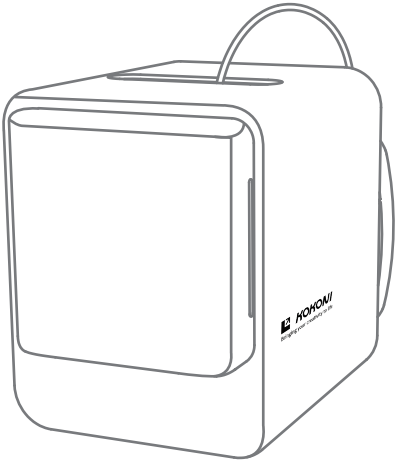
KOKONI



3D Printer User Manual

Important Statement

KOKONI

Thank you for choosing the KOKONI 3D printer. We hope you enjoy using it!

Before you start operating your printer, we strongly recommend that you read this manual carefully. By using the printer, you indicate that you have read this manual and agreed to the safety instructions provided below.

At KOKONI, we are committed to delivering the best possible service. If you need assistance, please don't hesitate to contact our customer support team using the phone or email provided at the end of this manual.

For a better experience, we encourage you to visit our official website at www.kokoni3d.com. There, you can find information about hardware and software, contact details, operating instructions, and maintenance tips.

Please note that Moxin (Huzhou) Technology Co. Ltd reserves the right to modify and interpret this user manual.

IMPORTANT SAFETY INSTRUCTIONS

1.Only use the printer for its intended purposes as described in the manual. Using it for other things can cause personal injury or damage to property.

2.Keep the printer away from things that can catch fire, explode, or produce heat. Place it in a well-ventilated, cool, and clean area.

3.Avoid putting the printer in a place that vibrates or is unstable, as it can affect the quality of your prints.

4.Use the power adapter that comes with the printer to connect it to a power outlet that follows local regulations. Don't use any other adapters. Also, keep the printer away from rain or moisture to prevent the risk of fire or electric shock.

5.Don't wear woven gloves while operating the printer. They can get caught in the moving parts and cause injuries.

6.Keep any part of your body away from the moving nozzle and printing platform while the printer is working.

7.Remember that the models printed by the printer are not meant to be eaten.

8.Don't loosen any screws on the machine to avoid the risk of electric shock.

9.For good print quality and to prolong the printer's lifespan, use the recommended filament.

10.Regularly maintain the printer by turning it off, cleaning the outer shell with a dry cloth, removing any filament residue from the printing chamber using tweezers, and checking for foreign objects on the belt.

11.Children who are 10 years old or younger should not operate the printer alone to prevent accidents.

12.When using this product, make sure to follow the laws and regulations in your area, act ethically, and prioritize safety. Failure to do so may result in legal consequences.

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Please read this manual thoroughly before use it and keep it for further reference

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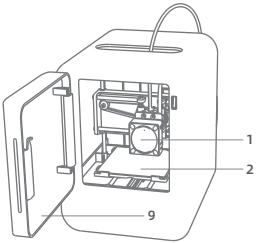
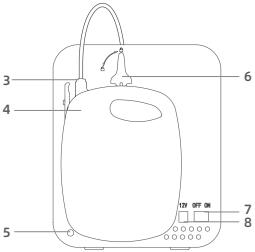




1.Nozzle assembly

2.Printing platform

3.Filament outlet

4.Filament chamber

5.Networking button

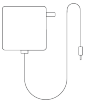
6.Filament replacement buckle

7.Power switch

8.Power port

9.Cabin door

Tweezer *1



Power adapter*1

Printing plate*1
(Pre-assembled)

Camera*1

Note: Please wait till the white indication light stop flashing before operating the device!

Product Specifications

KOKONI

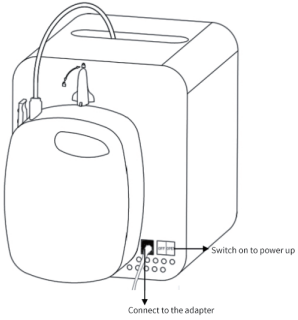
Description	Model No.	Dimensions	Printing size
KOKONI 3D Printer	KOKONI-EC2	189*302*231mm	100*100*60mm
Execution standard	Net weight	Rated voltage/Current	Rated power
GB 4943.1-2011	3.2 kg	DC12V/5A	60W

