FLASHFORGE®

Guider 3 Ultra / 引领者3 Ultra

Quick Start Guide

快速启动指南

⚠ WARNING
注意事项

1. Do not remove the wrapping around the nozzle.
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. 切勿去除包裹在喷嘴处的耐高温材料。
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。

1. Open the top carton cover, and remove the top foam containing the power cord, user guide, USB flash drive, and after-sales service card. Take out the whole outer box from bottom to top and then move the machine off the wooden base.
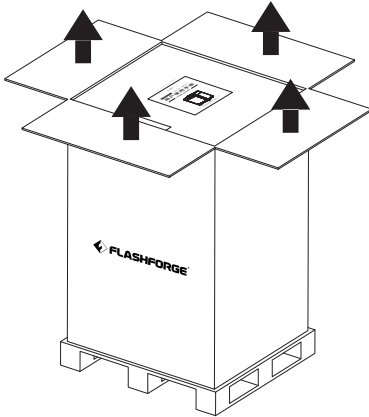
2. Open the front door. First remove (just pull out) the two foam cubes below the platform.

Foam cube   Foam cube
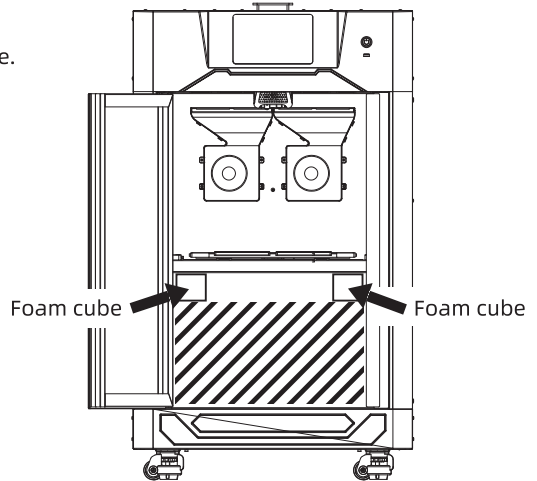
3. Then, remove the remaining foam below the platform, with two layers in total. The upper layer contains the tool kit. The lower layer contains the supplied filament, heat resistant gloves, and desiccant (for details, please refer to the packing list).

TOOL KIT
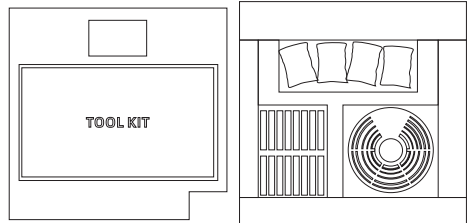
4. Cut the zip ties securing the extruder and guide rails with diagonal pliers. Ensure the extruder can move freely after ties are removed. Unboxing is completed.
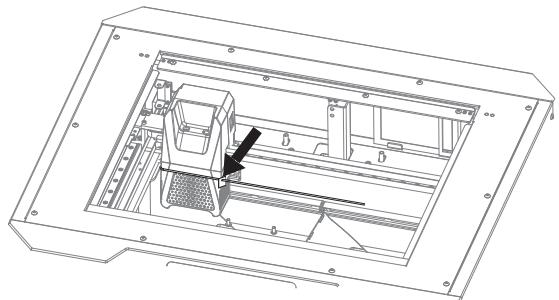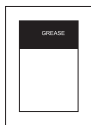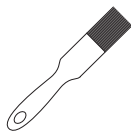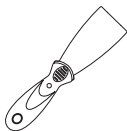
Packing List
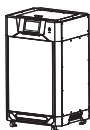
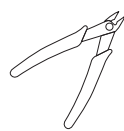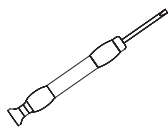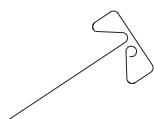|			
3D Printer	Power Cable	Grease x 2	Glue
Brush	Scraper	Needle-nose Pliers	Diagonal Pliers
Straight Screwdriver	Unclogging Pin Tool	Allen Wrench Set	Elbow Tweezers
Nozzle Assembly x 2	Heat Resistant Gloves	Filament x 2	USB Disk
After-sales Service Card	Quick Start Guide	Fuse x 2	Desiccant x 12
Flexible Steel Build Plate			
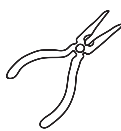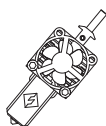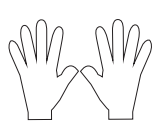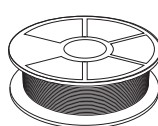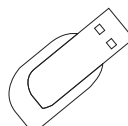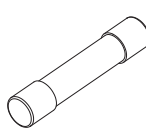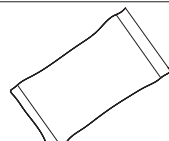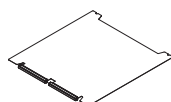
1. Top cover
2. Extruder
3. Screen switch
4. USB port
5. Front door
6. Flexible steel plate
7. Platform plate
8. Top cover handle
9. Air filter
10. Camera
11. Chamber light
12. Filament chamber
13. Hygrometer
14. Desiccant position
15. Heat dissipation holes
16. Power switch
17. Power port
18. Ethernet port
19. Air inlet
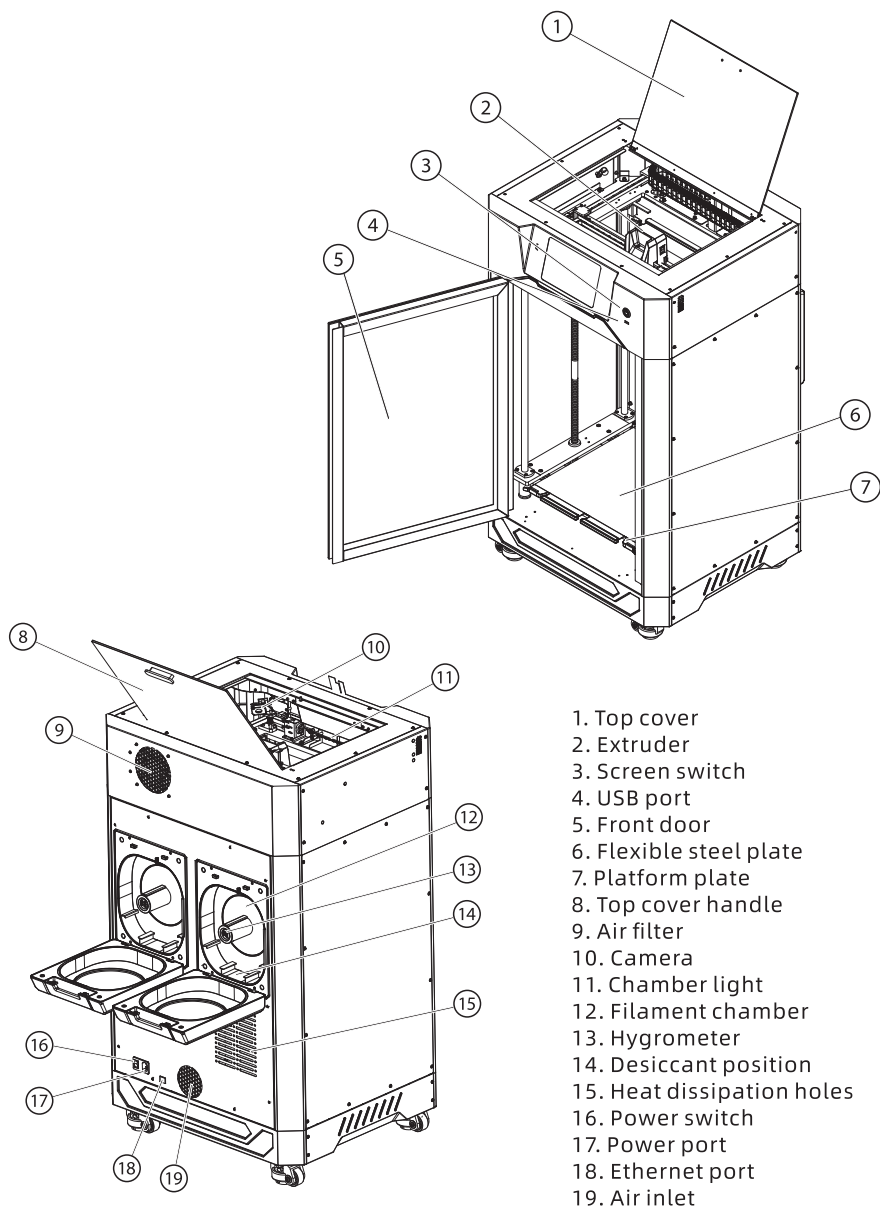
First Print

