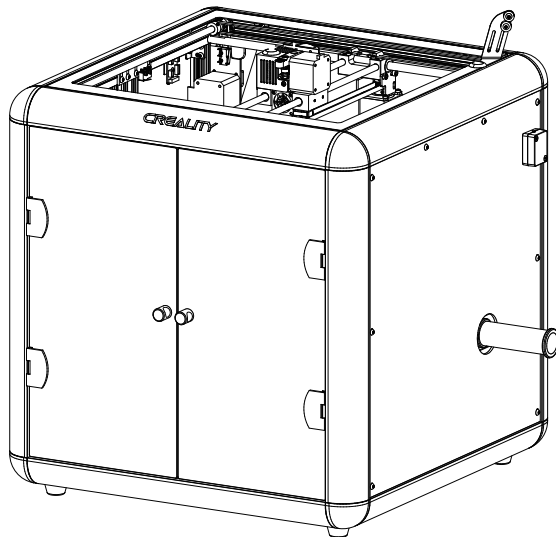


CREALITY

3D Printer User Manual

3D打印机使用说明书

Sermoon D1 DIY



V1.0

Content 目录

Dear Consumers,

Thank you for choosing our products. For the best experience, please read the instructions before operating the Printer. Our teams will always be ready to render you the best services. Please contact us by phone number or e-mail address provided at the end when you encounter any problem with the Printer.

For a better experience in using our product, you can also learn how to use the Printer in the following ways:

View the accompanied instructions and videos in the storage card.

Visit our official website www.creality.com to find relevant software/hardware information, contact details and operation and maintenance instructions.

尊敬的创想三维用户：

感谢您选择、使用创想三维的产品。为了您使用方便，请您在使用之前仔细阅读该说明书，并严格按照说明书的指示进行操作。

创想三维团队时刻准备为您提供优质的服务。在使用过程中无论遇到什么问题，请按照说明书结尾所提供的电话、邮箱与我们联系。

为了您能够更好地体验我们的产品，您还可以从以下方式获取设备操作知识：

随机使用说明：你可以在存储卡内找到相关使用说明及视频。

创想三维官网：www.cxsw3d.com（您可以登陆创想三维官网寻找相关软硬件、联系方式、设备操作、设备保养等信息）。

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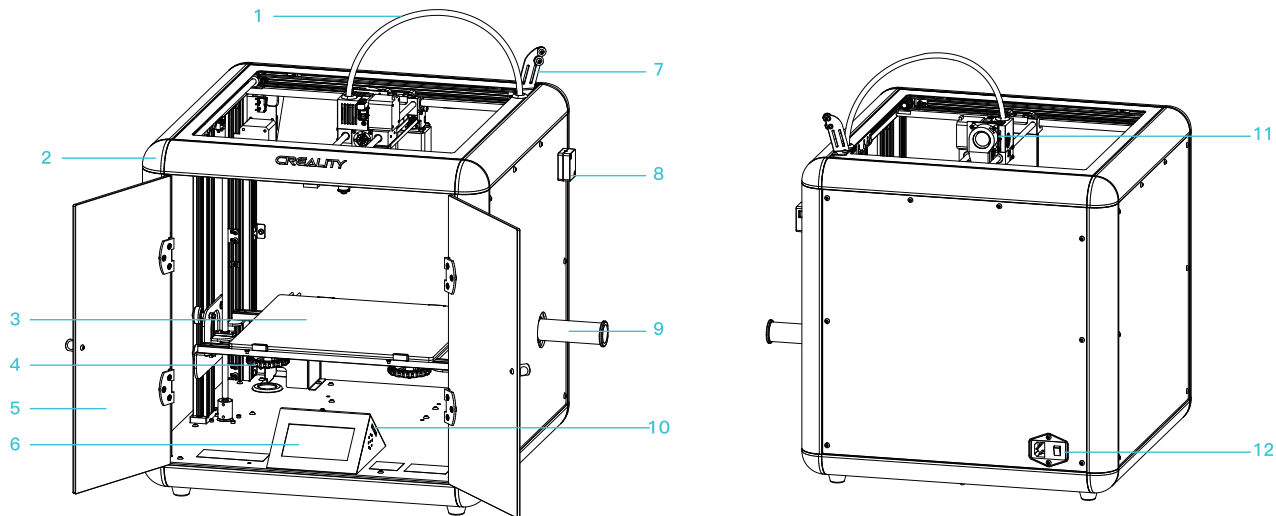
NOTES 使用须知

1. Do not use the printer any way other than described herein in order to avoid personal injury or property damage.
2. Do not place the printer near any heat source or flammable or explosive objects. We suggest placing it in a well-ventilated, low-dust environment.
3. Do not expose the printer to violent vibration or any unstable environment, as this may cause poor print quality.
4. Before using experimental or exotic filaments, we suggest using standard filaments such as ABS or PLA to calibrate and test the machine.
5. Do not use any other power cable except the one supplied. Always use a grounded three-prong power outlet.
6. Do not touch the nozzle or printing surface during operation as they may be hot. Keep hands away from machine while in use to avoid burns or personal injury.
7. Do not wear gloves or loose clothing when operating the printer. Such cloths may become tangled in the printers moving parts leading to burns, possible bodily injury, or printer damage.
8. When cleaning debris from the printer hotend, always use the provided tools. Do not touch the nozzle directly when heated. This can cause personal injury.
9. Clean the printer frequently. Always turn the power off when cleaning, and wipe with a dry cloth to remove dust, adhered printing plastics or any other material off the frame, guide rails, or wheels. Use glass cleaner or isopropyl alcohol to clean the print surface before every print for consistent results.
10. Children under 10 years of age should not use the printer without supervision.
11. This machine is equipped with a security protection mechanism. Do not manually move the nozzle and printing platform mechanism manually while booting up, otherwise the device will automatically power off for safety.
12. Users shall comply with related nation and region' s laws, regulations and ethical codes where the equipment or produced prints by it is used, and users of our product shall not use aforesaid products to print any end-use products, objects, parts or components or any other physical prints that violate the national or regional laws, regulations and ethical codes where herein referred product and produced prints by it is located.

- 1、请勿尝试任何使用说明中没有描述的方法来使用本机，避免造成的意外人身伤害和财产损失；
- 2、请勿将本机放置在易燃易爆物品或高热源附近，请将本机放置在通风、阴凉、少尘的环境内；
- 3、请勿将打印机放置在振动较大或者其他不稳定的环境内，机器晃动会影响打印机打印质量；
- 4、建议使用厂家推荐耗材，以免造成挤出头堵塞和机器损坏；
- 5、请勿在安装过程中使用其他产品电源线代替，请使用本机附带的电源线，电源插头需接插在带有地线的三孔插座；
- 6、请勿在打印机工作时接触喷嘴以及热床，以防止出现高温烫伤，造成人身伤害；
- 7、请勿在操作机器时佩戴手套或缠绕物，以防可动部件对人身部件造成卷入挤压和切割伤害；
- 8、在打印完毕后及时利用喷头的余温借助工具将喷头上的耗材清理干净，清理时请勿直接用手触摸喷头，以防出现烫伤；
- 9、常做产品维护，定期在断电的情况下，用干布对打印机做机身清洁，拭去灰尘和粘结的打印材料、导轨上的异物；
- 10、年龄在10岁以下的儿童，请勿在没有人员监督的情况下使用本机，以免造成人身伤害；
- 11、本机设有安全保护机制，请勿在开机状态下手动快速移动喷头及打印平台机构，否则设备会自动断电关机保护；
- 12、使用者应遵守设备打印产品与设备所在地及相应国家及地区法律、法规，恪守职业道德，严禁使用我司产品打印有违设备打印产品与设备所在地及相应国家、地区法律禁止的任何产品或物件。

Equipment Introduction

设备简介



1 Corrugated pipe 波纹管

2 Profile cover 型材盖

3 Printing platform 打印平台

4 Leveling nut 调平螺母

5 Front door 前门

6 Display screen 显示屏

7 Filament guide support 耗材导向支架

8 Filament detecting kit 断料检测组件

9 Spool holder 料架及料管筒

10 Storage card slot 存储卡卡槽

11 Nozzle kit 喷头套件

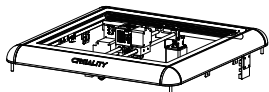
12 Power supply 电源

Equipment Parameters

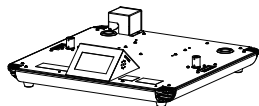
设备参数

Basic Parameters 基本参数	
Model 型号	Sermoon D1
Printing Size 成型尺寸	280*260*310mm
Molding Tech 成型技术	FDM
Nozzle Number 喷头数量	1
Slice Thickness 切片层厚	0.1mm-0.4mm
Nozzle Diameter 喷嘴直径	Standard 0.4mm 标配0.4mm
Precision 打印精度	±0.1mm
Filament 打印材料	PLA
File Format 切片支持格式	STL/OBJ/AMF
File Transfer 打印方式	USB/Storage card 联机或存储卡脱机
Slice Software 可兼容切片软件	Creativity Slicer/Cura/Repetier-Host/Simplify3D
Rated Voltage 额定电压	Input 输入:AC100-240V 50/60Hz Output 输出:DC 24V
Total Power 额定功率	350W
Bed Temp 热床最高温度	≤100°C
Nozzle Temp 喷嘴最高温度	≤260°C
Resume Print 断电续打	Yes 有
Dual Z-Axis 双Z轴	Yes 有
Language 语言	Chinese/English 中/英
Operating System 电脑操作系统	Windows XP/Vista//7/8/10 MAC/Linux
Printing Speed 打印速度	≤180mm/s,Normal 正常为 30-60mm/s

