



Model name : X6-2E

Instructions

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TRONXY SHENZHEN TRONXY TECHNOLOG CO.,LTD

Precautions for use

Before using this machine, please carefully read this manual and the following notes.

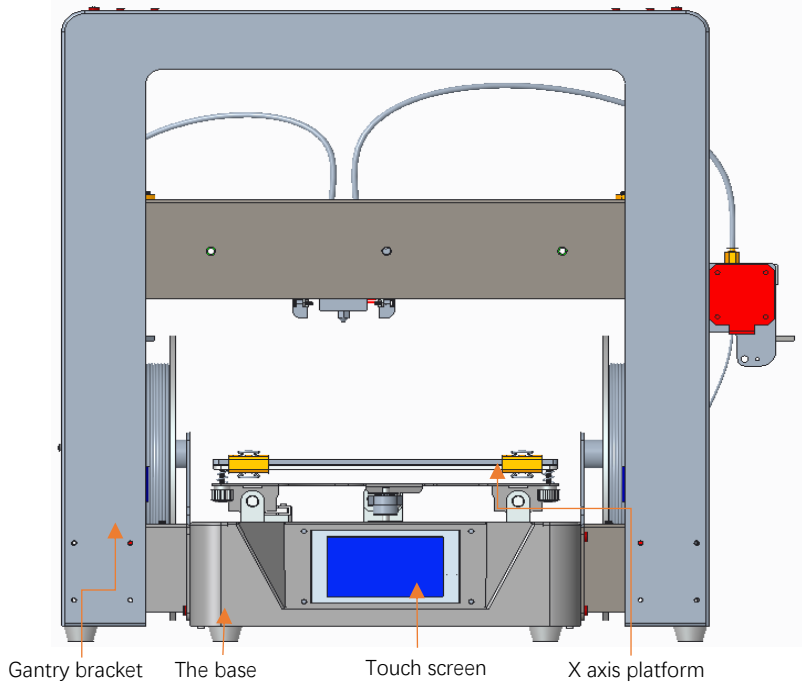
1. Keep children away from the machine when using the machine. Children are forbidden to touch the machine in use.
2. Please put the machine on a stable surface before using the machine.
3. Please keep this manual for future reference.
4. The open hole of the housing is strictly prohibited to cover, which is used for ventilation and heat dissipation of the machine to avoid overheating.
5. Please pay attention to the notice and warning posted on the machine to avoid danger or injury.
6. It is strictly forbidden to use the machine in the environment of inflammable and explosive substances.
7. It is strictly forbidden to pour any liquid or dust into the machine, or it will damage the machine or even cause a dangerous accident.
8. Please do not disassemble or repair the machine without permission. In addition to normal quick assembly steps and common problems, please ask a professional to help.
9. Do not use the machine under high temperature (above 85 ° C) environment, otherwise may damage to the machine.
10. When unattended, it is recommended not to run the printer.
11. For use of the machine, the following is not covered by warranty:
 - a. Due to abnormal external forces (such as fall, extrusion, knock against, impact) caused by the damage of products;
 - b. Product damage caused by violation of product operation manual;
 - c. Product damage caused by using materials that are not compatible with or have not been recognized by relevant national standards;
 - d. Beyond use under the conditions of use (such as the mainboard working environment for 5 to 40 ° C, customers in the above 40 ° C or below 5 ° C when used under the condition of damage).
 - e. Damage caused by privately modifying firmware and appearance structure.
 - f. Damage caused by improper storage (such as dampness, mildew, etc.).
 - g. Damage caused by irresistible external factors.
 - h. Normal consumption of parts, such as printing platform, nozzle and other accessories.
 - i. Damage by Pure artificial condition
 - j. Cannot provide Valid documents or Beyond the warranty period.

1. Product parameters

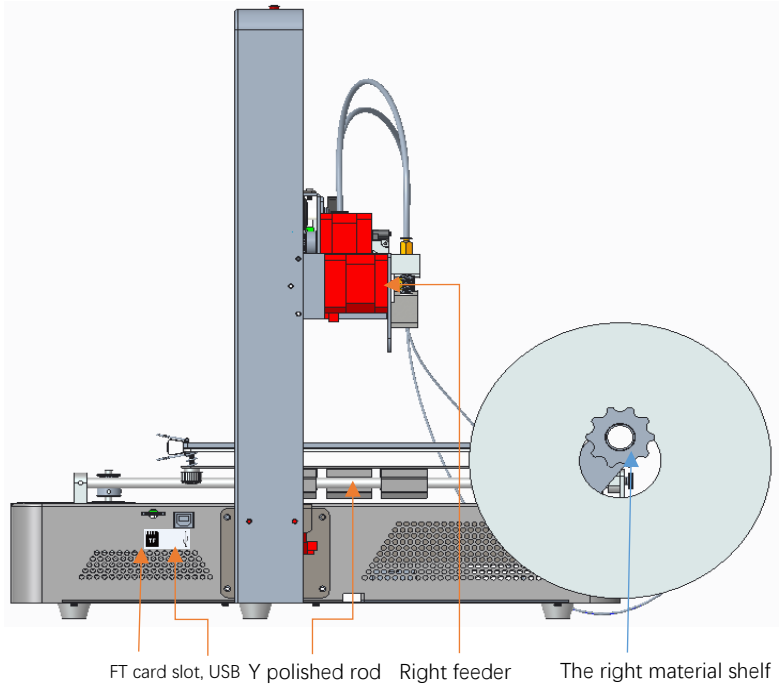
Print size	220*220*210	Power input	110V/220V AC, 50/60Hz
Pocision	X/Y0.0125mm, Z0.02mm	Power	DC 12V 20A
Print	20-100mm/s(advised 60mm/s)	Certificate	CE FCC
Nozzle size	0.2mm, 0.3mm, 0.4mm optional	Connection	USB interface.TF card
Print color	Dual color	Hotbed	support
Material	PLA.ABS	Nozzle	Maxium260°C
Display	3.5 inches full color touch screen	Ambient temperature	8-40°C
Print	0.1mm-0.4mm optional	ambient	20-80%
Machine material	Aluminium profiles, sheet metal	slicing software	TRONXY exclusive slice software
Machine weight	≈10.1kg	files format	STL.OBJ.DAE.AMF.G-Code
Packing weight	≈12.3kg	operation software	Repetier-Host.Cura
Packing size	500*530*220mm	Operaton system	WinXP/Win7/MacOS
Machine	470*445*407	Power	support

