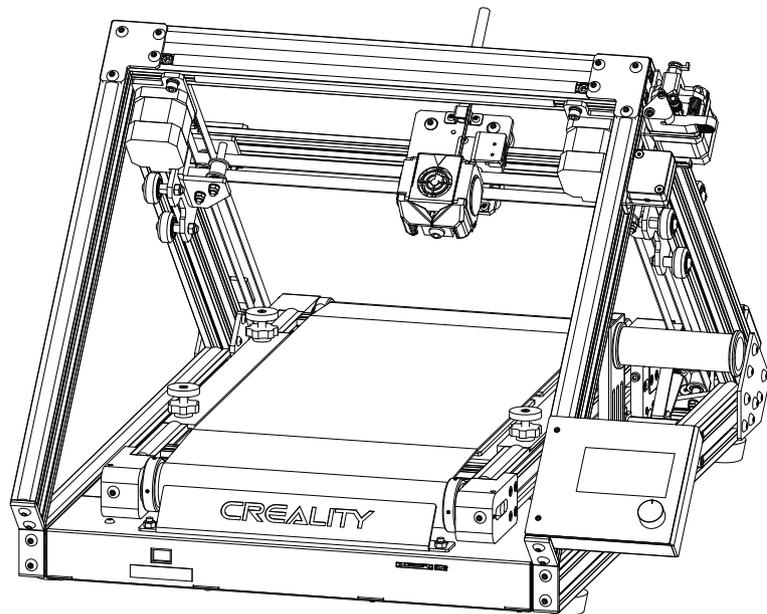


CREALITY

3DPrintMill

3D打印机使用说明书

3D Printer User Manual



V2.0

Content 目录

Dear Consumers,

Thank you for choosing our products. For the best experience, please read the instructions before operating the Printer. Our teams will always be ready to render you the best services. Please contact us via the phone number or e-mail address provided at the end when you encounter any problem with the Printer.

For a better experience in using our product, you can also learn how to use the Printer in the following ways:

View the accompanied instructions and videos in the storage card.

Visit our official website www.creality.com to find relevant software/hardware information, contact details and operation and maintenance instructions.

尊敬的创想三维用户：

感谢您选择、使用创想三维的产品。为了您使用方便，请您在使用之前仔细阅读该说明书，并严格按照说明书的指示进行操作。

创想三维团队时刻准备为您提供优质的服务。在使用过程中无论遇到什么问题，请按照说明书结尾所提供的电话、邮箱与我们联系。

为了您能够更好地体验我们的产品，您还可以从以下方式获取设备操作知识：

随机使用说明：你可以在存储卡内找到相关使用说明及视频。

创想三维官网：www.cxsw3d.com 您可以登陆创想三维官网寻找相关软硬件、联系方式、设备操作、设备保养等信息。

A

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使用须知

B

Assemble the 3D Printer

组装 3D 打印机

C

Use the 3D Printer

使用 3D 打印机

Load Filament

装料

Start Printing

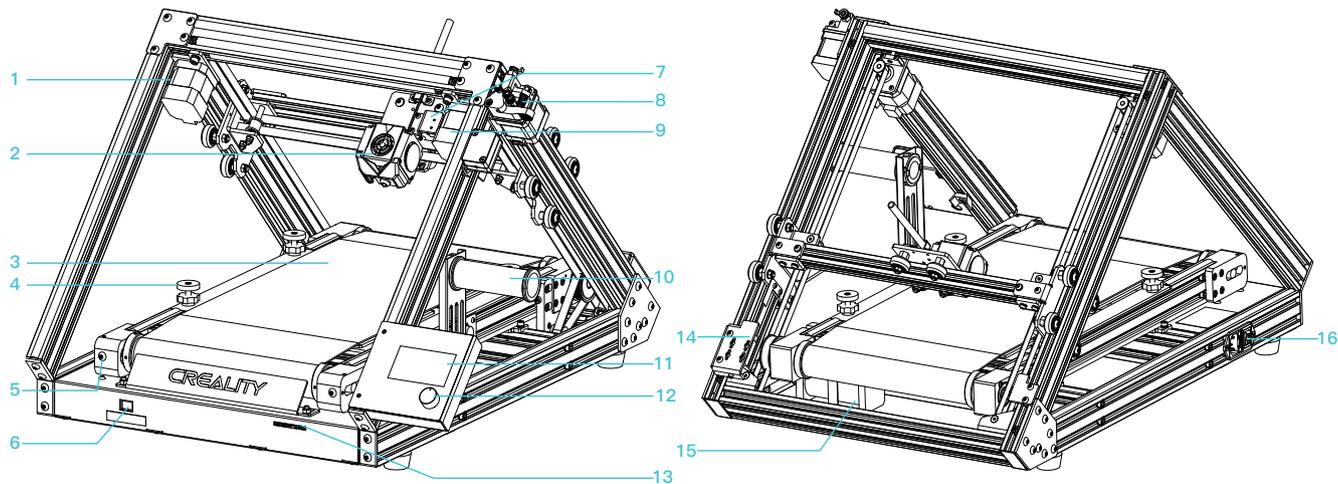
开始打印

NOTES 使用须知

1. Do not use the printer any way other than described herein in order to avoid personal injury or property damage.
2. Do not place the printer near any heat source or flammable or explosive objects. We suggest placing it in a well-ventilated, low-dust environment.
3. Do not expose the printer to violent vibration or any unstable environment, as this may cause poor print quality.
4. Before using experimental or exotic filaments, we suggest using standard filaments such as ABS or PLA to calibrate and test the machine.
5. Do not use any other power cable except the one supplied. Always use a grounded three-prong power outlet.
6. Do not touch the nozzle or printing surface during operation as they may be hot. Keep hands away from machine while in use to avoid burns or personal injury.
7. Do not wear gloves or loose clothing when operating the printer. Such cloths may become tangled in the printers moving parts leading to burns, possible bodily injury, or printer damage.
8. When cleaning debris from the printer hotend, always use the provided tools. Do not touch the nozzle directly when heated. This can cause personal injury.
9. Clean the printer frequently. Always turn the power off when cleaning, and wipe with a dry cloth to remove dust, adhered printing plastics or any other material off the frame, guide rails, or wheels. Use glass cleaner or isopropyl alcohol to clean the print surface before every print for consistent results.
10. Children under 10 years of age should not use the printer without supervision.
11. This machine is equipped with a security protection mechanism. Do not manually move the nozzle and printing platform mechanism manually while booting up, otherwise the device will automatically power off for safety.
12. Users shall comply with related nation and region's laws, regulations and ethical codes where the equipment or produced prints by it is used, and users of our product shall not use aforesaid products to print any end-use products, objects, parts or components or any other physical prints that violate the national or regional laws, regulations and ethical codes where herein referred product and produced prints by it is located.

