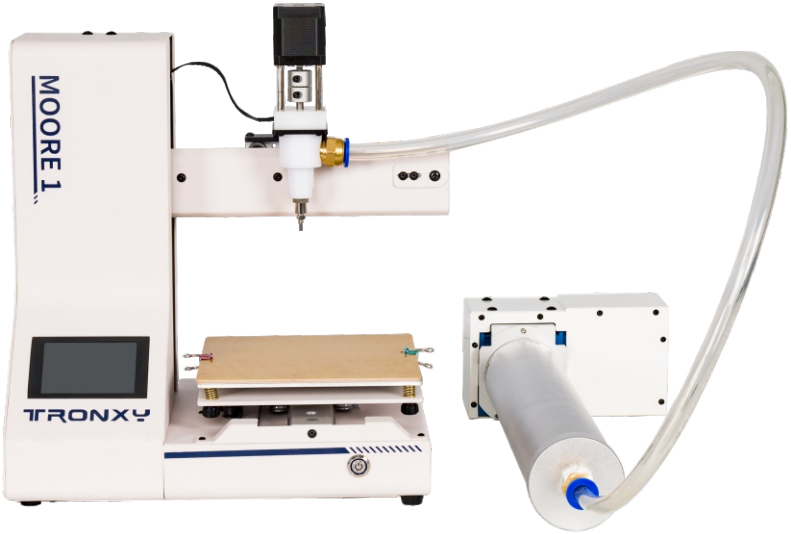

TRONXY

USER MANUAL

MOORE 1 CLAY 3D PRINTER

陶泥3D打印机使用说明书

User notes 用户须知

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. Children are not allowed to use the printer alone.
It is not recommended to use this 3D printer when unattended.

该机器包含高速运动部件，儿童不得单独使用打印机；
无人看管情况下，不建议运行 3D 打印机。

The recommended room temperature for 3D printers is 8 °C-40 °C, and the humidity is 20% - 80%. If used outside this temperature and humidity range, it may lead to a bad printing effect.

3D 打印机的使用环境温度建议为 8°C-40°C，湿度为20%-80%，
在此范围之外使用，可能带来不良的打印效果。

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 SD card, please check.

视频，软件等相关信息存储在SD卡中，请查看。

Directory 目录

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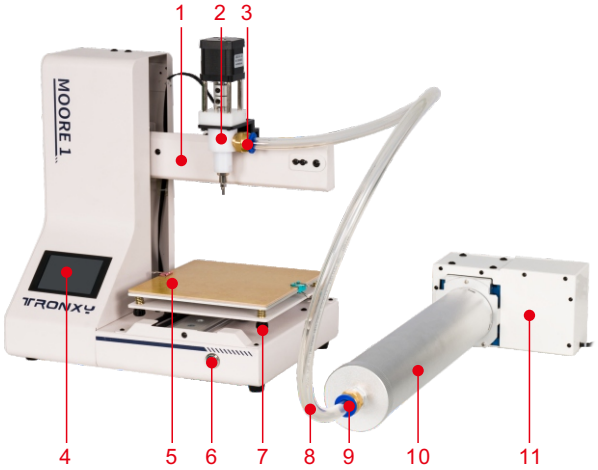
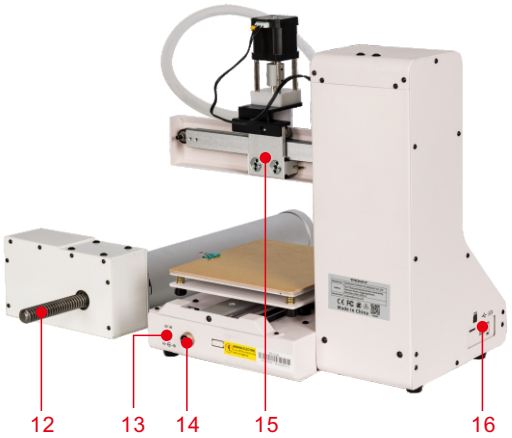
Introduction 设备简介





1 X axis system
X轴运动系统

2 Print head module
打印头模块

3 PC14-03 pneumatic connector
PC14-03气动接头

4 3.5 inch full color touch screen
3.5寸全彩触摸屏

5 Printing platform
打印平台

6 Power switch
电源开关

7 Leveling nut
调平螺母

8 Tube
料管

9 PC14-03 pneumatic connector
PC14-03气动接头

10 Barrel
料筒

11 Feeding transmission
推料变速器

12 M18 feeding screw
M18送料螺杆

13 DC interface
DC接口

14 Transmission interface
推料变速器接口

15 X axis slider
X轴滑块

16 USB-A, USB-B and TF card sockets
USB-A、USB-B和TF卡插口

Parameter 设备参数

Print parameters
打印参数

Printing principle : 打印原理	LDM (Liquid Deposition Molding) LDM (液体沉积成型)
Print volume : 打印体积	180×180×180 (mm)
Printing accuracy : 打印精度	0.3-3.0mm
Positioning accuracy : 定位精度	X/Y: 0.00625mm, Z:0.00125mm
Number of printhead : 喷头数量	1
Nozzle diameter : 喷嘴直径	1.0-3.0 mm (optional) 1.0-3.0 mm (可选)
Print speed : 打印速度	10~40mm/s (30mm/s is recommended) 10~40mm/s (建议30mm/s)
Moving speed : 移动速度	60mm/s
Consumables : 耗材	Ceramic mud, porcelain mud, purple sand mud, etc 陶泥 瓷泥 紫砂泥等

Temperature parameter
温度参数

Ambient temperature : 环境温度	8°C - 40°C

Software parameters
软件参数

Slicing software : 切片软件	Cura
Input format : 输入格式	.STL .OBJ
Output format : 输出格式	G-Code
Connection method : 连接方式	TF card, USB disk, USB cable (for skilled users) TF卡、U盘、USB线(适用于熟练使用者)

