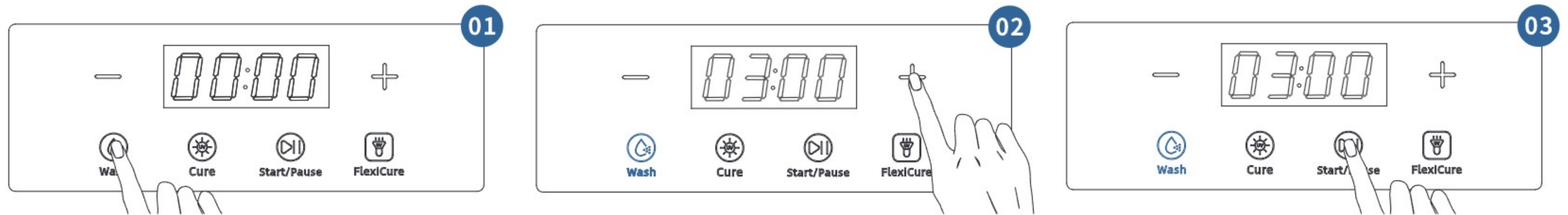


3. Press Wash button to select this mode. You can modify the washing time by pressing +/– button. Then, press Start/Pause button to start the washing process. If the washing has to be paused, press the Start/Pause button.



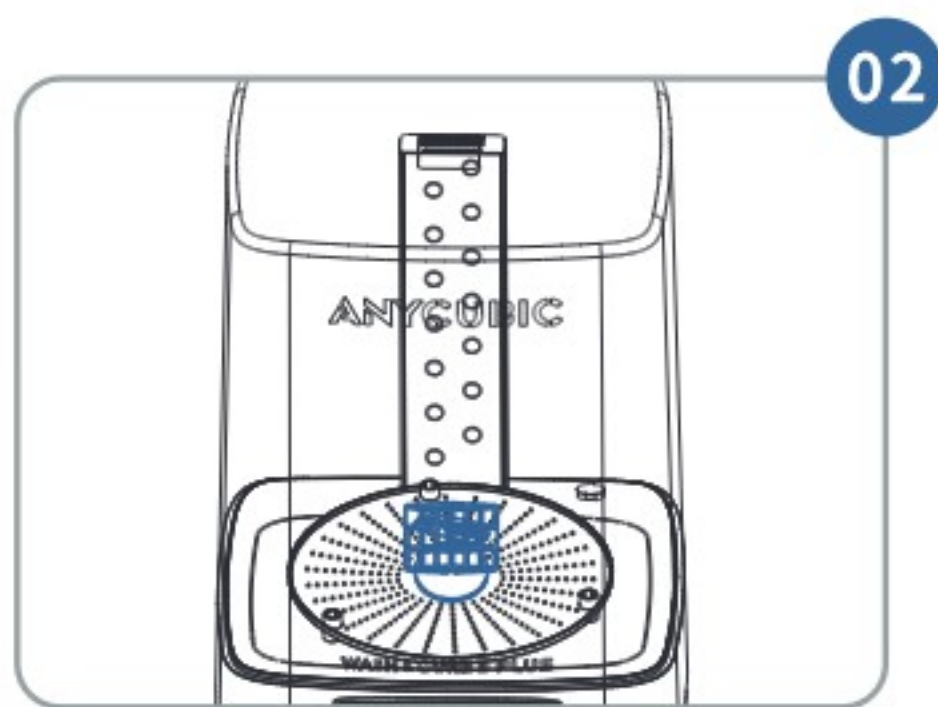
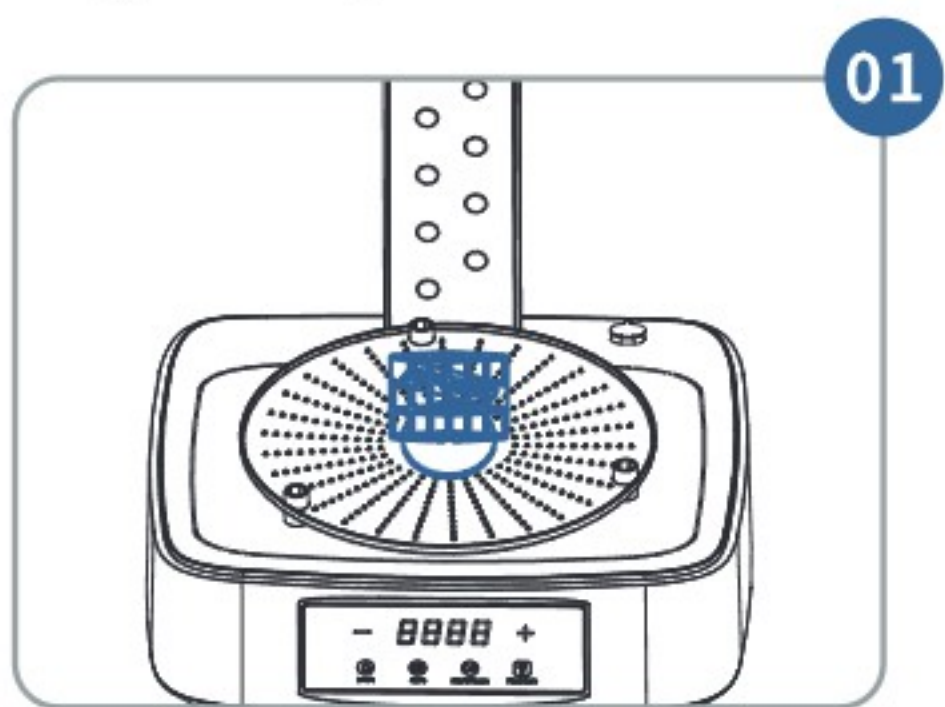
4. A beeping sound indicates the process is finished. Please air dry the objects before curing. After washing, please cover the lid and remove the washing bucket to avoid spilling the washing solvent.