Forming technique	Number of nozzles	Nozzle diameter	Nozzle temperature
FDM/FFF	Single nozzle	0.6 mm	≤260°C
Printing speed	Printing layer thickness	Compatible file format	Raw material of filament
100 mm/s (MAX)	0.04~0.35 mm	STL., OBJ, etc.	Modified PLA

Environmental Specifications

Environmental condition	Recommended value	Allowed value
Temperature	18~25°C	10~27°C
Humidity	Relative humidity 20~60%	Relative humidity 10~70%
Altitude	Not applicable	0~2000 m

Printer Start-up



1.After turning on the Power switch, there will be a beep sound and the indicating light in white color will start to flash (to ensure better print quality, please place the printer on an flat and stable place).

2.Wait for the printer to perform its power-on self-test procedure. This may take about 30 to 60 seconds. Then, the white indicating light will stop flashing, and the printer is ready for use.

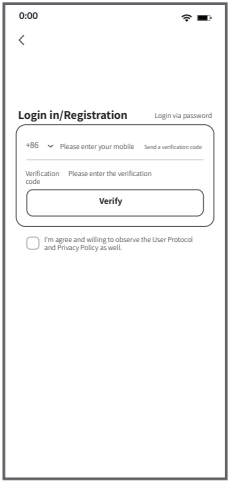
Tips:

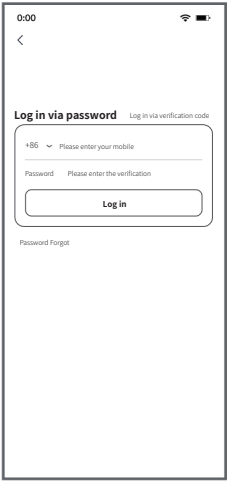
You can download the printer control KOKONI 3D App while waiting (Search **KOKONI 3D App** in the App store Android/IOS)

Indicator status

Printer status	Indicator light	Status of indicators
Printer self-inspection	White	Flash
Printer network configuration	White	Off
Printer normal condition	White	On
Incorrect WiFi password	Orange	On
Filament replacement	Orange	On
Maintenance mode	Orange	On

KOKONI 3D App Installation



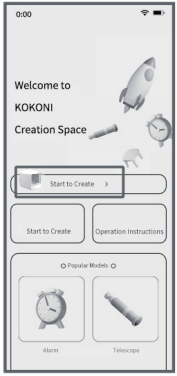


1.Scan the QR code to download the KOKONI 3D App

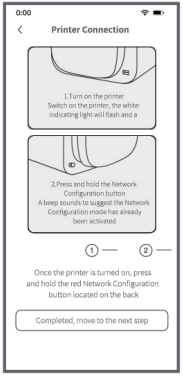
2.Register/Log

WiFi Network Configuration

KOKONI



1、Add a printer.



2、Press and hold the Network Configuration button till it beeps, which indicates that the Network Configuration mode has been activated.

3、Printer hotspot connection: Go through Settings – WLAN to connect to the printer hotspot of (KOKONI3D-xxxx) with the password of 12345678.

4、Connection to users' WiFi: Return to KOKONI App and enter the SSID and password of the currently available WiFi at user't place to have KOKONI printer connected to the Internet.

Attention:

Here are some simplified instructions regarding WiFi connectivity for certain phone models:

1.For certain phone models, it may take some time to find a WiFi hotspot. Please wait, refresh, or turn off the WiFi function and then restart it.

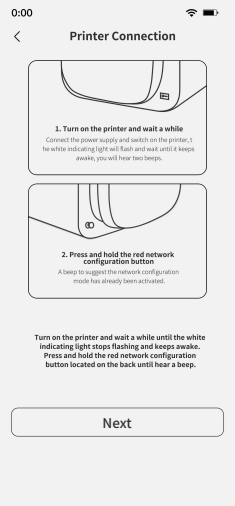
2.Please turn off the following functions on some phone models: WiFi Security Inspection, WLAN+, Network Intelligent Selection, Connect to the Best WLAN Network, and Automatically Switch the Cellular Network.

