

ezao

MATRIX M600

LARGE FORMAT CERAMIC 3D PRINTER

QUICK START

快速入门指南

Welcome to the Matrix Ceramic 3D Printer manual.

This manual will guide you through the step-by-step process of assembling your 3D clay printer, as well as provide instructions for your first print.

For your safety, please read the entire manual before operating the machine.

欢迎使用Matrix陶瓷3D打印机手册。

本手册将引导您逐步完成组装3D陶瓷打印机的过程，并为您的首次打印提供指导说明。

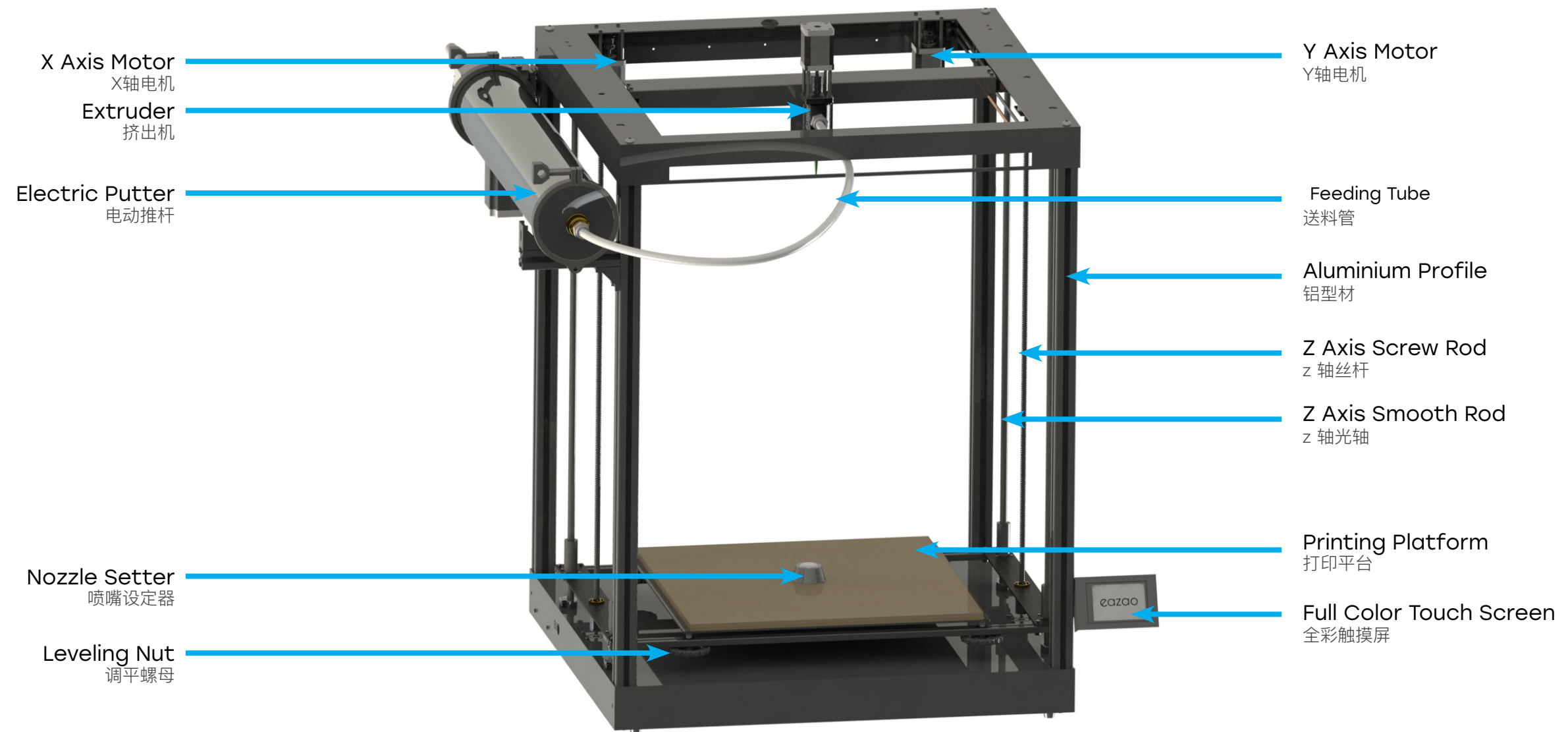
为了您的安全，请在操作机器之前仔细阅读整个手册。

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<https://www.eazao.com>

Introduction

简介



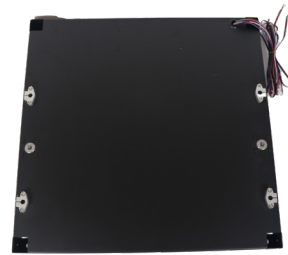
Parameter

参数

Technical Principle/ 技术原理	DIW (Direct Ink Writing)/ 陶瓷无模直写
Molding size/ 成型空间	400 x 400 x 600 mm (L x W x H)/(长 x 宽 x 高)
Cartridge Volume/ 料筒容积	5 L / 9 KG
Layer thickness/ 层厚	0.4 -1mm
Feeding method/ 送料方式	Electric putter+Screw extrusion/ 电动推杆 + 螺杆挤出
Nozzle diameter/ 喷嘴直径	1.6-3.3 mm
Printing speed/ 打印速度	10mm/s - 40mm/s
Supporting materials/ 支持材料	Pottery or porcelain clay, Viscous fluid/ 陶泥、瓷泥等粘滞流体
Operating system/ 支持操作系统	Windows, Mac, Linux
Slicing software/ 切片软件	Cura, Slic3r, Simplify3D etc
Support file format/ 支持文件格式	.STL, .Gcode, .OBJ etc
Interactive mode/ 交互方式	Full color touch screen, SD card, USB connection/ 全彩触摸屏, SD 卡, USB 联机
Input voltage/ 输入电压	100-120Vac/200-240Vac~50/60Hz
Output voltage/ 输出电压	24V/15A Max 360W
Machine size/ 机器尺寸	800 x 1100 x 1000 mm(L x W x H)/(长 x 宽 x 高)
Package dimensions/ 包装尺寸	900 x 800 x 400 mm(L x W x H)/(长 x 宽 x 高)
Package weight/ 包装重量	46KG

Machine Accessories

机器配件



① Base
底座



② Top
顶部



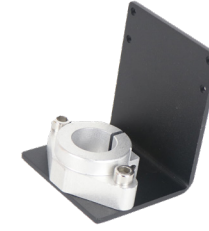
③ Z-axis Printing Platform
Z轴打印平台



④ Aluminium Profile*4
铝型材



⑤ Screw Rod*2 & Rod*4
丝杆*2 & 光轴*4



⑥ Extruder Holder
挤出机支撑



⑦ Touch Screen
全彩触摸屏



⑧ All metal Extruder
全金属挤出机



⑨ Motor reducer
电机减速器



⑩ 5L Cartridge
5L 料筒



⑪ Cartridge Holder
料筒固定座



⑫ Cartridge Cover
料筒盖子



⑬ Clamp*2
卡箍



⑭ Sealing Ring & Sealing Block
密封圈&密封固定块



⑮ Anti-Rotation Flange
防旋法兰



⑯ Thrust Block
推力块

Machine Accessories

机器配件



⑮ Threaded Push Rod
螺纹推杆



⑯ Motor Reducer Cable
电机减速机连接线



⑰ Putter Hanging Plate
推杆挂板



⑱ Putter Fixing Plate
推杆固定板



⑲ Coupling
联轴器



⑳ Screw Fixed Bearing
丝杆固定轴承



㉑ Bolt Nut Kit
螺栓螺母包



㉒ Clips*2
夹子



㉓ Feeding Tube
送料管



㉔ Nozzle Setter
喷嘴设定器



㉕ USB Data Cable
USB数据线



㉖ Power Cable
电源线



㉗ Allen Key*6
六角扳手*6



㉘ Cartridge Aluminum Profile
料筒铝型材



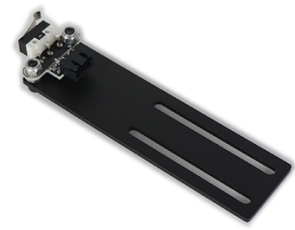
㉙ Cartridge Adapter
料筒转接



㉚ 5L Gasket
5L垫片

Machine Upgrading Accessories (Gifts)

机器升级配件 (赠品)



③① Z-axis side limit
Z轴侧边限位



③② Z-axis side limit cable
Z轴侧边限位连接线



③③ Z-axis side limit bolt
Z轴侧边限位螺栓



③④ Direct Extrusion Connector
直接挤出接头



③⑤ Direct Extrusion Plate
直接挤出板



③⑥ Extruder O-ring
挤出机O型圈



③⑦ ACE Extruder Sleeve
ACE挤出机套筒



③⑧ SD Card Reader
SD卡读卡器

The ③①, ③②, ③③ are upgrade parts for the Z-axis side plan and do not require installation./③①, ③②, ③③零件为Z轴侧边方案升级零件, 无需安装。
The ③④ and ③⑤ parts are direct extrusion upgrade solutions and do not require installation./③④和③⑤零件为直接挤出升级方案, 无需安装。
The ③⑥ and ③⑦ parts are spare parts for the extruder and do not need to be installed./③⑥和③⑦零件为挤出机备用零件, 无需安装。



③⑨ Nozzle*12*
喷嘴*12*



④⑩ Micro SD*
Micro SD卡*



④⑪ Grease*
润滑脂*



④⑫ Needle*
针管*



④⑬ MDF*
密度板*



④⑭ Zip Ties
束线带



④⑮ Tape
胶带



④⑯ Bobbin
绕线管

The inner diameter of the free nozzle is: 1.6, 1.9, 2.3, 2.5, 3.0, 3.3mm./赠送的喷嘴内径为: 1.6、1.9、2.3、2.5、3.0、3.3mm。

*This item may be restricted according to custom policies in certain regions. If you are unable to locate the item in the packaging, we kindly suggest contacting your local retailer for similar products.

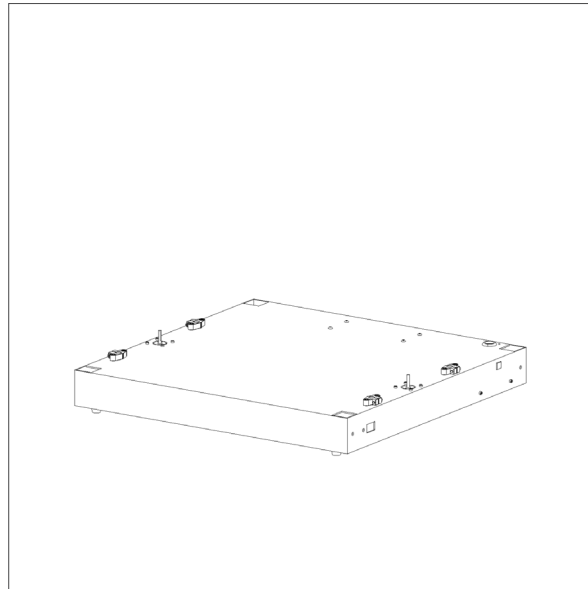
* 这个物品可能根据某些地区的海关政策受限。如果您无法在包装中找到该物品, 我们建议您联系当地的零售商寻找类似的产品。

*The accessories on this page are machine upgrade accessories and are given as gifts. There are differences due to different machine versions. If there are problems such as missing, reissue will not be issued.

* 本页面配件为机器升级配件, 为赠品。因机器版本不同存在差异, 如果缺失等问题, 不予补发。

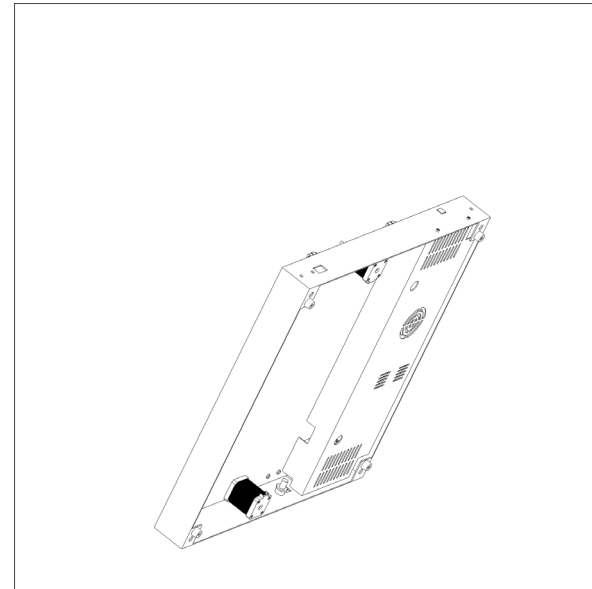
Step 1 - Main Body Assembly

第一步：主体组装



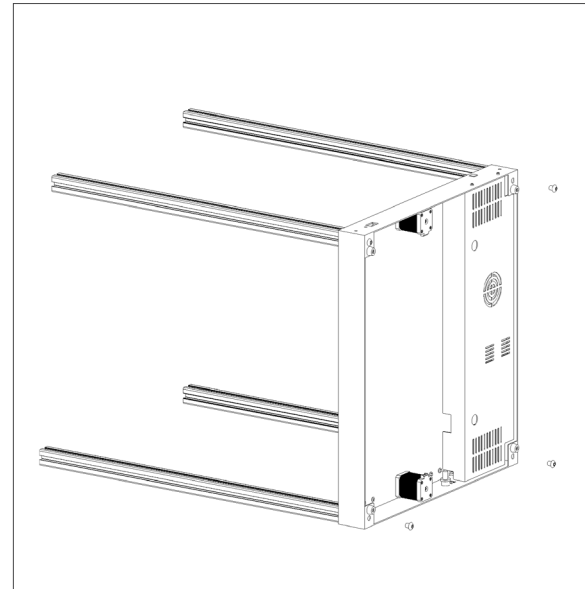
1. Place the base on a flat and even surface.

1. 将底座放在平坦的桌面上。



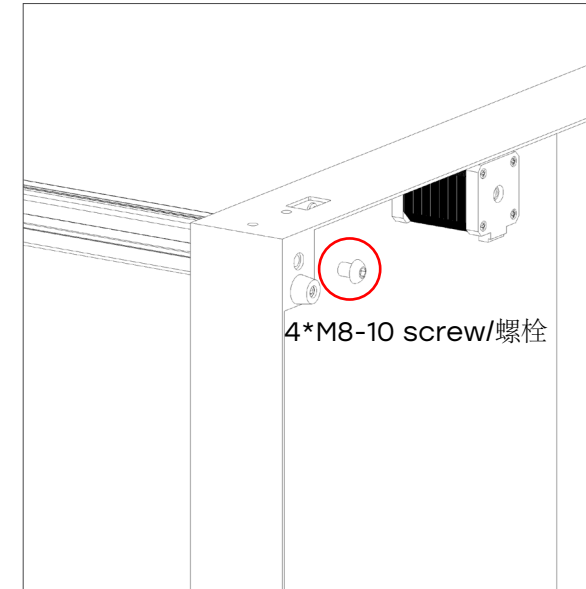
2. Rotate the base by 90 degrees.