Parts List 零部件清单



1 Top frame | 顶部框架 x 1



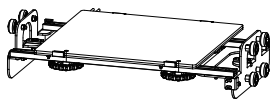
2 Base frame | 底座 x 1



3 Tool box | 工具包 x 1



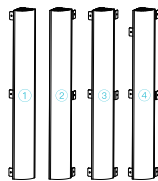
4 Filament | 耗材 x 1



5 Printing platform x 1
打印平台



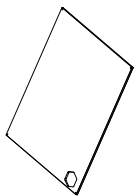
6 T-type screw rod | T型丝杆 x 2



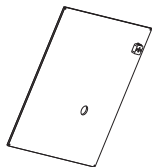
7 Profile | 型材 x 4



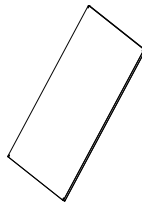
8 2040 profile | 2040型材 x 2



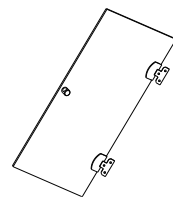
9 Back baffle x 1
背面挡板



10 Right baffle x 1
右挡板



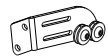
11 Left baffle x 1
左挡板



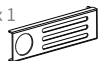
12 Front door x 2
前门

Tips: The above accessories are for reference only, please refer to the physical accessories! 注意: 以上配件仅供参考, 请以实物为准!

Tool List 工具包清单



13 Filament guide support x 1
耗材导向支架



14 Rack x 1
料架



15 Spool & Nuts x 1
料管及料管螺母



16 Hex keys, Wrench x 1
& Screwdriver
扳手和螺丝刀



17 Cable ties x12
扎带



18 Spade x 1
铲刀



19 Nozzle cleaner x 1
通针



20 Open-ended wrench x 1
22号开口扳手



21 Storage card & Card
reader x 1
存储卡和读卡器



22 Diagonal pliers x 1
剪钳



23 Power cable x 1
电源线



24 Spare nozzle x 1
备用喷嘴部件



25 Grease x 1
润滑脂



26 M6 socket spanner x 1
M6套筒扳手



27 M6*35 hexagon flat round
head screw x 8
M6*35内六角平圆头螺丝



28 M4*8 hexagon flat round
head screw x 24
M4*8内六角平圆头螺丝



29 M4*14 Hexagon round head
screws x4
M4*14内六角圆柱头螺丝



30 M4*8 Socket cap
screw x 8
M4*8内六角沉头螺丝



31 M6 Flat washers x8
M6平垫



32 M4*6 hexagon flat round
head screw x 2
M4*6内六角平圆头螺丝



33 M4*14 Hexagon flag
round head screws x4
M4*14内六角平圆头
螺丝



34 M5*8 hexagon flat round
head screw x 2
M5*8内六角平圆头螺钉



35 Profile cover x 8
型材盖



36 Consumable conduit x1
耗材导管



37 PTFE Tubing(Spare Part)
x 1 铁氟龙管(备品)



38 Crepe Paper x 1
美纹纸

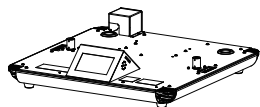
Tips: The above accessories are for reference only, please refer to the physical accessories! 注意: 以上配件仅供参考, 请以实物为准!

1

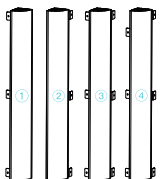
Install Profile 安装型材

Take out the components for the bottom, take apart the frame lid and then install the four section bars. Install based on the position of the digital tag and the direction of the arrow, use a No. 3 wrench to tighten the M6*35 hexagon socket head screws and M6 flat washers from the base to fix the four profiles.

取出底部组件，安装四根型材。按照型材数字标签位置和箭头方向安装，用3号扳手将M6*35内六角平圆头螺丝加上M6平垫从底座向上拧紧，固定四根型材。



2 Base frame | 底座 x 1



7 Profile | 型材 x 4



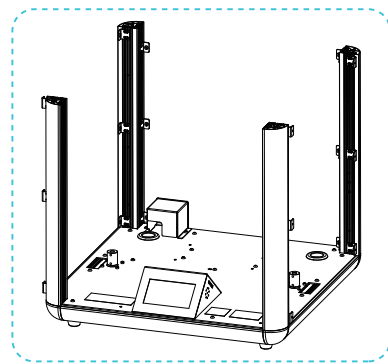
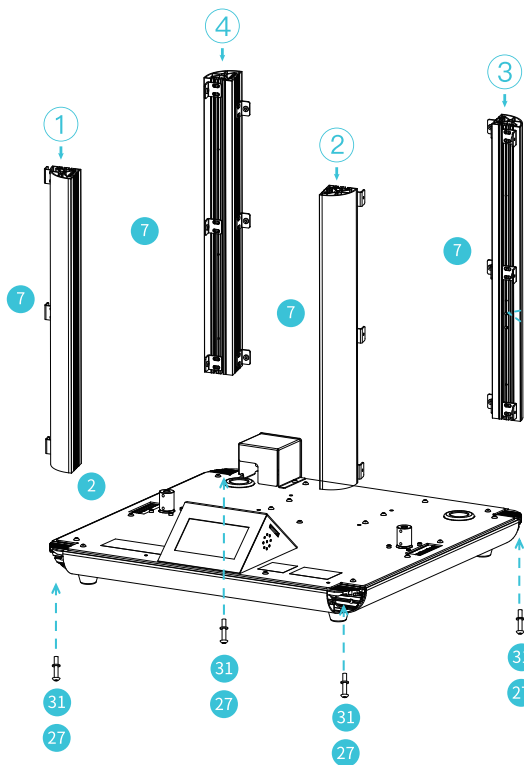
16 Allen wrench x 1
内六角扳手



27 M6*35 hexagon flat round head screw x 4
M6*35内六角平圆头螺丝



31 M6 Flat washers x 4
M6平垫



Please pay attention to distinguish four kinds of profiles:
Profile 1: 3 fixed plates installed on the left;
Profile 2: 3 fixed plates installed on the right;
Profile 3: 3 fixed plates installed on the left and right respectively (symmetric);
Profile 4: 3 fixed plates installed on the left and right respectively (asymmetric);

请注意区分四种型材：

型材1：左侧安装了3个固定板
型材2：右侧安装了3个固定板
型材3：左右两侧6个固定板（对称）
型材4：左右两侧6个固定板（不对称）

2

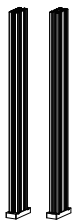
Install 2040 Profile 安装2040型材

Install the 2040 profile with four M4*14 hexagon socket head cap screws are used to;
用4颗M4*14内六角圆柱头螺丝锁紧2040型材;



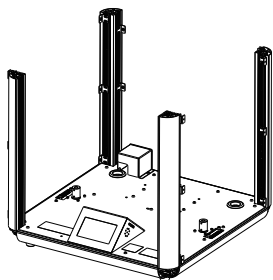
29

M4*14 Hexagon round head screws x4
M4*14内六角圆柱头螺丝

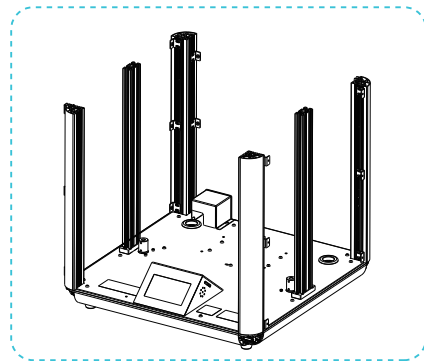
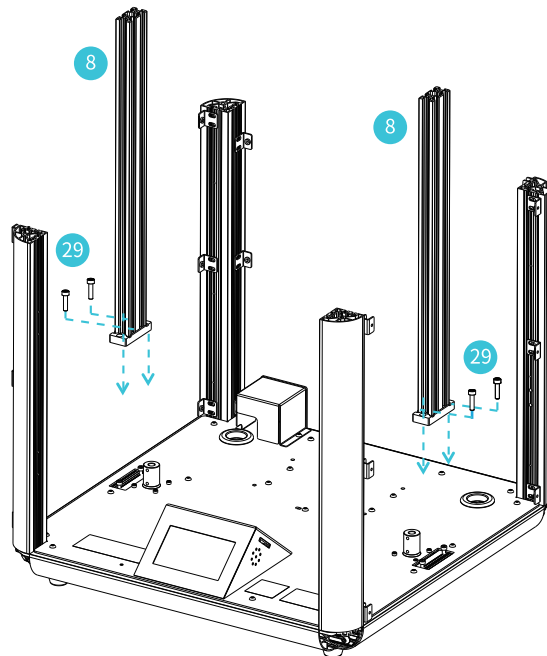


