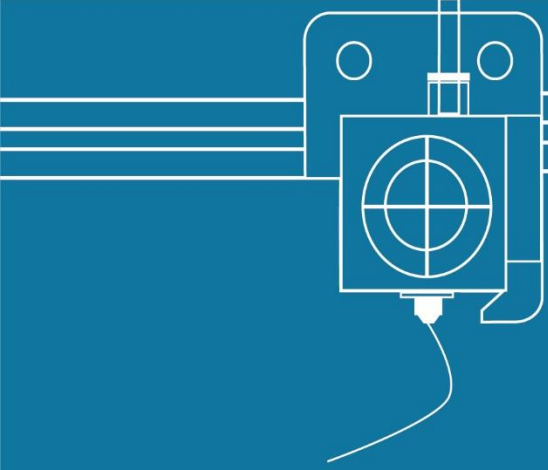
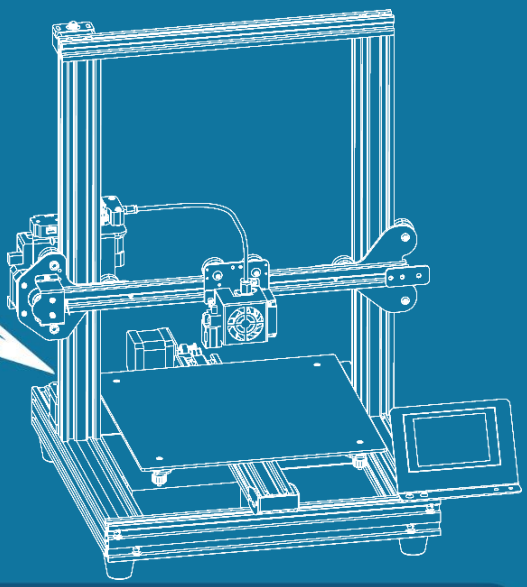


CREATE
FREE
DO AS ONE WISHES



XY-2 PRO

user's manual
Instruction Manual

TRONXY

Attention

Note: please make sure the voltage of the power supply is consistent with the voltage in the area before printing.If not, please turn the 110V-220V switch on the power supply.

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

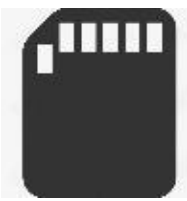
Please use the machine in a ventilated, dry, clean and flat environment

The machine contains high speed moving parts and high temperature parts. Children are not allowed to use the machine without permission

Part of the accessories are consumable, the warranty period is different

It is not recommended to use this machine when unattended

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



Relevant information is stored in SD card, please check

Directory

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6. Structure debug ····· 7

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8. Failure cause analysis ·····14

Service email ：Support@tronxy.com

Tronxy Support FaceBook

1. Machine parameters

Print parameters：

Print size	:	255*255*260mm
Print accuracy	:	0.1-0.3mm
Print principle	:	FDM（fused deposition molding）
Nozzle size	:	0.4mm
Nozzle quantity	:	1
Print speed	:	20-150mm/s（advise 60mm/s）
Position accuracy	:	X/Y -0.0125mm，Z – 0.000625mm
Filaments support	:	PLA、ABS

Temp parameters：

Print environment	:	8-40℃
Nozzle temp	:	275℃（MAX）

Power supply： AC 110/220V 50/60Hz DC 24V/360W

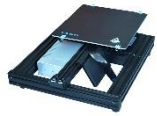
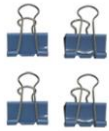
Software：

