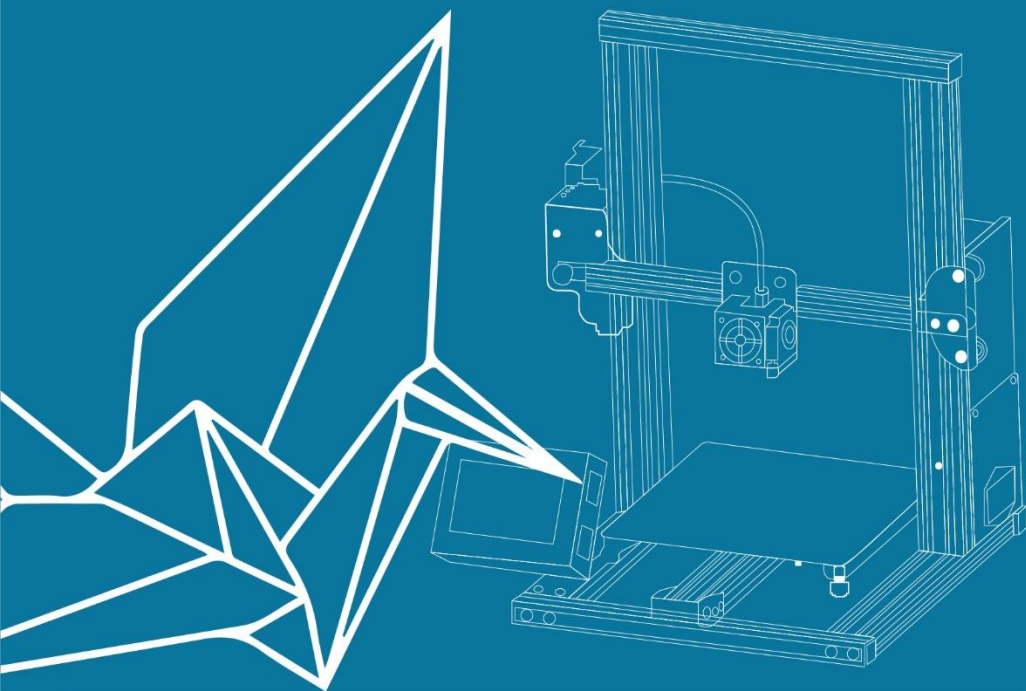




**CREATE  
FREE  
DO AS ONE WISHES**



**X4-3**

**user's manual  
Instruction Manual**

**TRONXY**

# Attention



After receiving the package, check the accessories according to the packing list. If you have any questions, please contact the customer service.



Please place the machine in a ventilated, dry, clean and smooth environment



The machine contains high-speed moving parts and high-temperature parts. Children are strictly prohibited to use the machine without permission



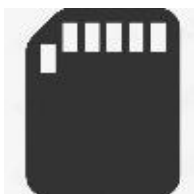
Part of the parts belong to consumable goods, the warranty period is not the same



It is not recommended to use this machine unattended



Do not modify or disassemble the core parts of the machine without permission



Relevant information is stored in the SD card, please check

# Catalogue

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5、 Wiring graphic	6
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After-sales Email: [Support@tronxy.com](mailto:Support@tronxy.com)



Tronxy



Support



FaceBook

# 1. Machine parameter

## Print parameter :

Print size	:	310*310*330mm
Print accuracy	:	0.1-0.3mm
Print principle	:	FDM (Fused Deposition Molding)
Nozzle size	:	0.4mm
Nozzle quantity	:	1
Print speed	:	20-100mm/s (suggest 60mm/s)
Position accuracy	:	X/Y -0.0125mm, Z – 0.0625mm
Filaments	:	PLA、ABS

## Temperature parameter :

Print environment	:	8-40°C
Nozzle Temp	:	260°C (MAX)

**Power supply :** AC 110/220V 50/60Hz DC 360W


## Software parameter :

Slice software	:	Tronxy、Cura、Simplify3D
Input format	:	.stl、.obj
Output format	:	.gcode
Connection	:	SD card、USB cable

