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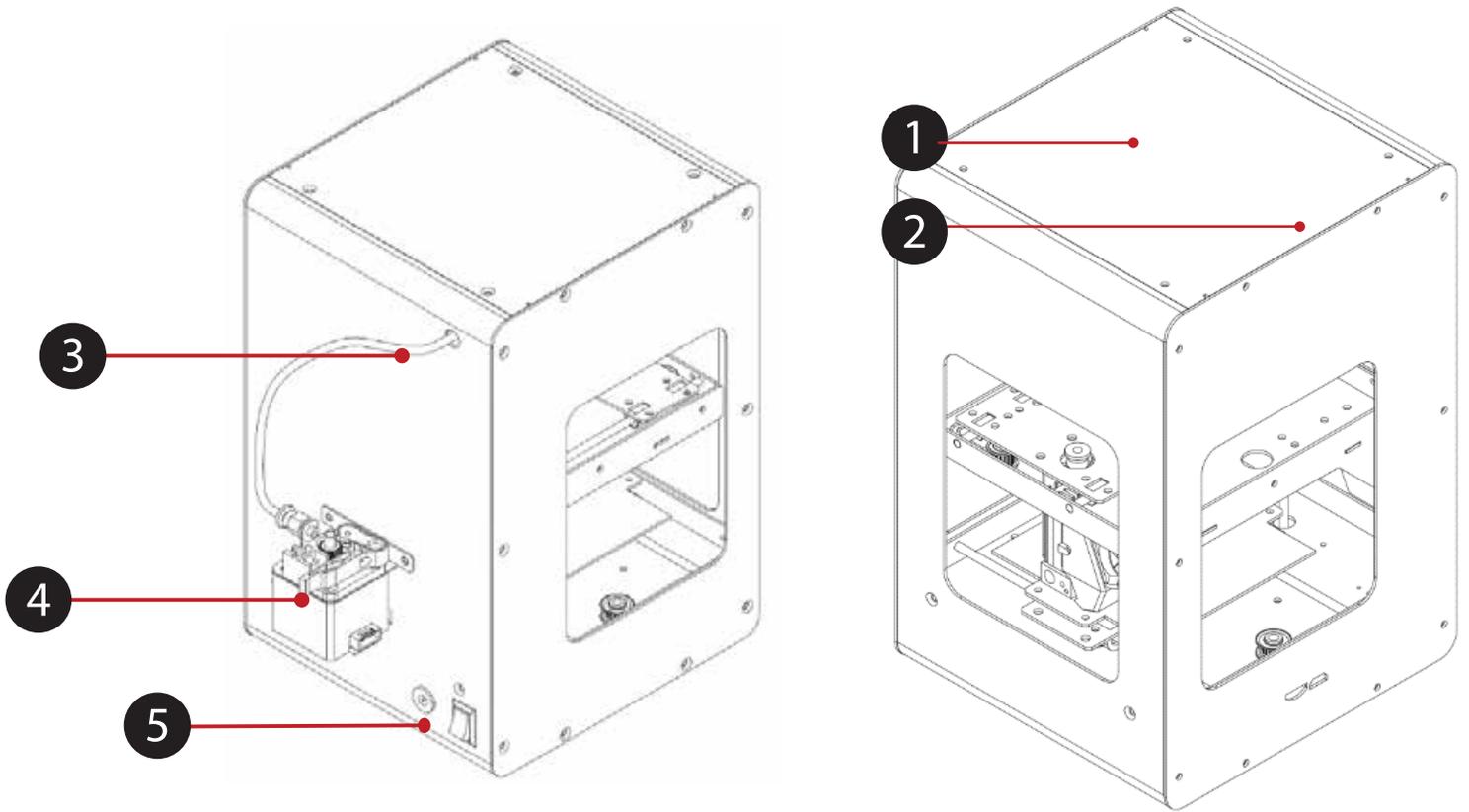
Precautions

