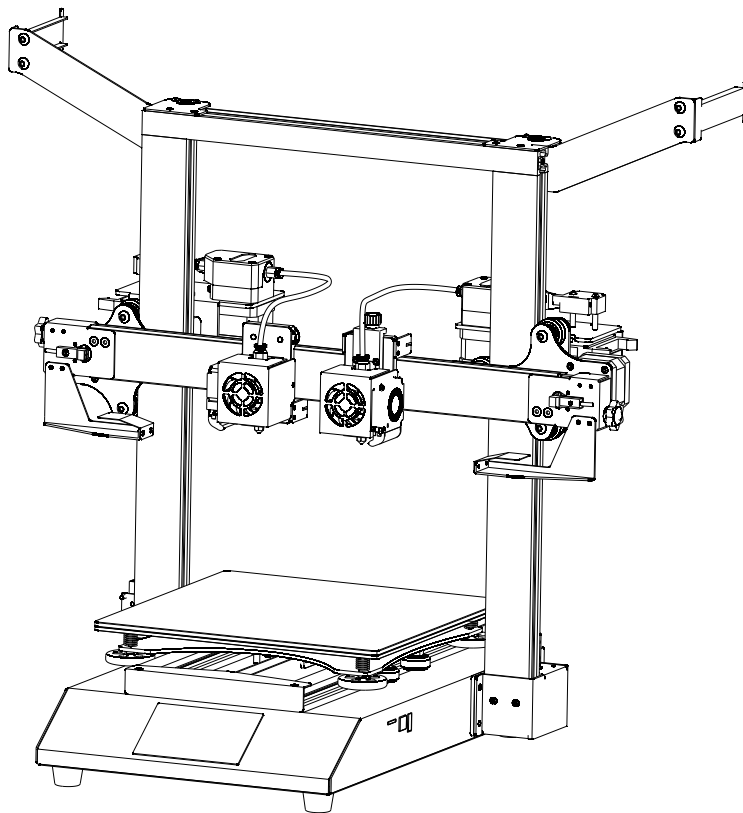


TRONXY

Gemini XS

User Manual

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 and high-temperature parts. Children are not allowed to use the printer alone.

该机器包含高速运动部件和高温部件,儿童不得单独使用打印机。



Part of the accessories are consumable, the warranty time is different.

部分配件为易耗品,保修时间不同。



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 TF card, please check.

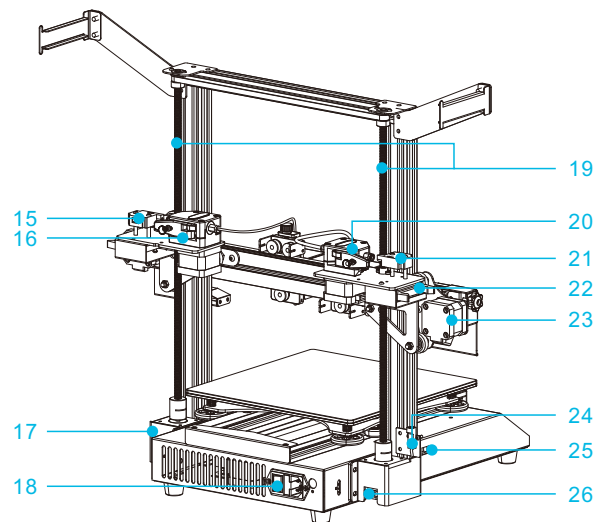
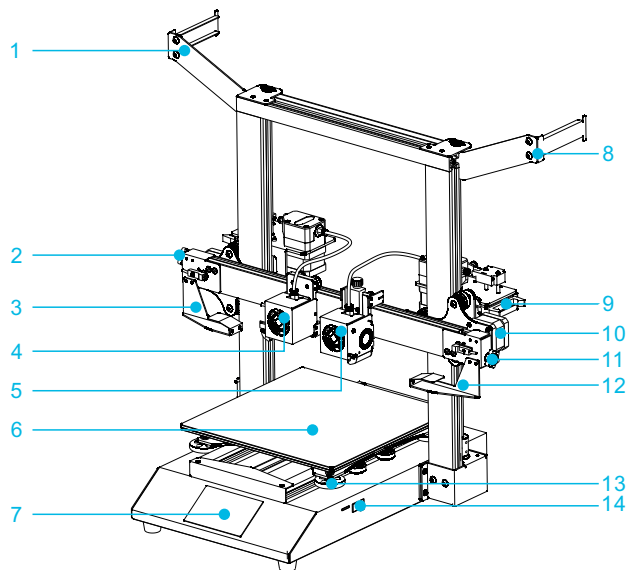
视频,软件等相关信息存储在TF卡中,请查看。

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Introduction 设备简介



1 E1 filament rack
E1料架

2 E2 print head belt adjustment knob
E2打印头皮带调节旋钮

3 E1 nozzle cleaning sheet
E1喷嘴清理片

4 E1 print head
E1打印头

5 E2 print head
E2打印头

6 Printing platform
打印平台

7 Touch screen
触摸屏

8 E2 filament rack
E2料架

9 E2 print head
E2接板接线口

10 E2 X axis motor
E2X轴电机

11 E1 print head belt adjustment knob
E1打印头皮带调节旋钮

12 E2 nozzle cleaning sheet
E2喷嘴清理片

13 Leveling adjustment nut
调平螺母

14 TF card, USB type B, U disk socket
TF卡、USB type B、U盘插口

15 E2 filament run-out detector
E2断料检测器

16 E2 extruder
E2挤出机

17 Right Z axis motor
右Z轴电机

18 Power switch and power cord slot
电源开关和电源线槽

19 Screw rod
丝杆

20 E1 extruder
E1挤出机

21 E1 filament run-out detector
E1断料检测器

22 E1 adapter board wiring port
E1接板接线口

23 E1 X axis motor
E1X轴电机

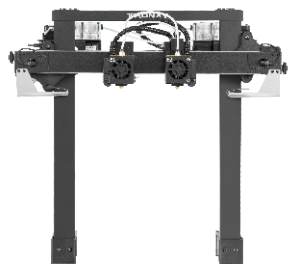
24 Z axis metal limit switch
Z轴金属限位开关

25 Voltage switch
电压转换开关

26 Left Z axis motor
左Z轴电机

Print parameters 打印参数	
Print size 打印尺寸	255*255*260mm (Single head printing 单头打印)
Print accuracy 打印精度	0.1-0.3mm
Print principle 印刷原理	FDM (fused deposition molding 熔融沉积成型)
Nozzle size 喷嘴尺寸	0.4mm
Nozzle quantity 喷嘴数量	2
Print speed 打印速度	20-150mm/s (advise 60mm/s 建议 60mm/s)
Position accuracy 位置精度	X/Y -0.00625mm, Z - 0.00125mm
Filaments support 耗材支持	PLA, ABS, PETG, TPU...
Temp parameters 温度参数	
Printing environment temp 打印环境温度	8-40°C
Nozzle temp 喷嘴温度	275°C (MAX 最大)
Power supply 电源参数	
DC 24V/360W AC 110/220V 50/60Hz	
Software 软件	
Slice software 切片软件	Cura、Simplify3D
Input format 输入格式	.stl, .obj
Output format 输出格式	.gcode
Connection 连接	TF card, USB cable,U disk TF卡、USB接口、U盘
Machine parameters 机器参数	
Machine size 机器尺寸	617*415*560mm
Package size 包装尺寸	622*602*225mm
Machine weight 机器重量	≈11.8kg

Packing list 包装清单



1
Gantry frame
龙门架



2
Base
底座



3
PEI magnetic steel plate 255mm
PEI磁性钢板 255mm



4
Filament holder*2
料架*2



5
Extruder accessories
spring screw*2
挤出机配件 - 弹簧螺丝*2



6
Filament*2
(Random color)
耗材*2 (颜色随机)



7
Power cable
电源线



8
Shovel
(Lattice glass version only,
color random)
铲刀 (仅晶格玻璃版本才有, 颜色随机)



9
Cutting pliers
剪钳



10
Toolkit
工具包

Toolkit list

工具包清单



11
M4*10 screws
M4*10螺丝



12
Allen wrench
内六角扳手



13
Slotted screwdriver
一字螺丝刀



14
L-shaped allen wrench
L型内六角扳手



15
Wrench
扳手



16
Card reader
读卡器



17
TF card
内存卡

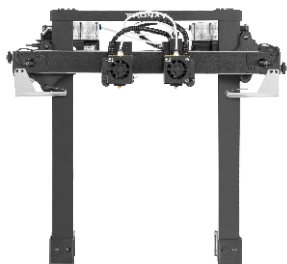


18
USB cable
USB连接线



19
Tie (Random color)
扎带 (颜色随机)

Install the gantry frame 安装龙门架



1

Gantry frame 龙门架



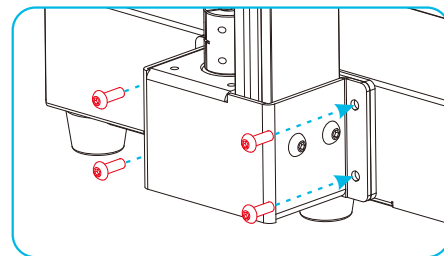
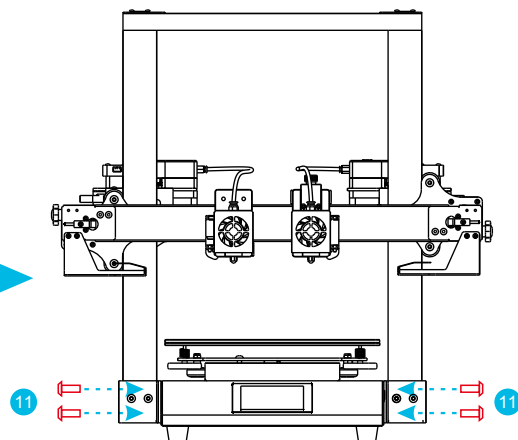
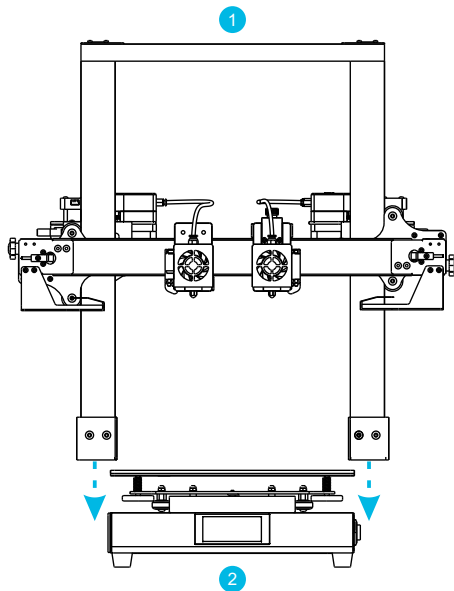
2

Base 底座



11

M4*10 screws *8
M4*10螺丝

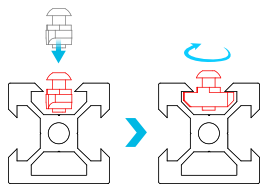


Filament holder installation 安装料架



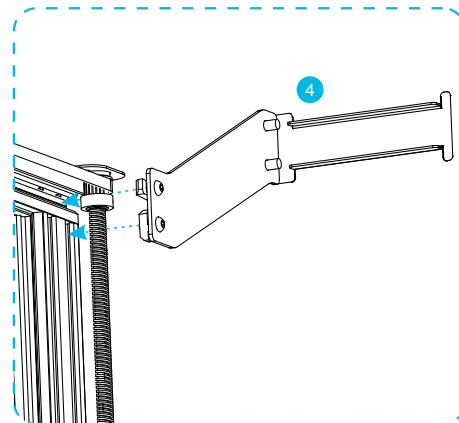
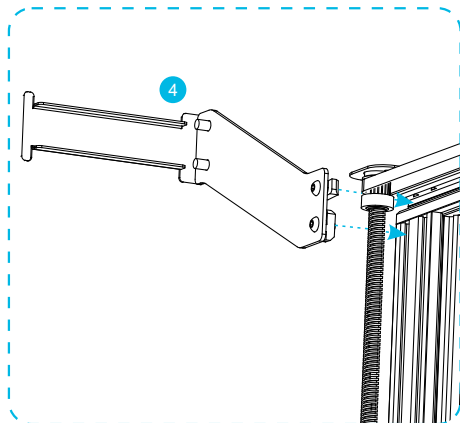
Filament holder*2
料架*2

Working principle of boat nut 船型螺母的工作原理



Loosen the boat nut on the filament holder slightly, pay attention not to remove the nut, then put it into the groove of the aluminum profile in parallel direction, and tighten the screw clockwise quickly, so that the boat nut is stuck in the groove of the aluminum profile at 90°.