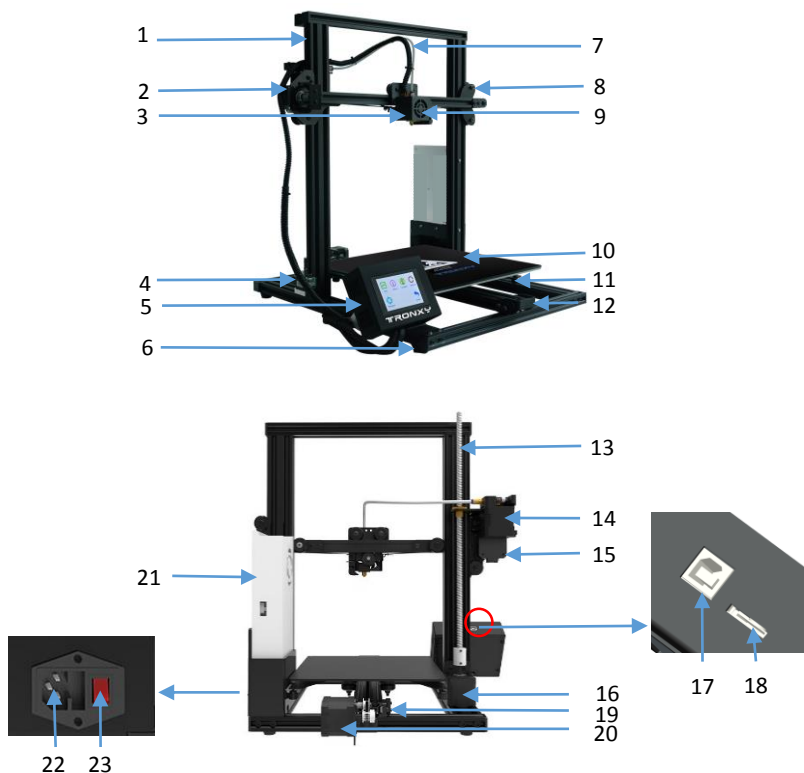
## Physical parameter :

Machine size	:	580*540*529mm
Packing size	:	630*552*195mm
Packing Weight	:	≈11kg

## 2. Packing list

				
	Upper rack		Base	Power supply
				
XY-3		Instructions	Filament rack	Power lines
				
USB cable	Hotbed sticker	Specification	Tools bag	Blade
				
Reader (Incl SD card)	Filament	Screw package	Quick coupling	Tie
				
printer head	reinforced plate			

### 3. Machine details



Serial numb	Name	Serial numb	Name	Serial numbe	Name	Serial numb	Name
1	Upper rack	8	right slider assembly	15	X axis motor	22	power interface
2	Left slider assembly	9	print head parts	16	Z axis motor	23	voltage change-over
3	extruder	10	hotbed	17	USB interface	24	
4	Z- Endstop	11	leveling nuts	18	SD card interface	25	
5	control box	12	Y axis wheel	19	Y axis motor	26	
6	bottom frame	13	lead screw	20	Z- Endstop	27	
7	teflon tube	14	feeding motor X axis moto	21	Power switch	28	

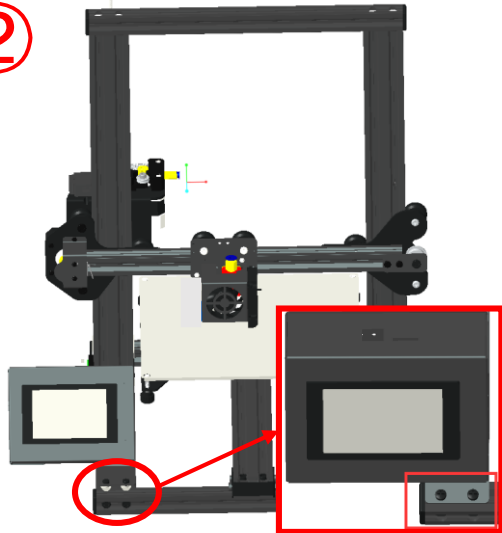
## 4.Installation

①



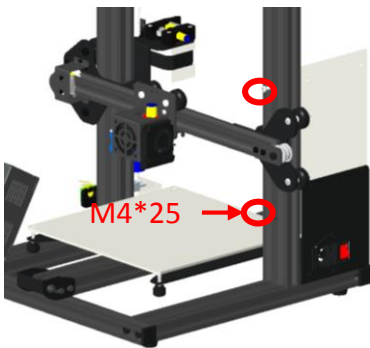
Fix the shelf with the base with 4 M5\*25 screws and gaskets , Then fix the enhanced version on both sides

