Geeetech DP200 3D Printer

User Manual V1.00

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Thank you for choosing Geeetech products!

[Important] Please read the instruction manual carefully before using this machine.

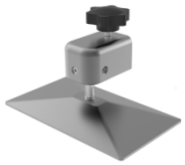
Official site: https://www.geeetech.com/

Email us for technical support: https://www.geeetech.com/contact_us.htm

Facebook Group:

Facebook group

1 Packing list

<table>
<tr><td colspan="2" rowspan="2"> </td><td>  </td></tr>
<tr><td>printing platform*1</td></tr>
<tr><td colspan="2">DP200 3D printer*1</td><td>
resin case*1</td></tr>
<tr><td>
resin*1</td><td>
USB Flash Drive*1</td><td>
rubber gloves*3 pairs</td></tr>
<tr><td>
filter funnel*2</td><td>
release film *2</td><td>
mask*1</td></tr>
<tr><td>
HSYV-5E *1</td><td>
tool* 1 set</td><td>
plastic scraper knife*1</td></tr>
<tr><td>
tweezers*1</td><td>
power supply*1</td><td>
power cord*1 roll</td></tr>
</table>

leveling paper*1	external antenna*1	After-sales contact card*1

2 Attentions

Please check the parts/accessories when you receive the printer (As shown above). If any spare parts are missing, please contact your sales representative.

Please put the machine on a flat surface in a cool, well ventilated environment （room temperature is 10 ℃ ~ 35 ℃）

Keep the printer and its accessories away from children，please make sure to wear rubber gloves to avoid direct skin contact with resin，please do not look directly at the light source and wear goggles if necessary.

A small number of parts of this printer are fragile items (such as release film, 2K forming screen), please be careful when using it.

If the printer will not be used for a long time, keep the resin case and the inner of the printer clean; and keep the printer dry, avoid moisture.

In case of emergency, please turn off the main power of the printer directly to avoid accidents.

Do not disassemble the printer without permission. If there is any problem, please contact after-sales service.

3 Printer Parameters

1) Printing Parameters

Printing technology:	LCD light curing surface forming technology
Printing volume:	115mm*65mm*150mm
XY resolution:	0.047mm（2560*1440）
Z axis precision:	0.001mm
Layer thickness:	0.01~0.2mm
Printing speed:	20mm / h
UV lamp rated power:	40W
Resin:	405nm wavelength ultraviolet resin
File type:	.STL, .ZIP (can be generated by CW, NanoDlp, MonkeyPrinter slicing)
Working environment temperature:	10℃~35℃
Working environment humidity:	30~70%

2) Electrical Parameter

Power input:	110V/220V, 50Hz
Power output:	12V/5A
Connectivity:	USB, WIFI transmission, network transmission
Touch screen:	3.2 -Inch Full-color Touch Screen
LCD screen resolution:	2K forming screen

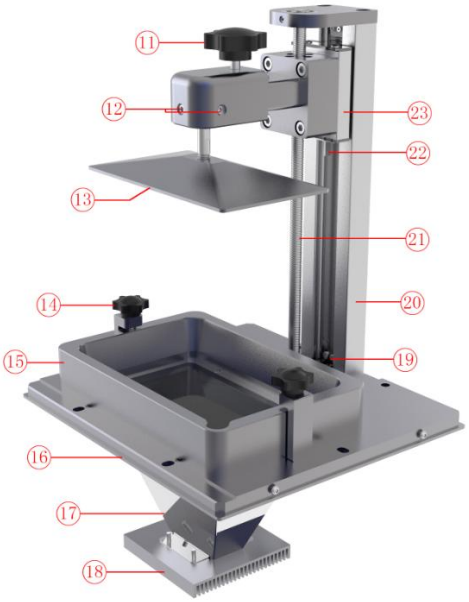
3) Mechanical Parameter

Printer size:	226mm*204mm*408mm
Package size:	298mm*276mm*545mm
Net weight:	about 9kg
Gross weight:	about 10kg

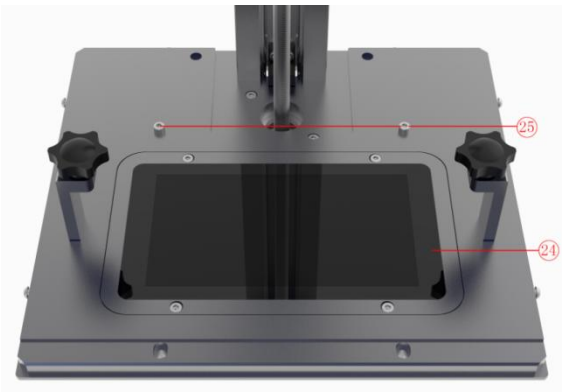
4 Printer Display

(Picture 4-1)

(Picture 4-2)



(Picture 4-3)



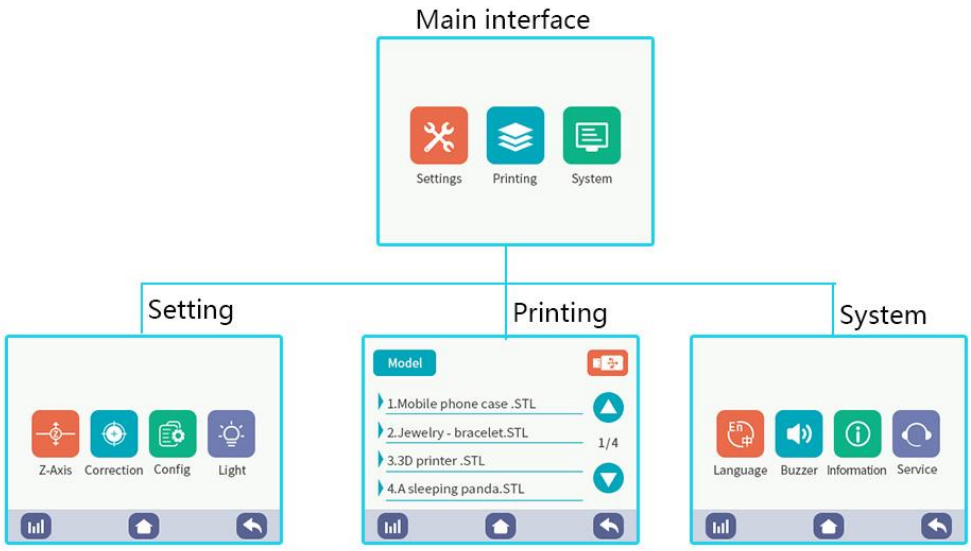
(Picture 4-4)

①upper flip cover; ②upper flip handle slot; ③operating screen; ④power switch; ⑤heat emission hole; ⑥handles; ⑦power input socket; ⑧cable interface; ⑨USB interface; ⑩

external antenna interface; ⑪ printing platform fixed knob; ⑫ leveling stopper screw; ⑬ printing platform; ⑭ resin case fixing knob; ⑮ resin case; ⑯ base; ⑰ light guide cover; ⑱ UV light board radiator; ⑲ bottom photoelectric limit switch; ⑳ guide rail; ㉑ trapezoidal lead screw; ㉒ photoelectric limit switch baffle; ㉓ rail slider and platform bracket suit; ㉔ 2K forming screen; ㉕ resin case limit screw

5 Introduction of touch screen menu

5.1 Tree diagram

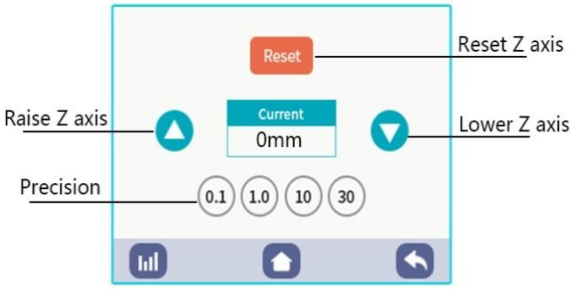


(Picture5-1)

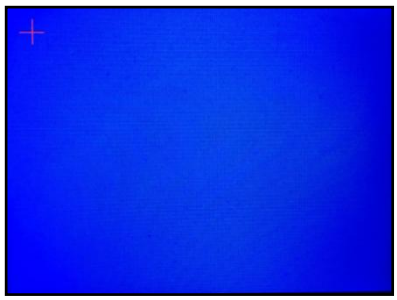
5.2 Main Functions

5.2.1 Setting interface:

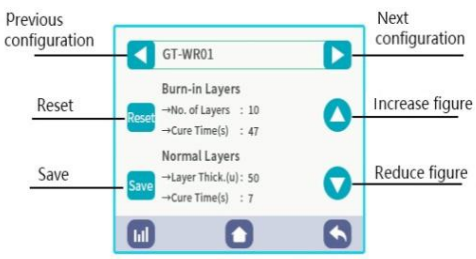
(Picture5-2)



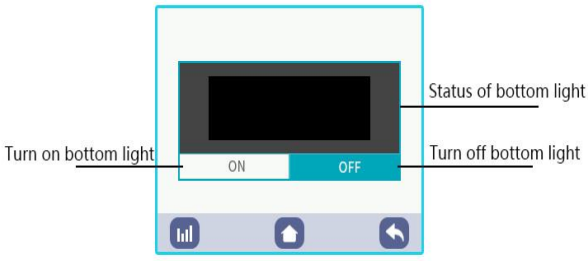
(Picture5-3)



