

EN/CN - A04

AD5X Quick Start Guide

≡ 快速启动指南 ≡

**WARNING
注意事项**

1. Please refer to this Guide for initial printer setup.
2. Hot! Avoid touching the heating nozzle in operation.
3. Moving parts in the printer may cause injuries. Do not wear gloves or other sources of entanglement in operation.

1. 请参照本指南完成打印机的初始准备。
2. 高温危险！打印机喷嘴在工作时会被加热，操作时请避免接触！
3. 可动部件可能会造成卷入挤压和切割伤害。操作机器时请不要佩戴手套或缠绕物。

**Safety Notice
安全提示**

Do not power on the printer until installation is completed.
请勿在打印机安装完成之前通电。

**LEGAL STATEMENT
法律申明**

Users are not authorized to make any modifications to this Quick Start Guide. Flashforge shall not be held responsible for any safety incidents resulting from the disassembly or modification of the equipment by the customer. No one is allowed to modify or translate this Guide without Flashforge's permission. This Guide is protected by copyright, and Flashforge reserves the right of the final interpretation of this Guide.

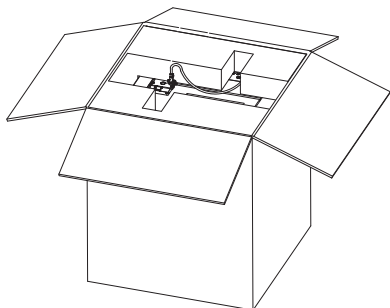
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Unboxing Instructions

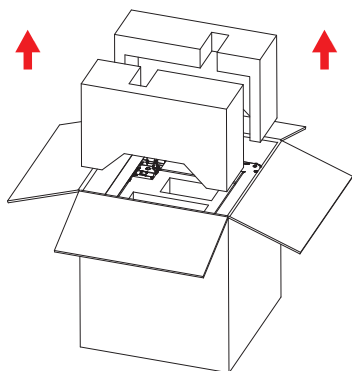


Scan for the unboxing video

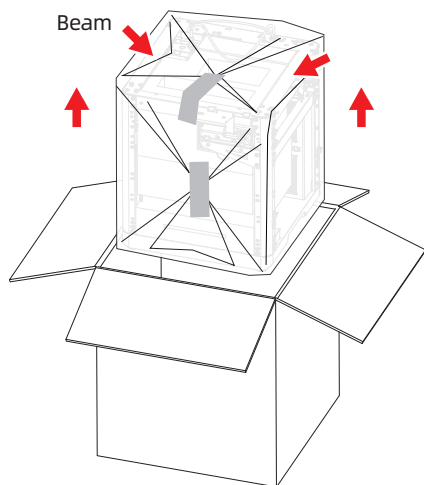
1. Open the box.



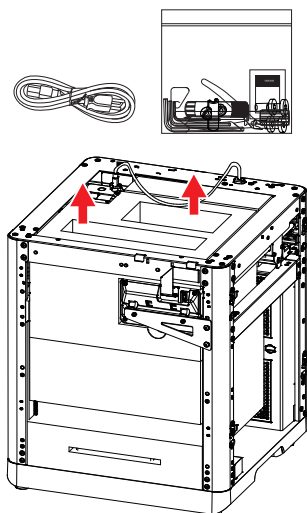
2. Remove the top foam, Quick Start Guide, and After-sales Service Card.



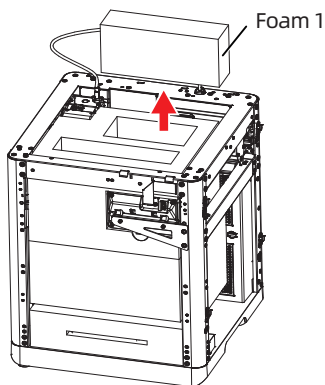
3. Grasp the top left and right beams of the printer with both hands, lift the printer out and place it on a level surface. Then, remove the packaging bags and tapes.



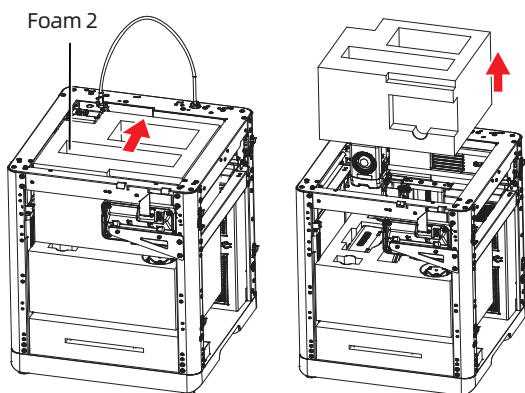
4. Remove the power cord and toolkit from the chamber protective foam.



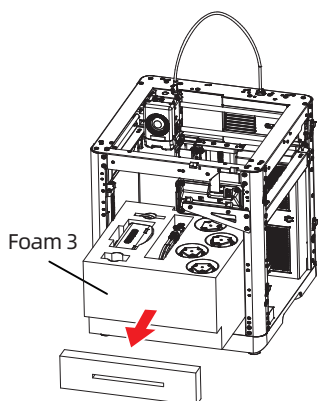
5. First, remove Foam 1.



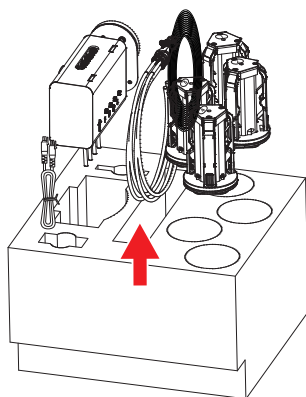
6. Push Foam 2 backward and pull it upward to remove.



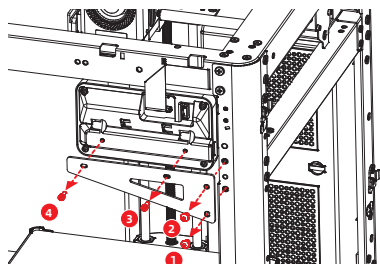
7. Pull out Foam 3.



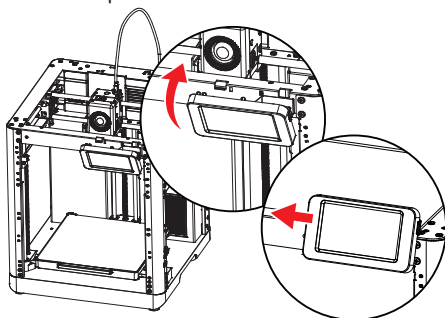
8. Take out the components inside the foam, including: 4-color module (IFS), IFS connection cable, mounting plate, 4-in-1 guide tube, filaments, and spool holders.



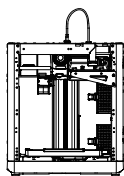
9. Remove the screws in numerical order. Then, remove the metal plate.



10. Tilt the screen upward at an angle (about 30°), and push it to the left in the direction of the arrow to lock it in place.



Packing List



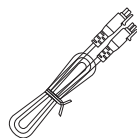
3D Printer



Filament*4



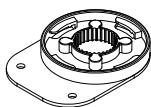
Power Cord



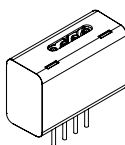
IFS Connection Cable



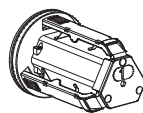
Quick Start Guide



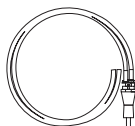
Mounting Plate



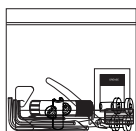
4-Color Module (IFS)