2. 将底座旋转90度。



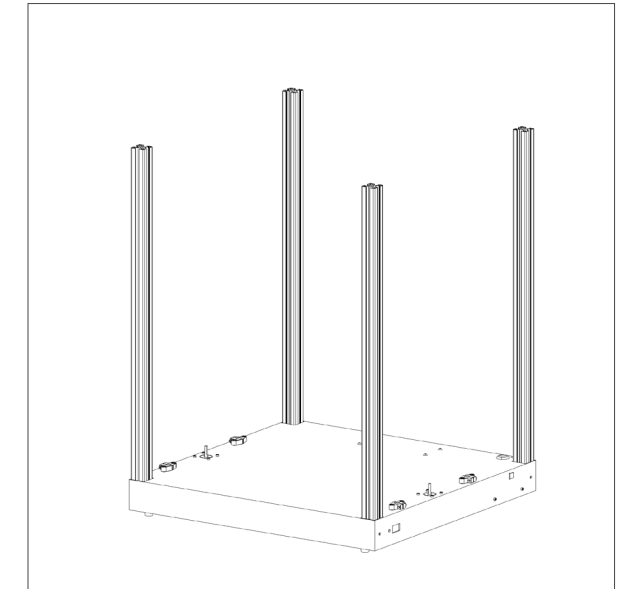
3. Take 4 aluminum profiles from the package.

3. 从包装中取出4根铝材。



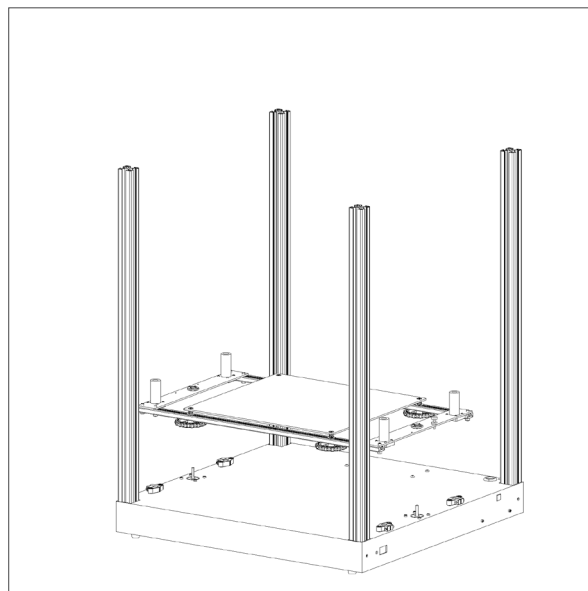
4. Fasten each aluminum profile to the base using 4 M8-10 bolts.

4. 使用4颗M8-10螺栓将每根铝材与底座固定。



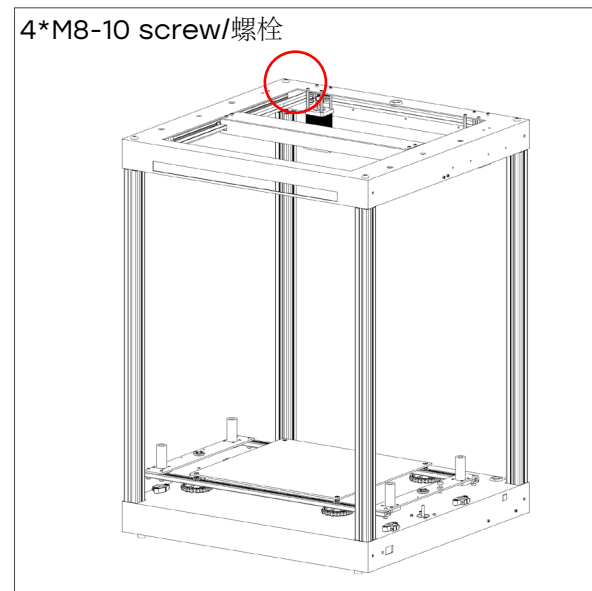
5. Rotate the base back to its original position, facing up.

5. 将底座旋转回正面朝上的位置。



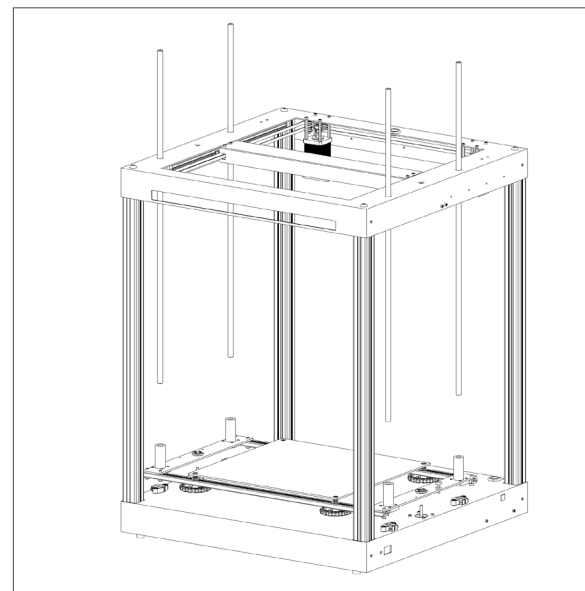
6. Place the Z-axis printing platform in position.

6. 放置Z轴打印平台。



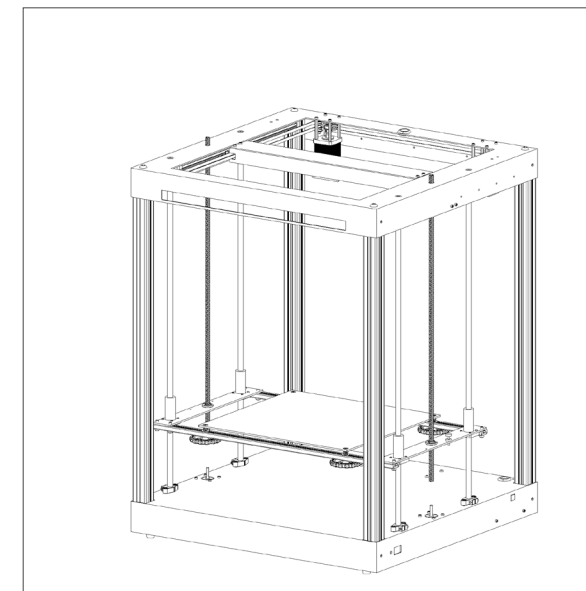
7. Secure the top using 4 M8-10 bolts, ensure that the motors are on the same side as the power switch.

7. 使用4颗M8-10螺栓固定顶部，确保电机与电源开关处于同一侧。



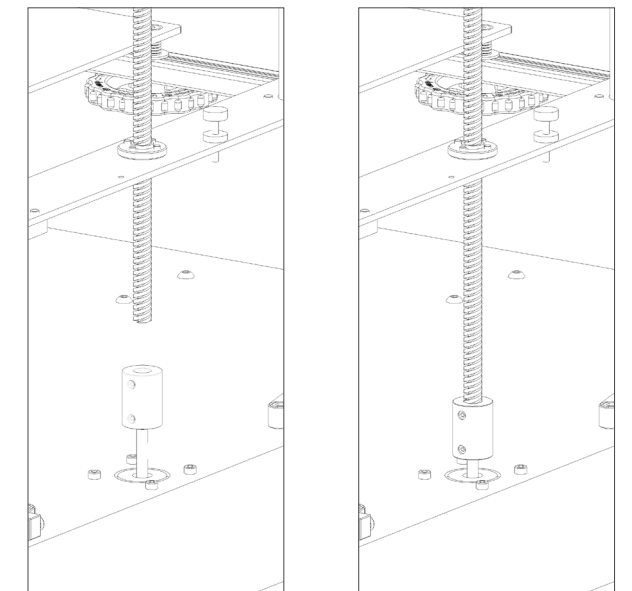
8. Insert 4 Z-axis smooth rods.

8. 安装4根Z轴光轴。



9. Insert 2 Z-axis screw rods.

9. 安装2根Z轴丝杆。

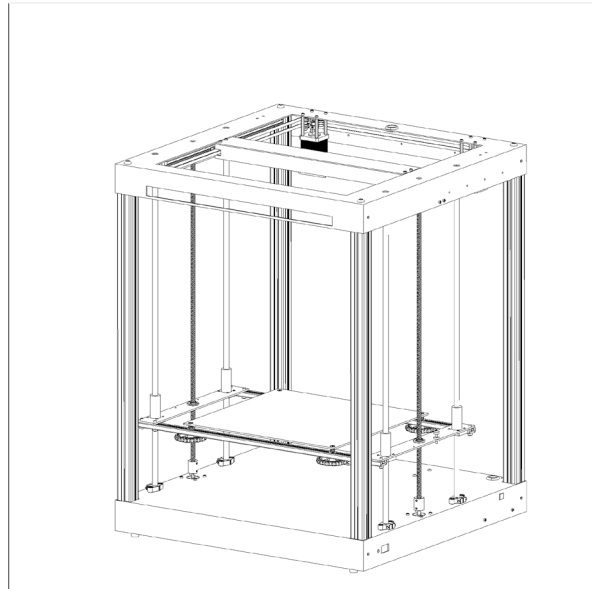


10. Attach a Z-axis coupling at the bottom of each screw rod and ensure it is tightly fastened.

10. 在每个螺纹杆底部加装Z轴联轴器，并确保牢固地拧紧。

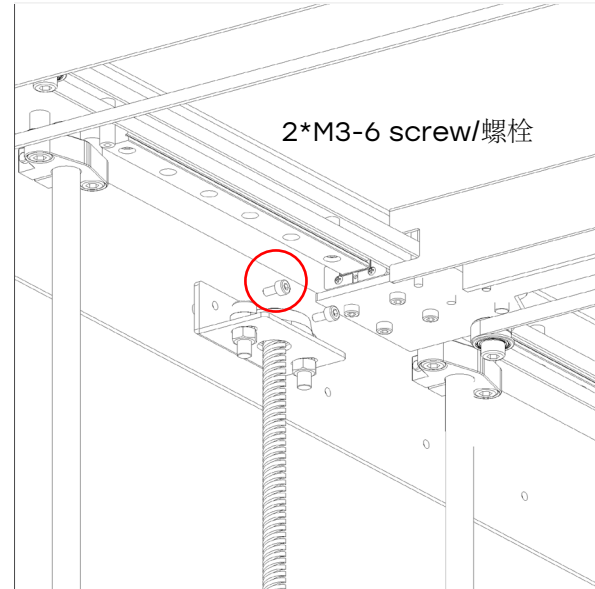
Step 2 - Parts Assembly

第二步：零件组装



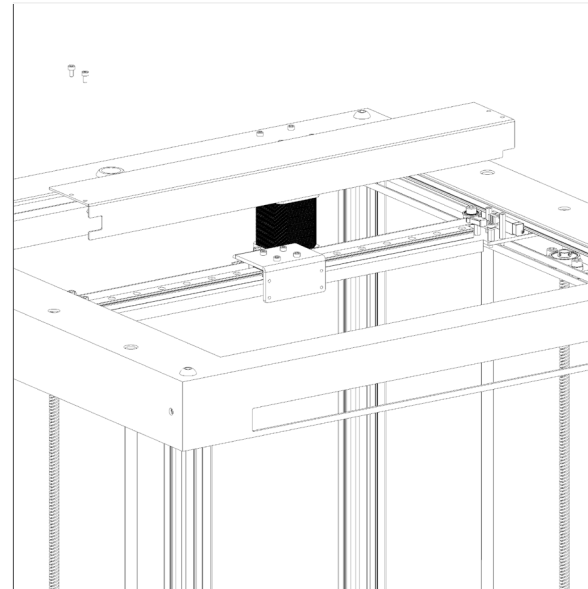
11. Identify the front face of your machine using the diagram reference. Now, let's start assembling the parts.

11. 使用图示参考标识机器的正面。现在，我们开始组装零件。



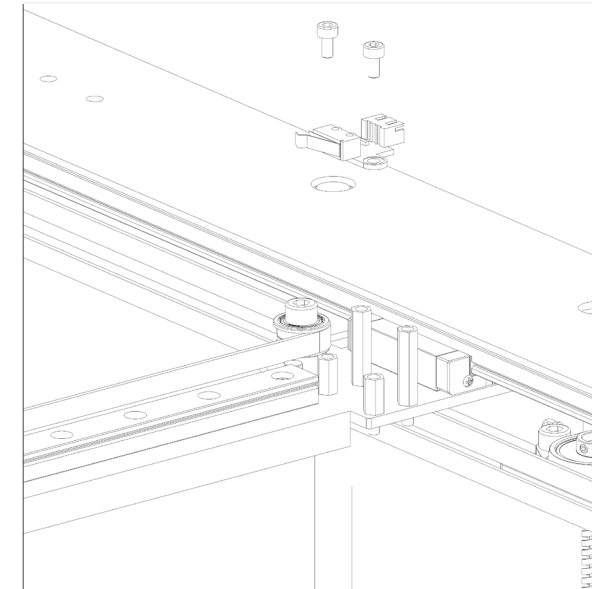
12. Assemble the Z-axis top bearing on each screw rod using 2 M3-6 bolts, and tighten the small black screws on the bearing.

12. 使用2颗M3-6螺栓在每根螺纹杆上组装Z轴顶部轴承，并紧固轴承上的小黑色螺丝。



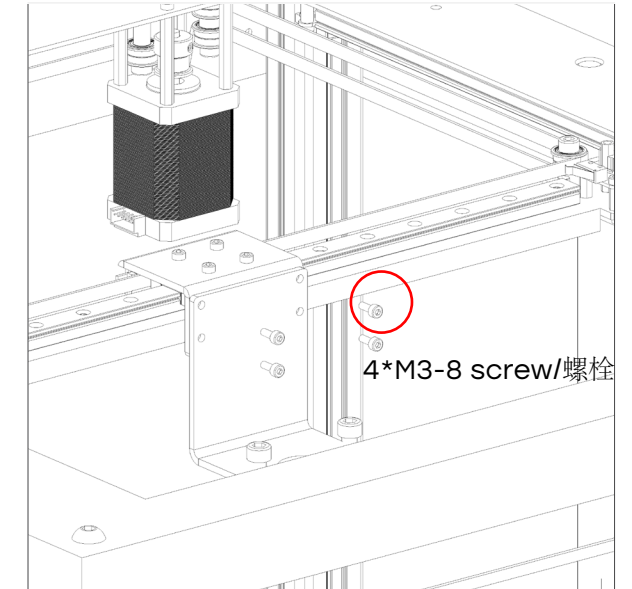
13. Unscrew the top X-axis cover.

13. 拆下X轴顶部盖子。



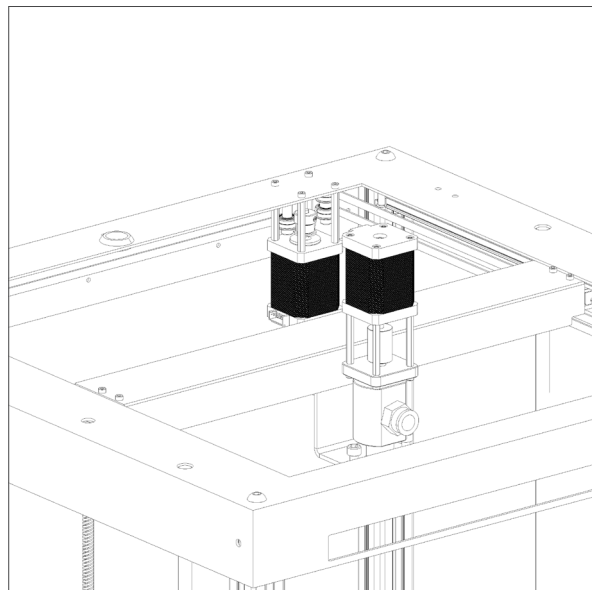
14. Unscrew the X-axis limit switch, and connect it with cable X (refer to the cable diagram).

