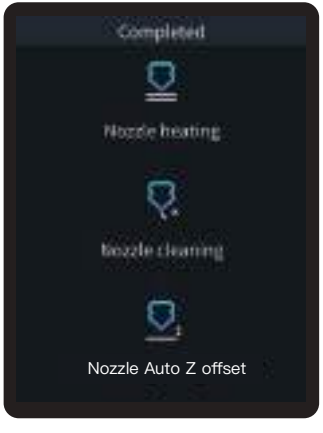
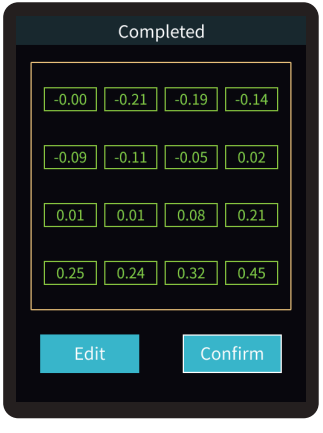
4.1 Leveling

Select “Leveling” with the knob and wait for the completion of the auto leveling operation;



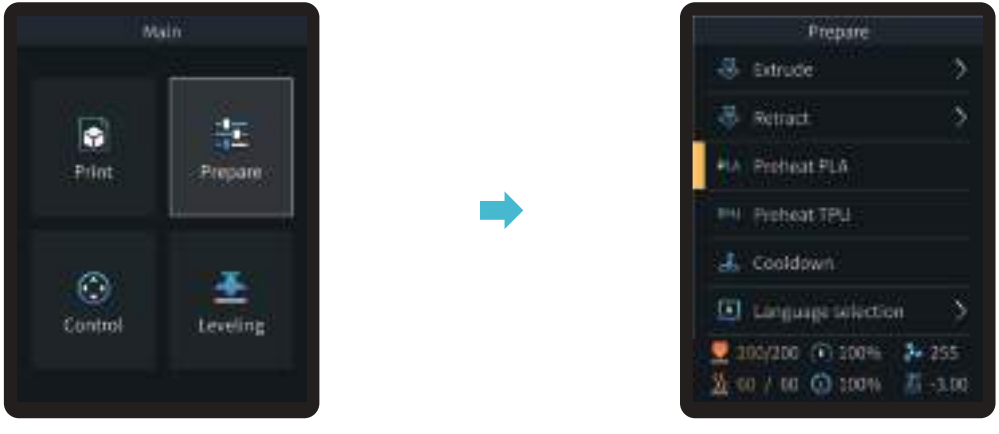


Value displayed in green: indicating platform is level;
Value displayed in blue: indicating platform is relatively level;
Value displayed in yellow: indicating platform is slightly inclined;
Value displayed in red: indicating platform is significantly inclined.

Tips:
Please clean the printing platform before leveling to ensure that there are no foreign objects or filaments left on the printing platform.

4.2 Printer preheating

Carry out PLA/TPU preheating by selecting “Prepare” with the knob;



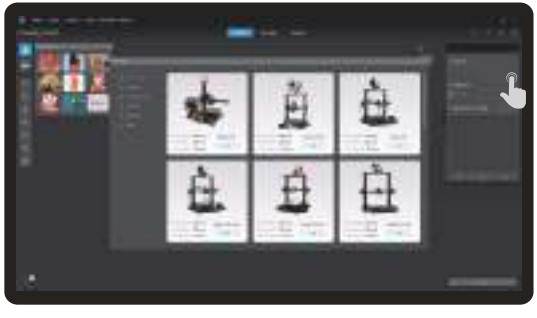
Official recommended print parameters for filament								
Filament	Adapted protective cover	Adapted dry box	Drawback distance	Drawback speed	Max. hotbed temperature	Nozzle temperature	Fan speed	Printing speed
CR-PLA	NO	NO	0.8mm	40mm/s	60℃	205℃	100%	180-250mm/s
HP-TPU	NO	NO	1.6mm	40mm/s	70℃	205℃	100%	50mm/s
CR-PETG	NO	YES	1.2mm	40mm/s	70℃	230℃	50%	120mm/s