1. Do not strip the yellow paper on the platform, it is for anti-slip printing.
2. Do not strip the wrapper which wrap up the nozzles, it is for holding nozzle temperature.
3. Use this printer under right power and follow all local laws.
4. Be ware of hot heat blocks, nozzles, extruded filament and heating plate.
5. Do not wear gloves when operating or repairing to avoid entanglement.
6. Do not leave the machine unattended when it is in operation.
7. Do not throw, disassemble, crush, burn your 3D printer or load unsupported filament.
8. Keep your 3D printer and all accessories out of children's reach.
9. When printing via USB, keep stable connection between the PC and the printer.
10. Do not move the extruder during printing.
11. Do not pull or twist the black cable any time.
12. Do not force or tear anything during unpacking and setup. This may damage the printer.
13. WARNING
 - a) Never reach inside while it is in operation. Always allow it to cool down before reaching inside.
 - b) If opening the printer for service, ensure that the power supply is turned off and the cord is disconnected.
14. CAUTION
 - a) The printer was built and packaged very carefully at the factory. We hope you'll take your time and be just as careful unpacking it and getting it set up.

Included in box

1. 3D Printer
2. Micro-USB cable
3. Micro-SD card
4. Power Adapter
5. Power line
6. Plastic scraper

Printer Diagram



1. Extruder
2. USB and SD card slot
3. Guide tube
4. Extruder motor
5. Power interface and switch

Technical Parameters

Construction	PLA with power-coated steel reinforcement
Extruder	Single
Nozzle diameter	0.4 mm (0.015 in)
Positioning Precision	XY 11 microns (0.0004 in), Z 2.5 micron (0.0001 in)
Layer Resolution	100 micron (0.0039 in)
Input Power	100-240V, Max 80W:
Nozzle heating	Max 250° C
Filaments	1.75mm diameter PLA
Interface	SDcard, USB and WIFI
Build Surface	Aluminum platform
Supported File	STL, OBJ/G-Code
OS	Windows10, Mac OS X, Linux
Certificate	CE, ROHS, FCC, ISO9001:2008
Warranty	6 months
Product Dimension	About 17.2x18.3x27 cm
Build Volume	100x100x100 mm
Shipping Box	About 220x220x320 mm

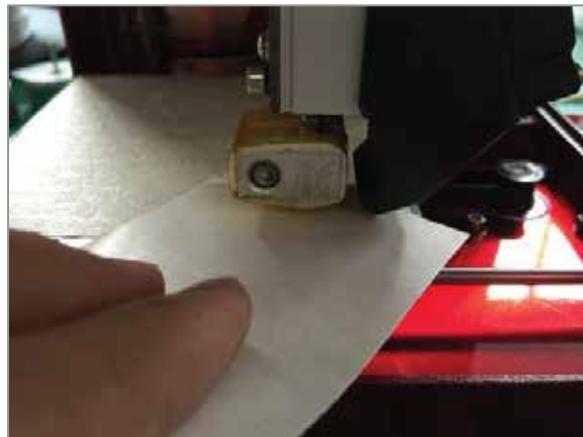
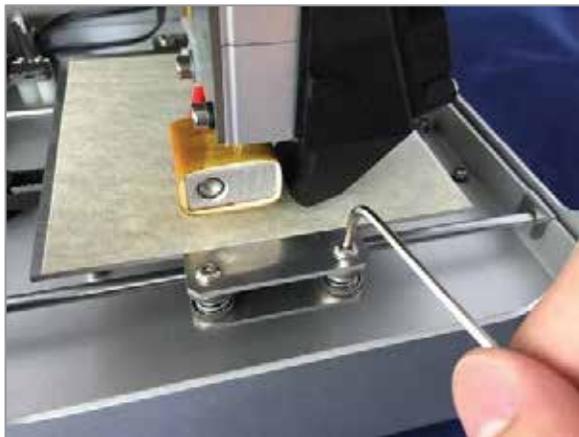
Installation

Connect the power line and the Micro USB line.

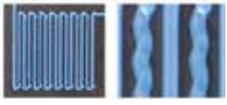


The print platform was adjusted during production, but it may need slight adjustment due to shipping. To adjust the platform prior to printing, follow the below instructions:

Use your software print controls to return to Home. The printer head should be very close to the printer platform. Use a piece of paper and slip it between the print head nozzle and the platform. It should just slip though - not too tight, and not too loose.

