



XY-2 PRO 2E

Installation Manual 安装使用说明书





When unpacking, please check the packing list to ensure that no parts are lost or damaged. If any, please contact our after-sales personnel immediately and we will reissue them for you in the shortest time.

开箱时,请对照装箱清单,确保无零件的丢失及损坏,如有发生,请立即联系我们的售后人员,我们会在最短时间内为您补发。



Please use the machine in a ventilated, dry, clean and flat environment.

请在通风、干燥、清洁、平坦的环境中使用机器。



The machine contains high-speed moving parts and high-temperature parts. Children are not allowed to use the printer alone.

该机器包含高速运动部件和高温部件,儿童不得单独使用打印机。



Part of the accessories are consumable, the warranty time is different.

部分配件为易耗品,保修时间不同。



In an emergency, you can turn off the power directly.

在紧急情况下,可直接关闭电源。



If the user's unauthorized modification or disassembly causes damage to the core components of the machine, the situation is not covered by the warranty.

如果用户擅自改装或者拆卸导致机器的核心部件损坏,则该情况不在保修范围内。



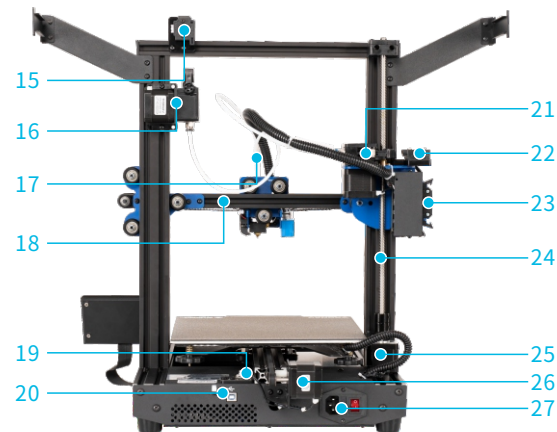
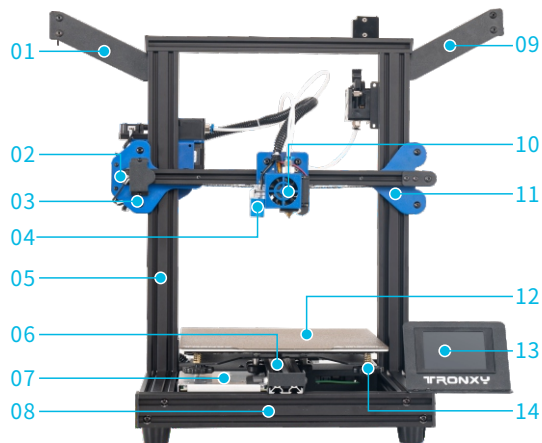
Video, software and other related information are stored in the TF card, please check.

视频,软件等相关信息存储在TF卡中,请查看。

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Introduction 设备简介



01 E1 filament rack
E1料架

02 X-axis motor assembly
X轴电机组件

03 X-axis left slider
X轴左滑板

04 Auto leveling detector
自动调平检测器

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龙门架铝型材

06 Y-axis aluminum profile
Y轴铝型材

07 Power supply
电源

08 Base aluminum profile
底座铝型材

09 E2 filament rack
E2料架

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打印头

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打印平台

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触摸屏

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调平螺母

15 E2 filament run-out detector
E2断料检测器

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E2 挤出机

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料管

18 X-axis aluminum profile
X轴铝型材

19 Y-axis limit switch
Y轴限位开关

20 TF card and type-B to USB slot
TF卡和USB插口

21 E1 extruder
E1挤出机

22 E1 filament run-out detector
E1断料检测器

23 30Pin cable socket
30Pin排线插口

24 Screw rod
丝杆

25 Z-axis motor
Z轴电机

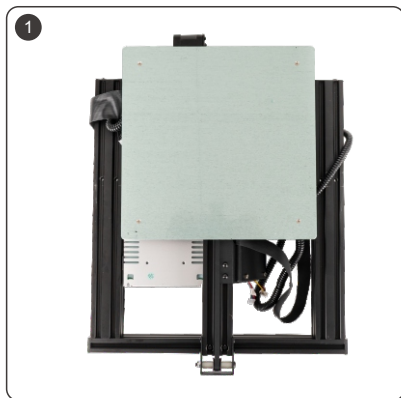
26 Y-axis motor
Y轴电机

27 Power cord socket and
power switch
电源插口和电源开关

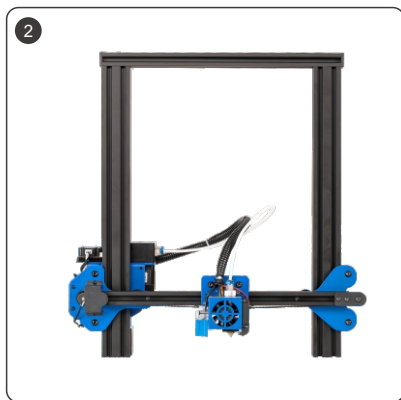
Parameter 设备参数

Print parameters 打印参数		
Print size	打印尺寸	255*255*245 (mm)
Print accuracy	打印精度	0.1-0.3mm
Print principle	印刷原理	FDM (Fused deposition molding 熔融沉积成型)
Nozzle size	喷嘴尺寸	0.4mm
Nozzle quantity	喷嘴数量	1
Print speed	打印速度	20-150mm/s (Advise 60mm/s 建议 60mm/s)
Position accuracy	位置精度	X/Y -0.00625mm, Z -0.00125mm
Filaments support	耗材支持	PLA、ABS、PETG、TPU ...
Temp parameters 温度参数		
Printing environment temp	打印环境温度	8-40°C
Nozzle temp	喷嘴温度	275°C (MAX 最大)
Power supply 电源参数		
AC 110/220V 50/60Hz DC 24V/360W		
Software 软件		
Slice software	切片软件	Tronxy、Cura、Simplify3D
Input format	输入格式	.stl、.obj
Output format	输出格式	.gcode
Connection	连接方式	TF card, USB type-B cable TF卡、USB type-B
Machine parameters 机器参数		
Machine size	机器尺寸	670*475*535mm
Package size	包装尺寸	620*500*225mm
Machine weight	机器重量	≈12kg

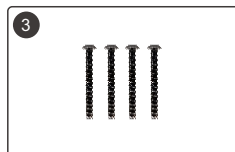
Packing List 包装清单



Base
底座



Gantry
龙门架



M5*45 screw *4
M5*45螺丝 *4



Feed tube
料管



Filament rack *2
料架 *2



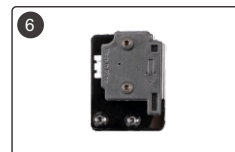
PEI magnetic steel plate
PEI磁性钢板



E2 extruder
E2挤出机



0.25KG Filaments*2
(Random color)
0.25KG耗材*2 (颜色随机)



E2 filament run-out
detector
E2断料检测器



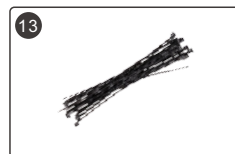
Power cord
电源线



Card reader and TF card
读卡器和TF卡



Type-B to USB Cable
数据线



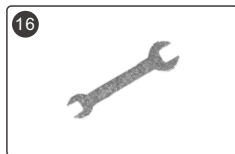
Tie
(Random color)
扎带(随机颜色)



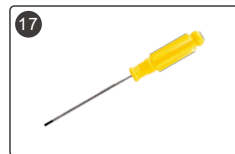
Allen wrench
内六角扳手



L-shaped Allen wrench
L型内六角扳手



Wrench
扳手

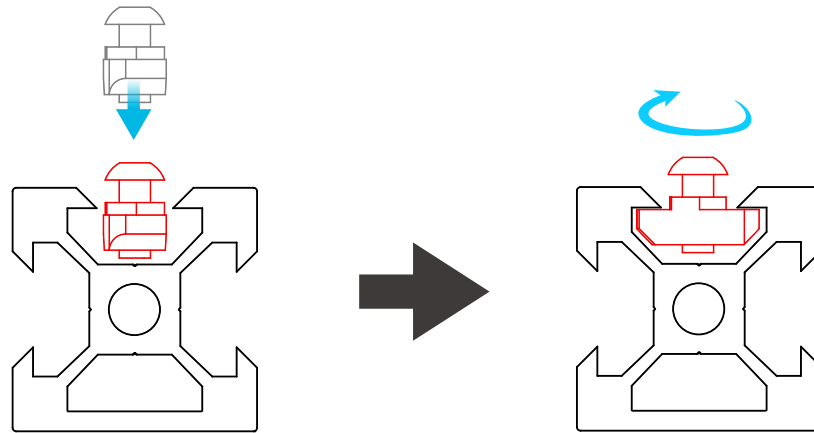


Screwdriver
一字螺丝刀



Limit switch (spare part)
限位开关 (备用)

Working Principle of boat nut 船型螺母的工作原理



Loosen the boat nut on the filament rack slightly, pay attention not to take down the nut, then put it into the groove of aluminum profile in parallel direction, and tighten the screw clockwise quickly, making the boat nut stuck in the groove of aluminum profile at 90°.

略微松开料架上的船型螺母，注意无需取下螺母，然后平行方向放入铝型材的槽内，顺时针快速拧紧螺丝，使得船型螺母90°卡在铝型材的槽内。

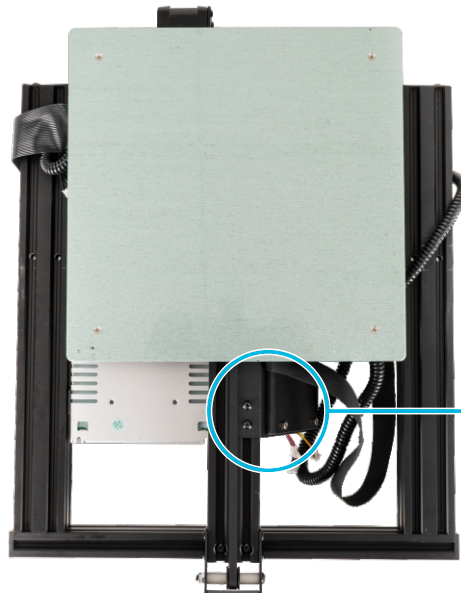
1. Remove the touch screen on the base 取下底座上的触摸屏



1
Base
底座



14
Allen wrench
内六角扳手



Loosen the two screws here
松开此处的两颗螺丝



Remove the touch screen
取下触摸屏

Machine Installation 产品安装

2. As shown in the following figure, adjust the screws and boat nuts pre-installed on the touch screen

如下图所示, 调整预安装在触摸屏上的螺丝和船型螺母



The touch screen just taken off
刚取下的触摸屏



Remove screws and boat nuts
取下螺丝和船型螺母



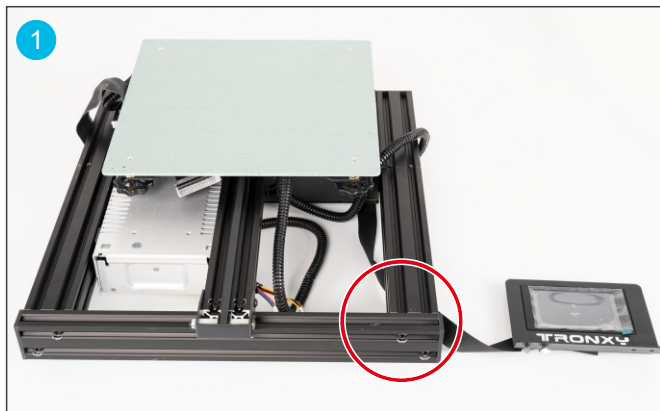
Install it back as shown in the figure
如图所示安装回去



Installation completion diagram
安装完成示意图

Machine Installation 产品安装

3. Correctly install the touch screen on the base 将触摸屏安装在底座上



Install the touch screen in the place of circle in the figure
将触控屏安装在图中圈中的位置



Put the boat nut into the groove
将船型螺母放入凹槽内



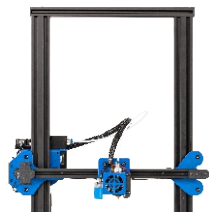
Tighten screws
拧紧螺丝



Tear off the screen protective film
撕掉屏幕保护膜



①
Base
底座



②
Gantry
龙门架



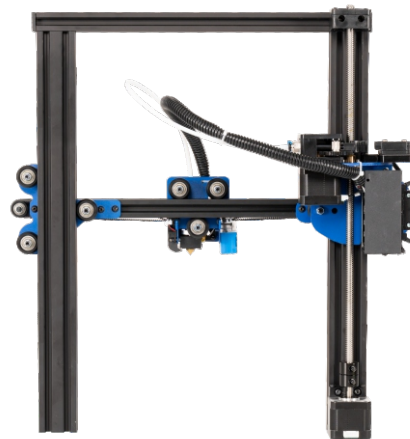
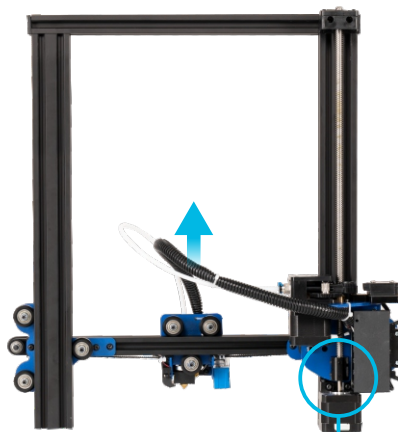
③
M5*45 screw *4
M5*45螺丝 *4