②



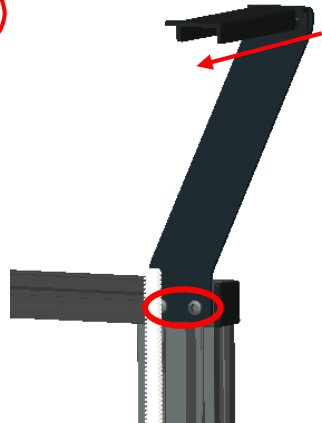
Fix the control box on the front beam of the base (Note: the control box must be fixed to the front beam to prevent collision with the X axis)

③



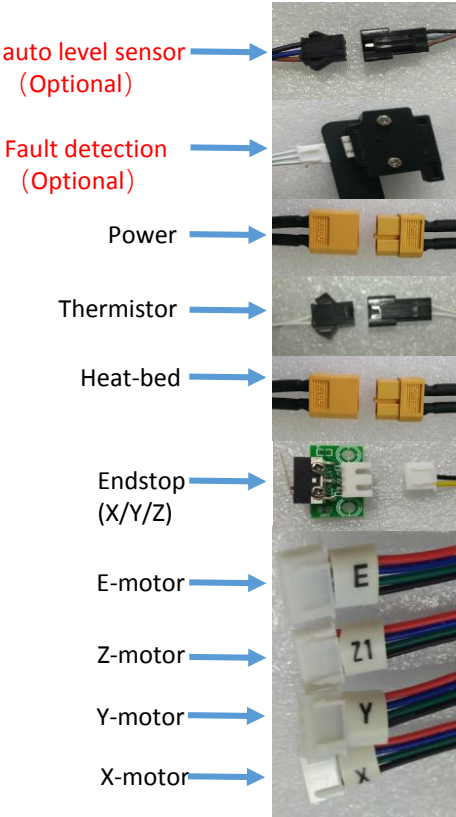
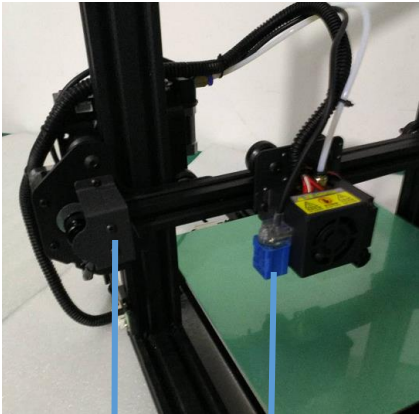
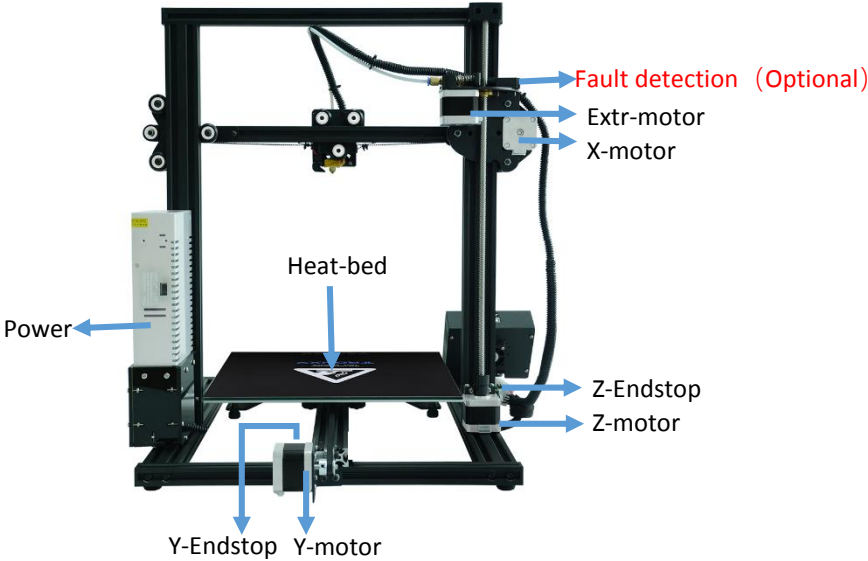
2 M4\*25 screws are used to fix the power box on the right side of the frame profile (aiming at the hole),

④



Fix the stock holder to one side of the top beam lead screw, pay attention to the direction in the picture