(Picture5-4)



(Picture5-5)



(Picture5-6)

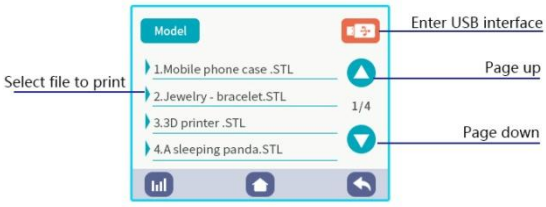
4 submenus at setting interface:

1) Z-axis interface: as shown in Picture (5-3), click **“Reset”** in this interface to return the printing platform to **“Z=0”** position. If you need to raise and lower the Z axis, you first need to select the appropriate accuracy **(0.1 mm, 1.0 mm, 10 mm, 30 mm)**, then click **"raise"** or **"down"** to the required coordinate value as needed.
2) Screen Cali interface: as shown in Picture (5-4), click the calibration icon to enter the screen Cali interface, a total of 5 positions.
3) Configuration interface: As shown in Picture (5-5), click the configuration icon to enter the resin parameter configuration interface. In this interface, the relevant

parameters of the factory-delivered resin have been preset, and need not to be changed during printing. In addition, customized parameter settings can be made if you use other resins **(Note: "Layer thickness" in the normal layer cannot be modified).** After each setting, you need to click **"Save"**, otherwise the parameters will be lost after exiting the interface. Click **"Reset"** to reset the parameters and return to the default settings.

4) Bottom light interface: As shown in Picture (5-6), click the bottom light icon to enter the bottom light detection interface.

5.2.2 Printing interface:



(Picture5-7)

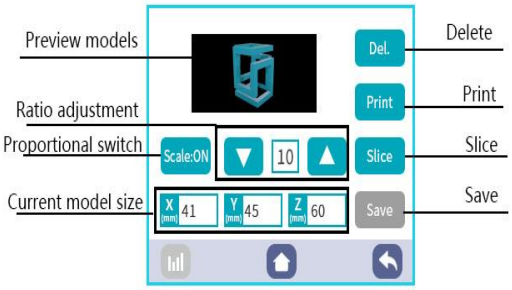
(Picture5-8)

2 submenus at printing interface menu:

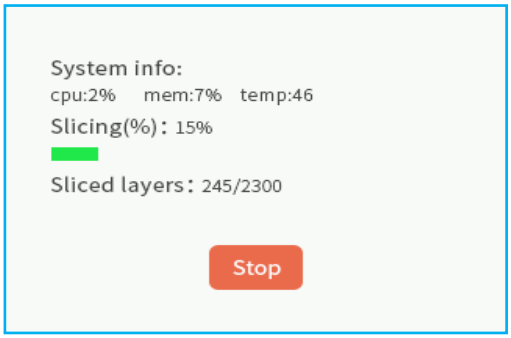
1) Picture (5-7) is **the model list** that has been loaded into the machine memory. Click on the name of the model to be printed in the list directly, and you can enter the model scaling and slicing operation interface, as shown in Picture (5-9). In this interface, you can preview a 3D model. If you need to adjust the scale of the model, you can turn the proportional switch button on or off as needed, select the appropriate value **"1mm/10mm"** in the scaling box, then click the X/Y/Z axis to be adjusted, click the up arrow icon to increase the size or click the down arrow icon to reduce the size. If you don't need to adjust the size, you can click **"save"** directly.

After adjusting the size, click **"Save"** -> **"Slice"**, the machine will start to slice the model **(Note: If you click "Stop" -> "Yes" during this process, the machine will delete the model file. If so, you need to reload the model into the machine memory from the USB)**. As shown in Picture (5-10).

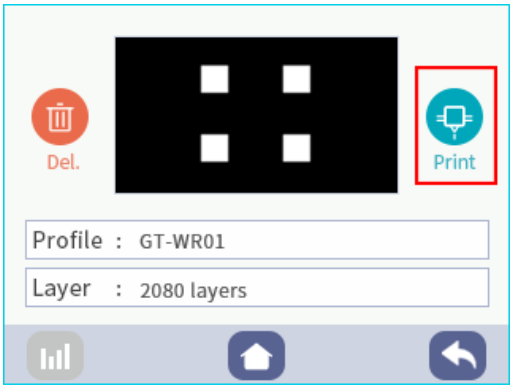
After the slicing completed, click the **"Print"** button on the right, and then the machine will automatically start printing, as shown in Picture (5-11). Current resin parameter configuration and total model layers can also be viewed below. If the resin is not enough to complete model printing or you want to check that the model is glued to the printing platform, Click the **"pause "**button, as shown in picture (5-12), (5-13). You can slowly replenish the resin into the resin box or observe the model directly.



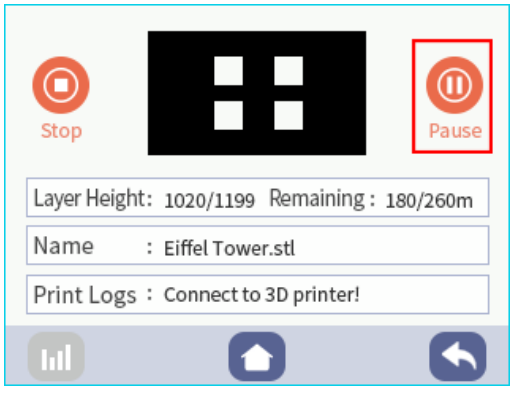
(Picture5-9)



(Picture5-10)



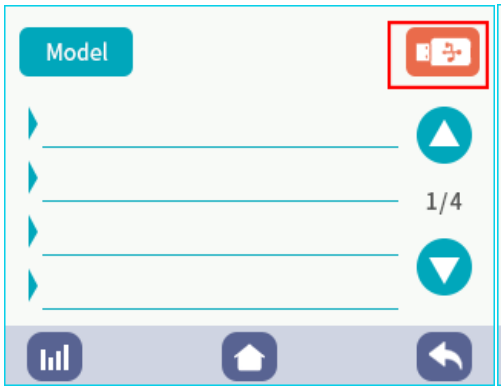
(Picture5-11)



(Picture5-12)

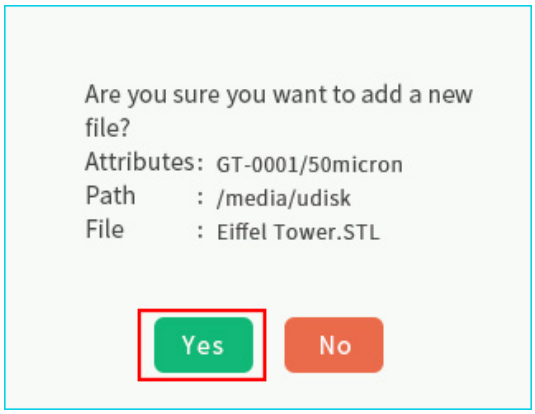
(Picture5-13)

2) **USB model interface:** If there is no model in the print interface. You need to insert the USB into the USB port on the back of the machine. Click the **"USB"** icon to enter the USB interface and select the model file to be loaded. The printer shows whether to create a New file, click **"Yes"** to load the model in USB into the printer internal storage **(Note: the loading time depends on the complexity of the imported STL model)**, so that you can load the STL file in the internal storage even after unplugging USB. See picture (5-14) ~ (5-17).

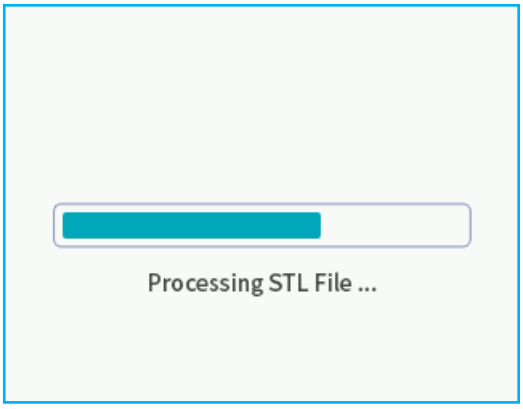


(Picture5-14)

(Picture5-15)

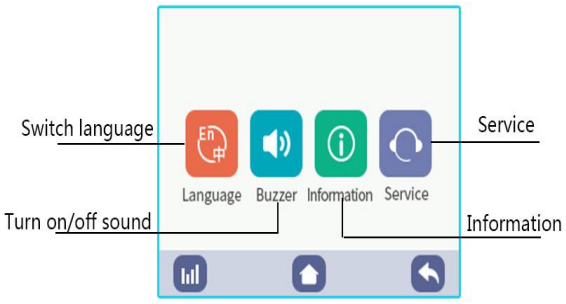


(Pictur5-16)

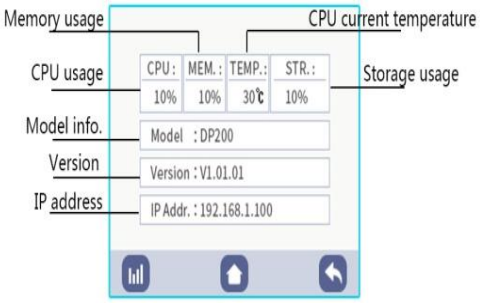


(Picture5-17)

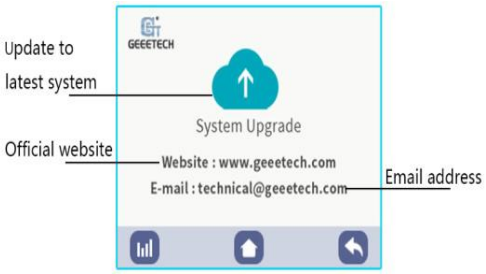
5.2.3 System interface:



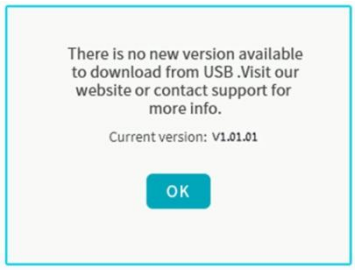
(Picture5-18)



(Picture5-19)



(Picture5-20)



(Picture5-21)

4 submenus at system interface:

1) Language: Click to switch between Chinese/English.

