MINGDA

Magician X2

Instructions for quick assembly
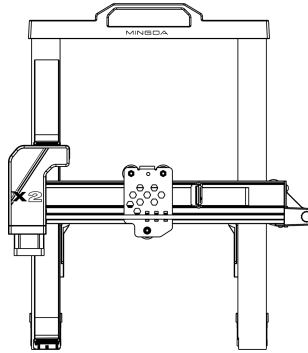
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1 Accessories

Extruder

Gantry
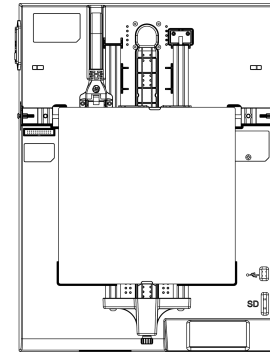
The Main Chassis

Toolkit

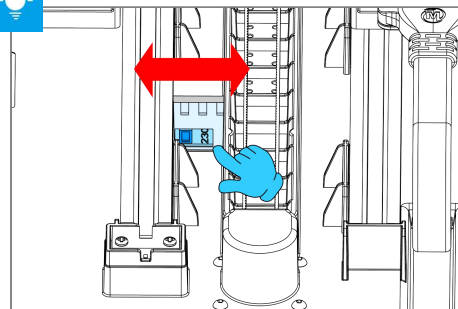|			
1 Filament	2 User manual	3 Filament holder	4 Nozzle
5 SD card	6 Power cable	7 Wrench	8 Allen wrench
9 M5*25 (2pcs)	10 M4*20 (4pcs)	11 M3*8 (2pcs)	12 M4*10 (2pcs)	13 Teflon tube

# 2 Assemble

Step 1 Install the gantry
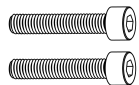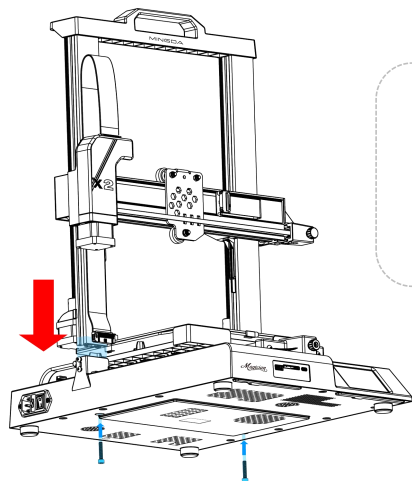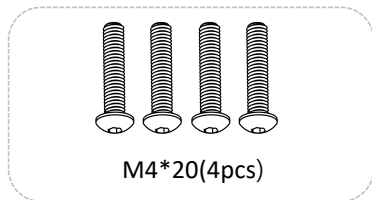
M5*25 (2pcs)

Note: To avoid bending the lead screw and effect the printing model, don't touch or twist the lead screw when take out the gantry from the package.
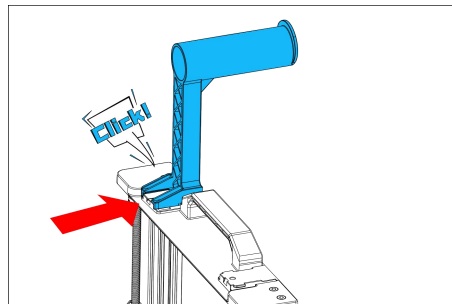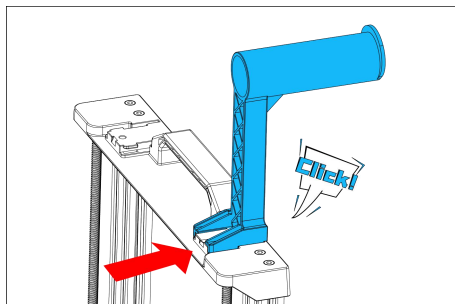
Note: The power supply has been adjusted according to the local voltage. If you need to adjust the voltage, please follow the picture to operate it.

