



Shenzhen Kelandi Tech co.,ltd

Website: www.kelandi.cn/sy

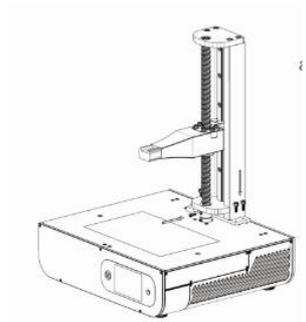
Contact : Sun Position : CEO & Foreign sales manager

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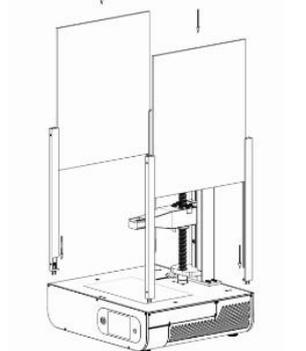
Email : jamesyihaoda@hotmail.com

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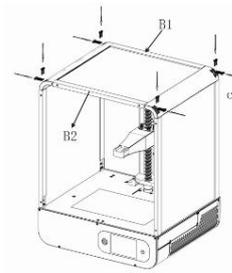
1. Parts assembling



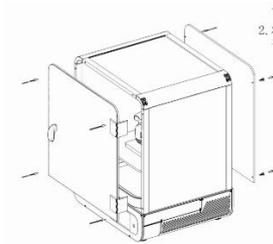
a) Insert the Z-axis module into printer and tighten it by M6 screws ; Inserts lead screw to coupling ,and tighten it by M3 screws



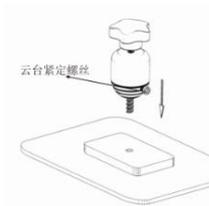
b) Case assembling 1) Insert 4 Pilar as image and tighten it by M3 screws , Pilar with Hinge on the right . 2) Tear acrylic protection paper and insert into pilar slot



c) 1) Fix 2 * R part to pliar , 2) Fix B1 part to R part 3) Insert acrylic to B1 part slot 4) Insert B2 part



d) 1) Assemble hinge and handle to front board 2) fix back board

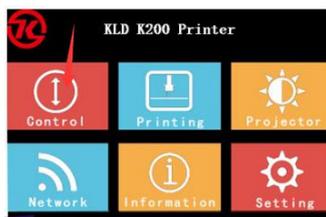


e) Platform assembling 1) tighten ball joint 2) tighten ball joint to base platform 3) Loose the "fix" screw as image shows

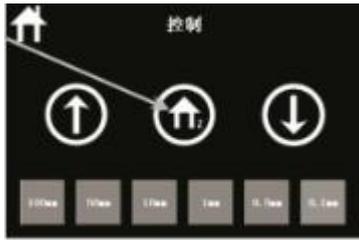
2. Platform levelling



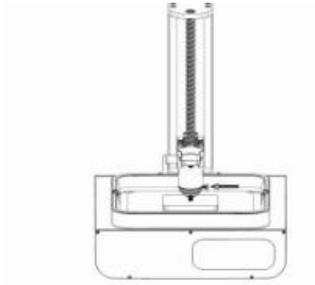
a) insert platform and fix it tightly , Rock the platform with your hand and make sure it has been loosened



b) Press "control" botton



C) Press "Home" button



d) tighten "fix" screw If the platform is not in the middle please adjust it manually

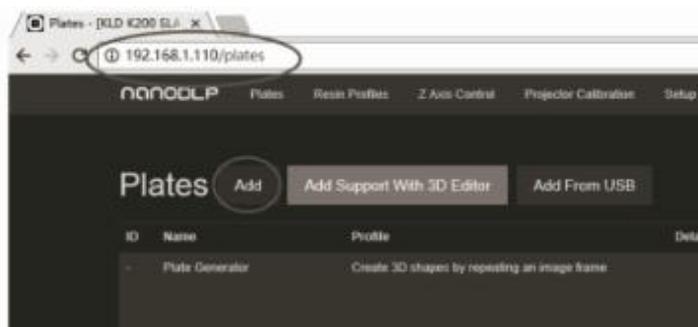
Notice : Make platform go up 50mm after it is calibrated , and pour resin to resin tray