2. Machine Introduction

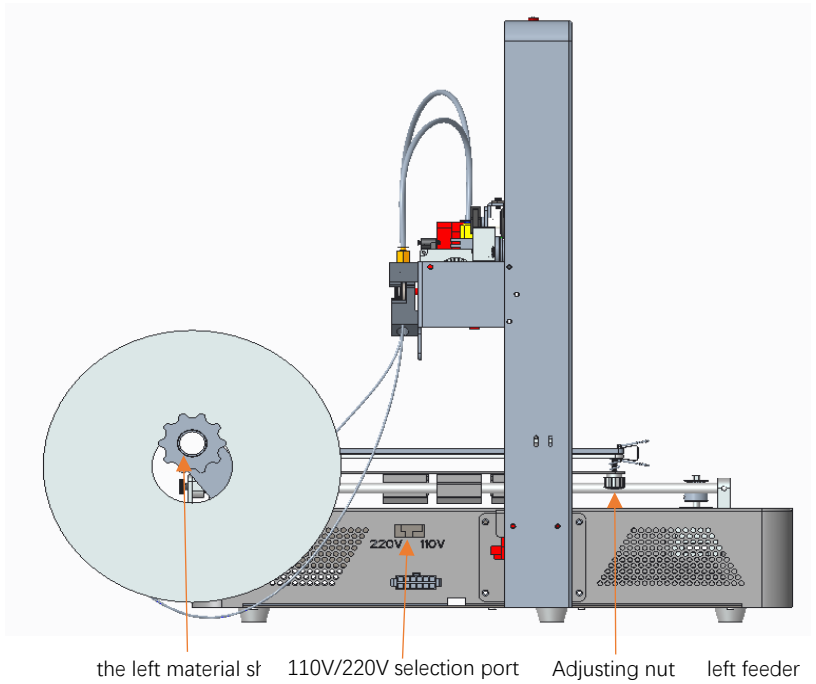
1. Front view



2.Right view

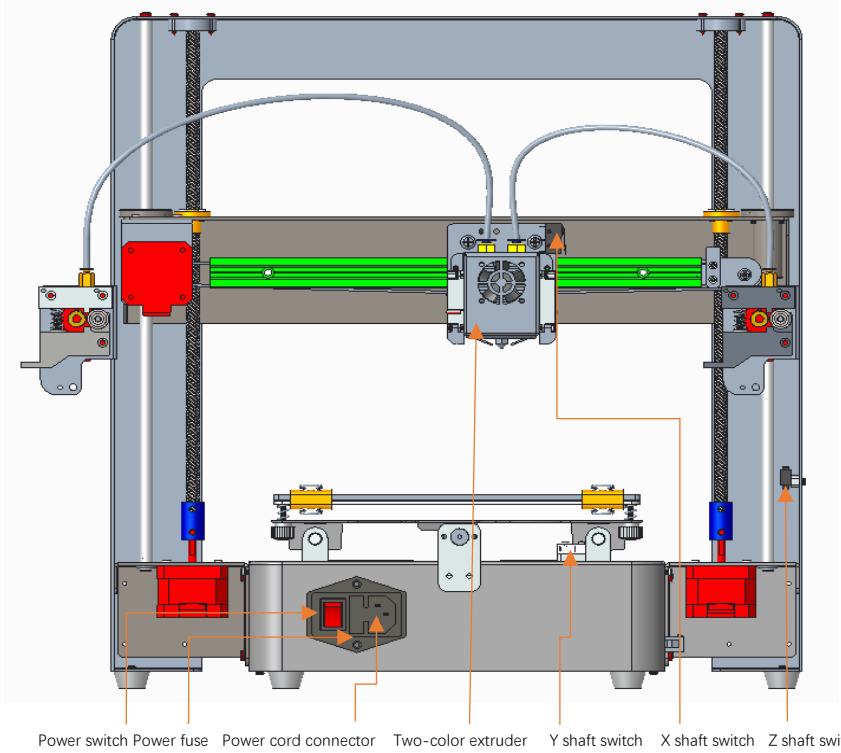


3. Left view



the left material sf 110V/220V selection port Adjusting nut left feeder

4.Back view



3. Product assembly

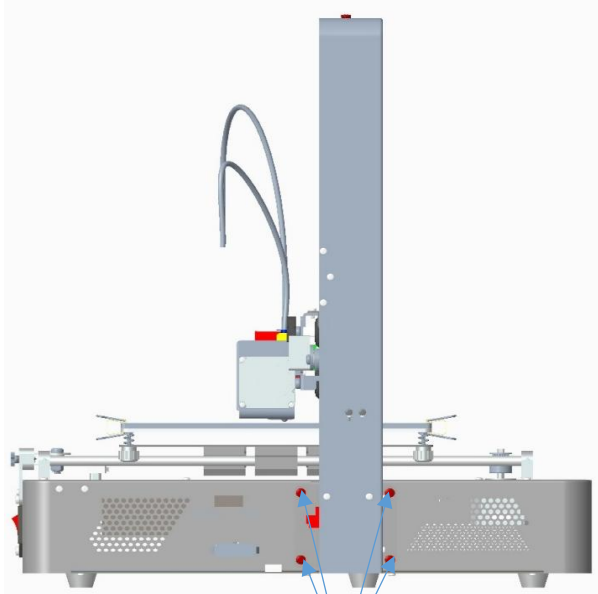
Step 1: assemble the base and the rack (take care to avoid scratching parts when taking and assembling).