2) Sound: Click to turn the button sound on/off.

3) Information: as shown in Picture (5-19). This interface displays basic information about the machine.

4) Service: After downloading the latest system file from the official website and

copying it to the USB driver, insert USB into printer to upgrade operation system in this interface, as shown in Picture (5-20).If the machine is already the latest system, as shown in Picture (5-21). **(Note: After each upgrade, you need to clear the browser cache before using the computer web.)**

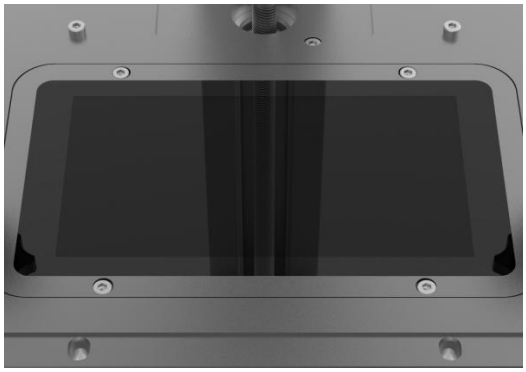
6 Printing instruction

6.1 Preparation before printing

1) Unpack the machine and then tear off the protection film outside.
2) Take off the cover, put out the EPE packing and the printing platform inside the printer to check whether it is clean. **(Note: To ensure quality, each machine will be tested before leaving the factory, and there may be slight scratches on the bottom of the printing platform during transportation, but it will not affect normal use of the machine and model printing effect.)**
3) As shown in Picture (6-1), Loosen the black fixing knob on the left and right sides of the 2K forming screen and take out the resin case.

   As shown in Picture (6-2).Check whether the upper surface of the forming screen is clean and free of foreign matter, and check whether the release film on the bottom of the resin case is damaged. (The printing platform and resin case are placed outside the machine at this time.)

(Picture6-1)



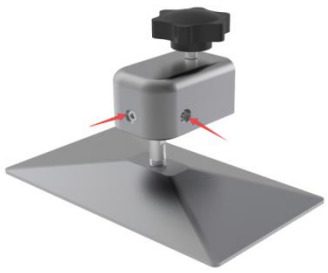
(Picture6-2)

4) After plugging in the power supply to the back of the machine, turn on the power switch on the front of the machine. as shown in Picture (6-3)

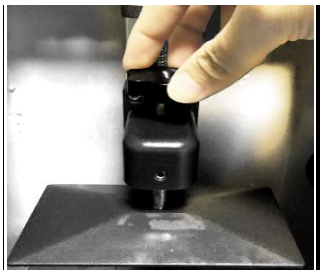
(Picture6-3)

6.2 Leveling

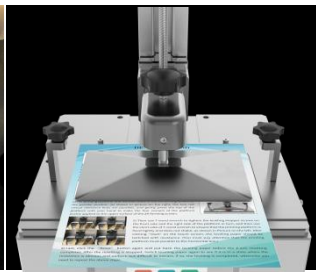
1) As shown in Picture (6-4), use a 7-word wrench to loosen the leveling stopper screws on the front side and the right side of the printing platform suit until the printing platform can rotate freely.
2) As shown in Picture (6-5), Picture (6-6) put a piece of A5 leveling paper on the 2K forming screen. Loosen the black fixing knob above the printing platform kit, and install it on the platform bracket, tighten the fixing knob. If the platform bracket position is too low and the print platform kit cannot be inserted, you can enter the picture (6-7) interface and select **“10mm”** or **“30mm”** precision to raise the Z axis to the pluggable position.
3) As shown in Picture (6-7), click **“Reset”** on the touch screen homepage, wait for the Z-axis to fall and stop automatically.



（Picture 6-4）

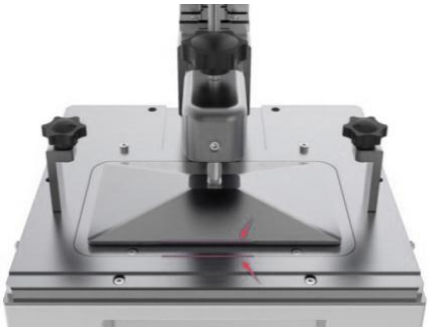


（Picture 6-5）

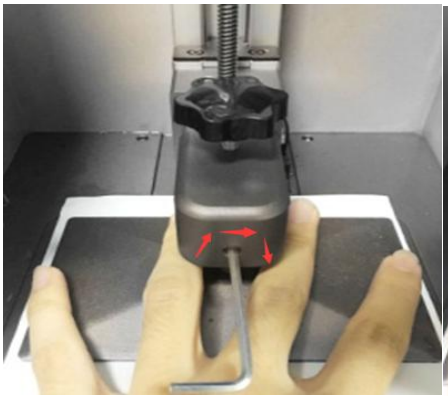


（Picture 6-6）

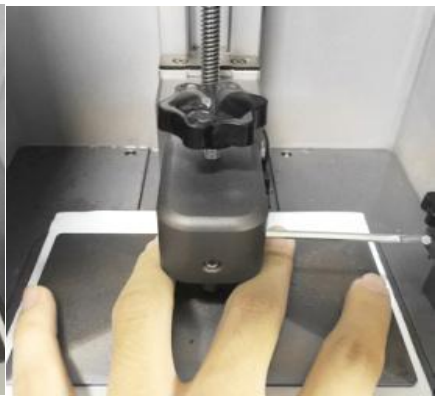
（Picture 6-7）



（Picture 6-8）



（Picture 6-9）



（Picture 6-10）

4) After the Z-axis resetting completes, manually adjust the four sides of the printing platform and the four sides of the 2K forming screen to the parallel position as shown in Picture (6-8), the two red virtual reference lines are parallel, and gently press the top of the platform with your hand to make the four corners of the platform evenly applied to the upper surface of the 2K forming screen.

5) Then use 7-word wrench to tighten the leveling stopper screws on the front side and the right side of the platform in turn, and then use the short side of 7-word wrench to ensure that the printing platform is fixed tightly and does not shake, as shown in Picture (6-9), (6-10). After clicking **"reset"** on the touch screen, Can twitch A5 leveling paper with obvious resistance but uniformity. **(Note: This step must pay attention to the printing platform can't be high side and low side)**

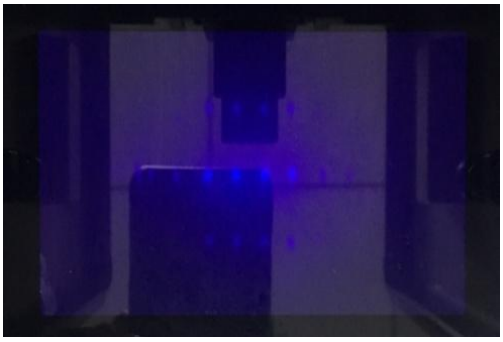
6) Last, click the **"Reset"** button again and put back the A5 leveling paper before the Z-axis resetting completes. After the resetting is stopped, twitch A5 leveling paper again to see if it is in a state where the resistance is obvious and uniform

but difficult to extract, if so, the leveling is completed, otherwise you need to repeat the above steps.

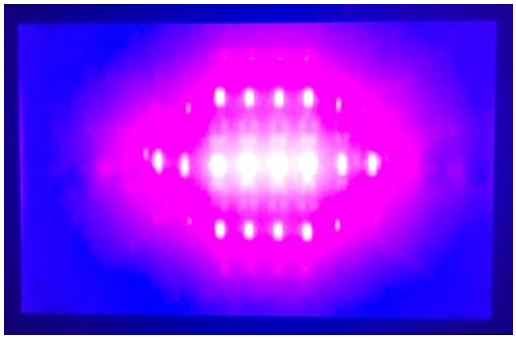
6.3 Check UV lamp

1) After the leveling is completed, raise the Z axis to approximately 100 mm and check that the UV lamp and the 2K forming screen are working properly.
2) As shown in Picture (6-11), turn on the UV light detector switch.
3) Wait for about 1 second, the image on the 2K forming screen changes from Picture (6-12) to Picture (6-13). If a bright rectangle can be displayed completely without missing corners, the UV lamp and 2K forming screen are normal.

(Picture6-11)



(Picture6-12)



(Picture6-13)

After finishing those checks and leveling mentioned above, Check that the release film on the bottom of the resin case is not damaged and is in a tight state. If normal, push the resin case from the front of the machine into the

base until it touches the resin case limit screw on the bottom, and finally tighten the fixing knobs on both sides, the resin box should not be loosened after tightening. As shown in Picture (6-14).

