

TRONXY

USER MANUAL

MOORE 1 MINI CLAY 3D PRINTER

陶泥3D打印机使用说明书





When unpacking, please check the packing list to ensure that no parts are lost or damaged. If any, please contact our after-sales personnel immediately and we will reissue them for you in the shortest time.

开箱时,请对照装箱清单,确保无零件的丢失及损坏,如有发生,请立即联系我们的售后人员,我们会在最短时间内为您补发。



Please use the machine in a ventilated, dry, clean and flat environment.

请在通风、干燥、清洁、平坦的环境中使用机器。



The machine contains high-speed moving parts. Children are not allowed to use the printer alone. It is not recommended to use this 3D printer when unattended.

该机器包含高速运动部件,儿童不得单独使用打印机;无人看管情况下,不建议运行 3D 打印机。



The recommended room temperature for 3D printers is 8°C-40°C, and the humidity is 20% - 80%. If used outside this temperature and humidity range, it may lead to a bad printing effect.

3D 打印机的使用环境温度建议为 8°C-40°C,湿度为 20%-80%,在此范围之外使用,可能带来不良的打印效果。



In an emergency, you can turn off the power directly.

在紧急情况下,可直接关闭电源。



If the user's unauthorized modification or disassembly causes damage to the core components of the machine, the situation is not covered by the warranty.

如果用户擅自改装或者拆卸导致机器的核心部件损坏,则该情况不在保修范围内。



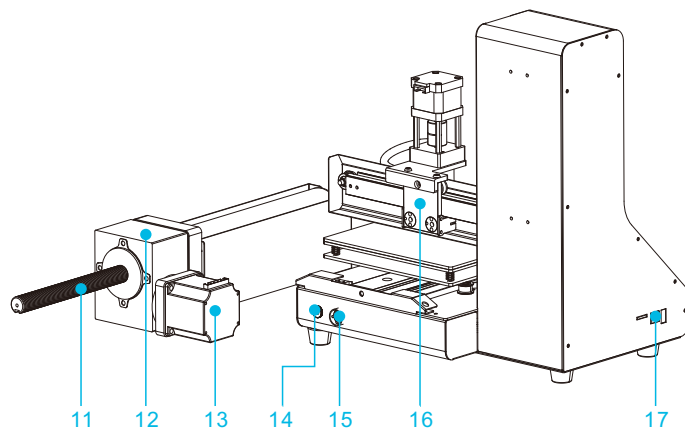
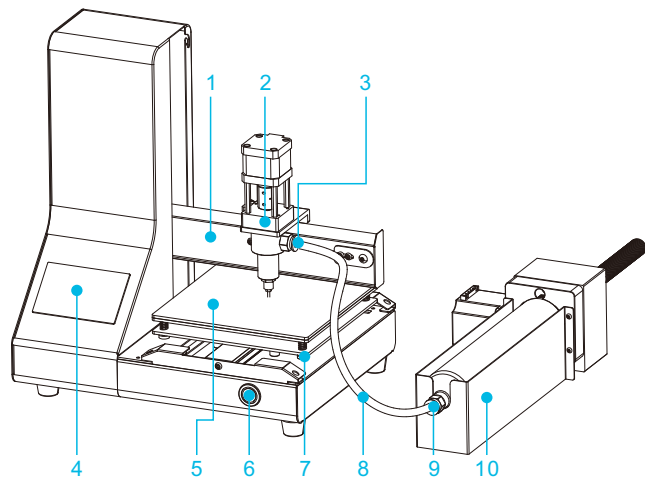
Video, software and other related information are stored in the SD card, please check.

视频,软件等相关信息存储在SD卡中,请查看。

Directory 目录

Introduction	01	设备简介	01
Parameter	02	设备参数	02
Packing list	03	包装清单	03
Install screw feeding device	05	安装螺旋送料装置	05
Install the print head and feed tube	08	安装打印头与送料管	08
Install Firberglass plate	09	安装玻纤板	09
Cable connection	10	接线	10
Platform leveling	11	平台调平	11
Slicing software settings	12	切片软件的设置	12
Precautions and operations for replacing the barrel	18	更换料筒的注意事项与操作	18
Preparation of the clay	20	调配泥料操作教程	20
Matters needing attention after printing	24	打印完成注意事项	24

Introduction 设备简介



1 X axis system

X轴运动系统

2 Print head module

打印头模块

3 PC10-03 pneumatic connector

PC10-03气动接头

4 3.5 inch full color touch screen

3.5寸全彩触摸屏

5 Printing platform

打印平台

6 Power switch

电源开关

7 Leveling nut

调平螺母

8 Tube

料管

9 PC10-02 pneumatic connector

PC10-02气动接头

10 Barrel holder

料筒固定支架

11 M18 feeding screw

M18送料螺杆

12 Transmission

变速器

13 57 feeding motor

57送料电机

14 DC interface

DC接口

15 57 Extrusion motor interface

57挤出电机接口

16 X axis slider

X轴滑块

17 USB-A, USB-B and TF card sockets

USB-A、USB-B和TF卡插口

Parameter 设备参数

Print parameters

打印参数

Printing principle :	LDM (Liquid Deposition Molding)
打印原理	LDM (液体沉积成型)

Print volume :	
打印体积	180×180×180 (mm)

Printing accuracy :	
打印精度	0.3-3.0mm

Positioning accuracy :	
定位精度	X/Y: 0.00625mm, Z:0.00125mm

Number of printhead :	
喷头数量	1

Nozzle diameter :	1.0-3.0 mm (optional)
喷嘴直径	1.0-3.0 mm (可选)

Print speed :	10~40mm/s (30mm/s is recommended)
打印速度	10~40mm/s (建议30mm/s)

Moving speed :	
移动速度	60mm/s

Consumables :	Ceramic mud, porcelain mud, purple sand mud, etc
耗材	陶泥 瓷泥 紫砂泥等

Temperature parameter

温度参数

Ambient temperature :	
环境温度	8°C - 40°C

Software parameters

软件参数

Slicing software :	
切片软件	Cura

Input format :	
输入格式	.STL .OBJ

Output format :	
输出格式	G-Code

Connection method :	TF card, USB disk, USB cable (for skilled users)
连接方式	TF卡、U盘、USB线(适用于熟练使用者)