④
L-shaped Allen wrench
L型内六角扳手

4. Rotate the screw coupling clockwise to raise the x axis above the middle
顺时针旋转丝杆联轴器, 将X轴升到中部以上

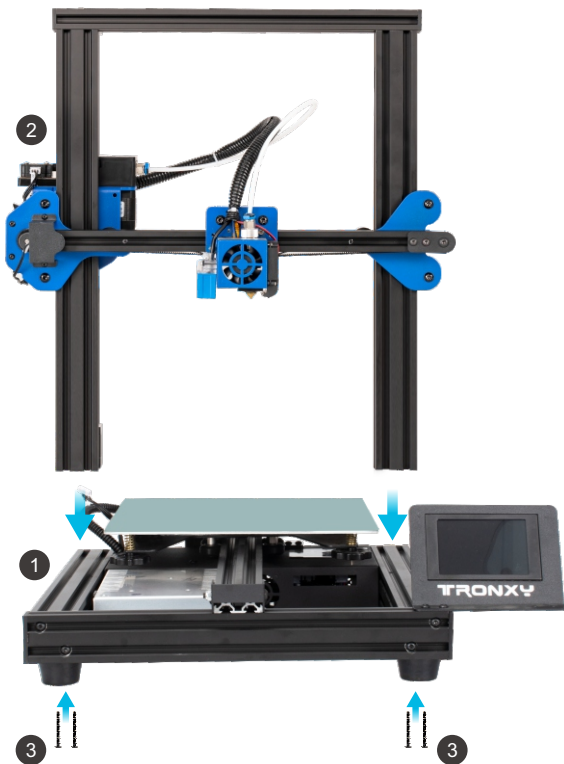
Back of gantry 龙门架背面



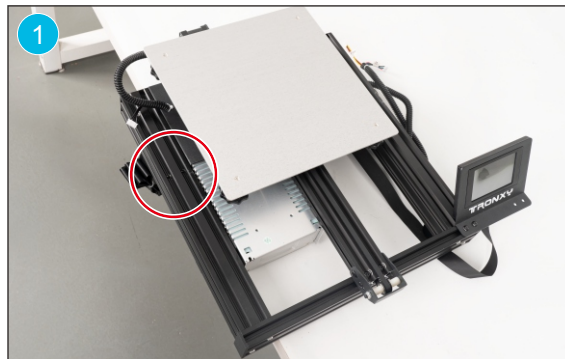
Machine Installation 产品安装

5. Install the gantry to the base 将上架安装到底座上

Installation diagram
安装示意图



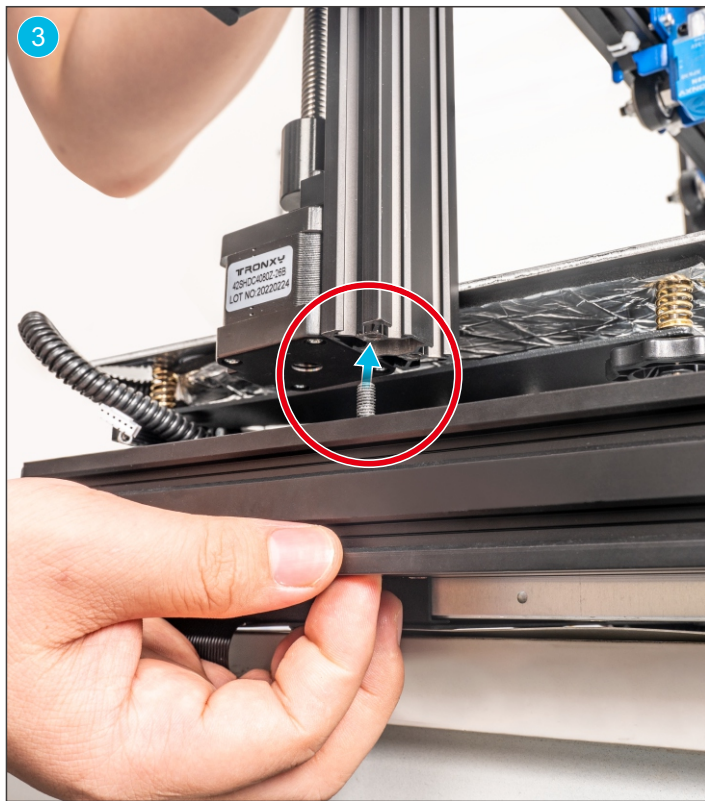
Procedure
详细安装步骤



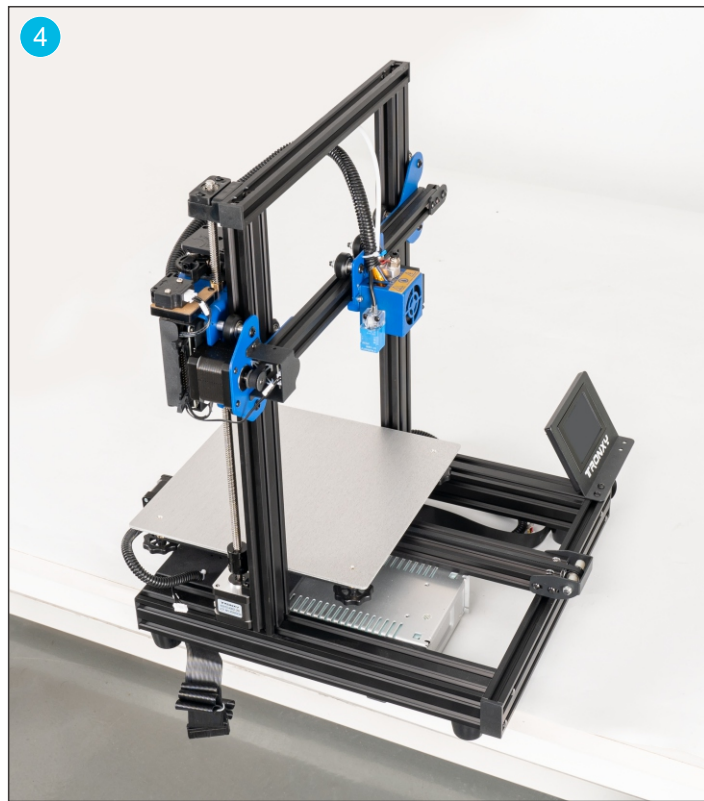
As shown in the figure, move the machine to the edge of the table to expose the screw holes at the bottom.
如图所示，将机器移动至桌子边缘，露出底部的螺丝孔。



Insert the M5*45 screw into the screw hole from the bottom
将M5*45螺丝从底部插入螺丝孔



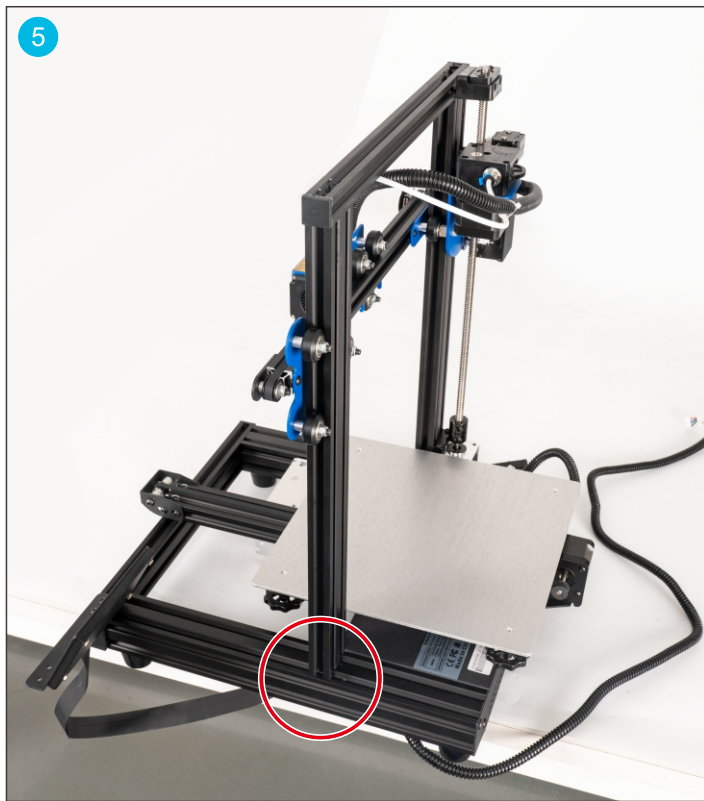
Align the screw hole at the bottom of the gantry with the protruding screw and tighten it by hand
将龙门架底部的螺丝孔对准凸出的螺丝,用手拧紧



As shown in the figure
如图所示



After inserting another M5*45 screw, tighten the two screws with a wrench
插入另一颗M5*45螺丝后,使用扳手拧紧两颗螺丝



Move the other side of the machine to the edge of the table as shown
如图所示, 将机器的另一侧移动到桌子边缘



Insert two M5*45 screws and tighten them to complete
the installation of the gantry
插入两颗M5*45螺丝拧紧, 完成龙门架的安装



4

Filament rack *2
料架 *2



5

E2 extruder
E2挤出机



6

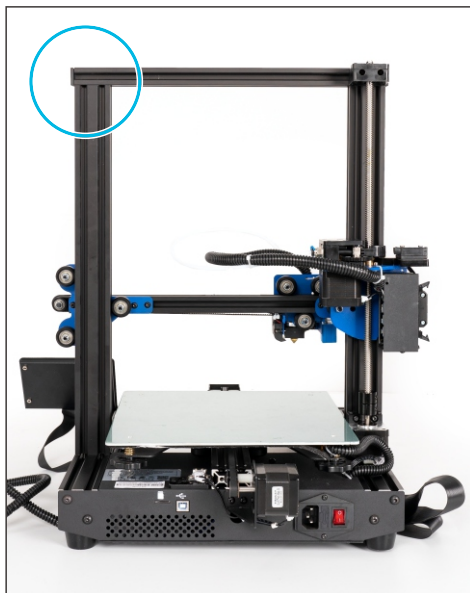
E2 filament run-out detector
E2断料检测器



14

Allen wrench
内六角扳手

6. Install filament rack, E2 extruder and E2 filament run-out detector 安装料架、E2挤出机和E2断料检测器

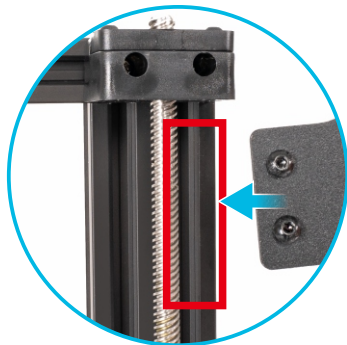


Install the E2 filament rack on the right
安装右边的E2料架

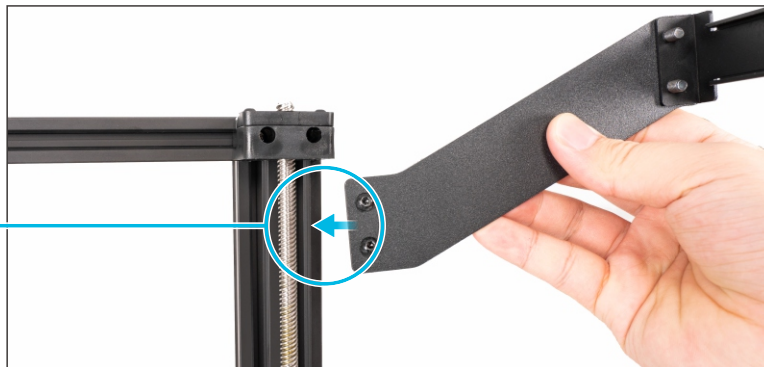


Use a hexagonal wrench to tighten the two screws clockwise
使用内六角扳手，顺时针拧紧两颗螺丝

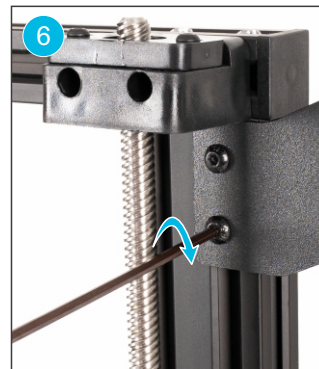
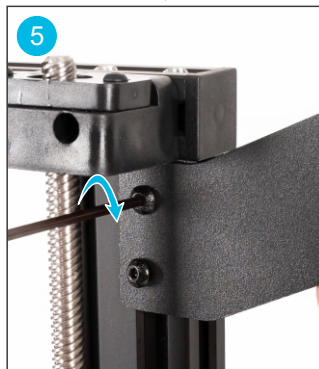
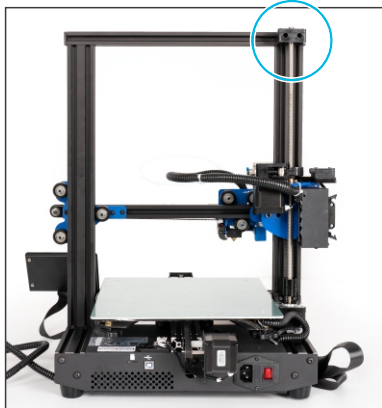
4



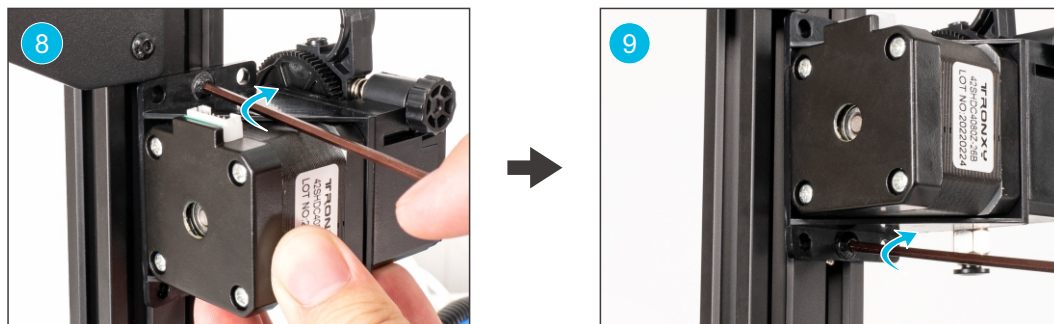
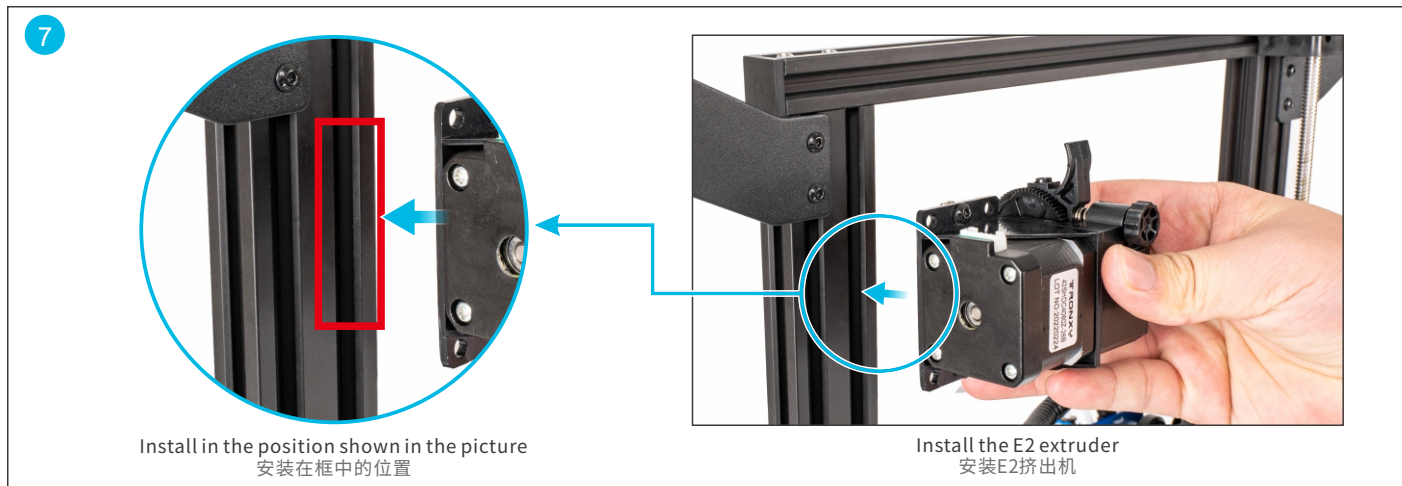
Install in the position shown in the picture
安装在框中的位置



