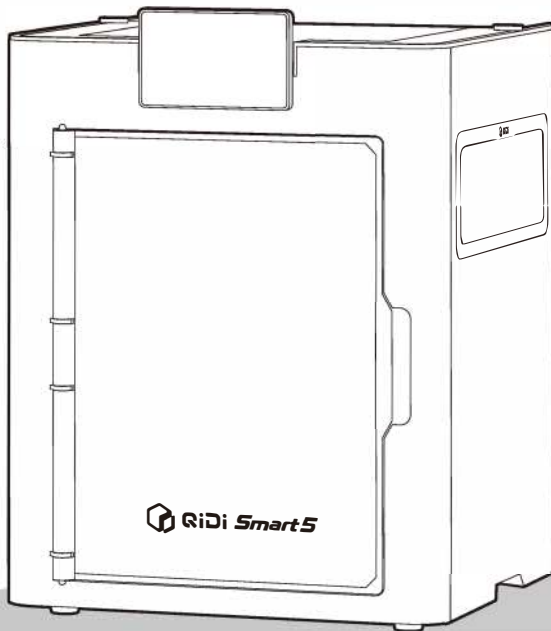


Smart5

Quick Start Guide

3D printer

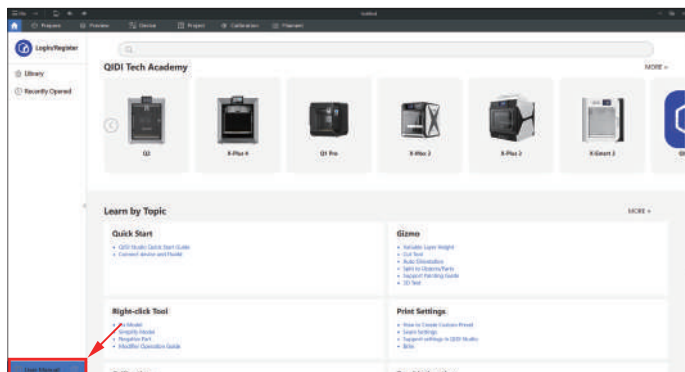


Usage Notice

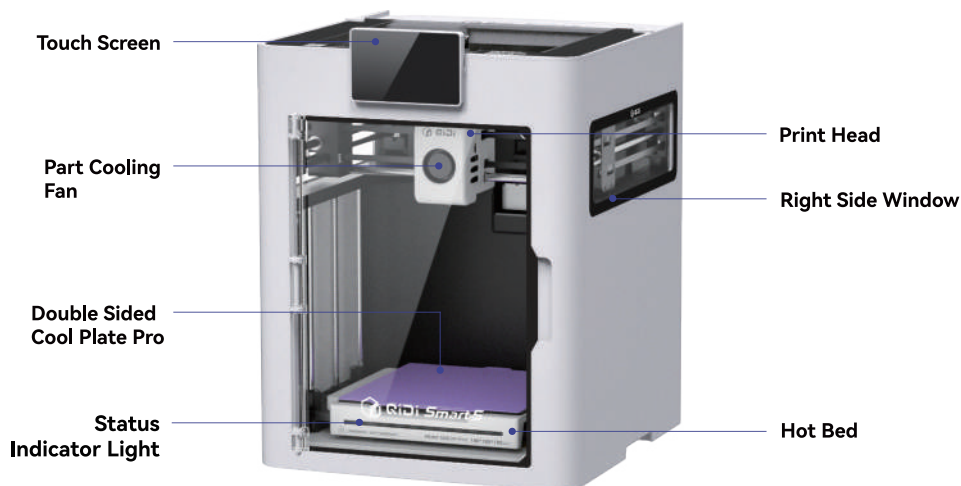
- Do not place the machine near flammable or explosive materials or high-temperature sources. Please place the machine in a ventilated, cool, and low-dust environment.
- Ensure the machine is powered off (unplug power cord) before performing maintenance or modifications.
- Before applying power to the machine, check that the voltage is correct.
- Never reach inside QIDI printers while they are in operation.
- Children should be under constant supervision when using QIDI products.
- The printer contains high-speed moving parts, so be careful of hands pinching.
- There is a potential risk of burns: the print head of the QIDI printers can reach temperatures above 300 °C, while the hot bed can reach temperatures above 100 °C. Do not touch either of these parts with your bare hands.
- Do not place the printer in a vibrating or other unstable environment. Otherwise the shaking of the machine will affect the printing quality.
- After printing, use the residual temperature of the print head to clean the filament around the nozzle with the dedicated tools in time. Do not touch either of these parts with your bare hands.
- Regular maintenance of the printer is essential. When the printer is powered off, use a dry cloth to clean the printer body, removing dust, residual filaments, and foreign objects from the optical axes. The linear guides and Z-axis lead screws require periodic cleaning and lubrication.
- If the machine is in standby mode for a long time, please unplug the power of it.
- If the machine is not used for a long time, please pay attention to protect the printer from dust and damp.
- There are manuals, slicer software and other related information in the USB flash drive. (The information in the USB flash drive may not be the latest. You can obtain the latest information by contacting the After-sales Service marked at the end.)
- Modifying system files or installing non-official plugins constitutes a voluntary waiver of official technical support. Users assume all risks associated with such actions, including firmware malfunctions, system failures, or other issues, which are explicitly excluded from warranty coverage. To restore the original system state, perform a "Factory Reset" via the settings interface.