3) Operation steps

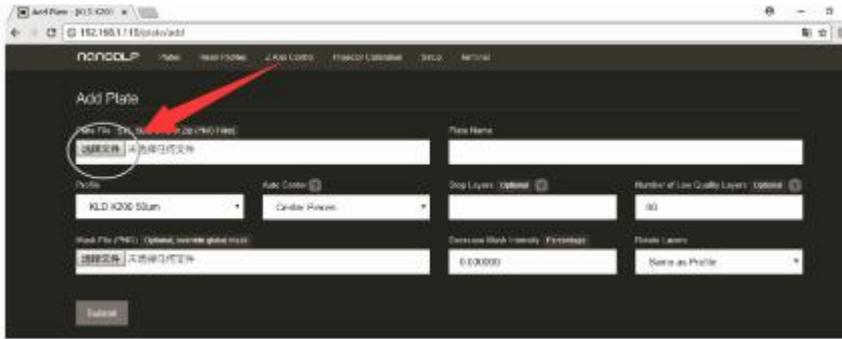
a) Connect ethernet cable between printer and router (make sure it is in the same network)



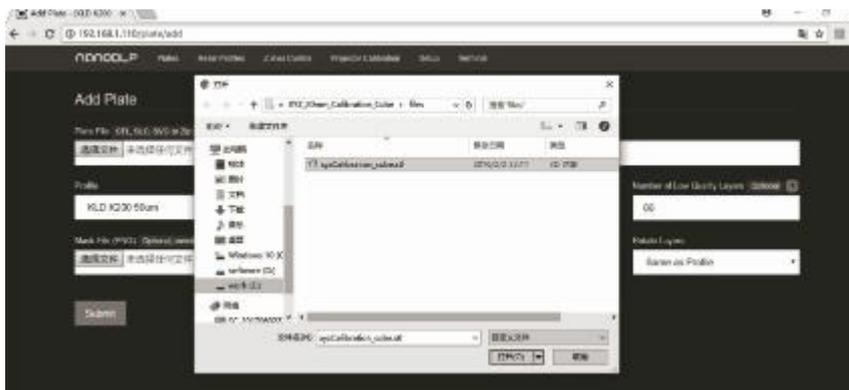
b) Click "Network"



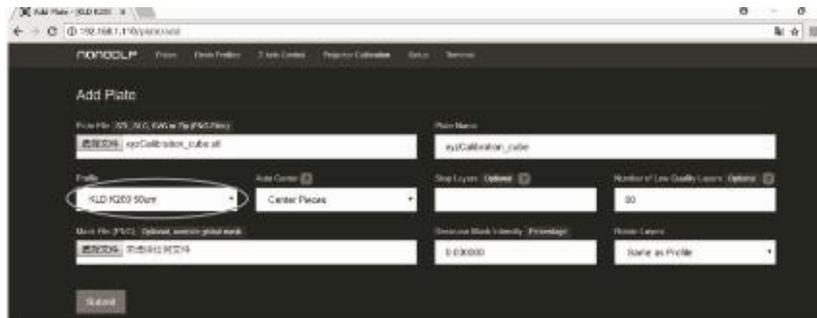
C) Search IP address at browser to connect printer (Notice: wifi can be connected only after some webpage parameters is modified)