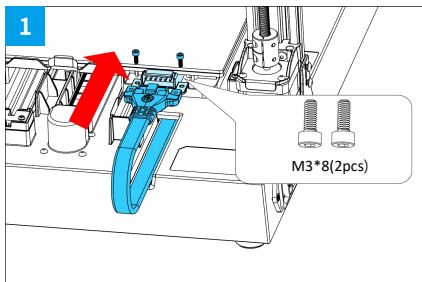**Step 2 Install the fixing plate screw**
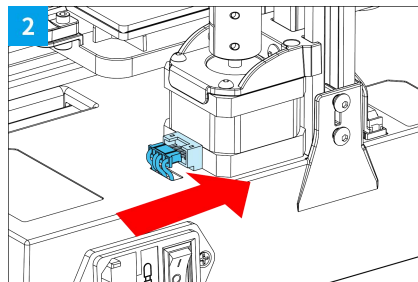
M4*20(4pcs)
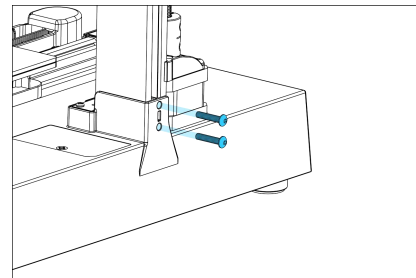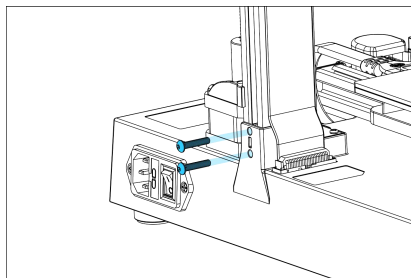
Step 3 Install the Filament Holder

Click!

Click!

The filament holder can be installed left and right

Step 4 Connect Cable
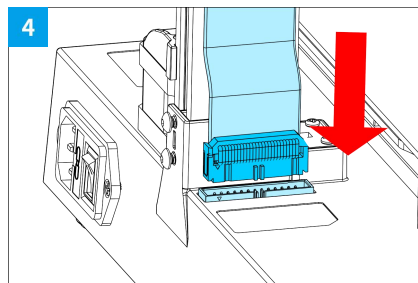

1

M3*8(2pcs)

Hotbed cable

2

Z Motor 1 cable
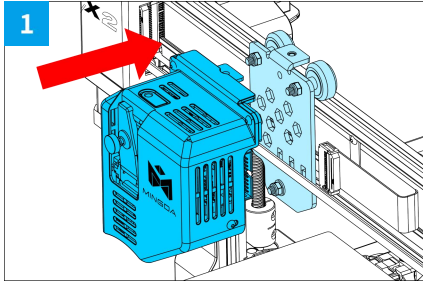

3

Z Motor 2 cable

4
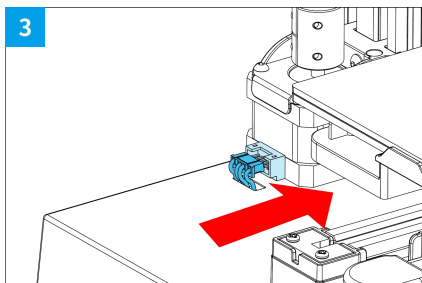
Arranging Wire

Note: **If you find there is a little shaking on extruder,bed or X-axis, don't worry, this is caused by long-term transportation. Please refer to the adjustment video link in the SD card to adjust, it is helpful.**
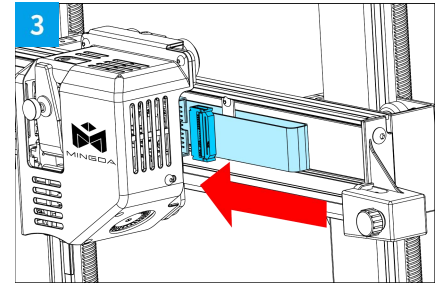
Step 5 Install the Extruder

