Moore X2540

Clay 3D printer User Manual 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。



Warning: The machine must use single-phase AC 110V/220V and the machine must be grounded.

Note: High voltage part is inside the machine, please under guidance of

注意:机器内部有高电压部分,当需要打开机器进行检修时请在专业人士的指导下

警告:本机必须使用单相110V/220V交流电,机器必须进行接地线。

professionals while opening machine for troubleshooting.



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。



进行。

Do not touch the heating element during heating process 机器在加热过程中请勿触摸加热部件



Use and maintein the machine following the manual. 根据说明手册对机器定期进行使用和保养.



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。



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。



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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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	255*255*400(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	10~200mm/s (20mm/s is recommended) 10~150mm/s (建议20mm/s)
Moving speed: 移动速度	300mm/s
Consumables: 耗材	Various clays such as pottery clay, porcelain clay, purple sand clay, etc 胸泥、瓷泥、紫砂泥等各种黏土

Temperature parameter

温度参数

Ambient	temperatu	re:
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环境温度

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	Gcode
Connection method : 连接方式	USB USB

Power parameters

由源参数

Powerinput:	
电源输入	115-230V 50/60HZ
Power output :	
电源输出	100W

Physical parameters 物理参数

8°C - 40°C

Machine size :

机器尺寸

497.5*497.5*805(mm)

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Packing list 包装清单





取下料筒

As shown in the figure 如图所示

Insert power and turn on the switch 插入电源,打开开关



Insert the connection line of the pushing device 插入推料装置连接线



Turn on the switch 打开开关



Click on "Tools" 点击"工具"





Set to 40 设置成40



> 1、点击"Hight"切换成高速模式 2、点击两次 ,退出材料



The piston retreats to the bottom, click on the " 🙆 " to stop 活塞退到最底部,点击" 🕥 "停止



Put the clay into the material barrel and compact it 将陶泥放入料筒中,并压实



Install the material barrel back into the pushing device 将料筒安装回推料装置



Hang the pushing device onto the machine 将推料装置挂到机器上



Connect the material tube to the material barrel 将料管连接料筒



Connect the extrusion head on the other side of the material tube, complete installation 料管另一边连接挤出头,完成安装

Slice Software Installation Steps 切片软件安装设置

- 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;





	Machine	Settings				Machine	e Settings
loore X2540					Moore X2540		
Printer	r	Extru	der 1		Printer		Extruder 1
rinter Settings		Printhead Settings			Nozzle Settings		
(Width)	255.0 mm	X min	-20	mm	Nozzle size	3.0 mm	
(Depth)	255.0 mm	Ymin	-10	mm	Compatible material diameter	3.0 mm	
(Height)	400.0 mm	X max	10	mm	Nozzle offset X	0.0 mm	
uild plate shape	Rectangular ~	Y max	10	mm	Nozzle offset Y	0.0 mm	
rigin at center		Gantry Height	260.0	mm	Cooling Fan Number	0	
eated bed		Number of Extruders	1	~	Extruder Start G-code		Extruder End G-code
eated build volume		Apply Extruder offsets to G	GCode 🗸				
-code flavor	Marlin ~						
tart G-code		End G-code					
G28 :Home		M104 S0					

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

2. parameter settings 参数设置

Moore X2	540 rse - 0.5mm 🔯 0% 🏠 Off 🛃 Off 🗸
Print setting	: x
r mit settings	
Profile	Moore X2540 Extra Coarse - 0.6mm 🔹 🗸
P Searc	Default Extra Fine - 0.06 mm
La Qua	Fine - 0.1 mm
Layer Height	Normal - 0.15 mm
Line Width	Draft - 0.2 mm
🔛 Wall	Extra Fast - 0.3 mm
Wall Thickne	Coarse - 0.4 mm
Wall Line	Extra Coarse - 0.6 mm
Optimize W	Custom profiles
Compensate	Moore X2540
Horizontal	<u>Create profile from current settings/overrides</u>
Z Seam Alig	Undete exefite with surrent estimations (even idea
Тор/	Update profile with current settings/overrides
Top/Bottom	Discard current changes
Top Thick	Manage Profiles Ctrl+J

Moore X2540rse - 0.5mn	n 🔀	0% 🏠 Of	ff 📥 Off 🗸
Print settings			×
Profile Moore X2540 - Ext	ra Coarse	- 0.6mm	* ~
₽ Search settings			\equiv
Quality		_	~
Layer Height	0 5	0.5	mm
Initial Layer Height	0 5) 1.0	mm
Line Width		1.5	mm
🔛 Walls			~
Wall Thickness	5 f	1.5	mm
Wall Line Count		1	
Optimize Wall Printing Orde	r		
Compensate Wall Overlaps	5		
Horizontal Expansion		0.0	mm
Z Seam Alignment	ť	User Spe	cified ~



(?) Speed			~
Print Speed	5	40.0	mm/s
Wall Speed		20.0	mm/s
Top/Bottom Speed		20.0	mm/s
Travel Speed		40.0	mm/s
Initial Layer Speed		20.0	mm/s
S Travel			~
Enable Retraction	5		
X Cooling			~
Enable Print Cooling		~	
Fan Speed		100.0	96
Support			~
Generate Support	Õ		
Build Plate Adhesion			~
Build Plate Adhesion Type	25	None	~
Dual Extrusion			<
🛠 Special Modes			~
Surface Mode	5	Both	~
Spiralize Outer Contour	25	~	





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

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Due to the differences between different machine models, the physical objects and the final images can differ. The final explanation rights shall be reserved by Shenzhen Tronxy Technology Co., Ltd. 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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