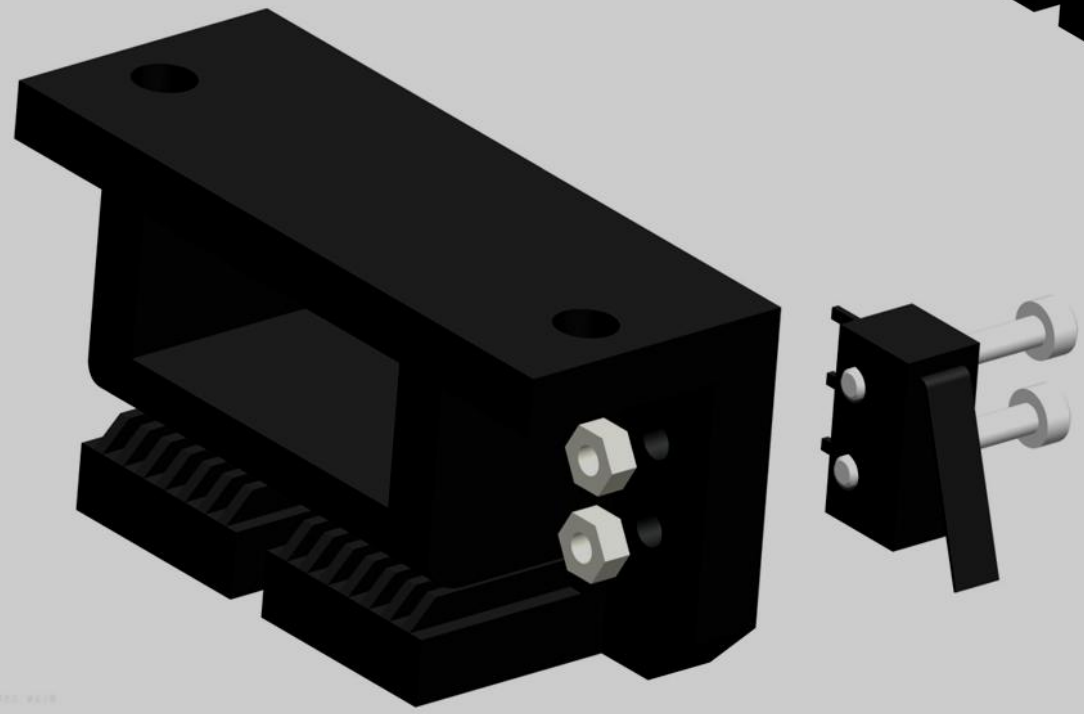




Step 14

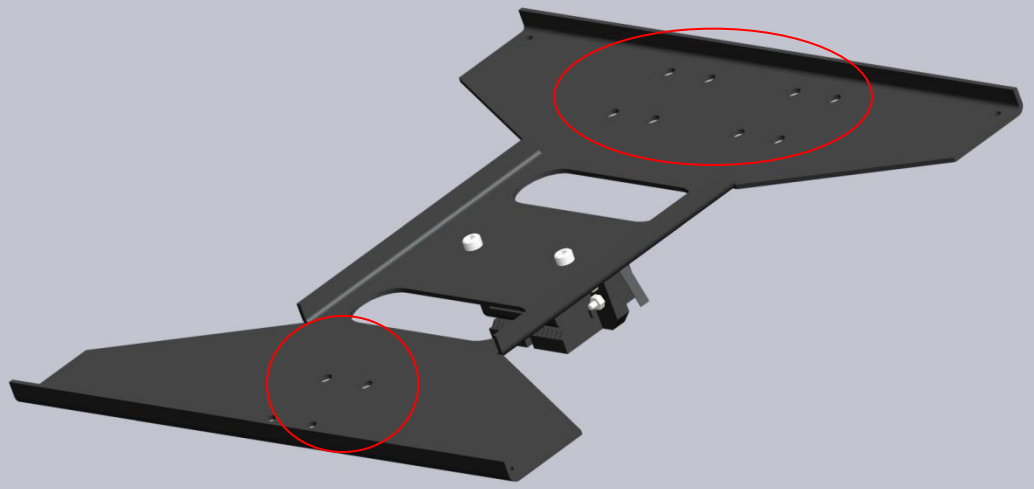
Endstop 1pcs
M2*16 2pcs
M2 nut 2pcs

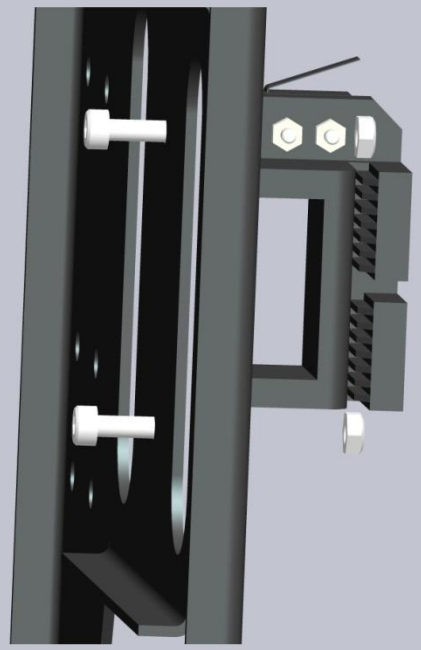




Step 15

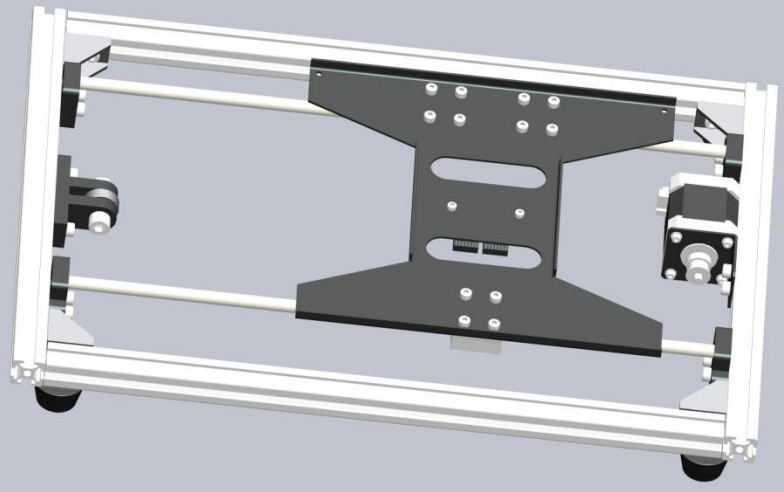
M3*10 2pcs
M3 nut 2pcs

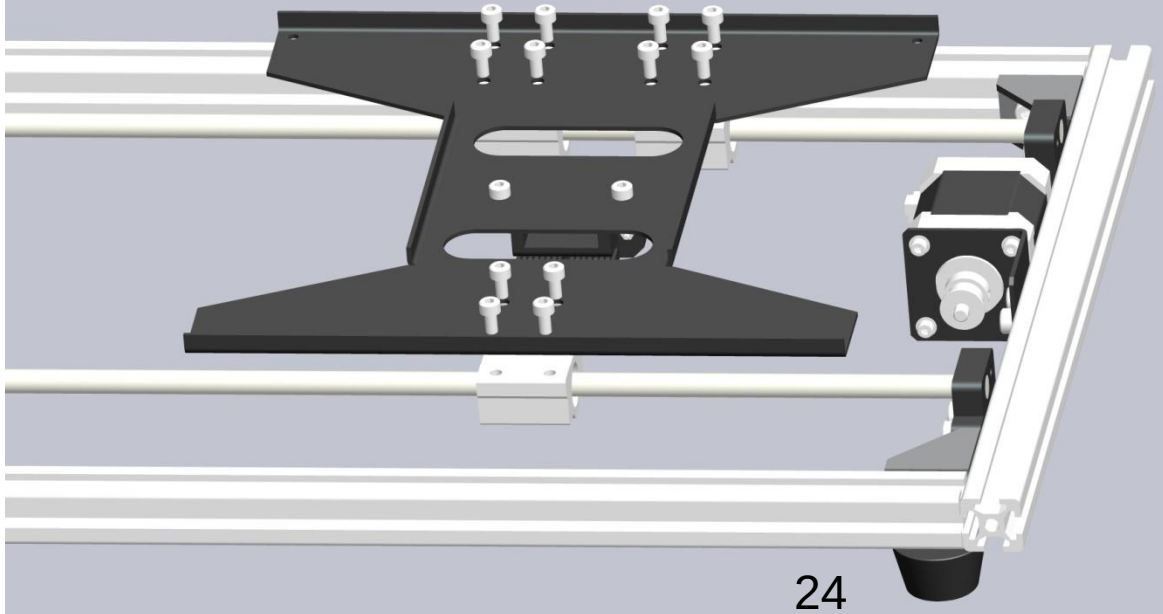




Step 16

M4*8 12pcs





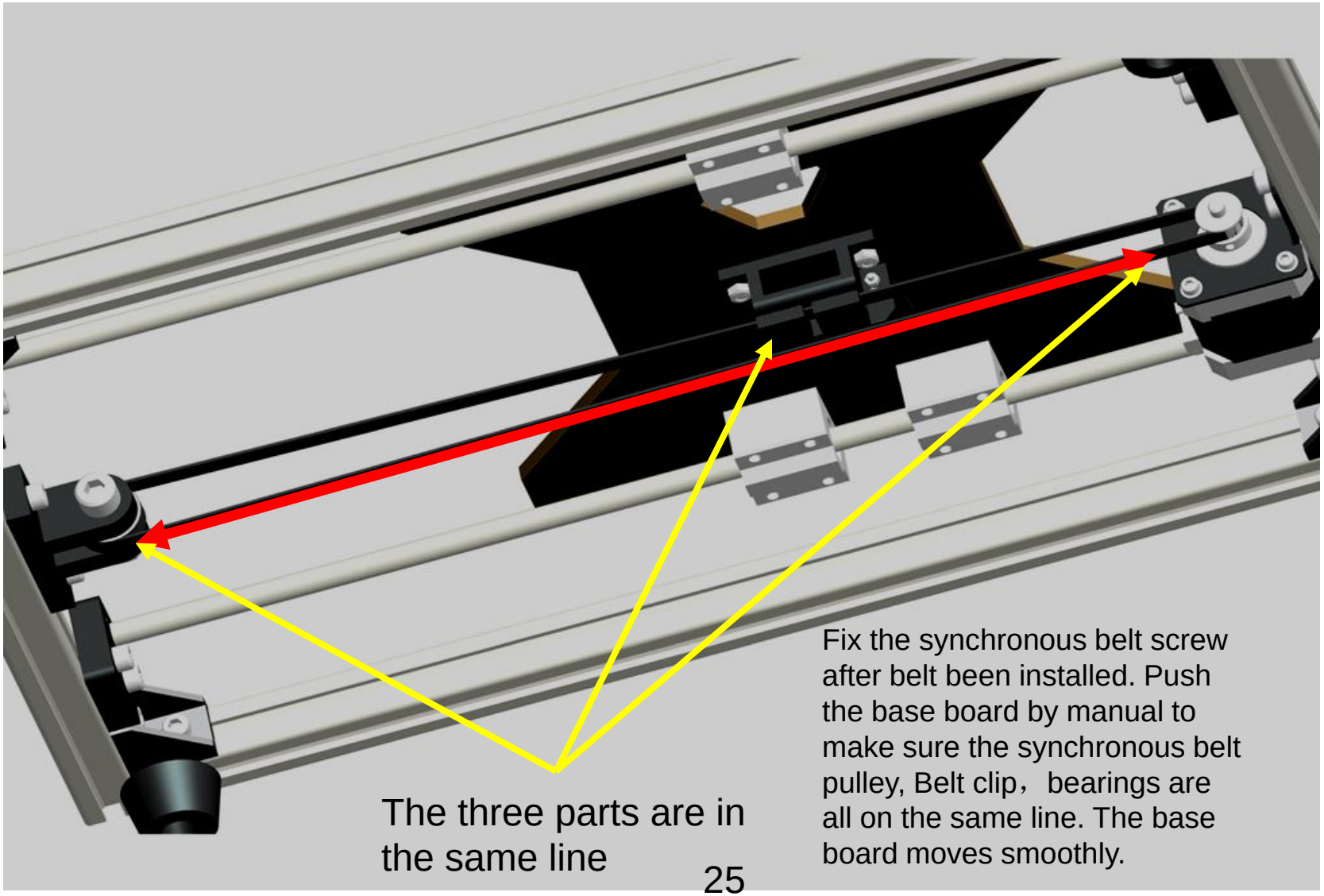
Pushing the acrylic base bo ard by manual backwards a nd forwards when building machine,fix all screws after it moves smoothly.You can adjust the acrylic parts'left a nd right position,which fix th e polished rods when neces sary.

Step 17

Synchronous belt is about 820mm.

The belt installation method is described in the belt installation section (please refer to that section)

https://www.youtube.com/channel/UC9Udtwu2QGX6iml-meV6s_w

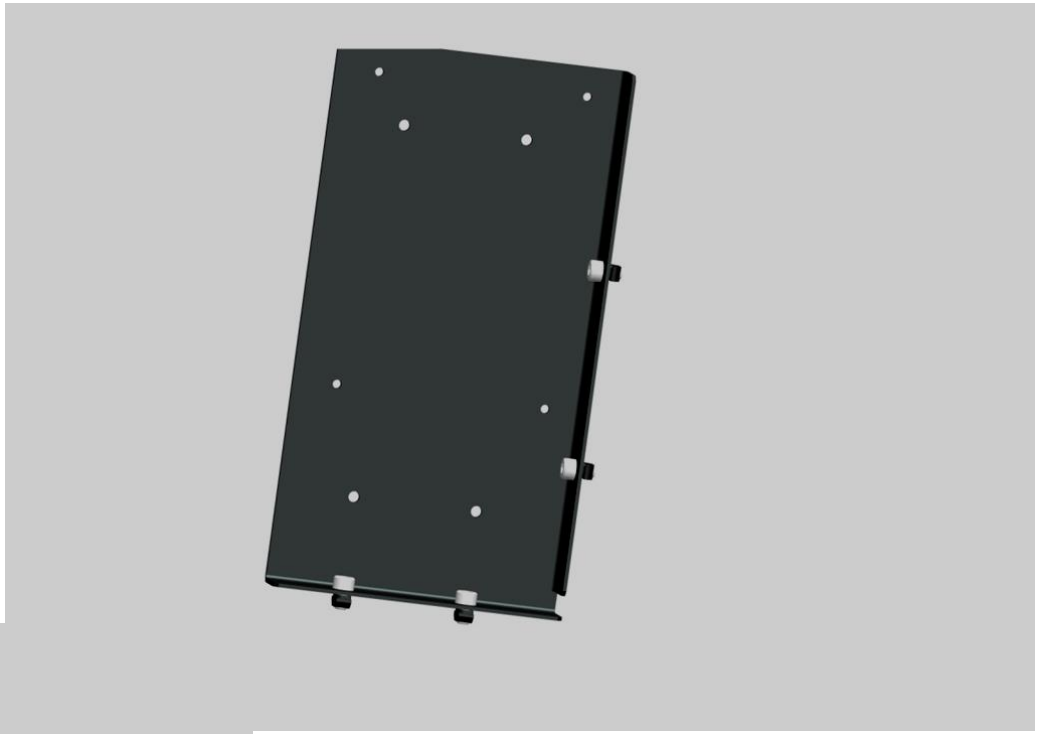


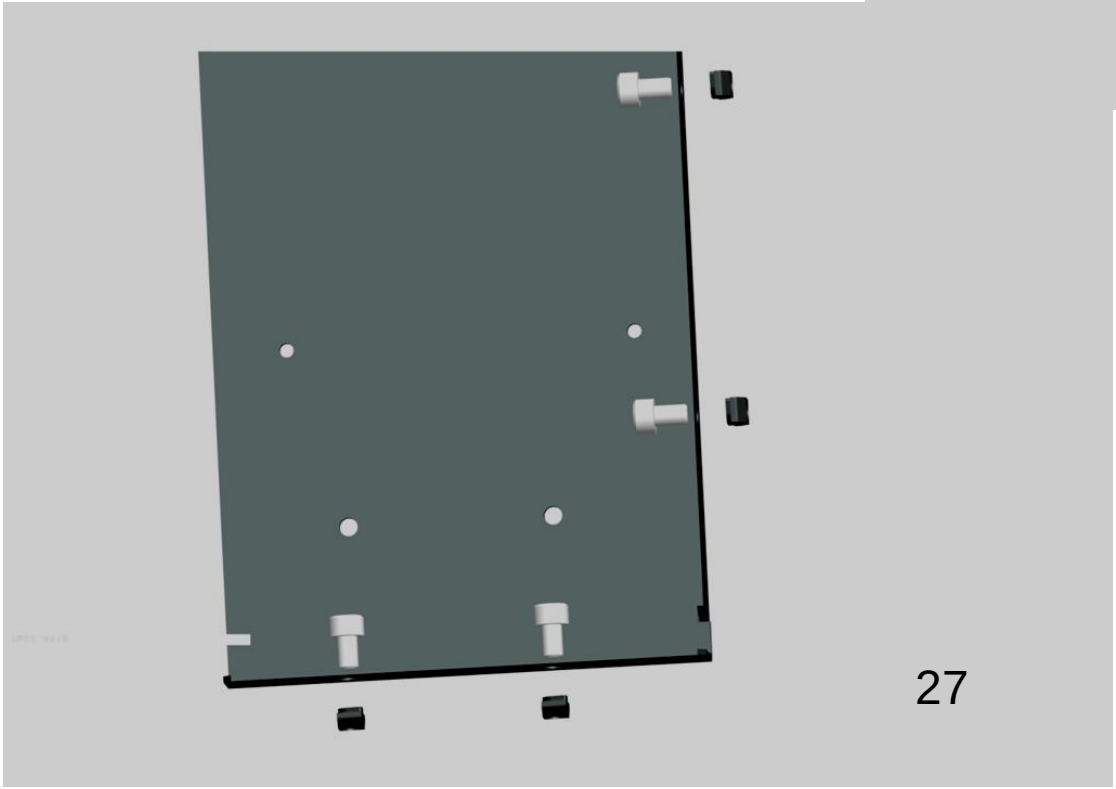
Z Axies Frame Assembly

Attention：
Aluminum Frame must be fixed well, not declining or loosen, otherwise, it will cause Z axies stuck.