略微松开料架上的船型螺母，注意无需取下螺母，然后平行方向放入铝型材的槽内，顺时针快速拧紧螺丝，使得船型螺母90°卡在铝型材的槽内。



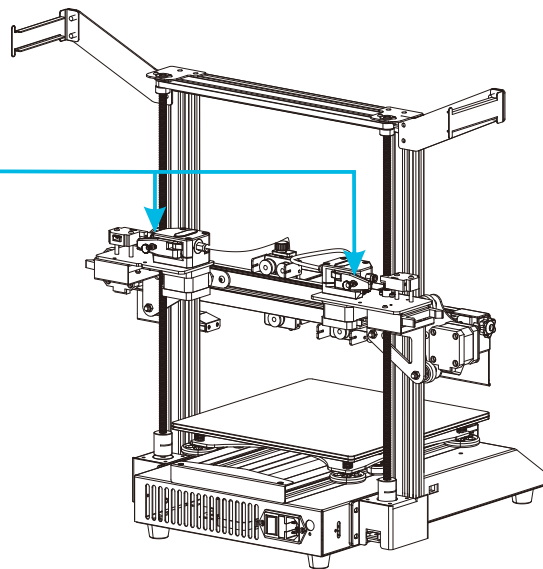
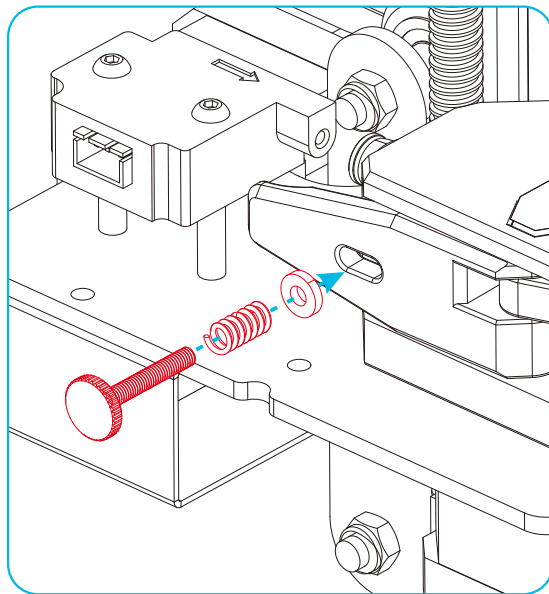
Install the springs and screws of the extruder 安装挤出机的弹簧及螺丝



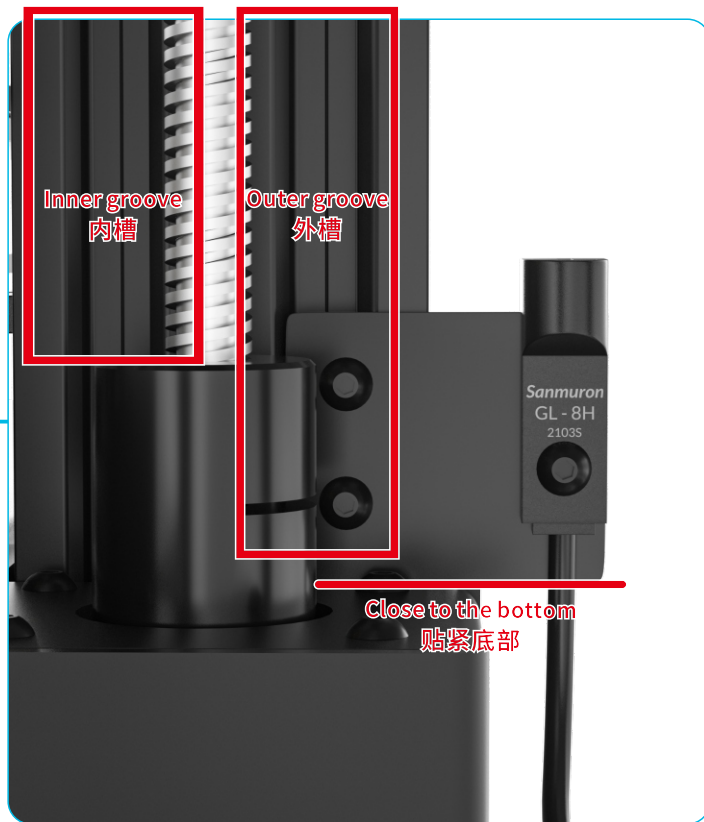
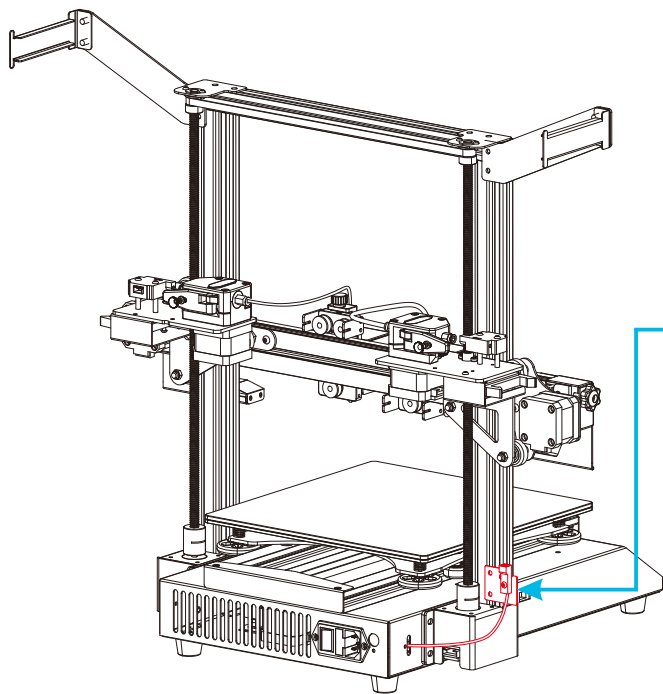
5

Spring and screw
of extruder * 2

挤出机的弹簧及螺丝*2



Install limit switch of Z axis 安装Z轴限位开关



Use the boat nut to install the limit switch to the position in the picture of the gantry. Note that the installation position is in the outer groove of the aluminum profile, and it can be installed close to the bottom position.

使用船型螺母将限位开关安装到龙门架的图中位置，注意安装的位置是在铝型材的外槽，紧贴最下方的位置安装即可。

Install PEI magnetic steel plate sticker 安装PEI磁性钢板贴纸

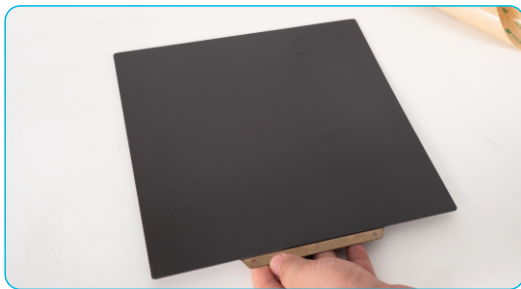


Please tear off the hot bed protective film before use.
使用前请将热床保护膜撕掉。



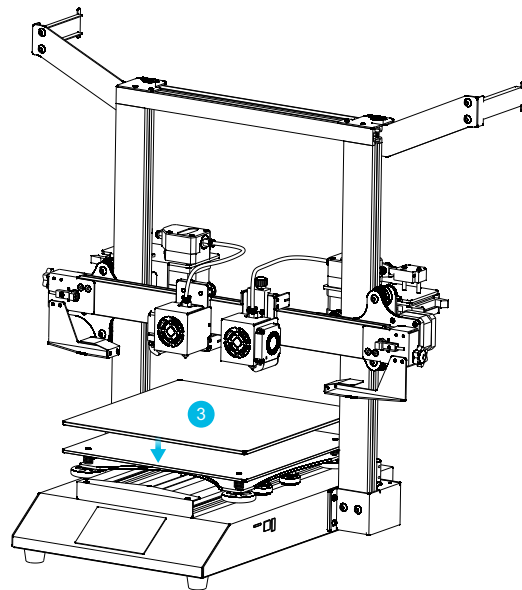
3

PEI magnetic steel plate
255mm
PEI磁性钢板 255mm

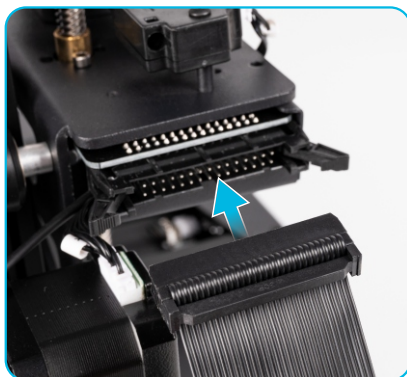


Tear off the PEI sticker to reveal the sticky side, and then stick it on the hot bed.

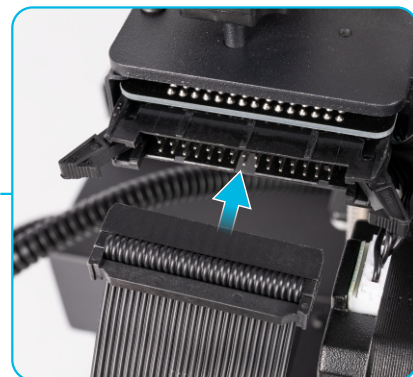
撕掉PEI贴纸，露出带有粘性的一面，然后将其贴在热床上。



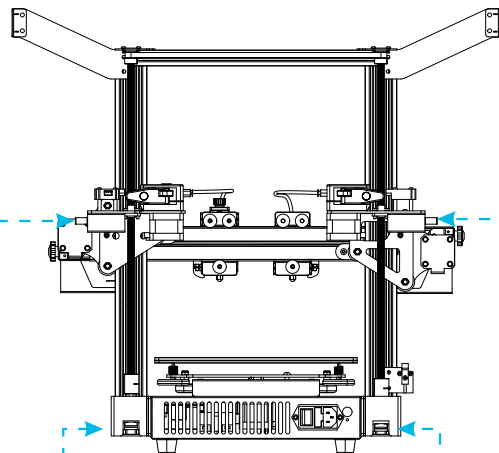
Cable connection 设备接线



Right adapter board wiring port
右转接板接线口



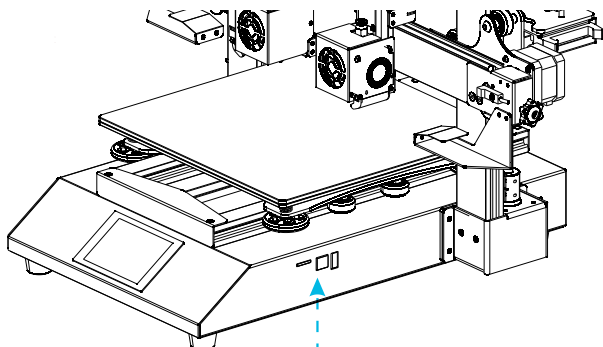
Left adapter board wiring port
左转接板接线口



Right Z axis motor
右Z轴电机

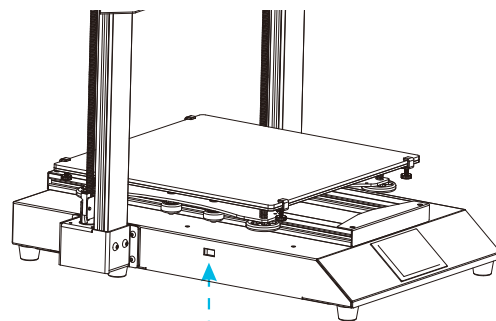


Left Z axis motor
左Z轴电机



The TF card, USB cable and U disk socket are all on the right side of the printer, as shown in the picture.

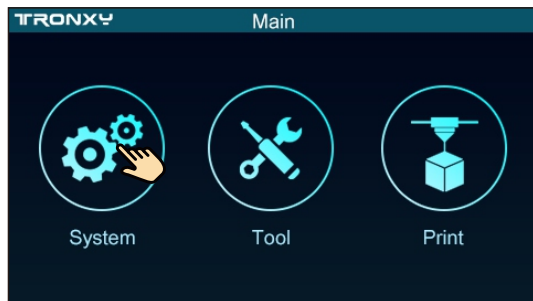
TF卡, USB线和U盘插口, 均在打印机的右侧, 如图中所示。



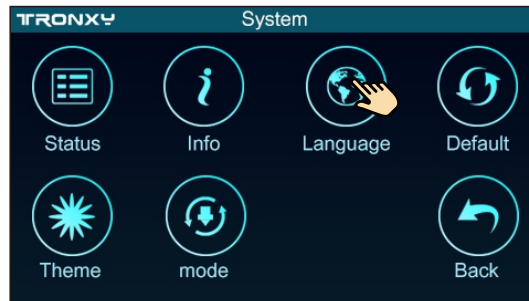
The output voltage of the printer can be adjusted at will according to the customer's needs. Dial the Red Square to the left, and the voltage is 220V. On the contrary, it is 110V. (Before turning on the power supply, customers should pay attention to whether the voltage is consistent with the local voltage.)

打印机的输出电压可根据客户的需求随意调整, 将红色方块拨至左侧, 电压为220V, 相反则为110V, (在接通电源之前, 客户需注意该电压是否与当地电压一致。)

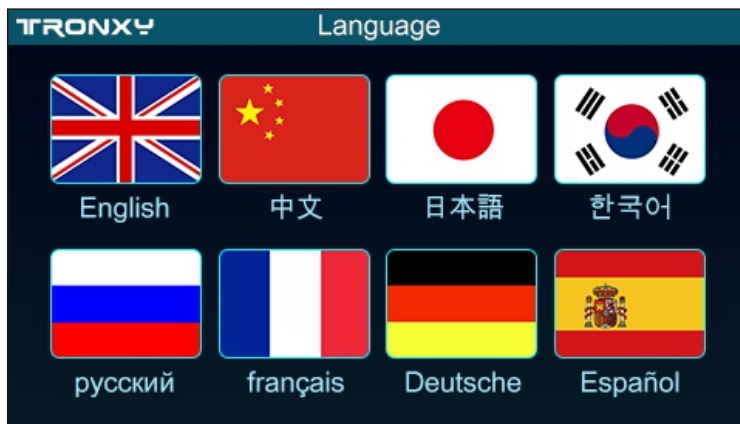
Language switch 语言切换



Select "System"
选择“系统”



Select "Language"
选择“语言”



Choose the language you want
选择你需要的语言

Leveling of the hot bed 热床的调平



Leveling Process:

Adjust the leveling of the E1 print head and the platform first, then adjust the height of the E2 nozzle to be consistent with the E1 nozzle, and finally adjust the E offset of the X and Y axis to be consistent with E1.