QIDI Studio

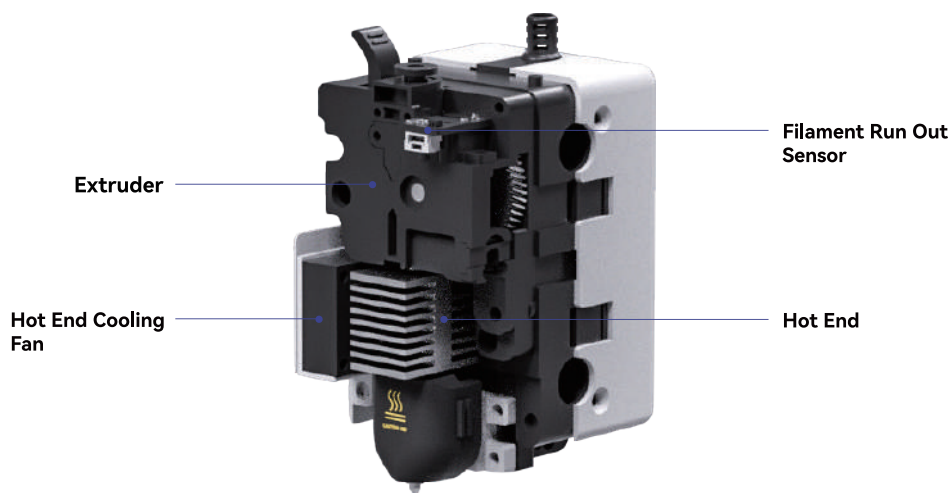
There is QIDI Studio slicing software in the USB flash drive. After installing and operating it, you can learn how to use the software in the User Manual.



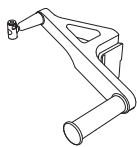
Printer Introduction



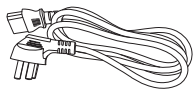
Print Head Introduction



Machine Accessories



**Filament
Extension Bracket**



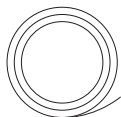
Power Cord



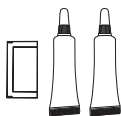
**Double-head
Pneumatic Fitting
and PTFE Tube**



**USB 2.0
Flash Drive**



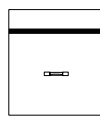
**Sample
Filament**



**Lubricant Oil and
Lubricant Grease
and Thermal Grease**



Glue Stick



Spare Parts Kit



**Allen Key H1.5
Allen Key H2.0
Allen Key H2.5**



Scraper

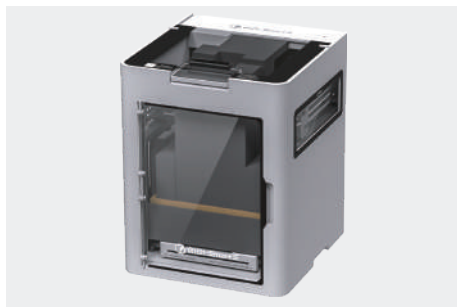


**Flat Head
Screwdriver**

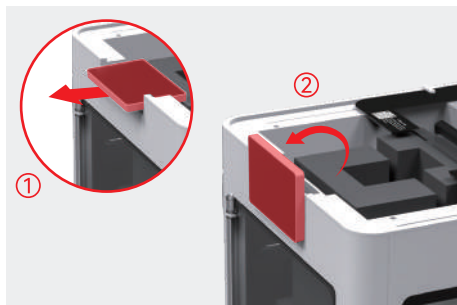
Unboxing



Open the shipping box, remove the top side foam first, then take out the printer.