Platform Check

Check the flexible steel plate for proper installation within the rear limit. Ensure that the platform is mounted flat without pressing any foreign objects.
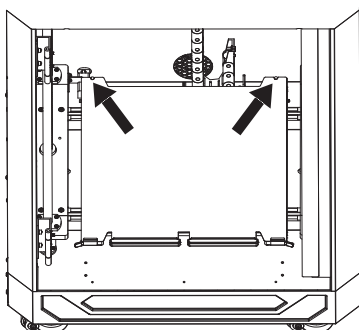
Printer Startup

1. Connect the power cord to the socket and the printer. Press the power switch to start the machine.
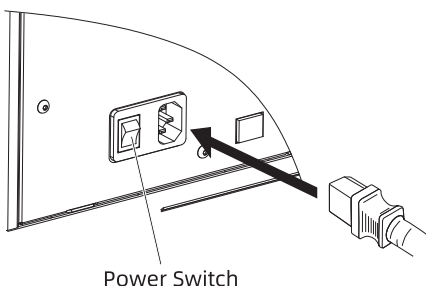
2. Press the screen switch. A solid light indicates the touch screen is activated.

Power Switch
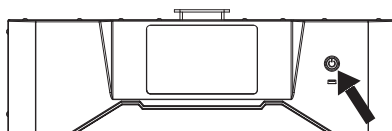
Boot Entry

On the first startup, the printer enters a boot setup process, enabling quick printer configuration and device status confirmation.
Operate the boot following the on-screen prompts. Steps are as follows:

Confirm the language   Skip the boot directly

1. Select the language.

中文   English   日本語

Deutsch   Français   Español

한국인

Next

04

2. Preparation Before Calibration:
Ensure that ties fixing the extruders are removed and there are no foreign objects on the build plate and nozzle end.

Make sure the inside of the machine is clean. Skip

Before continuing, please make sure that you have removed the ties fixing the extruder and there are no foreign objects above and below the platform.