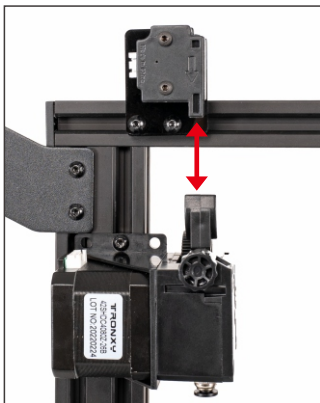
Install the E1 filament rack on the left
安装左边的E1料架



Use a hexagonal wrench to tighten the two screws clockwise
使用内六角扳手，顺时针拧紧两颗螺丝

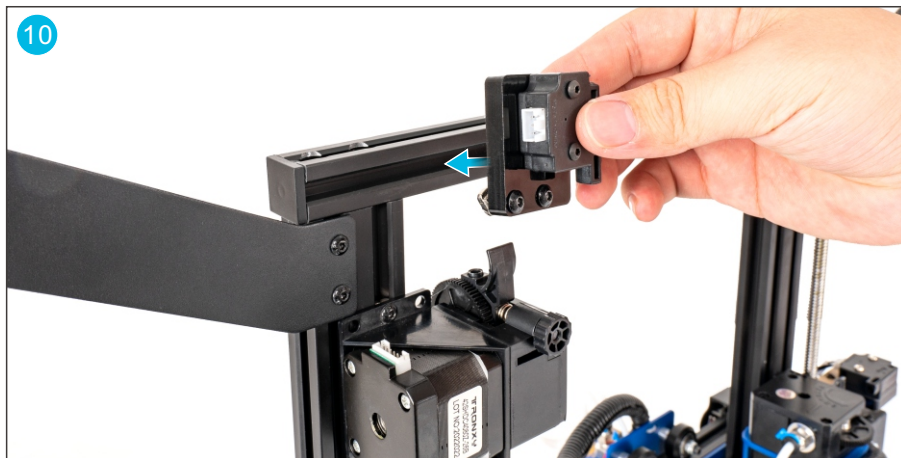


Tips 温馨提示

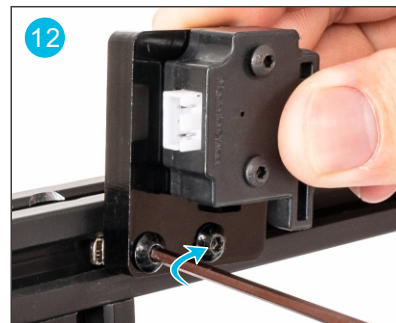
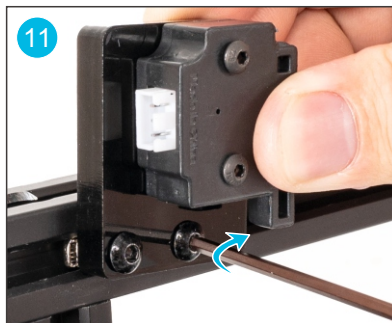


The filament run-out detector is installed right above the extruder, and the feeding hole of the detector is vertically aligned with the feeding hole of the extruder.

断料检测器安装在挤出机的正上方，将断料检测器的进料孔垂直对齐挤出机的进料孔。



Install E2 filament run-out detector
安装E2断料检测器



Use a hexagonal wrench to tighten the two screws clockwise
使用内六角扳手，顺时针拧紧两颗螺丝

7. Insert the connection line 插入连接线

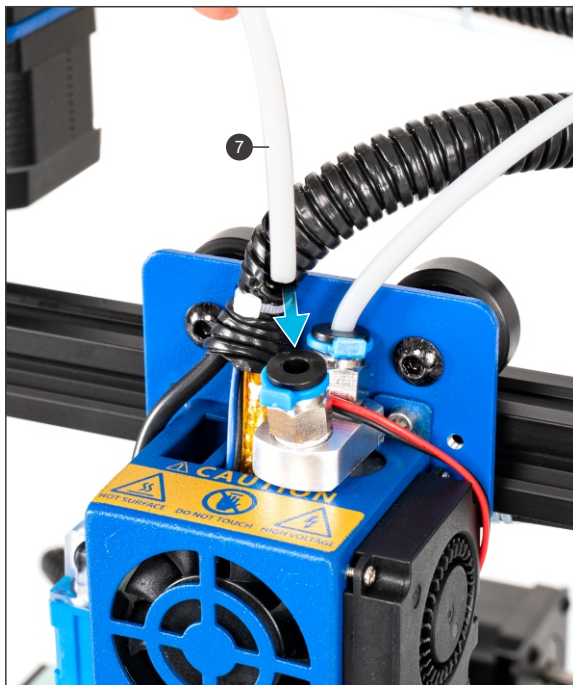


8. Insert the filament tube 插入料管

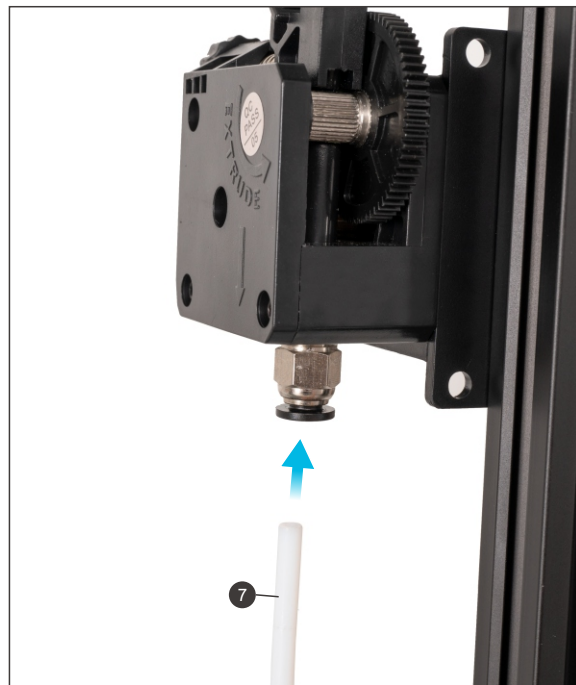


7

Feed tube
料管



Insert the filament tube into the print head until the push fails
将料管插入打印头，插到底部



Insert the other end of the filament tube into the
E2 extruder until it cannot be pushed
将料管另一端插入E2挤出机，插到底部

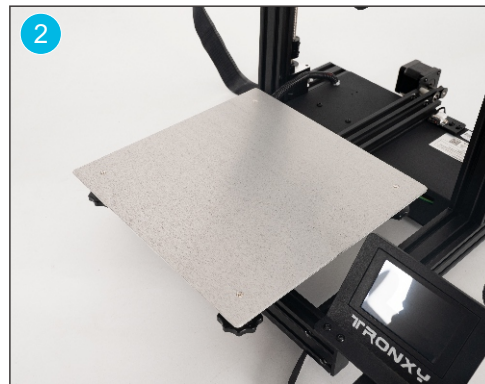


8
PEI magnetic steel plate
PEI磁性钢板

9. Install the PEI magnetic steel plate 9、安装PEI磁性钢板



Tear off the protective film on the
printing platform(hot bed)
撕开热床上的保护膜



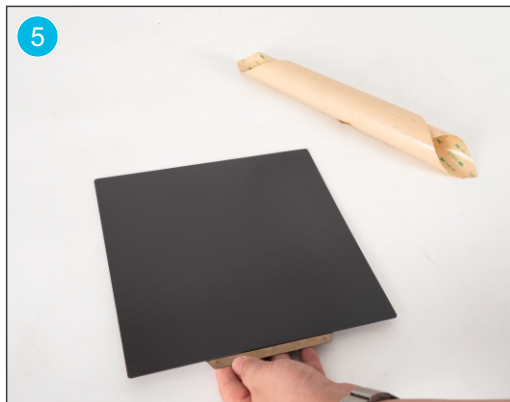
The hot bed after the protective film is torn off
撕掉保护膜后的热床



Take out PEI magnetic steel plate
拿出PEI磁性钢板



Tear off the sticker on the back
撕开背面的贴纸



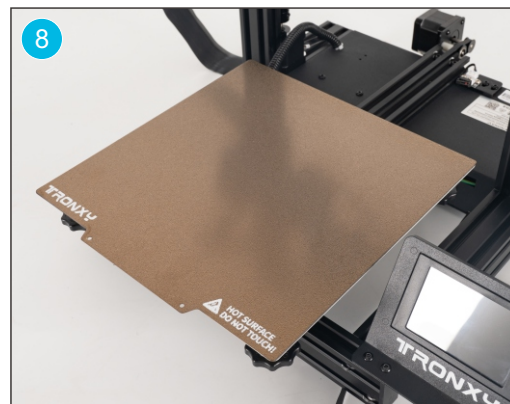
The sticky side appears after the sticker is torn off
撕开贴纸后露出有粘性的一面



Align the hot bed and paste it
对齐热床贴下去



Press it with your hand to make the sticker stick
to the hot bed
用手按压一下使贴纸粘紧在热床上



PEI magnetic sticker installation completed
PEI磁性贴纸安装完成



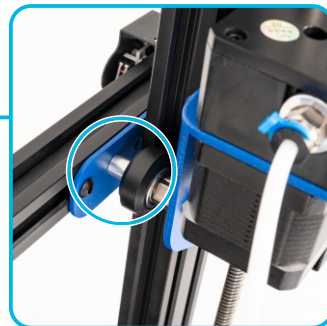
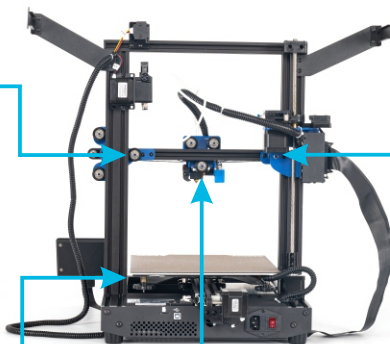
Tips 温馨提示

After the installation is completed, move the x-axis and y-axis hot bed. If the pulley is loose or the movement is not smooth, it can be solved by adjusting the eccentric nut near the pulley.

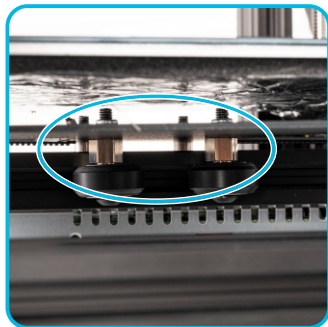
安装完成后, 滑动X轴和Y轴模块, 如果感到结构松动或过紧, 可以通过滑轮的偏心螺母进行调节。



Right slider
右滑块



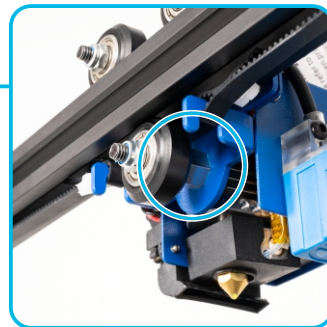
Left slider
左滑块



Print platform bottom
打印平台底部



Use wrench to adjust the tightness of eccentric nut
使用扳手调整



Pulley on the back of print head
打印头后方滑轮

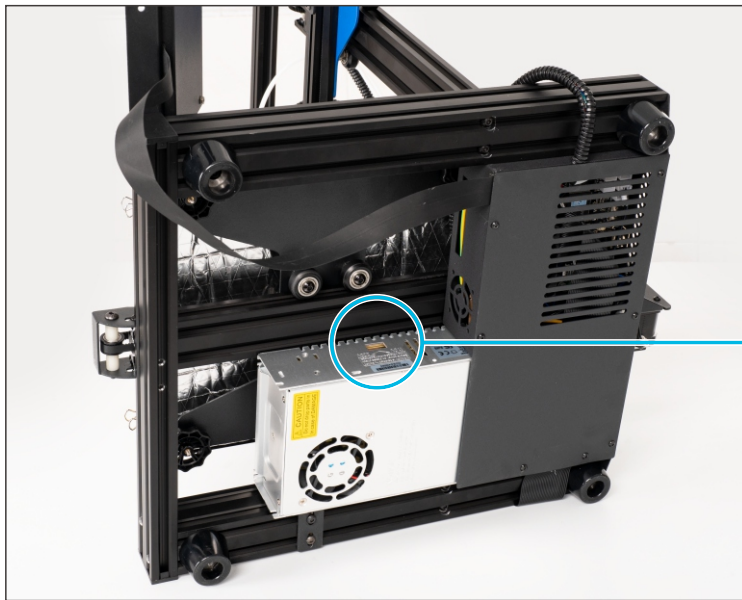
Power Supply Voltage Inspection And Adjustment Method 电源电压检查与调整方法



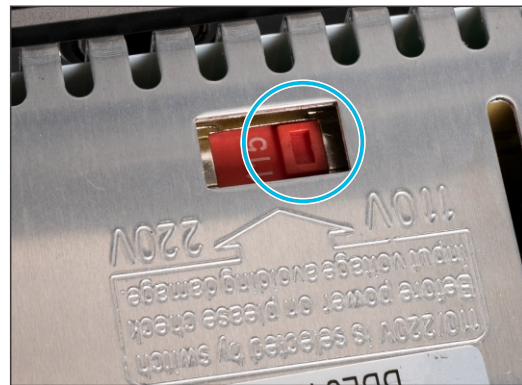
Important 重要提示

Before starting the printer for the first time, you must check whether the power supply voltage of the printer meets the local standard. Generally, the default setting is enough. For adjustment, please refer to the following contents.

