

TRONXY

Moore X4060

Clay 3D printer User Manual

陶泥3D打印机使用说明书





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. 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 on the USB flash drive. Please check.

视频,软件等相关信息存储在U盘中,请查看。

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Parameter 设备参数

Print parameters

Printing principle :	LDM (Liquid Deposition Molding)
打印原理	LDM (液体沉积成型)
Print volume :	400*400*600 (mm)
打印体积	
Printing accuracy :	0.3-3.0mm
打印精度	
Positioning accuracy :	X/Y: 0.00625mm, Z:0.00125mm
定位精度	
Number of printhead :	1
喷头数量	
Nozzle diameter :	1.0-3.0 mm (optional)
喷嘴直径	1.0-3.0 mm (可选)
Print speed :	10~200mm/s (20mm/s is recommended)
打印速度	10~200mm/s (建议20mm/s)
Moving speed :	300mm/s
移动速度	
Consumables :	Various clays such as pottery clay, porcelain clay, purple sand clay, etc
耗材	陶泥、瓷泥、紫砂泥等各种黏土

Temperature parameter

Ambient temperature :	8°C - 40°C
环境温度	

Software parameters

Slicing software :	Cura
切片软件	
Input format :	.STL .OBJ
输入格式	
Output format :	Gcode
输出格式	
Connection method :	USB
连接方式	USB

Power parameters

Power input :	100-240VAC 50/60HZ
电源输入	
Power output :	120W/24V
电源输出	

Physical parameters

Machine size :	642.5*642.5*1343(mm)
机器尺寸	
Machine weight :	≈90kg
机器重量	

Packing list 包装清单

1



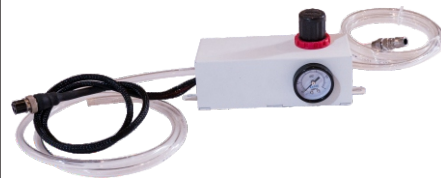
Machine body
机器主体

2



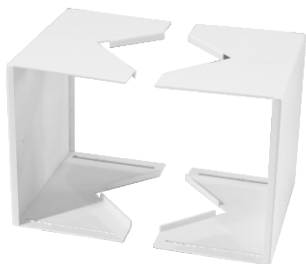
Material barrel
料筒

3



Air pressure controller
气压控制器

4



Material barrel fixing bracket
料筒固定架

5



Discharge pipe
出料管

6

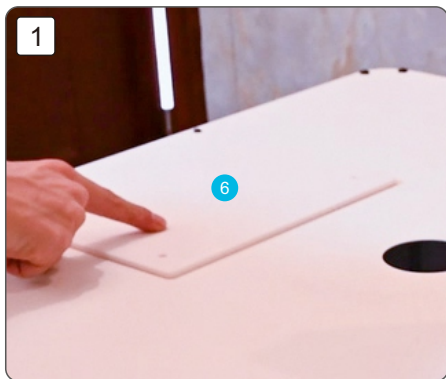


Material cylinder gasket
料筒垫片

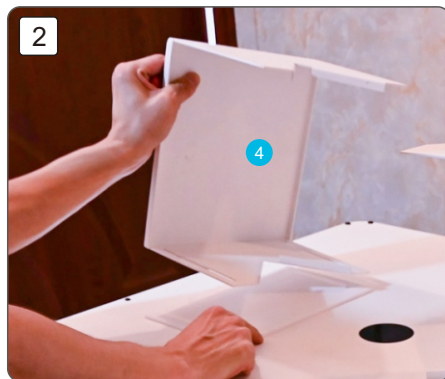
Machine installation and use

机器安装与使用

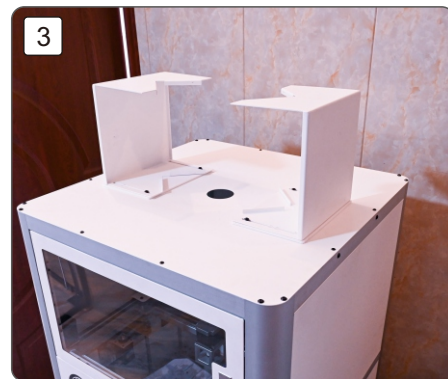
Machine installation and use 机器安装与使用



Align the pad with the screw holes on the top of the machine
将垫板对齐机器顶部的螺丝孔



Place the material cylinder fixing bracket on the base plate
将料筒固定架放置在垫板上



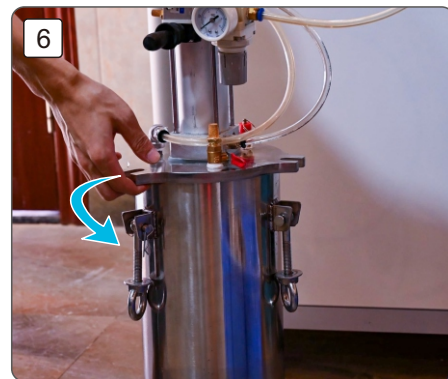
Use M5*20 screws to lock the material cylinder fixing bracket
使用M5*20螺丝, 锁紧料筒固定架