1. 请勿尝试任何使用说明中没有描述的方法来使用本机，避免造成意外的人身伤害和财产损失；
2. 请勿将本机放置在易燃易爆物品或高热源附近，请将本机放置在通风、阴凉、少尘的环境内；
3. 请勿将打印机放置在振动较大或者其他不稳定的环境内，机器晃动会影响打印机打印质量；
4. 建议使用厂家推荐耗材，以免造成挤出头堵塞和机器损坏；
5. 请勿在安装过程中使用其他产品电源线代替，请使用本机附带的电源线，电源插头需插在带有地线的三孔插座；
6. 请勿在打印机工作时接触喷嘴以及热床，以防止出现高温烫伤，造成人身伤害；
7. 请勿在操作机器时佩戴手套或缠绕物，以防可动部件对人身部位造成卷入挤压和切割伤害；
8. 在打印完毕后及时利用喷头的余温借助工具将喷头上的耗材清理干净，清理时请勿直接用手触摸喷头，以防出现烫伤；
9. 常做产品维护，定期在断电的情况下，用干布对打印机做机身清洁，拭去灰尘和粘结的打印材料、导轨上的异物；
10. 年龄在10岁以下的儿童，请勿在没有人员监督的情况下使用本机，以免造成人身伤害；
11. 本机设有安全保护机制，请勿在开机状态下手动快速移动喷头及打印平台机构，否则设备会自动断电机保护；
12. 使用者应遵守设备打印产品与设备所在地及相应国家及地区法律、法规，恪守职业道德，严禁使用我司产品打印有违设备打印产品与设备所在地及相应国家、地区法律禁止的任何产品或物件。

Introduction 设备简介



1 X motor
X电机

5 Belt tensioning screw
皮带张紧螺丝

9 Y motor
Y电机

13 Storage card slot and USB socket
存储卡槽及USB插口

2 Nozzle kit
喷头套件

6 Manual power switch
手拨电源开关

10 Material rack and material tube
料架及料管

14 Y-axis limit adjustment component
Y轴限位调节组件

3 Printing platform
打印平台

7 X axis limit switch
X轴限位开关

11 Knob screen
旋钮屏

15 Z axis belt motor
Z轴皮带电机

4 Bed leveling nut
调平螺母

8 Extruder
挤出机

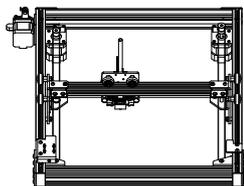
12 Knob
旋钮

16 Power cable connection
电源组合开关

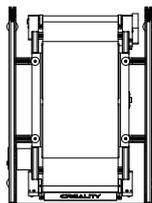
Parameters 设备参数

Basic Parameters 基本参数	
Model 型号	3DPrintMill
Print size 成型尺寸	无限长*200*170mm (长*宽*高) Infinite length*200*170mm (length*width*height)
Molding technology 成型技术	FDM
Number of nozzle 喷头数量	1
Layer thickness 打印层厚	0.1mm-0.4mm
Nozzle diameter 喷嘴直径	Standard 标配 0.4mm
XY axis precision 精度	±0.1mm
Filament 打印材料	PLA/TPU/PETG
File format 支持格式	STL/OBJ/AMF
File transfer 打印方式	Storage card 存储卡脱机打印
Compatible slicing software 可兼容切片软件	CrealityBelt
Power specification 电源规格	Input 输入:100-120/200-240V 50/60Hz Output 输出:24V/14.6A
Total power 总功率	350W
Hotbed temperature 热床温度	0-100°C
Nozzle temperature 喷嘴温度	0-240°C
Resume printing function 断电续打	Yes 有
Filament sensor 断料检测	Yes 有
Dual z-axis screws 双Z轴丝杆	No 不支持
Language switch 语言切换	English 中文
Computer operating system 电脑操作系统	Windows XP/Vista/7/10
Print speed 打印速度	≤180mm/s, 30-60mm/s normally ≤180mm/s, 正常为30-60mm/s

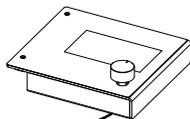
Parts List 零部件清单



1 X/Y axis belt assembly x1
X/Y轴皮带组件



2 Bottom belt assembly x1
底部皮带组件



3 Display kit x1
显示屏组件



4 Spool holder 料架 x1



5 Filament 耗材 x1



6 Profile bracket 1 x1
型材支架1



7 Profile bracket 2 x1
型材支架2

Accessory tool list 配件工具清单



8 Storage card and card reader x1
存储卡和读卡器



9 Diagonal pliers x1
剪钳



10 Cable tie x10
扎带



11 Needle x1
通针



12 Blue line claw x2
蓝色线夹



13 Pneumatic connector x2
气动接头



14 Power cord x1
电源线



15 Wrenches and screwdrivers x1
扳手和螺丝刀



16 M5T nuts x6
M5 T型螺母



17 Photoelectric switch line x1
光电开关线



18 Hexagon socket flat round head screw M5X8 x6
内六角平圆头螺钉M5X8



19 Hexagon socket flat round head screw M5X12 x6
内六角平圆头螺钉M5X12



20 Hexagon socket flat round head screw M5X18 x10
内六角平圆头螺钉M5X18



21 Hexagon socket head spring washer combination screw M5X45 x4
内六角圆柱头弹垫组合螺钉M5X45



22 Hexagon socket head spring washer combination screw M5X12 x4
内六角圆柱头弹垫组合螺钉M5X12



23 Teflon tube x1
铁氟龙管



24 Nozzles x2
喷嘴



25 Socket wrench x1
套筒扳手



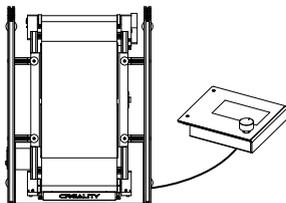
26 Feeler x1
塞尺

*Tips: the above accessories are for reference only, please refer to the physical accessories! 注意：以上配件仅供参考，请以实物为准！