第一次打开电源前, 必须检查电源电压是否符合当地标准, 一般保存默认设置即可, 如需调整可以参考以下内容。



Turn left, the voltage changes to 220V
往左拨为电压220V



Turn right, the voltage changes to 110V
往右拨为电压110V



Important 重要提示

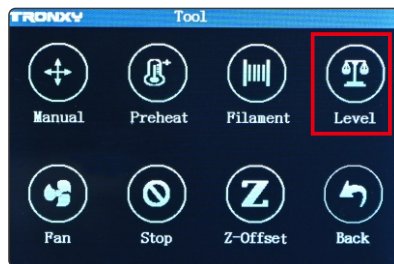
1. Before the first printing, the platform shall be leveled.
第一次打印之前, 需进行对平台进行调平。
2. This machine has two leveling methods: automatic leveling and manual leveling, and you can choose one of them for leveling.
本机有自动调平和手动调平两种调平方式, 选择其中一个进行调平即可。

1. Enter the automatic leveling detection interface

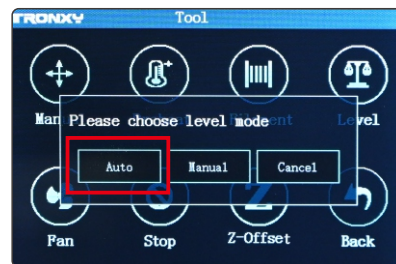
进入自动调平检测界面



Click "Tool"
点击“工具”



Click "Level"
点击“调平”

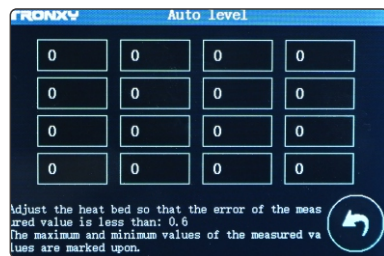


Select "Auto"
选择“自动”

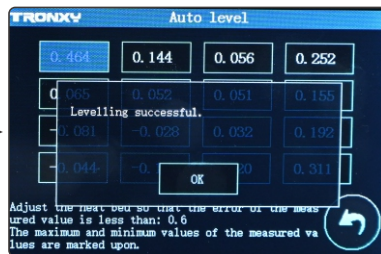
Print Platform Leveling - Method 1 - Automatic Leveling 打印平台调平 - 方法一 - 自动调平

2. The system will automatically carry out leveling detection

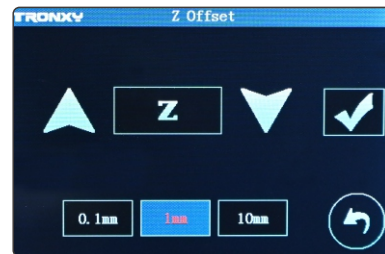
系统将自动进行调平检测



Automatic leveling interface
自动调平界面

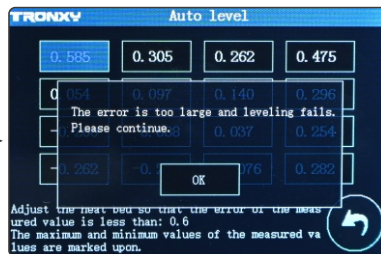


If the leveling is successful,
the next step is Z offset
调平成功, 下一步进行Z偏移操作

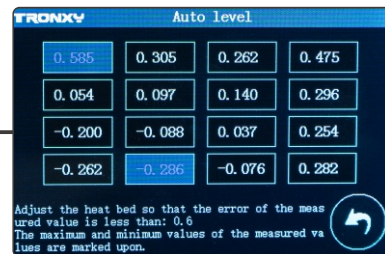


Enter the "Z offset" interface to
perform Z offset operation
(see next page for details)

进入“Z偏移”界面, 进行Z偏移操作
(操作方法请看下一页)



If the error is too large and the leveling fails,
the platform needs to be adjusted for re detection
误差过大, 调平失败, 需调整平台重新检测



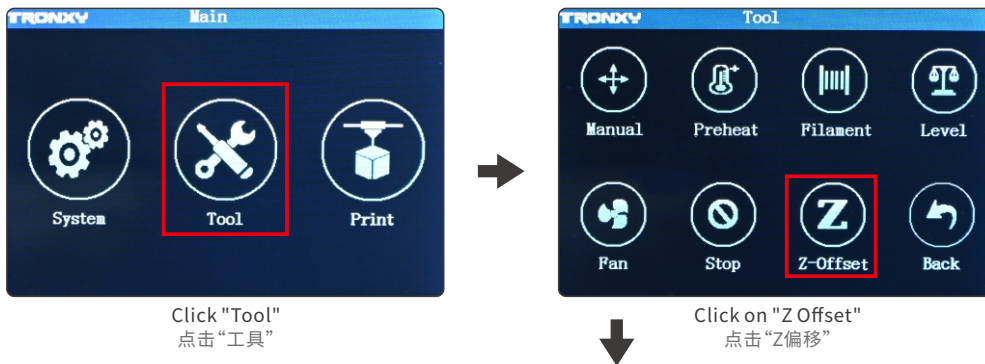
Check the leveling value and adjust the nut
at the corresponding position under the platform
(see page 27 for adjustment method)

查看调平数值, 调整平台下方相应位置的螺母
(调整方法请看第27页)

Z Offset Setting Z偏移设置

After the leveling is successful, perform the Z offset operation

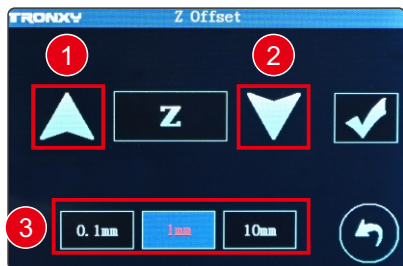
调平成功后, 进行Z偏移操作



At this time, the print head will move to the middle position above the hot bed, Next, we need to manually lower the print head to About 0.1mm away from the hot bed (About A4 paper thickness).

此时打印头会移动到热床上方中间位置, 下一步, 我们需要手动将打印头下降到距离热床约0.1mm处(约A4纸厚度)。

Z Offset Setting Z偏移设置

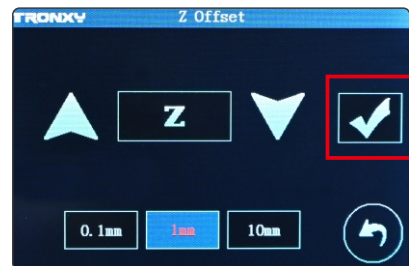


Select the distance you need to move, it is recommended to start from "1mm"
选择需要移动的距离, 建议从“1mm”开始

- 1 Nozzle rises
喷嘴上升
- 2 Nozzle down
喷嘴下降
- 3 Distance to move with one click
点击一次移动的距离



You can put a piece of A4 paper on the platform, adjust the nozzle to just touch the paper, Push the paper back and forth and feel a slight resistance.
可放一张A4纸在平台上, 将喷嘴调整到刚好碰到纸张, 前后推动纸张能感受到轻微阻力即可。

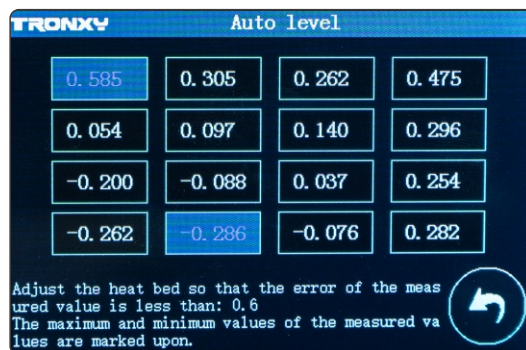


After the adjustment is complete, click the "✓" icon

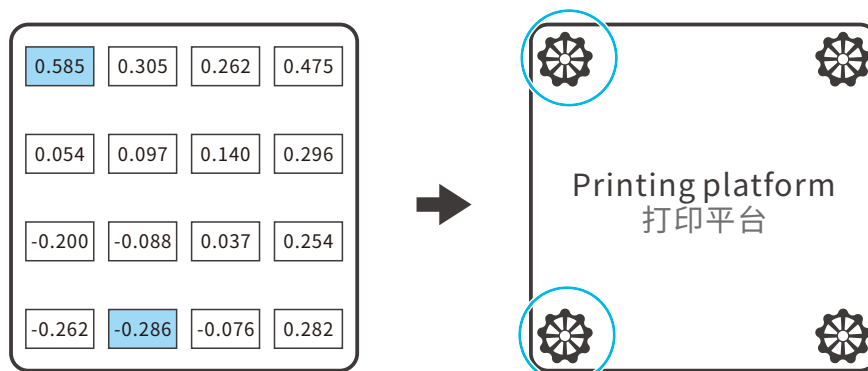
调整完成后, 点击“✓”图标即可

Print Platform Leveling - Operation After Auto Leveling Fails 打印平台调平 - 自动调平失败后的操作

After the automatic leveling fails, refer to the following example and use the leveling nut to level the printing platform
自动调平失败后,参考以下例子,使用调平螺母调平打印平台



Leveling failed values
调平失败的数值



The value corresponds to the 16 points on the platform,
See where the highest and lowest values are

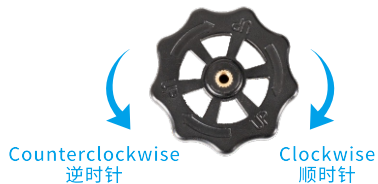
数值对应平台上的16个点,
查看最高与最低数值的位置

According to the value, adjust the
corresponding nut under the platform
根据数值,调整平台下方对应的螺母

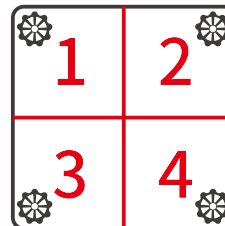
Print Platform Leveling - Operation After Auto Leveling Fails 打印平台调平 - 自动调平失败后的操作



Tips 温馨提示



0.585	0.305	0.262	0.475
0.054	0.097	0.140	0.296
-0.200	-0.088	0.037	0.254
-0.262	-0.286	-0.076	0.282

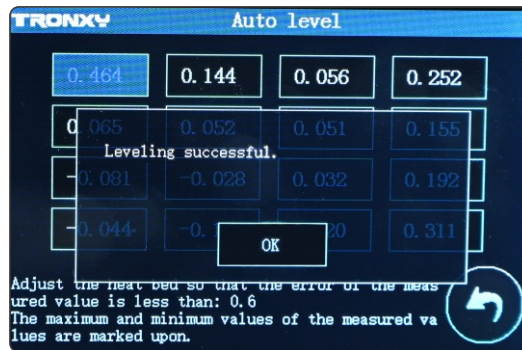


If the value is too large, rotate the nut counterclockwise;
If the value is too small, turn the nut clockwise.
When 16 points have errors, 4 values are adjusted by 1 nut.

数值过大, 逆时针旋转螺母;
数值过小, 顺时针旋转螺母。
16个点出现误差时, 4个数值由1个螺母进行调整。



After adjusting the nut,
conduct automatic leveling again
调整完螺母, 再进行一次自动调平



Leveling successful
调平成功

Print Platform Leveling - Method 2 - Manual Leveling 打印平台调平 - 方法二 - 手动调平



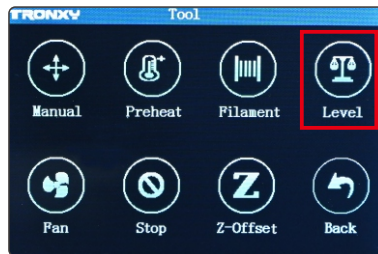
Before manual leveling, set the Z offset first.
(please refer to page 25 and 26 for Z offset setting operation)

手动调平之前,要先进行Z偏移设置。(Z偏移设置操作请查看第25、26页)

Manual leveling operation 手动调平的操作



Click "Tool"
点击“工具”

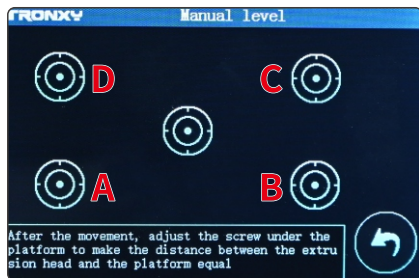


Click "Level"
点击“调平”



Select "Manual"
点击“手动”

Print Platform Leveling - Method 2 - Manual Leveling 打印平台调平 - 方法二 - 手动调平



Click the four points ABCD in turn, the print head will move to the corresponding position, and then adjust the leveling screw below the corresponding point, so that the distance between the nozzle and the platform is about 0.1mm.

(about the thickness of A4 paper)

依次点击ABCD四个点，打印头会移动到对应位置，然后调节对应点下方的调平螺母，使喷嘴与平台的距离约为0.1mm左右。

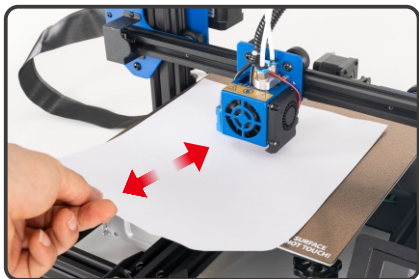
(约为A4纸厚度)



Observe the distance between the nozzle and the A4 paper, and adjust the leveling nut under the platform.

观察喷嘴与A4纸的距离，调节平台下方的调平螺母。

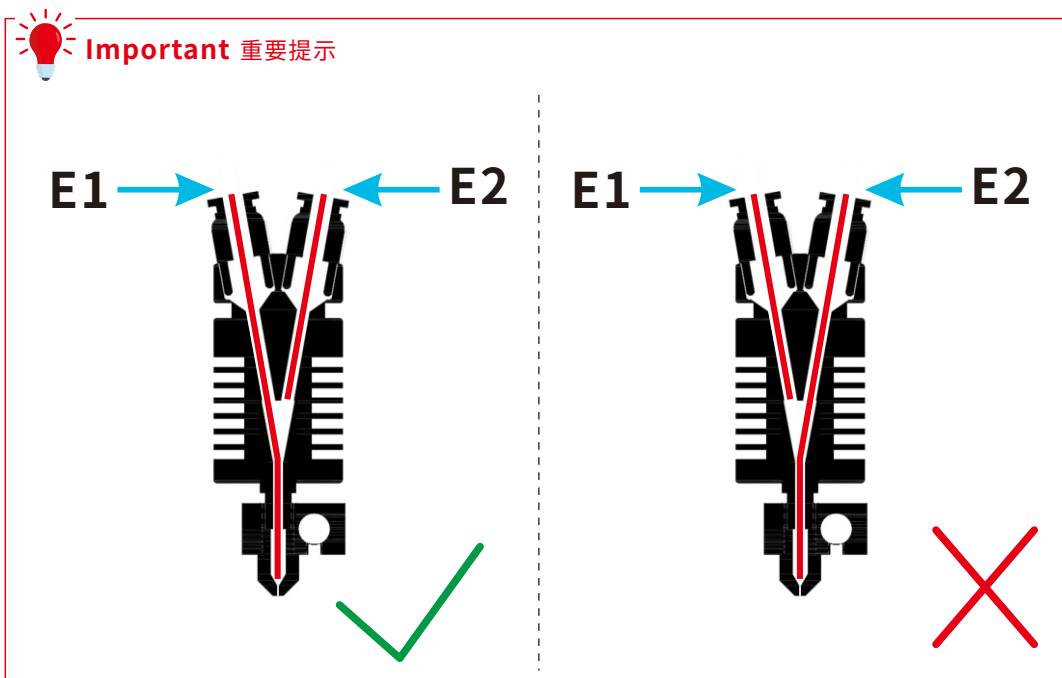
- 1 Turn the nut counterclockwise to lower the heatbed
逆时针旋转螺母，可降低热床
- 2 Turn the nut clockwise to raise the heated bed
顺时针旋转螺母，可升高热床



You can put a piece of A4 paper on the platform, adjust the nozzle to just touch the paper, Push the paper back and forth and feel a slight resistance.
(Adjust other points in this way)

可放一张A4纸在平台上，将喷嘴调整到刚好碰到纸张，前后推动纸张能感受到轻微阻力即可。
(按此方法调整其他的点)

Note when using 2-in-1 print head
使用2进1打印头时需要注意



Ensure E1 feeding and E2 returning before **each printing**, as shown in the left figure, otherwise it will lead to blocking.

