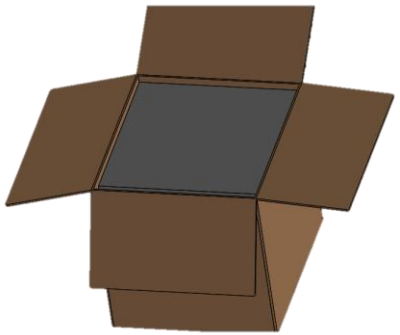
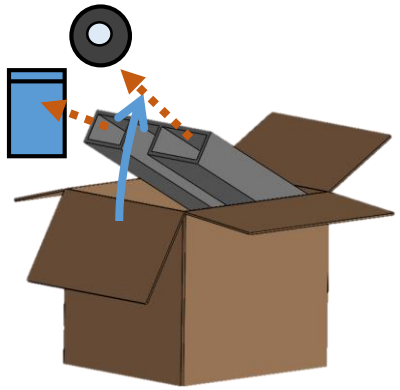
Unboxing

1

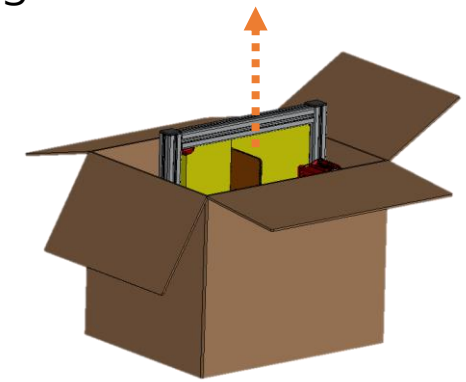


2



Remove miscellaneous bag and optional filament and or other parts

3



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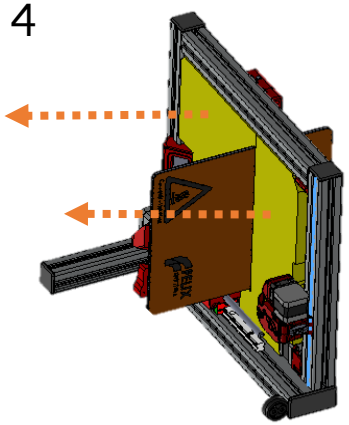

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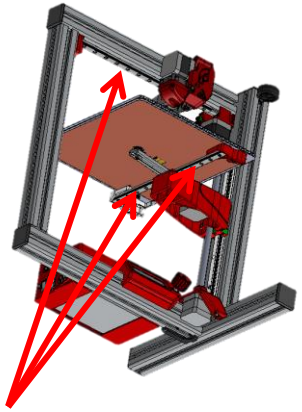
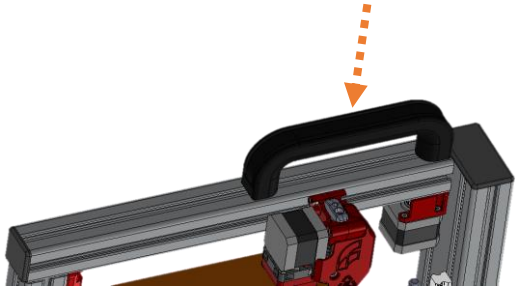


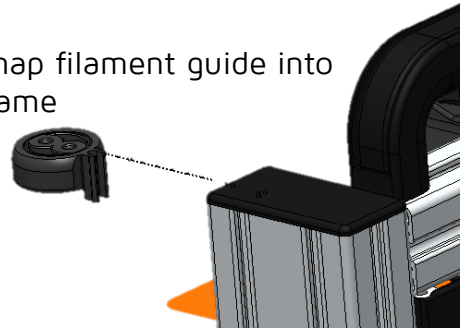
Remove tie-wrap on belt and on guide rail

