

Glitar Series Desktop 3D Printer User Guide



MINGDA Technology Co.,LTD











4 LastStep NextStep Back OFFLIN Adjust Platform 1 Select 3 2 Select -Select **NextStep** for 5 times, and review the gap between nozzle with hot bed, it's recommended by ~0.1 mm (It's proximate to the thickness of paper). Notes: Only need to calibrate for the first time.





Notes: It's recommended to stick a masking tape on the hot bed.

6 Installing Cura 14 version and guide

C Cura 14.09 Setup			- x	C Cura	14.09 Setup			- 🗆 🗙
Choose Components				Installia				
Choose which features of Cura 14.09	9 you want to install.			Please	ng wait while Cura 14.09 is be	eing installed.		
Check the components you want to in install. Click Install to start the installa	nstall and uncheck the componen ation.	nts you don't wa	ant to	Extrac	t: glunurbs.py			
Select components to install:	Cura 14.09 Install Arduino Drivers Open STL files with Cura Open OBJ files with Cura Open AMF files with Cura Uninstall other Cura versions				m octans			
Space required: 89.3MB								
Nullsoft Install System v2.46	< Back	nstall	Cancel	Nullsoft Ir	ıstall System v2.46 ———		< Back Next >	Cancel
	(1)			<u></u>		\bigcirc		
Davice Driver Installation Witard	<u>.</u>		File Tools M	achine Exc	ert Help	9		
Device Driver instandton Wizard		-	Machine setting	15	for the state			×
Completin Installatio	ng the Device Driver on Wizard		Gitar6c			_		
			Machine sett	inas		Print	er head size	
The drivers were	successfully installed on this computer.		E-Steps per 1	mm filament	85	Head	size towards X min (mm)	0
You can now co came with instru	nnect your device to this computer. If yo ctions, please read them first.	ur device	Maximum widt	:h (mm)	300	Head	size towards Y min (mm)	0
			Maximum dept	th (mm)	200	Head	size towards X max (mm)	0
			Maximum heig	ht (mm)	600	Head	size towards Y max (mm)	0
			Extruder coun	t	1	 Printe 	er gantry height (mm)	0
Driver Name	Status		Heated bed Machine center	er 0.0		Com	munication settings	
✓ Arduino LLC	C (www.ardui Ready to use		Build area shap	pe	Square	 Serial 	port	AUTO -
			GCode Flavor		RepRap (Marlin/Sprinter)	 Baudr 	ate	AUTO •
	<上一步® 完成	取消	Ok	Add new n	Remove mach	hine Change n	nachine name	
	3					4		
	File Tools Machine Ex	pert Help				-		
	Machine settings	And State Street		_		X	_	
	Gitar6C Gitar5C Gitar4C							
	Machine settings			Print	ter head size			
	E-Steps per 1mm filament	85		Head	size towards X min (mm)	0		
_	Maximum width (mm)	300		Head	size towards Y min (mm)	0		
(\mathbf{r})	Maximum depth (mm)	200		Head	size towards X max (mm)	0	-	
	Maximum height (mm)	400	-	Head	size towards Y max (mm)	0	-	
	Heated bed	v		Com	munication settings			
	Machine center 0,0 Build area shape	Square	-	Serial	port	AUTO -	ā	
	GCode Flavor	RepRap (Mari	in/Sprinter) 👻	Baud	rate	AUTO -	Ĩ	
	Ok Add new	machine R	emove machine	Change r	machine name			
	File Tools Machine Exp	pert Help					2	
	Machine settings	Contraction of Con-		_		×	-	
	Gitar6C Gitar5C Gitar4C						_	
	Machine settings			Print	er head size		=	
	E-Steps per 1mm filament	85		Head	size towards X min (mm)	0		
	Maximum width (mm) 300			Head	size towards Y min (mm)	0	-	
	Maximum depth (mm)	200		Head	size towards X max (mm)	0		
\mathbf{O}	Extruder count	1		Printe	r gantry height (mm)	0		
	Heated bed	V	•	Corre	nunication cottings			
	Machine center 0,0	Sauara		Sarial	numcation sectings	AUTO	ā	
	GCode Flavor	RepRap (Mark	/Sprinter) -	Baudr	ate	AUTO -		
		mehina a	mana meshini)	Chrone	achina anna		2	
	Ok Add new r	nachine Re	move machine	Change n	nachine name			