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

Machine parameters：

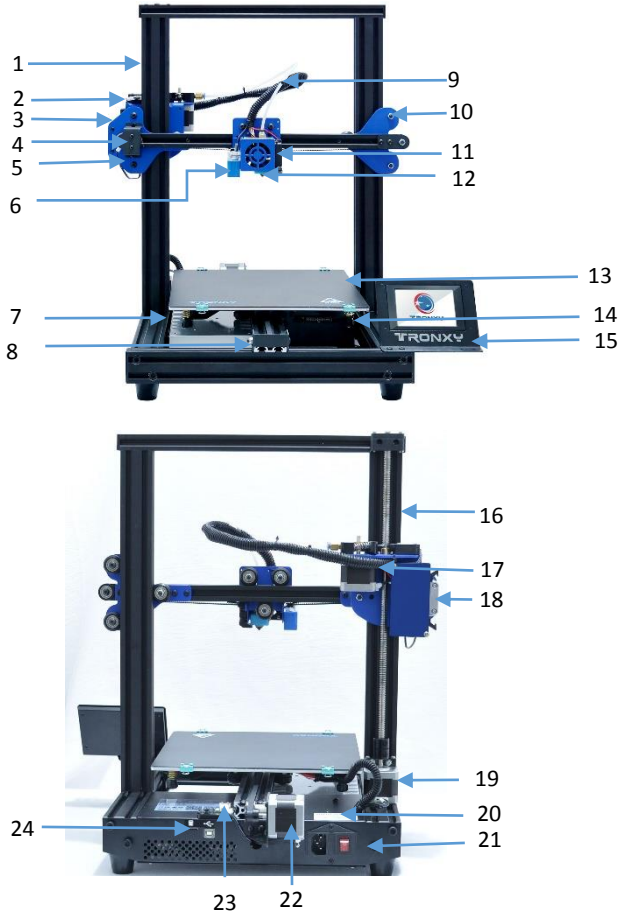
Machine size	:	478*455*520mm
Package size	:	510*480*230mm
Weight	:	≈12kg

2. Packing list

			
	Upper bracket	Base	Filament bracket
			
XY-2 PRO	Specification	HM5*50 4PCS	Tools
				
Shovel	Power line	USB cable	Stickers	Reader（with SD card）
				
Filament 0.25KG	Print head	Clips（Color random）	Quick connection M6	Ties

Notes ：Please insure you received all items on the packing list after receiving the printer.
If you have any questions , please contact the customer service.

3. Machine details



序号	NO.	Commodity	NO.	Commodity	NO.	Commodity	NO.	Commodity
1	1	Upper bracket	8	Y axis wheels	15	Touch screen	22	Y axis motor
2	2	Filament run-out	9	Feeding tube	16	Lead screws	23	Y limited switch
3	3	X axis motor	10	Right slicer	17	Extruder motor	24	USB/SD card interface
4	4	X limited switch	11	Print head component	18	30P single cable		
5	5	Left slicer	12	Extruder	19	Z axis motor		
6	6	Auto level sensor	13	Heatbed	20	Control box		
7	7	Power	14	Adjustment nuts	21	Power switch		

4. Installation

Note: please make sure the voltage of the power supply is consistent with the voltage in the area before printing.If not, please turn the 110v-220v switch on the power supply.

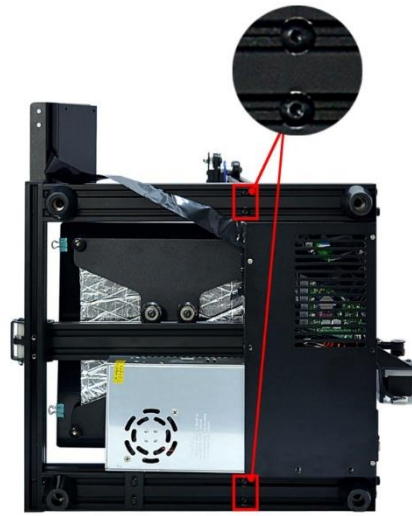
Loosen the screws with the socket wrench and remove the touch screen from the beam. Remove the screws and nuts.

Pass the removed screw through the touch acreen bracket and carry the ship nut.

Lock the ship nut with socket wrench and fix the touch screen on the front beam profile of the base.

Note: the controller must be locked on the front beam, otherwise it will collide with the hot bed.