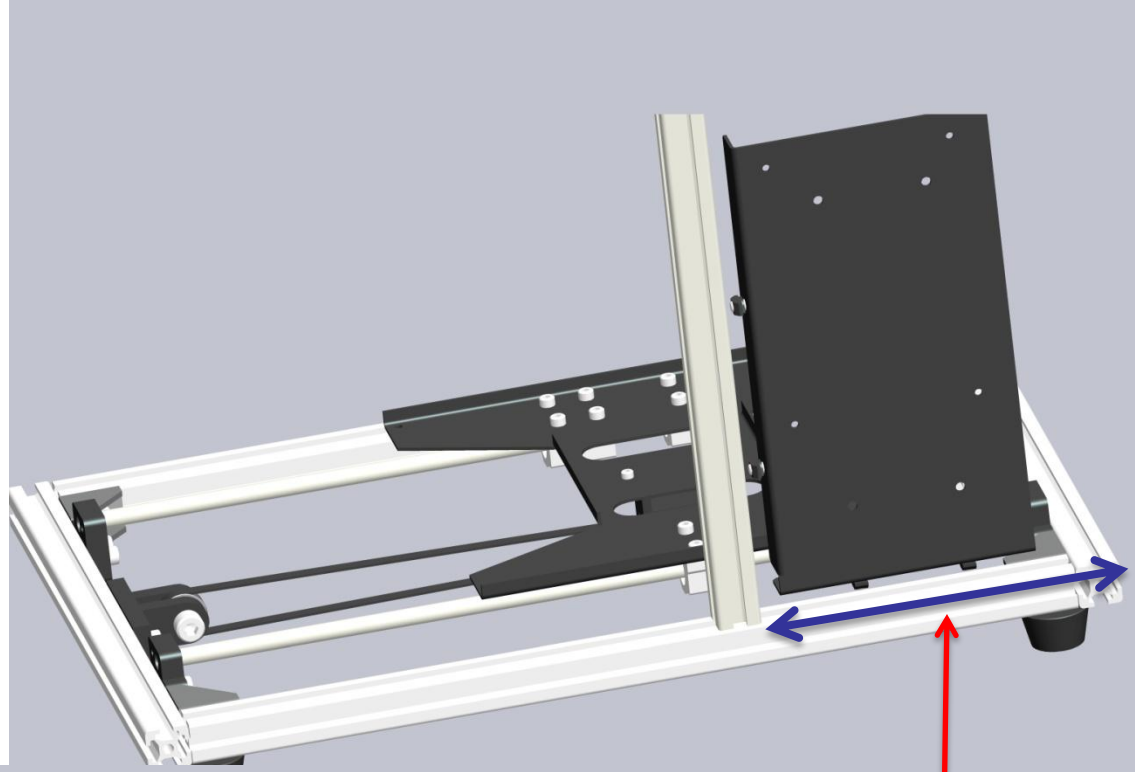
Step 18

M5*8 4pcs
M5 nut 4pcs



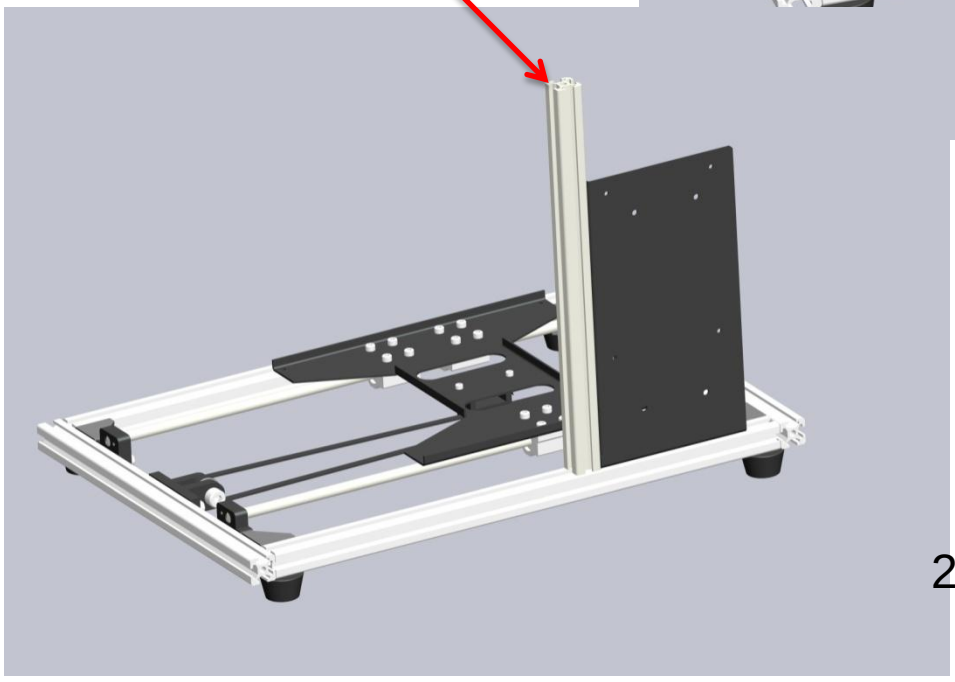


Step 19



About 165mm

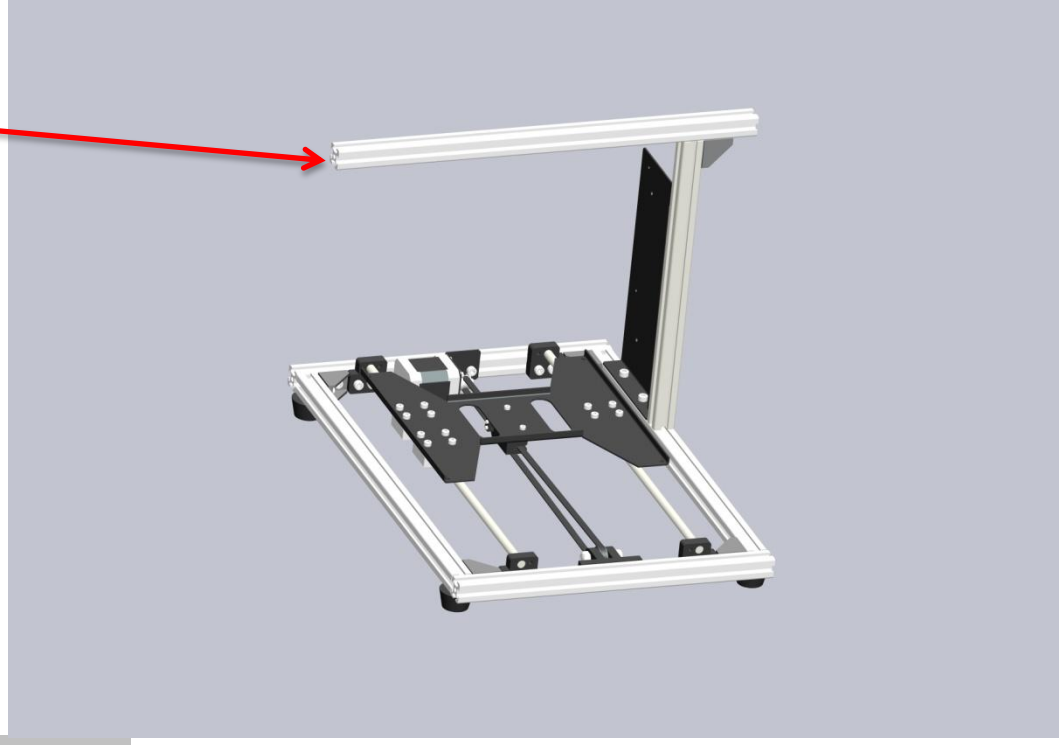
295mm long
aluminum frame

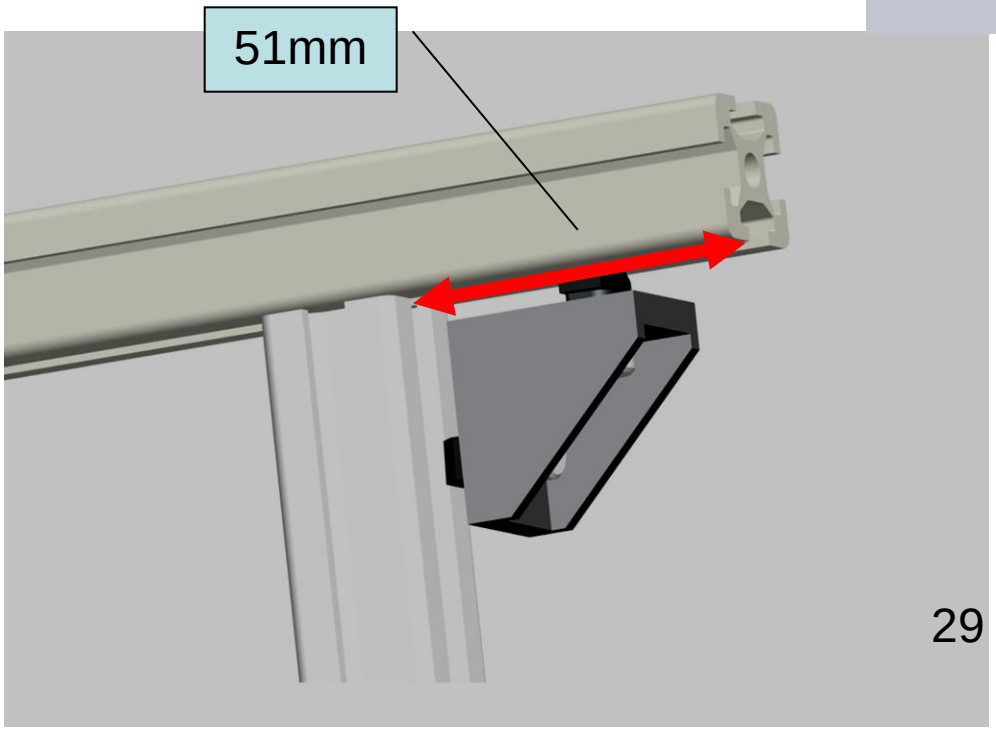


Step 20

M5*8 2pcs
M5 nut 2pcs

410mm long
aluminum frame

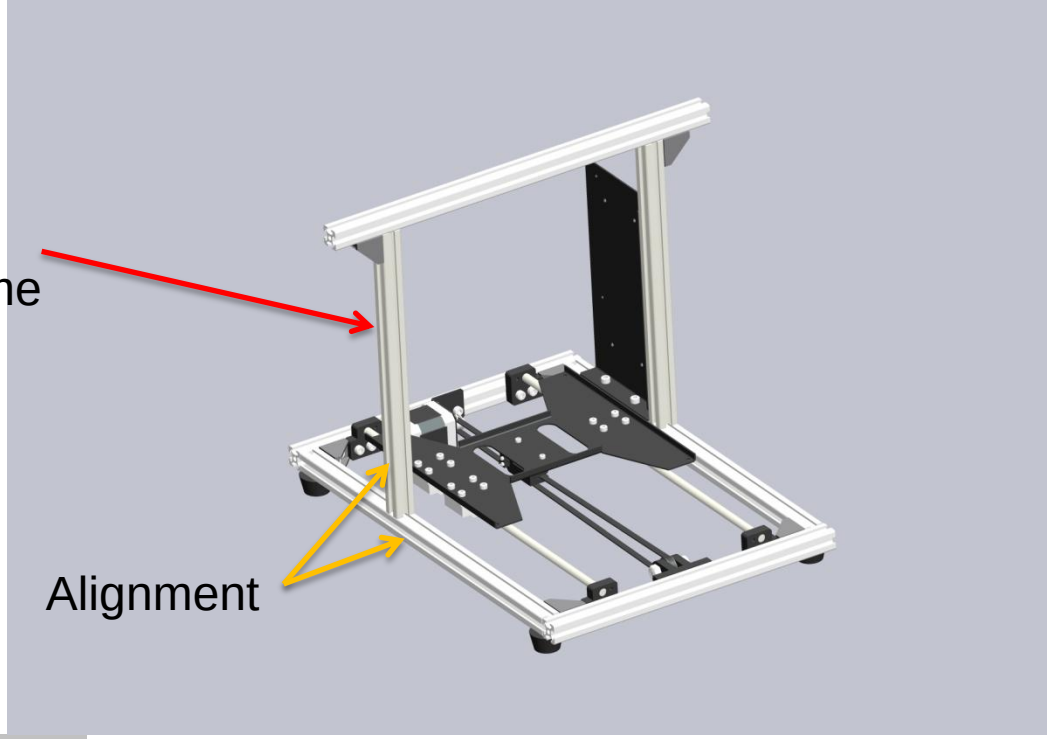




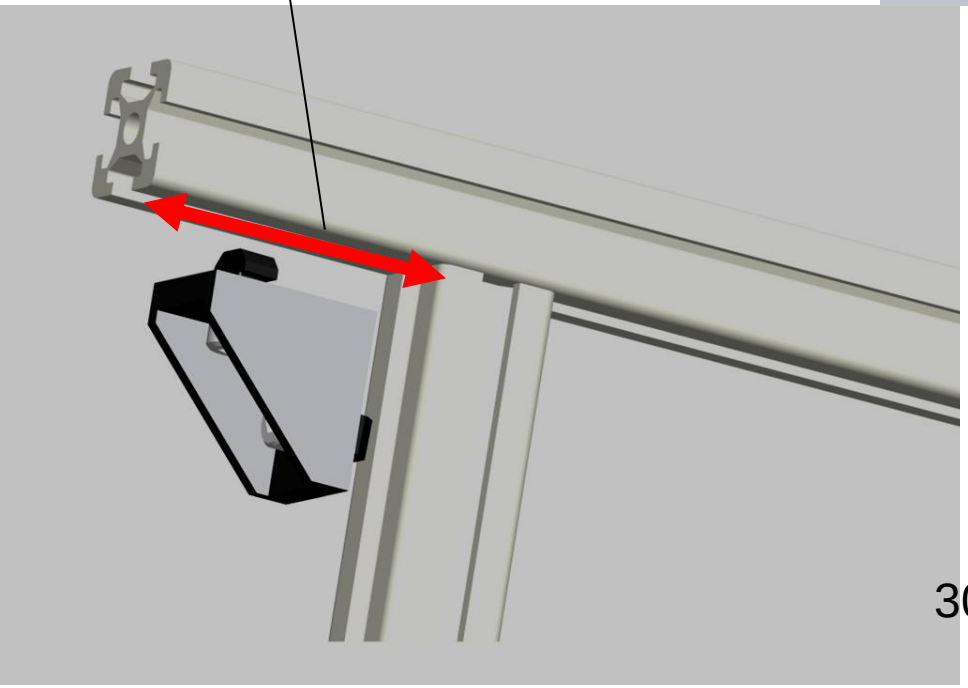
Step 21

M5*8 2pcs
M5 nut 2pcs

295mm long
aluminum frame

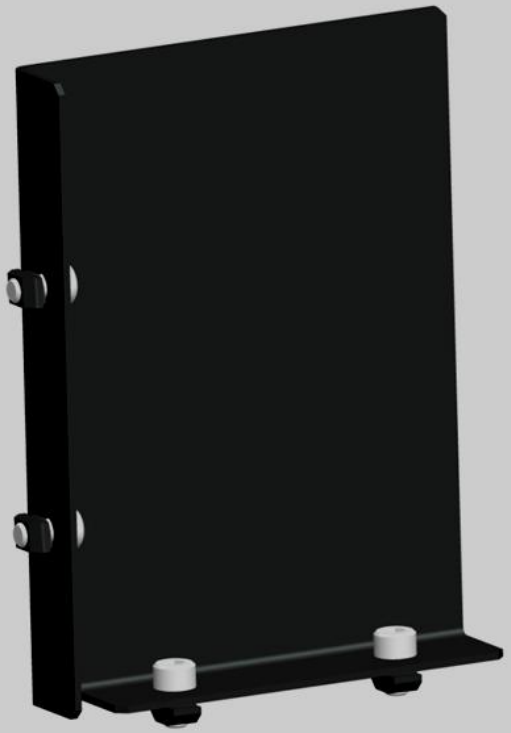


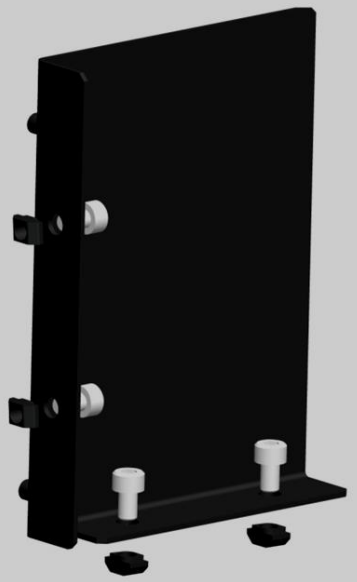
51mm



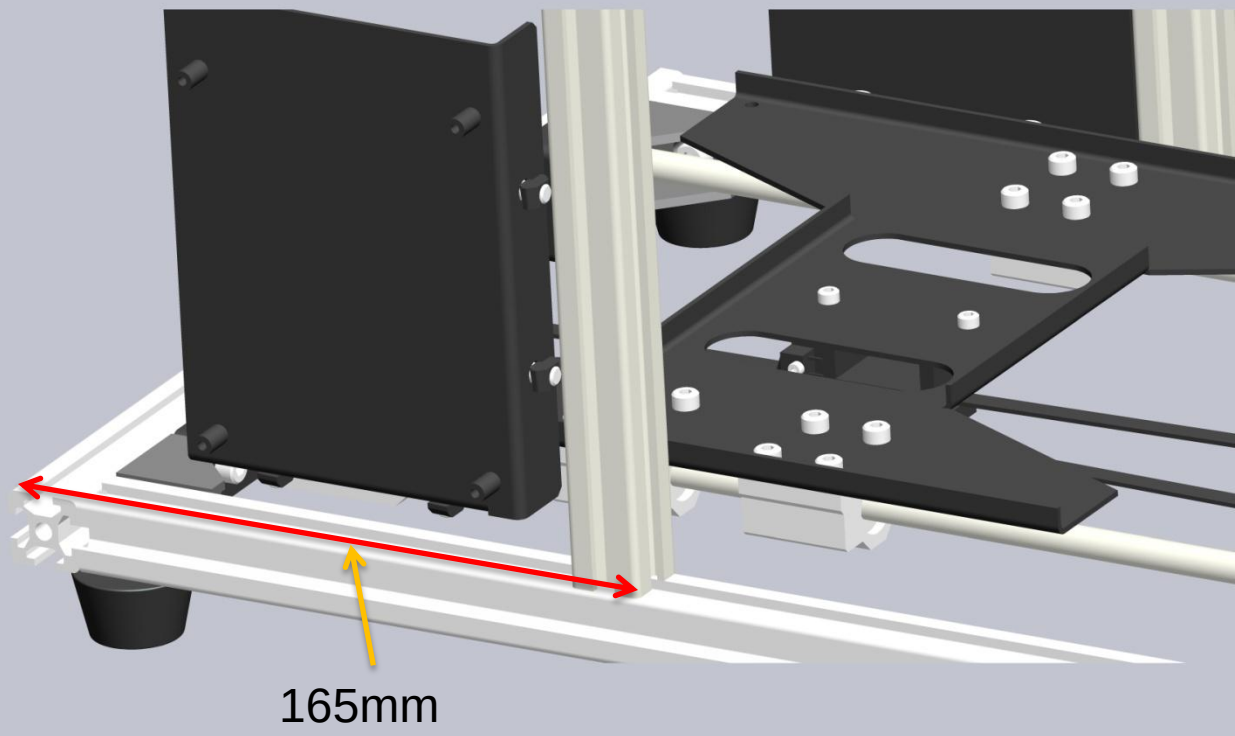
Step 22

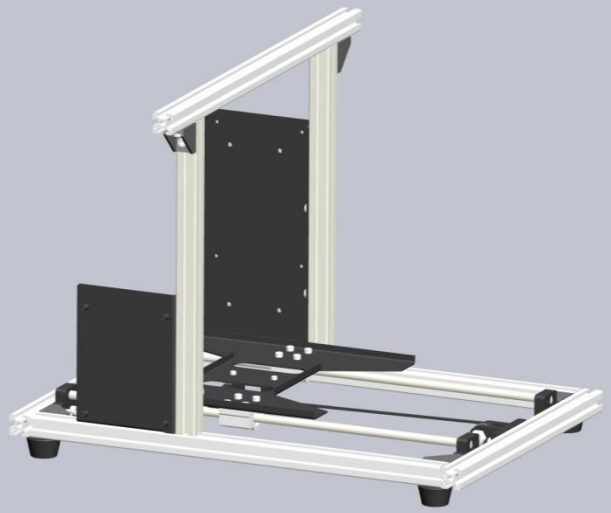
M5*8 4pcs
M5 nut 4pcs





Step 23



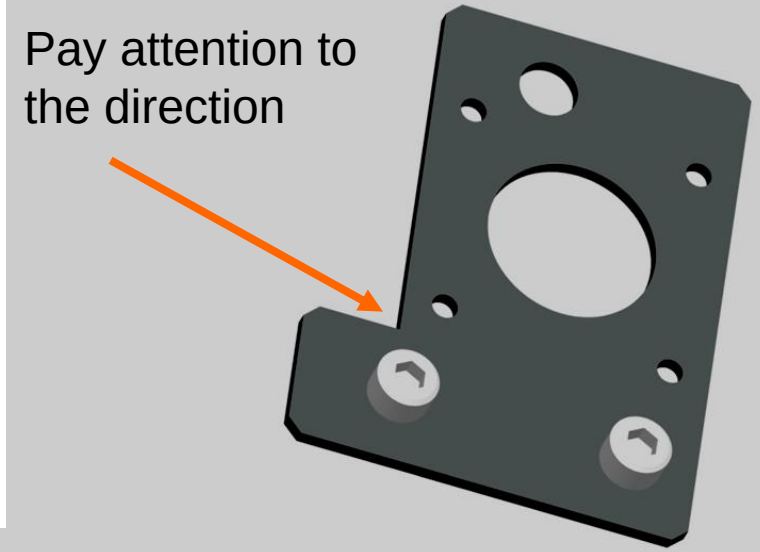


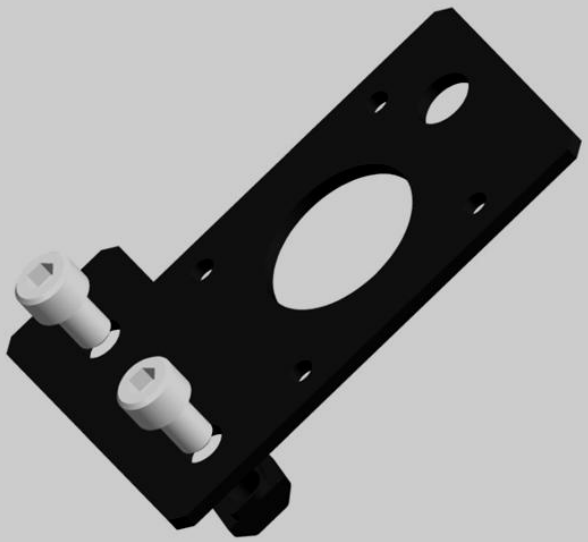
32

Step 24

M5*8 2pcs
M5 nut 2pcs

Pay attention to the direction

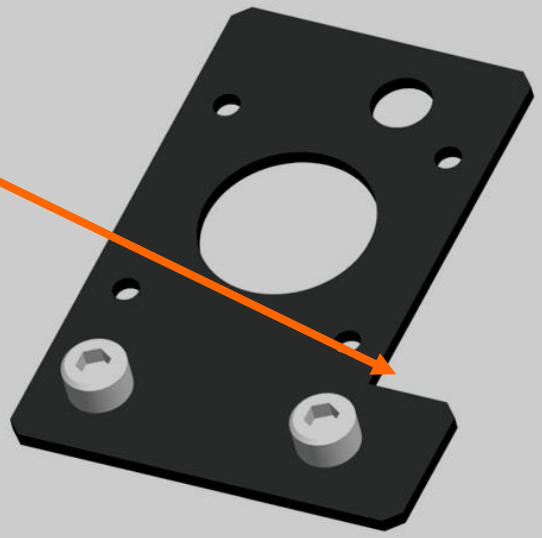


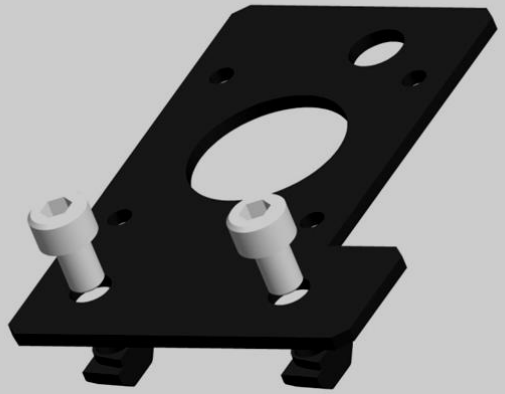


Step 25

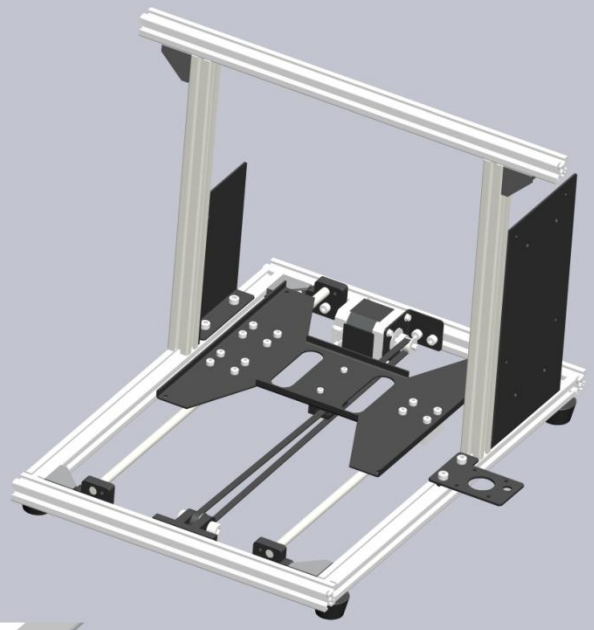
M5*8 2pcs
M5 nut 2pcs

Pay attention
to direction

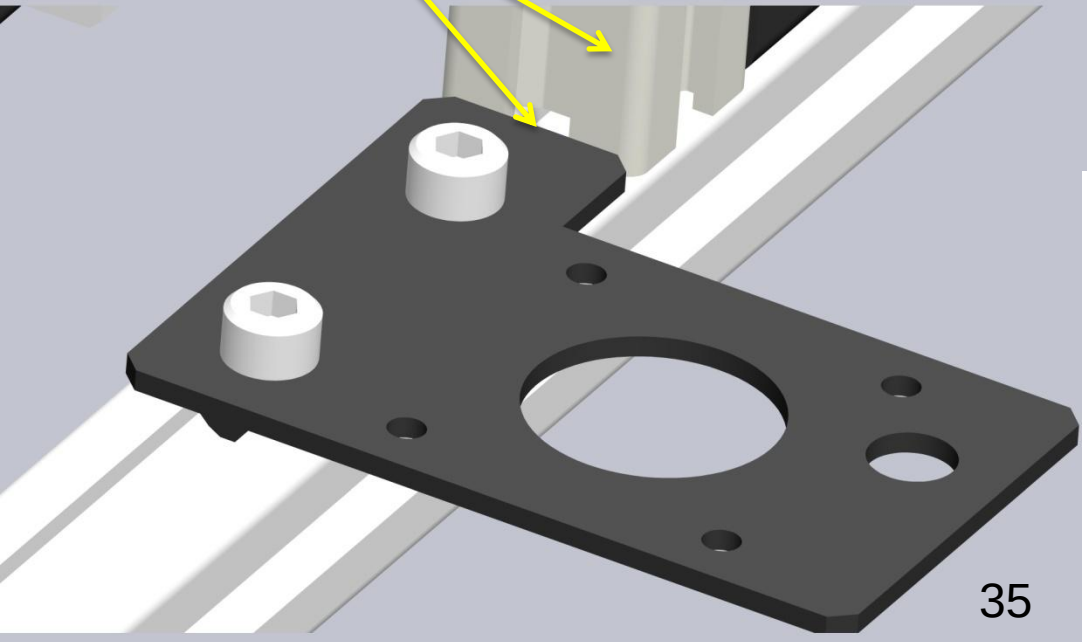




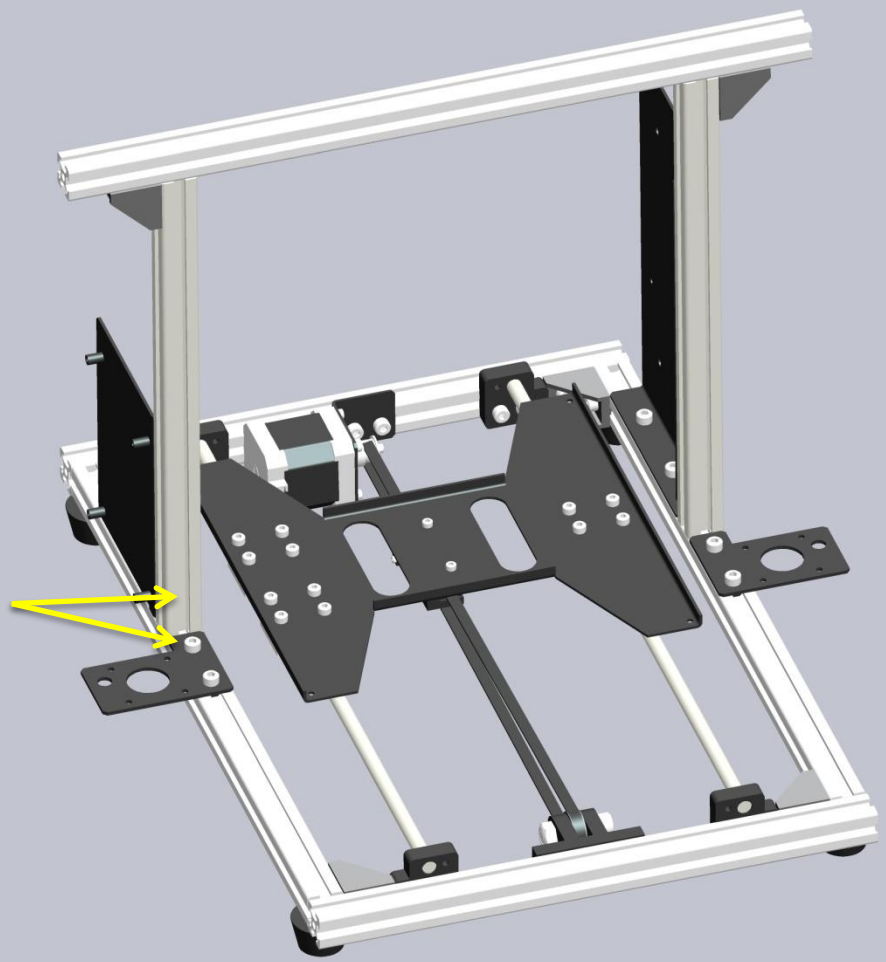
Step 26



Alignment



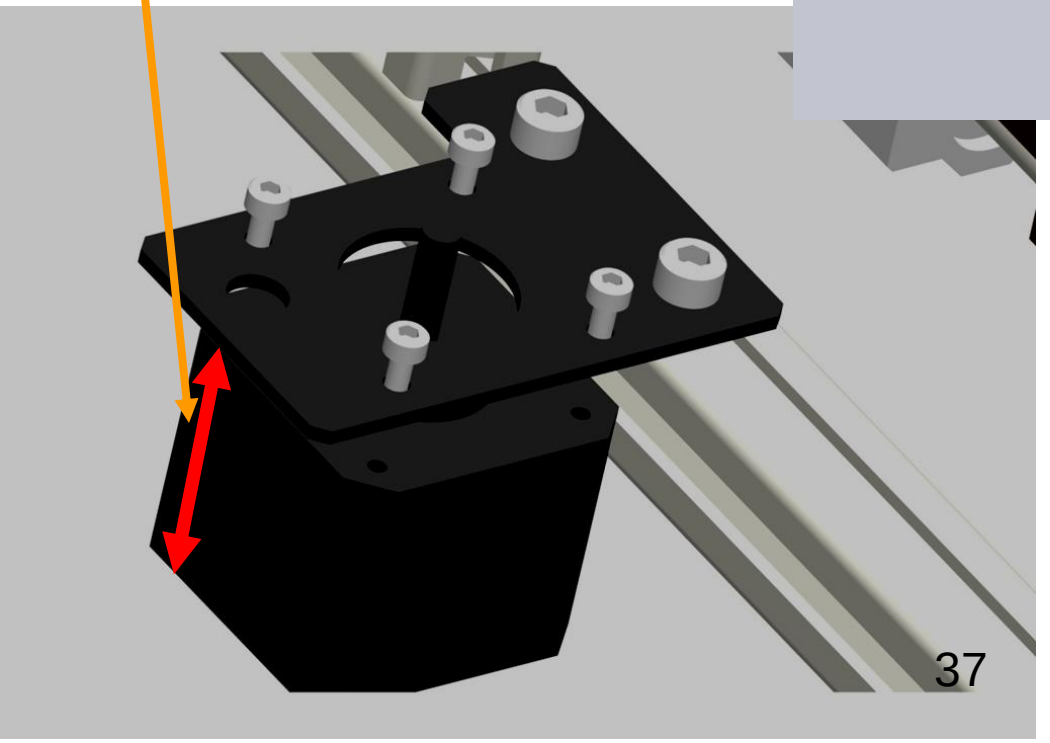
Step 27



Step 28

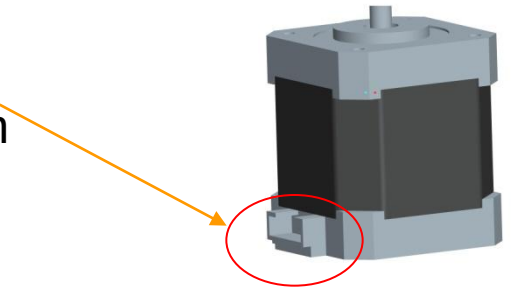
M3*5 4pcs
34mm motor 1pcs

34mm long



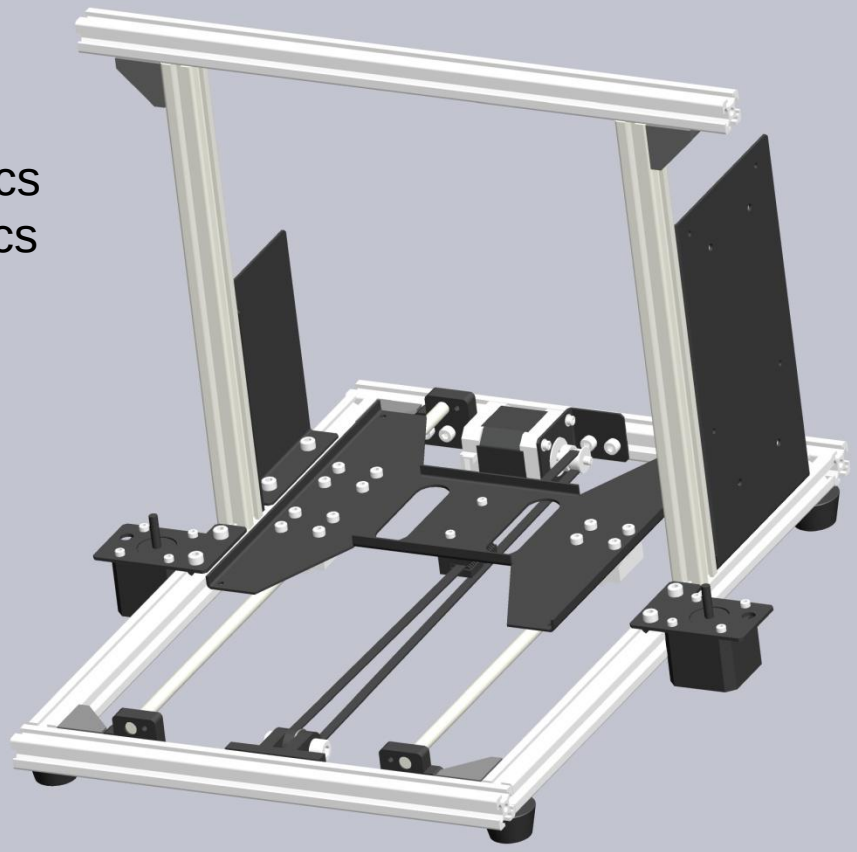
For your attention: please find that the motor terminal faces backwards

Wire connection port



Step 29

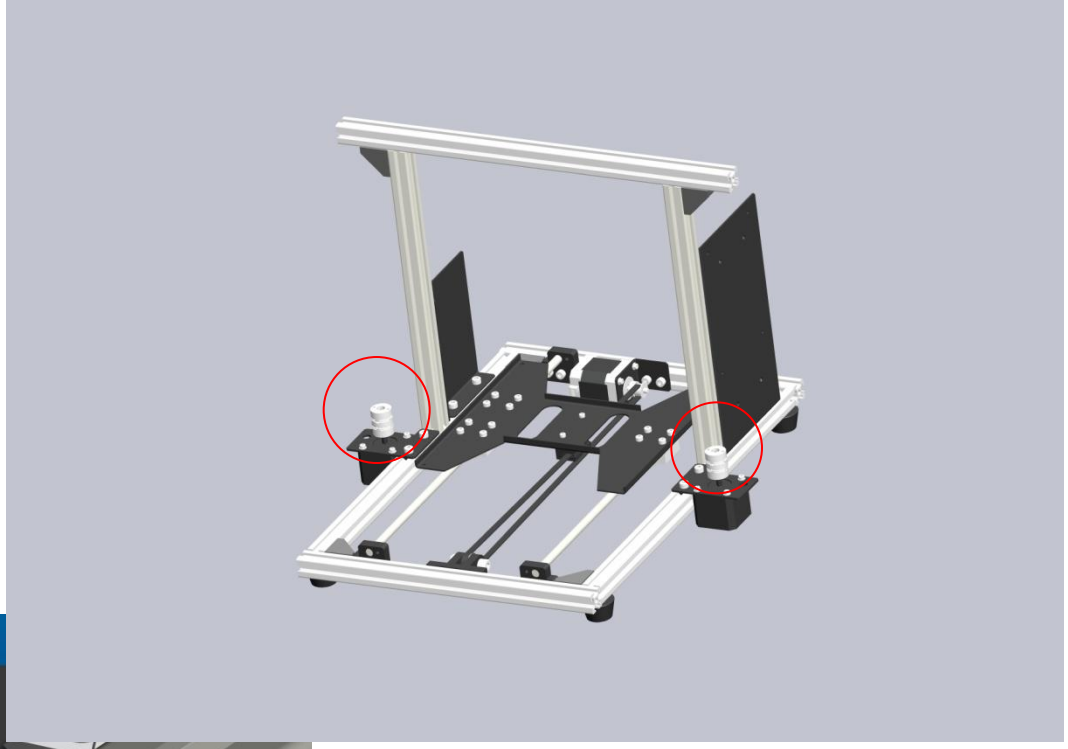
M3*5	4pcs
34mm motor	1pcs

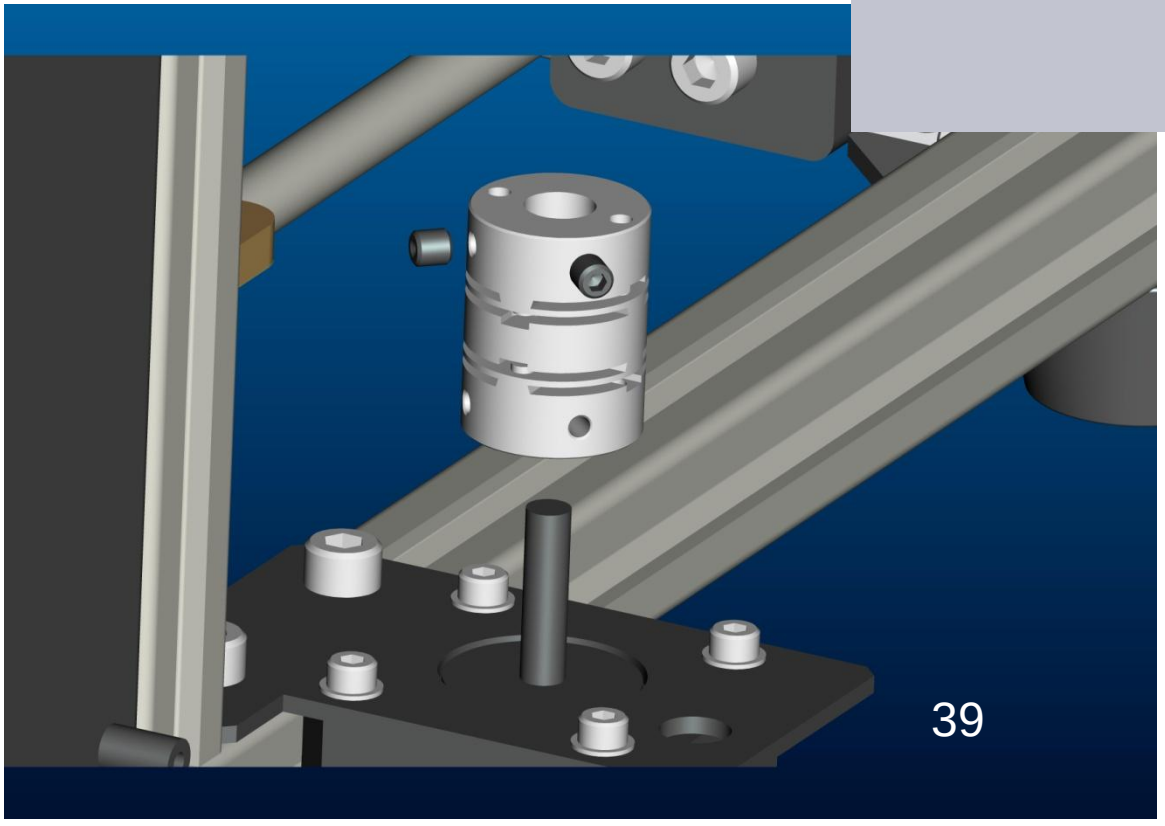


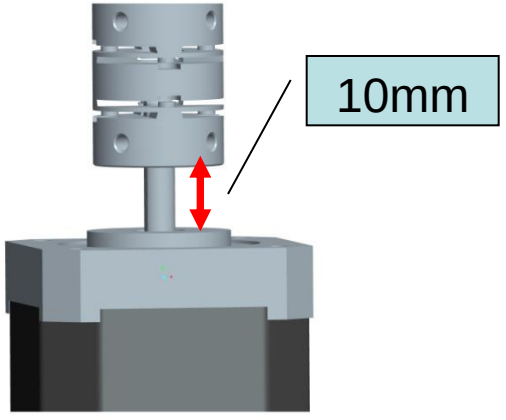
For your attention: please find that the motor terminal faces backwards

