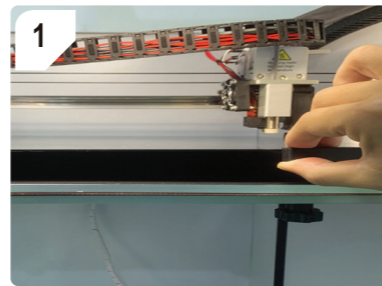
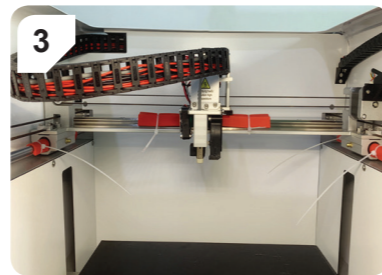


Read the safety instructions supplied with the product before using

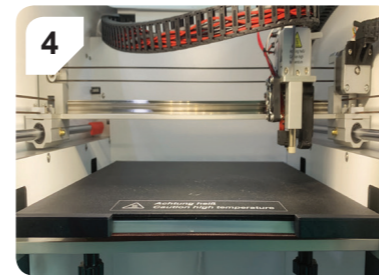
## 1 Set printer up



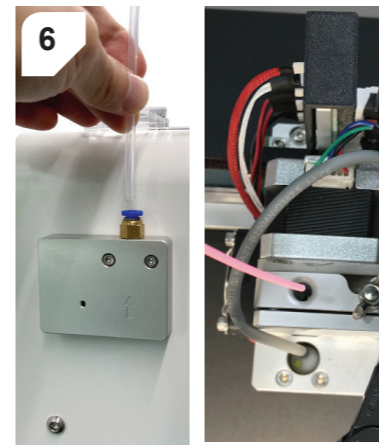
1 Insert the print bed and magnetic mat.



3 Remove the styrofoam pads



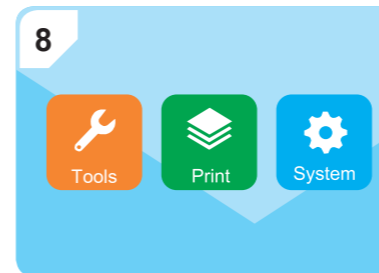
5 1. Install the spool holder.  
 2. Slide the filament spool onto the holder.



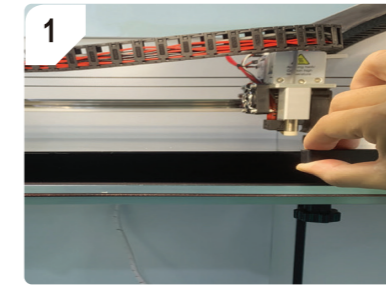
6 1. Insert the filament tube in the feeder.  
 2. Insert the filament tube into the extruder.



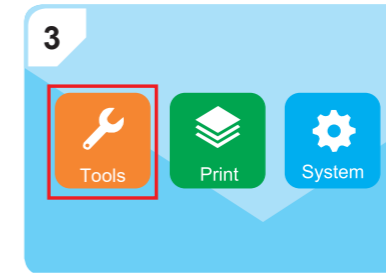
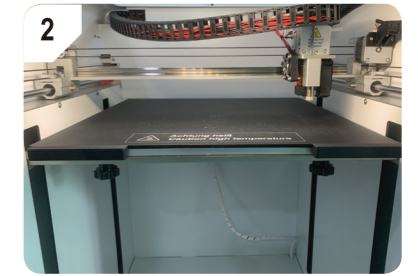
7 1. Connect the mains cable to the power inlet on the printer.  
 2. Flip the power switch into the position I to switch on. The display lights up.



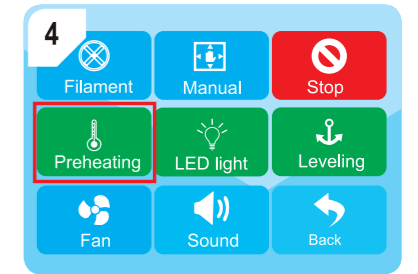
## 2 Calibrate Z-Offset



1 Insert the print bed and magnetic mat.



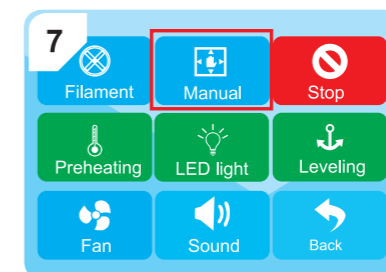
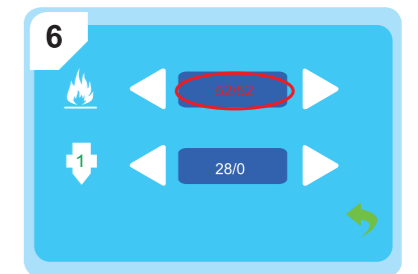
3 Open the menu **Tools**.