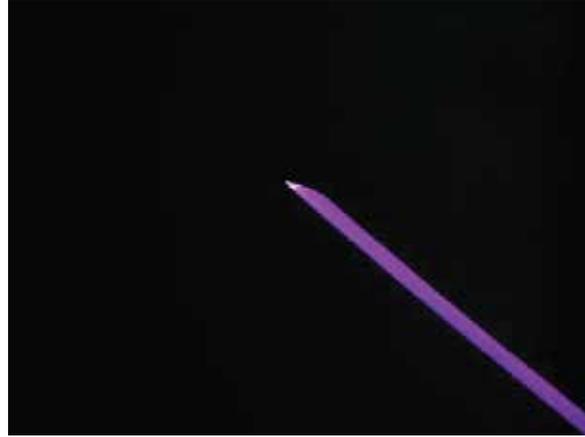


- If the hotend is too far from the printing platform, the filament will extrude too thick and will lump and peel back from the platform.
- If the heating plate is too close to the nozzle, it will directly affect the nozzle movement. This could also damage the hotend and platforms.

wrong		Nozzle is too far from the print bed and filament is coming out too thick and not well connected to bed
correct		Correct distance
wrong		Nozzle and platform too close. Filament is too thin and hot end may scrape against bed.

Installation - cont.

Use wirecutters or scissors to trim filament to a point before inserting into printer feed.



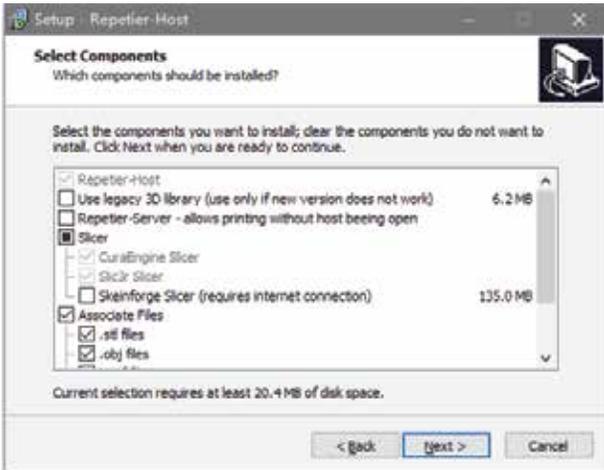
Pinch the feed grip with your fingers as shown below to open a channel to the filament line. Gently feed filament through the channel, allowing it to continue through the feed line until the filament meets resistance when it reaches the extruder.



NOTE: The extruder cooling fan will come on anytime the extruder is above 50° and will turn off automatically when the extruder cools below 50°.

It is very important you let the fan cool the extruder before removing power cord or this could cause the extruder to jam or clog next time you use it.