Back   Next

3. Machine Calibration: Directly click [Calibration] to initiate automatic Z-axis calibration and platform leveling. For smooth printer running, it is not recommended to skip this step during the first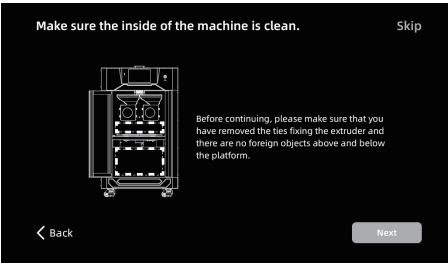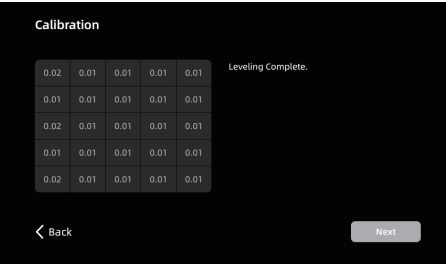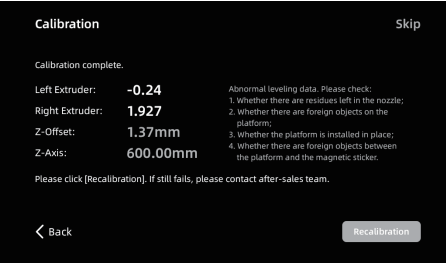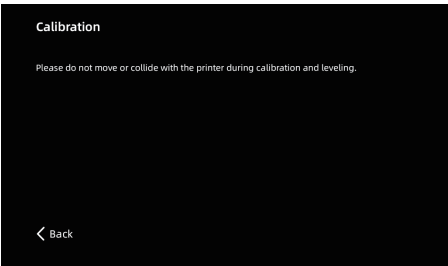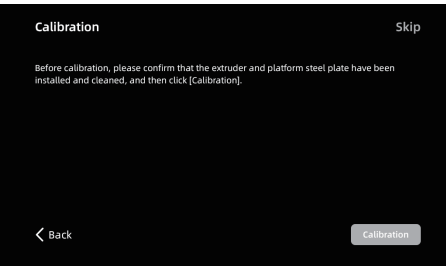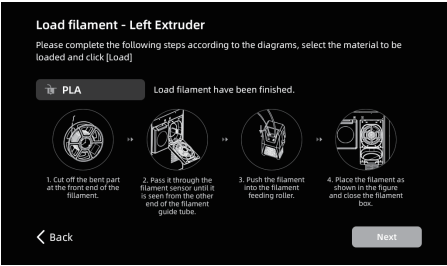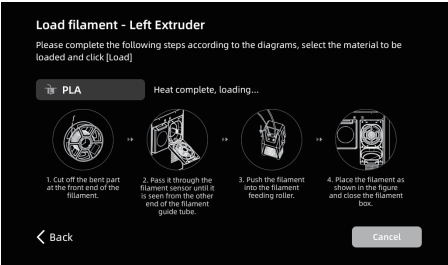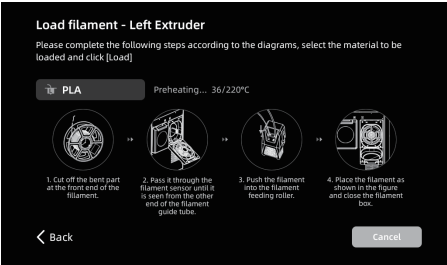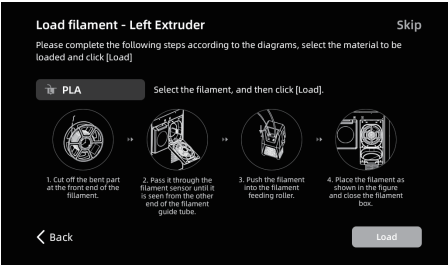 use. After replacing the extruder or platform plate, please perform Z-axis calibration and platform leveling. For details, please refer to Section 2.1 of Guider 3 Ultra User Guide.

Calibration Skip

Before calibration, please confirm that the extruder and platform steel plate have been installed and cleaned, and then click [Calibration].

Back   Calibration

Calibration

Please do not move or collide with the printer during calibration and leveling.

Back

Calibration Skip

Calibration complete.

Left Extruder: -0.24
Right Extruder: 1.927
Z-Offset: 1.37mm
Z-Axis: 600.00mm

Abnormal leveling data. Please check:
1. Whether there are residues left in the nozzle;
2. Whether there are foreign objects on the platform;
3. Whether the platform is installed in place;
4. Whether there are foreign objects between the platform and the magnetic sticker.

Please click [Recalibration]. If still fails, please contact after-sales team.

Back   Recalibration

Calibration

Leveling please wait..

9 / 25

		●	0.01	0.01	0.01
0.02	0.01	0.01	0.01	0.01

Calibration

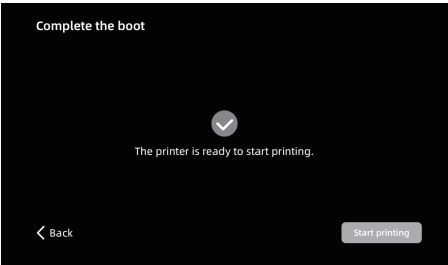| 0.02	0.01	0.01	0.01	0.01
0.01	0.01	0.01	0.01	0.01
0.02	0.01	0.01	0.01	0.01
0.01	0.01	0.01	0.01	0.01
0.02	0.01	0.01	0.01	0.01

Leveling Complete.

Back   Next

4. Filament Loading: Load filament into the left extruder following the on-screen instructions. Choose the material (PLA by default) and click [Load]. Wait for the nozzle to extrude filament to confirm successful loading.

⚠ Note

When loading filament, please pay attention to the left and right corresponding labels on the extruder, filament guide tube, and filament chamber. After successful loading, clean any filament extruded from the nozzle.
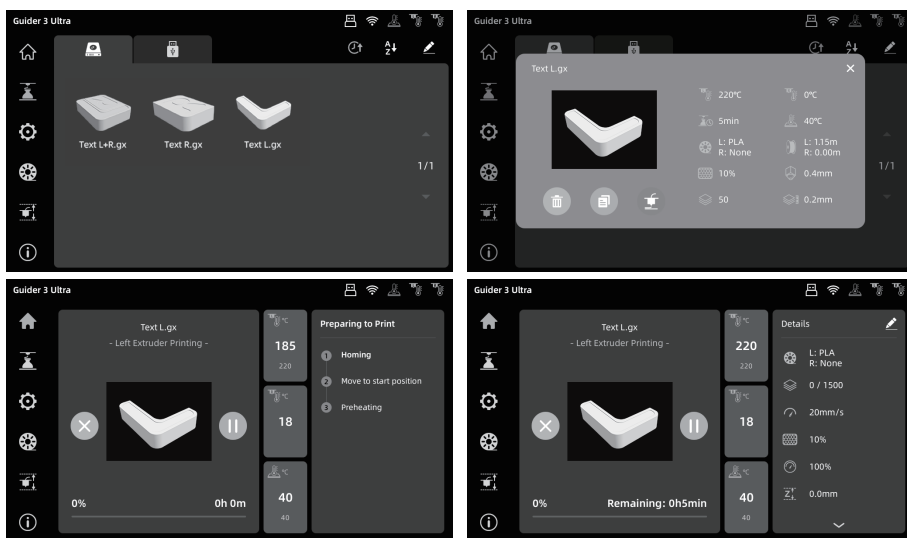
Load filament - Left Extruder   Skip

Please complete the following steps according to the diagrams, select the material to be loaded and click [Load]

PLA   Select the filament, and then click [Load].

