



Xplorer 3D[®] PRO[™]
Desktop 3D Printer

**QUICK START
GUIDE FOR USING
XPLORES 3D PRO**

WELCOME XPLOREERS!

This is the Quick Start Guide for using your XPLOREER 3D PRO

You can find updated versions of this guide on our website, at WWW.XPLOREER3D.COM, where you can get in touch with Customer Service if you have any questions.

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The current state of 3D desktop Art technology

Even though the only real limit is your own creativity, current 3D printing technology also has its limits. You can find out what they are by reading our 3D Modeling Directives document

(<https://www.xplorer3d.com/blogs>)

The most relevant aspect to guarantee print quality is calibrating Xplorer 3D PRO.

Proper calibration is essential to performance and to ensure the desired results.

Poor calibration may keep you from printing the object you wish to make.

High resolution printing requires an even more demanding calibration. For this reason, we advise you to print in medium resolution until you're a more experienced user.

Low resolution printing is also recommended whenever object resolution isn't the main concern, since this is quicker, more economical and more ecological



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1. SAFETY INFORMATON

1. SAFETY INFORMATION

Even though the XPLOER 3D PRO printer was designed to be as safe a piece of equipment as possible, we wish to remind you it was conceived for use by adults. Still, there are safety concerns you must keep in mind:

1 - Adult supervision: because we can never stress this enough, XPLOER 3D PRO was developed to be used by adults. Should you wish that your children also use it, you must supervise them at all times while they do so. You must also take great care with small printed objects, because children might try to swallow them, which poses a danger of them choking.

2 - Extruder: whenever XPLOER 3D PRO is functioning, the extruder nozzle can reach temperatures as high as 250° C (480° F), which can cause serious burns if touched. For that reason, even though it's shielded and covered with a fan, you must always be careful not to touch the extruder.

3 - Moving parts: whenever it's functioning, XPLOER 3D PRO has moving parts. For that reason, you should always keep a safe distance from the printer while it's operating.

4 - Filament: XPLOER 3D PRO has been developed and tested to function with the specific filament sold on the XPLOER 3D website. Using filament from other sources may result in poor-quality printing and even damage the printer itself, voiding the warranty.

5 - Cool and well-ventilated environment: XPLOER 3D PRO works best in cool environments with some ventilation, which, just like any other electrical item, is also recommended to maintain an acceptable level of air quality around the printer.

6 - XPLOER 3D PRO integrity: never use XPLOER 3D PRO without it being fully assembled. Using it without all of its components voids the warranty and can be dangerous. For the same reasons, avoid spilling any liquid on the printer.

7 - Modifications to XPLOER 3D PRO: if you modify XPLOER 3D PRO in any way, this will immediately void the warranty. If you still wish to modify it, get in touch with us, explain your project and we might be able to provide you with useful information.



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2. TECHNICAL SPECIFICATIONS

1. TECHNICAL SPECIFICATIONS

Printing technology	FFF
Max. Printing volume	200mm X 200mm X 200mm [7.9" x 7.9" x 7.9"]
Layer resolution	High - 100 micron Low - 300 micron
Filament diameter	1.75mm
Volume	40cm X 40cm X 45cm
Approx. Weight	16.5KG [36.3lb]
Working ambient temperature	15° - 30° C
Storage temperature	0° - 30° C
Humidity	Low
AC Input	200 - 240 VAC 2.0A 50 - 60 Hz
Connectivity	USB & SD-CARD
Exterior	Power Coated Aluminum
Printing table	Glass
Software name	Xplorer Engine
File type	STL & GCODE
Minimum system requirements	Windows (7 / 8) Linux (12.04 +) Core 2 Duo AMD Phenom II AMD Athlon X2 RAM: 2GB Free disk space: 500 MB Graphics card (GPU): 512 MB dedicated Mac OS X (10.7/10.8+) Mac hardware: late-2008+