14. 拆下X轴限位开关，连到X轴限位电线(参考电线图示)。



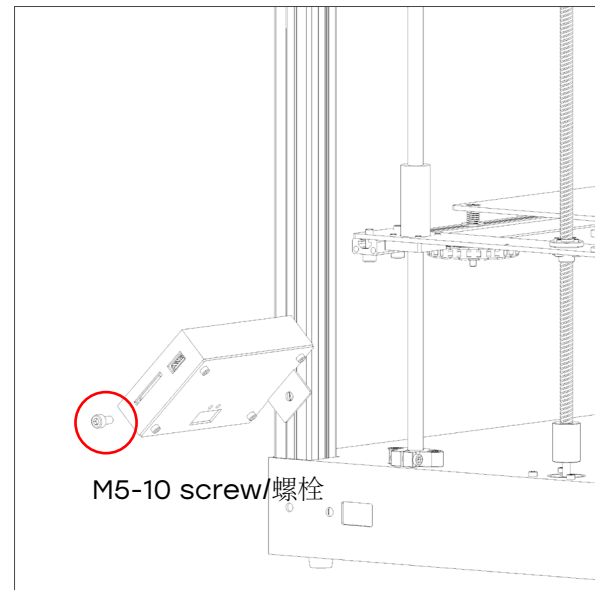
15. Attach the extruder holder with M3-8 bolts (4 in total) and screw back the X-axis cover.

15. 使用4颗M3-8螺栓固定挤出器支架(共4颗)，然后重新安装X轴盖子。



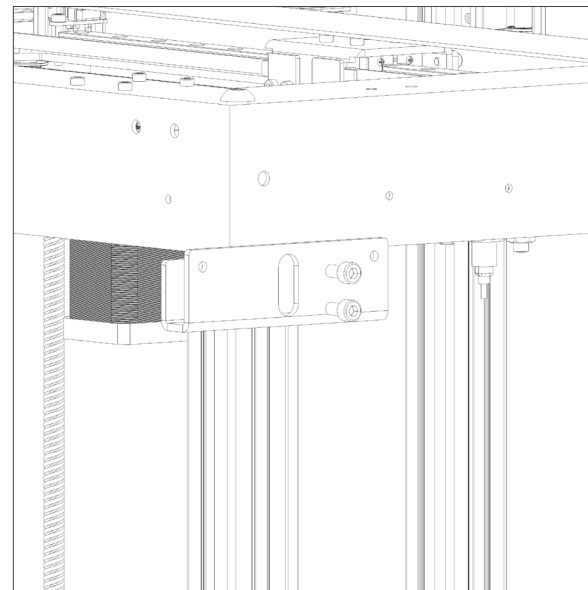
16. Put the extruder into the holder.

16. 将挤出器安装到支架上。



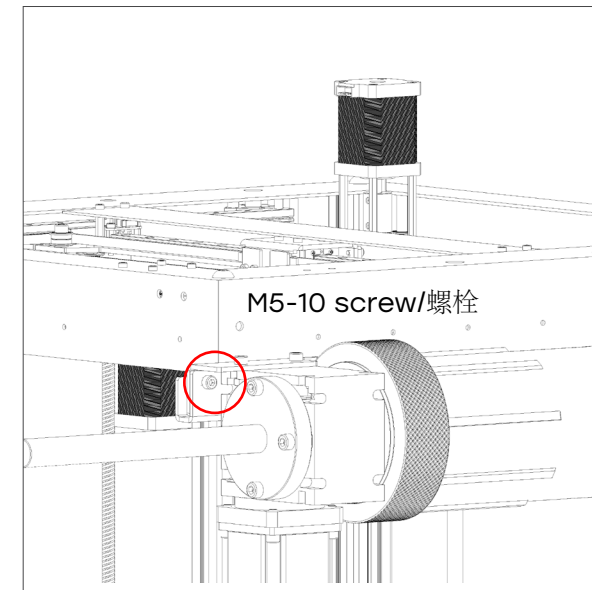
16. Connect the touch screen to the cables on the machine's right side, and secure it with an M5-10 bolt and T nut.

17. 将触摸屏连接到机器右侧的相对应电线接口，并用M5-10螺栓和T型螺母固定。



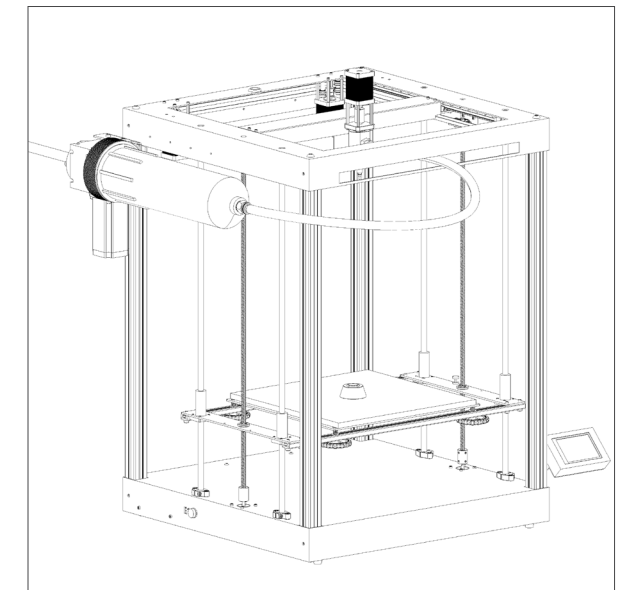
18. Install the putter hanging plate on the machine's left side, and secure it with 2 M5-10 bolts and T nuts.

18. 在机器左侧安装推杆挂板，并用2颗M5-10螺栓和T型螺母固定。



18. Insert the putter into the putter hanging plate, and secure it with lock bolt M5-10.

19. 将推杆部件插入推杆挂板，并用M5-10螺栓固定。



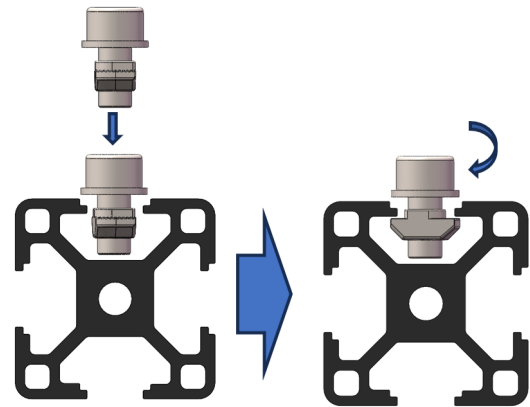
19. Add the feeding tube and MDF platform (do not remove the film).

20. 添加进料管和木质平台(请勿撕掉膜)。

Step 2 - Parts Assembly

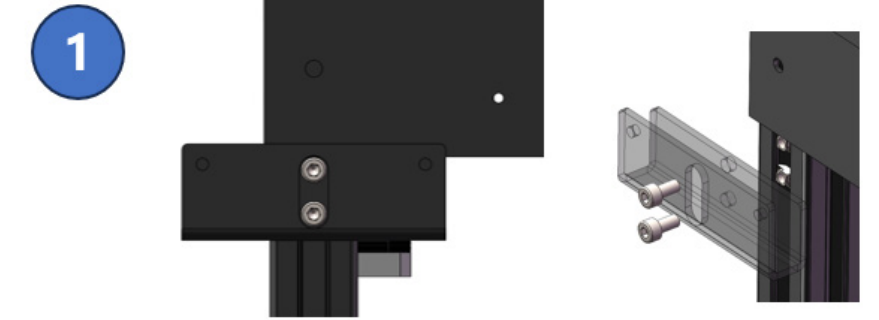
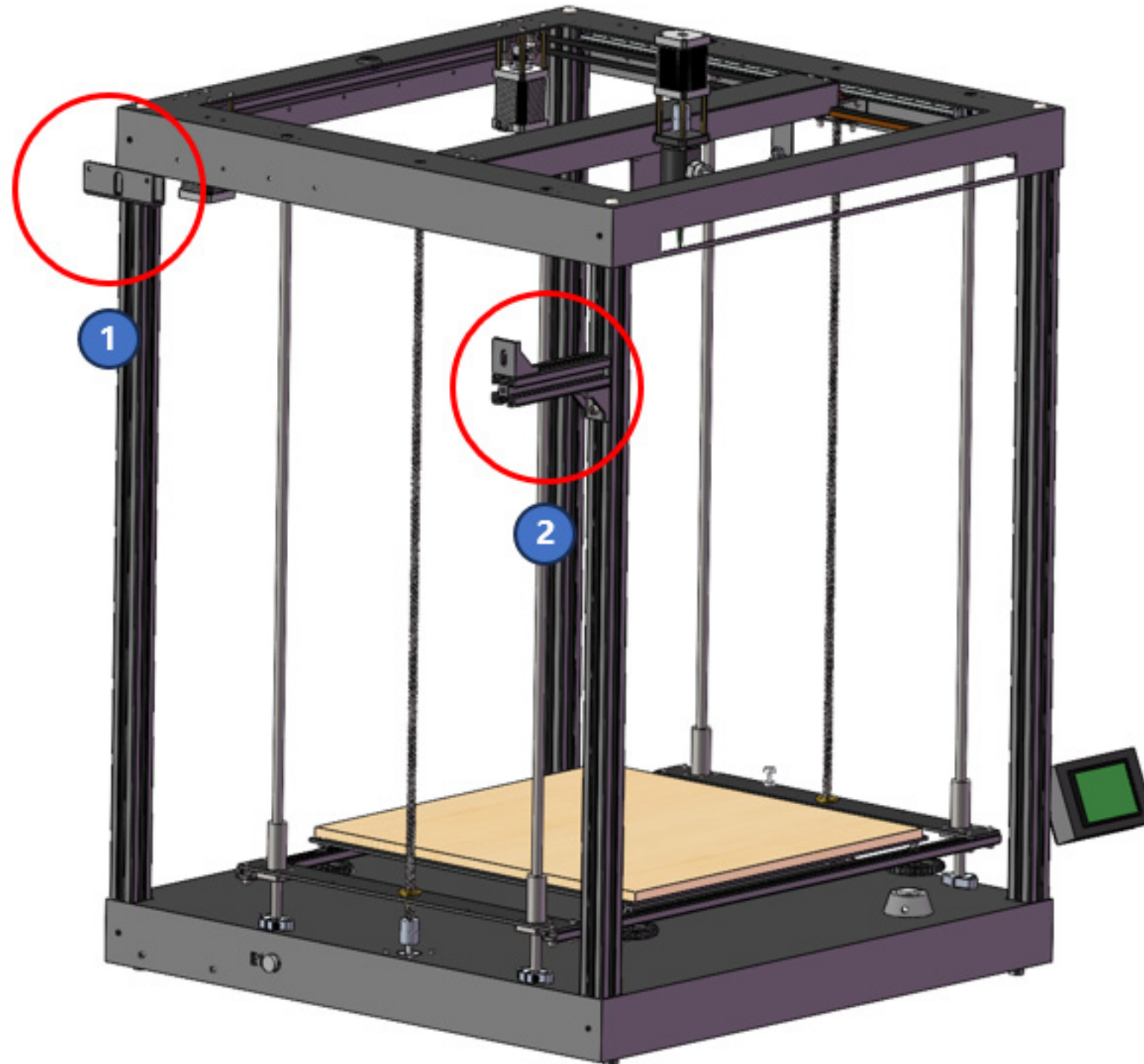
第二步：零件组装

Install T-Nuts. 安装T型螺母



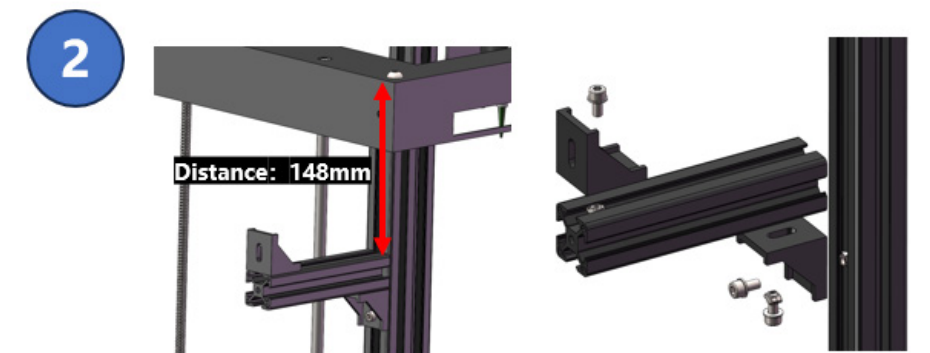
First, fix the bolt and the T-nut, then put the T-nut into the groove of the aluminum profile in a parallel direction, and quickly tighten the bolt clockwise so that the T-nut rotates 90° in the aluminum profile and gets stuck in the groove of the aluminum profile.

首先将螺栓与T型螺母固定，然后将T螺母平行方向放入铝型材的槽内，顺时针快速拧紧螺栓，使T型螺母在铝型材内旋转90°卡在铝型材槽内。



Use 2 M5-10 bolts and T-nuts to install the putter hanging plate.
使用2个M5-10的螺栓和T型螺母安装putter挂板。

Install 5L cartridge aluminum profile 安装5L 料筒铝型材



The distance between the beam profile and the top is 148mm.

横梁型材与顶端距离为148mm。

Step 3 - Assembly instructions

第三步： 组装说明

1. Please refer to the electric putter assembly instructions for electric putter assembly: <https://www.eazao.com/downloads/>

1. 电动推杆组装请参见电动推杆组装说明书: <https://www.eazao.com/downloads/>

2. After installation is completed, grease can be applied to the Z-axis screw and the screw of the electric putter.

2. 装完成后可以在Z轴丝杆和电动推杆的丝杆上涂抹润滑脂。

3. The feeding tube passes through the elongated slot at the top to prevent the feeding tube from interfering with the printing model.

3. 送料管从顶部细长槽孔内穿过，防止送料管与打印模型发生干涉。

*Refer to the assembly and usage tutorial video: <https://youtu.be/i4ZXauQAjDc?si=CGB6e4aOyWJfy2bQ>

*参考组装和使用教程视频: <https://youtu.be/i4ZXauQAjDc?si=CGB6e4aOyWJfy2bQ>

Step 4 - Voltage Range

第四步：电压档位



Warning:

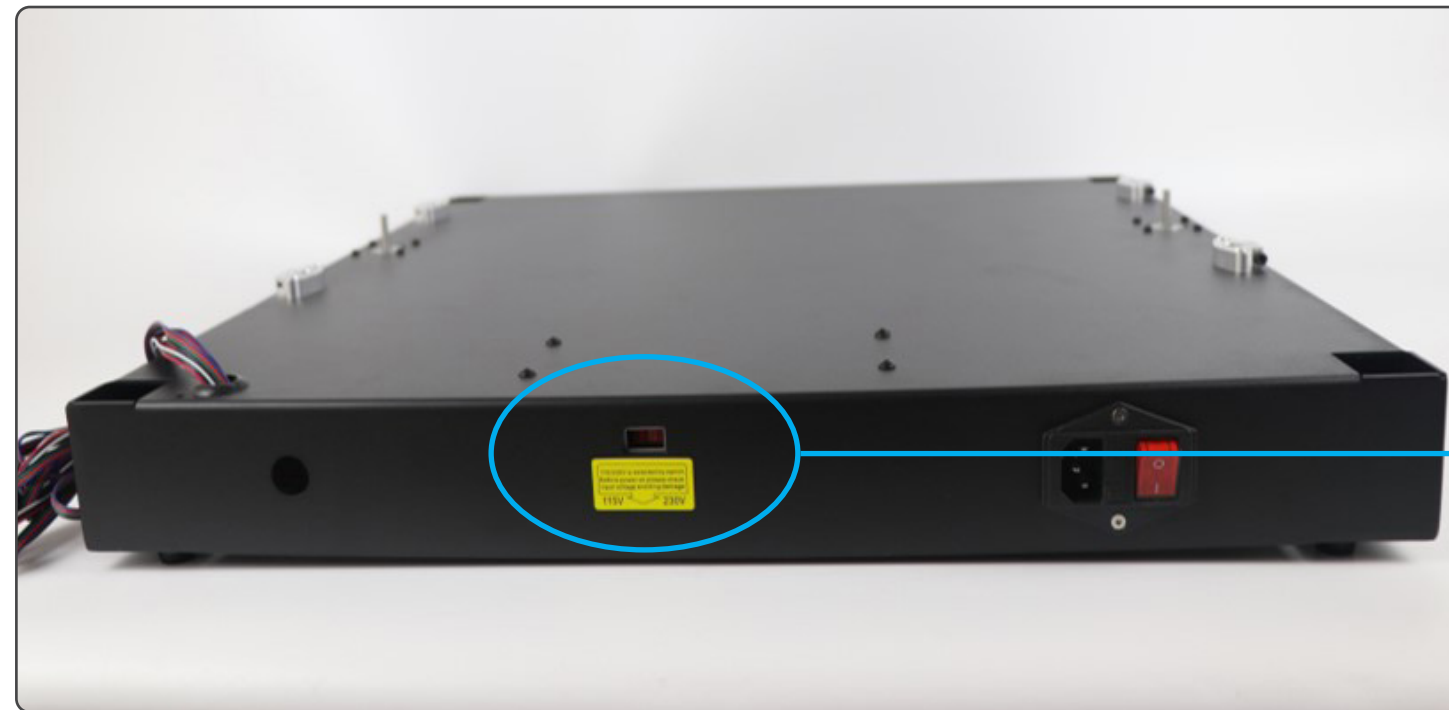
Before turning on the power for the first time, you must check whether the power supply voltage complies with local standards!!!