Take out the material barrel
拿出料筒



Loosen the screw
拧松螺丝



Put down the three screws
将三颗螺丝放下

Machine installation and use 机器安装与使用



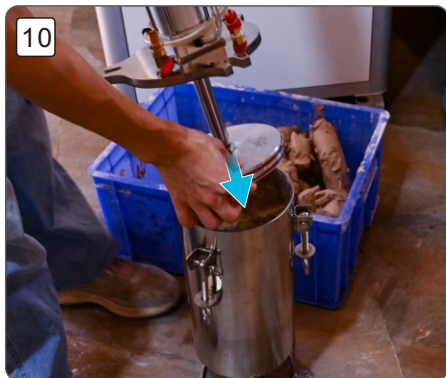
Extract piston
抽出活塞



Add clay
放入陶泥



Pressing clay
压紧陶泥



Insert piston
放入活塞

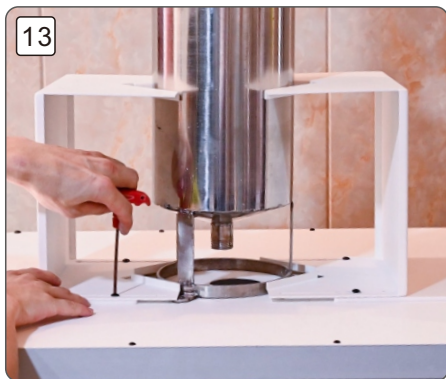


Align the position of the buckle
对齐卡扣的位置

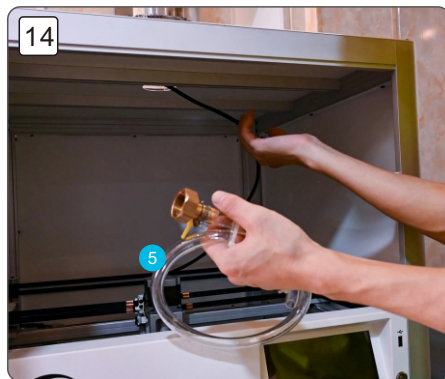


Use a tool to tighten the screws of the buckle
使用工具将卡扣的螺丝拧紧

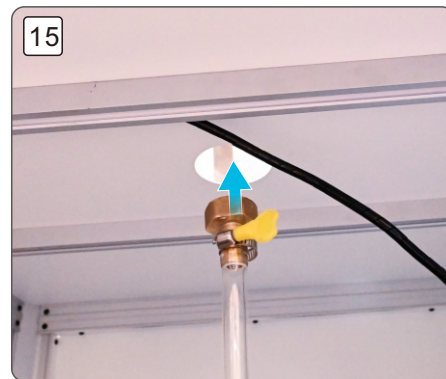
Machine installation and use 机器安装与使用



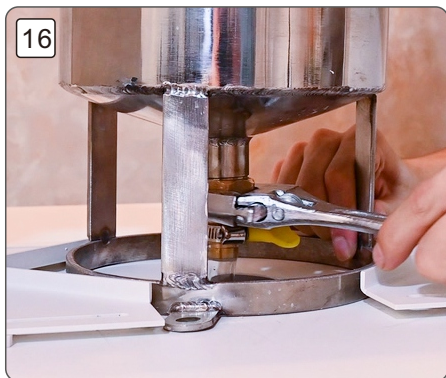
Place the material cylinder on the top of the machine and lock it with a fixed frame
将料筒放置在机器顶部,使用固定架锁紧



Take out the guide tube
拿出导料管



Thread upwards from the inside of the machine
从机器内部向上穿出



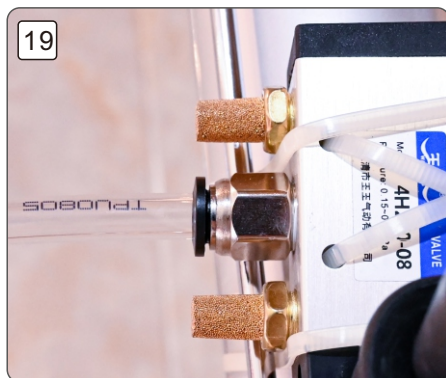
Connect the guide pipe to the discharge port of the material barrel and tighten it with a wrench
导料管连接料筒出料口,使用扳手拧紧