Install Accessories

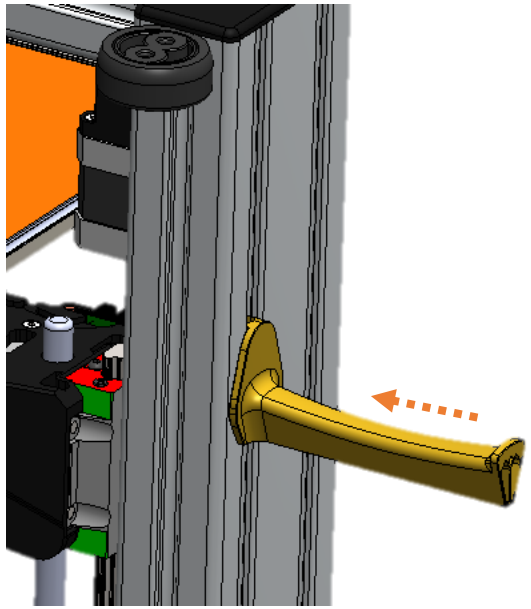
6 Mount handle



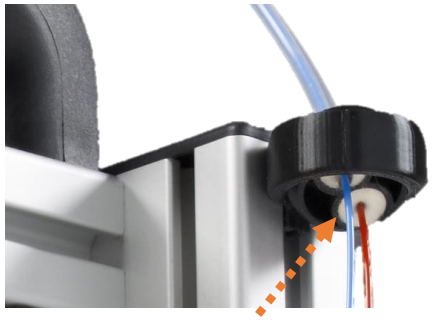
Snap filament guide into frame



7 Snap filament holder into frame



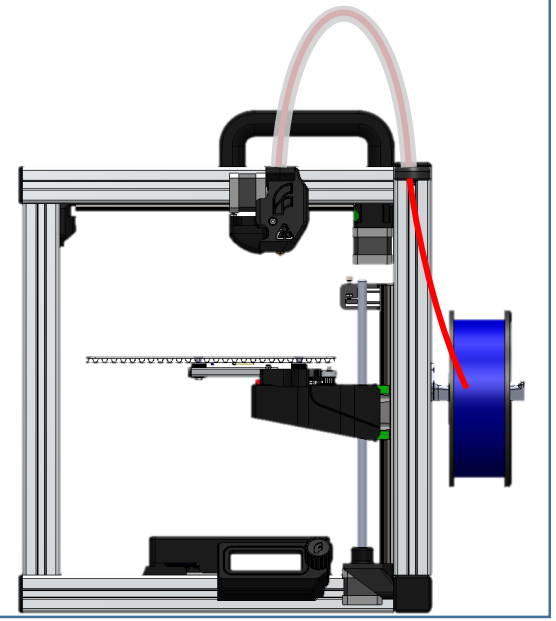
8



Insert dust cleaner disc(s)

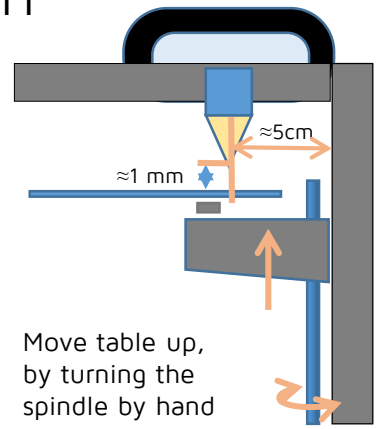
9 Insert Teflon tubes

10 Place filament roll(s) and guide the filament to the extruder entry



Offline Calibration

11

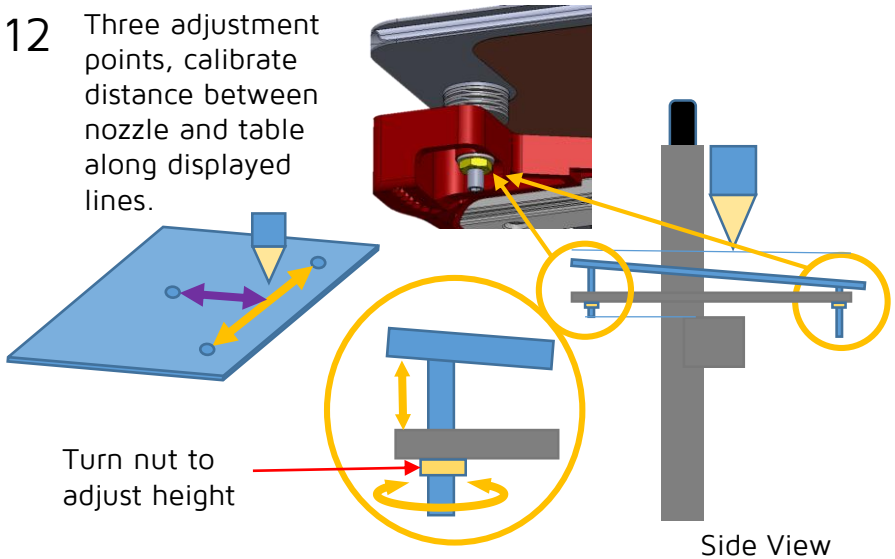


Move table up, by turning the spindle by hand

Front View

12

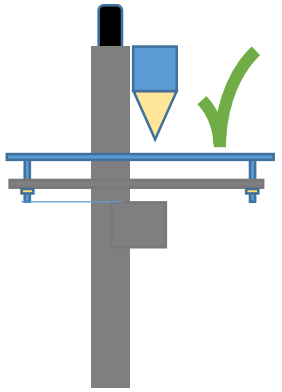
Three adjustment points, calibrate distance between nozzle and table along displayed lines.