Assembly parts :

					
The base 1pcs	shelves 1pcs	screw PM4*6 8个			

Take out the bottom rack from the packing box and put it on the shelf, as shown in the figure. Align with the position as shown in the figure, and use 8 PM4*6 screws

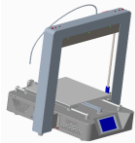

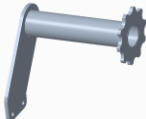
to pass through the hole in the position as shown in the figure, and lock it with the M4 tooth hole on the base.



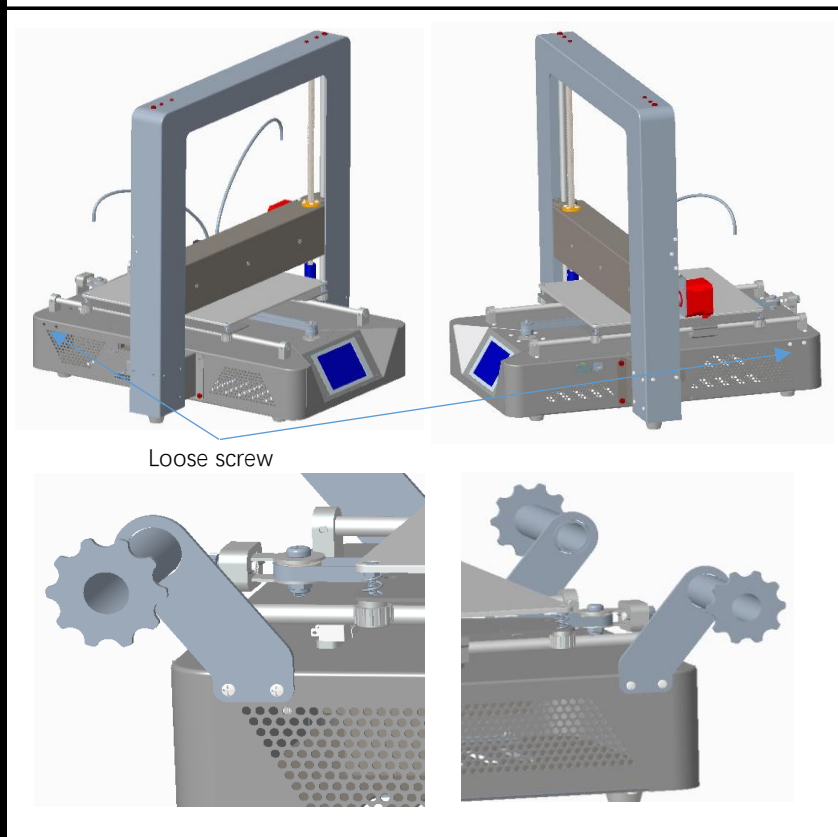
PM4*6 screws

Step 2: assemble the filament rack

Assembly parts:

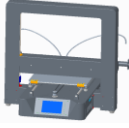
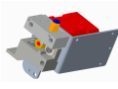

		
printer 1pcs	left rack parts 1pcs	right rack parts 1pcs

Loosen the 2 screws on the left and right sides of the cabinet, take 1 piece of left and right material rack as shown in the figure, place it according to the position shown, align the holes, and lock it with 2 screws.

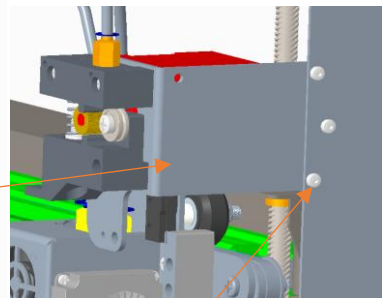
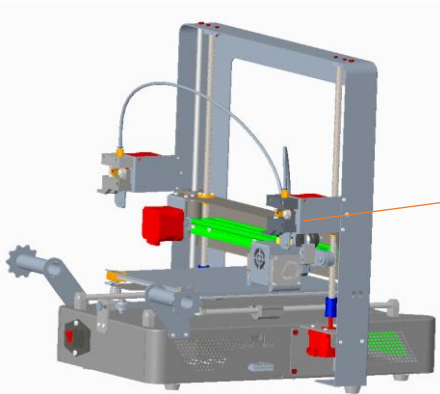


Step 3: feeder assembly

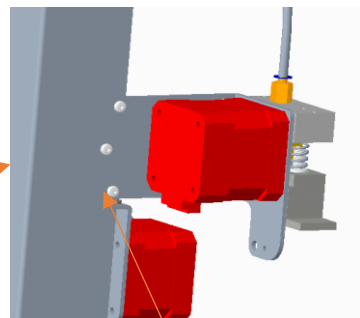
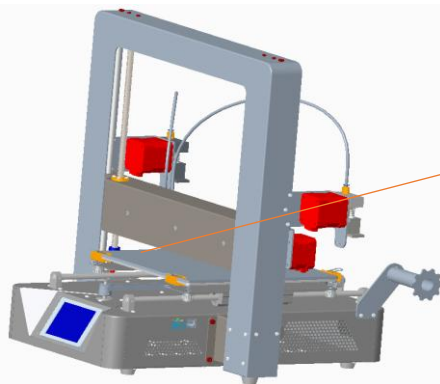
Assembly parts:

			
printer 1pcs	feeder parts 2pcs	screws PM3*4 6pcs	

1. Screw through the machine sheet metal hole, align with the screw tooth hole of the feeder component, and then lock it, as shown in the figure.
2. Insert the material tube into the air nozzle hole of the feeder.



