



Glitar Series Desktop 3D Printer

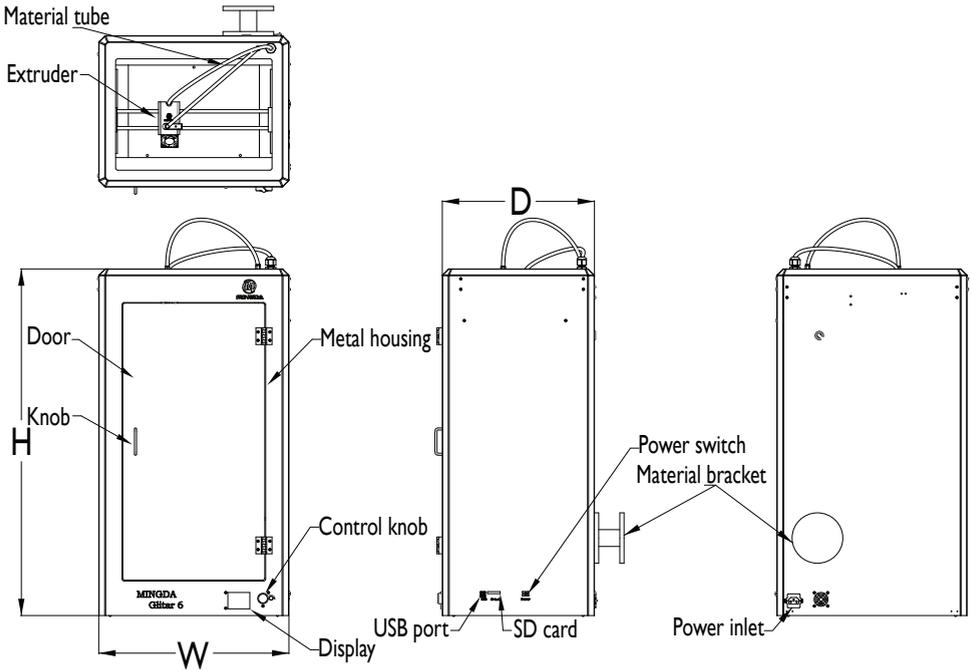
User Guide



MINGDA Technology Co.,LTD

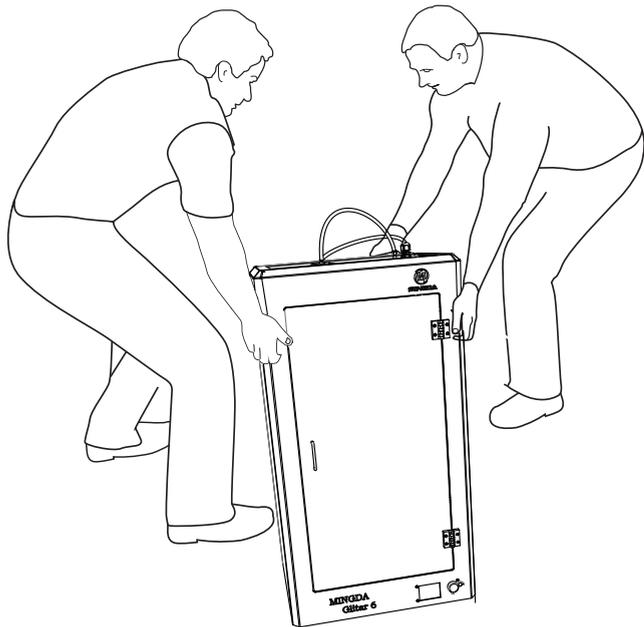
1

Overview



Model	Dimensions(H×W×D)mm	Print range(H×W×D)mm
Glitar 4		
Glitar 5		
Glitar 6	825×450×360	600×300×200

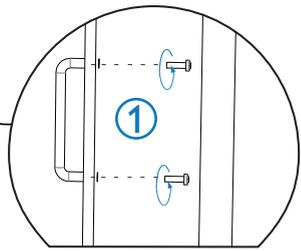
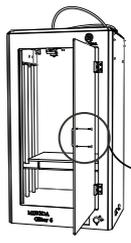
2 Unpack



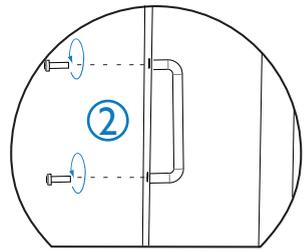
!