Cure Mode

1. Place the printed objects.

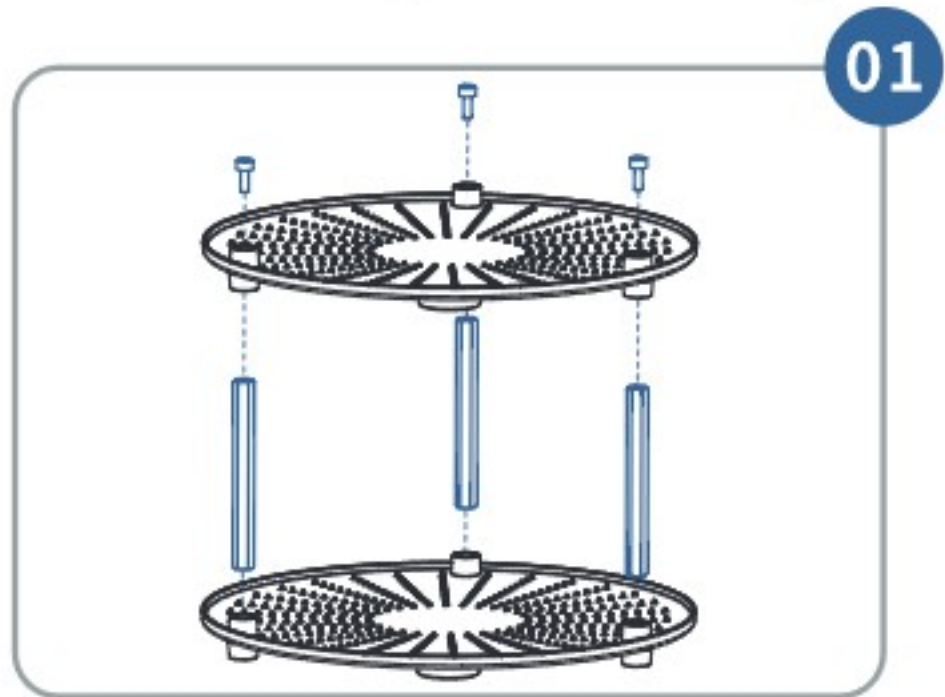
There are two cases to place, please choose according to the personal requirements.