Power parameters
电源参数

Power input : 电源输入	100V-240V AC, 50/60Hz
Power output : 电源输出	24V/4A DC

Physical parameters
物理参数

Machine size : 机器尺寸	355*252*370 (mm)
Machine weight : 机器重量	≈7.5kg

Packing list 包装清单

1 Moore 1 Main Body*1
主机

2 Screw print head * 1
打印头

3 Feed transmission*1
送料变速器

4 Barrel*1
料筒

5 Tube * 2
料管

6 Power adapter*1
电源适配器

7 Power cable * 1
电源线

8 Clay *2
陶泥

9 Firberglass plate * 2
玻纤板

Accessories and tools
配件与工具

10 	11 	12 	13 	14 	15 
16 	17 	18 	a 		

10 **PC14-03 pneumatic connector * 1**
PC14-03气动接头气动接头

11 **Plastic wrap * 1**
保鲜膜

12 **Card reader and TF card * 1**
读卡器和TF卡

13 **USB cable *1**
USB连接线

14 **A box of nozzles *1**
一盒喷嘴

15 **M4 allen wrench * 1**
M4内六角扳手

16 **10 inch wrench**
10寸扳手

17 **6mm open end wrench**
6mm开口扳手

18 **L-shaped allen wrench * 4**
L型内六角扳手

a **M4*10 screws * 10**
M4*10螺丝

Product installation

产品安装

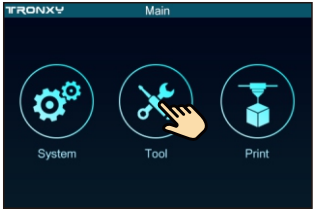
Product installation 产品安装

Insert the power cord and motor connection cable
插入电源线和电机连接线

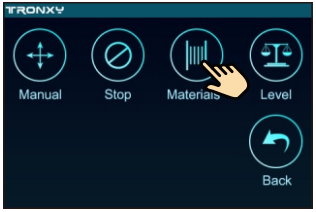
Turn on the machine
启动机器

Product installation 产品安装

3

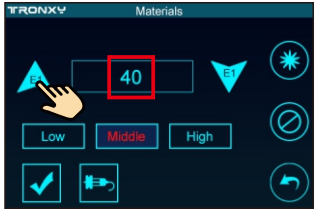


Select "Tool"
选择“Tool”



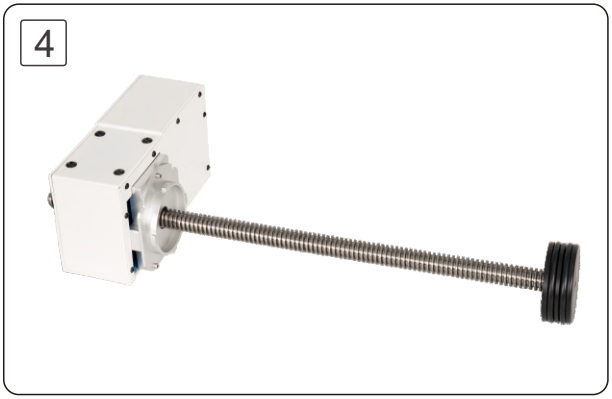
Select "Materials"
选择“Materials”

Click switch to
点击 切换到
(Speed range 0~40)
(速度范围0~40)



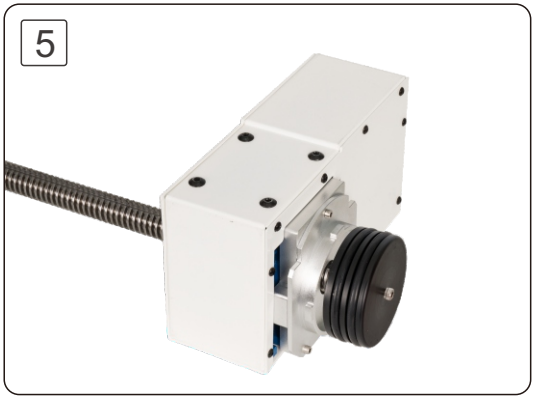
Set the speed to 40, click on to return the material
设置速度为40，点击 进行退料

4



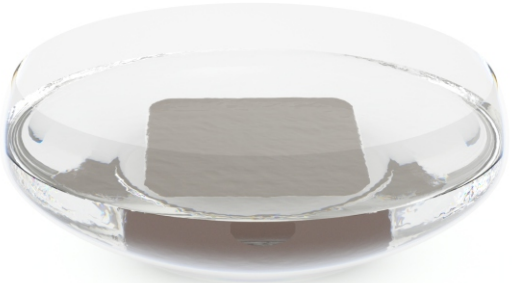
Place the transmission horizontally and wait for the screw to automatically enter the transmission
平放变速器，等待螺杆自动转入变速器内

5



Click on to turn off the transmission
点击 关闭变速器

6



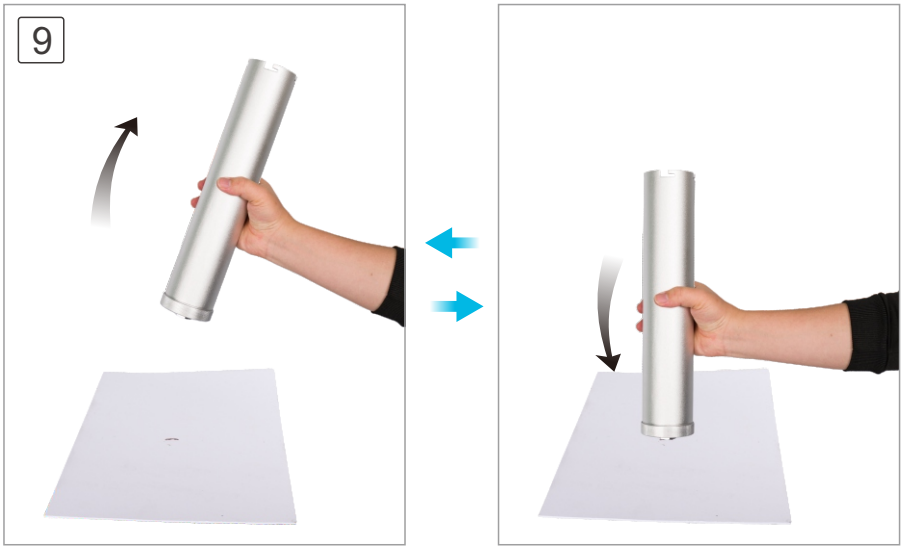
Put the clay into a basin, add some water (which needs to spread over the clay) , soak the clay for 2.5 hours.
将泥料放入盆中加入少量的水（需要漫过泥料）浸泡两个半小时左右