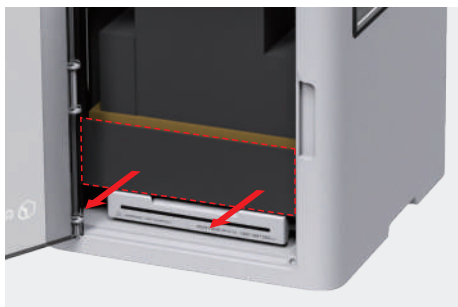


Push the top cover backward.

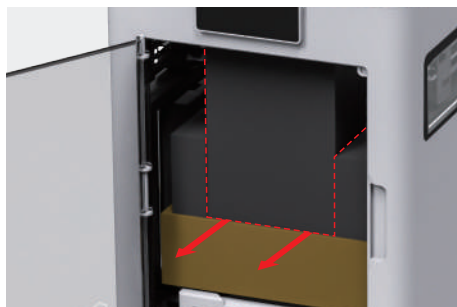


Flip the touch screen panel.

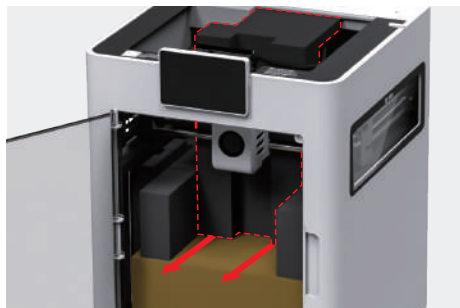
Steps: ① Push outward first, ② then flip the screen.



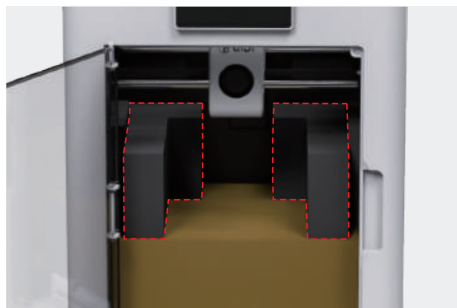
Remove the foam in front of the tool box.



Foam in front of the print head: Grab the bottom of the foam and pull it out.



Foam behind the print head: Push the print head forward, grab the bottom of the foam and pull it out.

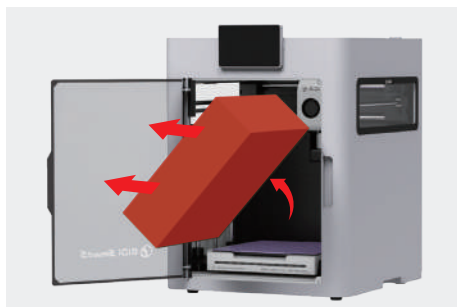


Remove the foam on top of the tool box.



Remove the foam pads on both sides of the tool box from the top.

To better protect the machine during transportation, the foam at this position fits tightly and is somewhat difficult to remove. Bend the foam at a slight angle first, then pull it out.

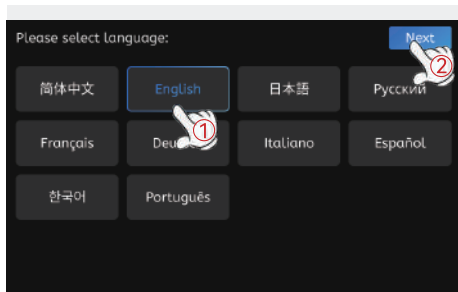


Rotate the tool box by a certain angle, then take it out.

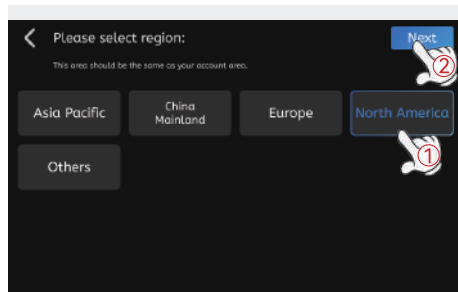


Take the power cord out of the tool box and plug it into the printer. Turn on the printer and complete the startup wizard following the on-screen instructions.