Spool Holder*4

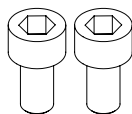


4-in-1 Guide Tube

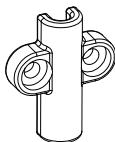


Toolkit

Toolkit Contents



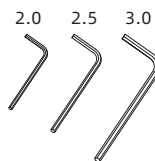
Screw M3×6 *6



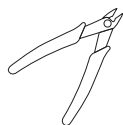
Cable Clip



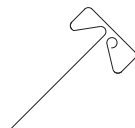
Glue



Allen Wrench



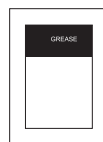
Diagonal Pliers



Unclogging Pin Tool

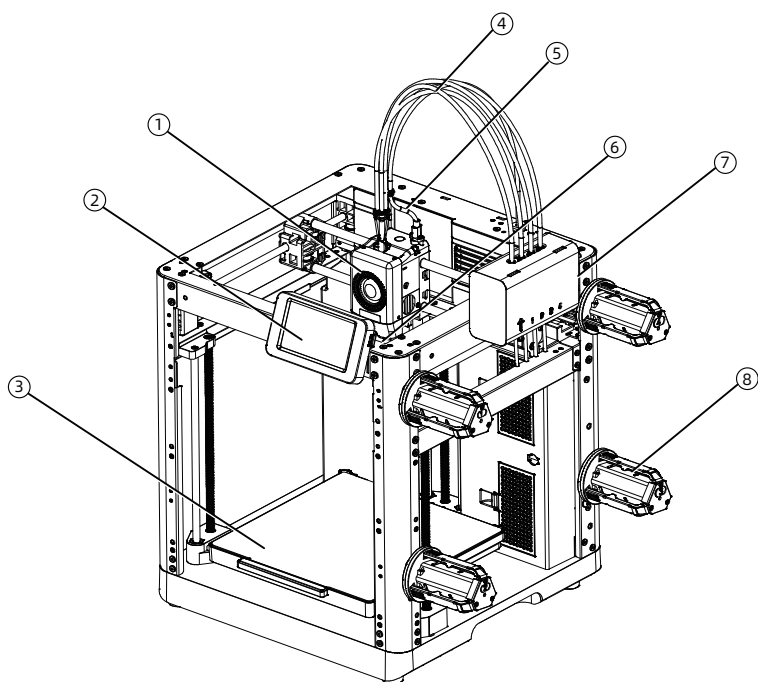


Phillips Screwdriver

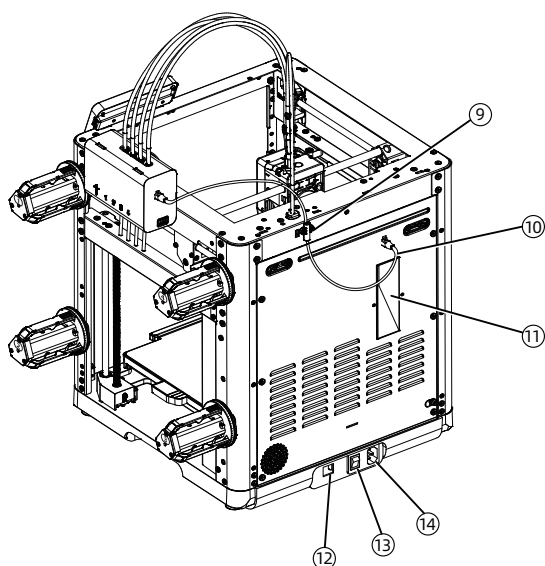


Grease

Printer Components

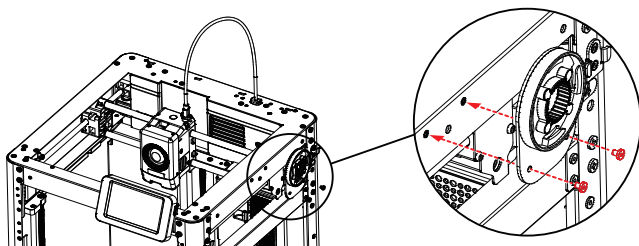


1. Extruder
2. Display Screen
3. Build Plate
4. 4-in-1 Guide Tube
5. Extruder Cable
6. USB Port
7. IFS Module
8. Spool Holder
9. Cable Clip
10. IFS Connection Cable
11. Waste Outlet
12. Ethernet Port
13. Power Switch
14. Power Port

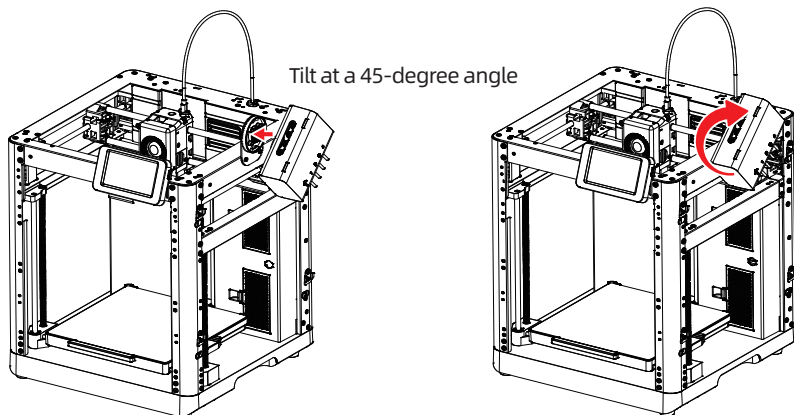


4-Color IFS Module

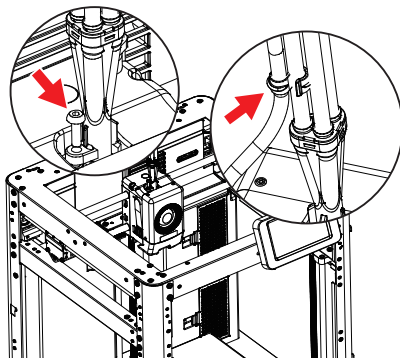
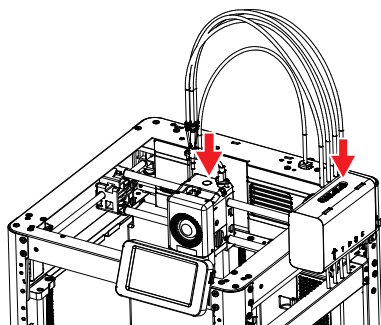
1. Secure the mounting plate to the side of the device using two M3×6 screws.



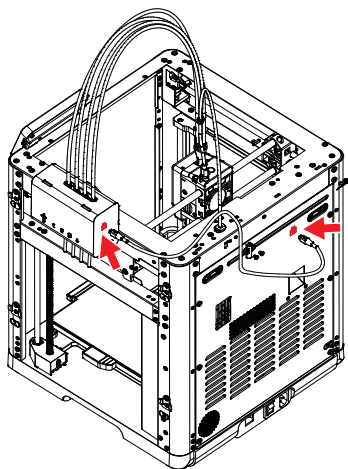
2. Tilt the IFS module at a 45-degree angle against the mounting plate as shown, and then rotate it 45 degrees clockwise to lock it into place. After installation, the four short guide tubes of the IFS module should face downward.



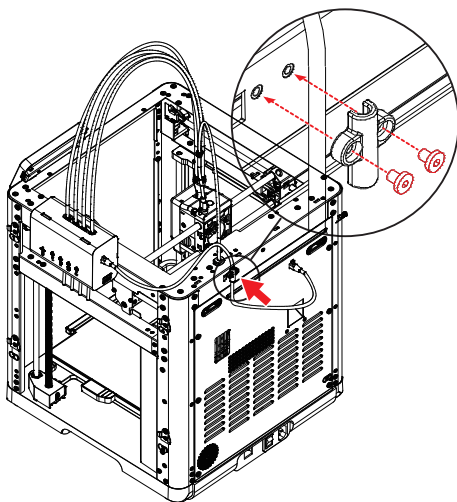
3. Insert the guide tubes into each channel of the IFS module. There's no need to follow a specific order for the channels. Connect the other end to the extruder.
4. Secure the 4-in-1 guide tube with the M3*6 screw. Connect the extruder cable and the guide tube together through the buckle.



5. Connect the IFS cable to the four-color module and the corresponding port on the back of the device.



6. Secure the cable clip with two M3x6 screws.

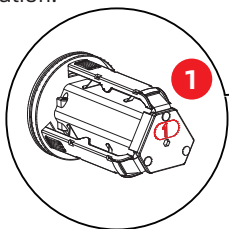


7. Snap the spool holders onto the side mounting clips and press down to secure.

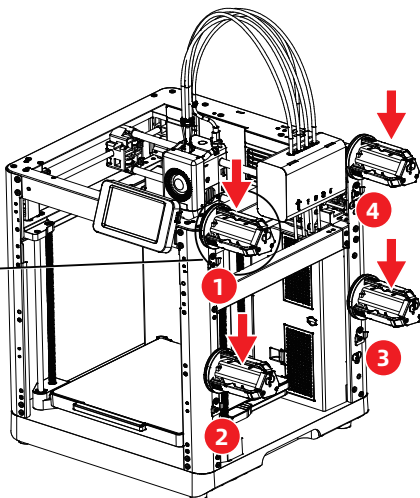
Note

During operation, filaments on both sides have different retraction directions. Therefore, the spool holders must be installed according to their corresponding numbers. Both the spool holders and the IFS channels should be installed according to the numbered positions shown in the figure.

The spool holders have numbered labels that correspond to the numbers on the printer for proper installation.



The spool holders support spools with an inner hole diameter ranging from 52 to 58 mm.



Unlock the Build Plate

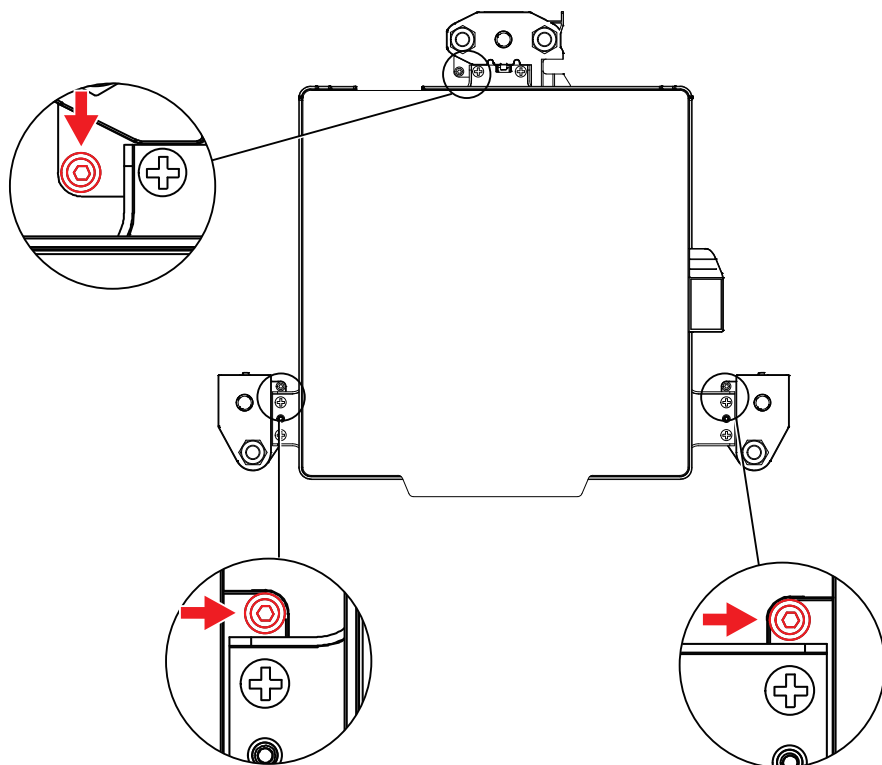


Note

Please ensure the bed has been cleared up!

