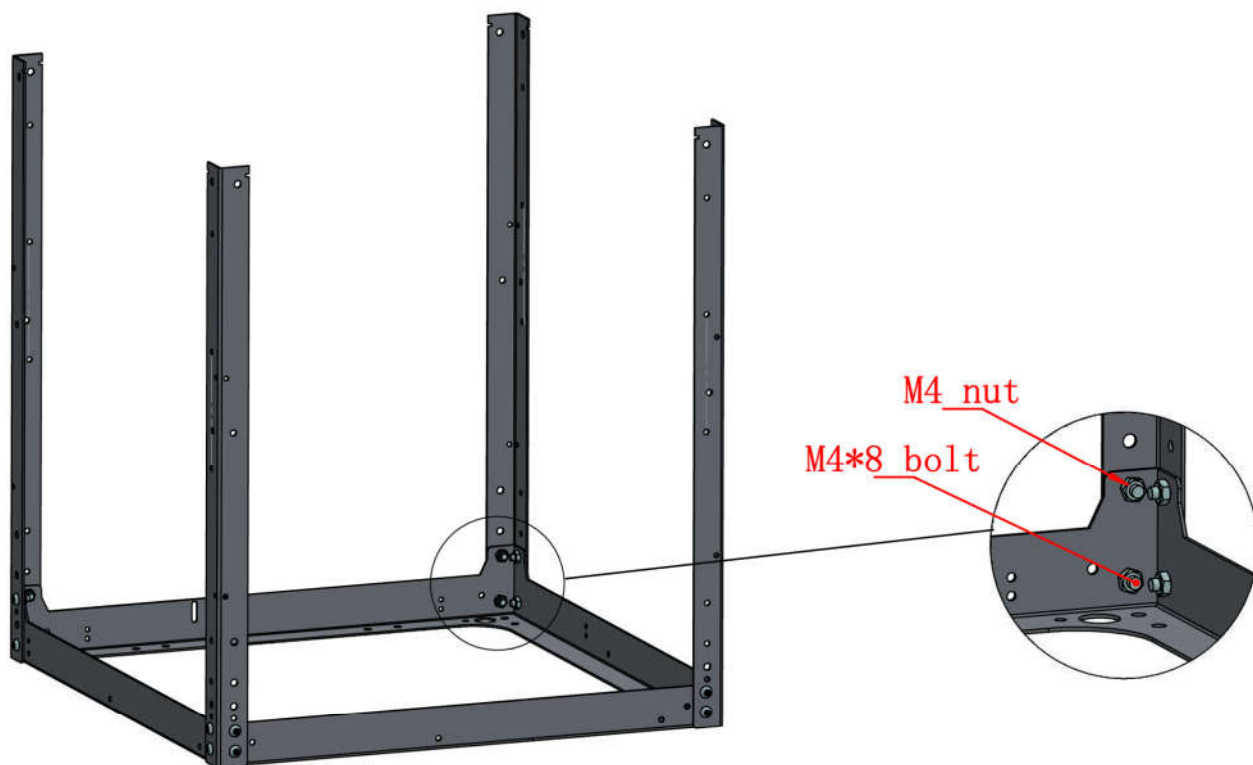


Flyingbear-P905 Installation Manual

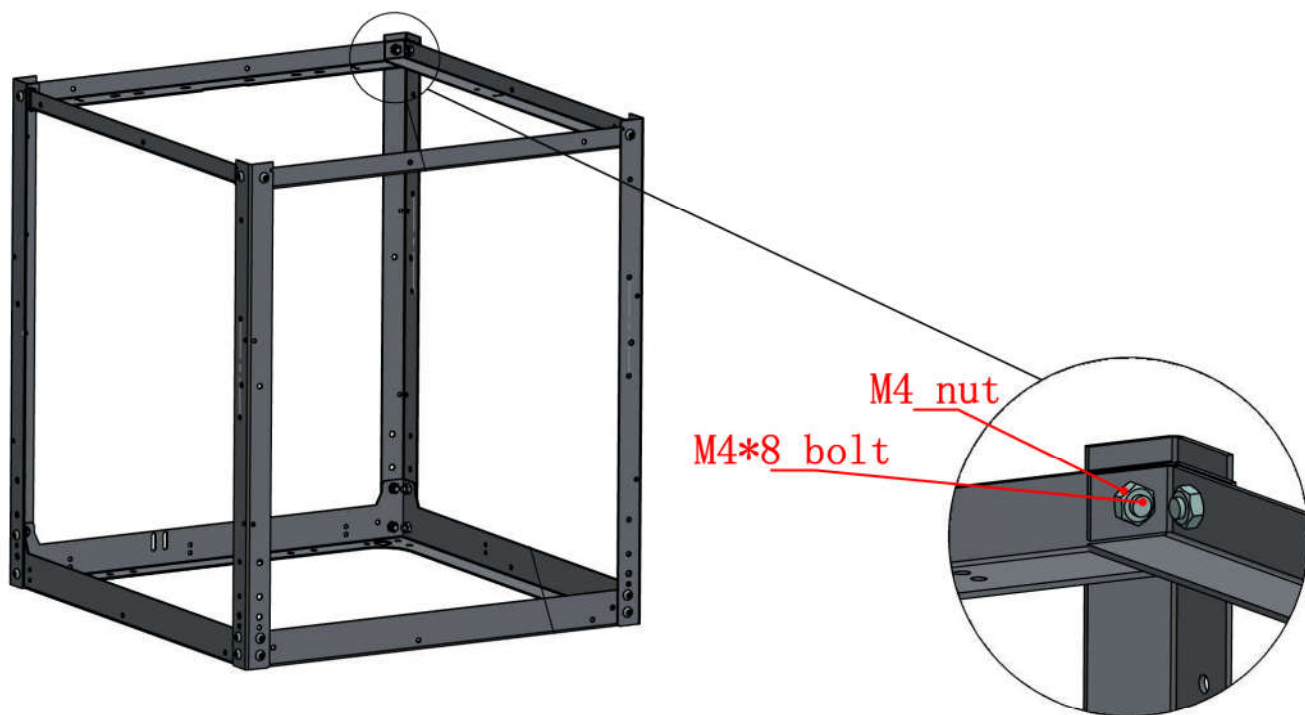
1.Frame installation-----	1
2.Z-axis installation-----	2
3.Hot-bed installation-----	5
4.Drive shaft installation-----	7
5.Y axis motor installation-----	9
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10.Motherboard and LCD installation-----	20
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12.Synchronous belt installation-----	22
13.Setting up slicing software-----	23
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1、Frame installation

