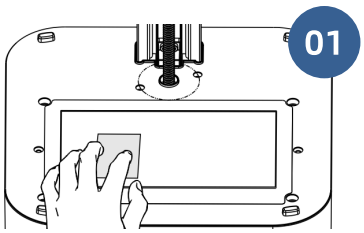
Preparations

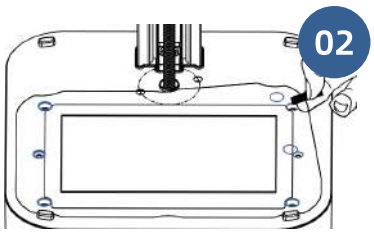
Please place the 3D printer on a stable, level workbench and operate it in an open, well ventilated area away from sunlight. Refrain from using the printer in areas with ultraviolet light sources(such as fluorescent lamps or UV disinfection lamps) to prevent poor printing results. For the first use, please follow the instruction to finish the preparations.

1. Unbox, take out the machine and its accessories, and inspect them.

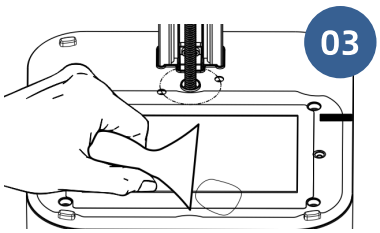
2. Install the screen protector.



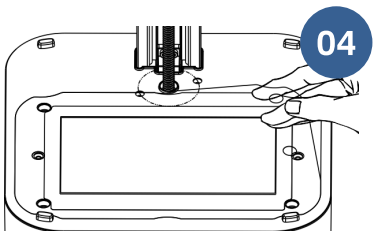
Peel off the protective film and clean the LCD screen



Peel off the film ①, then align with the locating holes to stick the screen protector

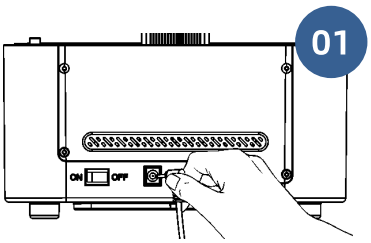


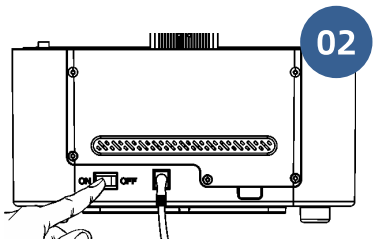
Squeeze out the air bubbles



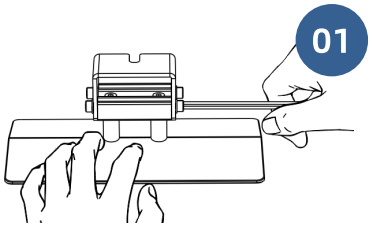
Peel off the film ②

3. Plug in power and turn on the machine.

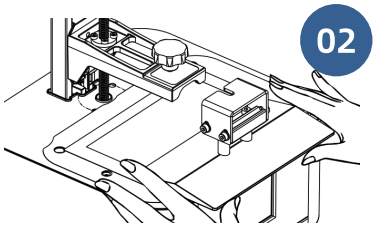




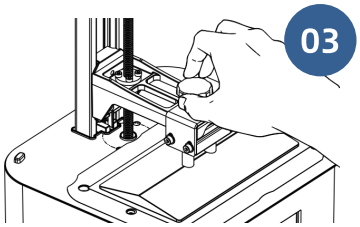
4. Install the print platform.



Loosen the four screws on the print platform

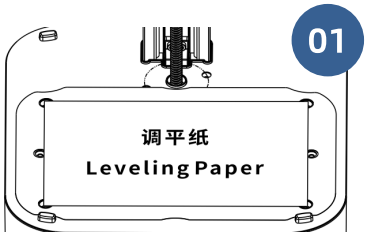


Push the platform onto the platform carrier

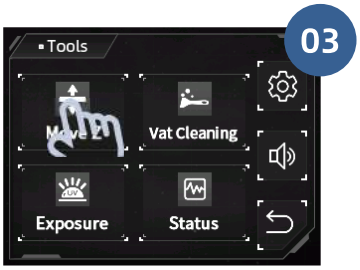


Tighten the knob

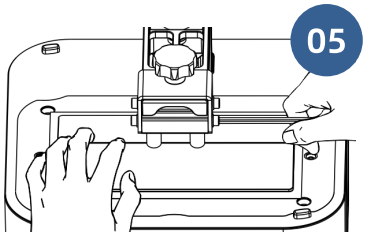
5. Leveling.