Please use a 2.5mm Allen wrench to remove the three screws which lock the build plate (as indicated by the arrows).

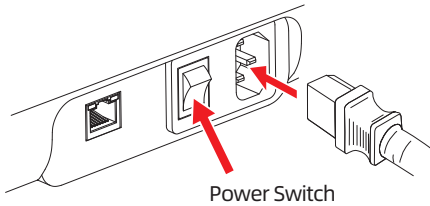
*This is a top-down view.



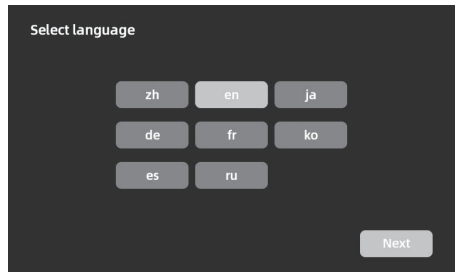
First Print

* The interface layout may change whenever there is an upgrade of firmware.

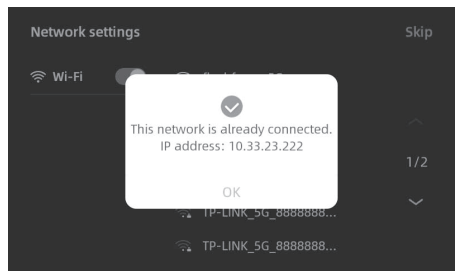
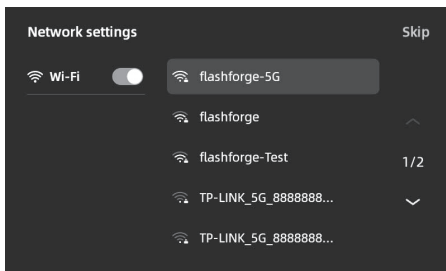
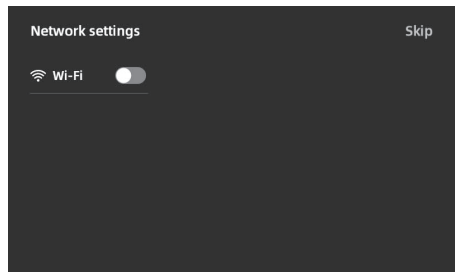
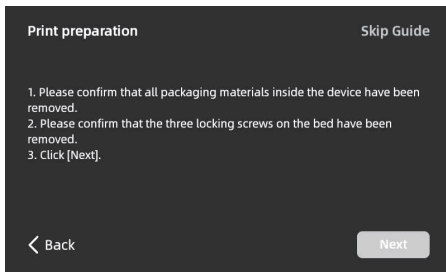
1. Plug in the power cord, turn on the power switch, and wait for the screen to respond.



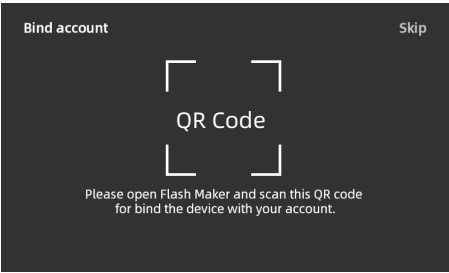
2. Following the guide on the screen, select the language.



3. Turn on the Wi-Fi switch and connect to the network following the instructions. A successful connection notification will pop up once connected.



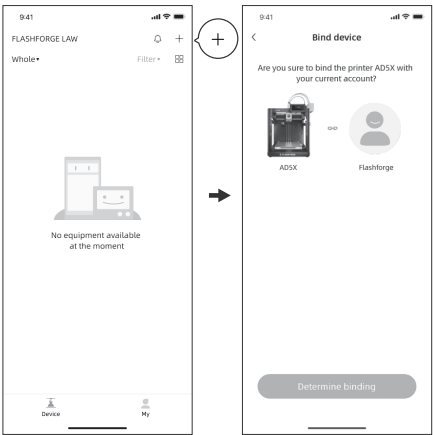
4. Bind the printer following the instructions. (Note: If skipped, binding can still be done later on the printer.)
- a. After clicking [OK], the QR code page will appear.



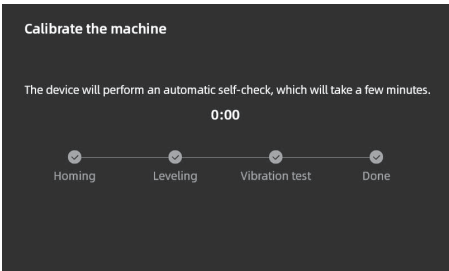
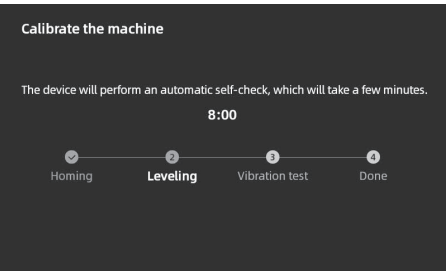
- b. Download Flash Maker by scanning the QR code (see right) or from the app store, register your Flashforge account, and log in.



- c. Use Flash Maker to scan the QR code on the printer screen to bind the printer to your account. (Note: Default printer name and location are set upon leaving the factory; after completing the startup, you can customize the printer name and location in the settings.)

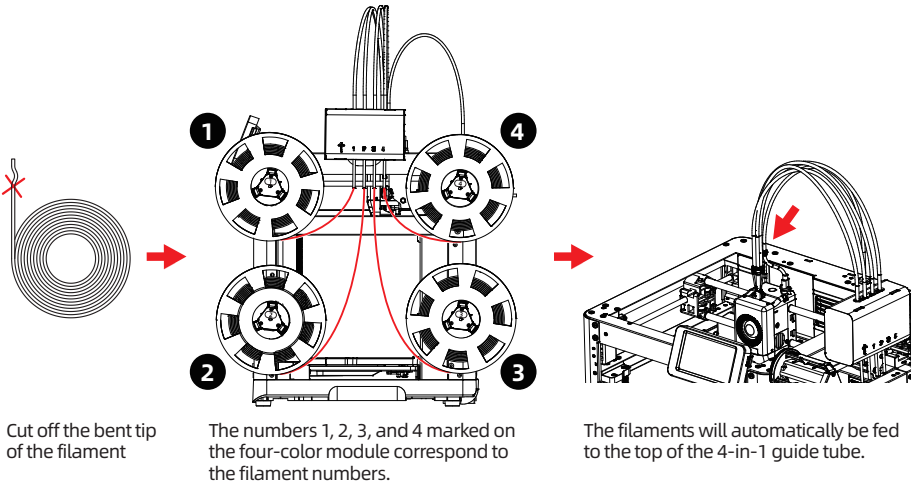


5. Click [Next] and the machine will perform the first calibration. Vibrations and noise during calibration are normal. (Note: Please keep the machine on a stable surface and do not move it during calibration.)

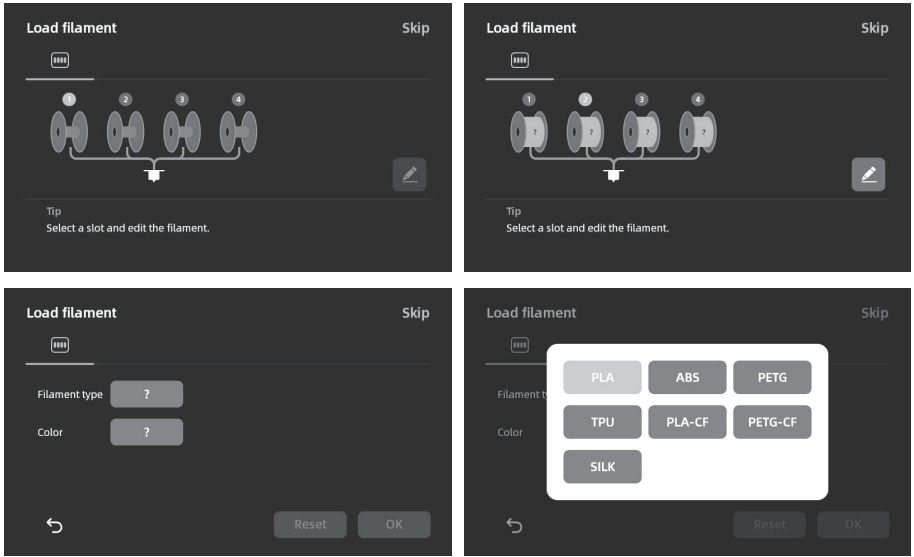


6. Load filament following the on-screen instructions:

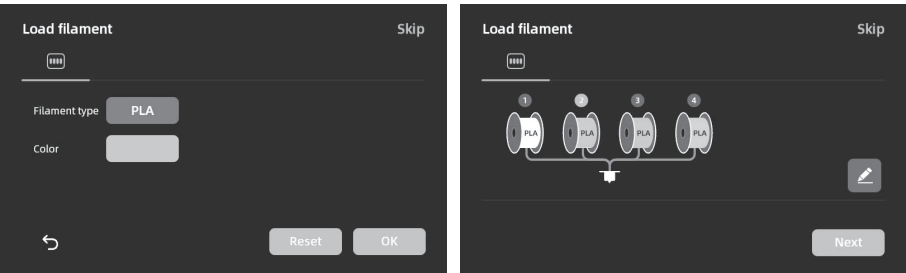
- a. Cut off the bent part of the filament end. Place the filament spools on the spool holders and insert the four filaments into the 1/2/3/4 inlets according to the direction indicated below. Thread them through the feed roller, and the device will automatically detect the filaments and feed them into the guide tubes one by one. The screen will display "Filament auto-loading, please wait...".
(Note: The small spool provided is for testing the first model only. It is recommended to load full spools directly.)