8

2040 profile | 2040型材 x 2



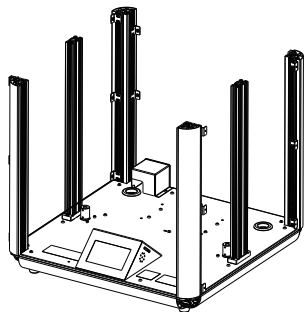
Take the first step 承接第一步组件



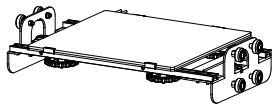
3

Install the Printing Platform 安装打印平台组件

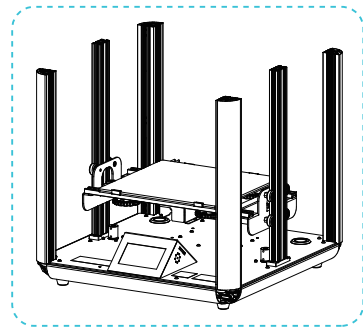
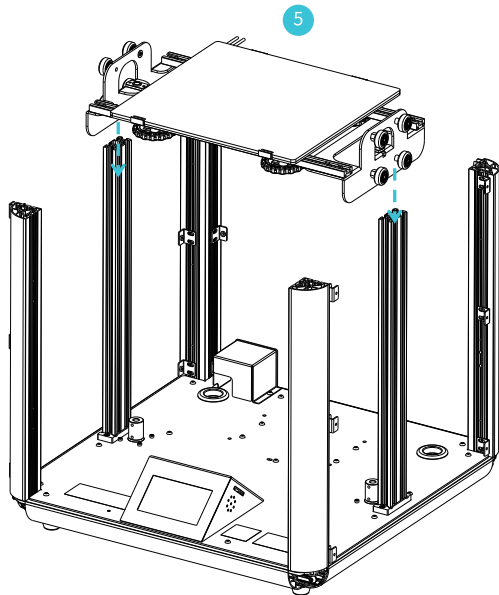
Insert the printing platform into the component installed in the second step;
将打印平台插进第二步装好的组件；



Take the second step 承接第二步组件



5 Printing platform | 打印平台 x 1



After installation, please check the tightness between v-wheel and profile to avoid idling of v-wheel.

装好后请检查V轮与型材的松紧度，避免出现V轮空转情况。

4

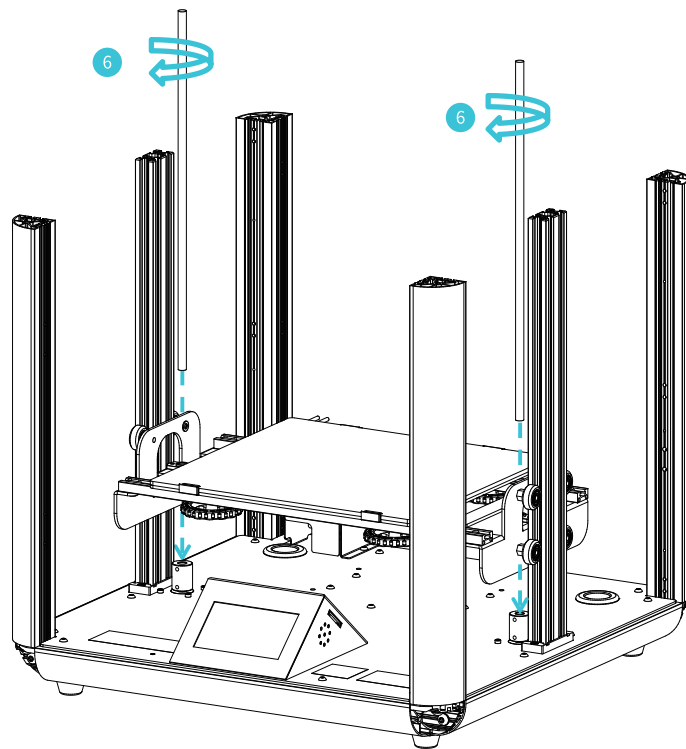
Install the T-type Screw Rod 安装T型丝杆

Install the T-type screw rod and tighten the screw between the T-type screw rod and coupling.

安装两边中间T型丝杆，将T型丝杆与联轴器处的螺丝拧紧。



6 T-type screw rod | T型丝杆 x 2

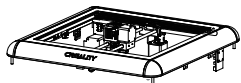


5

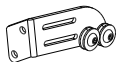
Install the Top Frame and Filament Guide Support 安装顶部框架和耗材导向支架

1. Install the filament guide support with M4*6 screws as shown in this figure; 2. Install and orientate the top frame, Using M6*35 screws and M6 flat gaskets to orientate the four profiles and top frame; 3. Use the M4*14 flat round head screw to lock the 2 profiles on left and right according to the circle icon position.

1. 安装耗材导向支架，用M4*6螺丝按图示位置安装好；2. 安装和定位顶部框架，用M6*35螺丝和M6平垫定位4根型材与顶部框架；3. 再用M4*14平圆头螺丝按圆形图示位置锁紧左右两根型材。



1 Top frame | 顶部框架 x 1



13 Filament guide support x 1
耗材导向支架



27 M6*35 hexagon flat round head screw x 4
M6*35内六角平圆头螺丝



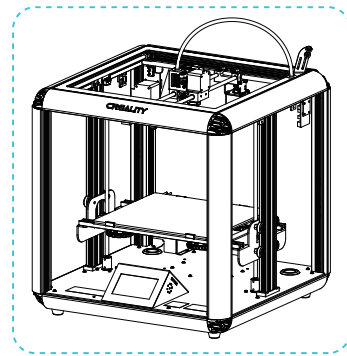
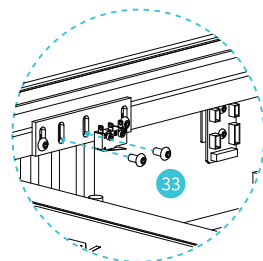
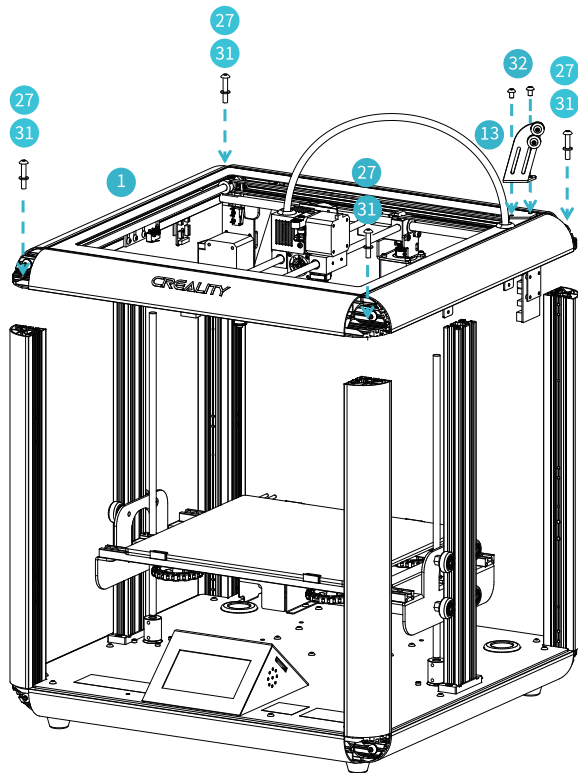
31 M6 Flat washers x 4
M6平垫x4



33 M4*14 hexagon flat round head screw x 4
M4*14内六角平圆头螺丝



32 M4*6 hexagon flat round head screw x 2
M4*6内六角平圆头螺丝

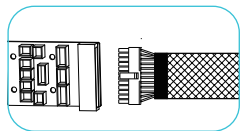


6

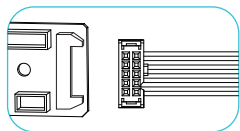
Wire Connection 设备接线

Connect all wires by color and marking(as shown in the figure)

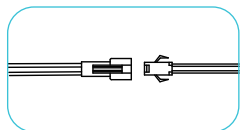
将所有线束按颜色、线标连接好 (如图所示)



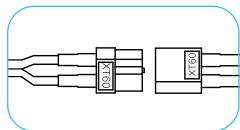
24PIN x 1



10PIN x 1



SM-2P x 1



XT60 x 1



Caution

Select the correct input voltage to match your local mains (AC100-240V)

Damage can occur if voltage is set incorrectly.

选择正确的输入电压以匹配您的本地电源 (AC100-240V)
如果电压设置不正确, 可能会造成损坏。



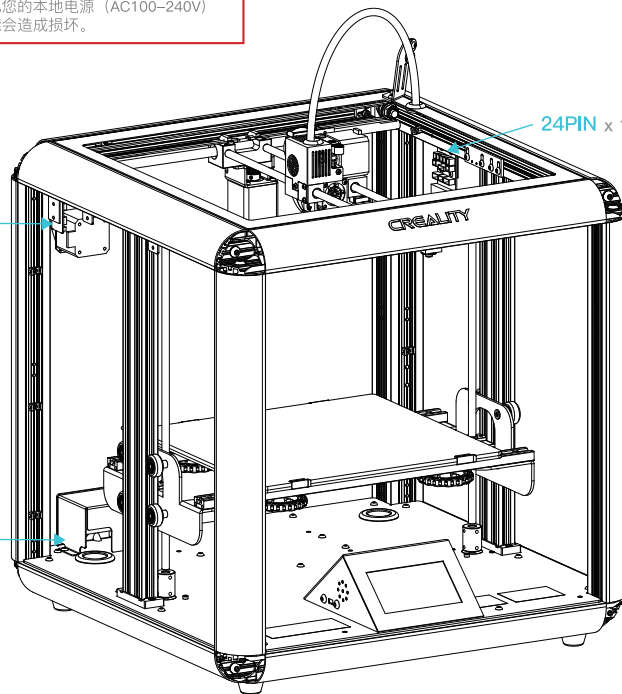
Do not connect or disconnect the cables when the machine is powered on.