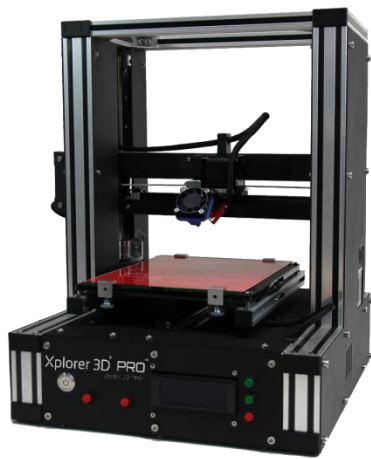


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3. UNPACKING AND INSTALLING XPLOER 3D PRO

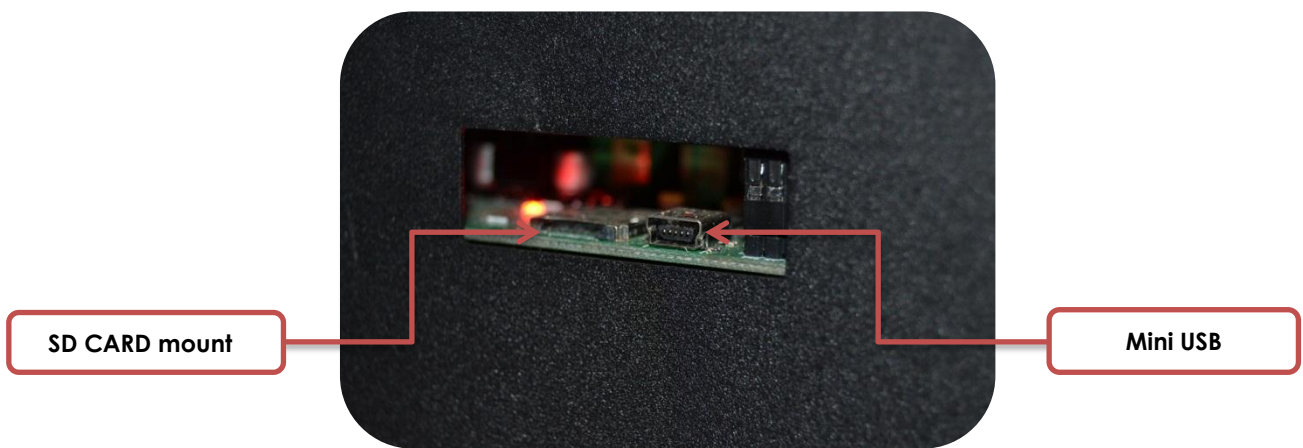
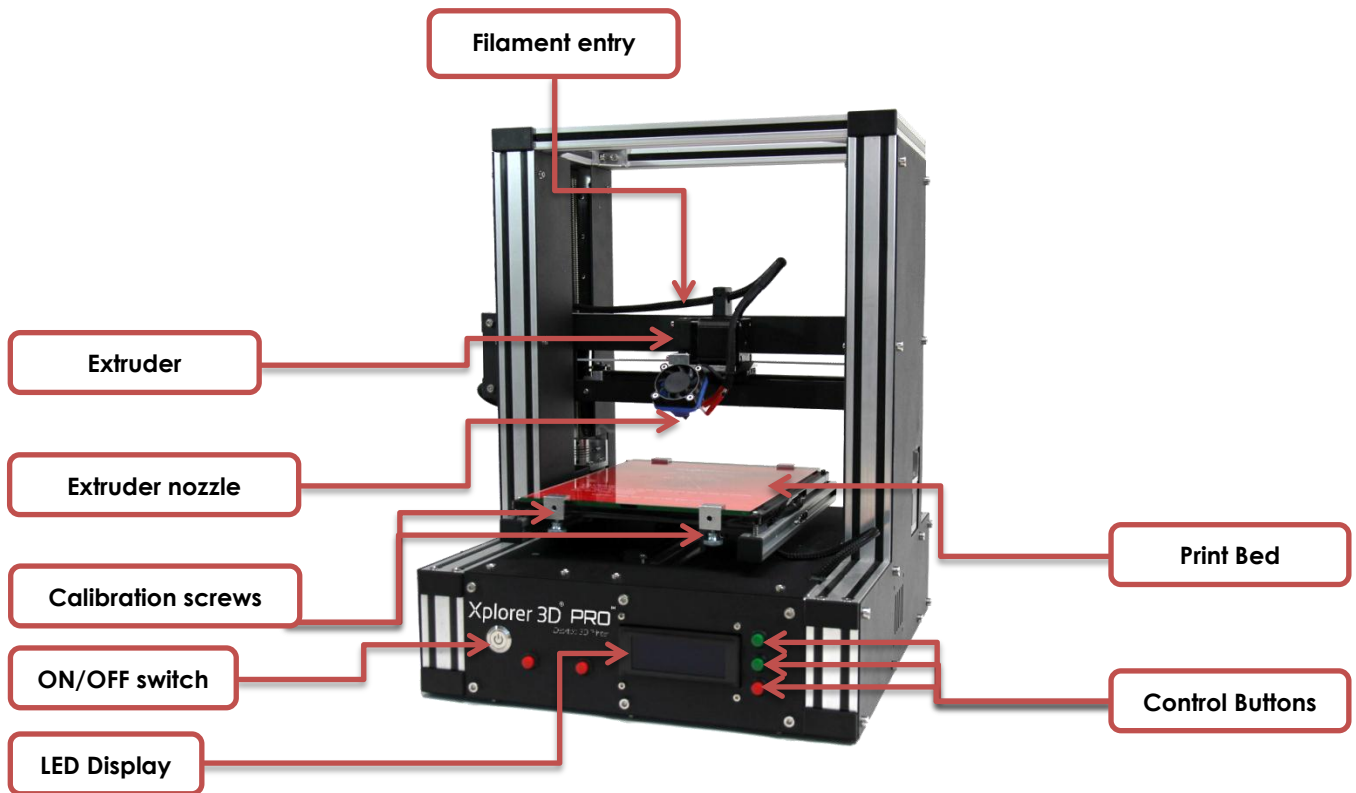