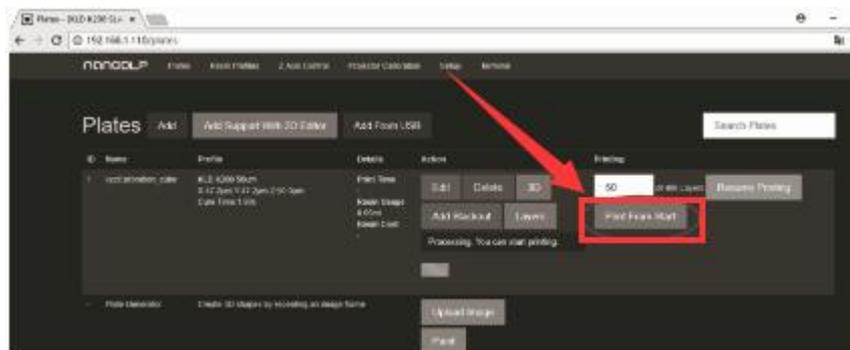
d) Click "add" to enter model upload page

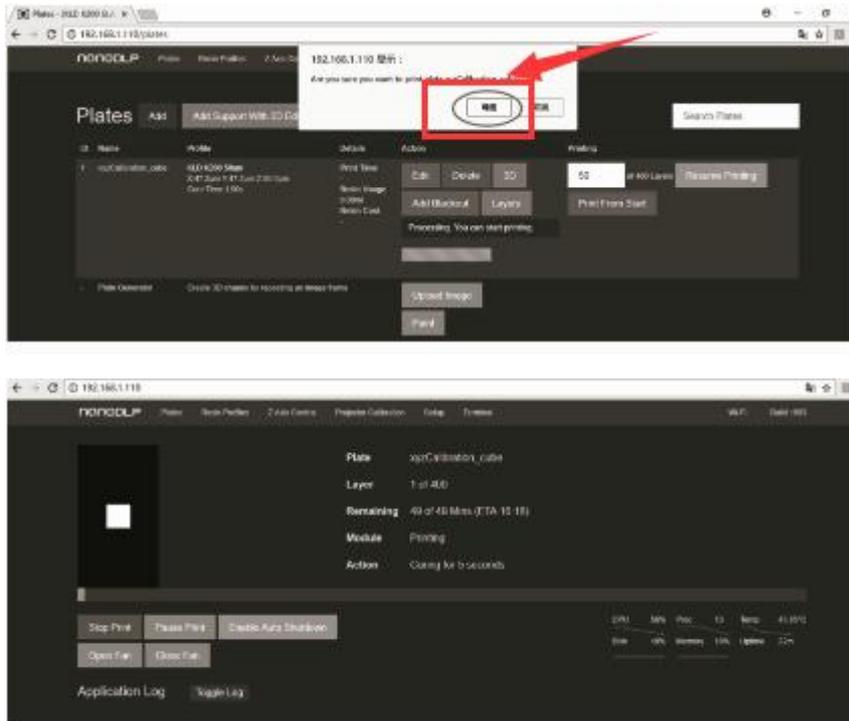


e) Choose the stl file and upload it



f) profile - Choose K200 50um (Resin parameters) and click "submit"





g) Press "start from start " to start printing
 Notice : Do not click any botton while printing

4) Precautions

- 1) Keep away from Children which below 12 when keep printer and resin
- 2) Keep away from inflammable and explosive materials
- 3) Make sure plateform is levelled before printing
- 4) Please change resin and clean resin tank if there is a fail print , or may result in destorying printer
- 5) Pour maximum half resin tray resin
- 6) Use 99.99% alcohol to wash the model after printing
- 7) Resin from other sellers can not be promised to work with our printer , please test yourself .

5) Model processing

- 1) Shovel the model off the platform
- 2) Wear protective gloves
- 3) Put the model into alcohol conatiner .and use toothbrush to clean the model surface , The best time to clean is around 2 minutes . It will get soft or brittle if it is too long .
- 4) It is better to left around 0.5mm while cut the "support" to avoid hole
- 5) Use rough polishing cotton at first to make model flat . and then use fine and finest cotton to polish .
- 6) Put the model into curing box after finished above steps