Step 30

Coupling 2pcs



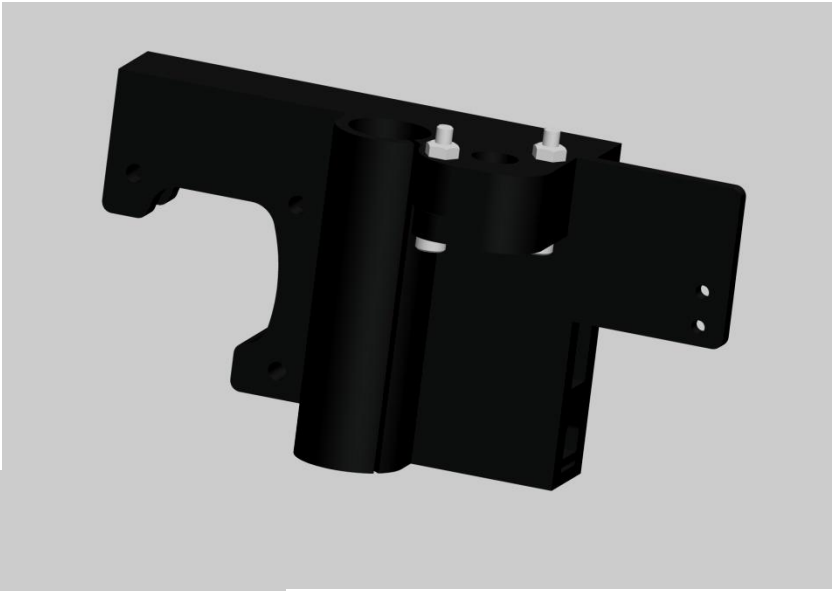


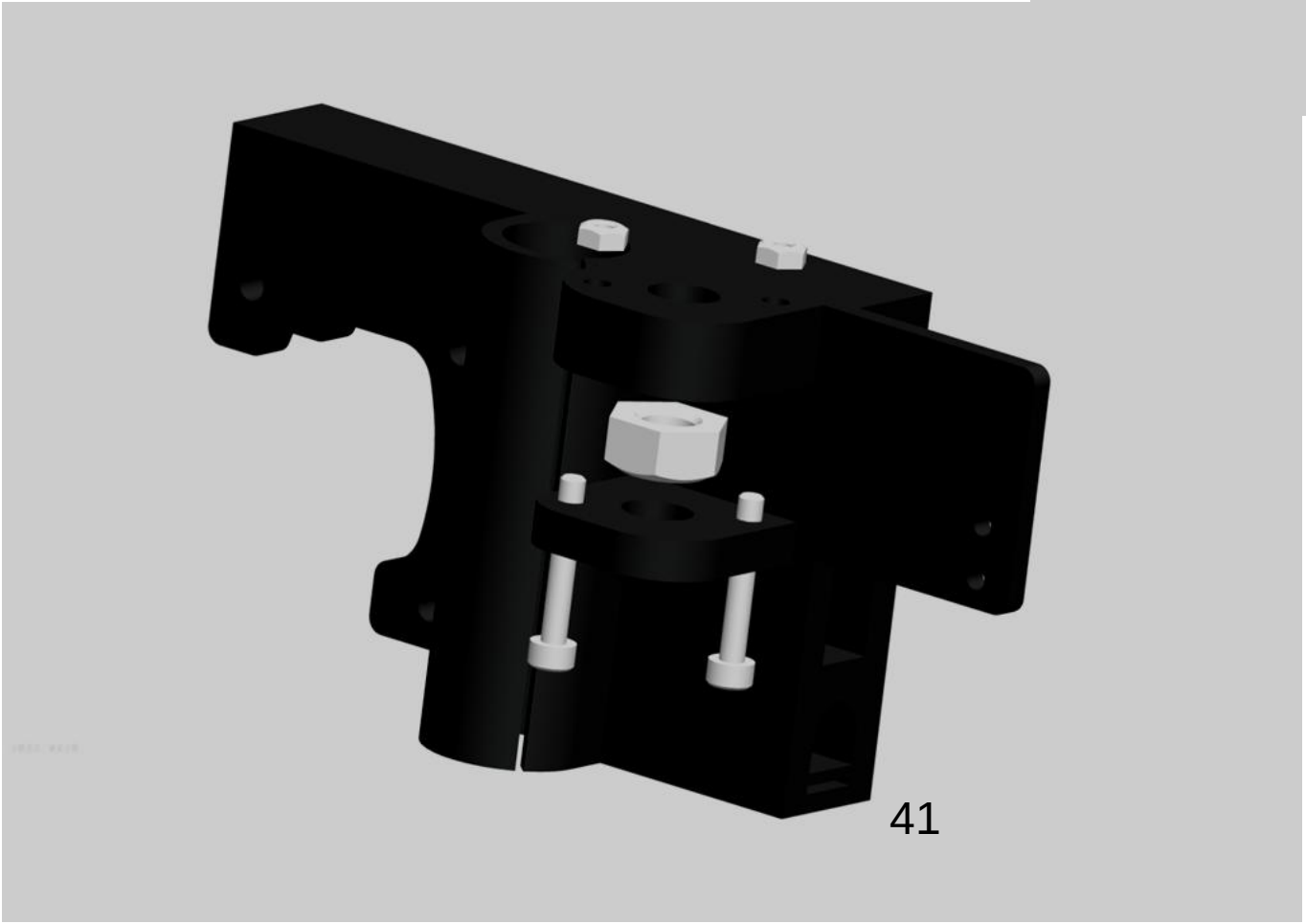


X Axies Assembly

Step 31

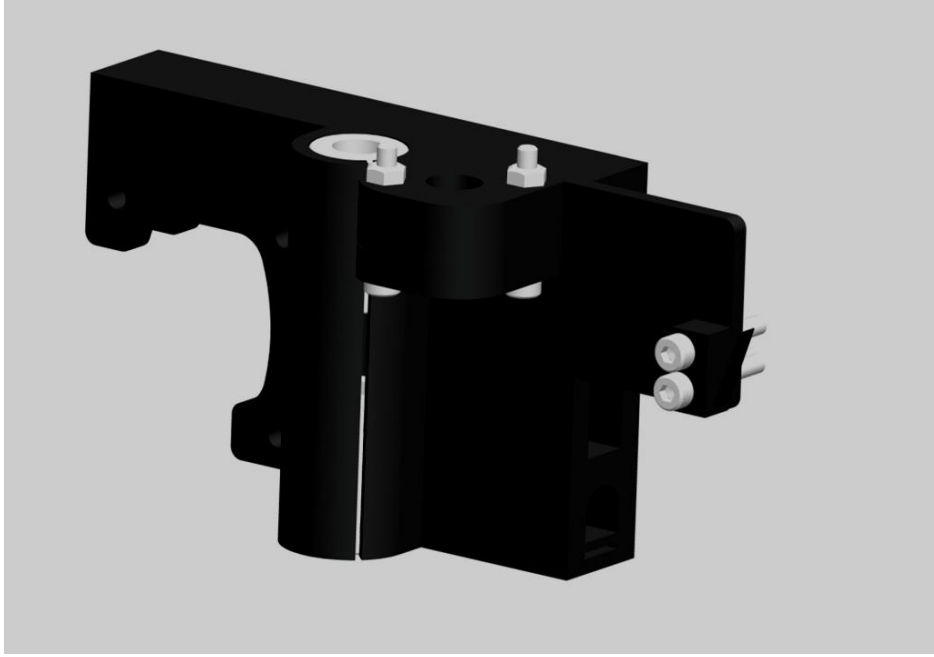
M8 nut	1pcs
M3*16	2pcs
M3 nut	2pcs

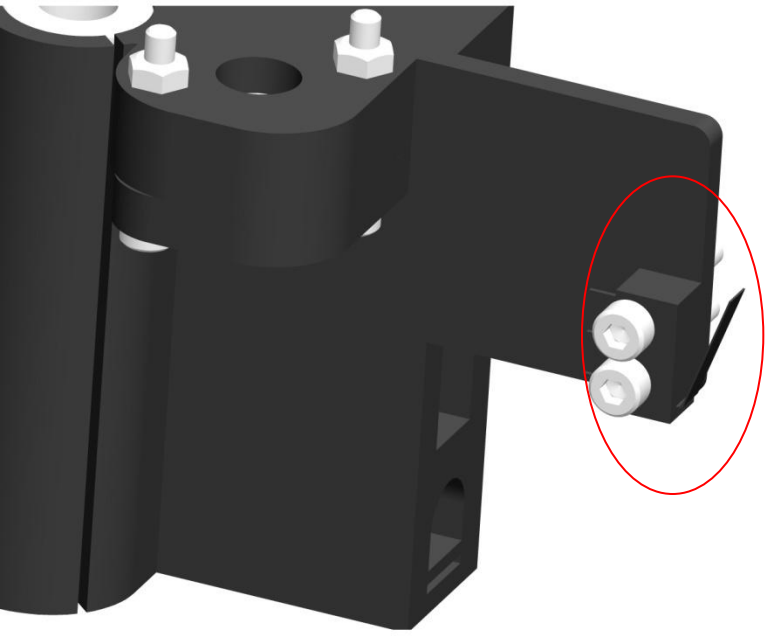




Step 32

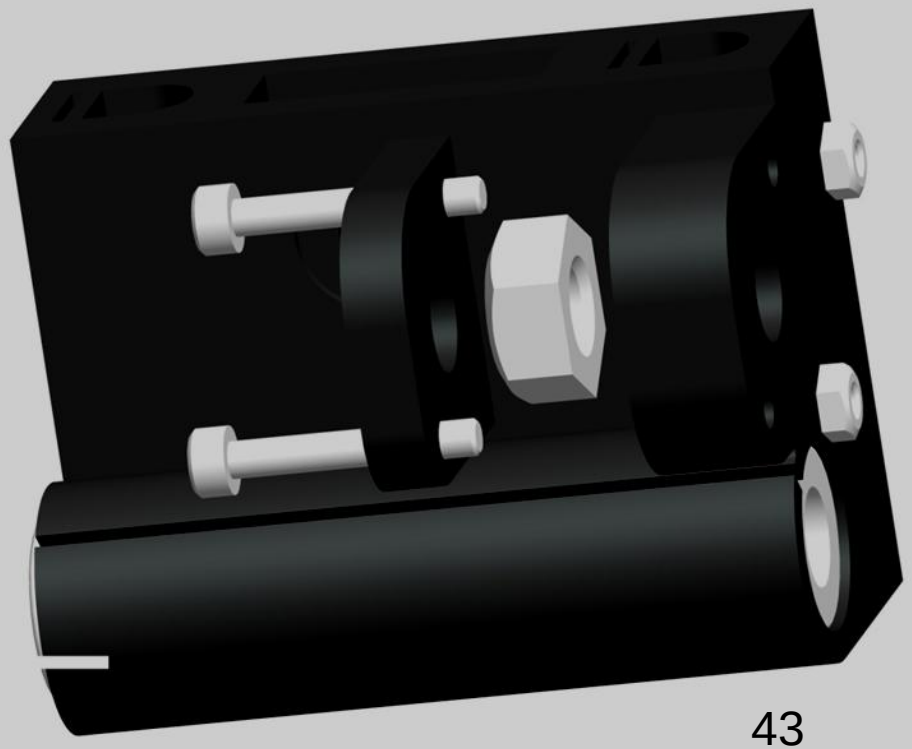
Endstop 1pcs
M2*16 2pcs
M2 nut 2pcs





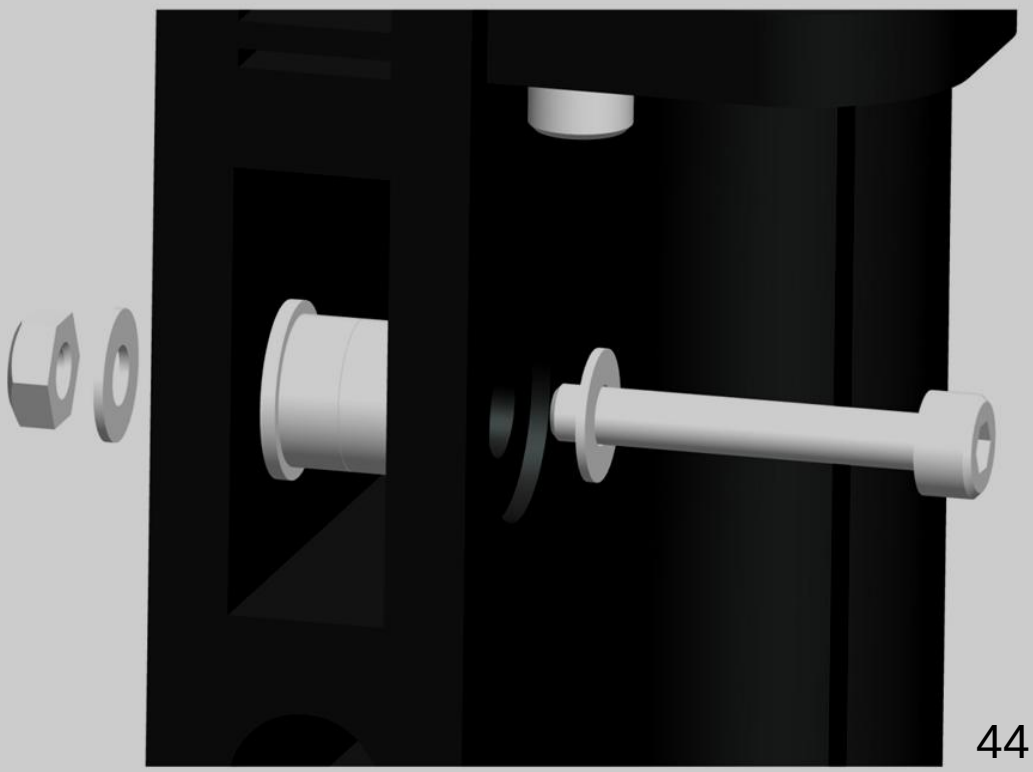
Step 33

M8 nut 1pcs
M3*16 2pcs
M3 nut 2pcs



Step 34

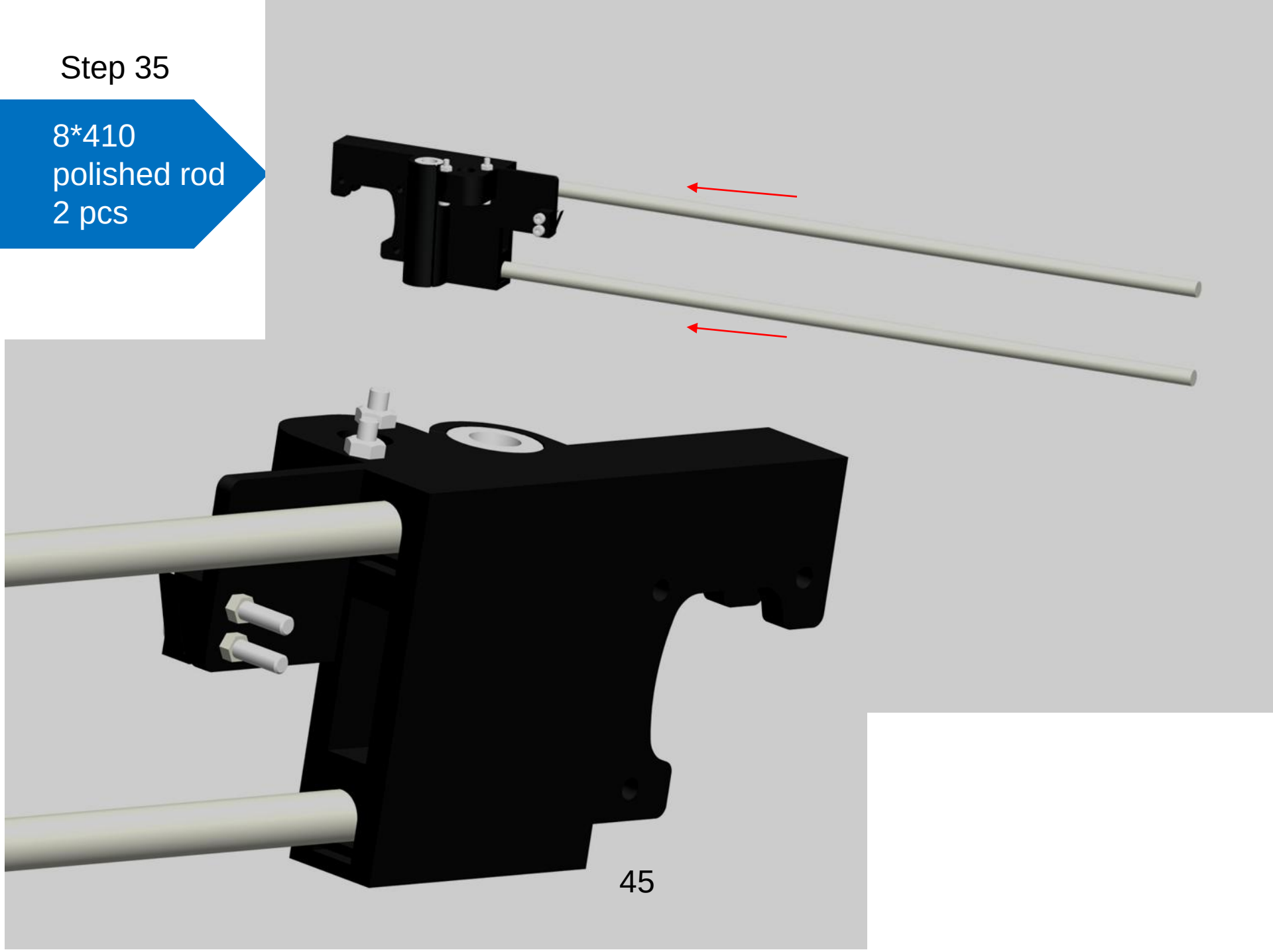
Bearing	2pcs
M3*20	1pcs
M3 nut	1pcs
M3 filler piece	2pcs



For your attention, M3 screw cannot be fix too tight, making sure the bearings turns smoothly

Step 35

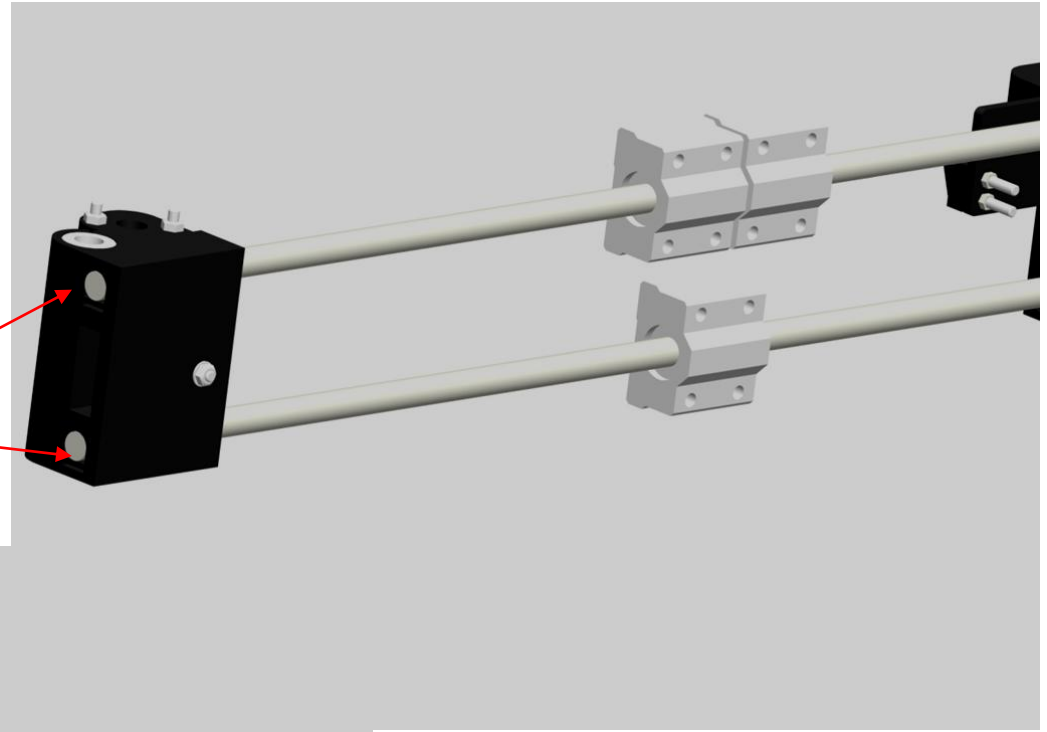
8*410
polished rod
2 pcs

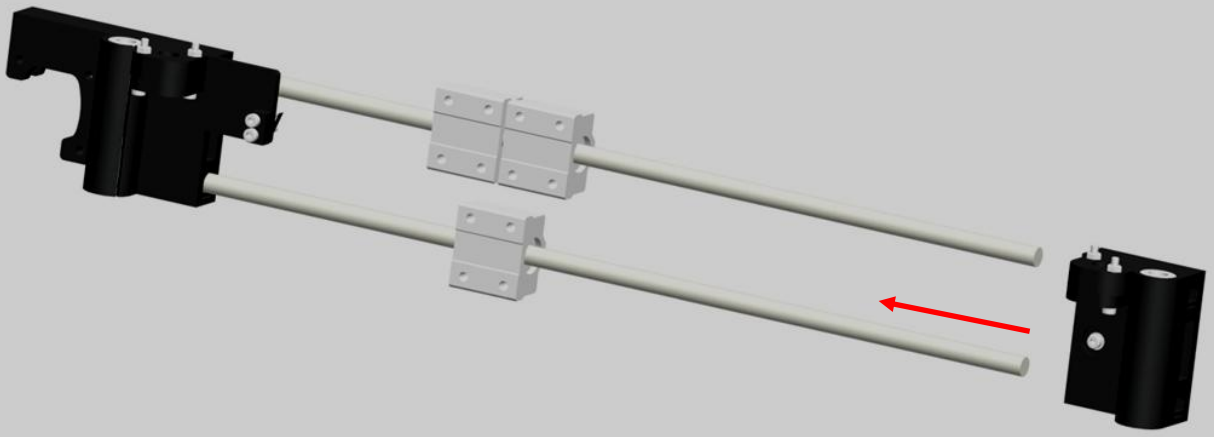


Step 36

Box type liner bearing 3pcs

Polished rods are align with printed part





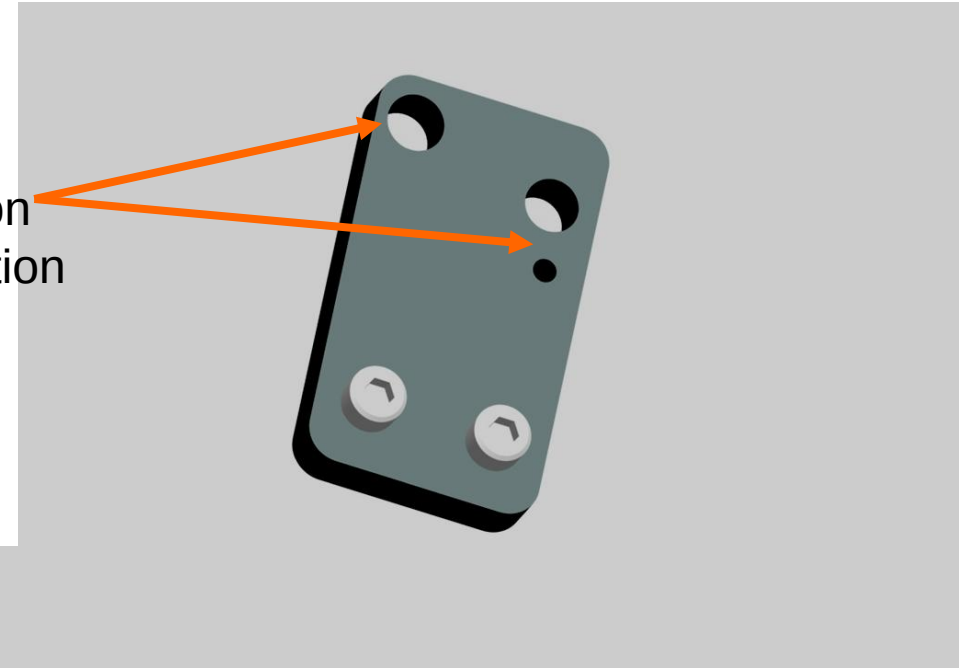
Z axies Assembly

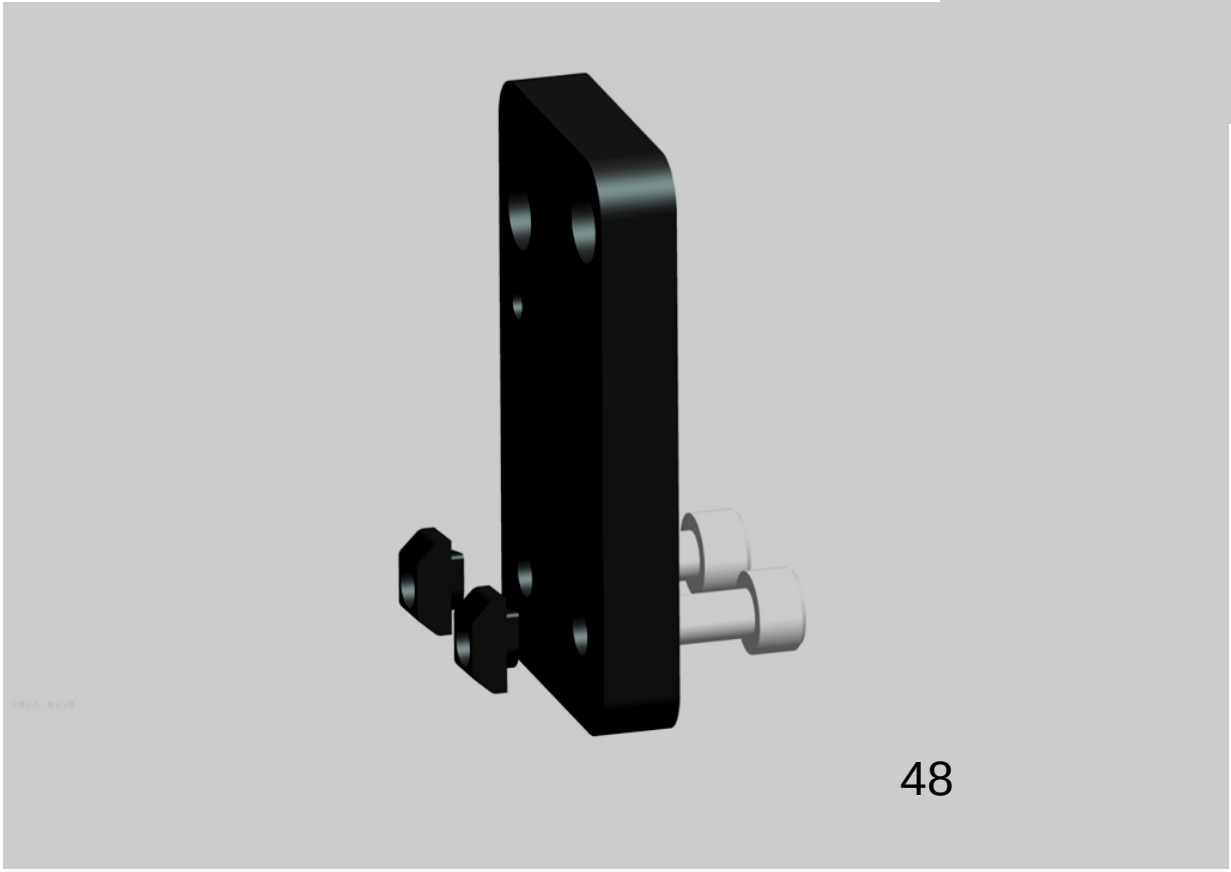
Attention：
1. Make sure X axies moves smoothly before assembling Z axies screw rods.
2. Make sure X axies is level, not gradient when you assemble screw rods. Otherwise, the Z axies will be stuck.
3.The screw must be fixed on the coupling，otherwise, the X axies will be gradient and Z aixes stuck.
4. After finishing assembly, please rotate the screw rods to the same direction by hands, make sure they move smoothly, no stuck, then power it and adjust.