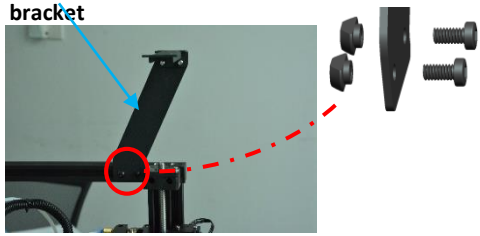
1



Take the upper bracket and match the four holes to the four holes of the base. Use four M5*50 screws to lock the upper bracket to the base.

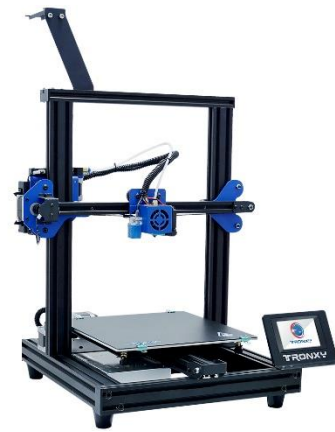
2

Filament bracket



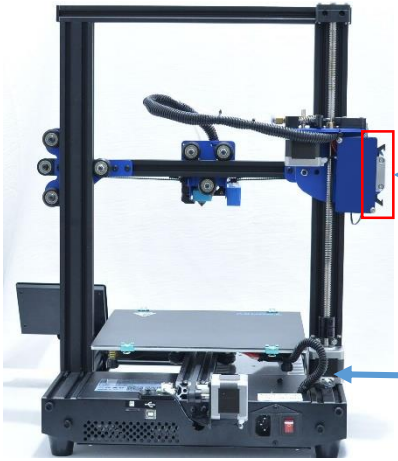
Take out the filament bracket, lock the ship nut with hexagon wrench, and fix the bracket on the upper beam.

3



done

5. Wiring connection

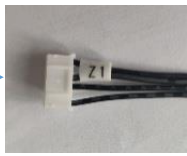


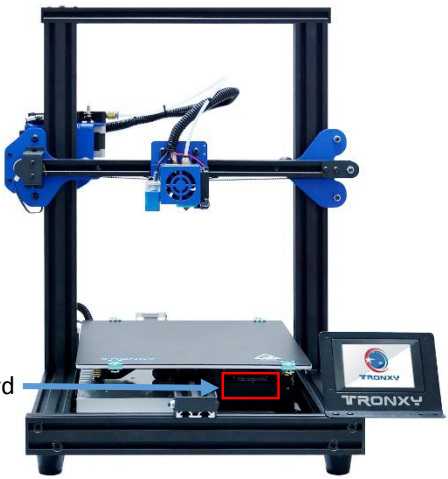
Switch board

Switch line

Z motor line

Z motor line



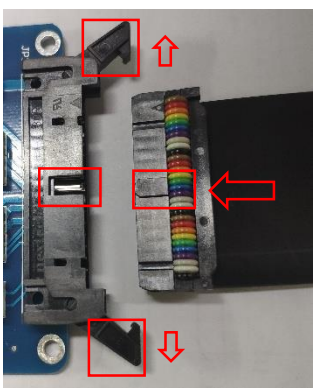


Switch board

Power 110v-220v switch

Switch line installation method:

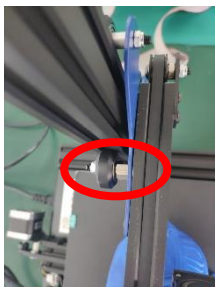
Remove the buckle, and put it on the notch side of the quasi-adapter plate on the raised side of the adapter, and insert it firmly until the buckle bounces back.



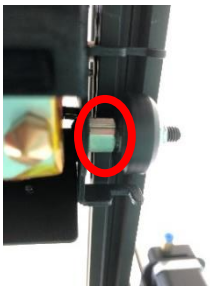
6. Structure debug

If the machine structure is loose during transportation, it can be solved by adjusting the eccentric nut.As shown in the figure below (eccentric nut in red circle), turn the nut with a wrench to adjust the tightness of the pulley (the pulley should not be adjusted too tight to avoid smooth operation).