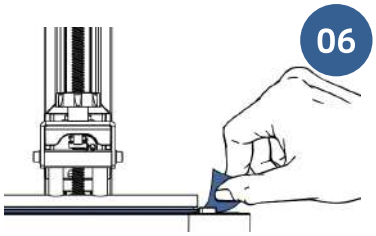
Place the leveling paper on the curing screen



Click “HOME”

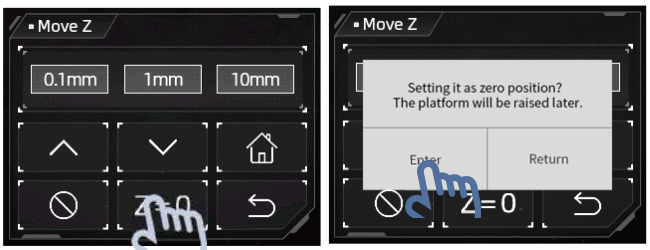


Press the platform gently, tighten the four screws

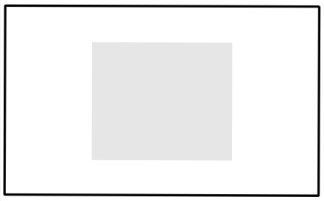


When pulling the leveling paper, there is a significant resistance or it cannot be pulled out

6. Set the zero position.

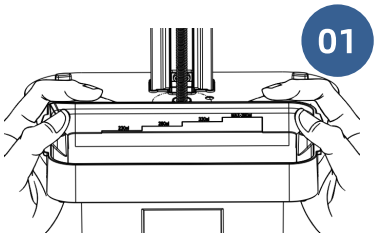


7. Choose an exposure image to test after the platform stops moving.

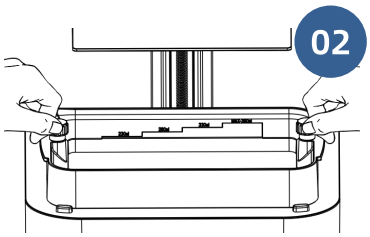


The white part is exposure area

8. Install the resin vat.



Put the resin vat with its feet stuck in locating holes

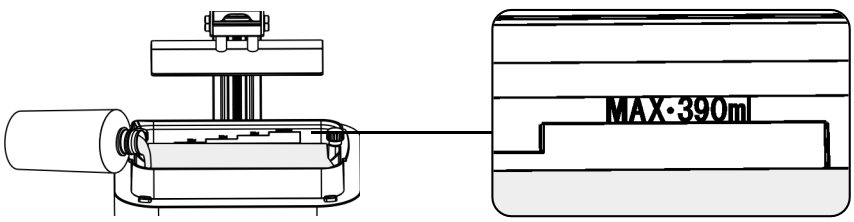


Tighten two knobs

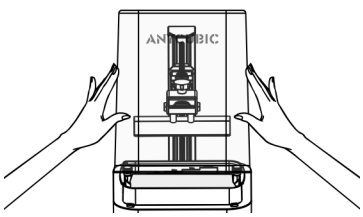
It is suggested to wear gloves and a mask for subsequent operations, as the contact with resin or the smell of the resin may cause your discomfort.

9. Please check the release film. If the film is broken, replace it immediately to avoid further damage to the machine.

10. Slowly pour the resin into the vat and make sure it is within the vat's maximum scale.

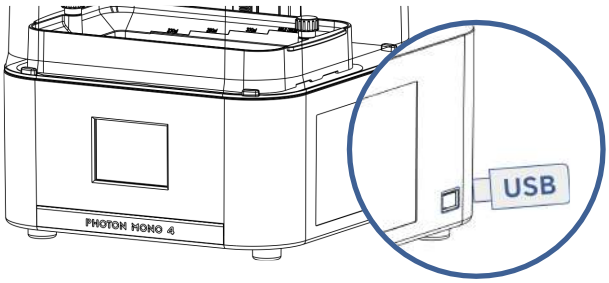


11. Put on the cover.

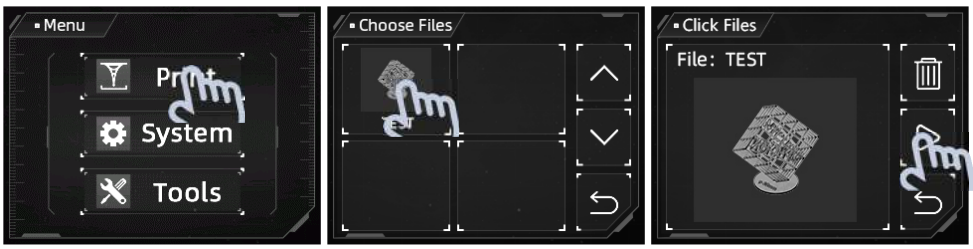


The included USB drive provides a slice file that can be used for printing test. The R_E_R_F file is to find out the optimal exposure parameters for different resins. For more details, please refer to “Resin Exposure Range Finder” chapter.