Step 37

M5*12 2pcs
M5 nut 2pcs

Pay attention
to the direction

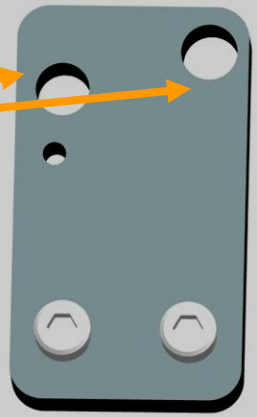


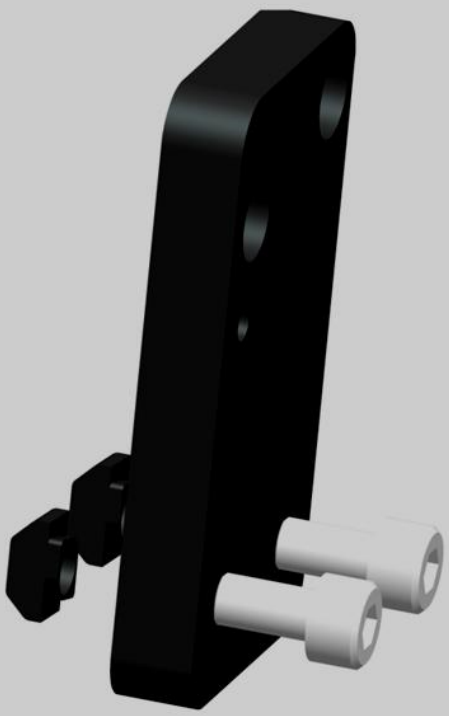


Step 38

M5*12 2pcs
M5 nut 2pcs

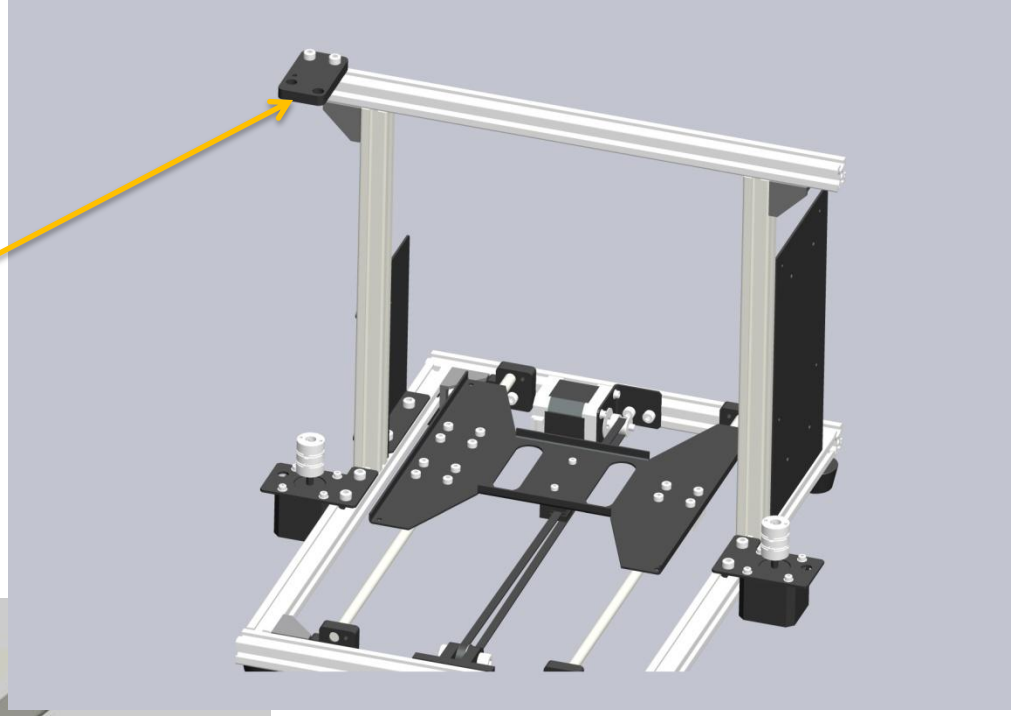
Pay attention to the direction

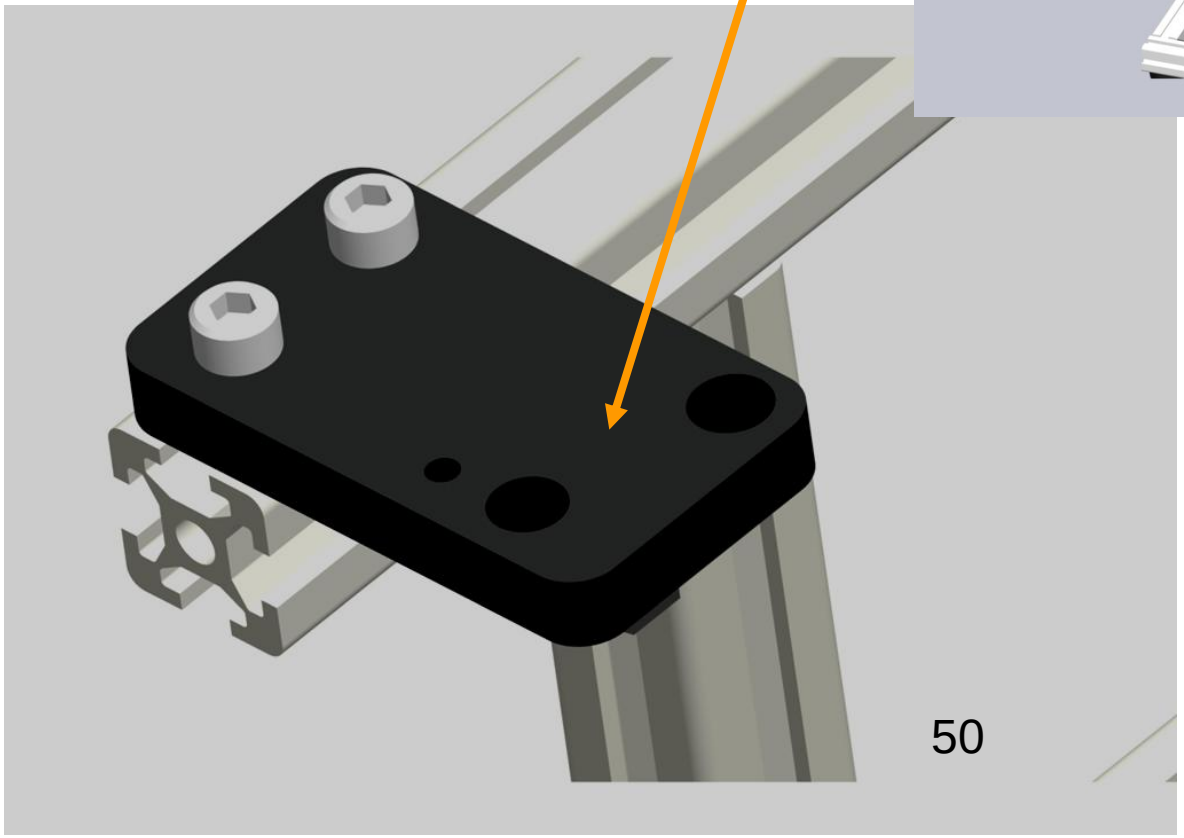




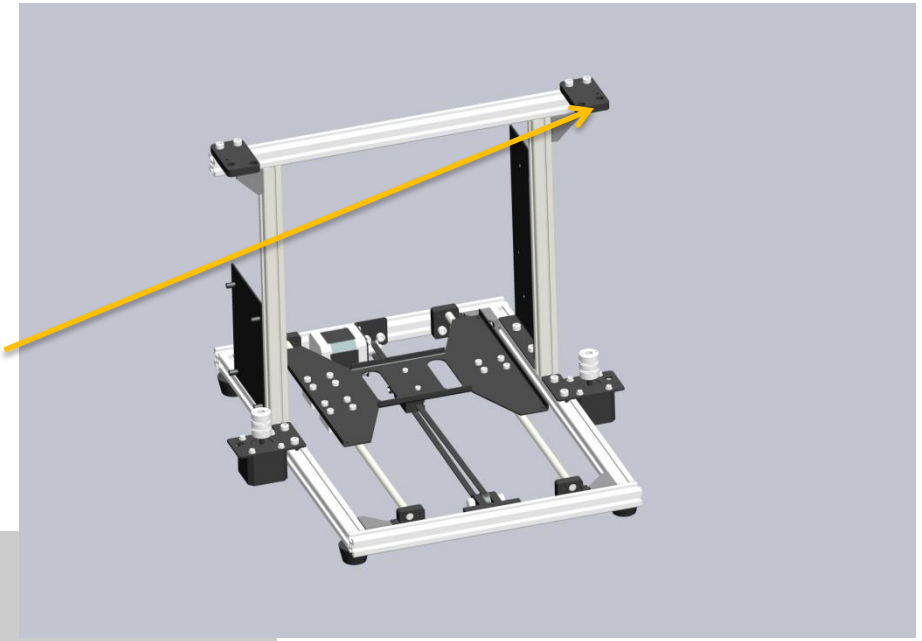
Step 39

Pay attention to the direction

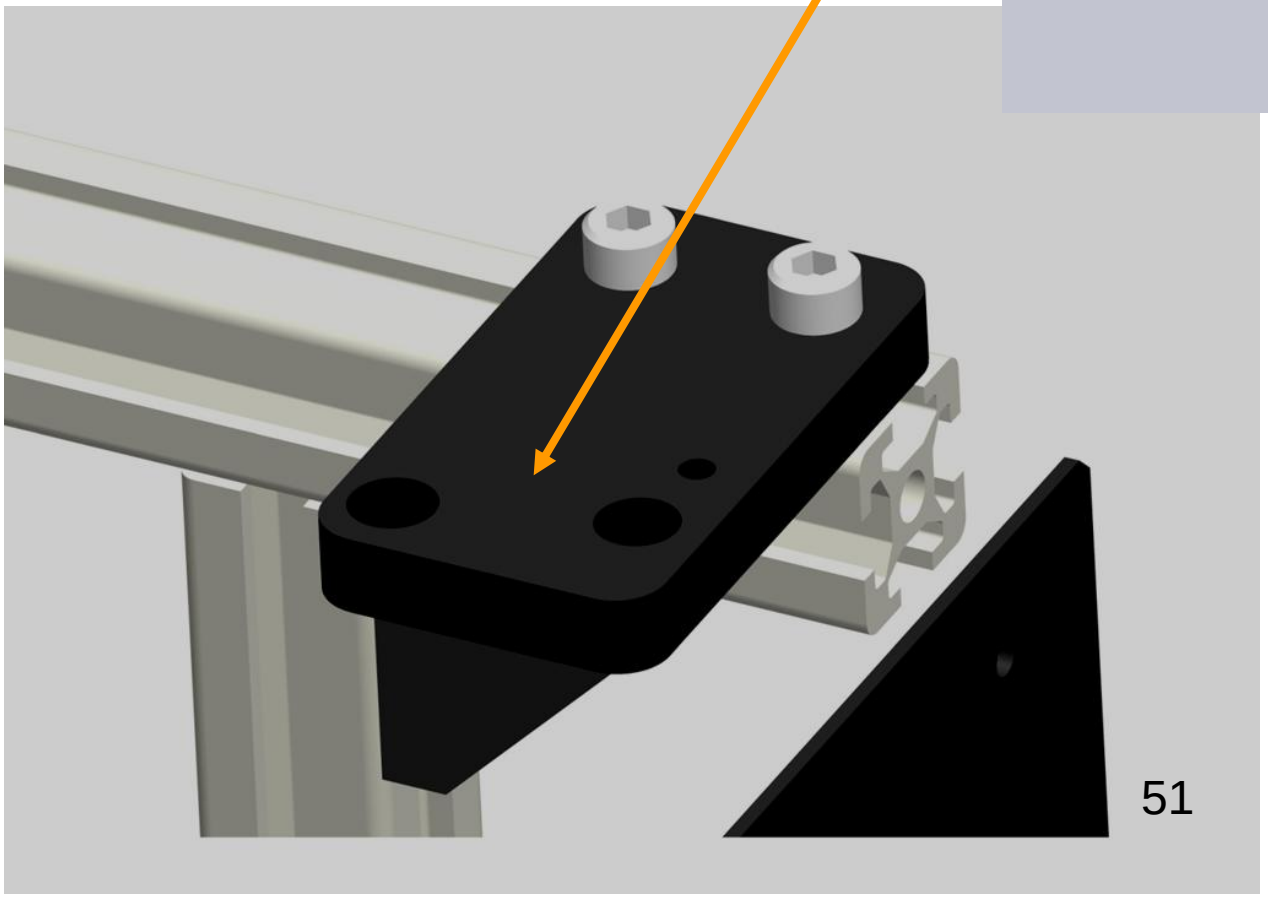




Step 40

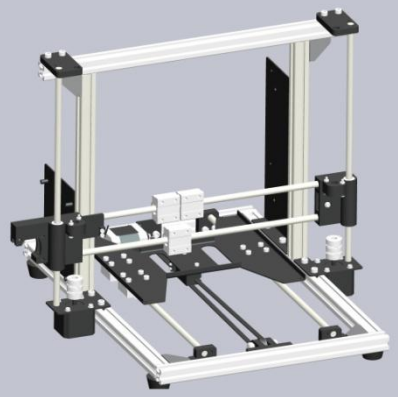


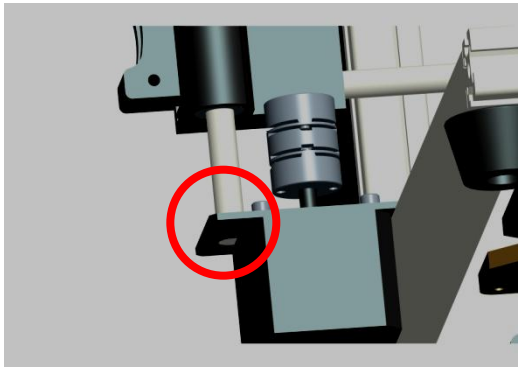
Pay attention to
the direction

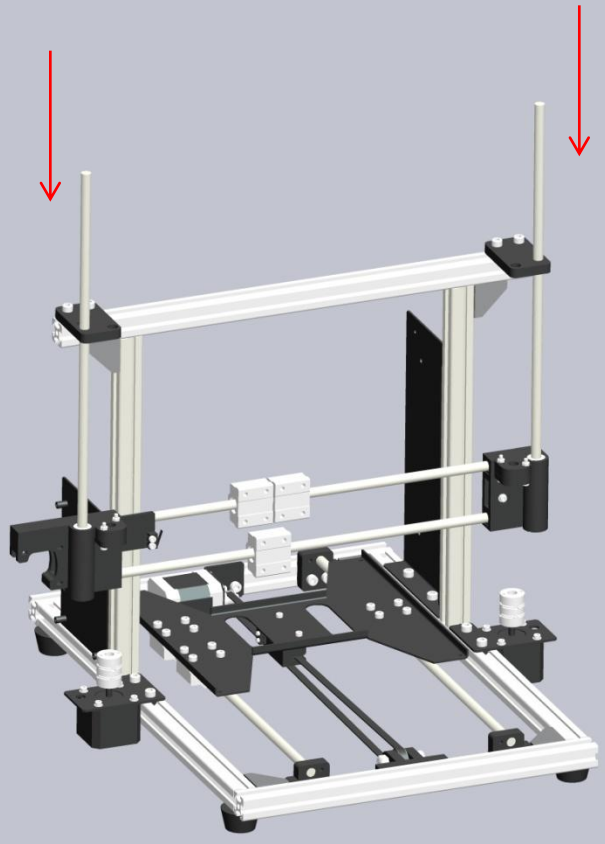


Step 41

320mm polished rod 2pcs





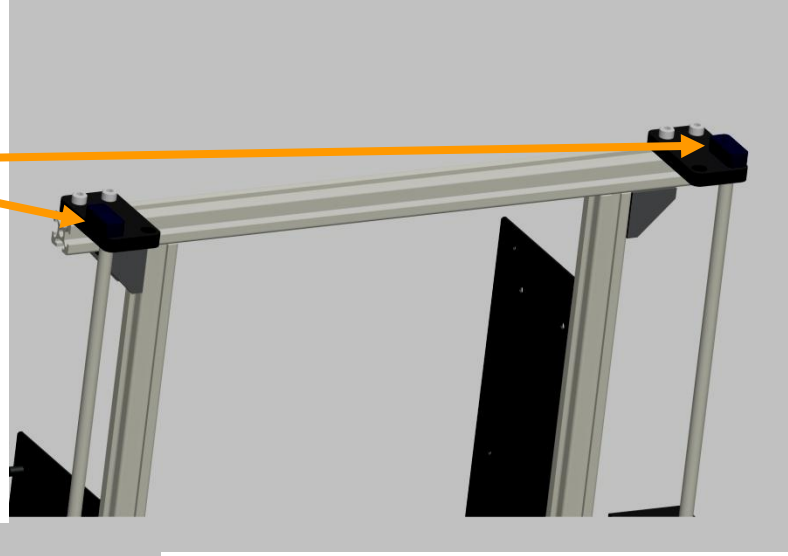


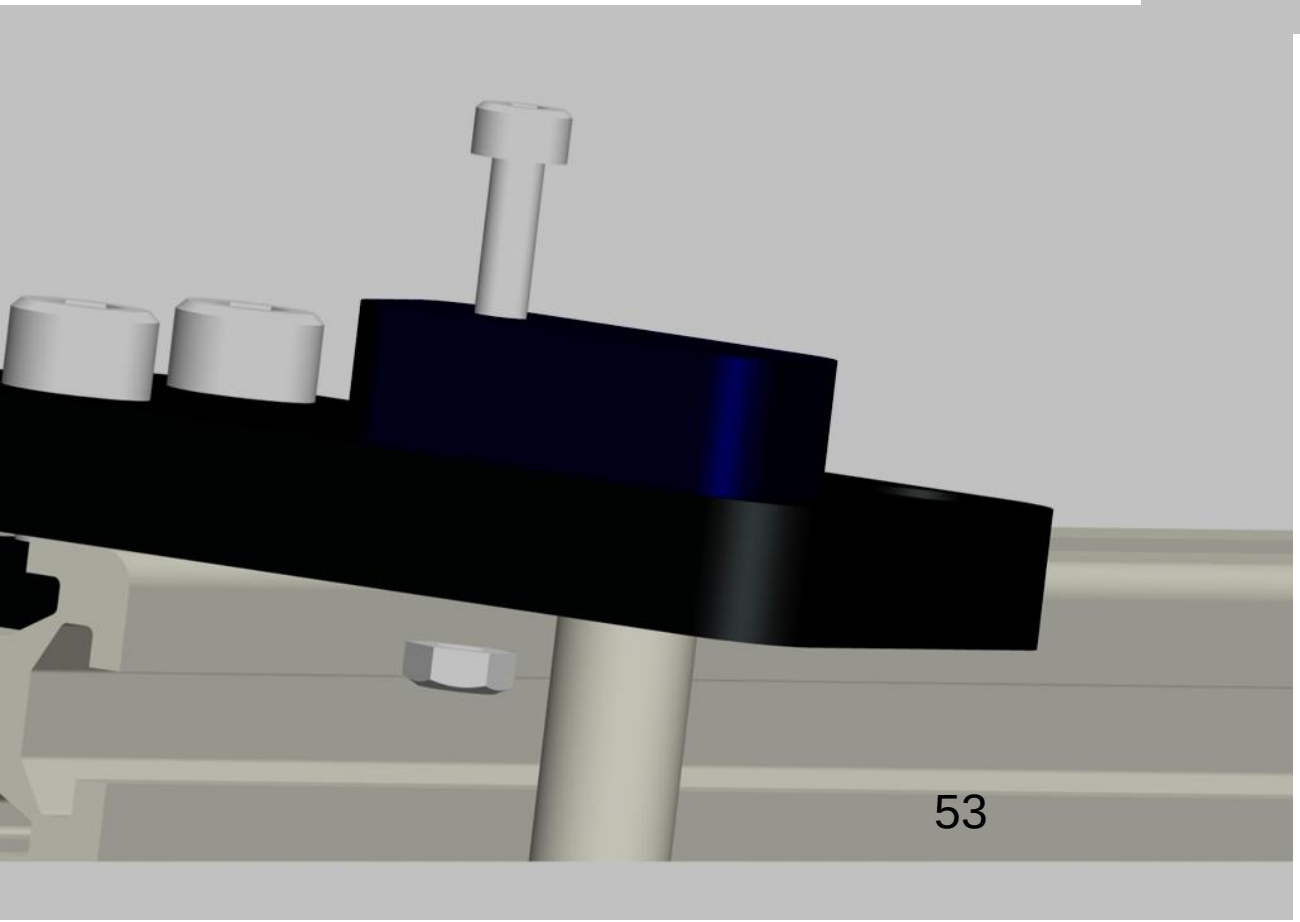
For your attention: Polished rods must insert into the metal hole after it through the bearings from up to down. Pushing X axies by manual from up to down to make sure it moves smoothly, if it doesn't, you can adjust the left and right printed parts distance of X axies.

Step 42

M3*20	2pcs
M3 nut	2pcs

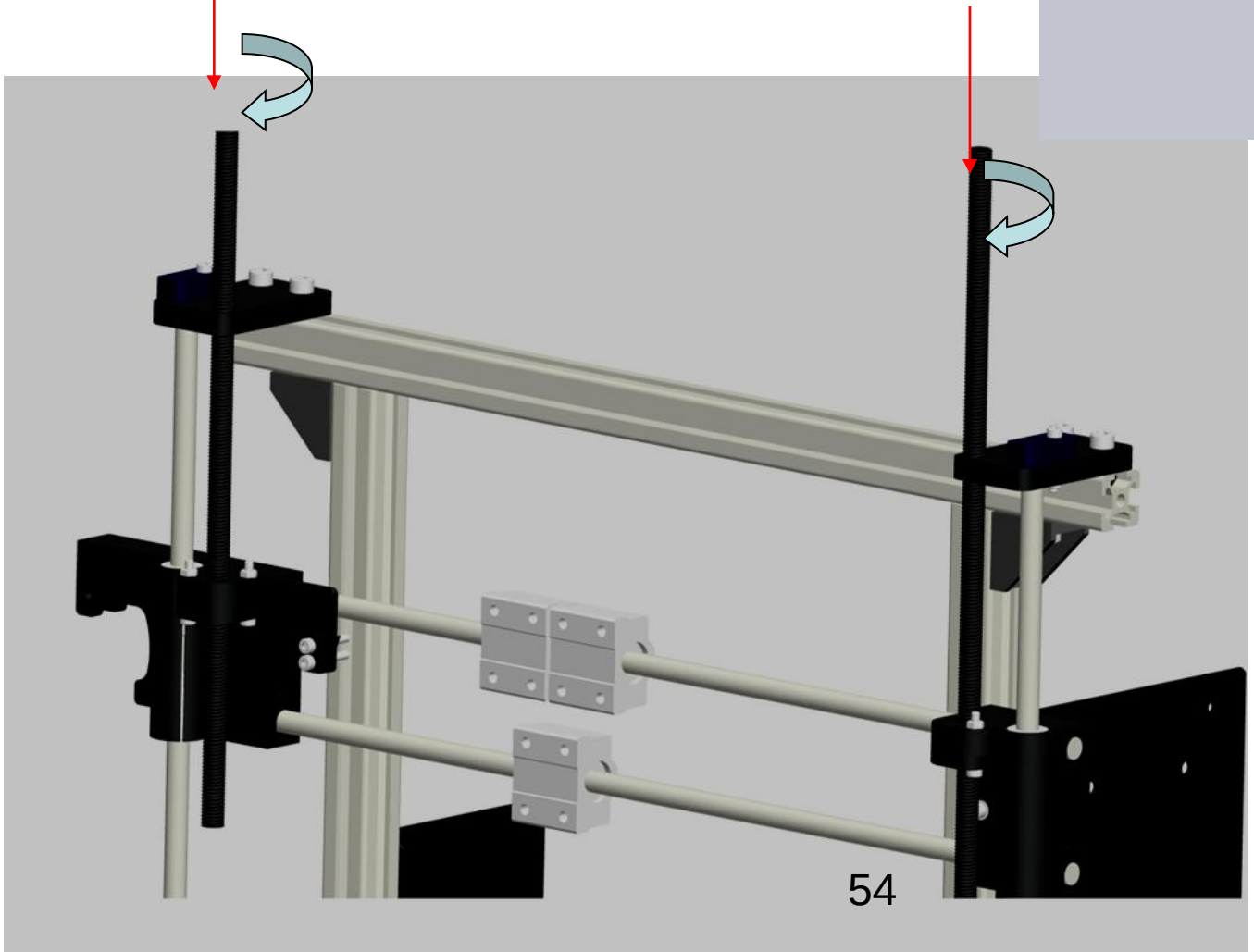
2 positions





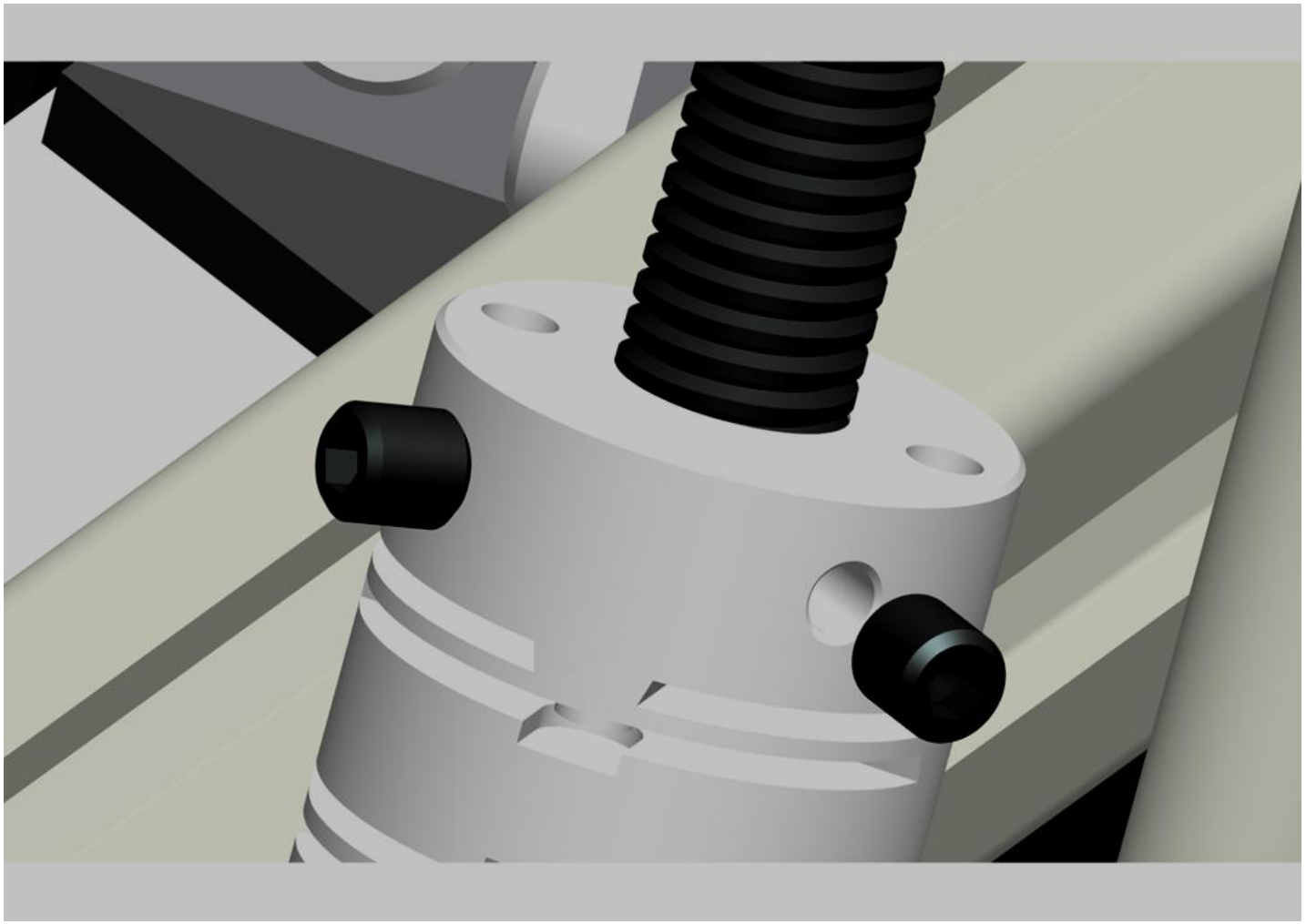
Step 43

M8 screw rod
2pcs



Clockwise insert two screw rods from up and down at the same time

Step 44



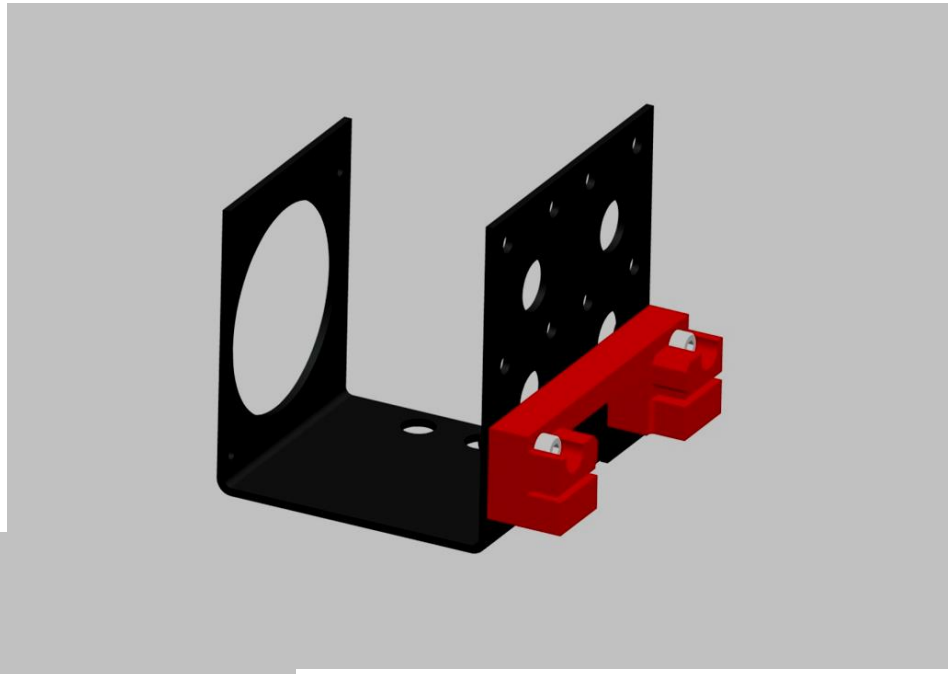
After insert the two screw rods into the coupling, Fix the coupling side screws in condition of making sure X axies is entirety level.

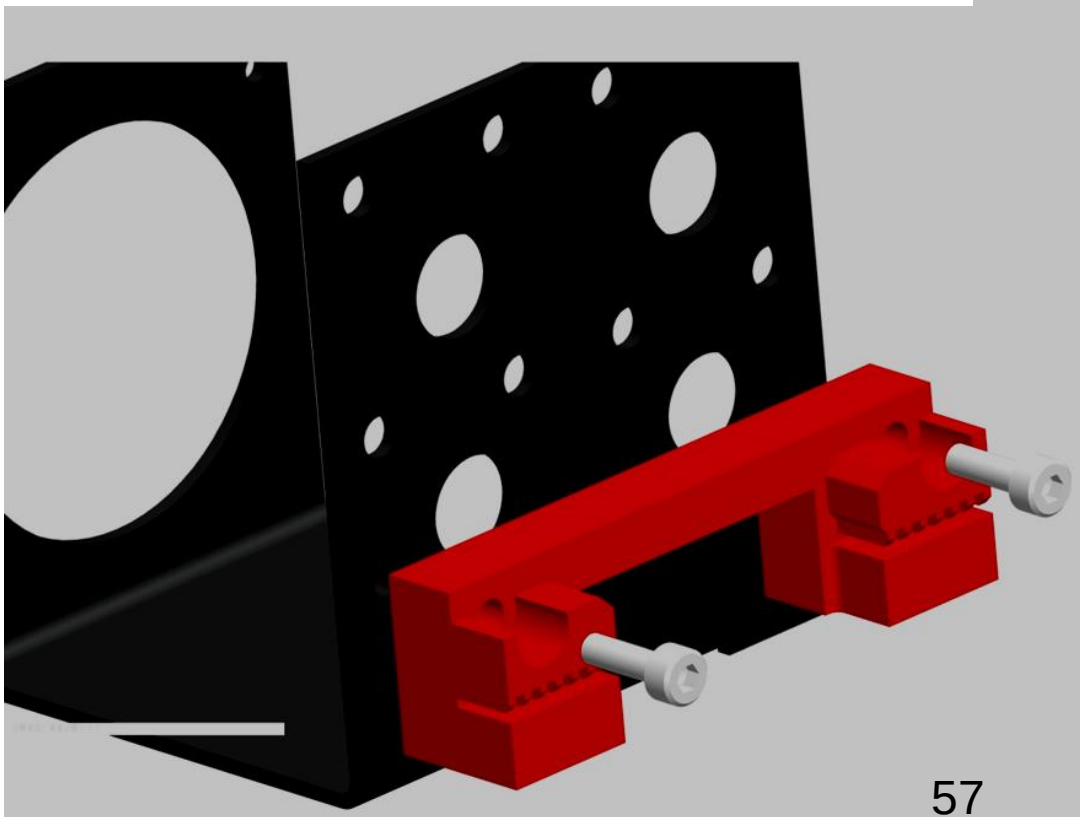
X Axies Motor Belt Assembly & Bed Auto Leveling

Attention：
1. Belt pulley must be fixed.
2. Bearings in right hand must rotate smoothly.
3. Belt must be tight .
4. Push the metal part from left to right and move smoothly when power off.
Otherwise, the X axies will lose step when printing