7

Take out the clay and mix it evenly by hand for 3-5 minutes. Shape the clay to be cylindrical by hand, and make sure its diameter is smaller than the barrel.
取出泥和均匀，大概和3-5分钟即可，最后将泥团揉成比料筒略小的圆柱形

Put the clay into the barrel

将泥团放入料筒里



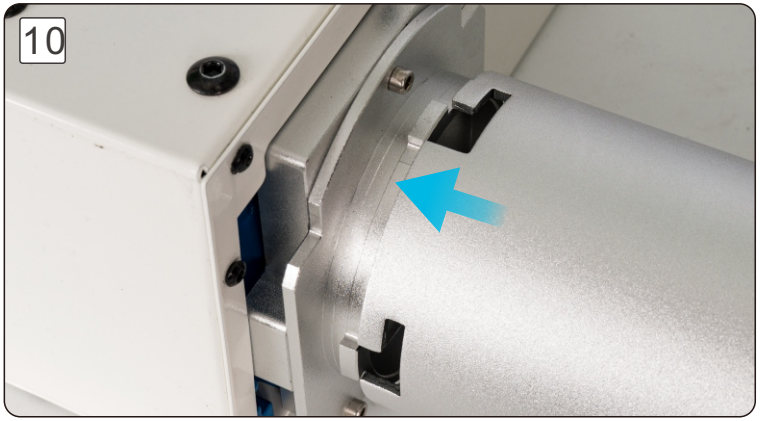
Beat the barrel up and down

上下捶打料筒

Find a piece of paper with a certain thickness and beat it up and down several times to squeeze out the bubbles in the barrel.

找一张有一定厚度的纸质材料，上下捶打料筒几次，将料筒中的气泡挤出。

Product installation 产品安装

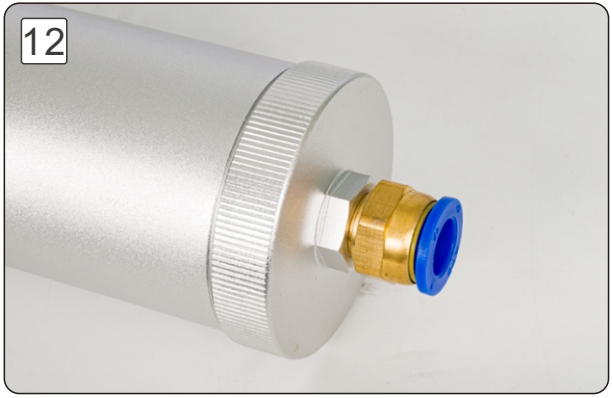


Align the material barrel with the buckle and install it into the transmission

将料筒对齐卡扣装进进变速器内

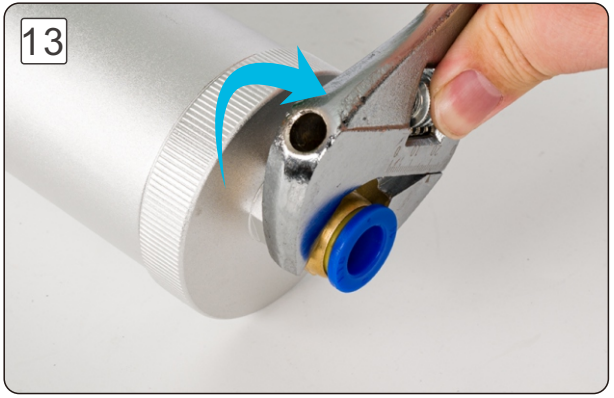
Rotate to the left to lock the buckle

向左旋转，卡住卡扣



Installing pneumatic interfaces

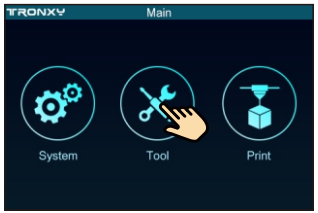
安装气动接口



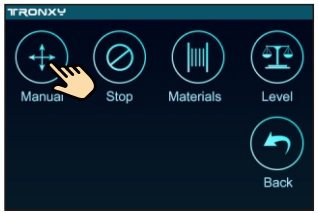
Tighten with a wrench

使用扳手拧紧

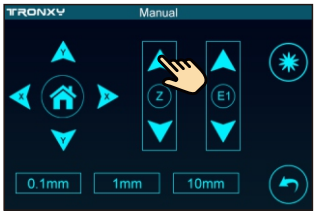
14



Select "Tool"
选择“Tool”

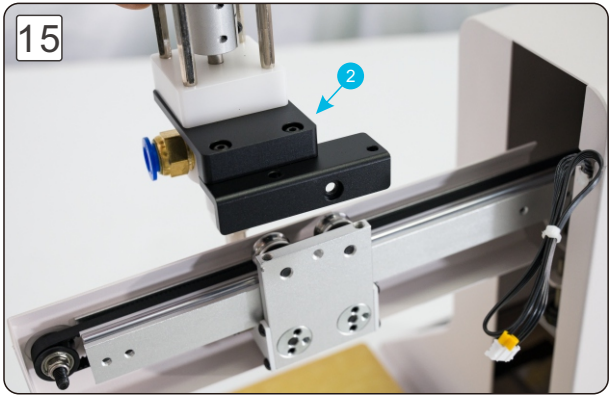


Select "Manual"
选择“Manual”