1. Cut off the bent part at the front end of the filament.
2. Pass it through the filament sensor until it is seen from the other end of the filament guide tube.
3. Push the filament into the filament feeding roller.
4. Place the filament as shown in the figure and close the filament box.

Back   Load

Load filament - Left Extruder

Please complete the following steps according to the diagrams, select the material to be loaded and click [Load]

PLA   Preheating... 36/220°C

1. Cut off the bent part at the front end of the filament.
2. Pass it through the filament sensor until it is seen from the other end of the filament guide tube.
3. Push the filament into the filament feeding roller.
4. Place the filament as shown in the figure and close the filament box.

Back   Cancel

Load filament - Left Extruder

Please complete the following steps according to the diagrams, select the material to be loaded and click [Load]

PLA   Heat complete, loading...

1. Cut off the bent part at the front end of the filament.
2. Pass it through the filament sensor until it is seen from the other end of the filament guide tube.
3. Push the filament into the filament feeding roller.
4. Place the filament as shown in the figure and close the filament box.

Back   Cancel

Load filament - Left Extruder

Please complete the following steps according to the diagrams, select the material to be loaded and click [Load]

PLA   Load filament have been finished.

1. Cut off the bent part at the front end of the filament.
2. Pass it through the filament sensor until it is seen from the other end of the filament guide tube.
3. Push the filament into the filament feeding roller.
4. Place the filament as shown in the figure and close the filament box.

Back   Next

Complete the boot

The printer is ready to start printing.

Back   Start printing

5. After completing the above steps, the device is ready for printing. Click [Start printing] to go directly to the model selection interface.

Model Printing

Method 1: Select a model file from the local file list for printing. Inside the machine, there are three test models: Test L.gx (left-extruder printing test model), Test R.gx (right-extruder printing test model), and Test L+R.gx (dual-extruder printing test model). Choose Test L.gx, and then click the 🖶 icon on the pop-up window to start printing. (Note: Please select the Test L.gx model for the printing test as the left extruder is the default extruder for loading filament. Do not reach your hand into the print area after starting printing.)

⚠ **ATTENTION**

To print the Test R.gx (right-extruder printing test model) or Test L+R.gx (dual-extruder printing test model), first load filament for the corresponding extruder before printing. Please perform XY offset calibration of the left and right nozzles before using dual-extruder printing for the first time. Follow these steps:

1. Access the [Leveling and Calibration] interface, and click the icon to enter the [XY Calibration] interface. After clicking [Start], the printer will automatically heat up, and both left and right nozzles will print a test line in the XY direction respectively.
2. After printing is completed, measure the deviation distance between the two lines printed in the same direction using a ruler. Compare the printed test lines with the examples on the screen. Adjust the XY spacing of the right nozzle according to the instructions.
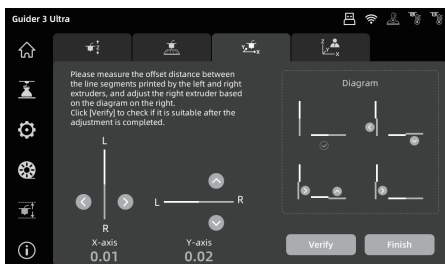
3. After adjusting is completed, click [Verify] to print the test lines again. If there is still any deviation, please repeat steps 1 and 2. When the actual printed lines are like the image below, it indicates that the XYZ offset values of the left and right nozzles are within a reasonable range.
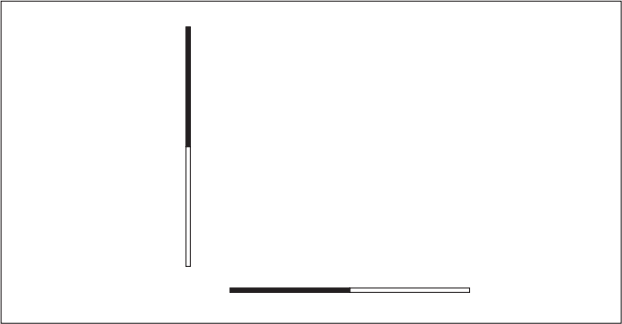
Method 2: Print via USB: Insert the provided USB flash drive into the printer. The USB drive contains pre-sliced test files for your first print. Go to the [Print] interface, click the icon on the touch screen to access the USB drive files, and select the desired file to begin printing.
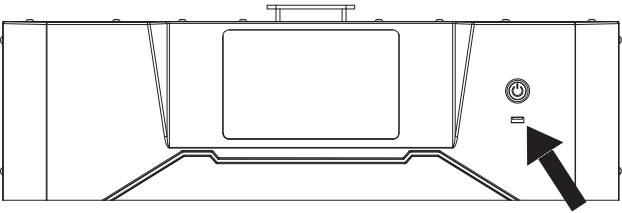
⚠ **ATTENTION**

1. Upon print completion, both the nozzle and build plate may still be hot. It is recommended to remove the model after the bed has cooled down.
2. Take the platform plate to the outside of the device for model removal, otherwise model debris will remain in the device. Please keep the chamber clean.
3. Directly remove the flexible steel plate and remove the model by bending the platform. For subsequent printing, please ensure there are no filament residues on the platform.