Step 45

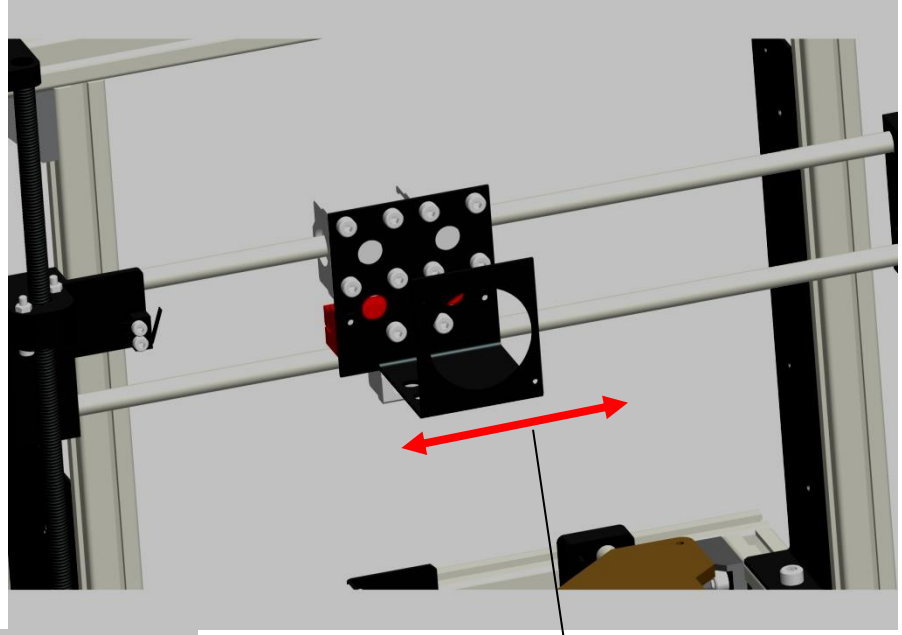
M3*12 2pcs



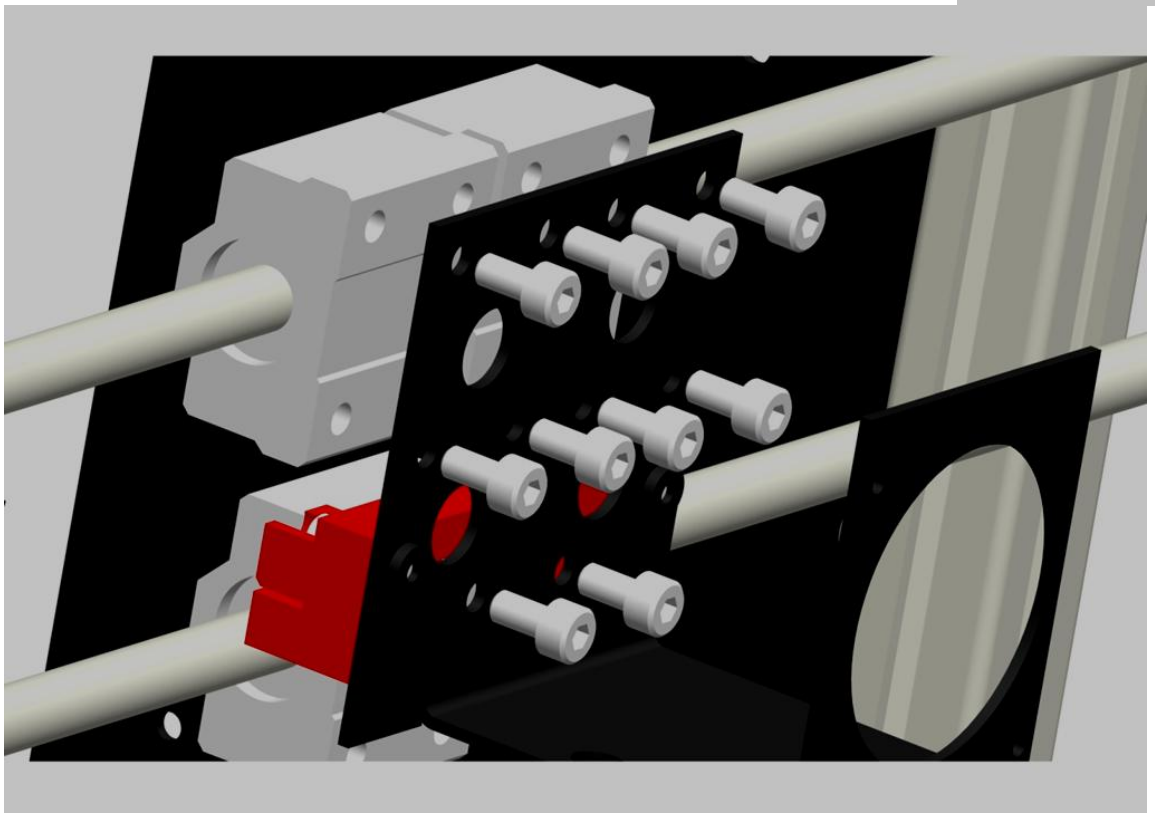


Step 46

M4*8 10pcs



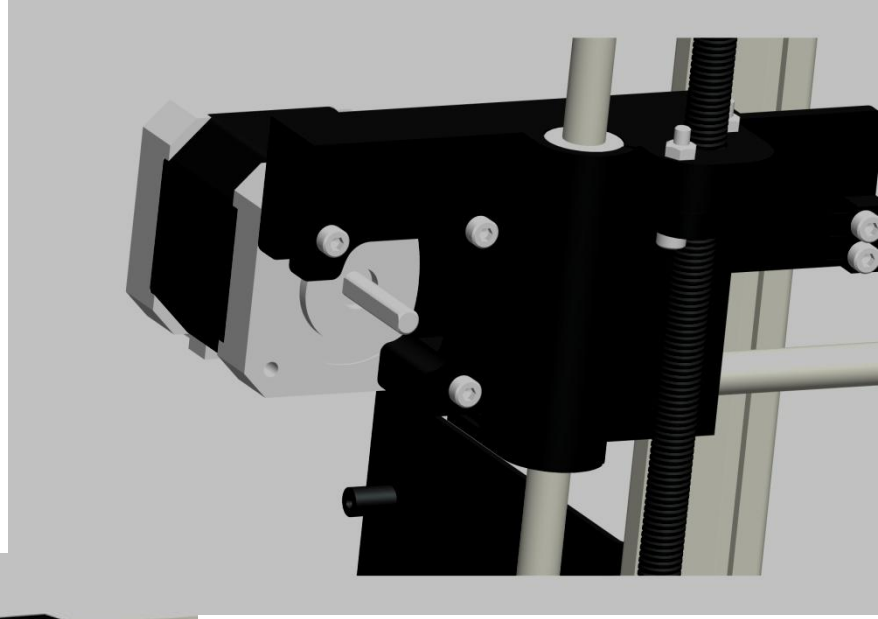
Moving to right and left smoothly

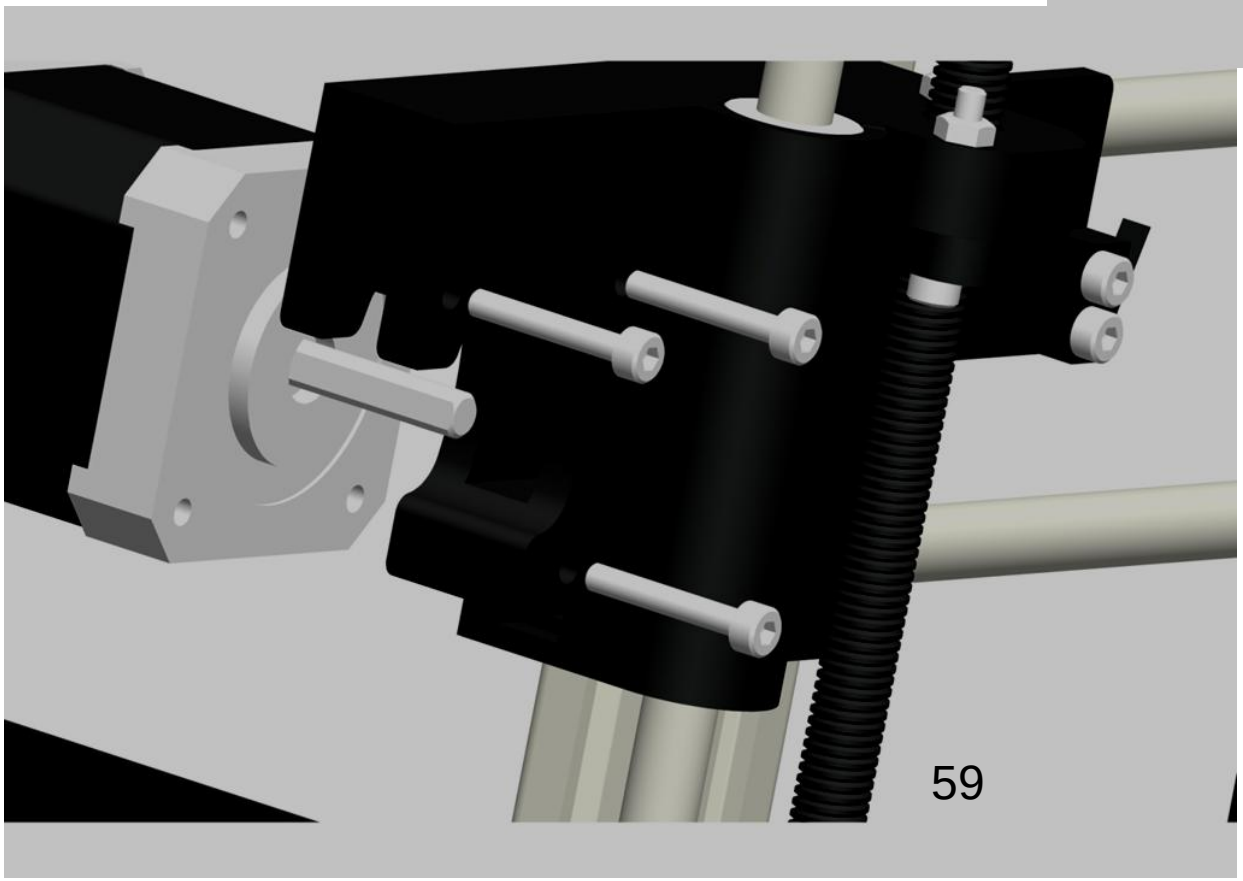


making sure the whole kit moves smoothly after screws fixed

Step 47

40mm motor	1pcs
M3*20	3pcs

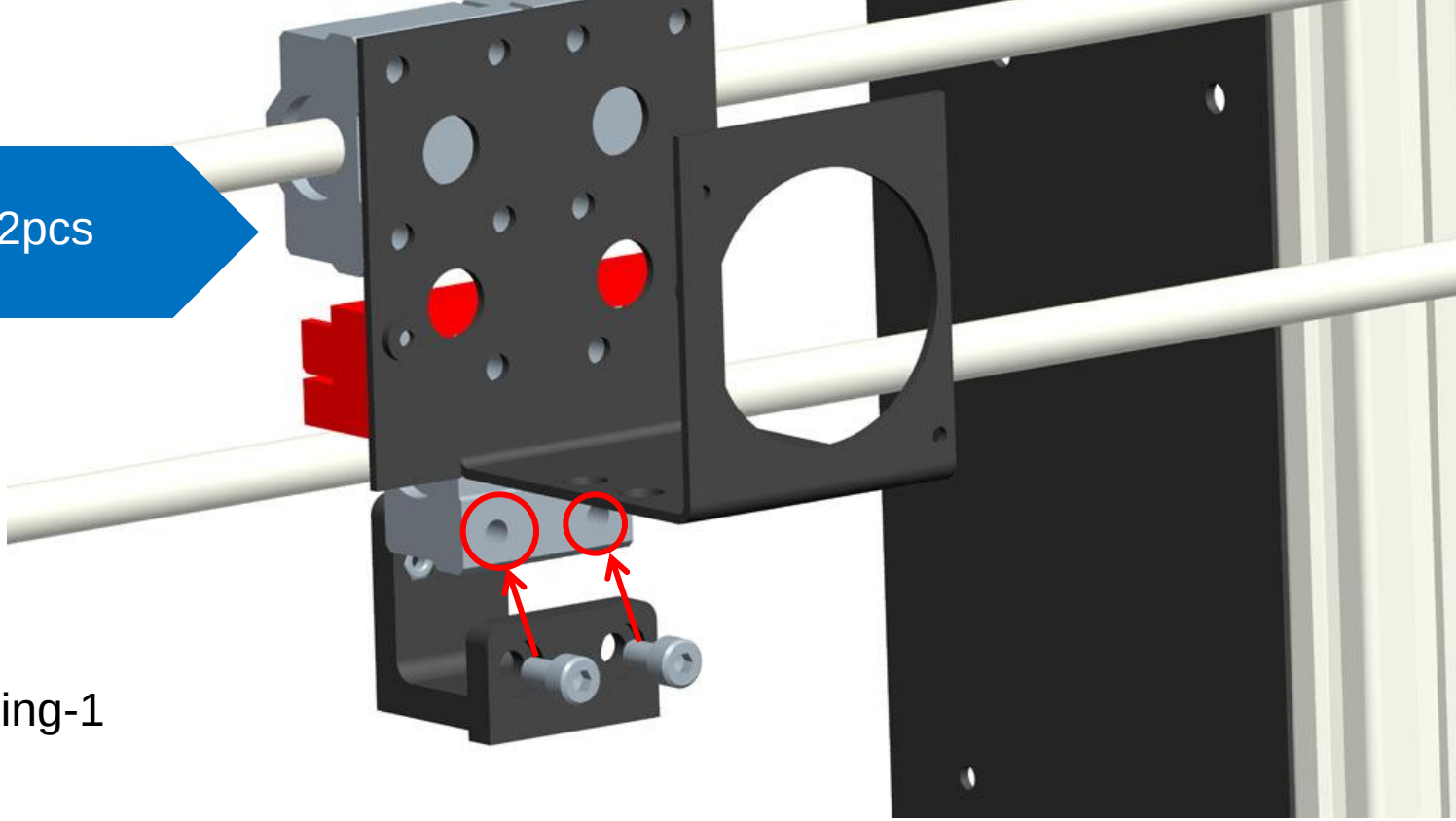




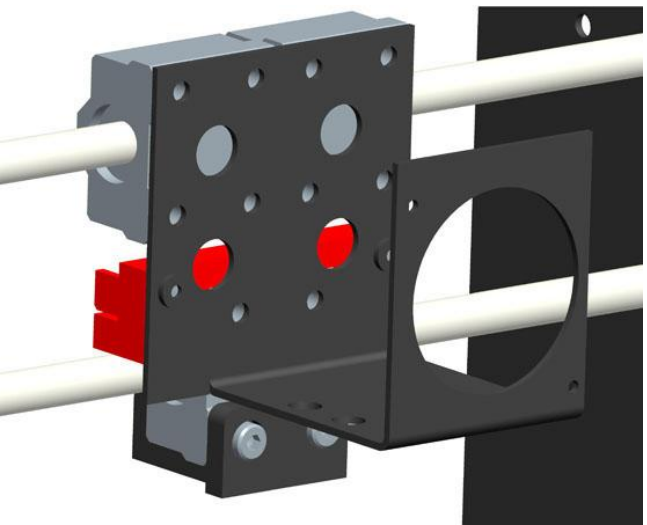
For your attention: please find that the motor terminal faces downwards

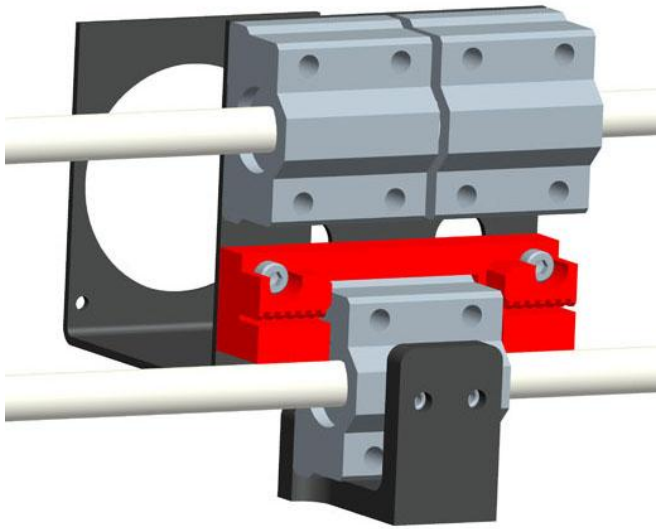
Step 48

M4*8 2pcs



Bed Auto Leveling-1

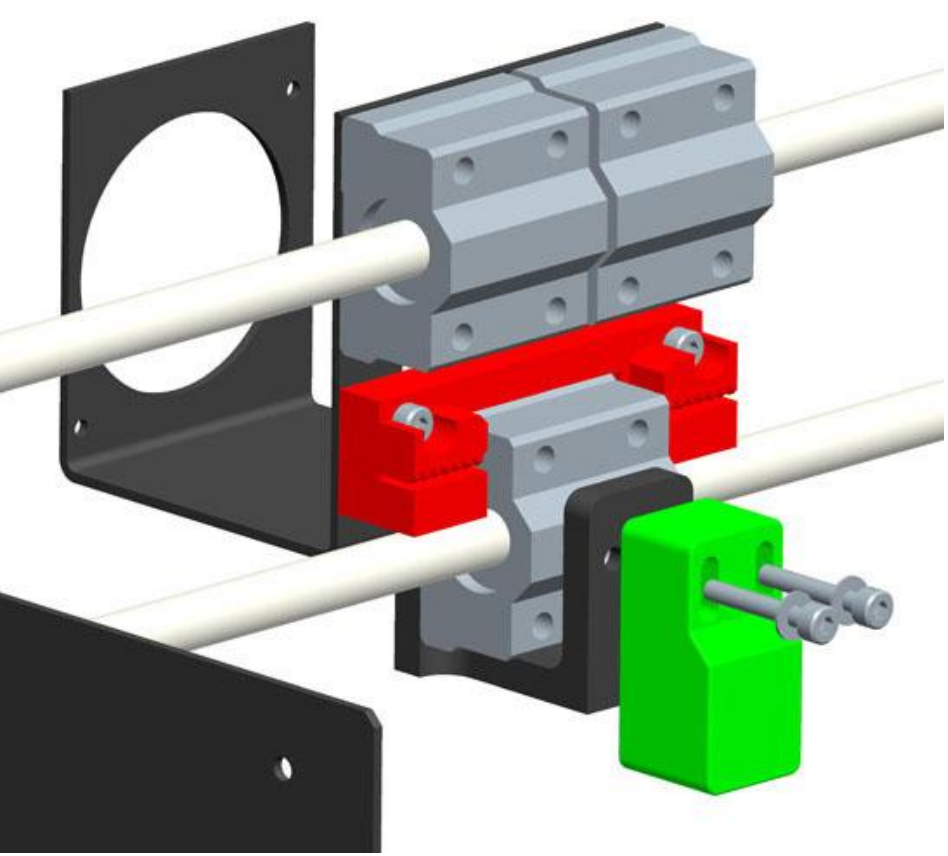


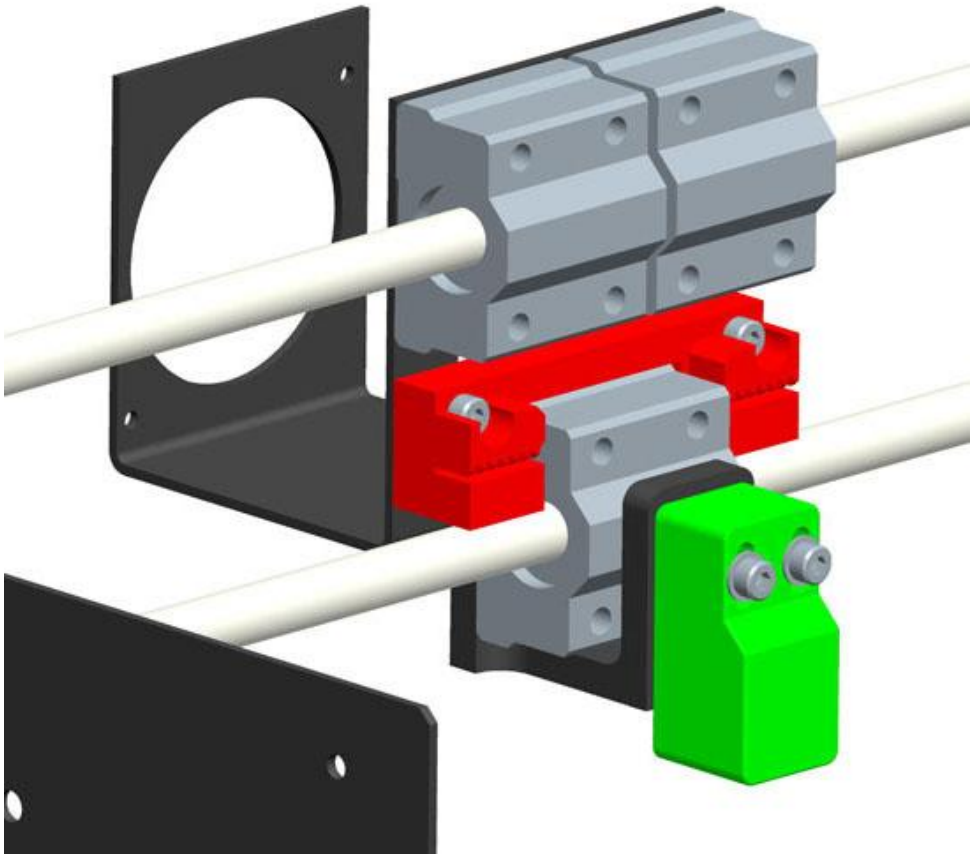


Step 49

SN40-N Endstop 1pcs
M3*20 2pcs
M3 filler piece 2pcs

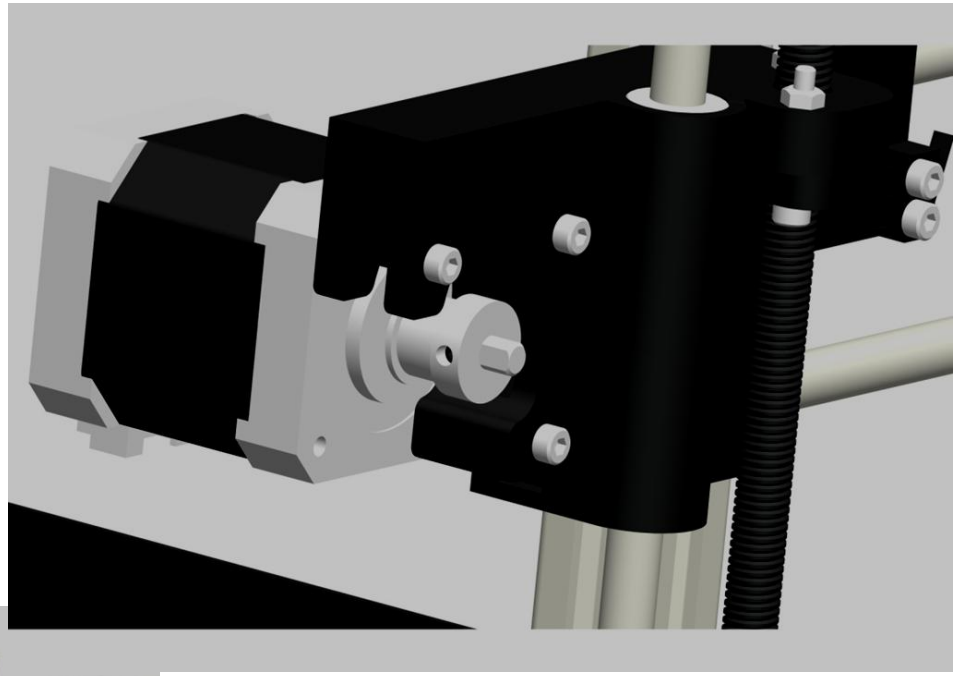
Bed Auto Leveling-2

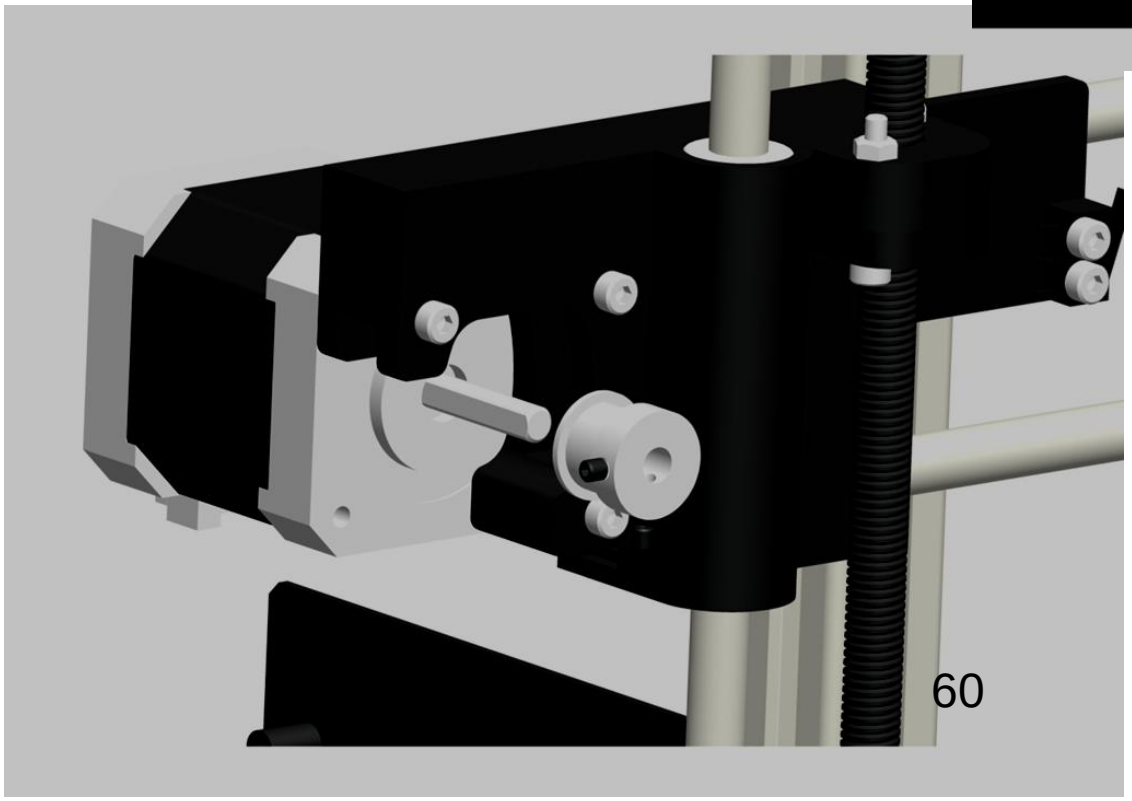


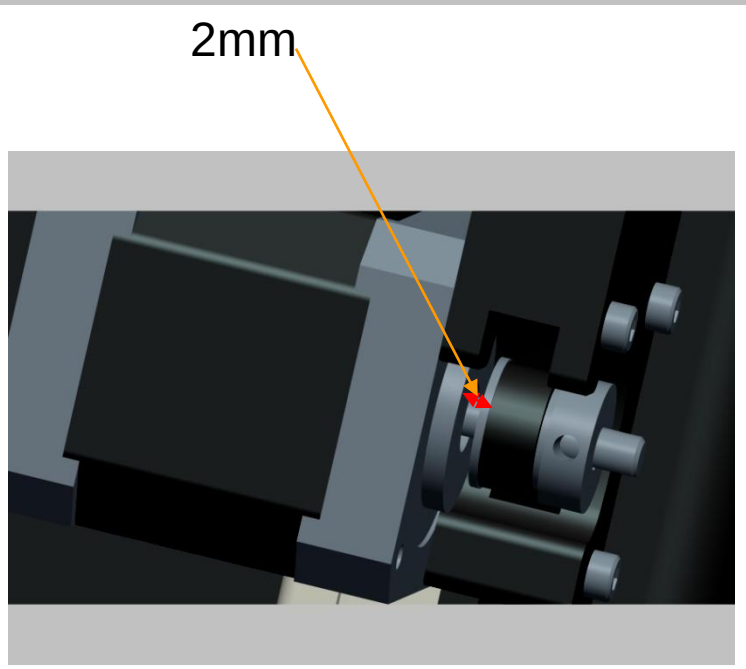


Step 50

Synchronous belt pulley 1pcs

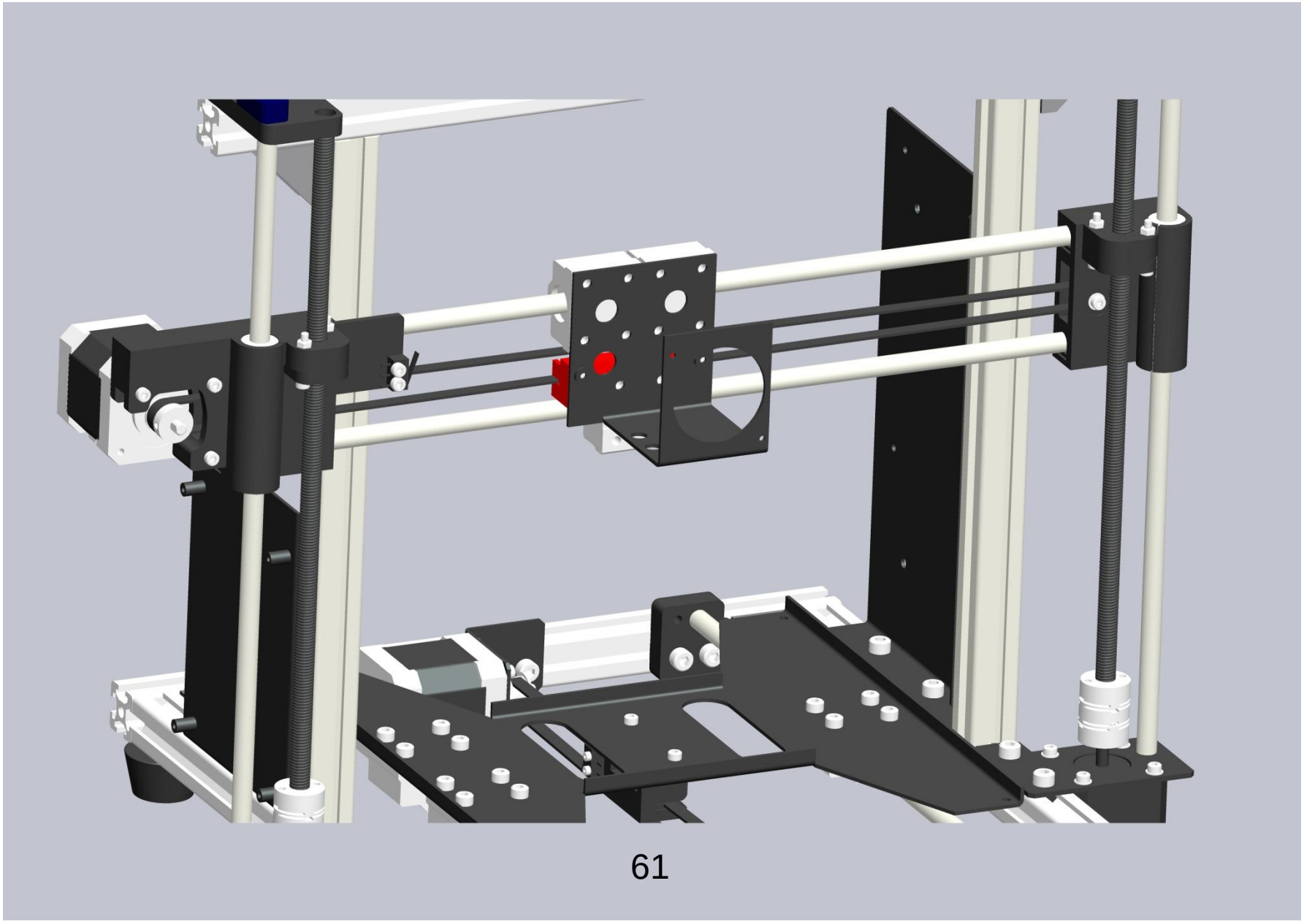






Step 51

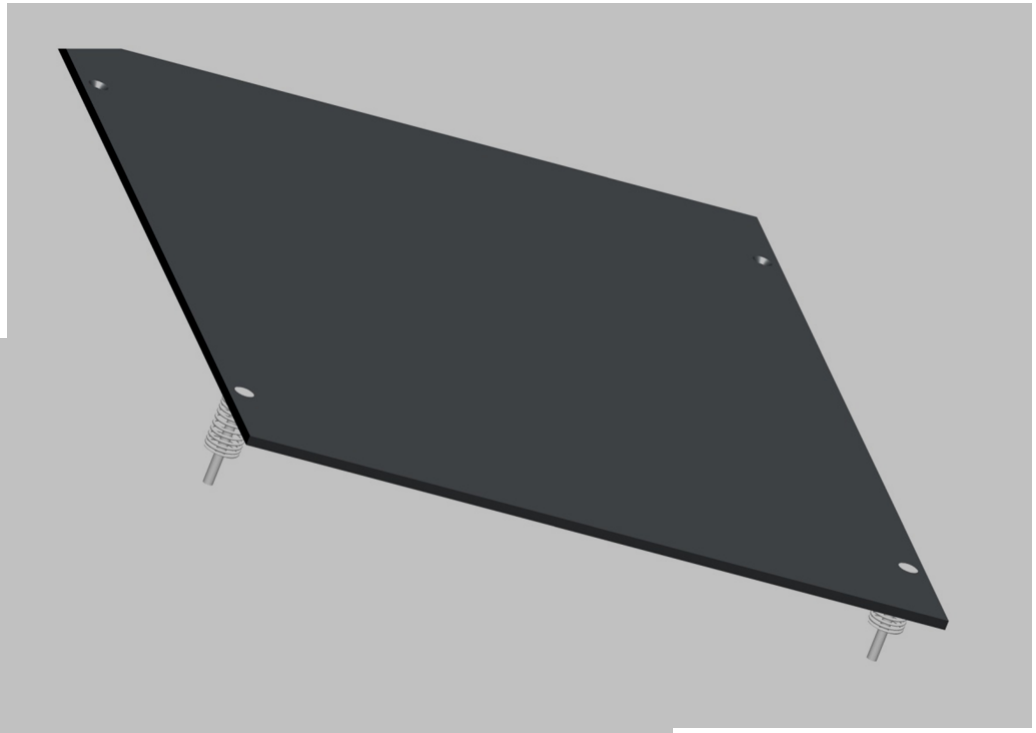
Synchronous belt is about 850mm，
The belt installation method is described in the belt installation section (please refer to thatsection).