1

2 M4*10(2pcs)

3

1.Push the extruder parallel into the support, make sure the screw holes on the top of the extruder are aligned with the screw holes on the support.
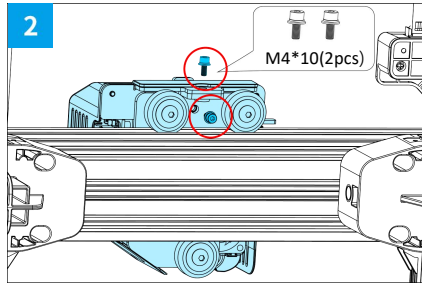
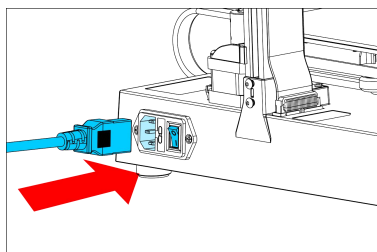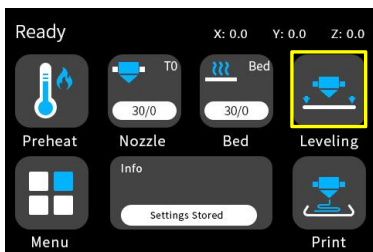2.Use M4*10 screws to fix the extruder on the support.

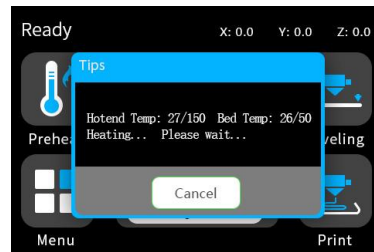3.Connect the ribbon cable to the port on the right side of the extruder.

3 Auto-leveling

Plug in the cable and turn on the power

Click "Leveling" on main interface

The printer will start auto-leveling after preheat.
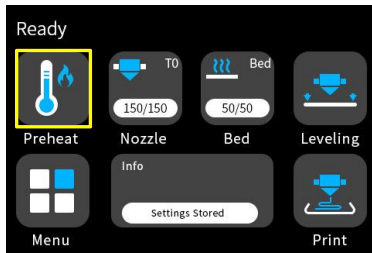
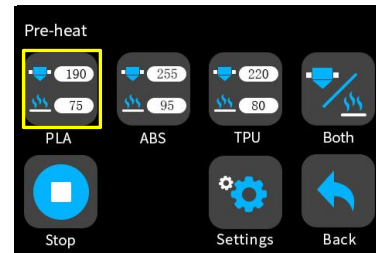**Nota:** le informazioni sull'interfaccia utente sono solo per riferimento, l'interfaccia utente effettiva potrebbe essere diversa.
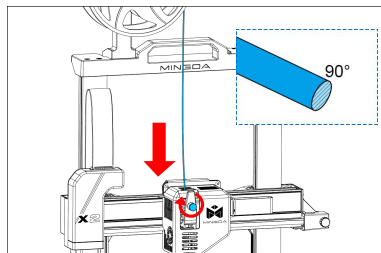
4 Preheat

Click "preheat" on the main interface

According to your filament, select appropriate settings

Nota: le informazioni sull'interfaccia utente sono solo per riferimento, l'interfaccia utente effettiva potrebbe essere diversa.

5 Insert the filament

In order to feed filament smoothly, Please keep the end of the filament at 90°.

Extrude

STOP

E0
0

Load

190/190
Nozzle

Normal

5
5mm

Back

Click "load" to feed the filament until the filament is out of nozzle.

Insert SD card

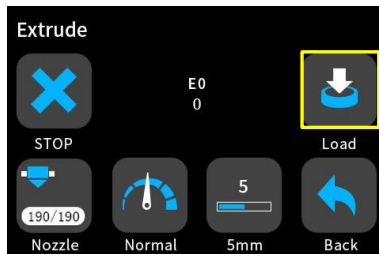**Nota:** le informazioni sull'interfaccia utente sono solo per riferimento, l'interfaccia utente effettiva potrebbe essere diversa.

6 Printing

Ready						SD:						001.gcode					

Ready

Preheat — 210/210 (T0 Nozzle)
Bed — 75/75
Leveling

Info — Settings Stored

Menu

Print

SD:
- 001.gcode
- 002.gcode
- 003.gcode
- 004.gcode
- 005.gcode
- 006.gcode

001.gcode

X:5.00 Y:0.00
1%
T0:190/190 B:50/50
T:00:02:26 Z:42.00

Pause

Stop

Heat Percentage BabyStep More

Select a gcode file to print

Nota: le informazioni sull'interfaccia utente sono solo per riferimento, l'interfaccia utente effettiva potrebbe essere diversa.