当机器通电时, 请勿连接或断开连接线。

10PIN x 1

24PIN x 1

SM-2P x 1
XT60 x 1



7

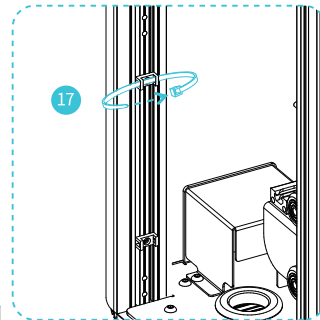
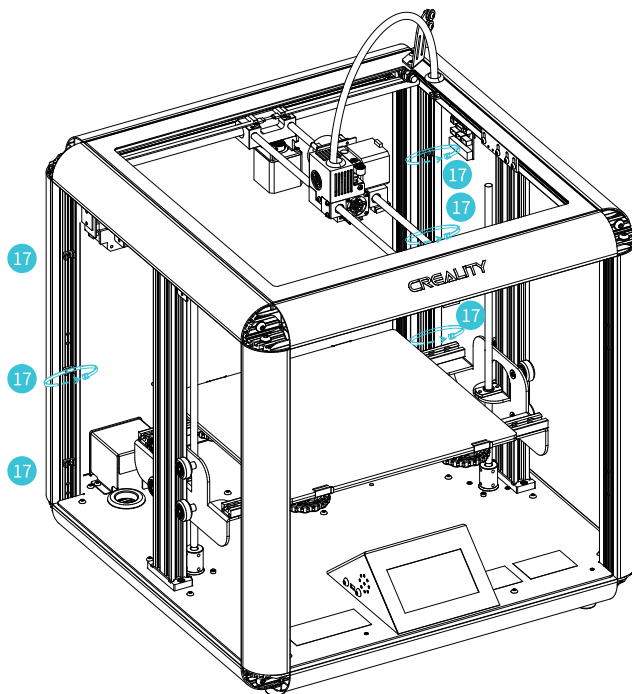
Arrange the Wiring Harness 整理线束

According to the real demand, tie the wire harness well with ribbon (as shown in the picture).

根据实际需求，将线束用扎带扎好（如图所示）。



17 Cable ties x 6
扎带



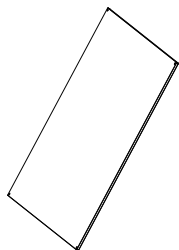
8

Install the Left Daffle

安装左挡板



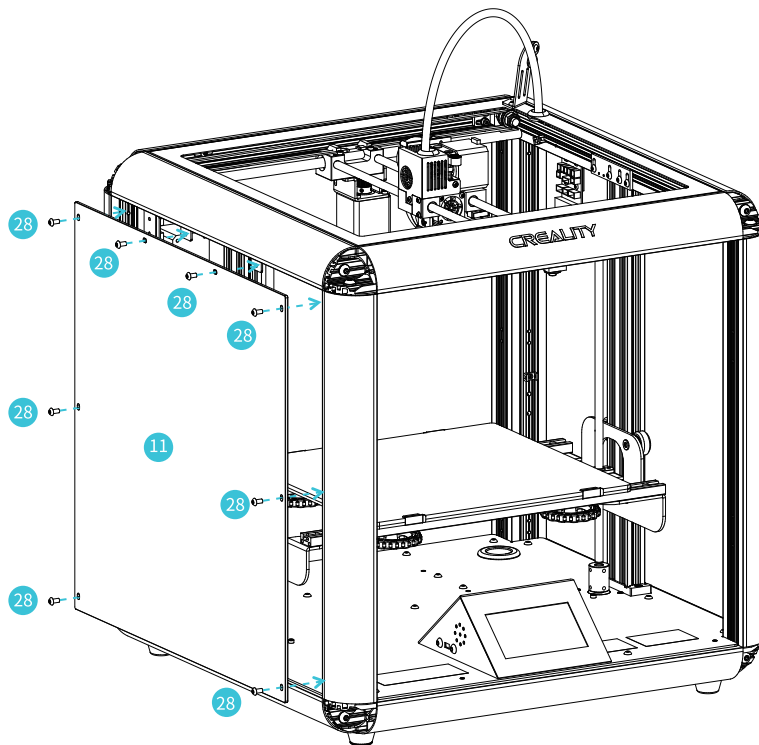
Before installing, remove the protective film on the door.
安装前, 请撕掉门板两面的保护膜。



11 Left baffle x 1
左挡板



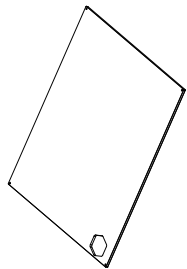
28 M4*8 hexagon flat round head screw x 8
M4*8内六角平圆头螺丝



9

Install the Back Baffle

安装背面门板



9 Back baffle x 1
背面挡板

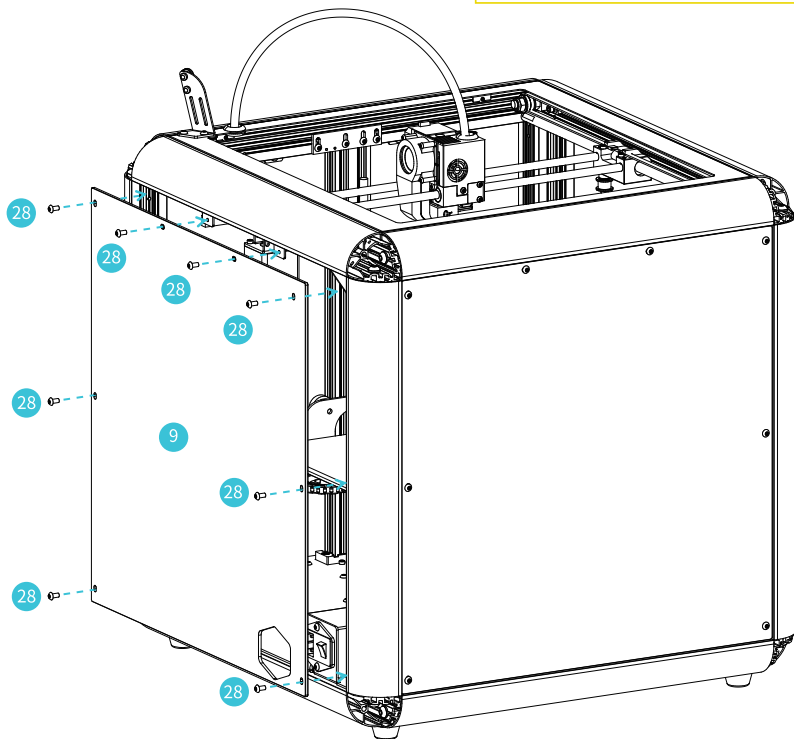


28 M4*8 hexagon flat round
head screw x 8
M4*8 内六角平圆头螺丝



Before installing, remove the protective
film on the door.

安装前, 请撕掉门板两面的保护膜。

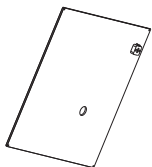


10

Install the Right Baffle and Filament Tube 安装料管、右挡板

1. Before installing the right dam-board, use 2 M5*8 screws to fix the rack on the right rear profiles and take the barrel through the rack, tighten the screw to fix the barrel; 2. As shown in this figure, lock tight 8 M4*8 screws and install the dam-board on the right.

- 1、安装右挡板前，请先用2颗M5*8螺丝固定料架在右后方型材柱上，再把料管穿过料架，拧紧螺母，固定料管；
- 2、如图所示，锁紧8颗M4*8螺丝安装好右挡板。



10 Right baffle x 1
右挡板



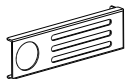
15 Spool & Nuts x 1
料管及料管螺母



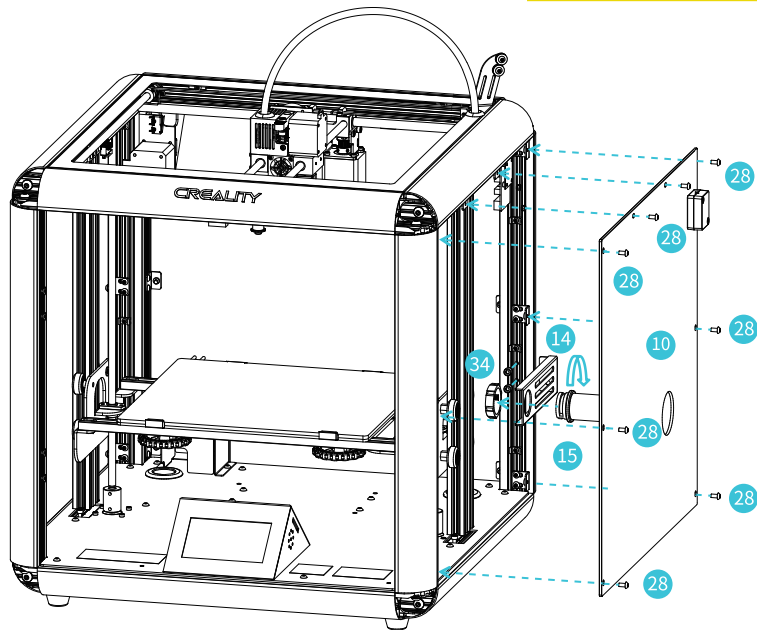
28 M4*8 hexagon flat round
head screw x 8
M4*8内六角平圆头螺丝



34 M5*8 hexagon flat round
head screw x 2
M5*8内六角平圆头螺钉



14 Rack x 1
料架



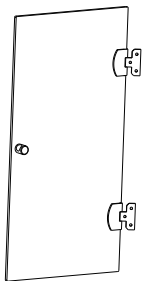
Before installing, remove the protective film on the door.