After printing is completed, open the front two latches of the platform plate, remove the entire platform plate, and then bend it to remove the model.
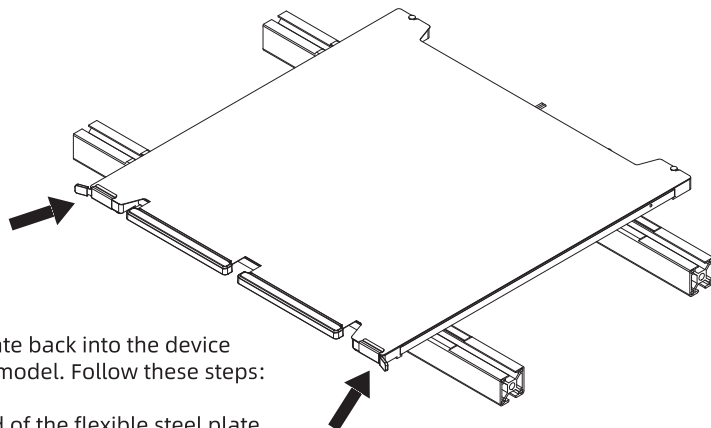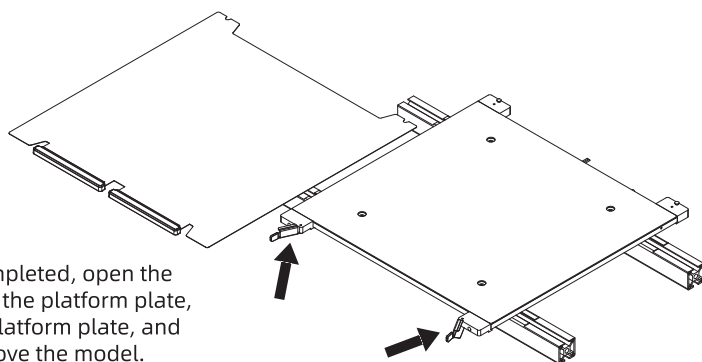
Put the platform plate back into the device after removing the model. Follow these steps:

1. Align the rear end of the flexible steel plate with the positioning blocks on the left and right edges of the platform, ensuring it is inserted into the slot.
2. Close the latches until the flexible steel plate is securely fixed in place.

1. 拆开顶部纸盖后，取出机器顶部泡沫，内有电源线、用户手册、U盘和售后服务卡。再从下往上将整个外箱取出，然后将机器搬离木制底座。
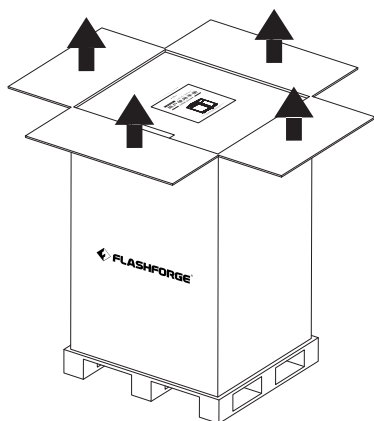
2. 打开设备前门，首先取出（拉出即可）平台下方最上面的两根方型泡沫棉。

方型泡沫棉　　　　　　　　　　　　　方型泡沫棉
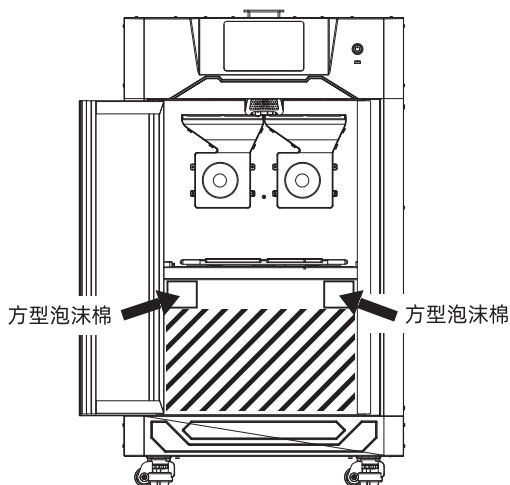
3. 随后取出平台下方的其余泡沫棉，共2层，上层为工具配件包；下层为附赠耗材、高温手套、干燥剂。（详细参考装箱清单）。

TOOL KIT
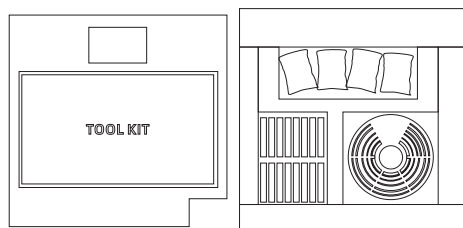
4. 使用斜口钳减去固定喷头和导轨上的扎带。移除后能正常移动喷头即可，完成开箱。
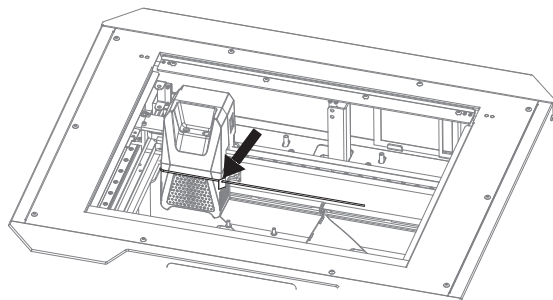
装箱物品
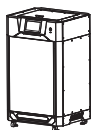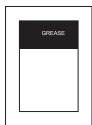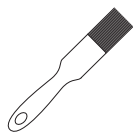
3D打印机	电源线	润滑脂 x 2	水洗胶
毛 刷	铲 刀	尖嘴钳	斜口钳
一字螺丝刀	通 针	内六角扳手套装	弯头镊子
喷嘴组件 x 2	隔热手套	3D打印耗材 x 2	U盘
售后服务卡	快速启动指南	保险丝 x 2	干燥剂 x 12
柔性钢板平台			
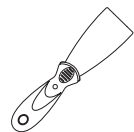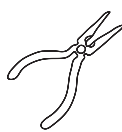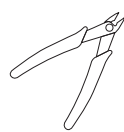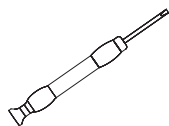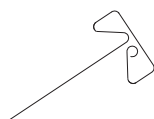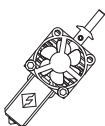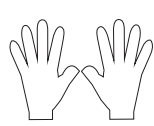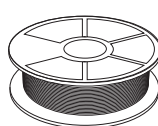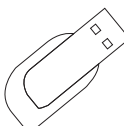
1. 上盖　　2. 喷头　　3. 屏幕开关