09

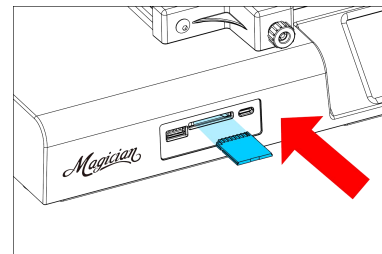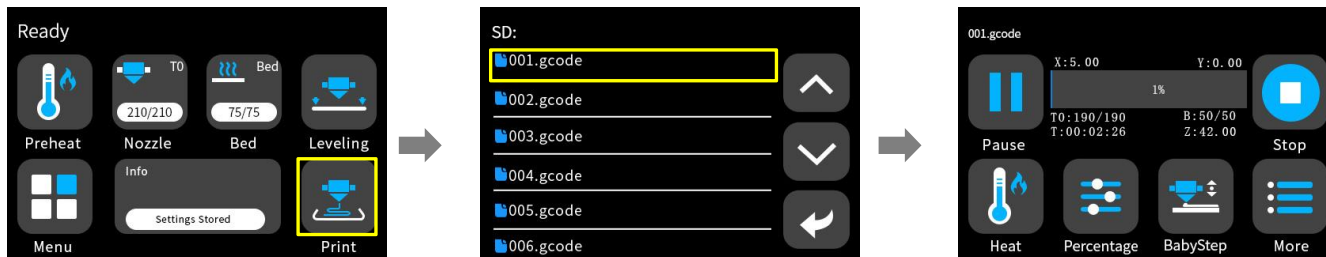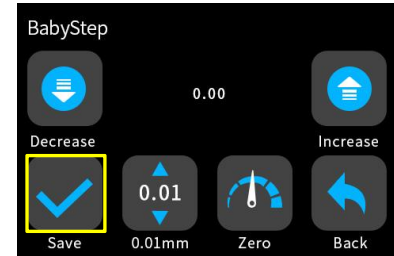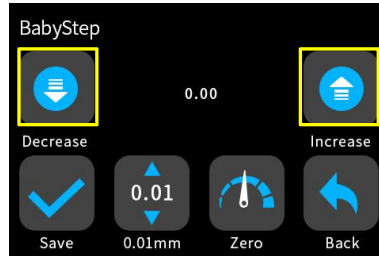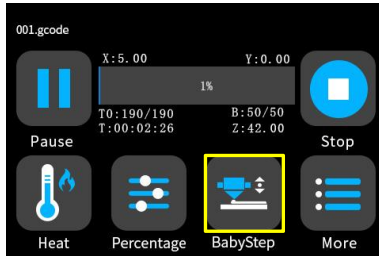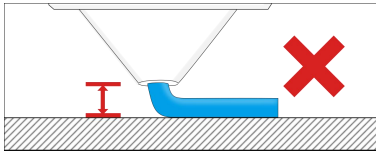# 7 Z-offset adjust



When you start your first printing,adjust the Babystep value according to the adhesion of the filament and the glass platform. Click "Save" to save your setting, and you don't need to adjust the value again next time.
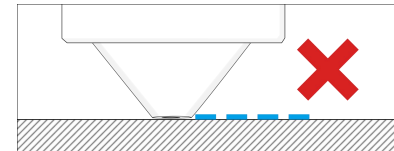[Note: Z-off set use for the first layer only]

If the distance between the nozzle and the platform is too high, the filament will not easy to stick to the platform. Should click "Decrease" until the distance is proper.
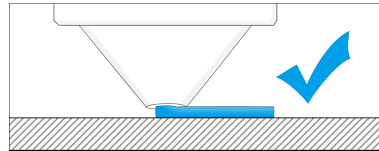
Keep the distance between the nozzle and the hot bed at 0.1mm, the filament will stick to the hot bed evenly

If the distance between the nozzle and the platform is too low, the filament will be not easy to feed out smoothly . Should click "Increase" until the distance is proper.