Power parameters

电源参数

Power input :	
电源输入	100V-240V AC, 50/60Hz

Power output :	
电源输出	24V/4A DC

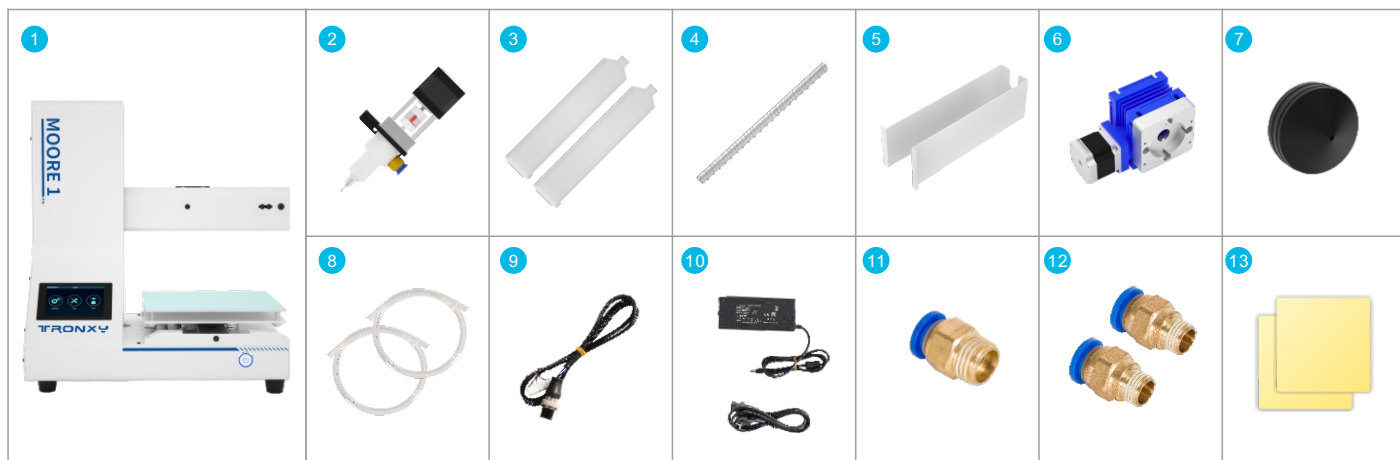
Physical parameters

物理参数

Machine size :	
机器尺寸	355*252*370 (mm)

Machine weight :	
机器重量	≈7.5kg

Packing list 包装清单



1 Moore 1 Main Body * 1 主机*1

2 Screw print head * 1 打印头*1

3 Barrel 0.5L *2 0.5L料筒*2

4 M18 extrusion screw * 1 M18挤出螺杆*1

5 Barrel holder * 1 料筒固定支架*1

6 Feed transmission * 1 送料变速器*1

7 Piston * 1 活塞*1

8 Tube * 2 料管*2

9 57 Motor connection line * 1 57电机连接线*1

10 Power adapter*1+ Power cable * 1 电源适配器*1+电源线*1

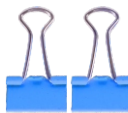
11 PC10-03 pneumatic connector * 1 PC10-03气动接头*1

12 PC10-02 pneumatic connector * 2 PC10-02气动接头*2

13 Firberglass plate * 2 玻纤板*2

Accessories and tools

配件与工具

14	15	16	17	18	19	20
						
21	22	23	24	25	26	
						

14 M4*10 screws *10 M4*10螺丝 *10

15 M4*20 screws *4 M4*20螺丝 *4

16 Clip *2 夹子*2

17 Plastic wrap *1 保鲜膜*1

18 Card reader and TF card *1 读卡器和TF卡

19 USB cable *1 USB连接线*1

20 A box of nozzles *1 一盒喷嘴*1

21 T-shaped allen wrench *1 T型内六角扳手*1

22 Slotted screwdriver *1 一字螺丝刀*1

23 Wrench *1 扳手*1

24 L-shaped allen wrench *4 L型内六角扳手*4

25 Shovel *1 铲刀*1

26 Clay *1 陶泥*1

Install screw feeding device 安装螺旋送料装置



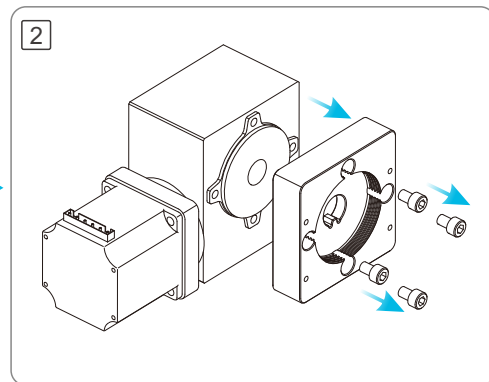
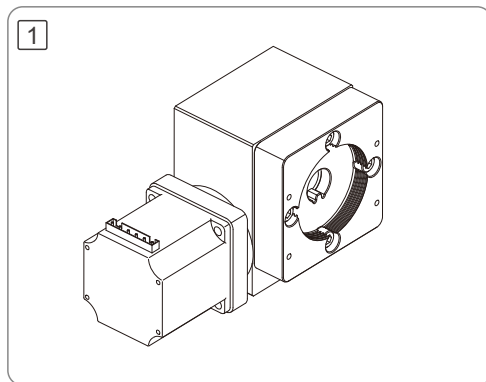
6

Feed transmission *1
送料变速器*1

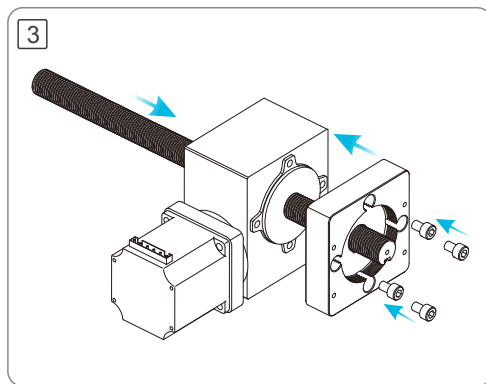


4

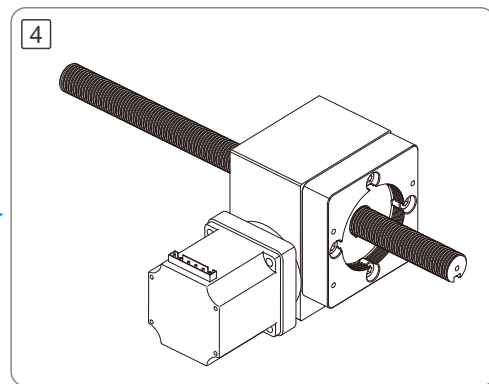
M18 extrusion screw * 1
M18挤出螺杆*1



Remove the barrel fixing block
取下料筒固定块



Insert the M18 extrusion screw and
install the barrel fixing block back
插入螺杆, 将料筒固定块安装回去