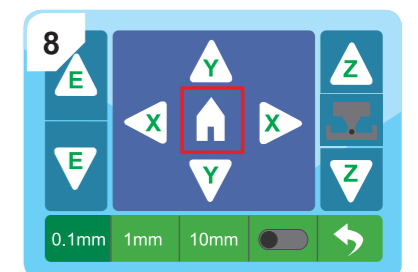
4 Touch the button **Preheating** to start the pre-heating process.



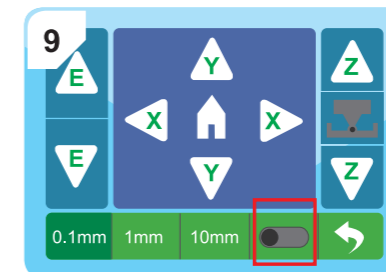
5 Wait until the preheat temperature has been reached.



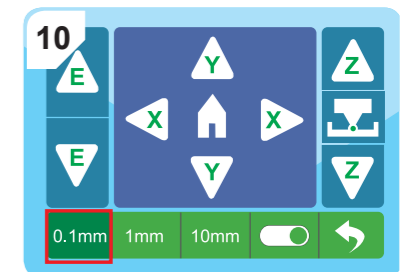
7 Open the menu **Manual**.



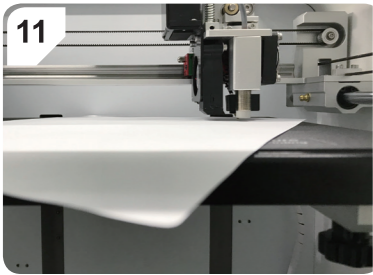
8 Touch **Home** to move the extruder to its zero position.



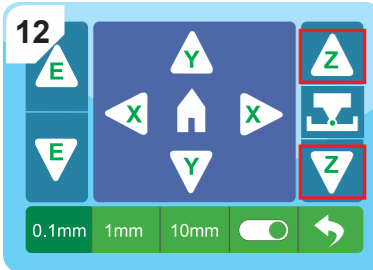
9 Activate the Z-offset calibration with the slider.



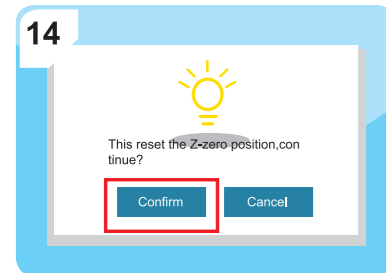
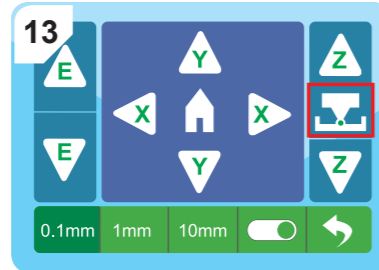
10 Touch the distance increment **0.1 mm** to activate it.



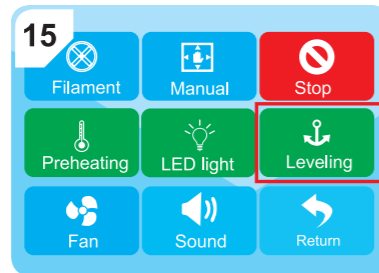
Slide one sheet of A4 paper (80 g) between the nozzle and the print bed.



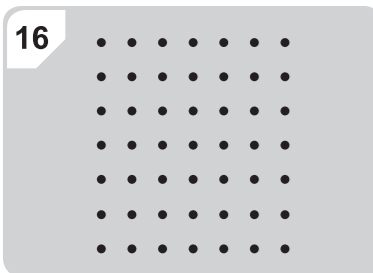
Slide the paper back and forth while repeatedly touching the button ▲ or ▼ to lift or lower the print bed. If you notice slight resistance between nozzle, paper, and print bed, touch the button 🛠️ to finish the calibration.



Confirm the Z-offset calibration.

