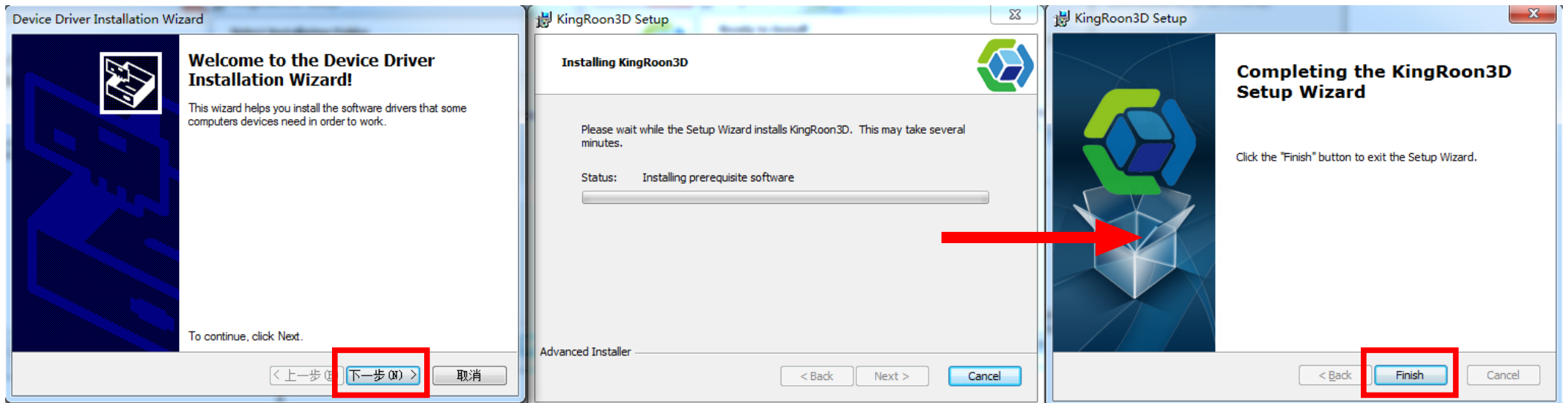
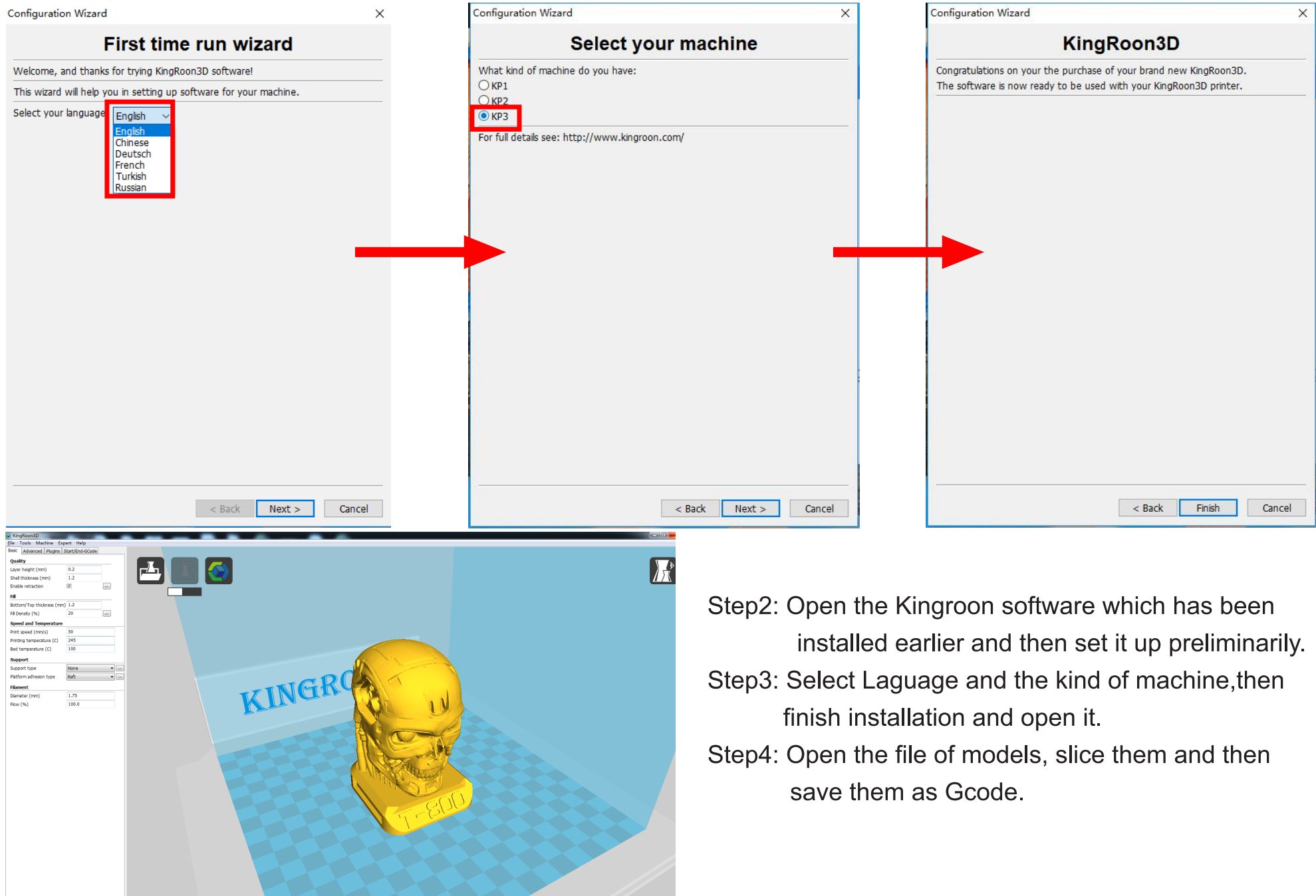