Step 1 -----

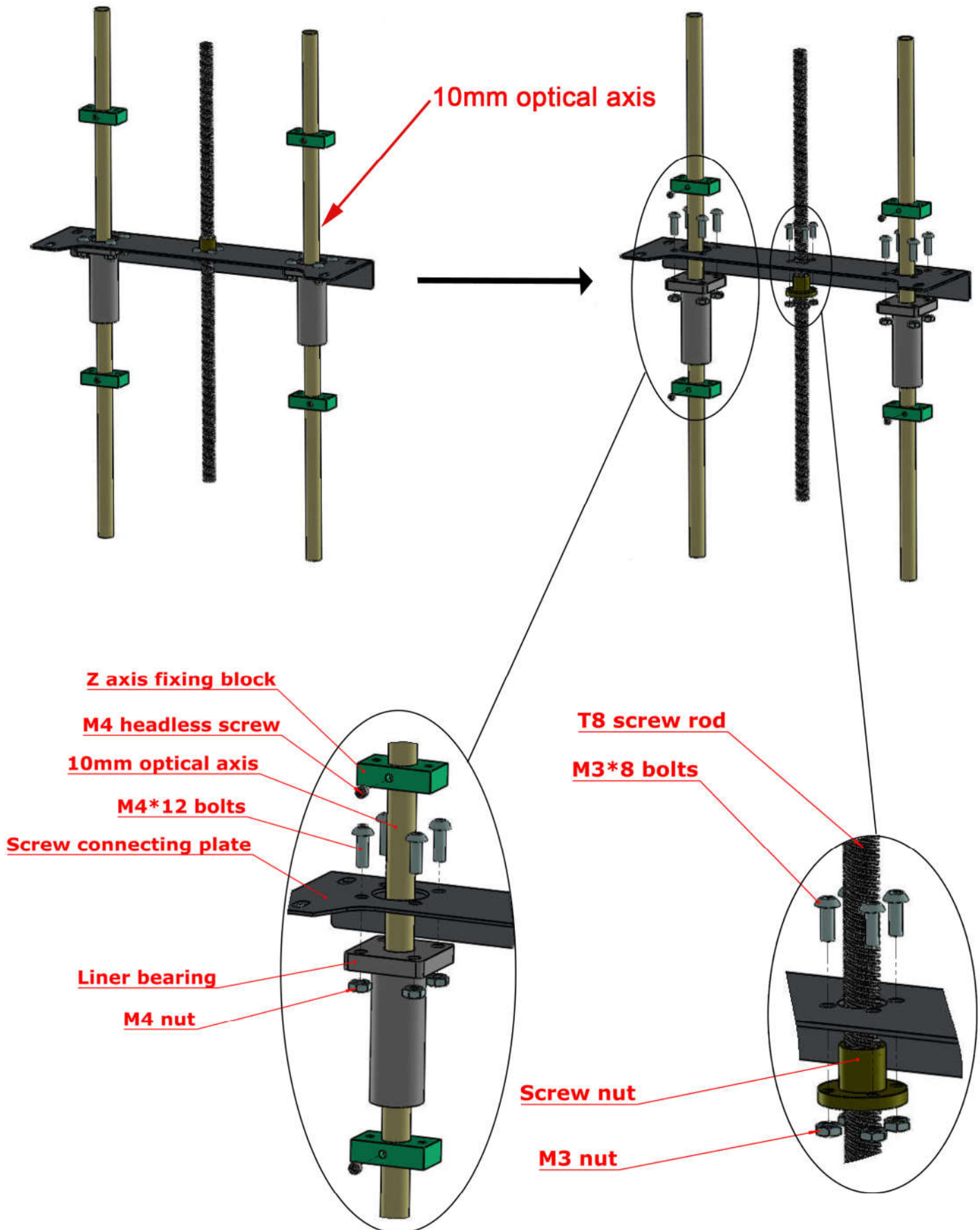


Step 2 -----



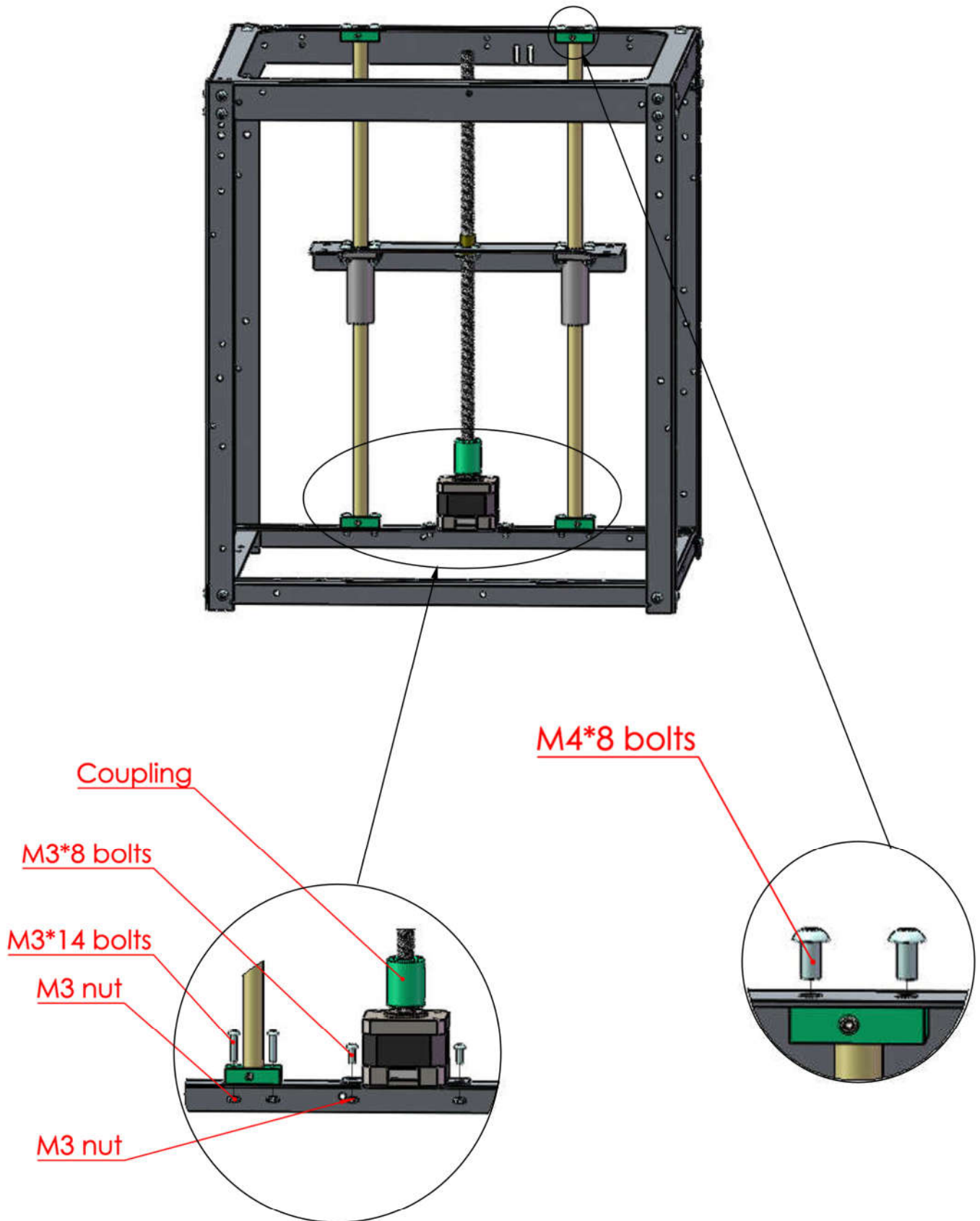
2. Z axis installation

Step 1 -----



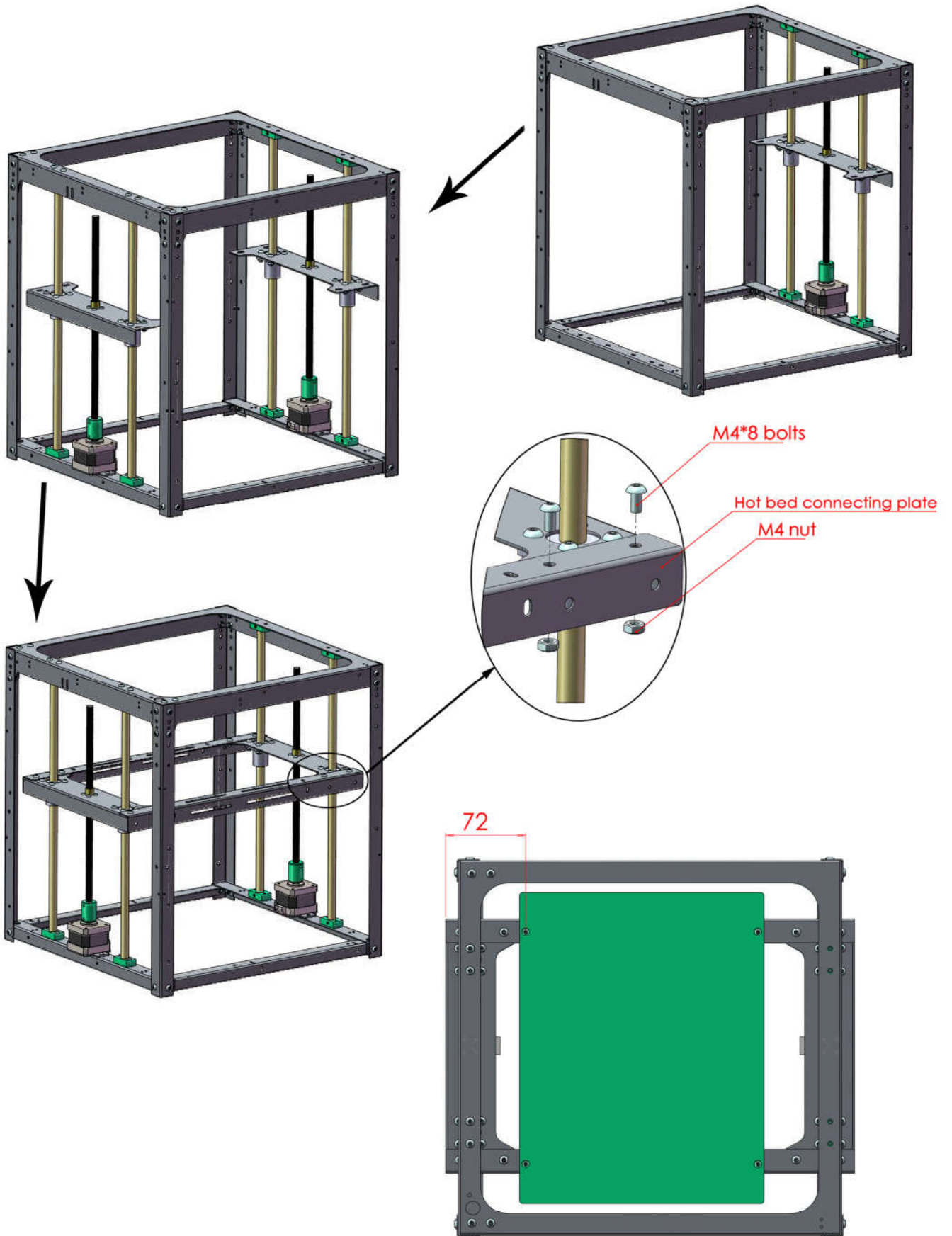
2. Z axis installation

Step 2 -----



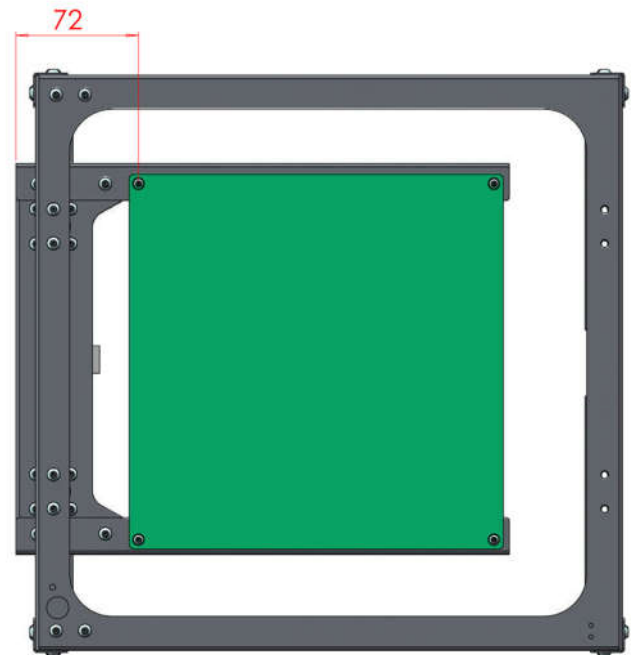
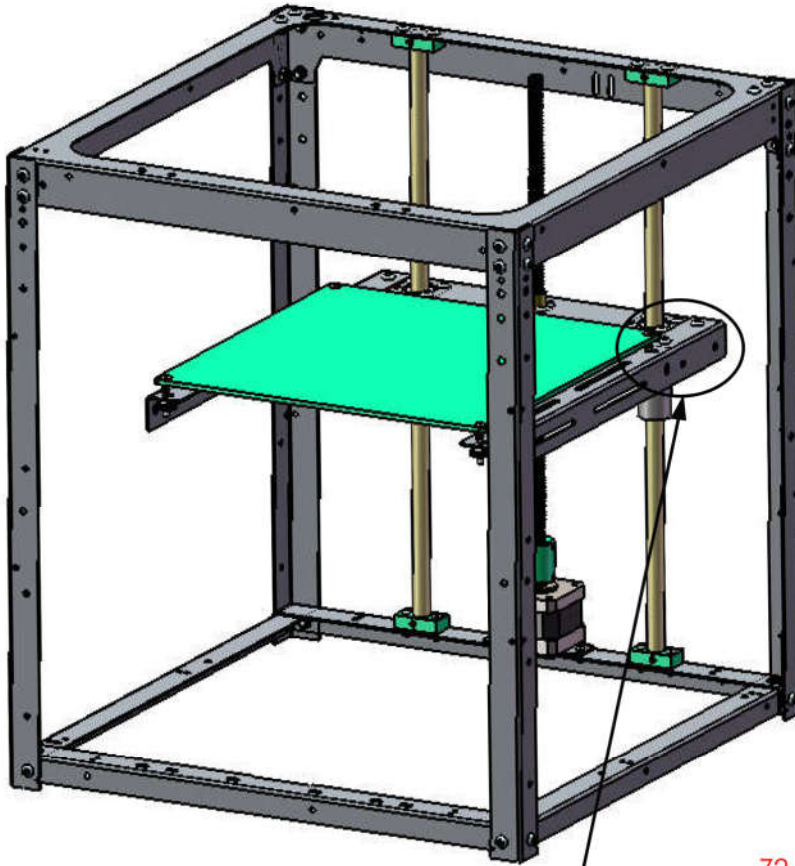
2. Z axis installation

If you are dual Z axis version, you can refer to the installation method

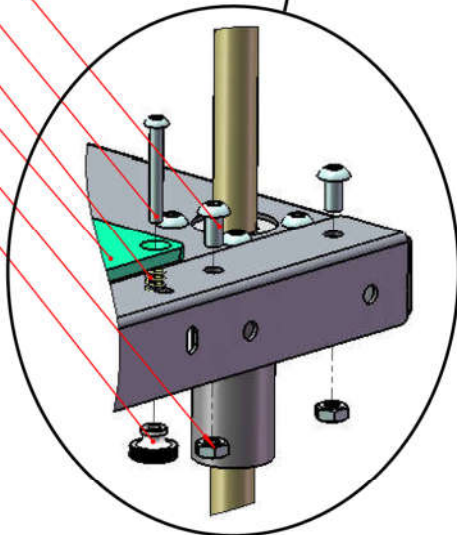


3. Hot bed installation

Step 1 -----

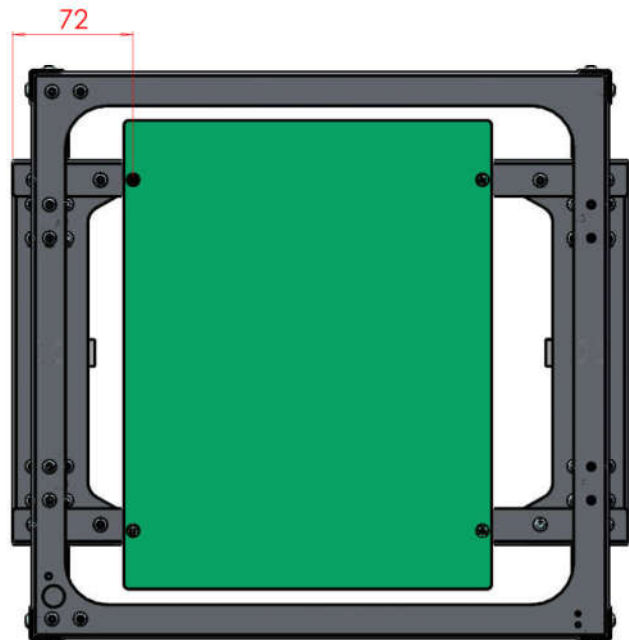
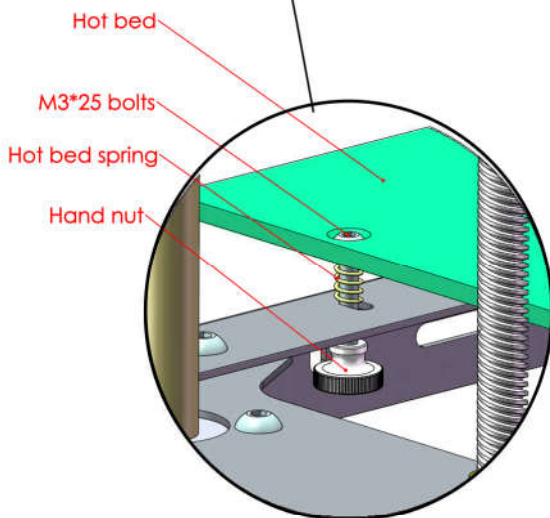
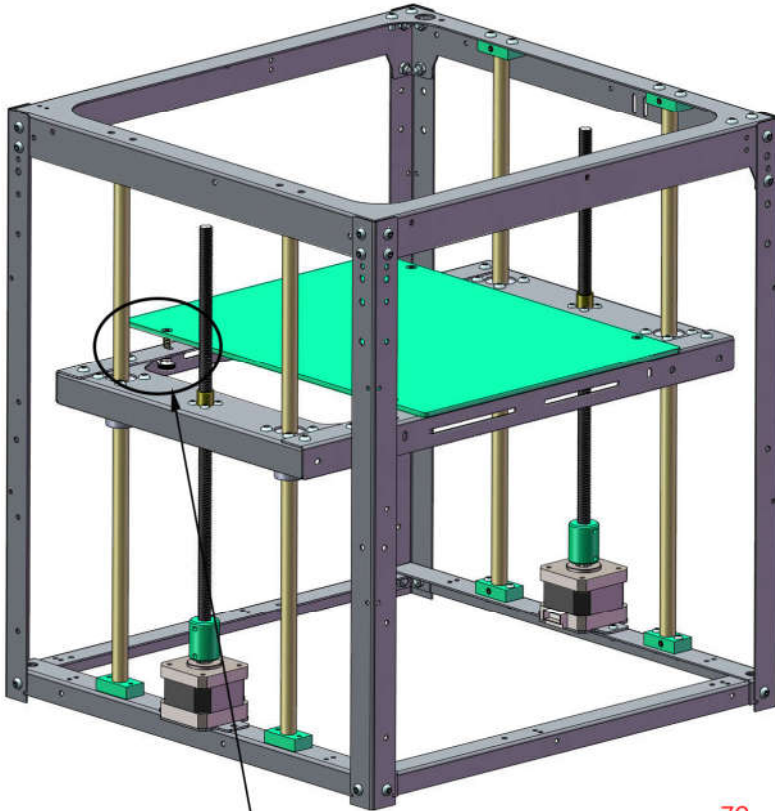


