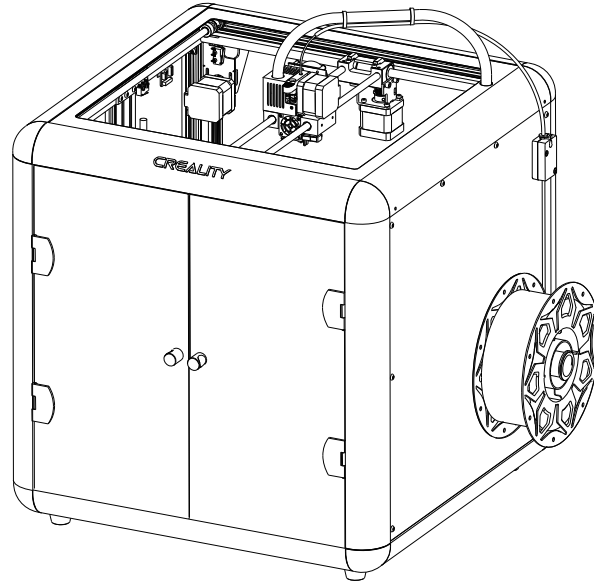


CREALITY

3D Printer User Manual

3D打印机使用说明书

Sermoon D1



V1.2

Content 目录

Dear Consumers,

Thank you for choosing our products. For the best experience, please read the instructions before operating the Printer. Our teams will always be ready to render you the best services. Please contact us by phone number or e-mail address provided at the end when you encounter any problem with the Printer.

For a better experience in using our product, you can also learn how to use the Printer in the following ways:

View the accompanied instructions and videos in the storage card.

Visit our official website www.creality.com to find relevant software/hardware information, contact details and operation and maintenance instructions.

尊敬的创想三维用户：

感谢您选择、使用创想三维的产品。为了您使用方便，请您在使用之前仔细阅读该说明书，并严格按照说明书的指示进行操作。

创想三维团队时刻准备为您提供优质的服务。在使用过程中无论遇到什么问题，请按照说明书结尾所提供的电话、邮箱与我们联系。

为了您能够更好地体验我们的产品，您还可以从以下方式获取设备操作知识：

随机使用说明：你可以在存储卡内找到相关使用说明及视频。

创想三维官网：www.cxsw3d.com（您可以登陆创想三维官网寻找相关软硬件、联系方式、设备操作、设备保养等信息）。

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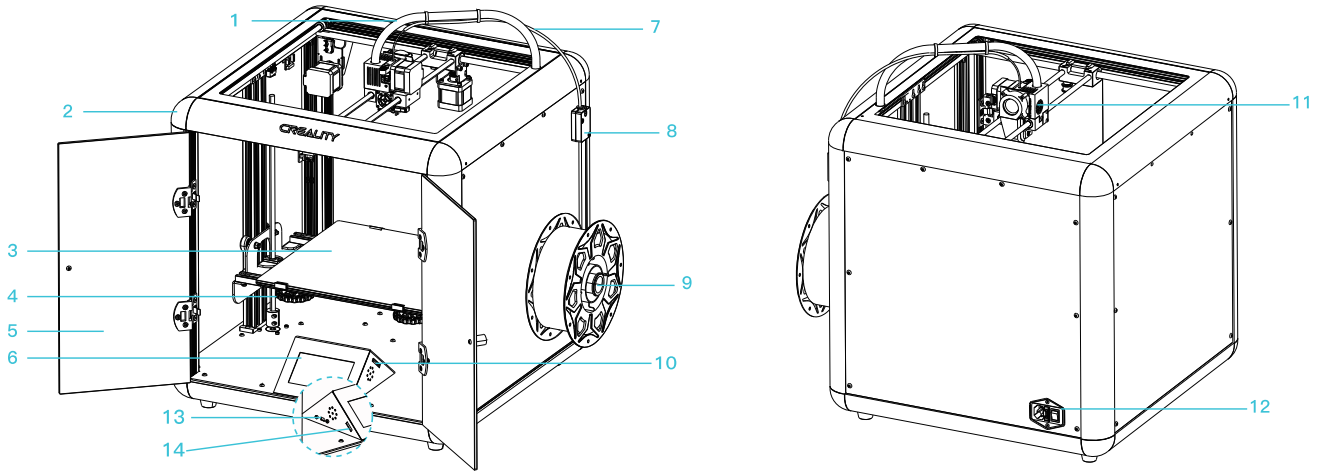
NOTES 使用须知