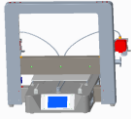
screws PM3*4



screws PM3*4

Step 4: wiring

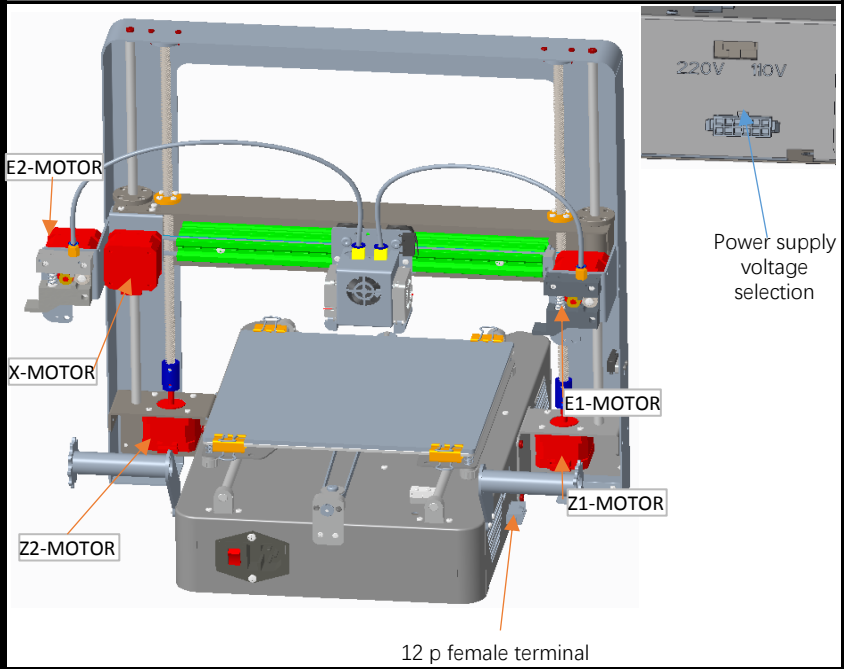
Assembly parts:



printer(included wiring) 1pcs

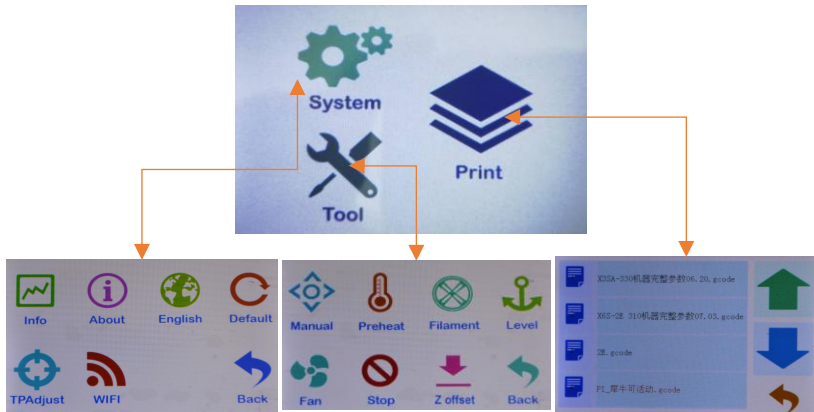
Power line 1pcs

1. Insert the male terminal of the shelf 12P wire into the female terminal of the left rear side of the base.
2. 2Motor 6P terminals protruding from the left back side of base, short plug in z1-motor, long plug in e1-motor.
3. 3 Motor 6P terminals protruding from the right rear side of the base are inserted into z2-motor for short while x-motor for long.
The rest is plugged into e2-motor.
4. According to the local voltage, select the power supply voltage of the host. As shown, the position shift is 220V, and the toggle switch is to the right.
You can select 110V voltage.
5. Remove the power cord and plug into the 3P port of the host power supply.
Make sure the debugging is good.

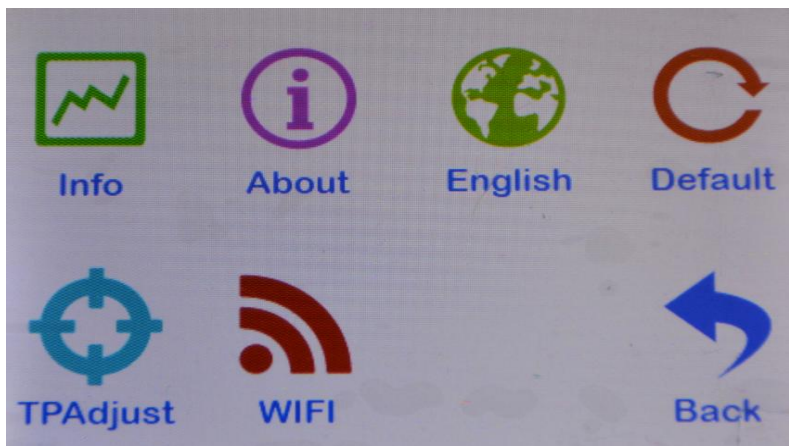


4. Operational guidelines

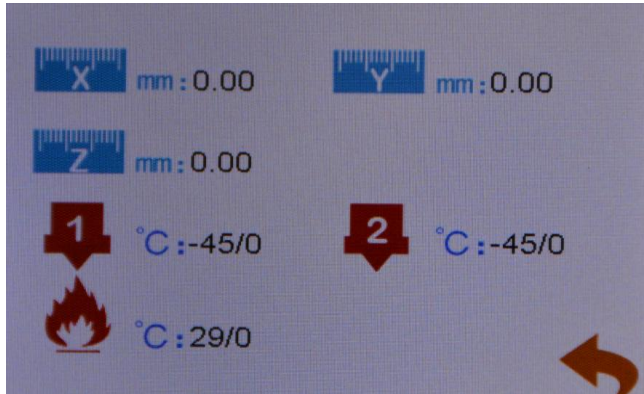
1. Enter the main screen of the startup, display the system, tools, and print three main menus. Click on each of the three sub-menus, as shown in the figure. Basic functionality for displaying submenus.



2. Click the system menu and enter it into the system submenu, as shown in the figure: click the return menu and return to the superior menu.



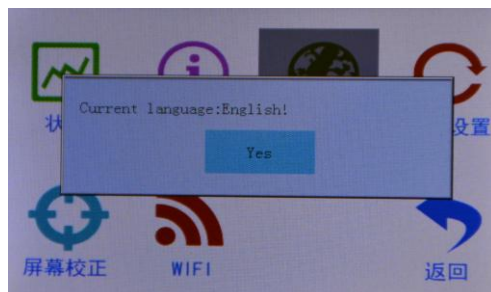
2.1 Click the state, and the display is as shown in the figure: the machine position state parameters are displayed. Click back menu to return to the superior menu.