① Single Layer

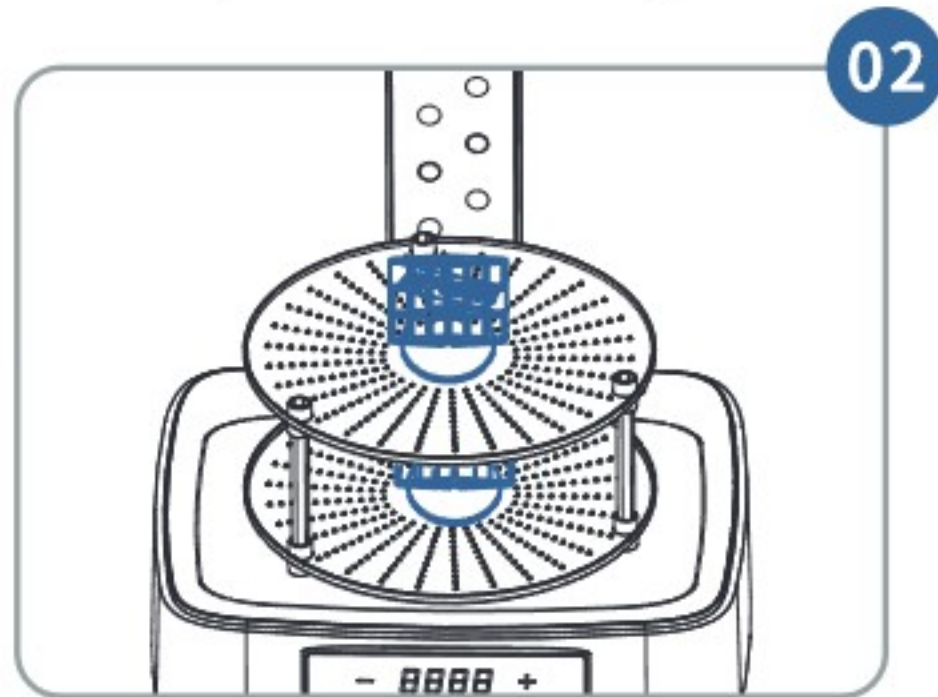


Put on the cover

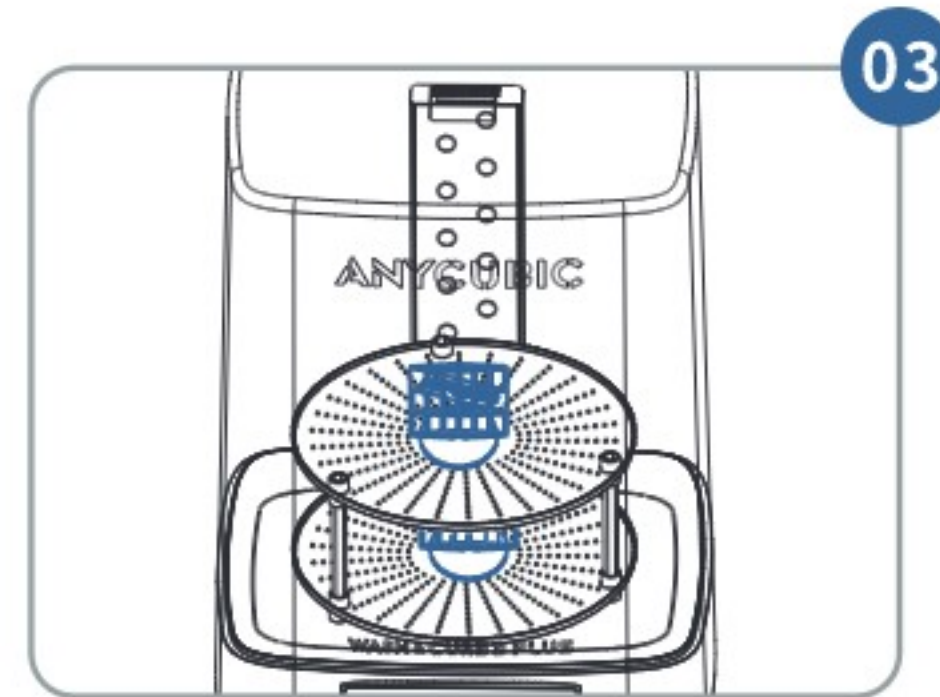
② Double Layers (height of the object on higher layer $\leq 100\text{mm}$ / on lower layer $\leq 80\text{mm}$)



