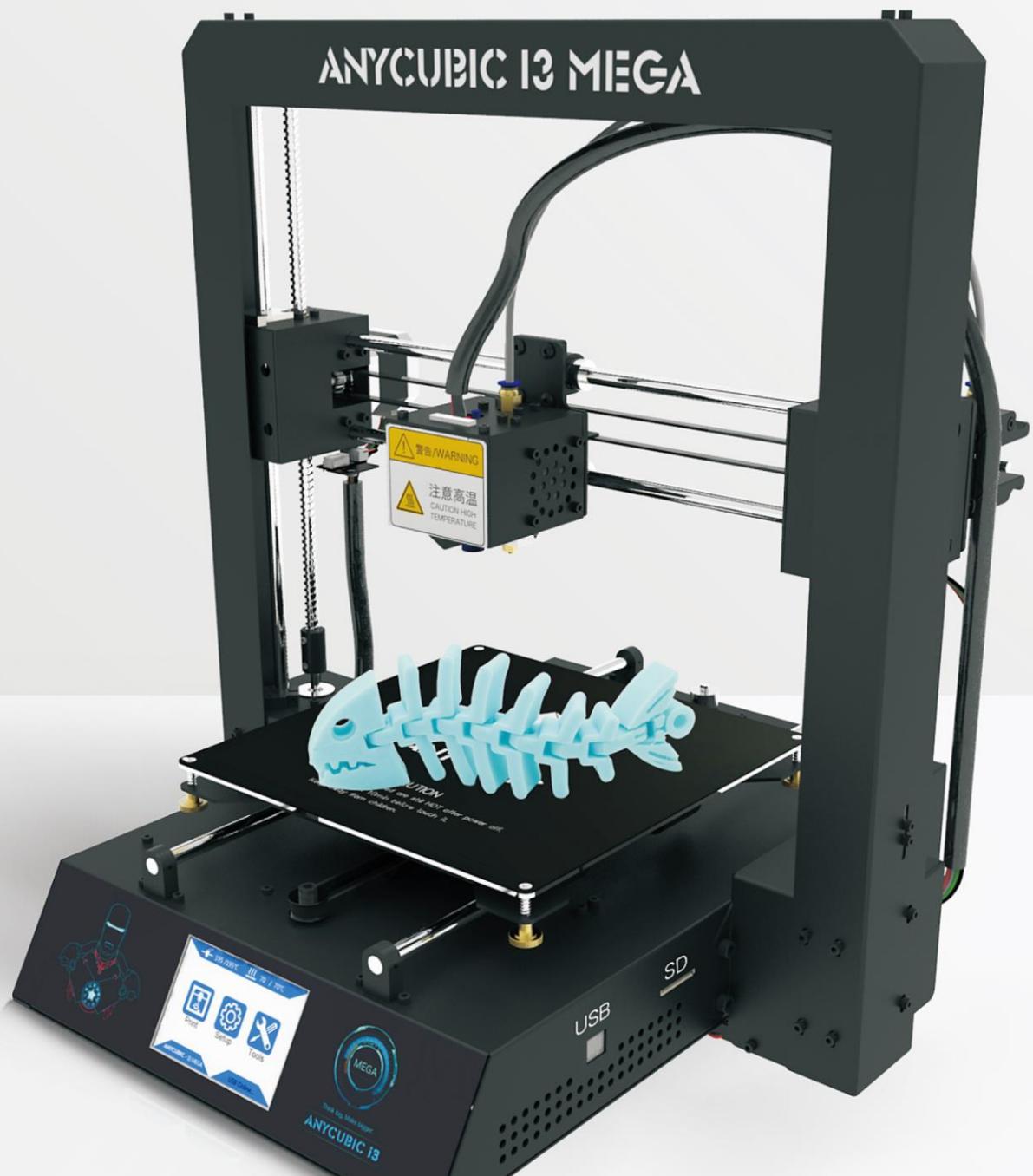


# ANYCUBIC 13 MEGA

## Quick Start Guide





## Safety Instructions

Please carefully read the safety instructions before get started.



**ANYCUBIC** 3D printer generates high temperature. Do not reach inside of the printer during operation. Allow time for the printer to cool down after printing. Contact with extruded materials may cause burns. Wait for printed objects to cool before removing them from the build platform.



**ANYCUBIC** 3D printer includes moving parts that can cause injury.



Vapors or fumes may be irritating at operating temperature. Always use the **ANYCUBIC** 3D printer in an open, well ventilated area.



Be cautious when using the scraper. Never direct the scraper towards your hand.



**ANYCUBIC** 3D printer **MUST NOT** be exposed to water or rain.



**ANYCUBIC** 3D printer is designed to be used within ambient temperature ranging 8°C-40°C, and humidity ranging 20%-50%. Working outside those limits may result in low quality printing.



It is recommended to use protection glasses when cleaning/sanding the printed models to avoid small particles contacting eyes.



In case of emergency, immediately turn off the **ANYCUBIC** 3D printer and contact us or consult for professional advice.

Never leave the **ANYCUBIC** 3D printer unattended during operation..

# Technical Specification

## Printing

Technology:	FDM (Fused Deposition Modeling)
Build Size:	210×210×205 (mm <sup>3</sup> )
Layer Resolution:	0.05-0.3 mm
Positioning Accuracy:	X/Y 0.0125mm , Z 0.002mm
Extruder Quantity:	Single
Nozzle/Filament Diameter:	0.4 mm/1.75mm
Print Speed:	20~100mm/s (suggested 60mm/s)
Travel Speed:	100mm/s
Supported Materials:	PLA, ABS, HIPS, Wood

## Temperature

Ambient Operating Temperature:	8°C - 40°C
Operational Extruder Temperature:	260°C max
Operational Print Bed Temperature:	100°C max

## Software

Slicer Software:	Cura
Software Input Formats:	.STL, .OBJ, .DAE, .AMF
Software Output Formats:	GCode
Connectivity:	SD card; USB port(expert users only)

## Electrical

Input rating:	110V/220V AC, 50/60Hz
Working Voltage:	12V DC

## Physical Dimensions

Printer Dimensions:	405mm×410mm×453mm
Net Weight:	~11kg

# Contents

<b>1. Product Overview</b> .....	1
<b>2. Part list</b> .....	4
<b>3. Assembly instruction</b> .....	5
<b>4. Leveling</b> .....	9
<b>4.1 Assisted Leveling</b> .....	9
<b>4.2 Manual Leveling</b> .....	16
<b>5. Software installation</b> .....	19
<b>5.1 Driver installation</b> .....	19
<b>5.2 Cura Installation</b> .....	21
<b>6. Printing</b> .....	29
<b>7. Manual filament change</b> .....	32
<b>8. Resume from outage</b> .....	33
<b>9. Trouble shooting</b> .....	36

Thank you for choosing **ANYCUBIC I3 MEGA** 3D printer.



Please read the assembly instructions carefully.



Please visit [www.anycubic3d.com](http://www.anycubic3d.com) for more support information.



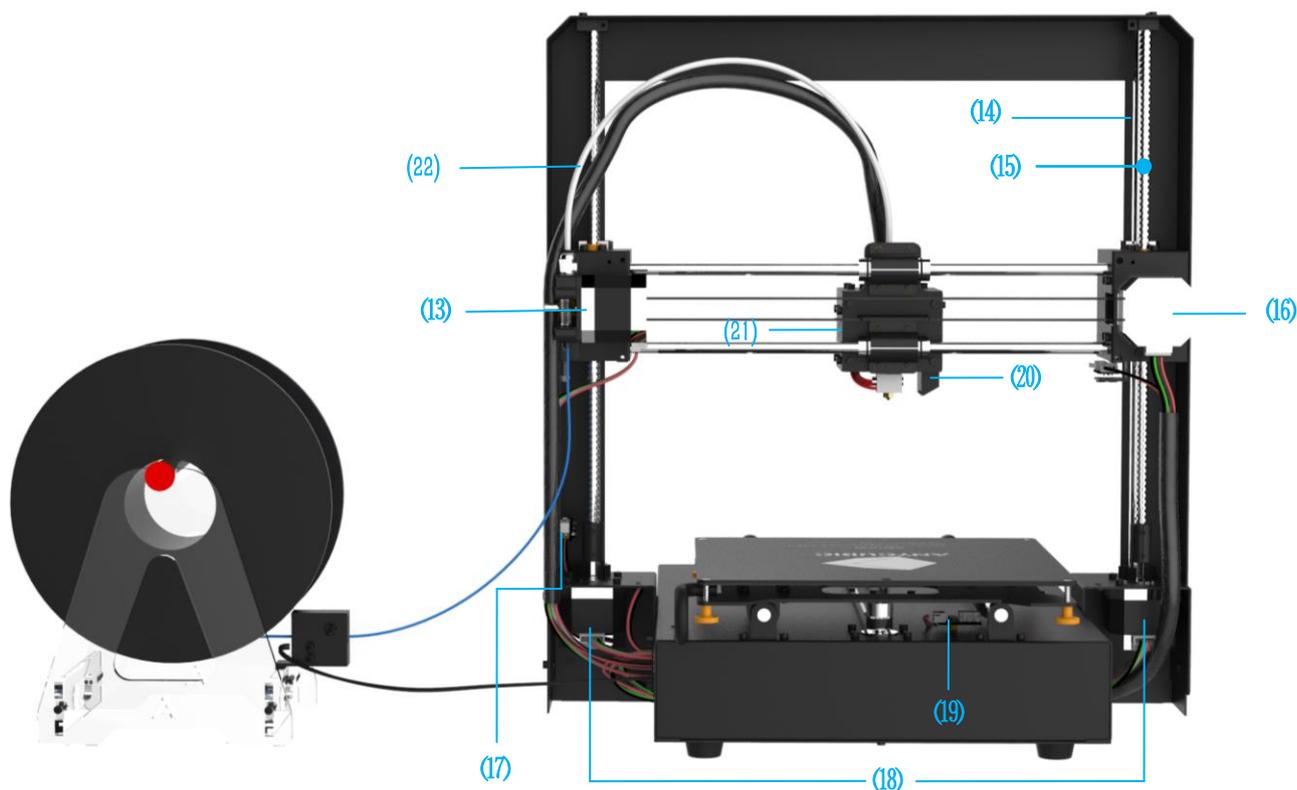
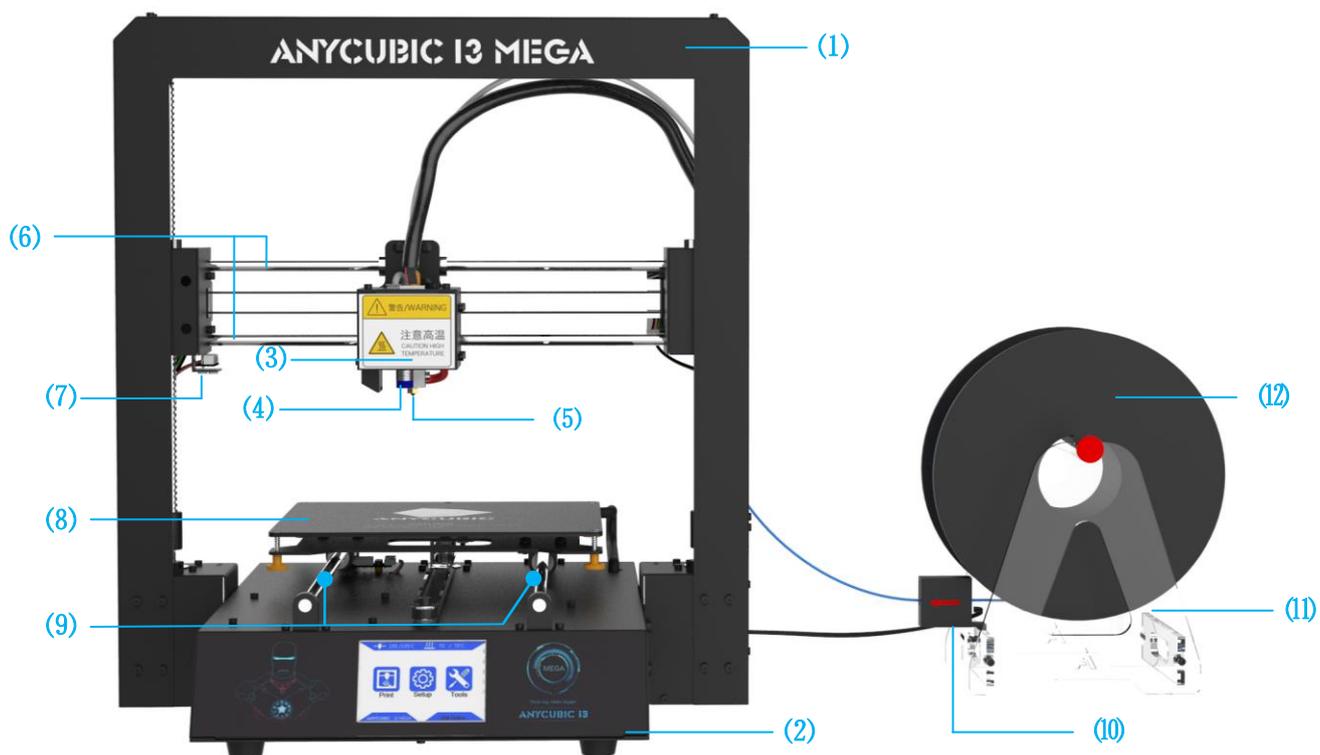
Email us on [support@anycubic3d.com](mailto:support@anycubic3d.com) or [james@anycubic3d.com](mailto:james@anycubic3d.com)

If you experience any issues with this product, or the performance is not what you had expected, please contact us first before returning the item. We are here to solve any problems for you.