If the voltage gear is wrong, it will burn the circuit.

警告:

第一次打开电源前，必须检查电源电压是否符合当地标准!!!

如果档位错位，会烧毁电路。



In this state, the voltage is **115V**, which is suitable for countries such as the United States, Canada and Japan.

此状态下为**115V**电压，适用于美国、加拿大和日本等国家。

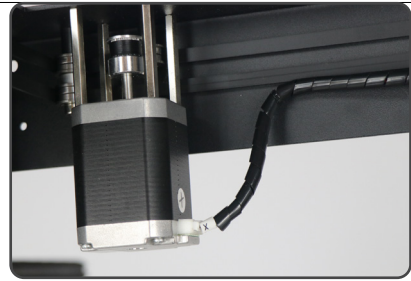


In this state, the voltage is **230V**, which is suitable for countries such as China, Germany and the United Kingdom.

此状态下为**230V**电压，适用于中国、德国和英国等国家。

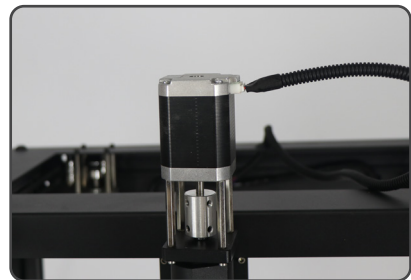
Step 5 - Cables

第五步：接线



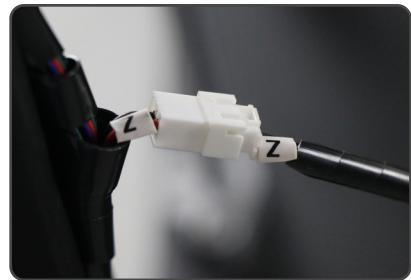
Insert the X-axis motor cable: Connect the 4-core cable marked with X number to the X-axis motor.

插入X轴电机线：将标有X号码的4芯线缆与X轴电机连接。



Insert the E-axis motor cable: Connect the 4-core cable marked with E number to the E-axis motor.

插入E轴电机线：将标有E号码的4芯线缆与E轴电机连接。



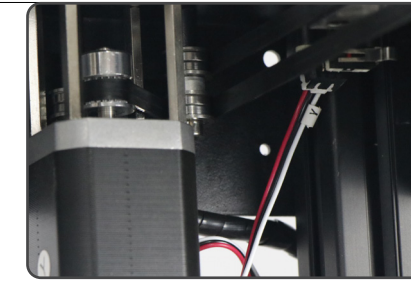
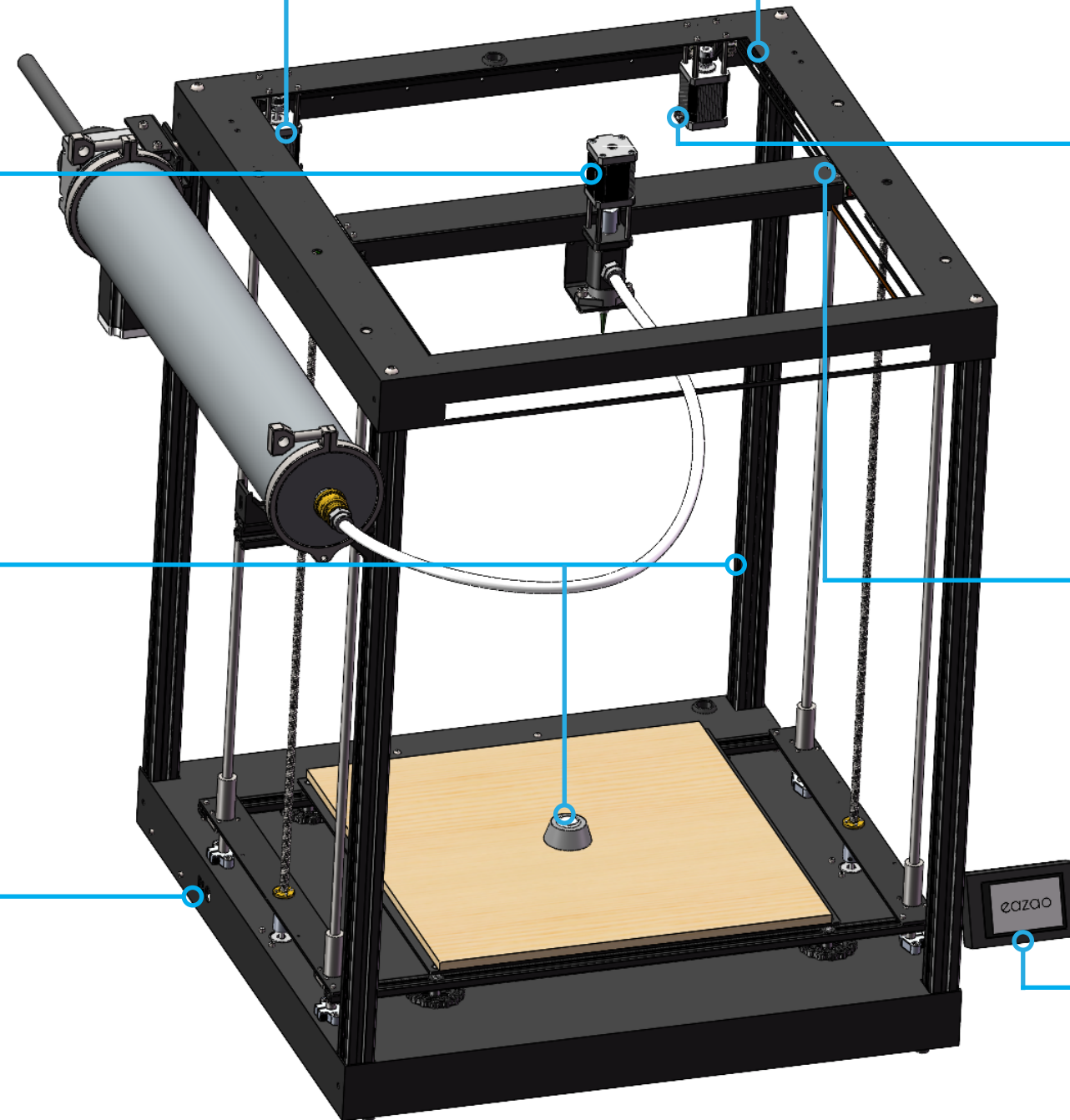
Plug in the Nozzle Setter Cable: Insert the cable marked with the Z number.

插入喷嘴设定器线：将标有Z号码的线对插。



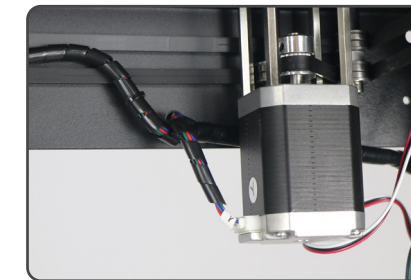
Inserting the electric putter cable: insert the electric putter cables.

插入电动推杆线缆：将电动推杆的线缆对插。



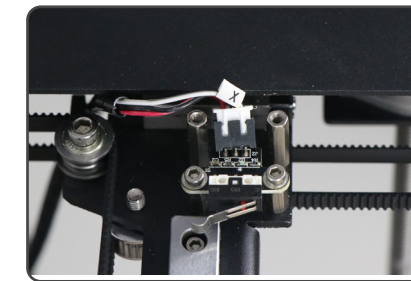
Insert the Y-axis limit cable: Connect the 3-core cable marked with Y number to the Y-axis limit switch.

插入Y轴限位线：将标有Y号码的3芯线缆与Y轴限位开关连接。



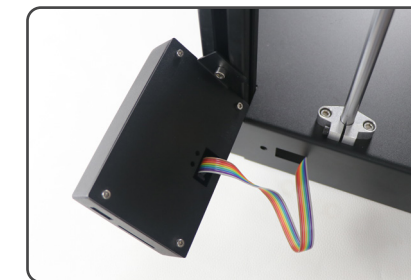
Insert the Y-axis motor cable: Connect the 4-core cable marked with Y number to the Y-axis motor.

插入Y轴电机线：将标有Y号码的4芯线缆与Y轴电机连接。



Insert the X-axis limit cable: Connect the 3-core cable marked with X number to the X-axis limit switch.

插入X轴限位线：将标有X号码的3芯线缆与X轴限位开关连接。

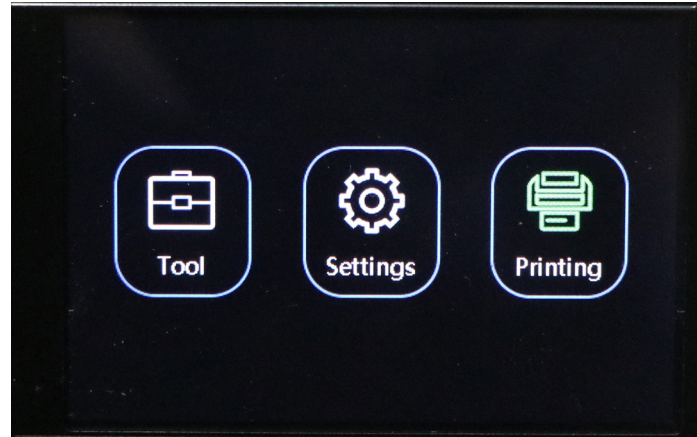


Insert the screen cable: Insert the screen cable into the screen rear case, pay attention to the direction.

插入屏幕线缆：将屏幕线缆插入屏幕后壳中，注意方向。

Step 6 - Platform Leveling

第六步：平台调平



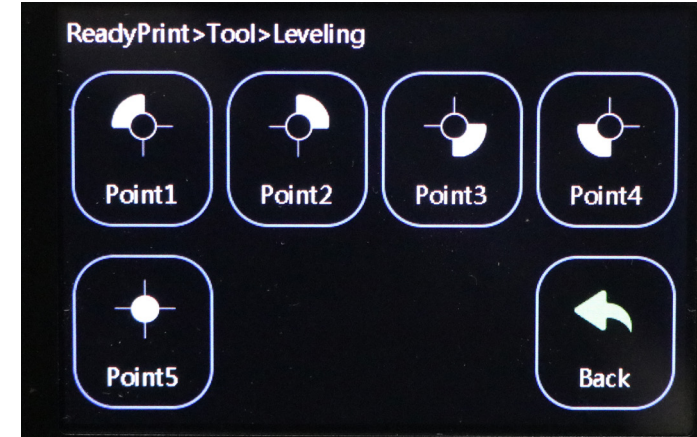
Turn on the power on the back of the printer and click "Tool".

打开打印机背部电源，选择“Tool”。



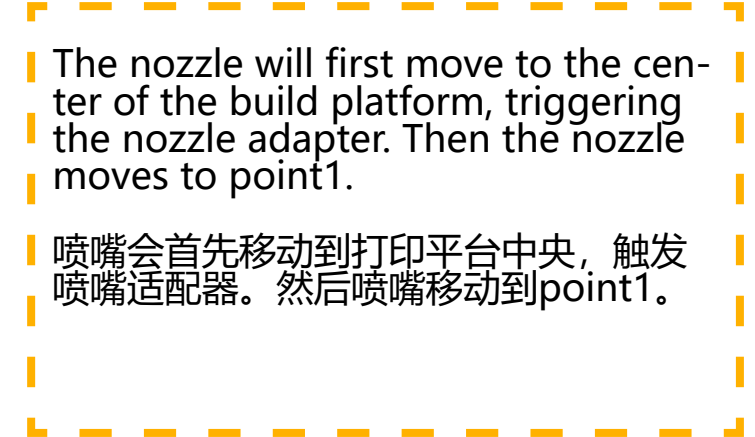
When printing for the first time, leveling is required and select "Leveling".

首次打印，需要进行调平，选择“Leveling”。



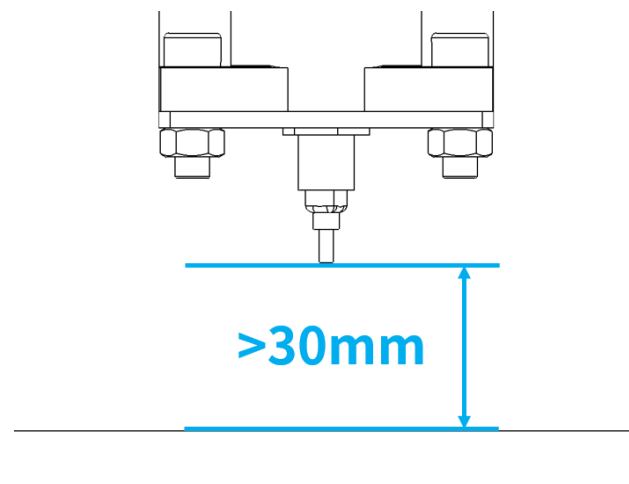
Click point1,2,3,4,5 in turn to perform leveling.

依次点击point1,2,3,4,5，进行调平。



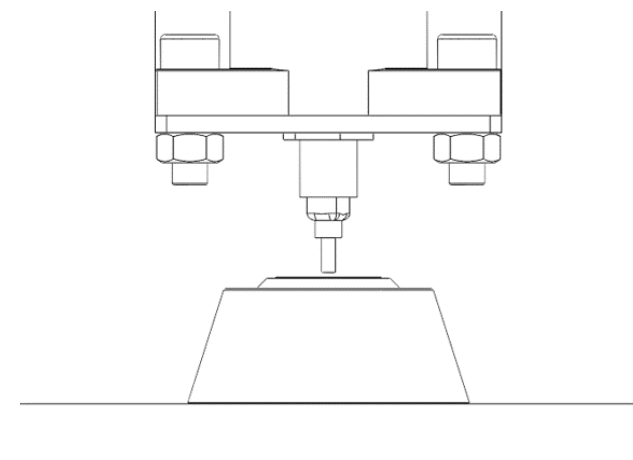
The nozzle will first move to the center of the build platform, triggering the nozzle adapter. Then the nozzle moves to point1.