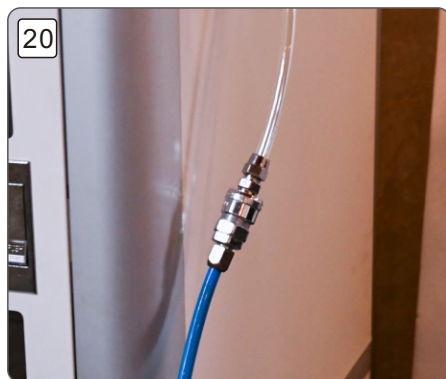
Take out the air pressure controller
拿出气压控制器



Insert the connecting wire into the machine
连接线插入机器



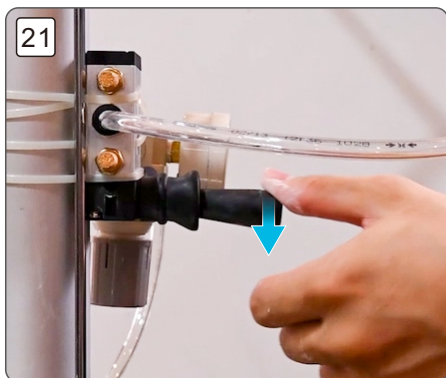
Air outlet connecting piston device
出气管连接活塞装置



Connect the intake pipe to the air compressor
进气管连接空压机



Machine installation and use 机器安装与使用



Pull down the loading and unloading valve switch
向下册装料退气阀开关



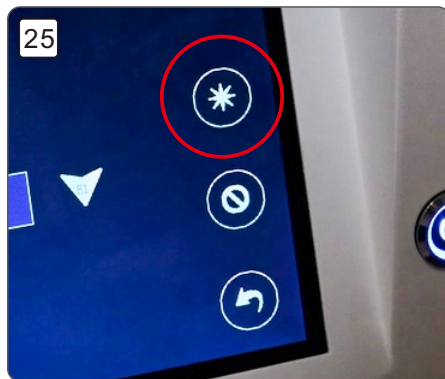
Adjust the air pressure to 0.2
调整气压至0.2



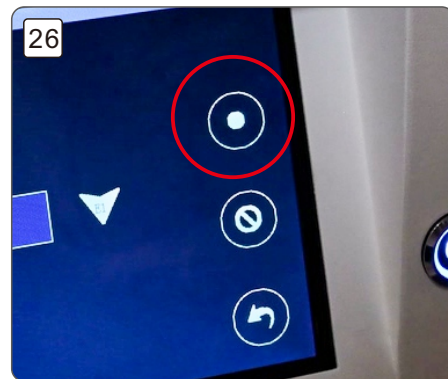
Turn on the machine and select 'Tools'
打开机器，选择“工具”



Select 'Material'
选择“材料”



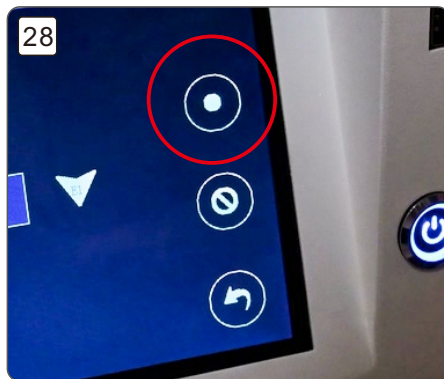
Click on the icon in the circle in the figure
点击图中圈中的图标



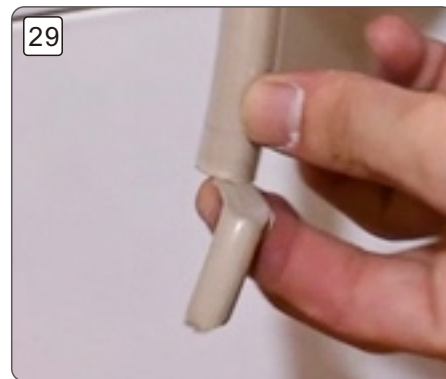
The icon becomes a dot, and the machine
begins to extrude the clay
图标变成圆点，机器开始挤出陶泥



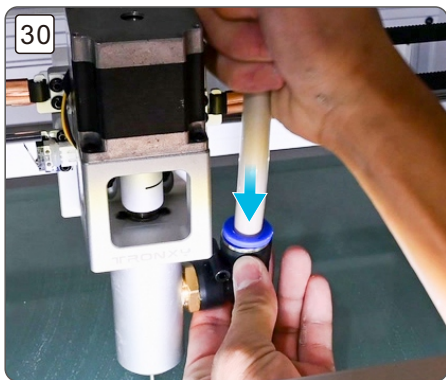
Waiting for the clay to extrude the material pipe
等待陶泥挤出料管