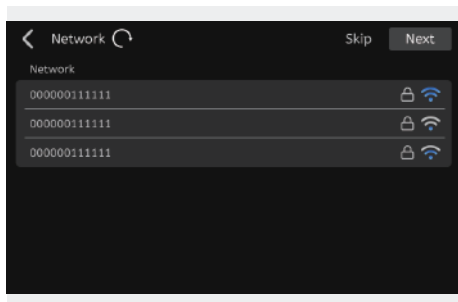
Basic Settings



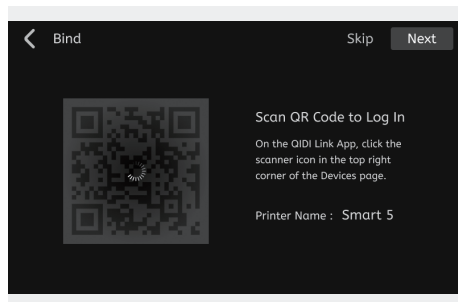
Please select your preferred language and click 'Next' to continue.



Please select your region and then click 'Next' to continue.



Please select your network and then click 'Next' to continue.

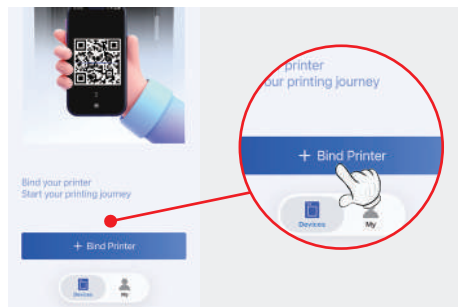


Please bind the printer and click 'Next' to continue.

QIDI Maker APP

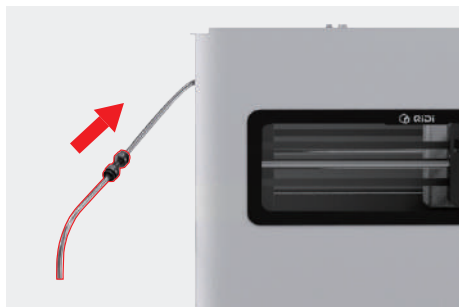


Scan the QR code to download the QIDI Maker App, register and log in to your account.



Use QIDI Maker App to scan the QR code on the screen, and bind the printer to your account.

Loading Filament



Attach the double-head pneumatic fitting to the PTFE tube extending from the feed port on the back of the printer.



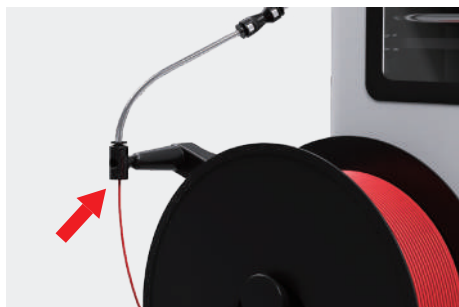
Install the filament extension bracket onto the bracket fixing block.



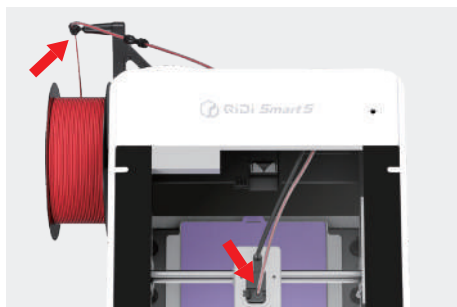
Insert the PTFE tube into the pneumatic fitting on the filament extension bracket.



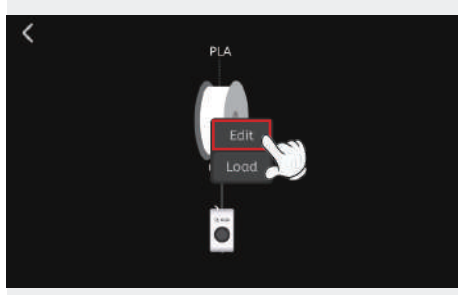
Place the filament spool on the filament extension bracket.



Thread the filament through the pneumatic fitting.



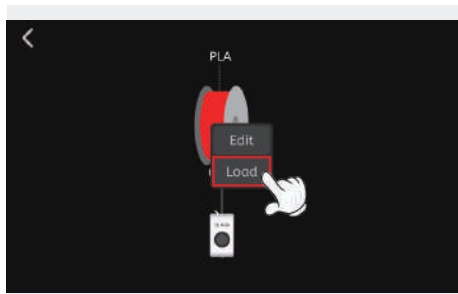
Keep pushing the filament until it fully enters the extruder and can no longer be pushed further.



