TRONXY

X5SA-2E
USER'S MANUAL

Thank you for choosing TRONXY products!

We will serve you whole heartedly!

Please read the instruction carefully

Please visit tronxy.cn for more information

After- sale service：support@tronxy.com

TEL：+86-755-89968500

Relevant information is stored in SD card,please check

Pay attention

Please read this instruction carefully and follow the safety instruction.

When the 3D printer is working, it will produce high temperature.Do not touch working parts or extruder directly.After printing, the working part may still be in the high temperature state.Please wait patiently for the working parts and the print model to cool down before removing the model from the print platform.

Please use the 3D printer in a spacious and well-ventilated environment.

The recommended ambient temperature for 3D printers is 8° c-40 °C, and the humidity is 20%-80%. Using outside this range may bring bad printing effects.

In case of emergency, could turn off the power of the 3D printer directly.

3D printers contain working parts that move at high speeds, so be wary of pinching your hands.

When removing the model from the print platform, be careful not to swipe sharp objects at your finger.

Assemble the 3D printer or polish the model. suggest Wear goggles.

Please pay attention to the protection of 3D printer against rain and moisture.

Keep children away from the machine when it running
It is not recommended to run a 3D printer when left unattended.

Catalogue

1. Machine parameter

Print parameters

Print principle: FDM (Fused deposition molding)

Print size: 330× 330×400 (mm3)

Print accuracy: 0.1-0.4 mm

Positioning accuracy: X/Y 0.00625mm ，Z 0.0125mm

Nozzle quantity: 1

Nozzle size: 0.4 mm

Print speed: 20~100mm/s (suggest 60mm/s)

Moving speed: 100mm/s

Filament: PLA, TPU, ABS, wood, pc,HIPS, wooden filament etc.

Temperature parameters

Environmental temp: 8℃ - 40℃

Nozzle temp: Max260℃

Heat bed temp: support

Software

Slice software: Cura Tronxy

Input format: .STL .OBJ

Output format: GCode

Connection: TF card, USB cable(Suitable for skilled users)

Power supply

Power input: 110V/220V AC, 50/60Hz

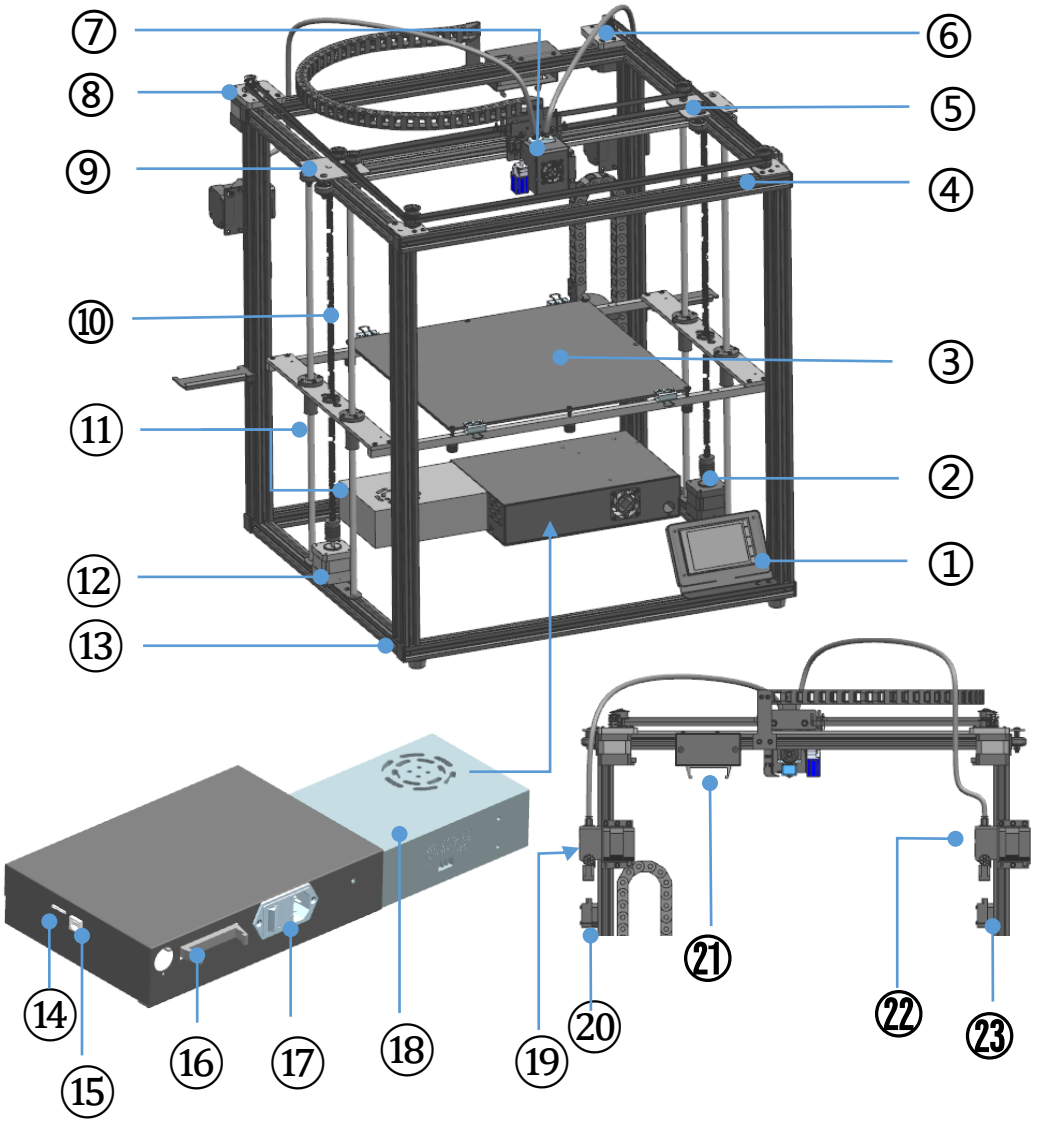
Power output： 24V/15A DC

Physical parameter

Machine size: 580mm×645mm×660mm

Machine weight: ~14.5kg

2. Introduction to machine structure



1.Touch screen	2.Z1motor	3.Heatbed	4.Y axis switch	5.Y right slider	6.X motor
7.extruder head	8.X motor	9.Y left slider	10.lead screw	11. polish rod	12.Z2motor

13.aluminum frame	14.TF interface	15USB interface	16.PIN line interface
17.power switch	18.power supply	19.E1-Titan extruder	20.filament run-out detection

21.switch lines box	22.E2-Titan extruder	23.filament run-out detection

3. Packing list

				
2040 aluminum profile 530mm 4pcs	2020 aluminum profile 484mm 1pcs 530mm 4pcs 460mm 4pcs	footlock/beam 2pcs	L eft retrn board Right retrn board	polished rod 528MM 4pcs lead screws 453MM 2pcs
				
print head	left /right belt pulley parts	X/Y axis motors	Zaxis motor parts	Titan extruder 2pcs
				
component bag 1pcs	controller & touch screen	belt bag	filament (Color random)	power line
				
seal (Color random)	heat bed	aluminum plate with balck sticker	screws bag 4pcs	shovel (Color random)
				
USB cable	Tools bag	reader+TFcard	drag chain parts 1pcs	Y axis switch
		**After receiving the goods, please check the accessories according to the packing list. If you have any questions, please contact customer service.**		
Filament sensor				