The specific operations are as follows:

调平过程：

先调整E1打印头与平台的水平，然后调整E2喷嘴高度与E1喷嘴保持一致，最后调整X,Y轴的E偏移量和E1保持一致。

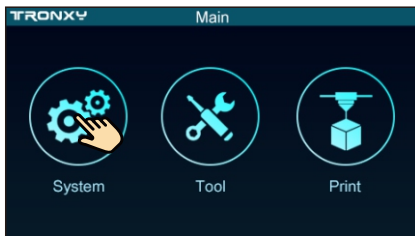
具体操作如下：

1. Use the E1 print head to level the hot bed platform

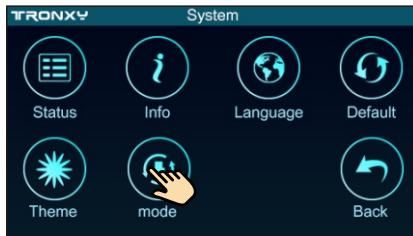
使用E1打印头调平热床

step 1: Change the printer's printing mode to "AutoPark" mode.

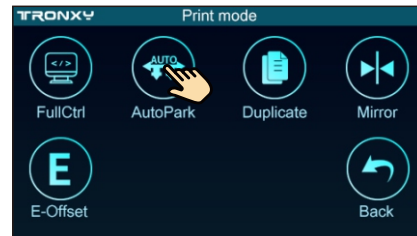
步骤1: 更改打印机的打印模式为“自动停靠”模式。



Select "System"
选择“系统”



Select "Mode"
选择“模式”

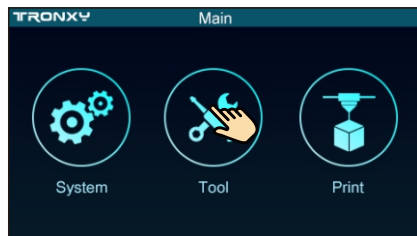


Choose "AutoPark" mode
选择“自动停靠”模式

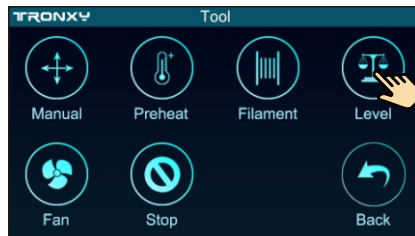
Leveling of the hot bed 热床的调平

step 2: Start manual leveling.

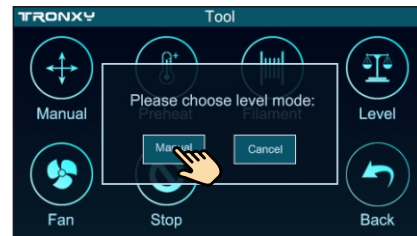
步骤2:进行手动调平操作。



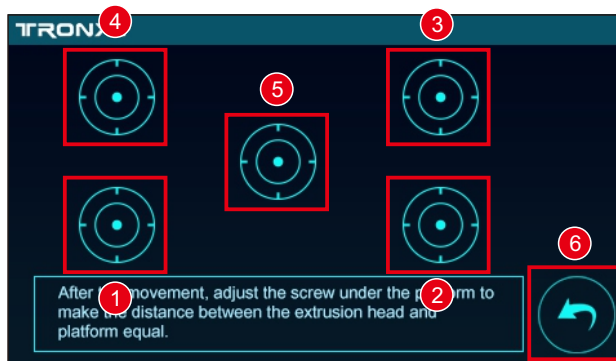
Select "Tool"
选择“工具”



Select "Level"
选择“调平”



Select "Manual"
选择“手动”



According to the sequence given in the figure, level the five positioning points one by one.

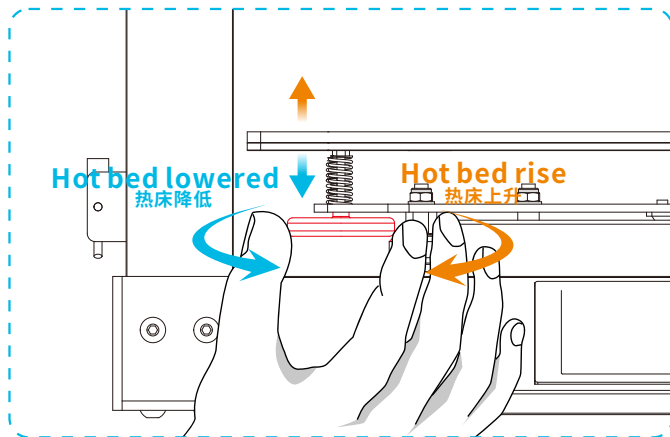
(Please refer to page 15 for the leveling method)

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。(调平方法请参考第15页)

Leveling of the hot bed 热床的调平

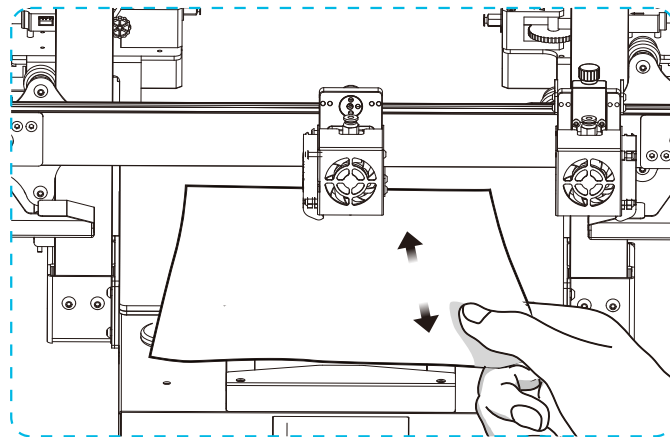
Leveling the hot bed method.

调平热床方法。



As shown in the figure, adjust the distance between the hot bed and the nozzle through the big nut under the hot bed. The central position of the hot bed requires the overall lifting of the platform, so when adjusting the distance between the central point, the other four corners of the hot bed need to do the same operation.

如图中所示，通过热床下的螺母，调整热床与喷嘴的距离。热床中心位置则需要平台的整体升降，所以在调整中心点的距离时，热床的其他四个角需做同样的操作。



Users can use a piece of A4 paper to verify whether the distance is appropriate and feel the slight resistance given by the nozzle when dragging A4 paper.

用户可使用一张A4纸验证距离是否合适，感受到拖拽A4纸时喷嘴给予的轻微阻力即可。



In order to pursue better printing effect, secondary leveling is required.

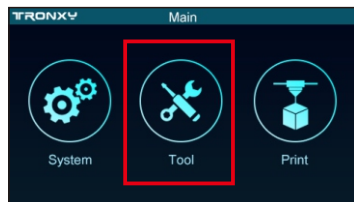
为追求更好的打印效果，需进行二次调平。

Leveling of the hot bed 热床的调平

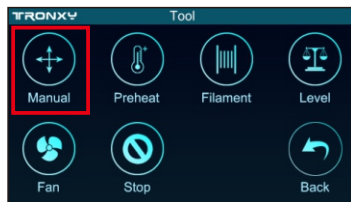
2.Leveling the E2 print head

调平E2打印头

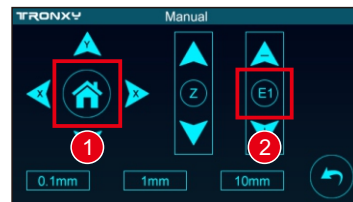
1



Select "Tool"
选择“工具”

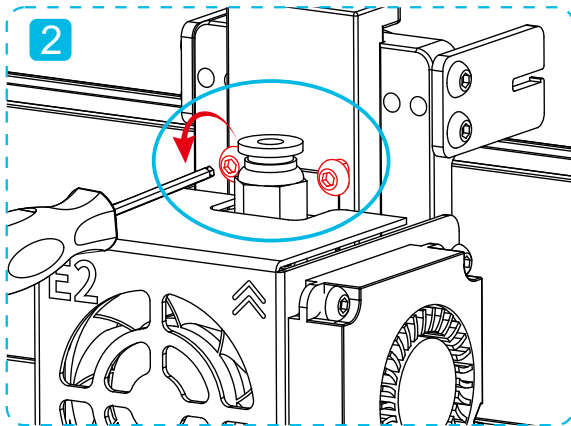


Select "Manual"
选择“手动”



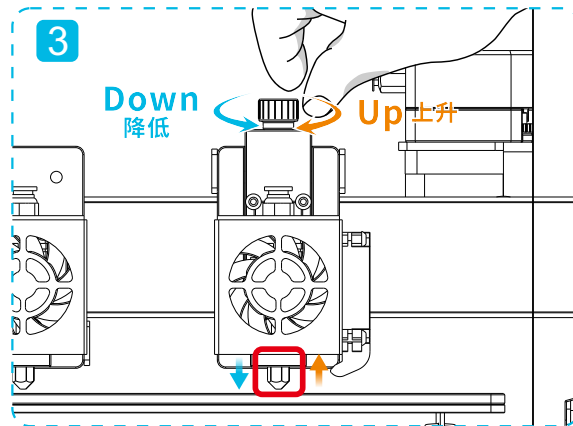
1. Click "Home"; 2. Click "E1" to switch to "E2".
1、点击“Home”；2、点击“E1”切换到“E2”。

2



Loosen the two screws shown in the picture. (Don't take it off)
拧松图中所示的E2打印头上的2颗螺丝(不需取下)。

3



As shown in the figure, rotate the nut on the top of the E2 print head to adjust the E2 nozzle to move up and down. After adjusting the distance between the nozzle and the hot bed to be close to the thickness of the A4 paper, re-tighten the screw in Figure 2.

(Distance adjustment details are the same as on page 15)

如图所示，旋转E2打印头顶部的螺母，可调整E2喷嘴上下移动，调整喷嘴与热床的距离接近于A4纸的厚度之后，重新锁紧图2的螺丝即可。

(距离调整细节与15页内容相同)

Load and unload filaments 耗材的装载和卸载

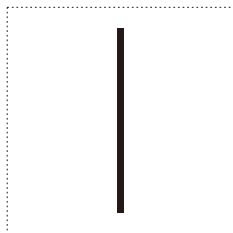
1. Install the filament to the holder

安装耗材到料架上

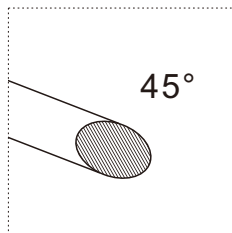


In order to successfully complete the loading, the filament needs to perform some necessary operations, as shown in the figure below.

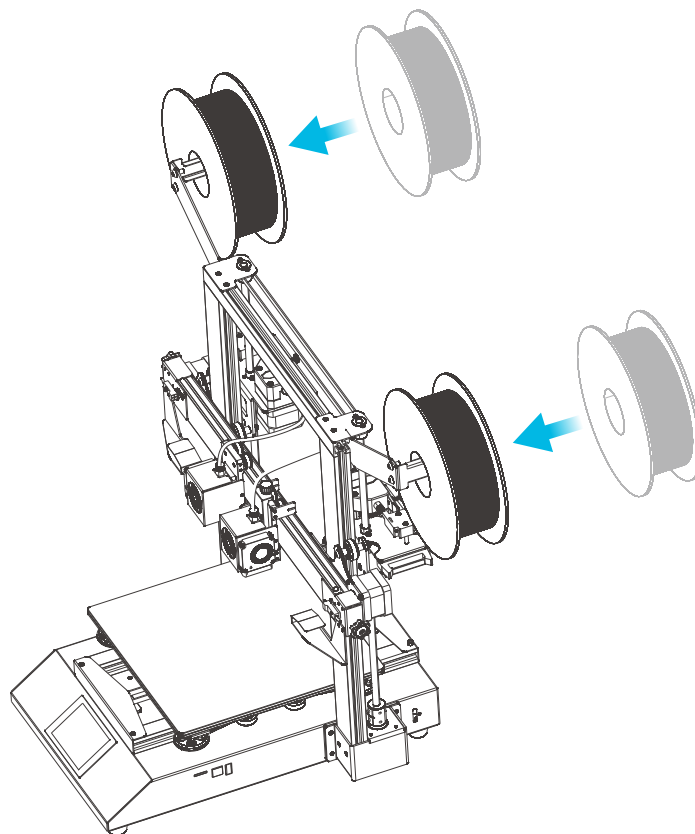
为了顺利完成加载, 灯丝需要进行一些必要的操作, 如下图所示。



Straighten Filament
拉直耗材



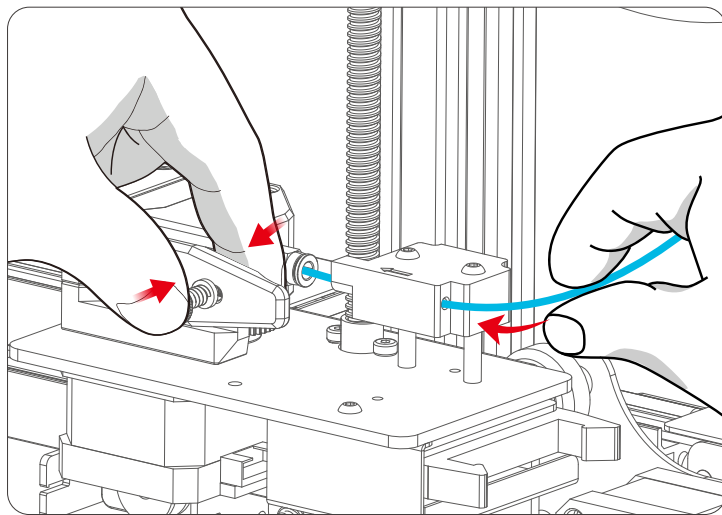
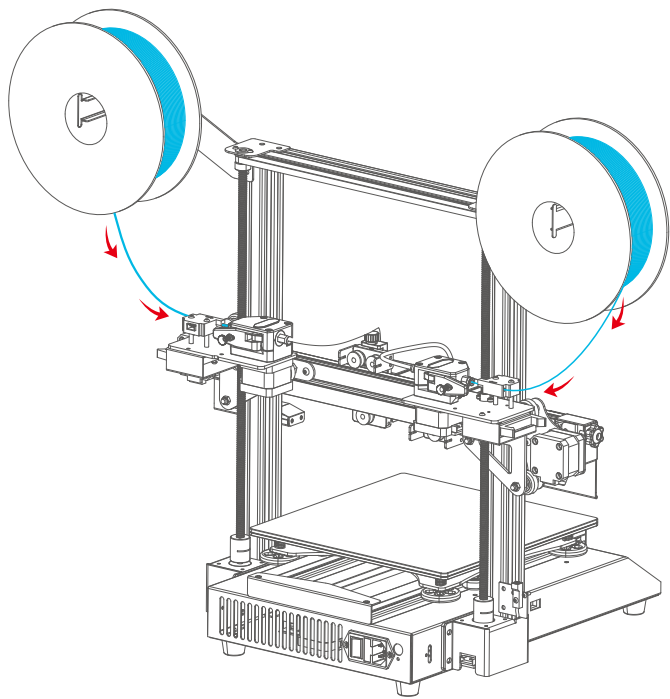
Cut the filament
to a 45° angle
将耗材剪成45°角