4. USB接口　　5. 前门　　6. 柔性钢板

7. 平台板　　8. 上盖把手　　9. 空气过滤

10. 摄像头　　11. 腔体灯　　12. 耗材仓

13. 耗材仓湿度计　　14. 干燥剂放置处

15. 驱动板散热孔　　16. 电源开关

17. 电源接口　　18. 网线接口

19. 进风口
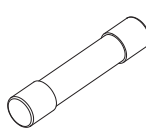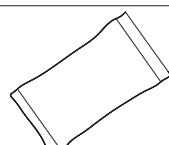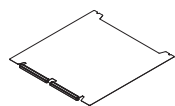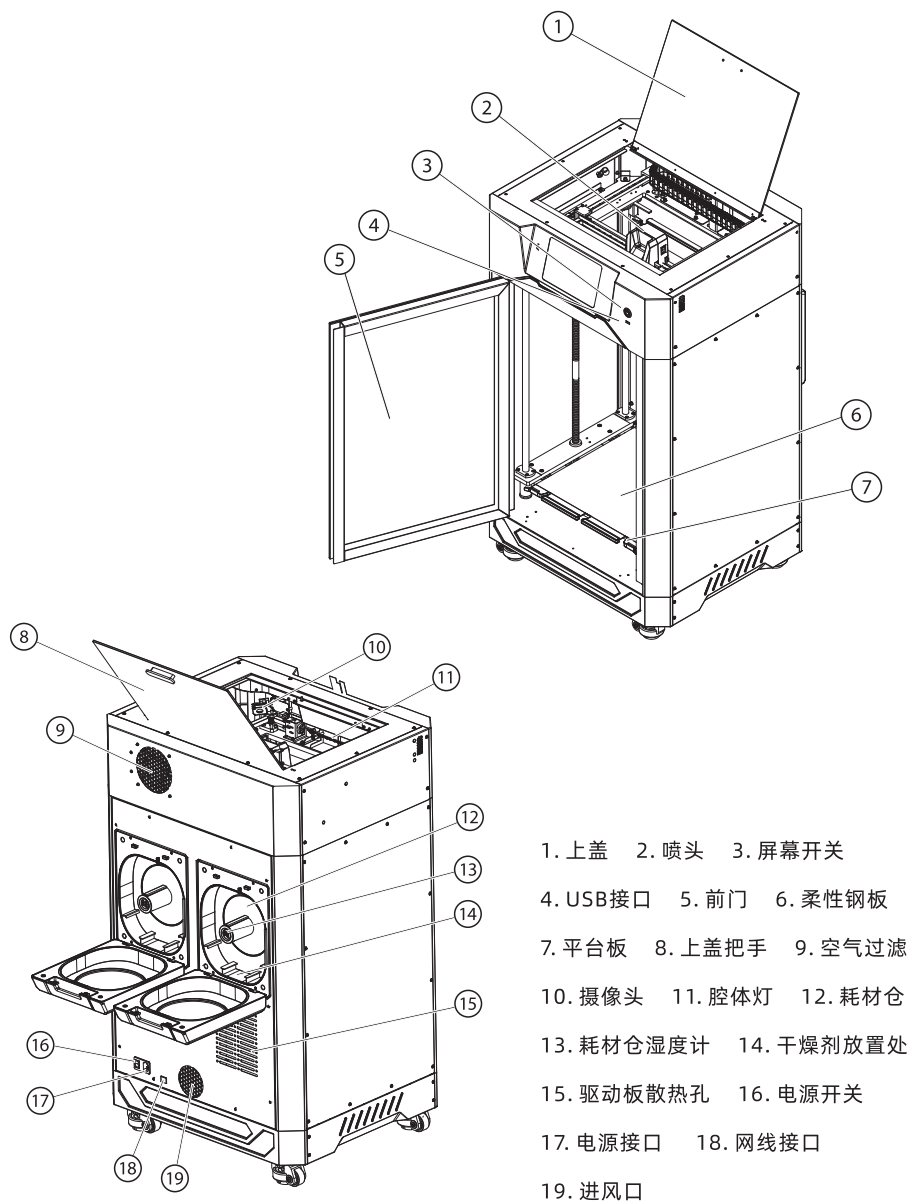
首次打印

检查平台

检查机器平台柔性钢板是否安装到位，是否
已安装在后方限位内。确保平台安装平整，
没有压到任何异物。
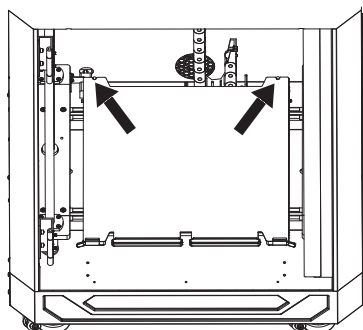
启动设备

1. 将电源线连接插座与设备，按下电源
   开关按钮，启动机器。

电源开关
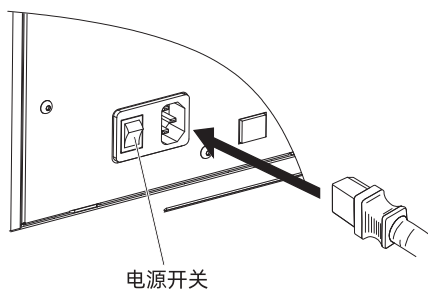
2. 按下屏幕开关，按钮灯长亮表示已开启
   触控屏。
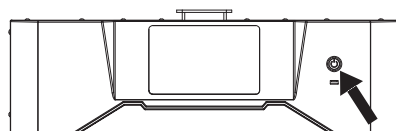
进入开机引导
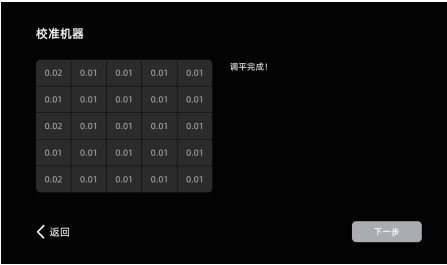
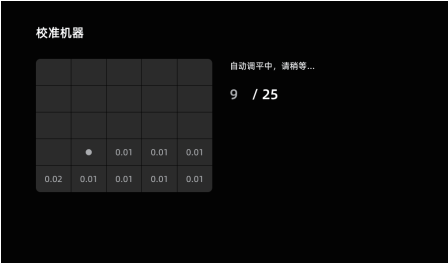设备首次开机会进入开机引导流程，让您快速设置打印机，并确认设备状态是否正常。
开机引导可按触控屏提示操作，步骤如下：
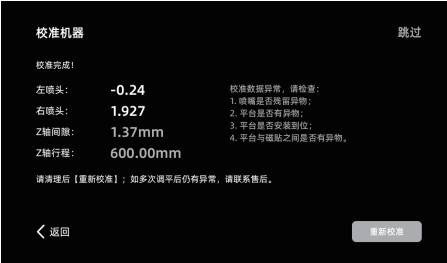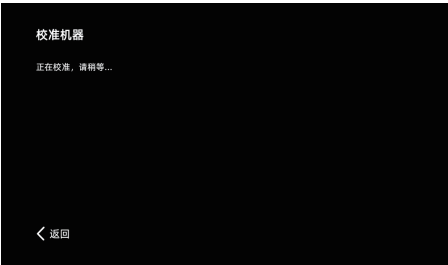
1. 确认机器语言。