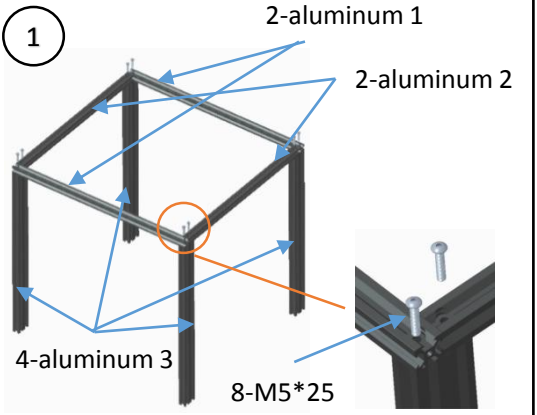
4. Installation instructions

Step 1：base frame assembly

Assembly material specification and quantity：

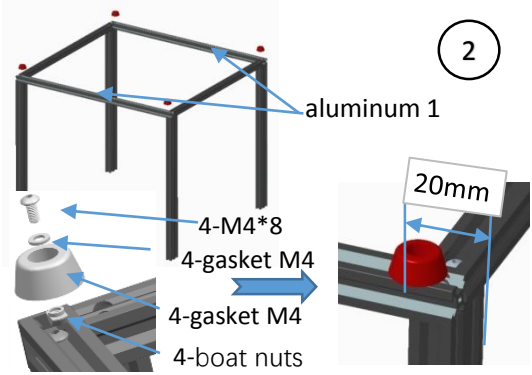
			
aluminum 1 20*20*530 4pcs	aluminum 2 20*20*460 2pcs	aluminum 3 20*40*530 4pcs	foot pad Φ20*12 4pcs
			
screws RM4*8 4pcs	gasket M4 4pcs	boat nuts M4 4pcs	scews RM5*25 12pcs

1



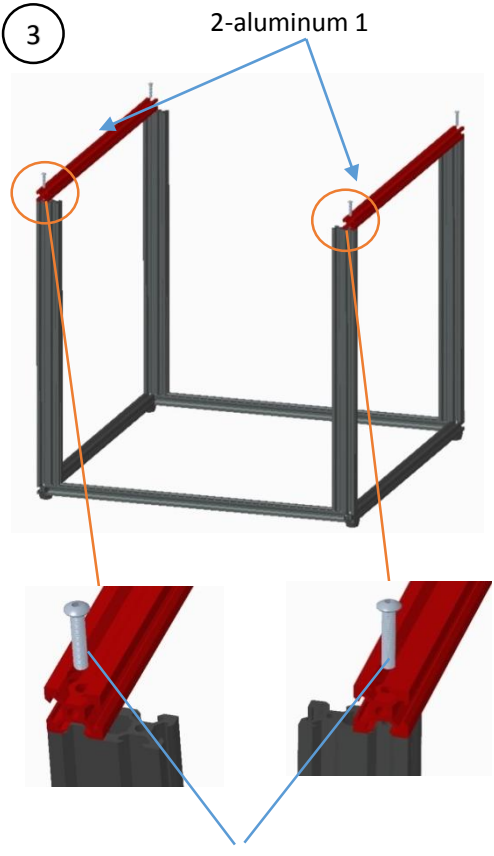
Assembly tips for M4 ship nut: first align the M4 nut with the aluminum profile slot, put it into the aluminum profile slot, use a screwdriver to reverse loosen, release the M4 ship nut over the aluminum profile slot, and then tighten it forward.

2



Note: do not lock the screw to facilitate subsequent adjustment.

3



Step 2: Sliding plate assembly

Assembly material specification and quantity：

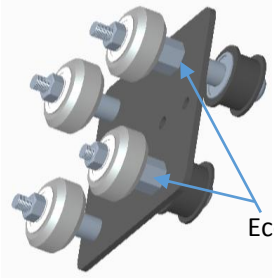
				
base frame 1pcs	aluminum 2 20*20*460 2pcs	left sliding parts 1pcs	right sliding parts 1pcs	screws RM5*25 4pcs

1.Take out thealuminum 2 and put it into the left and right sliding parts respectively, as shown in the figure.

2.Note the direction of the slide. The front of the slide should be on the same side as the counterbore of the guide, as shown in the figure.

1

Pay attention the direction of the counterbore

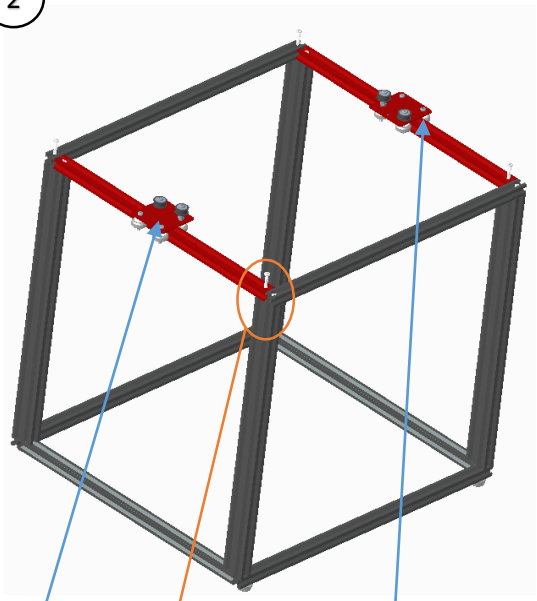


Eccentric nut

Note: slide the slider without shaking
No gap, smooth sliding

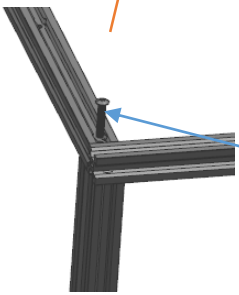
Screw RM5*25 do not lock the Y-axis aluminum profile 2 to facilitate subsequent adjustment

2



left sliding parts

right sliding parts



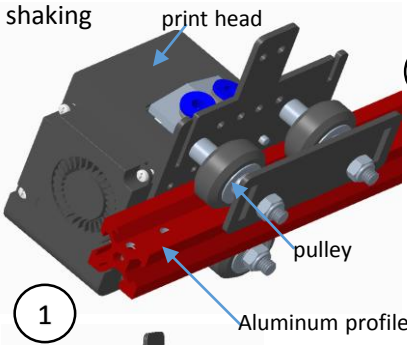
4-M5*25

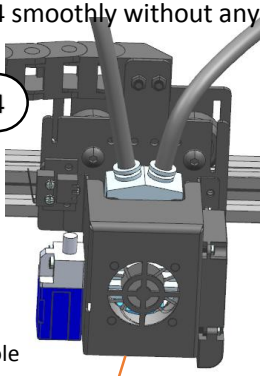
Step 3：Print head assembly

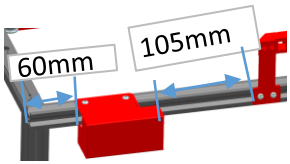
Assembly material specification and quantity：

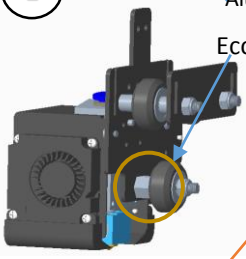
				
basic frame 1pcs	aluminum 4 20*20*484 1pcs	Print head parts 1pcs	drag chain plate 1pcs	screws RM4*20 4pcs

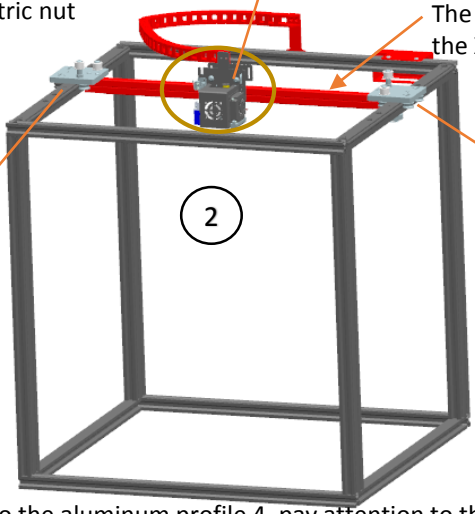
As shown in Figure 1, the pulley on the print head penetrates into the sliding slider of aluminum profile 4 smoothly without any gap shaking

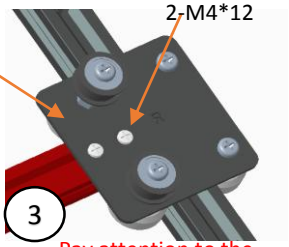




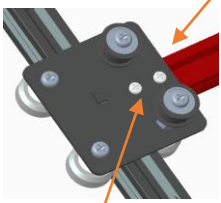








Pay attention to the smooth adjustment: please turn the eccentric nut on the left / right sliding plate to make the sliding plate smooth without gap



1.Insert the print head into the aluminum profile 4, pay attention to the M4 screw hole direction, as shown in Figure 1

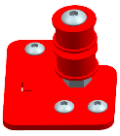
2.Install the x-axis aluminum profile assembly into the underframe to align the hole position, screw on the screw RM4 * 12 and do not lock it temporarily, as shown in Figure 2

3.Move the left and right sliders, after confirming that the x-axis aluminum profile component moves flexibly, lock the RM4 * 12 screw

4.After adjustment, lock the RM5 * 25 screw on the y-axis guide rail, and move the x-axis aluminum profile assembly again. Please adjust repeatedly to ensure that the slide plate moves flexibly without any space shaking after locking the screw.