(Picture6-14)

7 First print

In order to ensure the first print is successful, please check before printing:

① Whether the Z axis works normally.

② Whether the UV lamp and 2K forming screen work normally. Confirm that the 2K forming screen is clean and free of stains.

③ After the Z-axis is reset, ensure that the distance between the printing platform and the 2K forming screen is that the A5 leveling paper has a uniform resistance and it is difficult to extract A5 leveling paper.

④The printing platform and the edge of the 2K forming screen are in parallel position, not skewed, same height on both sides.

⑤Before the resin case is loaded into the machine check whether the bottom release film is not damaged and is in a tight state.

After the resin case is loaded into the machine, check whether the fixing knobs on both sides fix the resin case tightly and there is no looseness.

⑥ Check if the resin is in the shelf life, no abnormal phenomenon such as precipitation and agglomeration.

7.1 Device printing

Put on rubber gloves and masks, Shake the resin well and then slowly pour the resin into the resin case to about 1/3 of the height of the box click **"reset"**, Click **"reset"** again to drain the excess bubbles on the bottom of the printing platform. Click **“Print”** to enter the printing interface.

1) If there is no model in the print interface, you can import the model according to the relevant function introduction page in **Chapter 5**. **(Click to jump to that chapter)**

2) If you already have a model in this interface, click on the name of the model to be printed in the list directly, and you can enter the model scaling and slicing operation interface, adjust the model scale as needed, click **"Save"** -> **"Slice"**, the machine will start to slice the model **(Note: You need to re-save and slice each time you adjust the scale of the model)**. After the slicing completed, click the **“Print”** button on the right, and then the machine will automatically start printing. During the printing process, close the flip cover and place it in a cool, well-ventilated place. And then, just wait for the model print to complete.

7.2Model processing

(Picture7-1)

(Picture7-2)

1) After printing is finished, wait until the residual resin on the printing platform no longer drops, Picture (7-1). And loosen the fixing knob on the platform counterclockwise to remove the entire printing platform. As shown in Picture (7-2). Use scrapper knife to gently shovel the model. It is recommended to start from the corner that is the easiest to pick up. As one corner of the model is picked up, the whole model will fall off accordingly. Then clean the model with water/alcohol.

2) In case of printing failure or the first layer is not sticky, the resin may leave residues in resin case. Therefore, it is recommended to filter the resin in the resin case with the funnel after each printing and then rewind back into the resin bottle as shown in Picture (7-3).

   If you skip this step, the 2K forming screen may be crushed during the next printing when Z-axis drops. After the resin is filtered and poured back into the resin bottle, a small amount of resin remaining in the printing platform and the resin case can be wiped clean with tissue.

(Picture7-3)

8 FAQ (Frequently Asked Questions) and Machine maintenance

8.1 FAQ (Frequently Asked Questions)

Model doesn't stick

1) The exposure time of first layer is not enough, you need to increase the first layer exposure time, increase the number of layers.

2) The contact area between first layer of models and the printing platform is too small. You need to add base support when slicing.

3) Bad leveling, the first layer is too high or the platform is not leveled.

4) Printing platform or resin case is loose and not tightened.

5) Move the machine during printing, or the machine is on an unstable place.

6) The release film on the bottom of the resin case is loose after long-term use, and the fixing screws need to be tightened or replaced.

7) The resin is deteriorated and there are too many impurities, so it needs to be replaced.

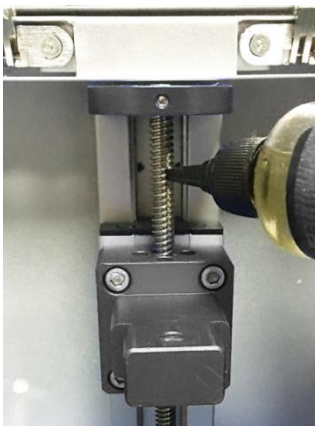
8) The surface of the 2K forming screen is stained and needs to be cleaned.

8.2 Maintenance after printing

1) If there is a solidified residues attached to the release film in the resin case after printing, use a plastic scrapper knife to remove the sharp film. But you cannot use sharp tools such as a metal blade to do that in case of scratching the case. As shown in Picture (8-1).

(Picture8-1)

2) If the Z-axis makes an abnormal sound during printing, apply some lubricant to the Z-axis screw. As shown in Picture (8-2).



(Picture8-2)

3) When the model is taken from printing platform, pay attention not to slip the platform, so as not to crush 2K forming screen below.

4) If the machine does not print within 24 hours, the resin in the resin box is filtered through a filter paper to remove the residue, and then poured back into the resin

bottle. As shown in Picture (8-3).

(Picture8-3)

5) Clean inside of the printer after each time of using, including the printing platform, 2K forming screen, resin box, etc.

6) If you need to change the color of resin, clean out the original resin in the resin case and then pour the new resin in.

9Maintenance instruction

9.1 Replace release film

1) Remove the new release film and tear off the protective film on both sides of the release film.
2) Unscrew all the screws on the bottom of the resin case. Remove the release film presser at the bottom of the resin case **(Note: It is normal to be in a relaxed state after the release film is removed)**. Unscrew all the screws on the platen.
3) Before replacing the old release film, clean the residual resin on pressure clamp and resin case with tissue dampened with alcohol or water. As shown in picture (9-1), (9-2).

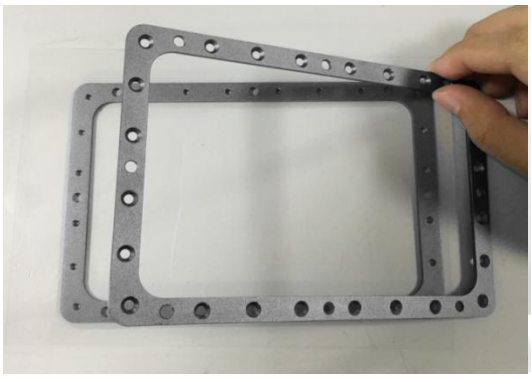
(Picture 9-1)

(Picture 9-2)

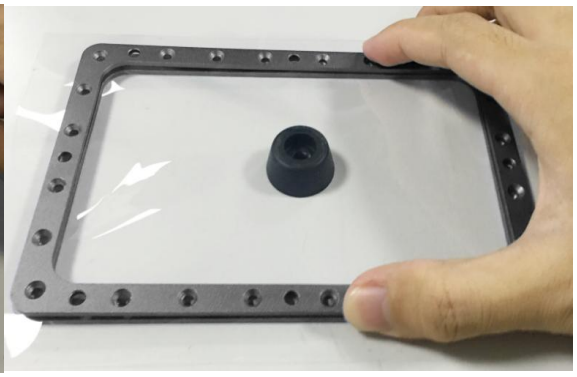
4) Install a new release film: Place a new release film between the upper and lower clamps, paying attention to the stacking sequence of the clamps, with the counter bore side facing up. The release film needs to have a certain amount of slack during installation. Placing a rubber foot pad of about 12 mm thick or other round-cornered items of similar size under the release film can make installation much easier. As shown in Picture (9-3), (9-4).

Use tweezers or other sharp objects to puncture the release film in the clamp fixing hole. When tightening the screw, always press down on clamp to make the middle of the release film swells a little bit. And the screws are installed in order of diagonal crossing. Install all the remaining screws. See picture (9-5).

After you finish the installation, check if the release film is loose or not. Then use scissors to cut off the excess release film on the outside of the clamp. See picture (9-6).

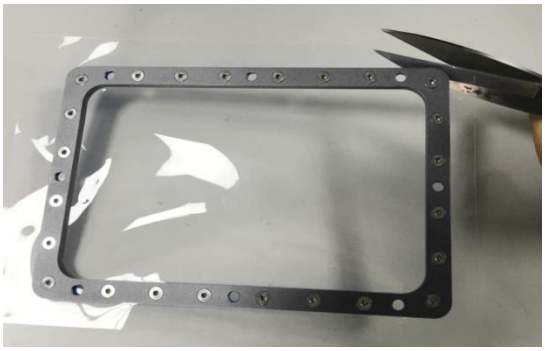


(Picture 9-3)



(Picture 9-4)

(Picture9-5)



(Picture9-6)

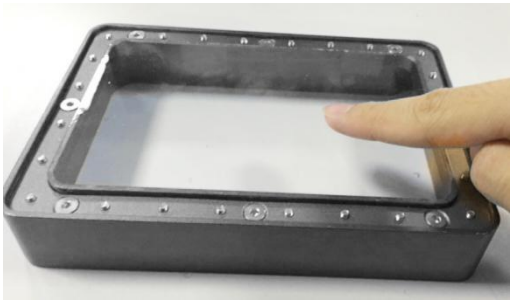
5） Put the replaced release film clamp back to the bottom of the resin case, the counter bore facing up. See picture (9-7).Pierce the release film inside the clamp fixing hole with tweezers or other sharp objects, and mount the fixing screws diagonally to the resin case. See picture (9-8).

Don’t tighten the screws completely. Adjust them in a clockwise direction and tighten them firmly after all the screws have been screwed on, so that the whole release film can be parallel with the resin case. Do not directly fix one side of the screw, which will easily cause damage to the release film.

(Picture9-7)

(Picture9-8)

6） Check whether the release film press clamp and the screws are lower than the undersurface of the resin case. Check whether the release film is tight and has no wrinkles. See picture (9-9). Finally, release film replacement is completed. See picture (9-10).