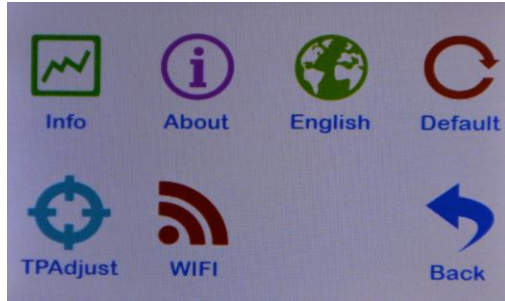


2.2 Click the machine information and the display is as shown in the figure: the machine brand, ID, version and other information are displayed. Click back menu to return to the superior menu.

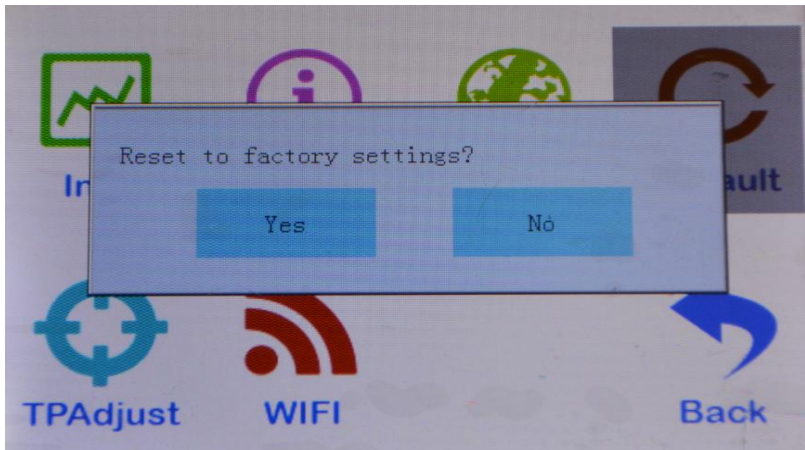


2.3 Click the Chinese location menu to enter Chinese and English. Click back menu to return to the superior menu.






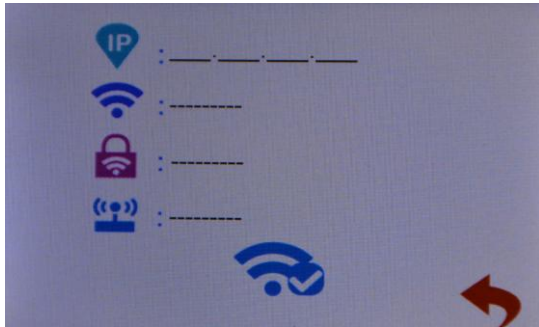
2.4 Click the factory setting and ask if the factory setting is restored. Click to return to restart and restore the factory Settings.



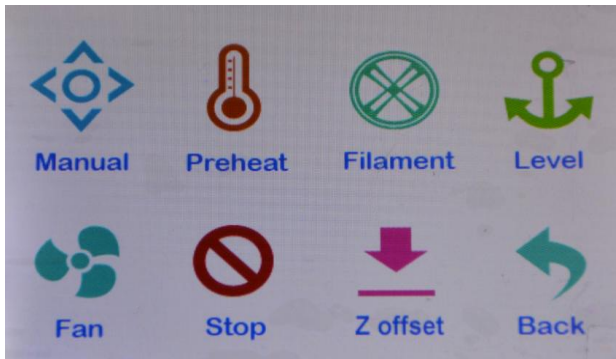
2.5 Click the screen correction icon to enter the screen correction and click the cross position for correction. Adjust the screen when the menu is off, save it back.



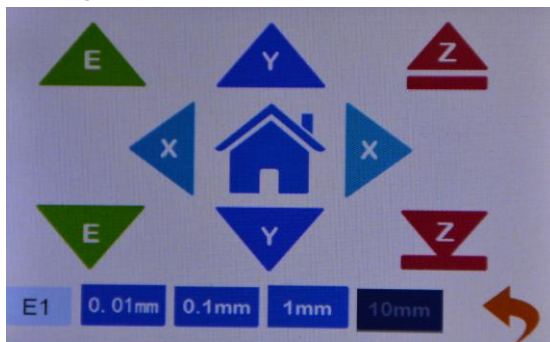
2.6 Click the WIFI menu to enter WIFI parameter setting. Save Settings click on the icon  to return.





3. Click the tools menu to enter the machine parameter setting and adjustment.



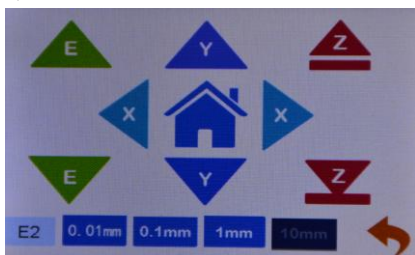
3.1.1 Click the manual menu to enter the manual adjustment mode. Adjust the motor rotation, E extruder feeding/discharging, XYZ shaft motor moving. ICONS 0.01mm, 0.1mm, 1mm, 10mm,





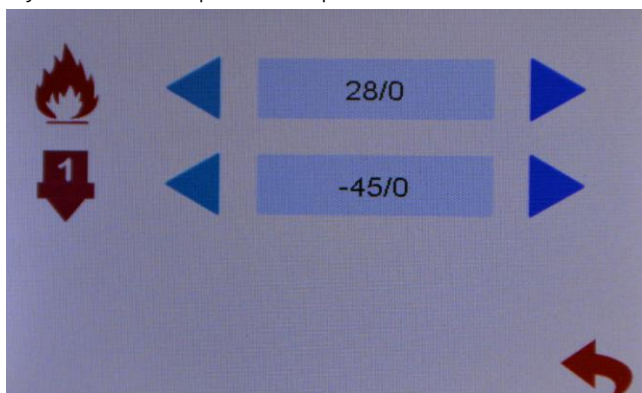
After clicking, the dark color is displayed, such as icon 10mm, indicating that each click of motor stroke moves 10mm.