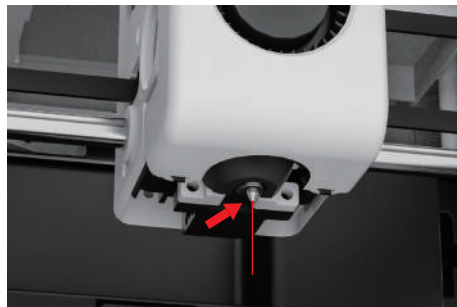
On the filament page, tap the filament icon and click 'Edit'.



Set the filament brand, type and color respectively, and finally click 'Confirm'.

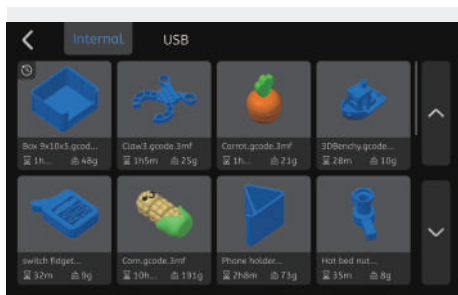


On the filament page, tap the filament icon and click 'Load'.



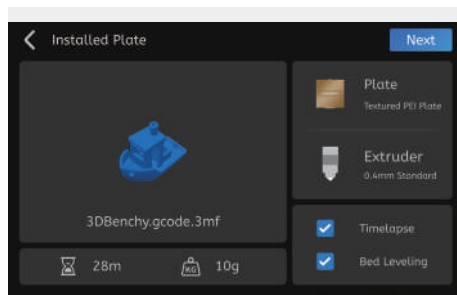
Check if filament is coming out of the nozzle.
If no filament comes out, click 'Retry' and push the filament until it flows out of the nozzle.

First Printing



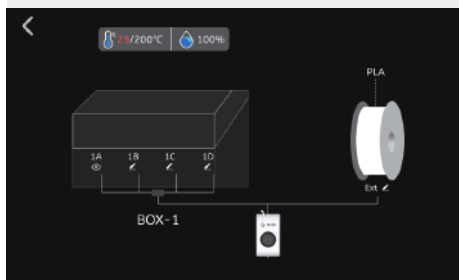
Click the button to start printing.

*Pre-saved models files use PLA Rapido filament by default.



QIDI BOX Load Filament

Users who have not purchased the QIDI BOX may skip this step.

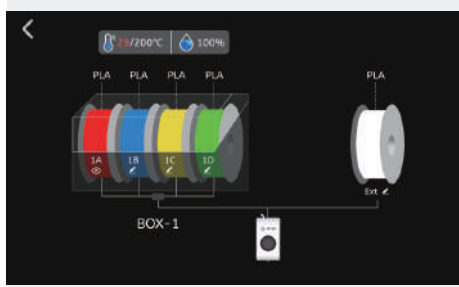


Confirm that the QIDI BOX is successfully connected to the printer. The QIDI BOX icon will appear on the filament page.

Detailed instructions for connecting the QIDI BOX to the printer can be found in the QIDI BOX Quick Start Guide or on the official Wiki.



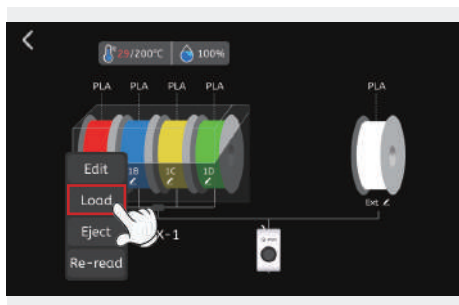
Place the filament into the filament slot, and insert one end of the filament into the extruder feed port of the QIDI BOX.



The RFID filament will be automatically recognized and its information read by the printer.



Set the filament brand, type and color respectively, and finally click 'Confirm'.



On the filament page, tap the filament icon and click 'Load'.



Check if filament is coming out of the nozzle. If no filament comes out, click 'Retry' until it extrudes.

Filament Guide for Beginners

QIDI Filament 1		PLA Rapido	PETG-Tough
Preparation	Necessity Of Drying	Optional	Optional
	How To Dry	55 °C 8 h	65 °C 8 h
	Nozzle Material	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide
	Nozzle Size	All Size	All Size
	Dry Box	Optional	Optional
	Print With Enclosure	✗	✗
Slicer Parameter	Print Speed	260 mm/s	180 mm/s
	Chamber Temperature	/	/
	Nozzle Temperature	200-230 °C	240-270 °C
	Build Plate Temperature	60 °C	80 °C
	Cooling Fan	100 %	60 %
Post- processing	Annealing Needs	✗	✗