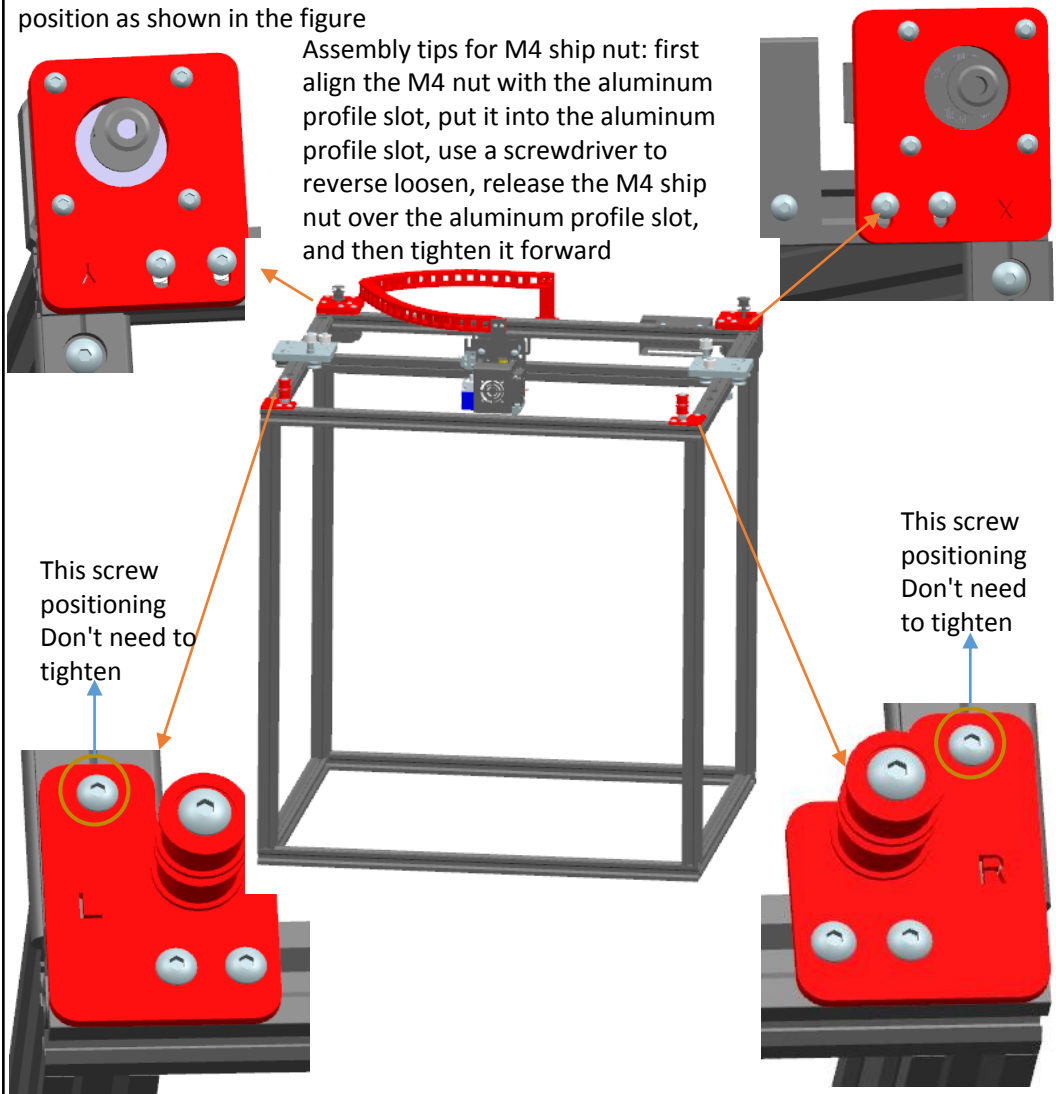
Step 4：XY axis motors and wheels assembly

Assembly material specification and quantity：

				
basic frame parts 1pcs	right wheel parts 1pcs	left wheel parts 1pcs	X motor 1pcs	Y motor 1pcs

1. Lock and fix the assembled parts in the position as shown in the figure

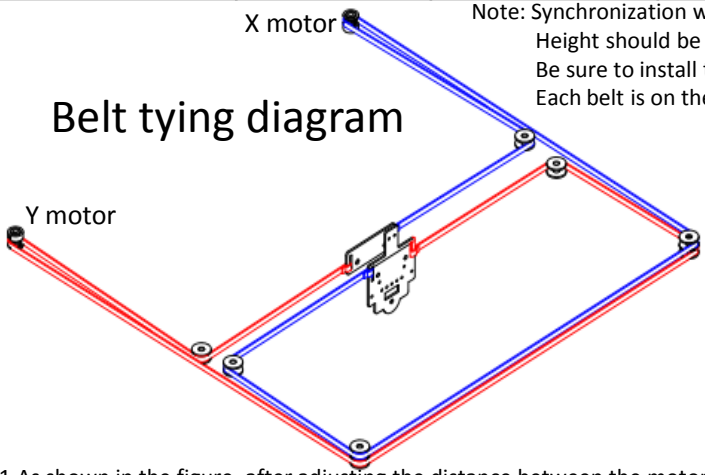
Assembly tips for M4 ship nut: first align the M4 nut with the aluminum profile slot, put it into the aluminum profile slot, use a screwdriver to reverse loosen, release the M4 ship nut over the aluminum profile slot, and then tighten it forward



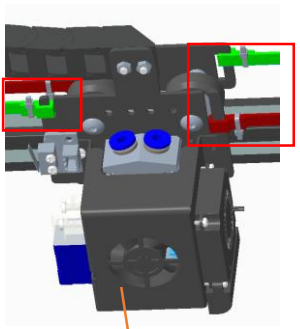
Step 5：Belts assembly

Assembly material specification and quantity：

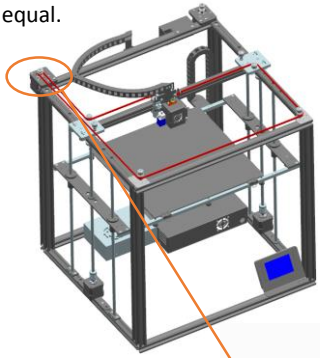
				
basic frame 1pcs	Belt 2pcs	Ties		

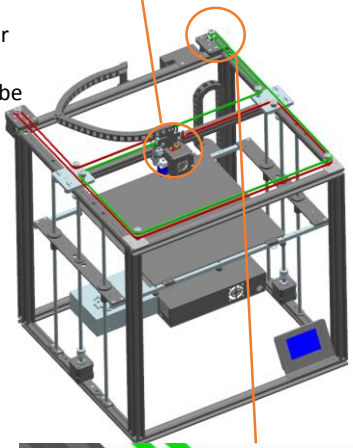


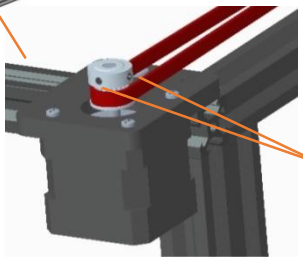
Note: Synchronization wheels on X, Y axis motors
Height should be adjusted by itself.
Be sure to install the belt
Each belt is on the same planeUp.



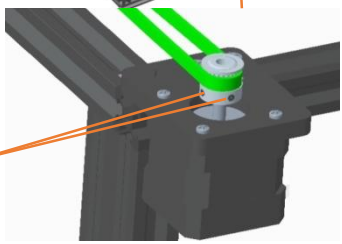
1.As shown in the figure, after adjusting the distance between the motor gear and the belt, lock the 2 rice screws on the gear.
2. Also assemble the second belt, the tension of the second belt should be equal.