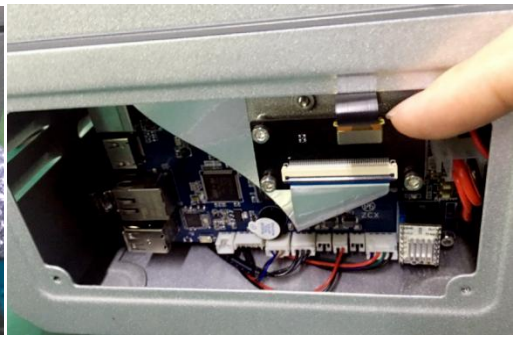


(Picture9-9)

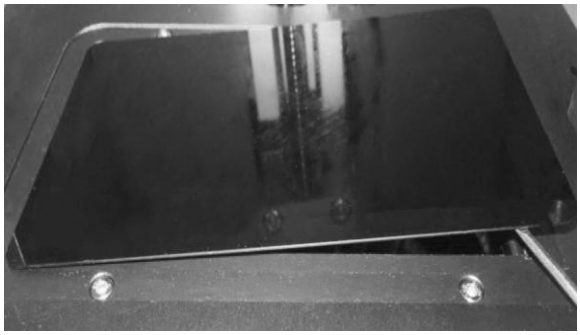
(Picture9-10)

9.2 Replace 2K forming screen

(Picture9-11)

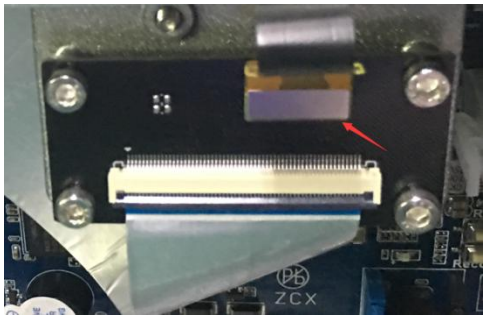


(Picture9-12)



(Picture9-13)

(Picture9-14)



(Picture9-15)

1) Loosen the screws of the radiator cap on the left side of the machine. See

picture (9-11).

2) Gently pry the plug of the 2K forming screen on the adapter plate. See picture (9-12).
3) Use a straight screwdriver or squeegee to gently pry the old 2K forming screen suit along the edge. See picture (9-13).
4) See picture (9-14)，Gently insert a new 2K forming screen suit line into the left slot, insert the cable of 2K forming screen on the left side of the machine into the original position of the adapter plate. See picture (9-15), then completely replace the 2K forming screen suit into the groove. Gently press the four sides of the screen to make sure it is in place and no bumps.
5) Finally, put back the radiator cap on the left side of the machine.

10 Web printing

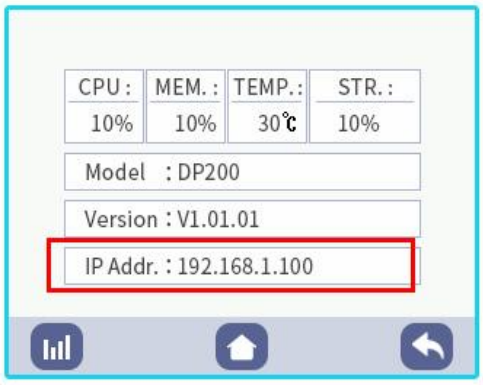
The computer configuration must be satisfied with the following requirements:

Memory: 4GB and above; Processor: I5 and above.

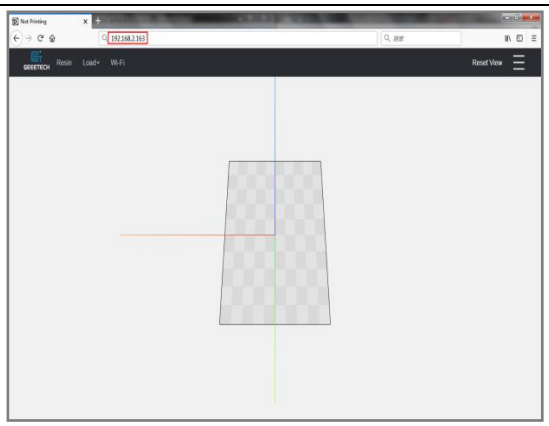
10.1 Configuring WIFI

Before printing, you need to install the external antenna to the corresponding antenna interface on the back side of the machine and fix it tightly. Then configure the wireless function of the printer. If you do not configure WIFI, you can also control the printer by cable. The specific process is as follows：

1) Connect the printer with network through network cable，and make computer and printer on the same subnet，which can be achieved by connecting computer and printer to the same router with a network cable.（**Note: The computer and router need to be set to the status of obtaining IP automatically.)**
2) Click **“System”** -> **“Information”** on the main interface of the touch screen to check current IP address of the printer, as shown in picture (10-1). Then enter the IP address in the address bar of computer's browser to browse its operation interface (WebGUI), as shown in picture (10-2). Google Chrome or Firefox is recommended.

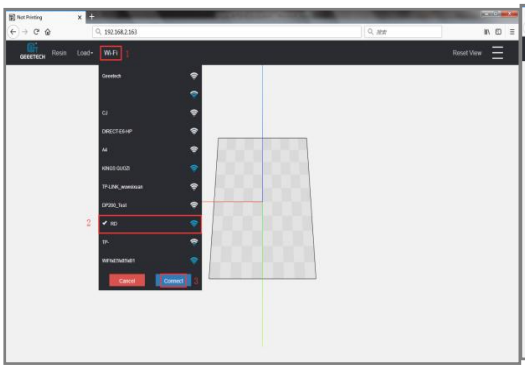


(Picture10-1)

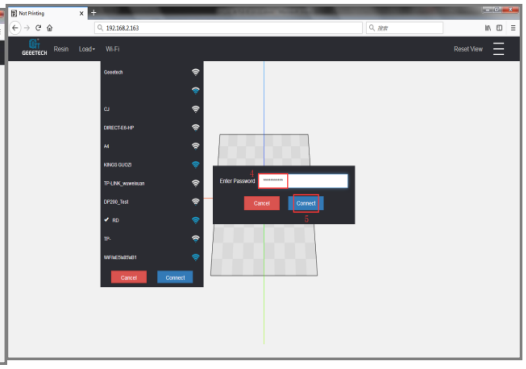


(Picture10-2)

3) Click **"Wi-Fi"** button to bring up Wi-Fi drop-down list. Select the WIFI SSID of target router. Enter corresponding password **(Note: the computer and printer need to be in the same subnet)**. Now because the printer has switched networks, current page cannot be used. See picture (10-3), (10-4).



(Picture10-3)



(Picture10-4)

4) Unplug the cable on the back of the printer， and let it connect to the network through its own WIFI function.

5) Enter reassigned IP address in the printer touch screen again on your computer browser， and then online operating interface of the printer (WebGUI) can be accessed wirelessly. **(Note: If the printer is not connected to the router network or the network speed is poor, it is recommended to use a network cable for wired connection printing or restart the router to let the machine search for signals again.)**

10.2 Operating Instructions

Next, we load the model file into the printer to slice and print it. The process is as follows:

1) Click the **“Resin”** button in the top navigation bar to enter the resin parameter configuration window, as shown in Picture (10-5).

- Click **"Add Resin"** to add a resin configuration.
- Click **"Import Resin"** to import the resin configuration. After selecting target configuration in the list, click **"Edit"** below to edit resin configuration.
- Click **"Delete"** to delete resin configuration.
- Click **“Export”** to export resin configuration for the next import via “Import Resin”.

As shown in Picture (10-6), the **“Edit Resin”** window that pops up after clicking **“Edit”** contains two types of settings: **“Burn-in Layers”** and **“Normal Layers”**.

- **"Burn-in Layers"** includes seven fields, namely **"Number of Layers"**, **"Layer Thickness"**, **"Cure Time"**, **"Wait Before Print"**, **"Wait After Print"**, **"Lift After Print"**, and **"Wait After Lift"**, representing the number of burn-in layers, the thickness of burn-in layer, printing time, waiting time before printing, waiting time after printing, lifting distance after printing, and waiting time after lifting respectively.
- **"Normal Layers"** includes six fields: **"Layer Thickness"**, **"Cure Time"**, **"Wait Before Print"**, **"Wait After Print"**, **"Lift After Print"**, and **"Wait After Lift"**, representing layer thickness, printing time, waiting time before printing, waiting time after printing, lifting distance after printing, and waiting time after lifting respectively.

Click **"Default"** button below to restore to factory default configuration, and then click **"Submit"** button to submit form, save resin settings and upload them

to the printer.

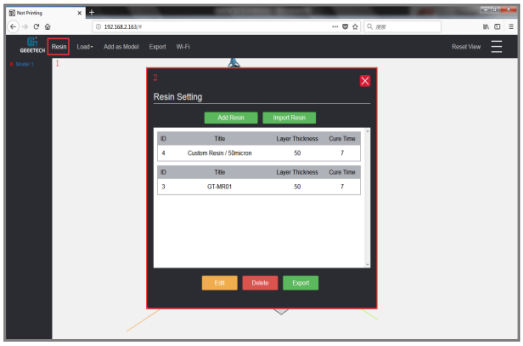
2) When loading the model, you can drag the **“STL”** or **“ZIP”** files directly into the middle editing area or click the **“Load”** button to select the **“STL”** or **“ZIP”** files to load, as shown in Picture (10-7). **(Note: If the loading speed is too slow, it is recommended to use “Drag and drop” option to drag the model directly into the editing area)**

- If it is **"STL"** go to step 3)
- If it is **"ZIP"** go to step 5).