Click the  icon and the machine returns to the origin. Click  back to the parent menu.

3.1.2 Click on the E1 icon, and the E1 icon changes to show E2. Click on the E2 icon again to show E1, as shown in figure E1E2. Click on the switch state. When displaying E1, click icon E to start extruder 1; when displaying E2, click icon E to start extruder 2.

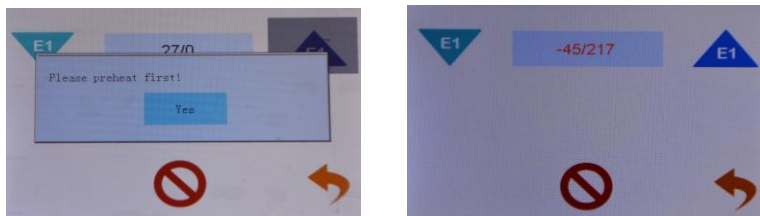






3.2 Click the preheat icon, as shown in the figure, to set the heating temperature of the machine extrusion head and the hot bed, the icon  hot bed heating and the icon  hot head heating, and click the icon on the right and left direction to adjust the setting temperature heating. Use the heating function when replacing filaments. Click the digital icon to directly switch to the preset temperature.



3.3 Click the icon of loading and unloading filaments to indicate preheating. Remove the filaments to warm up before pulling them out. Set the heating temperature, the temperature reached, click the icon  to return the material. When installing the consumables, insert the consumables directly into the feeder hole.

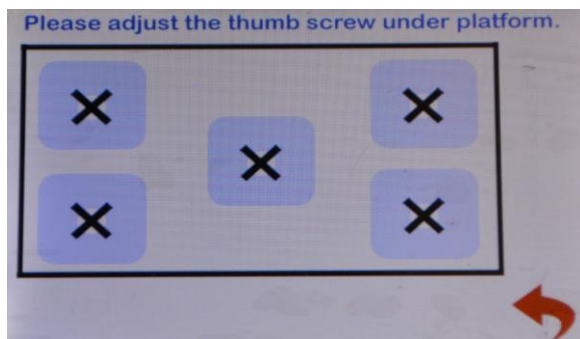
and press down the feeder pressing block. As shown in the figure, pass the filaments through the feeder to the material pipe,



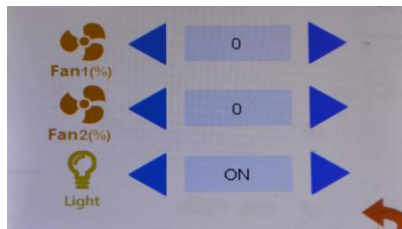
and click the icon  to send the materials to the nozzle to flow the materials. Click the icon  motor to stop. Single side feed can not be too long, Avoid plugging the hot material into the cold end of E2. E2 motor filaments feed back and forth. changed to E2, click  filaments return, click  filamenst in.




3.4 Leveling menu, auto leveling function, click the icon to enter auto leveling. The machine reads the parameters of the leveling point and saves them. Automatic leveling function selection. This function is not available on this machine.

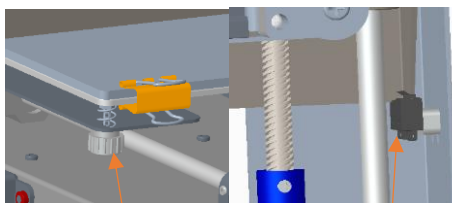
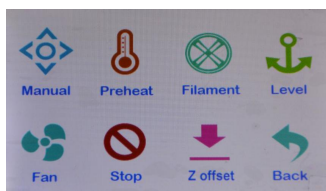


3.5 Click the fan icon to enter the fan setting, and turn the fan value 0 OFF, 100 ON, light ON, and light OFF.





3.6.1 Click the emergency icon, the machine stops in the current state, and the motor unlocks. When adjusting the gap between the printing platform and the nozzle, use emergency stop to let the extruder slide freely. Gap size, with a piece of A4 paper between the nozzle and the platform sliding resistance, but do not tear the paper is appropriate. The platform should be positioned near the support point of the platform, The platform should be positioned near the support point of the platform, but avoid screw holes. Adjust each support point.

3.6.2 Will print platform of the first four adjusting nut is tightened, the spring pressure in the shortest possible location, click on the icon  , extrusion head down, run into the Z axis stop switch, adjust the position of the switch, to squeeze head nozzle and the platform about 2-3 mm apart, then loosen the adjusting nut, fine-tuning platform for extrusion head nozzle and the mobile platform about 2-3 mm apart, Distance from the nozzle to an A4 sheet of paper thickness.



Adjusting nut

The Z axis switch

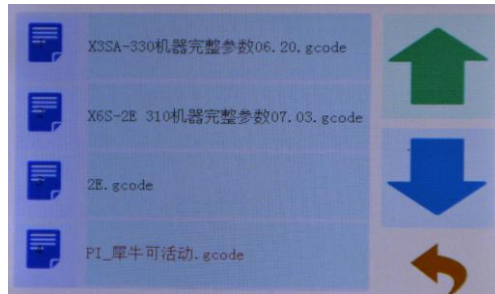
3.7 Click the Z offset icon to enter the Z axis position adjustment. The function of automatic leveling is effective. Select the fine tuning 0.1mm icon, click the icon  Z axis to move up, and click the  Z axis to move down. Adjust the nozzle and platform to A4 paper thickness. Click the icon set Z to zero and save the setting.



This function is automatically leveling Z axis compensation, with leveling function used, leveling simple. This function is not available on this machine.