1

Install the Profile Support Frame

安装型材支撑架



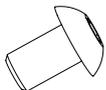
2 Bottom belt assembly x 1
底部皮带组件



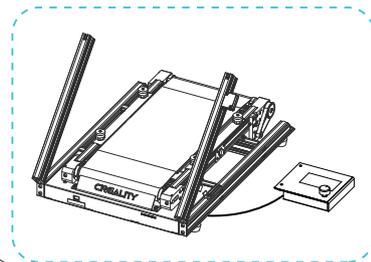
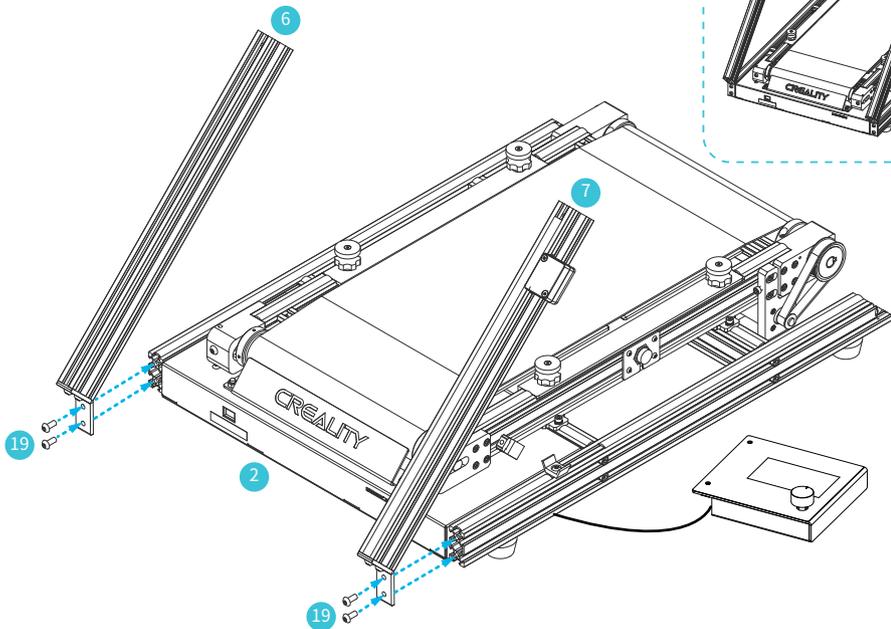
6 Profile bracket 1 x 1
型材支架1



7 Profile bracket 2 x 1
型材支架2



19 Hexagon socket flat round
head screw M5X12 x 4
内六角平圆头螺钉M5X12



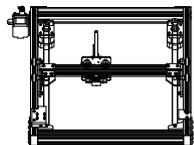
Step: Install the profile support 1 and profile support 2 to the bottom of machine with four hexagon flat head screws M5x12 (As shown in the figure above).

步骤：用4颗内六角平圆头螺钉M5X12将型材支撑架1和型材支撑架2安装到底部组件上（如上图）。

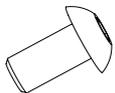
2

Install X/Y Axis Belt Assembly

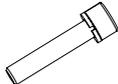
安装X/Y轴皮带组件



- 1 X/Y axis belt assembly x 1
X/Y轴皮带组件



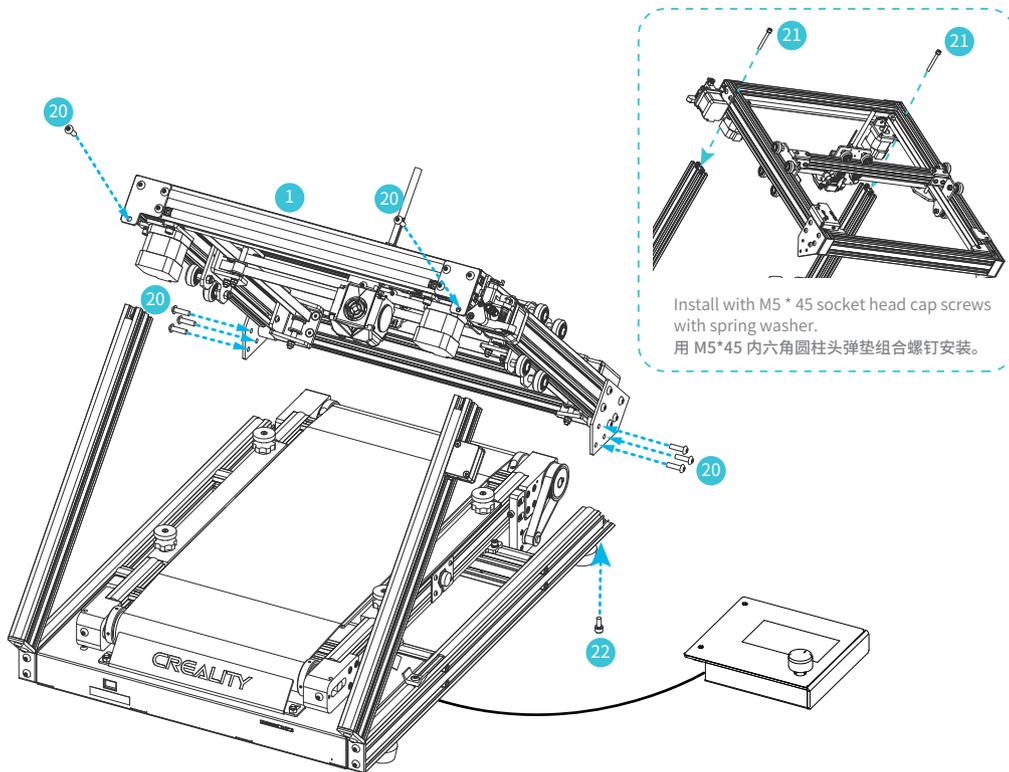
- 20 Hexagon socket flat round head screw M5X18 x 8
内六角平圆头螺钉M5X18



- 22 Hexagon socket head spring washer combination screw M5X12 x 2
内六角圆柱头弹垫组合螺钉M5X12



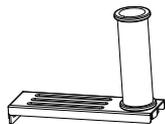
- 21 Hexagon socket head spring washer combination screw M5X45 x 2
内六角圆柱头弹垫组合螺钉 M5X45