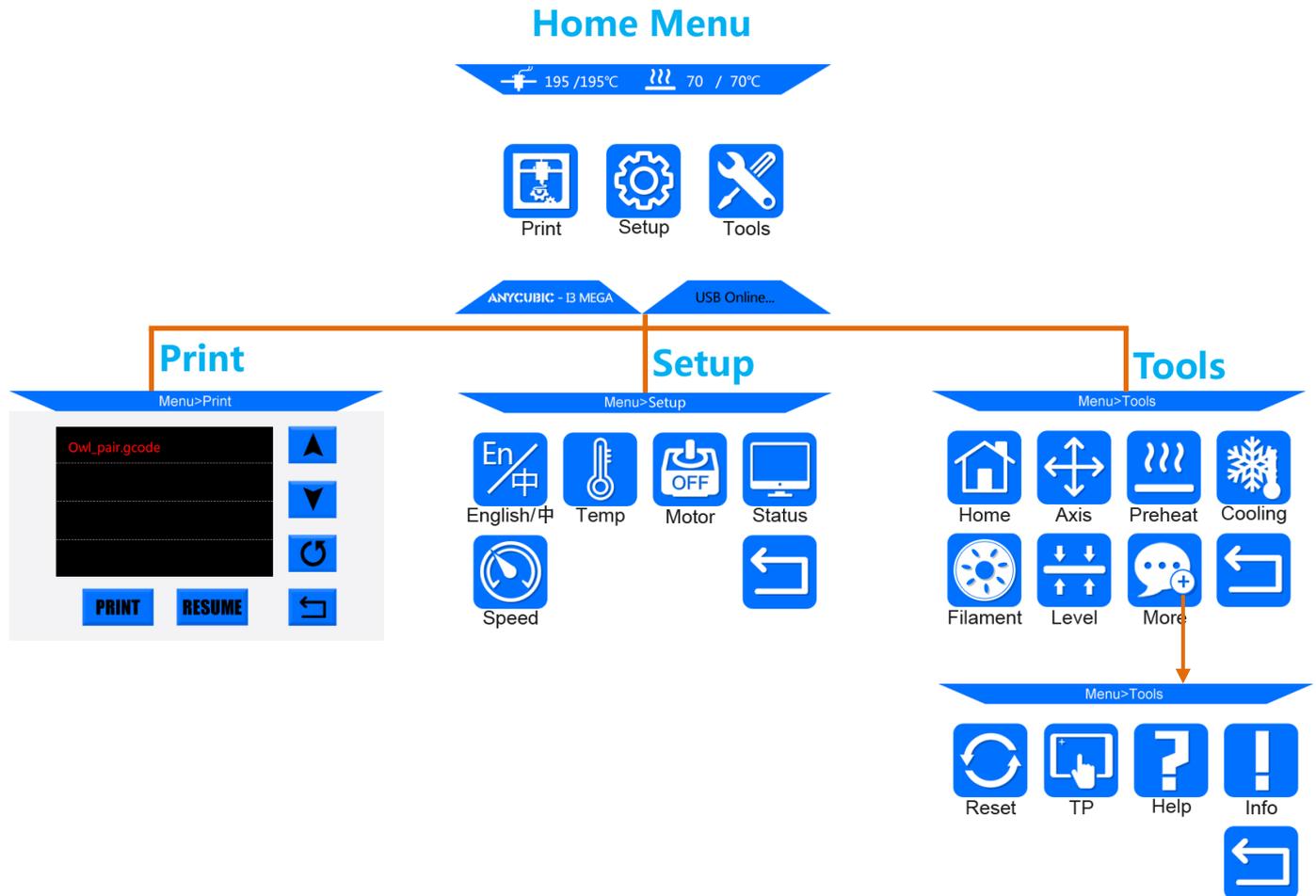
Team **ANYCUBIC**

# 1. Product Overview



- (1)Frame (2)Base (3)Print head (4)Z probe (5)Nozzle (6)**X smooth rods** (7)X end stop
- (8)Print platform (9)**Y smooth rods** (10)Filament sensor (11)Spool holder (12)Filament spool
- (13)Extruder (14)**Z smooth rods** (15)Z lead screw (16)X motor (17)Z end stop (18)Z motors (19)Y end stop
- (20) Model cooling fan (21) Hotend cooling fan (22) Teflon tubing

# Menu Directory



## Home menu

**Print:** enter the print menu

**Setup:** enter the setup menu

**Tools:** enter the tools menu

(Other information: ①nozzle temperature ②heated bed temperature ③printer status)

## Print

**Print:** print the selected files in SD card

**Resume:** Resume from outage (only valid for offline print)

(Other information: ①Page up and down ②Refresh ③Return to the home menu)

## Setup

**En/中:** Language selection between English and Chinese

**Temp:** Enter the menu to adjust ① E0 (hotend) Temp (170-260°C) ②Bed Temp (0-120°C)

**Motor:** Disable all motors (only valid when no print job)

**Status:** Enter the sub-menu with Print/Pause/Resume icon (only valid for offline print)

(Other information: ①Files ②Print Rate ③Time ④Progress ⑤E0 Temp ⑥Bed Temp ⑦  
coordinates for X/Y/Z axis ⑧Return to previous menu)

**Speed:** Enter the menu to adjust ①Fan speed (0-100) ②Print Rate (50-999)

**Return:** Return to Home Menu

## Tools

**Home:** ①Home X ②Home Y ③Home Z ④Home All ⑤Return (only valid when no print job)

**Axis:** ① Home all axis ②Move X/Y/Z axis by 0.1/1/10 ③Choose the travel speed

Low/Medium/High (only valid when no print job)

**Preheat:** ①Preheat PLA ②Preheat ABS (only valid when no print job)

(Other information: ①E0 Temp ②Bed Temp)

**Cooling:** Cut off the power of hotend and heated bed (only valid when no print job)

**Filament:** ①Filament In ②Filament Remove ③ Stop (will automatically heating to 200°C for  
filament in or remove) (only valid when on print job)

**Reset:** Popup window to decide if reboot the mainboard

**More:** Enter the next page of Tools sub-menu

**TP:** Touch panel alignment ( click on the cue points )

**Help:** Basic description of the Menu

**Info:** Information about the product

**Return:** Return to Home Menu

## 2. Part list

				
<p>Tool pack</p>	<p>Screws ( M5*8 )</p>	<p>SD card</p>	<p>SD Card reader</p>	
<p><b>ANYCUBIC 13 MEGA</b></p>	<p>Gloves</p>	 <p>Power cord</p>	 <p>Tweezer</p>	 <p>Spool holder</p>
				
<p>Test filament (Random)</p>	<p>USB cable</p>	<p>Backup hotend</p>	<p>Scraper</p>	<p>Plier</p>

### 3. Assembly instruction

1. Unpack and take out the printer and accessories.

The smooth rods and lead screw may be greased in factory, so please wear gloves.

2. Find 8 pieces of M5\*8mm hex cap screws and the corresponding screw driver.

Follow ① ② ③ in Fig. 1. Carefully lift the base to fit into the frame and then fix them by the M5\*8mm hex cap screws. The screw locations are pointed with red squares in ③.

The screws can be installed in a diagonal order and can be tightened after all screws inserted in place.

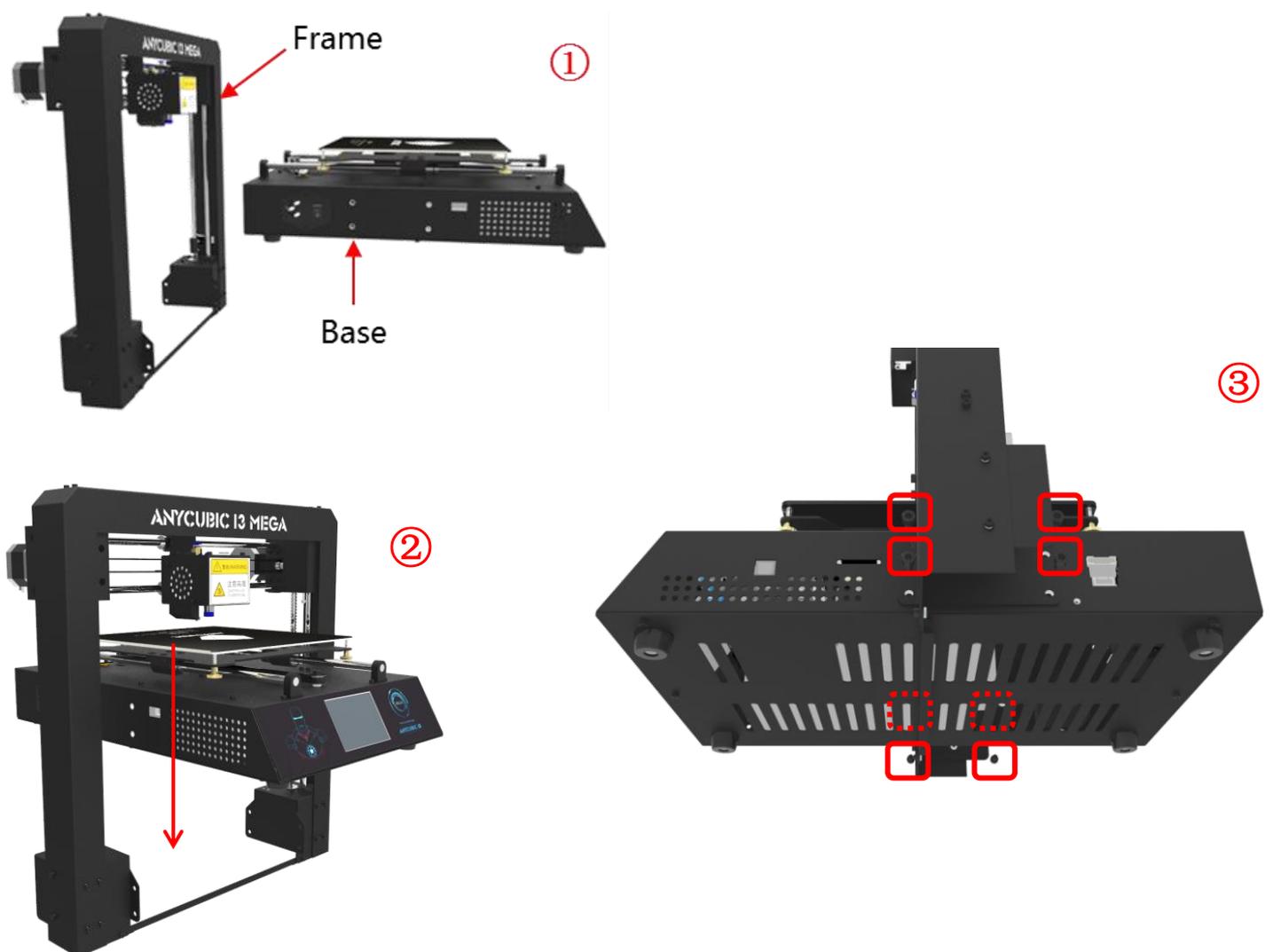
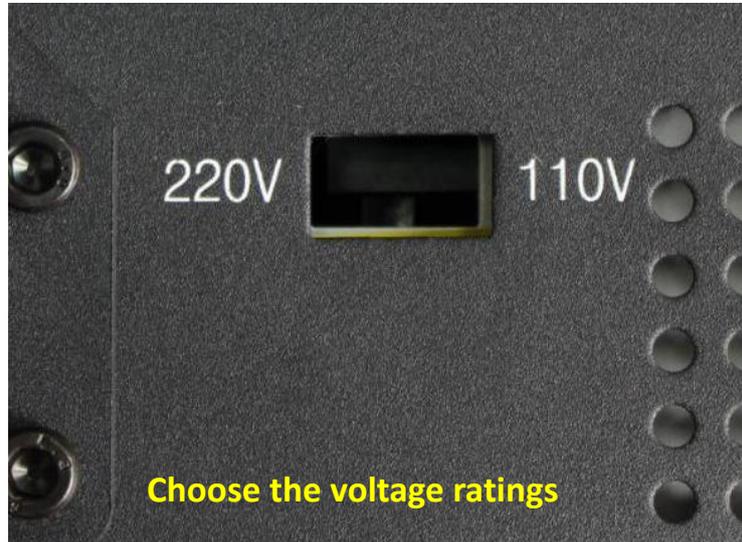


Figure 1

### 3. Wiring

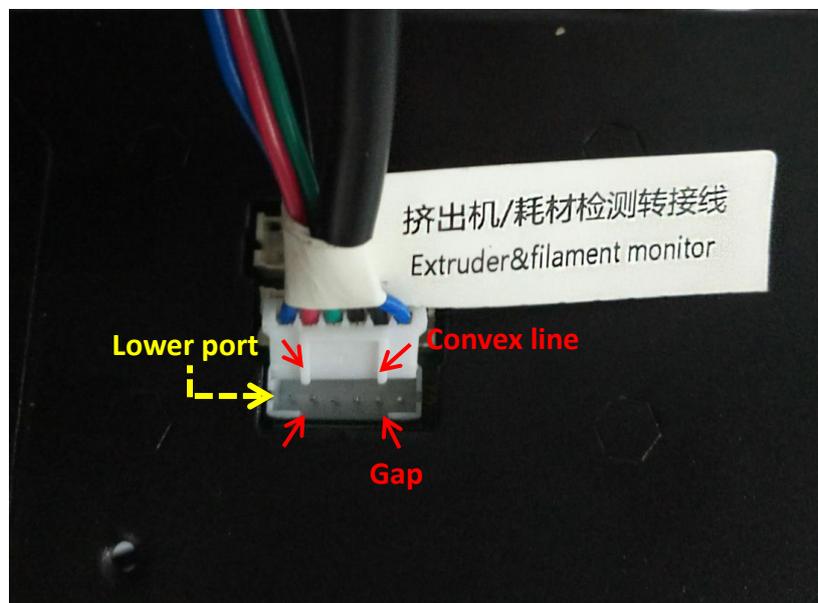
- (1) **Fig.2**, customers are required to select the correct voltage mode according to their local voltage ratings (110V/220V). Please notice that the switch is inside the bottom left of the base and **220V is default**. A hex screw driver can be used to move the switch inside.



(Figure 2)

- (2) There are 3 ports at the bottom right of the base, and accordingly there are 3 cable connectors. Firstly, in **Fig. 3**, insert the cable connector labeled “Extruder&filament monitor” (6 pins) to the lower port.

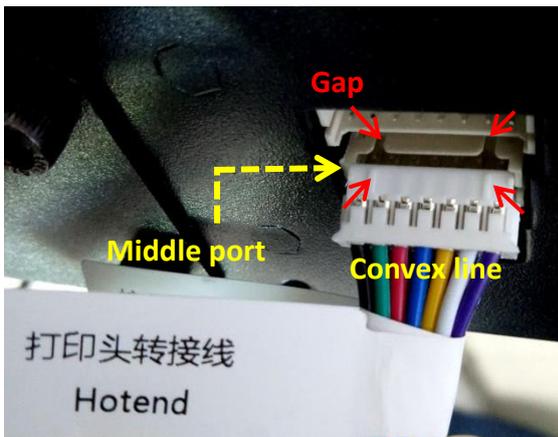
Pay close attention to the up and down side of the connector, and make sure the connector is well inserted in place, and no pins bent. WRONG or loose connection would lead to malfunction of the machine, the same for the rest of other two connectors.



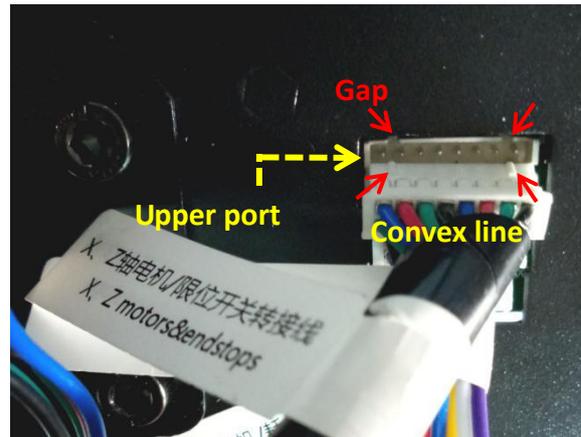
(Figure 3)

(3) **Fig.4**, insert "Hotend" connector to the **middle** port (14 pins).

(4) **Fig.5**, insert "X/Z motors&endstops" connector to the **upper** port (16 pins).