1. Open the box and remove the printer's protective material.
2. Remove the printer by holding the top frame
3. Carefully remove the protective packaging.



4. Check to make sure the box contains the following items:
 - 1 Xplorer 3D PRO
 - 1 Printing Bed's Glass
 - 1 Tweezers
 - 1 Allen key Set
 - 1 Roll of Adhesive tape
 - 1 Power cable
 - 1 USB connection cable
 - 1 Filament and respective mounting
 - 1 Precision screw driver set

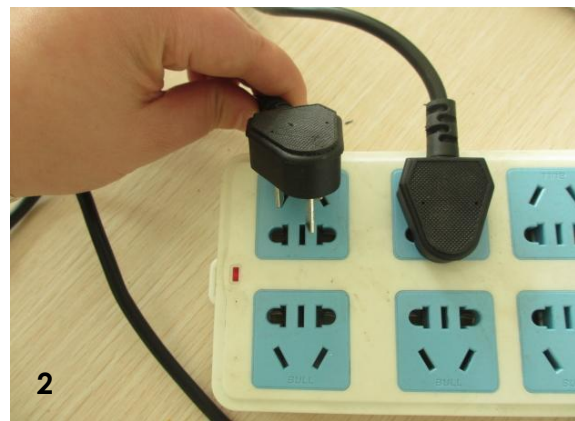
XPLORER 3D PRO DIAGRAM



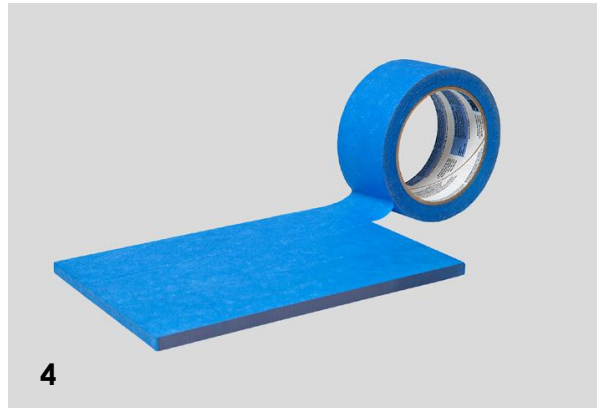
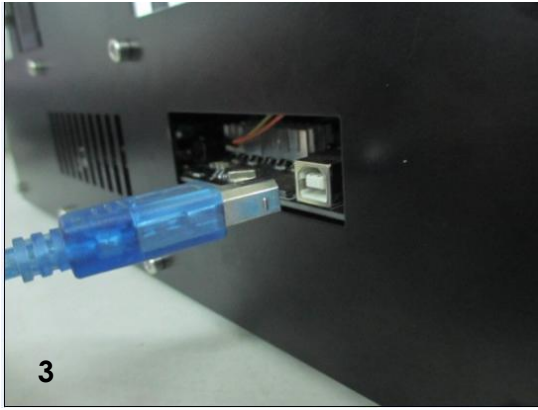
LEFT SIDE

INSTALLING XPLOER 3D PRO

1. Before you begin, make sure your computer has a working internet connection and that it's connected to the mains or has enough charge left in its battery.
2. Next, log on to www.Xplorer3D.com and download the most recent version of XPLOER ENGINE & XPLOER 3D DRIVERS for your particular operating system or find one in the SD-card given.
3. After XPLOER ENGINE & Driver has finished downloading, go to the download folder and run both the installation file one by one or install from SD-card.
4. Follow the installation instructions to the end, selecting the desired options.
5. Run XPLOER ENGINE as administrator by right clicking on the shortcut on your Desktop or Applications menu and selecting "Run as Administrator".
6. After installing XPLOER ENGINE, follow the steps in the bed leveling wizard to calibrate your XPLOER 3D PRO.



1. Make sure you've removed all the printer's packaging material and check to see if the main switch is in the "off" position.
2. Attach the power cable, connecting it first to the XPLOER 3D PRO printer, and next, to the socket.



3. Connect the USB cable to XPLOER 3D PRO and to the computer.
4. Place one, and only one, layer of Adhesive tape on the printer bed Glass, carefully to avoid any overlapping.
5. Place the spool inside the spool mount. Take care to keep the filament wound tight, because any looseness might cause kinks or knots to appear in the filament, which makes printing impossible.
6. Place assembled items (spool + mounting) over the top of XPLOER 3D PRO. (Optional)
7. Click the main switch to the “on” position.

HOW TO PRINT

1. Make sure you have disabled your computer's hibernation or suspend to disk function. If the computer goes into hibernation or suspend to disk state while something is being printed, you will be unable to resume this task and you will have to start again.
2. Make sure the adhesive tape is in an acceptable state. If it's damaged, it should be replaced as described in point 4 of 'Installing XPLOER 3D PRO'.
3. Check to see if no kind of object or filament debris is on the printer table.
4. Import the 3D model you wish to print. You can find a range of 3D models in the SD-CARD, online or you can create your own 3D model by using modeling software (not included).
5. Make sure you've followed the steps laid out in XPLOER ENGINE's printer calibration/bed leveling wizard.
6. Click on the "Load" button in XPLOER ENGINE and select the file you imported.
7. Click on the "Print" button and select the desired printing options.
8. XPLOER ENGINE will prepare the selected file for printing (a process called "slicing"), which may take a few minutes. Once it's ready, the printing process will begin.

AFTER PRINTING



After your print is over, you have to remove the object from the table. Try to do it first gently by hand without damaging it. If you are not able to do it, use something like spatula parallel to the table. If none of these techniques work, remove the tape. Don't forget to replace the tape before printing again.

TROUBLESHOOTING

We recommend you read our FAQ and Troubleshooting pages available on the website www.Xplorer3D.com. If you can't find the solution to a given problem, please contact Customer Support by using the form available on the aforementioned website.



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