8 Software Instructions

Magician X2 works with a variety of slicing software, such as Cura, Simplify 3D, Repetier-Host, and more. We will introduce CURA_xx.xx in detail, and you will learn how to set the slicing parameters, which will help you become more familiar with the slicing software and print your first model successfully.
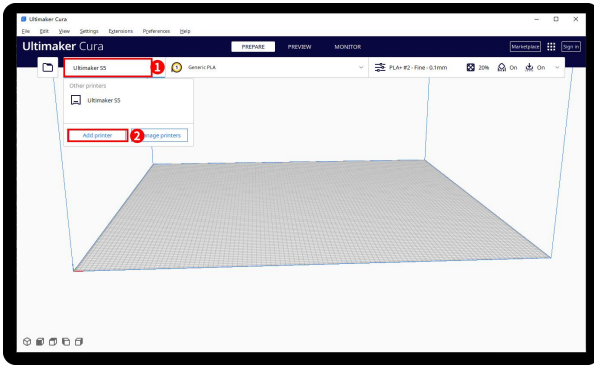
First, you can find the CURA_xx.xx from the SD card, and install it on your computer.
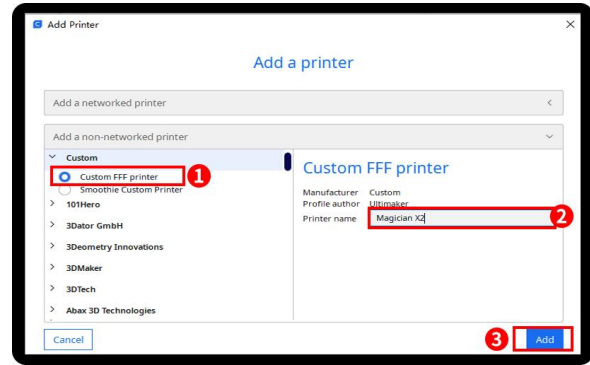
Install CURA

1. Double click Cura_xx.xx.exe to install
2. Install the software by default as follows.
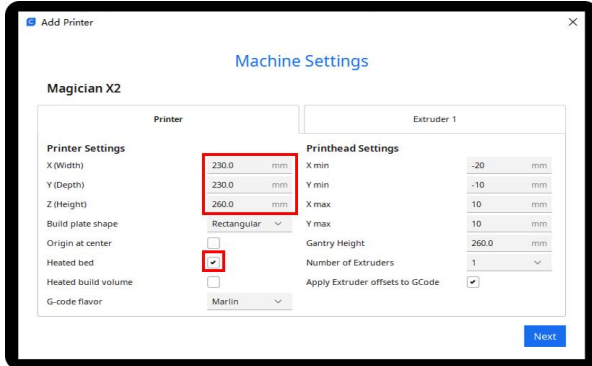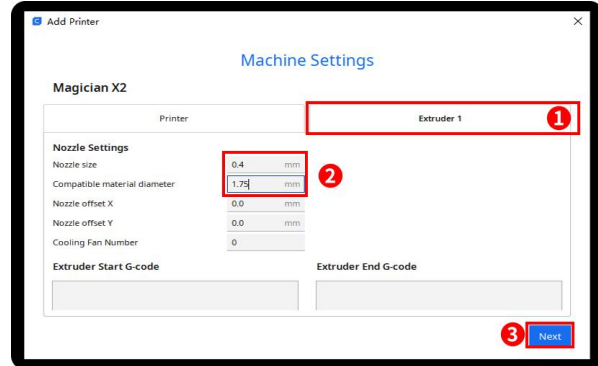
Step 1 Add Printer
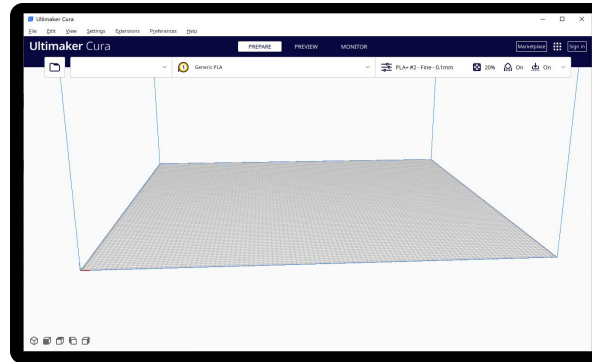
Click Add printer