Generic Filament		PETG	PLA
Preparation	Necessity Of Drying	Optional	Optional
	How To Dry	65 °C 8 h	55 °C 8 h
	Nozzle Material	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide
	Nozzle Size	All Size	All Size
	Dry Box	Optional	Optional
	Print With Enclosure	✗	✗
Slicer Parameter	Print Speed	120 mm/s	200 mm/s
	Chamber Temperature	/	/
	Nozzle Temperature	240-270 °C	200-230 °C
	Build Plate Temperature	80 °C	60 °C
	Cooling Fan	60 %	100 %
Post- processing	Annealing Needs	✗	✗

Specifications

Machine Name		Smart 5
Body	Print Size (W*D*H)	180*180*180mm (Full-frame printing requires cutter bracket removal)
	Printer Dimensions	322*344*410mm
	Net Weight	10kg
	XY Structure	CoreXY
	X Axis	8mm High-strength Steel Optical Axis
	Y Axis	8mm High-strength Steel Optical Axis
	Z Axis	Single Z Axis Motor+Synchronous Belt, 8mm Optical Axis
Print Head	Print Head Temperature	≤300°C
	Extruder Gear	Hardened Steel Single Gear
	Hot End	Ceramic Plate Heating, Quick Release Integrated Hot End
	Nozzle Diameter	0.4mm
	Filament Diameter	1.75mm
Hot Bed	Printing Platform	Aluminum Substrate Heating Bed
	Printing Plate	Double Sided Cool Plate Pro
	Hot Bed Temperature	≤80°C
Speed	Max Speed of Tool Head	600mm/s
	Acceleration	≤20000mm/s²
Fan	Activated Carbon Air Filter	HEPA Filter Cloth + Coconut Shell Activated Carbon + Breathable Mesh
	Hot End Cooling Fan	4-Pin PWM Fan with RPM Feedback
	Part Cooling Fan	4-Pin PWM Fan with RPM Feedback
	Motherboard Fan	Open-Loop Control
	Chamber Exhaust Fan	Open-Loop Control
Filament	Supported Filament	PLA, PETG
	Not Recommended Filament	ABS, ASA
	Filament Cutter	Yes
Sensor	Filament Clog Detection	Yes (For Use with QIDI BOX)
	AI Camera Detection	Yes
	Resonance Compensation	Yes
	Filament Tangle Detection	Yes (For Use with QIDI BOX)
	Filament Run Out Sensor	Yes
	Automatic Leveling	Loadcell Sensor Integrated into the Hot End
	Power Loss Recovery	Yes

Power	Voltage	100/240 VAC, 50/60Hz
	Rated Power	115V: 150W 220V: 150W
Electronics	Display Screen	4 Inch 800*480 Touch Screen
	Storage	32G EMMC and USB2.0 Flash Drive
	Camera	Low Framerate Camera (Up to 1080P) Timelapse Supported
Signal	Connectivity	Wi-Fi:2.4GHz/USB
Software	Slicer	QIDI Studio and other third-party software, such as Orca, PrusaSlicer etc.
	File Formats for Slicing	STL, OBJ, 3MF, STEP (.stp/.step), etc.
	Operating System	Windows、MacOS、Linux

* Special non-printable zone:
The 11 × 22 mm area at the bottom-right corner of the build plate is set as a non-printable zone by default.If full-frame printing is required, please contact customer service to remove the cutter bracket by following official instructions. After that, adjust relevant parameters in QIDI Studio and send the print task to the printer to start printing.

Tips

- If the filaments do not stick to the print platform:
- 1) Please check if the nozzle is far away from the print plate, you can adjust the platform upward by Z-offset adjusting function.
 - 2) Because of the different ambient temperatures in different regions, the temperature of the heat bed can be increased appropriately to increase the adhesion of the filaments.
 - 3) If above all can not work , please contact the after-sales service for assistance.



Scan QR to receive our latest product updates and latest news.

Official Website: www.qidi3d.com

If you need support, please feel free to contact us:

E-mail address: Smart5support@qidi3d.com
Smart5support02@qidi3d.com



Please visit the QIDI Tech official Wiki for more machine usage and maintenance tutorials.
<https://wiki.qidi3d.com/en/home>

If you have any suggestions or complaints,
please contact with this E-mail address: Karl@qd3dprinter.com

TEL: 0086-577-66881077

This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

Any Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

Note: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.
- This equipment complies with FCC radiation exposure limits set forth for an uncontrolled environment. This equipment should be installed and operated with minimum distance 20cm between the radiator & your body.