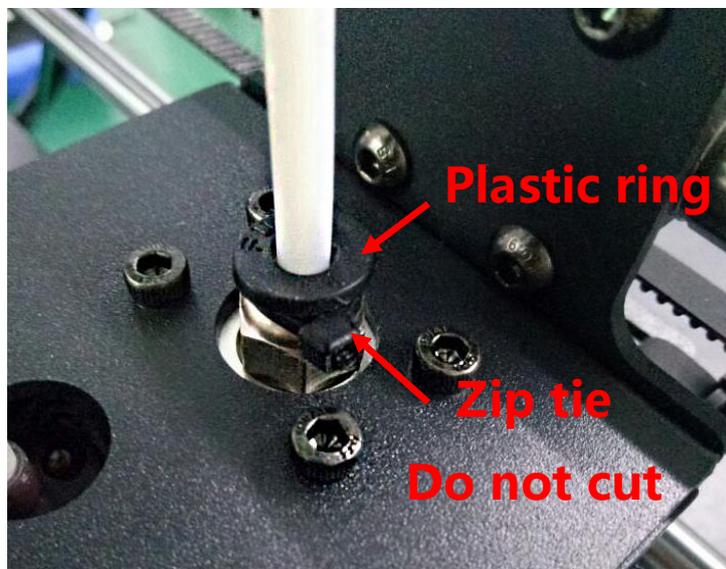


(Figure 4)



(Figure 5)

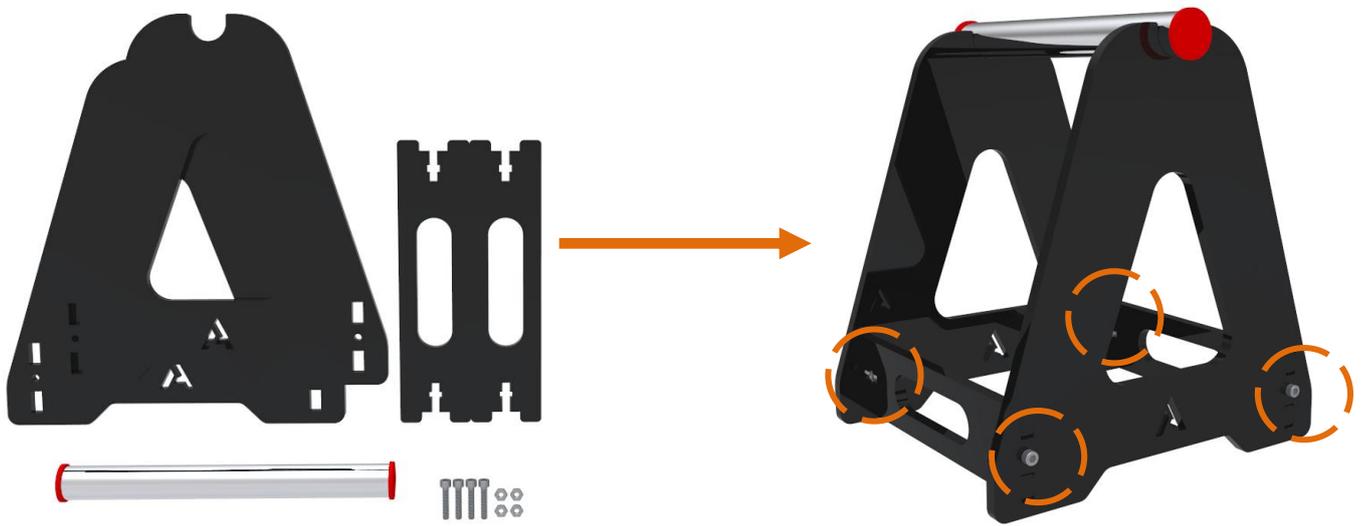
(5) **Fig. 6**, customers may notice there is a piece of zip tie attached just below the plastic ring of the quick connector. **Do not cut it off**. Only cut this zip tie when swapping or repairing a malfunction hotend, because it needs to push down the plastic ring and pull out the Teflon tubing.



(Figure 6)

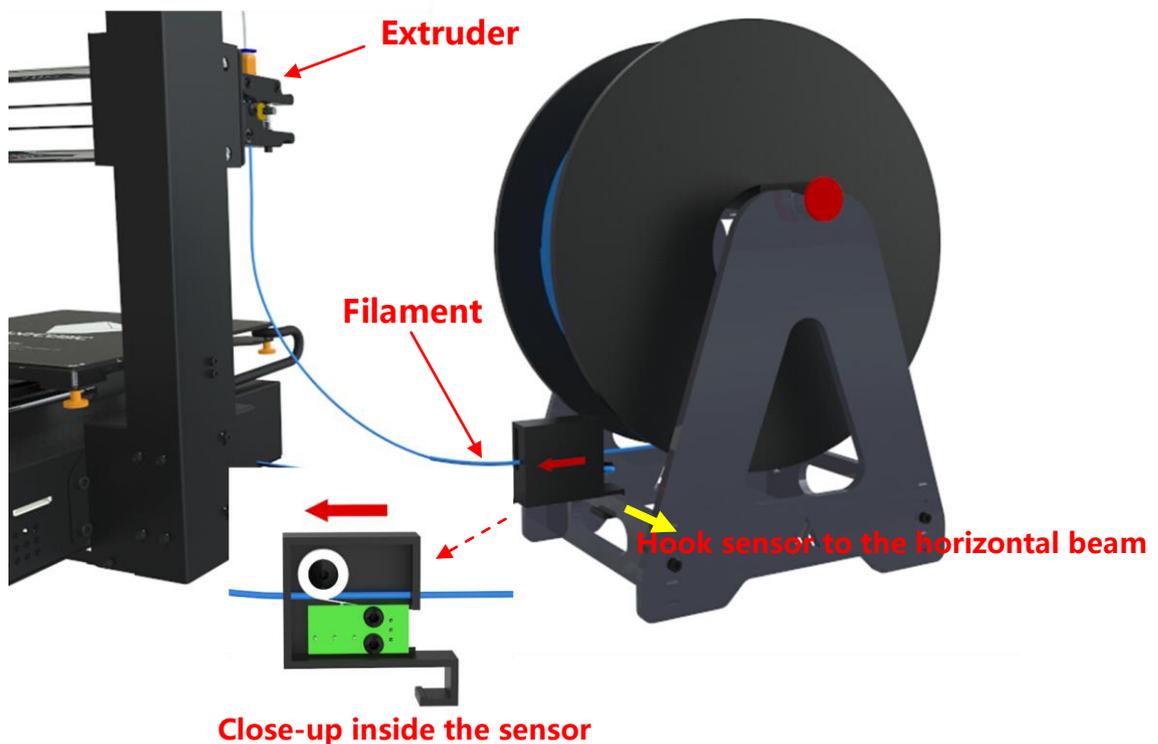
#### 4. Spool holder and filament sensor

(1) As shown in **Fig. 7**, assemble the spool holder and tighten 4 pairs of screw and nuts at the lower corner. (The color and shape of the spool holder might be slightly different from this picture)

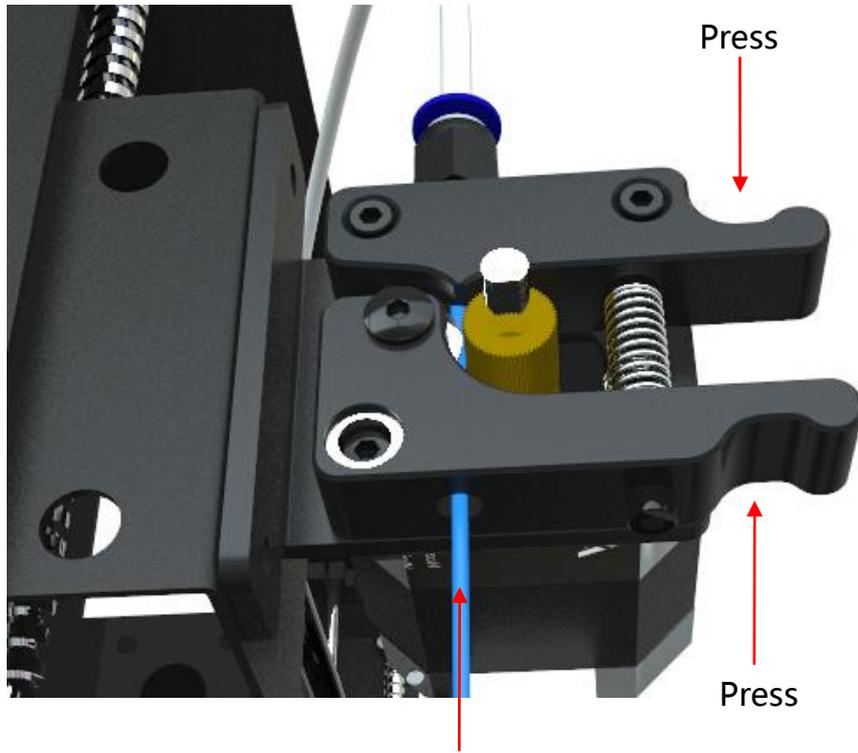


(Figure 7)

(2) Install the filament spool to the spool holder. As shown in **Fig.8**, pass the filament through the filament sensor. Then, as shown in **Fig. 9**, insert the filament into the extruder and then into the Teflon tubing (but not fully into the hotend yet). When insert the filament to the sensor and extruder, it is suggested to cut off the bent tip of the filament, and rotate the angle if feels any resistance at the sensor or extruder. The filament sensor can be hooked on the lower beam of the spool holder. It is important to make sure there is no tied or tangle on the spool.



(Figure 8)



(Figure 9) Load the filament manually

## 4. Leveling

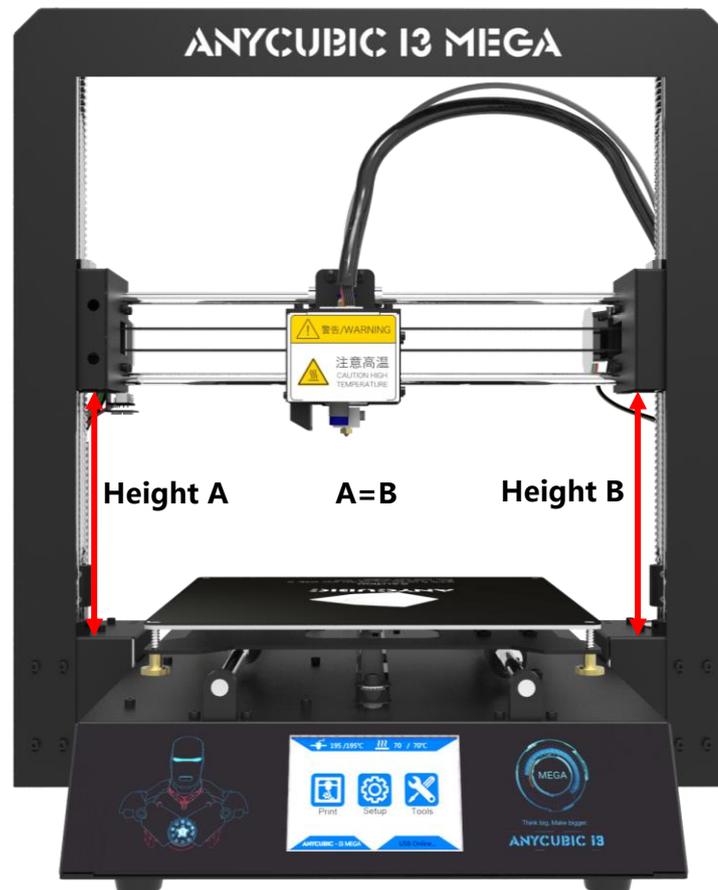
It is essential to have the platform leveled for 3D printing. **ANYCUBIC I3 MEGA** offers two methods for platform leveling: **assisted leveling and manual leveling**. For experienced users, it is recommended to just level the platform manually. For new customers, you may use the assisted leveling.

**ANYCUBIC I3 MEGA** equipped with proximity switch (sensor) for the assisted leveling function. Please note that this sensor is only function with metal platform (such as aluminum) and the results might be inconsistent when the platform is hot.

### 4.1 Assisted Leveling

1. Ensure the wiring is OK. Then connect the power cord to the machine and the power outlet respectively. Switch on the machine.

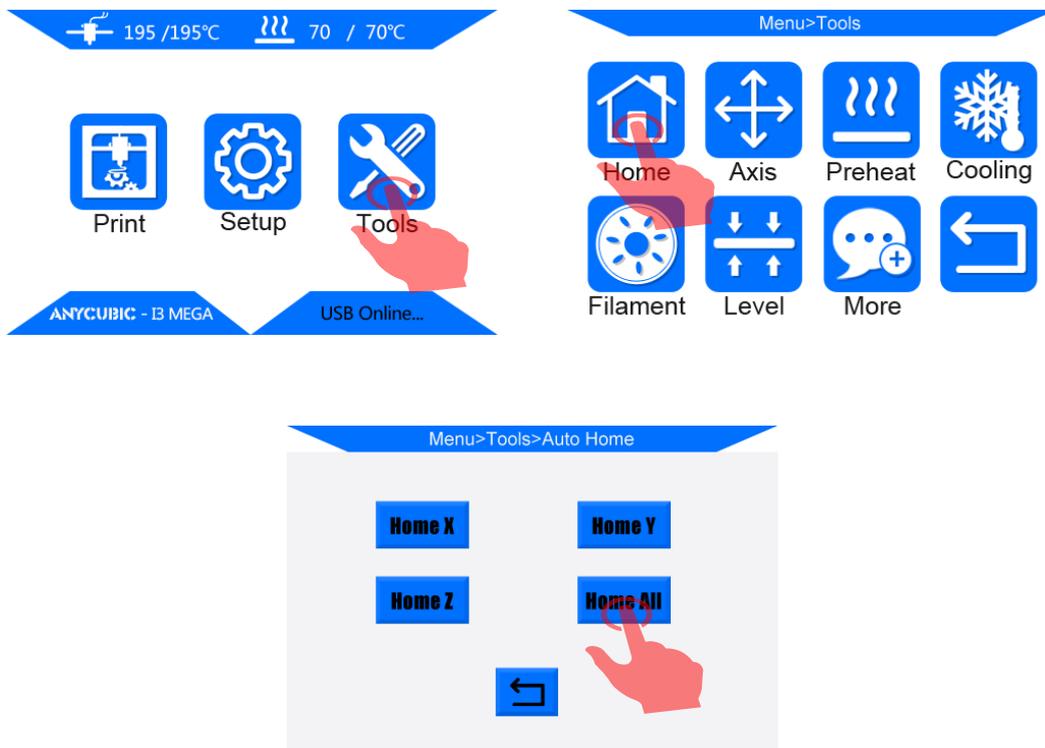
Before proceed, make sure the X axis is leveled (**Fig. 10**), in case X axis lost its balance during shipping or due to other unexpected causes. A rule or maybe caliper or anything with certain length can be used for this measure. The Z lead screw can be turned manually for adjust the levelness of the X axis (wear gloves).



(Figure 10)

2. **Fig. 11**, on the Home Menu, Click "Tools" --> "Home" --> "Home All" .

After "Home All" , it is suggested to visually check again if the X axis is leveled or not. If adjustment needed, you may have to click "Setup" --> "Motor" to disable the motor so the Z lead screws could be turned manually for height adjusting. After adjustment, click "Home All" again for the next steps.



(Figure 11)

3. Tighten the 4 screws/nuts underneath the print platform till stop (**Fig. 12**), to create a distance between the platform and print head.

Click "Tools" --> "Level" , the machine will auto home first and then the X/Y/Z axis will be locked and cannot be moved manually. Next, click "Start" in the pop-up window.