Install screw feeding device 安装螺旋送料装置



6
Piston *1
活塞*1



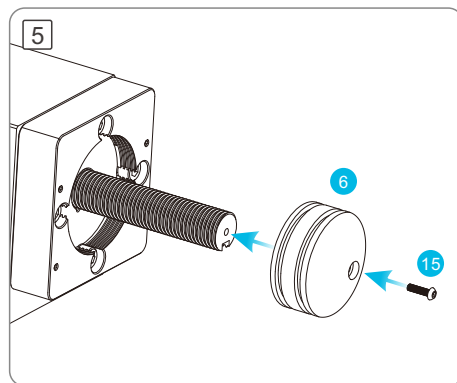
15
M4*20 screws *1
M4*20螺丝*1



3
Barrel 0.5L *1
0.5L料筒*1



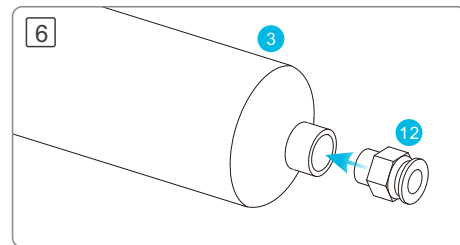
12
PC10-02 pneumatic
connector *1
PC10-02气动接头*1



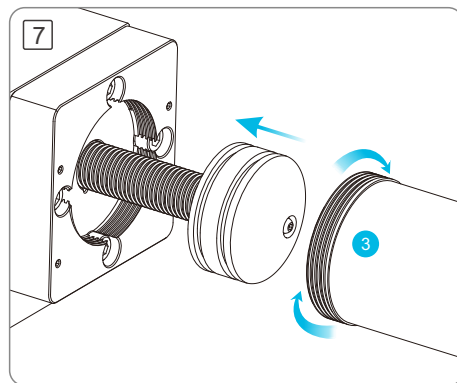
Install the piston on the screw
安装活塞到螺杆上



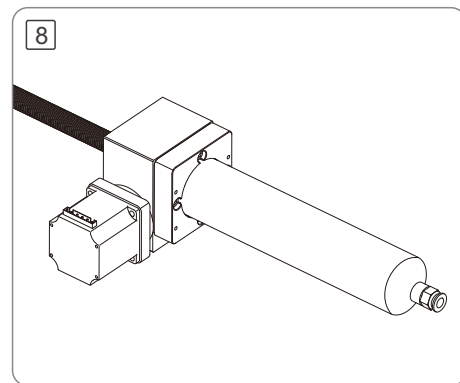
Before installing the barrel, it is necessary to pour the clay into the barrel.
(Please refer to page 20 for installation method)
安装料筒之前需要先把陶泥注入料筒内。
(安装方法请参考第20页)



Install the PC10-02 pneumatic interface to the barrel
安装PC10-02气动接头到料筒上



Twist the barrel in a clockwise direction
将料筒按顺时针方向拧进去



Install screw feeding device 安装螺旋送料装置



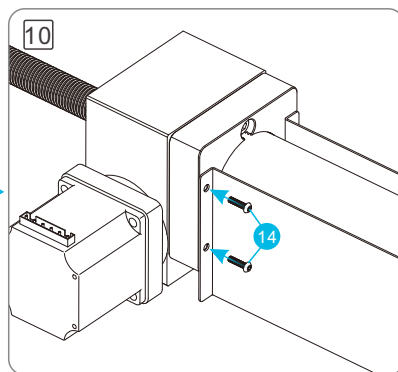
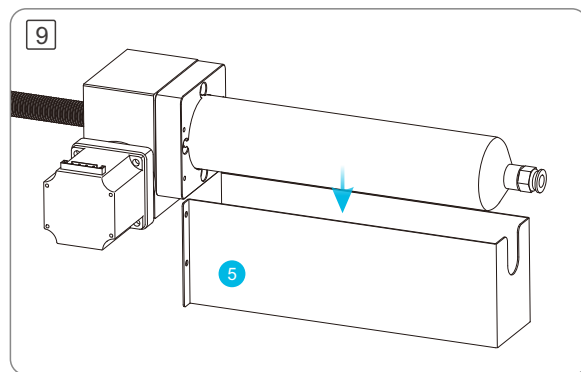
5

