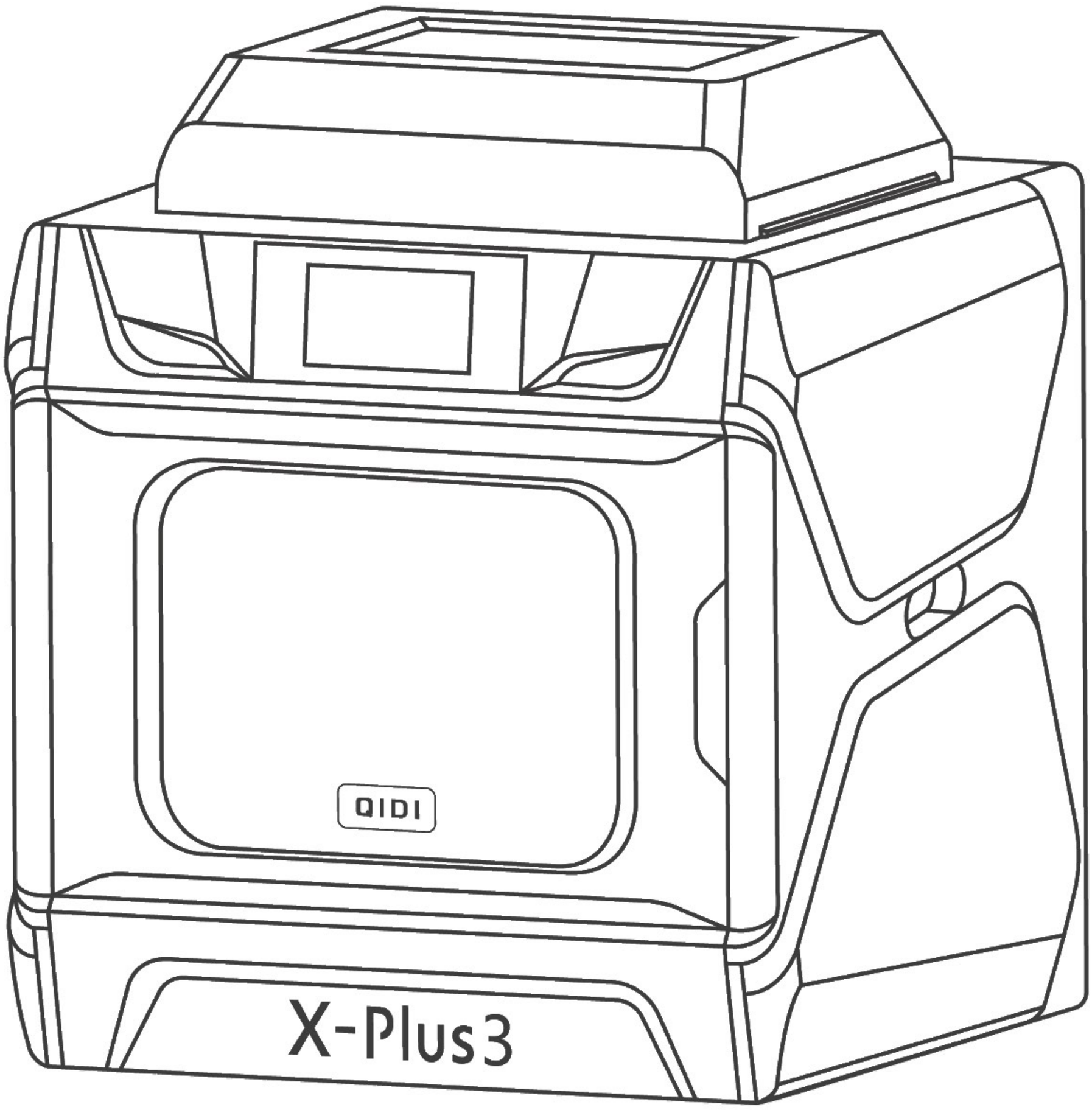
QIDI TECH

X-PLUS 3

Quick Start Guide



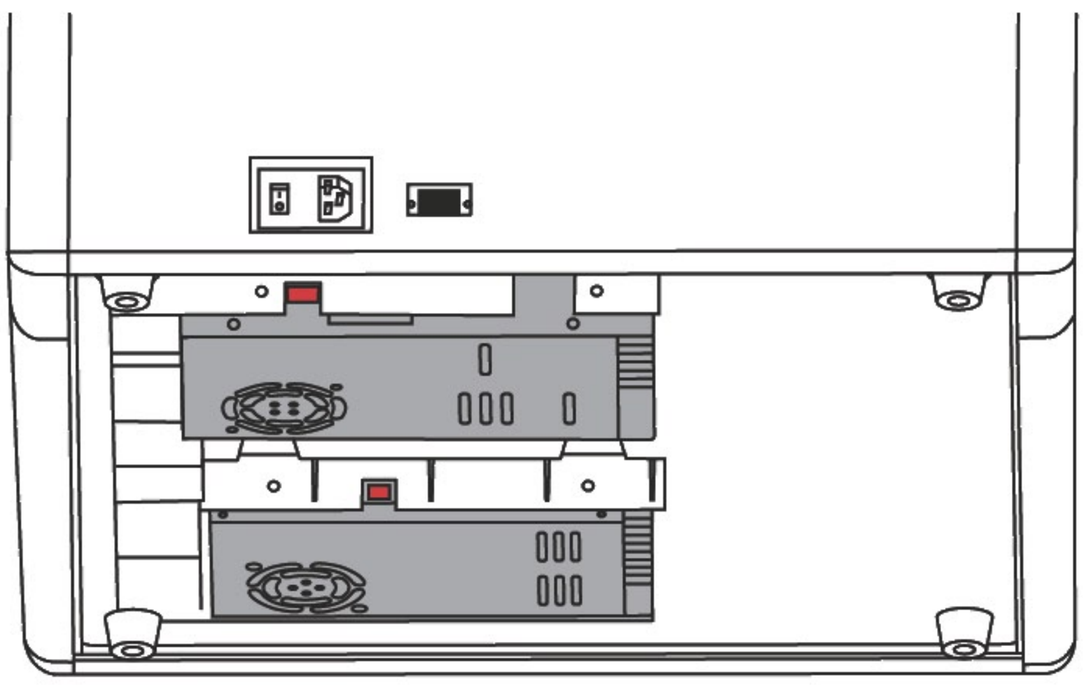
(All images are for illustrative purposes only, actual product may vary due to product optimization)