(Figure 12)

4. The print head will be traveling to the 4 corners of the print platform anti-clockwisely. When it arrives at the first point, please slowly loosen the corresponding nut (**Fig. 13**), so the platform will be gradually bouncing back toward the print head and proximity sensor

and finally triggers the sensor and there will be audio feedback from the beeper. When you hear the beep, please stop adjusting the nut and click "Next" for the following point (Fig. 13). Do the same to the rest points.

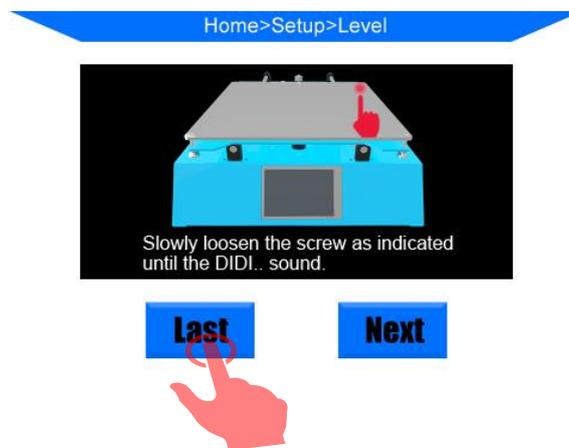


(Figure 13)

5. The principle of "Assisted leveling" is to manually adjust the height between proximity sensor (nozzle) and platform until the beep.

The procedures are: tighten the 4 nuts under print platform-->click "Level" -->loosen the nut at point No. 1-->hear the beep-->next point...-->done.

During leveling, it is suggested to click "Last" to check the previous points to verify the results because it may need fine tune few times to achieve the best result (Fig. 14).



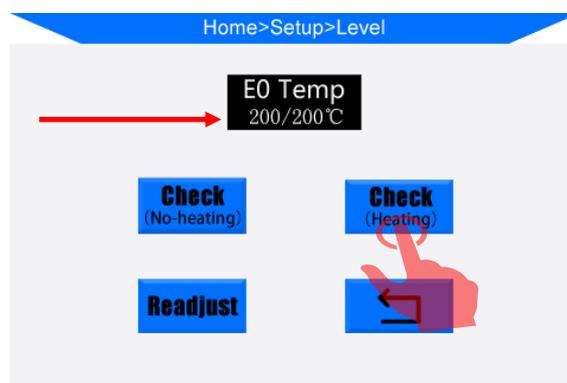
(Figure 14)

6. Upon finished, the checking interface will appear (Fig. 15).

If clicking “Check (No-heating)” , the print head will immediately run a rectangular on the print platform, you may observe the distance between the nozzle and platform. Ideally, the distance should be of 0.1~0.2 mm (approx. a paper thin)

If clicking “Check (Heating)” (**Fig. 15**), the machine will automatically heating the nozzle to 200°C and run a rectangular again with extrusion.

**Note:** because the filament has not been inserted to the hotend yet, so, here it is required to manually feed the filament through the Teflon tubing into the hotend as the temperature rising. Push down the handle at the extruder (**refer to Fig. 9**) and manually insert the filament all the way into the hotend and the filament should flow through when temperature reaching to over ~180-190°C, otherwise the filament has not been inserted properly. You may use the tweezer to carefully get rid of the extruded filament at the nozzle.

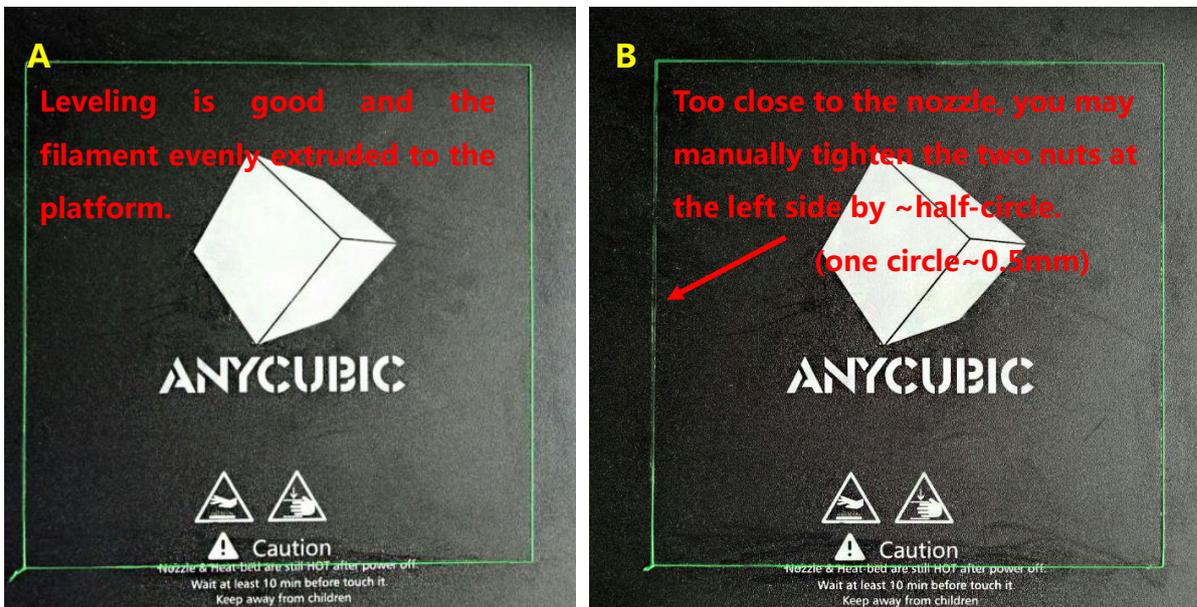


(Figure 15)

**Tips:** a during “Check (Heating)” , the touch screen will turn grey and non-responsive.

b when nozzle is too close to the print platform (i.e. leveling is not appropriate), the extrusion gear might be slipped and it will back to normal after manually increase the distance (refer to next step 7).

7. The results of “Check (Heating)” are described as in **Fig. 16**.



(Figure 16)

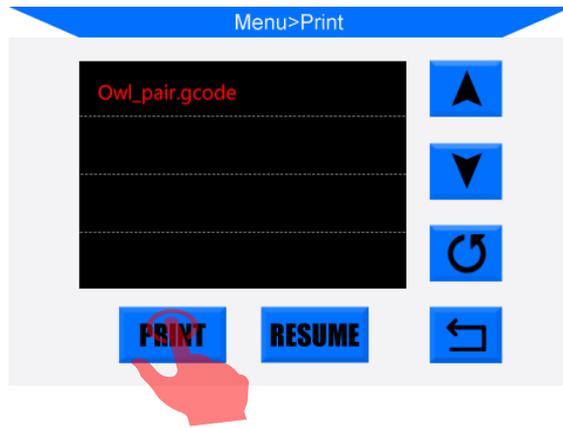
As shown in **Fig. 16B**, you may need to manually fine tune after assisted leveling to achieve satisfying results. After fine tune, please scrape off the previous one, and run another "Check (Heating)" to verify. **Never direct the scrapper toward your hands.**

For first time users, it may take few times to get satisfying results as shown in Fig. 16A.

However, it is still OK to go for the next step even if the result is like Fig. 16B shows.

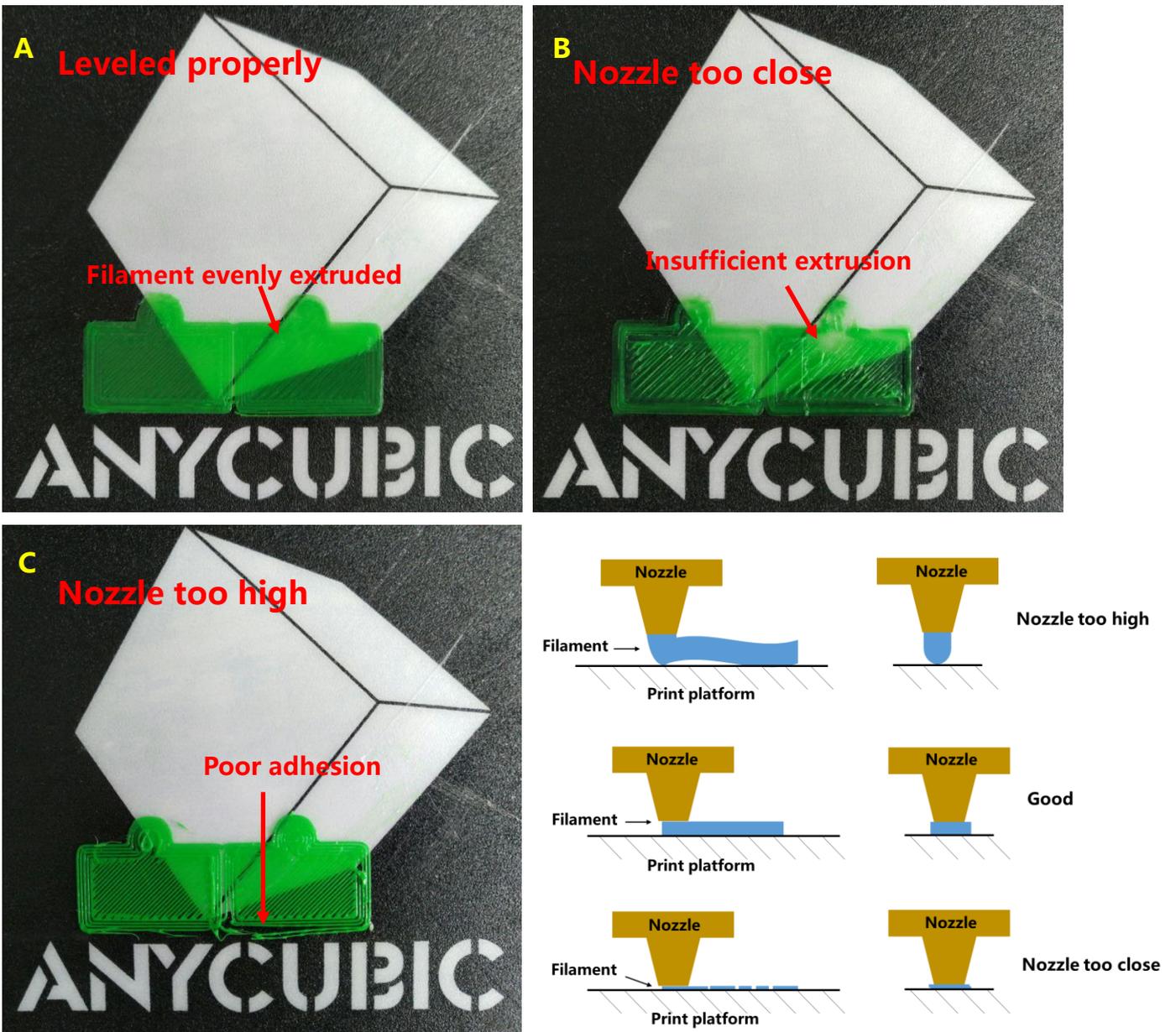
There will be more explanation on how to fine tune the leveling (**refer to next step 8**).

8. Insert the SD card (back side facing up) into the slot at the bottom right side of the base. Click on the Home "Print" into the print files interface. Click on the exist file "owl\_pair" (author: etotheipi, [www.thingiverse.com](http://www.thingiverse.com)), and click "Print" (**Fig. 17**). The machine will automatically heating and print the file (heating bed first then the nozzle). Again, if the filament has not been inserted to the hotend yet, please do so manually. Use the tweezers to carefully remove the extruded filament before printing.



(Figure 17)

As shown in **Fig. 18**, there might be 3 results for the first layer of the “owl\_pair” .



(Figure 18)

In case of “nozzle too high” or “nozzle too close” (**Fig. 18 B & C**), please click

“Stop” on the screen, raise the nozzle to avoid platform burnt (click “Tools” --> “Axis” --> “10” on +Z column), and manually fine tune the nuts under the platform. Specifically, when “nozzle too high” , slowly loosen the corresponding nuts underneath by half circle, while “nozzle too close” , slowly tighten the corresponding nuts underneath by half circle. After that, carefully scrape off the previous firstly layer, and run the owl\_pair print again to verify. It may need few times adjustment until satisfying results.

### **Tips:**

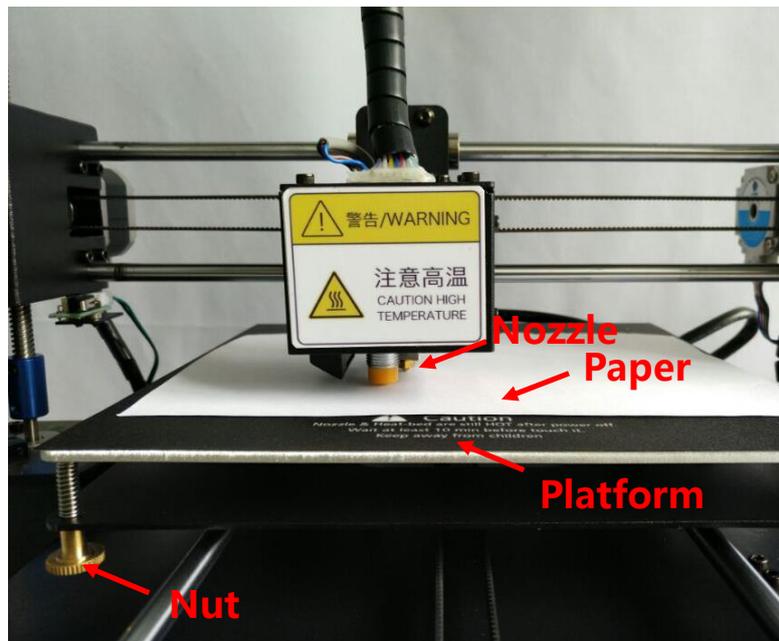
- a “Assisted Leveling” is only functional if the relative distance between proximity sensor and Z axis end stop is not changed. If it has been changed accidentally please contact us or you may have to use the manual leveling which will be explained in next section.
- b If using Cura for slicing, please set the “Initial layer thickness” to 0 for better adhesion.
- c During assisted leveling, it is OK the nozzle may out of the range of the print platform.
- d The proximity sensor only valid to metallic plate such as aluminum, and it is sensitive to temperature. It is suggested to use this function at room temperature. If changed to glass print platform, please use manual leveling.

## **4.2 Manual Leveling**

1. Switch on the machine, click on the Home Menu, “Tools” --> “Home” --> “Home all” , and make sure X axis is visually leveled as shown before, refer to the previous **Fig. 10**.
2. Click on Home Menu, “Setup” --> “Motor” to disable the motors. Manually move the print head and platform back and forth to let the print head travel to the 4 corners of the platform one by one.

Insert a piece of paper between the nozzle and the print platform, and adjust the

corresponding nut underneath the platform to let the nozzle and platform become closer until just feel the resistance when dragging the paper in between, (**Fig. 19**). Likewise, do the same to the rest of 3 corners and the center of the platform. Upon finish, you may refer to **Step 8** in last section (Assisted leveling) to try to print the “owl\_pair” model and fine tune the nuts when necessary.



(Figure 19)

Tips:

- a “just feel the resistance when dragging the paper in between” means the paper can be moved, but with resistance.
  - b It is suggested to always double check the 4 corners during manual leveling.
3. Sometime, customers may want to cover a piece of glass on top of the aluminum print platform. In this scenario, customers have to use manual leveling because the “Assisted leveling” only valid for metal platform.