Barrel holder *1
料筒固定支架*1

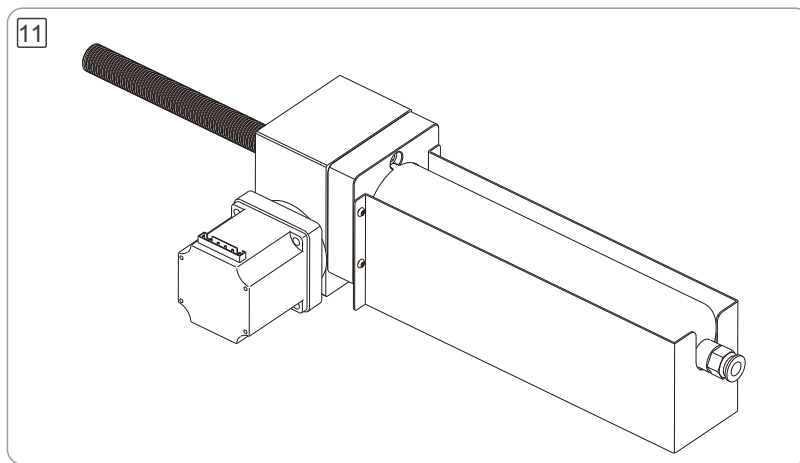


14

M4*10 screws *4
M4*10螺丝*4



Use 4 M4*10 screws to install
the barrel holder
使用4颗M4*10螺丝安装料筒支架



Install the print head and feed tube 安装打印头与送料管



1

Moore 1 Main Body *1

主机*1



2

Screw print head *1

打印头*1



14

M4*10 screws *2

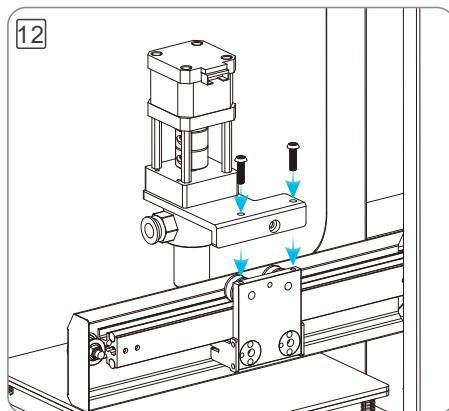
M4*10螺丝*2



8

Tube *1

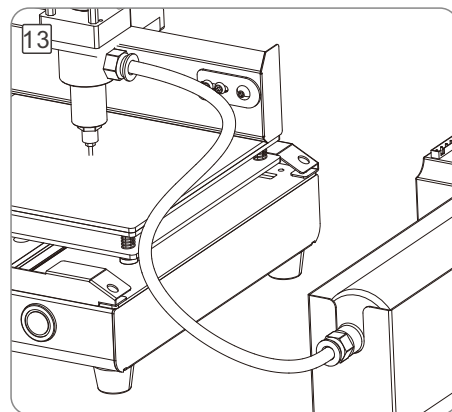
料管*1



12

Use two M4*10 screws to install the print head

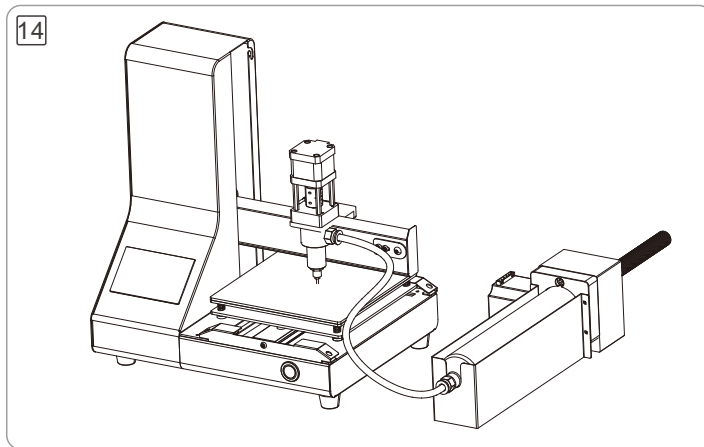
使用两颗M4*10螺丝安装打印头



13

Install the feed tube

安装料管



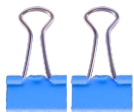
14

Install fiberglass plate 安装玻纤板



13

Firberglass plate *1
玻纤板 *1



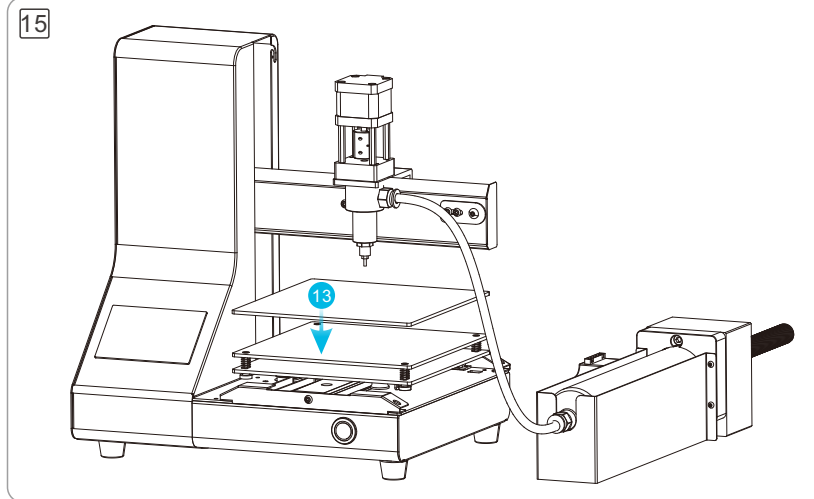
16

Clip *2
夹子 *2



17

Plastic wrap *1
保鲜膜 *1



Place the Firberglass plate on the platform
将玻纤板放在平台上



Use clip to fix the fiberglass board plate on the platform
使用夹子将玻纤板固定在平台上



Before printing, cover the fiberglass board plate with a layer of plastic wrap, It can prevent the bottom of the model from cracking.

在打印之前, 在玻纤板上覆盖一层保鲜膜, 可以防止模型底部干裂。

Cable connection 接线



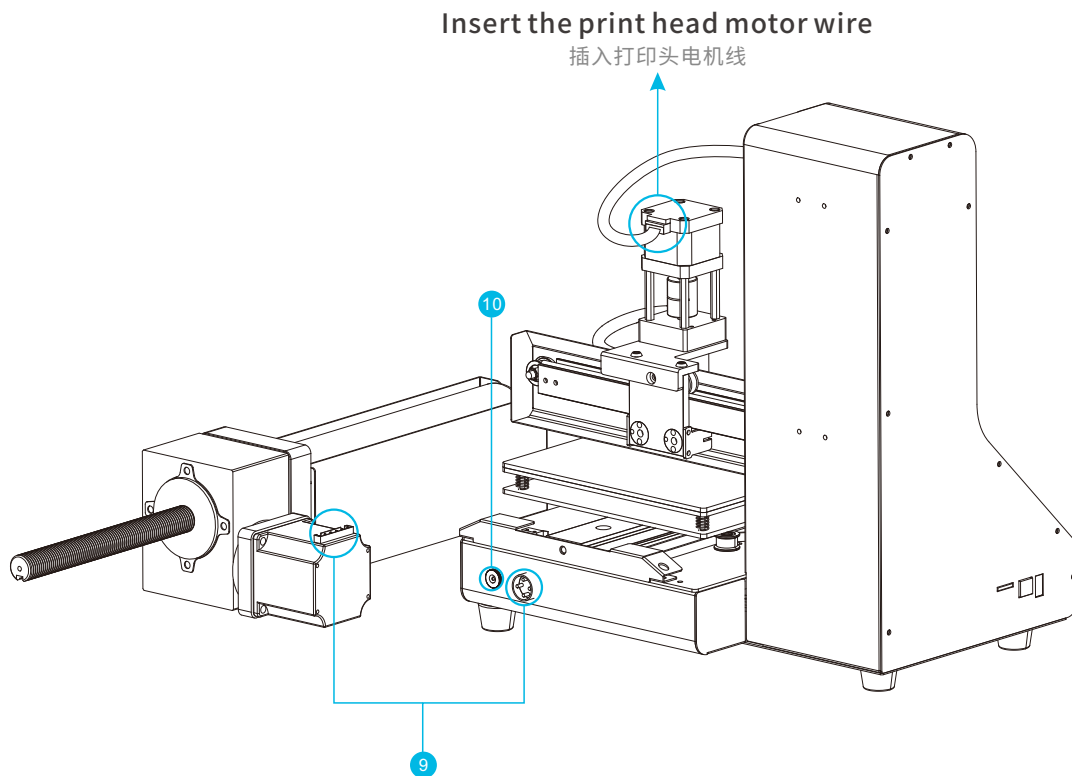
9

57 Motor connection line *1
57电机连接线*1

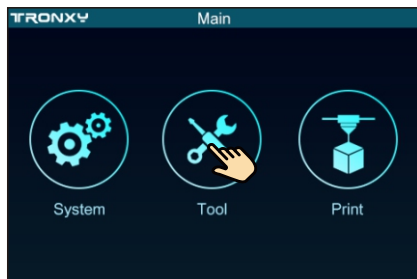


10

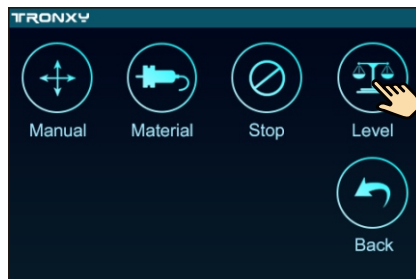
Power adapter*1
Power cable *1
电源适配器和电源线*1