喷嘴会首先移动到打印平台中央，触发喷嘴适配器。然后喷嘴移动到point1。



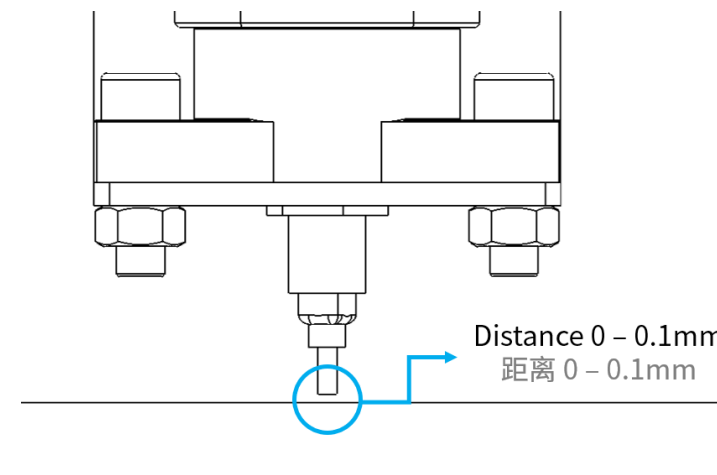
Before leveling, you need to ensure: the distance between the nozzle and the printing platform > 30mm.

调平前需要保证：喷嘴与打印平台距离 > 30mm。



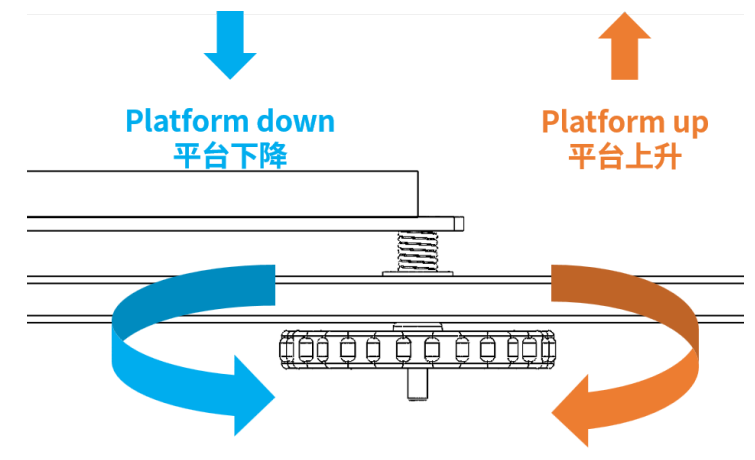
Place the nozzle setter on the center of the printing platform. (The nozzle setter needs to be removed after the nozzle is triggered.)

将喷嘴设定器放置在打印平台中央位置。（喷嘴触发后需要将喷嘴设定器移走。）



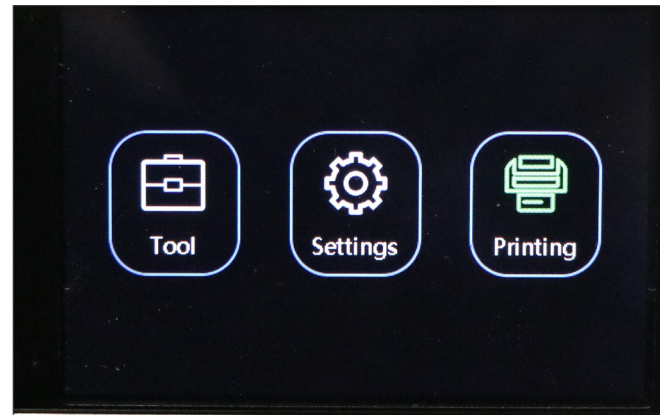
Adjust the four leveling nuts under the printing platform to adjust the distance between the nozzle and the platform to 0-0.1mm.

调节打印平台下方的四颗调平螺母，使喷嘴与平台的距离调整为0-0.1mm。



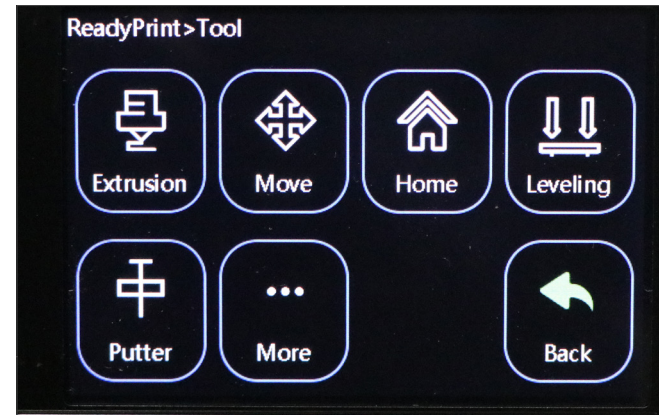
Step 7 - Prepare for Printing

第七步：打印前准备



Clay pre-extrusion settings, select "Tool".

陶泥预挤出设置，选择“Tool”。



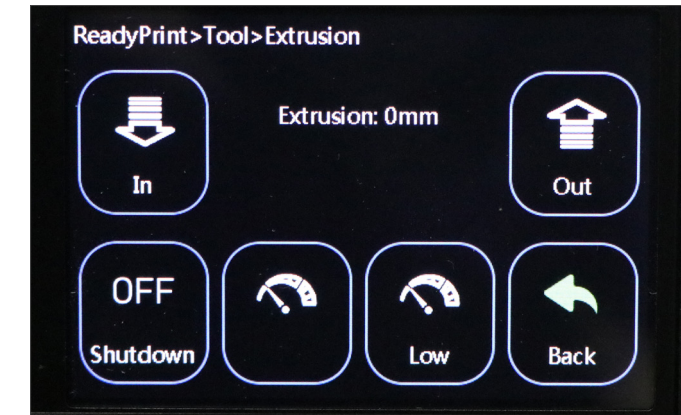
Click "Putter" and "Extrusion" respectively to pre-extrude the clay.

分别点击“Putter”和“Extrusion”，进行陶泥预挤出。



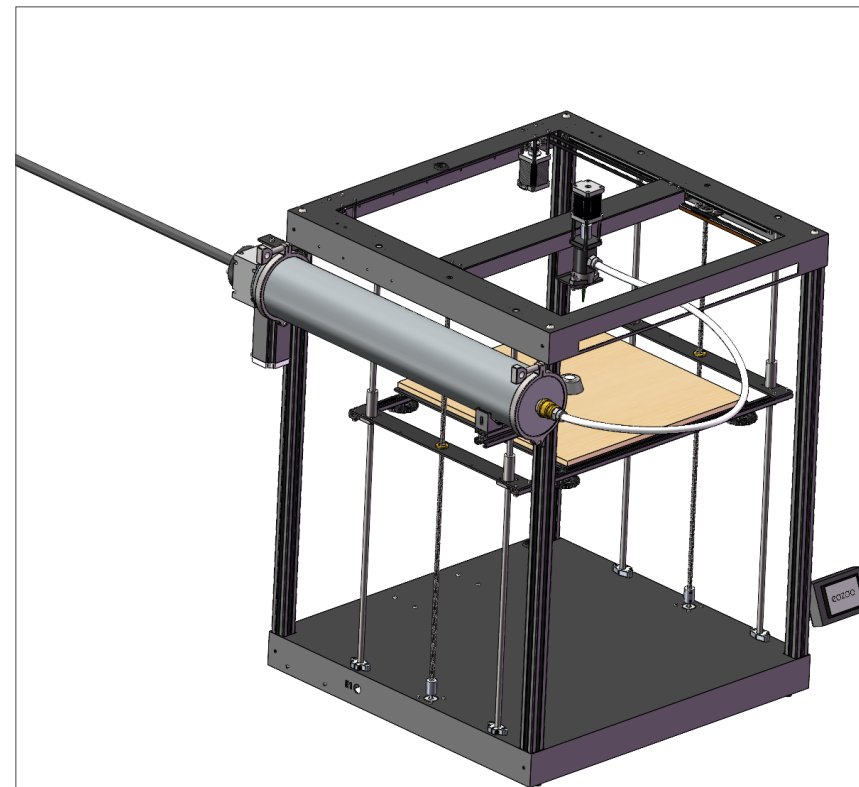
"Load", the putter moves forward, "Unload", the putter moves backward. "Shutdown", the putter stops.

“Load”，推杆前进，“Unload”，推杆后退。“shutdown”，推杆停止。



"In", the extruder feeds material, "Out", the extruder returns material. "shutdown", the extruder stops.

“In”，挤出机送料，“Out”，挤出机退料。“shutdown”，挤出机停止。



Equipment assembly:

1. Install the electric push rod and fill it with clay.
2. Install the electric push rod on the side of the printer and insert it into the feeding tube.

Clay pre-extrusion:

1. Click "Tool" -> "Putter" -> "Load", the clay enters the extruder from the feeding pipe.
2. After the clay enters the extruder, click "Shutdown" to stop feeding, and click "Back".
3. Click "Extrusion" -> "In", the extruder starts to extrude clay.
4. After the clay is smoothly extruded from the nozzle, click "Shutdown" to stop extrusion, and click "Back".

设备组装:

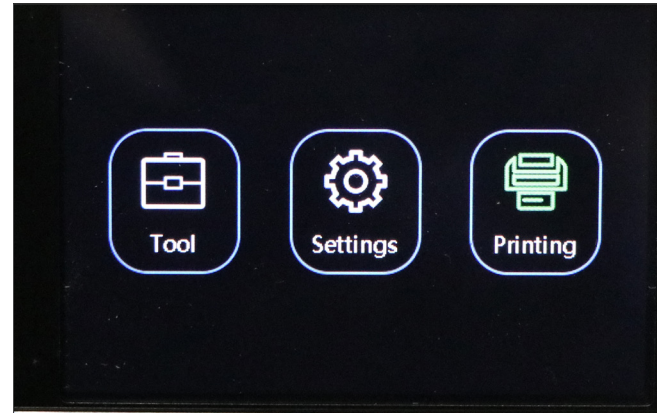
1. 安装电动推杆，并装填陶泥。
2. 将电动推杆安装在打印机侧边，并插入送料管。

陶泥预挤出:

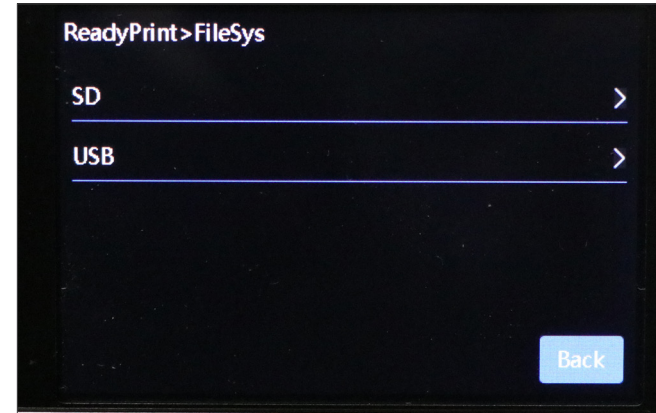
1. 点击“Tool” -> “Putter” -> “Load”，陶泥从送料管进入挤出机。
2. 陶泥进入挤出机后，点击“Shutdown”停止送料，点击“Back”。
3. 点击“Extrusion” -> “In”，挤出机开始挤出陶泥。
4. 陶泥从喷嘴顺畅挤出后，点击“Shutdown”停止挤出，点击“Back”。

Step 8 - Start Printing

第八步：开始打印

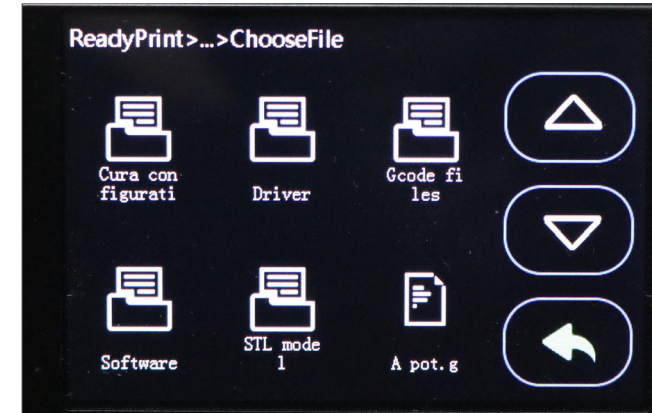


To start printing, select "Printing".
开始打印，选择“Printing”。



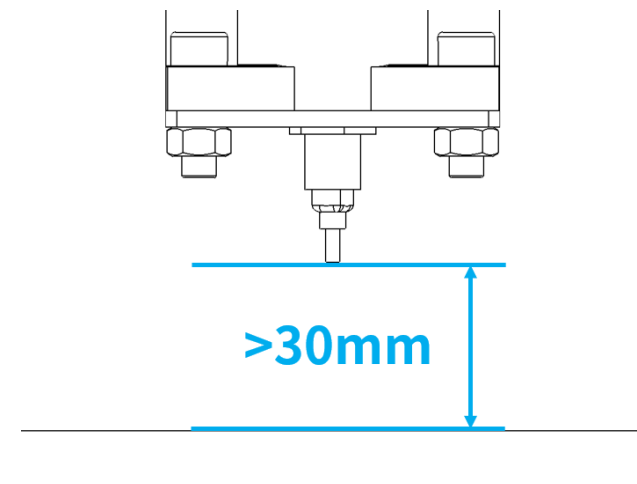
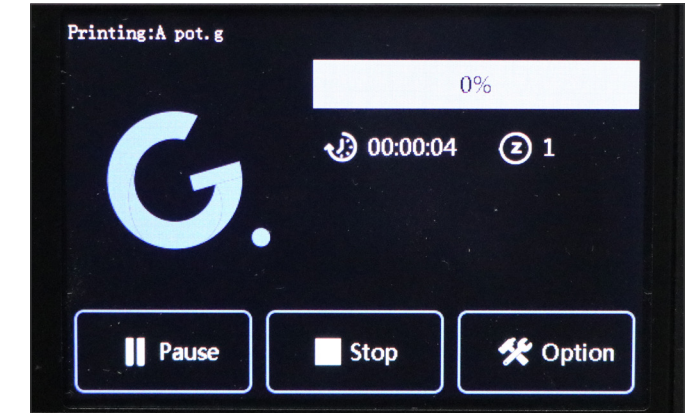
To use a USB card reader, please click "USB".

使用USB读卡器，请点击“USB”。



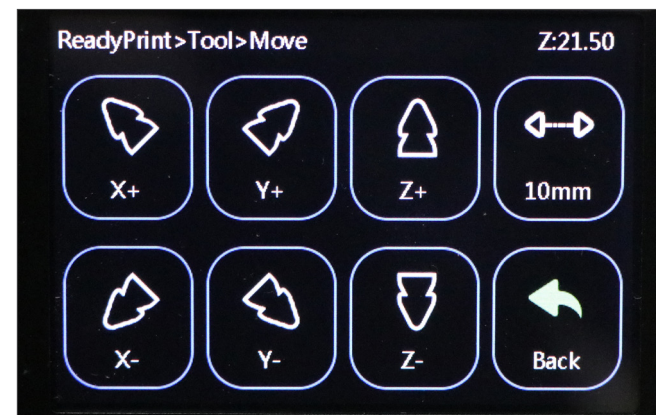
Select the sliced "Gcode" file to print.