Choose Custom[Custom FFF printer], insert Printer name for example Magician X2,and Click Add
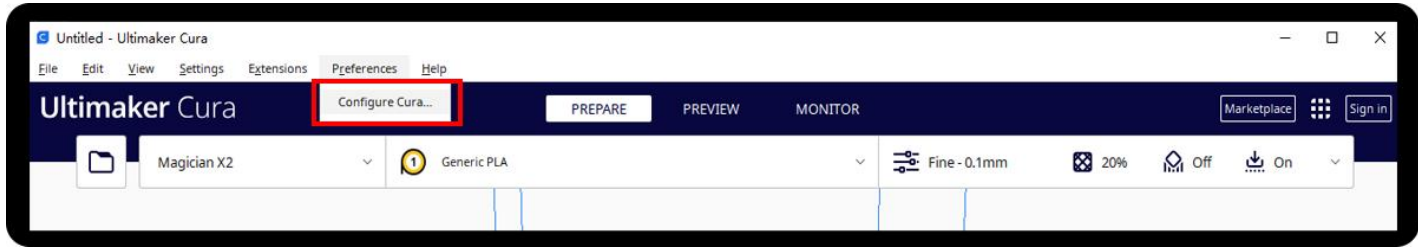

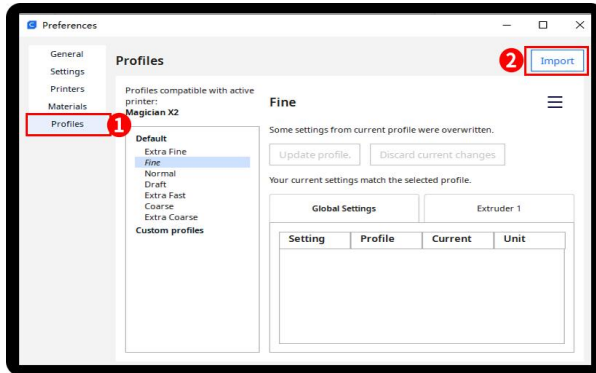Insert print size, X230 Y230 Z260, select Heated bed

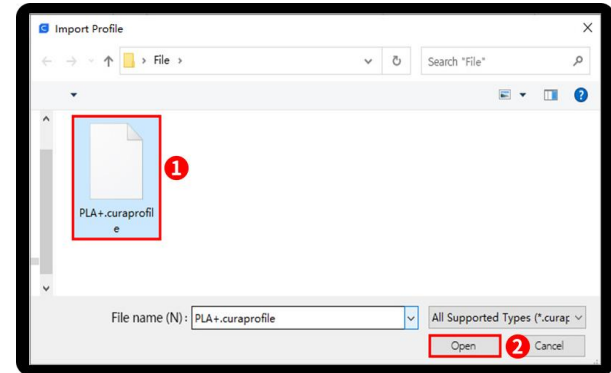Click Extruder 1, nozzle size 0.4mm, Compatible material diameter 1.75mm, Click next
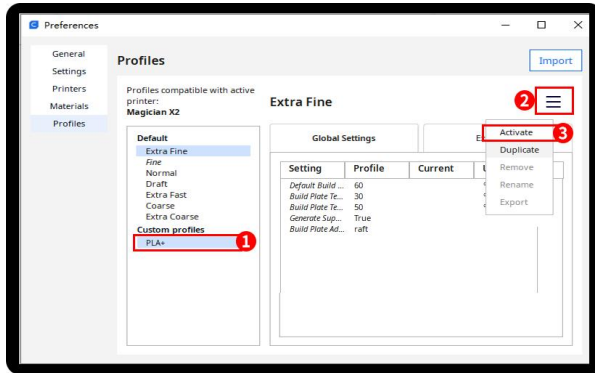
Step 2   Import Configuration file