Instructions for software installation and basic parameter setting

Step1: Find the software in the TF card and then install it according to the guidance. Please see the following pictures.

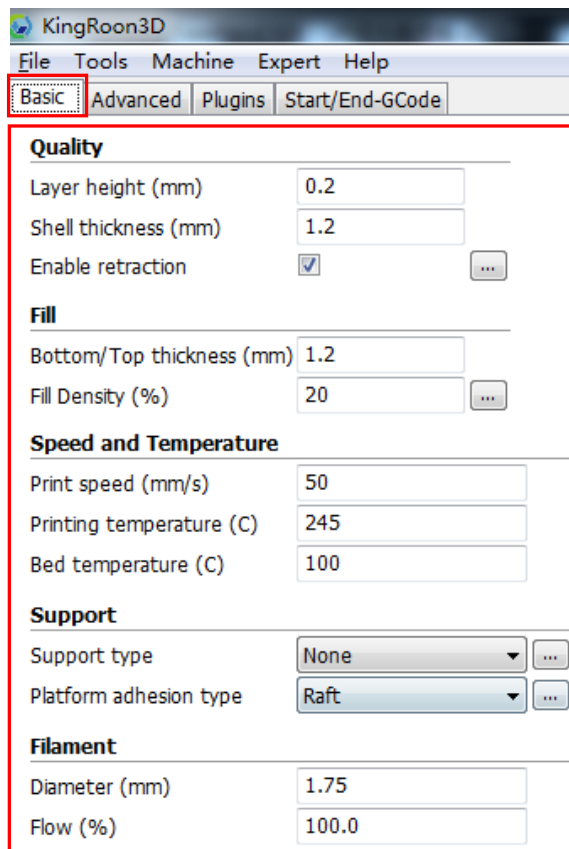


Instructions for software installation and basic parameter setting



- Step2: Open the Kingroon software which has been installed earlier and then set it up preliminarily.
- Step3: Select Language and the kind of machine, then finish installation and open it.
- Step4: Open the file of models, slice them and then save them as Gcode.