1. Insert the USB drive to the right USB port.



2. Then, choose a file to print.



Notes:

① It’s recommended that use the USB drive we provide. Otherwise, please use a USB drive whose memory size **does not exceed 32G** and ensure that it’s formatted to **FAT/FAT 32**.

② The print files should be placed at the root directory of USB drive to avoid read errors.

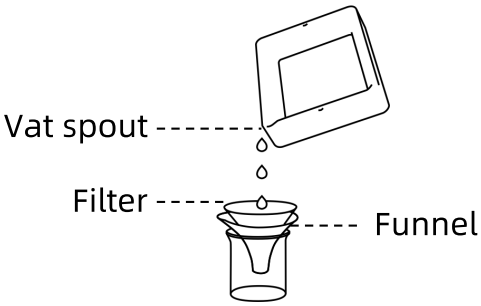
Resin Recycling

1. After printing, remove the platform when resin stop dropping from the platform. Remove the model by metal scraper and then wash it with 95% alcohol or other detergent. Then, dry and post-cure the model.

2. Please enable the vat cleaning function when the resin is partially cured to remove the residue. Otherwise, it may cause damage to the release film or LCD screen.

Remove resin sheet by plastic scraper

3. If there is any remaining resin, please pour it out through a vat spout and recycle it with a filter and a funnel. The model file of funnel is saved in the included USB drive, please print the model according to your personal requirements.

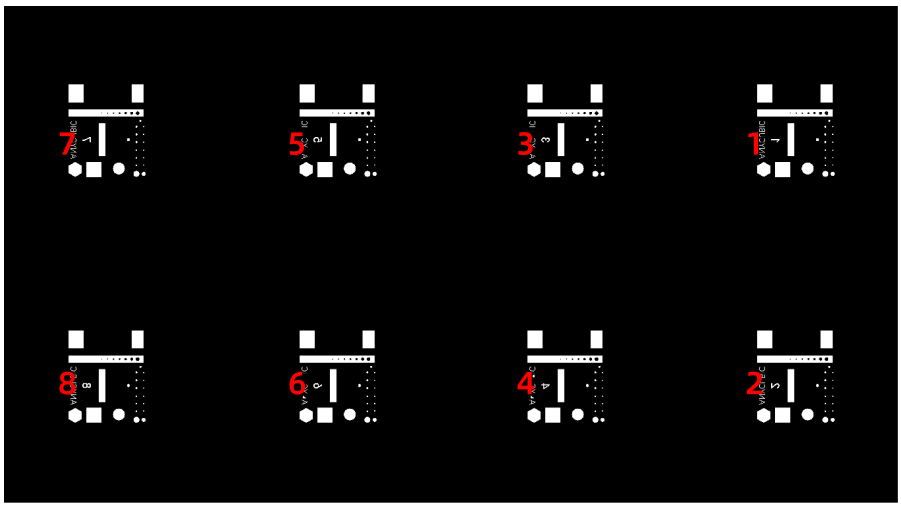


4. If you do not use the 3D printer for a long time, please clean the resin vat timely and store the resin in an airtight container away from light.

“R_E_R_F” is an abbreviation for “Resin Exposure Range Finder”. This function is used to find out the optimal exposure parameters for different resins.

1. Import the R_E_R_F file which is saved on USB drive into the slicing software. There are eight models in the file. The exposure time for model 1 is equal to "normal exposure time (s)" of the file, and the exposure time for other models will be increased by an increment of **0.25 s**.

For example:

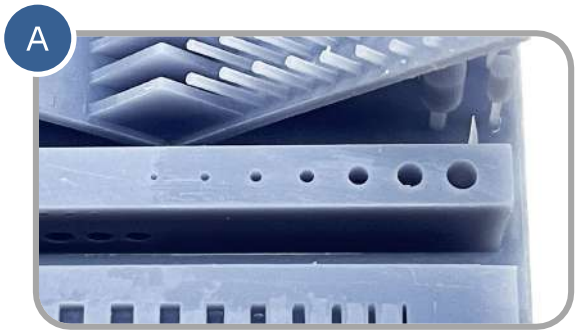


The numbers on the models indicate their order

2. According to the personal requirement, adjust the exposure time of the models by modifying "normal exposure time (s)“ of the file. When exposure time for Model No. 1 is changed, the exposure time for other models will be increased by an increment of **0.25 s.**

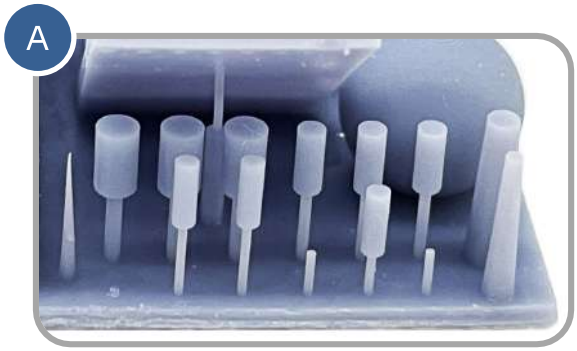
For example, when normal exposure time is set to 1.5 s, the exposure time for Model No.1-8 is: 1.5 / 1.75 / 2 / 2.25 / 2.5 / 2.75 / 3 / 3.25 s.