确认机器语言   直接跳过引导

中文   English   日本語

Deutsch   Français   Español

한국인

下一步
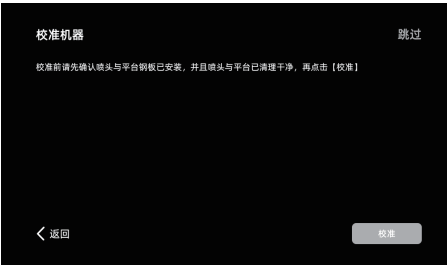
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2. 机器校准前准备，请确认固定喷头的轧带已移除，打印平台和喷嘴端无异物残留。

确认机器内部清理干净　　　　　　跳过

继续操作之前，请确认您已移除固定喷头的轧带，平台上方和下方无异物。

〈 返回　　　　　　　　　　　下一步

3. 校准机器，直接点击[校准]按钮既可开始Z轴自动校准和平台自动调平。首次使用机器为保证设备运行顺畅，不建议跳过此步骤，如果更换喷头或平台板需要单独进行Z轴校准和平台调平操作，可参考Guider3 Ultra用户使用手册2.1步骤。

校准机器　　　　　　　　　　跳过

校准前请先确认喷头与平台钢板已安装，并且喷头与平台已清理干净，再点击【校准】

〈 返回　　　　　　　　　　　校准

校准机器

正在校准，请稍等...

〈 返回

校准机器　　　　　　　　　　跳过

校准完成！

左喷头：	-0.24
右喷头：	1.927
Z轴间隙：	1.37mm
Z轴行程：	600.00mm

校准数据异常，请检查：
1. 喷嘴是否残留异物；
2. 平台是否有异物；
3. 平台是否安装到位；
4. 平台与磁贴之间是否有异物。

请清理后【重新校准】；如多次调平后仍有异常，请联系售后。

〈 返回　　　　　　　　　　　重新校准

校准机器

| | | | |
| 0.02 | 0.01 | 0.01 | 0.01 |

自动调平中，请稍等...

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校准机器

0.02	0.01	0.01	0.01	0.01
0.01	0.01	0.01	0.01	0.01
0.02	0.01	0.01	0.01	0.01
0.01	0.01	0.01	0.01	0.01
0.02	0.01	0.01	0.01	0.01

调平完成！

〈 返回　　　　　　　　　　　下一步

4. 装载丝料：按触控屏上的线框图提示对左喷头进行丝料的装载，选择材料（默认PLA材料）后点击[进丝]按钮，待喷嘴吐出丝料即进丝成功。

提 示

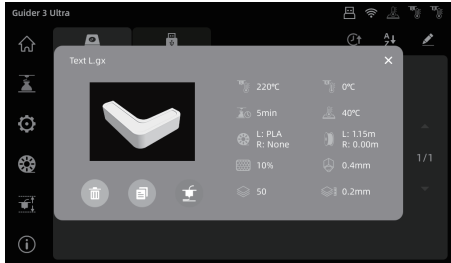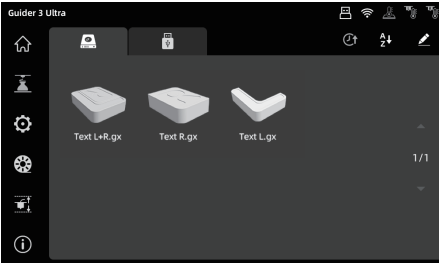装载丝料时，请注意喷头、导丝管和耗材舱上的左、右对应的标贴提示。丝料装载成功后，将喷嘴吐出的丝料清理干净。
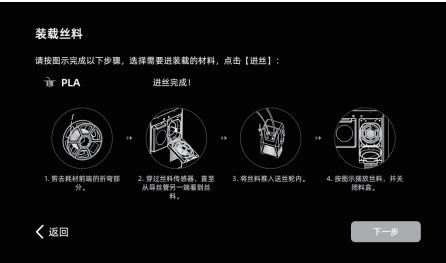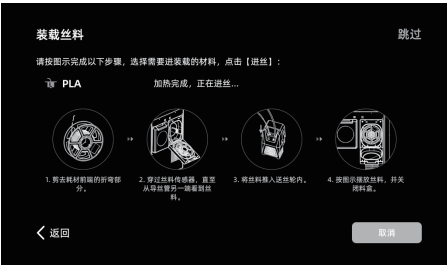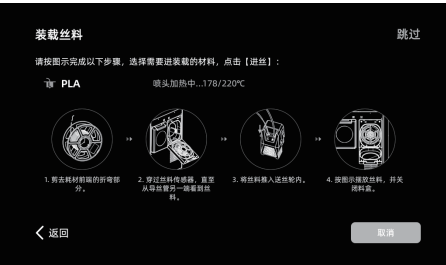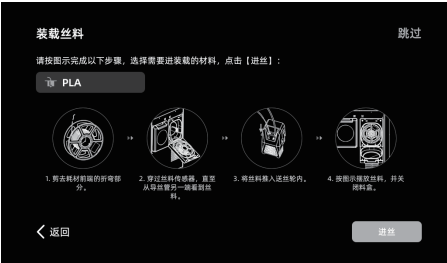
5. 完成以上步骤，设备可开始打印工作，点击**[开始打印]**按钮可直接跳转至打印模型选择界面。