Turn nut to adjust height

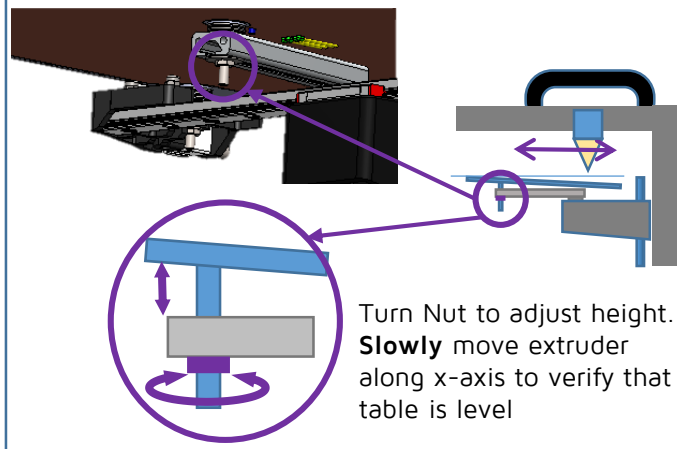
Side View

13



Side View

14



Turn Nut to adjust height. **Slowly** move extruder along x-axis to verify that table is level

Install and Setup Software

15

Download & Install
setupRepetierHostFELIXPrinters_*.exe
www.FELIXprinters.com/downloads

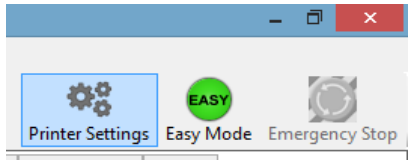
16

Connect USB & Power Plug

17

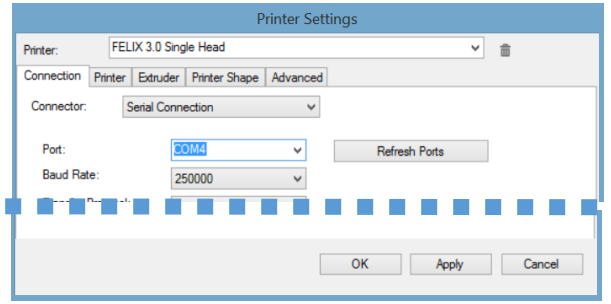
Start Repetier – Host

18



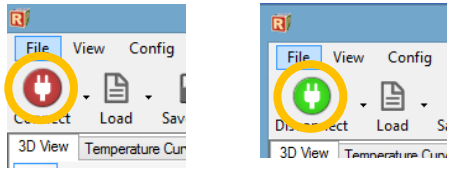
Open Printer Settings

19



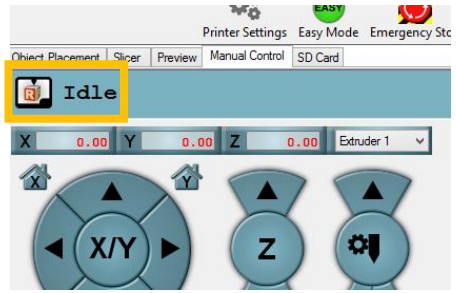
1. Select your printer.
2. Press "Refresh Ports" button, and then select the correct COM-port
3. Press OK