Load and unload filaments 耗材的装载和卸除

2.Insert the filament 插入耗材

插入耗材



Press and hold the spring buckle of the extruder and feed the consumables into the extruder.

按住挤出机的弹簧卡扣，将耗材送入挤出机。



Tip: How to replace consumables? After preheating the nozzle, push the consumables forward, quickly pull out the consumables, and put new consumables in.

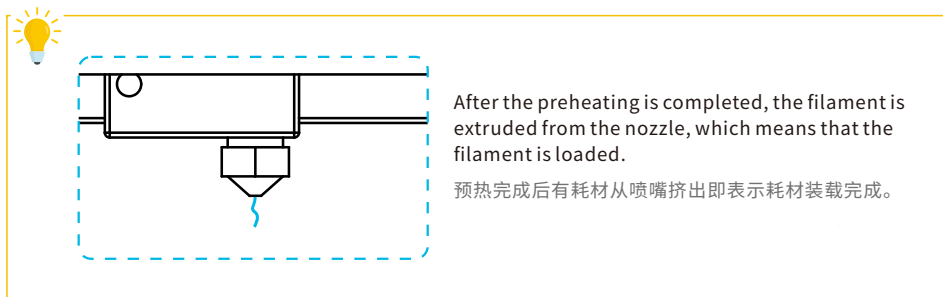
提示：如何更换耗材？

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。

Load and unload filaments 耗材的装载和卸除

3. Preheat nozzle.

预热喷嘴



4. Extruding filament and exiting filament

挤出耗材与退出耗材



1 Unload filament 退出耗材

2 Extruded filament 挤出耗材

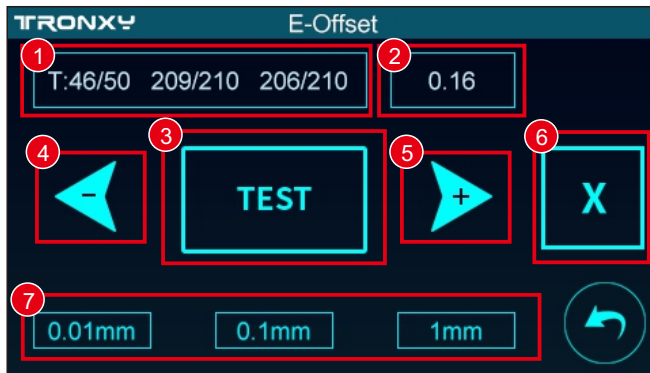
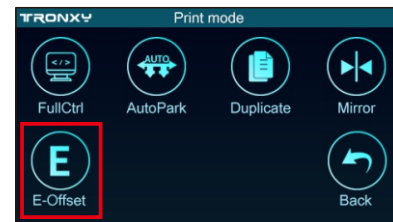
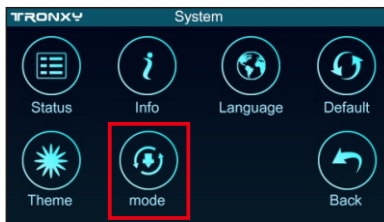
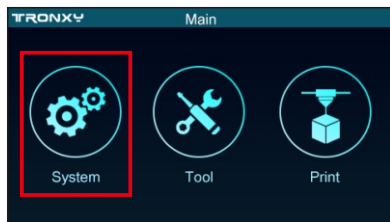
E-offset function introduction E偏移功能介绍



E-Offset
E-偏移

For printing with dual print heads, E-offset must be set to ensure the consistency of the dual heads in the X/Y direction, which is another necessary setting after the distance setting in the Z direction.

双打印头打印，都需要设置E偏移，确保双头在X/Y方向上的一致，是继Z方向的距离设置后的另一个必要的设置。



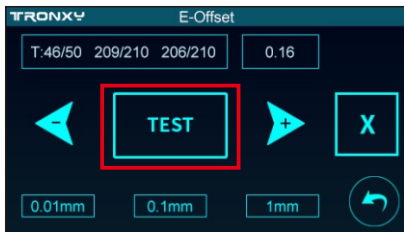
- 1 Temperature 温度参数
- 2 Moving distance 移动的距离
- 3 Start testing 开始测试
- 4 Reduce the offset value 减少偏移数值
- 5 Increase the offset value 增加偏移数值
- 6 Switch between X and Y axis X轴和Y轴测试切换
- 7 Choose the distance to move 选择移动的距离

***Wait until the temperature rises to the target temperature before the print head starts to move.**

***等待温度上升至目标温度后，此时打印头才会开始移动，在此之前请耐心等待。**

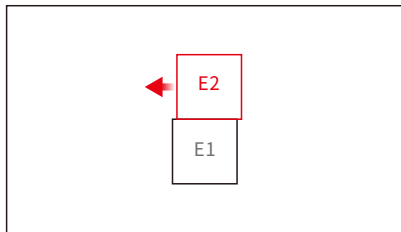
E-offset function introduction E偏移功能介绍

1. X axis offset X 轴偏移



Click "Test" and start the test after the temperature reaches the requirement

点击“测试”，待温度到达要求后开始进行测试



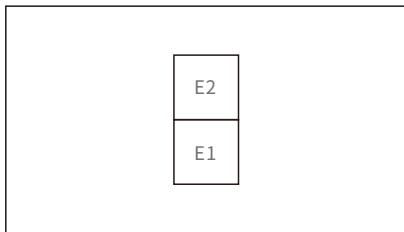
The machine will print two squares, observe whether the two squares are aligned horizontally and centered, if E2 is not aligned with E1, please adjust E2 to E1 to offset the X axis.

机器会打印两个方块，观察两个方块是否水平居中对齐，如果E2没有和E1对齐，请调整E2向E1进行X轴的偏移。

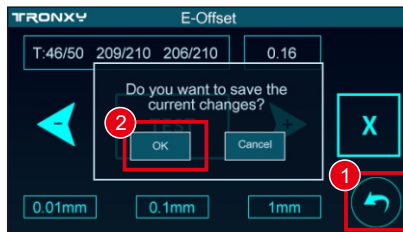


Adjust the offset distance of "E2" according to the offset distance of the two square boxes. 根据两个方框的偏移距离调整"E2"的偏移距离。

- 1 Choose the right moving distance 选择合适的移动距离
- 2 Adjust the position of the offset 调整偏移量的位置
- 3 Click test 点击测试

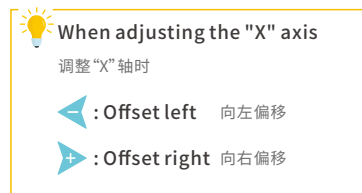


Adjust until the two boxes are horizontally centered 调整直到两个框水平居中对齐



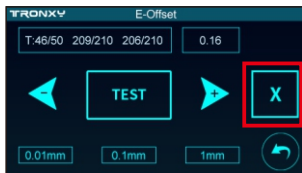
Save Settings 保存设置

- 1 Click back 点击返回
- 2 Select "OK" 选择“确认”



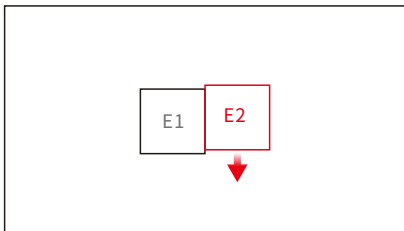
E-offset function introduction E偏移功能介绍

2. Y axis offset Y 轴偏移



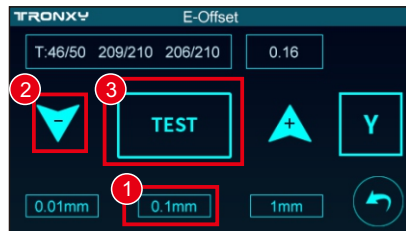
Click "X" to switch to "Y", click "Test", and start the test after the temperature reaches the requirement.

点击"X"切换至"Y", 点击"测试", 待温度到达要求后开始进行测试



The machine will print two squares and observe whether the two squares are aligned in the center. If the E2 square is not aligned with the E1 square, the Y axis of the E2 square needs to be offset.

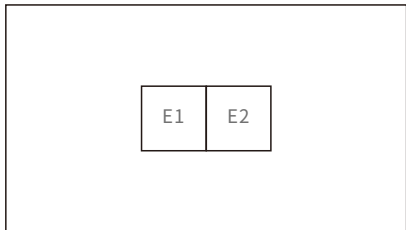
机器会打印两个方块, 观察两个方块是否居中对齐, 如果E2方块没有和E1方块对齐, 需要对E2方块进行Y轴的偏移。



Adjust the offset distance of "E2" according to the offset distance of the two square boxes.

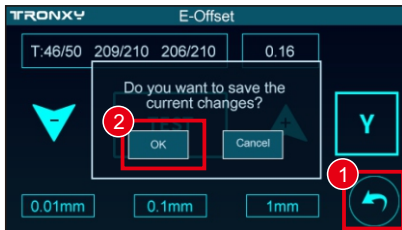
根据两个方框的偏移距离调整"E2"的偏移距离。

- 1 Choose the right moving distance 选择合适的移动距离
- 2 Adjust the position of the offset 调整偏移量的位置
- 3 Click test 点击测试



Adjust so that the two squares are vertically aligned in the center.

调整到两个方块垂直居中对齐。



Save Settings
保存设置

- 1 Click back 点击返回
- 2 Select "OK" 选择"确认"



When adjusting the "Y" axis

调整"Y"轴时

⬆️ : Offset forward 向前偏移

⬆️ : Offset backward 向后偏移

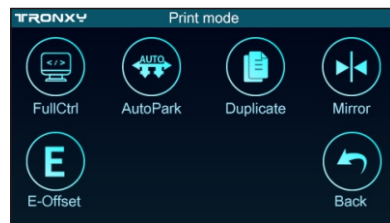
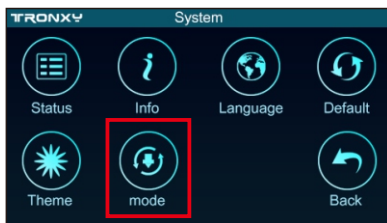
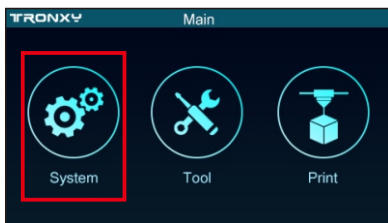
Printing mode introduction 打印模式介绍

Note: When printing different models, you must switch to the corresponding print mode first. Otherwise, the two print heads will collide!!!

注意事项: 打印不同模型时, 必须先切换到对应的打印模式, 否则会导致两个打印头相撞!!!

1.Introduction to print mode

打印模式介绍



FullCtrl
完全控制

Full control mode

In this mode, monochrome models are usually printed, the default print head is E1, and the print mode is determined by the setting mode of the slicing software.

完全控制模式

此模式下, 通常打印单色模型, 默认打印头为E1, 打印模式由切片软件设定模式决定。



AutoPark
自动停靠

Automatic docking mode (Double head, two in one)

In this mode, E1 and E2 print heads print the same model. When printing a two-color model, this mode must be selected, otherwise two print heads will collide.

自动停靠模式 (双头、2in1)

在此模式下, E1和E2打印头打印同一个模型, 打印双色模型时, 必须选择此模式, 否则会出现两个打印头碰撞的情况。



Duplicate
复制

Duplicate mode

In this mode, E1 and E2 use the middle of the printing platform as the dividing line, and print the same model on the left and right.