- M4*8 bolts
- M3*25 bolts
- Hot bed spring
- Hot bed
- M3 nut
- Hand nut



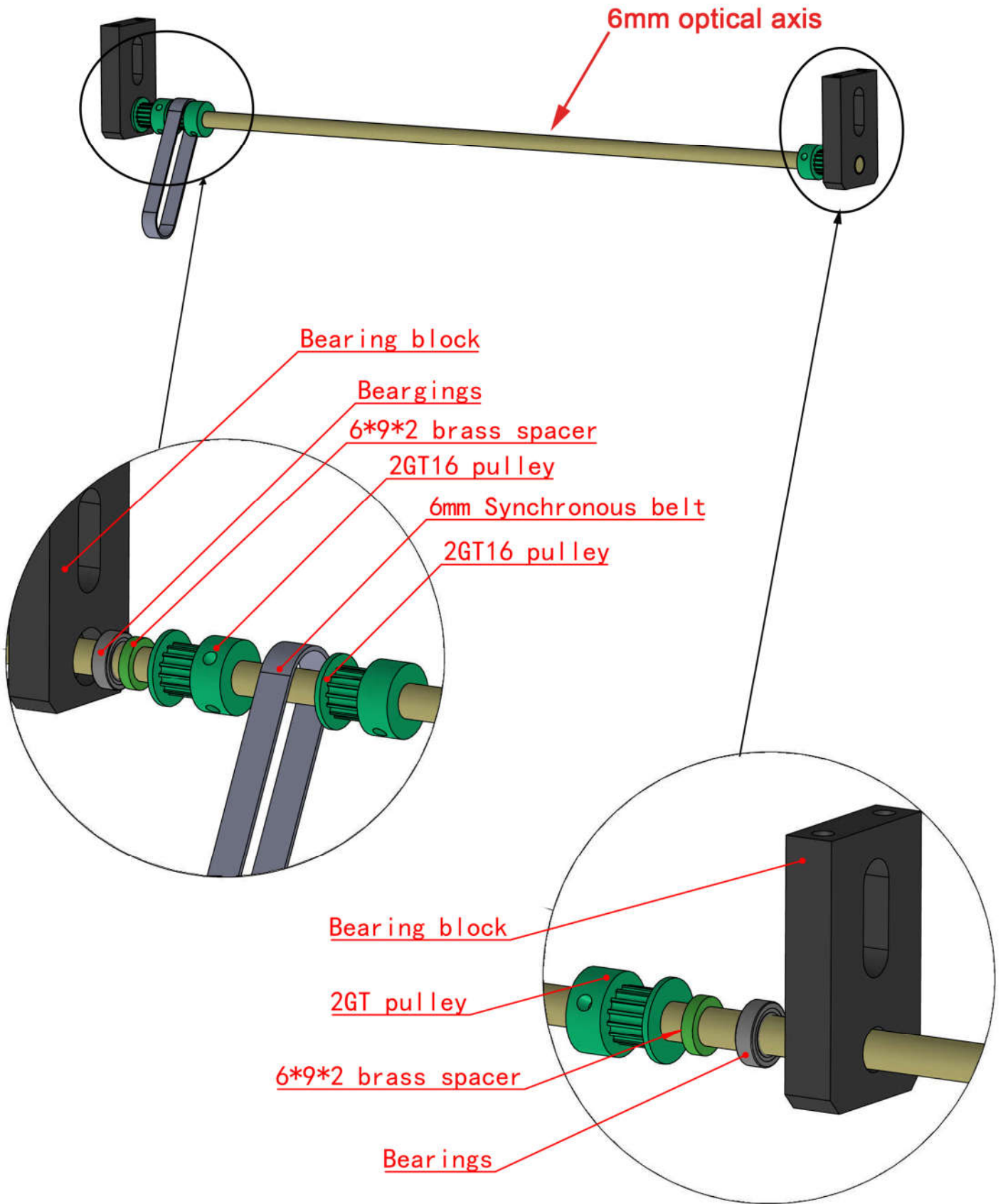
3. Hot bed installation

If you are dual Z axis version, you can refer to the installation method



4. Drive shaft installation

Step 1 -----

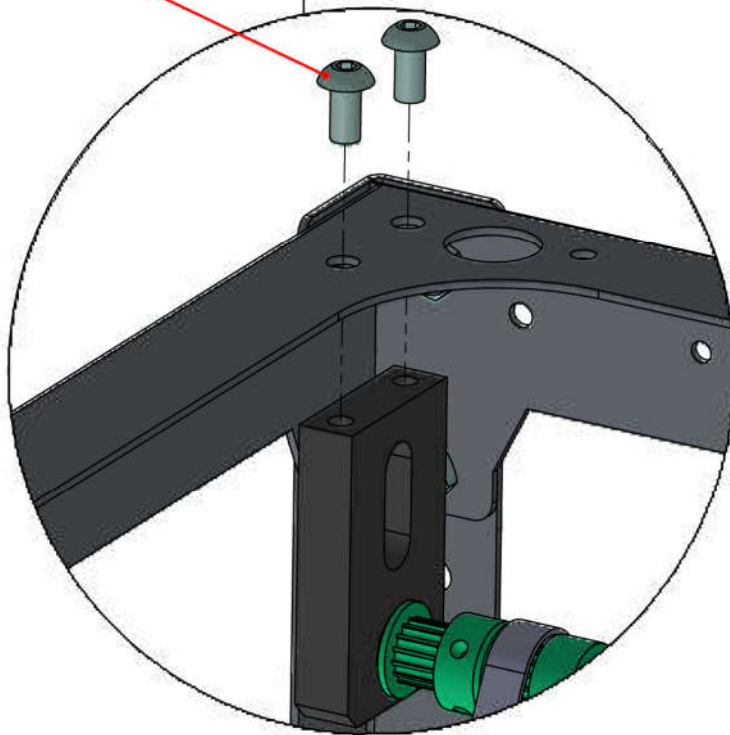


4. Drive shaft installation

Step 2 -----

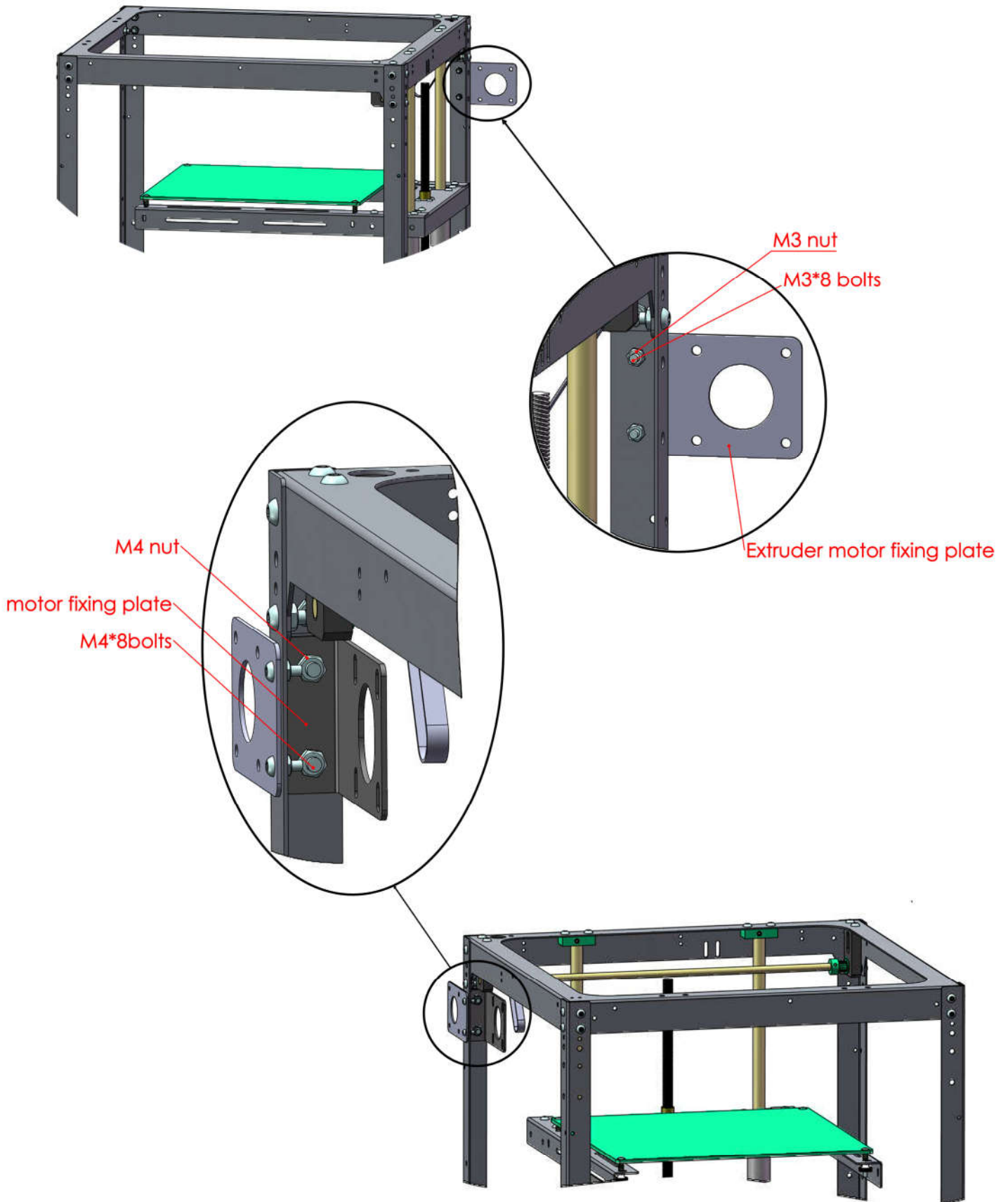


M4*8 bolt



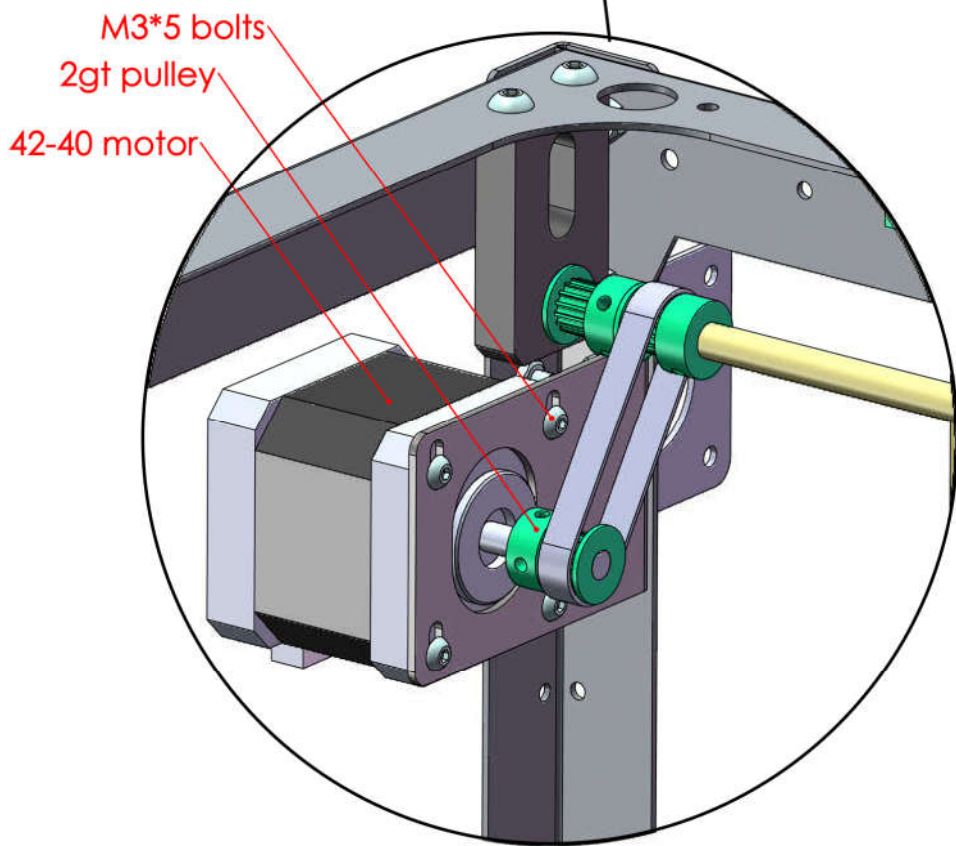
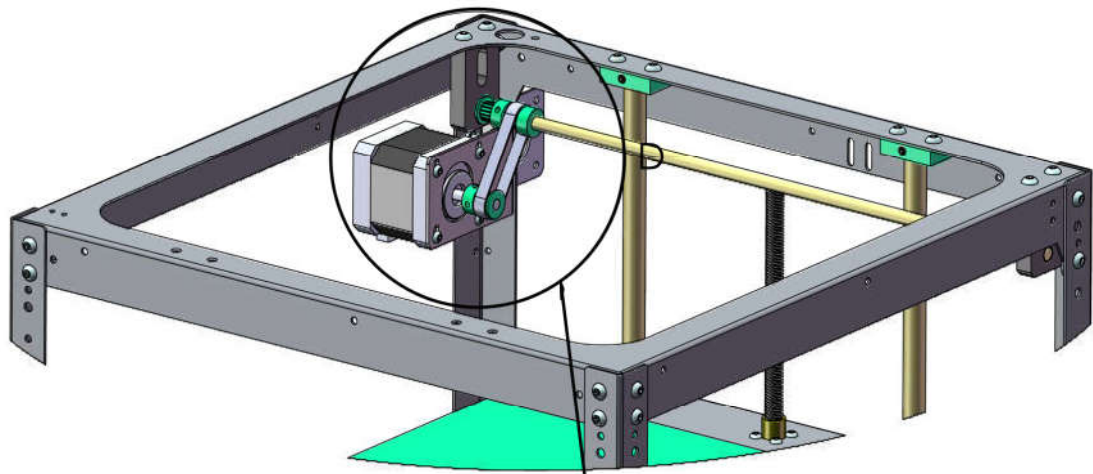
5. Y-axis motor installation

Step 1 -----



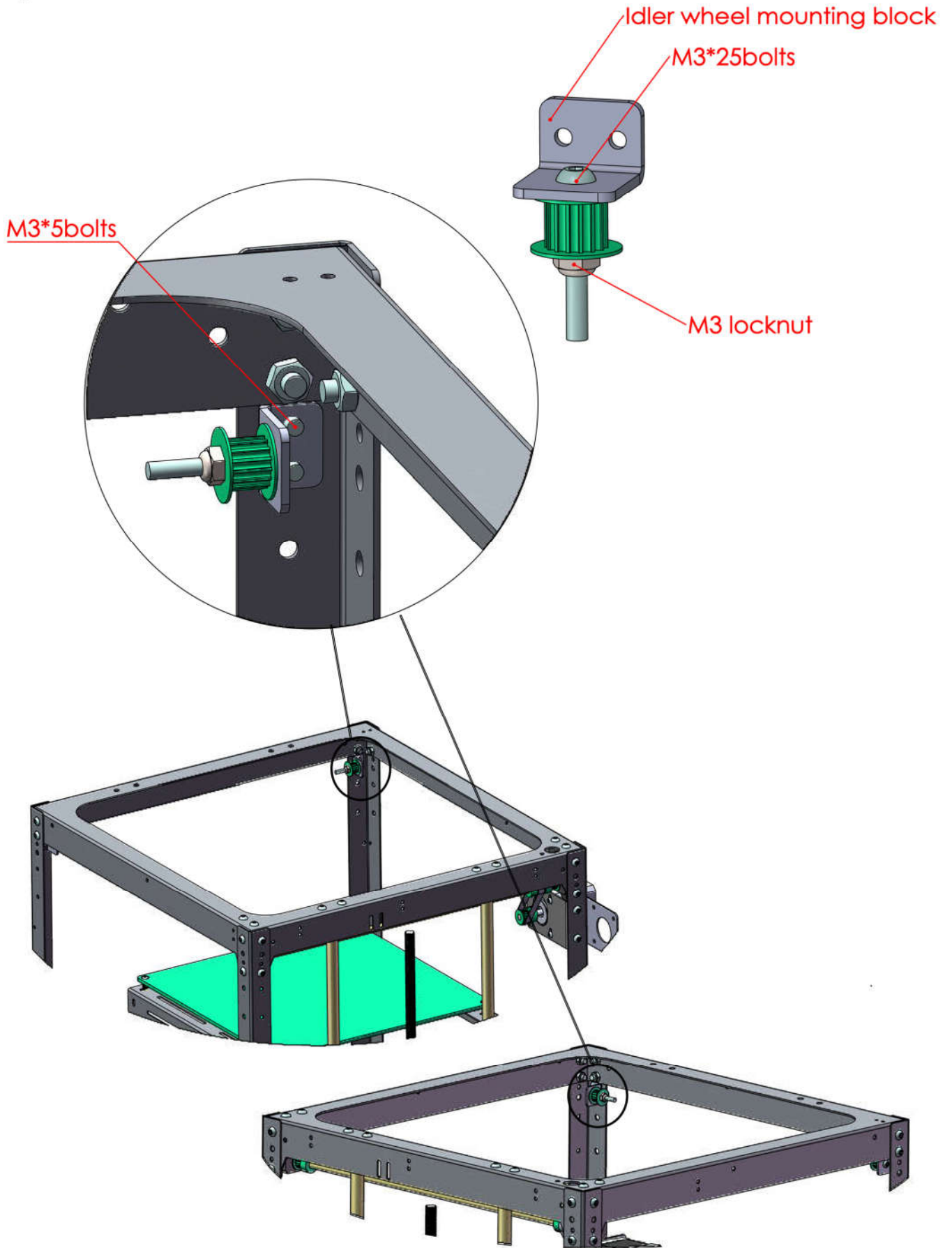
5. Y-axis motor installation

Step 2 -----



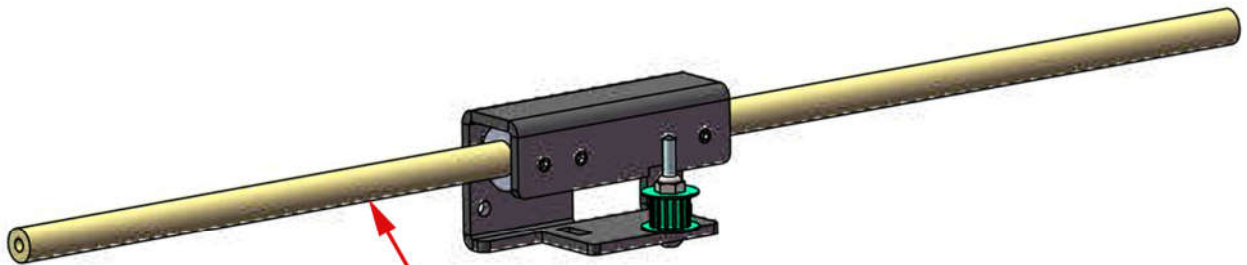
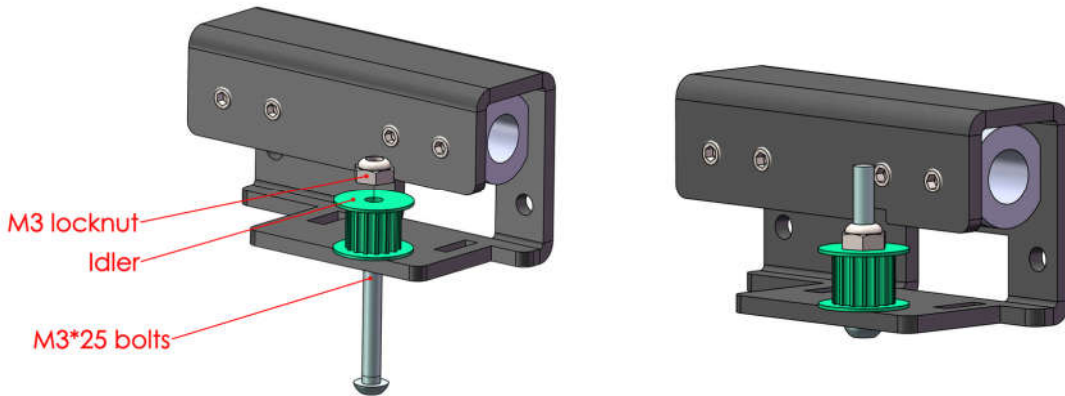
6. Idler wheel installation