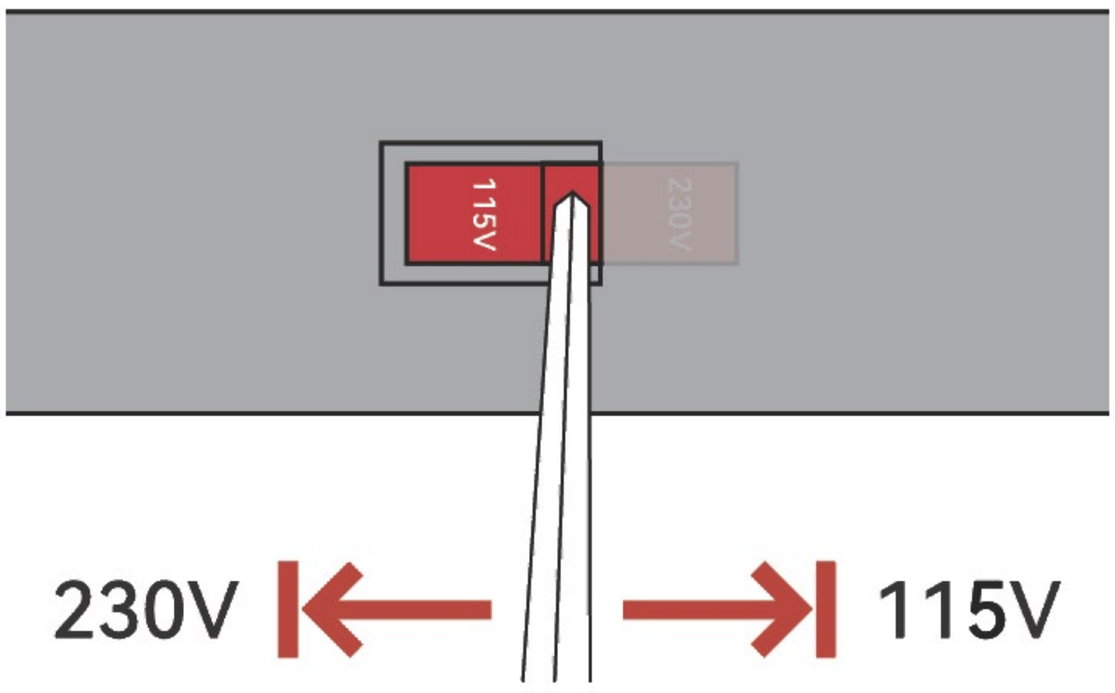
Usage Notice

- Do not place the machine in flammable and explosive materials or near high heat sources, please place the machine in a ventilated, cool and dust-free environment.
- The X-axis carbon fiber rod on the machine cannot be replaced,so please take care to protect it from scratching the carbon fiber rod and affecting printing.
- Ensure the machine is powered off(unplug power cord) before performing maintenance or modifications.
- Before connecting the power,please follow the power setup instructions to ensure that the voltage is correct.
- Never reach inside QIDI printer 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 heads 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 will reduce the wear and increase the life of the printer.Regularly clean the carbon fiber rod with absolute alcohol or isopropanol, clean the printer body with a dry cloth, wipe off dust, bonded printing materials, and foreign objects on the Z axis.Always unplug QIDI products before performing maintenance or modifications.
- If the machine is in standby mode for a long time,please unplug the power of the QIDI products.
- 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 informations 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.)

Power Settings

When products manufactured, we have switched the voltage values according to the sale countries/regions, but please ensure whether you need to switch it to the voltage values of your region/country. (The one marked "230V" is suitable for 220V, and the one marked "115V" is suitable for 110V; if in doubt, please contact our after-sales technical support.)

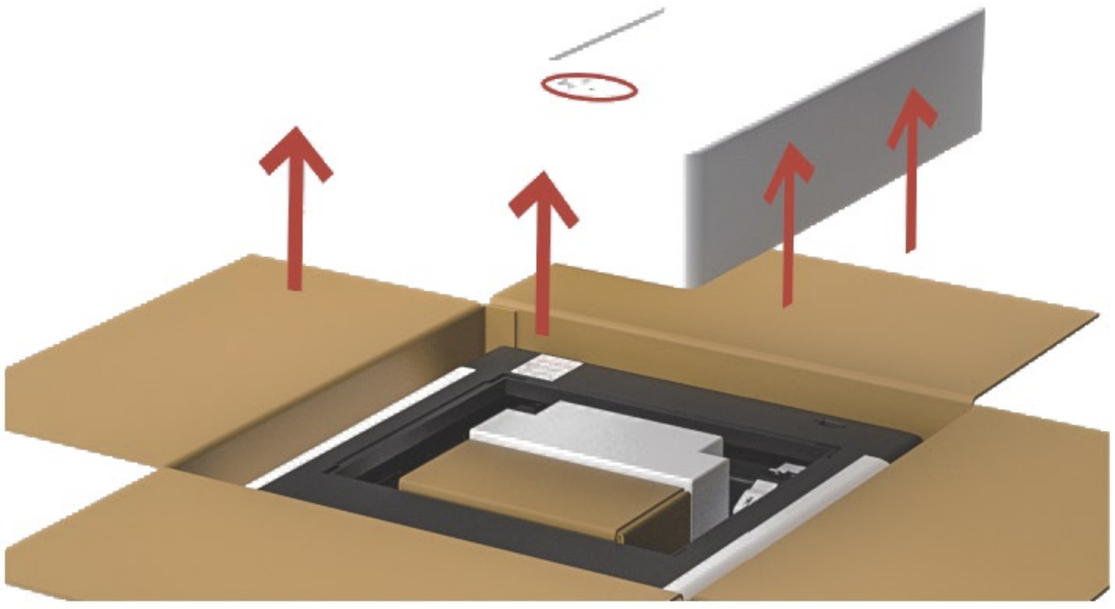




Mismatching voltage input will result in products breakdown.