3

Install the Spool Holder

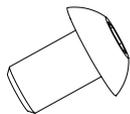
安装料架



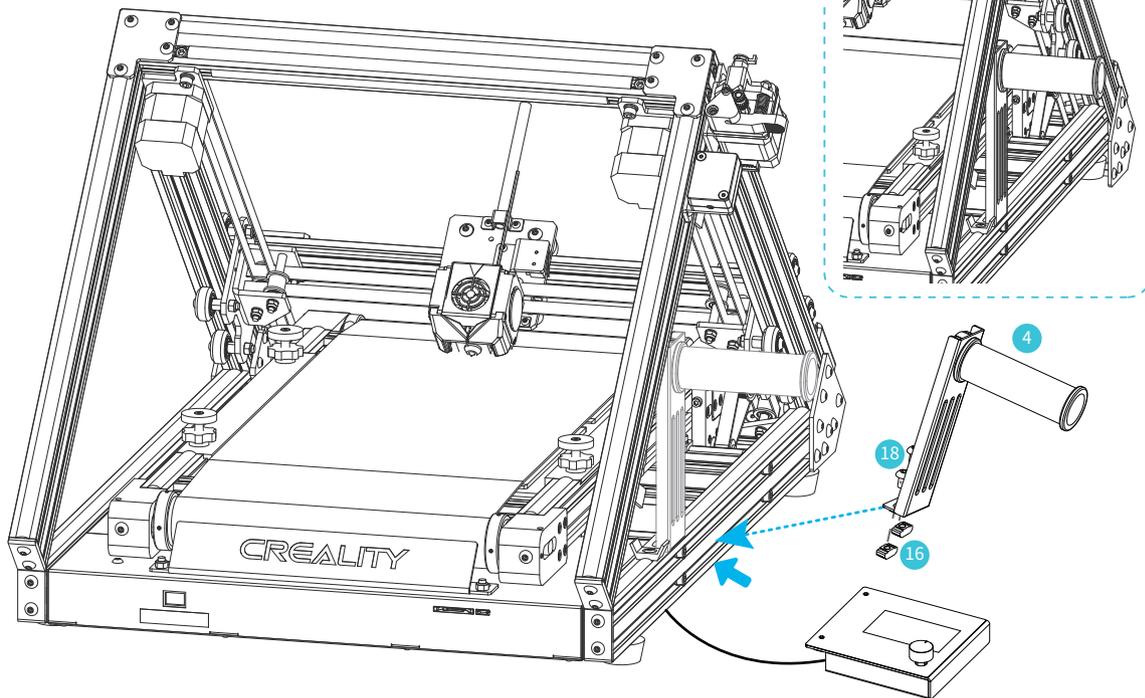
4 Spool holder料架 x 1



16 M5T nuts M5 T型螺母 x 2



18 Hexagon socket flat round head screw M5X8 x 2
内六角平圆头螺钉M5X8



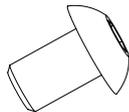
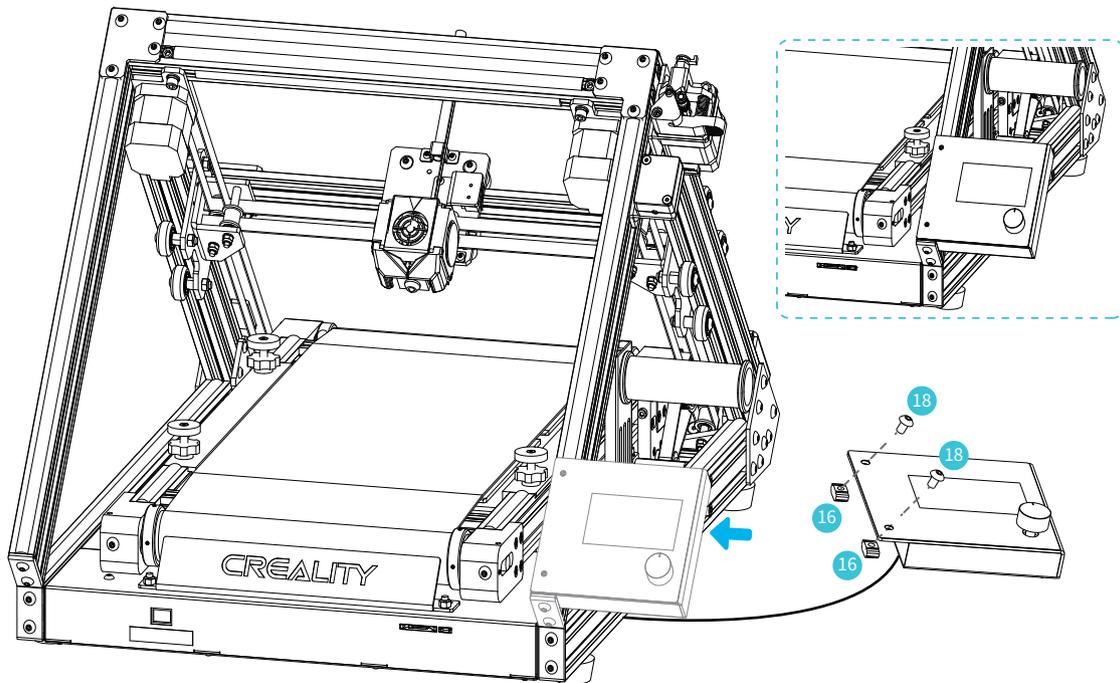
4

Install the Display

安装显示屏



16 M5T nuts M5 T型螺母 x 2

18 Hexagon socket flat round head screw M5X8 x 2
内六角平圆头螺钉M5X8

Step: Lock the display assembly with two M5X8 flat head screws and two M5 T-nuts, as shown in the figure above;
步骤：用2颗M5x8的平圆头螺丝跟2颗M5 T型螺母将显示屏组件锁住，如上图示；

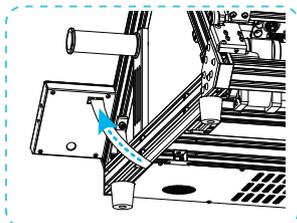
5

Cable Connection

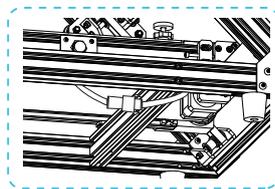
设备接线



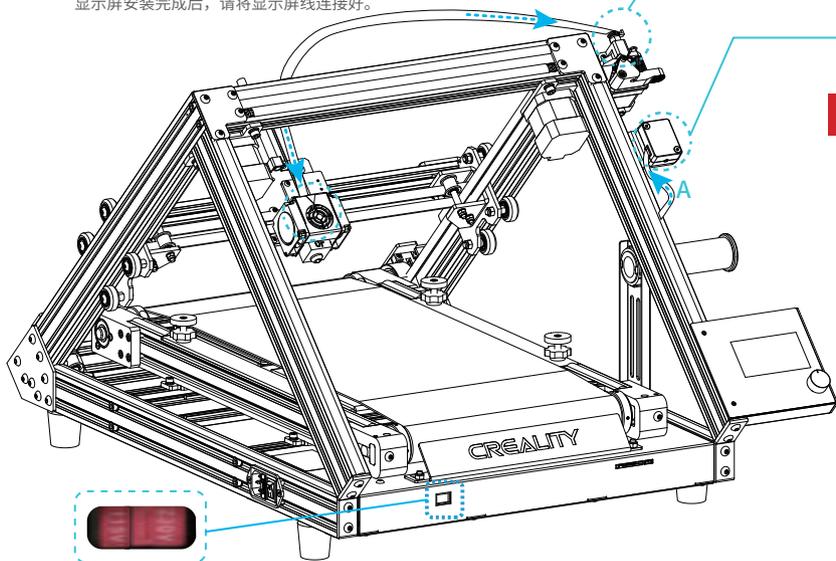
14 Power cord x 1
电源线



After the display is installed, please connect the display cable.
显示屏安装完成后, 请将显示屏线连接好。



Connect the Y-axis limit line.
连接Y轴限位线。



Insert the Teflon tube into the pneumatic connector (also insert the blue wire clamp)
将铁氟龙管插入气动接头 (同时插入蓝色线夹)