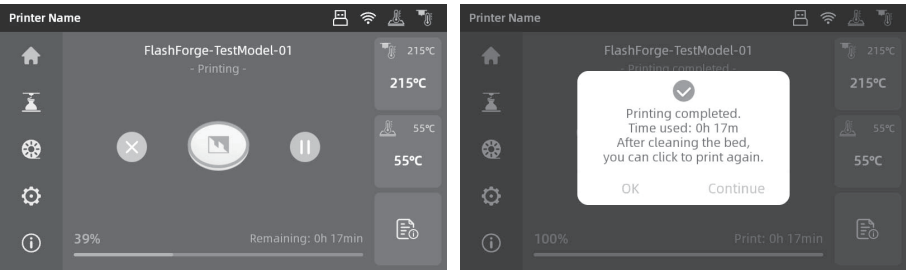
- b. Edit filaments: After loading the filaments, select channels 1-4 individually, click [], and select the corresponding filament type and color. For the first use, please select PLA.



- c. You may apply a thin layer of glue to the print bed. Please apply it evenly over the entire surface.
Note: Applying glue helps improve the adhesion.
- d. Click [Next], and the device will start printing the built-in file (configured for PLA material).



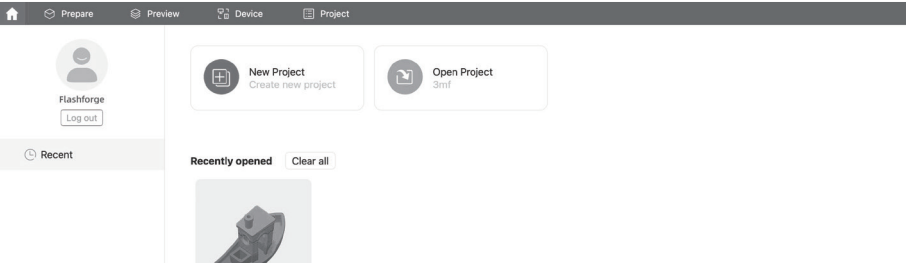
7. After printing is completed, please remove the model and clean the print bed.



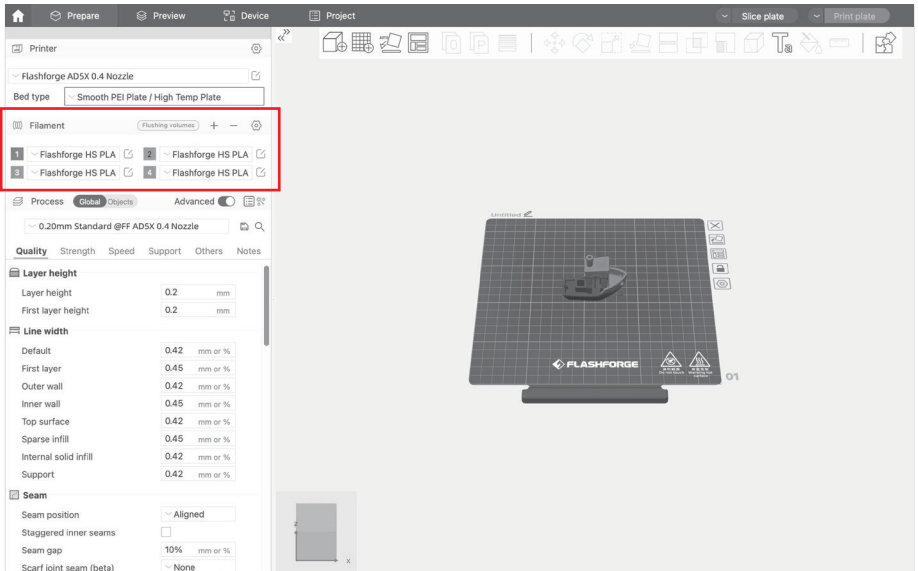
Orca-Flashforge Instructions



Download Orca-Flashforge from:
<https://flashforge.com/blogs/download-software/software>

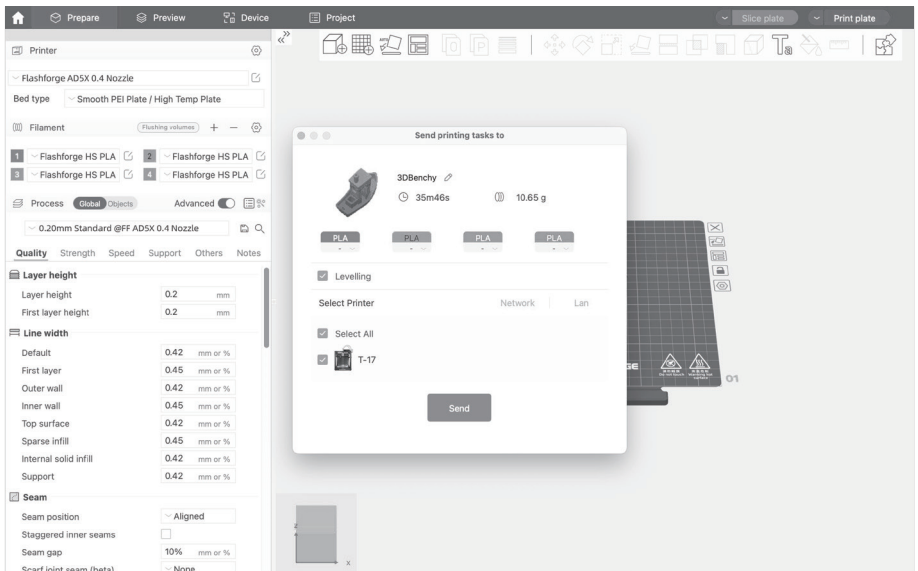


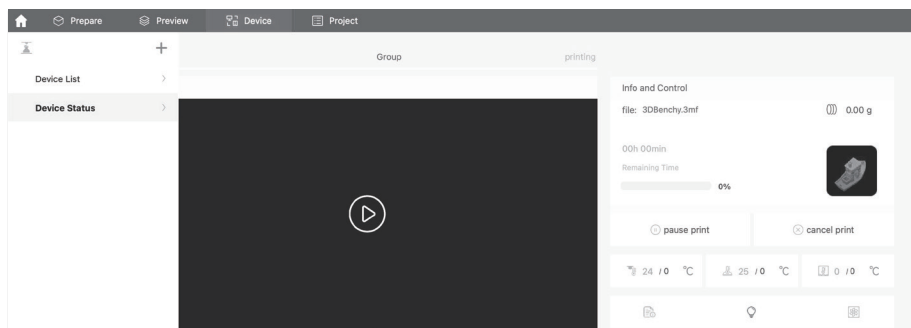
Log in to Orca-Flashforge using your Flashforge account. Create a new project or open an existing one. *Orca-Flashforge and Flash Maker share the same account.



First, select the printer as AD5X. If only one filament is shown, please add filaments until you have four before importing your multi-color model. Import your model, slice it, select your printer, and send it to print.

*It is recommended to select bed leveling when sending the print.





Monitor your print progress remotely on the device interface and pause/stop the print if needed.
 *You can only see the live view if a camera is installed. (AD5X does not come with a camera by default.)

(For details and tutorials on software usage, please refer to the User Guide or Flashforge Wiki.)

Parameters

Device Name	AD5X
Extruder Quantity	1
Printing Precision	±0.1mm (testing based on 100mm cubes)
Positioning Accuracy	X/Y-axis: 0.0125mm, Z-axis: 0.0025mm
Layer Thickness	0.1-0.4mm
Build Volume	220 x 220 x 220mm
Nozzle Diameter	0.4mm (default), 0.25/0.6/0.8mm (optional)
Printing Speed	10-300mm/s
Max Acceleration	20000mm/s ²
Max Travel Speed	600mm/s
Max Extruder Temp	300°C
Power Supply	Input: AC 100~120V/200~240V, 50/60Hz, 650W
Device Dimensions	363 x 363 x 413mm (excluding the display screen and spool holder) 363 x 402 x 448mm (including the display screen, excluding the spool holder)
Net Weight	11.4kg
Connectivity	USB/Wi-Fi/Ethernet
Operating Temp	15-30°C
Compatible Operating System	Windows 7/8/10/11; Mac OS: support version 10.9 or later
Slicing Software	Orca-Flashforge/Orca Slicer
Max Bed Temp	110°C
Leveling Method	One-click auto leveling
Filament Run-out Reminder	√
Power Loss Recovery	√
Smart Touch Screen	4.3-inch
Build Plate	PEI steel sheet