安装前，请撕掉门板两面的保护膜。

11

Install the Front Door

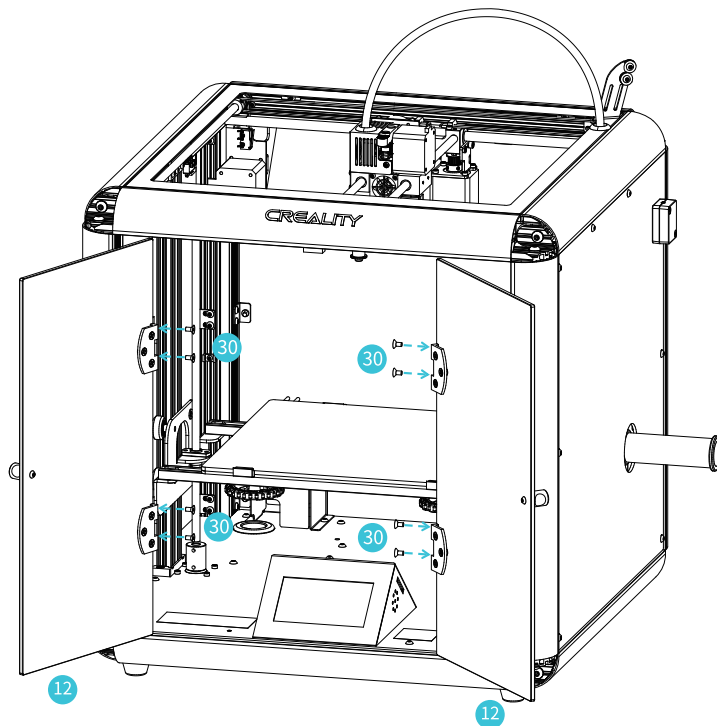
安装前门



- 12 Front door x 2
前门



- 30 M4*8 Socket cap
screw x 8
M4*8内六角沉头螺丝



12

Install the Profile Cover and Power Cable

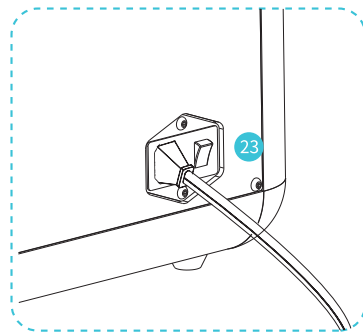
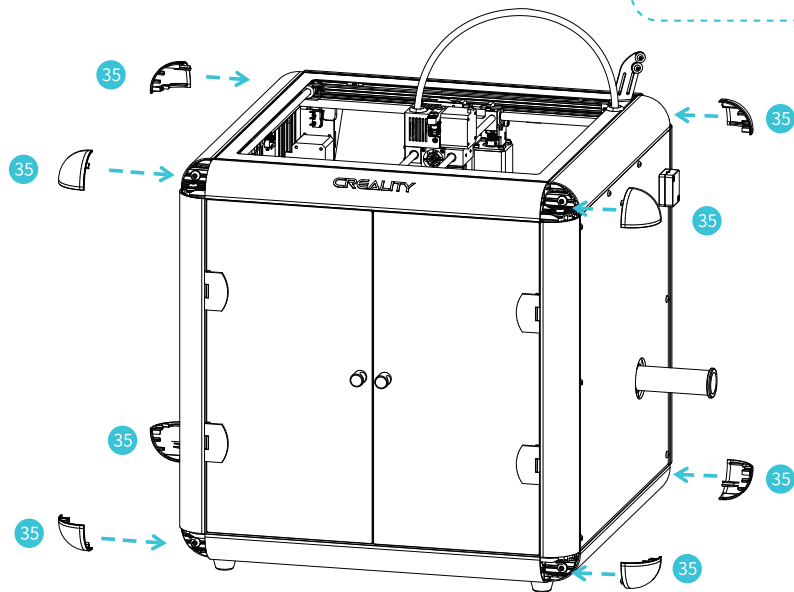
安装型材盖和电源接线



23 Power cable x 1
电源线



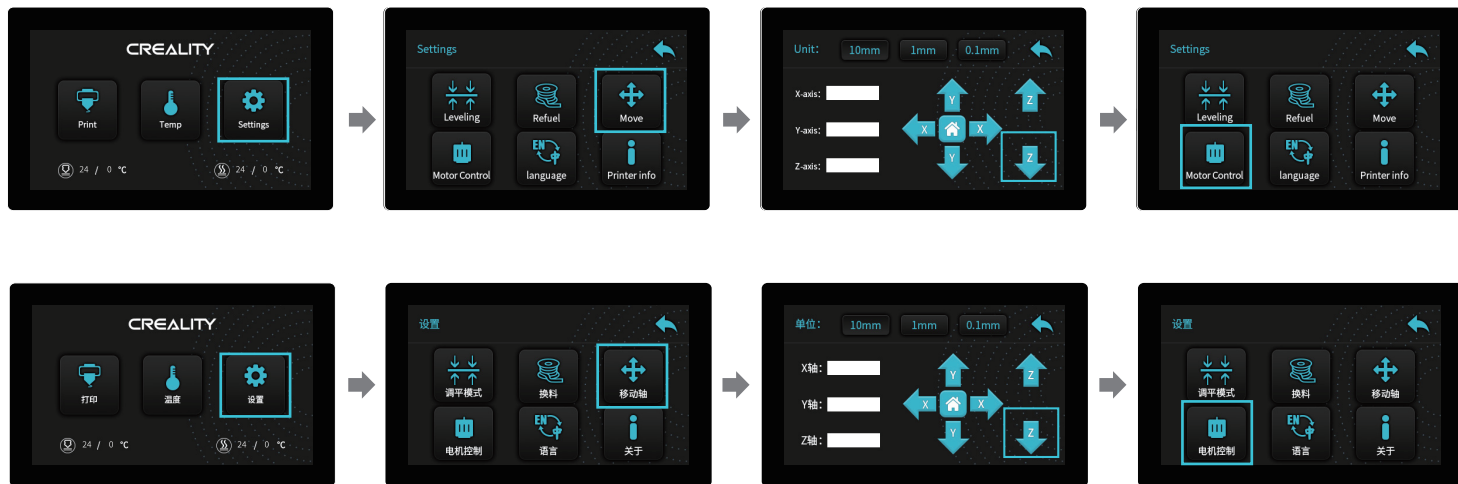
35 Profile cover x 8
型材盖



13

Bed Leveling 调平平台

For the first leveling :Set the Z-axis → move down 10mm → remove the motor ;
 初始调平:设置移动轴Z轴→向下移动10mm→解除电机;



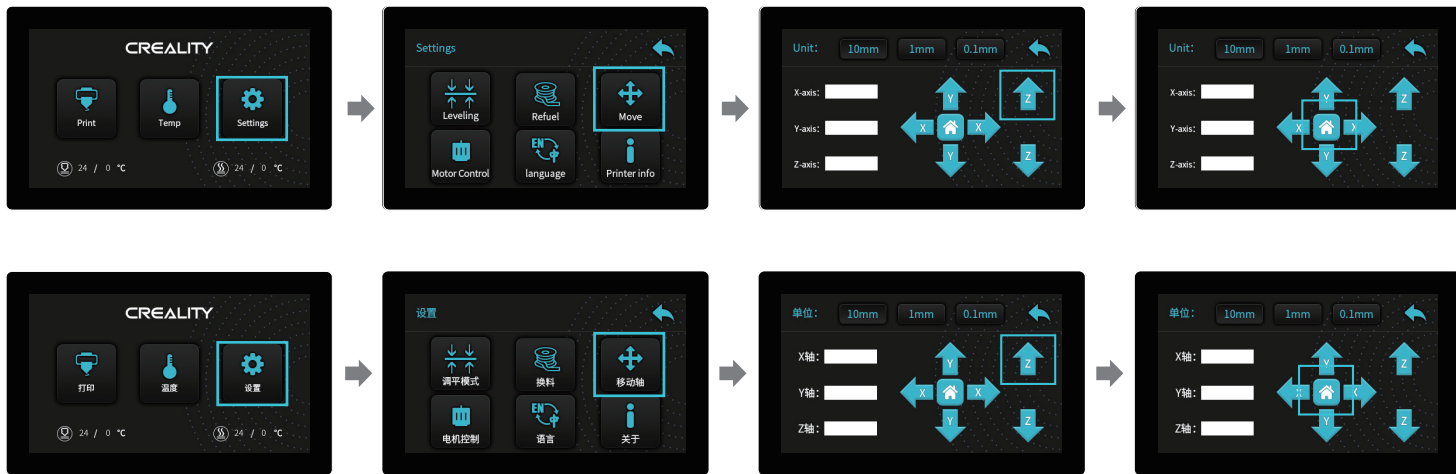
Note: The UI information is only for reference, the actual UI may be different.
 注意: 界面仅供参考, 实际以UI为准。

14

Bed Leveling 调平平台

Press the printing platform to the bottom → move up 10mm in Z-axis → return the motor to zero.