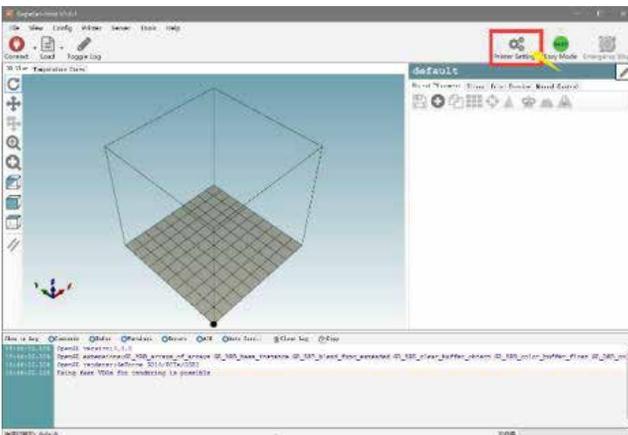
Software Installation



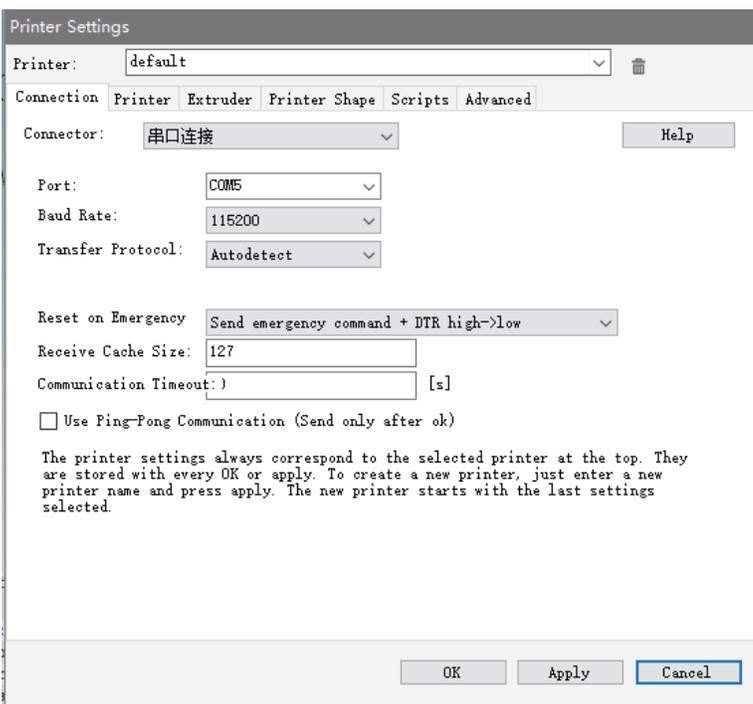
On the included SD card can be found the Repetier installation package (PC). Please follow the steps below to install this software.

Note: you can also download Repetier Host software from: <https://www.repetier.com/>

Mac users should download Mac OS software from the above link.



After running the software you can begin to adjust the parameters of the software to adapt to M100. Click on the top right corner of the icon.



Open the settings window, please switch to the Connection tab.

Please refer to the shown settings to set the parameters.

Software Installation

Continue to set up using the settings on the following screenshots.

Printer Settings

Printer: default

Connection Printer Extruder Printer Shape Scripts Advanced

Travel Feed Rate: 2000 [mm/min]
Z-Axis Feed Rate: 100 [mm/min]
Manual Extrusion Speed: 2 20 [mm/s]
Manual Retraction Speed: 30 [mm/s]
Default Extruder Temperature: 190 °C
Default Heated Bed Temperature: 0 °C

Check Extruder & Bed Temperature
 Remove temperature requests from Log
Check every 3 seconds. [Slider]
Park Position: X: 0 Y: 0 Z min: 0 [mm]
 Send ETA to printer display Go to Park Position after Job/Kill
 Disable Extruder after Job/Kill Disable Heated Bed after Job/Kill
 Disable Motors after Job/Kill Printer has SD card
Add to comp. Printing Time 8 [%]
Invert Direction in Controls for X-Axis Y-Axis Z-Axis Flip X and Y

OK Apply Cancel

Printer Settings

Printer: default

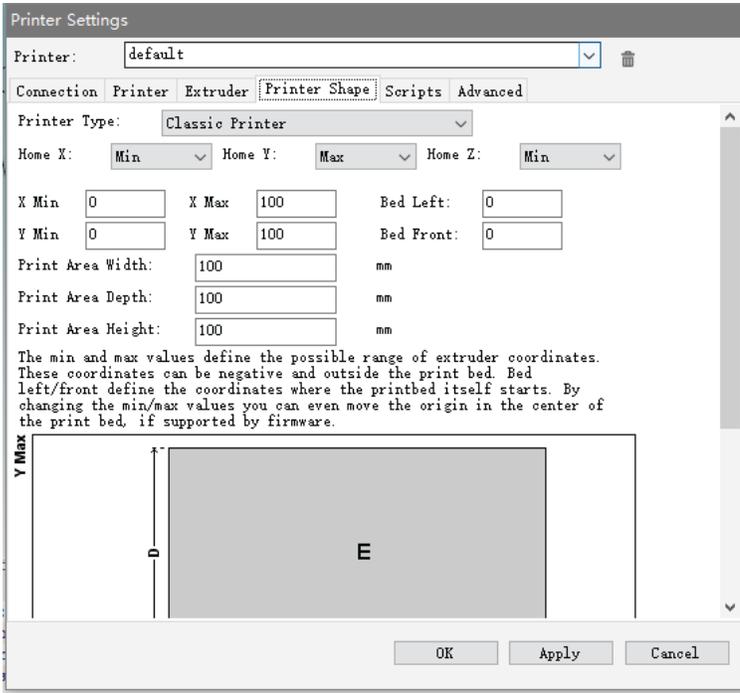
Connection Printer Extruder Printer Shape Scripts Advanced