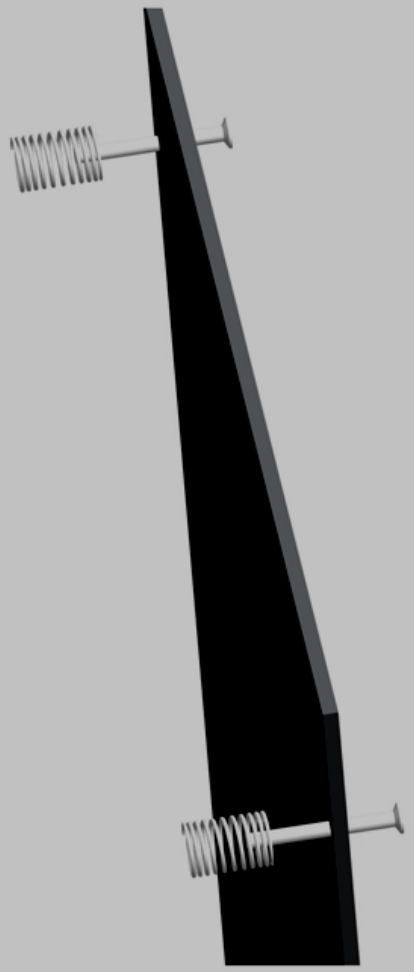


Hot bed Assembly

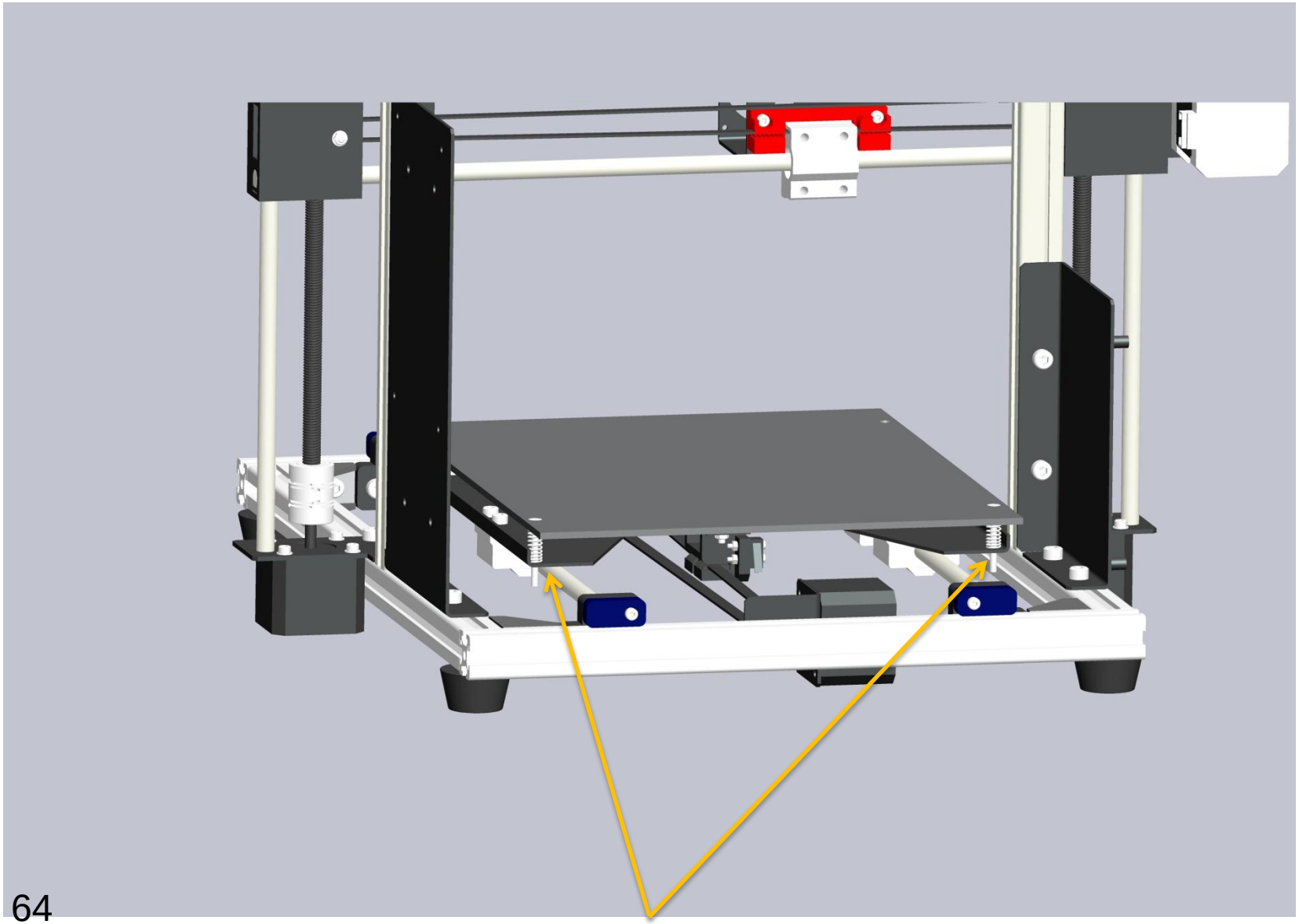
Step 52

M3*25 flat head screw	2pcs
Diameter 6mm spring	2pcs





Step 53



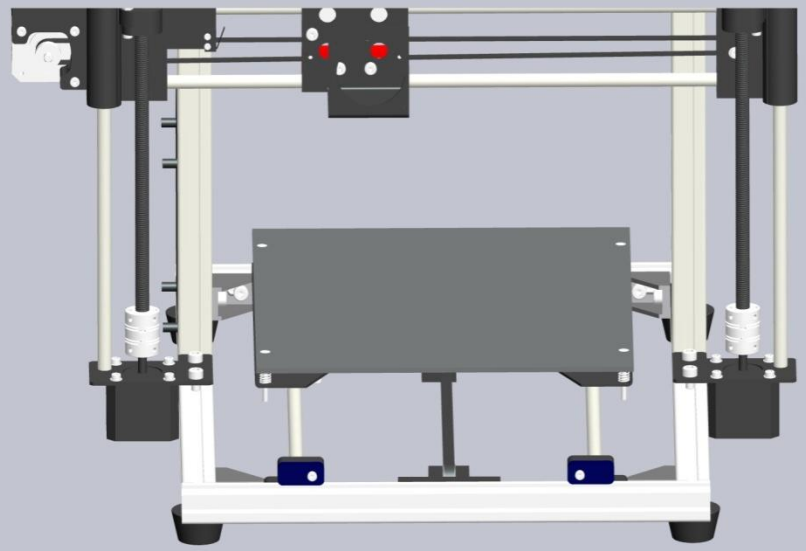
64

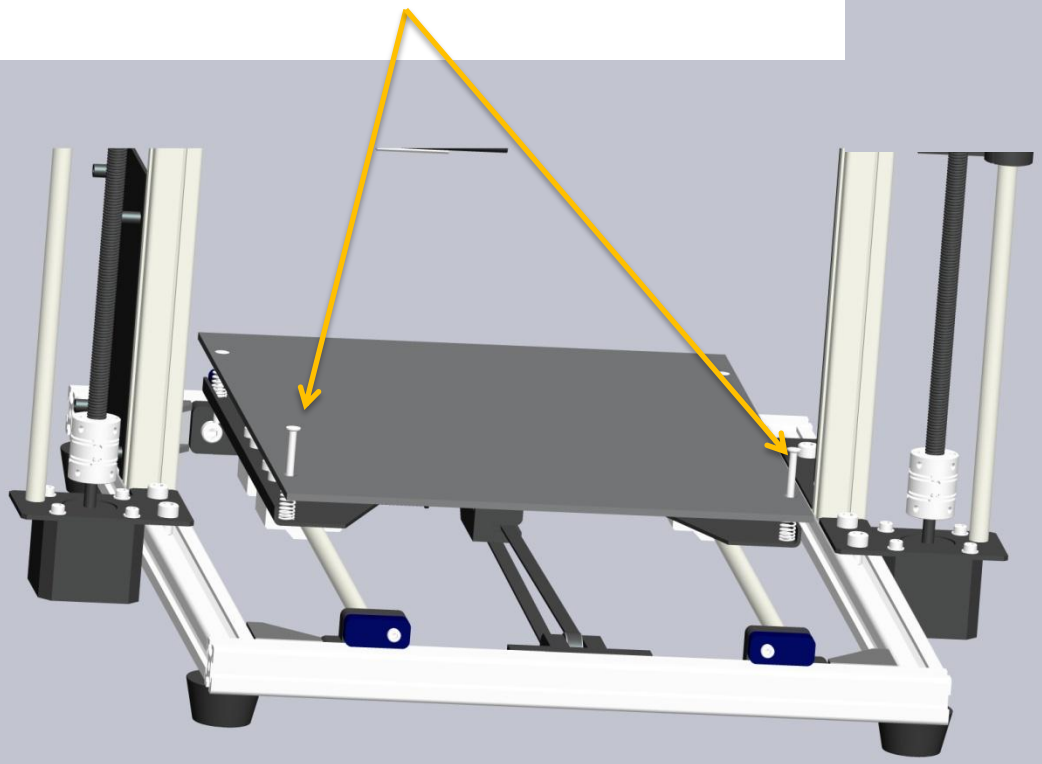
The two screws are inserted into the metal plate holes individually

Step 54

M3*25 flate head screw 2pcs
Diameter 6mm spring 2pcs

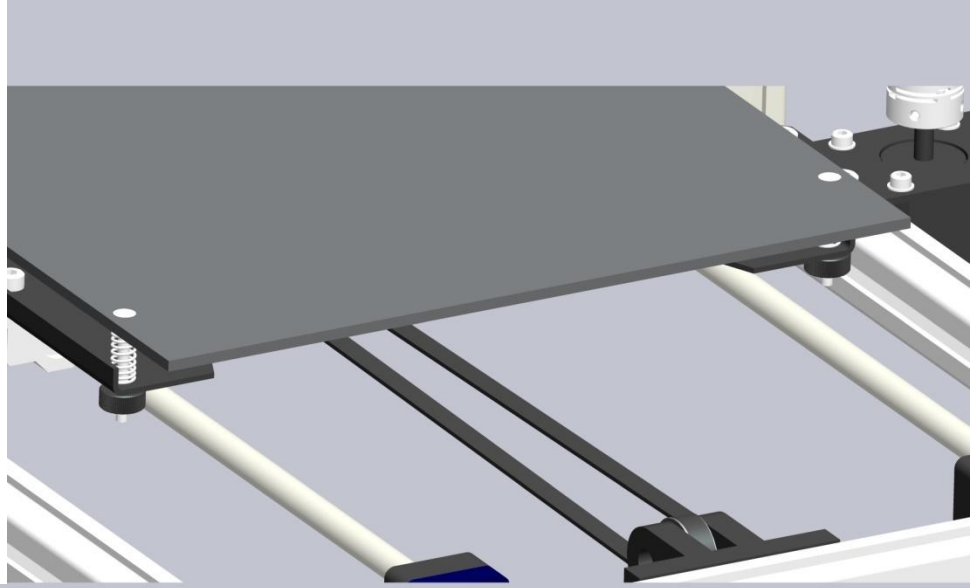
Installing two springs to other side of bed, insert the screws into the acrylic holes



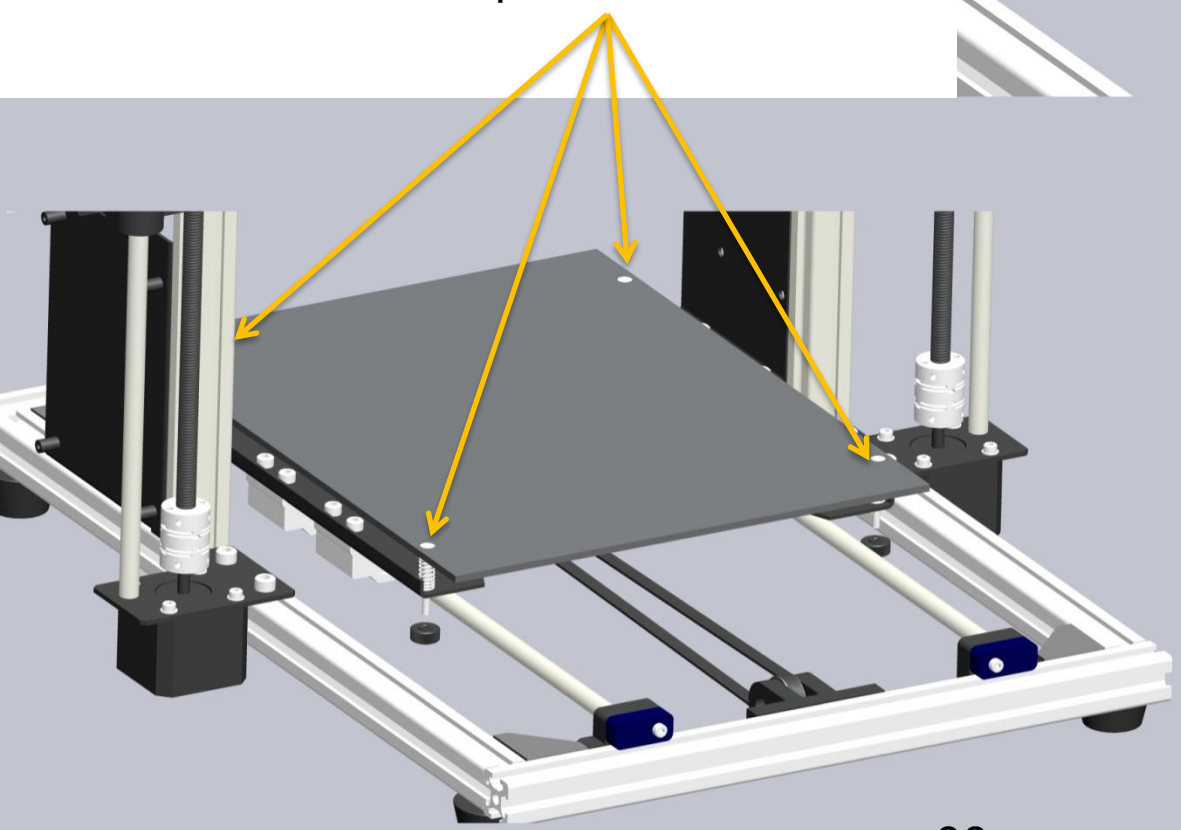


Step 55

Hand nut 4pcs



4 position

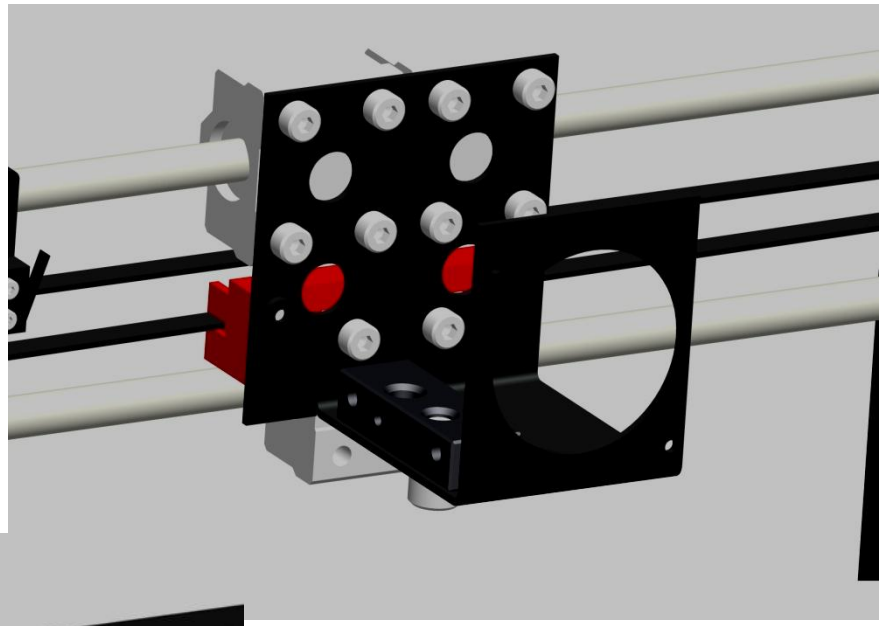


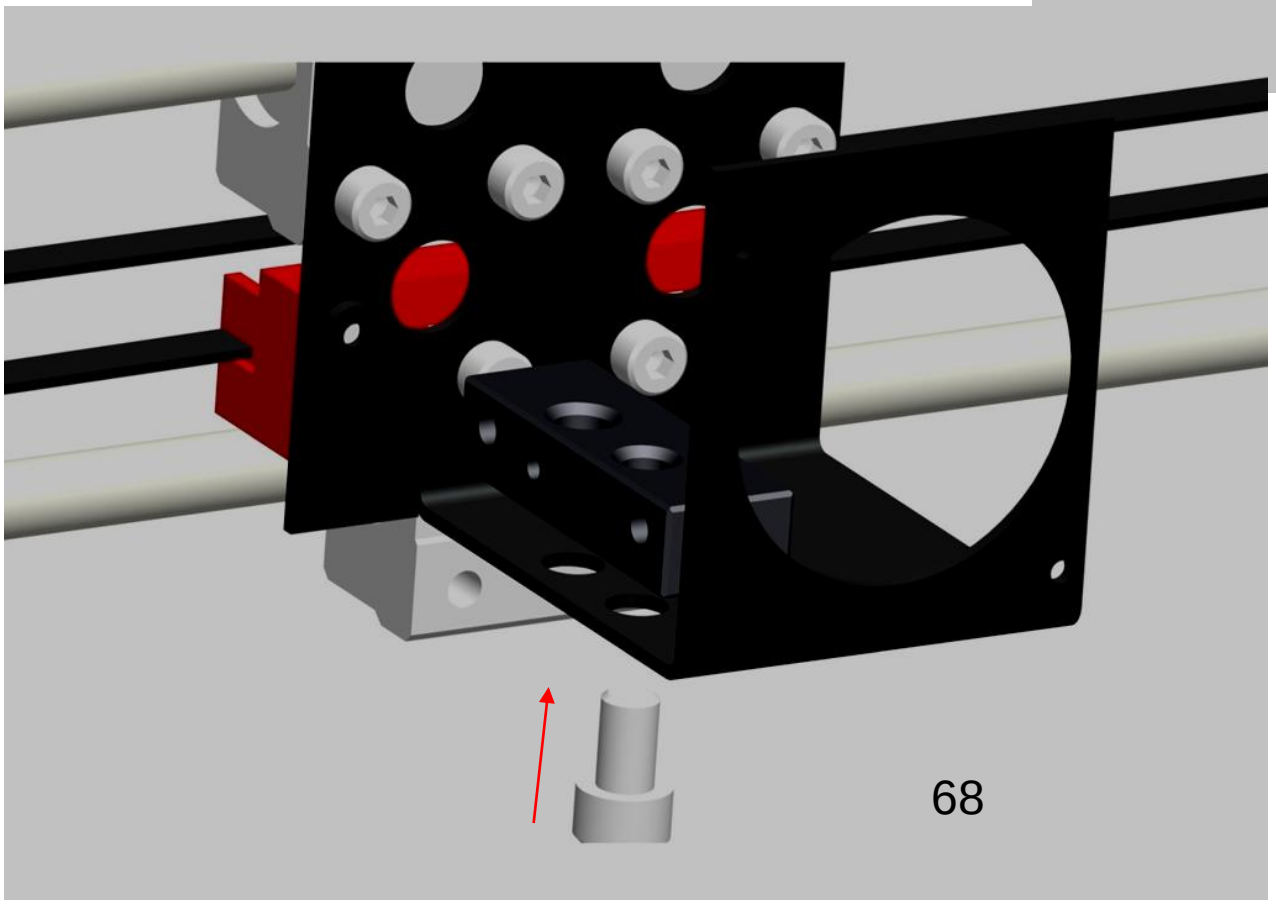
Extruder Assembly

Attention：
1. Make sure the V bearing can stick on the filament gear under the pressure of Spring.
2. Make sure the filament can be inserted from feed port into throat nozzel,otherwise, it will cause extruding filament abnormally or don't extrude filament.

Step 56

M6*8 1pcs

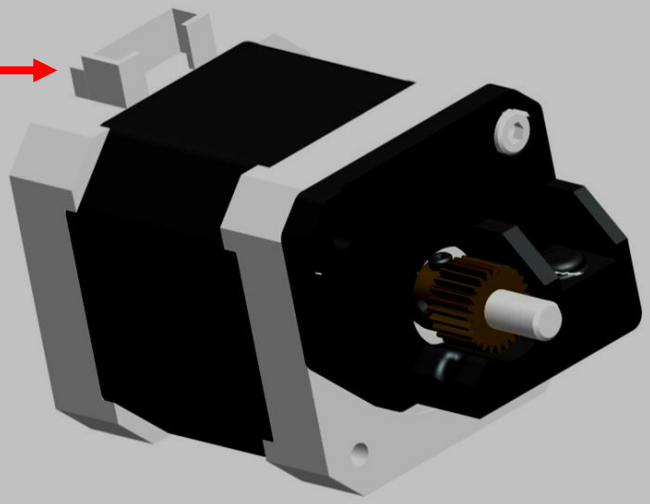


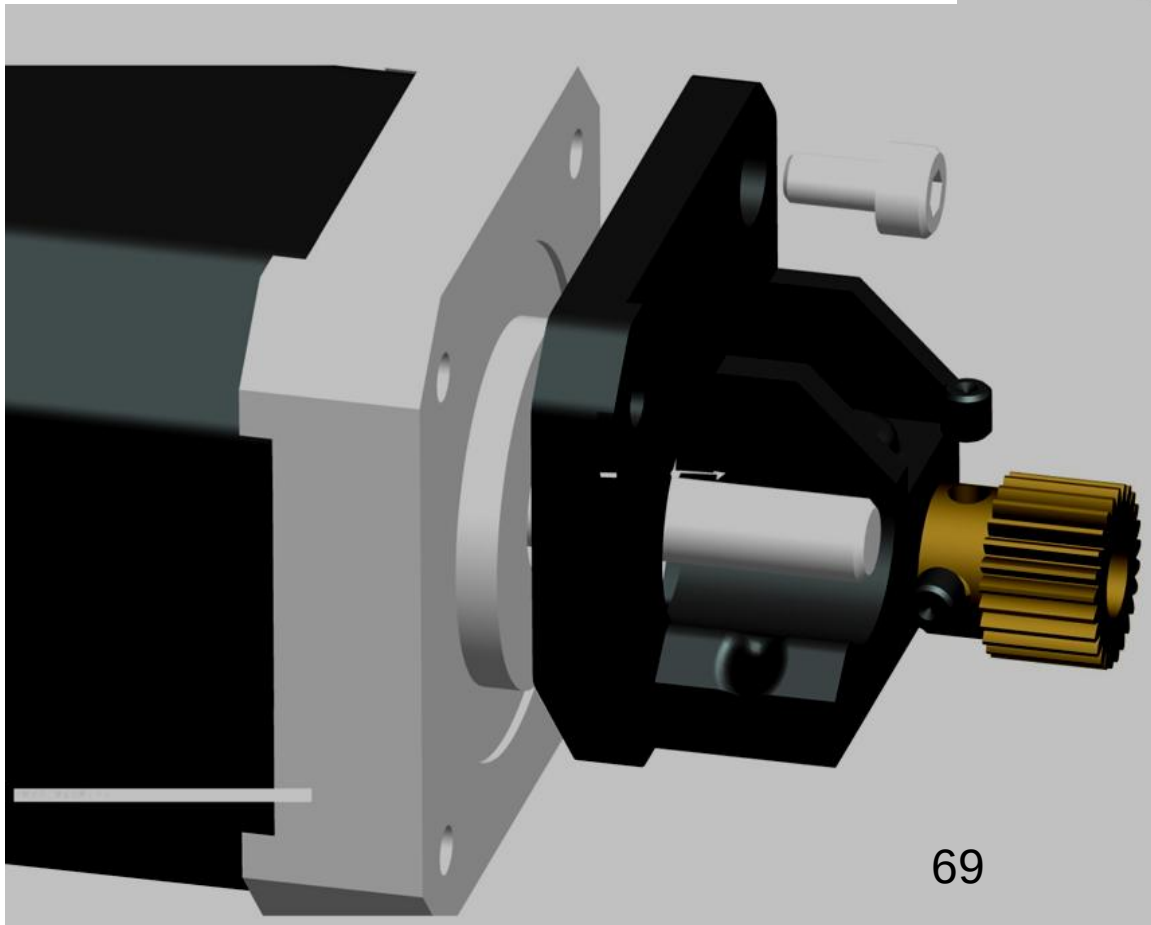


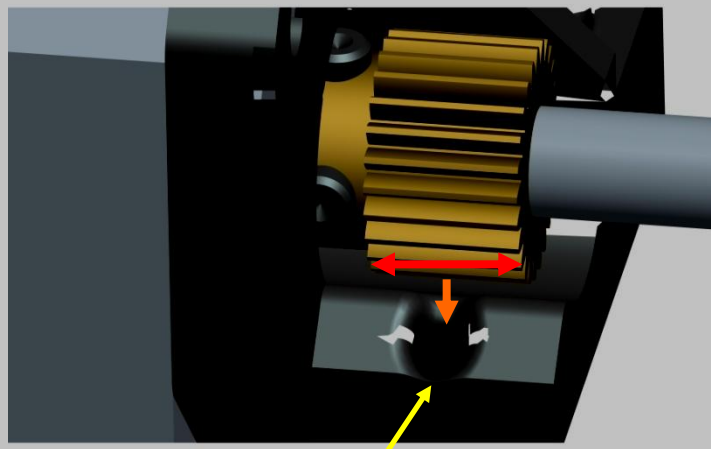
Step 57

40mm motor	1pcs
M3*5	1pcs

For your attention: please find that the motor termin -al faces upwards



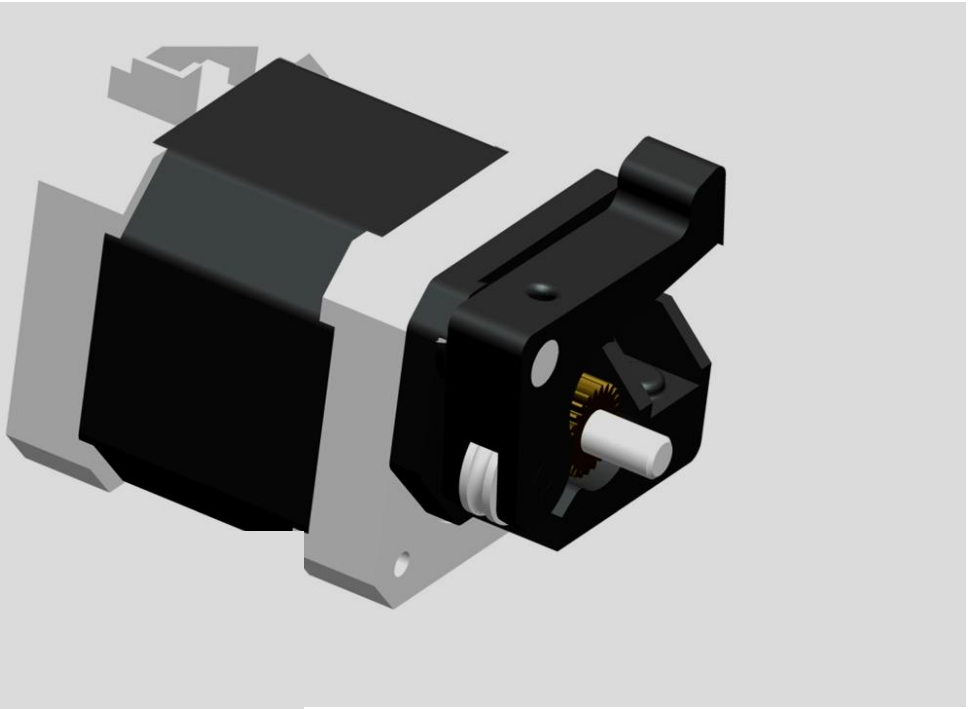


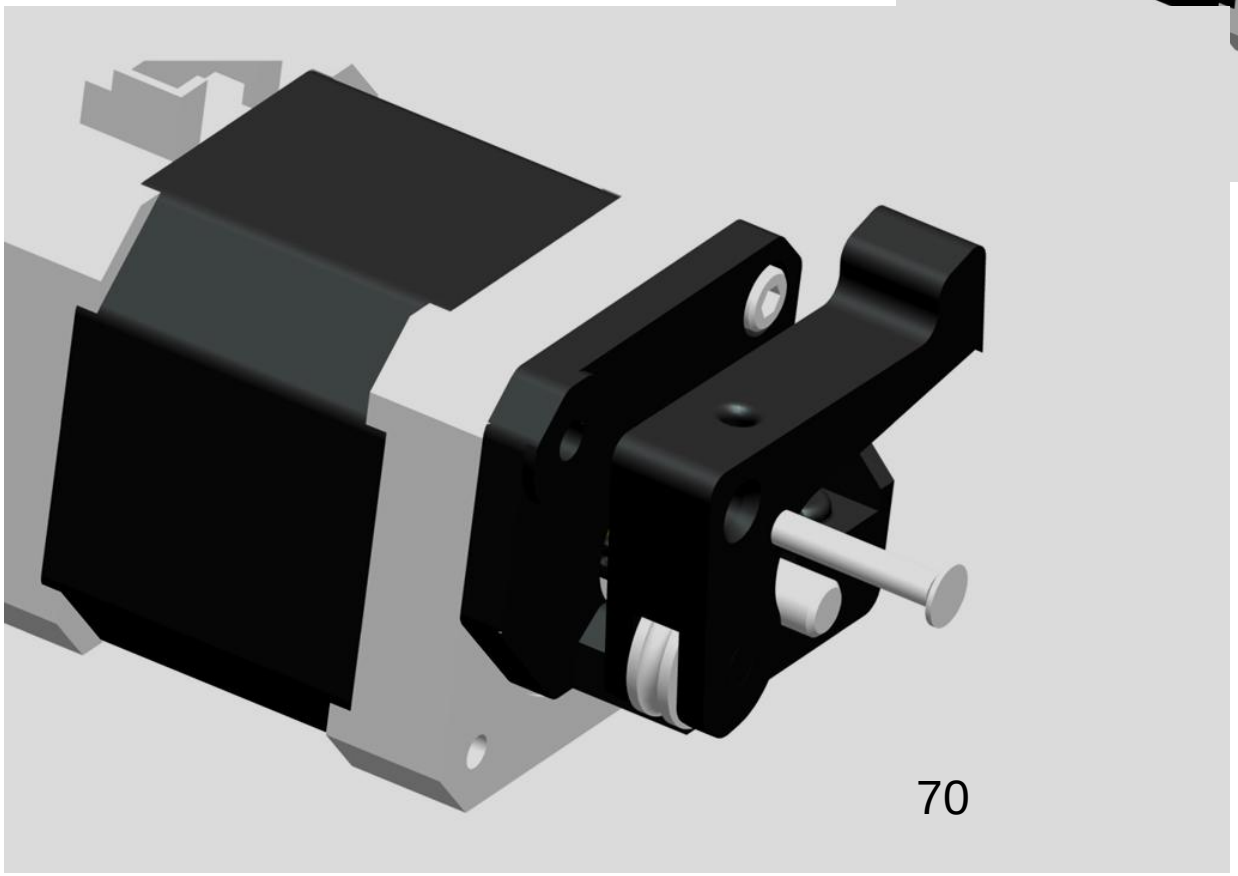


Filament hole is about in the middle of extrusion pulley.