Starting Up

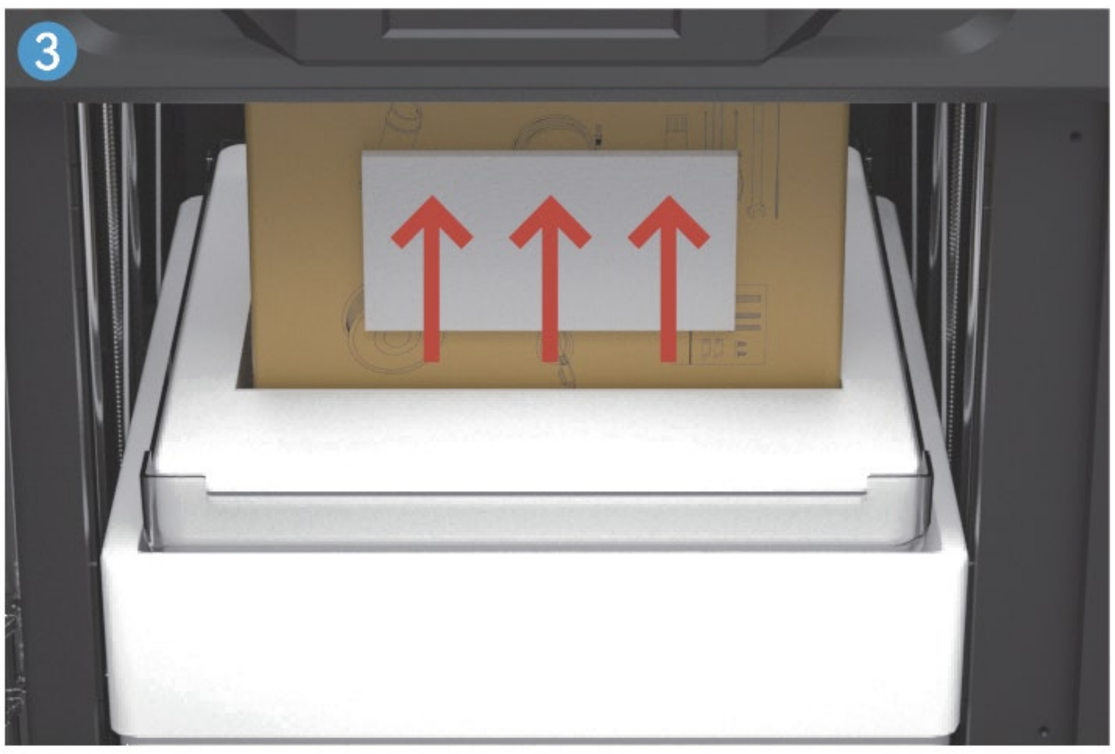
1



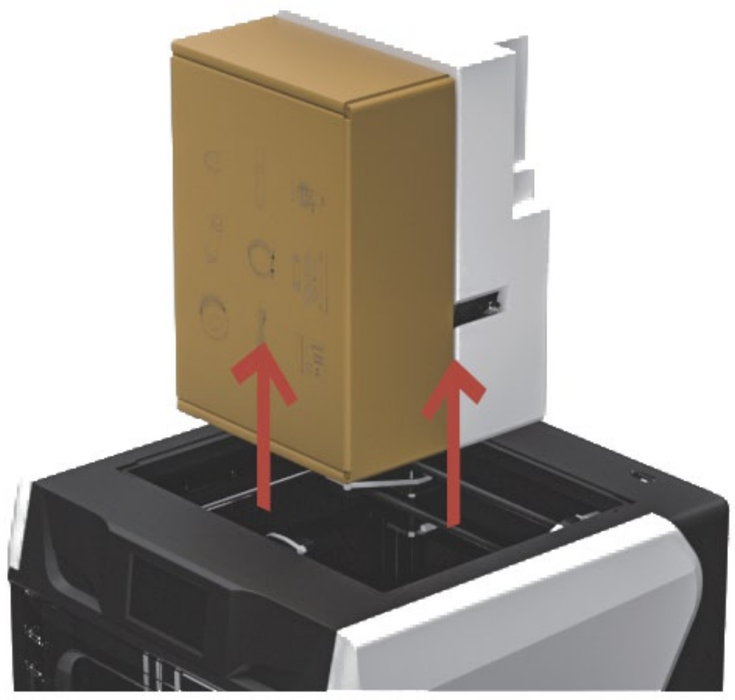
2

Take out the top EPS foam and USB flash drive， then lift the printer out of box.