Connect the broken detection line as shown in Figure A. | 按图示A连接断料检测线。



Caution

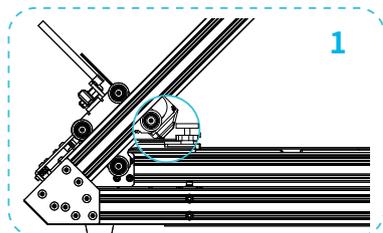
- Select the correct input voltage match your local power. **(115/230V)**
- Damage can occur if voltage is set incorrectly.
- Connect the power cord to turn the power switch on.
- 选择正确的输入电压以匹配您的本地电源。 **(115/230V)**
- 如果电压设置不正确, 可能会造成损坏。
- 连接电源线打开电源开关。

Do not connect or disconnect the cables when the machine is powered on.
当机器通电时, 请勿连接或断开连接线。

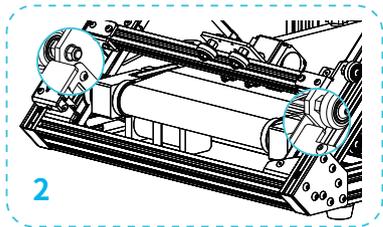
6

Leveling 调平

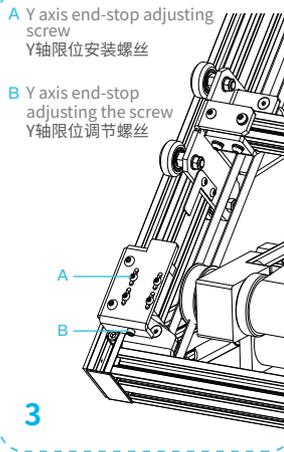
1. First move the X axis to the contact part between the nozzle and the belt (slightly press the nozzle onto the belt). 2. Push the two limit switches against the X sliding block to lock the limit; 3. Press back on the screen to get the printer back to the origin; adjust the Y axis end-stop adjusting screw according to the position of the nozzle relative to the belt after back to the origin in order to make sure the nozzle contacting with the belt rightly; then tighten the Y axis end-stop screw, leveling finished; 4. if there is any seam or over contact between the nozzle and the belt, adjust the leveling nut slightly. | 1.先把X轴移动到喷嘴与皮带接触位置(喷嘴微压皮带) 2.将两个限位开关顶着X滑动块锁紧。3.点击屏幕中的回原点,使得机器自动回原点,根据回原点后喷嘴与皮带的相对位置调节Y轴限位调节螺丝;使得回原点后喷嘴正好与皮带接触,锁紧Y轴限位安装螺丝,调平完成。4.如果发现喷嘴与皮带有间隙或者接触过多,可微调调平螺母调节。



1



2



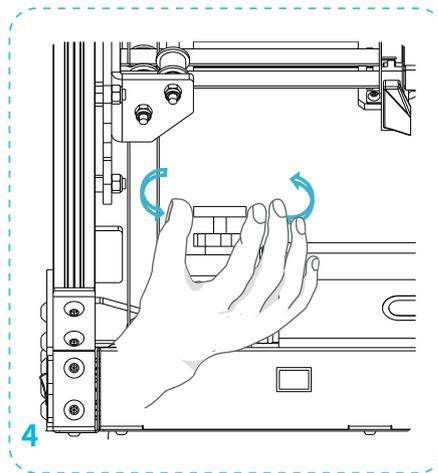
A Y axis end-stop adjusting screw

Y轴限位安装螺丝

B Y axis end-stop adjusting the screw

Y轴限位调节螺丝

3



4

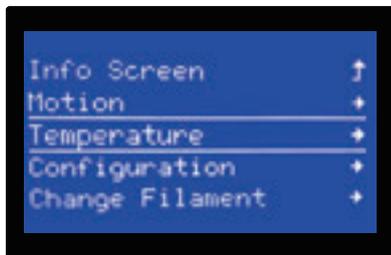
		<p>The nozzle is too far away from the platform, so the consumables can not adhere to the platform. 喷嘴离平台太远,耗材无法粘附在平台上。</p>			<p>The nozzle is too close to the platform, the consumables are not extruded enough, and the nozzle outlet is damaged. Causes a plug and scratches the belt. 喷嘴离平台太近,耗材挤出不足,喷嘴出口损伤,造成堵头,刮伤皮带。</p>
		<p>The even filament adheres right on the platform. 耗材挤出饱满均匀,刚好贴在平台上。</p>			

7

Preheating

预热

Method 1



方法1



Notes: The UI information is only for reference, the actual UI may be different.

注意: 界面仅供参考, 实际以UI为准。

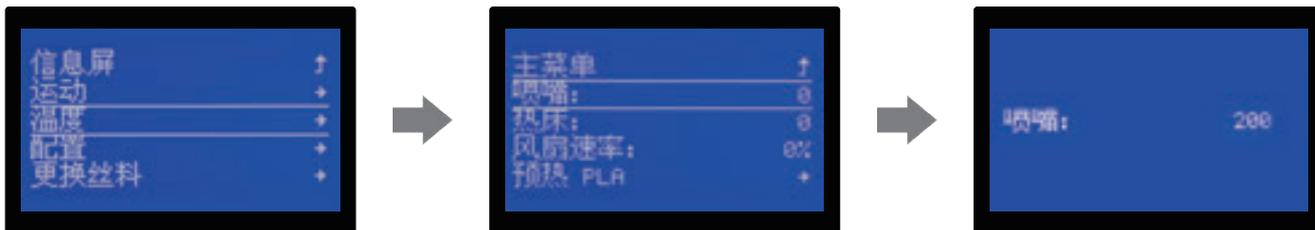
Preheating

预热

Method 2



方法2

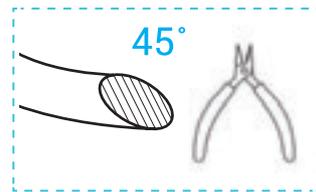
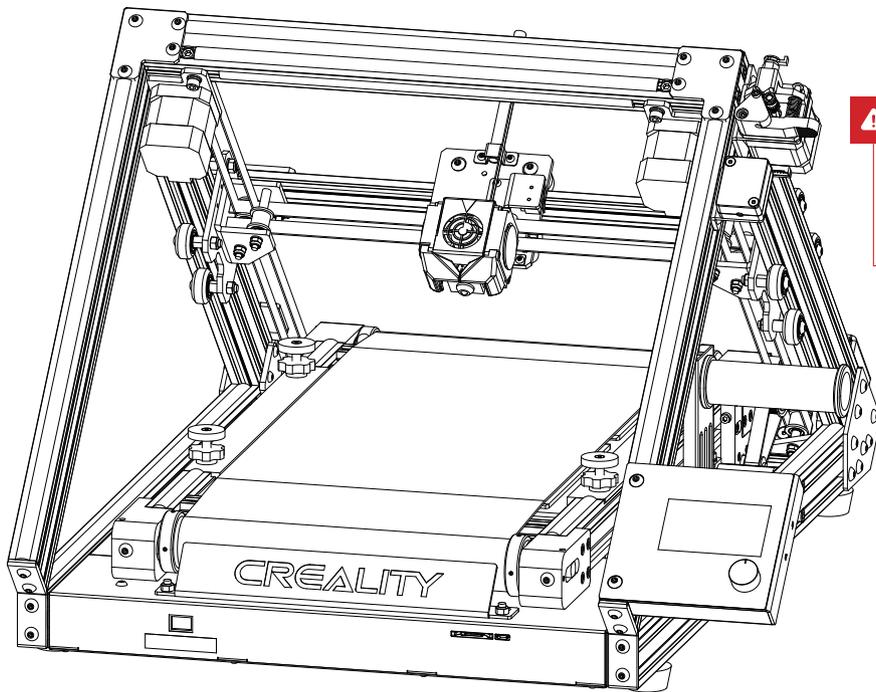