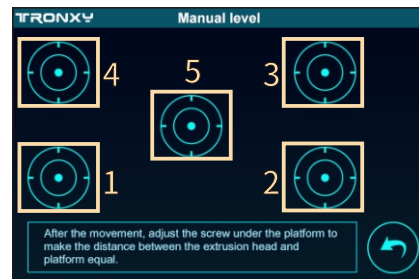
Platform leveling 平台调平



Select "Tool"
选择"工具"

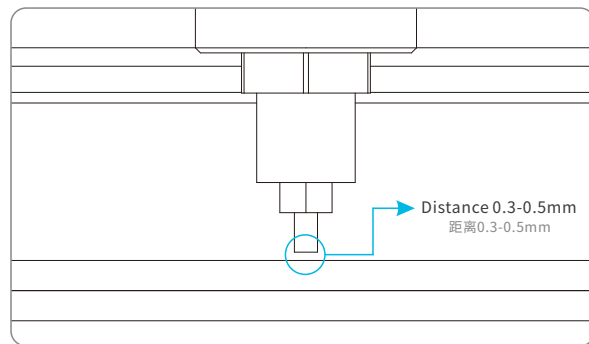
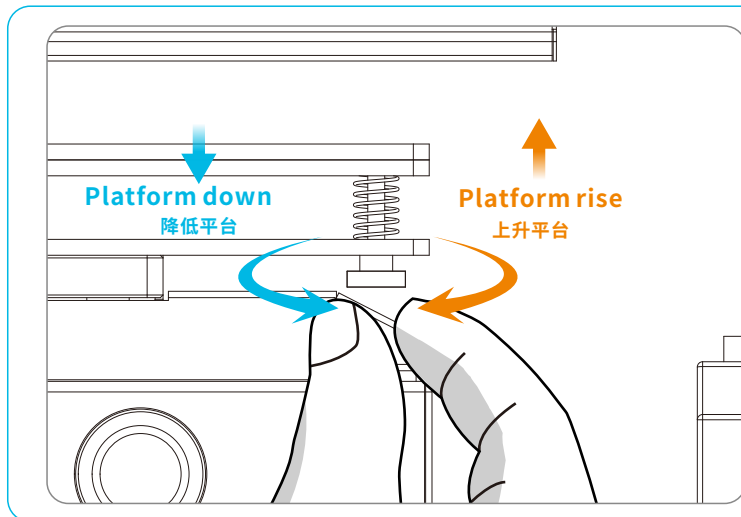


Select "Level"
选择"调平"



According to the sequence given in the figure, level the five positioning points one by one.
(Refer to the picture below for the leveling method)

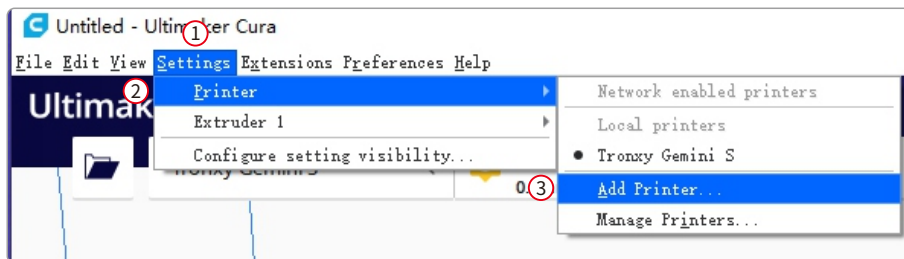
按照图中给出的顺序, 将五个定位点一一调平, 最后点击返回。(调平方法参考下图)



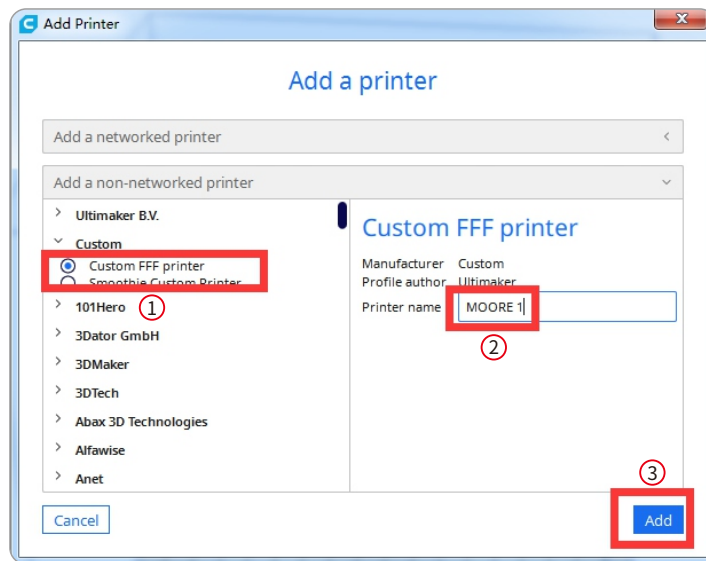
Adjust the four nuts under the platform to make the distance between the nozzle and the platform 0.3-0.5mm.

调节平台下方的四颗螺母, 使喷嘴与平台的距离为0.3-0.5mm

1. Model settings 机型设置

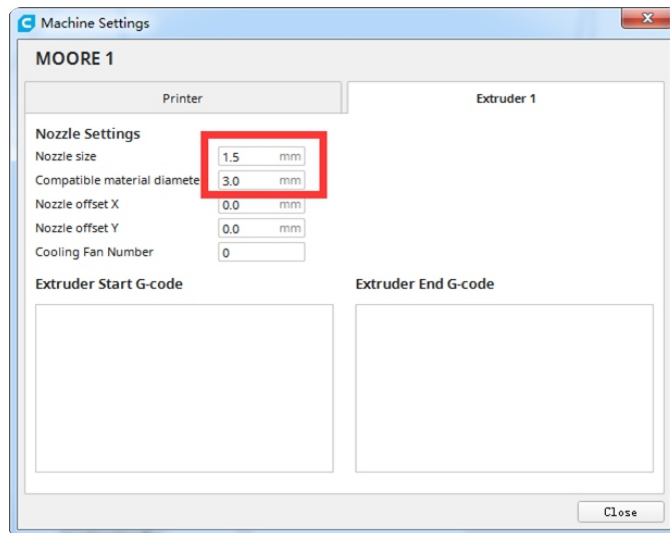
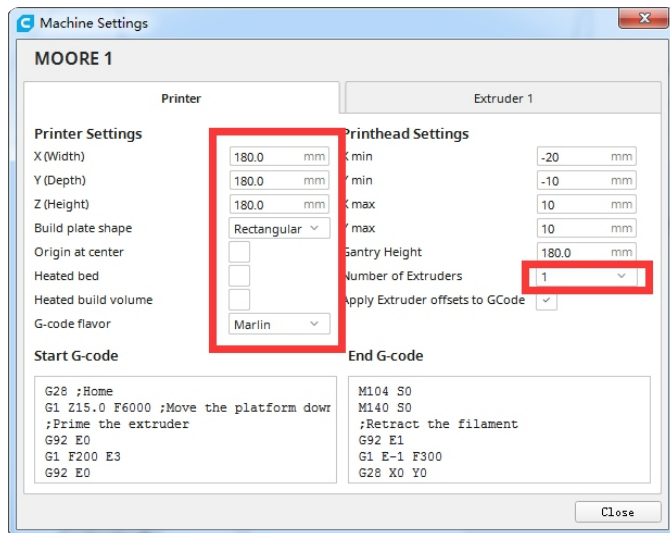