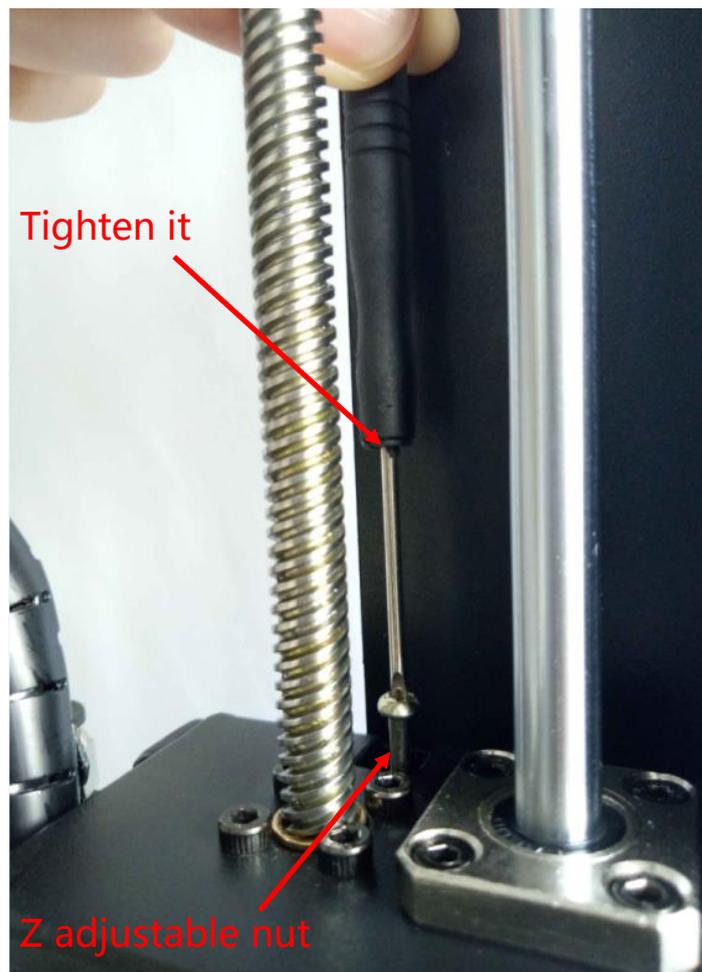
There are few things have to be done before proceed with manual leveling. Because the glass bed increases the height of the print platform, so the print head would probably hit the glass bed when Home (Zero) and that has to be prevented.

So, turn on the machine, fully tighten the 4 nuts underneath the print platform, and increase the height of print head by clicking "Tools" --> "Axis" --> "10" on +Z column. As shown in **Fig. 20**, at the right side of X axis, tighten the Z adjustable nut by ~2-3mm (which equals to the thickness of the glass bed).

Reason behind: the other end of Z adjustable nut can trigger the Z end stop when Home (going down) and 'tells' the machine that Z axis is now getting to the Zero position and stop moving. So, tighten the Z adjustable nut (~3mm) would let the Z axis getting to the Zero position and stop there ~3mm higher than before, thereby avoid hitting into the platform. It may need adjustment few times.

After adjustment, please click "Tools" --> "Home" --> "Home all" to verify.

Lastly, follow **Step 2** in manual leveling above to start.



(Figure 20)

4. After leveling, please refer to Step 8 in “Assisted Leveling” to insert the SD card and print the “owl pair” to check out the results.

## 5. Software installation

There are two working mode for **ANYCUBIC I3 MEGA** 3D printer, print offline (SD card) and print online (controlled by PC via USB).

**Print offline:** After leveling the platform, insert SD card, click “Print” at the Home menu and select a file (gcode file) to print.

**Print online:** Install CP2102 driver to bridging PC and machine, and install Cura for slicing and control the machine via USB.

Generally, it is suggested to use Print offline to minimize the noisy signal from USB connection.

### 5.1 Driver installation

Firstly, power on the machine and connect it to PC via USB cable.

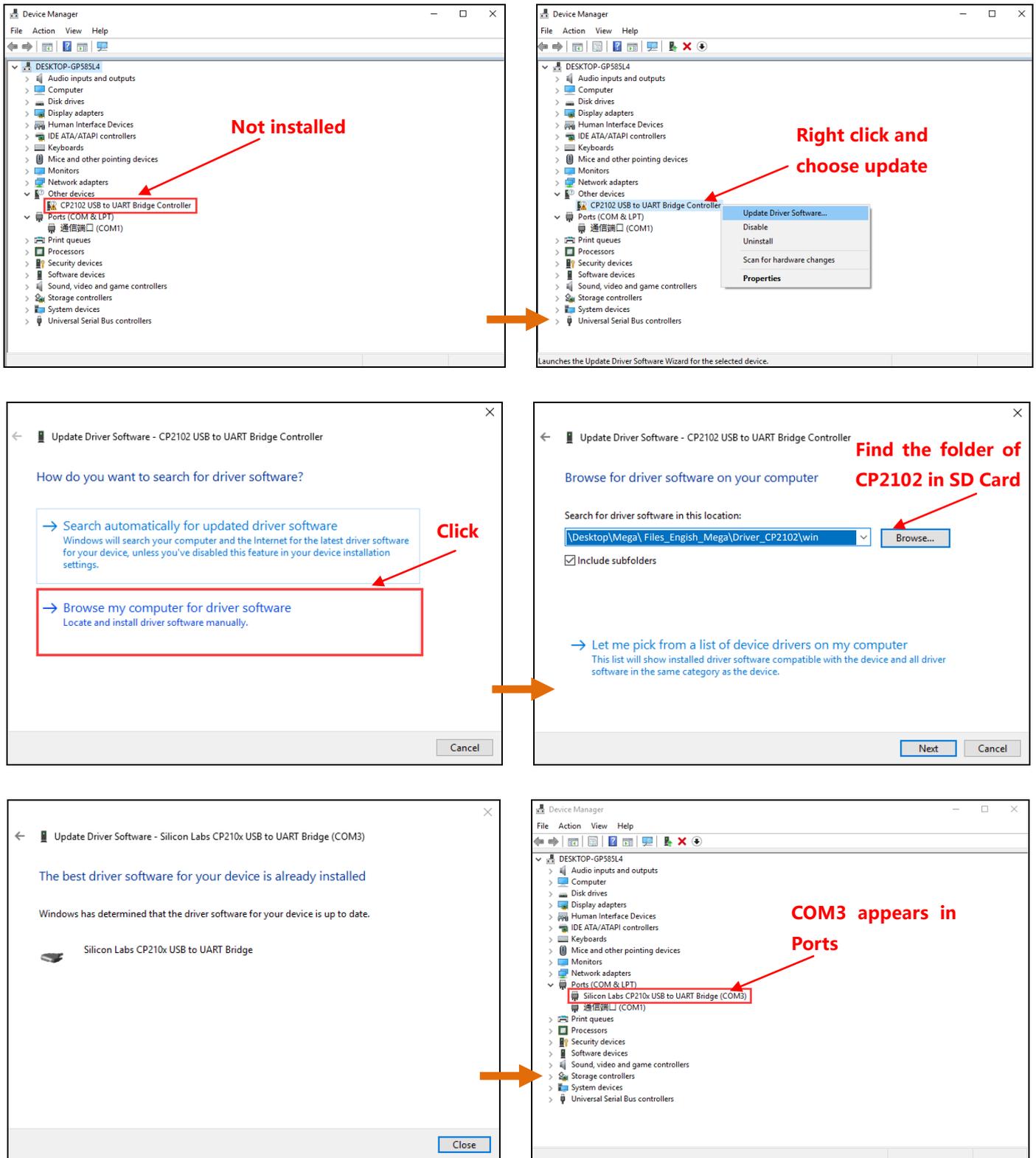
**ANYCUBIC I3 MEGA** 3D printer uses TriGorilla mainboard which has CP2102 chip for communication. So, it is required to install CP2102 driver so the 3D printer could be recognized by PC.

CP2102 driver has been stored in the SD card. “Files\_English\_Mega” ---> “Driver\_CP2102” . There are two versions, Windows and Mac version.

For Windows, specifically, “CP210xVCPInstaller\_x64” is for 64 bit system and “CP210xVCPInstaller\_x86” is for 32 bit system.

Here we take Windows 7-64 bit PC system for example. **(There is a PDF “Installation for Mac PC” in SD card explains how to install the driver and software for Mac).**

Detailed procedures: right click on "Computer" ---> "Properties" ----> "Device Manger" , and then follow the images in **Fig. 21**.



(Figure 21)

After successfully installation, the COMx will appear in the Ports of Device Manager. Here is COM3, 3 is random, customers would have their own number depends on the PC.

It is required to choose the correct COMx later for Cura to be able to connect with the 3D printer.

If the PC has been installed CP2102 driver before, then there should be already a COMx in Ports of Device manager.

In some cases, the driver could not be installed properly, but it may still see an abnormal COMx in Ports, please just uninstall the COMx and try to install the driver again.

## 5.2 Cura Installation

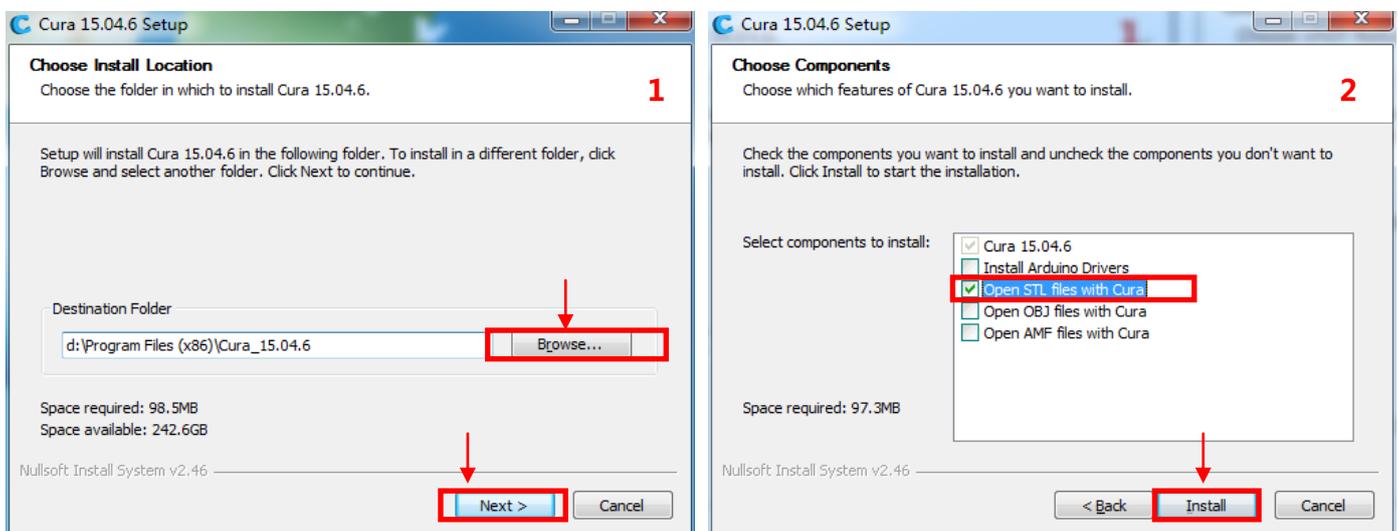
**ANYCUBIC 13 MEGA** 3D printer reads Gcode file and prints out object layer by layer.

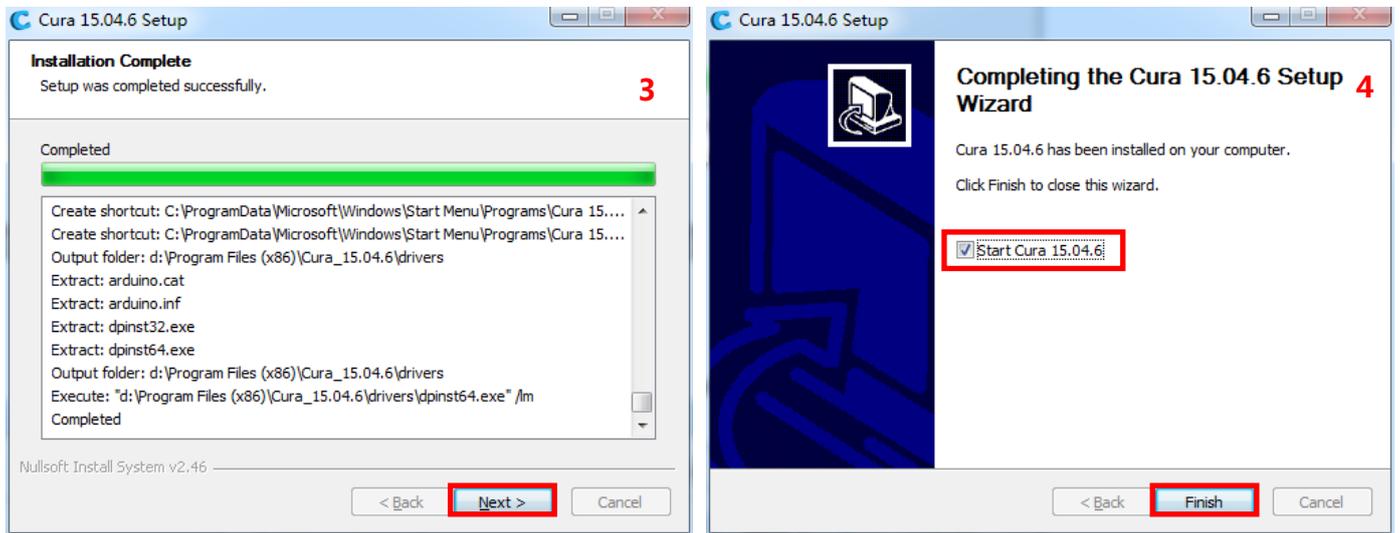
Normally we have to change 3D file (such as stl file) into Gcode file for 3D printer to read.

Software that can do convert 3D file into Gcode file has been called slicing software, which means this software can slice 3D objects into many layers.

There are several software for slicing. Here we take Cura\_15.04.6 for example. Location of Cura is SD card----> "Files\_Engish\_Mega" ----> "Cura" ----> "Windows" .