Step 1 -----

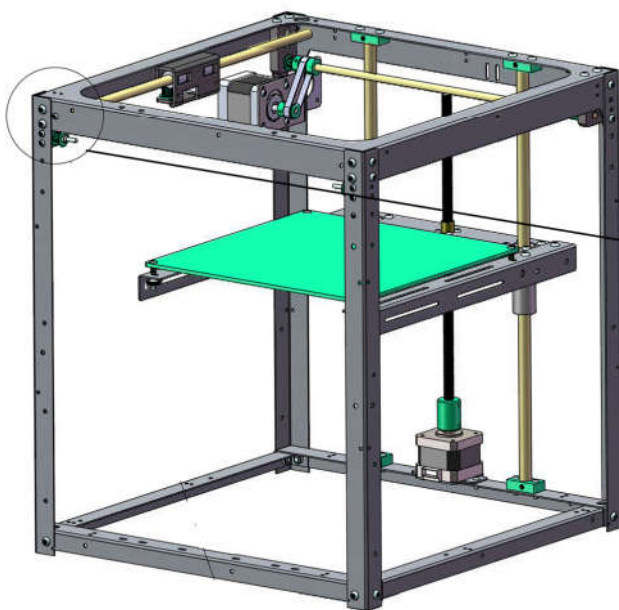


7. X-axis installation

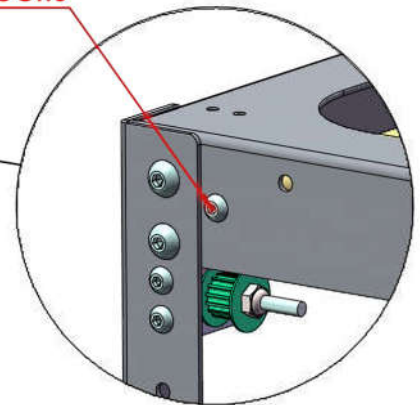
Step 1 -----



8mm optical axis
Length 342mm or 364 mm

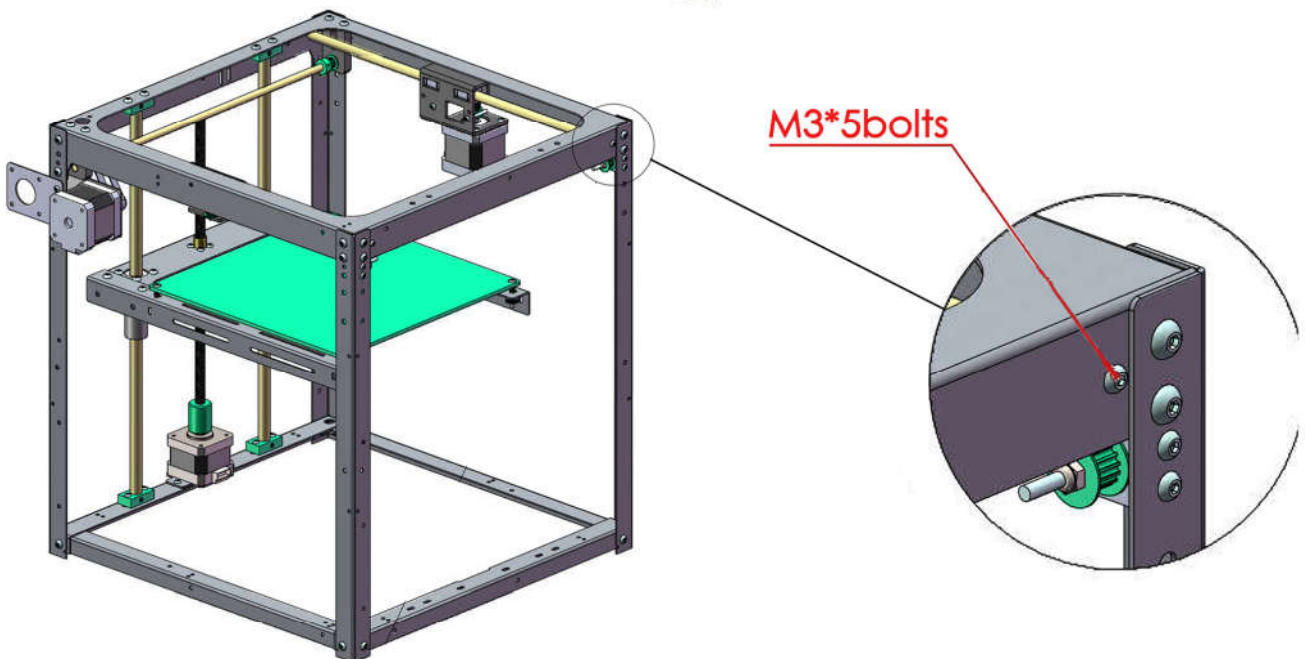
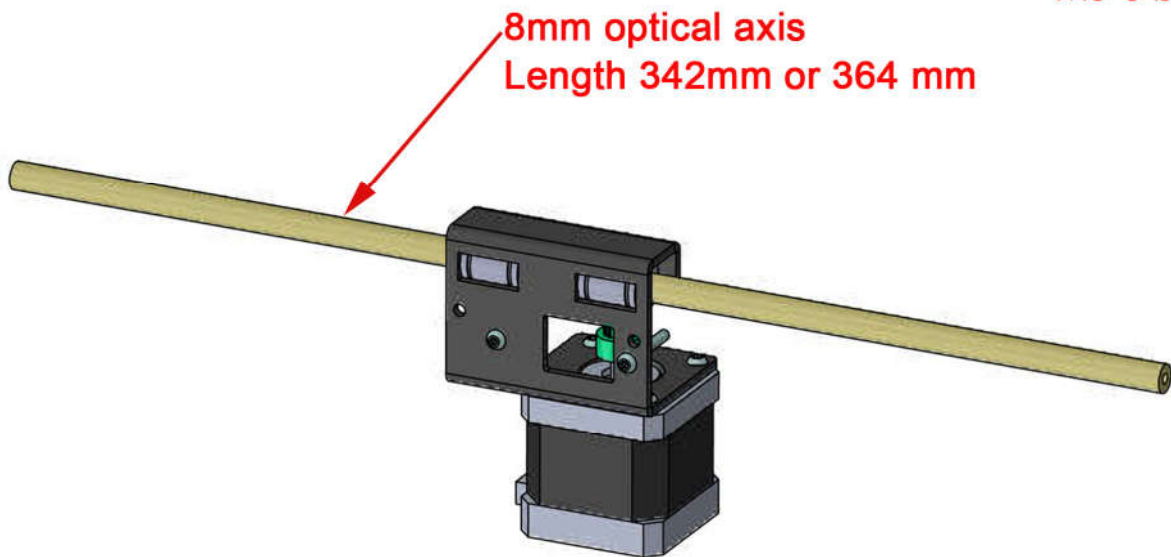
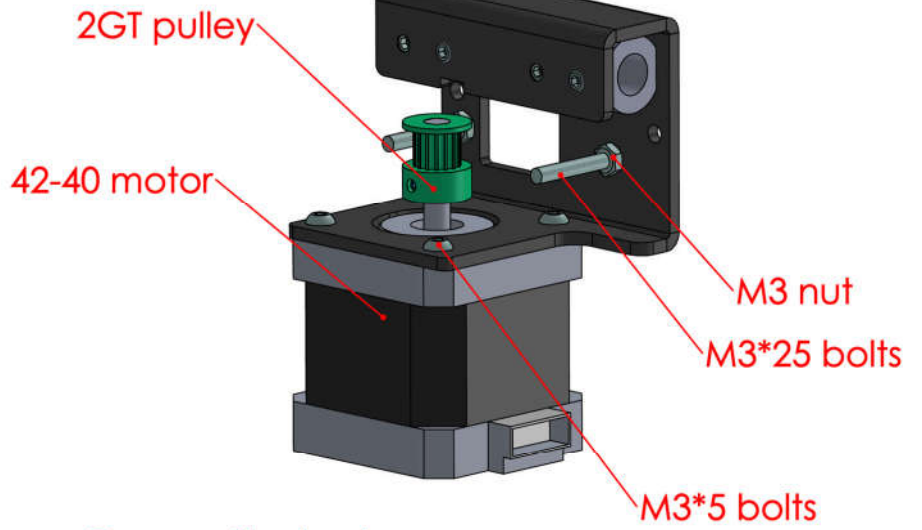
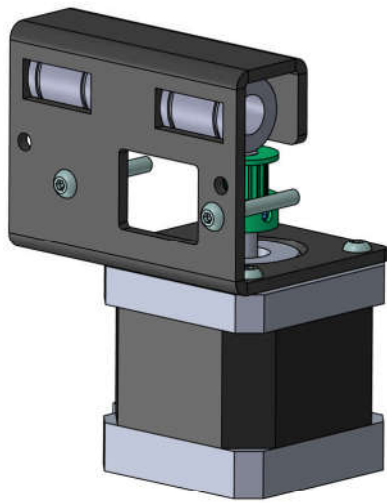


M3*5bolts



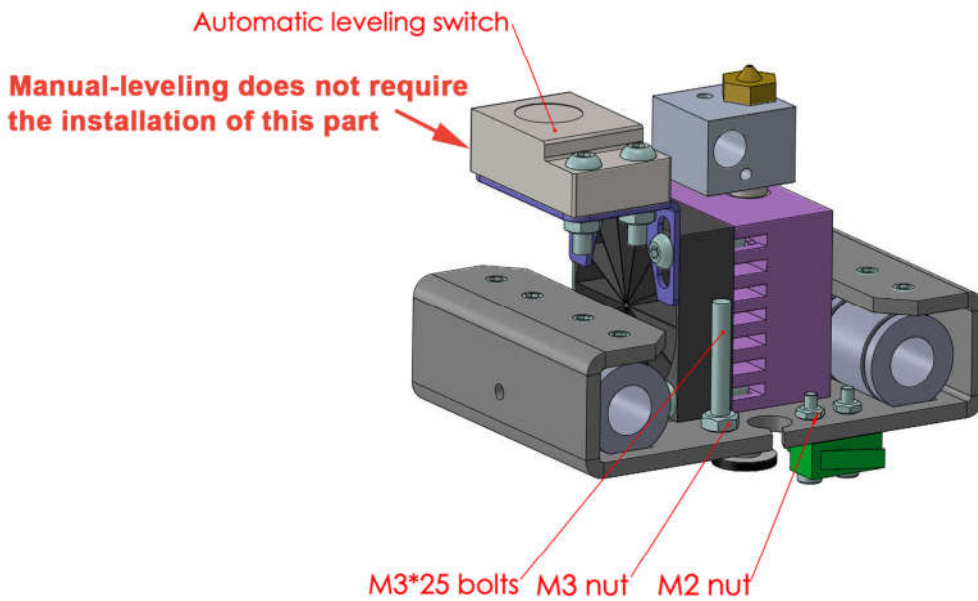
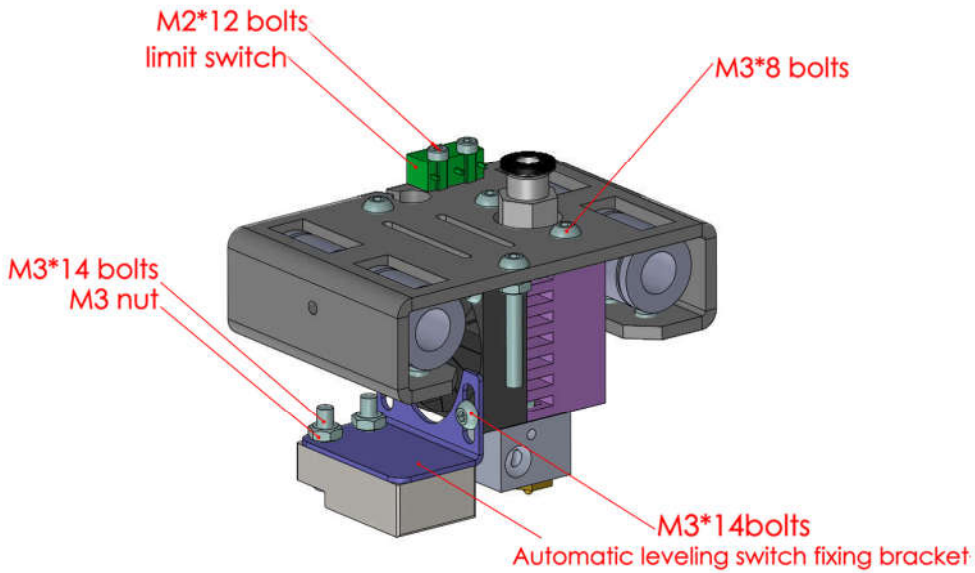
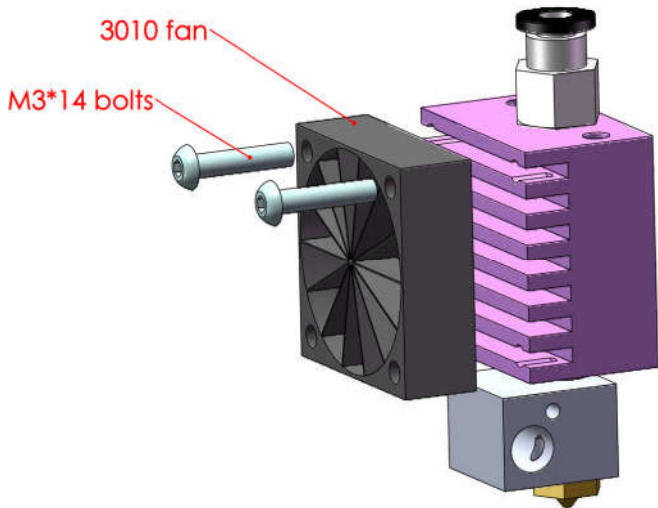
7. X-axis installation