复制模式

在此模式下, E1和E2以打印平台中间为分界线, 打印左右相同的模型。



Mirror
镜像

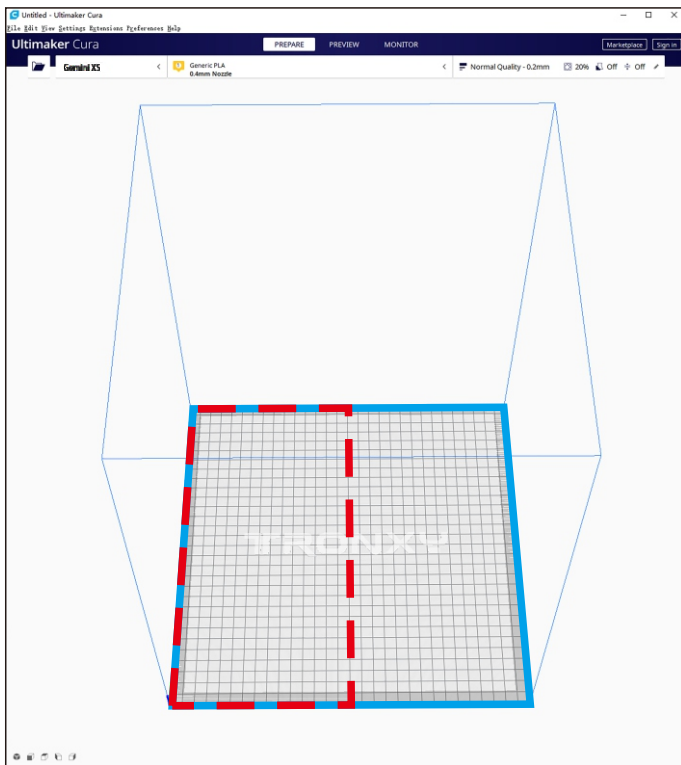
Mirror mode

In this mode, E1 and E2 take the middle of the printing platform as the dividing line, and print the left and right mirrored models

镜像模式

在此模式下, E1和E2以打印平台中间为分界线, 打印左右为镜像的模型。

Print mode size description 打印模式尺寸说明



1. Single-head printing: 255*255*260mm

2. Double-head printing: 255*255*260mm

3. Duplicate mode: 120*255*260mm

4. Mirror mode: 100*255*260mm

5. When copying and mirroring printing, the model can only be positioned on the left half of the platform (as shown on the left)

1、单头打印:255*255*260mm

2、双头印刷:255*255*260mm

3、复制模式:120*255*260mm

4、镜像模式:100*255*260mm

5、复制和镜像打印时, 模型只能定位在平台的左半部分 (如左图所示)

 Single-head and double-head printing range

单头和双头打印范围

 The printing range of duplication mode and mirror mode

复制模式和镜像模式的打印范围



Thumbdrive print
U盘打印



The metal side of
TF card is inserted
upwards
金属面朝上

1. Both the thumbdrive and TF card can read the printed content and keep reading at the same time;

2. When inserting the memory card into the card slot of the desktop, make sure that the metal surface is facing up, and do not use too much force, which may cause the risk of damaging the TF card or the card slot of the motherboard;

3. If the contents on the memory card cannot be read, please use FAT32 format, restart the machine and try again;

4. The printer is compatible with other memory cards of the same size;

5. Save the data to be printed in the root directory of the memory card. Do not save other folders or files in the memory card. It is better to name the G-CODE file name with a number.

1、U盘和TF卡皆可读取打印内容，且支持同时读取；

2、将内存卡插入桌面卡槽时，确保金属面朝上，不要用力过猛，存在损坏TF卡或主板卡槽的风险；

3、如果无法读取内存卡上的内容，请使用FAT32格式化后，重启机器再重试；

4、打印机兼容其他同大小尺寸的内存卡；

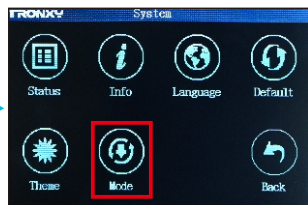
5、将要打印的数据保存在内存卡根目录下，不要在内存卡中保存其他文件夹或文件，并且最好用数字命名G-CODE文件名。

1. "FullCtrl" mode test (Single color printing)

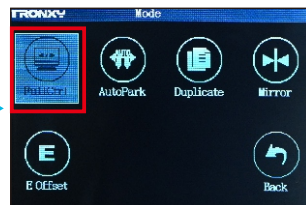
“完全控制”模式测试(单色打印)



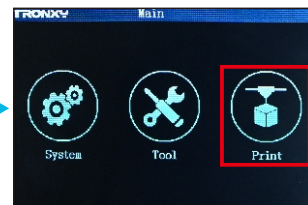
Click "System"
点击“系统”



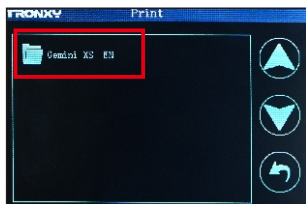
Click "Mode"
点击“模式”



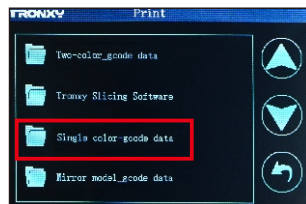
Click "Full Control"
点击“完全控制”



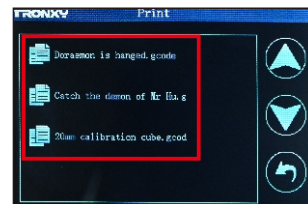
Back to the main page, Click "Print"
返回主页面, 选择“打印”



Select the "Gemini XS EN" folder
选择“Gemini XS EN”文件夹



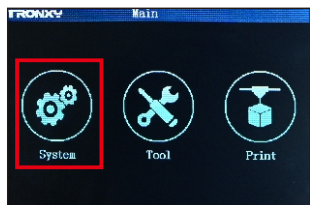
Select "Single color - gcode data"
选择“Single color - gcode data”



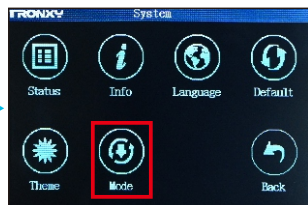
Select one of the models
to start printing
选择其中一个模型开始打印

2. "AutoPark" mode test (Two-color printing)

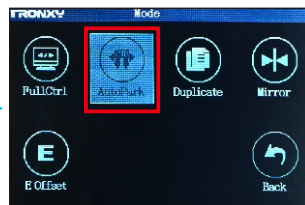
“自动停靠”模式测试(双色打印)



Click "System"
点击“系统”



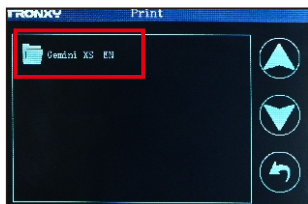
Click "Mode"
点击“模式”



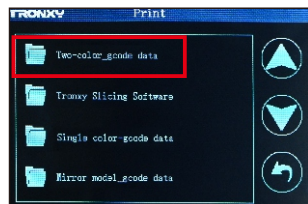
Click "AutoPark"
点击“自动停靠”



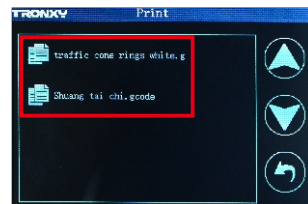
Back to the main page, Click "Print"
返回主页面, 选择“打印”



Select the "Gemini XS EN" folder
选择“Gemini XS EN”文件夹



Select "Two-color_gcode data"
选择“Two-color_gcode data”



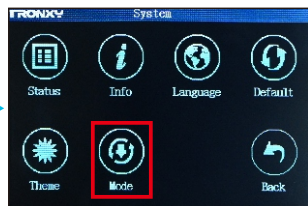
Select one of the models
to start printing
选择其中一个模型开始打印

3. "Duplicate" mode test (Copy model Printing)

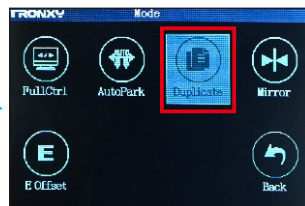
“复制”模式测试(复制打印)



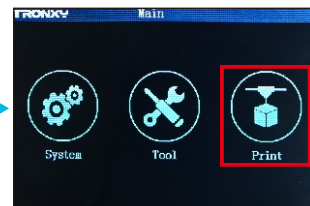
Click "System"
点击“系统”



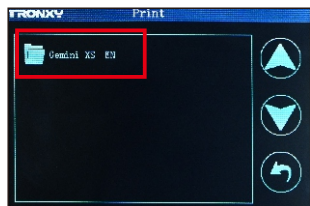
Click "Mode"
点击“模式”



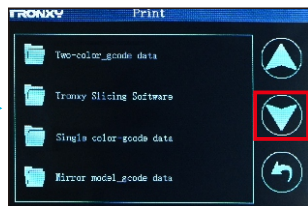
Click "Duplicate"
选择“复制模式”



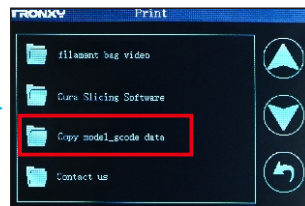
Back to the main page, Click "Print"
返回主页面, 选择“打印”



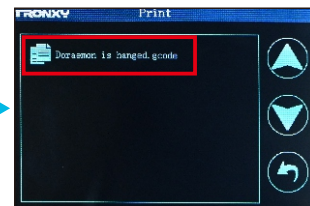
Select the "Gemini XS EN" folder
选择“Gemini XS EN”文件夹



Click "▼" to go to the next page
选择“▼”进入下一页



Select "Copy model_gcode data"
选择“Copy model_gcode data”



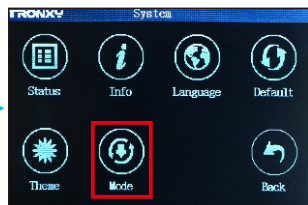
Select one of the models
to start printing
选择其中一个模型开始打印

4. "Mirror" mode test (Mirror model printing)

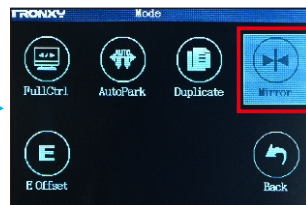
“镜像”模式测试(镜像打印)



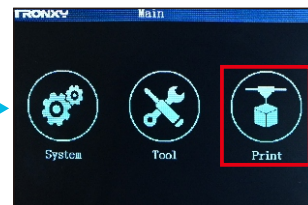
Click "System"
点击“系统”



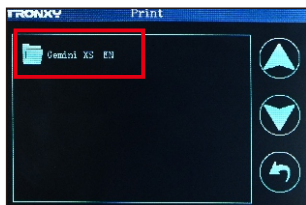
Click "Mode"
点击“模式”



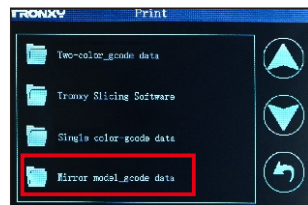
Click "Mirror"
选择“镜像模式”



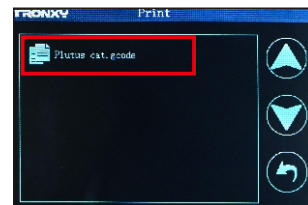
Back to the main page, Click "Print"
返回主页面, 选择“打印”



Select the "Gemini XS EN" folder
选择“Gemini XS EN”文件夹



Select "Mirror model_gcode data"
选择“Mirror model_gcode data”

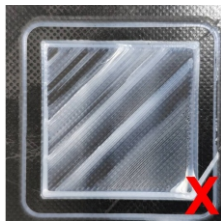


Select one of the models
to start printing
选择其中一个模型开始打印

Print test 打印测试

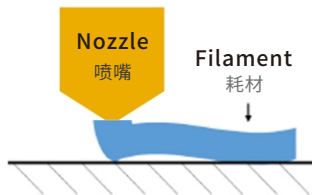
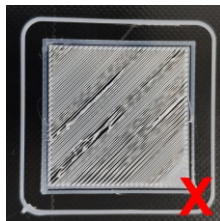
Possible situations and solutions when extruding consumables

挤出耗材时可能出现的情况以及解决的办法



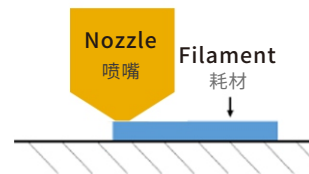
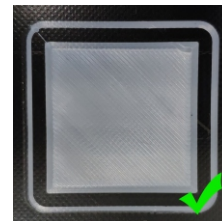
The distance between the hot bed and the nozzle is too close, you need to adjust the Z compensation, press the **arrow 1** in the figure to compensate the difference.

热床与喷嘴距离太近, 需要调整Z补偿, 按图中**箭头1**补偿差值。

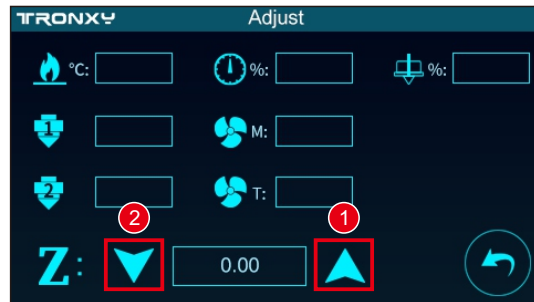
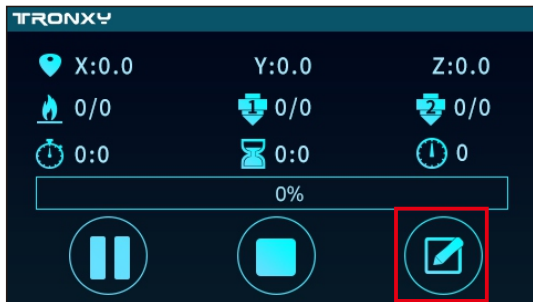


The distance between the hot bed and the nozzle is too far, you need to adjust the Z compensation, press the **arrow 2** in the figure to compensate the difference.