1.If you encounter issues with WiFi network configuration, please follow these steps to diagnose the problem:

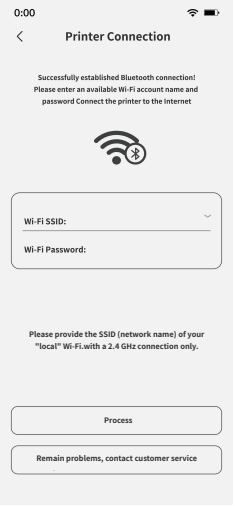
2.Double-check the WiFi account and password, ensuring that you are entering the correct credentials for the current WiFi environment and not the KOKONI3D hotspot.

Make sure the network environment is good. If the problem persists, try connecting to a different network. Please note that 5G WiFi is not compatible. For specific WiFi network configuration instructions for different phone models, refer to the Operation Guidance of the App.

Bluetooth Connection



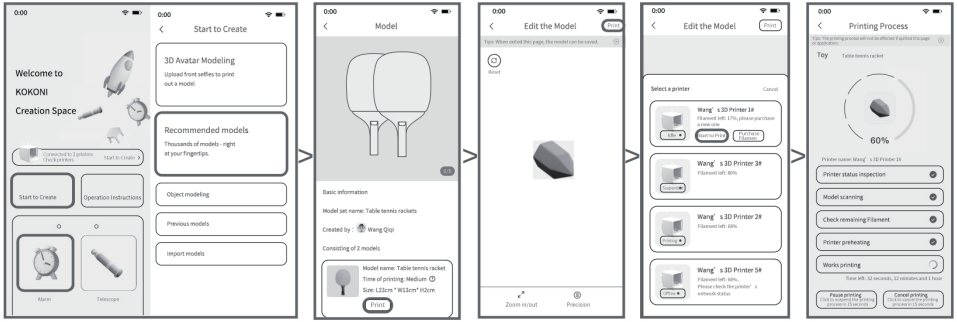
1.Connect the power supply and switch on the printer, wait until the white light stops flashing, then press and hold the red Network Configuration button till it beeps. Start the Bluetooth connection and wait for the pairing.



2.Successfully established Bluetooth connection, enter an available Wi-Fi name and password, connect the printer to the Internet.

Attention:

1. Please connect to your "local" Wifi SSID
2. Support 2.4GHz connection Only



1.Browse a model:
(1)Home – Start to Create – Recommended Models.
(2)Home – Popular Models – Select a Model

2.Click "Print" on the model details page.

3.Click "Print" on the model editing page.

4.Select the printer and Click "Print" to print.

5.While printing, you can pause or cancel the printing task.

Attention:

1.Once you start printing, the printer typically takes around 2 minutes to heat up. Please be patient and wait for it to complete the heating process.

2.It is crucial that you never touch any moving parts of the printer, as it can cause injuries. Be cautious of the hot nozzle. If anything goes wrong during the printing process, you can press on the "Cancel" button in KOKONI 3D App to stop the printing or simply unplug the power adapter. In such cases, try to avoid touching both the nozzle and the printing bed.

Video Monitoring

1.
Press on the "Video Monitoring" button during the printing process.

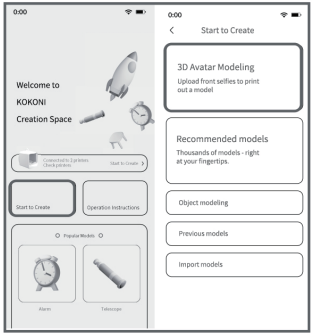
2.
You will be redirected to the Video Monitoring screen, and see the 5s video

Time-lapse Video

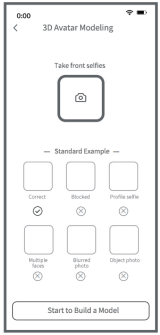
1.
Click on "View and Download Time-lapse Video" on the completed model printing screen

Note: If you close this page, the video will not be saved.

2.
You will be redirected to the Time-lapse Video screen, where you can download or share the video.

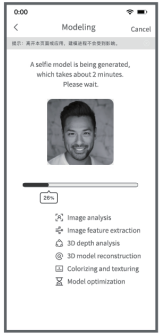


1、Home – Start to Create – 3D Avatar Modeling



2、Click "Upload Photos"

3、Click "Start Modeling"



4、Wait for modeling finished, you can print it out then.