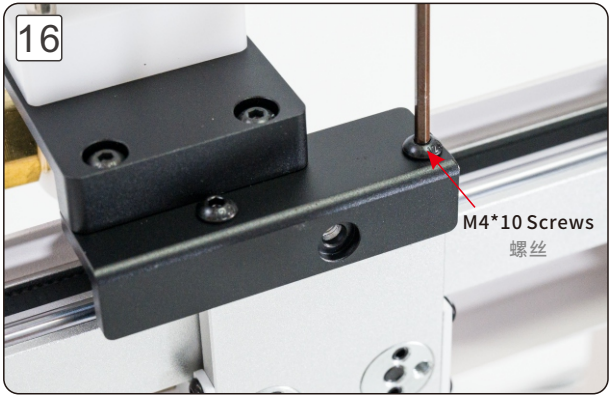


Click ▲ on the Z-axis to move it up
点击Z轴的 ▲，将Z轴向上移动

Product installation 产品安装

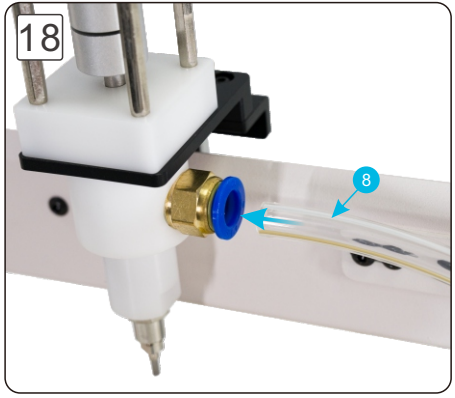


Installing the Print Head
安装打印头

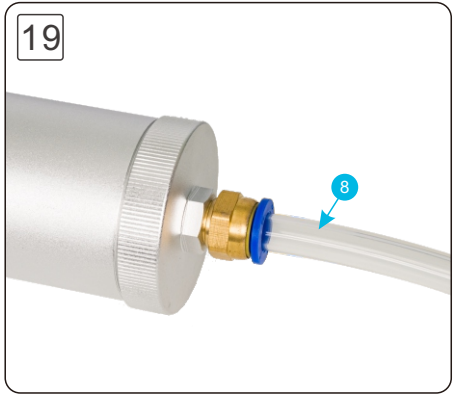


Lock with 2 M4 * 10 screws
使用2颗M4*10螺丝锁紧

Insert motor cable
插入电机线



Insert the material tube into the print head
将料管插入打印头

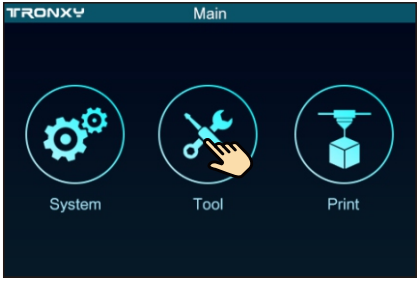


Insert the other end of the material tube into the material barrel, and the installation is complete
料管另一头插入料筒，安装完成

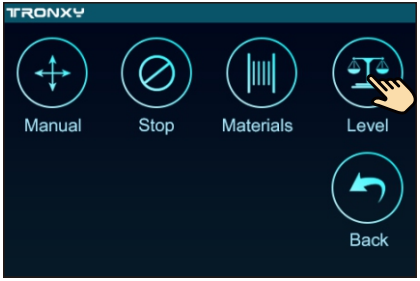
Platform leveling

平台调平

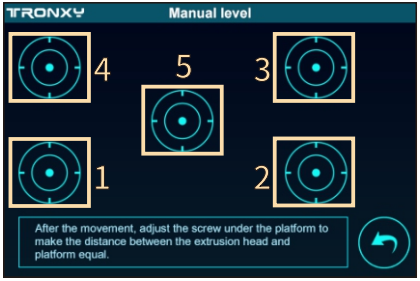
Platform leveling 平台调平



Select "Tool"
选择"工具"

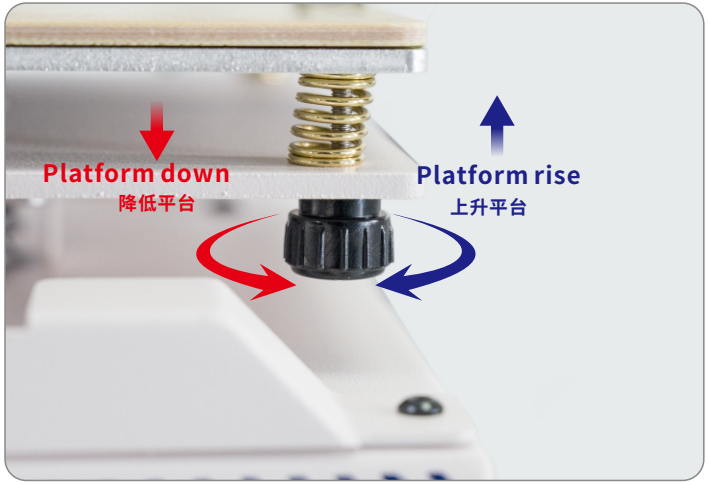


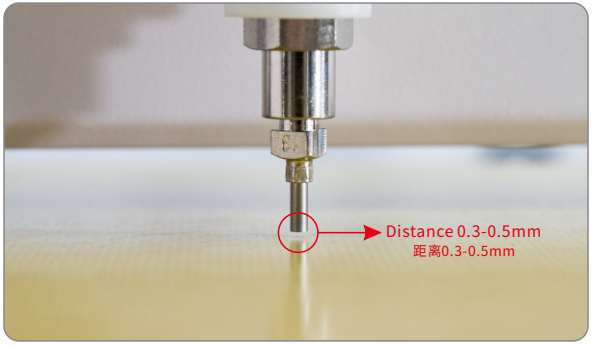
Select "Level"
选择"调平"



According to the sequence given in the figure, level the five positioning points one by one.
(Refer to the picture below for the leveling method)

按照图中给出的顺序，将五个定位点一一调平，
最后点击返回。(调平方法参考下图)





Adjust the four nuts under the platform to make the distance between the nozzle and the platform 0.3-0.5mm.