选择切片好的“Gcode”文件进行打印。



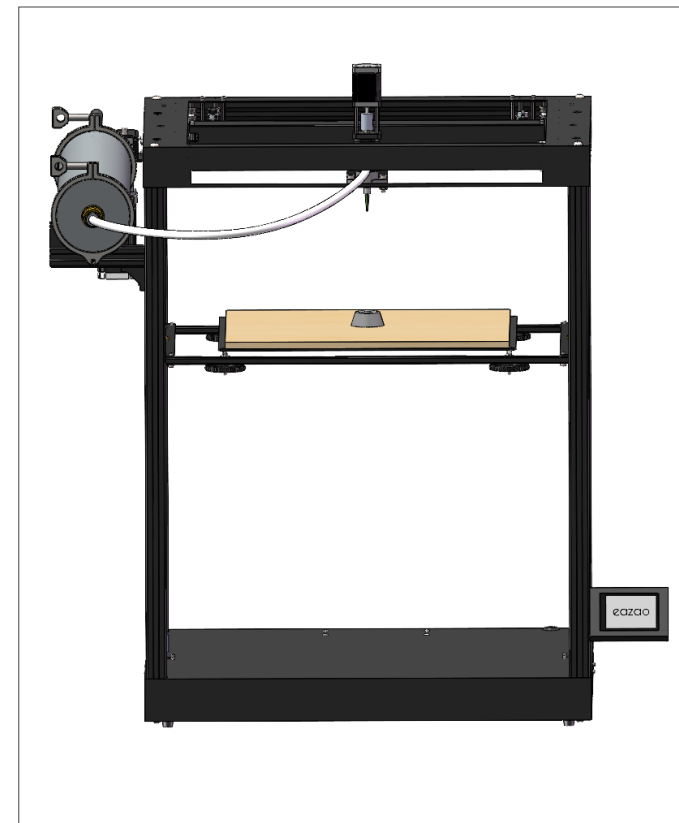
Before starting to print, you need to ensure that the distance between the nozzle and the printing platform is > 30mm.

开始打印前，需要确保：喷嘴与打印平台距离 > 30mm。



If you are not satisfied, you can move the printing platform down through "Tool" -> "Move" -> "Z+".

如不满足，可通过“Tool” -> “Move” -> “Z+”，向下移动打印平台。



1. After confirming the printing, the nozzle moves to the center of the printing platform.

2. The nozzle setter needs to be manually placed in the center of the printing platform. After the nozzle setter is triggered, remove the nozzle setter.

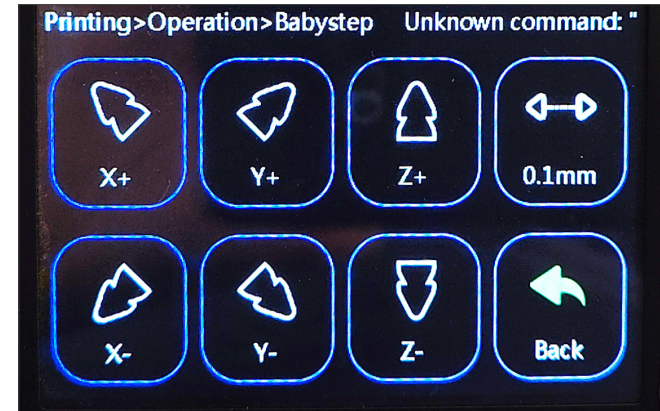
1. 确认打印后，喷嘴向打印平台中央移动。

2. 需要手动将喷嘴设定器放置在打印平台中央，喷嘴设定器触发后，将喷嘴设定器移走。

Step 8 - Start Printing

第八步：开始打印

1. Babystep settings/ Babystep设置



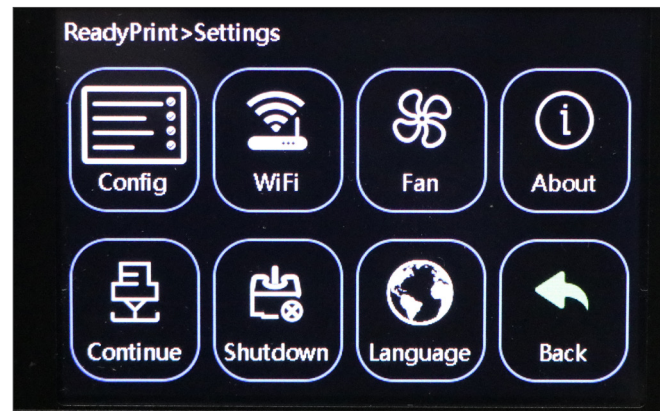
If the first layer of clay cannot be attached to the printing platform, the following operations can be performed.

Click "Option" -> "Babystep" -> "Z-" to move the printing platform up so that the first layer of clay is attached to the printing platform. (The range is switched to 0.1mm)

如果打印首层陶泥无法附着在打印平台上，可进行如下操作。

点击“Option” -> “Babystep” -> “Z-”，将打印平台向上移动，使陶泥首层附着在打印平台上。（量程切换到0.1mm）

2. Language settings/ 语言设置



Switch the touch screen language: Click "Settings", click "Language", and select the language you need.

切换触摸屏语言：点击“Settings”，点击“Language”，选择您需要的语言。

Step 9 - Slicing Software Settings

第九步：切片软件设置

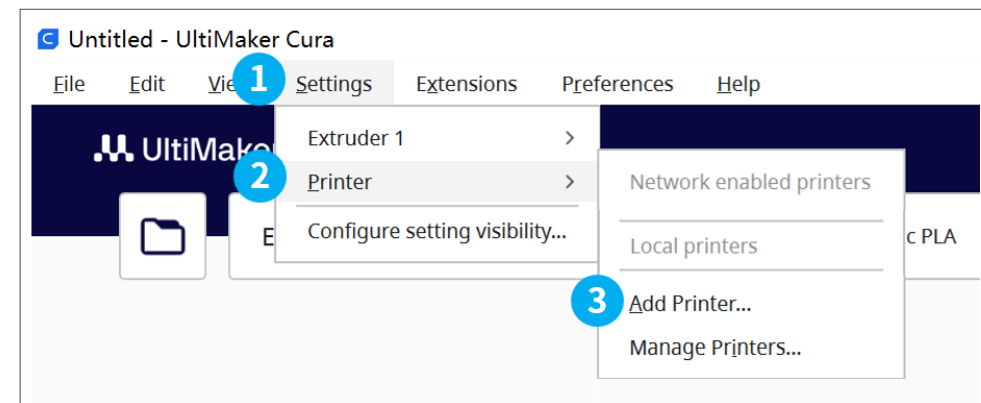
1. Software download and install/ 软件下载和安装

According to the computer operating system, it is recommended to download and install the latest version of Cura software:

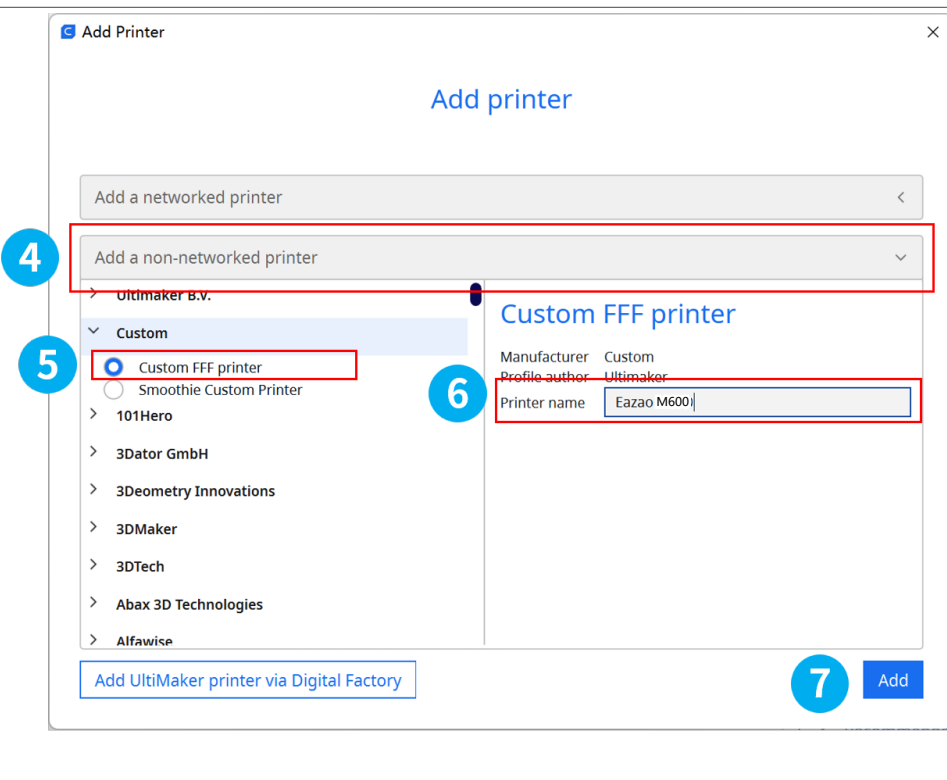
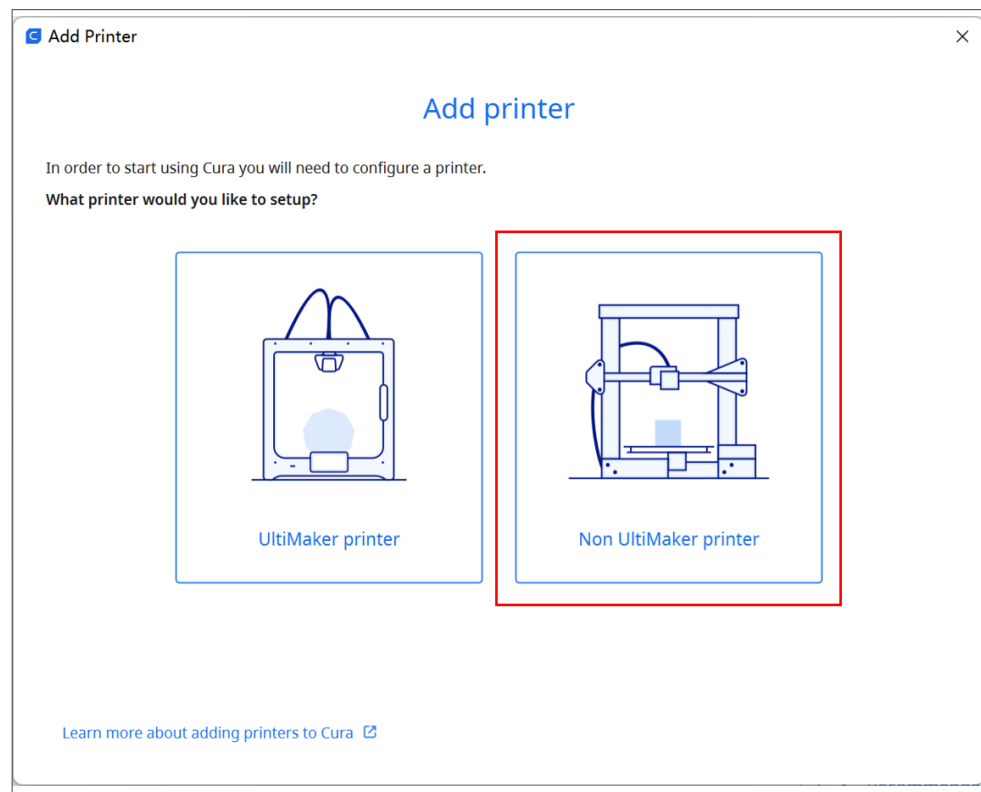
<https://ultimaker.com/software/ultimaker-cura/>

根据电脑的操作系统，下载并安装 Cura 软件最新版本：<https://ultimaker.com/software/ultimaker-cura/>

2. Add a printer/ 添加打印机



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

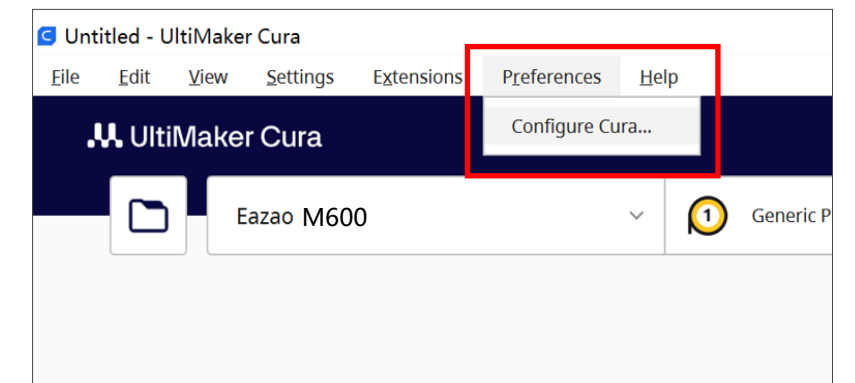


- 4 Add a non-networked printer 点击“添加未联网打印机” → 5 Custom FFFPrinter 选择“Custom FFFPrinter”

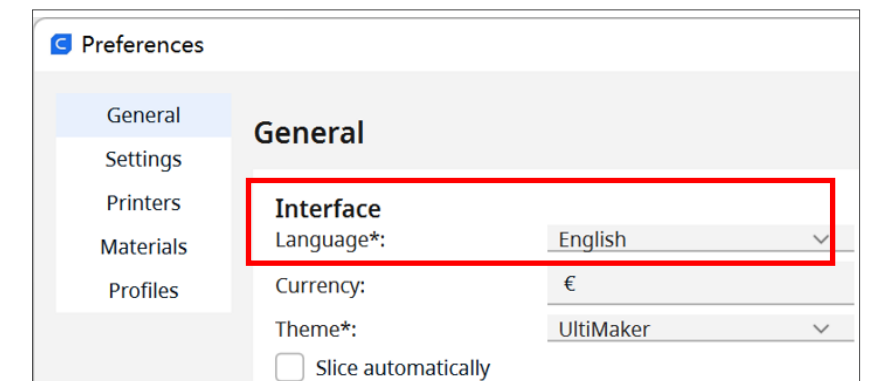
- 6 Enter “EazaoM600” 输入“EazaoM600” → 7 Add 点击“添加”

Select "Non UltiMaker printer"
选择"Non UltiMaker printer"