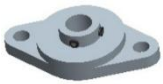


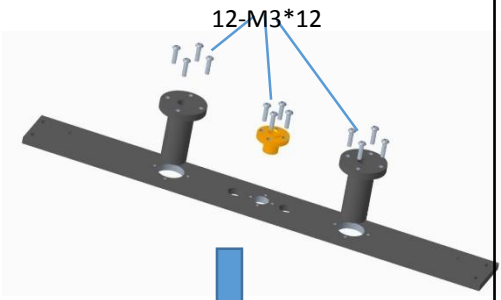
4-M3*3

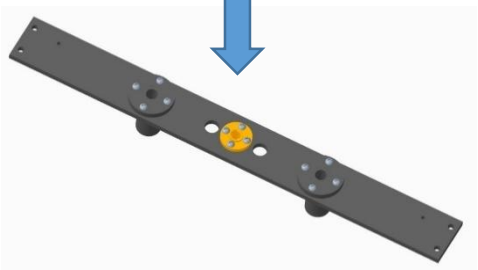


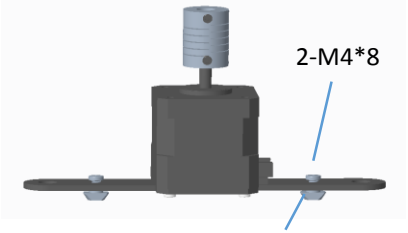
Step 6：Linear bearing assembly

Assembly material specification and quantity：

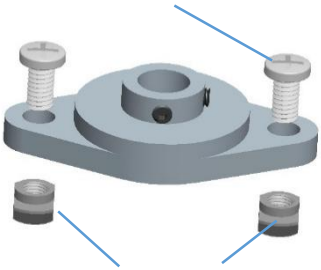
				
beams 2pcs	Linear bearing 4pcs	copper linear bearing 2pcs	screws RM3*12 24pcs	bearing base parts 2pcs
				
screwsRM4*8 8pcs	boat nuts M4 8pcs	Zaxis motor parts 2pcs		







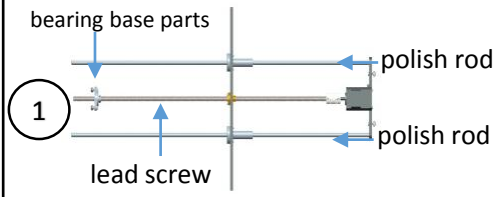
Bearing pedestal installation: 2 sets in total



Step 7：Z axis parts assembly

Assembly material specification and quantity：

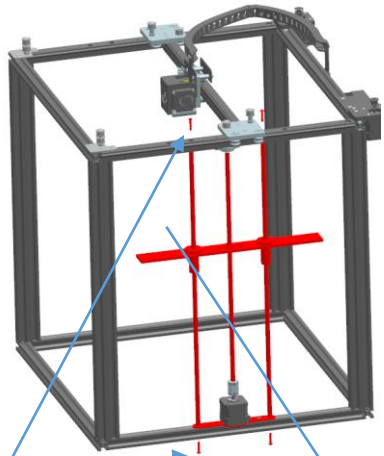
				
basic frame 1pcs	Z axis motor parts 2pcs	foot lock parts 2pcs	bearing base parts 2pcs	polish rod Φ8*528 4pcs
				
lead screwT8*453 2pcs	screws RM4*20 8pcs	screws RM4*8 4pcs	Dφ5*dφ4.2*1 Shim	



1

As shown in Figure 1, assemble the assembly, put the assembly into the frame as shown in Figure 2, and align the holes to lock the screws.

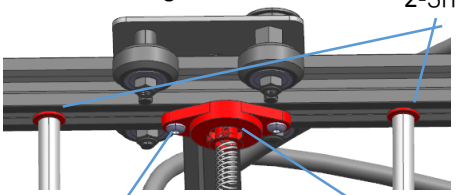
2

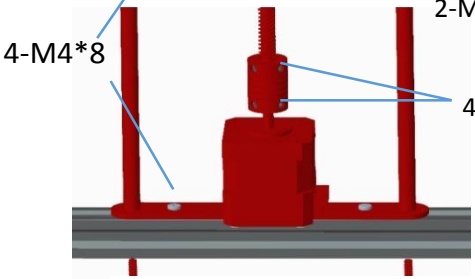


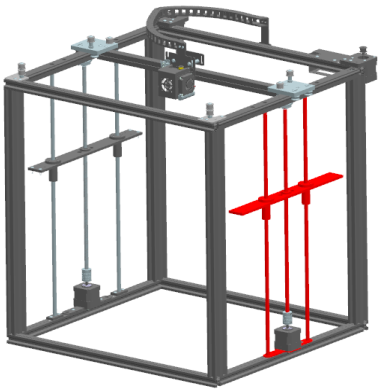
M3 hole is on the outside

3

Adjust the verticality of the polished rod and tighten the screws

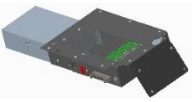






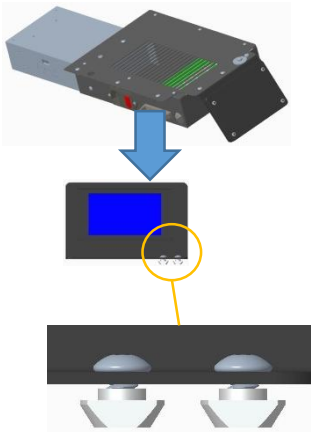
Step 8：Controller box assembly

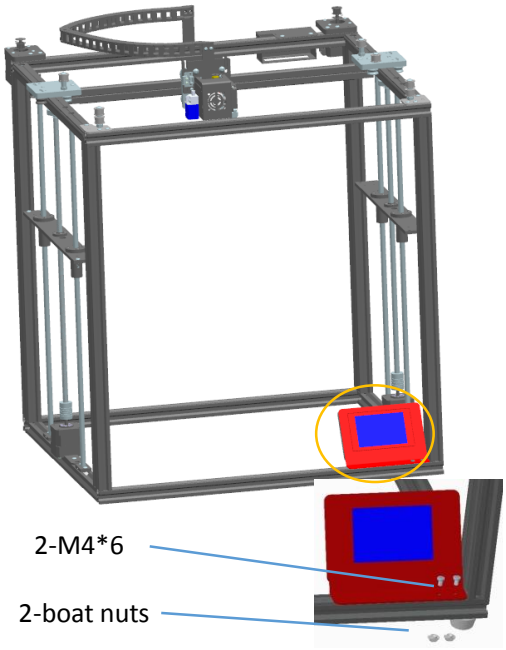
Assembly material specification and quantity：

				
basic frame 1pcs	Z axis motor parts 2pcs	screws RM4*6 2pcs	boat nuts M4 1pcs	

Separate the screen from the host and
Fix the M4 boat nut on the bottom rack as shown

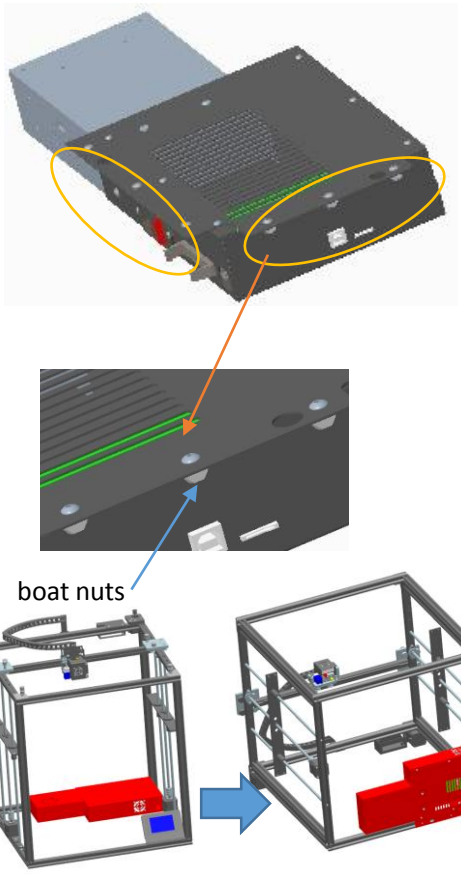
1





2

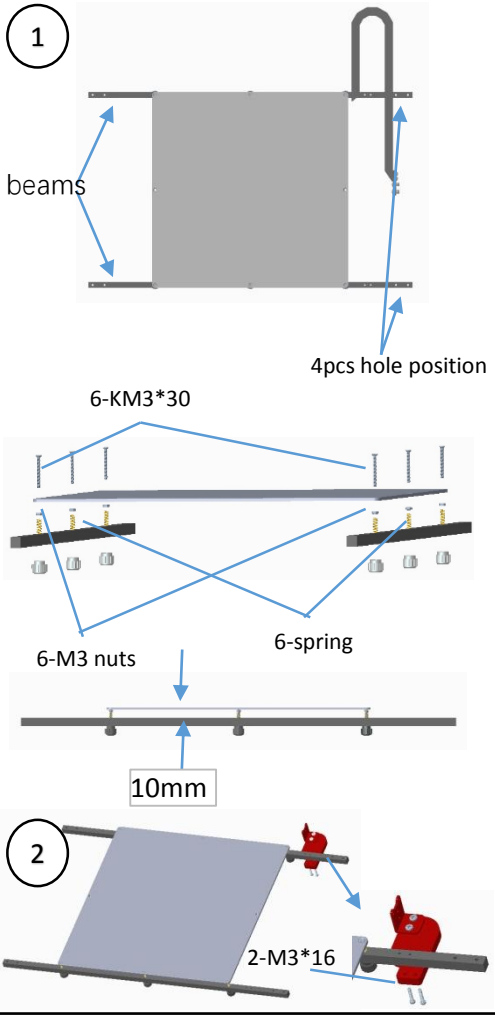
Fix the boat nut on the main box to the bottom shelf with the locking L corner code, as shown in the figure