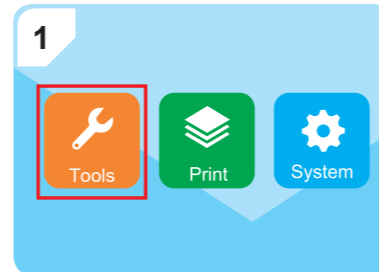


Touch the button **Leveling** to start "Auto-levelling".



Wait for "Auto-levelling" to finish.

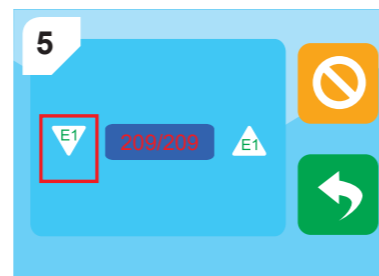
### 3 Load filament



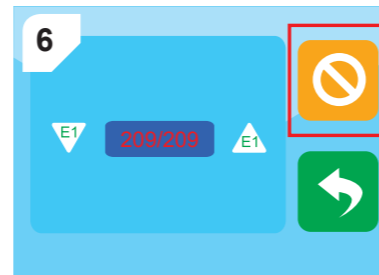
Open the menu **Tools**.



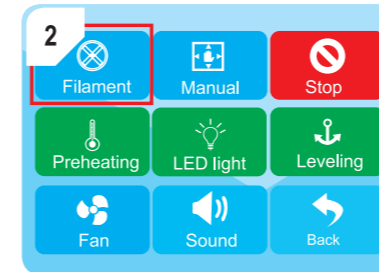
Touch the temperature display to preheat the extruder.



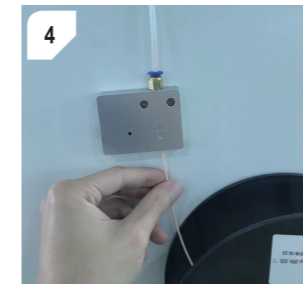
Touch the button **E1** (down arrow) to load the filament into the extruder.



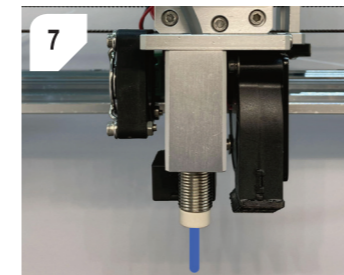
Touch the button **Stop** as soon as molten filament flows from the nozzle.



Open the menu **Filament**.



Cut the filament at an angle and then feed it into the feeder.



### 4 Print

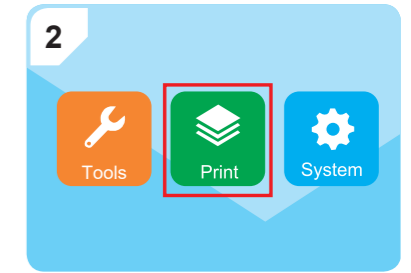


#### CAUTION

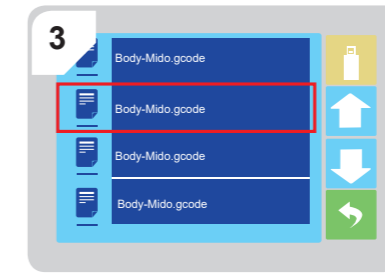
**Hot print bed**  
Touching hot print bed can cause burns  
Let cool down before touching



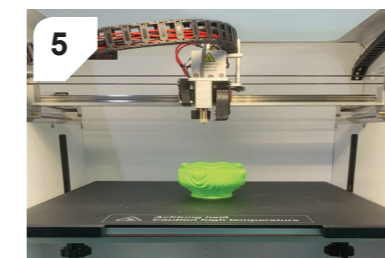
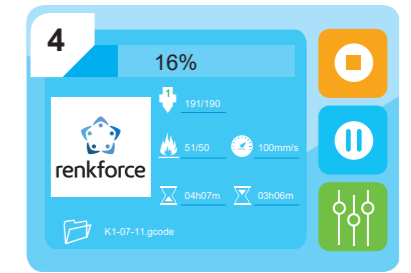
Connect the USB memory stick that contains the print file to the USB port.



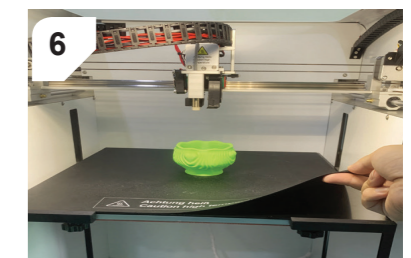
Open the menu **Print**.



Select file to print. The printer starts printing.



After printing is complete, let the printer cool down to room temperature.



Remove the magnetic mat.