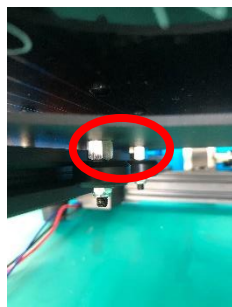
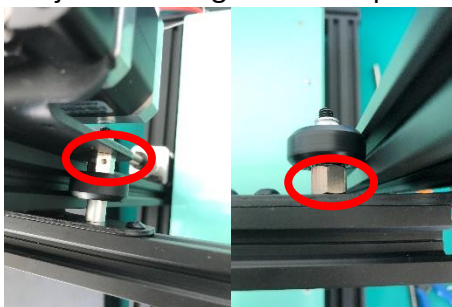
# 5.Wiring graphic





## 6. Institutional adjustment

If the machine structure becomes loose during transportation, the eccentric nut can be adjusted to solve the problem. As shown in the figure below (eccentric nut in red), Turn the nut with a spanner to adjust the elastic state of the pulley (the pulley is not easy to be adjusted too tight to avoid poor operation).

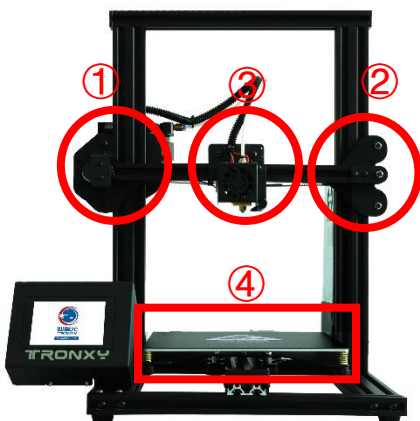


① Left slider

② Right slider

③ Extruder

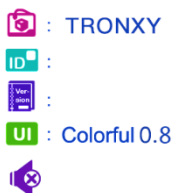
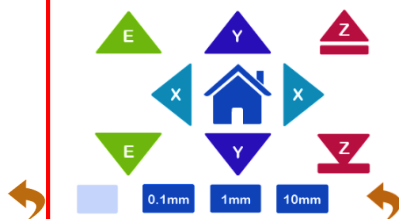
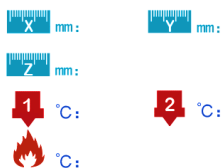
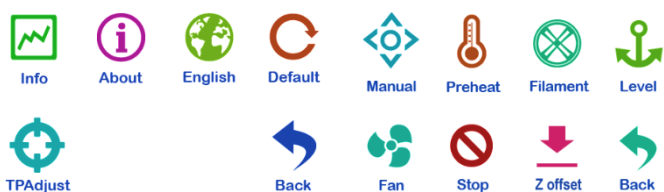
④ Heatbed



Wrench

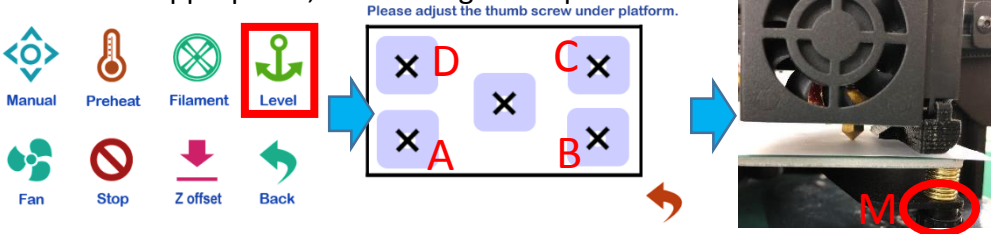
If there are other loose places on the structure, you can tighten the screws directly. To ensure the machine structure is in a stable and smooth state before debugging, the manual sliding print head and platform module can be used to ensure the smooth and stable sliding before leveling printing.