Step 9：Print plate assembly

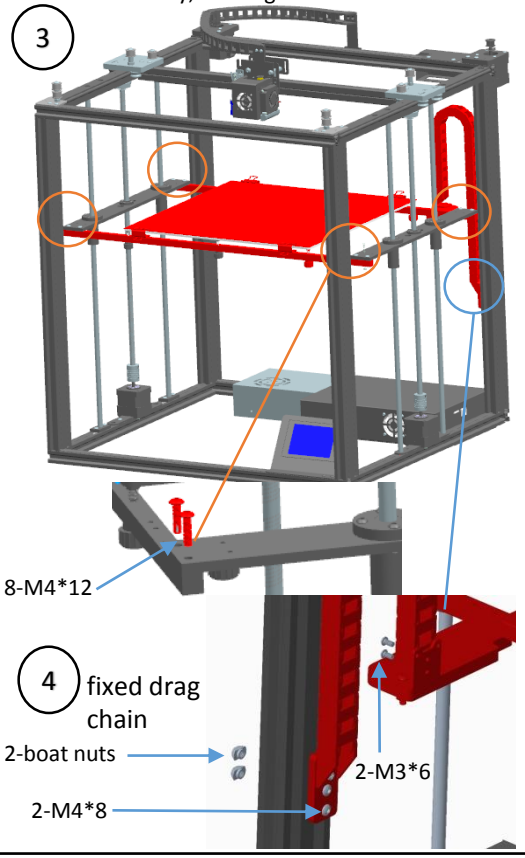
Assembly material specification and quantity：

				
basic frame 1pcs	heat bed parts 1pcs	beams 2pcs	plastic nuts M3 6pcs	screws RM3*16 2pcs
				
spring 6pcs	nuts M3 6pcs	screws KM3*30 6pcs	screws RM4*12 8pcs	drag chain parts 1pcs



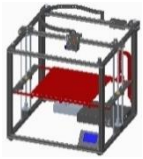
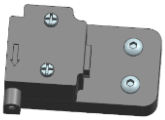
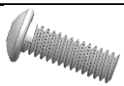
Place the left and right horizontal plates on the same plane, and lock the hot bed assembly on the horizontal plate according to Figure 3. Fix the towline bracket according to Figure 4.

Adjust the hot bed to the left and right level, move up and down smoothly, then tighten the screws

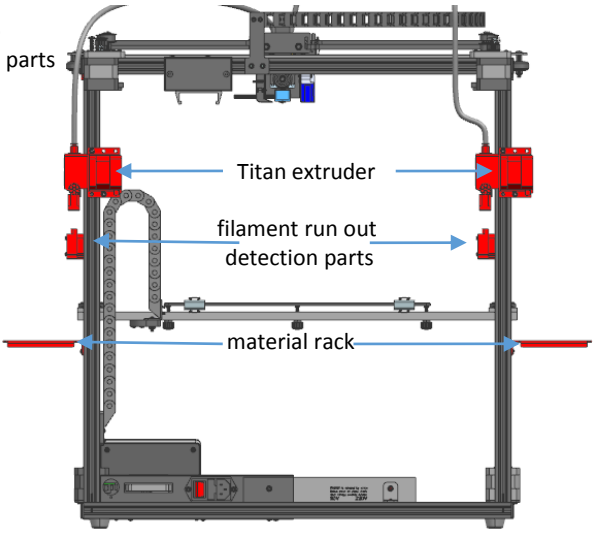


Step 10：Feeding motor assembly

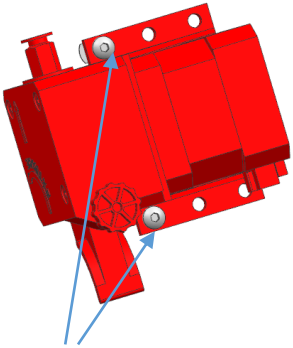
Assembly material specification and quantity：

				
basic frame 1pcs	filament run out detection parts 2pcs	Titan extruder 2pcs	screw RM4*6 8pcs	boat nuts M4 12pcs
				
screw M4*12 4pcs	material rack 2pcs			

Assemble Titan extruder to filament runout detection parts

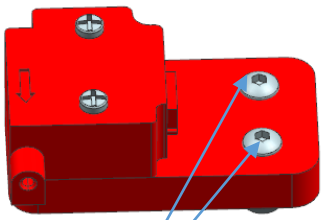


Titan extruder



2-M4*6+boat nuts

filament run out detection parts



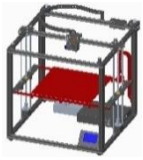
2-M4*12+boat nuts

material rack

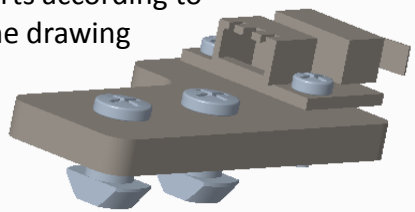
2-M4*6+boat nuts

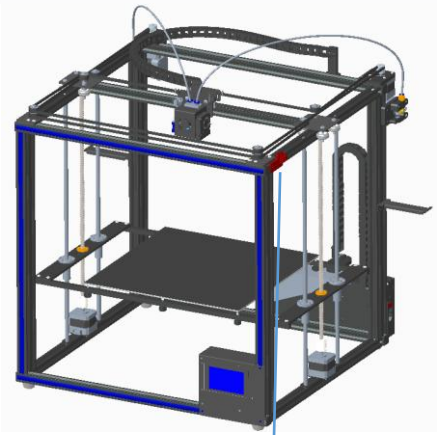
Step 11：Assembly of limit switch and end cover

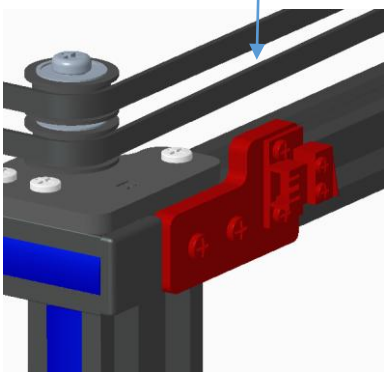
Assembly material specification and quantity：