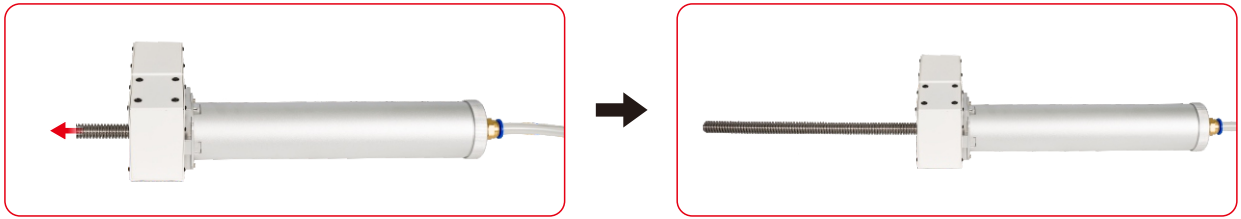
调节平台下方的四颗螺母，使喷嘴与平台的距离为0.3-0.5mm

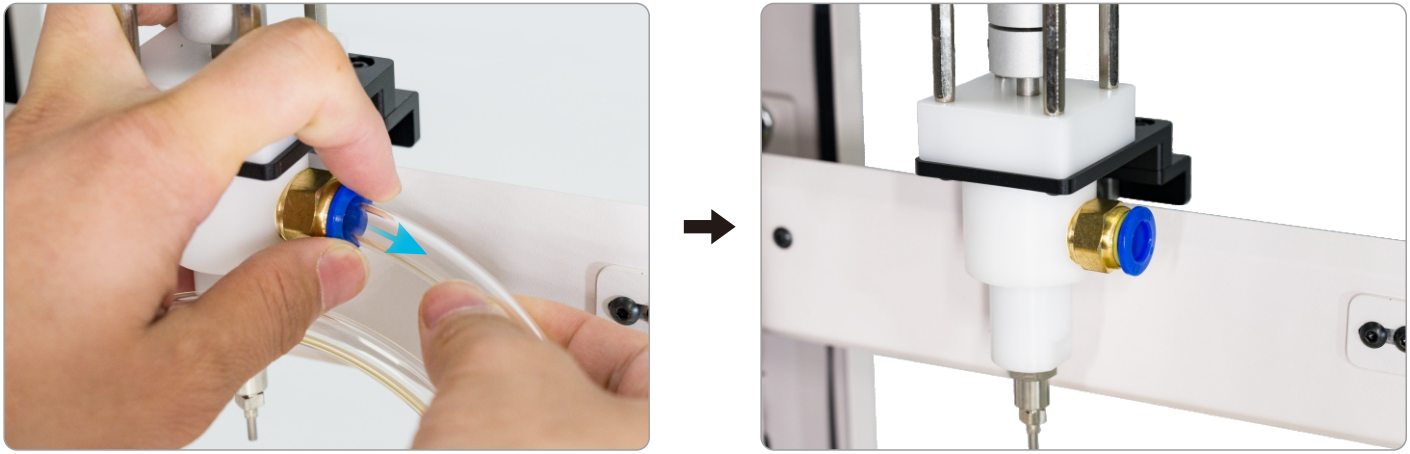
Precautions and operations for replacing the barrel

更换料筒的注意事项与操作

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作

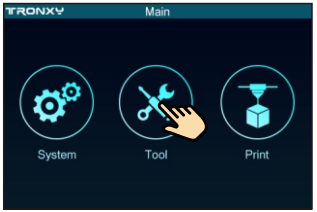
The piston must be moved to its original position before changing the barrel.
更换料筒前，必须将活塞移动到初始位置。



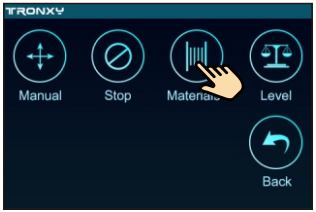


The feed tube of the print head must be unplugged before operation.
操作之前必须拔下打印头的进料管

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作

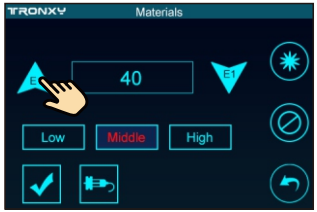


Select "Tool"
选择“Tool”



Select "Materials"
选择“Materials”

Click switch to
点击 切换到
(Speed range 0~40)
(速度范围0~40)



Click to retraction
点击 进行回抽

Three control methods of Materials
耗材的三种控制方式

Linkage mode (default)
Can control the feeding device and the motor of the print head at the same time.

联动模式(默认)
可以同时控制送料装置与打印头的电机。

Feeding device mode
Separately control the motor of the feeding device.

送料装置模式
单独控制送料装置的电机。

Print head mode
Separately control the motor of the print head.