热床与喷嘴距离过远, 需调整Z补偿, 按图中**箭头2**补偿差值。



Proper nozzle height
Good extrusion and adhesion
合适的喷嘴高度良好的挤出和附着力



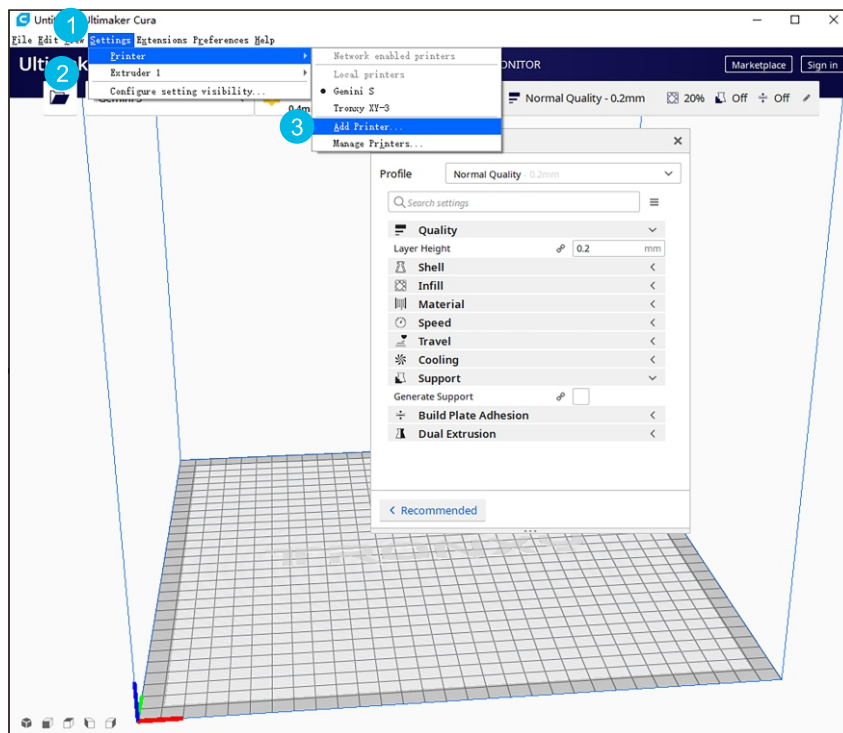
Slice software installation steps 切片软件安装设置

1. Install "Ultimaker_Cura-amd64", double-click to install the software, follow the prompts to complete the installation steps.

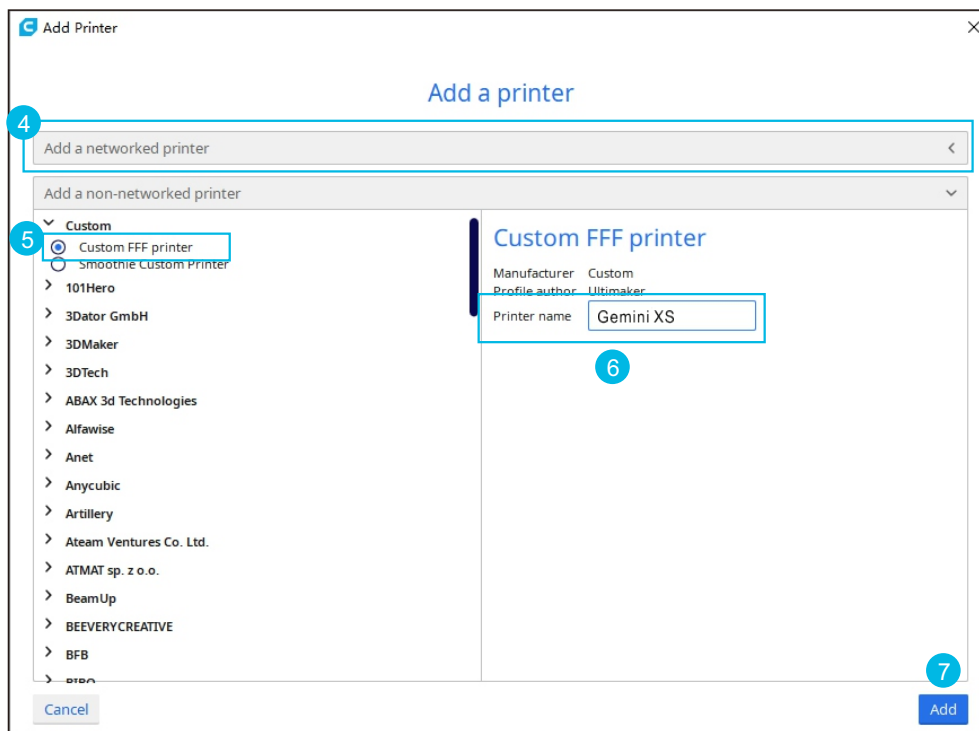
1、安装“Ultimaker_Cura-amd64”，双击安装软件，按照提示完成安装步骤。

2. Add a printer and set it up according to the figure below.

2、根据下图添加打印机并进行设置。



① Settings → ② Printer → ③ Add printer
设置 打印机 新增打印机



4 Add a non-networked printer → 5 Select "Custom FFF printer"

添加已联网打印机

选择“自定义打印机”

→ 6 Enter Gemini XS → 7 Click "Add"

输入 Gemini XS

点击“添加”

Machine Settings

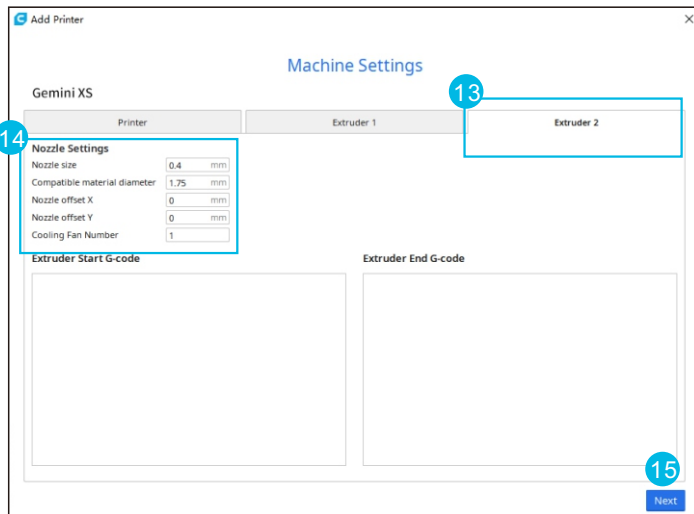
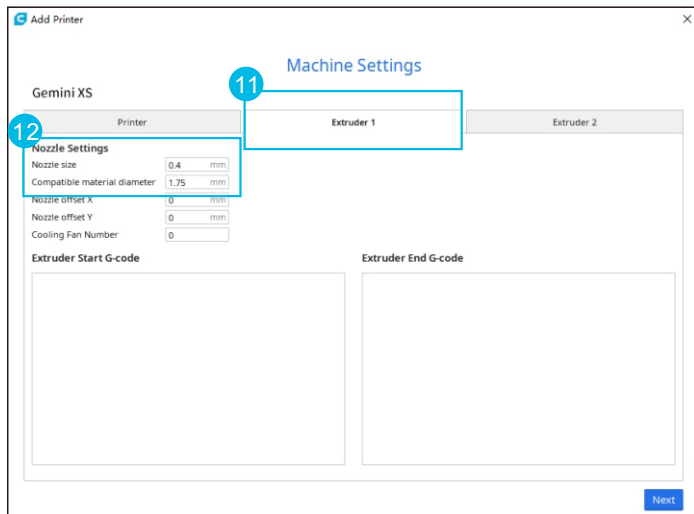
Gemini XS

Printer	Extruder 1	Extruder 2
Printer Settings X (Width) 255 mm Y (Depth) 255 mm Z (Height) 260 mm Build plate shape Rectangular Origin at center ☐ Heated bed ☒ Heated build volume ☐ G-code flavor Marlin	Printhead Settings X min -20 mm Y min -10 mm X max 10 mm Y max 10 mm Gantry Height 70 mm Number of Extruders 2	2 mm 10 mm 10 mm 70 mm 2 1 2 3 4 5 6 7 8
Start G-code <pre>G28 ;Home</pre>	End G-code <pre>M104 S0 M140 S0 ;Retract the filament G92 E1 G1 E1 F300</pre>	Next

8 Set the size of the printing platform, check "Heated bed" → 9 Set the "Number of Extruders" to "2"
设置打印平台尺寸, 勾选“加热床” 挤出头设置为“2”

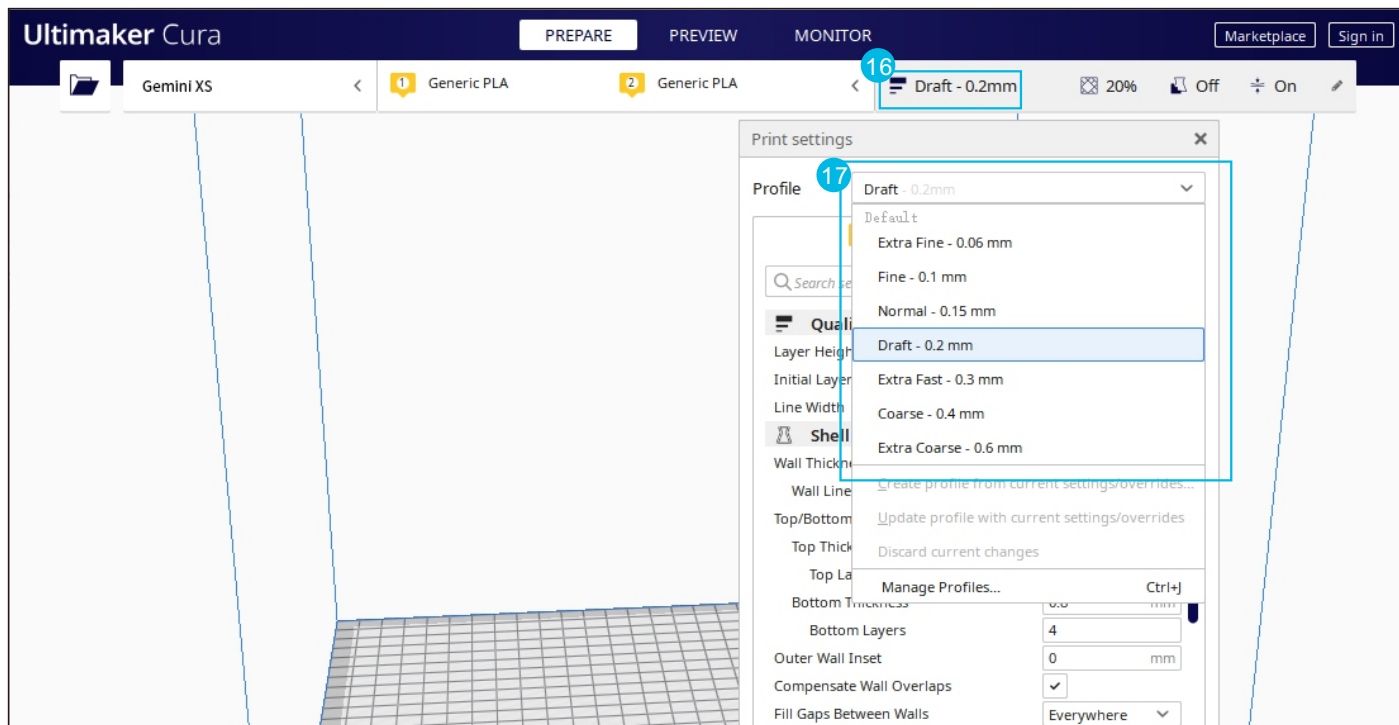
→ 10 Click "Next"
点击“下一步”

Slice software installation steps 切片软件安装设置



- 11 Select "Extruder 1" → 12 "Nozzle size" is 0.4, "Compatible material diameter" is changed to 1.75
选择“Extruder 1” “喷嘴孔径”为0.4，“兼容的材料直径”为改为1.75
- 13 Select "Extruder 2" → 14 "Nozzle Aperture" is 0.4, "Compatible Material Diameter" is 1.75, "Cooling Fan Number" is 1
选择“Extruder 2” “喷嘴孔径”是0.4，“兼容的材料直径”是1.75，“冷却风扇数量”是1
- 15 Click "Next"
点击“下一步”