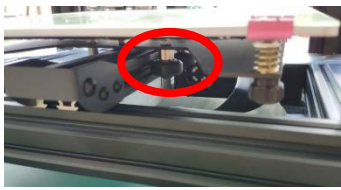
Left slicer



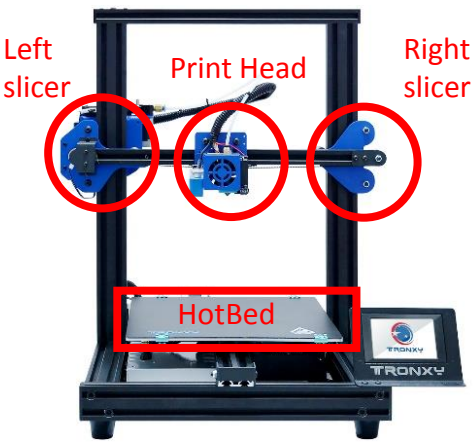
Right slicer

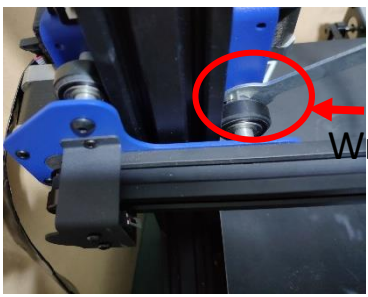


Print Head



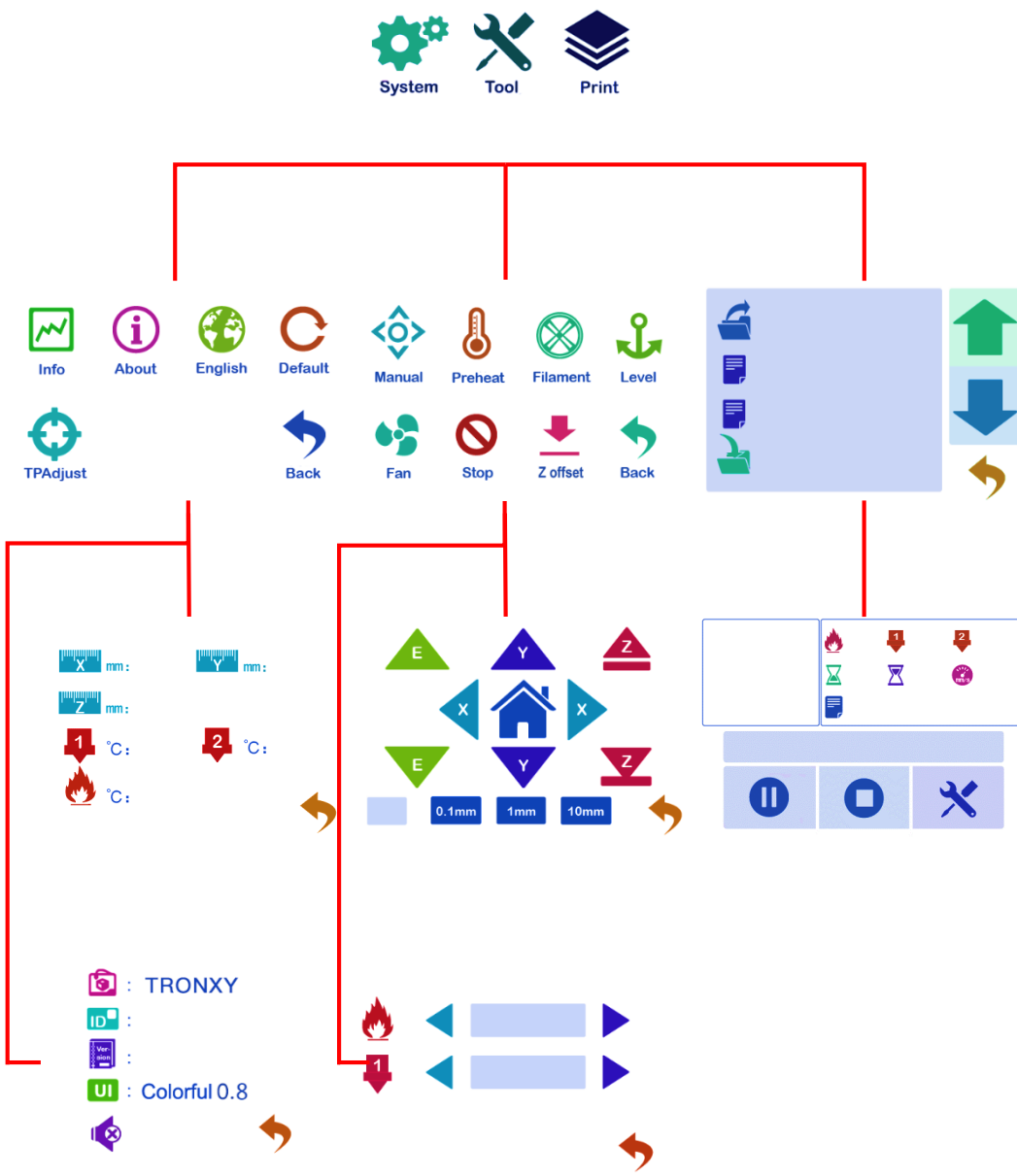
HeatBed





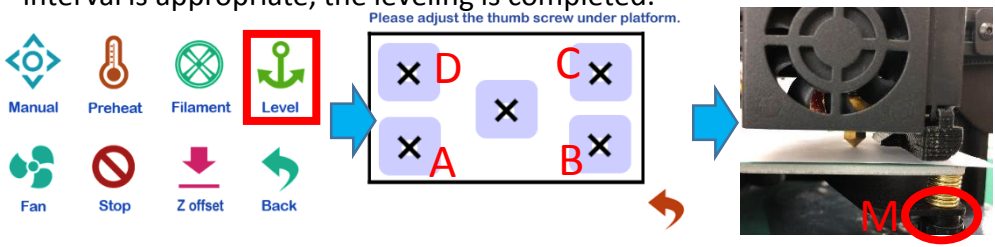
If the structure is loose in other places, you can tighten the screws directly.Before debugging, make sure the machine structure is in a stable and smooth state. You can slide the print head