4.3 Software Installation and Slicing

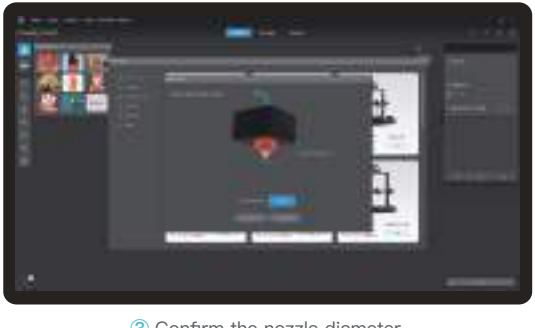
※ Install Creality Print slicing software by opening the random data on the storage card.

※ Login to the website to download and install: https://www.crealitycloud.com/software-firmware/software?type=7

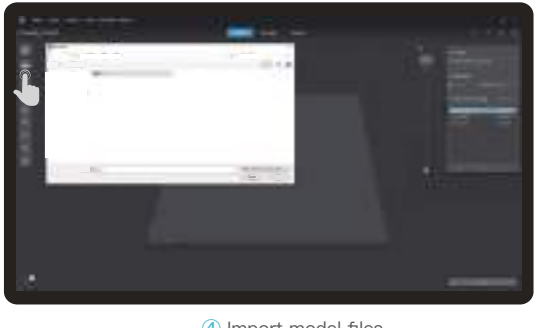
① Select “Language” and “Server”



② Add the printer



③ Confirm the nozzle diameter



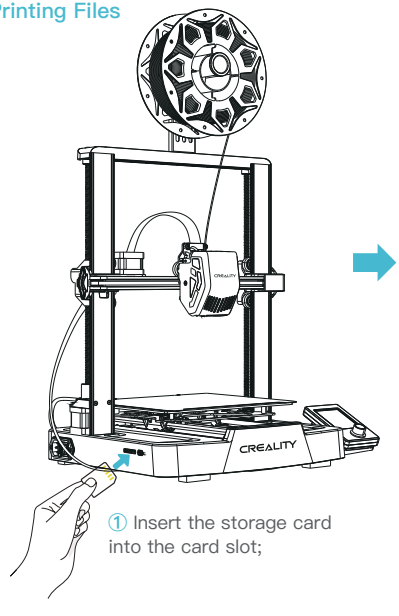
④ Import model files

⑤ Set filament type

⑥ Adjust parameter configuration and click on ”Slice”

⑦ After the slicing is completed, gcode files are generated, then click “Export to Local” to save it to the storage card;

4.4 Printing Files



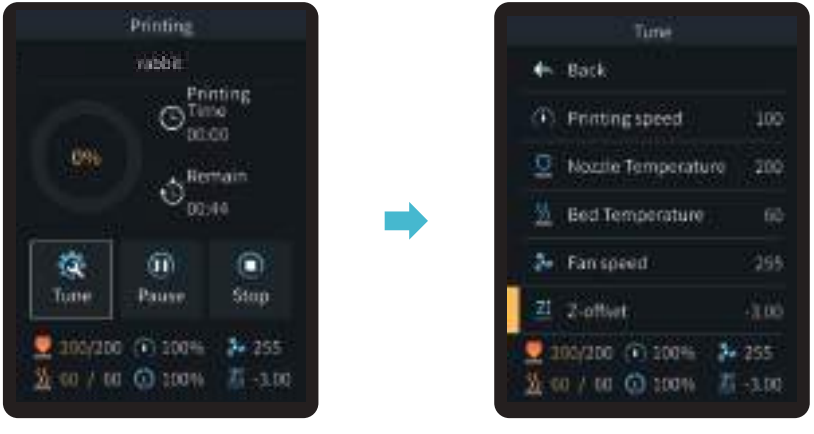
① Insert the storage card into the card slot;

② Select ”Print”;

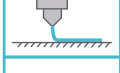
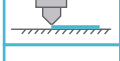
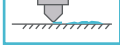
③ Select the file to be printed;

Note:
1. For details on using the software, please refer to the slicing software user manual on the memory card.
2. Saved files must be placed in the root directory (not a subdirectory) of the memory card.
3. The file name must be Latin letters or numbers, not Chinese characters or other special symbols, and no more than 20 characters.
4. Do not insert or remove the memory card during the printing process.