Click on the icon in the circle to stop extrusion
点击圈中的图标, 停止挤出



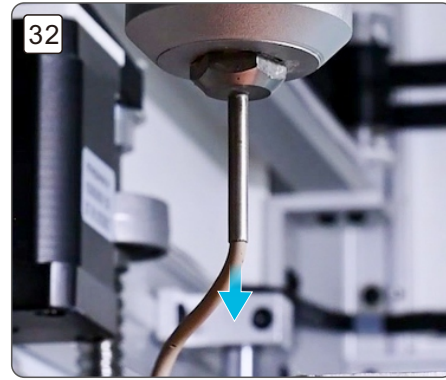
Wipe away the spilled clay
抹去溢出的陶泥



Insert the print head feed port
插入打印头进料口



First click on icon 1, then click on icon 2 to extrude the clay
先点击图标1, 再点击图标2, 挤出陶泥



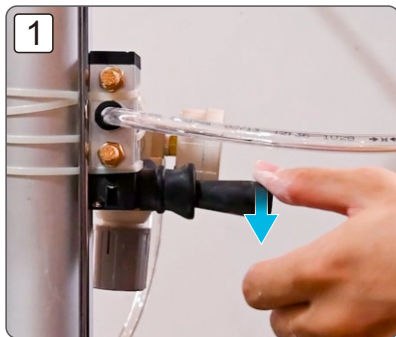
The clay is extruded from the printing head nozzle to start printing
陶泥从打印头喷嘴挤出, 即可开始打印



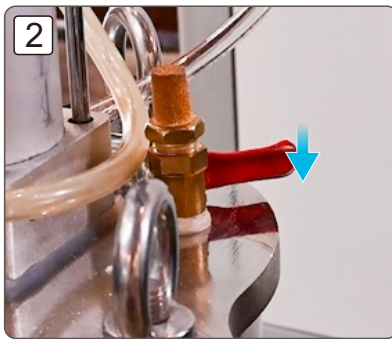
Operating Steps for Extrusion and Extraction of Pottery Mud

陶泥挤出和回抽的操作步骤

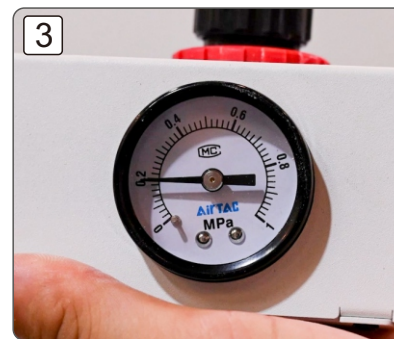
1. Extrusion 挤出



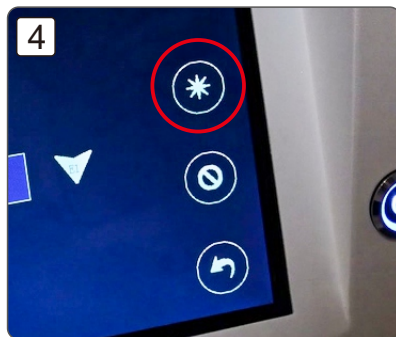
Pull down the loading and unloading valve switch
向下掰装料退气阀开关



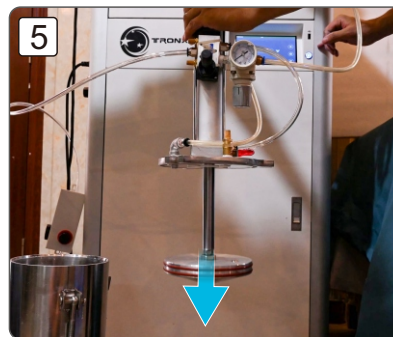
Pull down the material discharge switch
向下掰装料放气开关



Adjust the air pressure to 0.2
调整气压至0.2



Click on the icon
点击图标



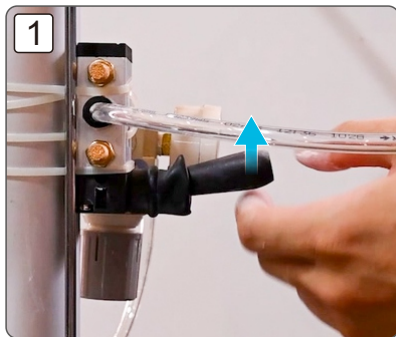
The piston extends and squeezes out the clay
活塞伸出, 挤出陶泥