Assembly the curing table

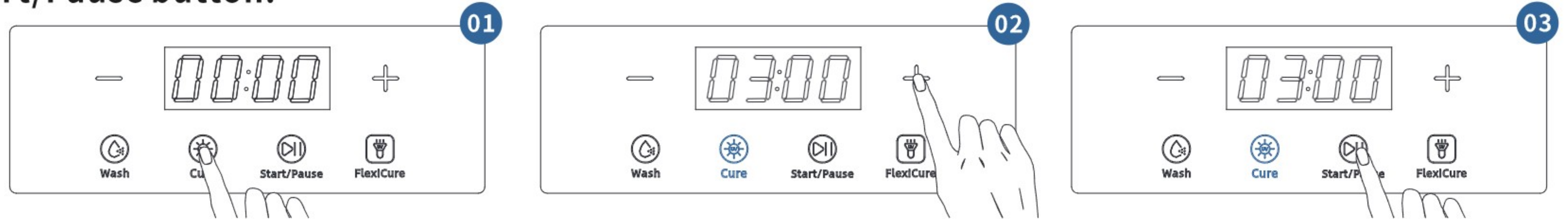


Place the models



Put on the cover

2. Press Cure button to select this mode. You can modify the curing time by pressing $+/-$ button. Then, press Start/Pause button to start the curing process. If the curing has to be paused, press the Start/Pause button.



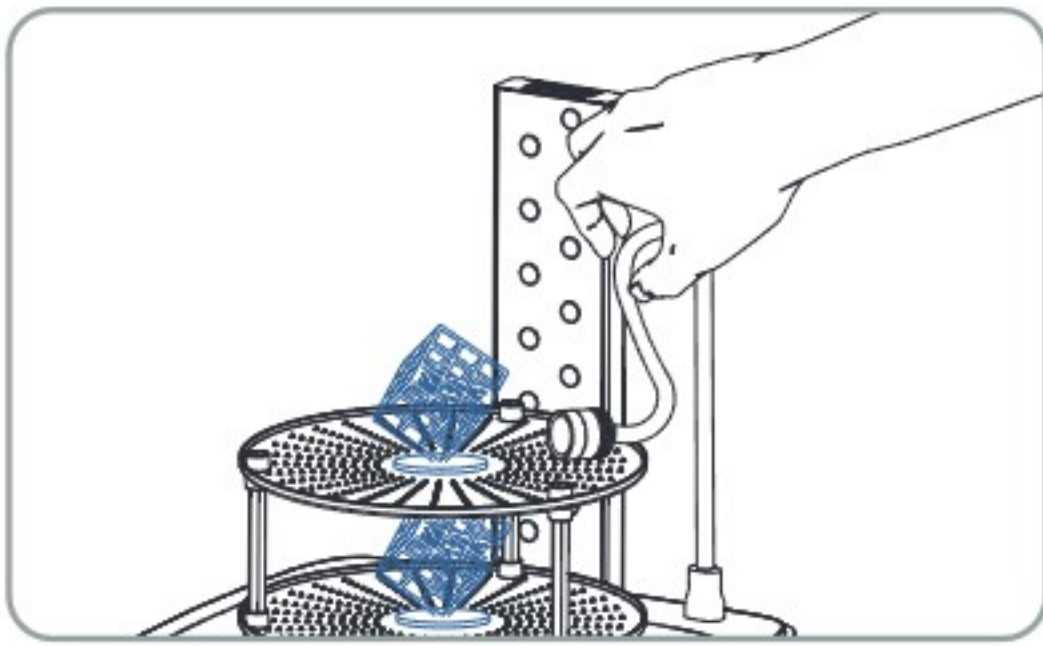
 The curing will pause if the cover is removed. Do not remove the cover in the curing process to ensure the curing effect.

3. A beeping sound indicates the process is finished. If the machine is not used at this time, please cut off the power. If it is continuously cured for a long time, the temperature of UV LED panel may be high. Do not touch the panel after curing.