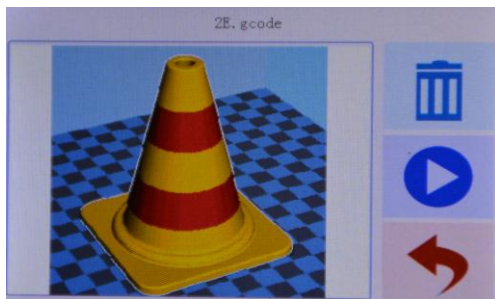


4.1 Click on the print icon to enter print. The screen displays the files in the machine memory card.

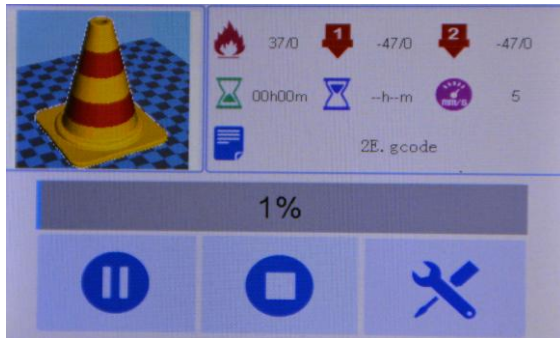
Click the arrow to scroll up and down. Click the folder, open the folder, and display the folder contents.




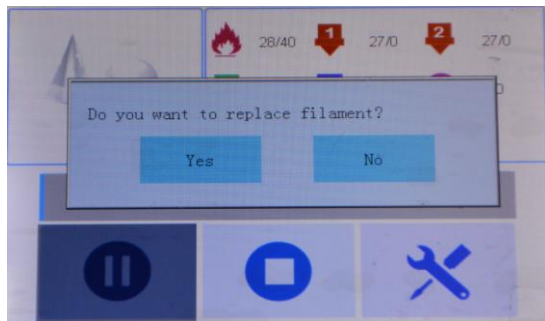
4.2 Click on the file and select the file, which is sliced, to enter the file screen. Click the icon  to delete the file. Click the icon  to enter print mode.




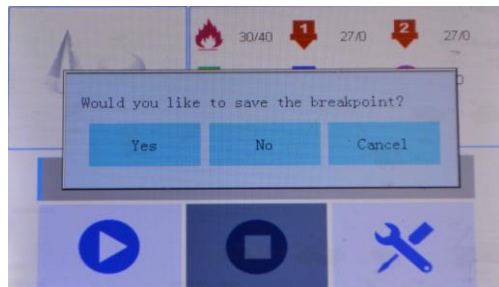
Top left frame preview model; The right picture frame shows the status parameters, the green hourglass shows the printing time, and the blue hourglass shows the time needed after printing. Indicates the printing speed by the number of the icon, the name of the printing file by the icon, and the printing progress by the percentage.

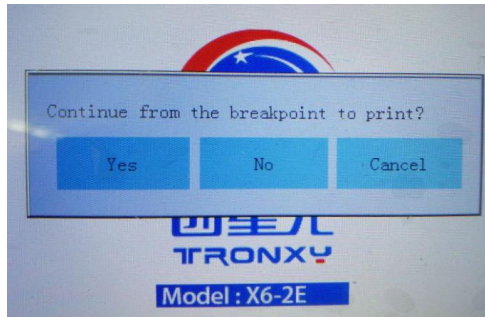



4.2.1 Click the icon  to stop printing and ask if the filaments should be replaced. To replace the filaments, click YES to replace the filaments as step 3.3 and return to continue printing. Click NO and go back to print.





4.2.2 Click the icon  to stop printing, and the machine asks if the state is saved. Select "YES". The next printing will start from the current state. Select NO, machine state reset. Click cancel to continue printing. This function continues for breakpoint. After the model print stops, the stop save state is shut down, and you can continue printing after the next start. Boot prompt last print interrupt, select YES continue last print

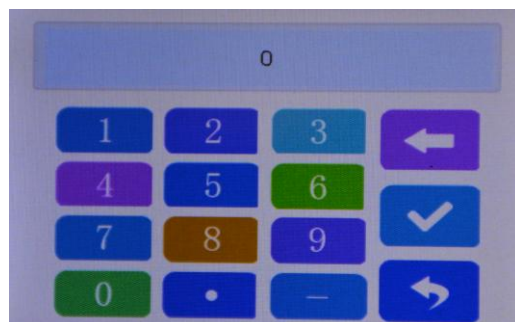
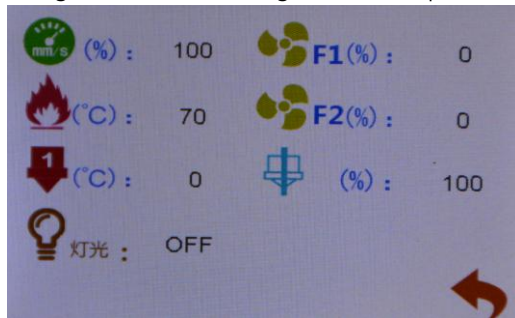




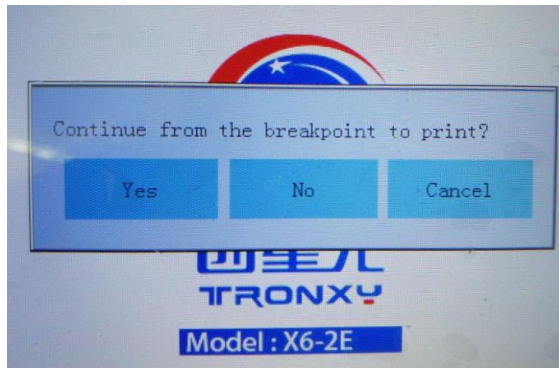
4.2.3 Click the icon  to enter the machine parameter setting change. The initial parameters are set by slicing software.

The parameters can be changed in printing, as shown in the figure corresponding to the icon parameters. Click the parameters on the right side of the icon, enter the parameter setting screen, set the parameters, click the icon  to save and exit, and click the icon to exit without saving.

 the icon exit. The preview of the machine model is required to cooperate with the company's slicing software. After the parameter is changed, the file is changed, and the preview is invalid.