Instructions for software installation and basic parameter setting



KingRoon3D
File Tools Machine Expert Help

Basic Advanced Plugins Start/End-GCode

Quality

Layer height (mm) 0.2

Shell thickness (mm) 1.2

Enable retraction ☒

Fill

Bottom/Top thickness (mm) 1.2

Fill Density (%) 20

Speed and Temperature

Print speed (mm/s) 50

Printing temperature (C) 245

Bed temperature (C) 100

Support

Support type None

Platform adhesion type Raft

Filament

Diameter (mm) 1.75

Flow (%) 100.0

Basic setup

Layer height(mm)0.05-0.3mm,Recommended0.2mm

Shell thickness(mm)0.8-1.6mm,>0.8mm

Bottom/Top thickness(mm)0.8-1.6mm,>0.8mm

Fill Density(%)0-50,>0

Print speed(mm/s)30-150mm/s-Recommended 30-50mm/s

Printing temperature:PLA-190-220°C ABS-190-220°C

Bed temperature:PLA-40-60°C ABS-70-110°C

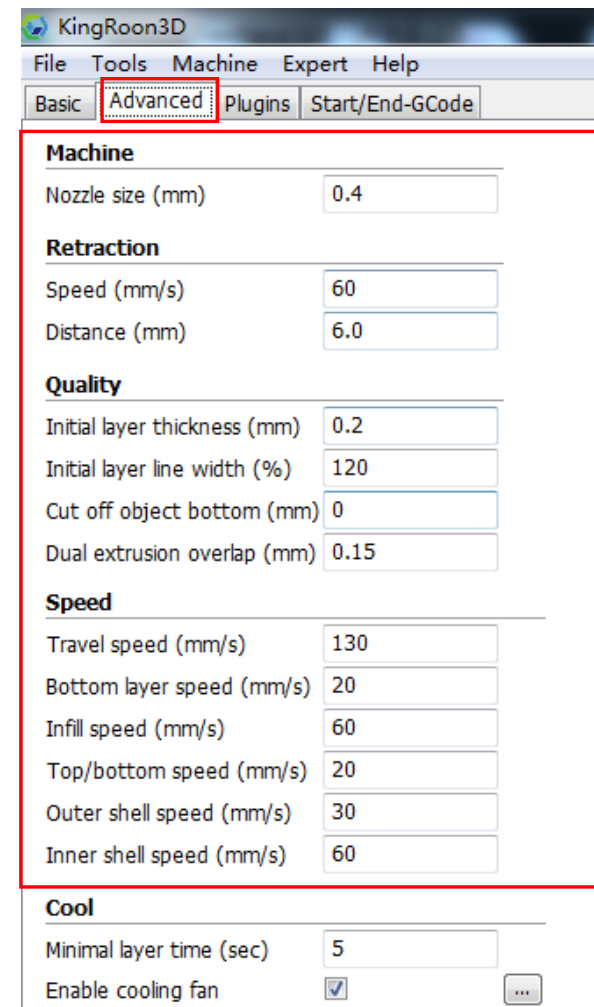
Support type:Models support type

Platform adhesion type:Make models and Bed better attached

Filament Diameter(mm):1.75

Flow(%):100

Machine Nozzle size(mm):0.4



KingRoon3D
File Tools Machine Expert Help

Basic Advanced Plugins Start/End-GCode

Machine

Nozzle size (mm) 0.4

Retraction

Speed (mm/s) 60

Distance (mm) 6.0

Quality

Initial layer thickness (mm) 0.2

Initial layer line width (%) 120

Cut off object bottom (mm) 0

Dual extrusion overlap (mm) 0.15

Speed

Travel speed (mm/s) 130

Bottom layer speed (mm/s) 20

Infill speed (mm/s) 60

Top/bottom speed (mm/s) 20

Outer shell speed (mm/s) 30

Inner shell speed (mm/s) 60

Cool

Minimal layer time (sec) 5

Enable cooling fan ☒

Advanced setup

If a fly wire appears during printing processes,
pls modify the Retraction.

Retraction Speed(mm/s):40-80mm/s

Retraction Distance(mm):4-8mm

Quality,Speed,Cool,
default parameters can keep it original.

Instructions for software installation and basic parameter setting