35kg

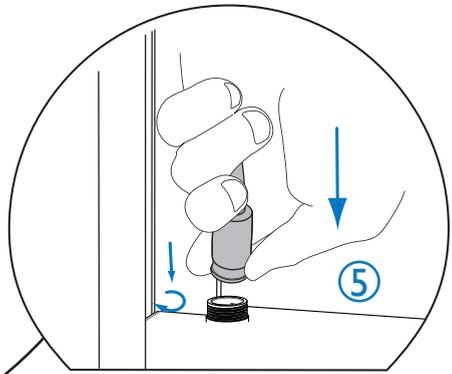
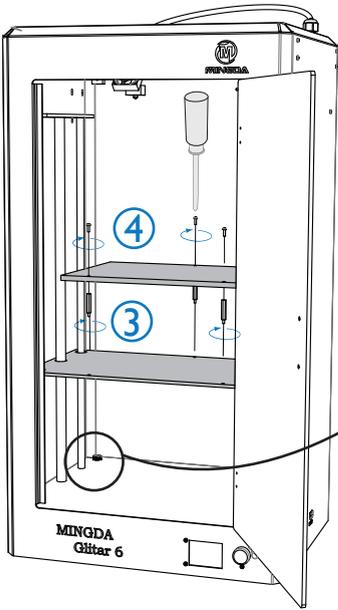
3 Installation



Disassemble screws



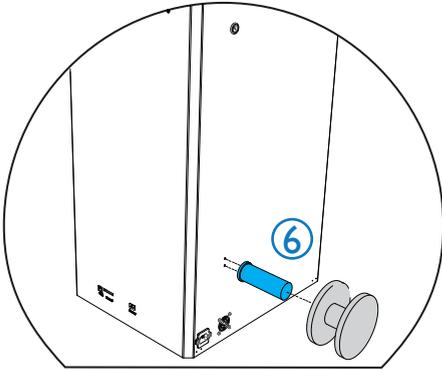
Assemble screws on opposite



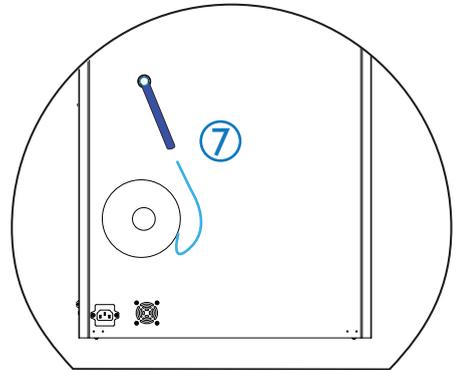
Install hot bed

Note:

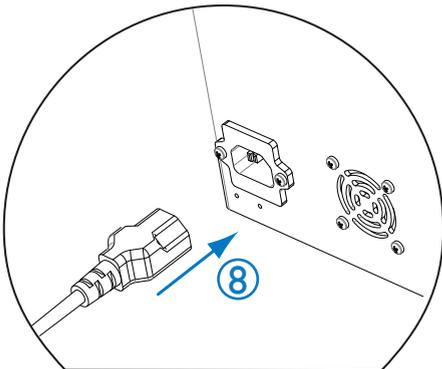
Because Mingda 3D printer is very exact, in case of hot bed has deviation during transportation, hot bed was packed individually.



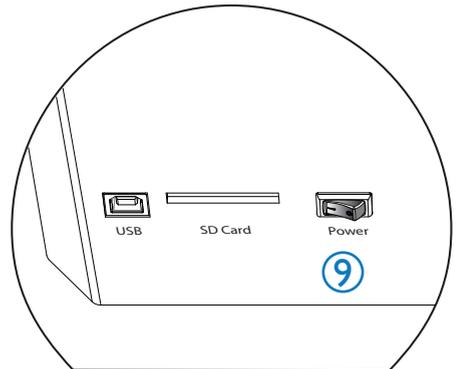
Install material bracket&filament material