3

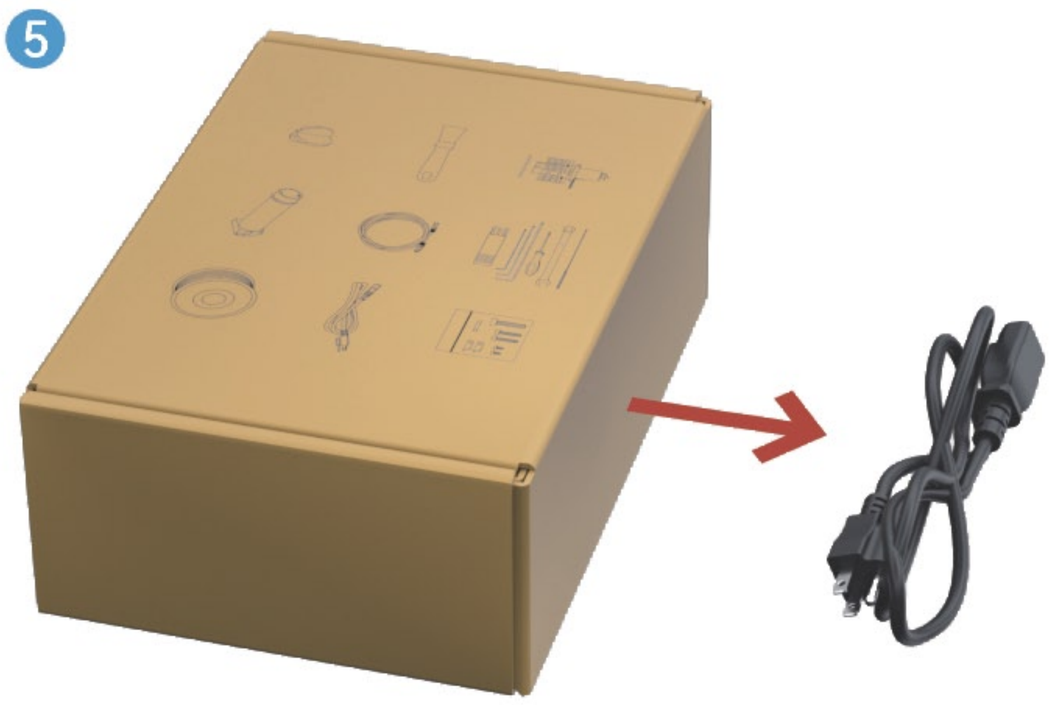


4



Remove the packing foam that fix accessory kit and dry box, then take accessory kit and dry box out from top.

5

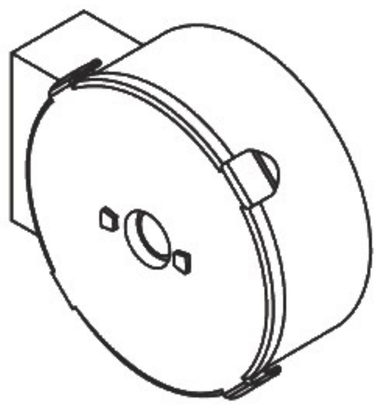


6

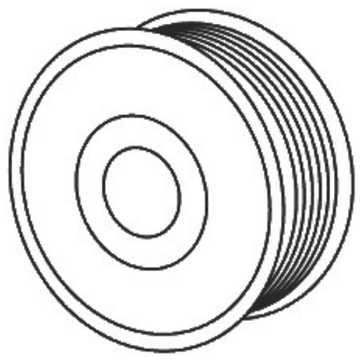
Take out the power cord from the accessory box and plug it into the printer. Turn on the printer and follow the instructions of screen to complete the unboxing process,calibration,etc.

Warning: Before starting up, please confirm whether the voltage setting of the power supply matches the voltage value of your region/country.