Flexicure

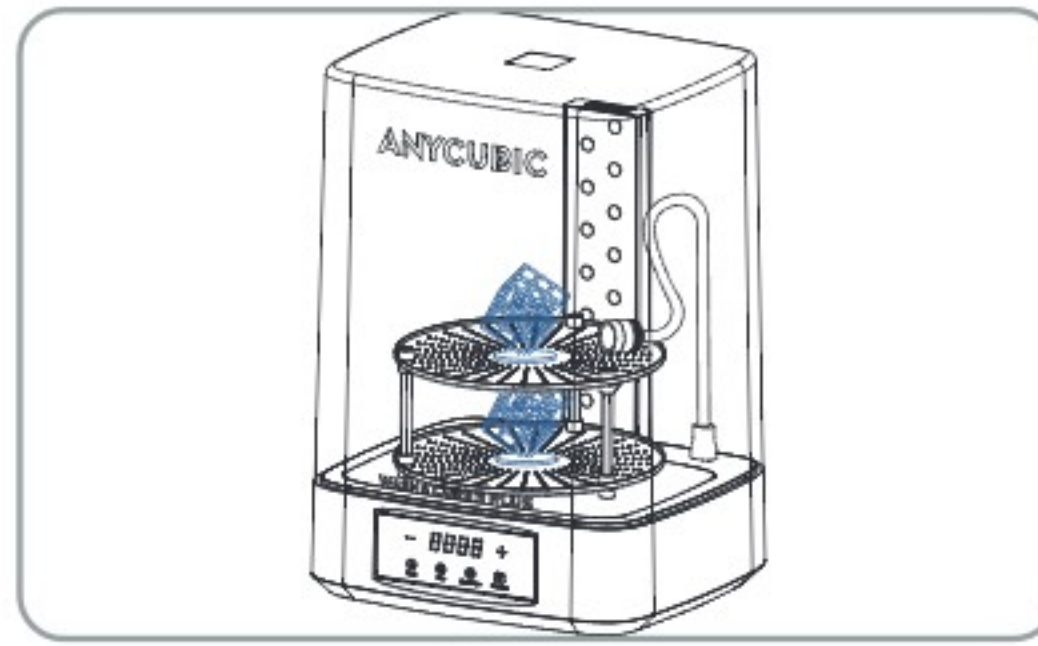
FlexiCure can be used singly to cure small printed objects or detail model details; it also helps to cure some dead corners. Insert the gooseneck light into the USB port before use it.

Supplementary curing: Adjust the gooseneck light to a proper position to cure where the LED panel cannot illuminate.