Cura - 14.09	
File Tools Machine Expe	ert Help
Basic Advanced Plugins S	tart/End-GCode
Quality	
Layer height (mm)	0.1
Shell thickness (mm)	1.2 Range 0.1~0.2
Enable retraction	
Fill	
Bottom/Top thickness (mm)	1.2
Fill Density (%)	0
Speed and Temperature	
Print speed (mm/s)	80
Printing temperature (C)	210
Bed temperature (C)	50
Support	
Support type	Touching buildplate 🔻
Platform adhesion type	None 🔻
Filament	
Diameter (mm)	1.75
Flow (%)	100.0

7

Cura 14.00	-					
File Tools Machine Evo	ert Help					
Paris Advanced Blugins Start/End Code						
pasic Auvanceu Piugins Start/End-GCode						
Machine						
Nozzle size (mm)	0.4					
Retraction						
Speed (mm/s)	40					
Distance (mm)	4.5					
Quality						
Initial layer thickness (mm)	0.3					
Initial layer line width (%)	100					
Cut off object bottom (mm)	0.0					
Dual extrusion overlap (mm)	0.2					
Speed						
Travel speed (mm/s)	100					
Bottom layer speed (mm/s)	20					
Infill speed (mm/s)	0					
Outer shell speed (mm/s)	0					
Inner shell speed (mm/s)	0					
Cool						
Minimal layer time (sec)	5					
Enable cooling fan	V					

It's not available for ABS material.



7 FAQ&Solutions

Printing Problem

- Q1:The filament doesn't stick onto the build plate.
- A1: The gap between nozzle and build plate is too big.
- A2: The build plate has not been leveled yet.
- A3: Kapton tape has not been sticked on the build plate yet; or the non-sticky top layer of the Kapton tape is not removed.
- A4:The first layer's height is too small, recommended setting as ≥ 0.2

Q2: Print in the air.

A:The nozzle is too far from plate, please adjust the limitation switch or the screws under the heat bed.

Q3: No filament output from the nozzle.

A:The filament has not entered into the end of the nozzle yet when you feed the filament.

Q4: Model surface is loose with crack

A:The layer thickness is too big; Or printing speed is too high(the nozzle temperature needs to do responded balance to have a faster printing speed); Or the temperature is too low; Or the wall thickness is too thick; Or the feeding device's fixing screw is too loose; Or wrong choice of filament diameter; Or filament quality is poor; Or the filament gets stuck and could not be fed smoothly.

Q5: Model surface is unsmooth

A: Reduce the retraction travel; Or reduce minimal extrusion before retracting;

Q6: Failed prototyping of small model

A: If printing a small model, the extruder will always move in a small space, so the heat will be concentrated in the model, and hard to be distributed. The solution is to print 3-4 pieces of the small model together. If so, the extruder will move among different models, leaving time for heat dissipation.

Hardware problem

- Q7: Filament Feeder Motor make intermittent noise
- A: 1. The clamp of the feeding device is too tight. Loosen the screw of the clamp. 2. Nozzle clogging, causing the filament not to be fed smoothly. Please clean the nozzle
 - with drill and needle.

Q8: Nozzle clogged

- A:1. There is the impurity in the filament, which is stacked in the nozzle.Please clean the nozzle by the needle; or take the nozzle off and clean inside of the nozzle by needle and drill.
 - 2. The nozzle is overheated causing the filament carbonized inside. Please clean the nozzle by needle; or take the nozzle off and clean inside of the nozzle by needle and drill.
 - 3. The deformation of the nozzle hole occurred by external force. Please replace the nozzle.

Q9: The nozzle heating failed

- A: 1. The heating tube connection is too loose. Please tighten the connection.
 - 2. Check the heating wire is well connected to mainboard.
- Q10: Print Head Stuck/Cannot move
- A: 1. The axis lack of lubricating oil. Please clean the axes and smear the lubricating oil evenly
 - 2. The deformation of machine framework caused by external force during the transportation.
 - 3. The cable connection of X.Y motor is loose. Please open the machine base, check and re-connect the cable.

Mingda Technology Co.,Ltd.

Address: MinLe Technical Building,Minle Industrial Zone, Meiban Road, Longhua New district,Shenzhen,Guangdong Province, China.

Sales director: Doris Hot line: 86-0755-82783379 Email: md-99@163.com Website: www.md-3d.com Cell Phone: 86-13500068891 Fax: 86-0755-82788221 Skype: mdantistatic QQ: 751326193