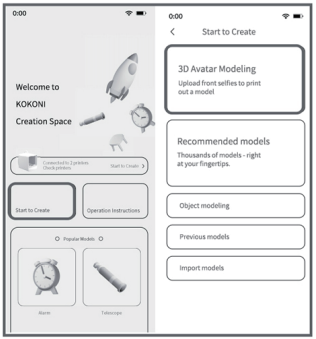
Attention:

1.Requirements for 3D Avatar modeling: (1) You can use a smartphone to capture a selfie or upload a photo. (2) Make sure the person is well-lit and facing the camera without any obstructions. (3) Avoid wearing hats in the photos. (4) Do not take side profile selfies. (5) Upload high-definition photos. (6) Only upload photos of one person. Please note that this function is only suitable for modeling the faces of living human beings.

2.If you see a prompt saying "no face," please try changing to a brighter environment, remove your glasses, and take a clear photo of your face without any obstructions.

3.If you see a prompt saying "Image format is not standard," please try taking pictures with your camera instead and avoid uploading motion pictures like GIFs.

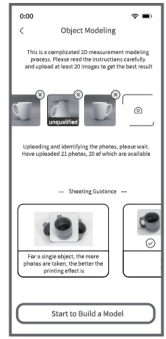
Object Modeling



1、Home – Start to Create – 3D Avatar Modeling

2、Click "Upload Photos"

3、Take photos around the object with each movement of the viewing angle less than 30 degrees



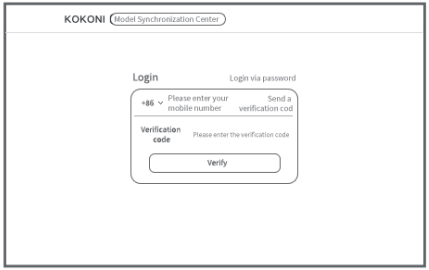
4、Taking at least 20 photos, and then then click "Start to Build a Model"

Attention:

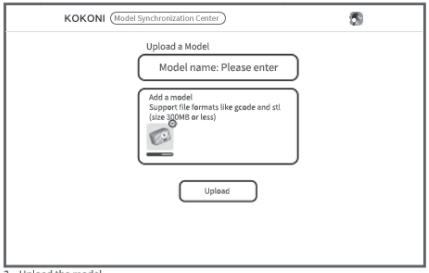
1.Object modeling requires precise 3-dimensional measurement using 20 to 300 images taken around the object. Each image should be taken from a different angle, with movements of the viewing angle being less than 30 degrees. The images should also overlap with each other by more than 60%.

2.The system will automatically verify if the uploaded photos meet the requirements. You need at least 20 qualified photos for the modeling process.

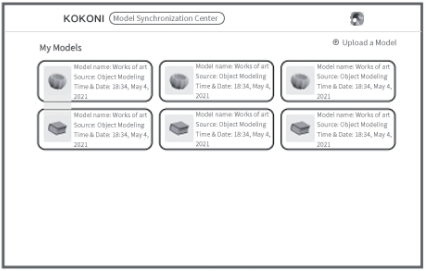
The modeling process, done through a computer algorithm, takes approximately half an hour in the background. You can close the page while the modeling is in progress. Once completed, a notification message will pop up if the "Push Notification" function is enabled. You can then check the model in the "My Models" section.



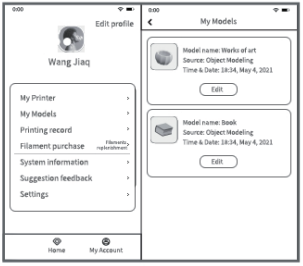
1、Access the KOKONI model synchronization website:
http://www.KOKONI.ltd/home/#/pages/modelSync/modelSync



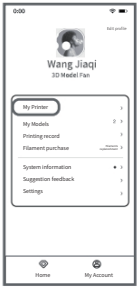
3、Upload the model



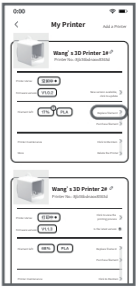
2、Enter "My Models" and click " Upload a Model " in the right upper corner



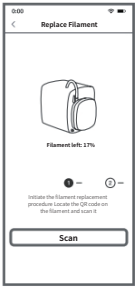
4、Go to"My Account" –"My Models" in the App to check uploaded models.