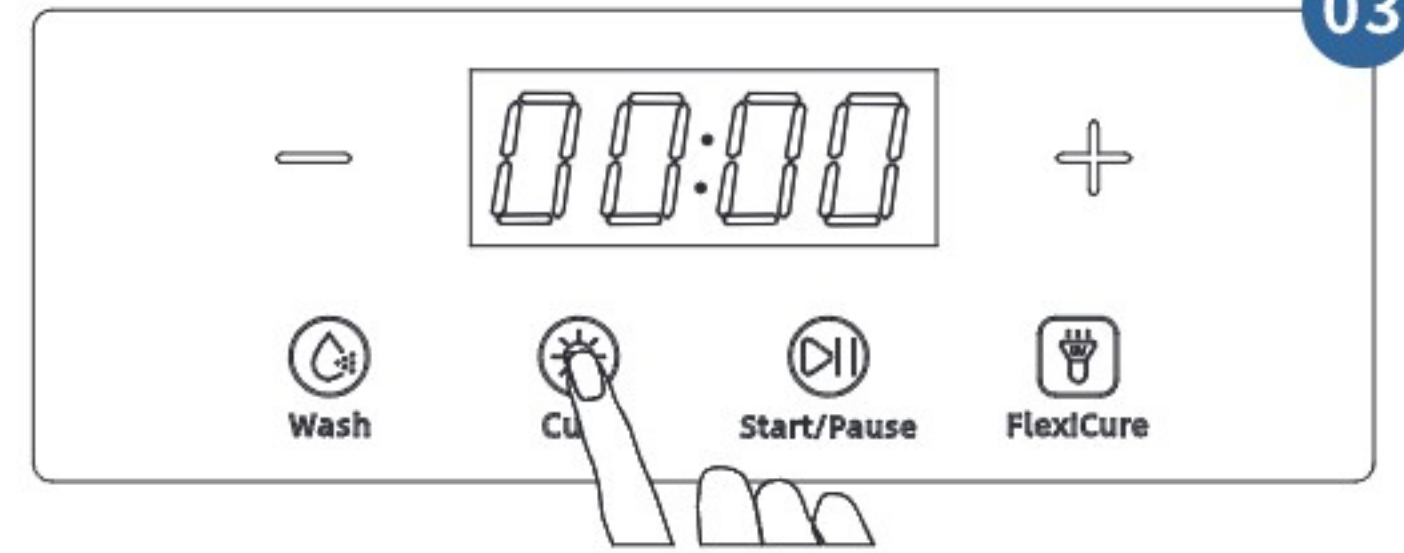
01

Adjust the position



02

Put on the cover



03

Select the cure mode



04

Set the time



05

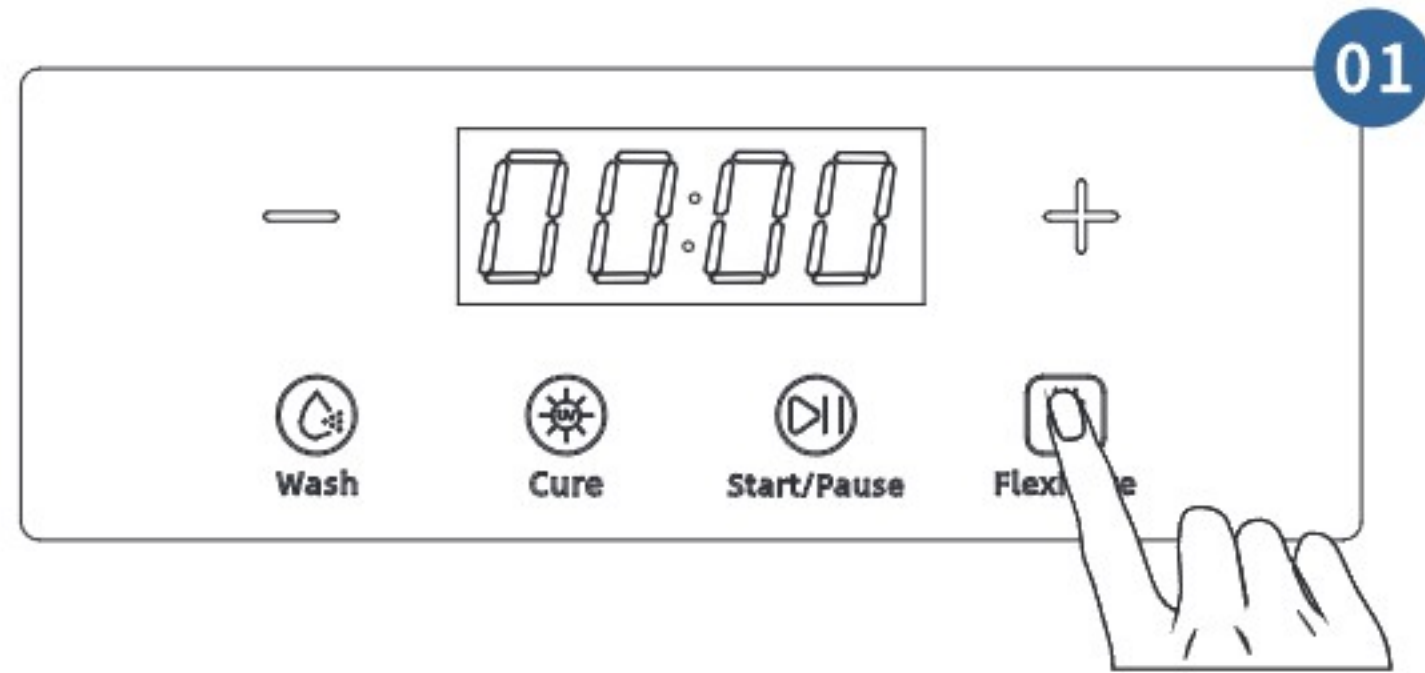
Start the curing



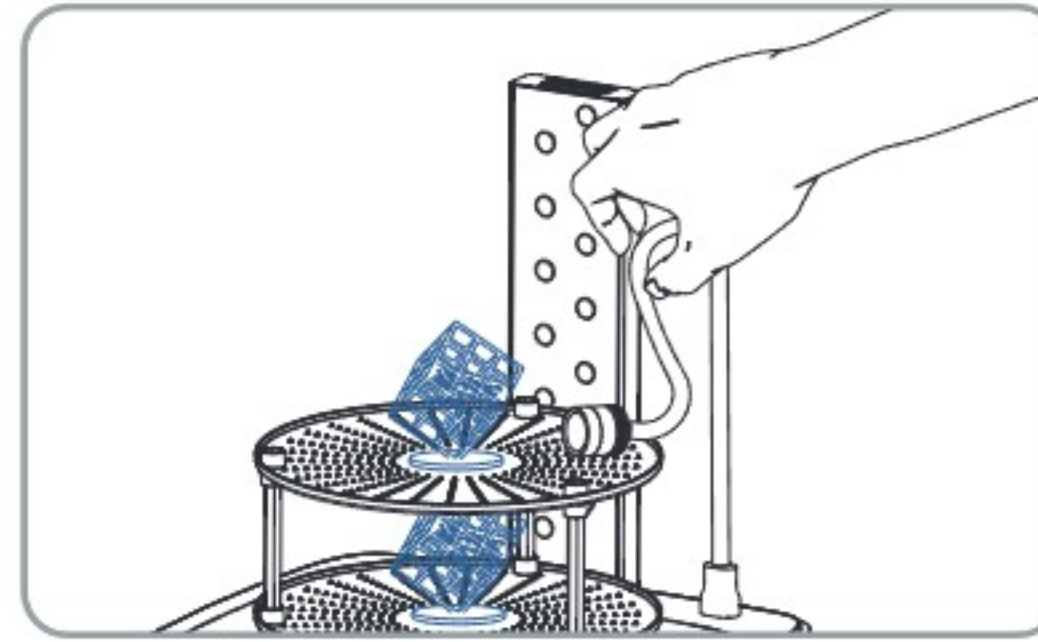
06

Click to turn on/off FlexiCure