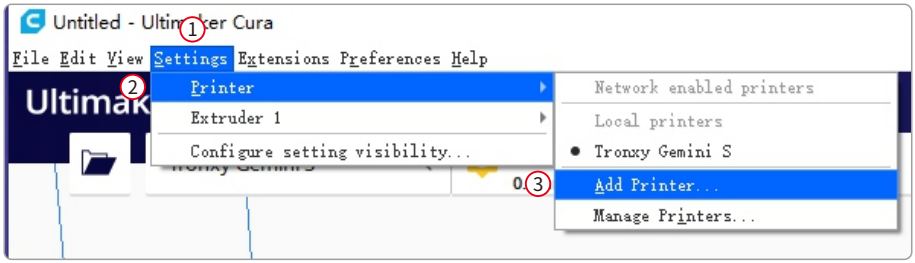
打印头模式
单独控制打印头的电机。

Slicing software settings

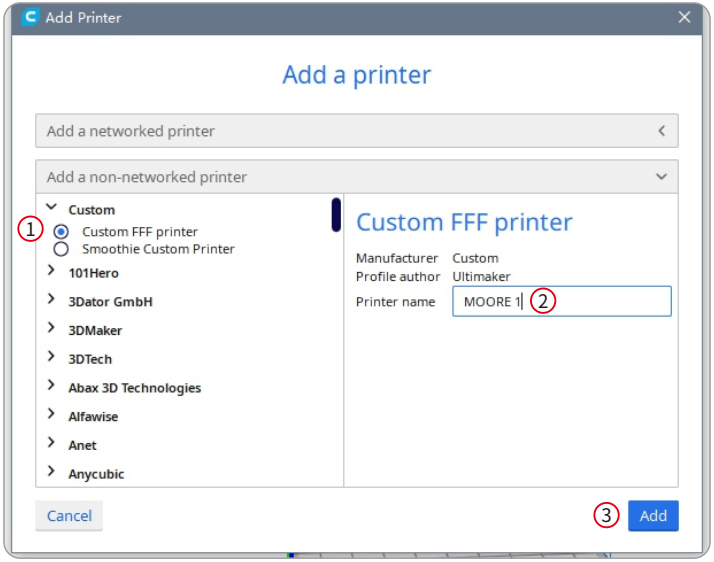
切片软件的设置

Slicing software settings 切片软件的设置

1. Model settings 机型设置

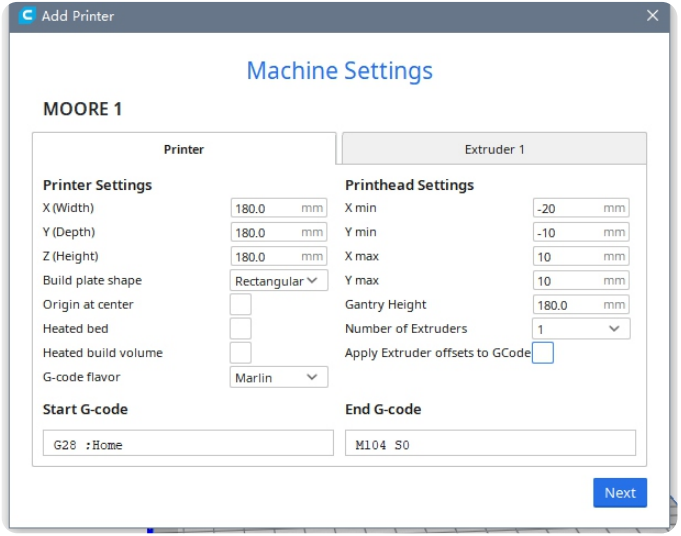


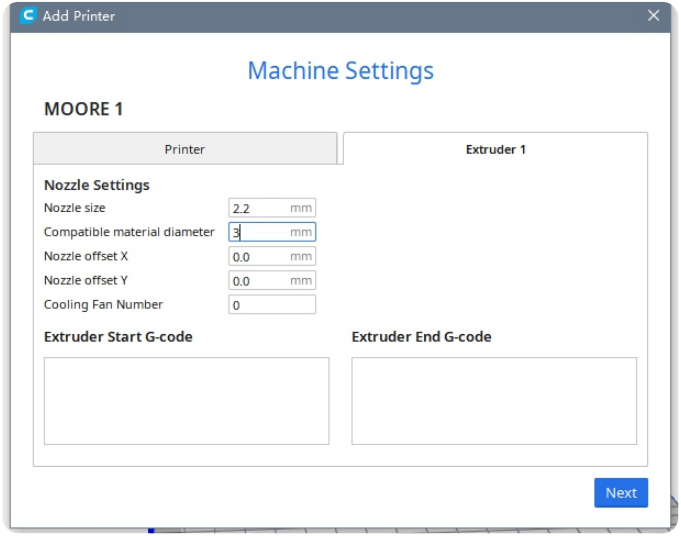
① Settings → ② Printer → ③ Add Printer...