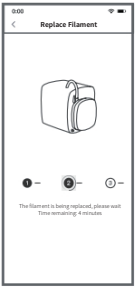
1.Go to "My Printer"



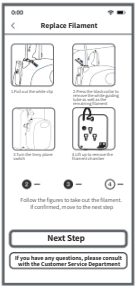
2.Click "Replace Filament"



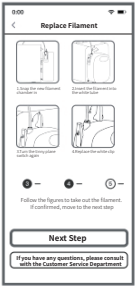
3.Scan the QR code on the filament box



4.The printer is heated up to prepare for filament replacement

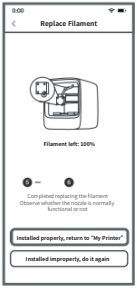


5.Refer to the figures as shown on Page 12 to uninstall the filament box

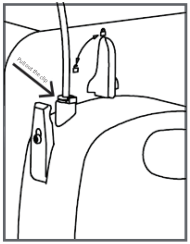


6.Refer to the figures as shown on Page 12 to attach the filament box to the printer.

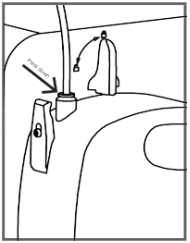
7.The filament is being loaded in, please wait.



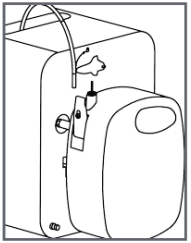
8.Filament replacement is finished.



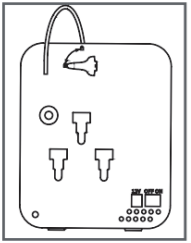
9. Pull out the white clip



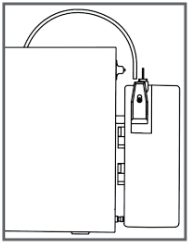
10. Press the black collar to remove the white guiding tube as well as the remaining filament



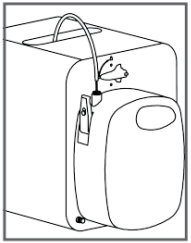
11. Turn the tinny plane switch



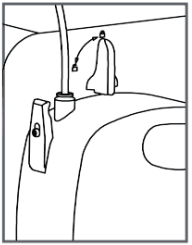
12. Lift up to uninstall the filament box.



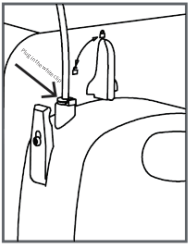
13. Snap the new filament box in.



14. Insert the filament into the white guidance tube



15. Turn the plane switch again

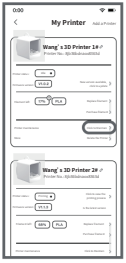


16. Plug in the white clip

Product Maintenance

In case the model is unable to be taken out from the printbed, or any foreign objects need to be removed from the printer, click "My Printer" in the App for maintenance. The printer will automatically heat up and push the printing bed outwards.

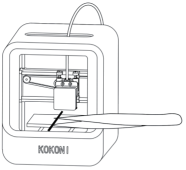
1.Go to "My Printer"



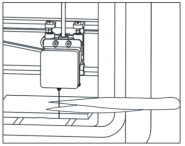
2.Click " Maintain "

3.Lift up the base plate with the model on to take it out from the cabinet and just bend the former a little bit to separate it from the latter (suggested to change the base plate every 3~6 month)

Cleaning Up



1.Clear the cabinet with tweezers



2.As the nozzle needs to heat up to 200°C more or less before started to print, it is normal to see surplus materials coming out.

Q: How can I make the surface of a model smoother?

A: To achieve a shiny and smooth surface for your model, you can use sandpaper or other polishing tools to smooth it out. You can also select the "High" precision setting for better surface finishing. If the condition is severe and difficult to fix, please contact the Customer Service Department.

Q: Can the printer work with other filaments?

A: Currently, the printer is only compatible with KOKONI modified PLA filament. Please use that filament for your printing needs.

Q: How do I change the filament?

A: To change the filament, open the KOKONI 3D App and navigate to "My Printer" - "Replace Filament" option. More detailed instructions can be found on pages 11-12 of the manual. Changing the filament without using the KOKONI 3D App may result in print quality issues or even damage to the printer itself.

Q: Why doesn't the model stick to the base plate?

A: If the first layer of the model doesn't stick to the base plate, apply a layer of glue to the base plate and ensure that the printing temperature is within the range of 20°C to 25°C. This temperature range helps prevent the base plate from bending. Model warping is a normal occurrence due to the physical properties of the plastic material, and printing in a warm environment can help reduce bottom warping.