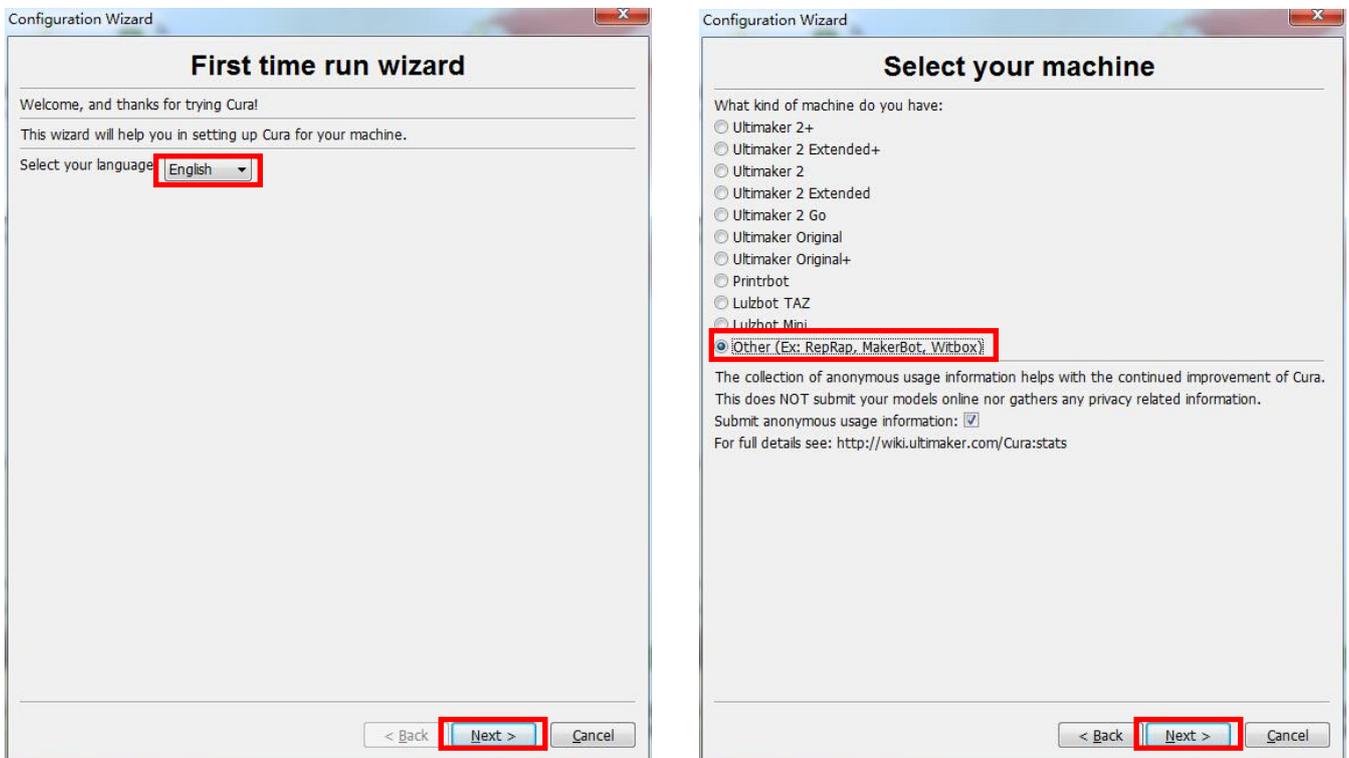
Double click "Cura\_15.04.6" , and follow the procedures shown in **Fig. 22**:

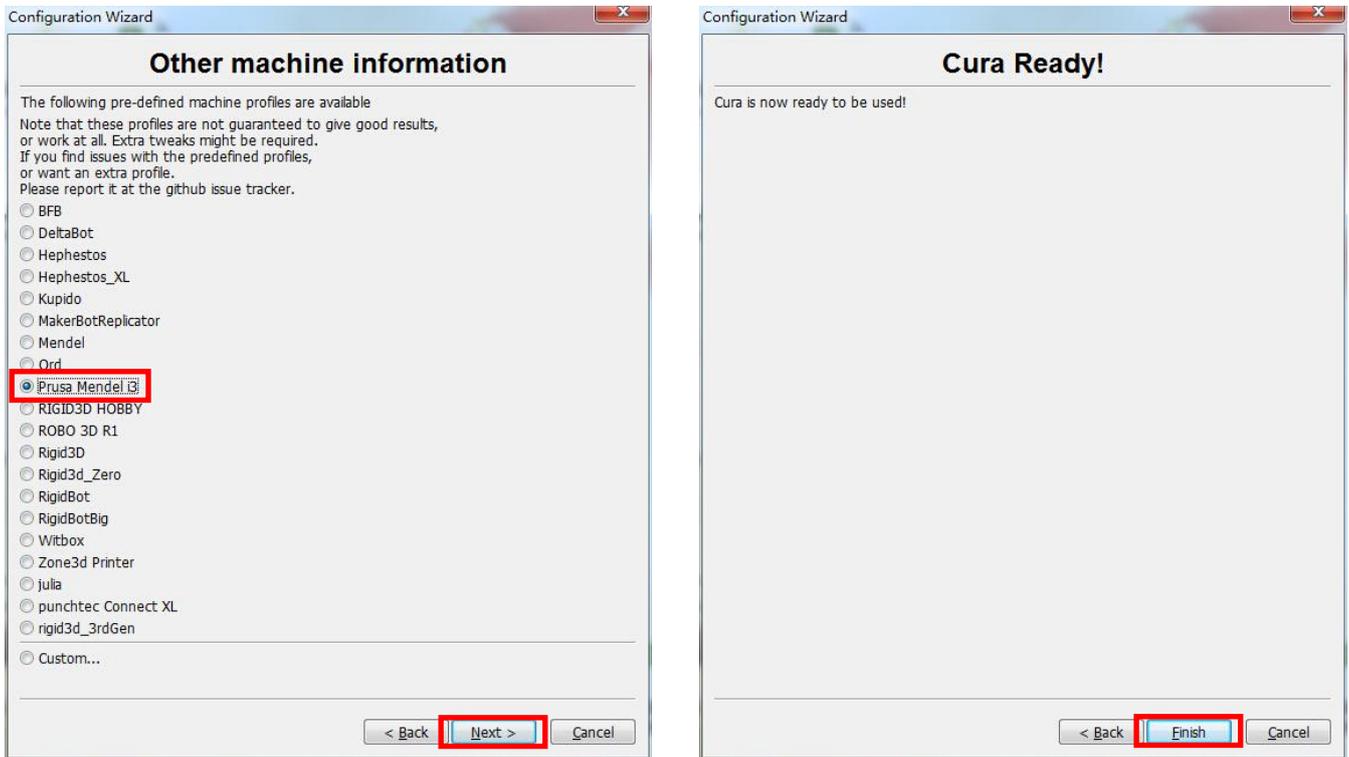




(Figure 22)

Next, there are few more settings regarding the machine type, show in Fig. 23.





(Figure 23)

Upon finish, and run Cura for the first time, there will be a default model, customers may click "File" ---> "Clear platform" to delete it.

### 5.2.1 Load 3D model into Cura

- (1) Clear the platform by clicking "File" ---> "Clear platform"
- (2) Load 3D files onto the platform by "File" ---> "Load model file...". Files with extension such as "STL" , "OBJ" , "DAE" and "AMF" can be loaded.

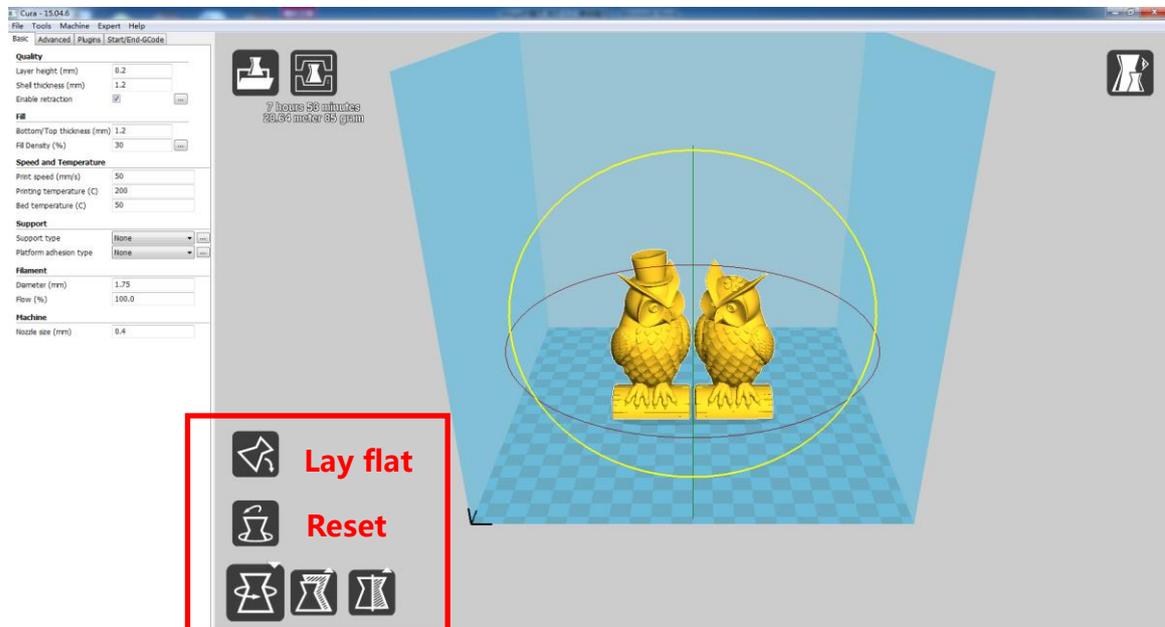
\*\*Files in grey are outside of the print area and need to be moved or scaled to fit in.

### 5.2.2 Manipulate 3D model in Cura

- (1) Zoom in/out: scroll the mouse wheel
- (2) Change viewing angle: right click the model and hold on and move the mouse
- (3) Position change: left click on the model and hold on and drag the model to move.
- (4) Rotate: single left click on the model and a few icons will appear in the bottom left of the window (**Fig. 24**). Click the rotate button, 3 circles will surround the model. Rotate the model by move the circle lines.

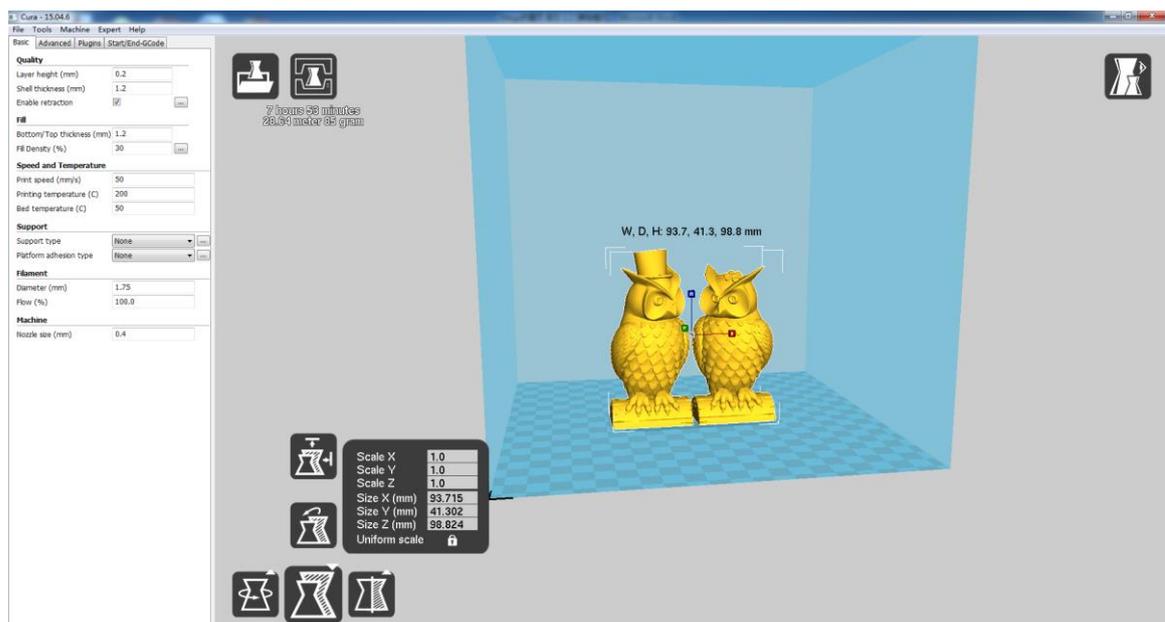
(4.1) Lay flat: it is very important to ensure the flat portion of the model is well attached to the platform. So, please use Lay Flat option everytime after rotating the model, as it will minimize the adhesion issues during printing. (**Fig. 24**)

(4.2) Reset: click it to return the model to the original orientation.



(Figure 24)

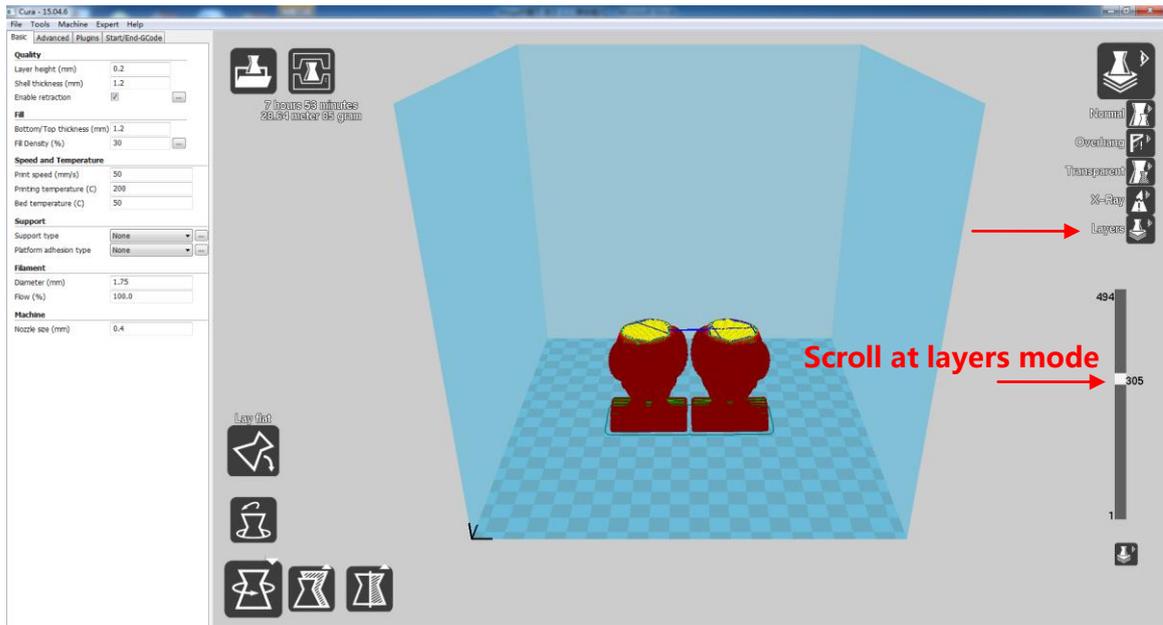
(5) Scale: to uniformly scale the model along X/Y/Z dimensions. To disable uniform scaling, click the lock in the lower section of the scaling window. (**Fig. 25**)



(Figure 25)

(6) View mode (**Fig. 26**): to view the model in different ways and helps to spotting issues

before print starts. Such as the Layers mode: to view the toolpath of the print head to check if there are skipped layers or gaps.