Step 2 -----



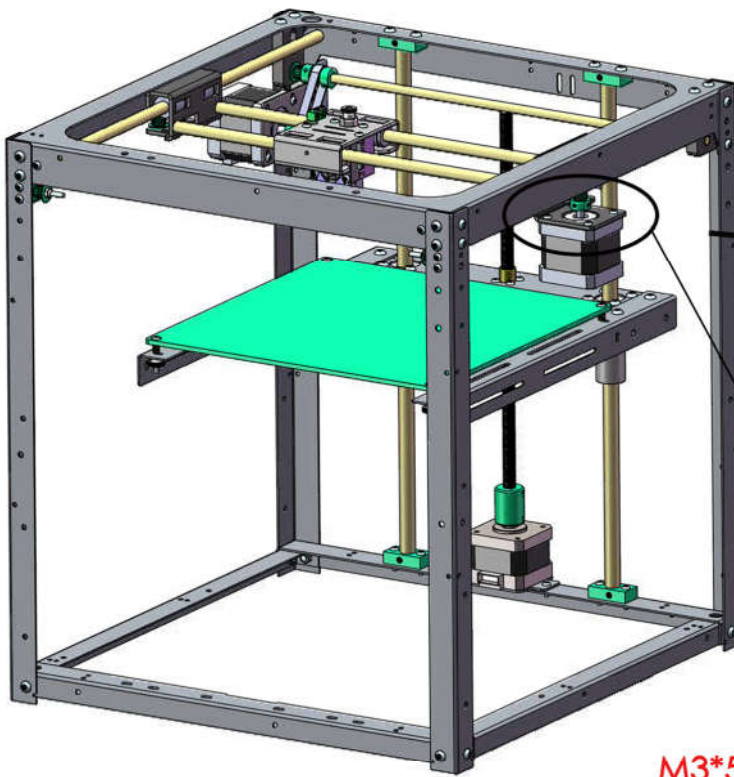
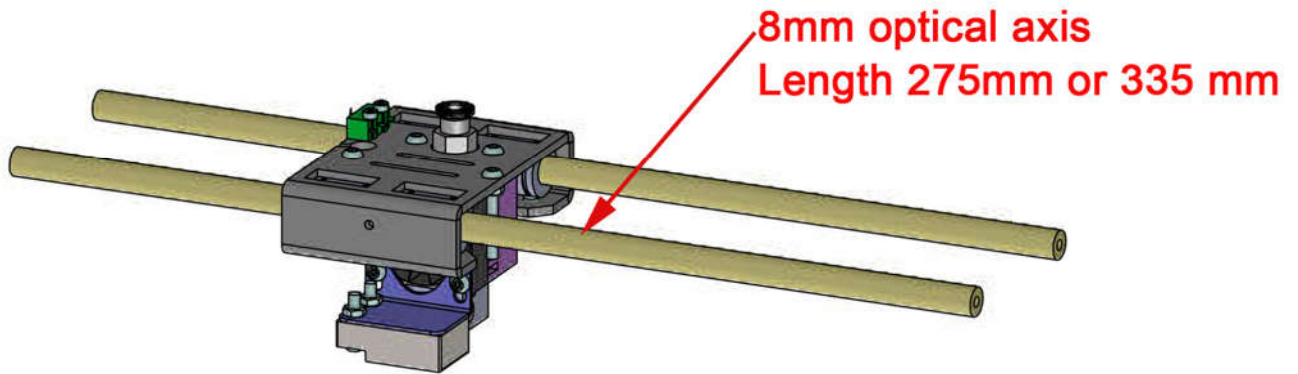
7. X-axis installation

Step 3 -----

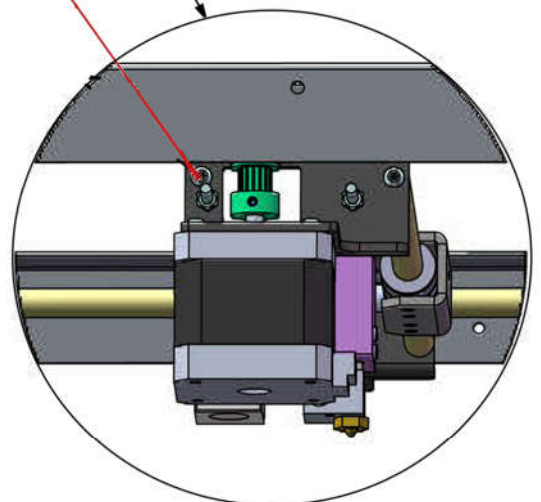


7. X-axis installation

Step 4 -----

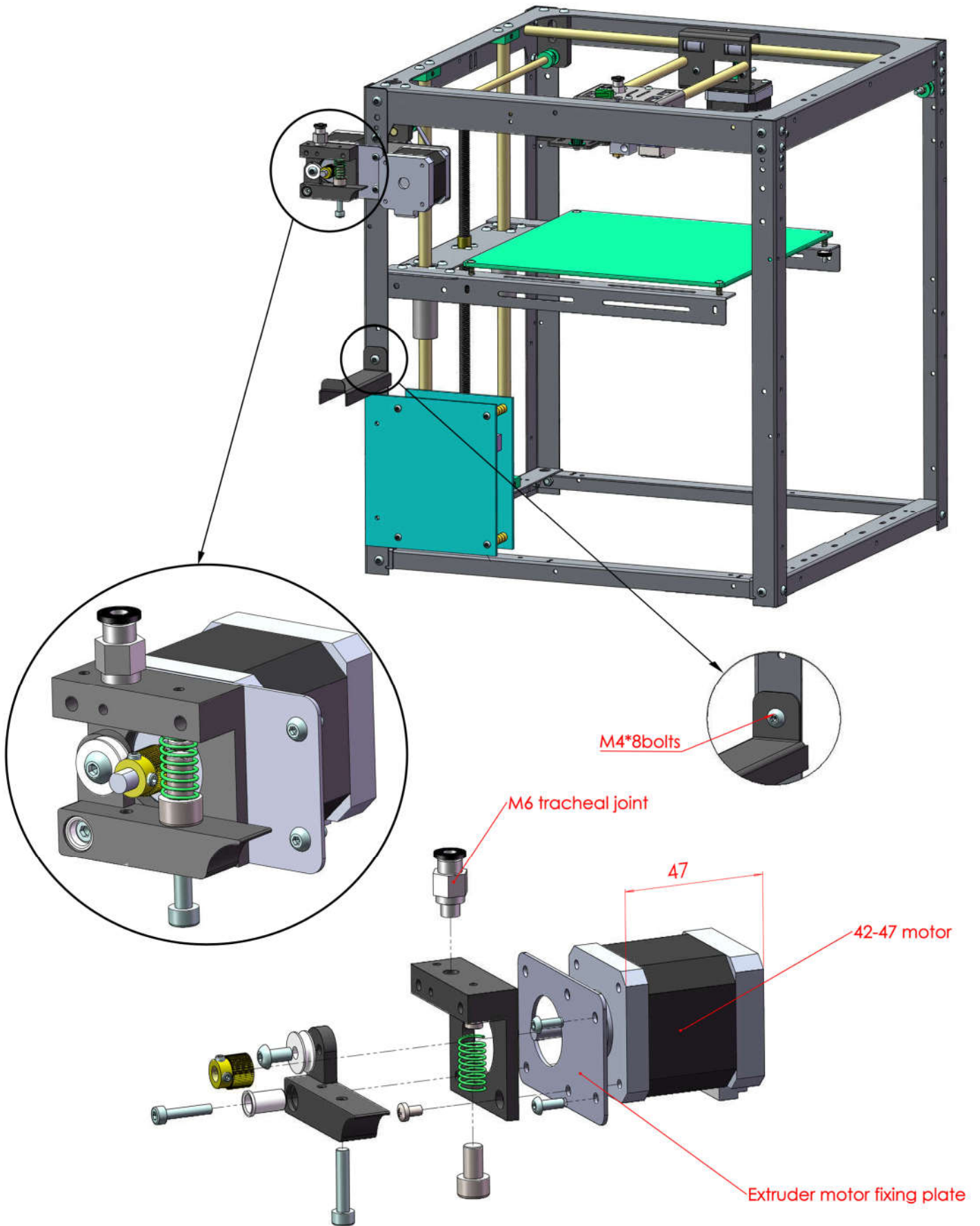


M3*5bolts



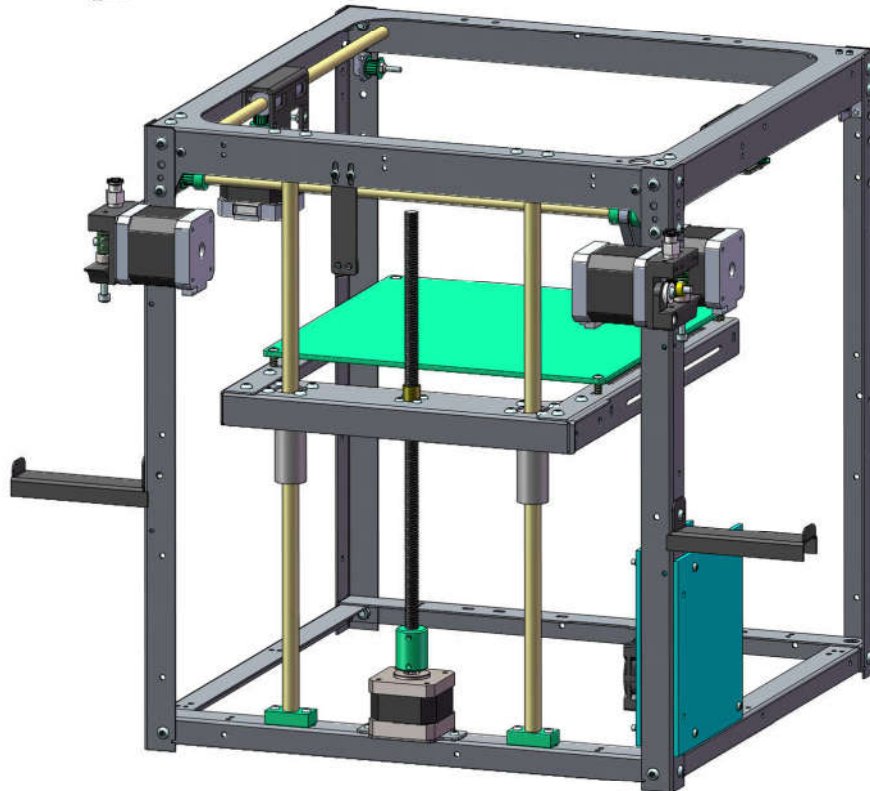
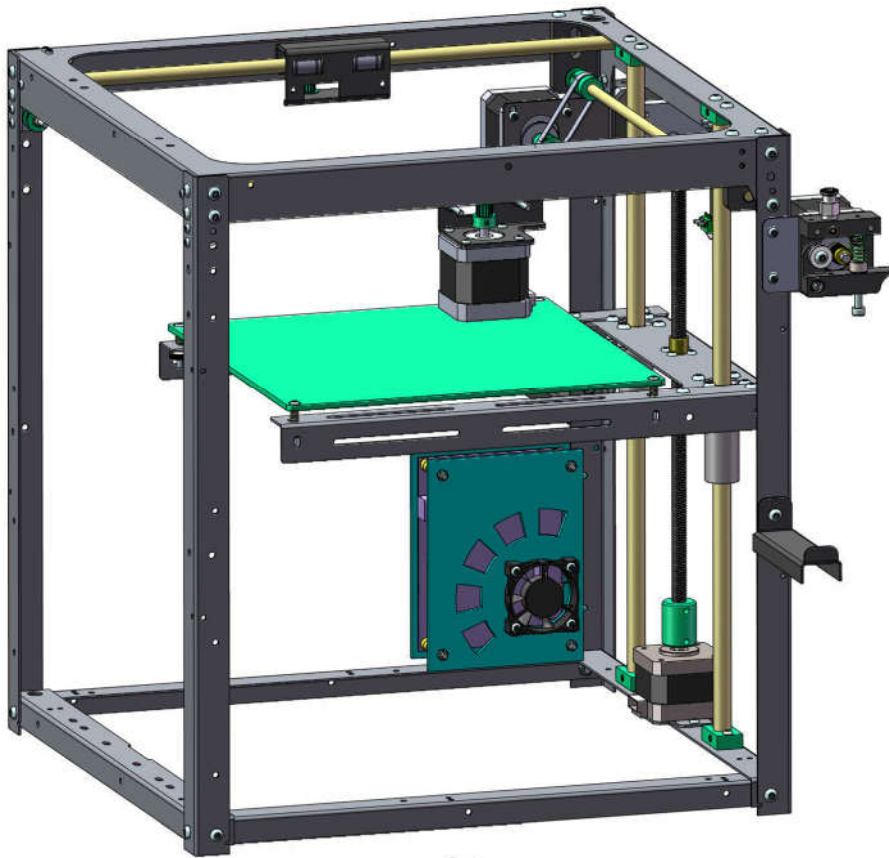
8. Extruder installation