① Settings → ② Printer → ③ Add Printer...



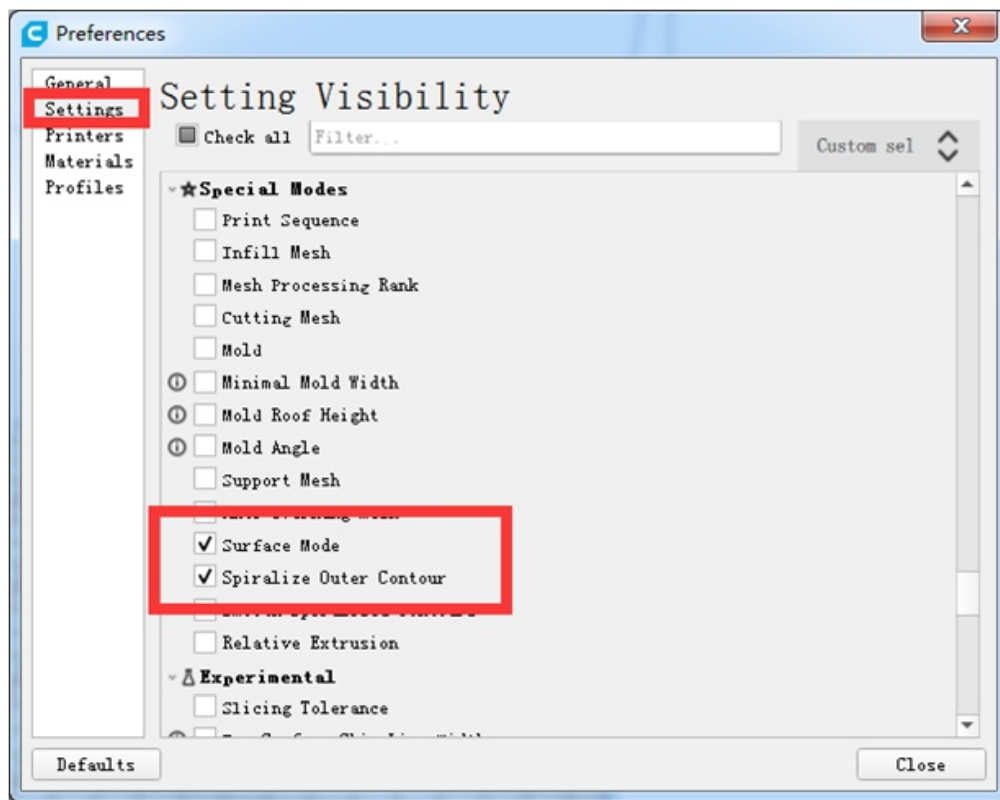
① Custom FFF printer → ② Type "Moore 1" → ③ Add

Slicing software settings 切片软件 的设置



Set the value as shown in the figure

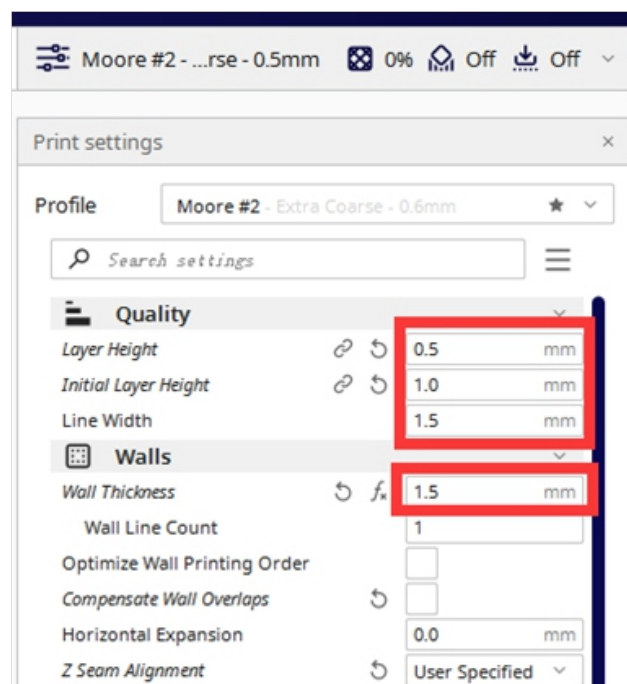
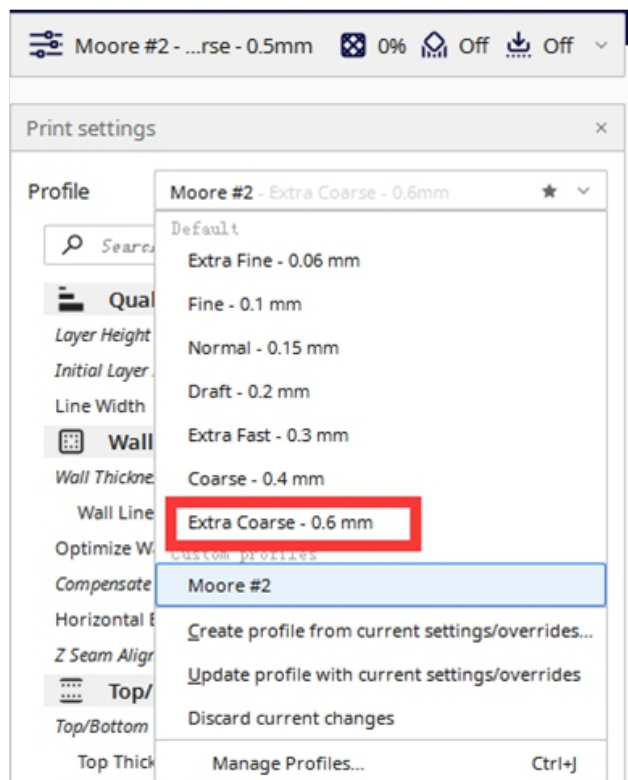
如图所示设置数值