## 7. Interface operation and printing



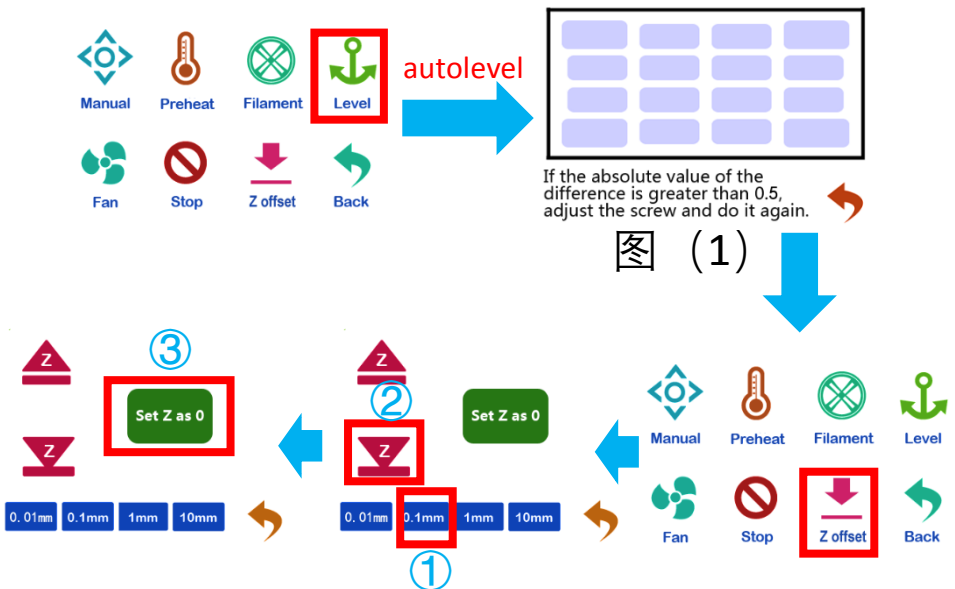
### Manual leveling :

Click the four points of ABCD in the figure below, the print head will move to the corresponding position, and then adjust the leveling nut M, so that the interval between the nozzle and the platform is a piece of A4 paper. After adjusting the four points in turn, it needs to be verified again. If the interval is appropriate, the leveling is completed.

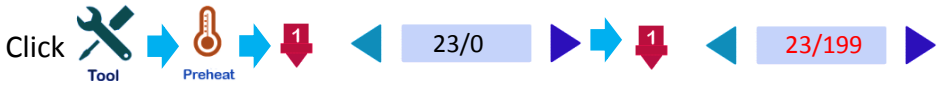


### Auto leveling :

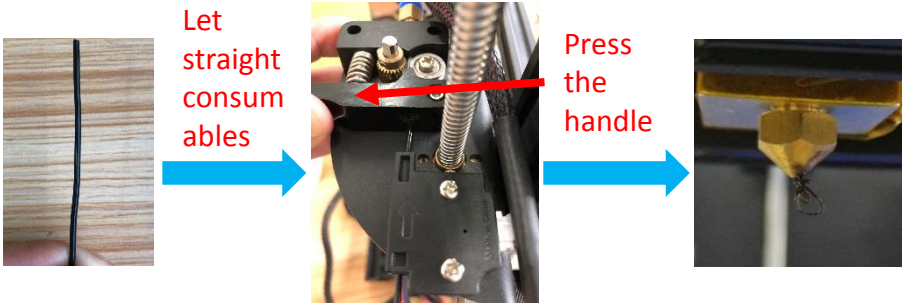
- ① Automatic leveling for automatic leveling version of the machine, the manual version can not be use. Click the leveling function in the figure to automatically pop up the interface, select "automatic leveling", jump out of the figure (1) interface, and start leveling. After the Detection is completed, the error value of each point will be displayed. If the value is greater than 0.5, adjust the leveling nut in the corresponding area, and then reset until all values are less than 0.5, then the automatic leveling is completed
- ② Then click "Z offset", the print head will move to the middle of the platform, observe the height of the nozzle and platform, and then click ①②, make the distance between the nozzle and platform for a piece of A4 paper height, then click ③, reset the zero, so that the end of leveling.





## Unload consumables :



After waiting for temperature up to 180 °C, consumables through the run out detection, extruder and Feed pipe until the nozzle has consumable extrusion, as shown in the figure below:



## Print test :

Click  → "Testing file" →  , start print.