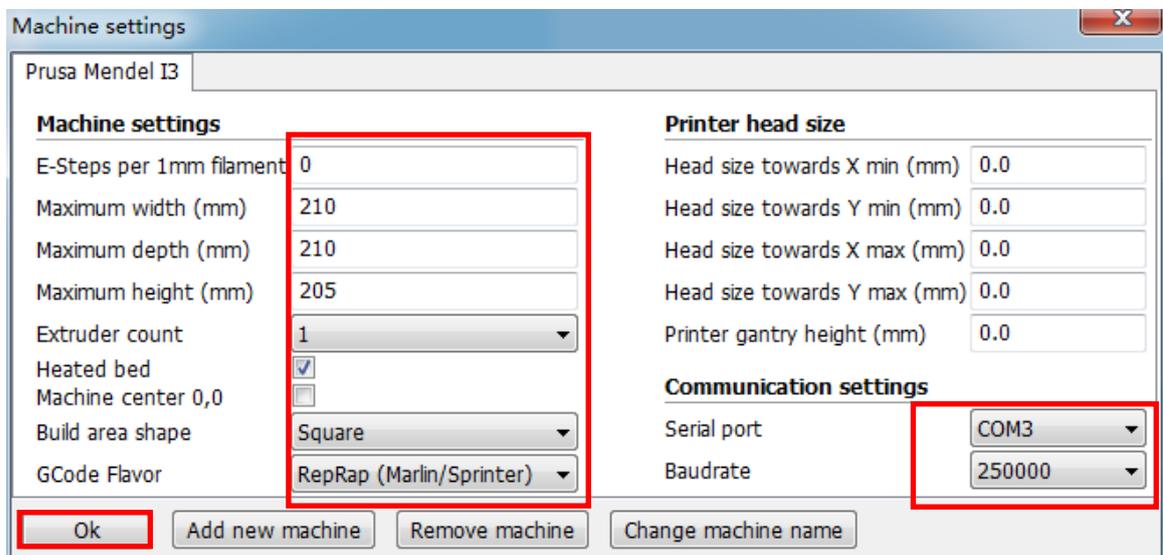


(Figure 26)

### 5.2.3 Cura settings

#### (1) Machine settings

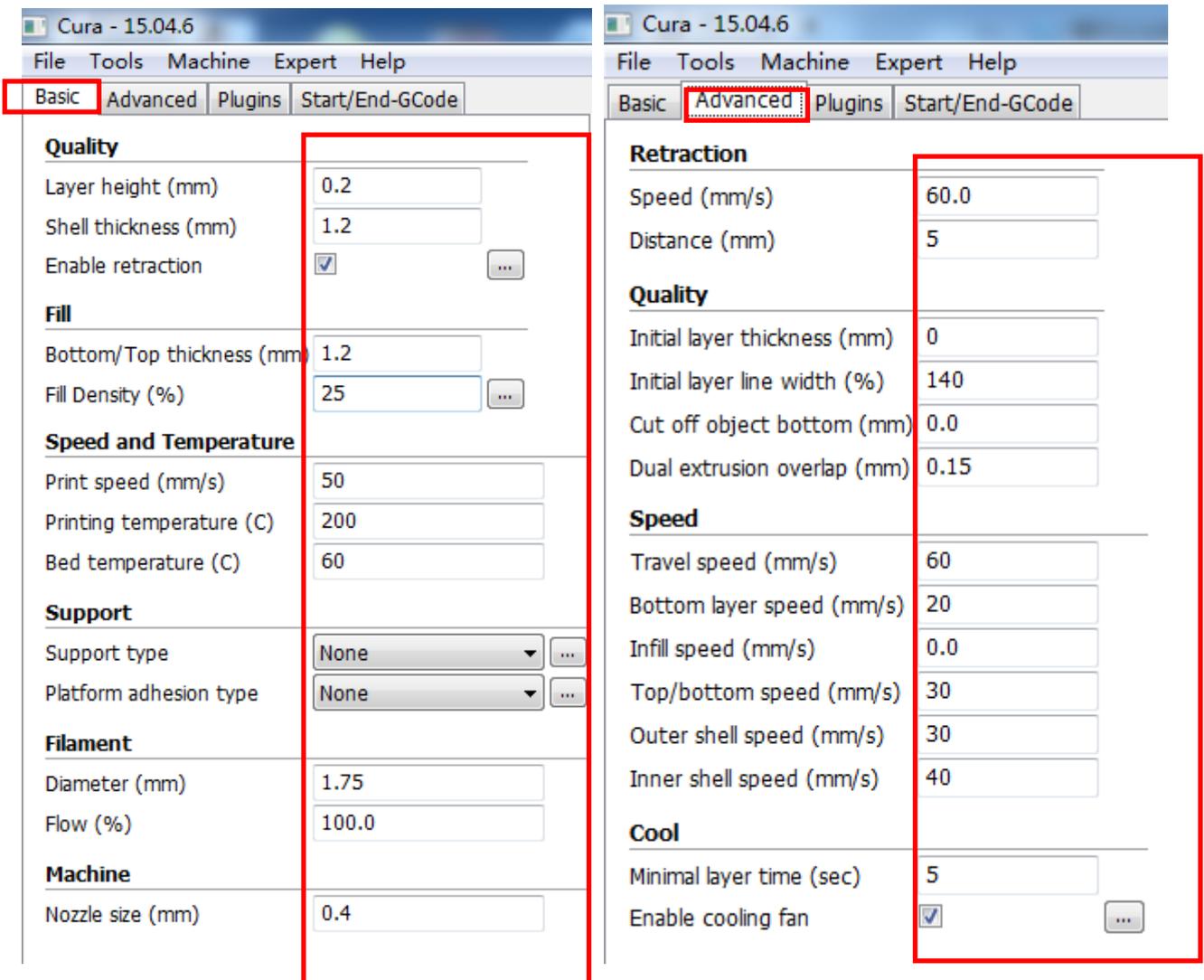
Refer to **Fig. 27**, click “Machine” ---> “Machine settings” to input those suggested parameters into the corresponding column. Please choose the same serial port which appears in the “Device Manager” (refer to **Fig. 21** and it is COM3 in this example, you may have a different COMx), and set the Baudrate to 250000.



(Figure 27)

## (2) Basic and Advanced options

Suggested parameters of “Basic” and “Advanced” for printing PLA are shown in **Fig. 28**. Stay the mouse upon each box and there will be explanation for it.



(Figure 28)

## (3) Plugins

\*It is recommended for new user to leave the plugins as default (no plugin enabled).

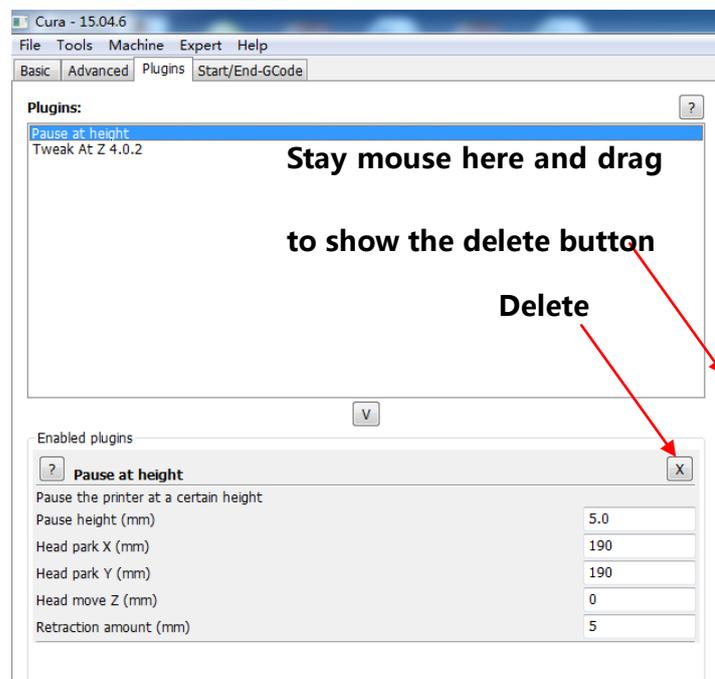
Plugins are custom settings which will active at specific point during printing. There are two pre-loaded plugins with Cura: Pause at height and Tweak At Z. More plugins can be found via: <http://wiki.ultimaker.com/Category:CuraPlugin>

As shown in **Fig. 29**, to enable one of the plugins, such as Pause at height, first click it and then click the drop-down arrow to enter the setting interface.

**“Pause at height”** will allow the printing to pause at a specified height, as well as where the print head would move to and how much filament to retract to prevent extruded filament blobs. So, customers could do filament change during printing.

**“Tweak at Z”** would allow custom changes at specified Z height. Customers may decide the Z height or layer counts at which to make a change. Then there are more settings for how you would like to change, such as temperature, fan speed and print speed. Fine tune those for specific model would produce better results.

**If wish to delete the plugins, stay mouse at the edge, hold the left button and drag mouse to show the Delete.**



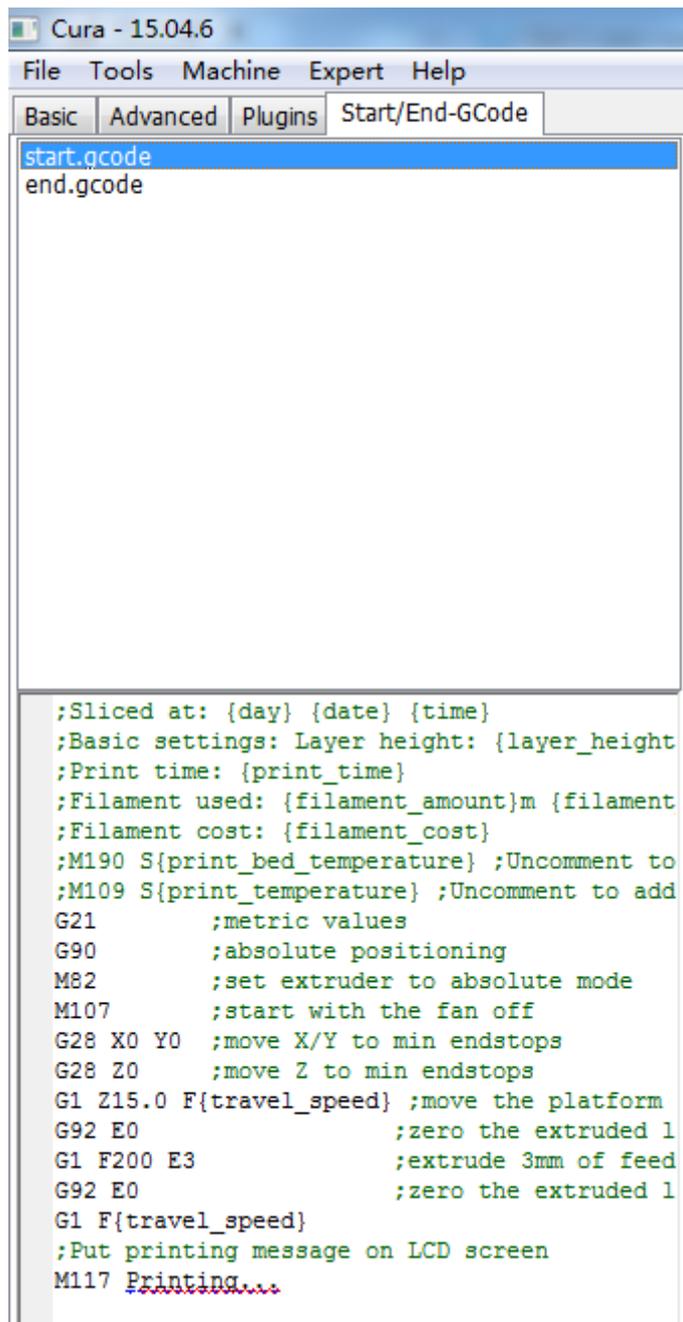
(Figure 29)

#### (4) Start/End-GCode

As shown in Fig. 30, custom Gcode allows for complex automatic printer movements and operations. By adding custom Gcode into the start or end of the Gcode file, customer could change how it prints. A detailed list of Gcode commands can be found via: <http://reprap.org/wiki/G-code>

There will be explanation later about how to resume from outage by adding command

to start.gcode.



(Figure 30)

#### 5.2.4 Printing by Cura

After parameter settings, customer can print online by Cura.

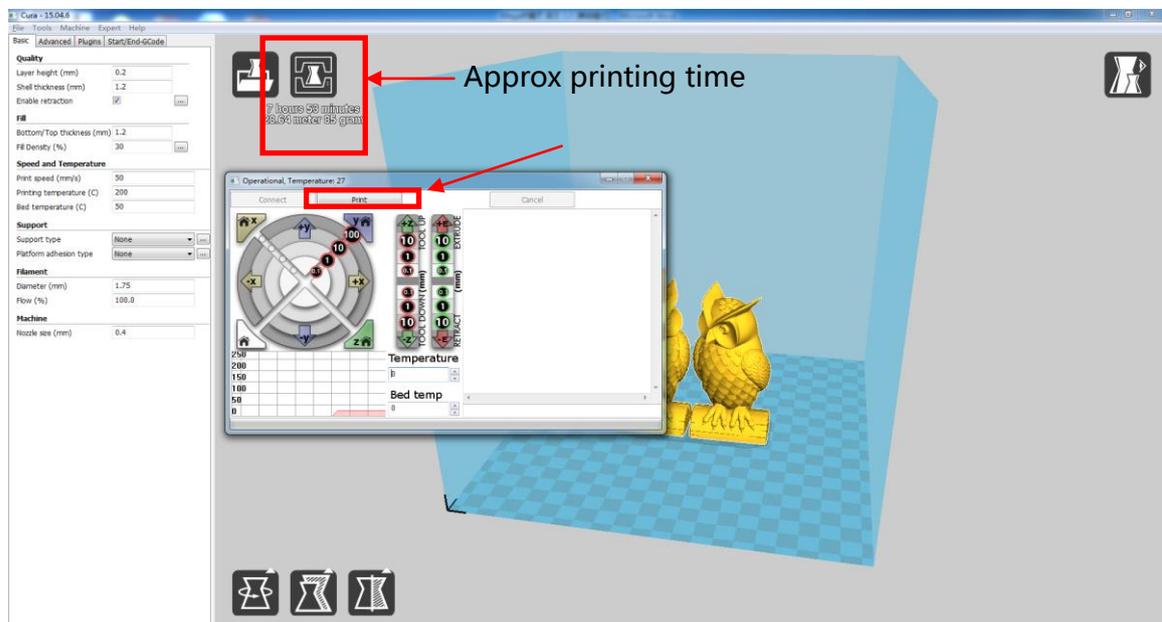
Click “File” ---> “Print...” enter the printing window. If you have a simplified printing window which is different from that in **Fig. 31**, please click “File” ---> “Preferences...” to choose the ‘Pronterface UI’ in “Printing window type” drop-down menu.

Click “Print” icon when it is available after auto connect with the printer. Then the

temperature would rise and it will start to print when reaching to the target temperature.

Use tweezers to carefully get rid of the pre-extruded filament.

Check with the COMx or baudrate in "Machine settings" if Cura fails to connect the printer in the "Printing window" .



(Figure 31)

### 5.2.5 Save GCode in Cura

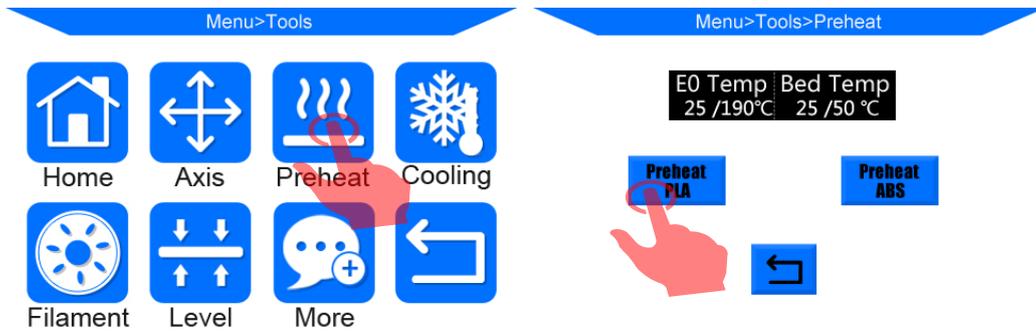
At the top menu in Cura, click "File" ---> "Save GCode..." to save the file to a directory. And it is highly recommended to save the Gcode in SD card to do printing offline.