and platform module by hand to ensure smooth and stable sliding before leveling printing.

7. Operation & Print



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 0.8, adjust the leveling nut in the corresponding area, and then reset until all values are less than 0.8, 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.

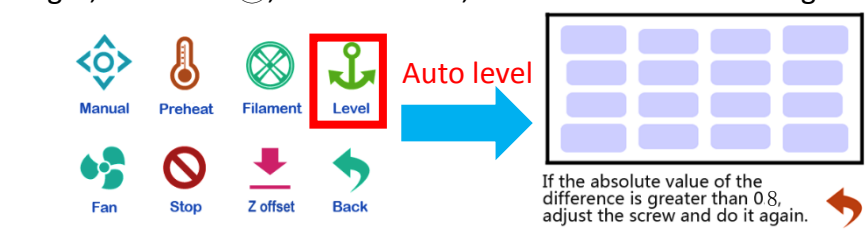
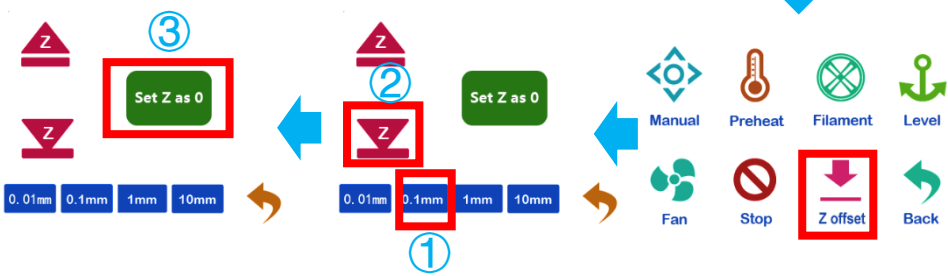
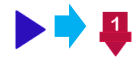