If the first layer of printing effect is overpressure or does not stick to the platform, you need to use the knob to select the setting, adjust the Z axis compensation, so that the printing platform and the nozzle fit as much as possible, and click OK to start printing.



For levelling effect, please refer to the operation and try to maintain a distance of approximately 0.1 mm between the printing platform and the nozzle.

		⊗ The nozzle is too far away from the platform, so the filaments can not adhere to the platform.
		✓ Filaments are extruded evenly, just sticking on the platform.
		! The nozzle is too close to the platform, leading to insuficient filament extrusion, even scraping the platform.

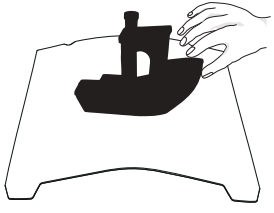
④ Printing...

⑤ Printing can be paused in the event of an unexpected situation during printing;

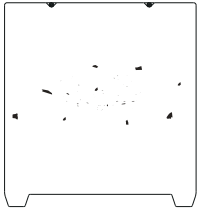
⑥ Click on "OK" when printing is done.

5. Equipment Maintenance

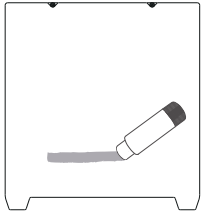
5.1 Platform plate removal and maintenance



① a. When printing is finished, wait for the platform plate to cool before removing the printing platform with the model attached;
b. Slightly bend the platform with both hands to separate the model from the platform."



② If there are residual filaments on the platform plate, scrape them off lightly with a blade and print again.

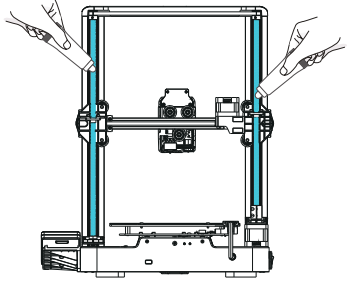


③ If the first layer of the model is not properly glued, it is recommended to apply solid adhesive evenly on the surface of the platform plate before preheating for printing.

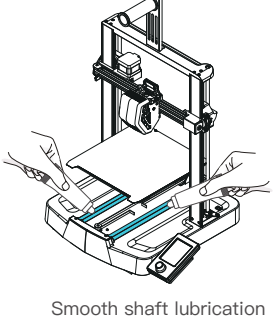
Tips: 1. The printing platform is not easy to bend too large in daily use, and it is impossible to prevent deformation from being unusable;
2. The printing platform is a perishable part, and it is recommended to replace it regularly to ensure that the first layer of the model sticks properly.

5.2 Screw and smooth shaft lubrication

It is recommended to purchase your own lubricant and regularly lubricate and maintain the screw and smooth shaft.

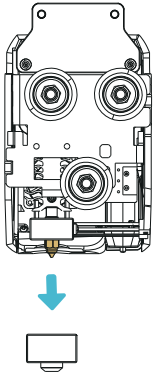


Lead screw lubrication

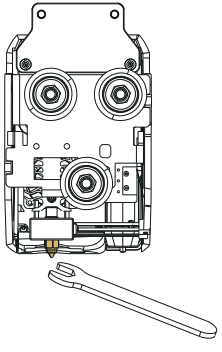


Smooth shaft lubrication

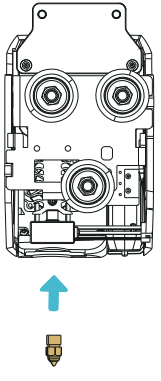
5.3 Nozzle Replacement



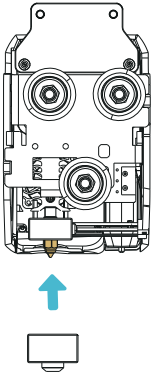
① Remove the silicone protective cover;



② Remove the old nozzle;



③ Mount a new nozzle;



④ Mount the silicone protective cover.