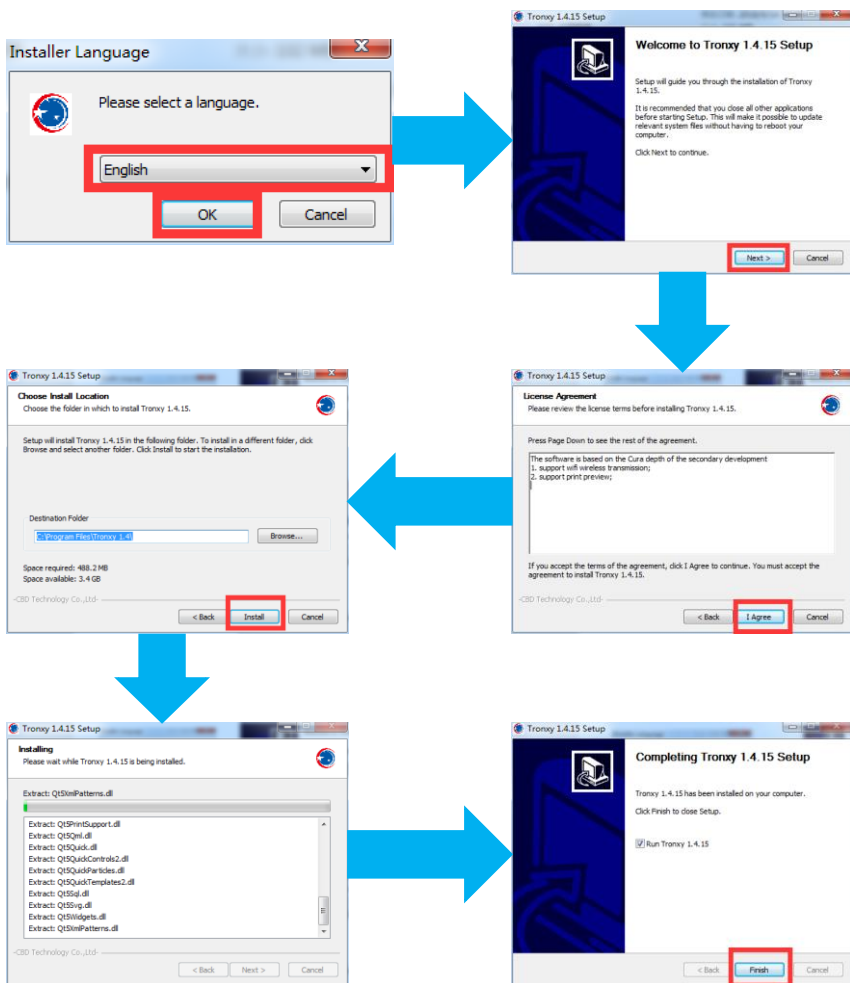
Print

If the first layer is not sticky, the nozzle is on the high side and the platform can be raised appropriately; If the nozzle has a small amount of thread, the nozzle is on the low side and the platform can be appropriately lowered.