Number of Extruder: 1
Max. Extruder Temperature: 250
Max. Bed Temperature: 60
Max. Volume per second: 12 [mm³/s]
 Printer has a Mixing Extruder (one nozzle for all colors)

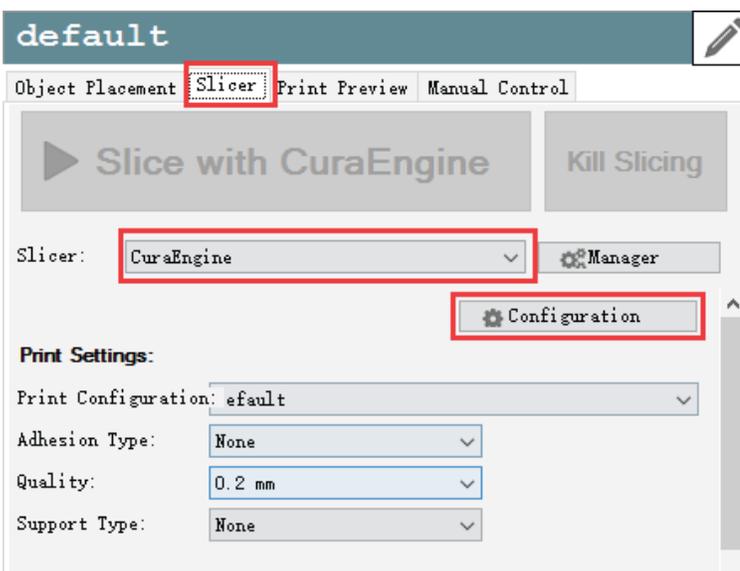
Extruder 1
Name:
Diameter: 0.4 [mm] Temperature Offset: 0 [°C]
Color:
Offset X: 0 Offset Y: 0 [mm]

OK Apply Cancel

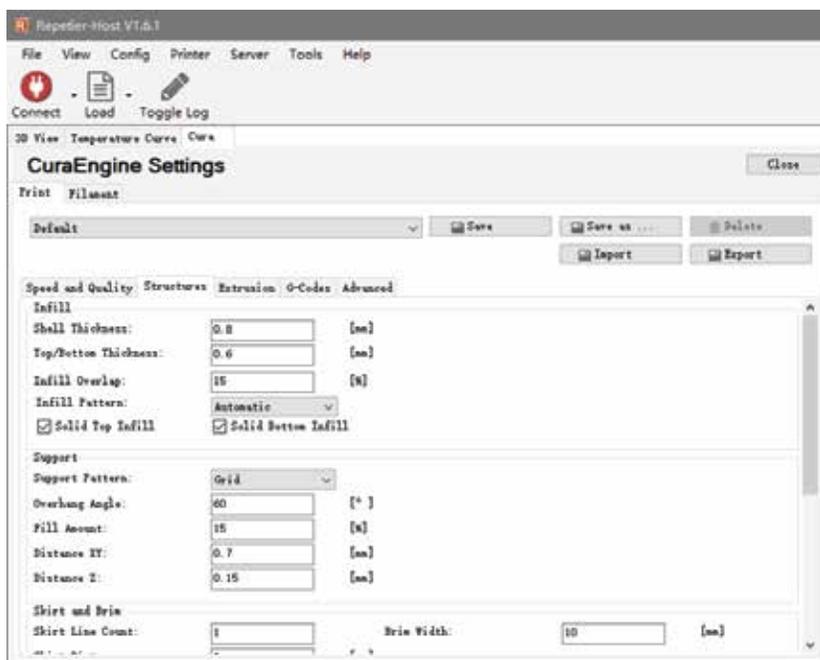
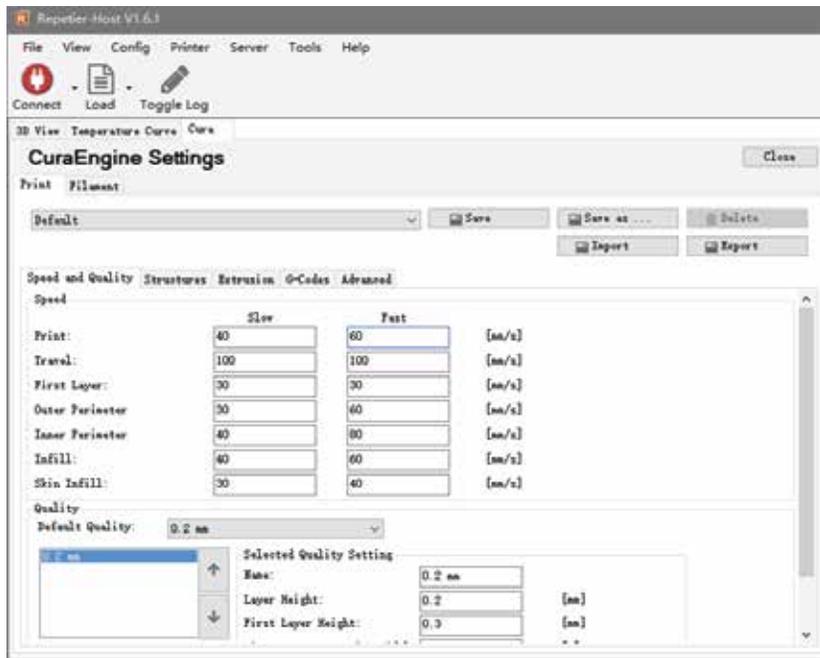
Software Installation