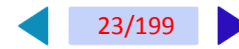
Figure (1)



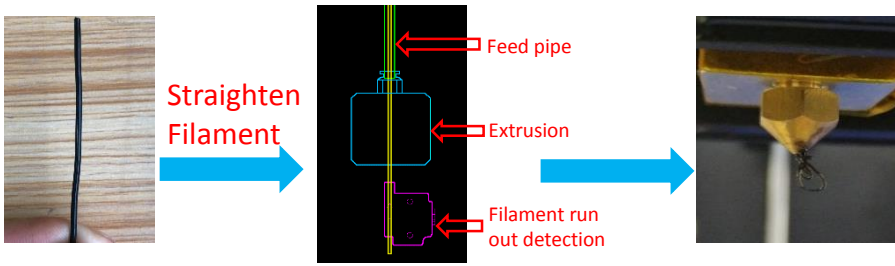
Load and unload filaments：

Click 





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



Print test：

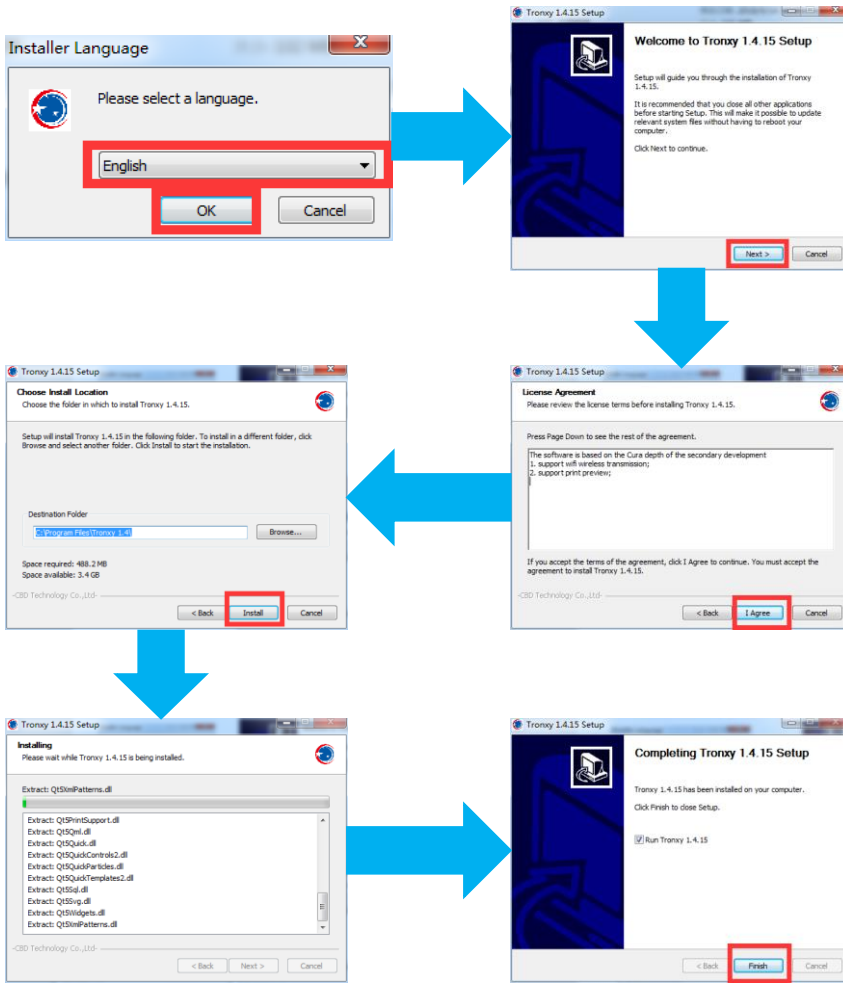
Click 

→"TEST FILE"→  Start printing

If the filaments cannot stick to the first layer when printing, the nozzle will be on the high side. The Z offset value can be appropriately increased when setting the Z offset value, or a lower first layer height can be set when setting the slice.If the feeding of nozzle filament is very small, the nozzle is too low. The z-offset value can be appropriately reduced when setting Z offset or the first layer height can be set higher when setting slice.