Step 58

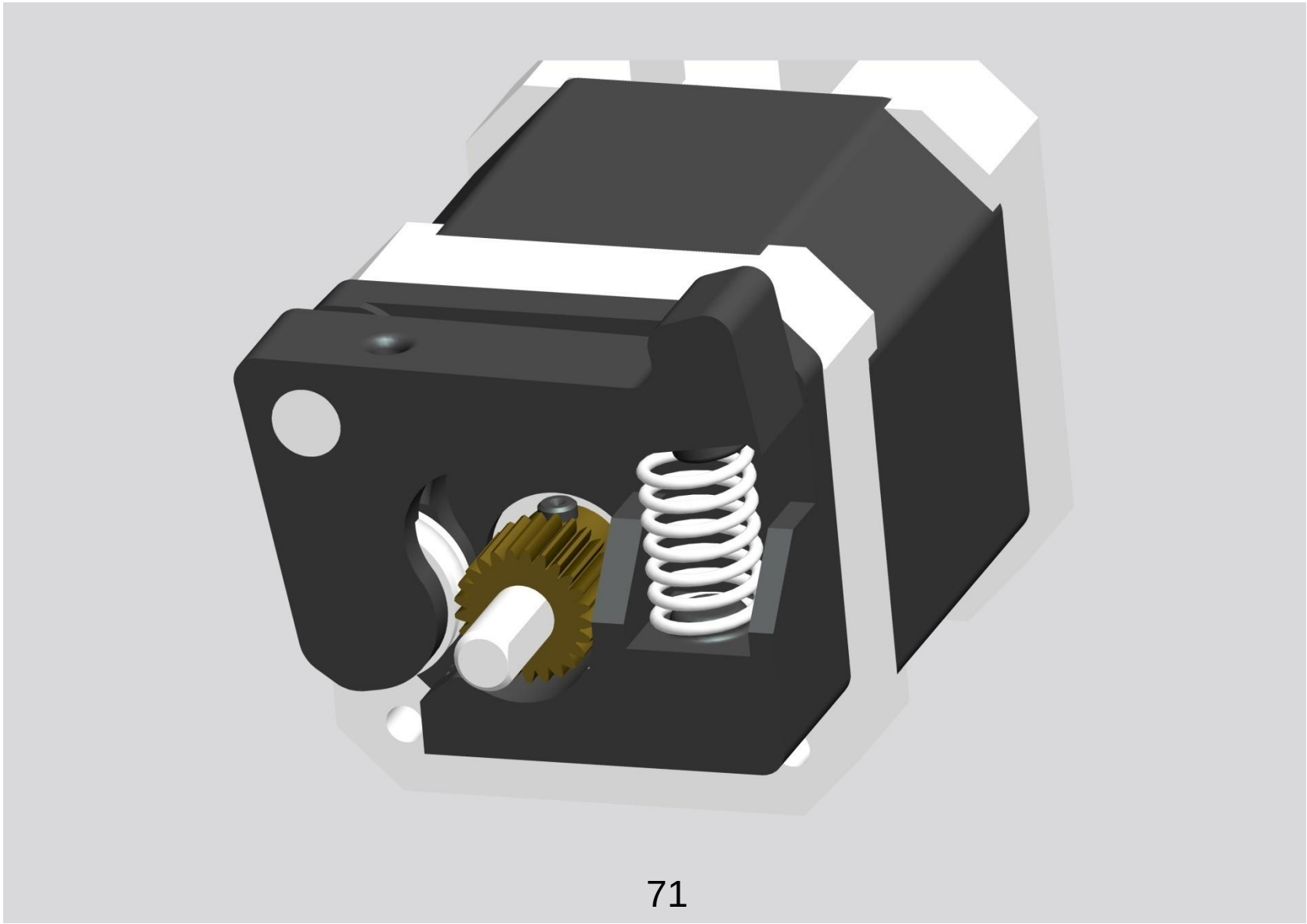
M3*16 flat headed screw
1pcs





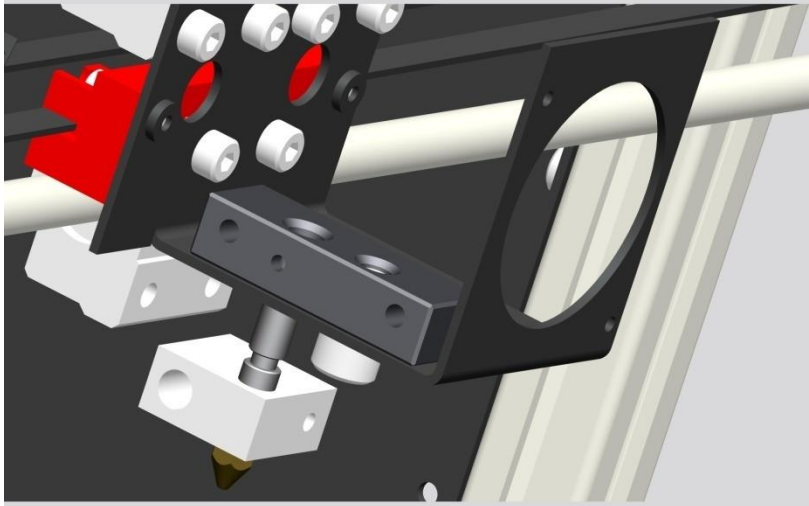
Step 59

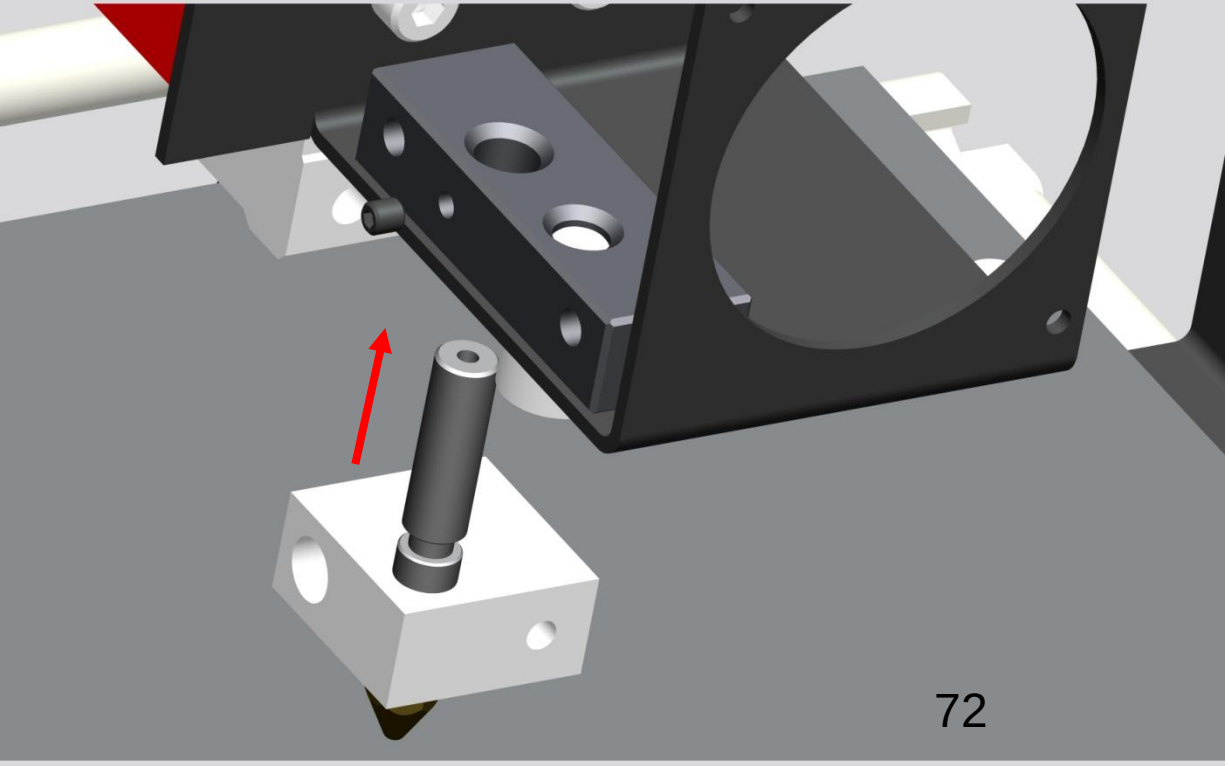
Diameter 8mm spring 1pcs



Step 60

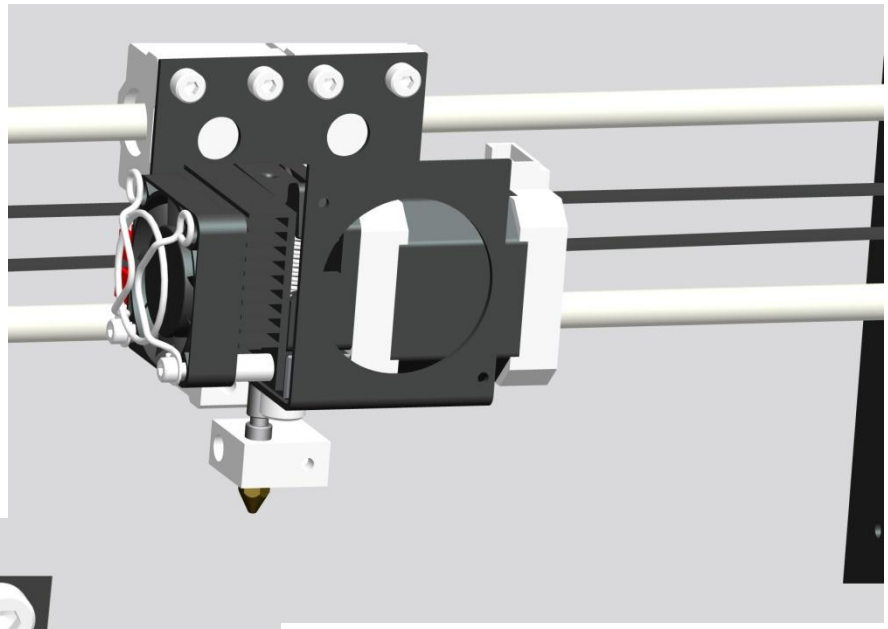
M3*5screw 1 pcs

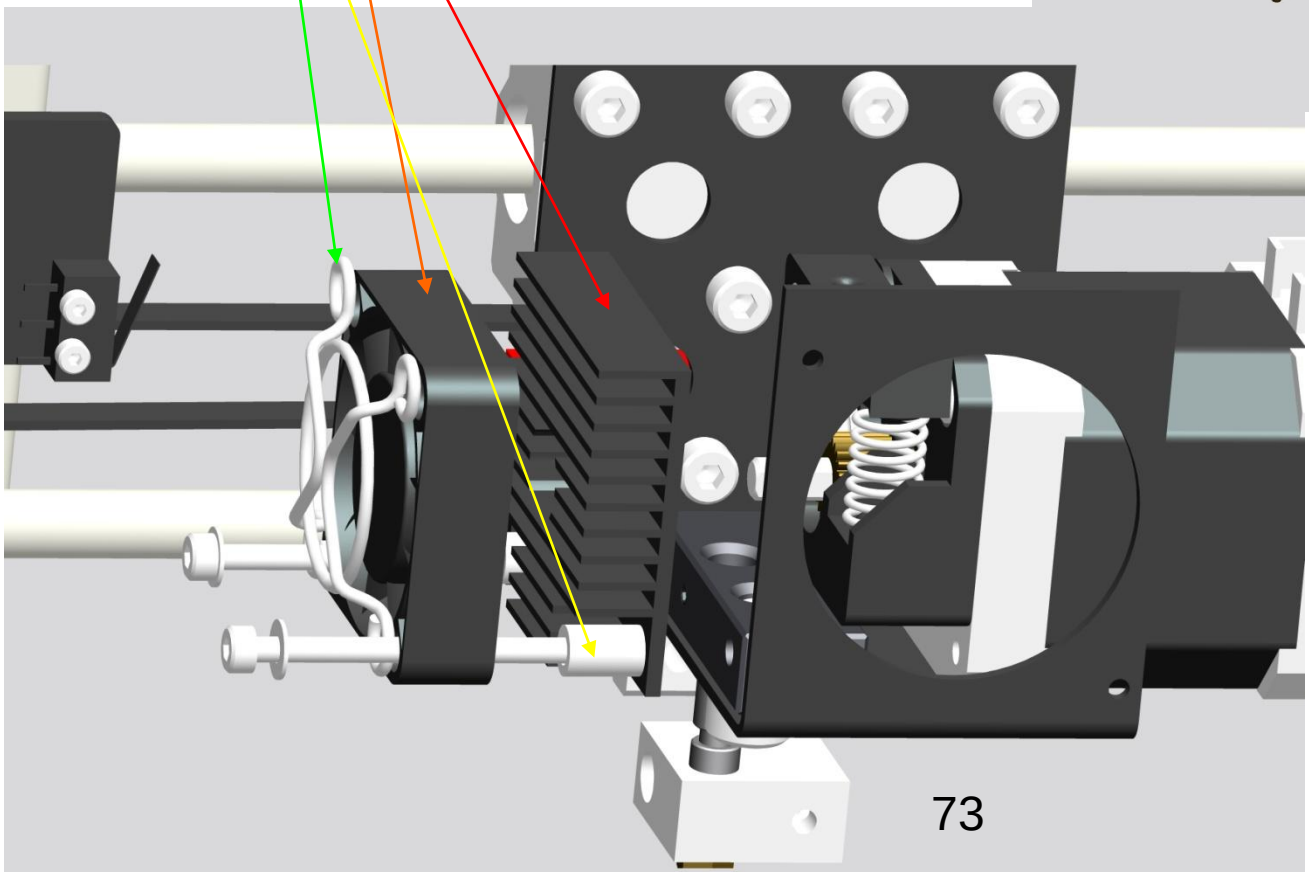




Step 61

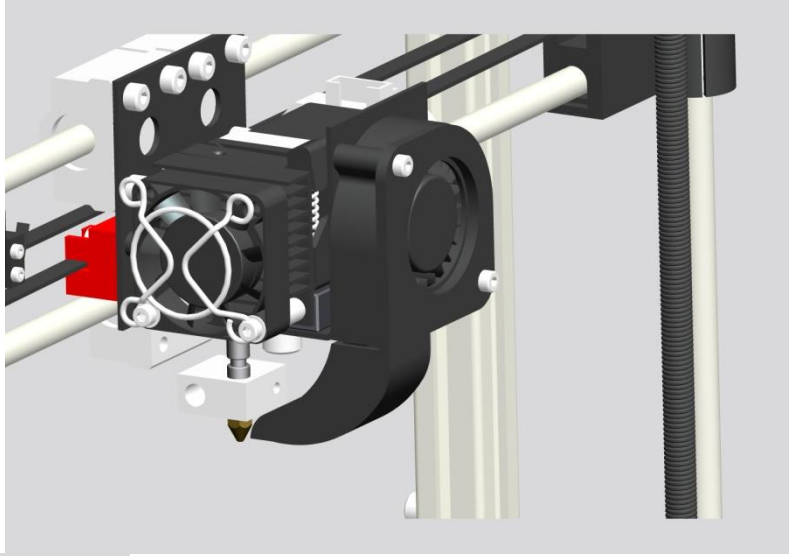
Heat sink	1pcs
4010 fan	1pcs
Fan net	1pcs
Isolation pillar	2pcs
M3*45	2pcs
M3 filler piece	2pcs

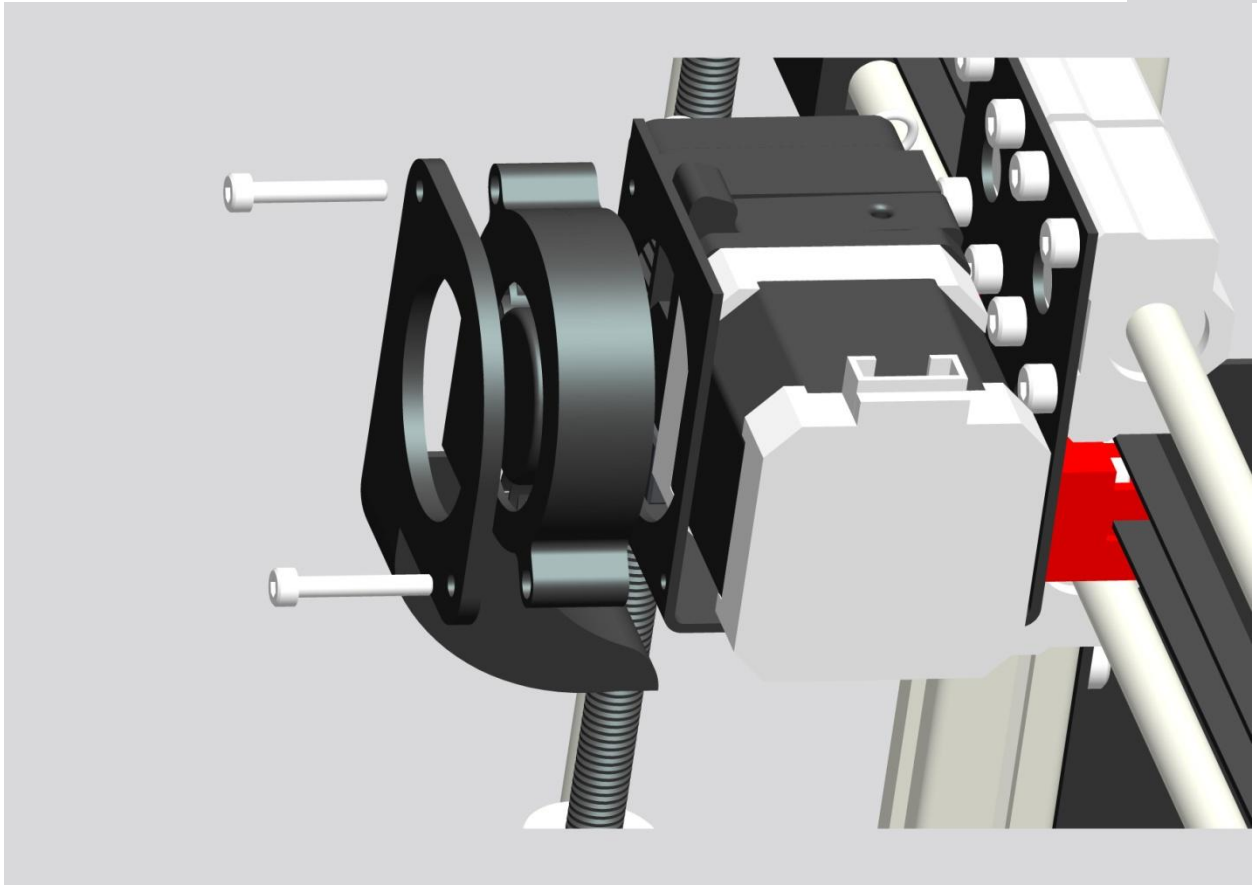




Step 62

Turbine fan 1pcs
M3*20 2pcs



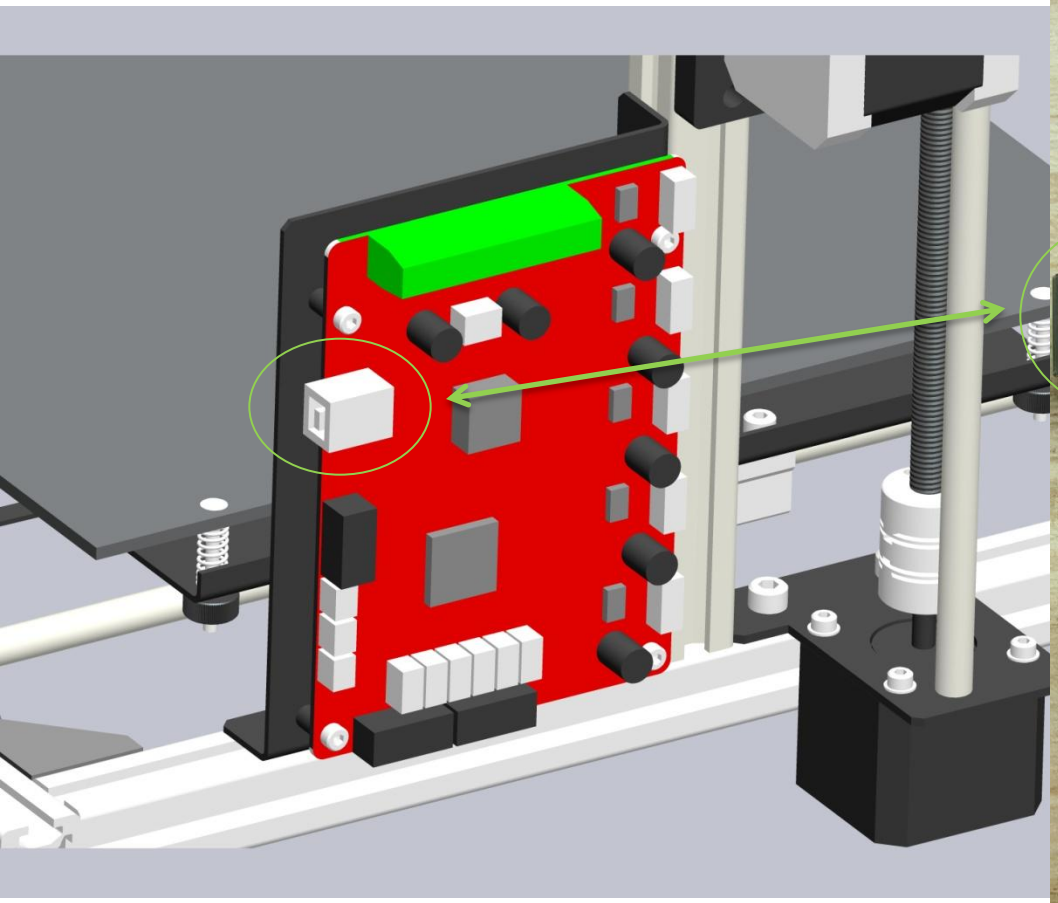


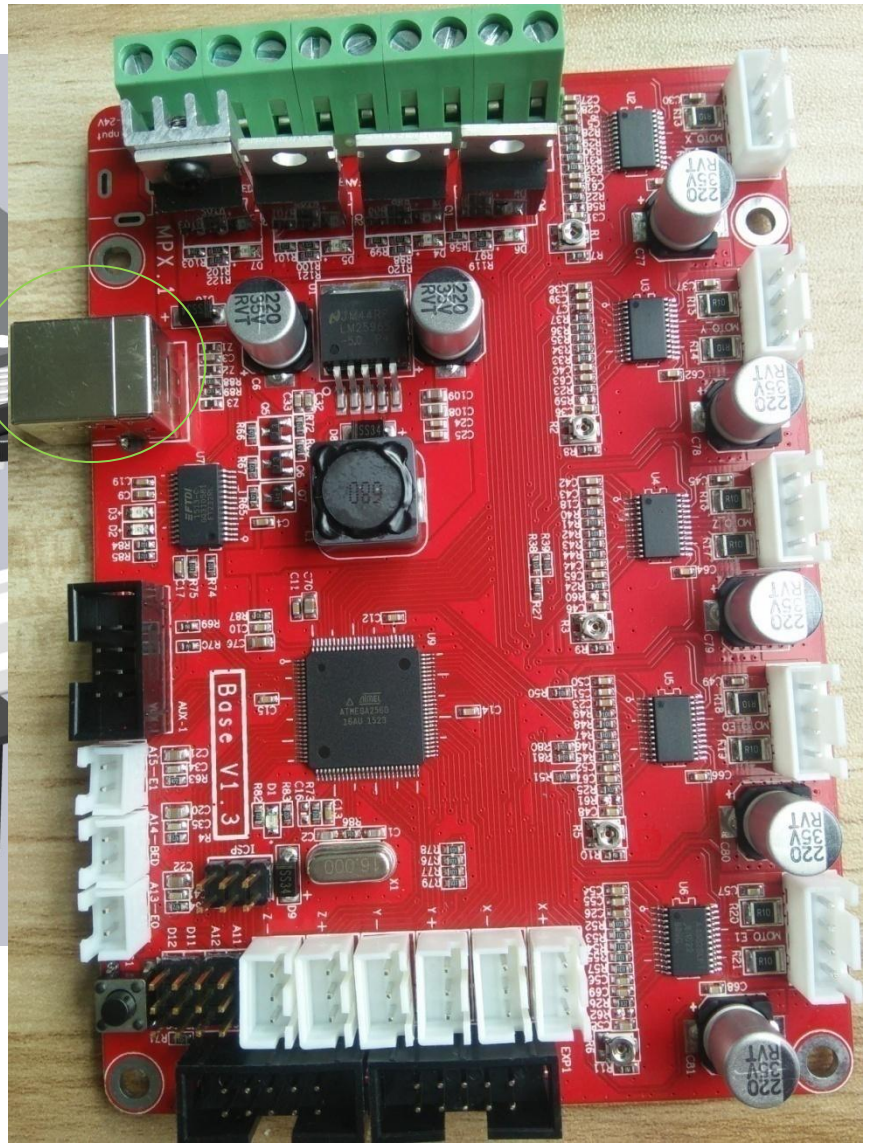
Control Board Assembly

Step 63

M3*5 4pcs

Pay attention to the control board direction,Printing interface is on the upper left.



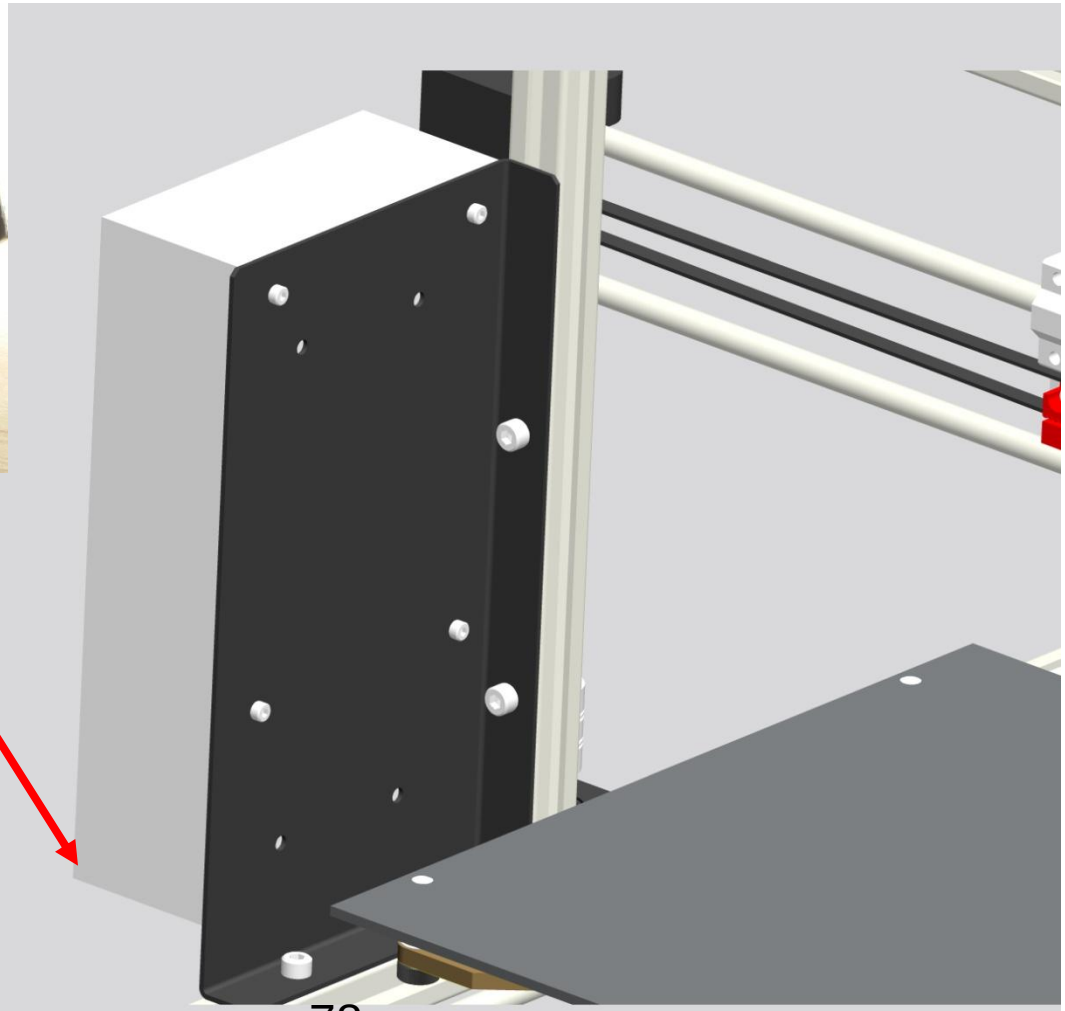


Power Supply Assembly

Step 64

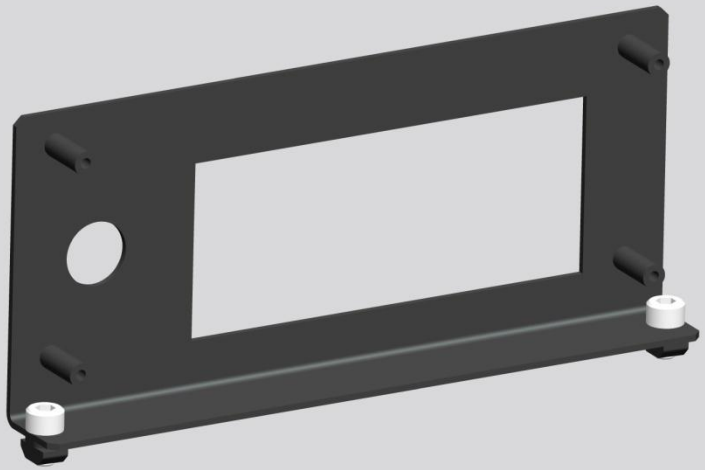
M3*5 4pcs

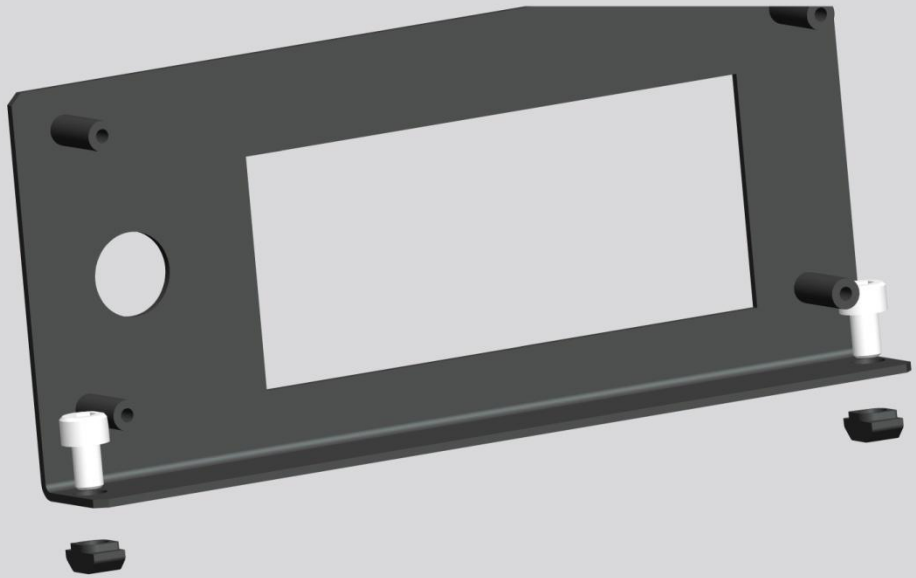
Pay attention to the power supply terminal faces downwards



Step 65

M5*8 2pcs
M5 2pcs

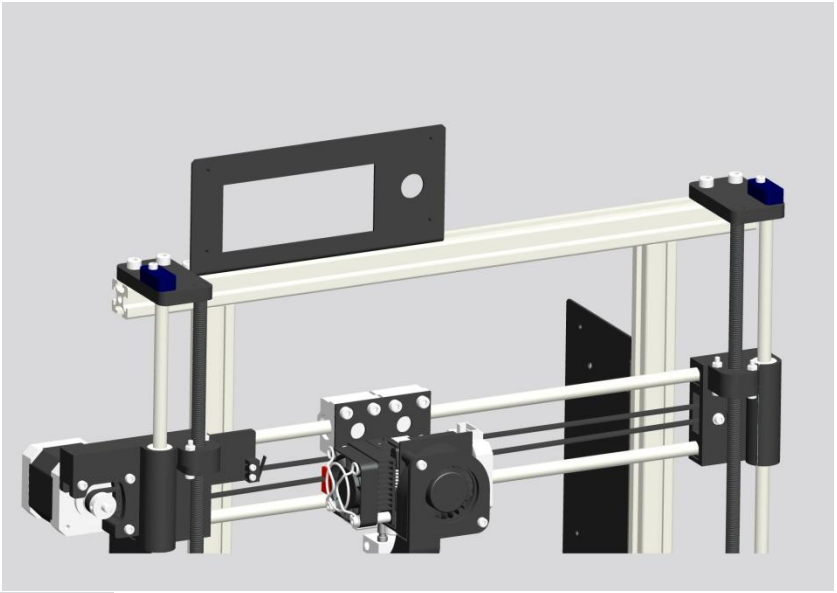


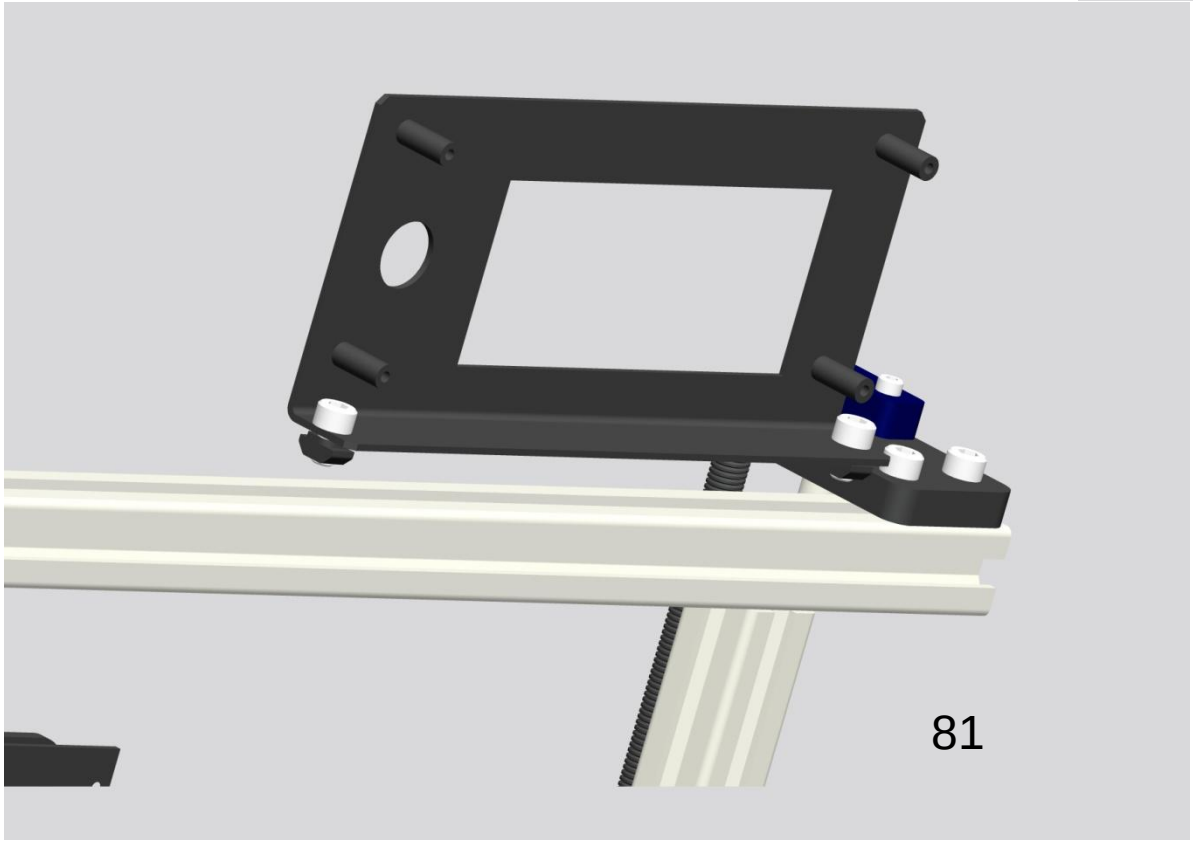


LCD Assembly

Pay Attention to Connection Of LCD and Control Board（Refer to picture on final page）