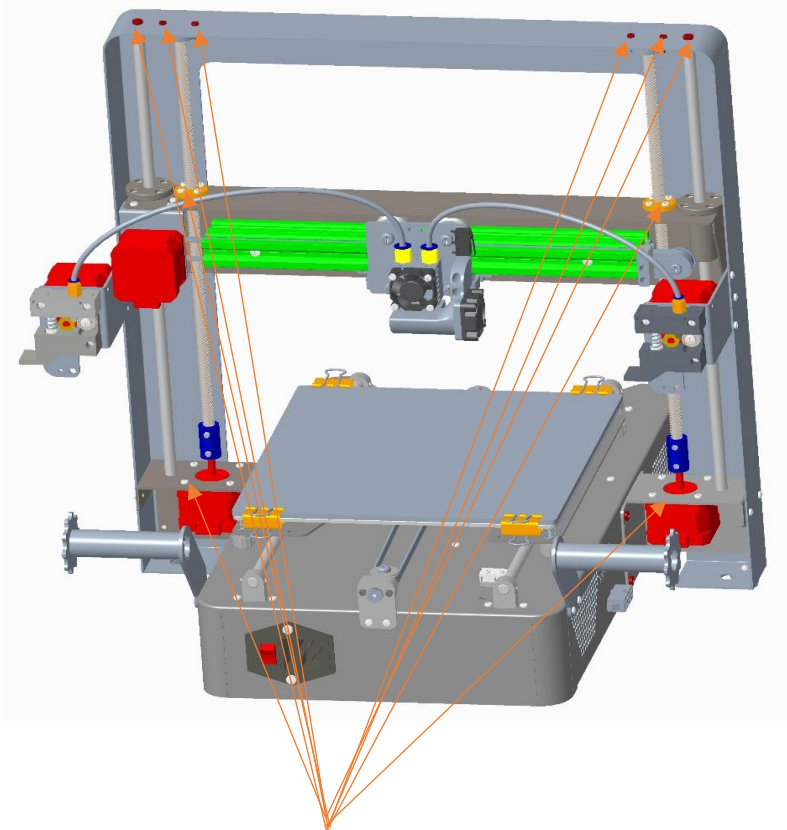
5. Power failure resume to print : When the machine is printing, the machine will automatically save the current status parameters. When the machine is restarted, the screen will show the last interrupt. Will you print from the breakpoint? The option is to print from the breakpoint. Select no or cancel, and the parameters are cleared.



5. Product debugging

1.Z-axis screw debugging:

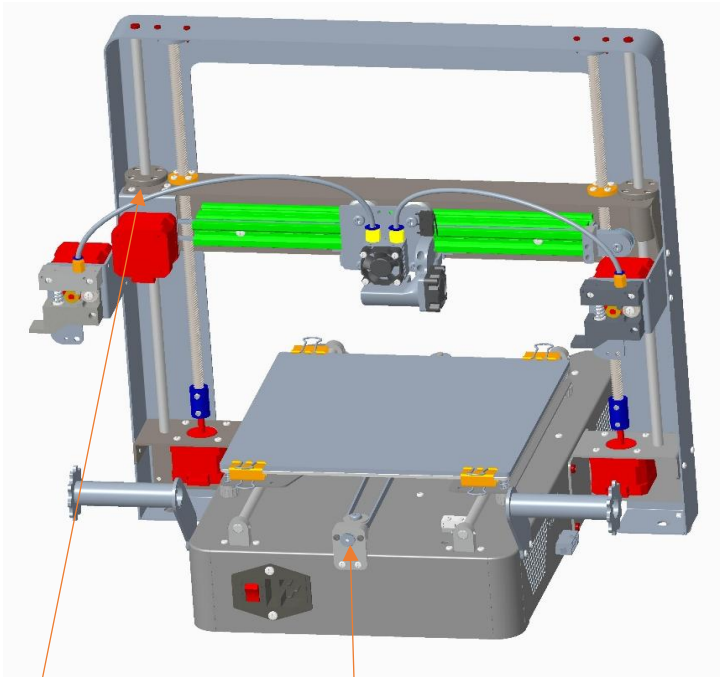
Machine Z axis direction not free or jammed, please loosen the around Z axis motor fixed screw, screw nut screw, screw at the top of the limit bearing fixed screw, polished rod at the top of the screw, the screw loosen to fixed parts can be moved, at the same time synthetic rotating screw, screw, polished rod parallel automatic correction, the motor shaft core, screw nut, shaft core limit bearing shaft core in the same line, locking polished rod at the top of the screw, screw nut screw, rotating screw again, fixed screw locking motor, rotary screw again, fixed screw, locking the top bearing rotating screw again, confirm the rotate smoothly.Key rotation automatic centering.



Adjust screw position

2

Belt adjustment: Y axis belt tension can be adjusted through the connecting screw and nut of the belt passing the wheel. Adjust the tension of X axis belt, loosen the screws of X motor's fixing plate, pull the fixing plate outward, and then lock the screw. If the belt is too loose, it is easy to jump the teeth, which causes the loss of step. If the belt is too tight, it will increase the pressure of the



X-axis belt control

Y axis belt adjusting ki

6. FAQ

- 1.Nozzle plugging material: will the print head heated to above needle dredge nozzle, until manual feeding normal out of
- 2.Pipe plugging material: the printing head is a straight-through it is easy to cause the pipe blocking material. The pipe should be removed and cleaned.
- 3.Poor quality filaments lead to poor feeding filaments: replace
- 4.Problems such as not reading the card and online failure:
 - a.The SD card can be read on the computer, but cannot be Retry, change GCODE file to uniform format (no special symbol Bad contact with SD card slot.
 - b.If the computer cannot display, the SD card is damaged.
 - c.Could not be online: serial port was not selected correctly, or failed to install, USB data cable was damaged.
 - d.The interference of external signal makes it impossible to be
- 5.Rubber leakage of printing head: the nozzle is loose, the heating block is loose, and the throat tube is loose, tightened or worn out due to use, replace accessories.
- 6.Print the wrong layer, loose the belt, and tighten the belt properl