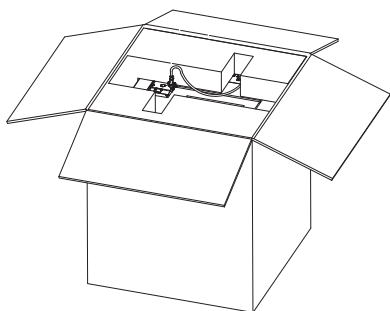
For more product information, please visit our official website.
www.flashforge.com - [Support]

产品开箱

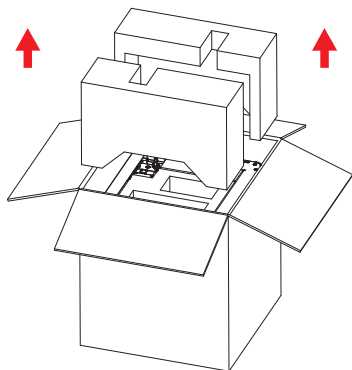


可扫二维码查看开箱视频

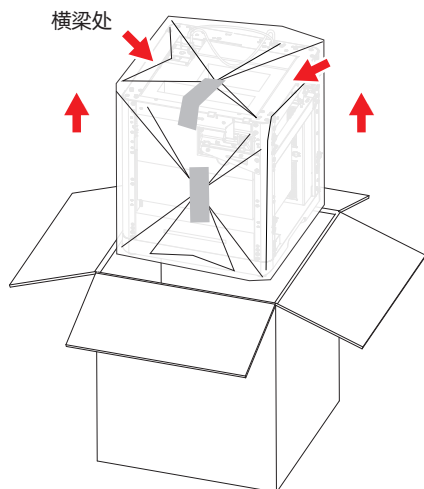
1. 打开纸箱。



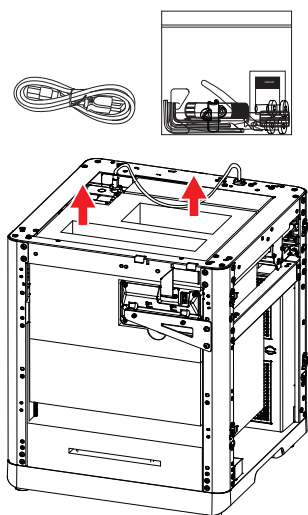
2. 取出上方固定泡棉以及快启售后服务卡。



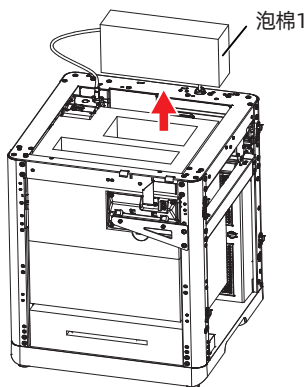
3. 双手可抓握机器顶部左右两侧横梁位置，取出机器放到水平桌面，去除包装袋以及胶带。



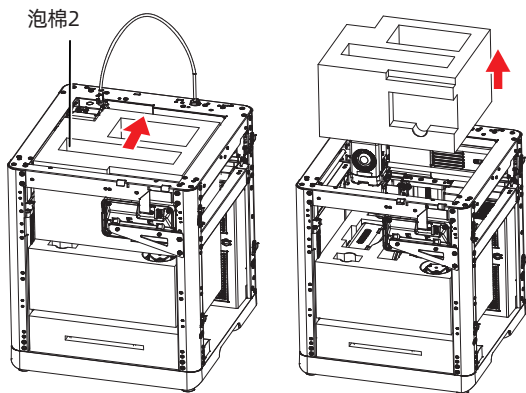
4. 取出腔体保护棉内的电源线和工具包。



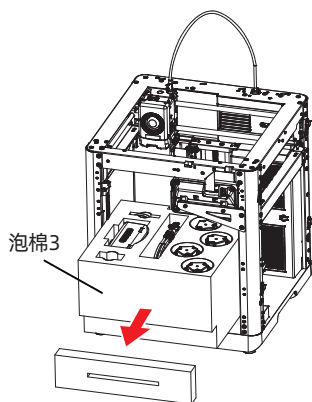
5. 先取出侧面泡棉1。



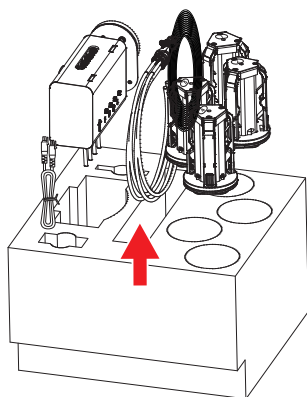
6. 向后推动泡棉2，向上取出泡棉2。



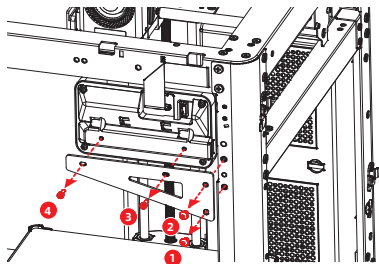
7. 向外抽出下部泡棉3。



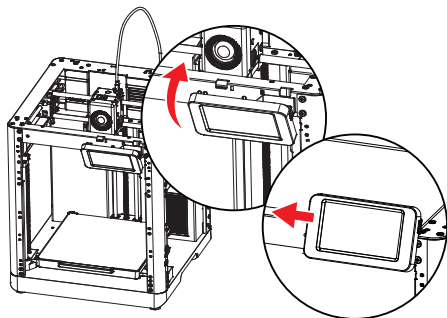
8. 取出泡棉内的零件，包含如下：四色模块(IFS)，IFS 连接线，安装固定板，四合一导丝管，4小卷耗材，4个耗材架。



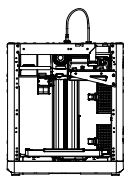
9. 按照数字顺序依次取下螺丝，然后取下支撑钣金件。



10. 向上翻转一定角度(约30度)，将显示屏按箭头方向向左推动，将其与打印机卡扣锁紧。



装箱清单



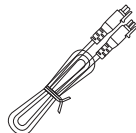
3D打印机



耗材*4



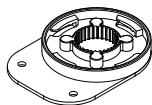
电源线



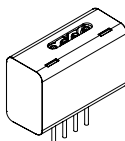
IFS连接线



快速启动指南



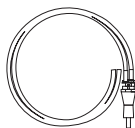
安装固定板



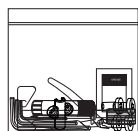
四色模块 (IFS)



耗材架*4

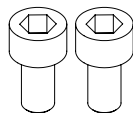


四合一导丝管

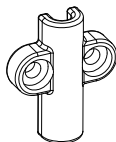


工具包

工具包清单



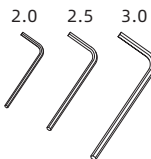
M3×6-6颗



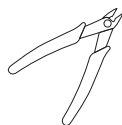
压线扣



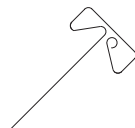
水洗胶



内六角扳手



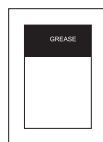
斜口钳



通针

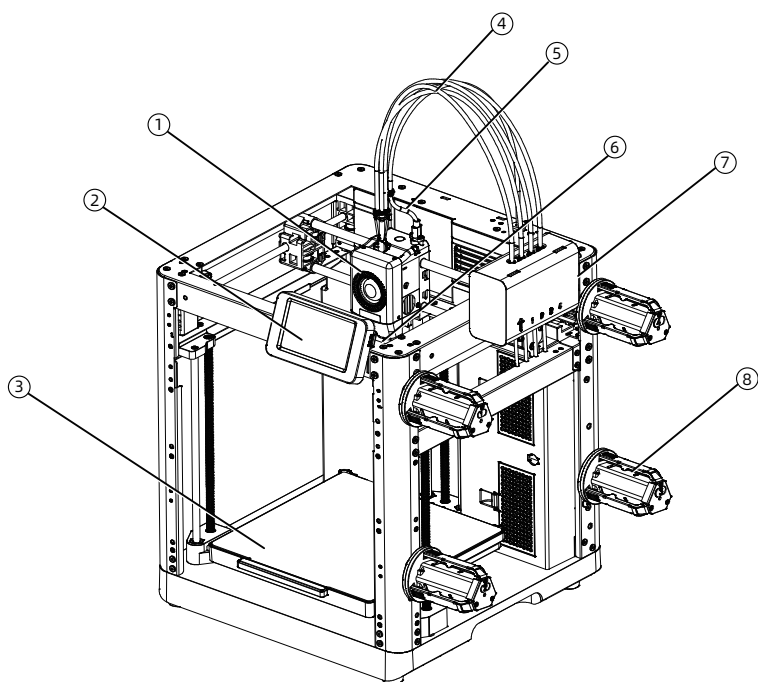


十字螺丝刀

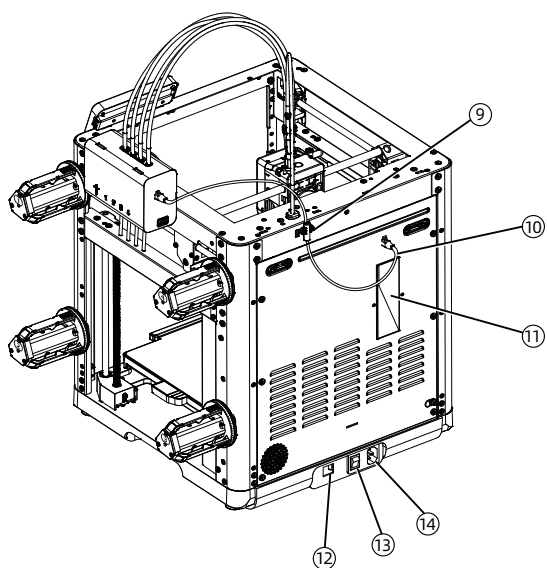


润滑脂

部件介绍



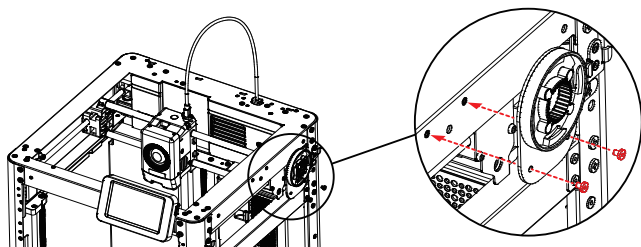
- 1. 喷头
- 2. 显示屏
- 3. 打印平台
- 4. 四合一导丝管
- 5. 喷头线
- 6. USB接口
- 7. IFS组件
- 8. 耗材架