Warnings:

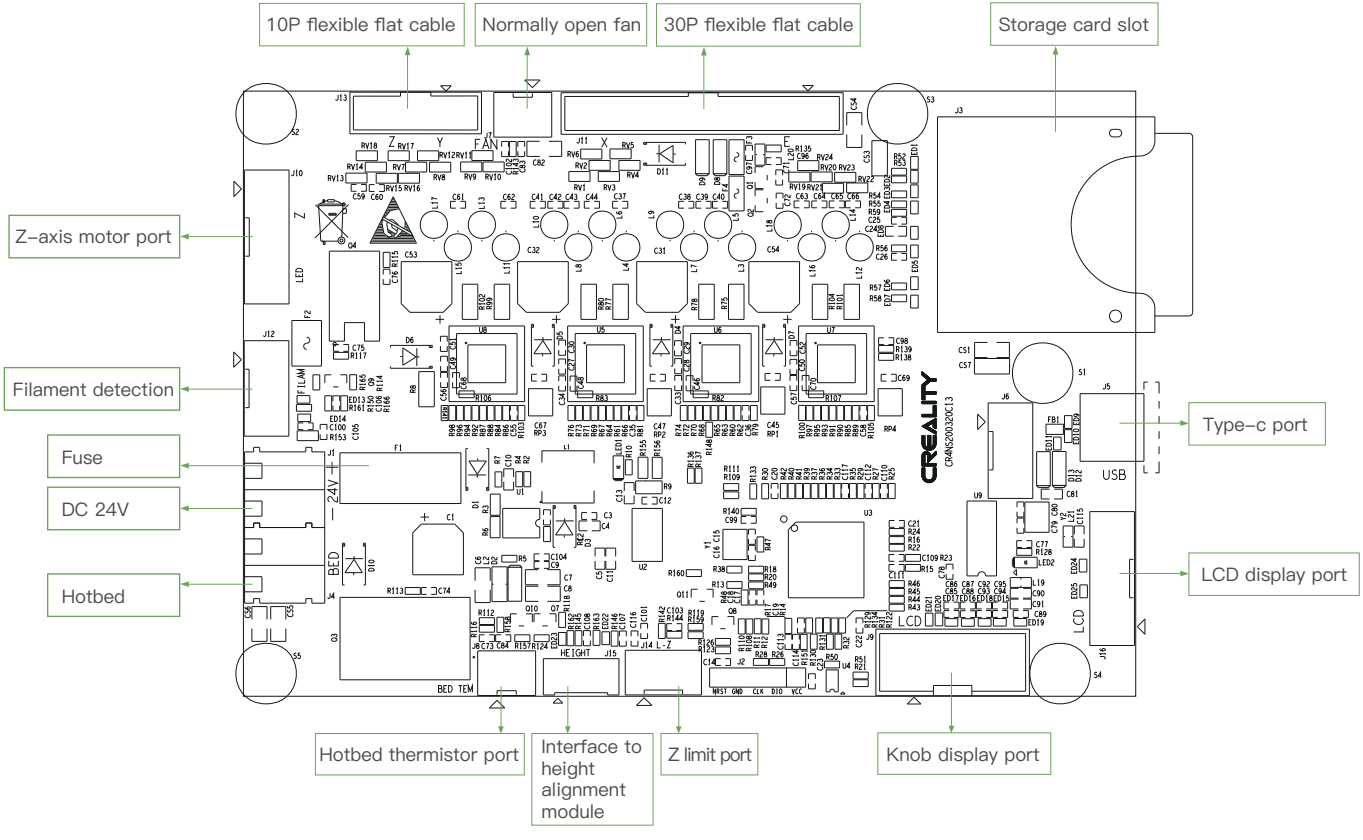
1. To replace the nozzle, you need to preheat the nozzle first;
2. Prevent scalding when replacing nozzles which are hot;
3. Use a tool to hold the heating block in place when removing the nozzle to avoid damage to the components.