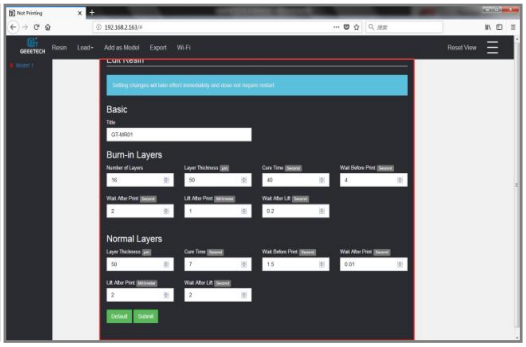
3) Click **“STL”**, and select .**STL** file in file selection dialogue box to load the model into the 3D image editing area. You will see **“Add as Model”** and **“Export”** buttons in the top navigation bar, and the model list in editing area on the left side of the interface, as shown in Picture (10-8).

Click the red **“X”** button on the left side to remove the model from editing area, as shown in Picture (10-9).

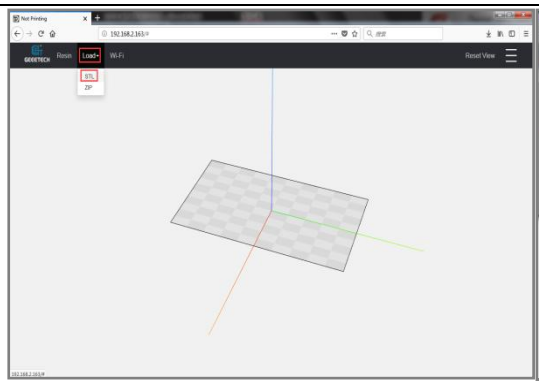
In the editing area, you need to close hotkeys of browser such as mouse gestures to avoid conflicts with this interface operation. Hold the left mouse button to move the model view; hold the right mouse button to move the model view; hold down the middle mouse button to move up or down or scroll the wheel to zoom in and out of the model view.



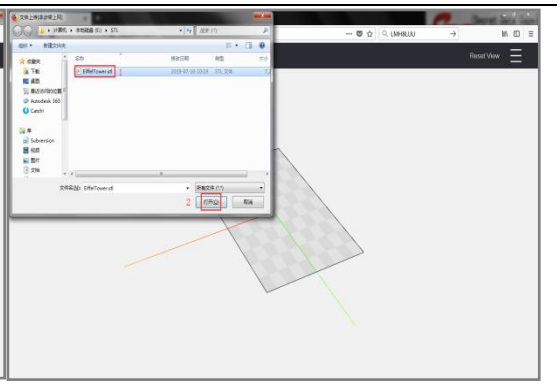
(Picture10-5)



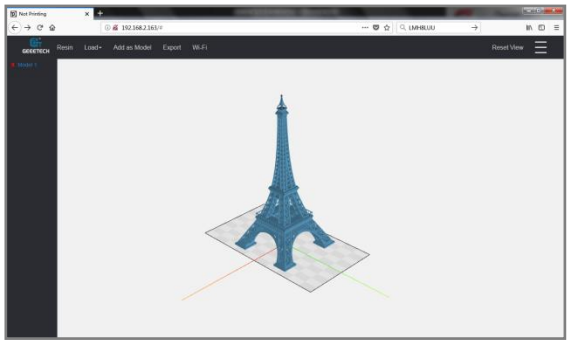
(Picture10-6)



(Picture10-7)

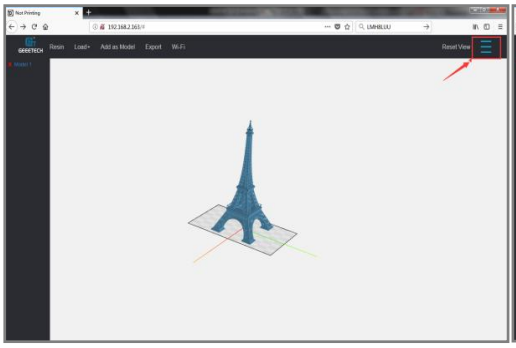


(Picture10-8)

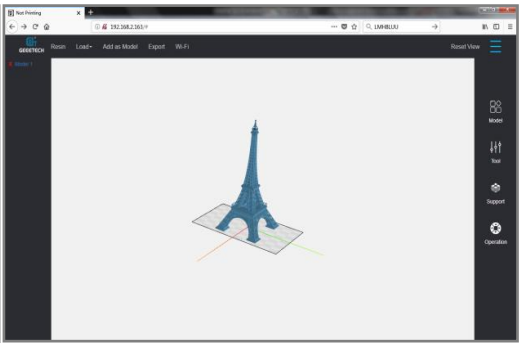


(Picture10-9)

4) Click the toolbar icon on the right side of the interface to expand the toolbar. As shown in Picture (10-10), (10-11). There are 4 buttons in the toolbar, namely **"Model"**, **"Tool"**, **"Support"**, and **"Operation"**. The specific functions are as follows:



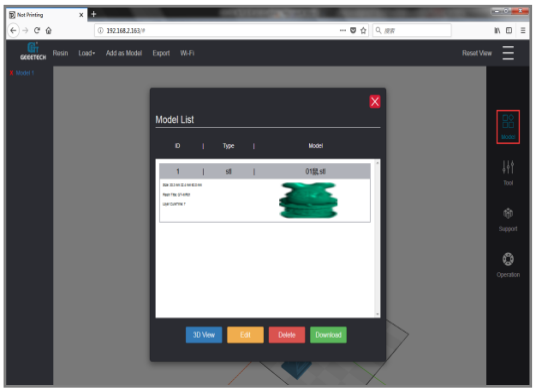
(Picture10-10)



(Picture10-11)

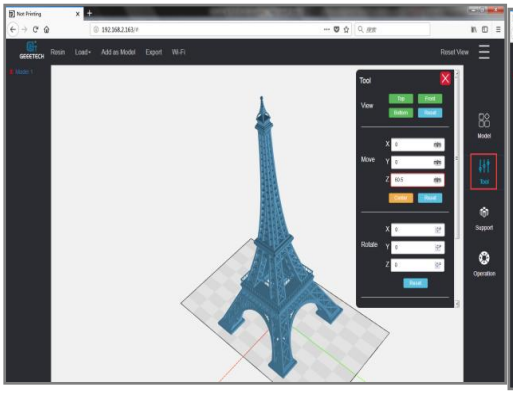
- **"Model"**: This page displays model list that has been loaded into printer's memory, allowing **"3D View"** **(note: ZIP files do not support 3D View, it is only available for STL files)**, **"Edit"**, **"Delete"**, and

"**Download**". As shown in Picture (10-12).

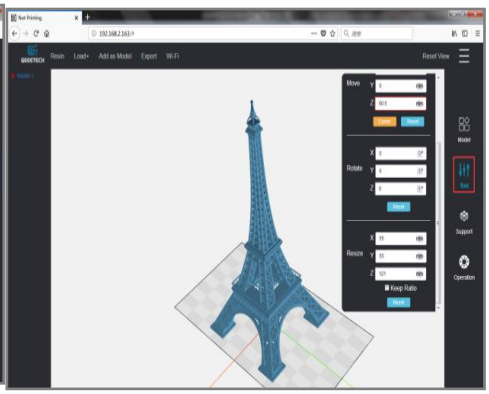


(Picture10-12)

◆ "**Tool**": This page can control the model view, move the position of model, rotate the model, and resize model. See Picture (10-13) and (10-14).



(Picture10-13)

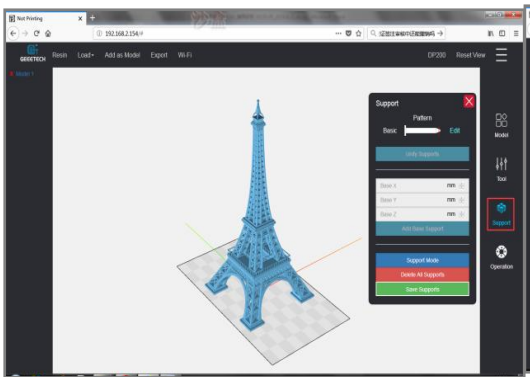


(Picture10-14)

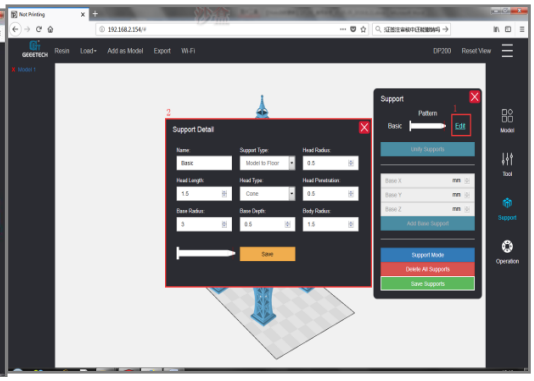
- *View* control includes four operation buttons, namely **"Top"**, **"Front"**, **"Bottom"**, and **"Reset"**.
- *Move* has three fields, namely X, Y, and Z, and their values represent the coordinates at each axis. It also includes two function keys: **"Center"** (model is centered) and **"Reset"** (default position).
- *Rotate* has three fields, namely X axis, Y axis, and Z axis, and their values represent the angles of rotation counterclockwise around each axis. **"Reset"** represents default angle.