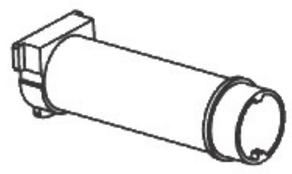
Accessory List



Dryer Box

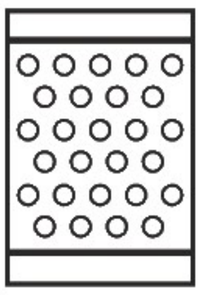


500g Filament



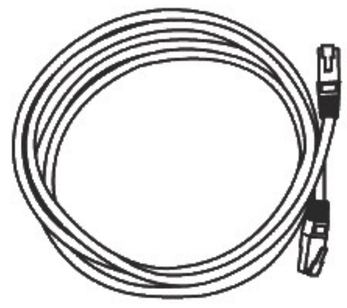
Filament
Spool Holder

Holder Cover



Desiccant

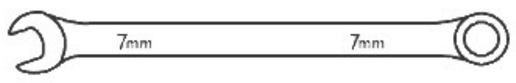
Power Cord



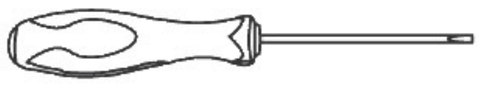
Ethernet Cable

Scraper

Allen Key H1.5
Allen Key H2
Allen Key H2.5



7mm
Spanner

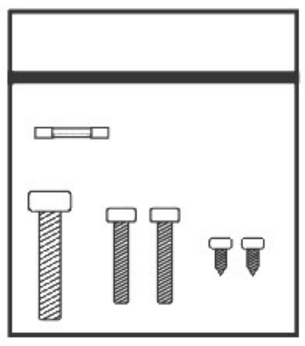


Flat Head
Screwdriver

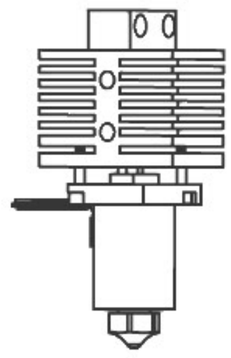
0.4mm Nozzle