Slice software installation steps 切片软件安装设置

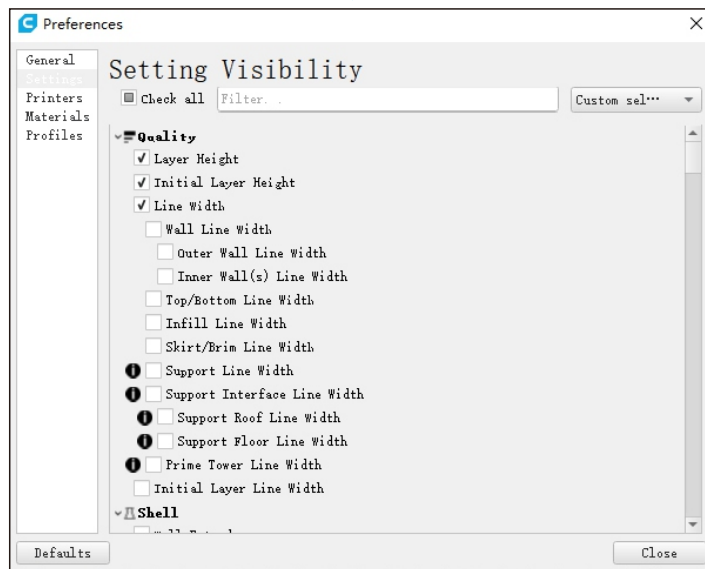
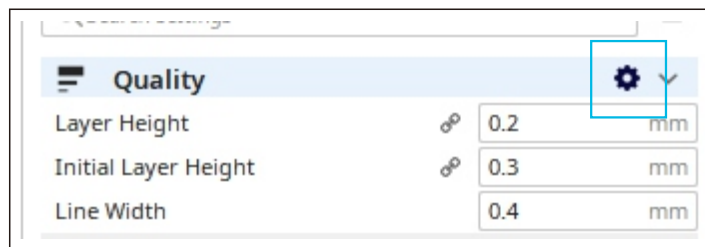


- 16 Open the settings panel → 17 Select "Draft-0.2mm"
- 打开设置面板 选择“Draft - 0.2mm”

Slice software installation steps 切片软件安装设置

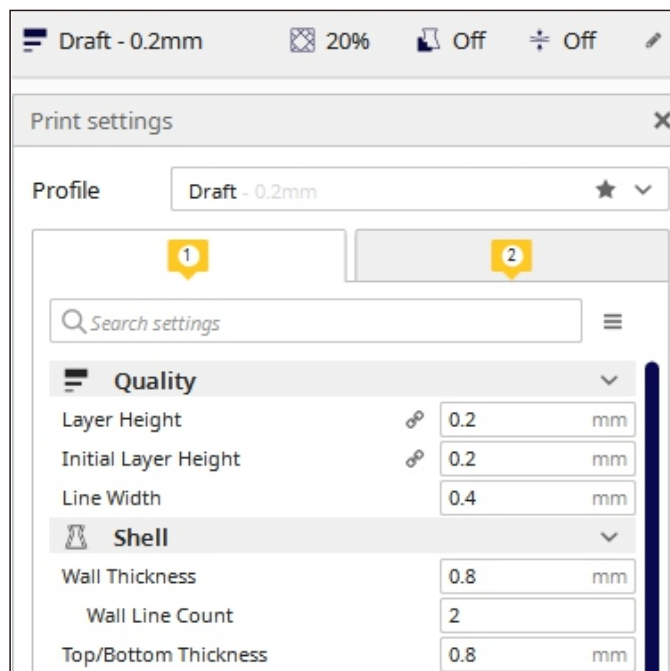
Open the hidden parameters as shown in the figure below

如下图所示打开隐藏的参数

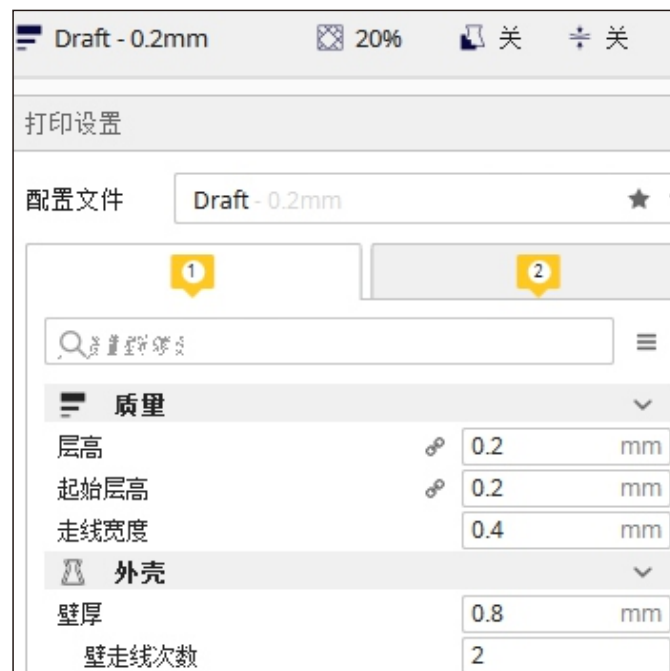


Slice software installation steps 切片软件安装设置

Set the printing parameters as shown in the figure



如图所示设置打印参数



 Shell	
Wall Thickness	0.8 mm
Wall Line Count	2
Top/Bottom Thickness	0.8 mm
Top Thickness	0.8 mm
Bottom Thickness	0.8 mm
Outer Wall Inset	0 mm
Compensate Wall Overlaps	☒
Fill Gaps Between Walls	Everywhere
Print Thin Walls	☐
Horizontal Expansion	0 mm
Z Seam Alignment	Sharpest Corn...
Skin Overlap Percentage	5 %
 Infill	
Infill Density	20 %
Infill Pattern	Grid
 Material	

 外壳	
壁厚	0.8 mm
壁走线次数	2
顶层 / 底层厚度	0.8 mm
顶层厚度	0.8 mm
底层厚度	0.8 mm
外壁嵌入	0 mm
补偿壁重叠	☒
填充壁之间空隙	全部填充
打印薄壁	☐
水平扩展	0 mm
Z 缝对齐	最短
皮肤重叠百分比	5 %
 填充	
填充密度	20 %
填充图案	网格

 Material ▼		
Printing Temperature	200	°C
Flow	100	%
Wall Flow	100	%
Top/Bottom Flow	100	%
 Speed ▼		
Print Speed	60	mm/s
Infill Speed	60	mm/s
Wall Speed	30.0	mm/s
Top/Bottom Speed	30.0	mm/s
Travel Speed	80	mm/s
Initial Layer Speed	30.0	mm/s
 Travel ▼		
Enable Retraction	☒	
Retraction Distance	8	mm
Retraction Speed	80	mm/s
Retraction Minimum Travel	0.8	mm

 填充 ▼		
填充密度	20	%
填充图案	网格	▼
 材料 ▼		
打印温度	200	°C
流量	100	%
壁流量	100	%
顶部/底部流量	100	%
 速度 ▼		
打印速度	60	mm/s
填充速度	60	mm/s
速度 (壁)	30.0	mm/s
速度 (顶部 / 底部)	30.0	mm/s
空驶速度	80	mm/s
起始层速度	30.0	mm/s
 移动 ▼		

 **Travel**

Enable Retraction☒

Retraction Distance

8

mm

Retraction Speed

80

mm/s

Retraction Minimum Travel

0.8

mm

Z Hop When Retracted☐

 **Cooling**

Enable Print Cooling☒

Fan Speed

100.0

%

Minimum Layer Time

5

s

 **Support**

Generate Support



☐

 **Build Plate Adhesion**

Build Plate Adhesion Type





None

 **Dual Extrusion**

 **移动**

启用回抽☒

回抽距离

8

mm

回抽速度

80

mm/s

回抽最小空驶

0.8

mm

回抽时 Z 抬升☐

 **冷却**

开启打印冷却☒

风扇速度

100.0

%

最短单层冷却时间

5

s

 **支撑**

生成支撑



☐

 **打印平台附着**

打印平台附着类型





无

 **双重挤出**

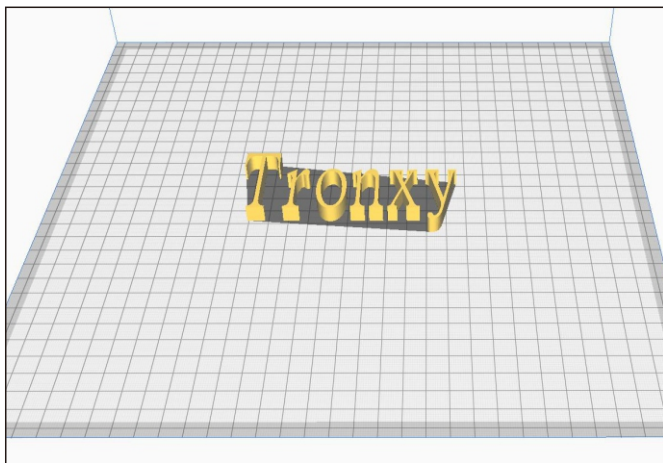
The slicing method of the 4 printing modes 四种打印模式的切片方法



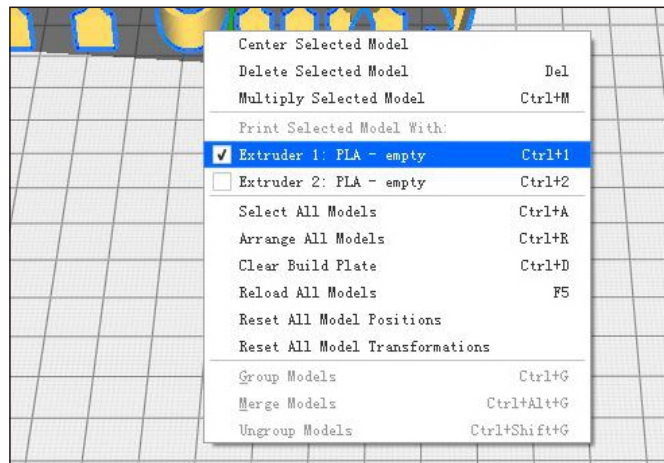
FullCtrl
完全控制

Import a single model, the model is centered, select print head 1 to print the monochrome model, and then click the slice to output the G-code file, and finally select the "Full Control" mode on the printer to start printing.

导入单个模型，模型居中，选择打印头1来打印单色模型，然后点击切片即可输出G-code文件，最后选择打印机上的“完全控制”模式开始打印。



Import model
导入模型



Select "Extrusion Head 1"
选择“挤出头1”

The slicing method of the 4 printing modes 四种打印模式的切片方法



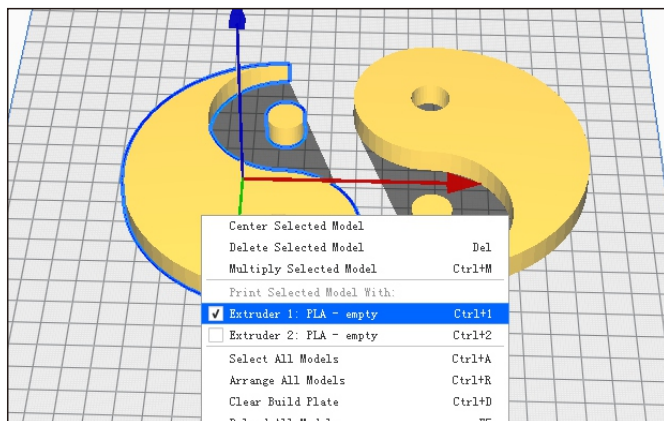
AutoPark
自动停靠

1. Import two associated STL models (mergeable);
2. Press the left mouse button to select the model on the left, then press the right mouse button, and select "Extruder 1:PLA - empty" from the pop-up options;
3. Press the left mouse button to select the model on the right, then press the right mouse button, and select "Extruder 2:PLA - empty" from the pop-up options;
4. Press and hold the "Shift" key on the keyboard, press the left mouse button to select all models, then press the right mouse button, and select "Merge Models" from the pop-up options;
5. Finally, click the slice to output the G-code file, and select the "auto-dock" mode on the printer to print.

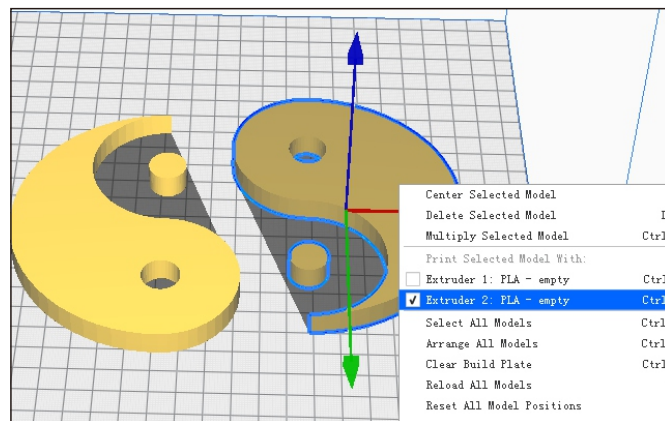
- 1、导入两个相关联的STL模型(可合并);
- 2、按鼠标左键选中左边模型,再按鼠标右键,从弹出的选项中选择“Extruder 1:PLA - empty”;
- 3、按鼠标左键选中右边模型,再按鼠标右键,从弹出的选项中选择“Extruder 2:PLA - empty”;
- 4、按住键盘“Shift”键不放,按鼠标左键选中全部模型,再按鼠标右键,从弹出的选项中选择“Merge Models”;
- 5、最后点击切片即可输出G-code文件,选择打印机上的“自动停靠”模式打印。



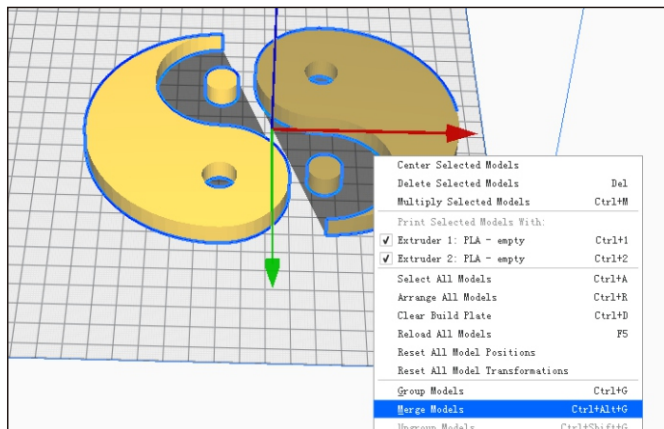
The slicing method of the 4 printing modes 四种打印模式的切片方法