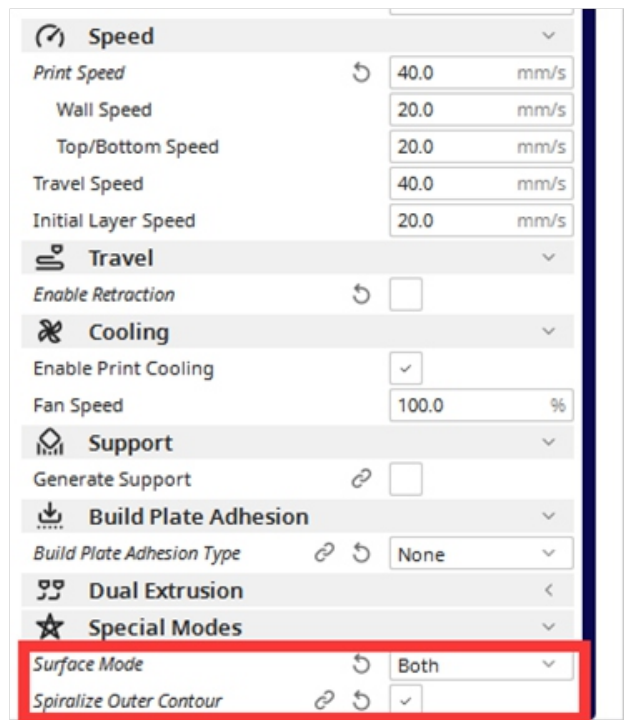
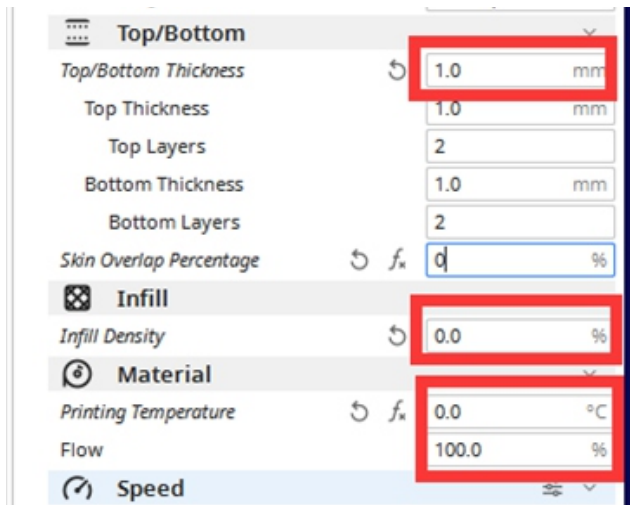
Select the option in the red circle

勾选红圈中的选项

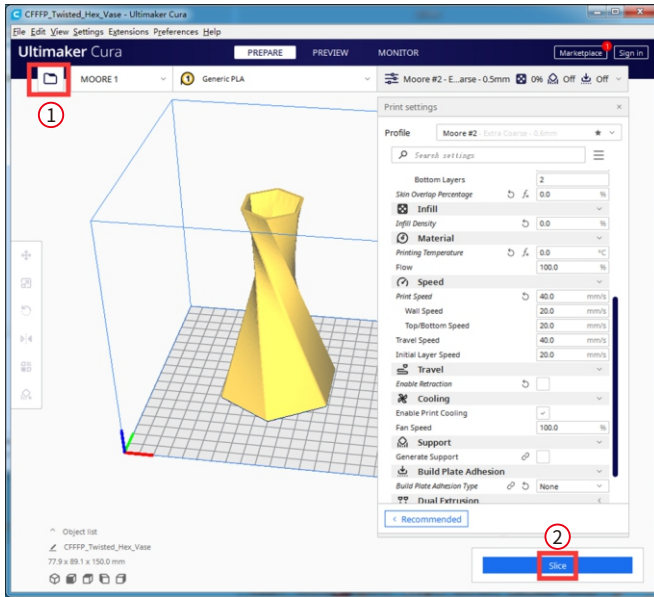
2. parameter settings 参数设置



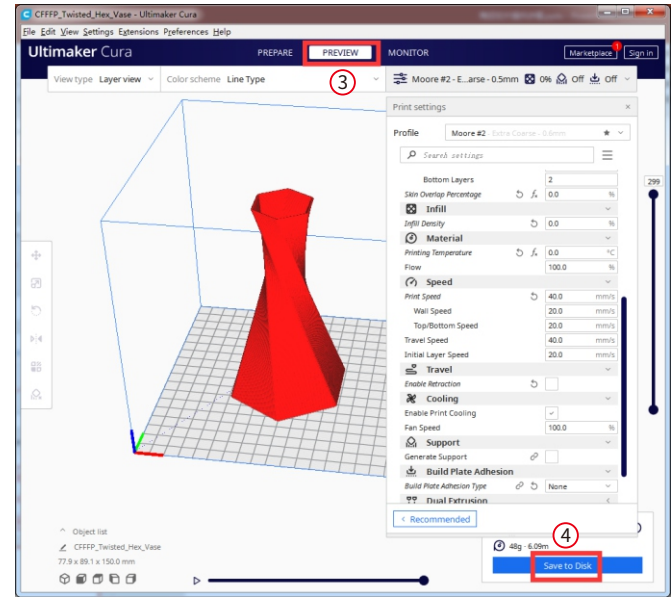
Slicing software settings 切片软件 的设置



Slicing software settings 切片软件 的设置



① Open a file → ② Slice

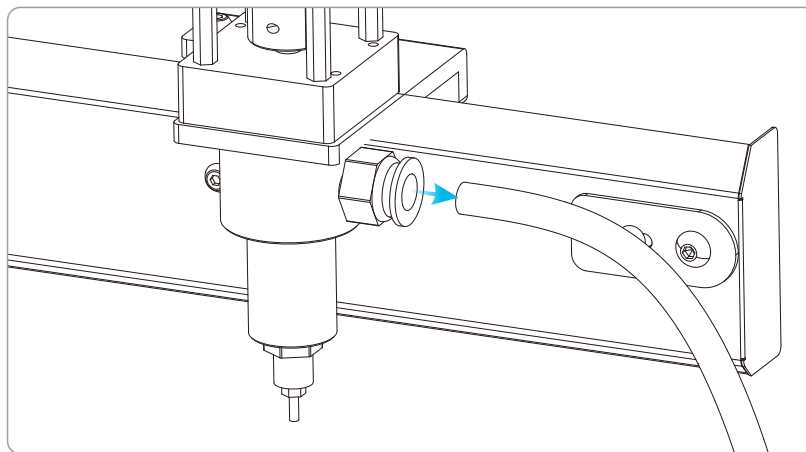
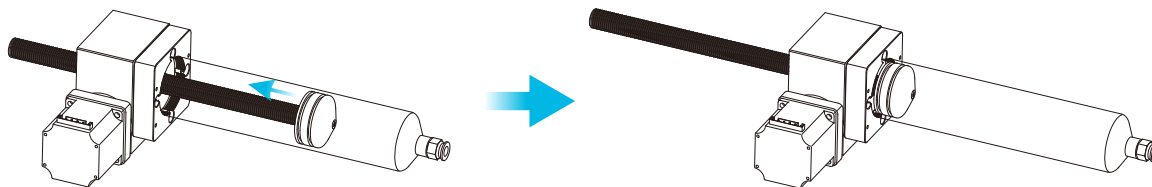