5.4 Troubleshooting

No.	Description of the problem	Possible causes
1	No extrusion of filaments as printing begins	1) Filaments not loaded in place 2) Extruder planning 3) Filament jamming
2	Insufficient extrusion	1) Incorrect diameter of filaments; 2) Flow rate is too low, please readjust slicing parameters.
3	Holes or gaps in the top	1) Inadequate number of solid layers at the top; 2) Too low infill density; 3) Insufficient extrusion.
4	Wire drawing or draping	1) Too little drawback distance; 2) Slow drawback speed; 3) Extruder temperature too high; 4) Too long idle running distance.
5	Why does warping occur?	1) Hotbed temperature is too low; 2) Model cooling fan disabled, cooling fan needs to be restarted; 3) Base area of the model is too small, it is required to increase the edges and base.
6	Why does the hotbed not heat up?	1) Check the hotbed heating cable for broken or loose connections and re-enforce or replace with new wiring; 2) Contact after-sales staff to resolve.
7	What can I do if there is no response when the memory card is inserted into the machine?	1) Corrupt print file, re-slice it; 2) The print file is too long, it is better to keep it to 8 letters or less; 3) If the file name is not English/numeric, insert the card into the machine and restart it; 4) Format the storage card; 5) TF card / mainboard card slot is damaged, contact after-sales service to assist in testing.
8	What can I do about loose X-axis and Y-axis belts?	Tighten the X-axis and Y-axis adjustment screws with a tool and keep the belt with a certain amount of spring back and then start printing again.
9	How to deal with abnormal nozzle temperatures (too low/too high)?	1) Check nozzle NTC wire for open circuit (too low temperature) / short circuit (too high temperature). 2) Check the nozzle heating block for abnormalities. 3) Replace the nozzle thermistor.
10	How to deal with abnormal hotbed temperatures (too low/too high)?	1) Check hotbed NTC wire for open circuit (too low temperature) / short circuit (too high temperature). 2) Check the hotbed heating system for abnormalities. 3) Replace the hotbed thermistor.

6. Equipment Parameters

Equipment Parameters	
Model	Ender-3 V3 SE
Modeling Technolog	FDM
Modeling Dimensions	220*220*250mm
Leveling Method	Auto-leveling with CR-Touch
Number of Nozzles	1pcs
Extruder Diameter	0.4 mm (standard)
Slice Thickness	0.1-0.35mm
Precision	±0.1mm
typical printing speed	180mm/s
Maximum printing speed	250mm/s
Acceleration	2500mm/s^2
Nozzle Temperature	⩽ 260℃
Hotbed Temperature	⩽ 100℃
Ambient Temperature	5℃~35℃
Filaments	PLA/TPU(95A)/PETG
Rated Power	350W
Input voltage	100-120V~, 200-240V~, 50/60Hz
Power Loss Recovery	Yes
Printing Method	Storage card printing
File Format	STL/OBJ/AMF
Slicing Software	Creality print/Cura/ Repetier-Host/Simplify3D
Operating Systems	Windows/MAC/Linux
Language	中文/ English/ Español/ Deutsche/ Français/ Русский/ Português/ Italiano/ Türk/ 日本語


10P flexible flat cable
Normally open fan
30P flexible flat cable
Storage card slot
Z-axis motor port
Filament detection
Fuse
DC 24V
Hotbed
Type-c port
LCD display port
Hotbed thermistor port
Interface to height alignment module
Z limit port
Knob display port

Due to the differences between different machine models, the actual objects and the images can differ. Please refer to the actual machine. The final explanation rights shall be reserved by Shenzhen Creality 3D Technology Co., Ltd.

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