Cleaning Tool

Glue Stick

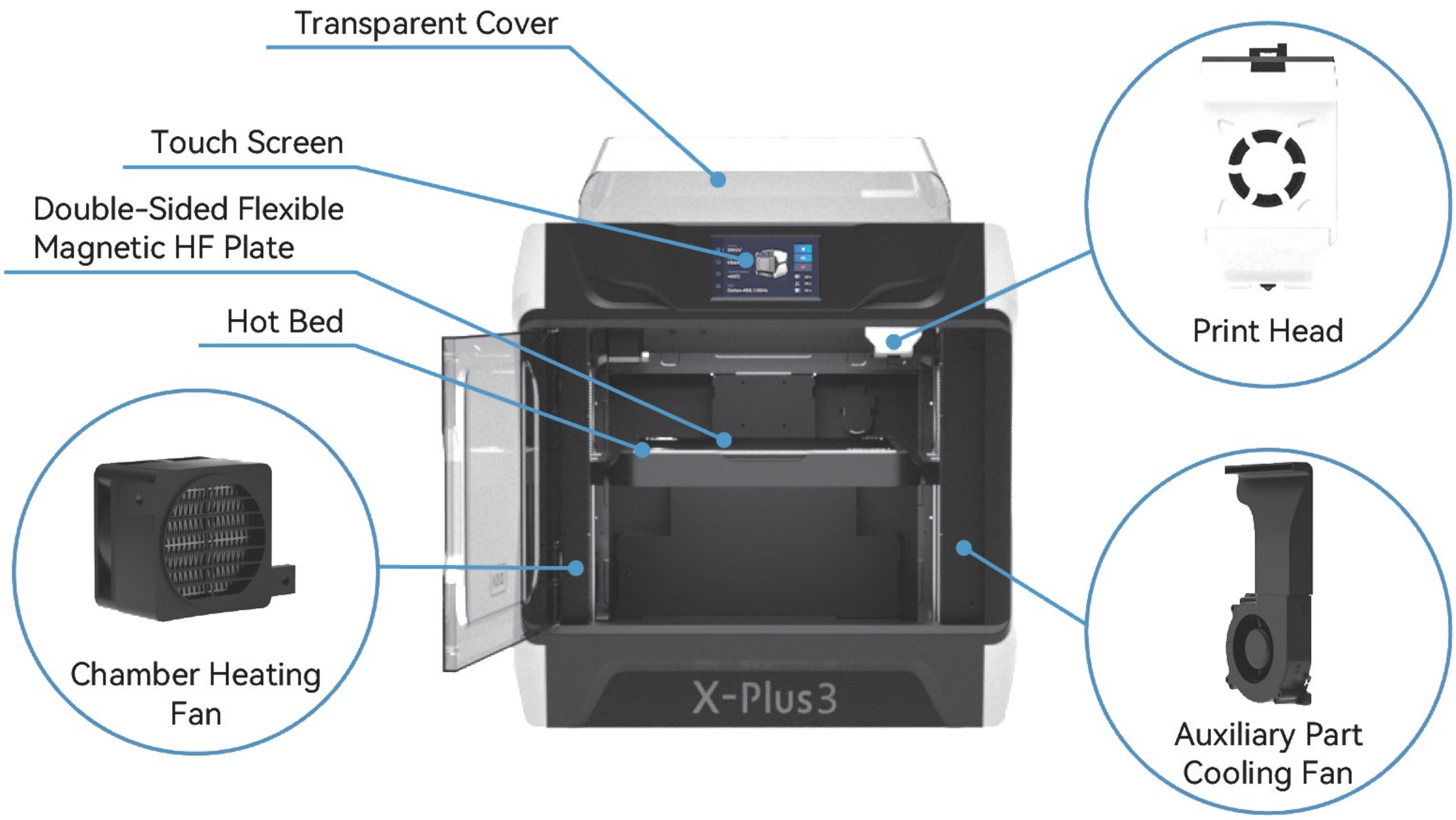
USB 2.0
Flash Drive



Spare Parts Kit

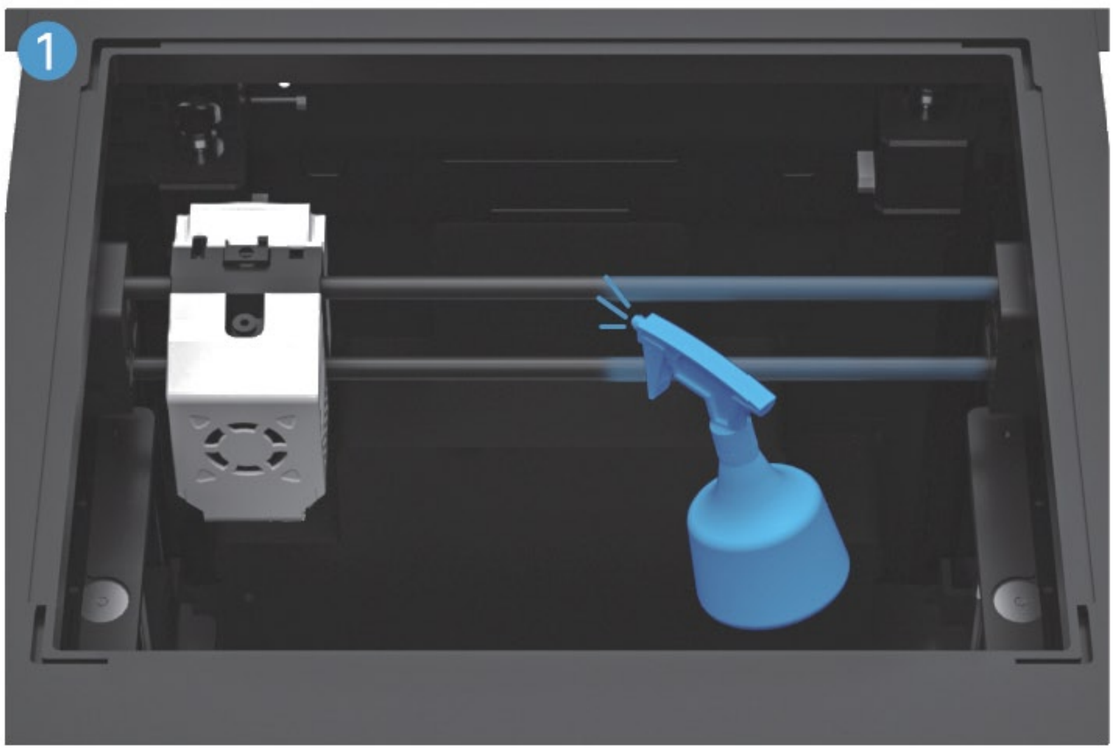


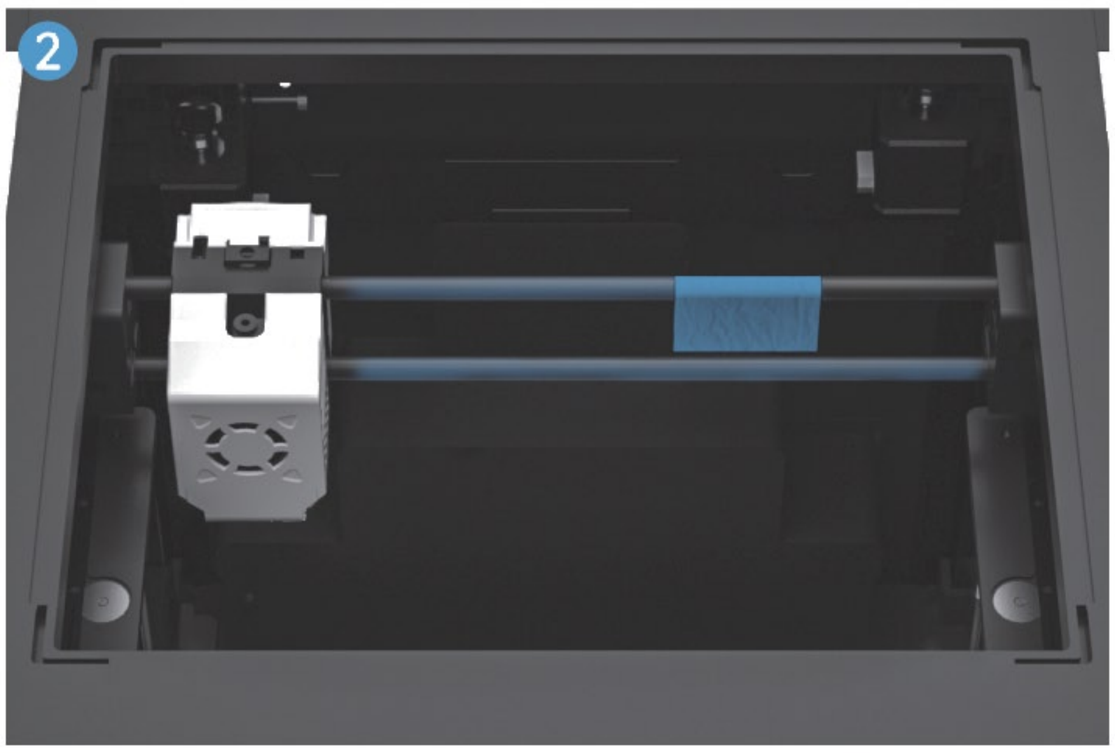
Ordinary Hotend


Transparent Cover
Touch Screen
Double-Sided Flexible Magnetic HF Plate
Hot Bed
Print Head
Chamber Heating Fan
X-Plus3
Auxiliary Part Cooling Fan

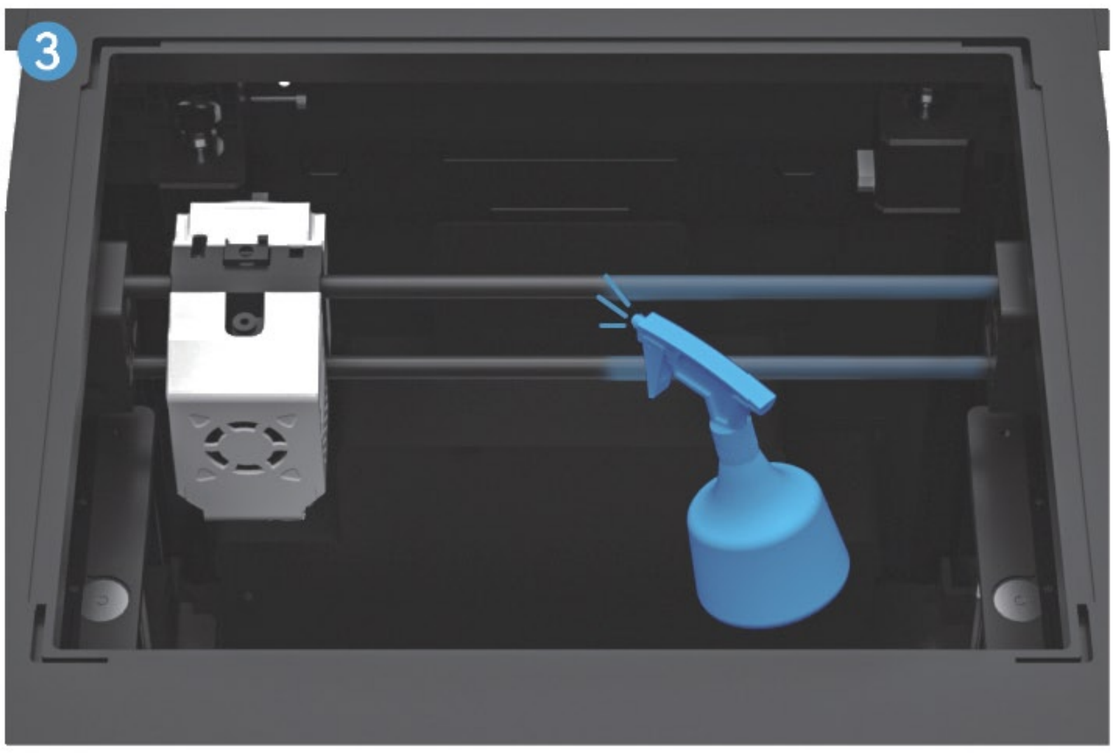
USB Port
Filament Run Out Sensor
Filament Spool Holder + Holder cover
Ethernet Cable Port
Power Switch
Power Cord Port