Notes: The UI information is only for reference, the actual UI may be different.
注意: 界面仅供参考, 实际以UI为准。

8

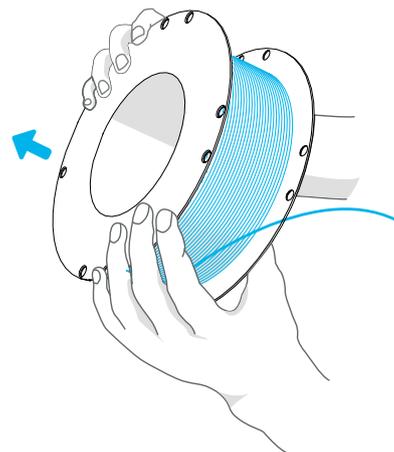
When you wait for the temperature to rise, hang the filament over the filament holder.

当您等待温度上升时,把耗材挂在料架上。



For smoother printing, the end of the filament should be placed as shown above.

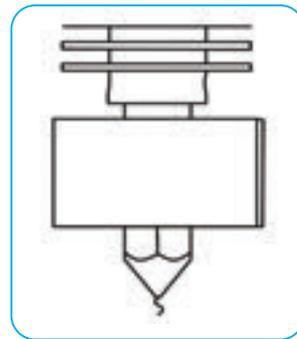
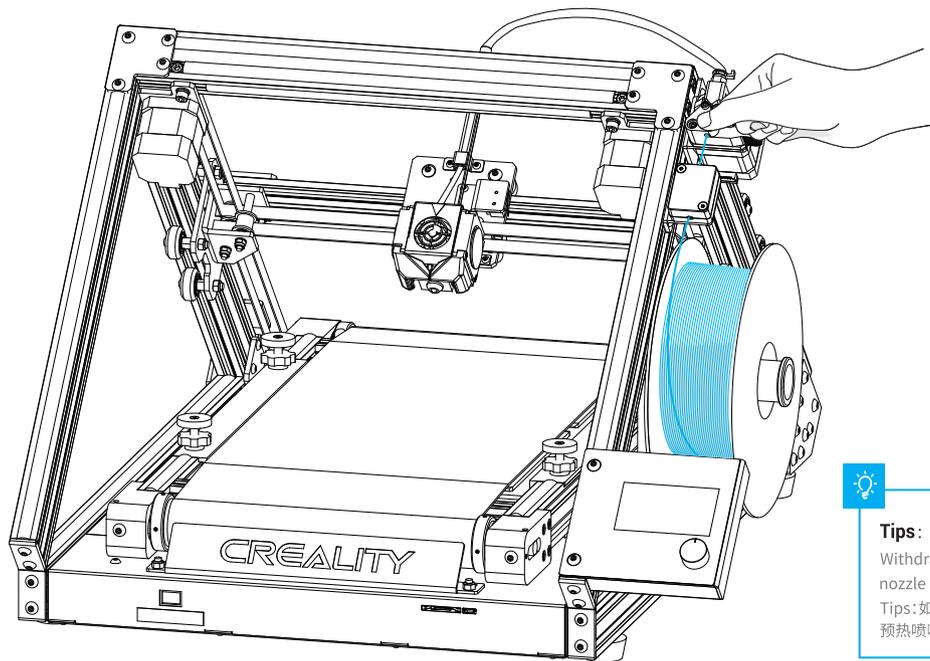
为了顺利完成打印,耗材的末端位置应如图所示。



9

Load Filament 装料

When the current temperature reaches the target temperature, press and hold the spring of the extruder and insert the consumables into the charging detection hole one by one, then insert the consumables into the small hole of the extruder until the nozzle position. | 当前温度达到目标温度时,按住挤出机弹簧,将耗材依次插入装料检测孔,再将耗材插入挤出机小孔直至喷嘴位置。

**Tips:** How to Replace the Filament?

Withdrawing the filament quickly and feeding the new filament after nozzle preheated and filament pushed a little forward.

Tips: 如何更换耗材?

预热喷嘴后,将耗材往前推进一下后,迅速抽出耗材,将新耗材送入。

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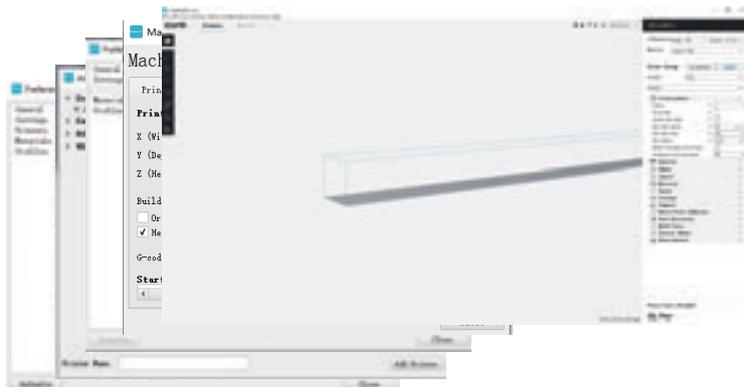
Start Printing

开始打印

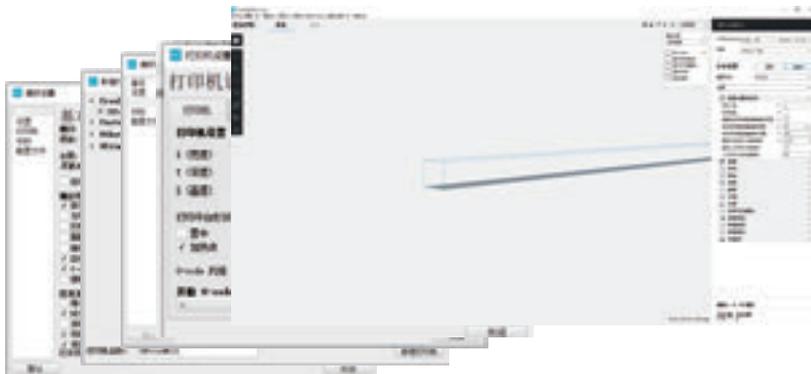


1. Double click to install the software. | 安装软件

2. Double click to open the software. | 打开软件



3. Select language→close→setting→add corresponding model→printer setting→close→customize→configuration→number of prints to complete the setting.