用手将打印平台压到底部 → 再设置Z轴向上移动10mm → 电机回零；



Note: The UI information is only for reference, the actual UI may be different.

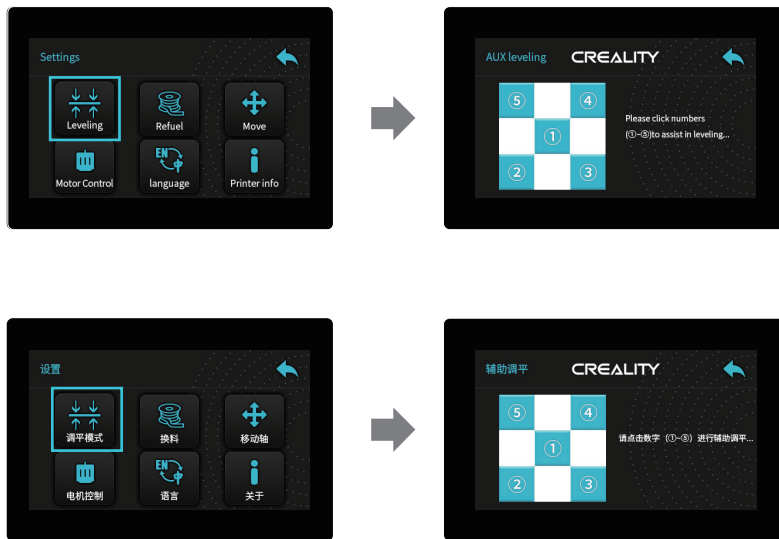
注意：界面仅供参考，实际以UI为准。

15

Bed Leveling 调平平台

“Leveling” -- Aid-leveling and click ①/②/③/④/⑤.

调平模式→辅助调平，点击数字①/②/③/④/⑤。

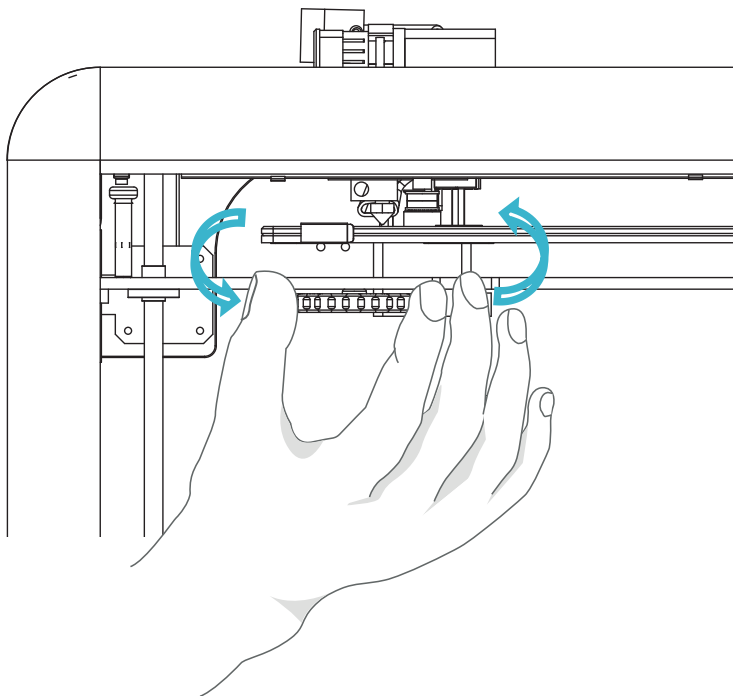


Note: The UI information is only for reference, the actual UI may be different.
注意：界面仅供参考，实际以UI为准。

16

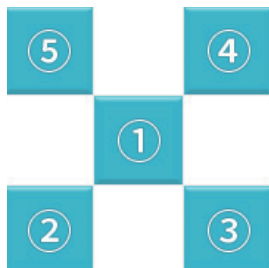
Move the nozzle near the top of the leveling screw, twist the screw left or right to make the distance between the nozzle and the platform is as thick as A4 paper. Leveling the four corners in order, click ① to verify whether the gap between the nozzle and the platform is proper or not.

移动喷嘴至螺丝上方附近。拧动螺丝，调节打印平台喷嘴使二者处于刚好贴合状态，间距约为0.1mm（一张A4纸的厚度）。按顺序调平四个角，点击①号，测试平台中间间隙是否合适。



⚠

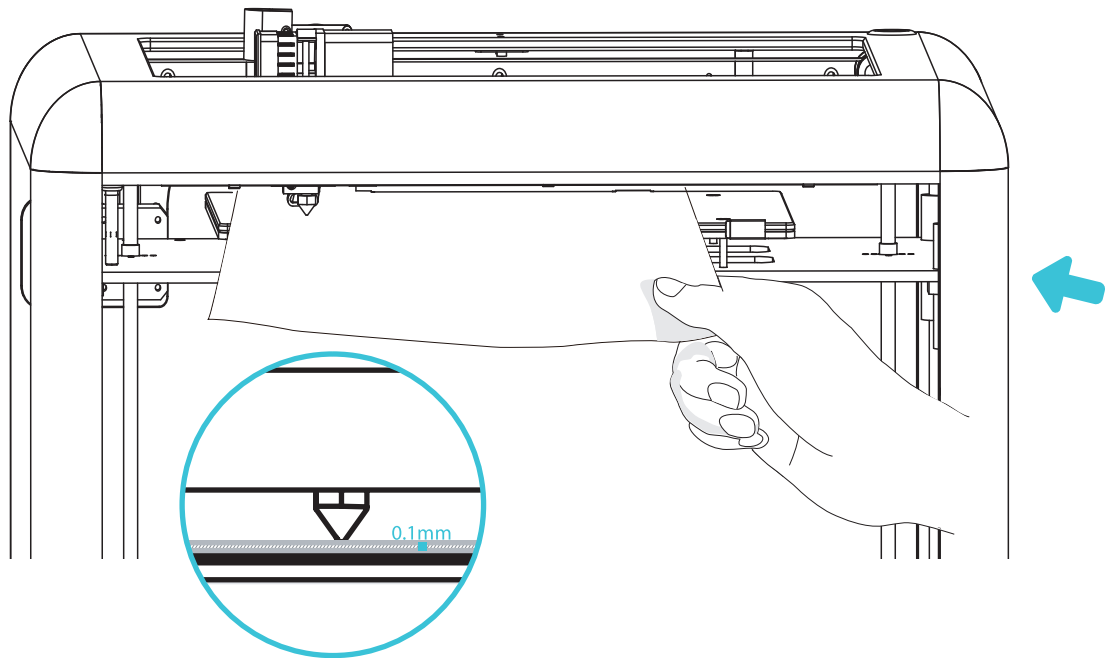
		<p>⊗</p> <p>The nozzle is too far away from the platform, so the consumables can not adhere to the platform. 喷嘴离平台太远，耗材无法粘附在平台上。</p>
		<p>✓</p> <p>Filament are extruded evenly, just sticking on the platform. 耗材挤出均匀，刚好贴在平台上。</p>
		<p>!</p> <p>The nozzle is too close to the platform, and the filament are not extruded enough, even scraping the platform. 喷嘴离平台太近，耗材挤出不足，甚至刮坏平台。</p>



17

Use a piece of A4 paper (standard printer paper) to assist with the adjustment, making sure that the nozzle lightly scratches the paper. Complete the adjustment of the screw on all 4 corners. Repeat above steps 1-2 times if necessary. Keep adjusting until there is slight resistance on the A4 paper from the nozzle.

我们可以利用一张A4纸辅助调平,使喷嘴刚好能在A4纸上产生划痕。依次完成四个边上调平螺丝的调节。不断调整直到在拉动A4纸时能感受到来自喷嘴的轻微阻力。



19

When you wait for the temperature to rise, hang the filament over the filament holder.

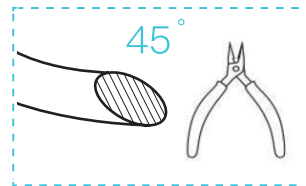
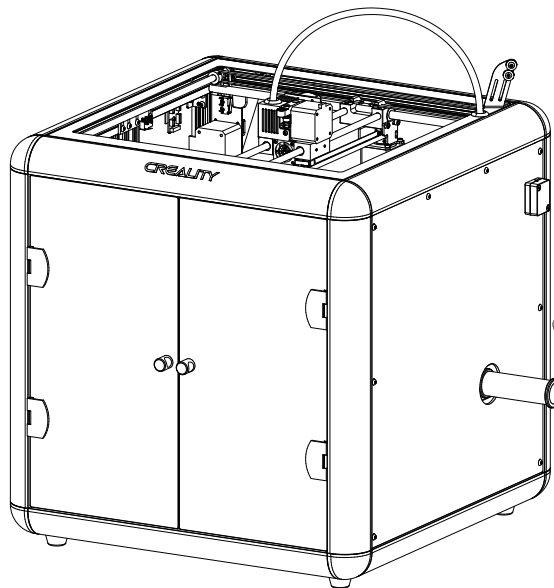
当您等待温度上升时，把耗材挂在料架上。



4 Filament | 耗材 x 1

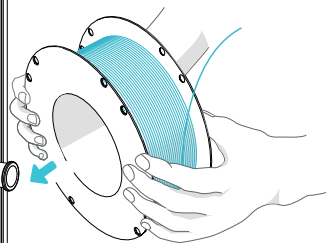


22 Diagonal pliers x 1
剪钳



For smoother printing, the end of the filament should be placed as shown above.