# Slice software

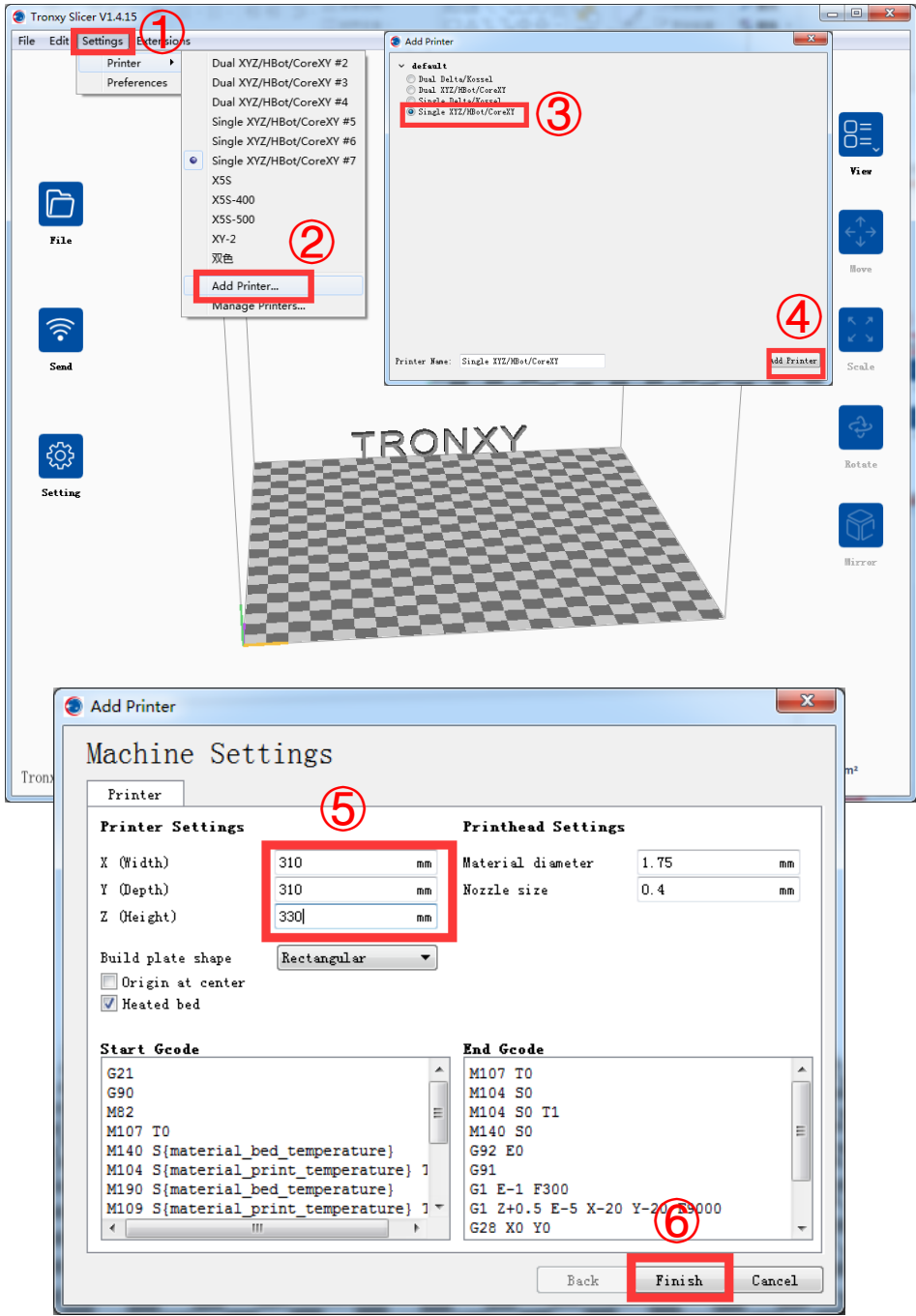
## 1. Installation

Find out slice software in SD card "TronxyInstall.exe" double click, Then follow these steps to complete the installation.

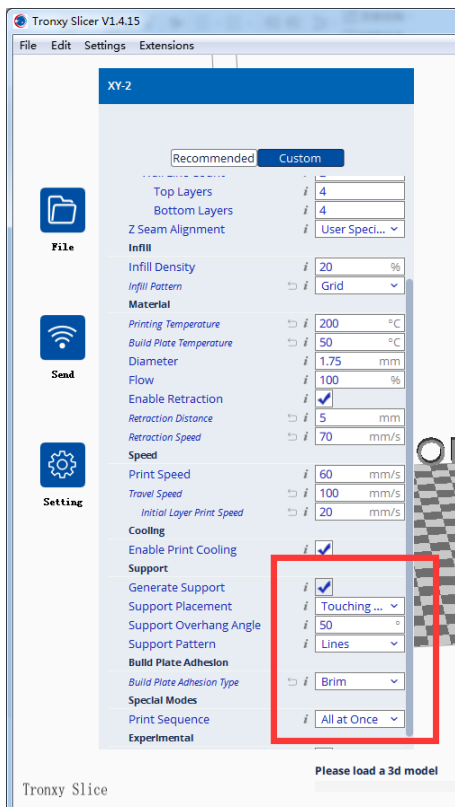
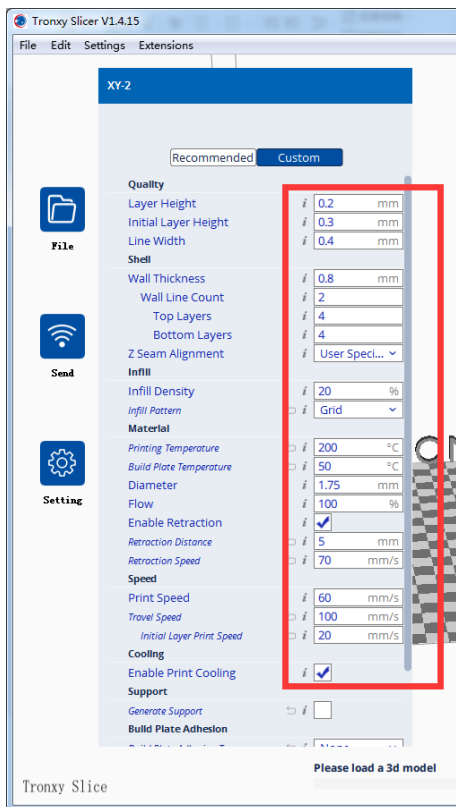


2. How to use slice software

① 、 Type setting: follow the steps below to complete the setting.