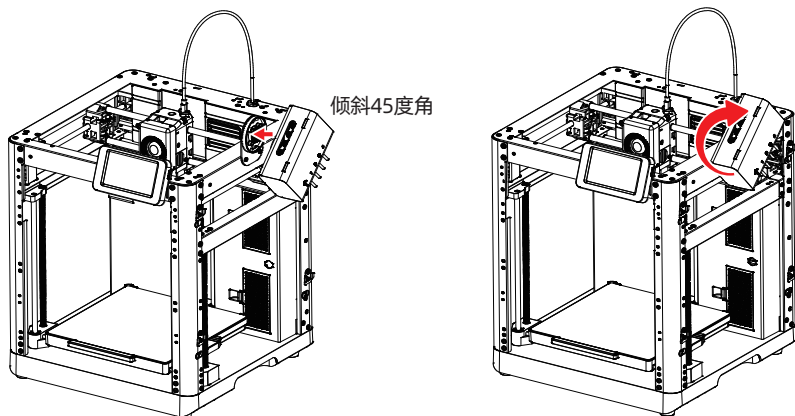
- 9. 压线扣
- 10. IFS模块连接线
- 11. 排料口
- 12. 网线接口
- 13. 电源开关
- 14. 电源接口

四色模块IFS

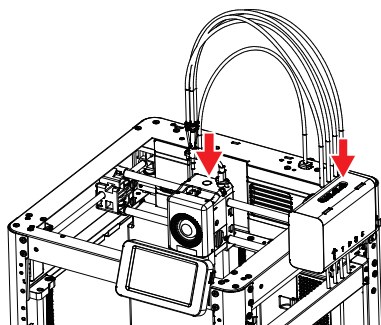
1. 使用2颗M3*6螺丝将安装固定板固定在设备侧面；



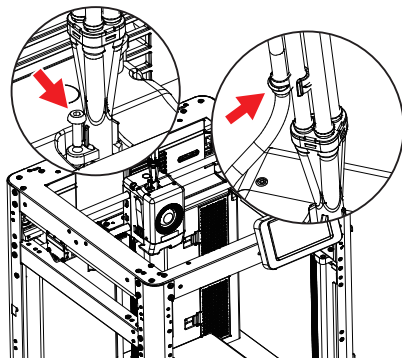
2. 安装IFS四色模块，如图所示，倾斜45度角靠上固定板，向右旋转45度，卡在固定板上。安装完毕后的IFS 4根短的导丝管在下方。



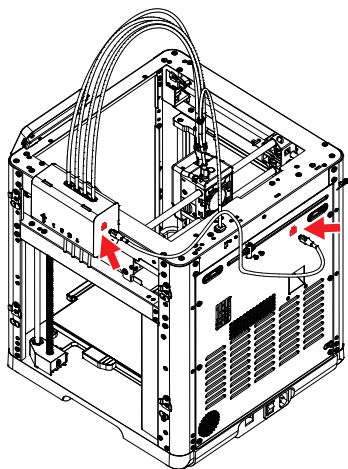
3. 将导丝管插入至IFS的各个通道口，此处导管无需区分通道口编号顺序。将另一端插入至喷头。



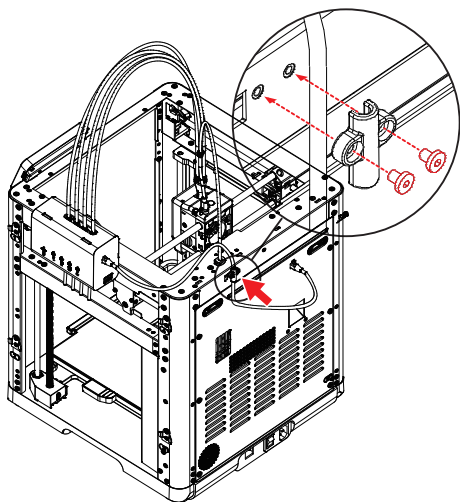
4. 使用M3*6的螺丝固定住四合一导丝管。将喷头线与导丝管通过卡扣连接在一起。



5. 连接IFS数据通讯线，将连接线分别插入四色模块与设备背部的端口。



6. 用2颗M3*6螺丝锁住压线扣。

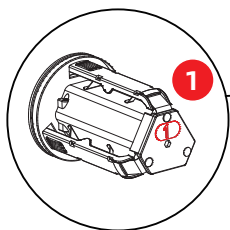


7. 安装耗材架，将耗材架扣到侧面的安装卡扣上，向下扣住卡扣。

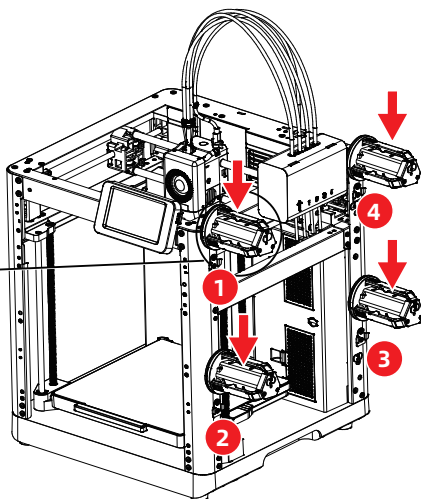
⚠ 注意事项

在设备运行过程中，位于两侧的耗材回卷方向不同，因此安装耗材架需按序号对应安装。耗材架和IFS丝料输入通道需按图示序号位置安装。

耗材架上有数字标贴
和机器上数字对应安装



丝料架支持内孔直径
52~58mm范围的料盘

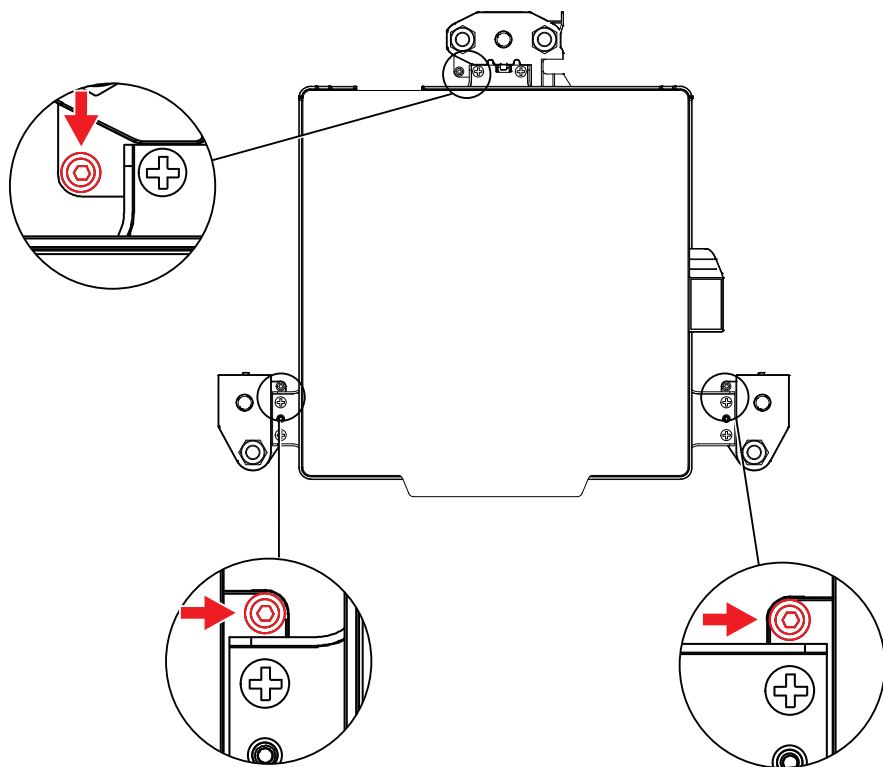


解锁平台

⚠ 注意事项 请确认打印平台无异物!