① Custom FFF printer → ② Type "Moore 1" → ③ Add

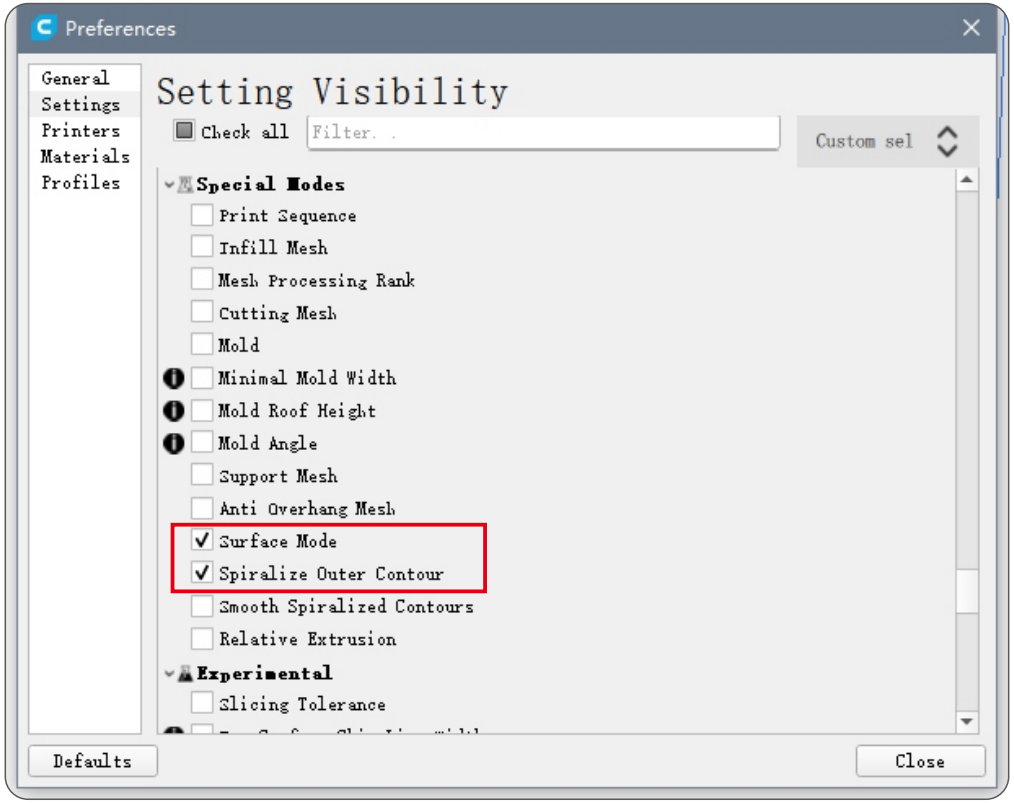
Slicing software settings 切片软件的设置





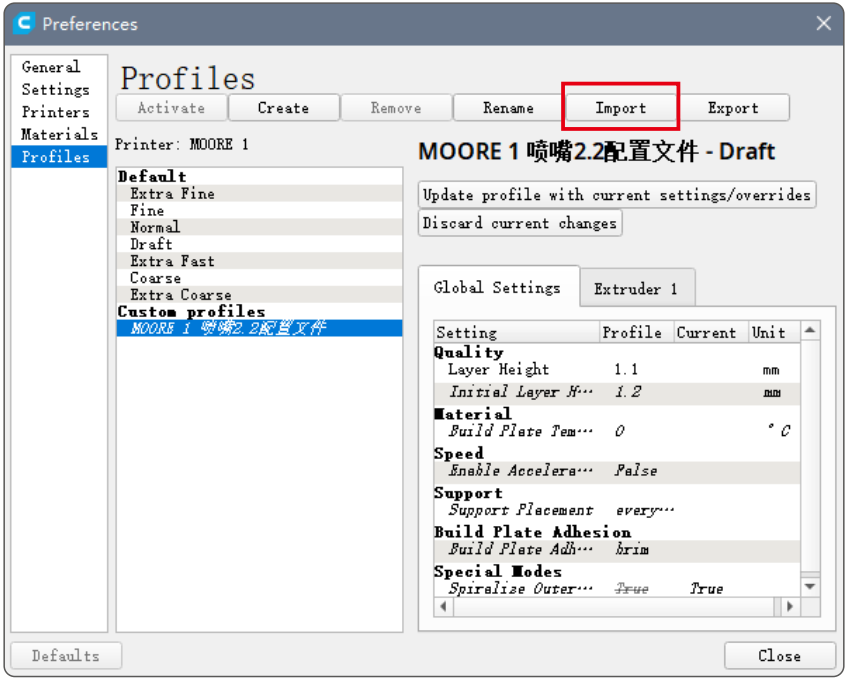
Set the value as shown in the figure

如图所示设置数值



Select the option in the red circle

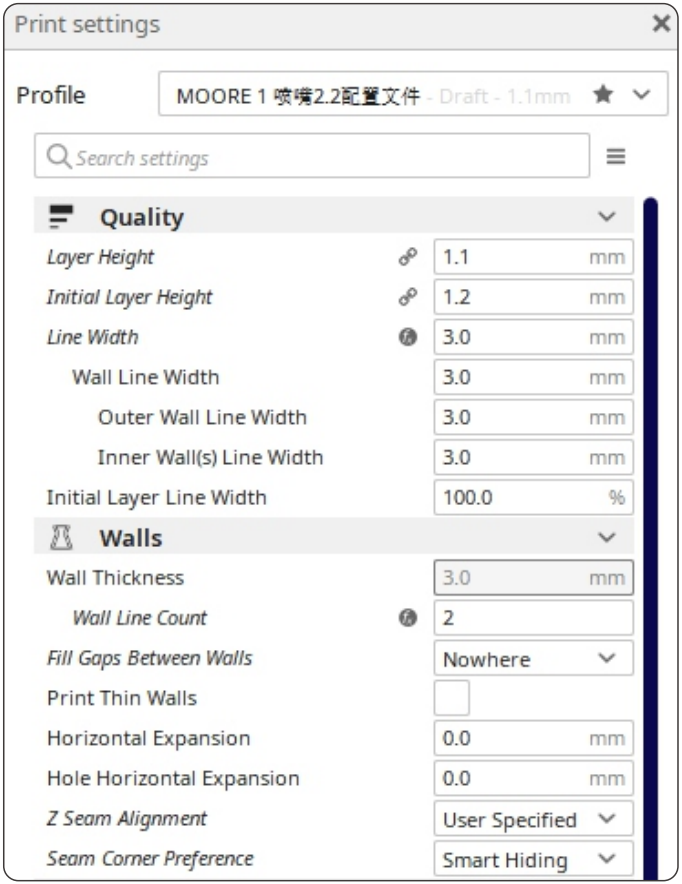
勾选红圈中的选项

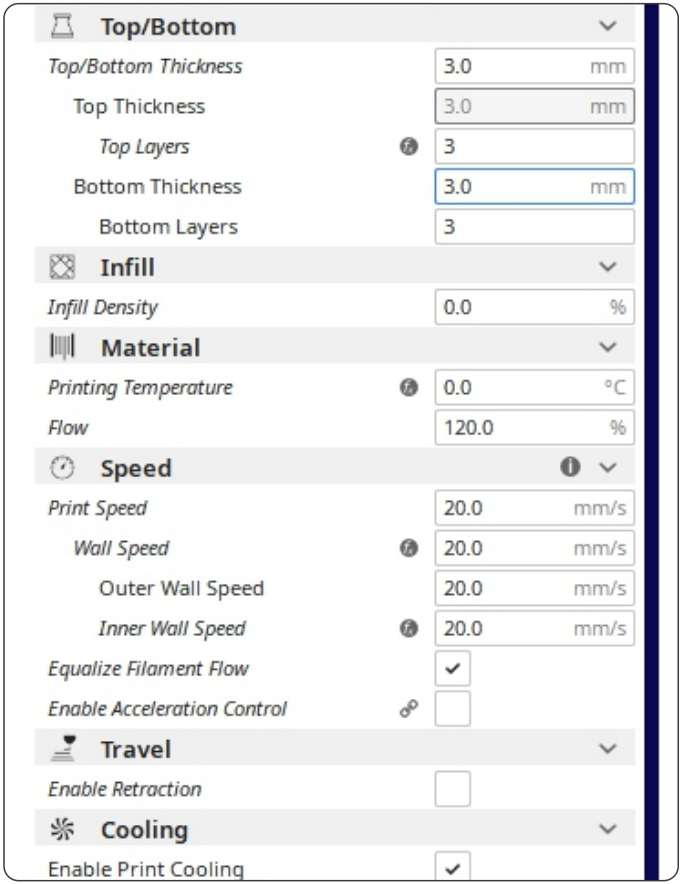


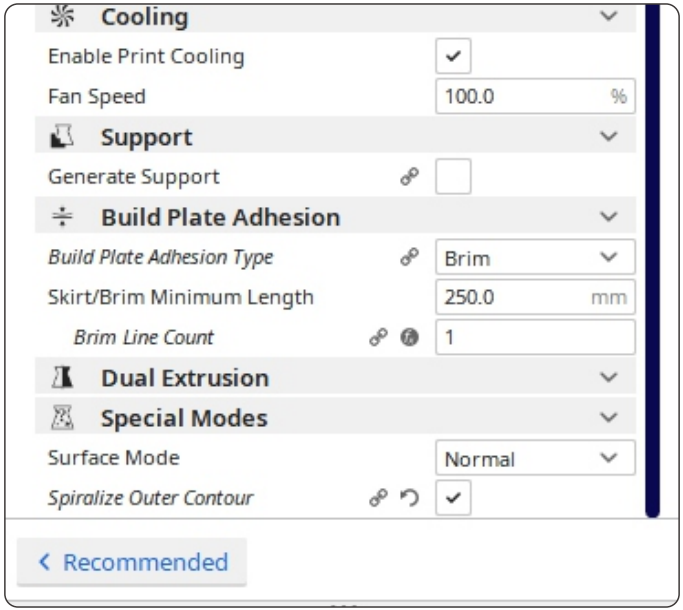
Import the configuration file from the TF card to start slicing

导入TF卡内的配置文件，即可开始切片

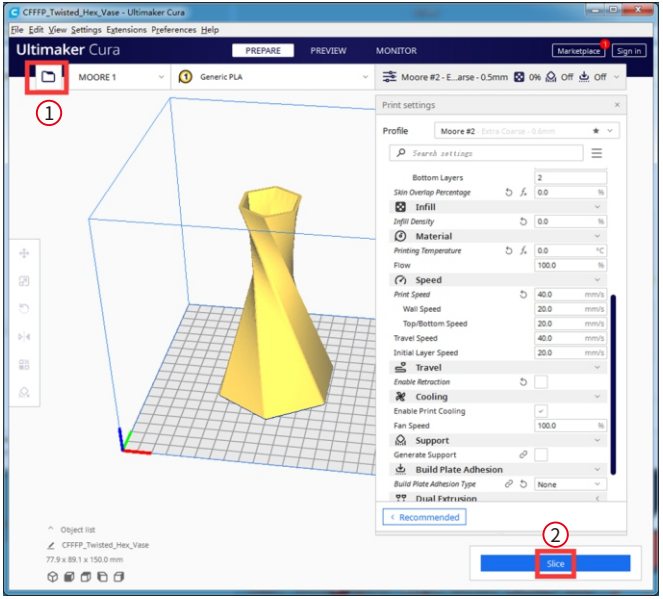
Slicing software settings 切片软件的设置



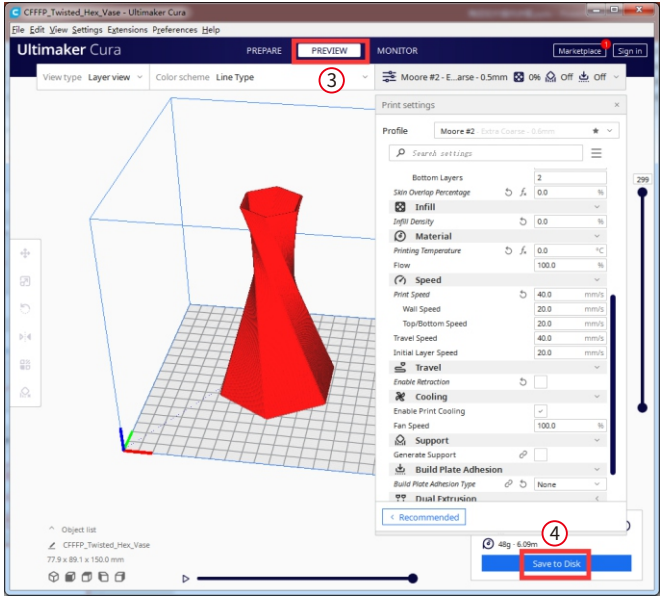



Cooling
Enable Print Cooling
Fan Speed
100.0
%
Support
Generate Support
Build Plate Adhesion
Build Plate Adhesion Type
Brim
Skirt/Brim Minimum Length
250.0
mm
Brim Line Count
1
Dual Extrusion
Special Modes
Surface Mode
Normal
Spiralize Outer Contour
Recommended

Slicing software settings 切片软件的设置



1 Open a file → 2 Slice



3 Preview → 4 Save to Disk

Cautions after printing 打印完成注意事项

Note: soak the printhead/nozzle in the water after printing to prevent the mud from drying and clogging the printhead

注意:打印完将喷嘴浸泡在水中以防泥料干掉

TRONXY

Intelligent print for you

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