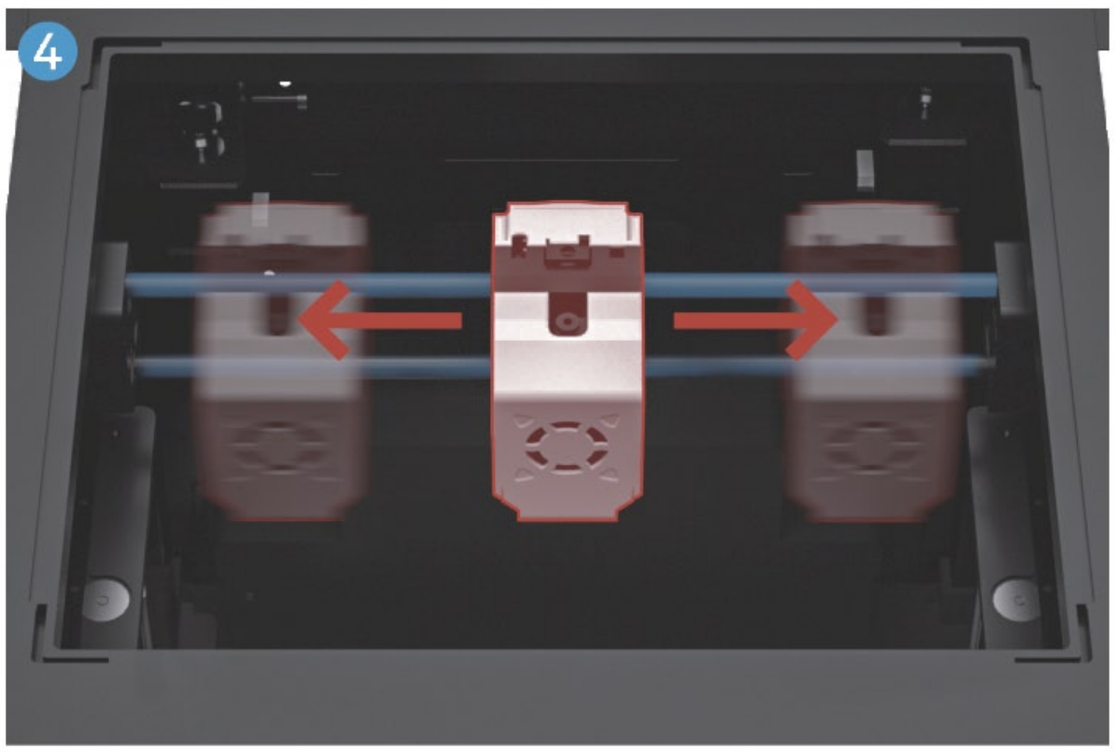
X-Axis Cleanup



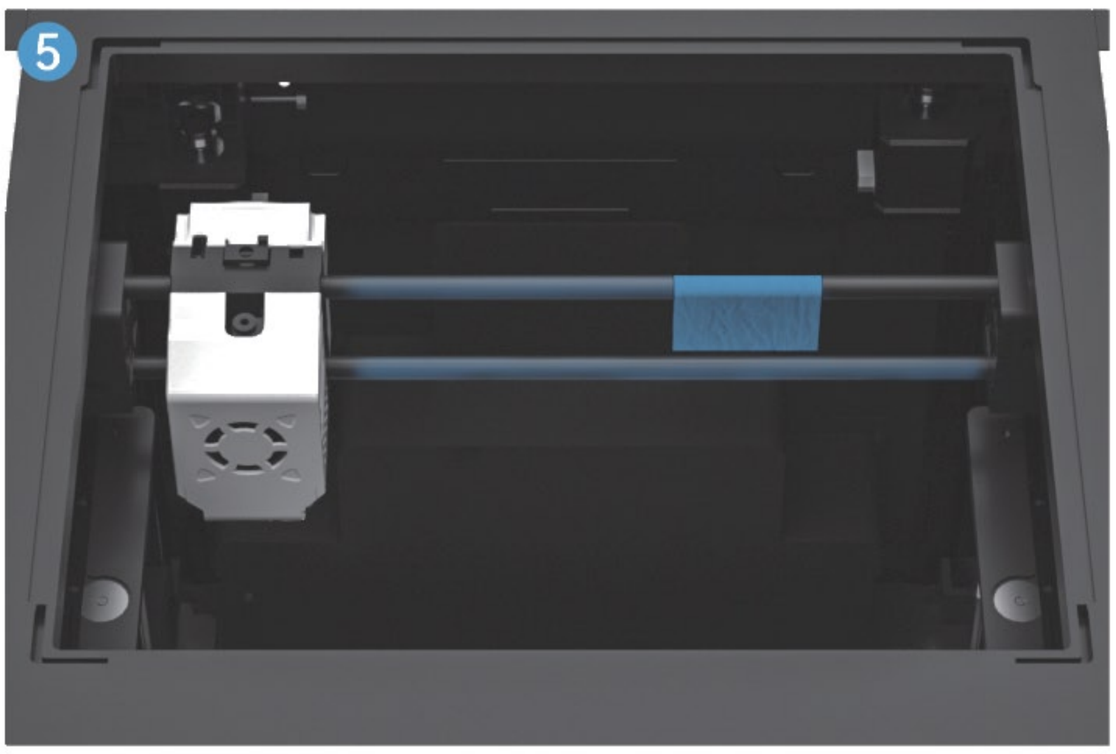


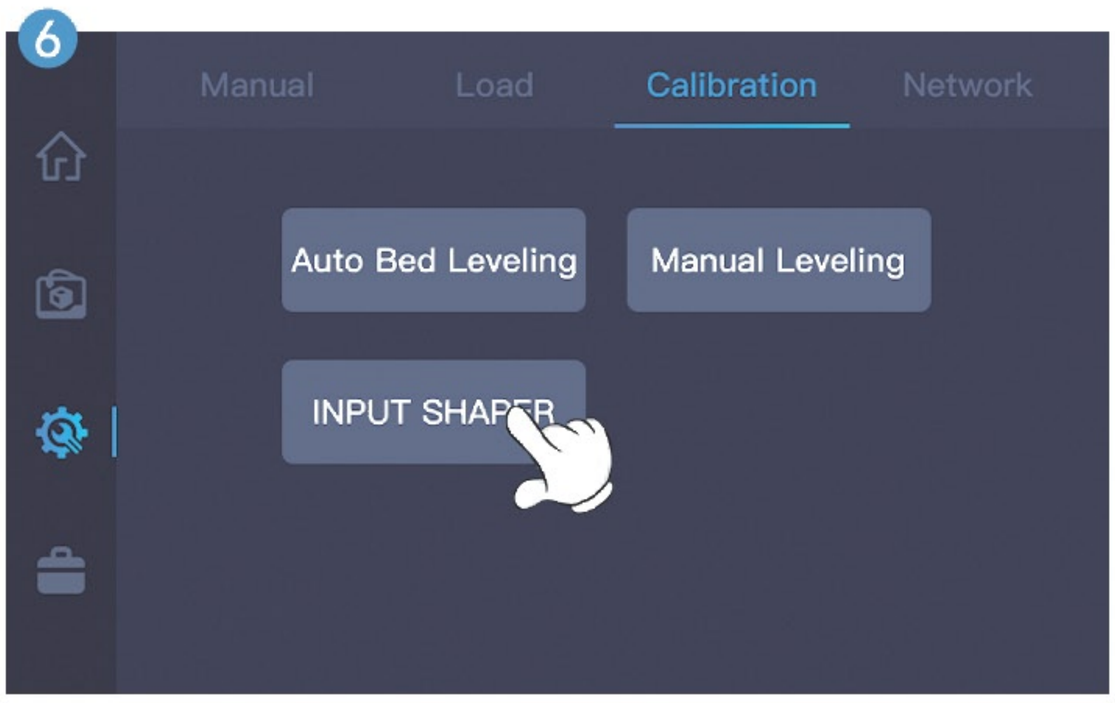
Wet the carbon fiber rods with alcohol or isopropanol, and gently rub the carbon rods to clean any debris with a dust-free cloth.