用2.5mm内六角扳手取下图示中的3颗螺丝（可参照机器上箭头标识），解锁打印平台。

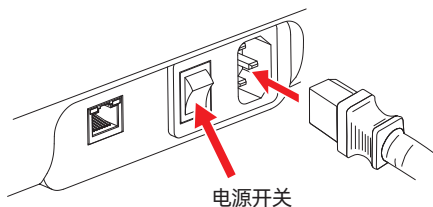
*该视图为俯视图



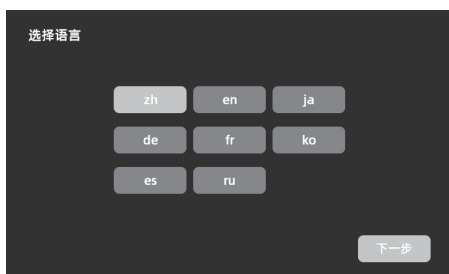
首次打印

* 固件不定期更新，本快启不一定为最新UI界面，UI界面请以实际为准。

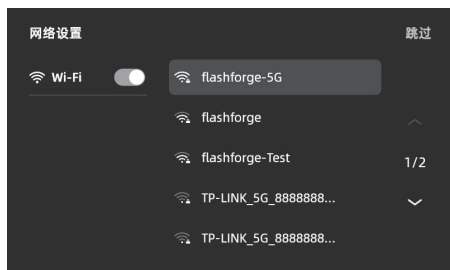
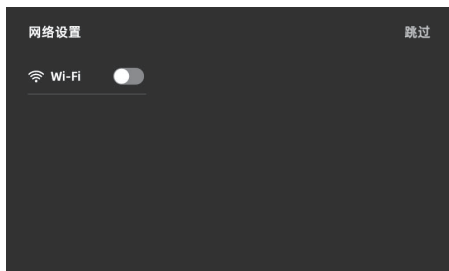
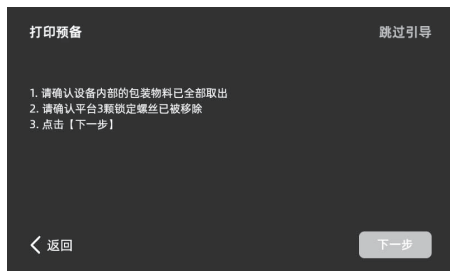
1. 插入电源线，打开电源开关点亮屏幕。



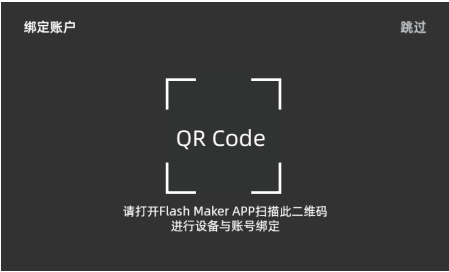
2. 根据屏幕上的开机指引完成界面语言选择。



3. 根据引导打开WiFi开关连接网络，连接成功后会出现提示弹窗。



4. 根据引导绑定打印机。（注：此步骤若跳过，后续仍可在设备上操作绑定。）
- a. 点击【确定】后出现打印机二维码页面。



- b. 扫码或通过手机应用商城下载 Flash Maker 手机应用，注册您的闪铸账号并登录。



- c. 用Flash Maker手机应用扫描打印机屏幕上的二维码，将打印机与您的账号绑定。（注:设备出厂时默认设备名称与位置；开机指南完成后，可在设备中自定义设备名称与位置）

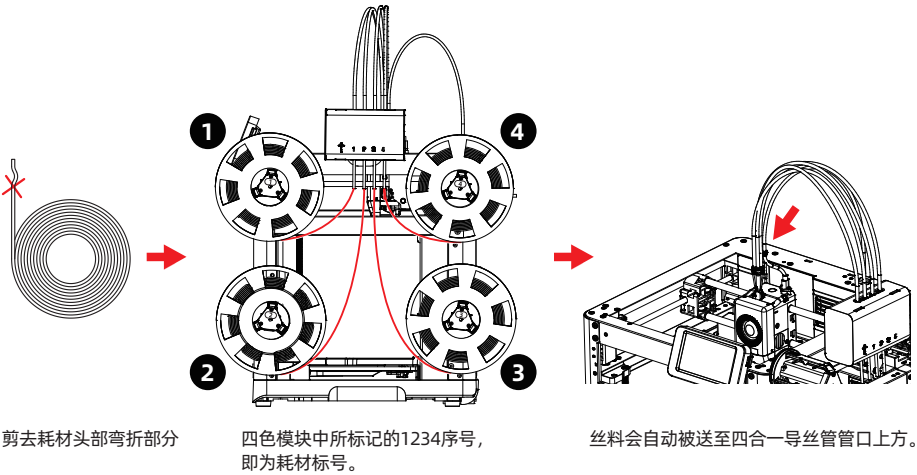


5. 点击[下一步]，机器进行首次校准。校准过程中出现震动和噪音属于正常现象。（注：请将机器放置于稳定的平台面，且校准过程中请勿移动机器。）



6. 根据屏幕开机指引完成耗材安装进丝操作：

- a. 剪去耗材头部弯折部分，将丝料盘放到耗材支架上，按如图耗材进料方向将4个耗材分别插入1-2-3-4 进料口，穿过送丝轮，设备将检测到丝料，并逐个自动送入导管内，屏幕会主动弹出“丝料自动装载中”的提示。
(注：附赠的小卷耗材，仅供测试首个模型使用，建议直接安装整卷耗材)



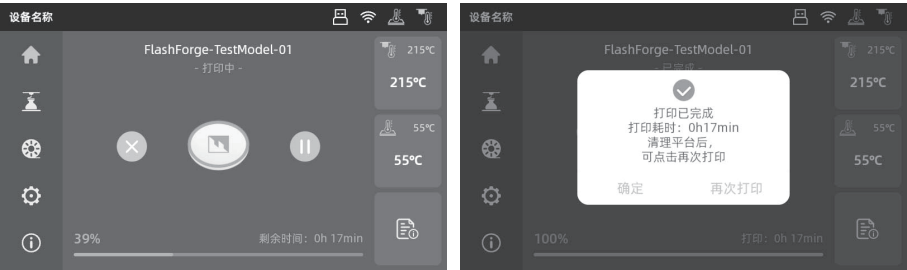
- b. 编辑耗材：丝料装载后，分别选中1-4号耗材通道，点击编辑  按钮，选择对应的耗材类型与颜色；首次使用请选择PLA。



- c. 可以在打印平台上涂一层胶水，请全幅面涂抹均匀。注：涂抹胶水有利于改善模型粘附。
- d. 点击[下一步]，机器开始首次打印内置文件（该文件的配置参数使用的材料为PLA）。



7. 打印完成后，请取下模型，清理平台。



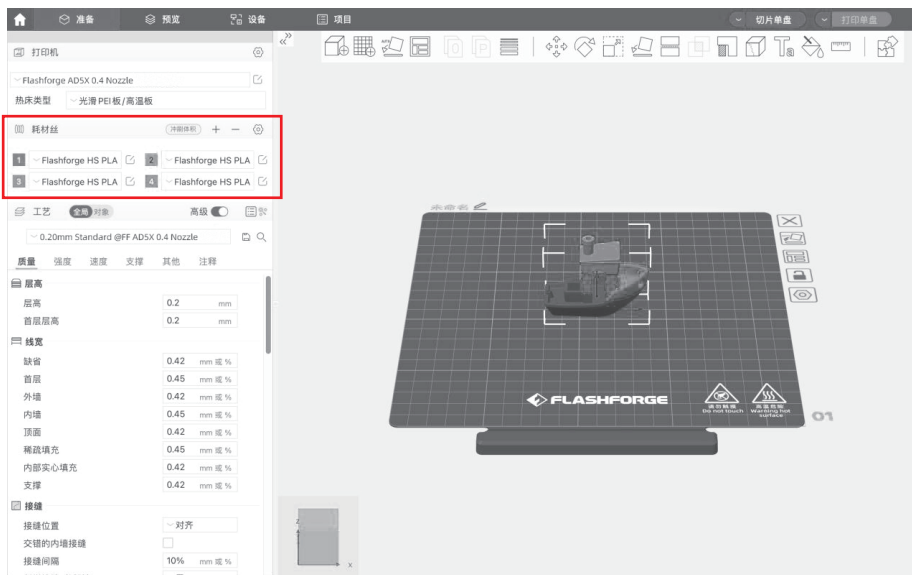
Orca-Flashforge 切片软件



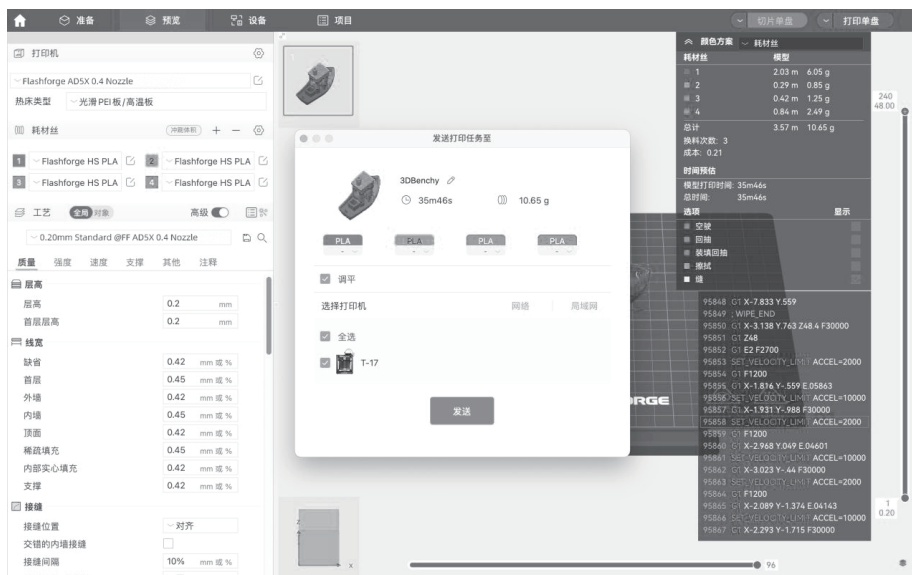
下载Orca-Flashforge:
<https://flashforge.com/blogs/download-software/software>