Cure singly: Please wear the protective glasses to avoid the injury to eyes.



Click to turn on/off FlexiCure



Cure the objects manually



Notice: 1. FlexiCure cannot be enabled in wash mode.

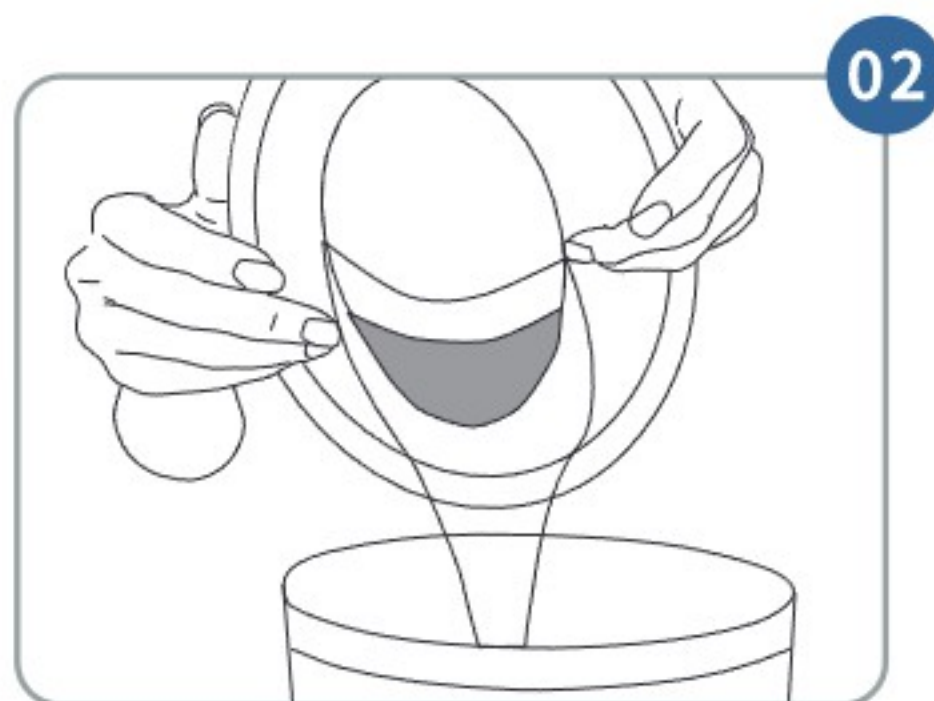
2. When the FlexiCure is used for 30 minutes, the protection mechanism of the machine will be triggered to turn it off.