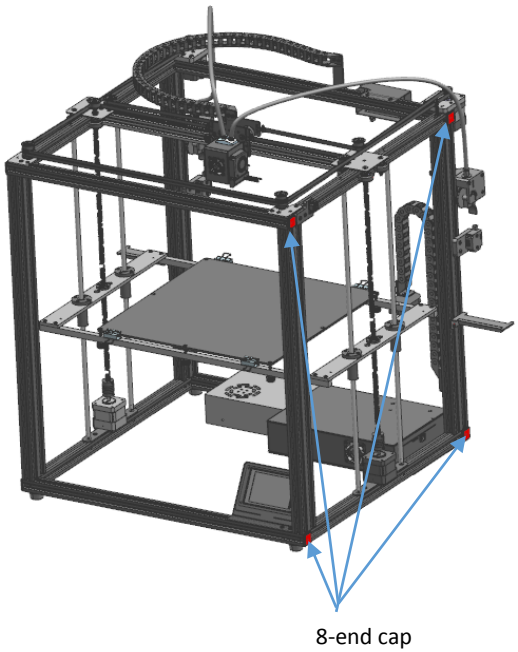
				
printer 1pcs	Y axis switch lpcs	end cap 8pcs	boat nuts M4 4pcs	screw PM4*8 4pcs

Assemble the parts according to the drawing









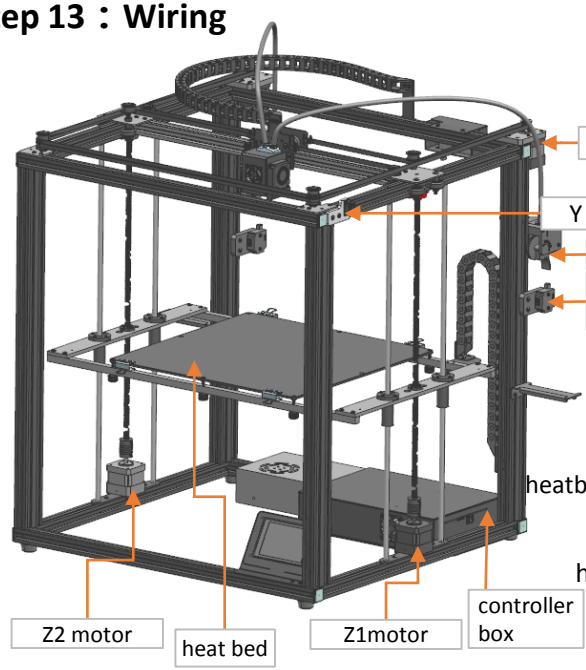
8-end cap

Step 12：Black sticker and seal assembly

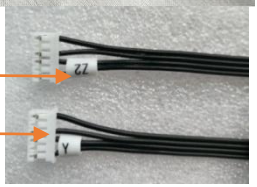
Assembly material specification and quantity：

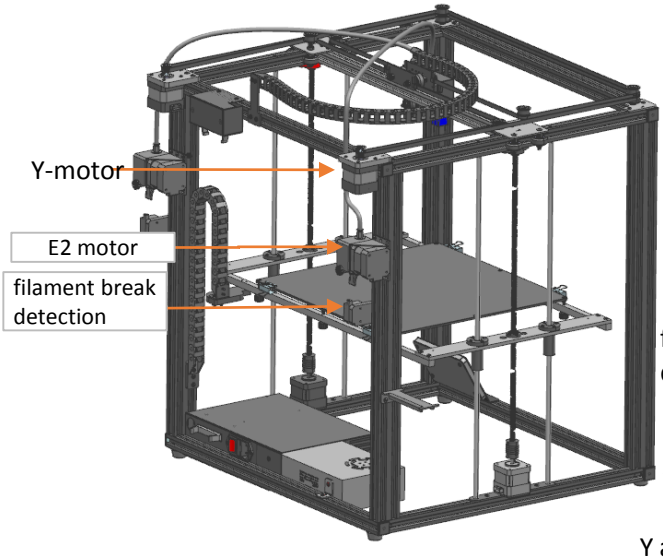
				
printer 1pcs	seal	clips		

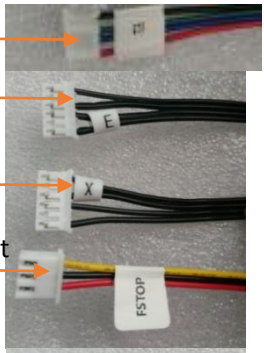
Step 13：Wiring

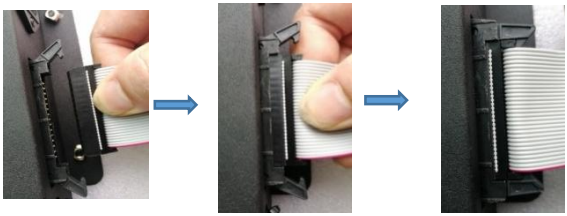


controller box

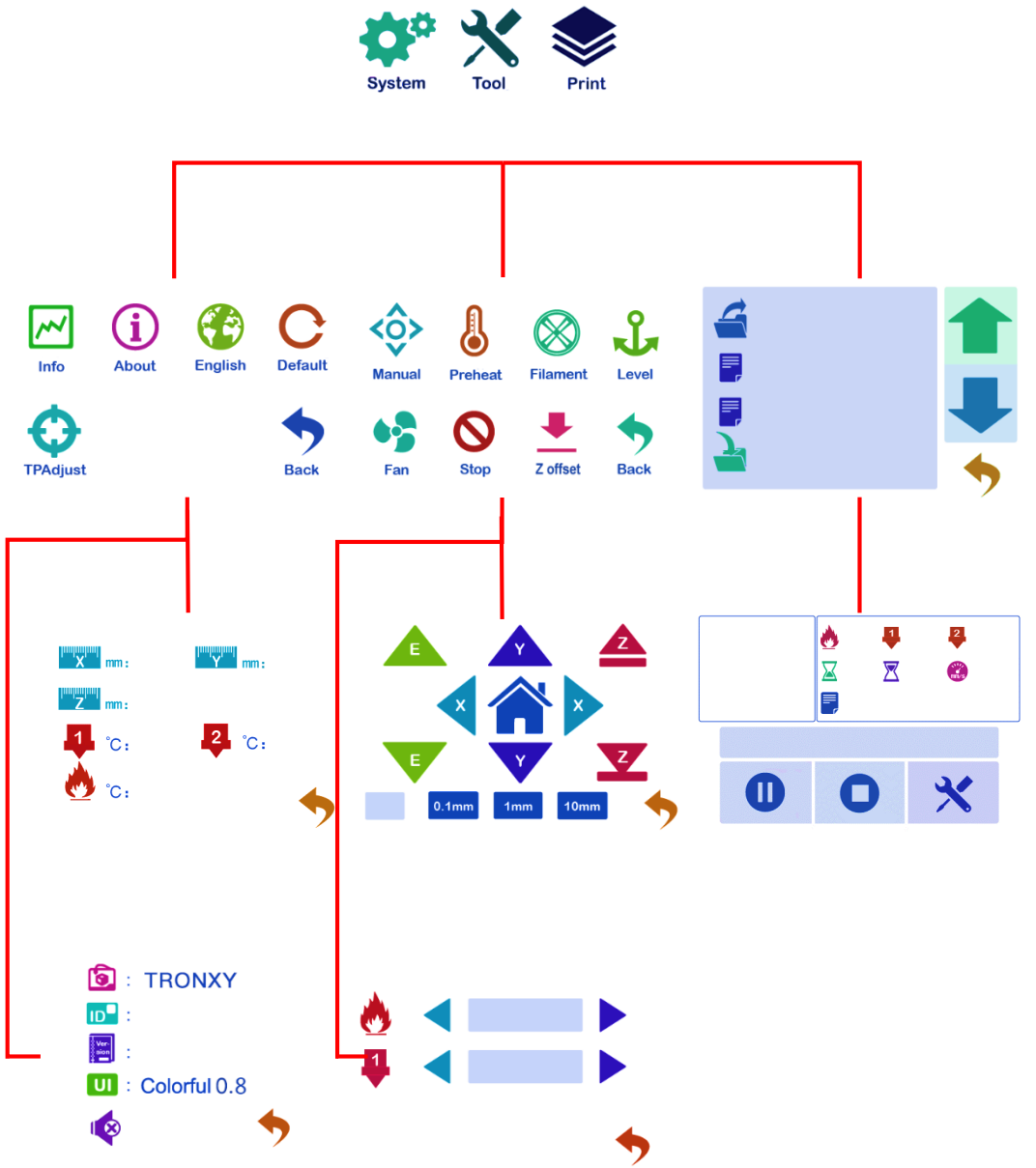








5. Interface operation and printing



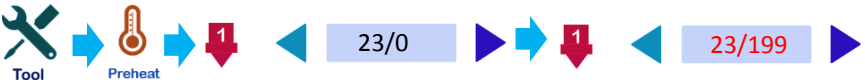
Print test：

Click 

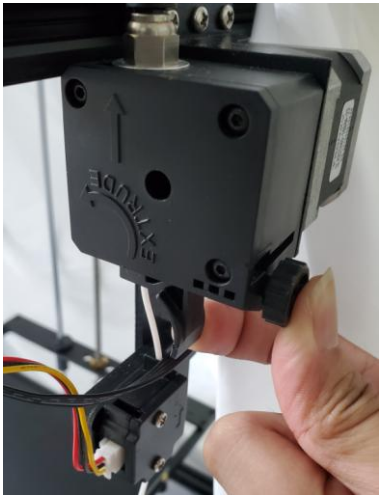
→ “Testing file” →  , start print。

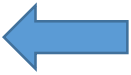
If the first layer is not sticky, the nozzle is on the high side and the platform can be raised appropriately; If the nozzle has a small amount of thread, the nozzle is on the low side and the platform can be appropriately lowered.