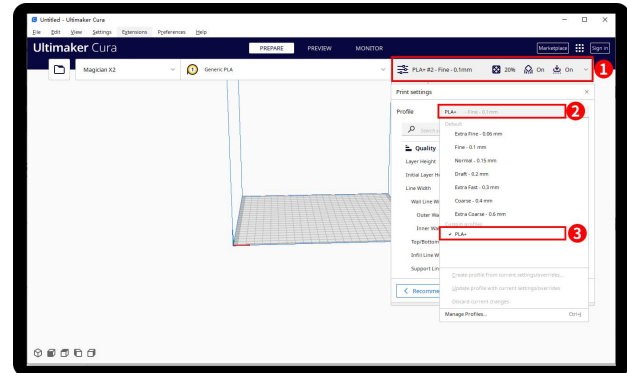Click Preferences, Configure Cura…
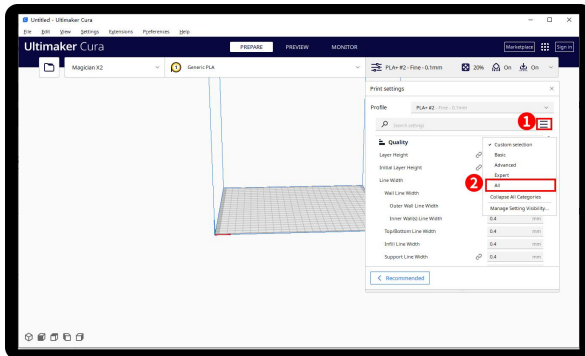

Click Profiles, Import

Choose PLA+.curaprofile in SD card
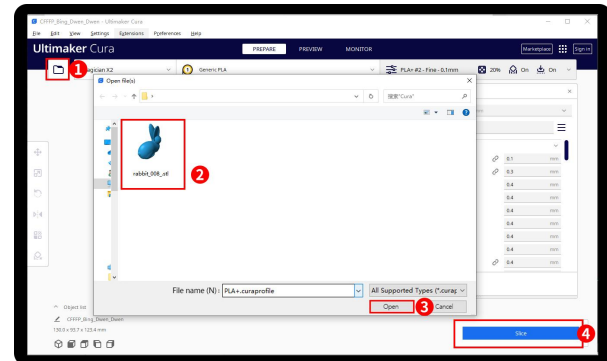
After Import the profile, you will see it below,
choose PLA+, and click Activate
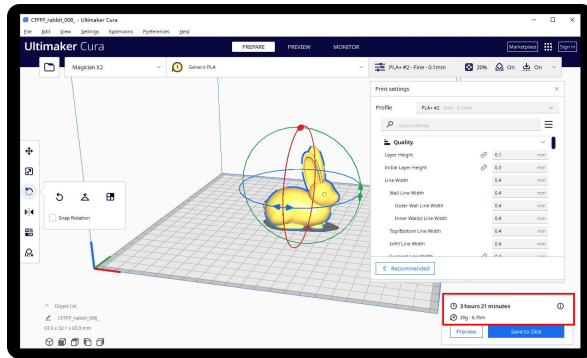

On the right side you can see PLA+ active

Click here, you can check all the parameter, when you move mouse
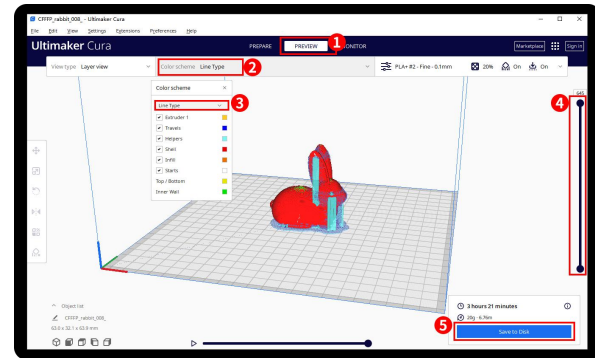on it will show the explanation to help you under more clearly

Step 3 Slicing

Click load button you can load a stl file, you can move,
rotate, and Zoom the model. Click Slice button.

After slice completed, you can see the time and weight of material that the printing will take;

We suggest you click PREVIEW to check, you can choose line Type and Drag the slider on the right side to see the printing process clearly. After that , you can save it in your SD card to print it out by the printer.

For detailed warranty policy, please visit
http://www.3dmingda.cc/single/request_after_sales_service.html

For support ,please visit our Youtube Channel
https://www.youtube.com/channel/UC6PO64H7CfQtBy4H-fSRM4A?view_as=subscriber

Or you can visit our Facebook group at
https://www.facebook.com/groups/1018823731846578

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