为了顺利完成打印，耗材的末端位置应如图所示。

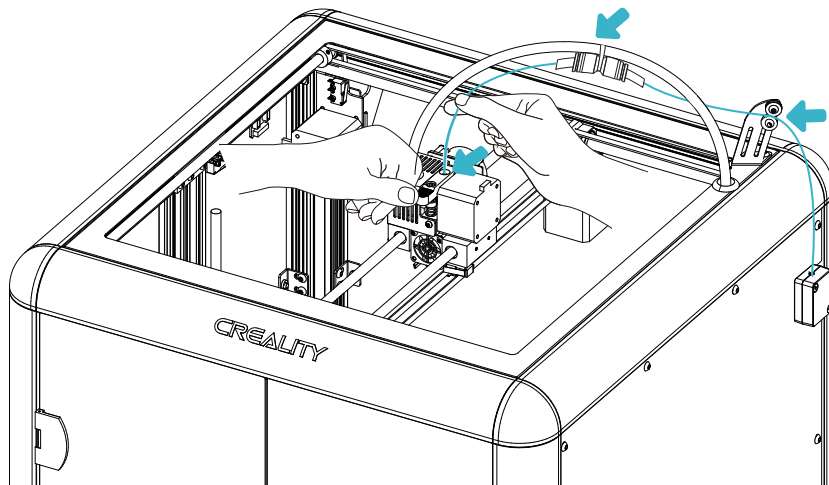


20

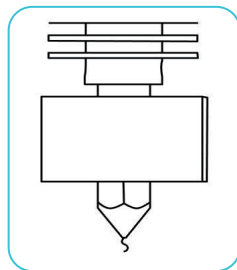
Load Filament 装料

Put the filament into the filament detector, pass through the two wheels of the filament guide support, When the temperature reaches at the target temperature pressing the extruder spring. Insert the filament into the extrude small hole till the nozzle position. When the filament comes out from the nozzle it means the filament has been loaded successfully.

将耗材穿过断料检测器，再穿过耗材导向支架的两轮之间，当温度达到目标温度时，按住挤出机弹簧，将耗材插入挤出机小孔直至喷嘴位置，等看到喷嘴处有耗材流出即表示耗材已经装载完成。



Please fix the filament tube on the corrugated pipe with a tie and dress the filament through the middle of the tube if you need to hoist the filament under special circumstances. 特殊情况下，如需要把耗材挂起来，请用扎带把耗材导管固定在波纹管上，耗材从导管中间穿过。



Tips: How to replace the filament?

1. Cut filament near the Extruder and slowly feed in the new filament to the material tube.
2. After preheating the nozzle, push the filament a little forward and quickly withdraw the filament, and then feed in the new filament.

Tips: 如何更换耗材?

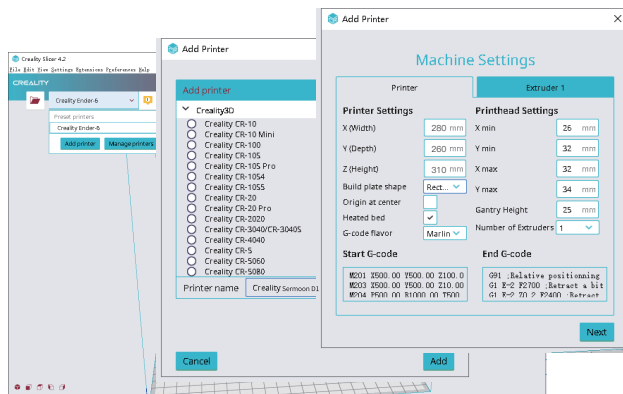
方法一、在靠近挤出机处将耗材剪断，将新耗材缓缓送入，直到耗材被送入导管为止。

方法二、预热喷嘴后，将耗材往前推进一下后，迅速抽出耗材，将新耗材送入。

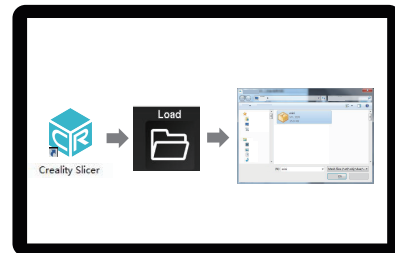
21

Start Printing

开始打印



3. Select language→Next→Select your machine→Next→Finish.



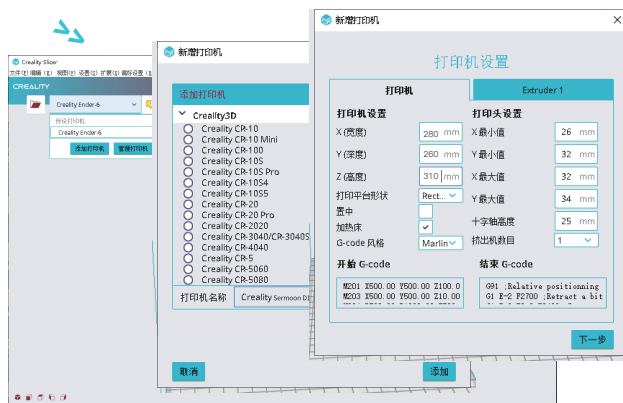
4. Open Creality 3D slicer → Load (Read file) → Select file.

打开创想三维切片软件→Load(读取文件)→选择文件。



1. Double click to install the software. | 安装软件

2. Double click to open the software. | 打开软件

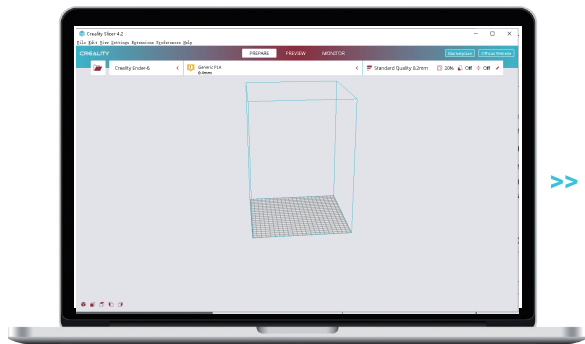


3. 依次选择语言→Next→选择对应机型→Next→Finish, 完成设置。

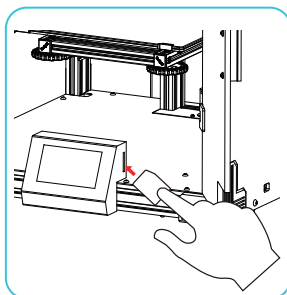
22

Start Printing

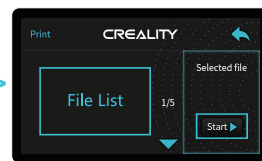
开始打印



5. Generate G-code, and save the gcode file to storage card.
生成 G 代码 → 保存到存储卡



6. Insert the storage card → Print
→ Select the file to be printed.
插入存储卡 → 点击打印控件 →
选择要打印的文件



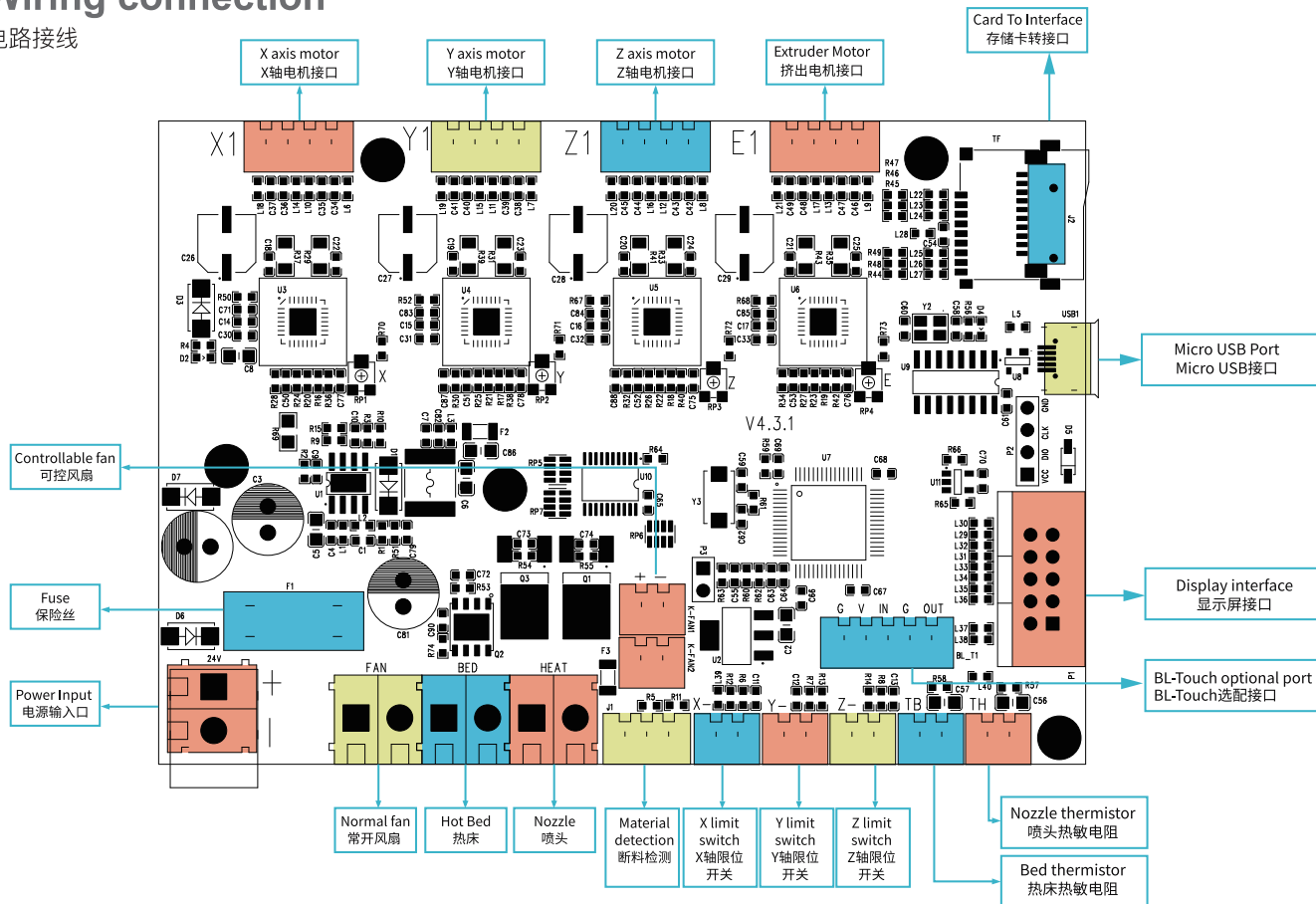
File names must be Latin letters or numbers, not Chinese characters or other special symbols
文件名需为拉丁字母或数字，不能为汉字或其他特殊符号