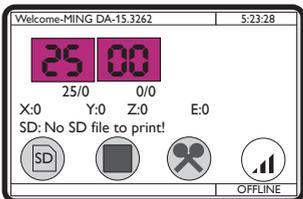
Insert filament material to tube



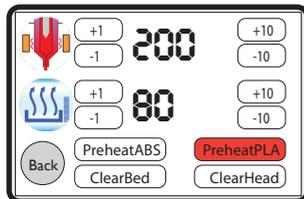
Connect power cable



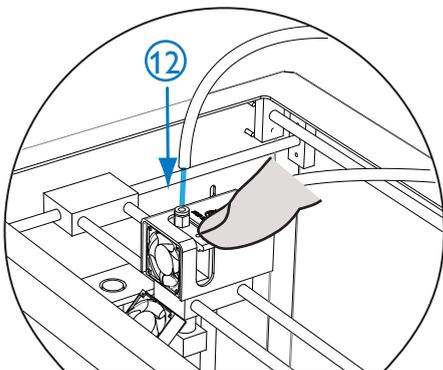
Turn the power ON



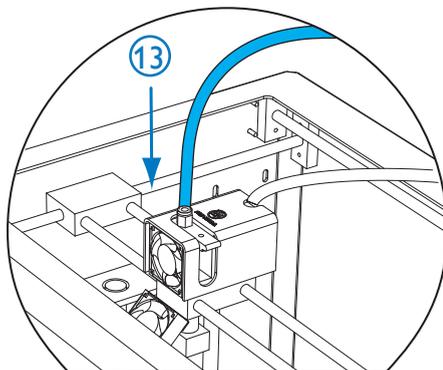
⑪ Rotate control knob to temperature option, press control knob.



⑫ Select **PreheatPLA**, change the nozzle temperature to 200°C, select **Back** to return main interface.

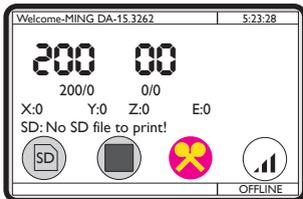


Once temperature is up to 200 °C, press retainer, and then insert material to nozzle.



Once melting wire flows out from nozzle, it means loading material is successful, then insert material tube.

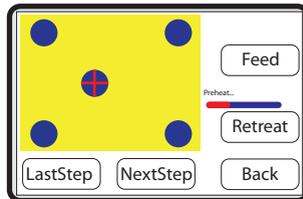
4 Calibration



① Select 



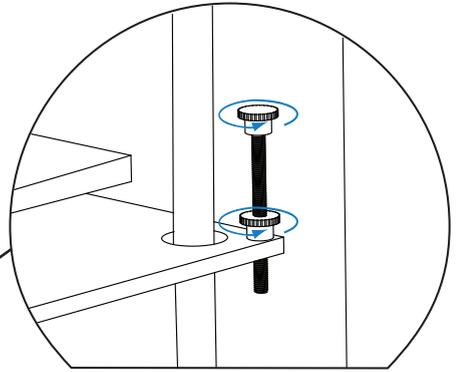
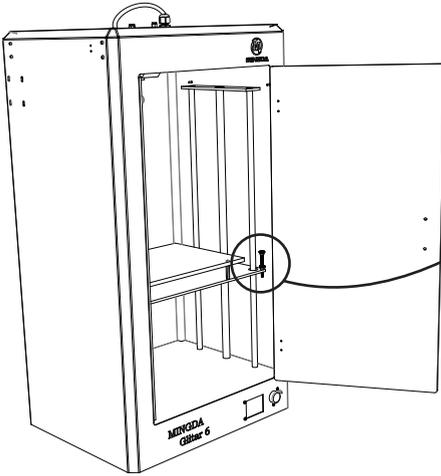
② Select 



③ Select **NextStep** for 5 times, and review the gap between nozzle with hot bed, it's recommended by ~0.1 mm (It's proximate to the thickness of paper).

Notes:

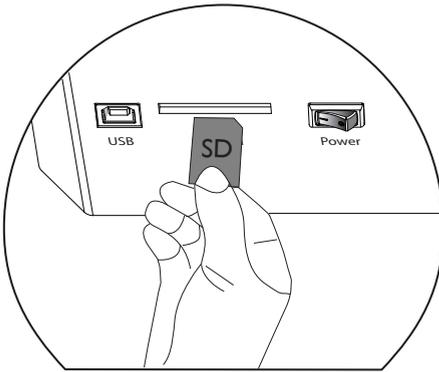
Only need to calibrate for the first time.



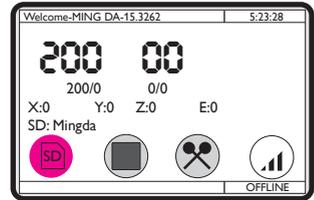
3

If gap is too large or too less, it needs to adjust the stopping switch.