- ② 、Parameter setting: (The following figure gives the reference value, according to their own needs can be modified)



Some parameters are set for reference :

- Layer thickness : 0.1-0.3mm
- Print temp : PLA - 200 °C ABS - 240 °C
- Heatbed temp : PLA - 50°C ABS - 80 °C
- Print speed : 20-120mm/s (suggest 60mm/s)
- Support : Choose according to the model structure
- Platform support : It is recommended to use the model when the bottom contact is small

## **8、 Fault cause analysis**

### **1. Machine cannot start ?**

- 1) Check the power line and other wires connect correct or not.
- 2) Check whether the supply voltage matches the local standard.
- 3) Check whether the screen or power supply is damaged and replace in time.
- 4) Check the wires if damage or breakage.
- 5) Check whether the power fuse is burnt out.

### **2. The contents of the SD card cannot be read?**

- 1) Check the card reader if damage.
- 2) If the connect computer show empty, please format the SD card and try again.
- 3) Check whether the SD card is inserted into the socket correctly.
- 4) The filename has an illegal character, please rename it.
- 5) Please replace the damaged SD card and try again.

### **3. if the print head does not produce enough material or does not produce enough material?**

- 1) Check whether the print head temperature have not reached 200 °C above (PLA), led to consumable cannot squeeze, waiting for the temperature rises to the set target.
- 2) Check whether the filaments are knotted, which leads to unsmooth feeding.
- 3) Check whether the filaments or pipes are not inserted in place, resulting in the failure of feeding.
- 4) Check whether the temperature of the print head is too high, which leads to excessive softening of filaments and can't be extruded normally.
- 5) Check whether the diameter of filaments is inconsistent with the diameter set in the slicing software, so that the amount of extrusion filaments is not enough.
- 6) Check whether the consumables are blocked by dirt or nozzle blocked during extrusion.
- 7) Replace with better quality filaments.



#### **4. If the first layer upwarp ?**

- 1) Check that the hot bed has been leveled.
- 2) Check the surface of the hot bed for dirt.
- 3) Check whether the distance between the nozzle and the platform is too high, resulting in insufficient adhesive force.
- 4) Check the hot bed for adequate temperature.
- 5) Check the first layer of the slicing software to see if it is printing too fast.

#### **5. The model is not easy to take off ?**

- 1) Heating the hot bed to 50-70 °C, and after cooling to try again, or use the shovel.
- 2) It is recommended to buy TRONXY magnetic stickers.

#### **6. Can't heat it up?**

- 1) Check the heating rod and thermistor for poor contact or damage.
- 2) Check that the slice software has set the target temperature.
- 3) Check whether the thermistor wire falls off.

#### **7. Motor out of step?**

- 1) Check the tightness of the belt, whether the pulley is not locked.
- 2) Check the current voltage.
- 3) Check X/Y/Z axis motion is smooth.
- 4) Print speed too fast.
- 5) Environment temp too high.
- 6) Need flash the firmware.

#### **8. Abnormal motor noise or vibration?**

- 1) Check whether the motor line is in bad contact, loose or wrong connection.
- 2) Motor temperature is too high.
- 3) Check whether the motor is damaged.
- 4) Flash the firmware.
- 5) The printing load is too heavy.

## **9. Model dislocation and fault**

- 1) Nozzle feeding not smoothly, please clean the nozzle or replace the nozzle
- 2) Check that if the printing speed is too fast
- 3) The quality of filaments is poor, please replace with new filaments

## **10. Abnormal sound and vibration of filaments feeding motor**

- 1) Please check whether the nozzle is blocked
- 2) The nozzle feeding is not smooth, please clean the nozzle
- 3) Whether the software Settings are incorrect
- 4) Check whether the motor does not work
- 5) Check the motor working or not or feeding gear is not working

## **11. Screen related questions**

- 1) No screen/blue screen, please restart or check whether the cable is plugged in
- 2) Touch screen malfunction, check whether the screws are installed too tight
- 3) Garbled/splash screen, static, ground connection or restart

## **12. Motherboard related issues**

- 1) The wiring is not responding. Please check the wiring installation
- 2) Automatic shutdown restart, may be abnormal firmware or module of “resume print after power failure” damaged
- 3) Lack of heat dissipation, please lower the ambient temperature
- 4) No response due to motherboard damage

## **13. Unable to connect to printer**

- 1) Check that the driver is not installed or properly installed
- 2) The serial port was not selected correctly
- 3) The software parameters do not match



**ONLY NEEDS 4 STEP TO FINISH  
THE REST INSTALLATION  
BROKEN MATERIAL DETECTION  
POWER RECOVERY  
MAGNETIC STICKER  
ALL METAL**

New  
attack