Operating Steps for Extrusion and Extraction of Pottery Mud

陶泥挤出和回抽的操作步骤

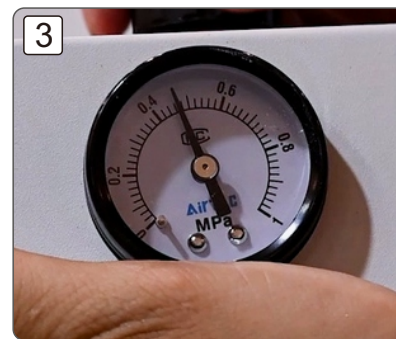
2. Pullback 回抽



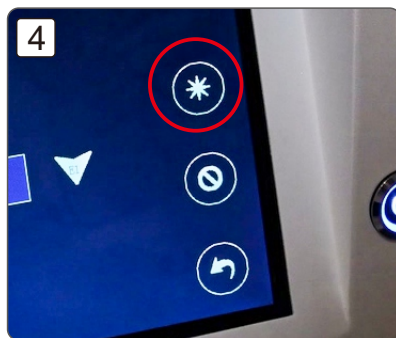
Pull up the loading and unloading switch
向下装卸退气阀开关



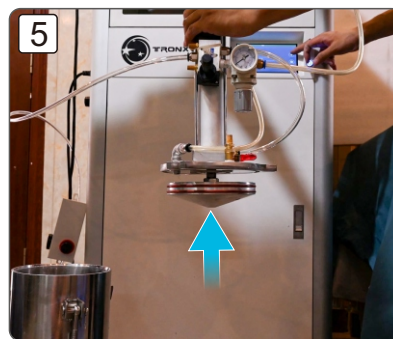
Pull up the material discharge switch
向下装卸放气开关