Tips:

- (1) Always reopen the Gcode file again in Cura to confirm that all slices of the model have been included by check it in the "Layers view" (refer to **Fig. 26**).

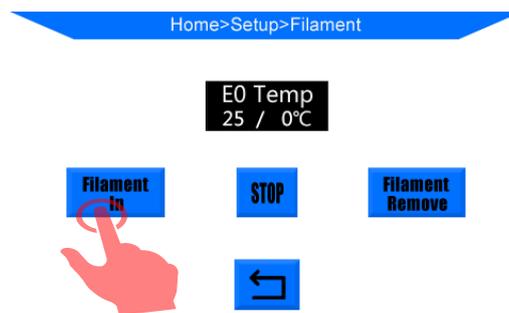
## 6. Printing

1. When experienced customer skips the previous step and directly wants to print right after assembly, please follow the steps shown below: "Tools" --> "Preheat" --> "Preheat PLA (for example)" , **Fig. 32**.



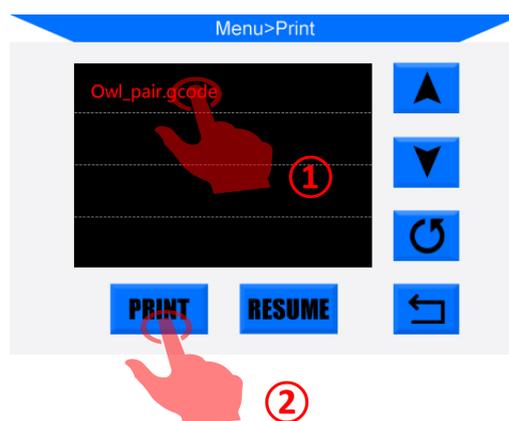
(Figure 32)

- After pre-heat is finished, please click on Home screen "Tools" --> "Filament" --> "Filament in" (Fig. 33). The extruder motor will work to feed the filament into the hotend. There might be some excessive filament melt through the nozzle, please use tweezers to carefully remove it from the nozzle.



(Figure 33)

- Insert the SD card (back side facing up) into the slot at the bottom right side of the base. Click on the Home "Print" into the print files interface. Click on the exist file "owl\_pair" , and click "Print" (Fig. 34). The machine will automatically heating and print. It will be heating the heated bed first and then the nozzle.



(Figure 34)

4. When printing finished, the print head and heated bed will be automatically cooling down. Only remove the printed object from the heated bed when it completely cooled. Pull the heated bed to the front, and use scraper to carefully remove the object as shown in **Fig. 35**. Never direct scarper to your hands.



(Figure 35)

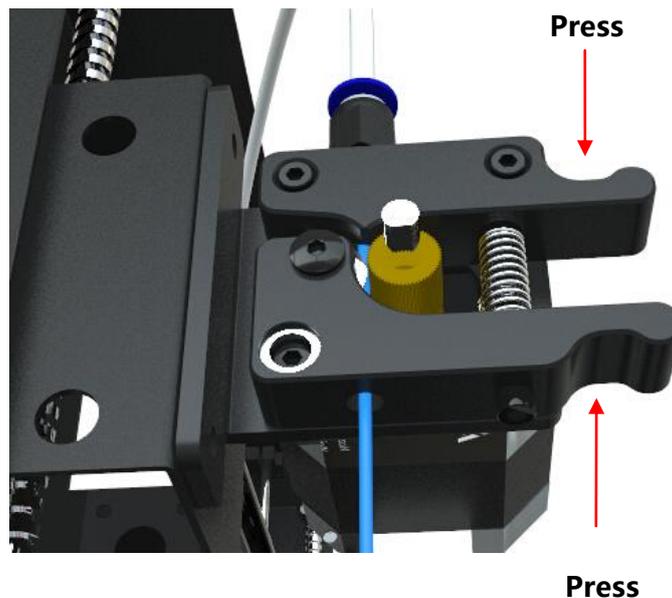
**ANYCUBIC I3 MEGA** 3D printer has a printing sticker which has a lift time about few weeks depends on the usage. Customer may use masking tape as alternative.

**Tips:**

- ① Suggested printing temperature for PLA: 190-210°C, ABS: 230-240°C, bed temperature for PLA: room temperature-60°C, ABS: 80-100°C.
- ② Please be mindful that the nozzle and heated bed are still hot after operation.
- ③ After operation, switch off the printer after the print head cools to room temperature because it still needs fan cooling to minimize the clogging.

## 7. Manual filament change

1. Feed the filament: click via the Home menu: "Tools" --> "Preheat" --> "Preheat PLA (for example)" . After it reaches to the target temperature, press down the handle at the extruder as shown in **Fig. 36**, and manually push the filament through the Teflon tubing till the hotend and there should be filament melt through the nozzle.
2. Remove the filament: click via the Home menu: "Tools" --> "Preheat" --> "Preheat PLA (for example)" . After it reaches to the target temperature, press down the handle at the extruder as shown in **Fig. 36**, and firstly manually push in the filament until seeing the filament melt through the nozzle, then quickly remove/draw out the filament.



(Figure 36)

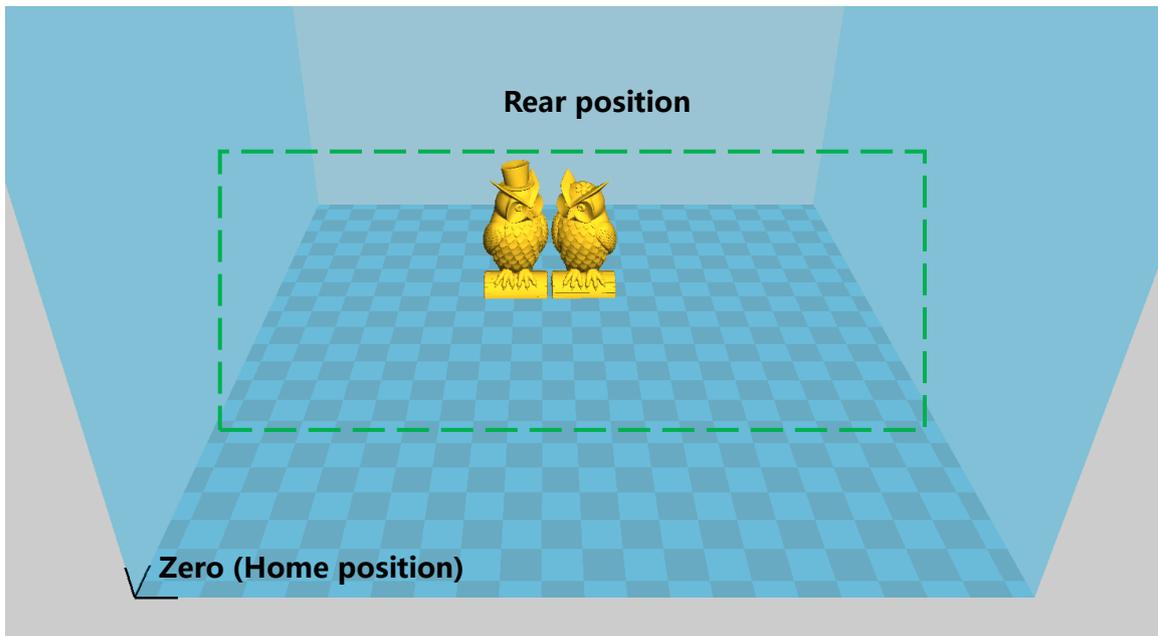
**Tips:** For easy feeding the filament, it is suggested to cut off the bent tip of the filament.

## 8. Resume from outage

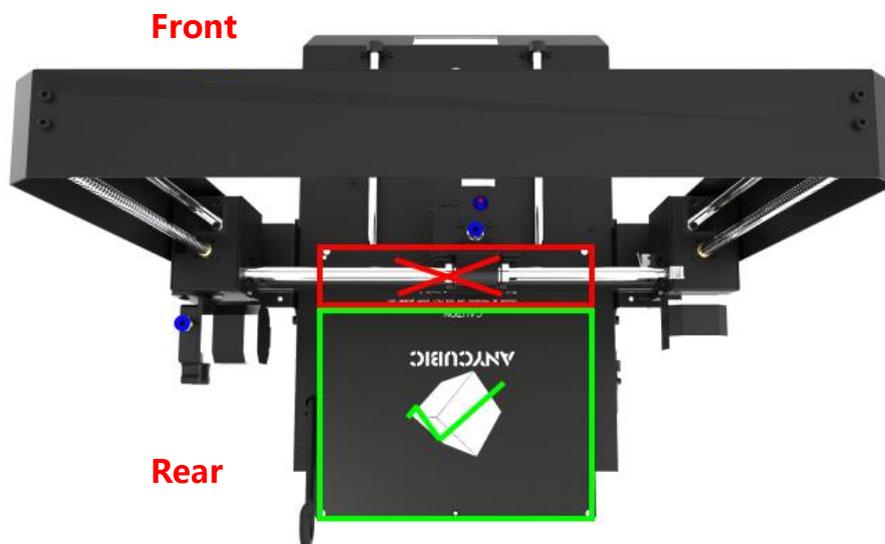
**ANYCUBIC 13 MEGA** allows resuming print job after accident power loss.

This function only valid when print offline (by SD card only).

1. As shown in **Fig. 37**, in slicing software (i.e. Cura), it is required to place the model at the rear of platform. Because in case of “Resume from outage” , machine will home first and could touch/interfere with the unfinished object if the model was placed in the front area (**Fig. 38**).

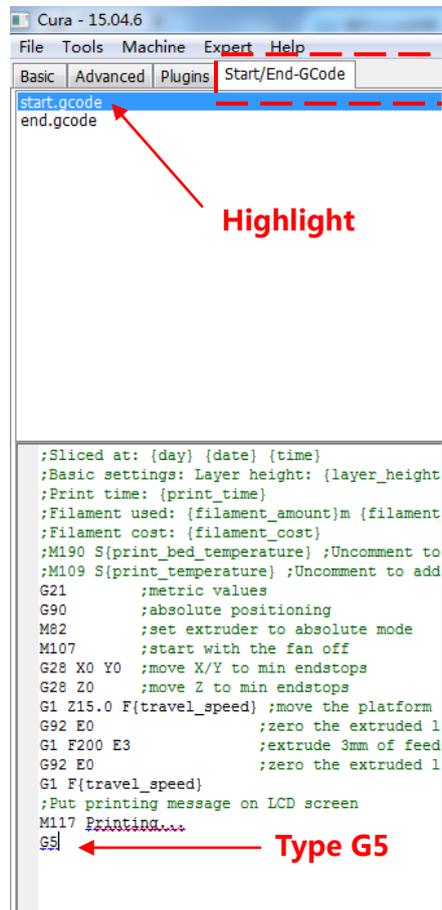


(Figure 37)



(Figure 38)

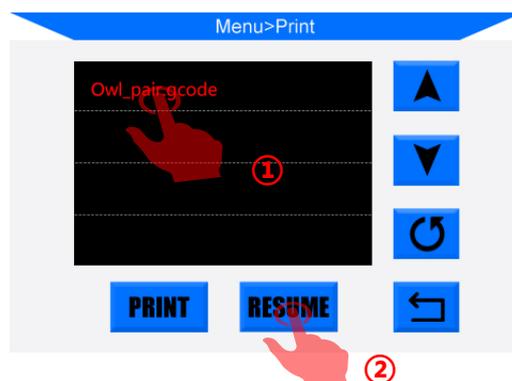
- For the first time of using this function, customers are required to add "G5" to the start.gcode, as shown in Fig. 39. Then, save the model as Gcode file to the SD card by "File" ---> "Save GCode..." .



(Figure 39)

- Insert the SD card (back side facing up) into the slot. Print the just saved file (i.e. "owl\_pair" ). The machine will automatically heating on and print.

If there is an accident power loss during this printing, the print will stop immediately. However, when power comes back, please click "Print" , choose the unfinished file and click "Resume" (Fig. 40). Machine will home first and continuing the unfinished object.



(Figure 40)

**Tips:**

- ① In order to get smooth surface, please use tweezer to remove the excessive filament before nozzle continuing print at the last point.
- ② It is required not to move the Z axis after power off otherwise resume will be invalid.
- ③ **ANYCUBIC I3 MEGA** 3D supports resume from outage only when print offline
- ④ This function is developed based on Cura. We could not guarantee that this function compatible with other slicing software.
- ⑤ Due to the differences of filaments, temperature, extrusion, etc...we could not guarantee a perfect surface at the point of "Resume from outage" , especially when printing small object.

## 9. Trouble shooting

### 1. Motor shaking or abnormal sound

- ① The corresponding end stop could not be triggered when Home, check the wirings, and inspect any obstacles when manually move the corresponding axis.
- ② The motor cable are not connected properly, check each connection and then inspect the cable routing for any faults.

### 2. File not printing and SD card failure

- ① Remove the SD card and insert into PC. Open the Gcode files using text editor (eg. Notepad), and inspect if Gcode is readable or not. If files contains of multiple "ÿÿÿ" symbol, then file has been corrupted. Try reformatting the SD card to FAT32 format and reloading the Gcode file.
- ② SD card is not readable, ensure file name does not contain special characters or Change SD card.
- ③ Touch screen freeze, reboot the machine and try again.

### 3. No extrusion or extrusion motor knocking

- ① Ensure that the nozzle temperature has been set to match the filament.
- ② Filament tangled on spool.
- ③ Not enough cooling for the hotend.
- ④ Nozzle clogged please try to replace it or clean it.
- ⑤ Teflon tubing has been tangled or squeezed.

### 4. Filament leaking

Nozzle and throat tube has not been tightened properly, try to fix it after cooling.

### 5. No sticking to the bed

- ① Print too fast at the bottom layer speed, reduce it to ~20mm/s
- ② Ensure that the print platform is clean

- ③ Check that the bed is leveled and set to a distance of approx. 0.1 mm.
- ④ Inspect if print mat needs replacement, or use masking tape instead.
- ⑤ add a brim or raft to the model in slicing software.
- ⑥ Check the bed temperature matches the filament.

## **6. Warping/curling of the printed object**

- ① Check the bed temperature matches the filament
- ② Check the infill % of the Gcode. The higher the infill, the more likely to warp
- ③ add a brim or raft to the model in slicing software.

## **7. Layer shifting**

- ① Print head moving too fast, slow down the print speed.
- ② Check X/Y belt and the driving wheel and ensure they are properly installed.
- ③ Lubricate the rods by grease and check all nuts and bolts remain tightened.

## **8. Freezing screen**

- ① Inspect if the touch screen has been pressed by the metal frame at the edge.
- ② Check if there is any cracks, if so, please contact us at [support@anycubic3d.com](mailto:support@anycubic3d.com).

## **9. T0 sensor abnormal**

- ① Check the wiring of the hotend and ensure a good connection
- ② Check if there is any bended pins inside the connector.

## **10. Print head move abnormal**

- ① Check if choosing the right machine model in slicing software.
- ② Check if any plugins in the slicing software.

## **11. Print stopped halfway**

- ① Check if the Gcode file is complete and not corrupted.
- ② Check no plugins in the Gcode file.
- ③ Use print offline instead of via USB.