③ Preview → ④ Save to Disk

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作



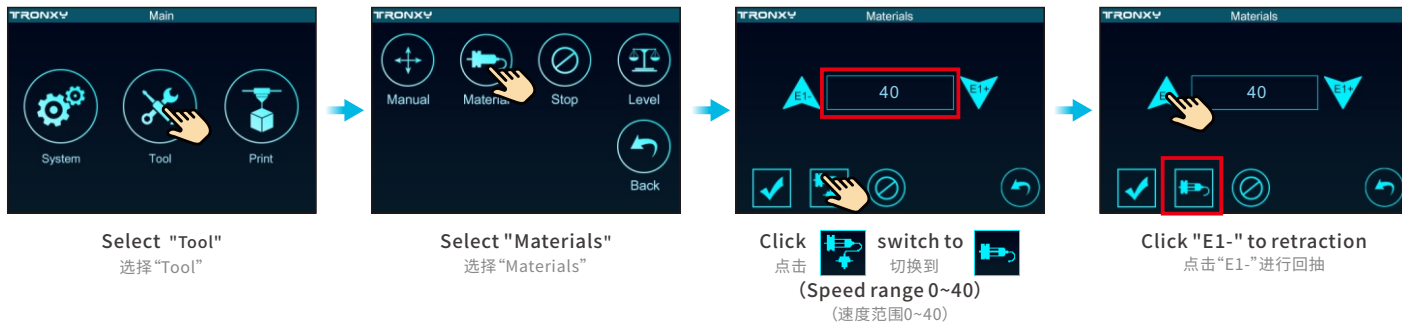
The piston must be moved to its original position before changing the barrel.
更换料筒前，必须将活塞移动到初始位置。



The feed tube of the print head must be unplugged before operation.

操作之前必须拔下打印头的进料管

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作



Three control methods of Materials

耗材的三种控制方式



Linkage mode (default)

Can control the feeding device and the motor of the print head at the same time.

联动模式 (默认)

可以同时控制送料装置与打印头的电机。



Feeding device mode

Separately control the motor of the feeding device.

送料装置模式

单独控制送料装置的电机。



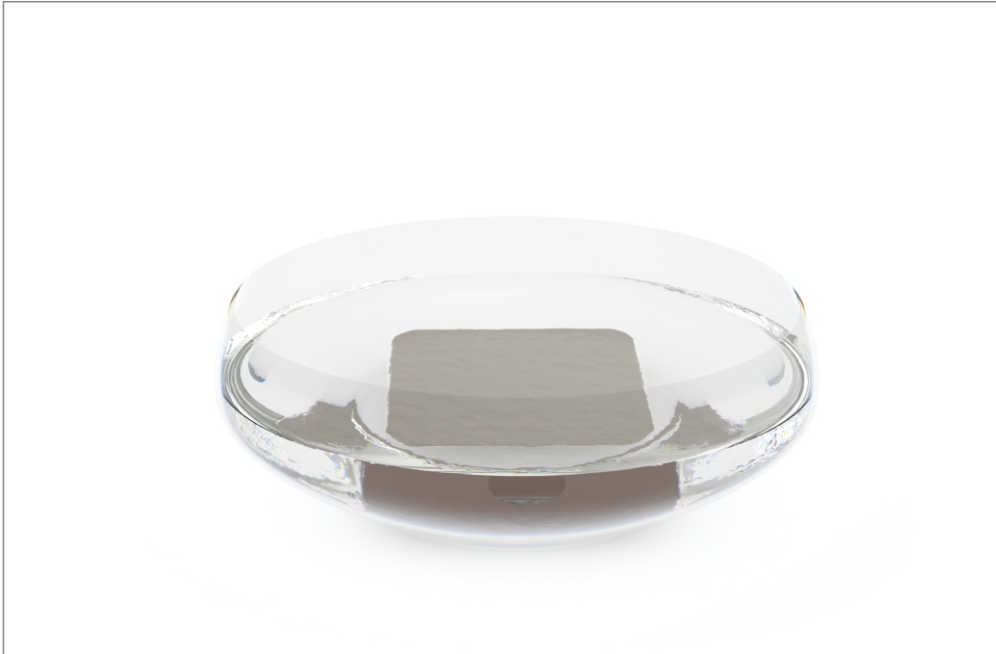
Print head mode

Separately control the motor of the print head.

打印头模式

单独控制打印头的电机。

1. Soak the clay 浸泡



Put the clay into a basin, add some water (which needs to spread over the clay) ,
soak the clay for 2.5 hours.

(The complimentary clay can be used directly without adding water to soak.)

将泥料放入盆中加入少量的水(需要漫过泥料)浸泡两个半小时左右
(附赠的陶泥可以直接使用,不需要加水浸泡。)

2. mix/blend the clay 和泥



Take out the clay and mix it evenly by hand for 3-5 minutes.
Shape the clay to be cylindrical by hand, and make sure its diameter is smaller than the barrel.

取出泥和均匀,大概和3-5分钟即可,最后将泥团揉成比料筒略小的圆柱形

3. Load the clay into the barrel 装泥



Put the clay into the barrel
将泥团放入料筒里

4. Squeeze the air/bubbles out 挤出气泡



Bubbles were found after filling the mud

装泥后发现气泡



Beat the barrel up and down

上下捶打料筒



After squeezing out the bubbles

挤出气泡后

Find a piece of paper with a certain thickness and beat it up and down several times to squeeze out the bubbles in the barrel.

找一张有一定厚度的纸质材料，上下捶打料筒几次，将料筒中的气泡挤出。



Note: soak the printhead/nozzle in the water after printing to prevent the mud from drying and clogging the printhead

注意:打印完将喷嘴浸泡在水中以防泥料干掉



Shenzhen Tronxy Technology Co., Ltd

Address: No.23 Baoya Road, Danzhutou Community, Nanwan Street, Longgang District,
Shenzhen, China, 518114.

Official Website: <https://www.tronxy.com>

Email: support@tronxy.com