Adjust the air pressure to around 0.5
调整气压至0.5左右



Click on the icon
点击图标



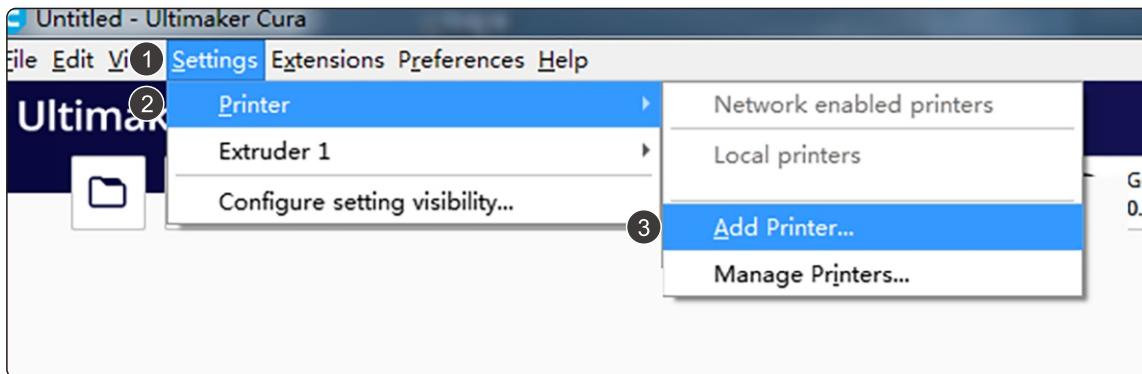
Piston retraction
活塞回抽

Slice Software Installation Steps

切片软件安装设置

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；

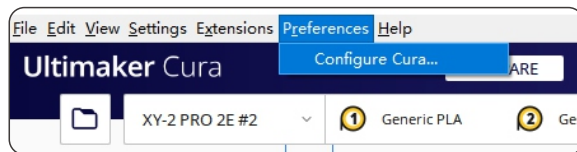


① Settings → ② Printer → ③ Add Printer...
设置 → 打印机 → 新增打印机

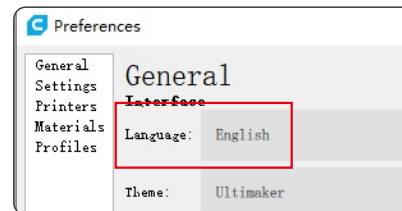


How to change the language of slicing software

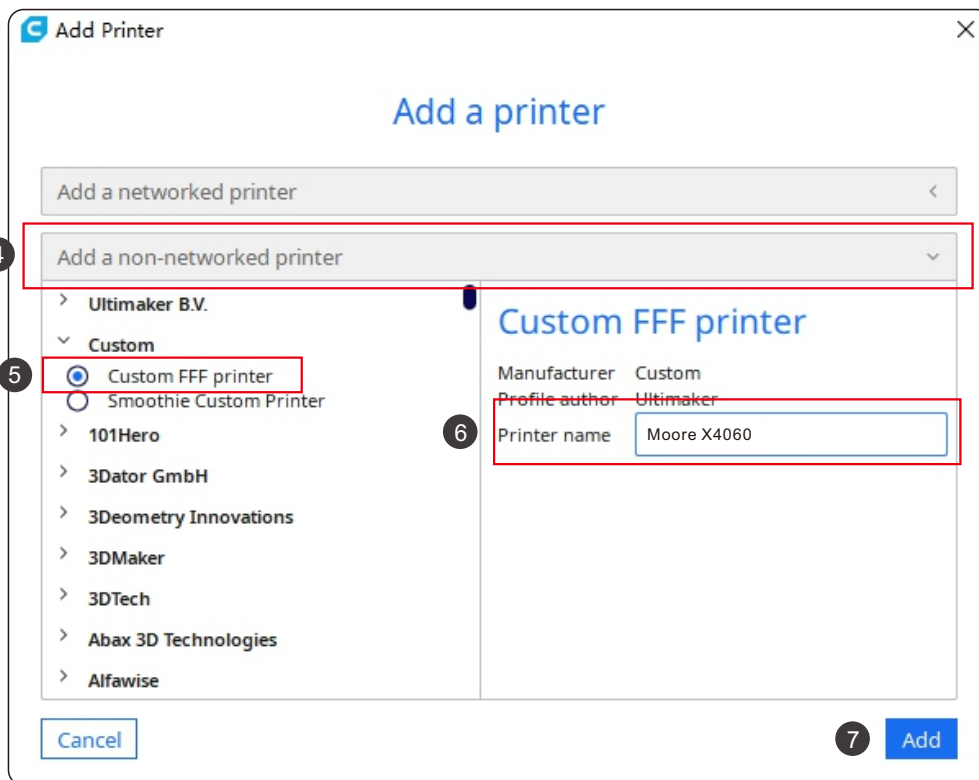
切片软件如何更换语言



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 "Moore X4060"
点击“添加未联网打印机” 选择“Custom FFFprinter” 输入“Moore X4060”
- ⑦ Add
点击“添加”

Slicing software settings 切片软件 的设置

Add Printer

Machine Settings

Moore X4060

Printer

Printer Settings

X (Width)

400.0

mm

Y (Depth)

400.0

mm

Z (Height)