3. After printing, remove and clean the models. Compare the print effect of models and choose the model’s exposure time that meets your needs as the print parameter. Take a comparison of model A&B as an example.

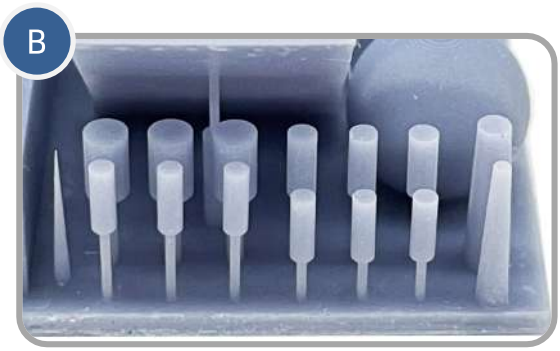


More holes

Less holes



Less cylinder



More cylinder

- Model A has more holes and fewer cylinder. If you print by the parameter of model A, more details of model can be printed with high risk of failure.
- Model B has fewer holes and more cylinder. If you print by the parameter of model B, model may be printed successfully yet with some details lost.

In addition, you can compare the bridges, needles or other parts to choose a proper model and find the parameter. If none of them can be chose, adjusting the "normal exposure time (s) " is suggested.

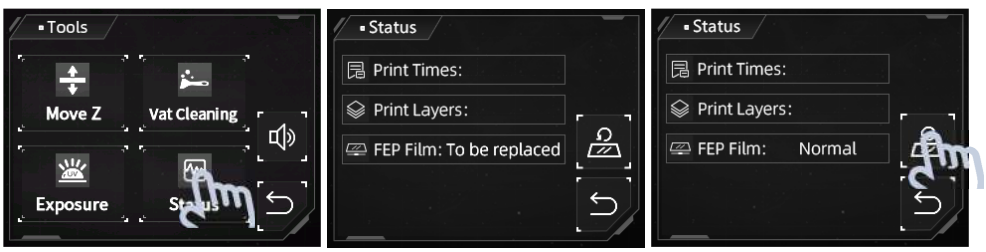
Notice: DO NOT change the file name of "R_E_R_F" , because Anycubic 3D printer can only recognize THIS file name to run this function. Also, do not name other file as "R_E_R_F" .

Resin vat maintenance

- **Remove the cured resin from release film:** Click Vat Cleaning and then remove the cured resin sheet to protect the film. Do not use sharp objects to scrape off the residues on the film.

Remove resin sheet by plastic scraper

- **Release film replacement:** The statistics of print times and print layers are shown in Status interface. Please check them and replace release film timely to avoid print failure or even the damage to printer.



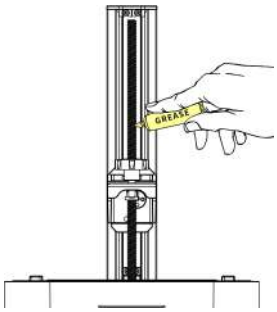
Replace release film at this time

Click reset button after replacement

- If you do not use the resin for over two days, store it in an airtight container away from light.
- If resin is stained on the resin vat, wipe it off timely.

Z axis maintenance

If Z axis makes a noisy sound, please apply lubricant to Z lead screw.



Cleaning

- **Clean the print platform:** Clean platform with alcohol and paper towel.
- **Protect LCD screen :** If the resin cured on screen protector, please replace it immediately to protect LCD screen.
- **Clean the body of printer:** Clean the body of the printer with alcohol.

FAQ

Complete the initial trouble shooting steps by referring to the following proposed solutions, or contact our technical support for additional assistance.

1. Model do not stick to platform

- Bottom exposure time is insufficient. Please increase the exposure time.
- Contact area between the model and platform is small. Please add a raft.
- Bad leveling.

2. Layer separation or splitting

- The machine is not stable during printing.
- The release film is not tight enough or needs a replacement.
- The printing platform or resin vat is not tightened.
- The lift speed is too fast.
- The model is hollowed without punching.

3. Layer shift

- Add supports.
- Reduce the lift speed.

4. Floccules left in resin vat or attached to models

- The exposure time is too long. Reduce the normal exposure time and bottom exposure time.

Thank you for purchasing Anycubic products! Under normal usage and service, the products have a warranty period of up to one year. Please visit Anycubic support center(support.anycubic.com/en) to report any issues with Anycubic products. Our professional after-sale service team would respond within 24 hours and solve the issues.