- *Resize* has three fields, namely X, Y, and Z. The values represent the length of the model in each dimension (mm). When **“Keep Radio”** is selected, X, Y, and Z axis figures will be reduced or enlarged according to the original scale. **"Reset"** button restores original scale. All of the entries for the editable page are activated immediately.

◆ **“Support”:** This page can add support to the model's suspended part of the model. As shown in Picture (10-15). This page contains the following functions:



(Picture10-15)



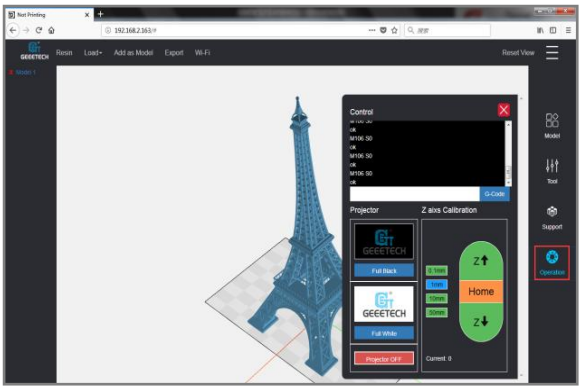
(Picture10-16)

- Click **“Edit”** to customize the shape of the support, as shown in Picture (10-16). It Contains nine fields: **"Name", "Support Type"**, **"Head Radius"**, **"Head Length"**, **"Head Type"**, **"Head Penetration"**, **"Base Radius"**, **"Base Depth"**, **"Body Radius"**. Click **“Save”** to save support shape information.
- Before each time you need to use the support, you need to click the **“Support Mode”** button below to enter the model support state, and then click on the model dangling position in the editing area. Click on **“Unify Supports”** to connect the bottom of each isolated support into a single base.
- If the bottom of the added model is too small and the adhesion is insufficient, add Base Support in the middle of the window

and enter the corresponding dimensions in the X, Y, and Z axis directions in “Base X”, “Base Y”, and “Base Z” respectively. Click **"Add Base Support"** to add a sized base block to the bottom of the model to increase model adhesion. **(Note: After the base support is added, the same support height is required to raise the model in the Z-axis direction to avoid the overlap of the model and the base support.)**

- Click **“Delete All Supports”** to delete all unsaved supports with one click, but the support that has been merged with the model can’t be deleted.
- After adding support and checking it, click **“Save Supports”** to save the support. **(Note: the support after saving cannot be modified, only the original model can be reloaded)**

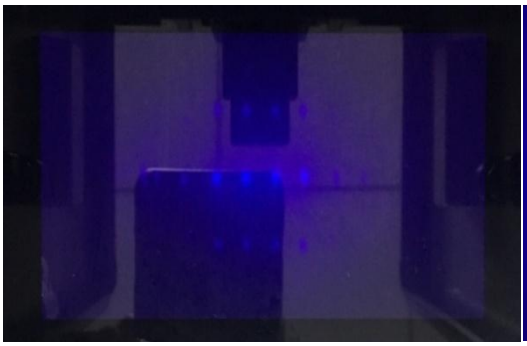
◆ **“Operation”:** This page features include **“Control”**, **“Projector”**, **“Z Axis Calibration”**. As shown in Figure (10-17).



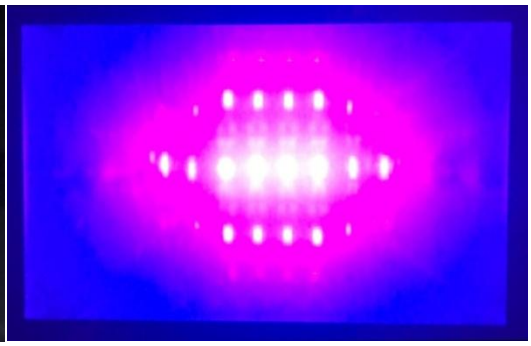
(Picture10-17)

- The upper window in **“Control”** contains the default command that the current printer is running. Enter the Gcode command in the **"Gcode Command Input Box**" and click the **"G-Code"** button to send an instruction to the printer.
- **“Projector”** can control LED lights and forming screens, including **“Full Black: only turn on LED lights”**, **“Full White: turn on LED**

lights and forming screens at the same time”, and **“Projector OFF: Full Off”. “Full Black: Turn on only the LED light”** and **“Full White: Turn on the LED light and the forming screen at the same time”** on the machine side as shown Picture (10-18), Picture (10-19).



(Picture10-18)

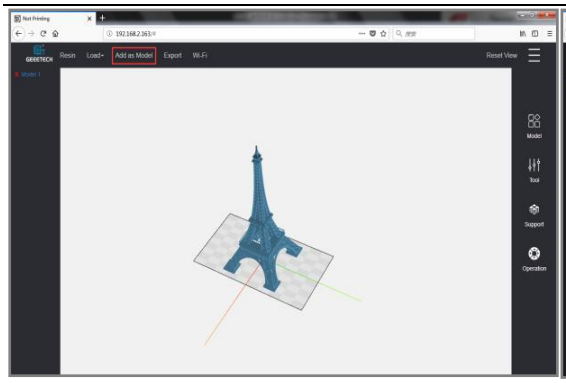


(Picture10-19)

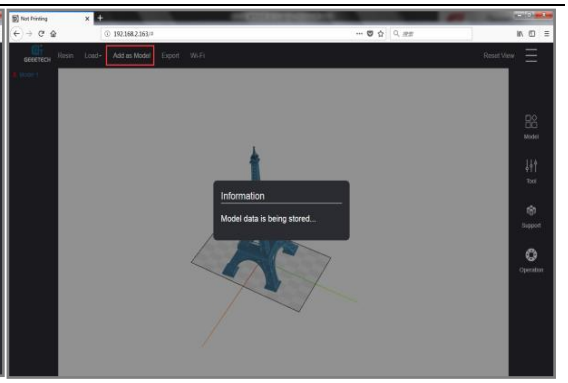
- **“Z Axis Calibration”** includes four unit scale buttons of 0.1mm, 1mm, 10mm,50mm, and three moving buttons: **“Z ↑ Up”, “Home resetting” and “Z ↓ Down”.** First select the target unit scale button, then click on the operation you want the Z axis to do. "Current" below shows the current coordinates.

After model is edited as above, click **“Add as Model”** button on the top navigation bar to save it as a Model object. See Picture (10-20) and Picture (10-21).You can name the model in **"Load STL to Model"** window, select corresponding resin parameter configuration, and finally click **"Submit"**. See Picture (10-22).

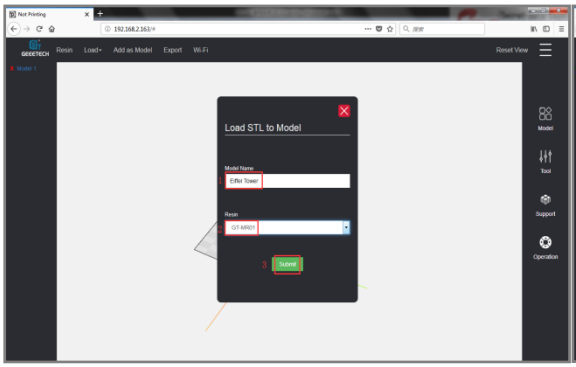
When submitted, the bottom of the interface is shown as Picture (10-23). Now the model is loaded into the memory of the printer **(Note: The loading time depends on the complexity of the imported STL model and the network speed of the current status)**, and can be viewed on **“Print”** page of the touch screen, as shown in Picture (10-24). Then go to step 6).



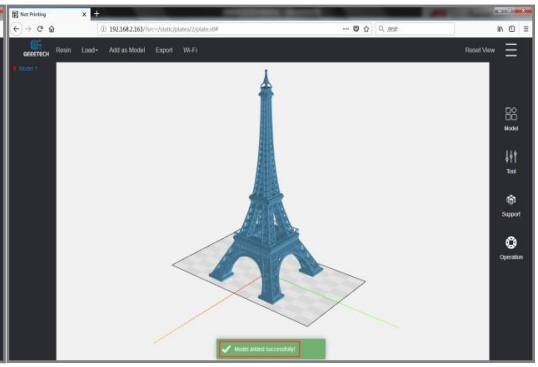
(Picture10-20)



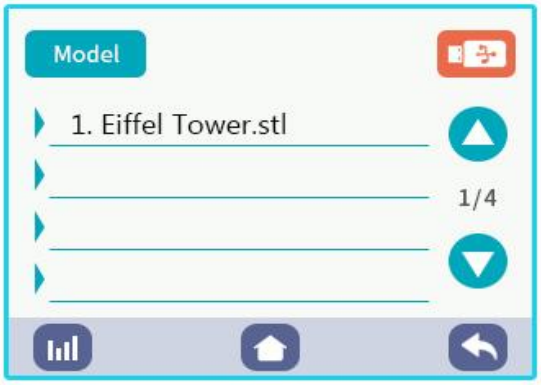
(Picture10-21)