600.0

mm

Build plate shape

Rectangular

Origin at center☐

Heated bed☐

Heated build volume☐

G-code flavor

Marlin

Start G-code

G28 ;Home

Extruder 1

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

1

Apply Extruder offsets to GCode☒

End G-code

M104 S0

Next

Add Printer

Machine Settings

Moore X4060

Printer

Nozzle Settings

Nozzle size

3.0

mm

Compatible material diameter

3.0

mm

Nozzle offset X

0.0

mm

Nozzle offset Y

0.0

mm

Cooling Fan Number

0

Extruder Start G-code

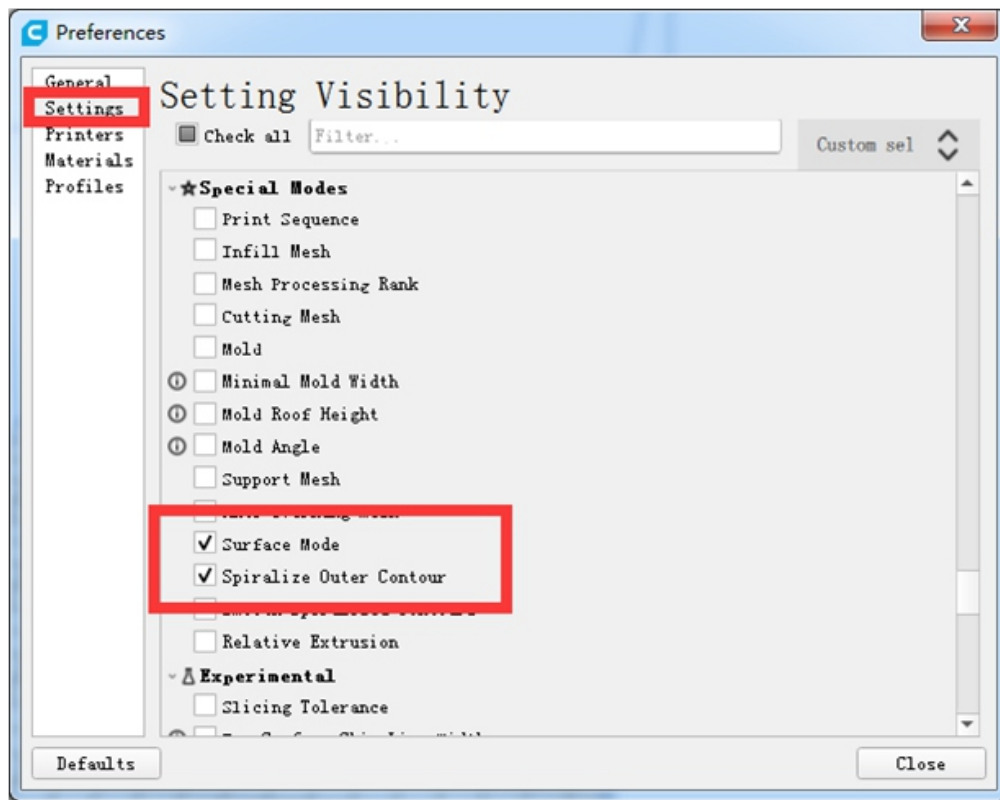
Extruder End G-code

Extruder 1

Next

Set the value as shown in the figure
如图所示设置数值

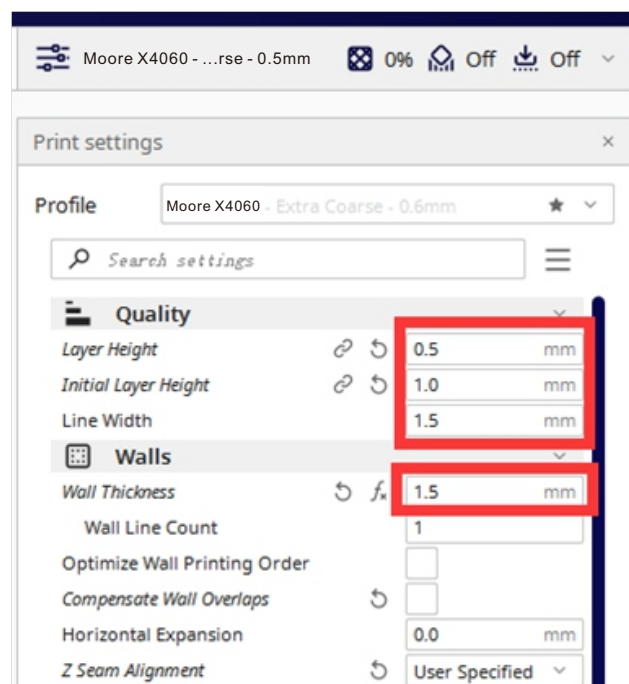
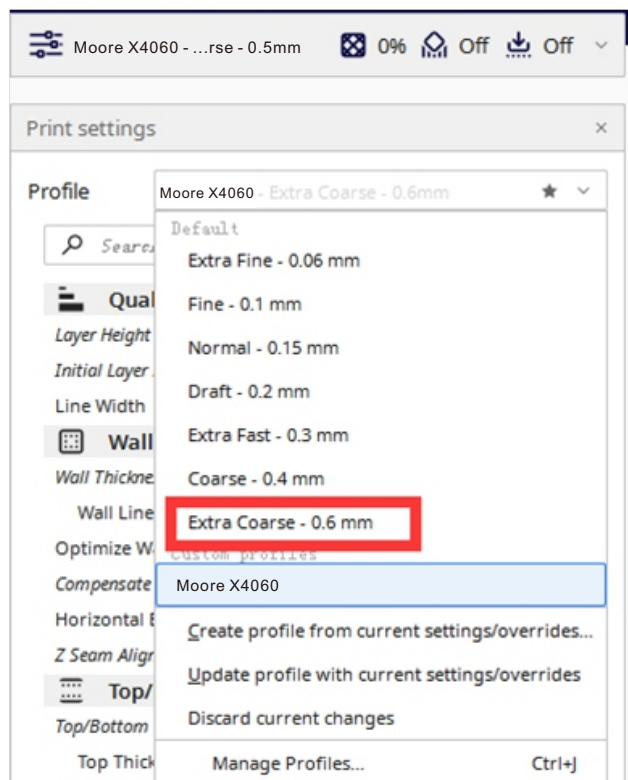
15