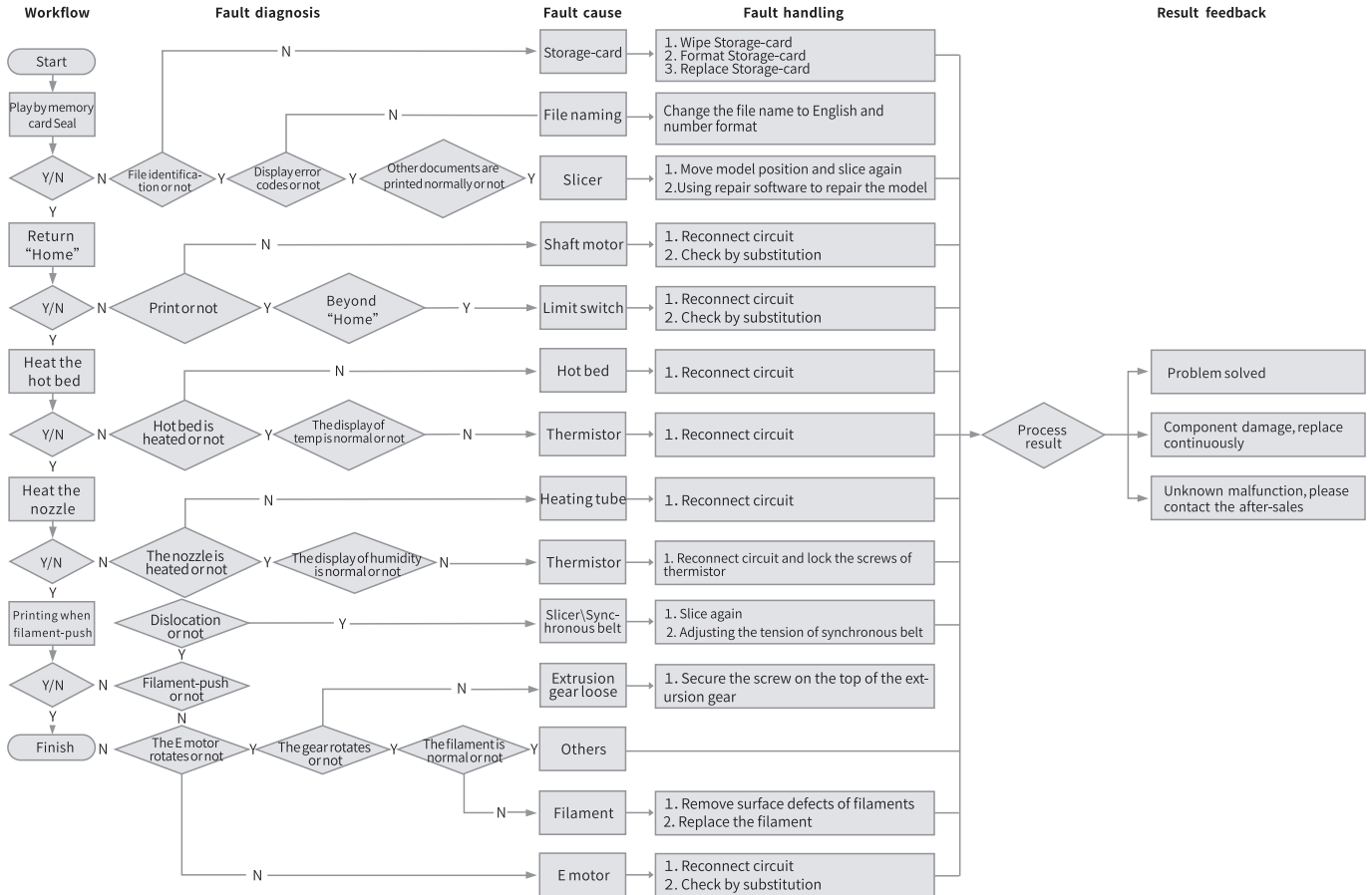
Notes: For details on the software instructions, please refer to the slicing software manual in the memory card!
温馨提示：软件使用说明详情，请见存储卡内切片软件使用手册！

Wiring connection

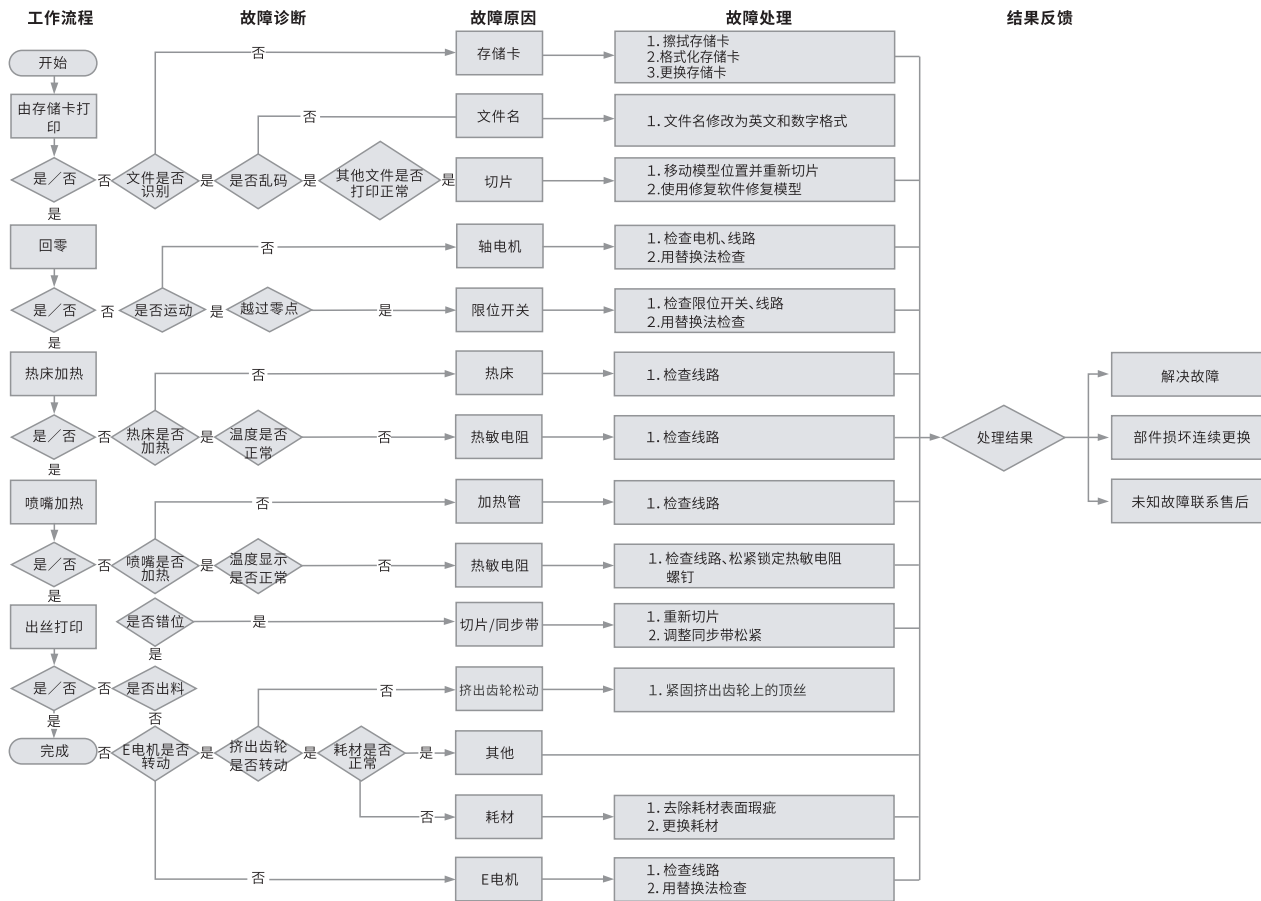
电路接线



Trouble shooting



故障检修



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

因每款机型不同,实物与图可能有所差异, 请以实物为准, 最终解释归深圳市创想三维科技有限公司所有。



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