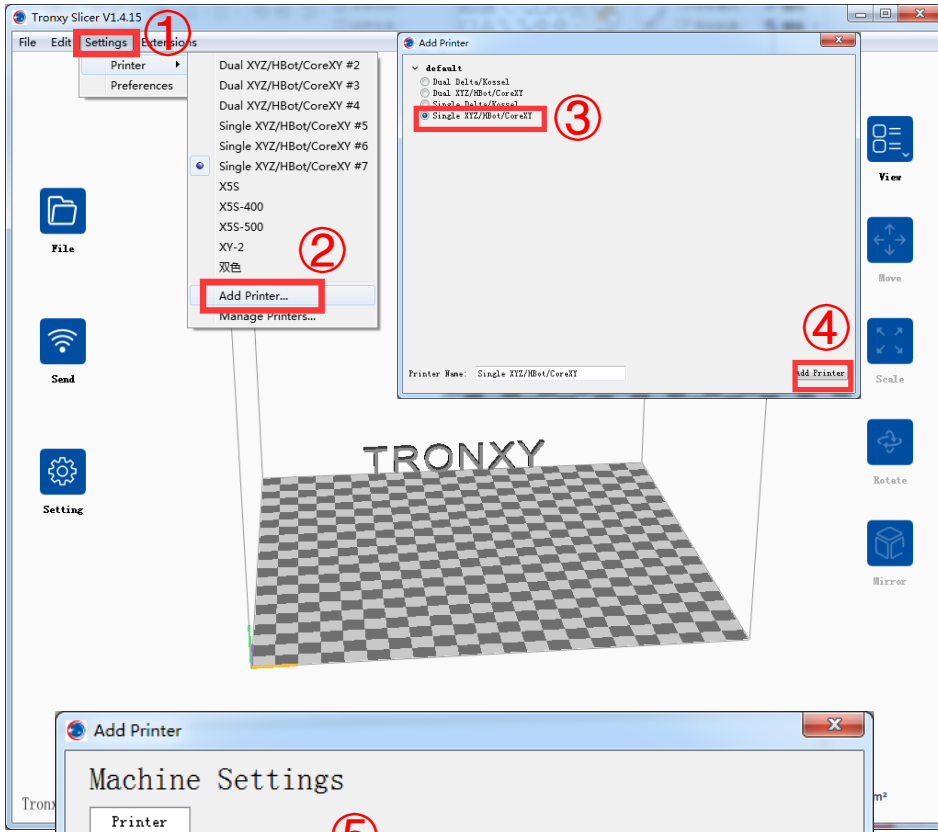
1. Installation

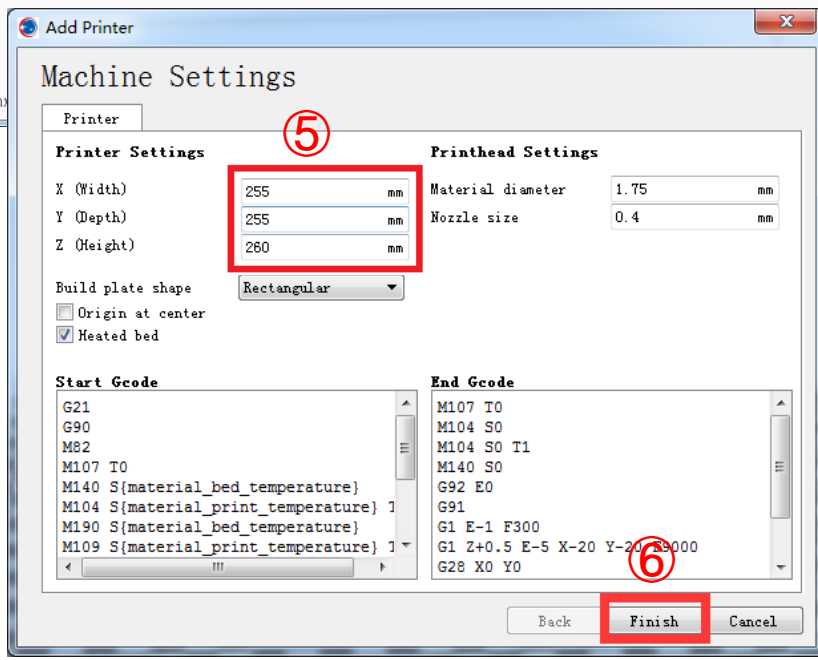
Find out slice software in SD card“TronxyInstall.exe ”double click，
Then follow these steps to complete the installation.