Step 66

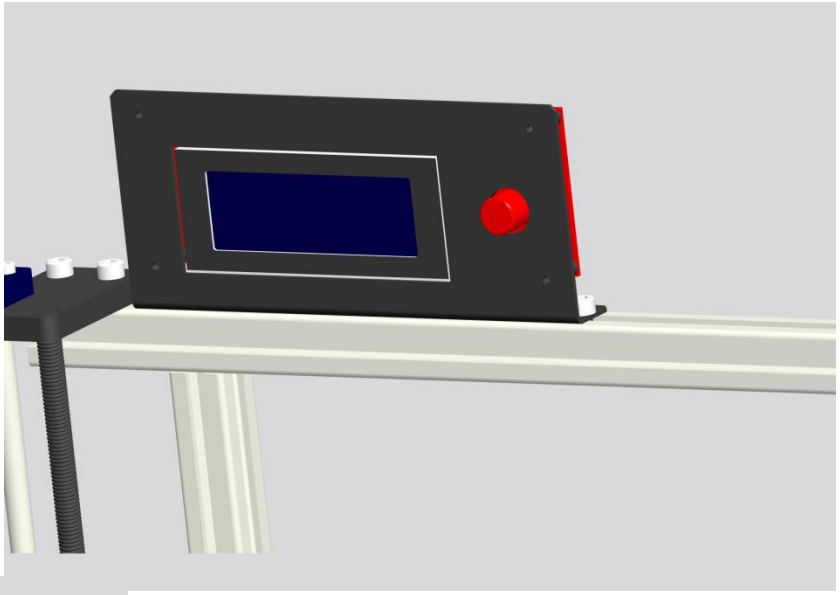


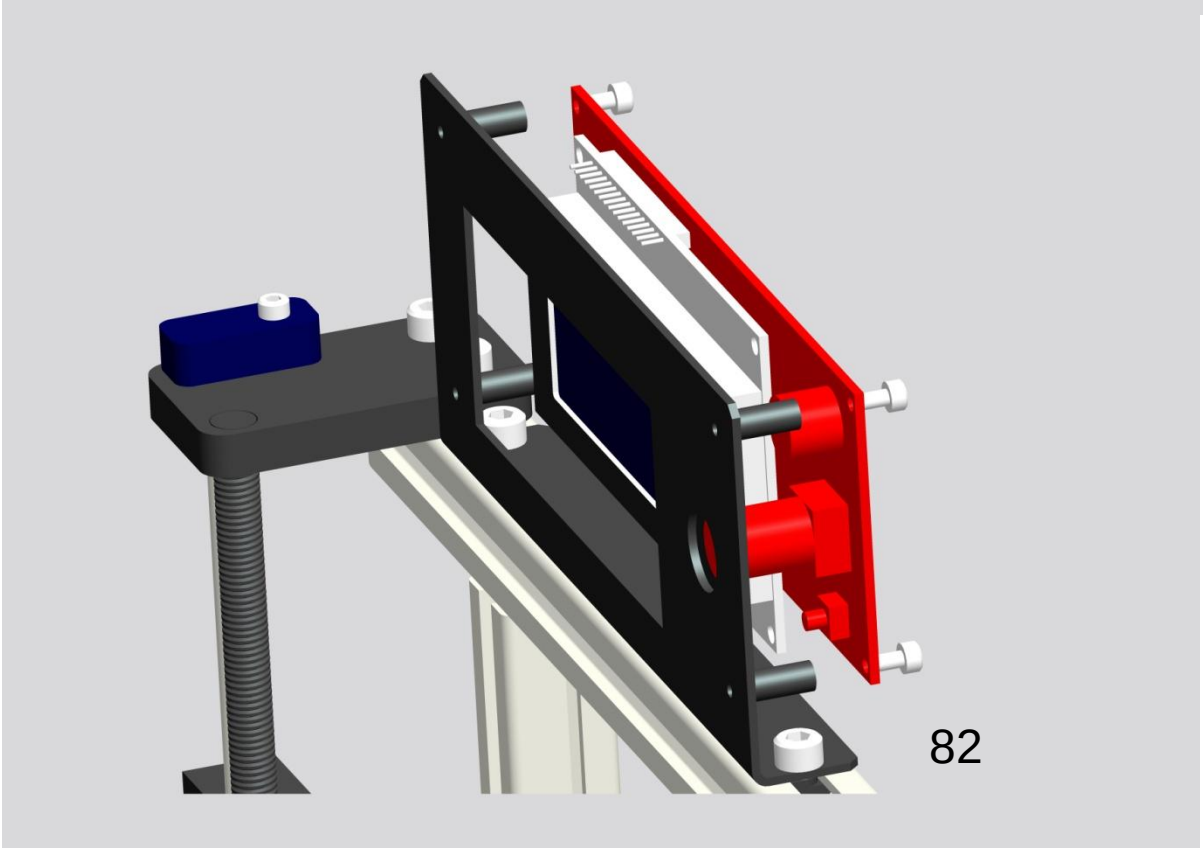


81

Step 67

M3*5 4pcs





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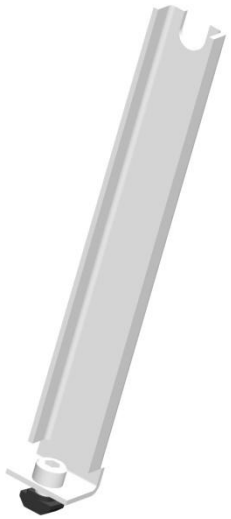
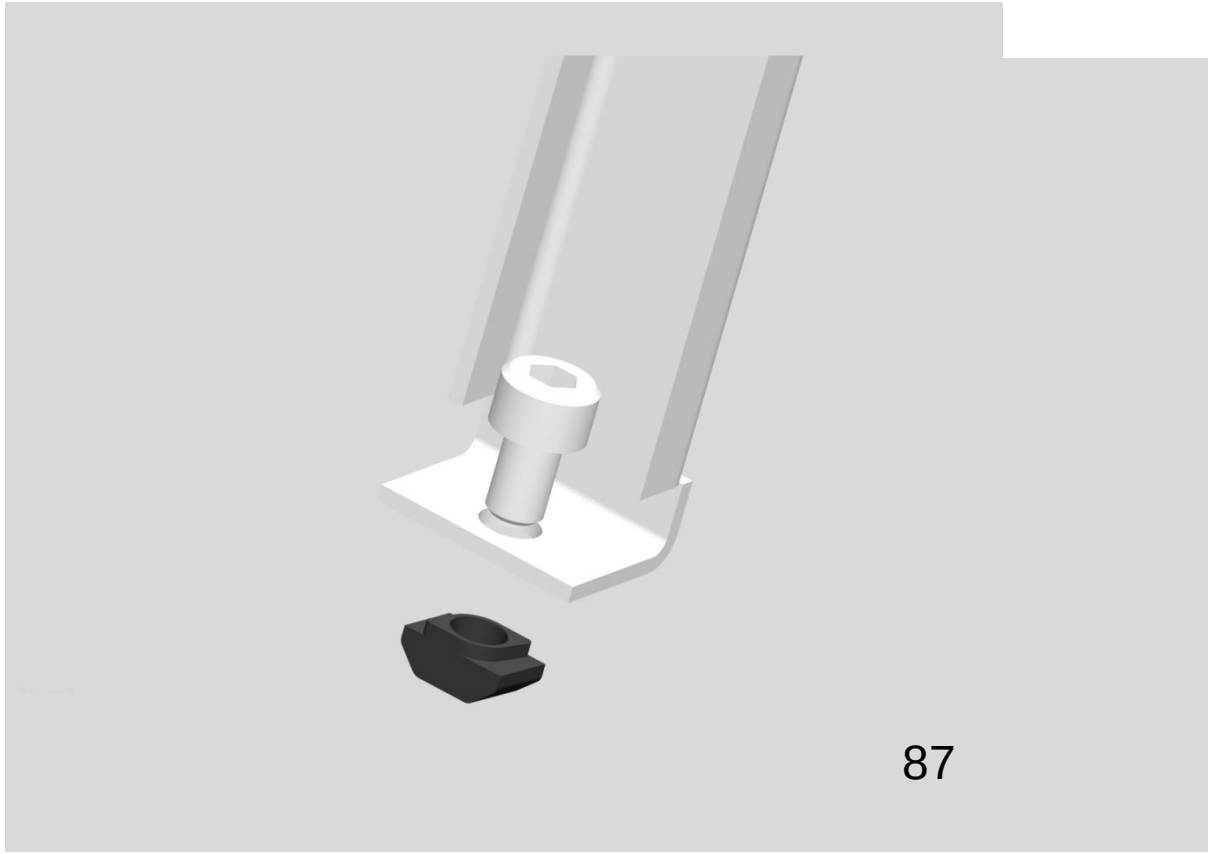
Filament Holder Assembly

Step 68

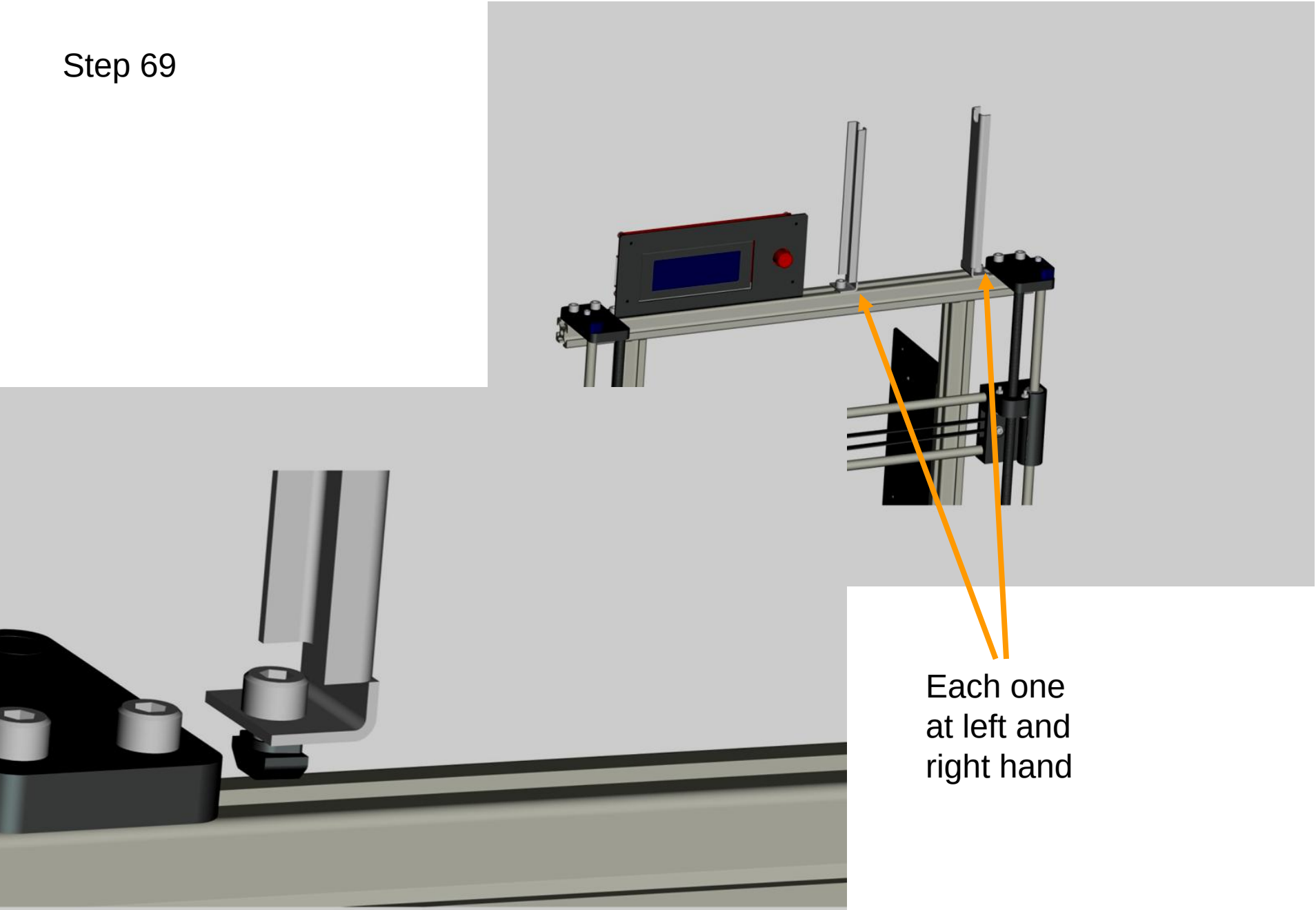
M5*8 2pcs
M5 nut 2pcs

2 groups in total



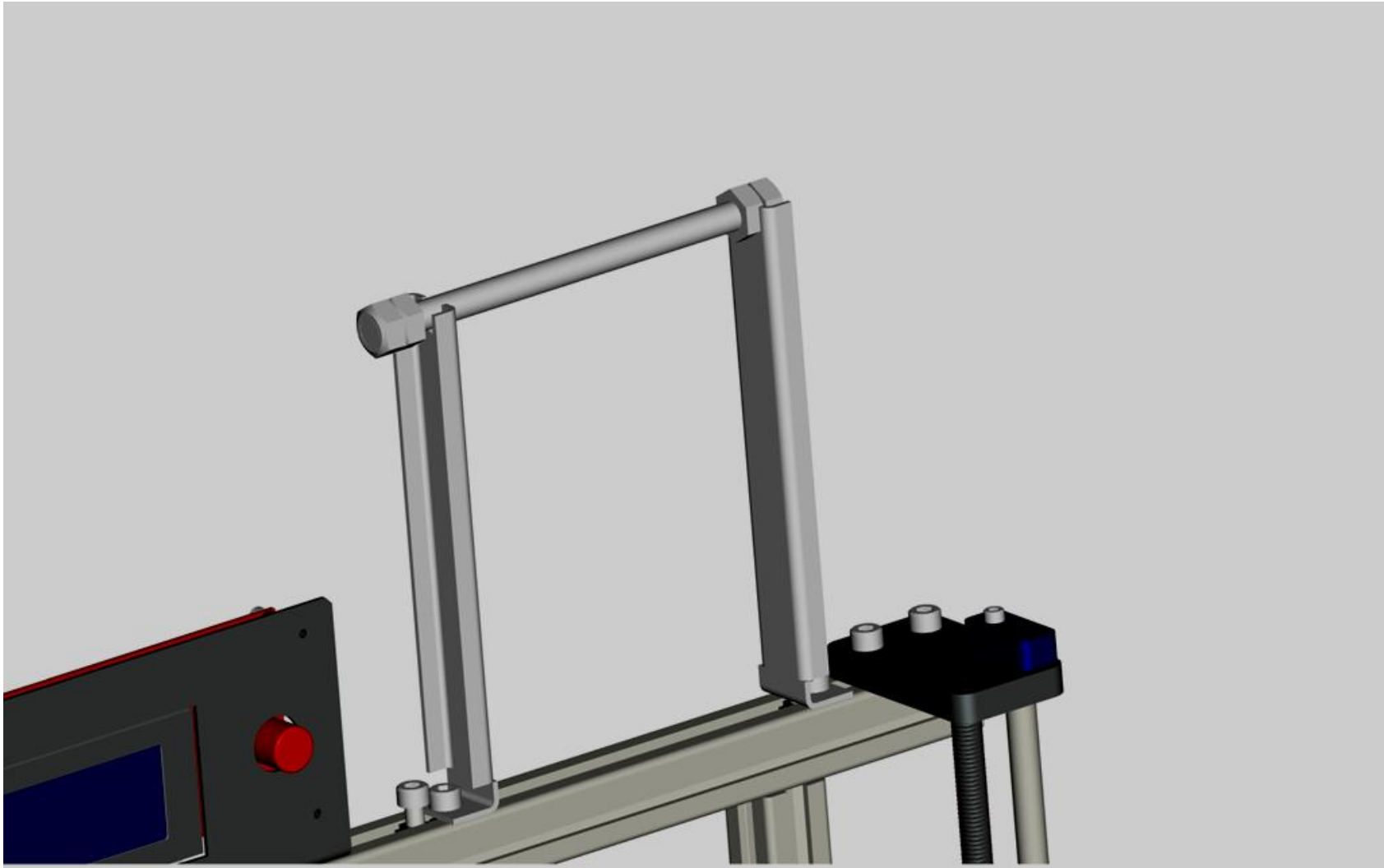


Step 69



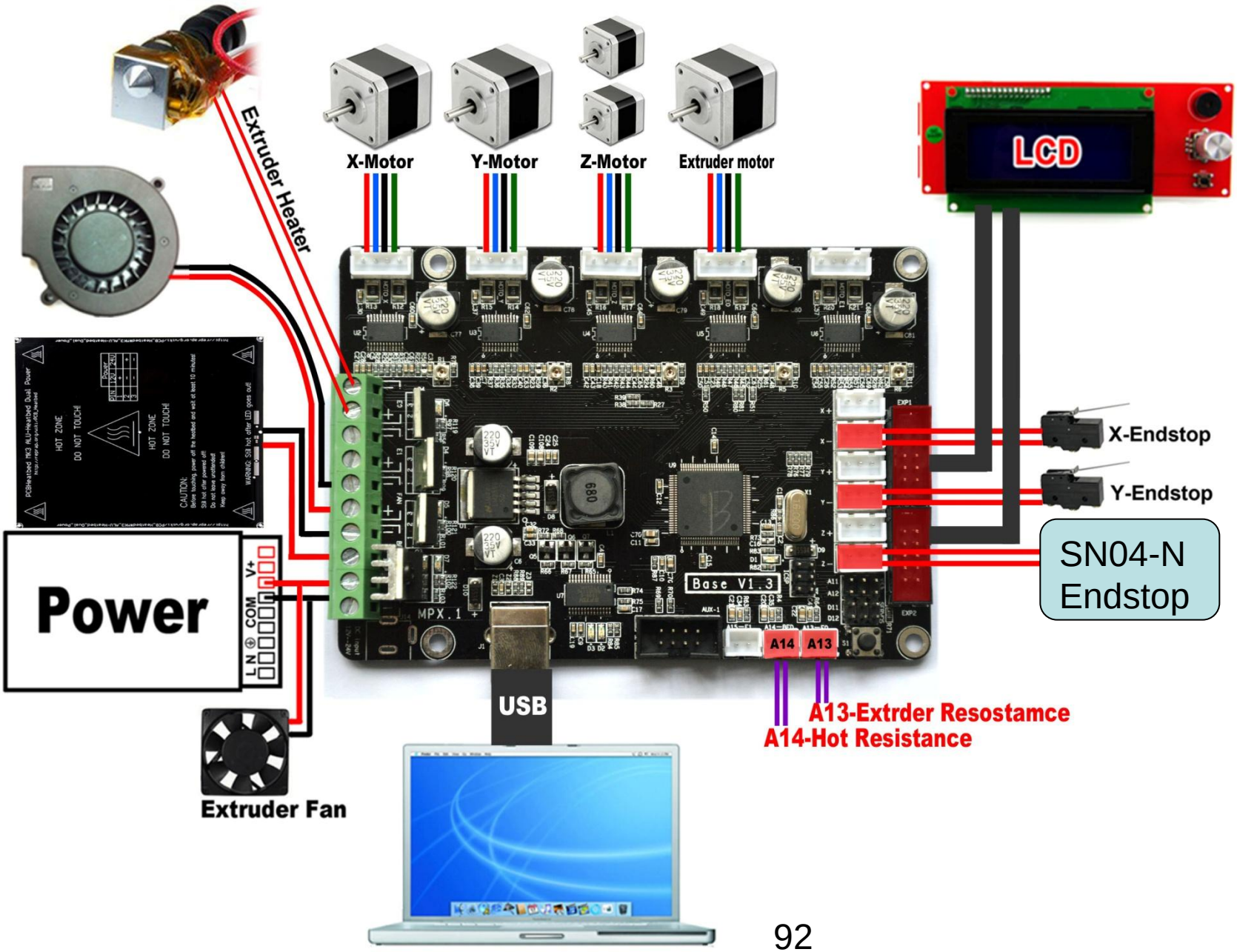
Each one
at left and
right hand

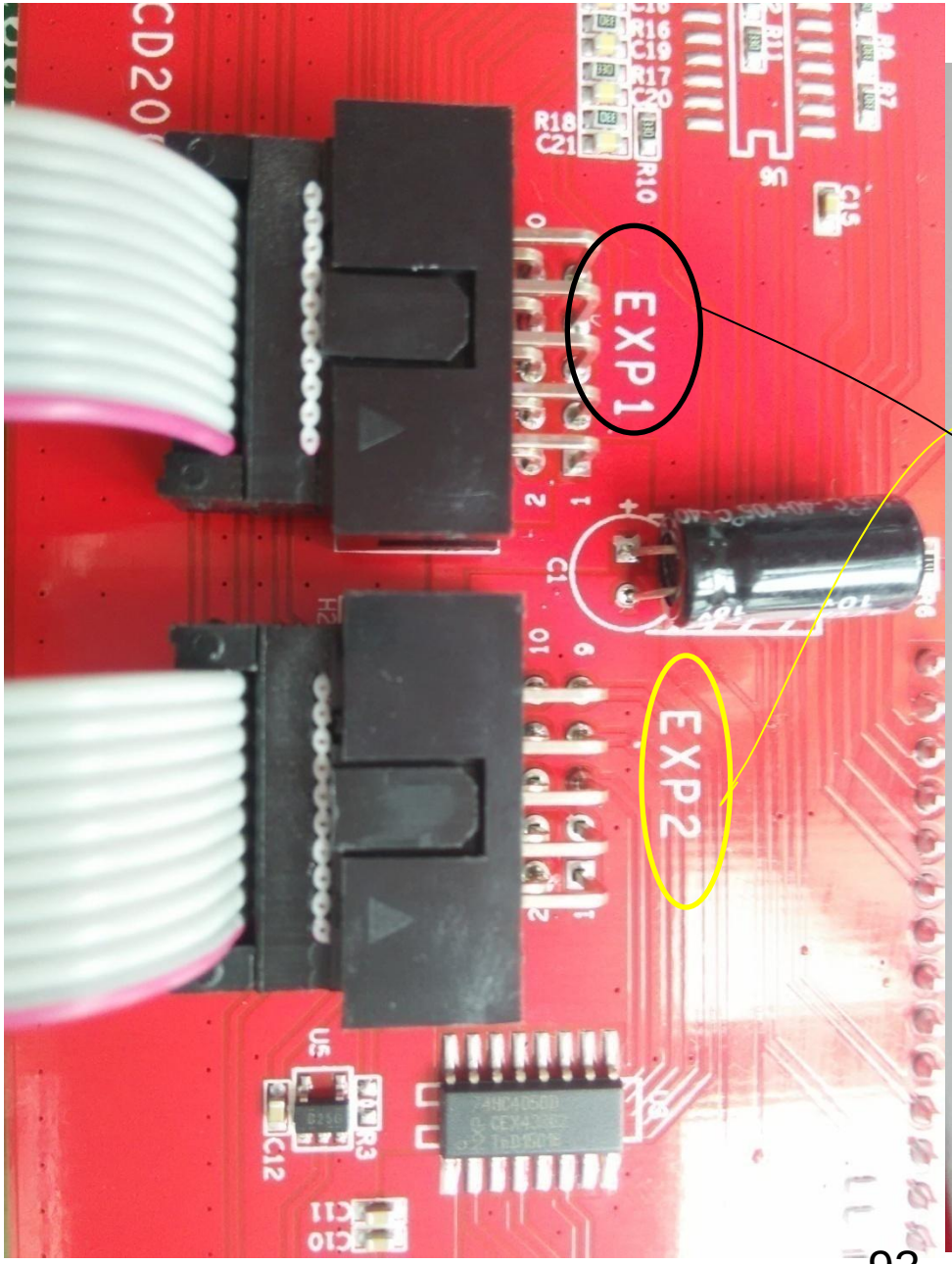
Step 70

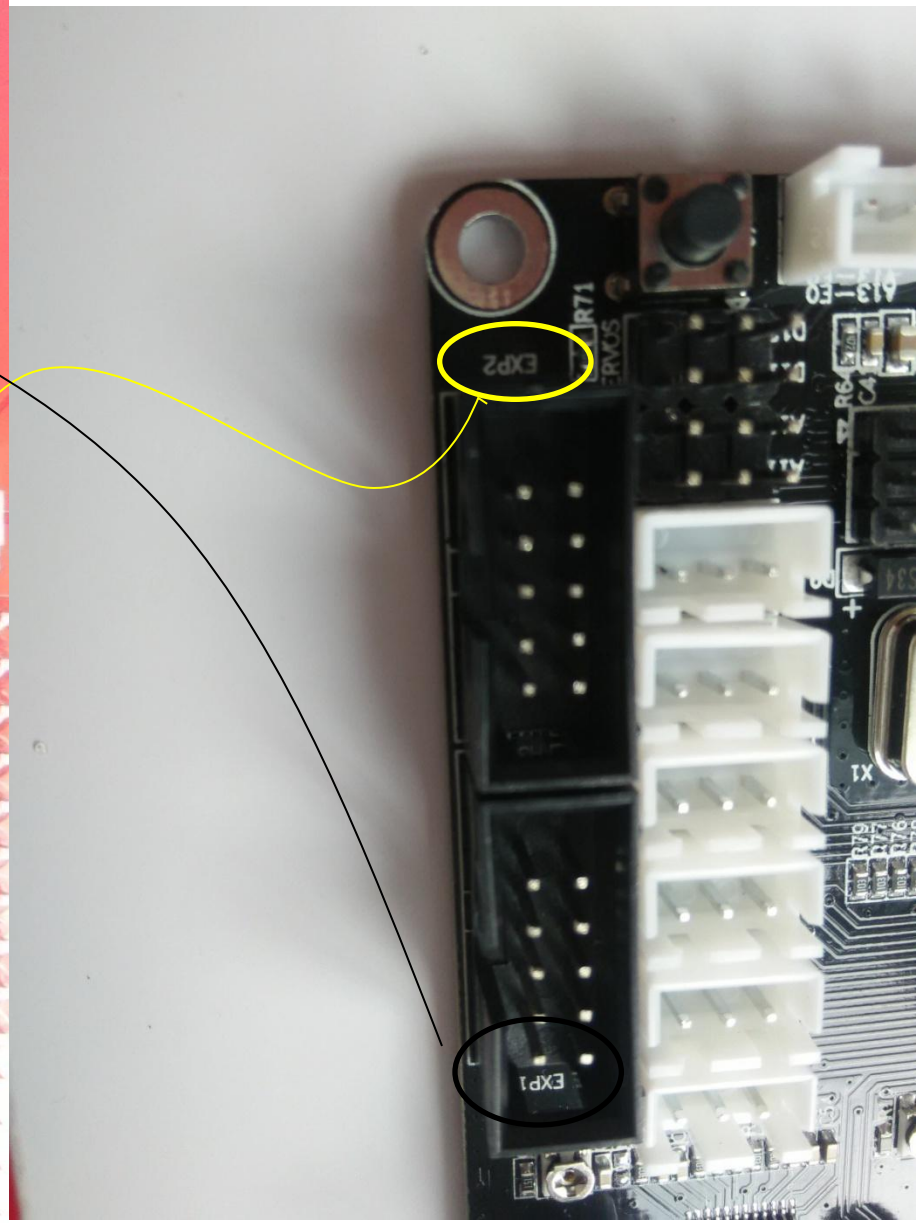


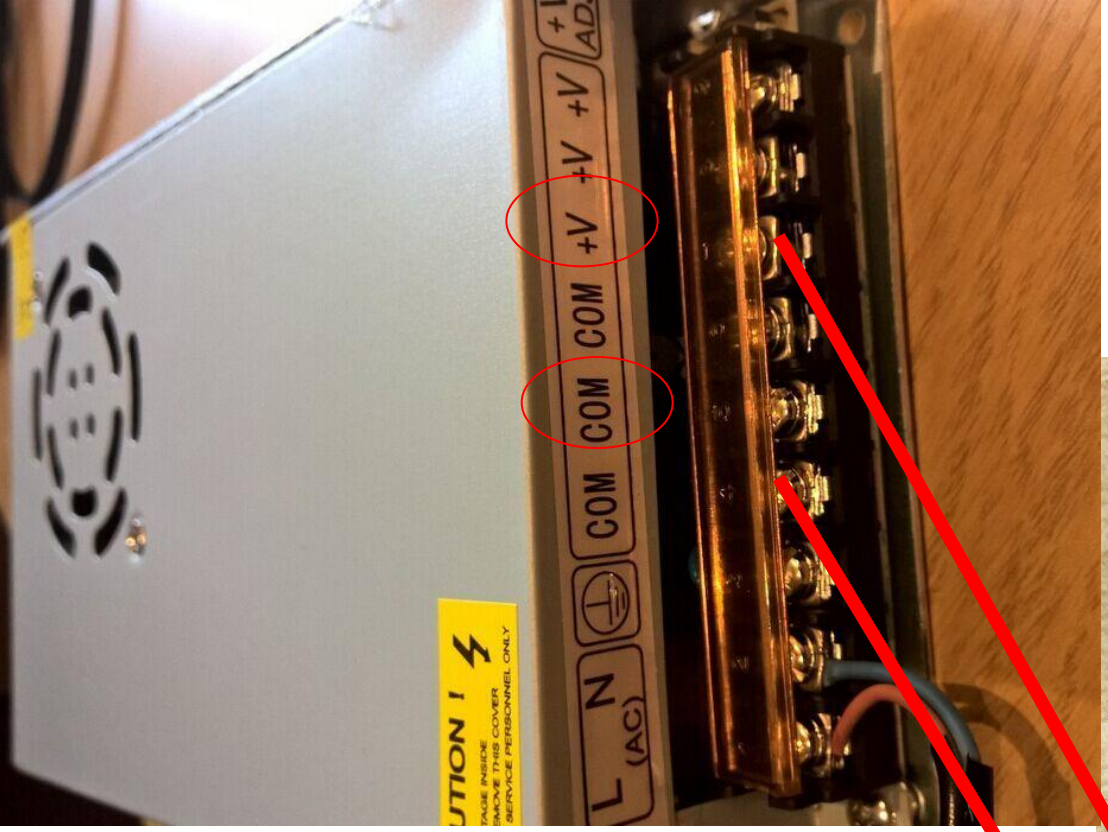
Wiring Instruction

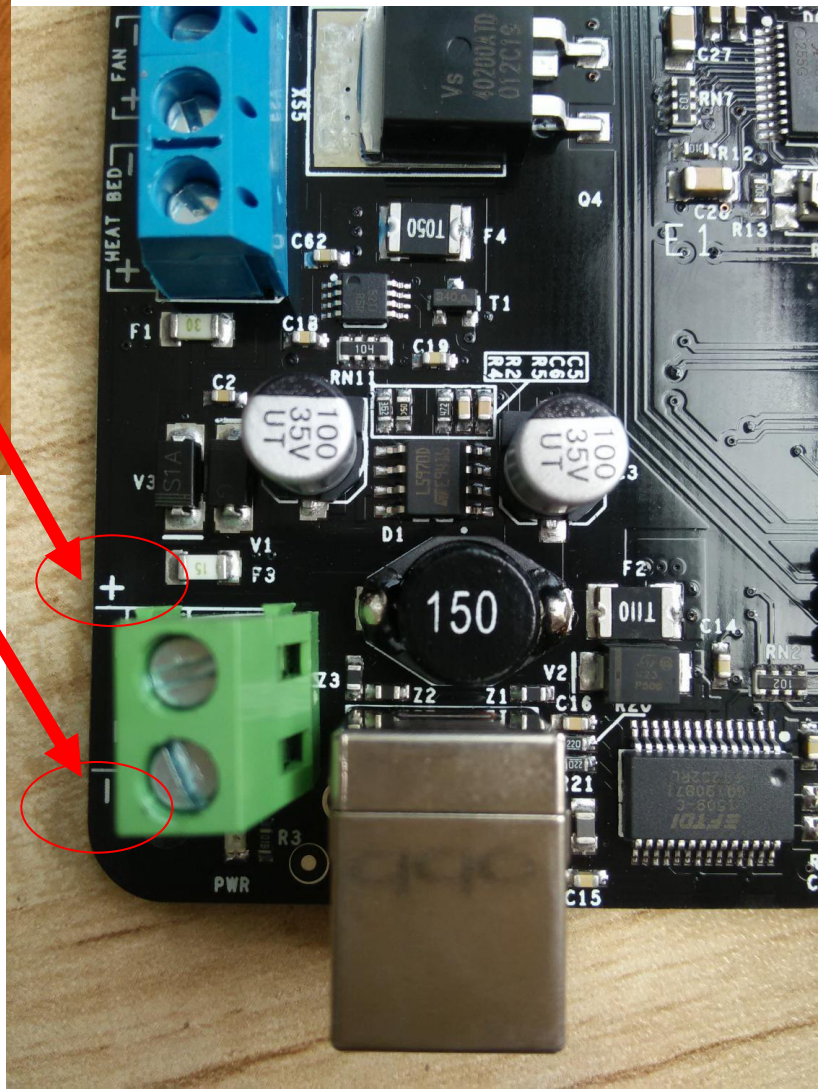
Attention：
When you are wiring, must distinguish the positive and negative pole and make sure connecting position correct. otherwise, it will cause abnormal or defective. If you have any quesitons, please contact us firstly ！


Extruder Heater
X-Motor
Y-Motor
Z-Motor
Extruder motor
LCD
X-Endstop
Y-Endstop
SN04-N
Endstop
Power
L N ⊕ COM V+
Base V1.3
MPX.1
USB
A14
A13
A13-Extrder Resostamce
A14-Hot Resistance
Extruder Fan


EXP1
EXP2


EXP2
EXP1





+V on power supply connects to + on upper left corner of control board.

COM connects to - on upper left corner of control board.

Attention: If the + and - are connected contrary, the board will be defective

Thanks for watching!
We are trying our best to keep improving
If any question or suggestion,
Welcome to contact us at
info@ljelectronic.com
www.hic3dprinter.com

Tech Support: hic_technology@outlook.com
Instructional Videos: https://www.youtube.com/channel/UC9Udtwu2QGX6iml-meV6s_w