05 Maintenance

Recycling of detergent

The solvent in the washing bucket might become muddy after long-time washing. The solvent can be recycled through the following treatment. It is recommended to dispose or replace the solvent after washing 30 models to ensure the washing effect.

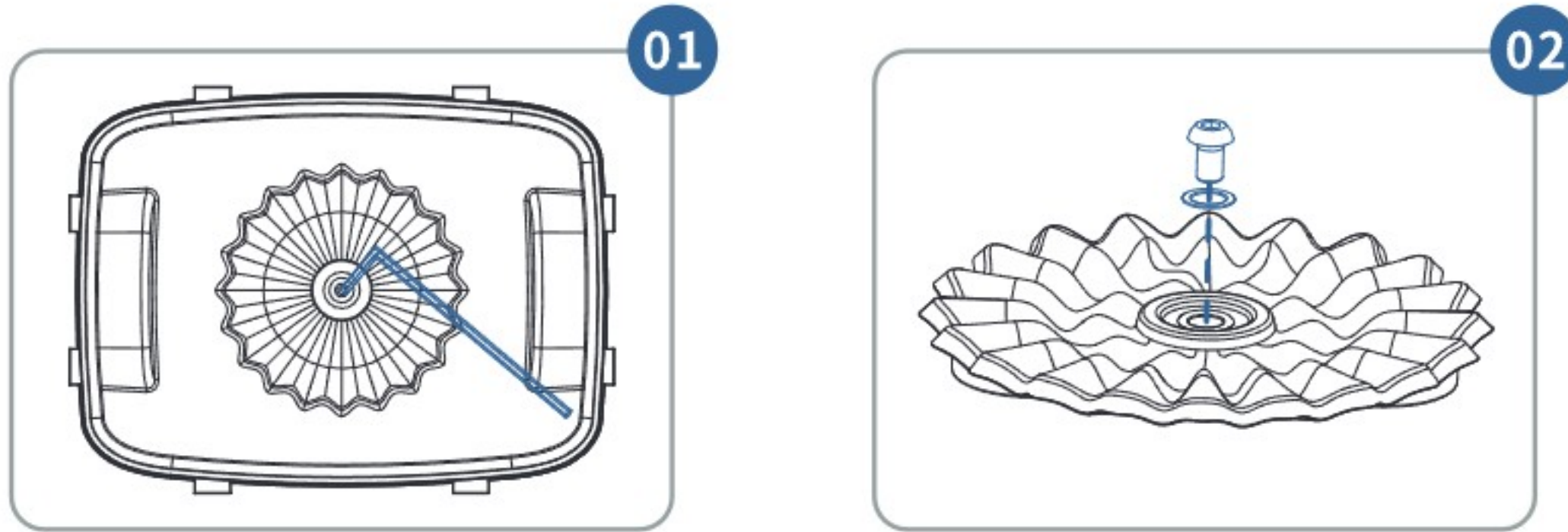
- 1. Allow the washing solvent stay still for over 10 hours so the residue could be precipitated and settled.**
- 2. Filter the top layer of solvent and pour it into another container. Then, seal the container.**
- 3. Expose the residue in the sunlight. Then, the cured resin can be handled as general solid waste.**



Clean the rotor

The rotor may rotate abnormally after long-term use, you can remove the rotor from washing bucket to clean it. Please take off the washing bucket from the base and drain the solvent before cleaning.

1. Remove the rotor from the bottom of bucket and then clean it.



2. Install the rotor to the bottom of the bucket.

06

Troubleshooting

1. The machine does not work.

- Poor power contact. Pull out the power cord and plug it in again.
- The anti-UV cover is removed in the curing process. Please put on the cover.

2. The rotor inside the washing bucket does not rotate during the washing process.

- The rotor is stuck by foreign matter. Stop washing, pour out the solvent and remove the foreign matter.
- There are too much precipitation in the washing solvent. Stop washing, drain the solvent and clean the precipitation.

3. The machine has abnormal sound during operation.

- The ground where the machine is placed is not flat enough.
- The screw on the rotor is loose. Tighten the screw.

4. Part of print objects are white after wash and cure.

- The printed objects are cured immediately after washing. Please air dry them before curing.
- The concentration of the alcohol which is used for washing is not high enough. Use alcohol with concentration exceeding 95%.

5. The mode lights are not lit when you touch the mode button.

- Try again or reboot the machine.



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