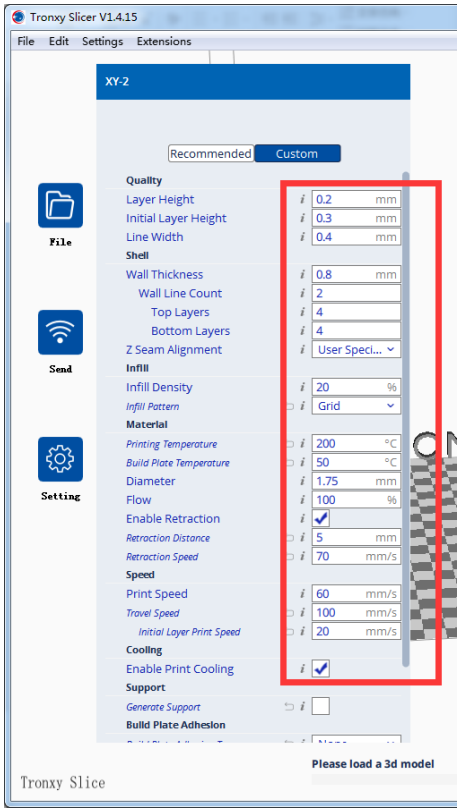
2. How to use slice software

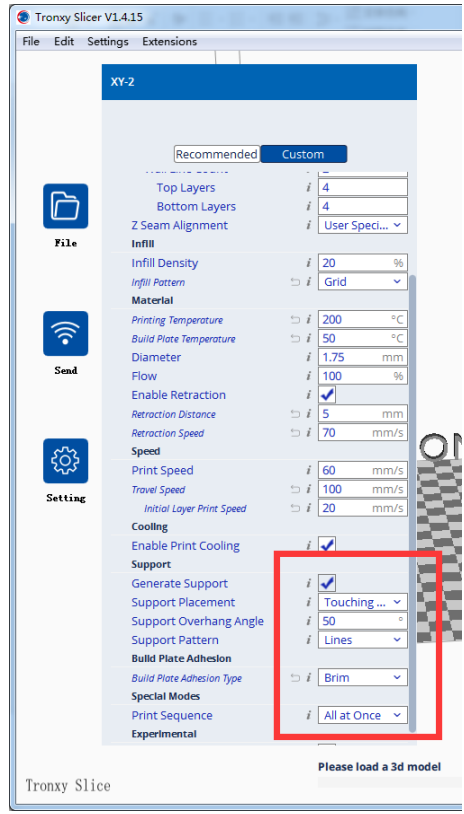
① 、Type setting: follow the steps below to complete the setting.





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 ℃ ABS - 240 ℃
Heatbed temp ： PLA - 50℃ ABS - 80 ℃
Print speed ： 20-150mm/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. Failure 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 ℃ 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 ℃, 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 3 STEP TO FINISH
THE REST INSTALLATION
FILAMENT RUN-OUT DETECTION
RESUME PRINT AFTER POWER-OFF
AUTO LEVEL
ALL METAL

New attack