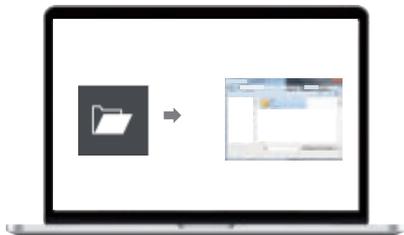


3. 依次选择语言→关闭→设置→新增对应机型→打印机设置→关闭→自定义→配置→打印个数，完成设置。

10

Start Printing

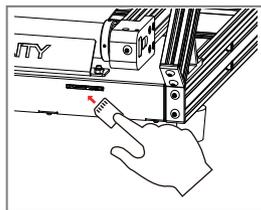
开始打印



4. Open the file in turn → select the file.
依次打开文件→选择文件。



5. Generate G-code, and save the gcode file to storage card.
生成G代码→保存到存储卡。



6. Insert the storage card → print from card → select the file to be printed.
插入存储卡→从存储卡上打印→选择要打印的文件。



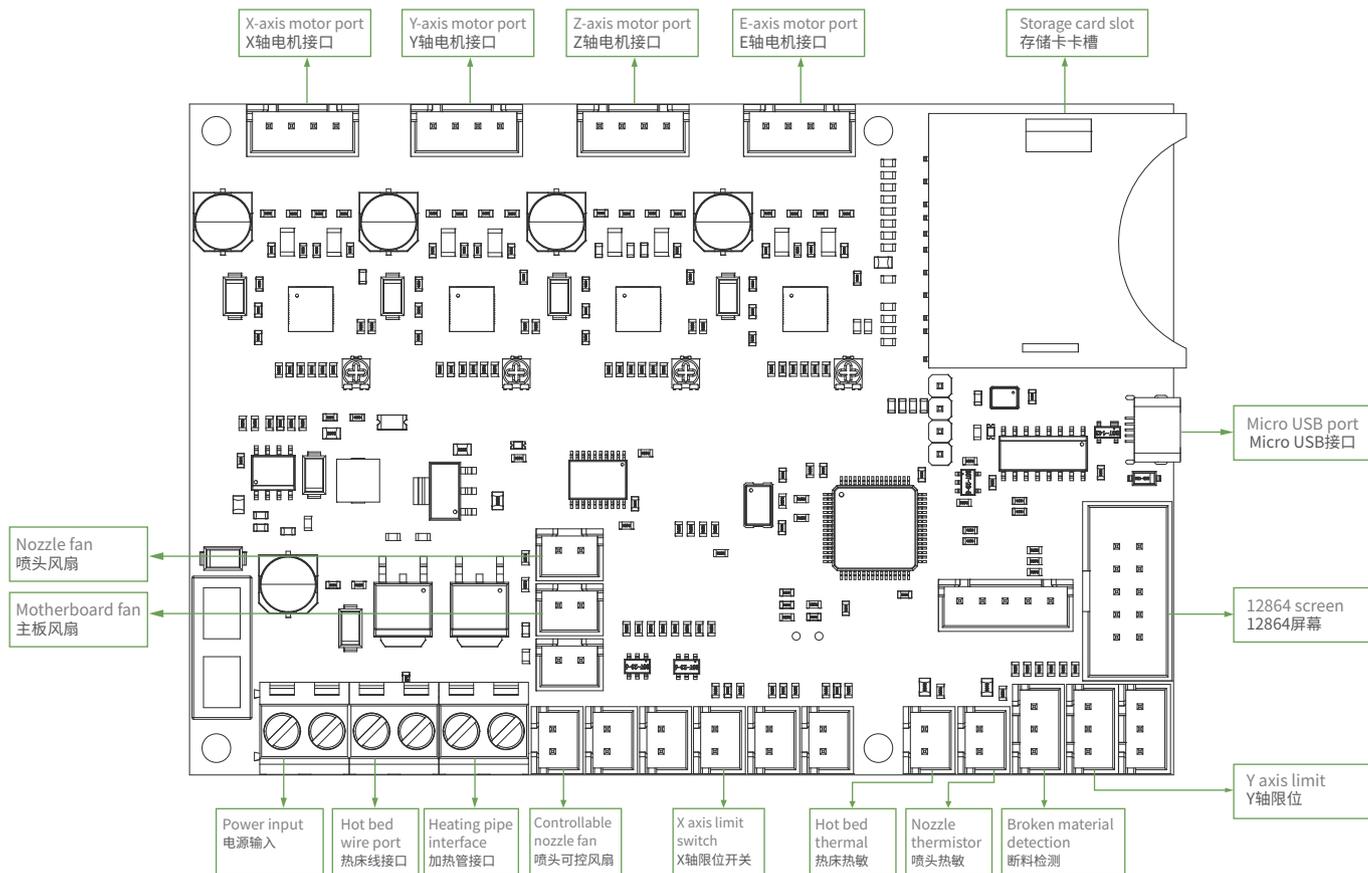
File names must be Latin letters or numbers, not Chinese characters or other special symbols.
文件名需为拉丁字母或数字，不能为汉字或其他特殊符号。