How to change the language of slicing software.
如何更换切片软件的语言。



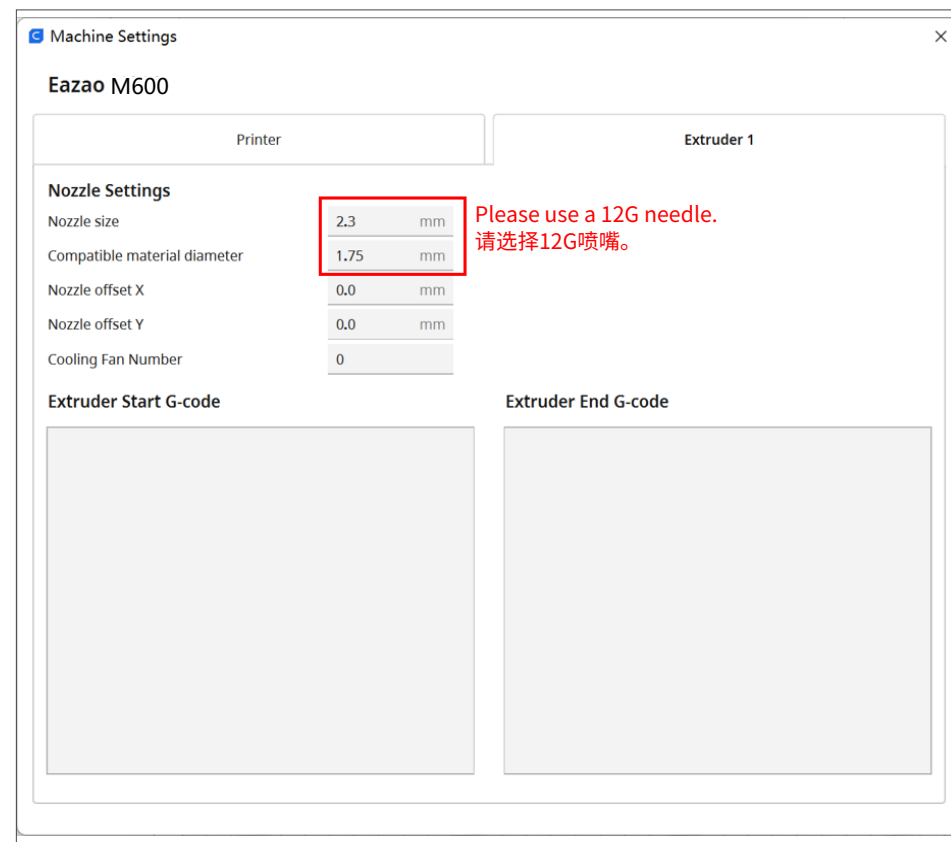
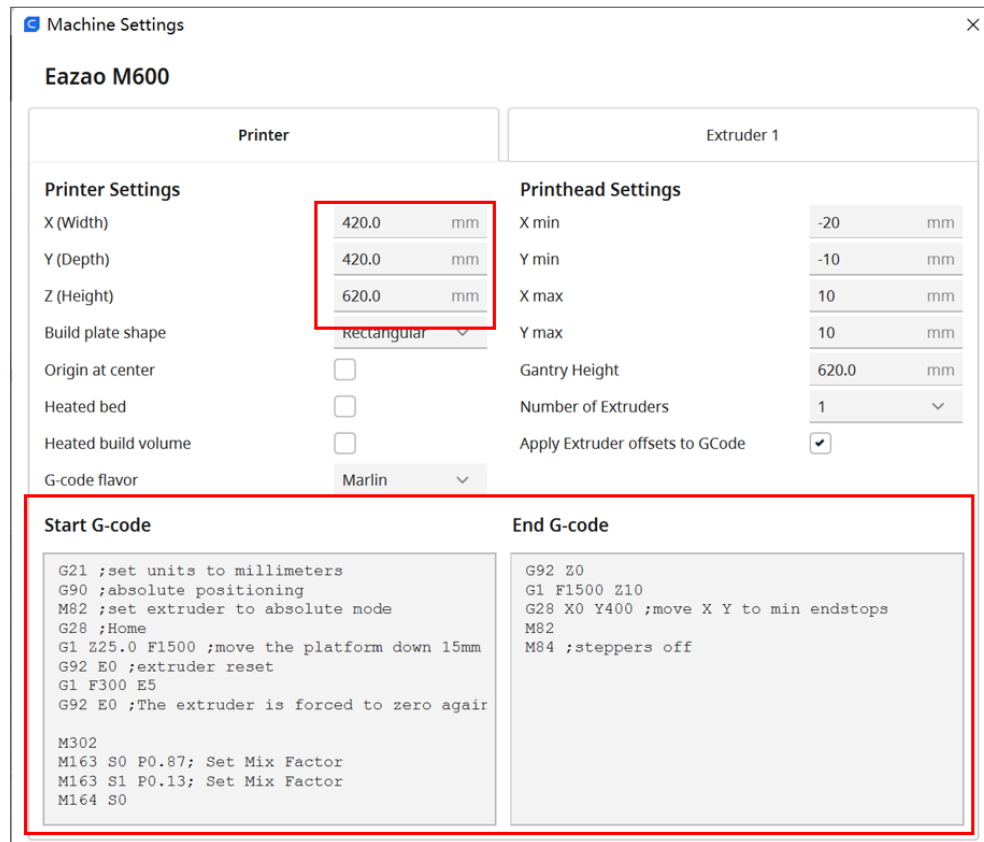
Preferences —> Configure Cura ...
偏好设置 配置Cura



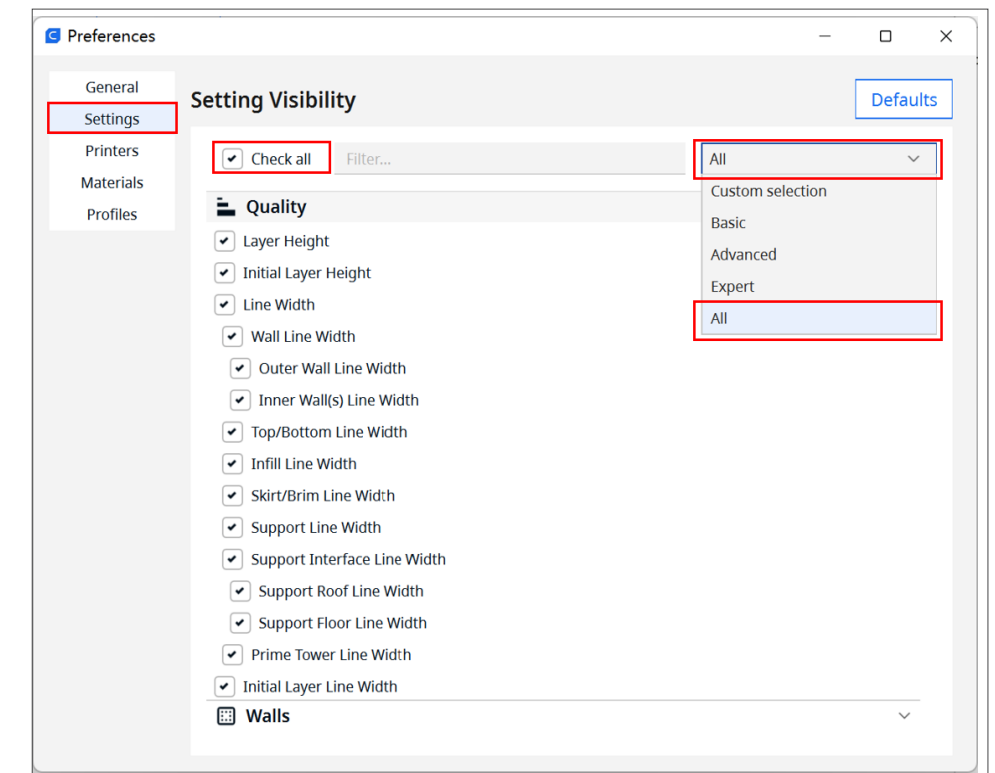
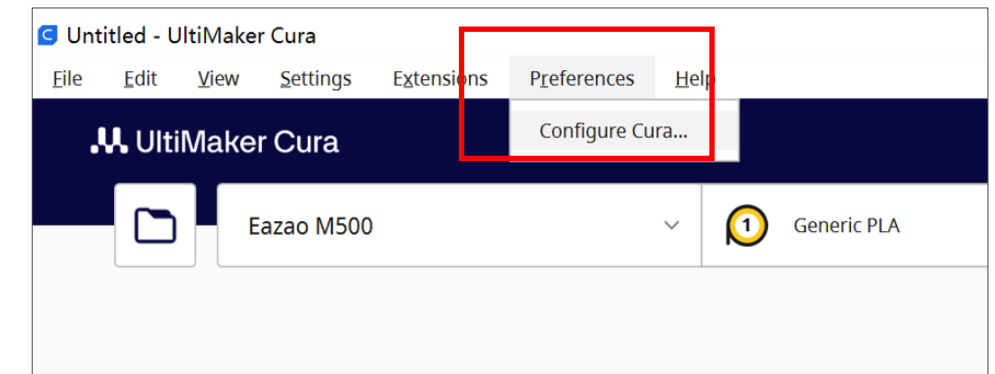
After selecting the language you need, you need to restart the Cura software.
选择您需要的语言后，需要重启Cura软件。

Step 9 - Slicing Software Settings

第九步：切片软件设置



Refer to the figure to configure the visibility of the slicing software settings.
参照如图，配置切片软件设置可见性。



Set the printer and extruder parameters as shown in the figure, the configuration of Start G-code and End G-code can copy the text below.
如图所示设置打印机和挤出机参数，Start G-code和End G-code的配置可以复制下方文本。

Start G-code

```
G21 ;set units to millimeters
G90 ;absolute positioning
M82 ;set extruder to absolute mode
G28 ;Home
G1 Z25.0 F1500 ;move the platform down 15mm
G92 E0 ;extruder reset
G1 F300 E5
G92 E0 ;The extruder is forced to zero again
```

End G-code:

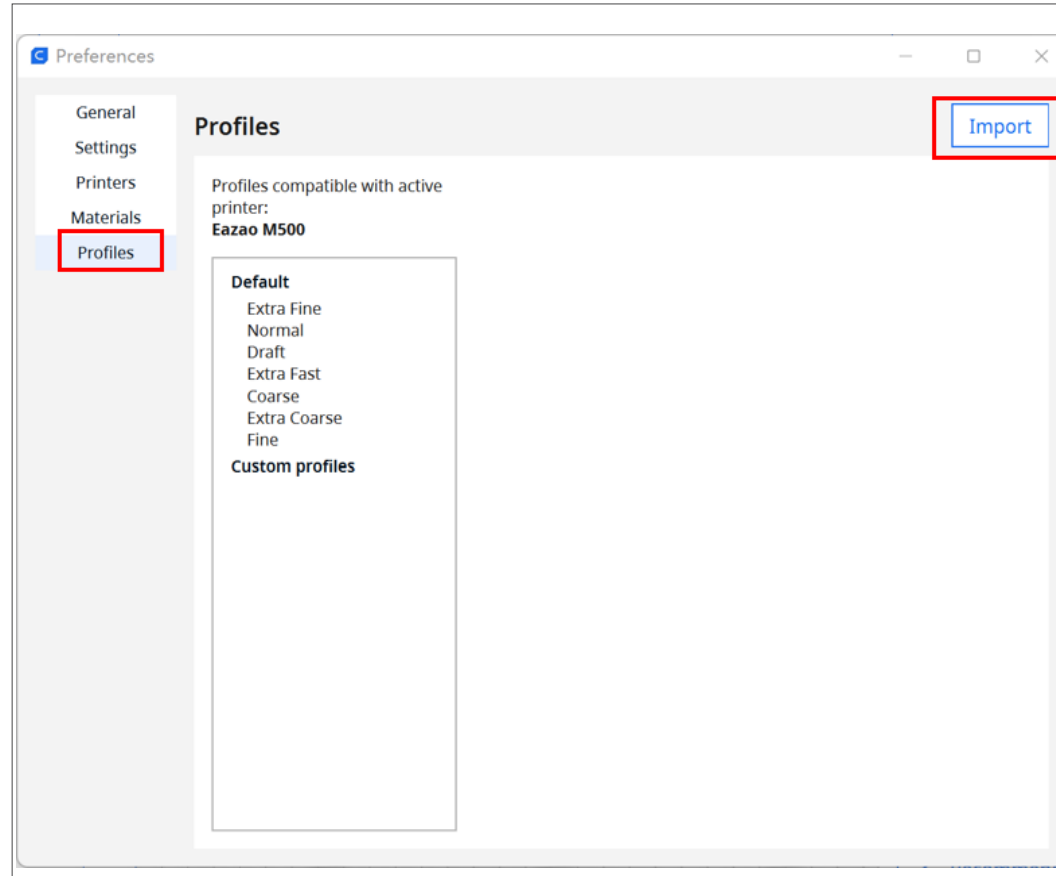
```
G92 Z0
G1 F1500 Z10
G28 X0 Y400 ;move X Y to min endstops
M82
M84 ;steppers off
```

```
M302
M163 S0 P0.87; Set Mix Factor
M163 S1 P0.13; Set Mix Factor
M164 S0
```