Wet the carbon fiber rod again, and move the print head right and left repeatedly to clean out the dirt in the print head bearing.

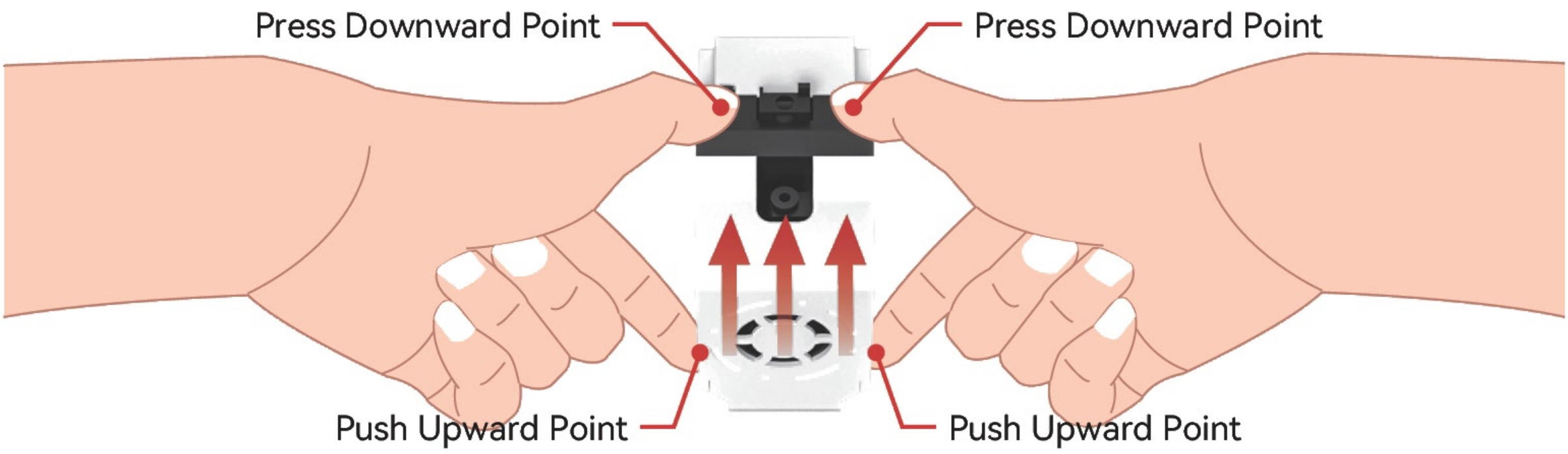




Wipe the carbon fiber tube with a cloth, and repeat steps 3 to 5 until there is no stain on the print head bearing and carbon fiber tube. After cleaning, perform resonance compensation once.

Note: The X-axis rod needs to be cleaned every 1-2 weeks.

How To Remove The Print Head Front Cover



Carefully push upward to unlock the front cover,then remove it.

Specifications

Machine Name		X-Plus 3
Body	Print Size (W*D*H)	280*280*270 mm
	Dimensions	511*527*529 mm
	XY Structure	CoreXY
	X Axis	10mm Hardened Wear-Resistant Carbon Fiber Rod
	Z Axis	Double Z Axis
	Shell	Plastic
	Chassis	Steel
	Motor	42-48 High Temperature High Speed Motor
Print Head	Print Head Temperature	≤ 350℃
	Extruder Gear	Hardened Steel Gears
	Transmission Ratio	9.5：1
	Hot End	Circular Ceramic Heating Hot End Only need 40S Heating From 20℃ to 220℃
	Temperature Measurement Unit	Thermocouple
	Nozzle	Copper Alloy Nozzle + Hardened Steel Nozzle
	Nozzle Diameter	0.4mm
	Filament Diameter	1.75mm
Hot Bed	Printing Platform	Aluminum Substrate Heating Bed
	Printing Plate	Double-Sided Flexible Magnetic HF Plate
	Hot Bed Temperature	≤ 120℃

Speed	Printing Speed	250-500mm/s
	Maximum Printing Acceleration	20000mm/s^2
Cool Down	Hot End Cooling Fan	Closed-Loop Control
	Model Cooling Fan	Closed-Loop Control
	Auxiliary Part Cooling Fan	Closed-Loop Control
	Motherboard Fan	Open Loop Control
	Chamber Circulation Fan	None
	Chamber Temperature	65° C Independent Chamber Heating
Filament	Recommended Filament	ABS-GF25
	Compatible Filament	PLA, ABS, ASA, PETG, TPU, PET-CF, PA12-CF, PC, UltraPA, Nylon, etc.
	Seal Print	Dryer Box + Desiccant
Sensor	Broken Filament Detection	Support
	Automatic Leveling	Support
	Resonance Compensation	Support
Power Supply	Voltage	100-240 VAC, 50/60Hz
	Rated Power	800W
Electronics	Display Screen	5.0 Inch 800*480 Touch Screen
	Connectivity	Wi-Fi, USB Flash Drive, Ethernet Cable
	Motion Controller	Dual-Core Cortex-M4
	Application Processor	Quad-Core 1.5GHz Cortex-A53
	Extruder Independent Processor	Dual-Core Cortex-M0+
Software	Slicer	QIDI Print and other third-party software, such as Ultimaker Cura, Simplify3D, PrusaSlicer, etc.
	Operating System	Windows、MacOS、Linux

After-sales Service E-mail address:

Plus3support@qd3Dprinter.com Plus3AMS@qd3Dprinter.com

If you have any suggestions or complaints,please contact with this E-mail address:

Audrey@qd3dprinter.com

Official website: www.qd3dprinter.com Skype ID: Plus3support@qd3Dprinter.com

TEL: 0086-577-66881077

FCC Statement

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 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.

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

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.