5 Printing



1 Insert SD Card



2 Select 



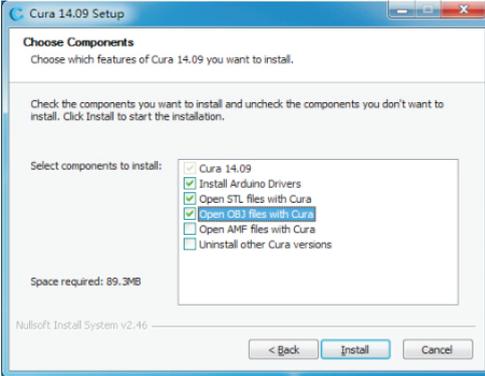
3 Select .gcode file to print.

Notes:

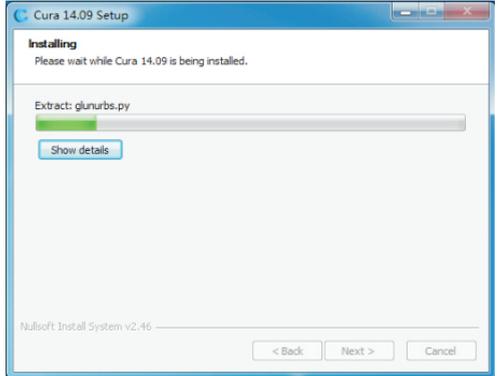
It's recommended to stick a masking tape on the hot bed.