Step 9 - Slicing Software Settings

第九步：切片软件设置

1.Import parameter setting /导入参数设置



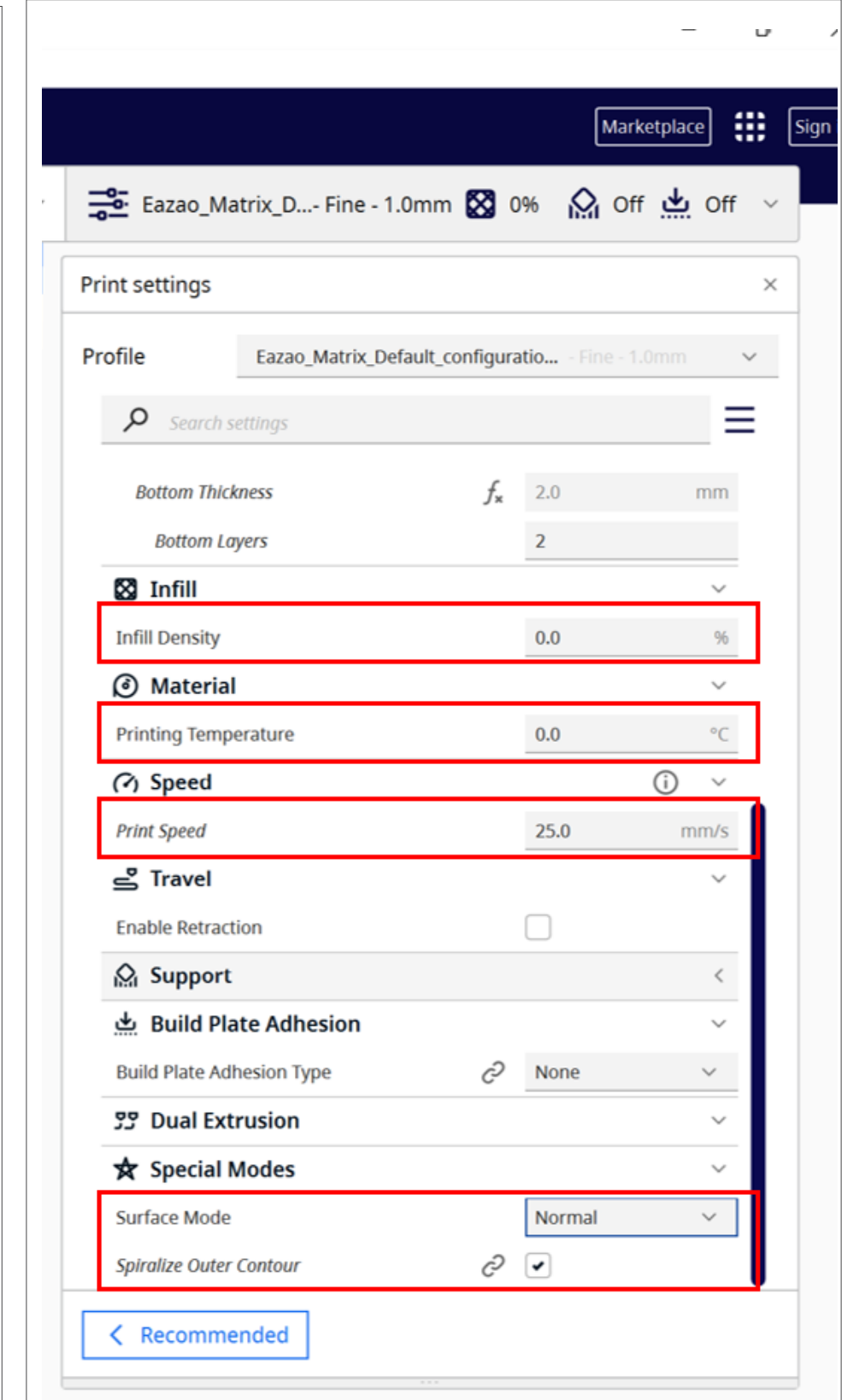
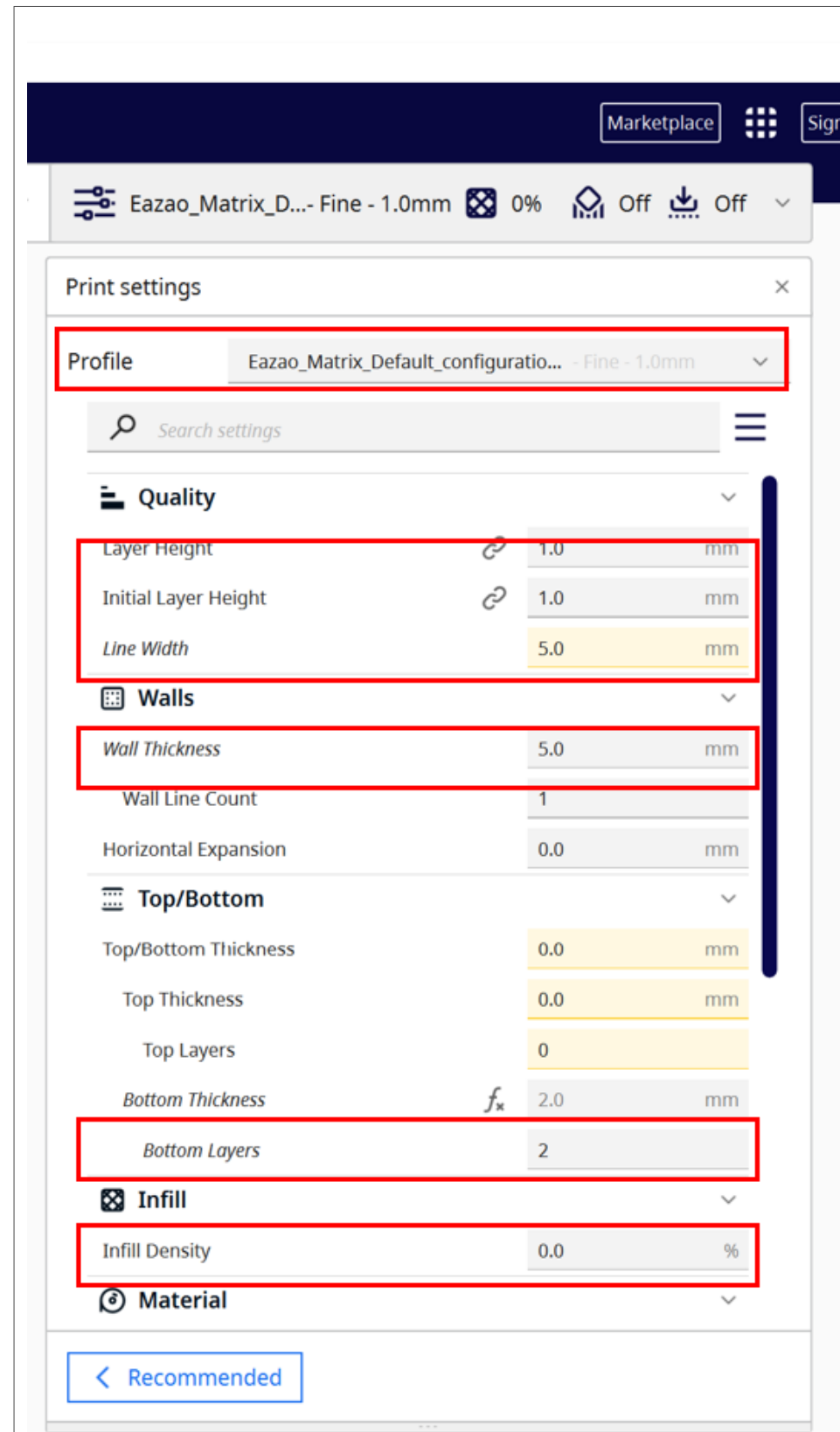
Import configuration file: Click "Preferences" and select "Profiles". Click "Import" in the upper right corner and select the configuration file in the SD card: **Eazao Matrix Default configuration_20230520** (the file is under the Cura folder in the SD card).

导入配置文件：点击“Preferences”，选择“Profiles”。点击右上角“Import”，选择SD卡内的配置文件：**Eazao Matrix Default configuration_20230520**（该文件在SD卡内Cura文件夹下面）。

After importing the file, you can click "Profile" on the right figure and select the configuration file settings. If the import fails, you can configure the parameters yourself by referring to the figure on the right.

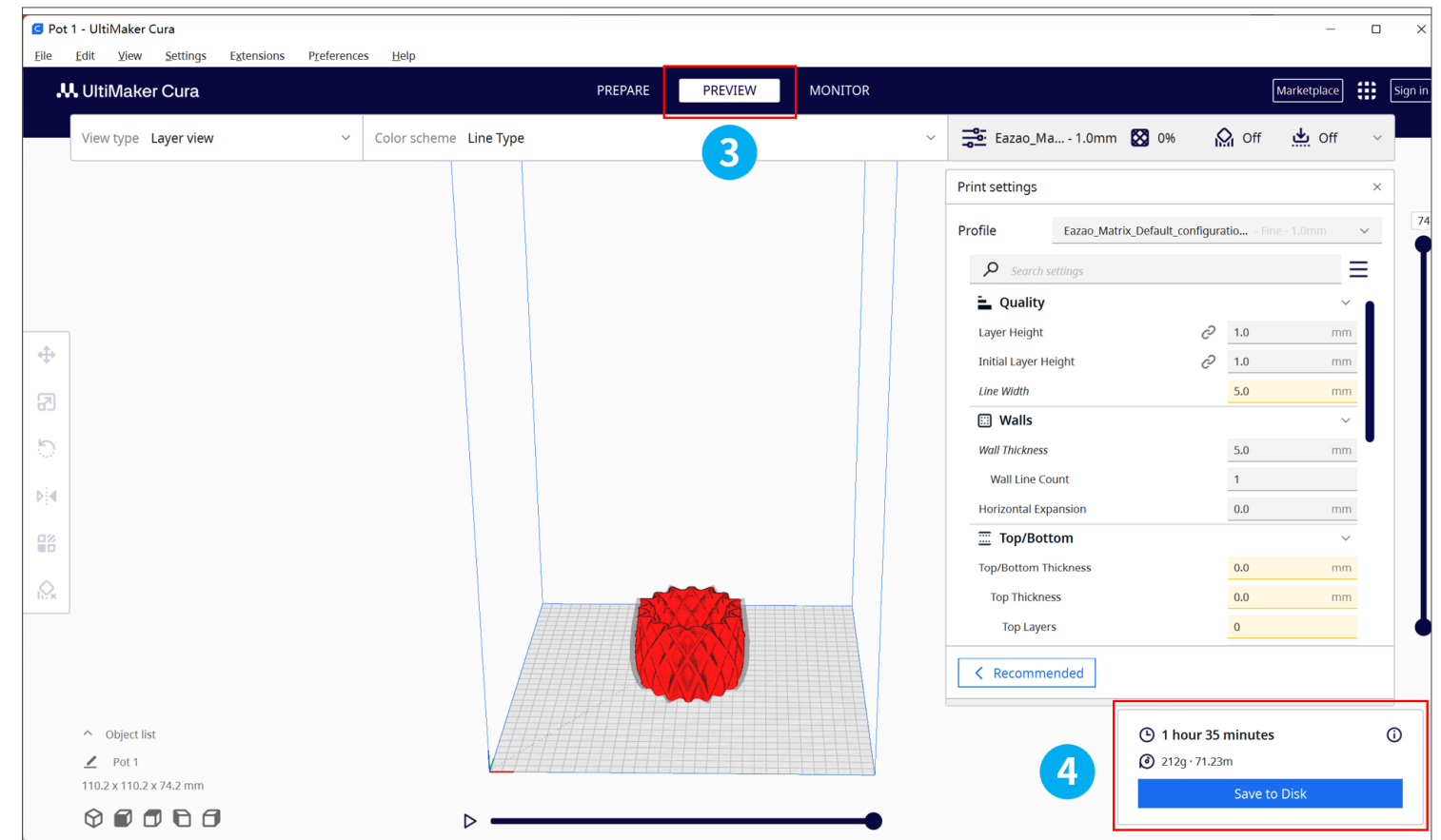
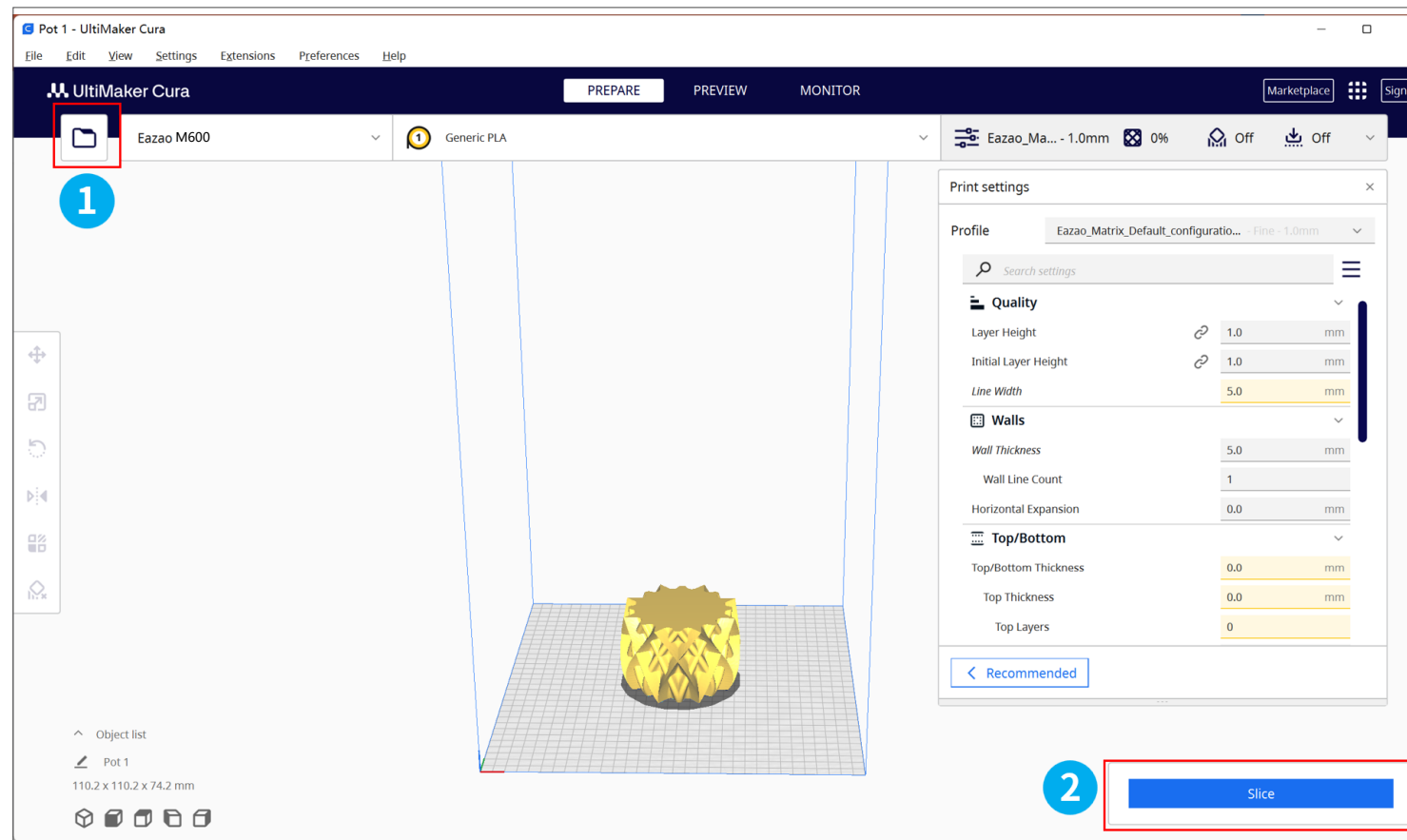
导入文件后，可以在右图点击“Profile”，选择配置文件设置。如果导入失败，可以参照右图手动配置参数。

2.Manual parameter setting /手动参数设置



Step 9 - Slicing Software Settings

第九步：切片软件设置



1 Open a file
打开一个文件 → 2 Slice
切片

3 Preview
预览 → 4 Save to Disk
保存到磁盘

Step 10 - Q & A

第十步：Q & A

1. What must the consistency be so that the M500 can cope with it?

The noise is caused by the putter not being able to push the clay. The reasons for the noise may be: 1. The clay is too hard, you need to continue to add water to the clay. 2. Or the clay conveying system is blocked, you need to disassemble and clean it. Since the specific composition and proportion of clay varies from place to place, the hardness of clay needs to be adjusted according to the actual printing situation. Even if your pressure is 2.5kg, it may be difficult to extrude, because we have to consider factors such as the fluidity of the material. For example: under the same 2.5kg pressure, China Clay has a higher printing success rate than Red Clay, because China Clay has better fluidity and China Clay dries slowly. The hardness, fluidity, and printability need to be adjusted according to the actual situation. Make the clay as soft as possible and have better fluidity, which is conducive to successful printing. <https://www.eazao.com/blog/testing-of-six-clays-for-extrusion-3d-printing/>

2. What kind of noises of the printer are normal? I noticed that as soon as the printer starts its paths, the two motors of the Z-axis "tremble" they turn slowly and tremble? is that normal?

There are many reasons why the first layer cannot be completely fitted. Here are several solutions:

A. At the beginning of printing, observe the printing status of the first layer. If two adjacent lines do not fit completely, you can enable the Babystep setting. Fine-tune the Z-axis distance on the screen operation interface, as follows: Option->Babystep->Z-. If two adjacent lines fit too closely, fine-tune the Z-axis distance on the screen operation interface, as follows: Option->Babystep->Z+.

On the Babystep interface, do not click Z+ or Z- multiple times, which will easily cause the Z value to be disordered and the Z axis not to drop. It is recommended to select an appropriate stroke (0.01, 0.05, 0.1), and click several times to complete the Z-axis adjustment.

B. In the pre-extrusion step before printing, let the electric push rod perform sufficient pre-extrusion until you hear the abnormal sound of clicking, and stop the movement of the electric push rod immediately. In this way, when printing the first layer, the clay can be fully extruded, and two adjacent lines fit closely. Clay is a non-Newtonian fluid, and the relationship between shear stress and shear strain is nonlinear. That is to say, when the clay is pushed, the clay will not respond immediately (such as deformation and extrusion), which leads to the hysteresis of clay printing. The hysteresis here causes the clay without enough flow to be squeezed out when printing the first layer. Sufficient pre-extrusion can make the pressure of the clay in the feeding system strong enough. Once the extruder rotates, the clay can be extruded smoothly, and the first layer can be printed perfectly.

For the trembling problem of the Z-axis, you can apply grease on the Z-axis screw rod (this grease can also be used to push rod of the electric push rod to reduce the wear of the push rod). In the standard packaging of the Matrix, a tube of white grease is carried. However, the item was taken out due to reasons such as logistics providers and customs policies. If you cannot find the item in the packaging, we recommend contacting your local retailer for similar products.

3. XY returns to the home position abnormally and makes a clicking sound.

Please check whether the limit switches of the XY axis are normal? Is there any bending? Has the wiring harness fallen off?

Because each model is different, there may be differences between the actual product and the picture. The actual product shall prevail.

The final right of interpretation belongs to Eazao.

因为每款机型不同，实物与图片可能存在差异，一切以实物为准。最终解释权归Eazao所有。

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