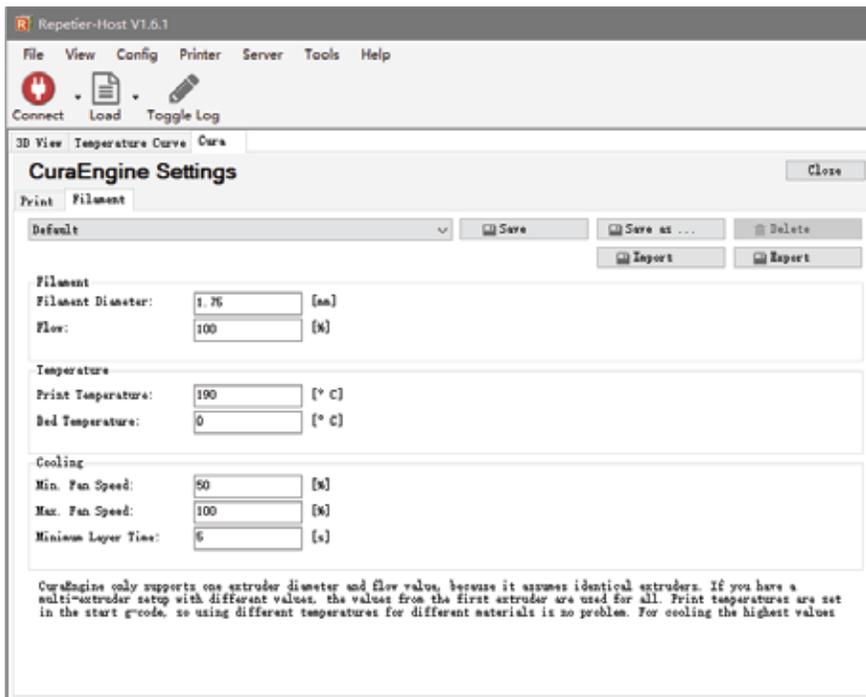
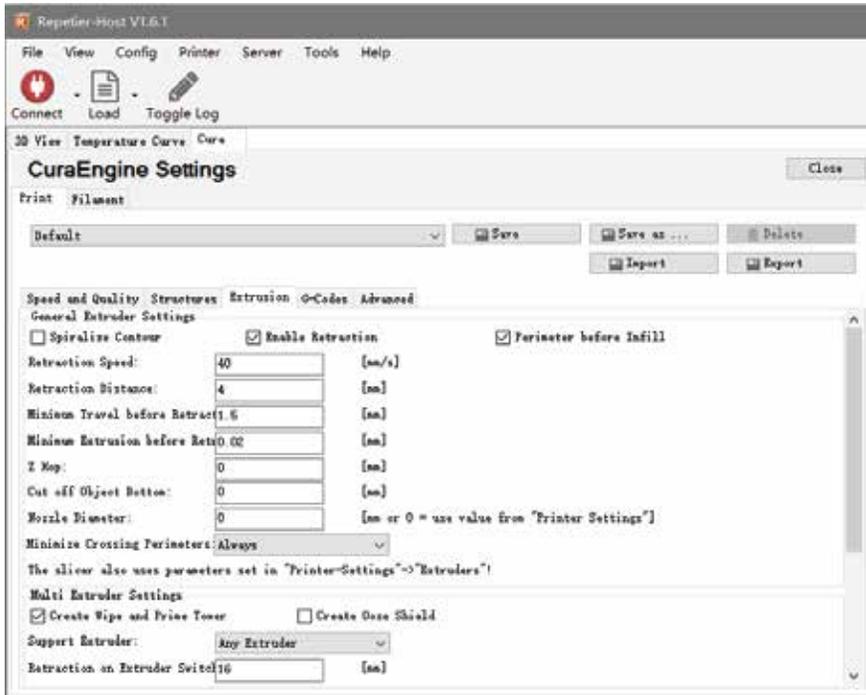
To setup your Slicer software (software that slices your 3D model into individual layers for printing), reference the following screenshots. Note: you may use any slicer you like. We recommend either Cura or Slicr using the following guidelines.