Step 1 -----



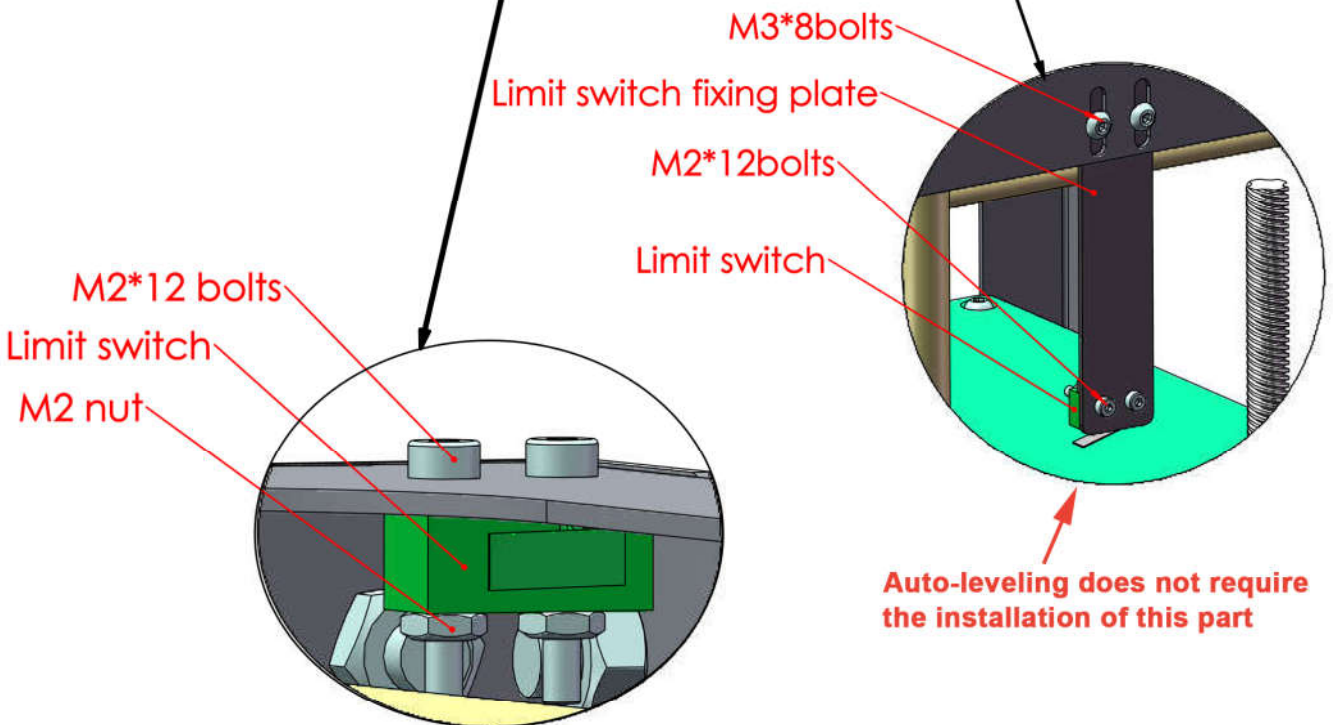
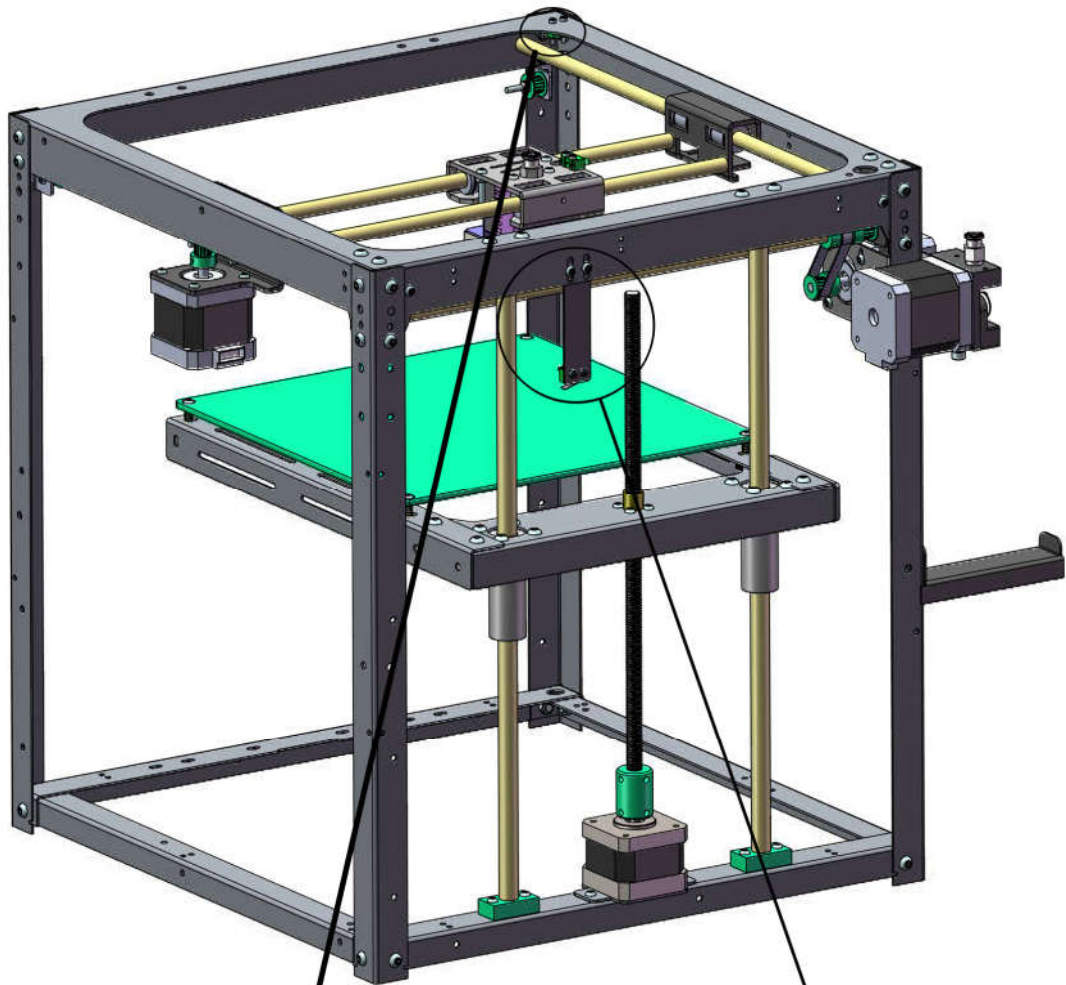
8. Extruder installation

If you are dual Extruder version, you can refer to the installation method



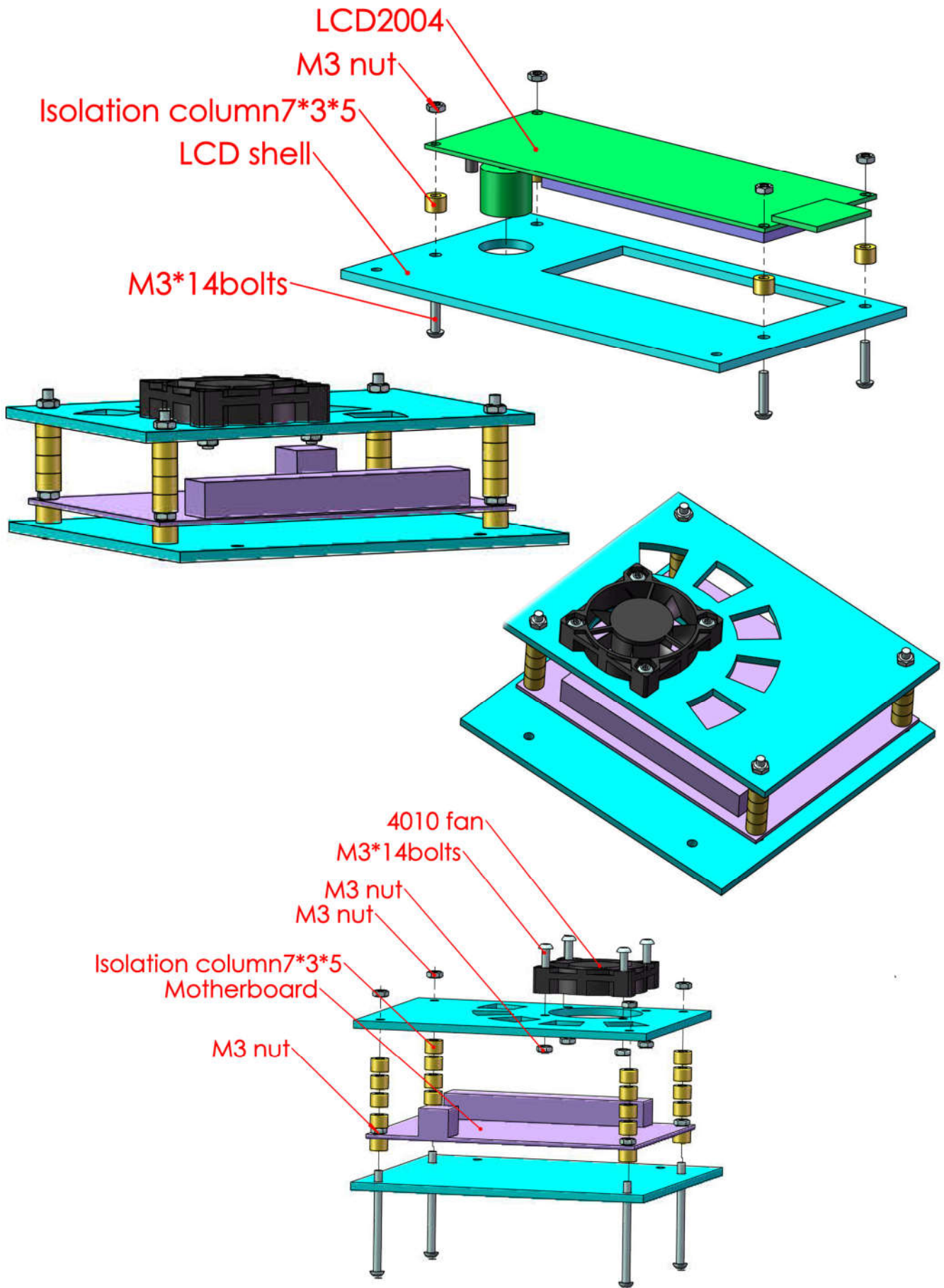
9. Y shaft and Z shaft limit switch installation

Step 1 -----



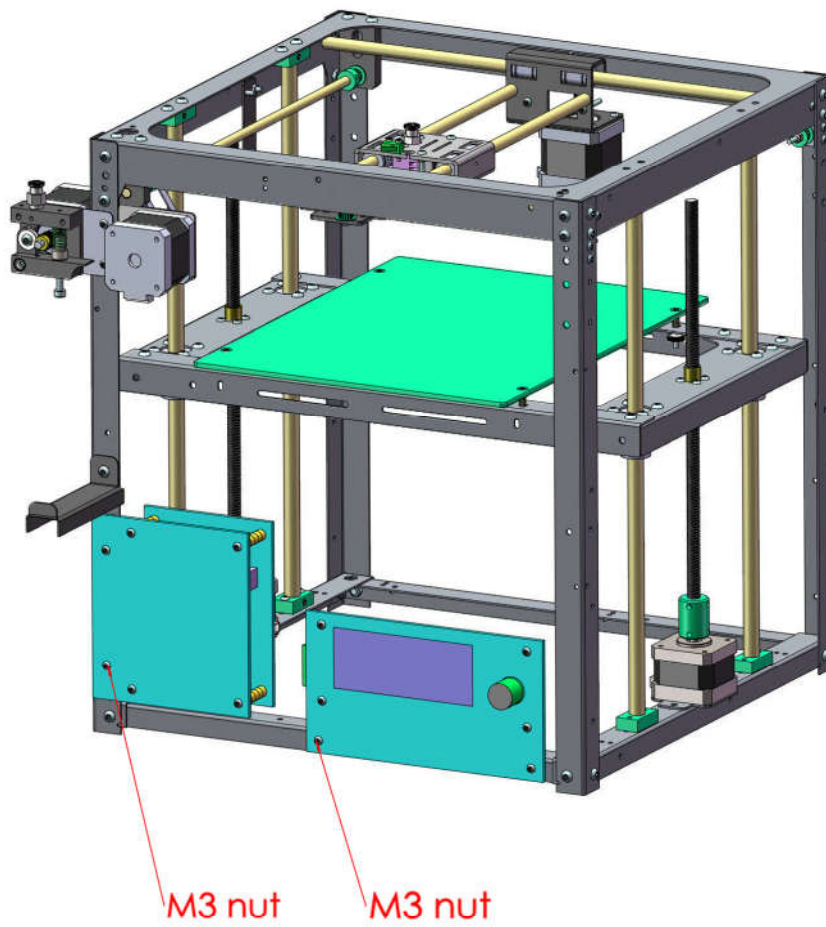
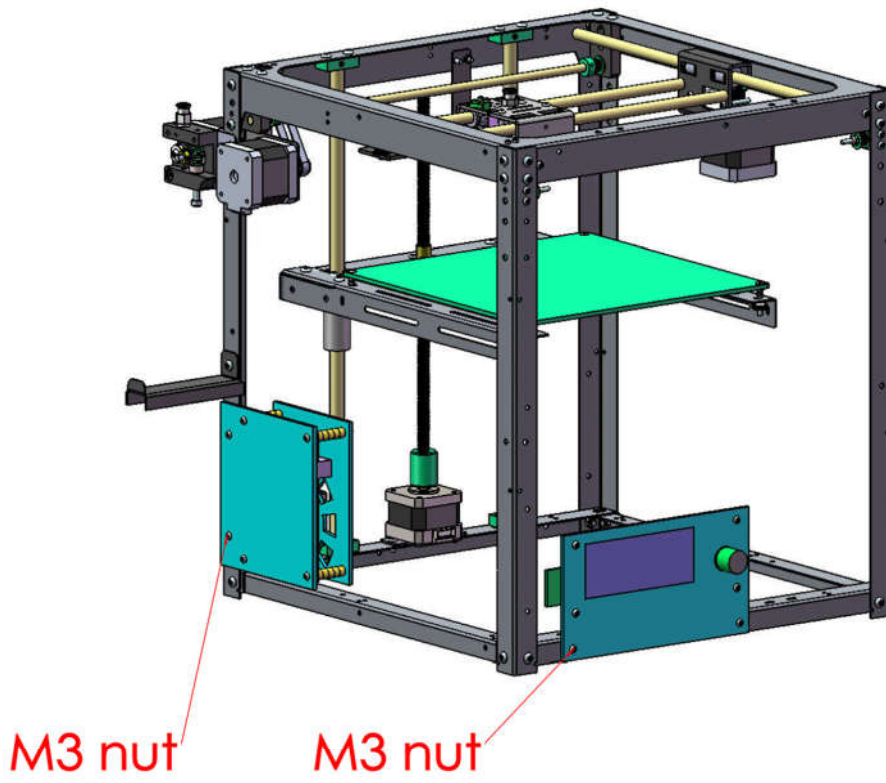
10. Motherboard and LCD installation