6

Installing Cura 14 version and guide



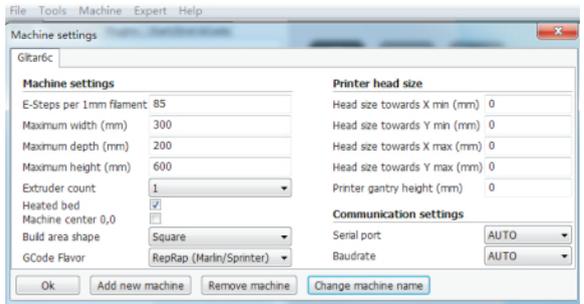
①



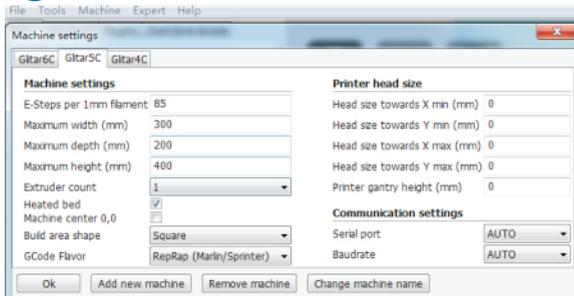
②



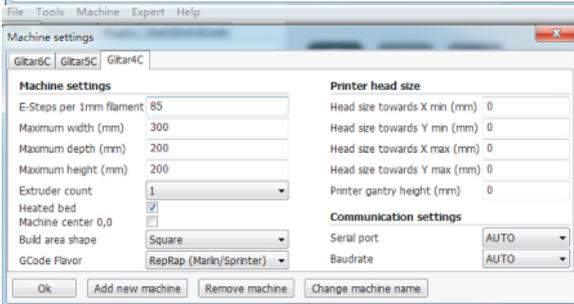
③



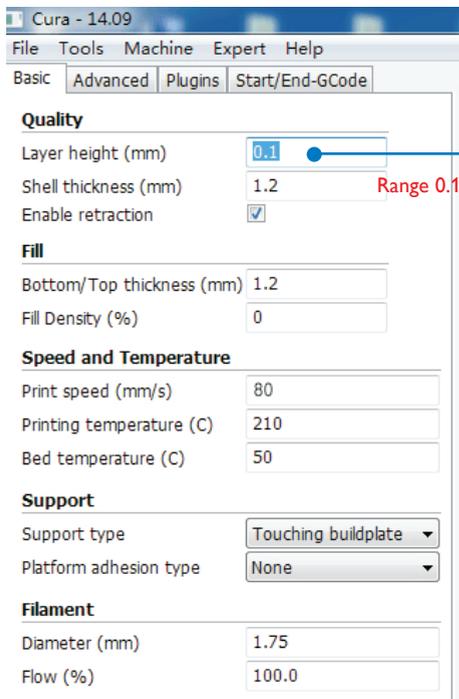
④



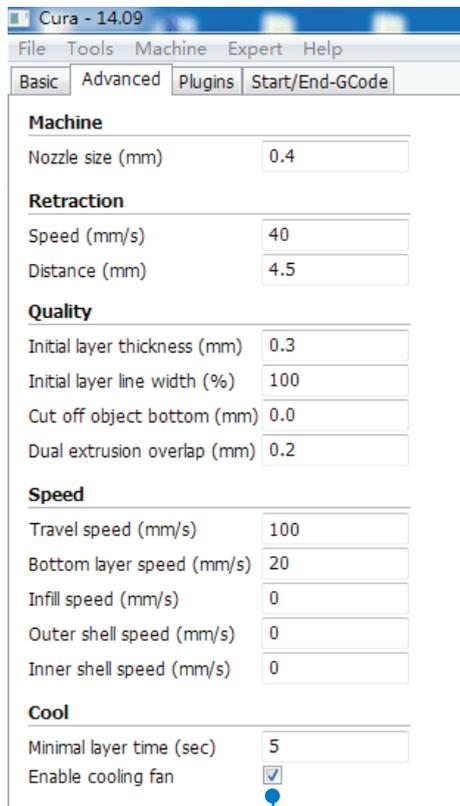
⑤



⑥



7



8

Printing Problem

Q1: The filament doesn't stick onto the build plate.

- A1: The gap between nozzle and build plate is too big.
- A2: The build plate has not been leveled yet.
- A3: Kapton tape has not been stuck on the build plate yet; or the non-sticky top layer of the Kapton tape is not removed.
- A4: The first layer's height is too small, recommended setting as ≥ 0.2

Q2: Print in the air.

A: The nozzle is too far from plate, please adjust the limitation switch or the screws under the heat bed.

Q3: No filament output from the nozzle.

A: The filament has not entered into the end of the nozzle yet when you feed the filament.

Q4: Model surface is loose with crack

A: The layer thickness is too big; Or printing speed is too high(the nozzle temperature needs to do responded balance to have a faster printing speed); Or the temperature is too low; Or the wall thickness is too thick; Or the feeding device's fixing screw is too loose; Or wrong choice of filament diameter; Or filament quality is poor; Or the filament gets stuck and could not be fed smoothly.

Q5: Model surface is unsmooth

A: Reduce the retraction travel; Or reduce minimal extrusion before retracting;

Q6: Failed prototyping of small model

A: If printing a small model, the extruder will always move in a small space, so the heat will be concentrated in the model, and hard to be distributed. The solution is to print 3-4 pieces of the small model together. If so, the extruder will move among different models, leaving time for heat dissipation.

Hardware problem

Q7: Filament Feeder Motor make intermittent noise

- A: 1. The clamp of the feeding device is too tight. Loosen the screw of the clamp.
2. Nozzle clogging, causing the filament not to be fed smoothly. Please clean the nozzle with drill and needle.

Q8: Nozzle clogged

A: 1. There is the impurity in the filament, which is stacked in the nozzle. Please clean the nozzle by the needle; or take the nozzle off and clean inside of the nozzle by needle and drill.

2. The nozzle is overheated causing the filament carbonized inside. Please clean the nozzle by needle; or take the nozzle off and clean inside of the nozzle by needle and drill.

3. The deformation of the nozzle hole occurred by external force. Please replace the nozzle.

Q9: The nozzle heating failed

A: 1. The heating tube connection is too loose. Please tighten the connection.

2. Check the heating wire is well connected to mainboard.

Q10: Print Head Stuck/ Cannot move

A: 1. The axis lack of lubricating oil. Please clean the axes and smear the lubricating oil evenly
2. The deformation of machine framework caused by external force during the transportation.

3. The cable connection of X.Y motor is loose. Please open the machine base, check and re-connect the cable.

Mingda Technology Co.,Ltd.

Address: MinLe Technical Building, Minle Industrial Zone, Meiban Road,
Longhua New district, Shenzhen, Guangdong Province, China.

Sales director: Doris

Cell Phone: 86-13500068891

Hot line: 86-0755-82783379

Fax: 86-0755-82788221

Email: md-99@163.com

Skype: mdantistatic

Website: www.md-3d.com

QQ: 751326193