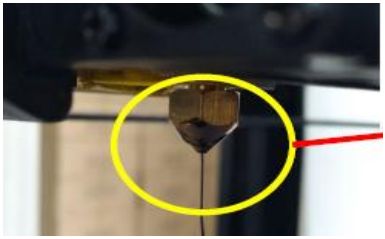
Unload consumables：

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:



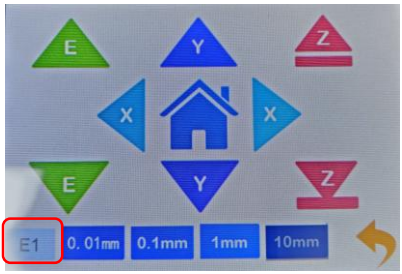




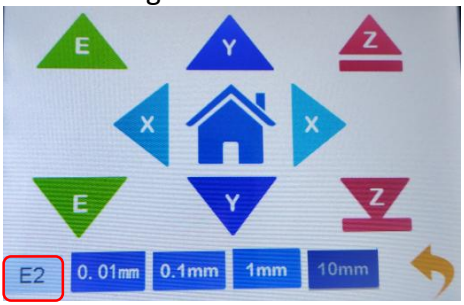
Precautions for double extrusion printing operation:

Enter the manual menu, switch to E1, and set the moving length to 10 mm.

Click to enter consumables  Nozzle with consumable extrusion , Click return  , the return length is 43mm.

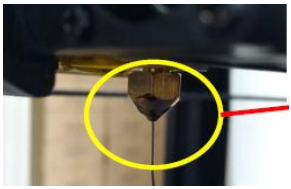


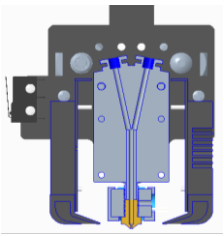
Click E1 in the lower left corner to switch to E2, and the moving length is set to 10 mm. Click to enter consumables  Nozzle with consumable extrusion , Clickreturn  , the return length is 43mm.



After the above operations are completed, switch back to E1 and feed to the nozzle again to discharge consumables

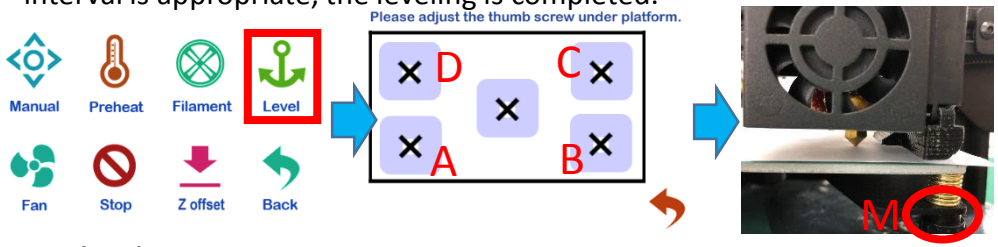
Note: the heating temperature of the PLA is 210± 5 degree and setting filaments return. When setting other kind of filaments, the temperature should little higher, to avoid the molten part of filaments its too big when it return, As a result, the filaments head is too big for feeding.





Manual leveling：

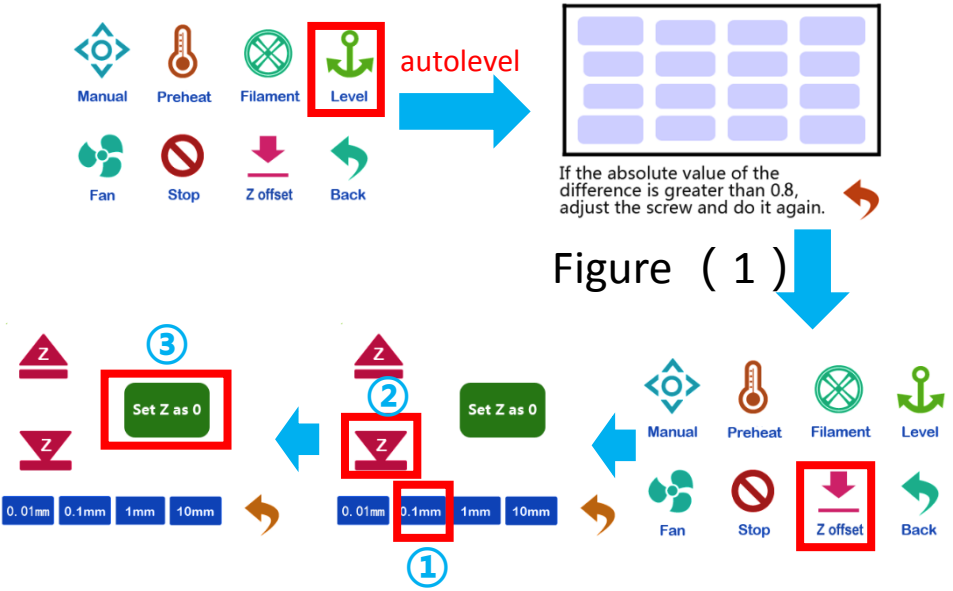
Click the four points of ABCD in the figure below, the print head will move to the corresponding position, and then adjust the leveling nut M, so that the interval between the nozzle and the platform is a piece of A4 paper. After adjusting the four points in turn, it needs to be verified again. If the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

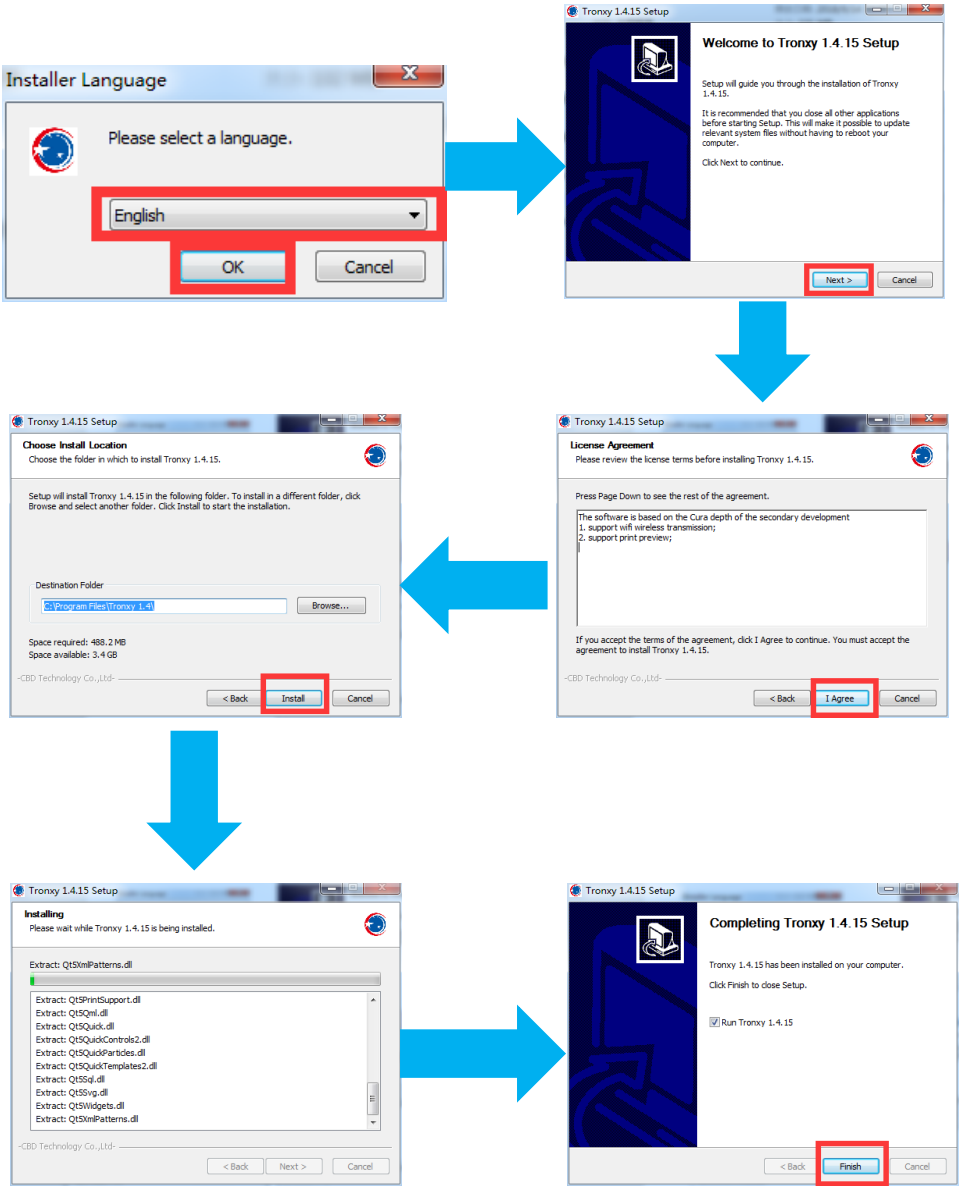
② Then click “Z offset”, the print head will move to the middle of the platform, observe the height of the nozzle and platform, and then click ①② ， make the distance between the nozzle and platform for a piece of A4 paper height, then click ③, reset the zero, so that the end of leveling.