每次打印前均需确保E1进料、E2退料，如左图所示，否则会导致堵料。

Load And Unload Filaments 耗材的装载和卸除



Important 重要提示

When using dual filament, it is necessary to pay attention to withdraw the existing filament in the print head first, and then feed the filament on the other side;

Feeding the filament on the other side without ejecting the filament may cause the print head to block.

Please see the next page for details.

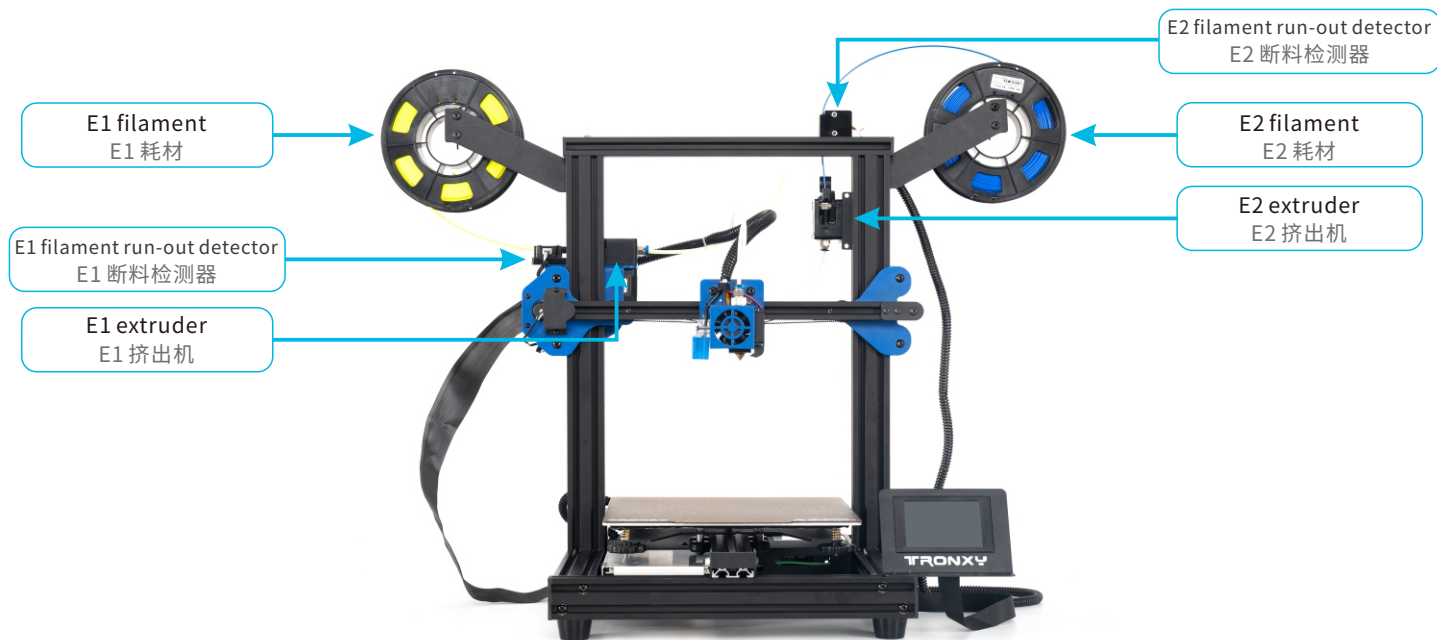
当使用双耗材时，需要注意，先将打印头内现有的耗材退出，再将另一侧的耗材送入；

如不退出耗材就送入另一侧的耗材，可能会造成打印头堵死的情况。

具体操作请看下一页。

Refer to the picture below to distinguish E1 and E2 filaments

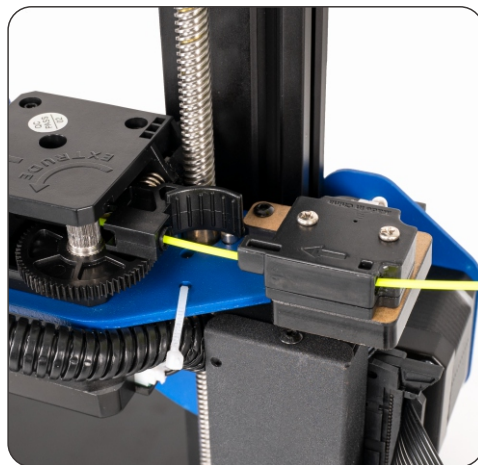
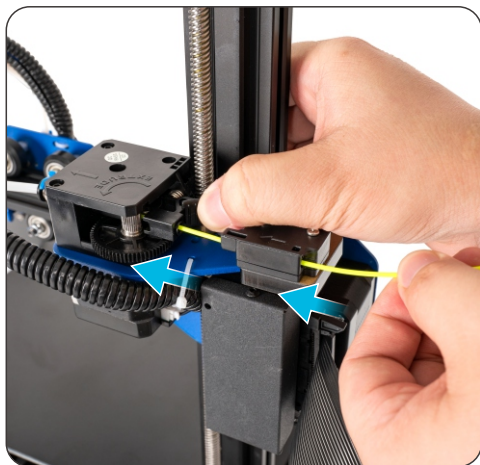
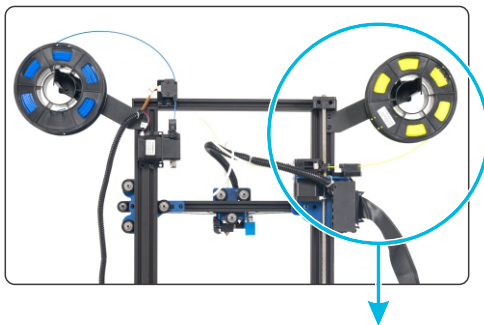
参考下方图片，区分E1和E2耗材



Load And Unload Filaments 耗材的装载和卸除

1. Install the E1 filament

安装E1耗材



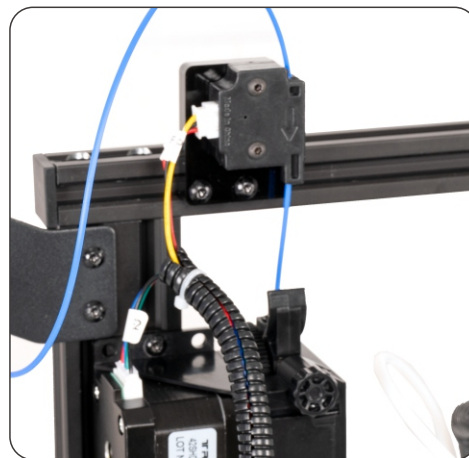
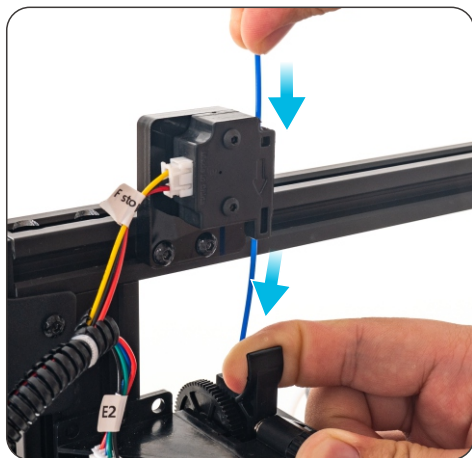
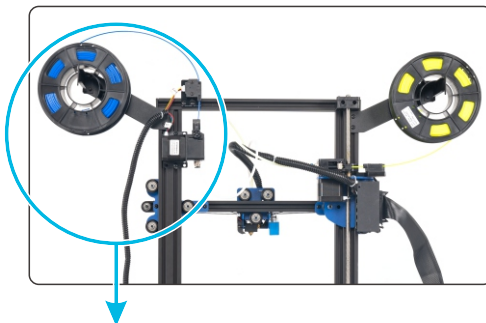
Insert it into the filament detector first, then press the elastic buckle of the extruder by hand to push the filament into the extruder.
(Just push the filament into the extruder, without pushing it to the print head)

先从断料检测器插入,再用手按压挤出机的弹力扣,将耗材推入挤出机。
(只需将耗材推入挤出机即可,不需将耗材推到打印头处)

Load And Unload Filaments 耗材的装载和卸除

2. Install the E2 filament

安装E2耗材



Insert it into the filament detector first, then press the elastic buckle of the extruder by hand to push the filament into the extruder.
(Just push the filament into the extruder, without pushing it to the print head)

先从断料检测器插入,再用手按压挤出机的弹力扣,将耗材推入挤出机。
(只需将耗材推入挤出机即可,不需将耗材推到打印头处)

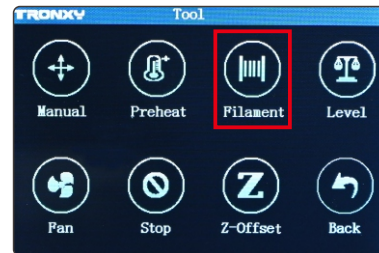
Load And Unload Filaments 耗材的装载和卸除

3. Preheat nozzle 预热喷嘴

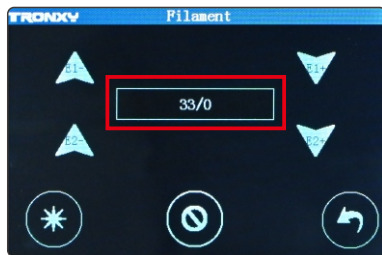
预热喷嘴



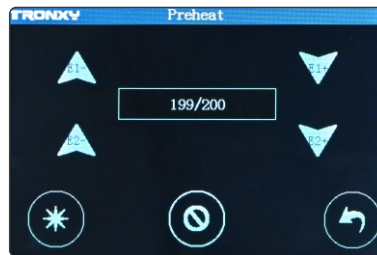
Click "Tool"
点击“工具”



Click "Filament"
点击“材料”



Click "33/0" to start heating
点击“33/0”开始加热



Wait for the temperature to rise to 200
等待温度提升到200



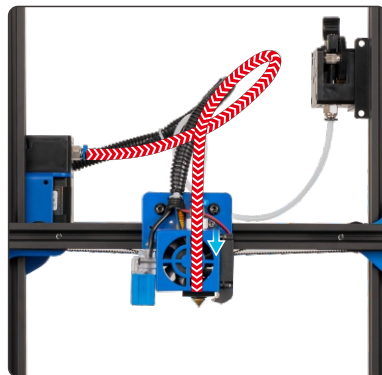
- ① (E1-/E2-): indicates retracting filaments
(E1-/E2-) 退出耗材
- ② (E1+/E2+): indicates feeding filaments
(E1+/E2+) 挤出耗材

Load And Unload Filaments 耗材的装载和卸除

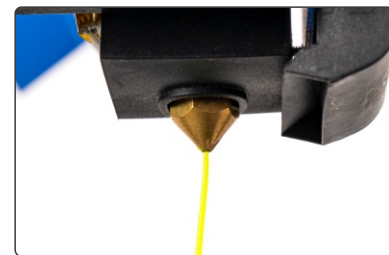
4. Extrude and retract E1 filament 挤出和退出E1耗材



After preheating the nozzle,
click "E1+" to send E1 filament
预热喷嘴后, 点击"E1+"送入E1耗材



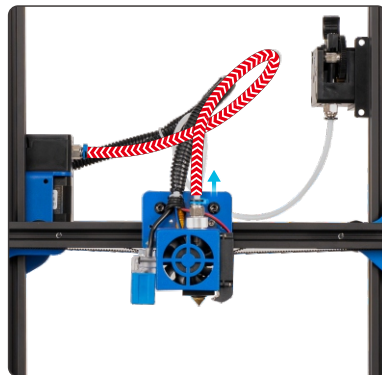
Wait for E1 filament to be sent to the print head
等待E1耗材被送入打印头



Until E1 filament flows out of the nozzle
直到喷嘴挤出E1耗材



Click "E1-" to retract E1 filament
点击"E1-"退出E1耗材



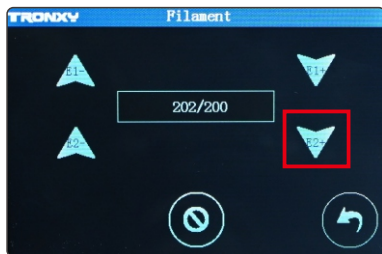
E1 filament can be pulled out from the print head,
and it does not need to be pulled out from the filament tube
E1耗材退出打印头即可, 不用退出铁氟龙管



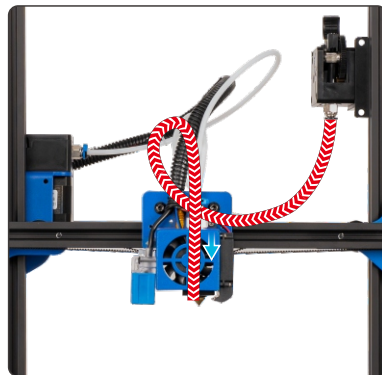
Click the Stop icon to stop retracting
点击“停止”图标, 停止退出

Load And Unload Filaments 耗材的装载和卸除

5. Extrude and retract E2 filament 挤出和退出E2耗材



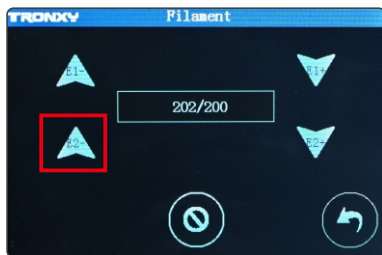
After preheating the nozzle,
click "E2+" to send E2 filament
预热喷嘴后, 点击"E2+"送入E2耗材