Step 1 -----



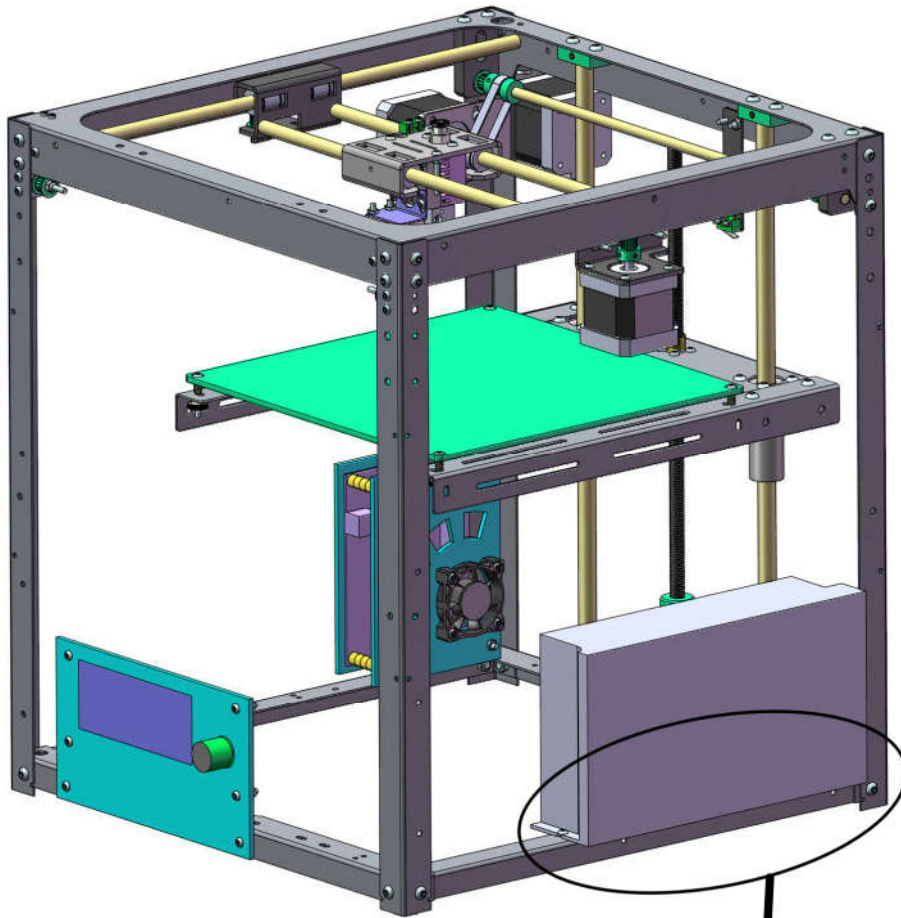
10. Motherboard and LCD installation

Step 2 -----



11. Power supply installation

Step 1 -----

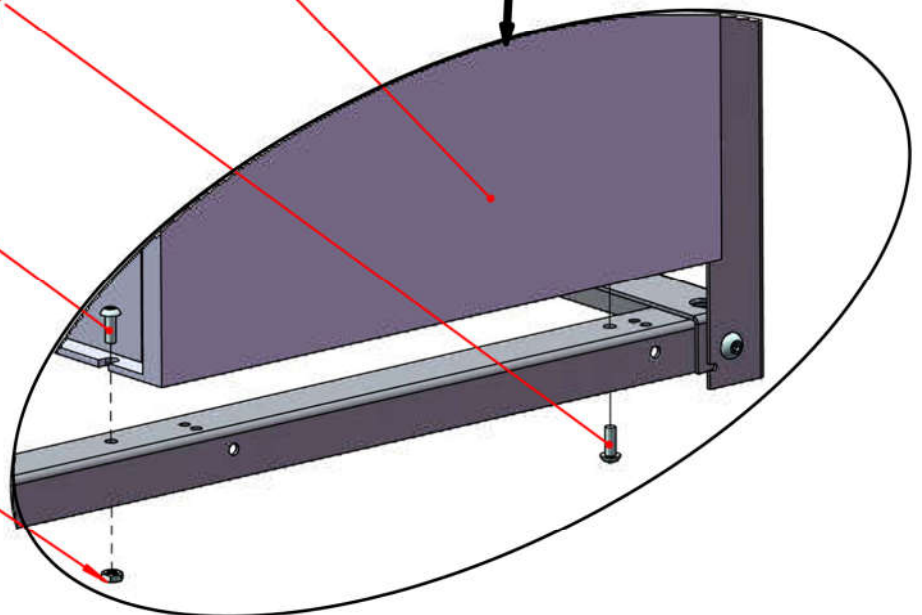


Power supply

M3*5 nut

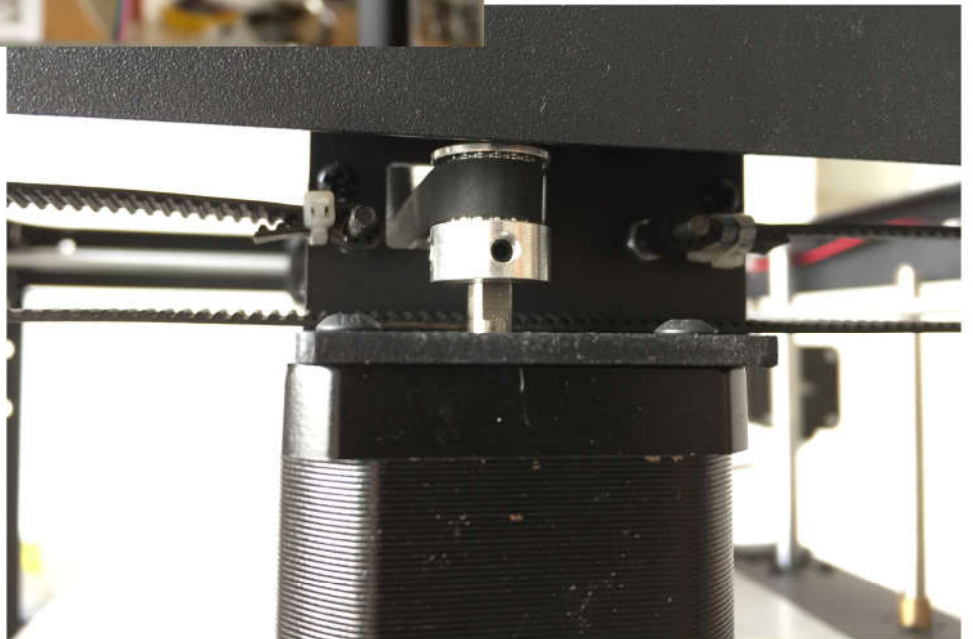
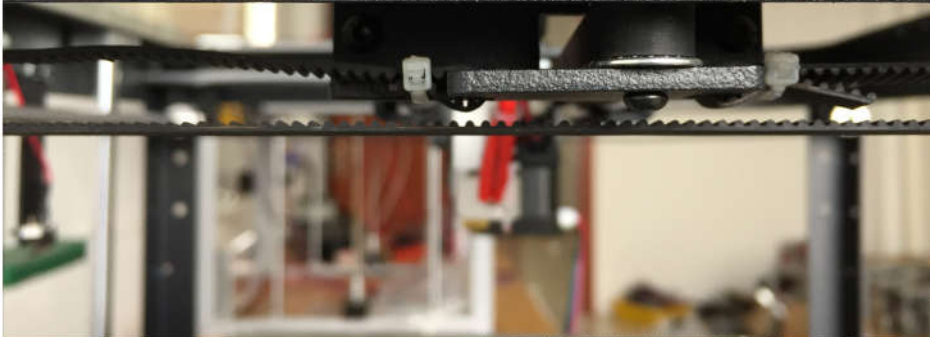
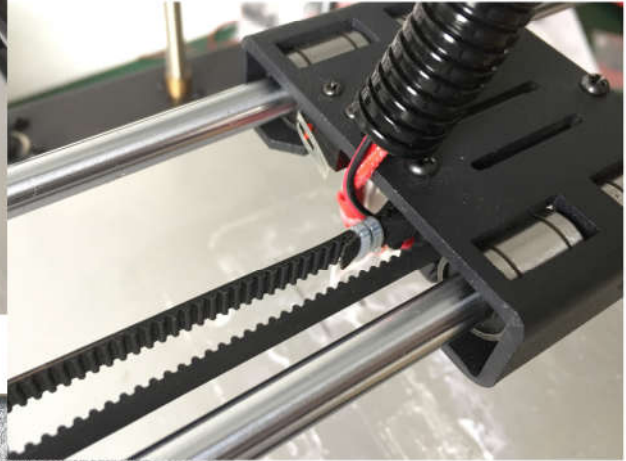
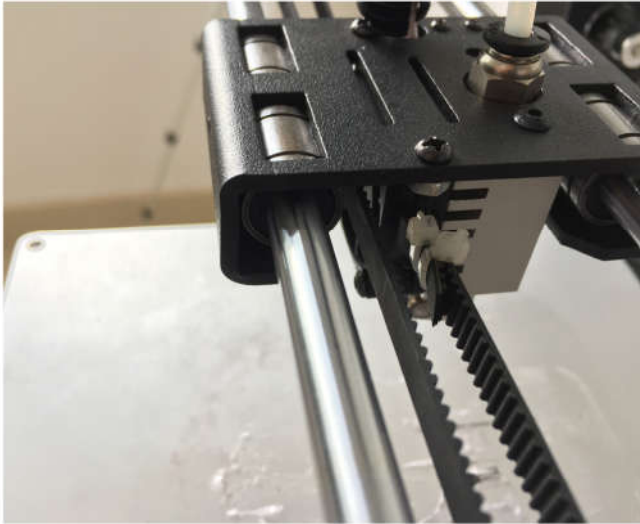
M3*8 bolts

M3 nut



12.Synchronous belt installation

Step 1 -----

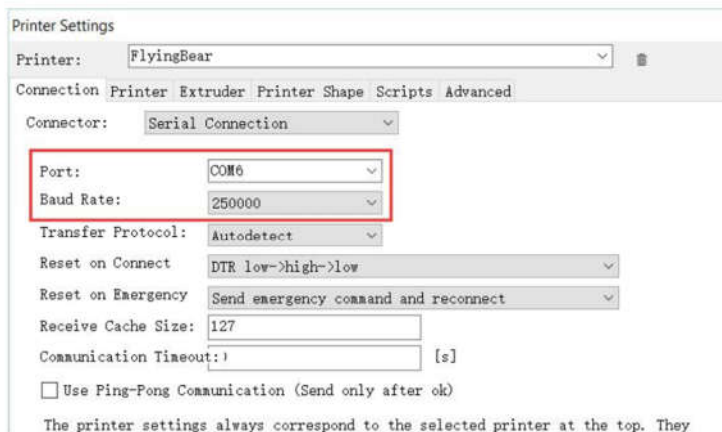
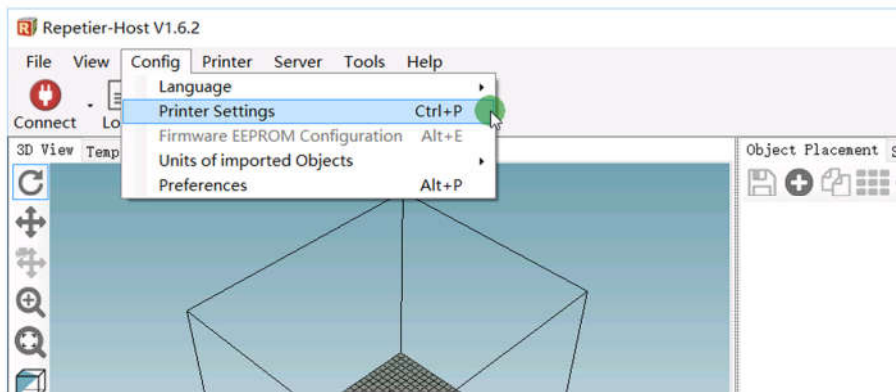


13. Setting up slicing software

3D printers have very many slicing software, such as Cura, simplify3D, and so on, but we only introduce how to use repetier-host.

Software download address: <https://www.repetier.com>

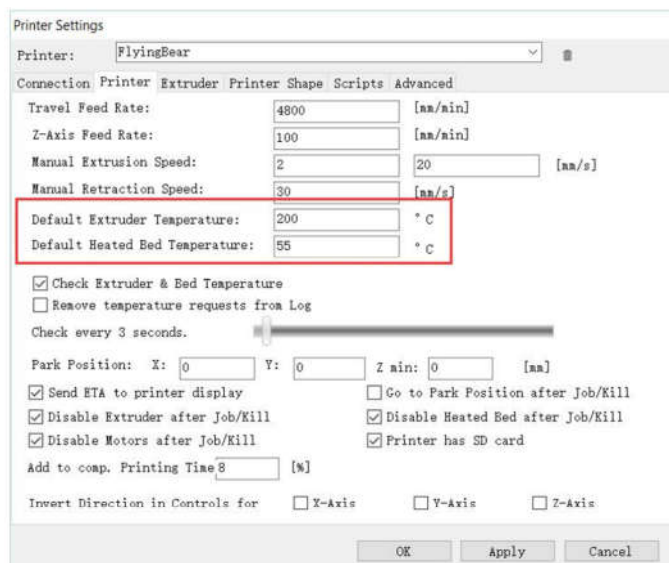
When the software installation is complete, click "printer settings", and then follow the pictures in turn to operate



Port :According to the ports in Device manager (COM&LPT) to choose, **(Notice: Each computer is different,my computer is COM5.)**

Baud Rate: fill in "250000"

Other parameters remain the same.



Reference temperature:

Print PLA

Extruder temperature: 190°C around

Bed temperature: 40°C around

Print ABS

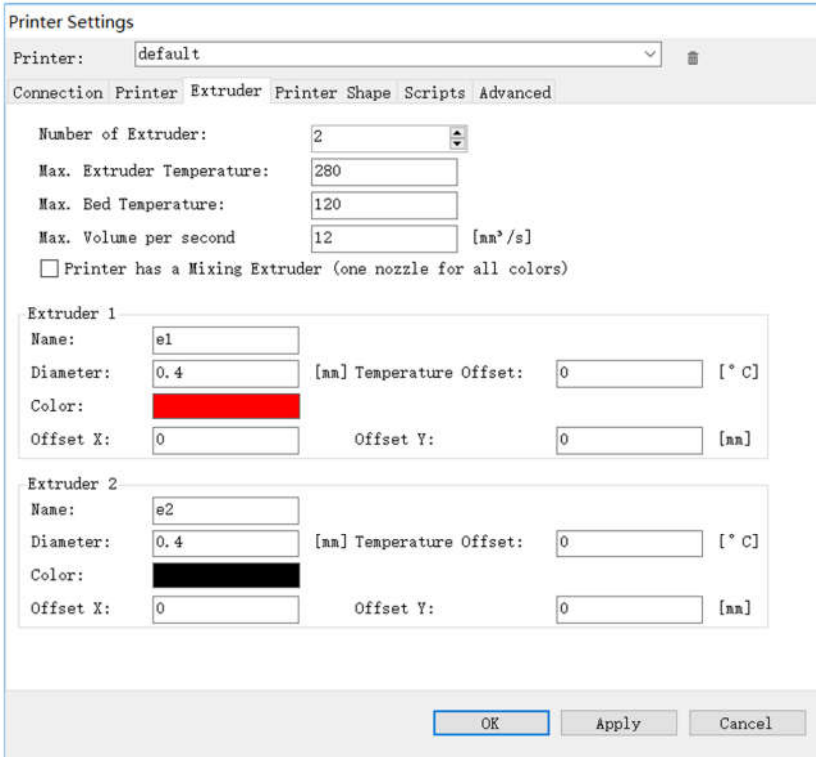
Extruder temperature: 230°C around

Bed temperature: 80~100°C around

Other parameters remain the same.



13. Setting up slicing software

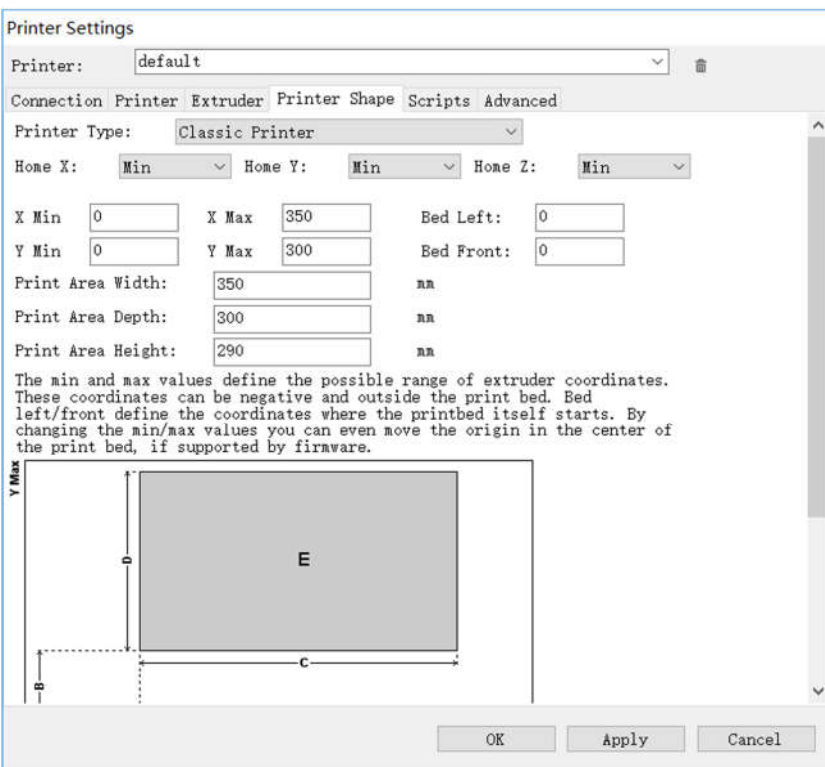


For double nozzles, please fill in 2
Number of Extruder: 1/2

Name: P9.2-0.4

Diameter: default it is 0.4, Please fill in it according to your nozzle's diameter.