6.Slice software

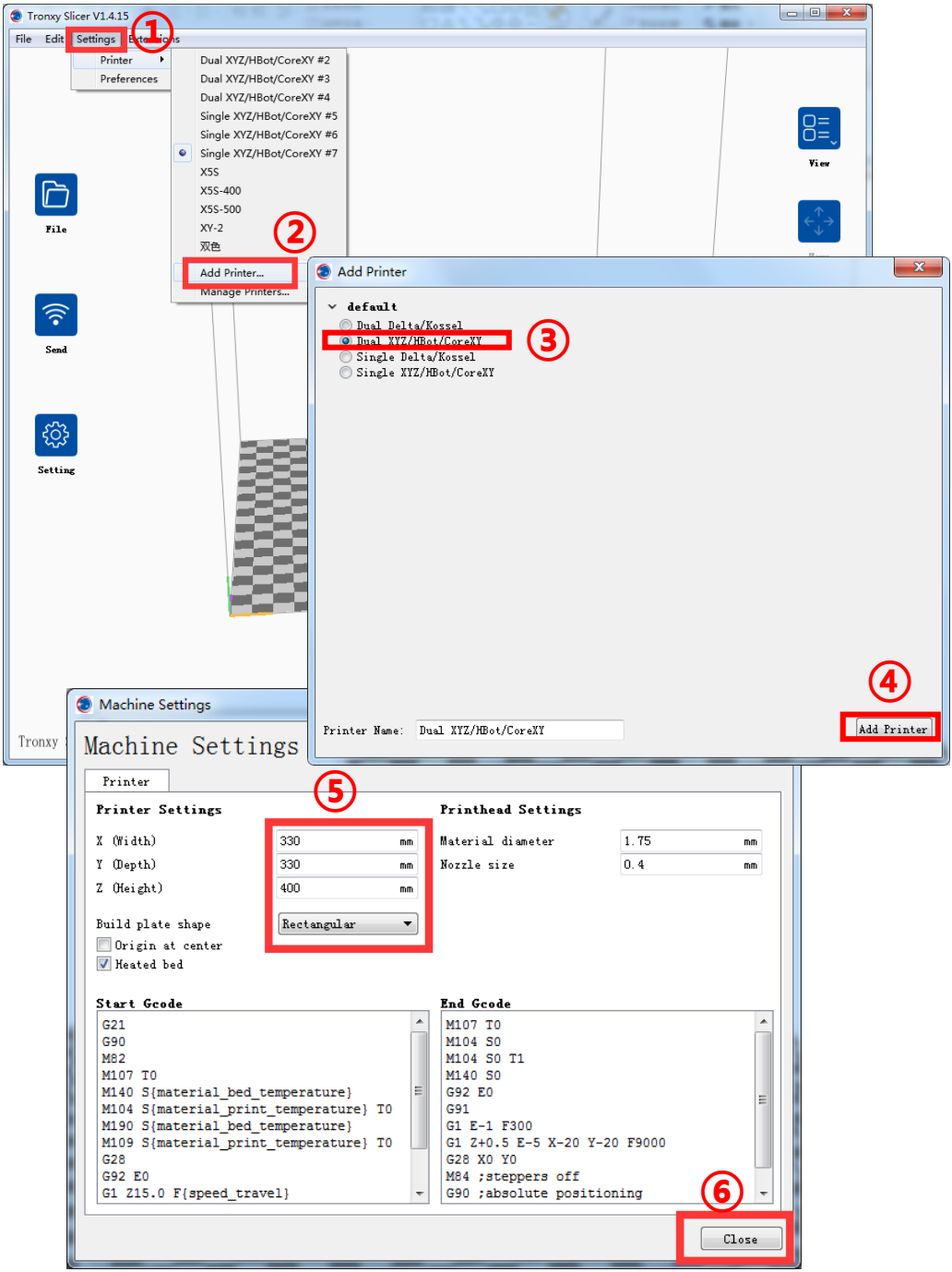
1. Installation

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

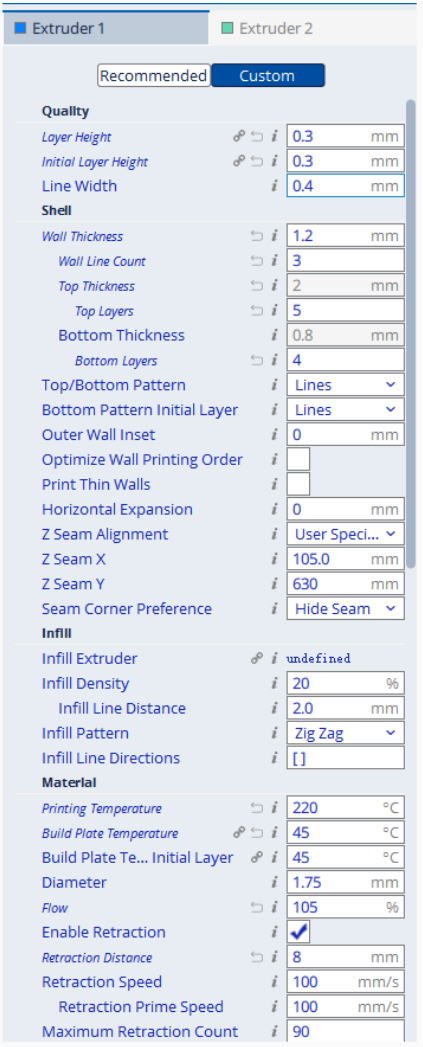


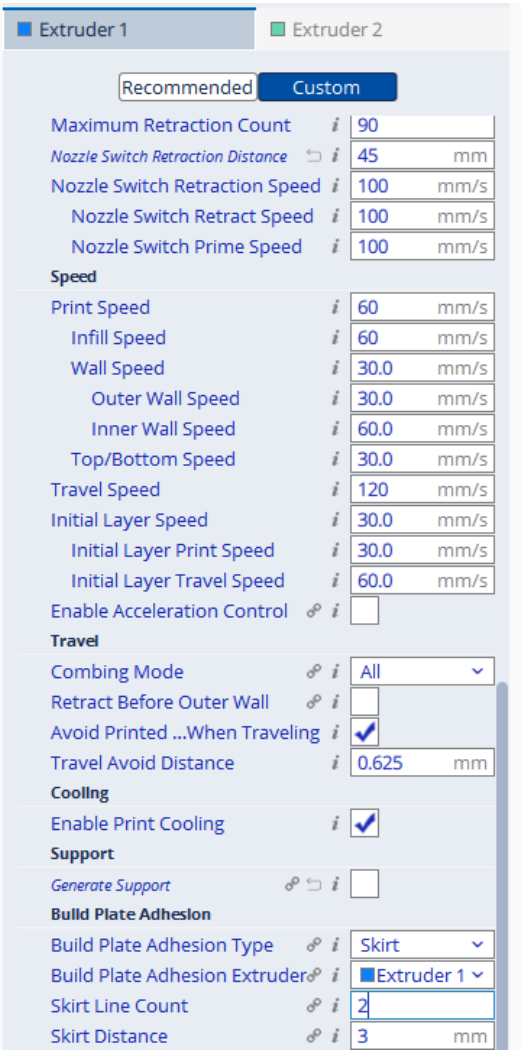
2. How to use slice software

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 ： 0.1-0.4mm
Print temp ： PLA - 200 ℃ ABS - 240 ℃
Heatbed temp ： PLA - 50℃ ABS - 80 ℃
Print speed ： 20-100mm/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
Nozzle switching back distance: About 45-50MM

7.Fault cause

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

Official Website

SHENZHEN TRONXY TECHNOLOGY CO.,LTD