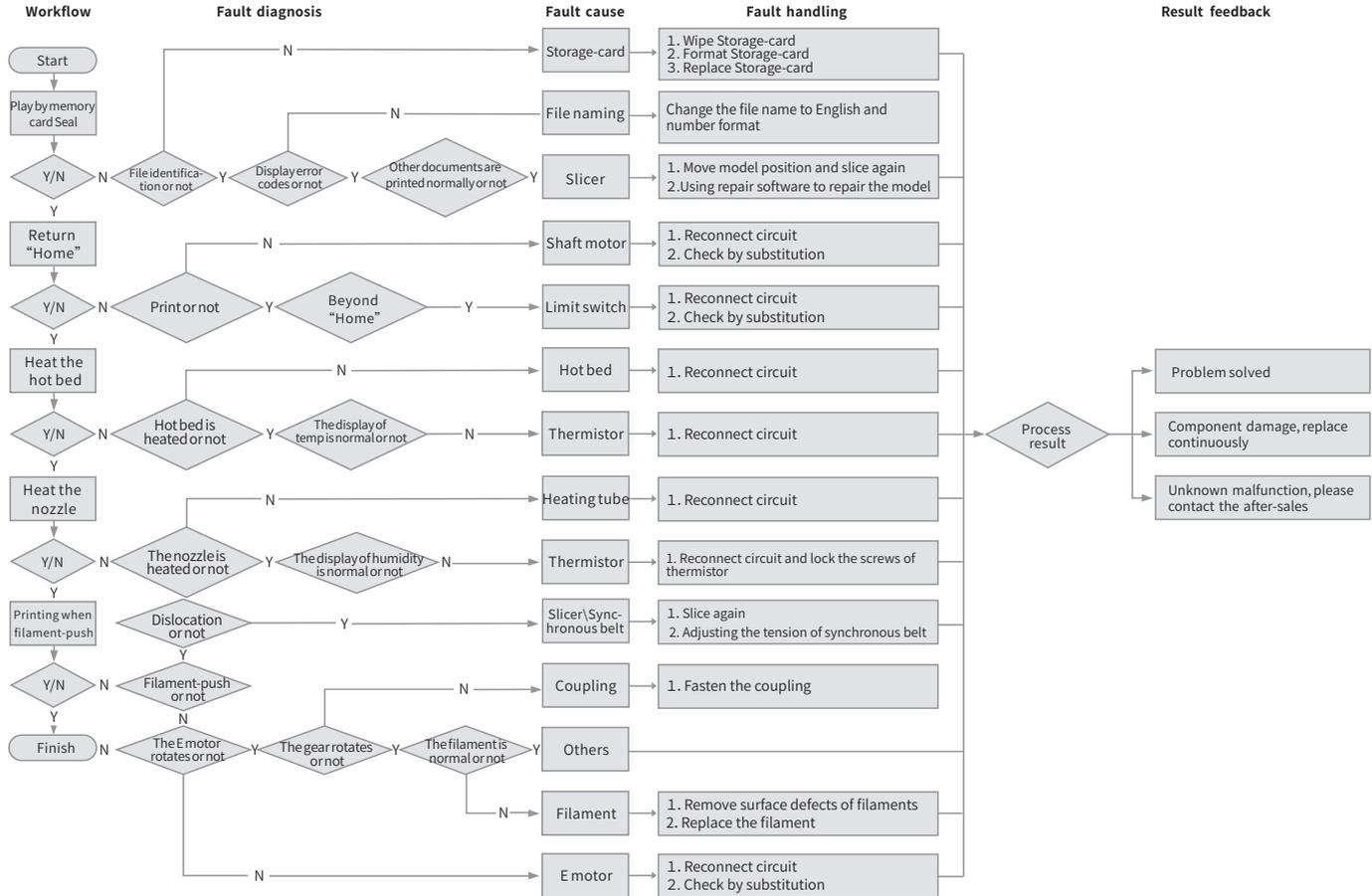
Notes: For details on the software instructions, please refer to the slicing software manual in the storage card!
温馨提示：软件使用说明详情，请见存储卡内切片软件使用手册！

Circuit Wiring

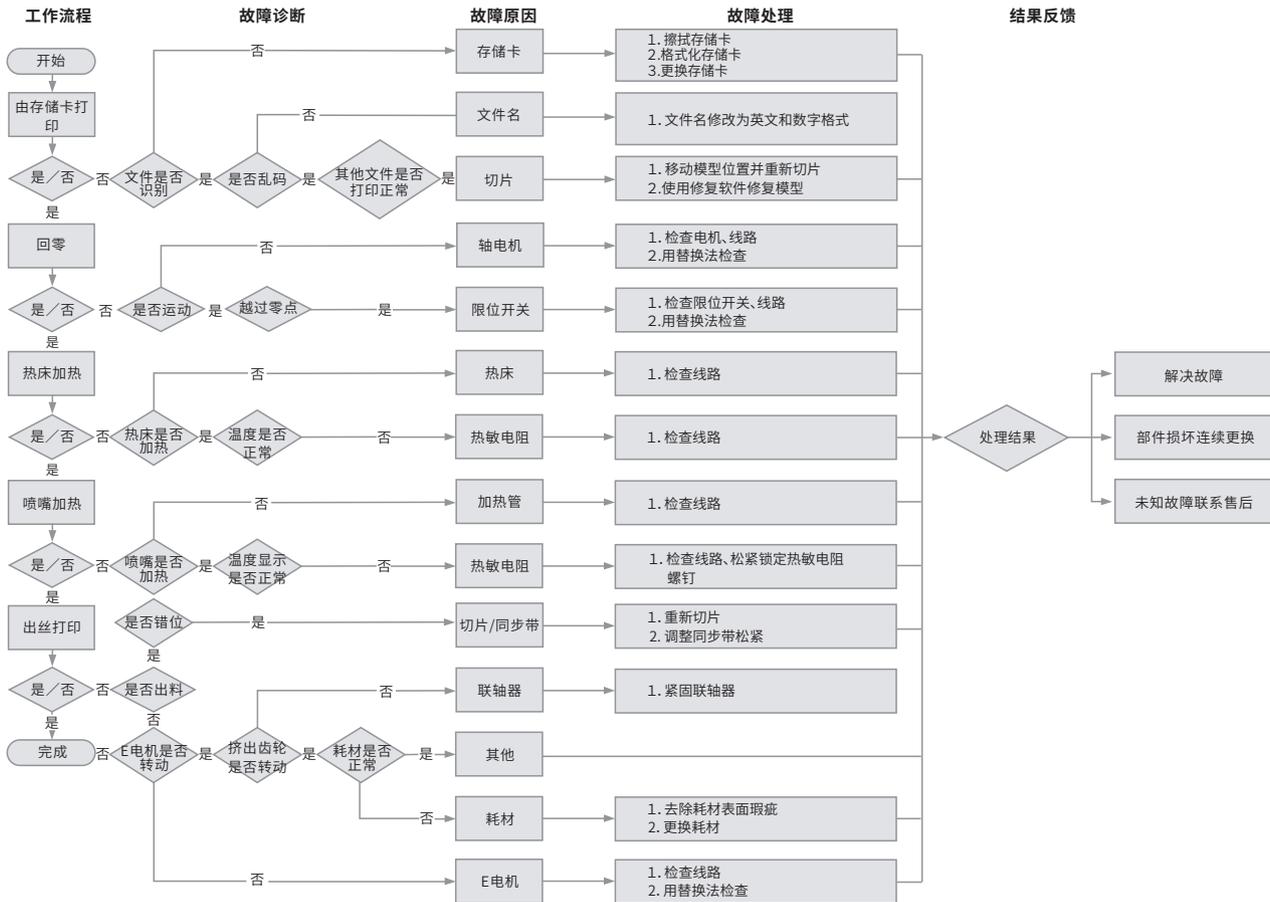
电路接线



Trouble-Shooting



故障检修



Due to the differences between different machine models, the physical objects and the final images can differ. The final explanation rights shall be reserved by Shenzhen Creality 3D Technology Co., Ltd.

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