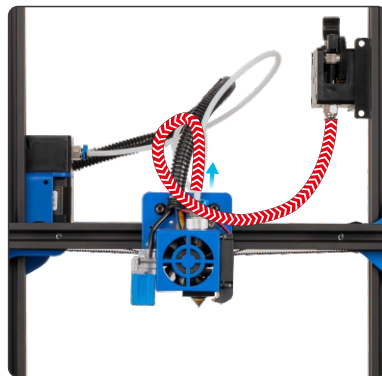
Wait for E2 filament to be sent to the print head
等待E2耗材被送入打印头



Until E2 filament flows out of the nozzle
直到喷嘴挤出E2耗材



Click "E2-" to retract E2 filament
点击"E2-"退出E2耗材

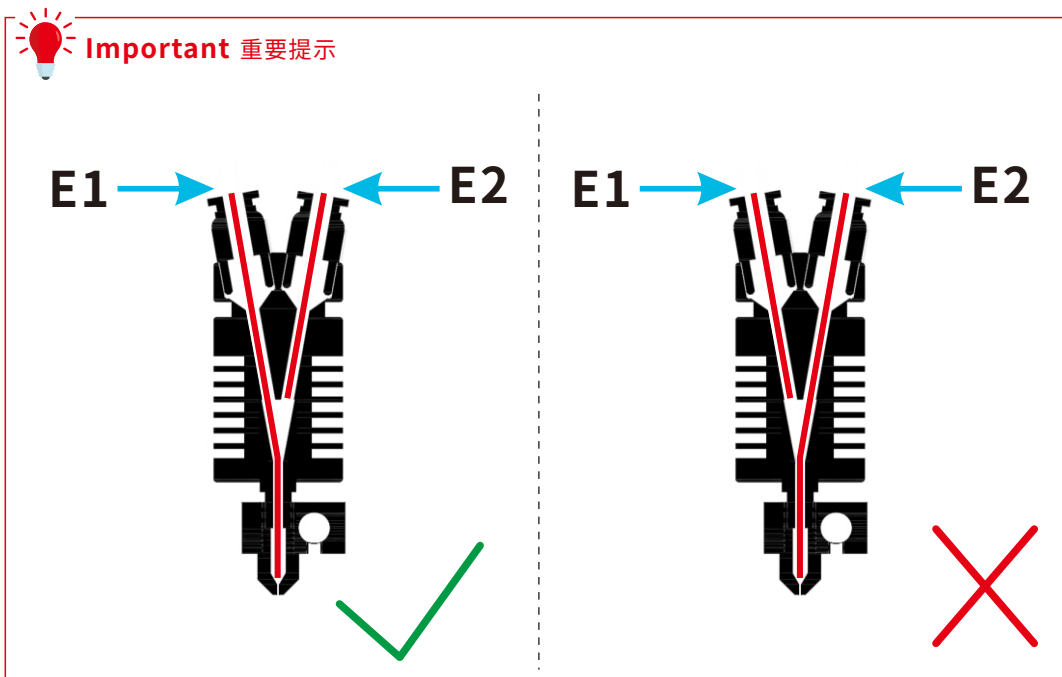


E2 filament can be pulled out from the print head,
and it does not need to be pulled out from the filament tube
E2耗材退出打印头即可, 不用退出铁氟龙管



Click the Stop icon to stop retracting
点击“停止”图标, 停止退出

Note when using 2-in-1 print head
使用2进1打印头时需要注意



Ensure E1 feeding and E2 returning before **each printing**, as shown in the left figure, otherwise it will lead to blocking.

每次打印前均需确保E1进料、E2退料，如左图所示，否则会导致堵料。



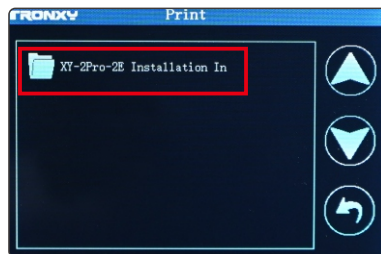
TF卡金属面朝上

1. When inserting the TF card into the card slot of the desktop, make sure that the metal surface is facing up, and do not use too much force, which may cause the risk of damaging the TF card or the card slot of the motherboard;
2. If the contents on the TF card cannot be read, please restart the machine, format with FAT32 and try again;
3. The printer is compatible with other TF cards of the same size;
4. Save the data to be printed in the root directory of the TF card. Do not save other folders or files in the TF card. It is better to name the G- CODE file name with a number.

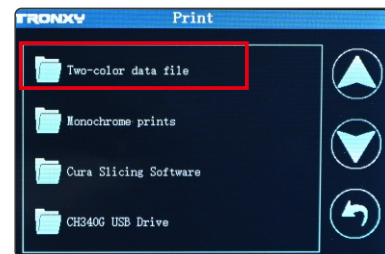
- 1、将TF卡插入桌面卡槽时，确保金属面朝上，不要用力过猛，存在损坏 TF卡或主板卡槽的风险；
- 2、如果无法读取TF卡上的内容，请重启机器，使用 FAT32 格式化后重试；
- 3、打印机兼容其他同大小尺寸的TF卡；
- 4、将要打印的数据保存在TF卡根目录下，不要在TF卡中保存其他文件夹或文件，并且最好用数字命名 G-CODE 文件名。



Click "print"
选择“打印”



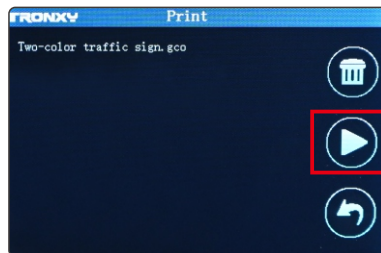
Click to enter the folder
点击进入文件夹



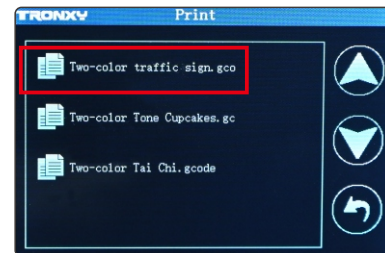
Select a two-color model folder
(or other folder)
选择双色模型文件夹 (或其他文件夹)



Start printing
开始打印



After confirming that the file is suffixed with .gcode,
click the "▶" icon
确认文件无误后，点击“▶”图标

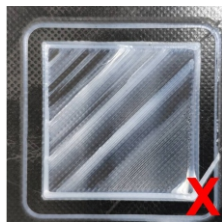


Select one of the files
选择其中一个文件

Print Test 打印测试

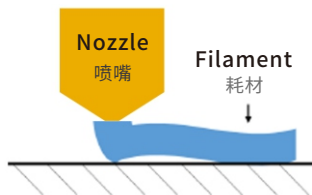
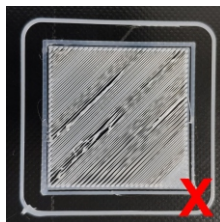
Possible situations and solutions when extruding filament

挤出耗材时可能出现的情况以及解决的办法



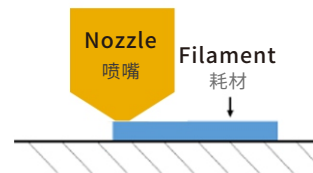
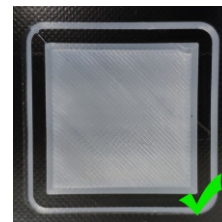
The distance between the hot bed and the nozzle is too close, you need to adjust the Z compensation, press the **arrow 1** in the figure to compensate the difference.

热床与喷嘴距离太近, 需要调整Z补偿, 按图中**箭头1**补偿

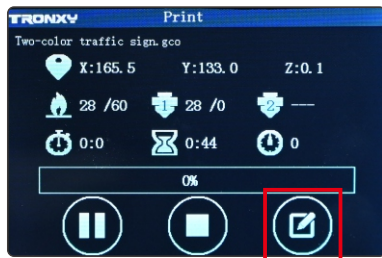


The distance between the hot bed and the nozzle is too far, you need to adjust the Z compensation, press the **arrow 2** in the figure to compensate the difference.

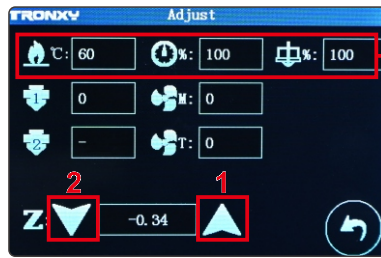
热床与喷嘴距离过远, 需调整Z补偿, 按图中**箭头2**补偿差值。



Proper nozzle height
Good extrusion and adhesion
合适的喷嘴高度良好的挤出和附着力



Page displayed when printing
打印中的页面



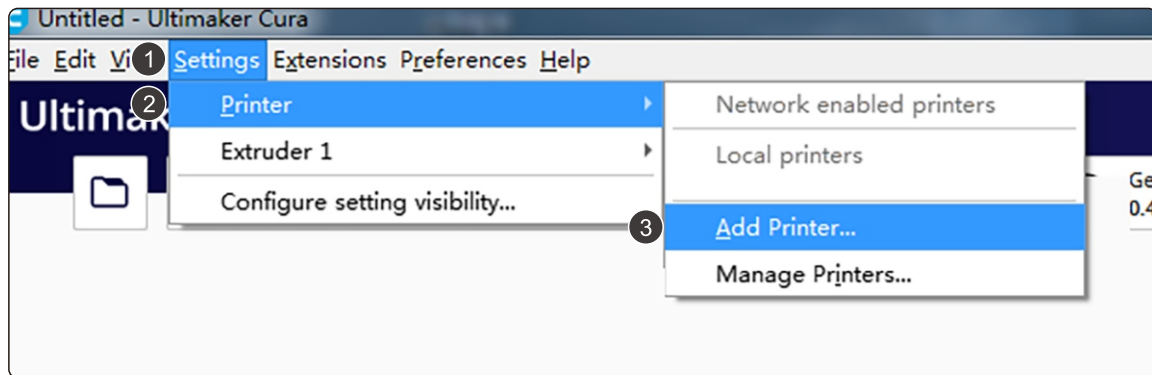
Real time adjustment page
实时调节页面



Hot bed temperature, printing speed, nozzle temperature
can be adjusted in real time
可以实时调节热床温度、打印速度、喷嘴温度

Slice Software Installation Steps 切片软件安装设置

1. Install "Ultimaker_Cura-amd64" on the computer, double-click to install the software,
and follow the prompts to complete the installation steps;
在电脑上安装“Ultimaker_Cura-amd64”，双击安装软件，按照提示完成安装步骤；
2. Add a printer;
添加打印机；

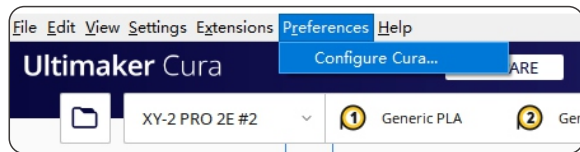


① Settings → ② Printer → ③ Add Printer...
设置 → 打印机 → 新增打印机

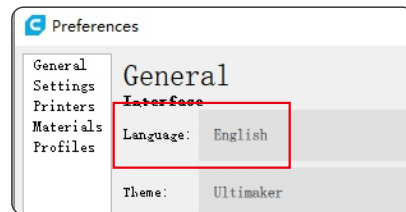


How to change the language of slicing software

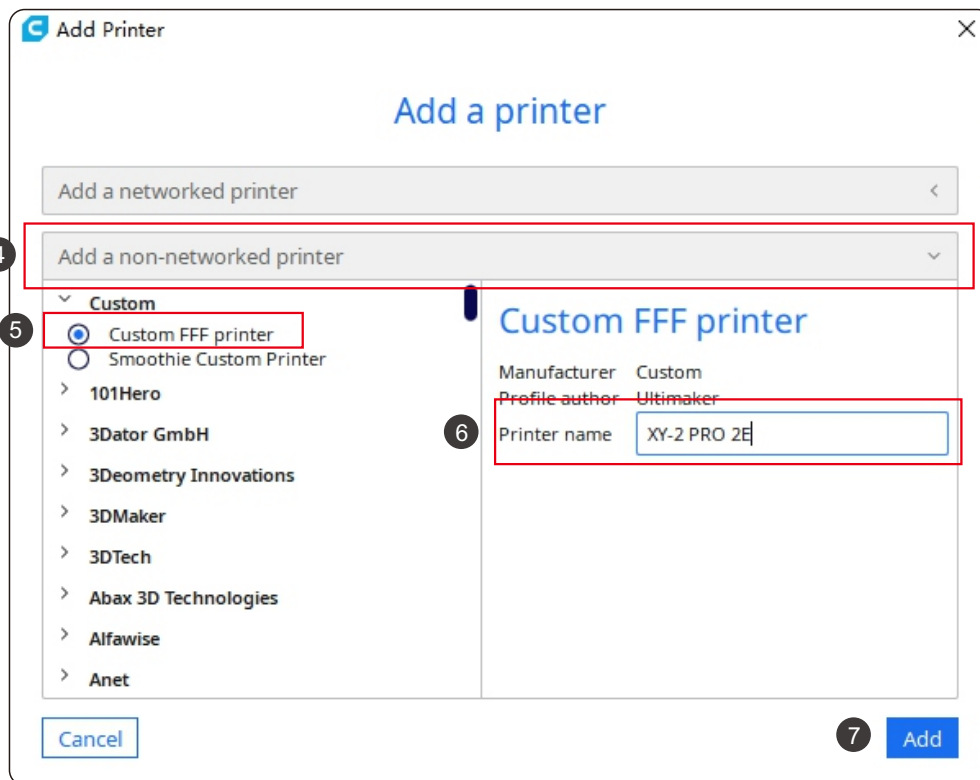
切片软件如何更换语言



Preferences → Configure Cura...
偏好设置 → 配置Cura



After selecting the desired language,
restart the software
选择好需要的语言后，后重启软件即可



- 4 Add a non-networked printer → 5 Custom FFFprinter → 6 Enter "XY-2 PRO 2E"
点击“添加未联网打印机” 选择“Custom FFFprinter” 输入“XY-2 PRO 2E”
- 7 Add
点击“添加”