**方法一：** 在本地文件列表中选择模型文件进行打印。机器设备内会有三个测试模型，分别是
Test L.gx(左喷头测试模型)、Test R.gx（右喷头测试模型）、Test L+R.gx(双头打
印测试模型)。选择Test L.gx模型，然后在弹窗页面点击 ▬ 图标即可开始打印。
（提示：开机引导默认是左喷头加载丝料，所以请选择Test L.gx模型进行打印测试。
开始打印后，请勿将手伸进打印区域)

⚠ 注意事项

如需打印Test R.gx（右喷头测试模型）或Test L+R.gx(双喷头测试模型)，请先将对应的喷头加载
丝料后再进行测试，且在首次使用双喷头打印前，先进行一次左右喷嘴XY轴偏移值校准，步骤如下：

1. 进入校准调平界面，在触控屏上点击图标 ⚙x 进入**[XY轴校准]**界面，点击**[开始]**后，打印机
   会自动加温，左右喷嘴会在XY方向上各打印一条测试线。
2. 打印完成后，可以用尺子测量实际打印同方向两条线的偏差距离。将打印的测试线与屏幕
   上的示例进行比较。对照示例的提示进行右喷嘴XY间距的调整。
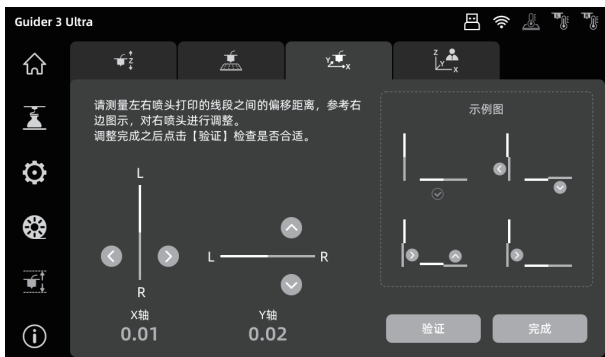
3. 调整完后点击[验证]按钮再次打印测试线，如果还存在偏移情况，请重新执行步骤1和2的操作。
   当实际打印线如下图所示，说明左右喷嘴 XYZ 方向偏移值在合理的范围内。
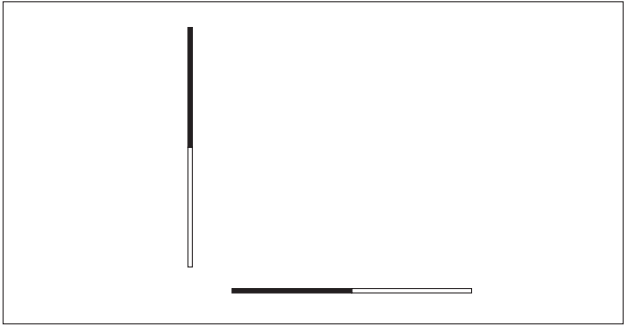
方法二： U盘打印，将随机配送的U盘插入打印机， U盘内存有已切片好的测试文件，可用于
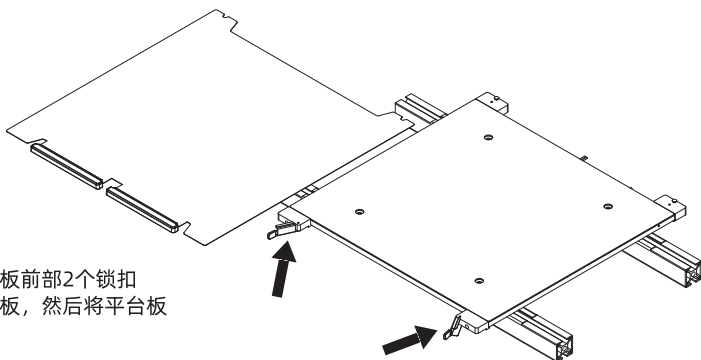完成首次打印。 进入[打印]界面，在触控屏上点击 [图标] 图标 进入U盘文件界面，选择
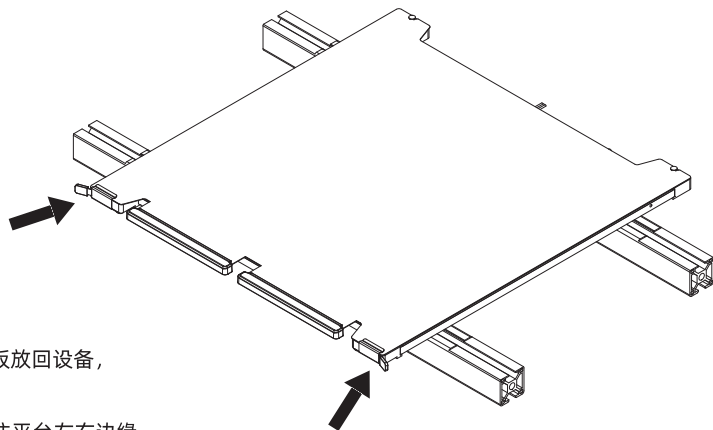对应的文件即可打印。
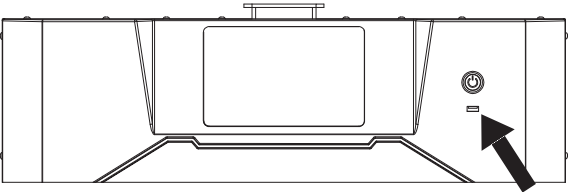
⚠ **注意事项**

1. 打印完成时，喷嘴和打印平台仍处于高温状态，建议冷却后再移除模型。

2. 将平台板拿到设备外部再进行移除，否则模型碎屑容易留在设备腔体内，建议保持腔体清洁。

3. 直接取出平台柔性钢板，折弯平台即可取下模型。二次打印时，请确保平台 无残余丝料。

打印完成后，将平台板前部2个锁扣
打开，取出整个平台板，然后将平台板
折弯即可取下模型。

取下模型重新将平台板放回设备，
操作如下：

1. 将柔性钢板后端顶住平台左右边缘
   的定位块；注意要插入卡槽内。
2. 合上锁扣直至固定住柔性钢板。

FLASHFORGE®

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