20



Connect to printer

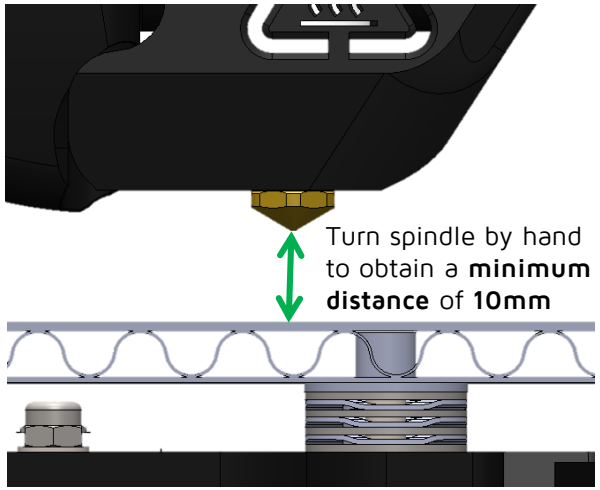
21



Idle indicates successful connection

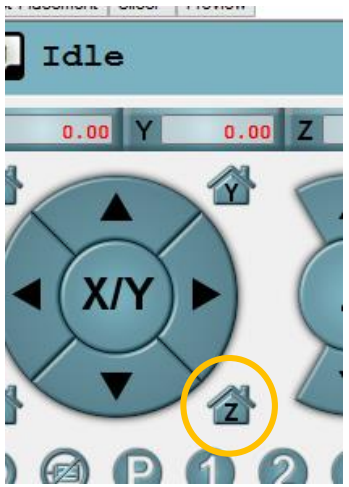
Online Calibration

22



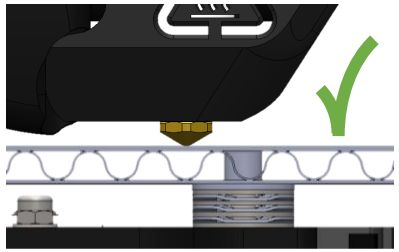
Turn spindle by hand to obtain a **minimum distance** of **10mm**

23



Press ***Home Z***

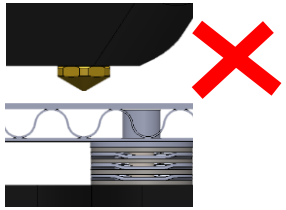
24a



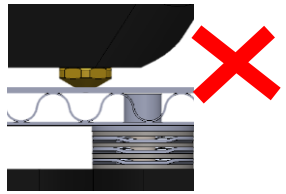
✓ No air gap
✓ No contact between nozzle and table