Add Printer

Machine Settings

XY-2 PRO 2E

Printer	Extruder 1	Extruder 2
Printer Settings		
X (Width)	255.0 mm	
Y (Depth)	255.0 mm	
Z (Height)	260.0 mm	
Build plate shape	Rectangular ▾	
Origin at center	☐	
Heated bed	☒	
Heated build volume	☐	
G-code flavor	Marlin ▾	
Start G-code		
G28 :Home		
Printhead Settings		
X min	-20 mm	
Y min	-10 mm	
X max	10 mm	
Y max	10 mm	
Gantry Height	260.0 mm	
Number of Extruders	2 ▾	
Apply Extruder offsets to GCode	1	2
	3	4
	5	6
	7	8
End G-code		
M104 S0		

- 8 Enter the machine print size and select "heated bed" → 9 "Number of Extruders" select "2"
- 输入机器打印尺寸和勾选“加热床” “挤出机数目”选择“2”

Add Printer

Machine Settings

XY-2 PRO 2E

Printer | **Extruder 1** | Extruder 2

Nozzle Settings

Nozzle size: 0.4 mm

Compatible material diameter: 1.75 mm

Nozzle offset X: 0.0 mm

Nozzle offset Y: 0.0 mm

Cooling Fan Number: 0

Extruder Start G-code

Extruder End G-code

Next

10 Set E1 print head
设置E1打印头

Add Printer

Machine Settings

XY-2 PRO 2E

Printer

Extruder 1

Extruder 2

Nozzle Settings

Nozzle size0.4 mm

Compatible material diameter1.75 mm

Nozzle offset X0.0 mm

Nozzle offset Y0.0 mm

Cooling Fan Number0

Extruder Start G-code

Extruder End G-code

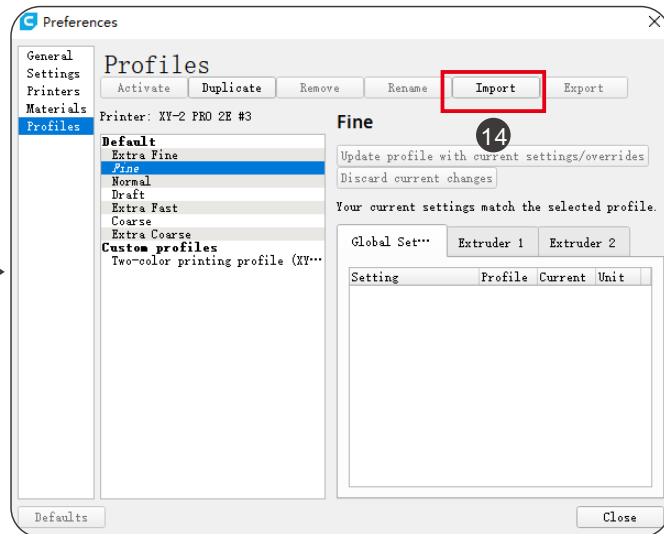
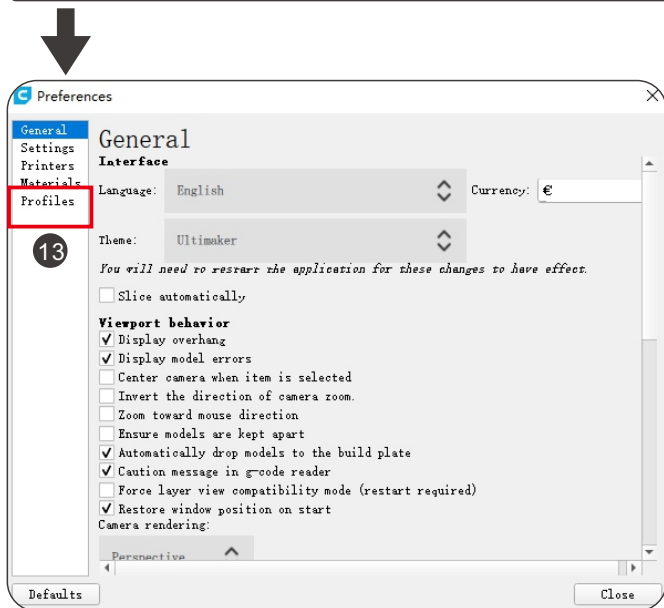
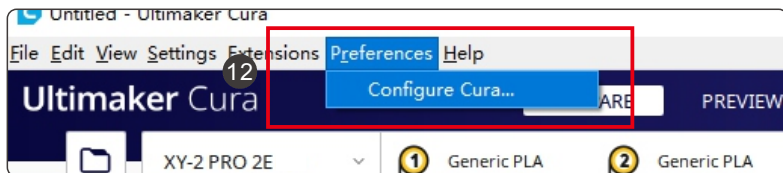
Next

11 Set E2 print head
设置E2打印头

Slice Software Installation Steps 切片软件安装设置

3. Import the configuration file "Two-color printing profile (XY-2PRO-2E XY-3SE-2E)" in TF card"

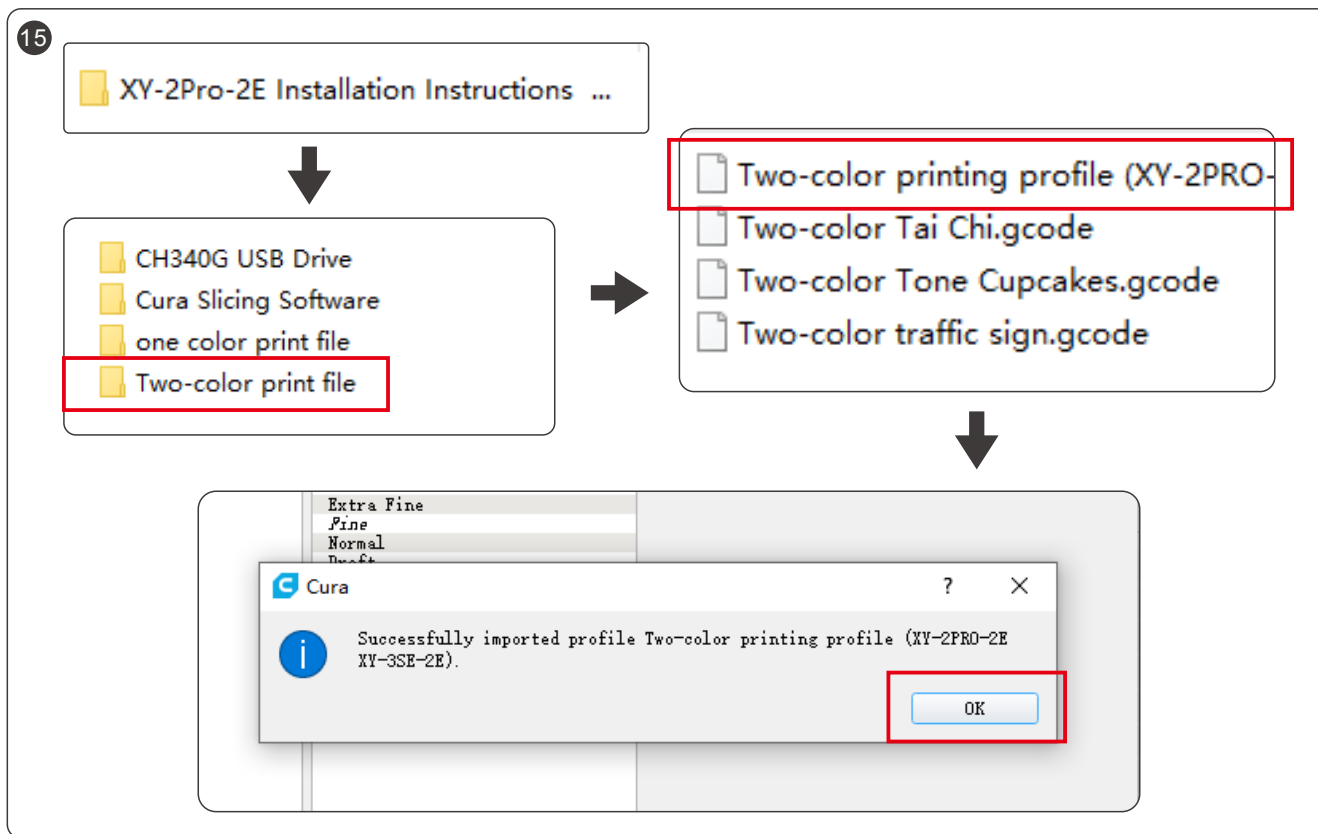
导入TF卡内的配置文件“Two-color printing profile (XY-2PRO-2E XY-3SE-2E)”



⑫ Preferences → Configure Cura... → ⑬ Profiles → ⑭ Import
点击“偏好设置” 选择“配置Cura...” 点击“配置文件” 点击“导入”

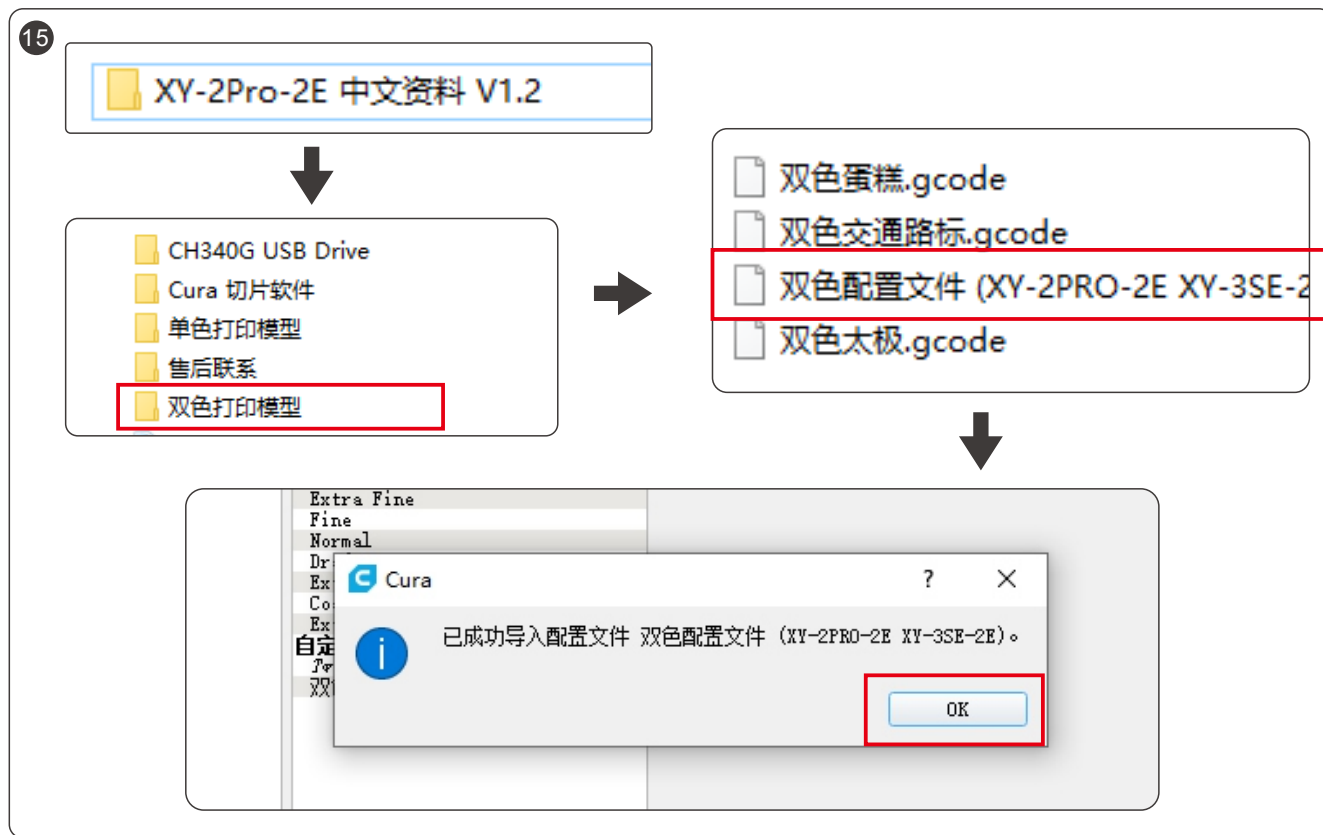
Slice Software Installation Steps 切片软件安装设置

English document instructions
英文文档指示图



15 Use the computer to read the TF card, find the configuration file in the TF card and import it

Chinese document instructions
中文文档指示图

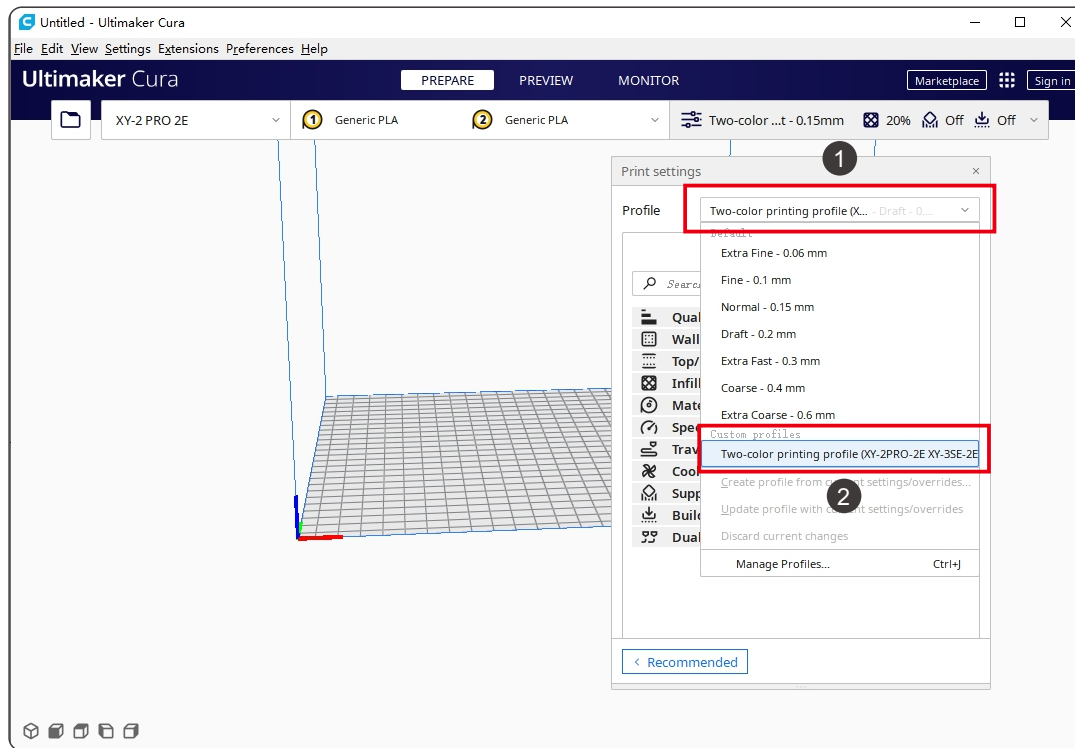


15 将TF卡插到电脑，找到TF卡内的配置文件并导入

How To Use Slice Software 模型切片

1. Import the model and slice it (taking the two-color model as an example)

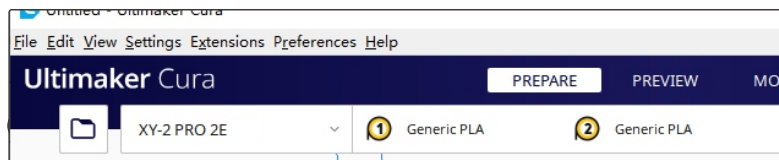
导入模型进行切片(以双色模型为例)