Software Installation



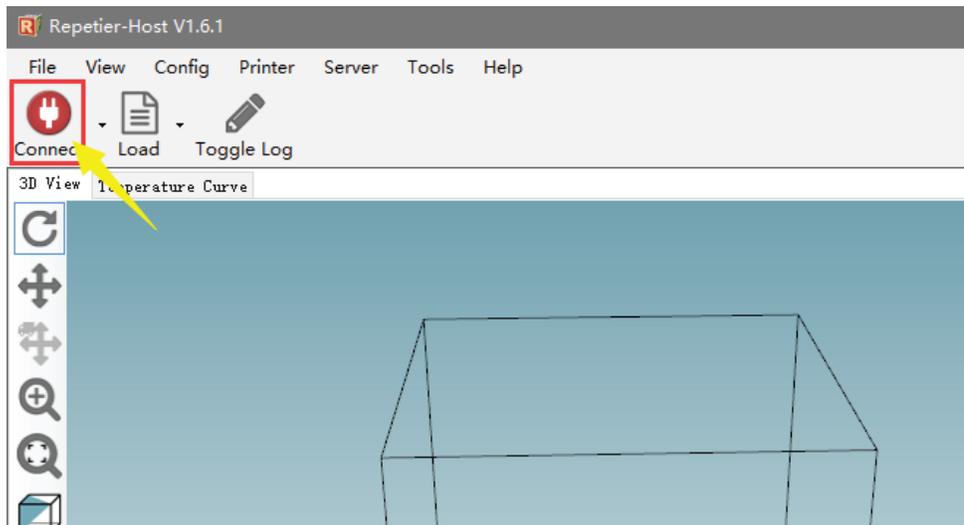
Software Installation



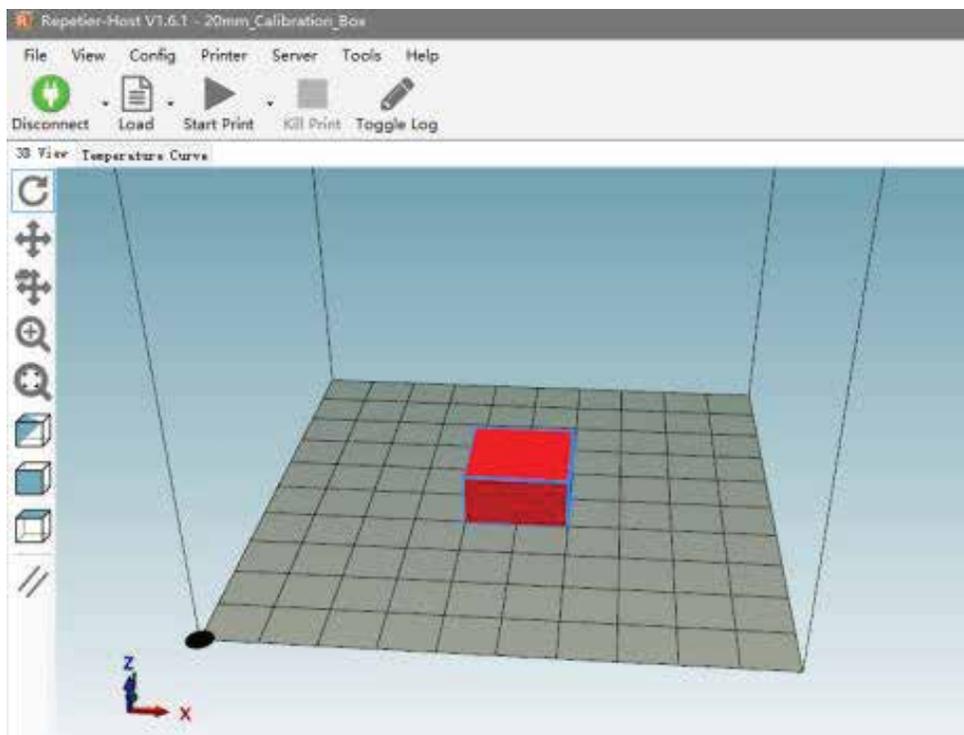
Connect to Printer

After setting up the parameters you can connect your PC to the 3D printer.

Click "Connect" to connect your computer to the 3D printer. When the connection is successful, the button will turn green.

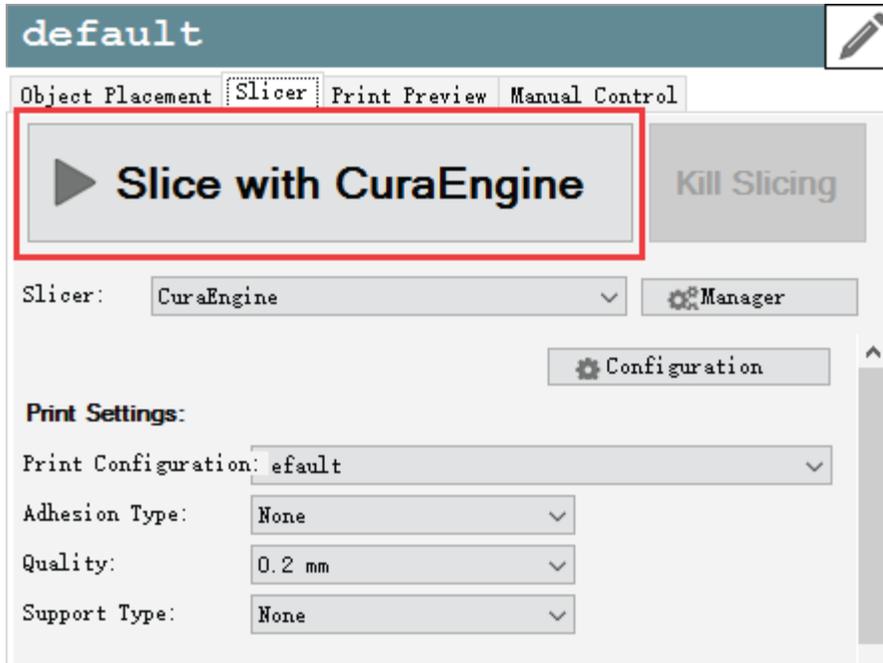


Once you are connected, load a 3D file. www.thingiverse.com is a great place to find test files to print - and they're all free! Find a file, then using Repetier, load the file. You will see the file represented in the 3D window of Repetier.



Slice & Print

Go to the Slicer tab and slice using either Cura or Slicr.



Once slicing it finished, you can begin printing.