(Picture10-22)



(Picture10-23)

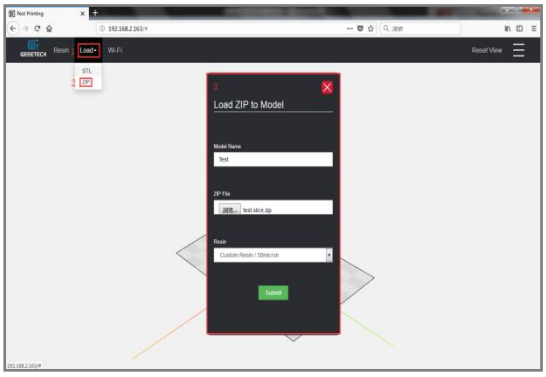


(Picture10-24)

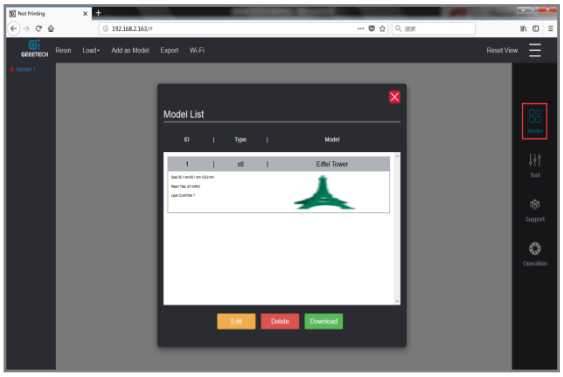
5) As shown in Picture (10-25), click **“ZIP”**, fill in **“Model Name”** in the pop-up dialog box **“Load ZIP to Model”**, and click **“Browse”** in **“ZIP File”** to select the target ZIP model file. Select corresponding resin configuration in **"Resin"**. Lastly, click **"Submit"** to save ZIP file directly into the Model object and load it into the printer-side print list. Then go to step 6).

6) Click **“Model”** in the toolbar on the right side and pop up the **“Model List”** page. See picture (10-26). Select target model and click **“3D View”** button below to

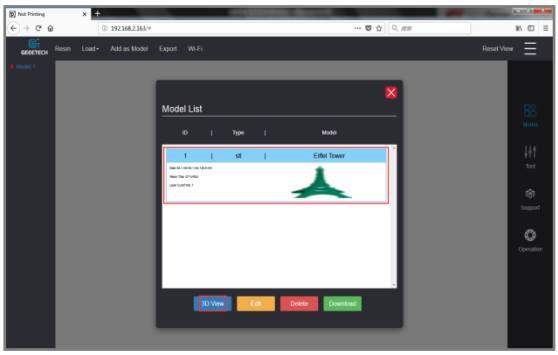
load the model into editing area, as shown in Picture (10-27). **(Note: ZIP file does not support "3D View"; this is only applicable to STL file)**In addition, in **"Model List"**, you can click **"Edit"** to edit the parameters of models, as shown in Picture (10-28).Click **"Delete"** to delete the model, as shown in Picture (10-29). **(Note: The model on printer side will be deleted synchronously)**Click **"Download"** to download the model to local, as shown in Picture (10-30).



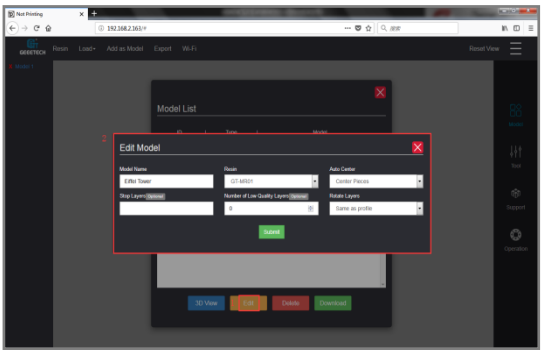
(Picture10-25)



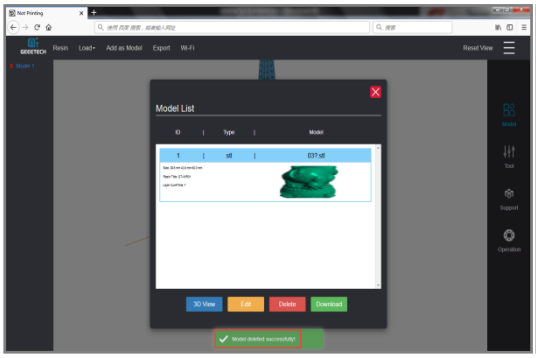
(Picture10-26)



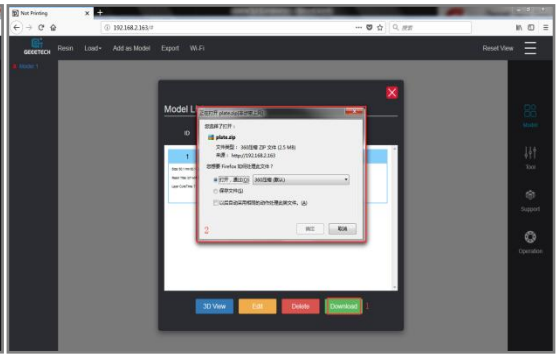
(Picture10-27)



(Picture10-28)



(Picture10-29)



(Picture10-30)

7) Click **"3D View"** button to load the model into the editing area, and click **"Slice"**

button in the top navigation bar to start slicing the target model until it is finished. Figure (10-31), Figure (10-32). **(Note: It is recommended not to operate on touch screen of printer during slicing process to avoid slicing failure)**

When the status of the dialog box shows **"Processed"**, it means slice is successful. Click **"Done"** to close the dialog. See picture (10-33).

8) When slicing is completed, the top navigation bar will show **“Preview”** and **“Print”** buttons.

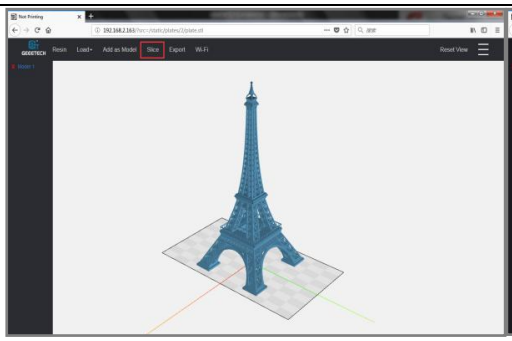
- Click **"Preview"** button to preview the sliced model.

  "Preview" window includes image preview area, current preview layer slider, layer up and down buttons, slice screen display button, and the information bar of the current layer on the right side. When you slide a few layers, or click the up and down buttons, the image preview area will display corresponding slice.

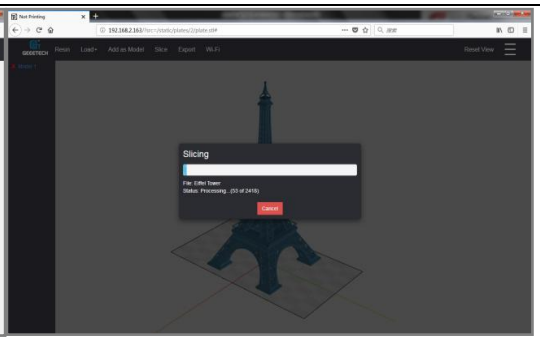
  The current layer information bar includes **"Current Layer"**, **"Area Count"**, **"Total Solid Area"**, **"Largest Area"**, **"Smallest Area"**, **"Boundry-X"**, **and "Boundry-Y"**. Click **“Display Layer on Screen”** below to project the picture of the current layer onto the 2K forming screen. Click **“Projector Off”** to close the projection. See Picture (10-34).

- Click **"Print"** button to start printing the target model.

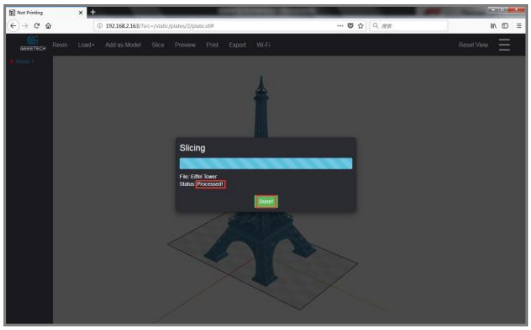
  "Print" window includes **"Model"** (model name), **"Layer"**(current layer), **"Remaining"** (remaining print time), current print slice preview, print progress bar, current layer time distribution bar, **"Stop"** (stop printing), **“Pause”** (pause printing). The name, number of layers, remaining time, and slice preview will change as print progresses.



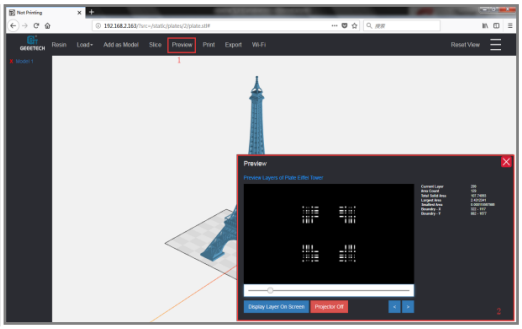
(Picture10-31)



(Picture10-32)



(Picture10-33)



(Picture10-34)

11 Declaration

11.1 Terms

Please be advised of the following terms (the “Terms”) regarding this User Manual (this “Manual”):

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11.2 Disclaimers

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