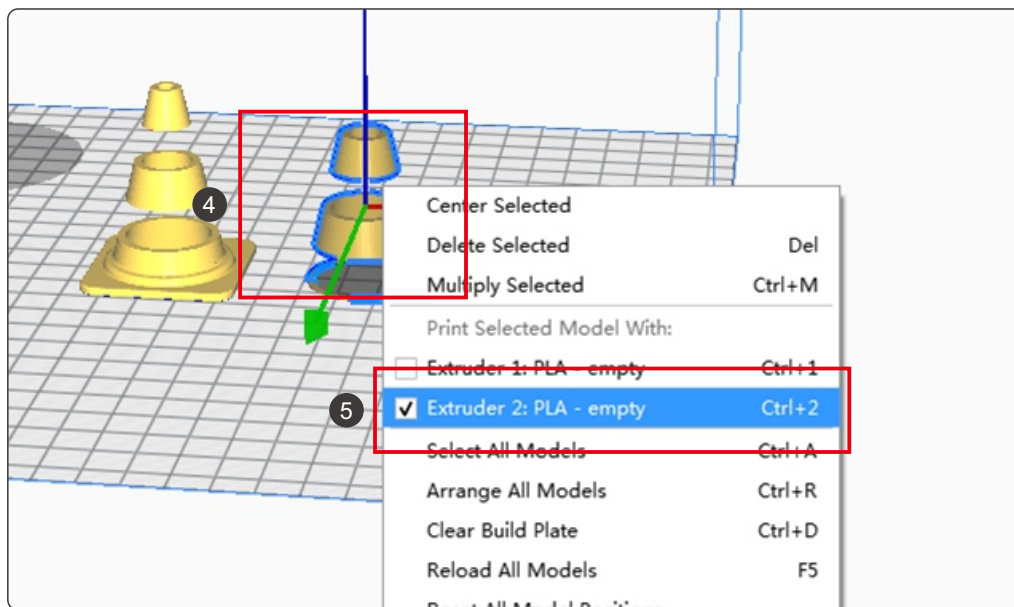
1 Click "Profile" 点击“配置文件”

2 Select the configuration file "Two-color printing profile (XY-2PRO-2E XY-3SE-2E)" that you just imported
选择刚导入的配置文件“双色配置文件 (XY-2PRO-2E XY-3SE-2E)”

How To Use Slice Software 模型切片

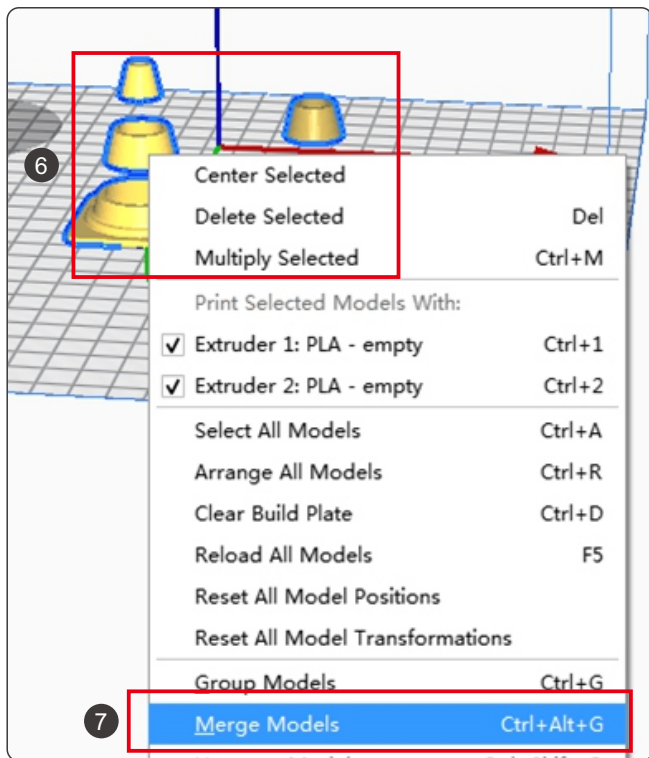


- 3 Import a two-color combination file
导入一个双色组合文件



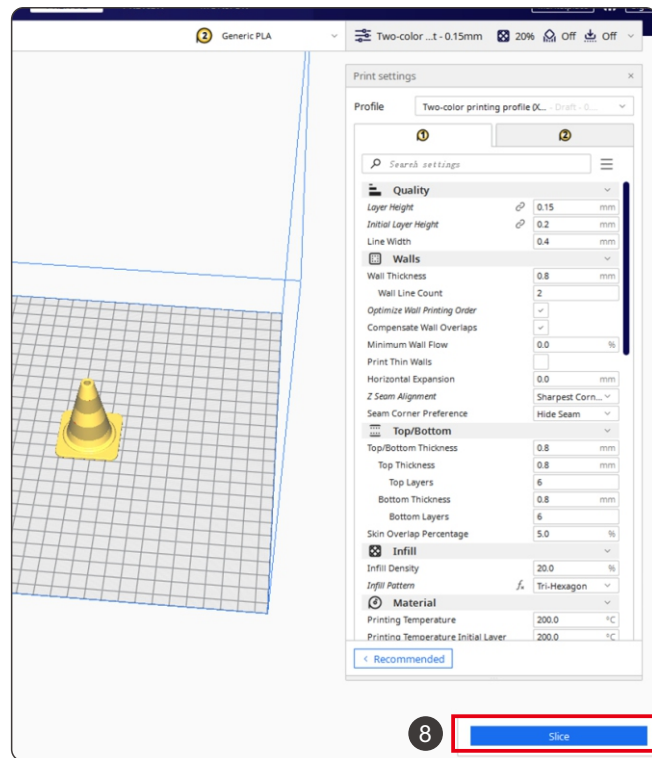
- 4 Select a model and right-click it.
选择其中一个模型，点击鼠标右键
- 5 Select "Extruder 2: PLA-empty" to let E2 print this part of the model
勾选“Extruder 2: PLA-empty”，作用是让E2打印打印这部分模型

How To Use Slice Software 模型切片



⑥ Hold down the "shift" key and select both models at the same time
按住“shift”键同时选中两个模型

⑦ Right-click and select "Merge Models"
点击鼠标右键，选择“合并模型”



⑧ Click "slice", and then export the file to TF card to insert the printer socket for printing.

点击“切片”，然后导出文件至TF卡内，即可打印

1. Machine cannot start

- 1) Check the power line and other wires are connected well or not.
- 2) Check whether the supply voltage suits the local standard.
- 3) Check whether the screen or power supply is damaged and replace it in time.
- 4) Check if the wires are damaged or broken.
- 5) Check whether the power fuse is burnt out.

1. 机器无法启动

- 1) 检查电源线和其他电线是否连接好。
- 2) 检查供电电压是否符合当地标准。
- 3) 检查屏幕或电源是否损坏,及时更换。
- 4) 检查电线是否损坏或断裂。
- 5) 检查电源保险丝是否烧断。

2. The contents of the TF card cannot be read

- 1) Check the card reader if it is good.
- 2) If the computer can't read the TF card, please format it and try again.
- 3) Check whether the TF card is inserted correctly.
- 4) The filename has an illegal character, please rename it.
- 5) Please replace the damaged TF card and try again.

2.无法读取TF卡内容

- 1) 检查读卡器是否完好。
- 2) 如果电脑无法读取TF卡,请格式化后再试。
- 3) 检查 TF 卡是否正确插入。
- 4) 文件名含有非法字符,请重命名。
- 5) 请更换损坏的 TF 卡并重试。

3. If the print head does not squeeze enough filament or can't squeeze any filament.

- 1) Check whether the print head temperature reach 200 °C above (PLA), led to filament cannot squeeze, waiting for the temperature rises to the set target.
- 2) Check whether the filaments are knotted, which leads to unsmooth feeding.
- 3) Check whether the filaments or pipes are not inserted in place, resulting in the failure of feeding.
- 4) Check whether the temperature of the print head is too high, which leads to excessive softness of filaments and can't be extruded normally.
- 5) Check whether the diameter of filaments is consistent with the diameter set in the slicing software, so that the amount of extrusion filaments is not enough.
- 6) Check whether the filament are blocked by dirt or nozzle blocked during extrusion.
- 7) Replace with better quality filaments.

3. 如果打印头没有挤压足够的耗材或无法挤压任何耗材。

- 1) 检查打印头温度是否达到200°C以上 (PLA) ,导致灯丝无法挤压,等待温度升至设定目标。
- 2) 检查细丝是否打结,导致送料不畅。
- 3) 检查灯丝或管道是否没有插入到位,导致送料失败。
- 4) 检查打印头温度是否过高,导致耗材过于柔软,不能正常挤出。
- 5) 检查长丝直径是否与切片软件中设置的直径一致,以免挤出长丝数量不够。
- 6) 检查耗材是否被脏物堵塞或挤出时喷嘴堵塞。
- 7) 更换质量更好的灯丝。

4. If the first layer upwarp

- 1) Check if the hot bed has been leveled well.
- 2) Check the surface of the hot bed for dirt.
- 3) Check whether the distance between the nozzle and the platform is too high, resulting in insufficient adhesive force.
- 4) Check the hot bed for adequate temperature.
- 5) Check the first layer of the slicing software to see if it is printing too fast.

4. 如果第一层向上翘起

- 1) 检查热床是否平整。
- 2) 检查热床表面是否有污垢。
- 3) 检查喷嘴与平台之间的距离是否太高,导致粘合力不足。
- 4) 检查热床是否有足够的温度。
- 5) 检查切片软件的第一层,看是不是打印太快了。

5. The model is not easy to take off

- 1) Try to heat the hot bed to 50-70 °C take off it by the shovel .
- 2) It is recommended to buy TRONXY magnetic stickers.

5.模型不易脱模

- 1) 尝试将热床加热至 50-70 °C 用铲子将其取下。
- 2) 建议购买TRONXY磁贴。

6. Can't heat it up

- 1) Check the heating rod and thermistor for poor contact or damage.
- 2) Check that the slice software has set the target temperature.
- 3) Check whether the thermistor wire falls off.

6.不能加热

- 1) 检查加热棒和热敏电阻是否接触不良或损坏。
- 2) 检查切片软件是否设置了目标温度。
- 3) 检查热敏电阻丝是否脱落。

7. Motor out of step

- 1) Check the tightness of the belt, whether the pulley is not locked.
- 2) Check the current voltage.
- 3) Check X/Y/Z axis motion is smooth.
- 4) Print speed too fast.
- 5) Environment temp too high.
- 6) Need flash the firmware.

7.电机失步

- 1) 检查皮带松紧, 皮带轮是否未锁紧。
- 2) 检查当前电压。
- 3) 检查 X/Y/Z 轴运动是否顺畅。
- 4) 打印速度太快。
- 5) 环境温度过高。
- 6) 需要刷固件。

8. Abnormal motor noise or vibration

- 1) Check whether the motor line is in bad contact, loose or wrong connection.
- 2) Motor temperature is too high.
- 3) Check whether the motor is damaged.
- 4) Flash the firmware.
- 5) The printing load is too heavy.

8. 电机异常噪音或振动

- 1) 检查电机线是否接触不良、松动或接错。
- 2) 电机温度过高。
- 3) 检查电机是否损坏。
- 4) 刷固件。
- 5) 打印负荷过重。

9. Model dislocation and fault

- 1) Nozzle feeding not smoothly, please clean the nozzle or replace the nozzle.
- 2) Check that if the printing speed is too fast.
- 3) The quality of filaments is poor, please replace with new filaments.

9. 模型错位与故障

- 1) 喷嘴进料不顺畅, 请清洁喷嘴或更换喷嘴。
- 2) 检查打印速度是否过快。
- 3) 灯丝质量差, 请更换新灯丝。

10. Abnormal sound and vibration of filaments feeding motor

- 1) Please check whether the nozzle is blocked.
- 2) The nozzle feeding is not smooth, please clean the nozzle.
- 3) Whether the software Settings are incorrect.
- 4) Check whether the motor does not work.
- 5) Check the motor working or not or feeding gear is not working.

10. 灯丝异常声音和振动送料电机

- 1) 请检查喷嘴是否堵塞。
- 2) 喷嘴进料不顺畅, 请清洁喷嘴。
- 3) 软件设置是否有误。
- 4) 检查电机是否不工作。
- 5) 检查电机是否工作或送料齿轮不工作。

11. Screen related questions

- 1) No screen/blue screen, please restart or check whether the cable is plugged in.
- 2) Touch screen malfunction, check whether the screws are installed too tight.
- 3) Garbled/splash screen, static, ground connection or restart.

11. 屏幕相关问题

- 1) 无屏/蓝屏, 请重启或检查网线是否插好。
- 2) 触摸屏故障, 检查螺丝是否安装过紧。
- 3) 乱码/闪屏、静电、接地或重启。

12. Motherboard related issues

- 1) The wiring is not responding. Please check the wiring installation.
- 2) Automatic shutdown restart, may be abnormal firmware or module of “resume print after power failure” damaged.
- 3) Lack of heat dissipation, please lower the ambient temperature.
- 4) No response due to motherboard damage.

12. 主板相关问题

- 1) 接线无反应。请检查接线安装。
- 2) 自动关机重启, 可能是异常固件或“断电恢复打印”模块损坏。
- 3) 散热不足, 请降低环境温度。
- 4) 主板损坏无反应。

13. Unable to connect to printer

- 1) Check that the driver is not installed or properly installed.
- 2) The serial port was not selected correctly.
- 3) The software parameters do not match.

13. 无法连接到打印机

- 1) 检查驱动程序是否未安装或正确安装。
- 2) 串口选择不正确。
- 3) 软件参数不匹配。

Due to the differences between different machine models, the physical objects and the final images can differ.

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