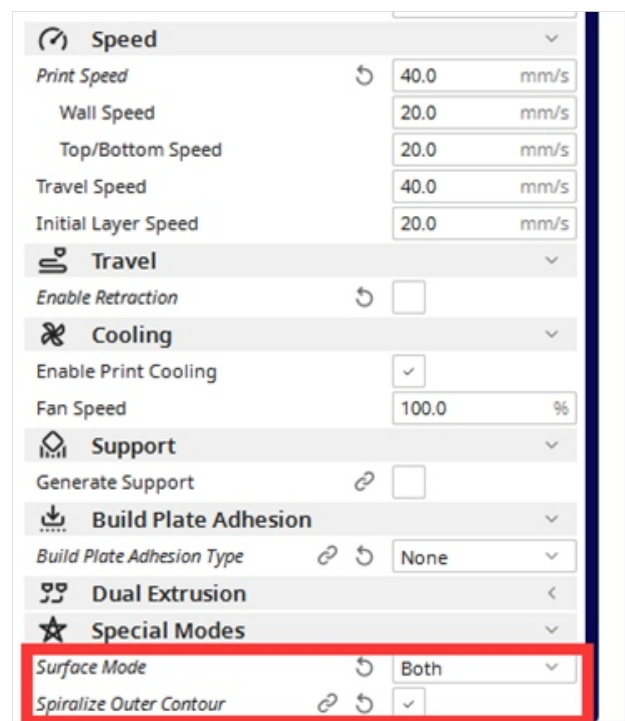
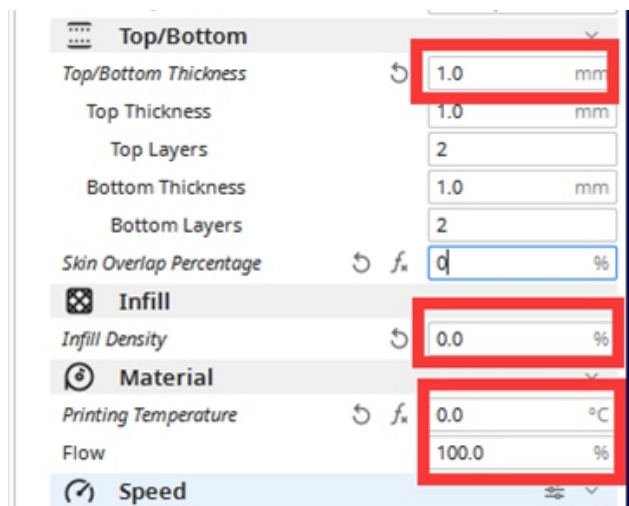
Select the option in the red circle

勾选红圈中的选项

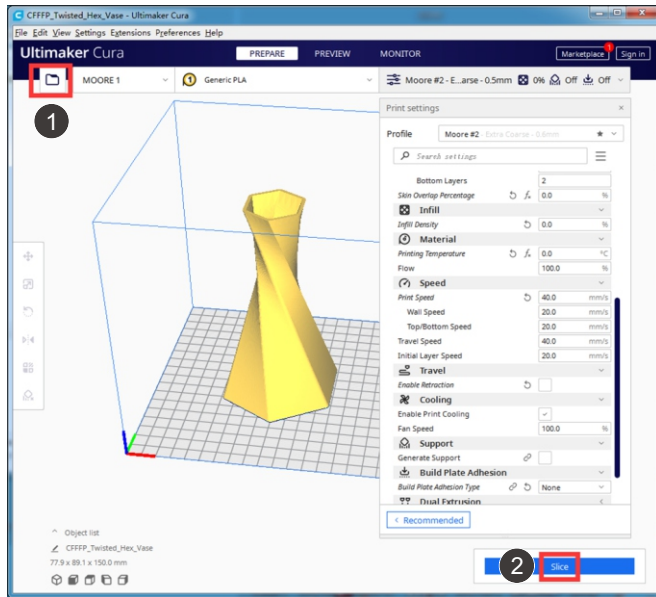
2. parameter settings 参数设置



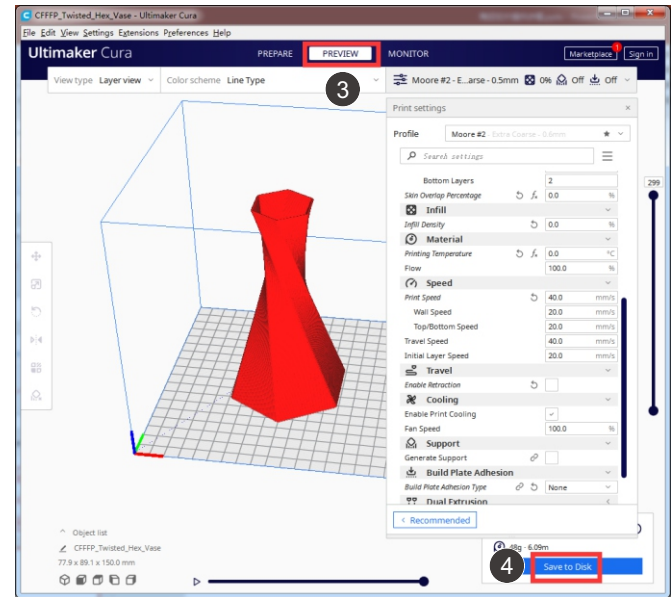
Slicing software settings 切片软件 的设置



Slicing software settings 切片软件 的设置



① Open a file → ② Slice
打开一个文件 切片



③ Preview → ④ Save to Disk
预览 保存到磁盘

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

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因每款机型不同, 实物与图可能有所差异, 请以实物为准, 最终解释权归深圳市创星元科技有限公司所有。



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