Other parameters remain the same.



Printer: FlyingbearP905

X Max: 220 (Big size 280)

Y Max: 220

Print Area Width: 220

Print Area Depth: 220

Print Area Height : 200 (Notice: The actual size is 210 ,but due to each customer's installation is different, it is possible to cause the size smaller than 210 .So it's more safe to fill in 200.)

Other parameters remain the same.

Printer: FlyingbearP905 Plus

X Max: 280

Y Max: 242

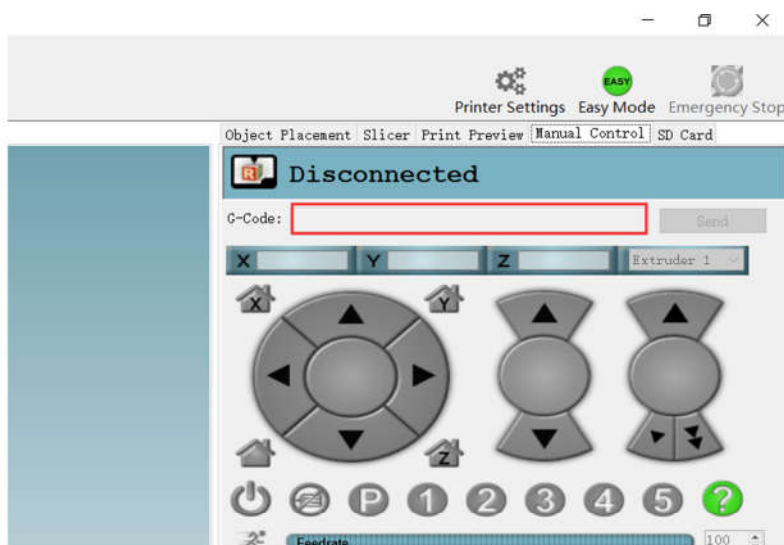
Print Area Width: 280

Print Area Depth: 242

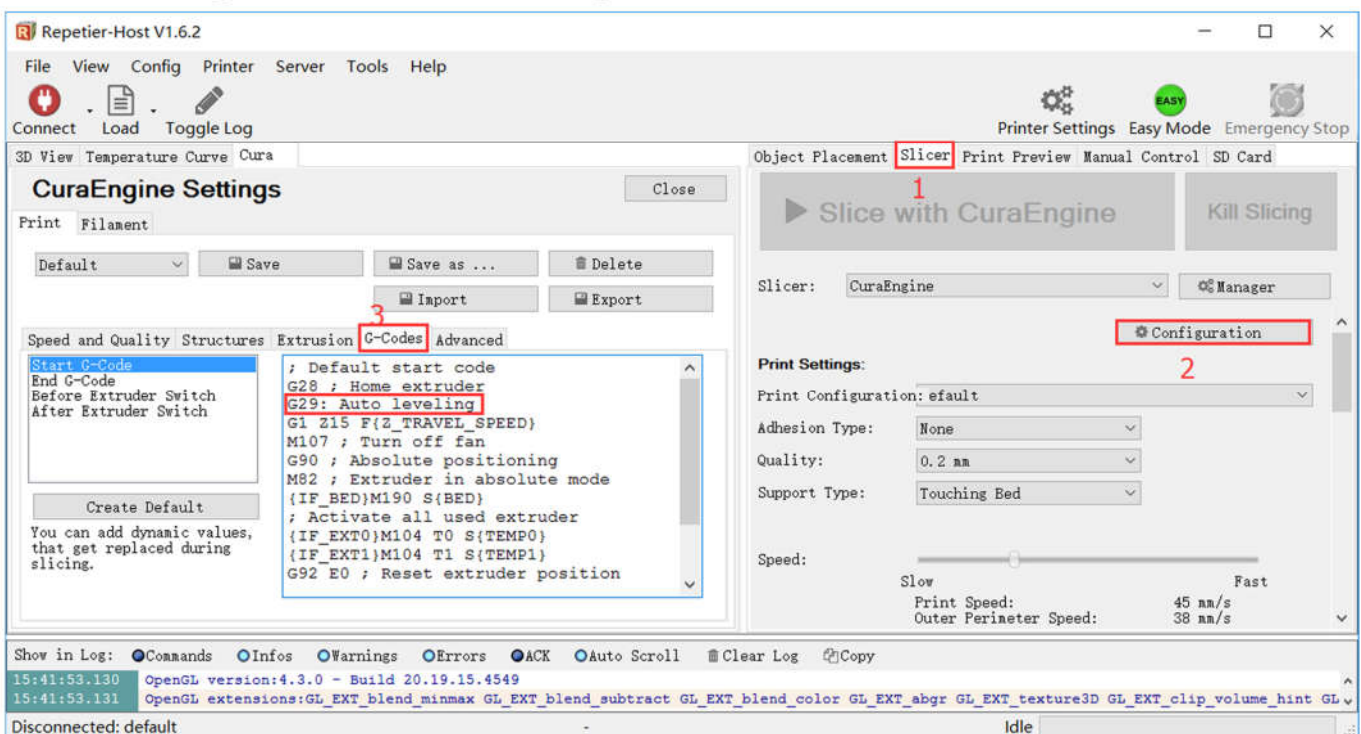
Print Area Height : 350

14. Setting auto leveling sensor

Open the repetier-host and connect to the printer. select "manual control" tab and you should see "G-Code". Write in this field "G28" and press send button, Then send the G1 Z0, the screen will show that the Z axis is "Z=0". Now you can operate the printer by LCD screen, select "prepare/move the axis / 0.1 mm/move z" according to the menu. Move the Z axis, until the distance between nozzle and hot bed reaches the most suitable distance. (the best distance between nozzle and hot bed is probably a piece of A4 paper). Then record the Z axis numerical that LCD displays (This numerical value should be a negative number, let's assume this value is -1.5). And then we send the G code "M851 Z - 1.5", finally send G code "M500" to save your changes



Before slicing, add the auto leveling "G29" code

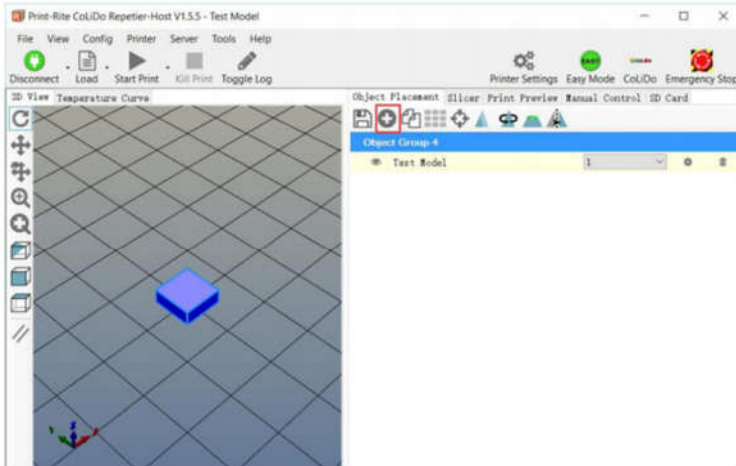


15. First print model

There are two ways to print: use the SD card to print and use the computer to print. It is recommended to use the SD card to print. The computer will be standby or have other abnormal situation to interrupt the printing process when use the computer to print.

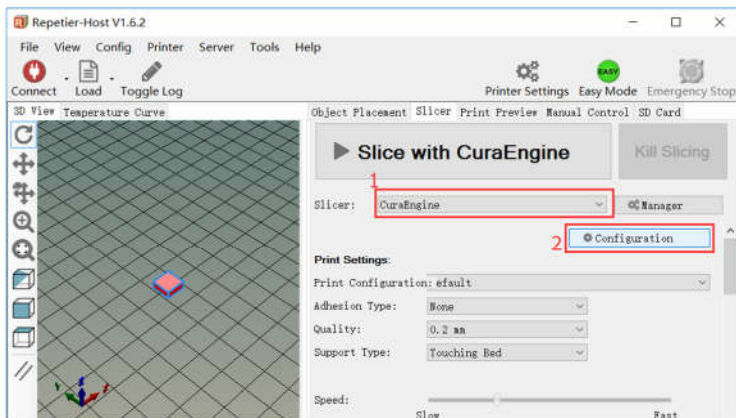
Attention:The hot bed needs to paste the masking tape or painted with the self-adhesive before printing.

Introduction of using SD card to print

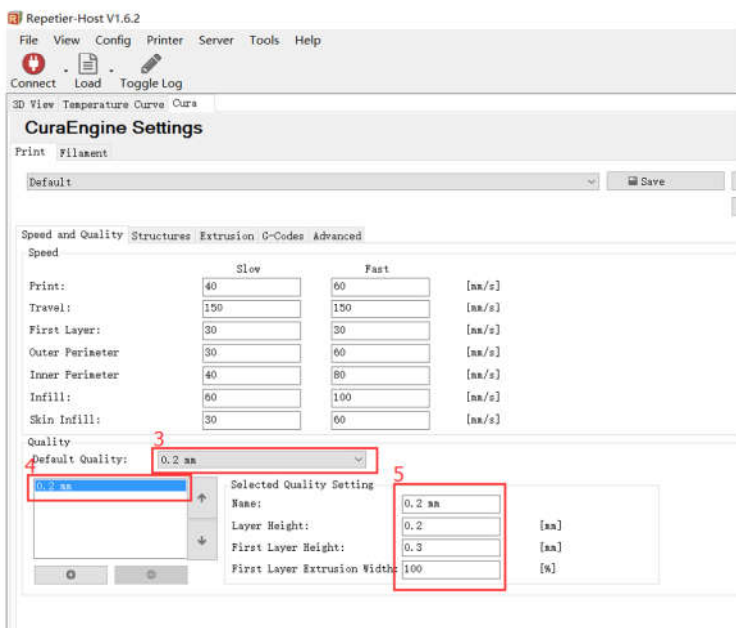


Click the button, load the folder

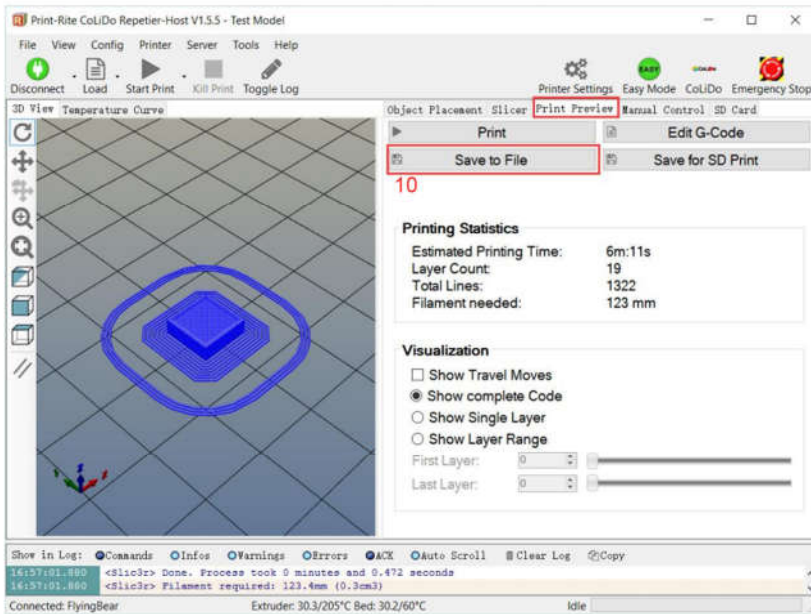
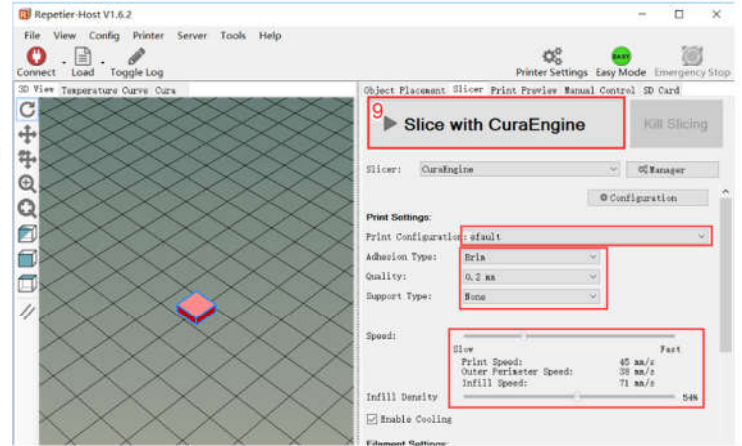
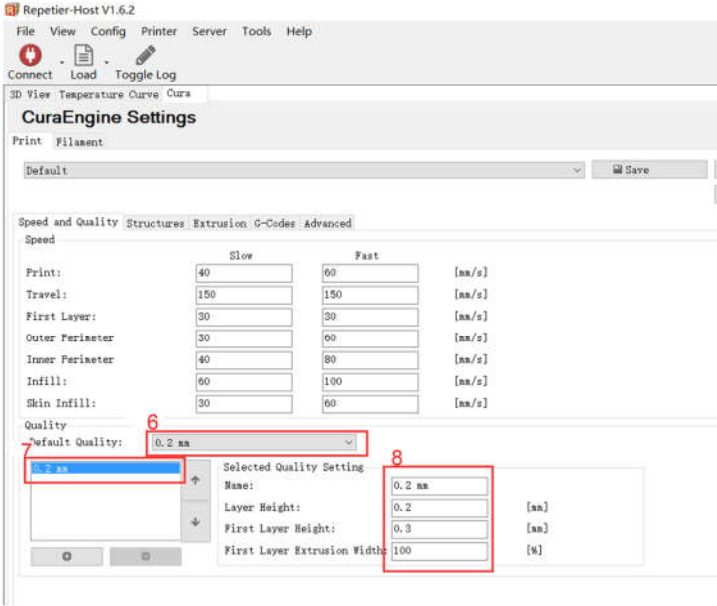
“Test Model” in “FlyingBear-tornado Printer”



Set parameters according to pictures



15. First print model



After slice is done, Click "Save to File" to save the file in SD card.



After insert the SD card into LCD, choose "Prepare" ---- "Auto home"



Choose "Prepare" ---- "Preheat PLA" ---- "Preheat PLA"



Choose "Print from SD" ----- "Test Model"

Then wait a moment, after the heating process all finished, it will begin to print.

16、Flyingbear-P905 wiring diagram