Q: How many models can I make with one reel of filament?

A: The length of the filament reel is 70 meters, and the number of models it can produce depends on their size. Larger models may require more filament, and more complex models may also consume additional filament. On average, a reel of filament can print approximately 20 simple models.

Q: Can I resume a printing task after a power failure?

A: No, once a power failure occurs, the printing process ends and cannot be resumed.

Q: What should I do if the connected printer goes offline?

A: Try rebooting both the printer and the KOKONI 3D App. If the printer remains offline, delete it from the app and reconnect it for network configuration.

Hazardous Substance Declaration

KOKONI

Component	Hazardous or toxic substance or element					
	Lead (Pb)	Mercury (Hg)	Cadmium (Cd)	Hexavalent chromium (Cr6+)	Polybrominated biphenyls (PBB)	PBDE
Modified PLA filament	○	○	○	○	○	○
Printed circuit board (PCB)	×	○	○	○	○	○
Shell	○	○	○	○	○	○
Wire	○	○	○	○	○	○
Hardware	○	○	○	○	○	○
Power adapter	○	○	○	○	○	○

The said table is compiled according to the standards of SJ/T 11364.
○ Indicates that all homogeneous materials of the component in question contain the current hazardous substance less than the limit as provided in GB/T 26572.
× Indicates that at least one certain homogeneous material of the component in question contains the current hazardous substance above the limit as provided in GB/T 26572.

Notes: No batteries are needed by the printer.

Warranty Information

- The printer and power adapter are covered by a 1-year Limited Warranty starting from the date of purchase.
- Vulnerable parts such as the extruder, belt, and printing platform nozzle module have a 3-month Limited Part Warranty.
- Tools, filaments, printer shell, user manual, warranty card, and other similar items are not covered by any warranty.

What Is Not Covered ?

1.Warranty coverage expires after the specified period.

2.The purchase voucher is either invalid or does not match the product model.

3.Damage or illegibility of the purchase voucher or warranty card due to intentional actions.

4.Unintended use, maintenance, or repair of the printer, unauthorized dismantling of hardware, or alteration of software without KOKONI's permission.

5.Damage to the circuit board caused by accidents, such as crashes, water damage, falls, or other human-related factors.

6.Use of components not certified by the manufacturer.

7.Damage caused by unforeseen circumstances like fires, lightning, floods, or other force majeures.

8.Normal aging or discoloration of the product that occurs during regular operation.

9.Products received as gifts are not covered by the warranty.

After-sales Services

- Before using the product, please carefully read the user manual and warranty card.
- For any after-sales service or support, please contact the local seller or reach out to us via email at support@kokoni3d.com or by calling (+86)400-900-1360 or (+86)-572-8219691.
- When applying for technical support, please provide the product's serial number.

Warranty Card

KOKONI

Maintenance service center		Date of delivery for repair	
Reason behind fault			
Fault description			
Return evidence			
Repairer (signature)		Repairer (seal)	

Moxin (Huzhou) Technology Co., Ltd

Address: C13, Deqing Geo-Information Town Innovation Park, Huzhou City, Zhejiang Prov., China. Website: www.kokoni3d.com

Hotline: (+86)400-900-1360

Email: support@kokoni3d.com

1. Due to variations in models, the actual product may differ slightly from the pictures. Please refer to the prevailing product description for accurate details.

2.The software update page is subject to change. For the most up-to-date instructions, please refer to the instructions provided on the actual software page.

3. Moxin (Huzhou) Technology Co., Ltd. reserves all rights for the final interpretation of any matters related to the product.

FCC Statement:

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.

This equipment has been tested and found to comply with the limits for aClass B digital device, pursuant to part 15 ofthe FCCRules. Theselimits aredesigned to provide reasonable protection against harmful interference in a residential installation. This equipmentgenerates,usesandcanradiateradiofrequencyenergyand,ifnotinstalled andused inaccordance withthe instructions,may causeharmfulinterferencetoradio communications.However,there isno guaranteethatinterferencewill notoccur ina particularinstallation.Ifthisequipmentdoescauseharmfulinterferencetoradioor 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.

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

Thise quipment complies withFCC radiation exposure limits setforth for an uncontrolled environment. This transmitter must not be co-located or operating in conjunction with any other antenna or transmitter.

This equipment should be installed and operated with minimum distance 20cm between the radiator&your body.