Calibration Successful

24b

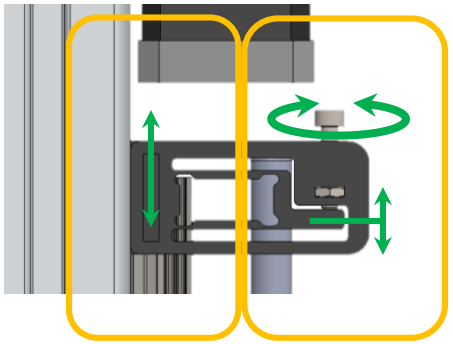


Too far:
Big gap



Too close:
Nozzle hits table

26



1. Move whole bracket for rough adjustment

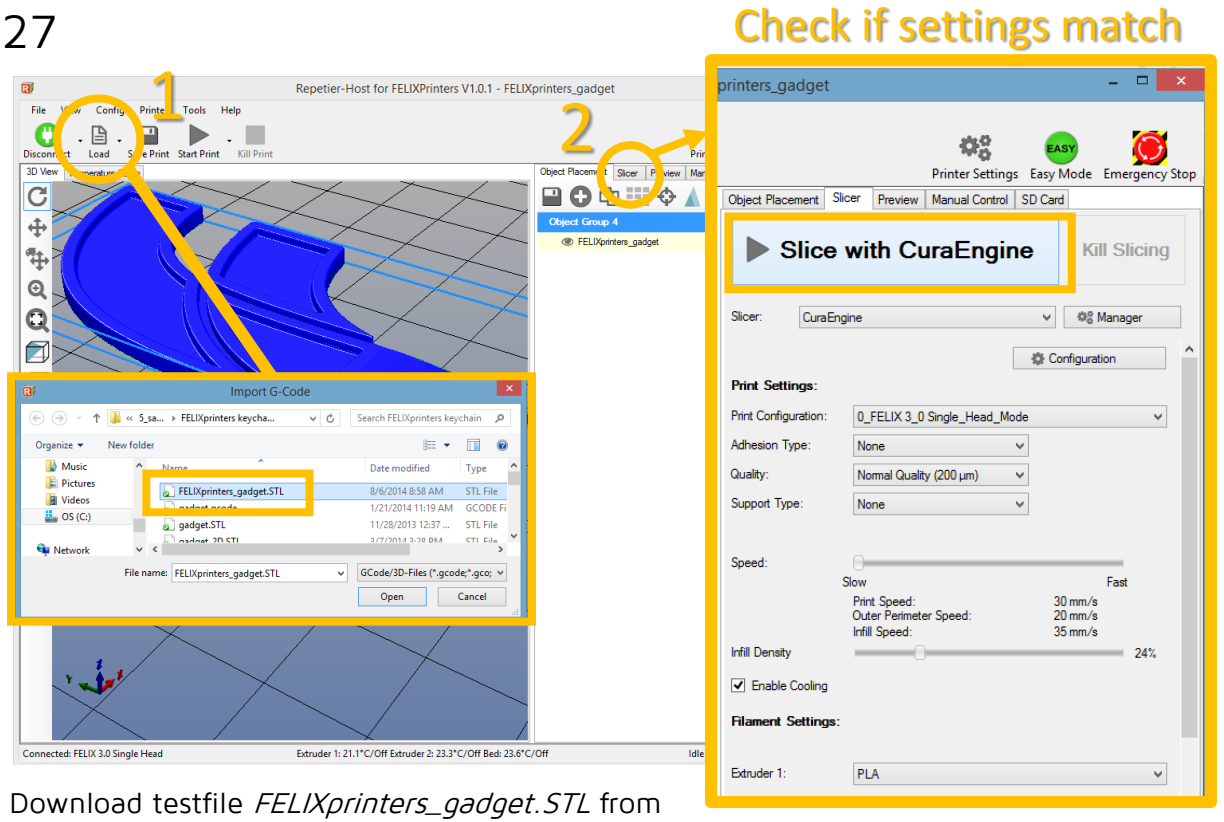
2.Turn screw for fine adjustment

NOTE:
Lowering the switching vane means that the print bed will stop further away from the nozzle tip.

NOTE:
This calibration step together with previous calibration of table are very important for the following reasons:
✓ Prevents damage to printer
✓ Ensures optimal adhesion of object to print bed.

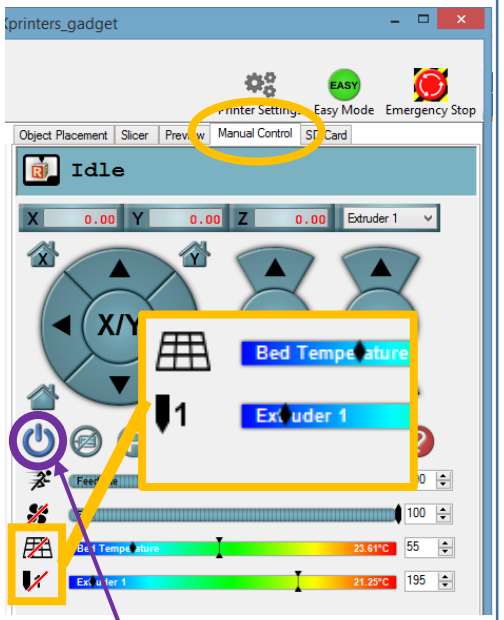
Load, Slice and Print Object

27



Download testfile *FELIXprinters_gadget.STL* from www.FELIXprinters.com/downloads

28

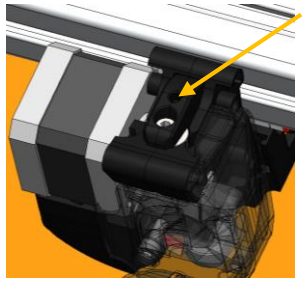


- ✓ Clean the heated bed with a detergent like blue spirit or alcohol
- ✓ Press indicated temperature buttons
- ✓ Check if temperature is rising.
  - If not press this button twice; the printer might be in standby mode due to long inactivity.

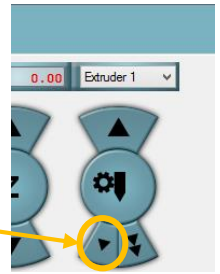
29

- ✓ Wait until temperature set points are reached.
- ✓ Make sure nothing is blocking any axes

30



Insert Filament

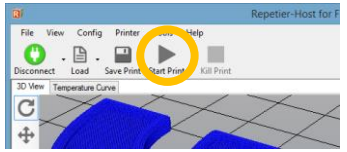


Extrude until filament comes out of nozzle

Note: Only works when temperature > 150°C

31

Start Print



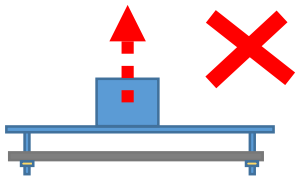
32a

If print object didn't adhere correctly to the heated bed, please go to step 23 and 28

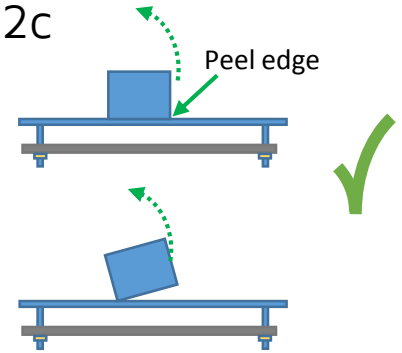
Remove object after print completes:

- ✓ Let bed cool down
- ✓ Don't vertically pull object away from print bed.
- ✓ Start peeling at edges
- ✓ After peeling edge, try to twist it from bed.

32b



32c



33

Congratulations, you've made your first print!

Tip: consult the **user manual** for more detailed information, and join our **user forum** to get the most out of your printer