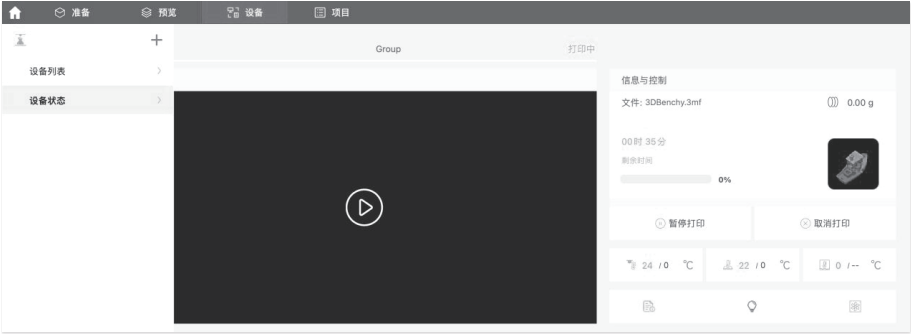


使用您的闪铸账号登陆 Orca-Flashforge。新建或者打开一个项目。
*Orca-Flashforge 和Flash Maker使用同一个账号。



请先选择设备AD5X,若界面中仅显示一个材料,请先将材料添加到4个,再导入多色模型。
 导入模型,完成模型切片后,选择打印机并发送打印。
 *推荐发送打印时选择热床调平。





在设备界面，对您的打印进程进行远程监控，并可在需要时暂停/停止打印。
*只有安装了摄像头，才能看到实时视图。（AD5X出厂默认未装摄像头）
（更多软件说明可查看说明书或者闪铸wiki）

技术参数

设备名称	AD5X
喷头数量	1
打印精度	±0.1mm [以100mm方块为测试基准]
定位精度	X/Y轴：0.0125mm，Z轴：0.0025mm
层厚度	0.1-0.4mm
打印尺寸	220 x 220 x 220mm
喷嘴口径	0.4mm默认[0.6/0.8/0.25mm可选]
打印速度	10-300mm/s
最大加速度	20000mm/s ²
最大移动速度	600mm/s
最高喷头温度	300°C
电 源	输入：AC 100~120V/200~240V，50/60Hz，650W
设备尺寸	363 x 363 x 413mm [不含显示屏、不含料盘支架] 363 x 402 x 448mm [含显示屏、不含料盘支架]
净 重	11.4kg
打印连接方式	USB接口/Wi-Fi/以太网
工作温度	15-30°C
兼容的操作系统	Windows 7/8/10/11；Mac OS支持10.9及以上版本
切片软件	Orca-Flashforge/Orca Slicer
平台最高温度	110°C
调平方式	一键自动调平
断丝提醒	√
断电续打	√
智能触控液晶屏	4.3英寸
打印平台	PEI钢板



更多产品相关资料您可以登陆闪铸官网查看。
www.sz3dp.com - [技术支持]

After-sales Service

≡ 售后服务卡 ≡

Zhejiang Flashforge 3D Technology Co., Ltd.



Service: support@flashforge.com
Suggestions and Complaints: mkt2@flashforge.com



Web: flashforge.com | enterprise.flashforge.com



Address: Floors 2-4, Building B, Huaxing Development Building, No.328 Wen'er Road, Xihu District, Hangzhou City, Zhejiang Province, China

浙江闪铸集团有限公司



服务热线: 400 8866 023



建议与投诉: mkt2@flashforge.com



网址: www.sz3dp.com



地址: 浙江省杭州市西湖区文二路328号华星发展大厦B座2-4楼



Note The one who sells you the printer should be responsible for your after-sales service.

1. Flashforge grants all end-users a 12-month limited warranty for all Flashforge 3D printers (except the Flashforge extruder) and a 3-month warranty for Flashforge FFF Extruder.
2. If Flashforge 3D printer fails during normal and proper use within the warranty period (judged by Flashforge engineers), Flashforge will provide users with free maintenance services or remote after-sales support.
3. The warranty period starts from the outbound date, or starts from the invoice date if clear and confirmed invoice is provided.
4. Flashforge will repair or replace only the defective parts with new or reconditioned parts or products that are functionally equivalent or superior to those originally supplied. If a part is repaired or replaced during the warranty period, the warranty period still remaining for the entire printer will apply to this part.



注意事项

闪铸科技采用谁销售谁服务的原则，如您的3D打印机是在非闪铸官方平台购买，请向您购买的商家获取相关支持

1. 闪铸科技所有3D打印机均为用户提供12个月整机有限质保。其中FFF技术3D打印机的喷头质保时间为3个月。
2. 质保期内若设备出现非人为损坏（由闪铸工程师评定），您将获得免费配件及售后技术支持。
3. 售后服务周期以产品出厂日期为起始。如能提供清晰的发票，则以发票开具日期为起始。
4. 维修零配件可能为非全新配件，但甲方保证配件功能完全正常。维修配件质保时间与其整机质保时间相同。

Parts Excluded from This Warranty

Build Tape / Build Plate / Acrylic Cover / SD Card / USB Stick / USB Cable / Filament / Filament Spool / Glue / Resin Vat / Film / Rinse Bucket / Gloves / Plastic Scraper / Metal Scraper / Brush / Allen Wrench (2.5mm*1/3mm*1/5mm*1) / Stamping Wrench / Tools Bag / Accessories

*FFF extruder kit shall be purchased independently due to upgrading.

WHAT IS NOT COVERED

- ◆ Unable to provide valid After-sales Service Card or Serial No. (Including but not limited to lost, alter or fuzzy cannot be confirmed);
- ◆ FFF commercial printers out of warranty period or over 1000 working hours; FFF consumer printers out of warranty period or over 400 working hours;
- ◆ Damage(s) caused by improperly or incorrectly performed modifications, alterations or repair;
- ◆ Damage(s) due to operation under improper environment (damp, wet or other extreme weather);
- ◆ Exterior scratch or flaw caused by abrasion, aging or normal use;
- ◆ The warranty period of printer or part has expired;
- ◆ Damage(s) caused in service shops unauthorized by Flashforge;
- ◆ Damage(s) caused by improperly installation, use or operation;
- ◆ Damage(s) caused by abuse(overloaded working), misuses;
- ◆ Damage(s) caused by using unauthorized spare parts or poor quality filament (Recommended to use Flashforge filament);
- ◆ Damage(s) caused by using 3rd party software;
- ◆ Damage(s) caused by force majeure (such as a lightning strike, fire, earthquake, floods or any other event beyond human control);
- ◆ Damage(s) caused by using 3rd party parts;



After-sales Service Registration Form

Series No.: _____ Purchase from: _____

Fault Description: _____

Tel.: _____ Contact: _____

Add.: _____

❗ Please fill in this form carefully, cut out this form and mail it back to Flashforge together with the printer, or download this form from **www.flashforge.com**, fill in this form and send it to **support@flashforge.com**. After-sales service shall not be provided without this form.

❗ Please contact your printer's reseller to get After-sales service help if your printer is not purchased on official Flashforge website.

以下配件不列入质保范围

平台贴纸 / 平台金属板 / 平台玻璃板 / 亚克力罩 / SD卡及U盘 / USB线 / 打印耗材 / 丝盘轴 / 溶液盒 / 薄膜 / 打印平台 / 遮光罩清洗盒 / 塑料铲刀 / 金属铲刀 / 刷子 / 清洗手套 / 内六角扳手(2.5mm*1/3mm*1/5mm*1) / 开口扳手 / 工具包及包内工具。

*由于FFF产品喷头会有迭代升级，喷头升级套件需单独购买。

以下情况不在质保范围内

- ◆ 无法提供有效质保卡或序列号(遗失、涂改、模糊无法确认)；
- ◆ 整机及部件已经超过质保有效期；
- ◆ FFF商用设备运行总时长超过1000小时，FFF消费级设备运行总时长超过400小时；
- ◆ 设备曾经在未经闪铸授权的维修店维修；
- ◆ 设备在非产品规定的工作环境下使用而造成的设备故障或损坏；
- ◆ 设备正常磨损、老化或因操作造成的外观划痕或瑕疵；
- ◆ 由于使用非闪铸指定的软件而造成的设备故障或损坏；
- ◆ 由于使用其它品牌部件造成的设备故障或损坏；
- ◆ 由于私自对设备进行改装而造成的设备故障或损坏；
- ◆ 由于错误安装、使用而造成的设备故障或损坏；
- ◆ 由于滥用(包括超出工作负荷)、误用而造成设备故障或损坏；
- ◆ 由于使用低质量耗材而造成的设备故障或损坏(建议使用闪铸官方耗材)；
- ◆ 由于维护不当(受潮、发霉或暴露在极端气候)造成的设备故障或损坏；
- ◆ 由不可抗因素(如火灾、地震、雷击、水灾等)造成的故障或损坏。



售后服务登记表

序列号：_____ 从何处购买：_____

故障描述：_____

联系电话：_____ 联系人：_____

地址：_____

❗ 请务必仔细填写此表，剪下并随机器寄回闪铸科技，或在闪铸官网(官网地址见反面)下载此表发送给support@flashforge.com。
未填写此表将无法进行售后服务。

❗ 如您在非闪铸官方平台购买机器，请直接联系您购买的商家获取售后支持。



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