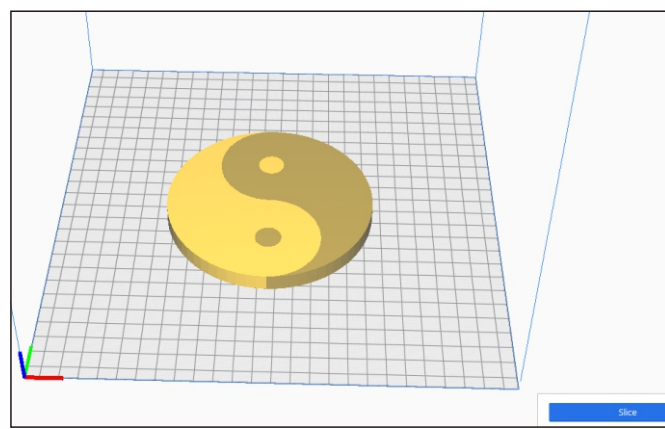
2



3



4



5

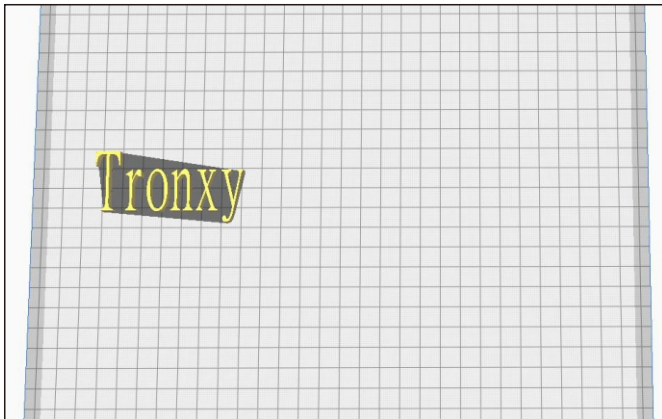
The slicing method of the 4 printing modes 四种打印模式的切片方法



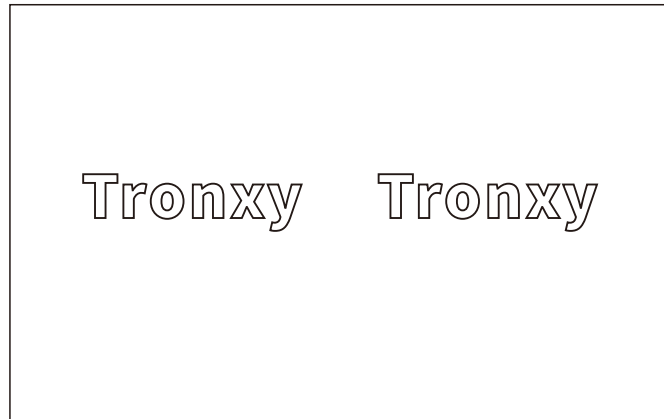
Duplicate
复制

1. Import a single model and place the model to the left of the middle line;
2. Click on the slice to output the G-code file, select "Duplicate" mode on the printer (the printing effect is shown in the figure).

- 1、导入单个模型,模型放中间线的左边.;
- 2、点击切片即可输出G-code文件,选择打印机上的复制模式(打印效果如图)。



1



2

(Simulation printing effect diagram)
(模拟打印效果图)

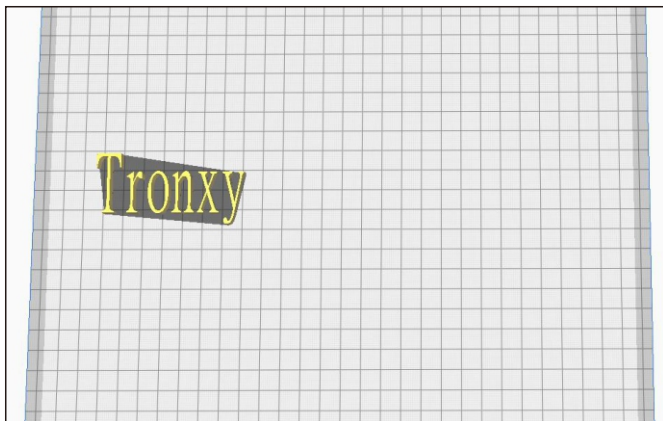
The slicing method of the 4 printing modes 四种打印模式的切片方法



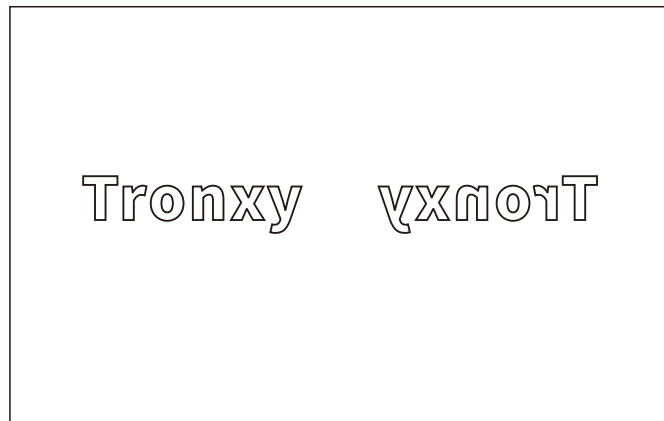
Mirror
镜像

1. Import a single model and place the model to the left of the middle line;
2. Click on the slice to output the G-code file, select "Mirror" mode on the printer (the printing effect is shown in the figure).

- 1、导入单个模型,模型放中间线的左边.;
- 2、点击切片即可输出G-code文件,选择打印机上的镜像模式(打印效果如图)。



1



2

(Simulation printing effect diagram)
(模拟打印效果图)

1. Machine cannot start

- 1) Check the power line and other wires are connected well or not.
- 2) Check whether the supply voltage suits the local standard.
- 3) Check whether the screen or power supply is damaged and replace it in time.
- 4) Check if the wires are damaged or broken.
- 5) Check whether the power fuse is burnt out.

1. 机器无法启动

- 1) 检查电源线和其他电线是否连接好。
- 2) 检查供电电压是否符合当地标准。
- 3) 检查屏幕或电源是否损坏,及时更换。
- 4) 检查电线是否损坏或断裂。
- 5) 检查电源保险丝是否烧断。

2. The contents of the TF card cannot be read

- 1) Check the card reader if it is good.
- 2) If the computer can't read the TF card, please format it and try again.
- 3) Check whether the TF card is inserted correctly.
- 4) The filename has an illegal character, please rename it.
- 5) Please replace the damaged TF card and try again.

2.无法读取TF卡内容

- 1) 检查读卡器是否完好。
- 2) 如果电脑无法读取TF卡,请格式化后再试。
- 3) 检查 TF 卡是否正确插入。
- 4) 文件名含有非法字符,请重命名。
- 5) 请更换损坏的 TF 卡并重试。

3. If the print head does not squeeze enough filament or can't squeeze any filament.

- 1) Check whether the print head temperature reach 200 °C above (PLA), led to filament cannot squeeze, waiting for the temperature rises to the set target.
- 2) Check whether the filaments are knotted, which leads to unsmooth feeding.
- 3) Check whether the filaments or pipes are not inserted in place, resulting in the failure of feeding.
- 4) Check whether the temperature of the print head is too high, which leads to excessive softness of filaments and can't be extruded normally.
- 5) Check whether the diameter of filaments is consistent with the diameter set in the slicing software, so that the amount of extrusion filaments is not enough.
- 6) Check whether the consumables are blocked by dirt or nozzle blocked during extrusion.
- 7) Replace with better quality filaments.

3. 如果打印头没有挤压足够的耗材或无法挤压任何耗材。

- 1) 检查打印头温度是否达到200°C以上 (PLA) ,导致灯丝无法挤压,等待温度升至设定目标。
- 2) 检查细丝是否打结,导致送料不畅。
- 3) 检查灯丝或管道是否没有插入到位,导致送料失败。
- 4) 检查打印头温度是否过高,导致耗材过于柔软,不能正常挤出。
- 5) 检查长丝直径是否与切片软件中设置的直径一致,以免挤出长丝数量不够。
- 6) 检查耗材是否被脏物堵塞或挤出时喷嘴堵塞。
- 7) 更换质量更好的灯丝。

4. If the first layer upwarp

- 1) Check if the hot bed has been leveled well.
- 2) Check the surface of the hot bed for dirt.
- 3) Check whether the distance between the nozzle and the platform is too high, resulting in insufficient adhesive force.
- 4) Check the hot bed for adequate temperature.
- 5) Check the first layer of the slicing software to see if it is printing too fast.

4. 如果第一层向上翘起

- 1) 检查热床是否平整。
- 2) 检查热床表面是否有污垢。
- 3) 检查喷嘴与平台之间的距离是否太高,导致粘合力不足。
- 4) 检查热床是否有足够的温度。
- 5) 检查切片软件的第一层,看是不是打印太快了。

5. The model is not easy to take off

- 1) Try to heat the hot bed to 50-70 °C take off it by the shovel .
- 2) It is recommended to buy TRONXY magnetic stickers.

5.模型不易脱模

- 1) 尝试将热床加热至 50-70 °C 用铲子将其取下。
- 2) 建议购买TRONXY磁贴。

6. Can't heat it up

- 1) Check the heating rod and thermistor for poor contact or damage.
- 2) Check that the slice software has set the target temperature.
- 3) Check whether the thermistor wire falls off.

6.不能加热

- 1) 检查加热棒和热敏电阻是否接触不良或损坏。
- 2) 检查切片软件是否设置了目标温度。
- 3) 检查热敏电阻丝是否脱落。

7. Motor out of step

- 1) Check the tightness of the belt, whether the pulley is not locked.
- 2) Check the current voltage.
- 3) Check X/Y/Z axis motion is smooth.
- 4) Print speed too fast.
- 5) Environment temp too high.
- 6) Need flash the firmware.

7.电机失步

- 1) 检查皮带松紧, 皮带轮是否未锁紧。
- 2) 检查当前电压。
- 3) 检查 X/Y/Z 轴运动是否顺畅。
- 4) 打印速度太快。
- 5) 环境温度过高。
- 6) 需要刷固件。

8. Abnormal motor noise or vibration

- 1) Check whether the motor line is in bad contact, loose or wrong connection.
- 2) Motor temperature is too high.
- 3) Check whether the motor is damaged.
- 4) Flash the firmware.
- 5) The printing load is too heavy.

8. 电机异常噪音或振动

- 1) 检查电机线是否接触不良、松动或接错。
- 2) 电机温度过高。
- 3) 检查电机是否损坏。
- 4) 刷固件。
- 5) 打印负荷过重。

9. Model dislocation and fault

- 1) Nozzle feeding not smoothly, please clean the nozzle or replace the nozzle.
- 2) Check that if the printing speed is too fast.
- 3) The quality of filaments is poor, please replace with new filaments.

9. 模型错位与故障

- 1) 喷嘴进料不顺畅, 请清洁喷嘴或更换喷嘴。
- 2) 检查打印速度是否过快。
- 3) 灯丝质量差, 请更换新灯丝。

10. Abnormal sound and vibration of filaments feeding motor

- 1) Please check whether the nozzle is blocked.
- 2) The nozzle feeding is not smooth, please clean the nozzle.
- 3) Whether the software Settings are incorrect.
- 4) Check whether the motor does not work.
- 5) Check the motor working or not or feeding gear is not working.

10. 灯丝异常声音和振动送料电机

- 1) 请检查喷嘴是否堵塞。
- 2) 喷嘴进料不顺畅, 请清洁喷嘴。
- 3) 软件设置是否有误。
- 4) 检查电机是否不工作。
- 5) 检查电机是否工作或送料齿轮不工作。

11. Screen related questions

- 1) No screen/blue screen, please restart or check whether the cable is plugged in.
- 2) Touch screen malfunction, check whether the screws are installed too tight.
- 3) Garbled/splash screen, static, ground connection or restart.

11. 屏幕相关问题

- 1) 无屏/蓝屏, 请重启或检查网线是否插好。
- 2) 触摸屏故障, 检查螺丝是否安装过紧。
- 3) 乱码/闪屏、静电、接地或重启。

12. Motherboard related issues

- 1) The wiring is not responding. Please check the wiring installation.
- 2) Automatic shutdown restart, may be abnormal firmware or module of “resume print after power failure” damaged.
- 3) Lack of heat dissipation, please lower the ambient temperature.
- 4) No response due to motherboard damage.

12. 主板相关问题

- 1) 接线无反应。请检查接线安装。
- 2) 自动关机重启, 可能是异常固件或“断电恢复打印”模块损坏。
- 3) 散热不足, 请降低环境温度。
- 4) 主板损坏无反应。

13. Unable to connect to printer

- 1) Check that the driver is not installed or properly installed.
- 2) The serial port was not selected correctly.
- 3) The software parameters do not match.

13. 无法连接到打印机

- 1) 检查驱动程序是否未安装或正确安装。
- 2) 串口选择不正确。
- 3) 软件参数不匹配。



If you have any usage problems, you can directly contact the manufacturer to master the machine's first-hand information, advanced gameplay, and user communication, all in the GEMINI S Facebook user group, scan it and join us!

如遇使用问题可直接联系厂家，掌握机器的第一手资料，
进阶玩法，用户交流，尽在GEMINI XS脸书用户组，扫一扫 加入我们吧！

Due to the differences between different machine models, the physical objects and the final images can differ.

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