1. Do not use the printer any way other than described herein in order to avoid personal injury or property damage.
2. Do not place the printer near any heat source or flammable or explosive objects. We suggest placing it in a well-ventilated, low-dust environment.
3. Do not expose the printer to violent vibration or any unstable environment, as this may cause poor print quality.
4. Before using experimental or exotic filaments, we suggest using standard filaments such as ABS or PLA to calibrate and test the machine.
5. Do not use any other power cable except the one supplied. Always use a grounded three-prong power outlet.
6. Do not touch the nozzle or printing surface during operation as they may be hot. Keep hands away from machine while in use to avoid burns or personal injury.
7. Do not wear gloves or loose clothing when operating the printer. Such cloths may become tangled in the printers moving parts leading to burns, possible bodily injury, or printer damage.
8. When cleaning debris from the printer hotend, always use the provided tools. Do not touch the nozzle directly when heated. This can cause personal injury.
9. Clean the printer frequently. Always turn the power off when cleaning, and wipe with a dry cloth to remove dust, adhered printing plastics or any other material off the frame, guide rails, or wheels. Use glass cleaner or isopropyl alcohol to clean the print surface before every print for consistent results.
10. Children under 10 years of age should not use the printer without supervision.
11. This machine is equipped with a security protection mechanism. Do not manually move the nozzle and printing platform mechanism manually while booting up, otherwise the device will automatically power off for safety.
12. Users should comply with the laws and regulations of the corresponding countries and regions where the equipment is located (used), abide by professional ethics, pay attention to safety obligations, and strictly prohibit the use of our products or equipment for any illegal purposes. Creality will not be responsible for any violators' legal liability under any circumstance.

- 1、请勿尝试任何使用说明中没有描述的方法来使用本机，避免造成的意外人身伤害和财产损失；
- 2、请勿将本机放置在易燃易爆物品或高热源附近，请将本机放置在通风、阴凉、少尘的环境内；
- 3、请勿将打印机放置在振动较大或者其他不稳定的环境内，机器晃动会影响打印机打印质量；
- 4、建议使用厂家推荐耗材，以免造成挤出头堵塞和机器损坏；
- 5、请勿在安装过程中使用其他产品电源线代替，请使用本机附带的电源线，电源插头需接插在带有地线的三孔插座；
- 6、请勿在打印机工作时接触喷嘴以及热床，以防止出现高温烫伤，造成人身伤害；
- 7、请勿在操作机器时佩戴手套或缠绕物，以防可动部件对人身部件造成卷入挤压和切割伤害；
- 8、在打印完后及时利用喷头的余温借助工具将喷头上的耗材清理干净，清理时请勿直接用手触摸喷头，以防出现烫伤；
- 9、常做产品维护，定期在断电的情况下，用干布对打印机做机身清洁，拭去灰尘和粘结的打印材料、导轨上的异物；
- 10、年龄在10岁以下的儿童，请勿在没有人员监督的情况下使用本机，以免造成人身伤害；
- 11、本机设有安全保护机制，请勿在开机状态下手动快速移动喷头及打印平台机构，否则设备会自动断电关机保护；
- 12、使用者应遵守设备所在地(使用地)相应国家、地区法律法规，恪守职业道德，注意安全义务，严禁将我司的产品或设备使用在任何非法用途上。如有违反者所应承担的相关法律责任我司概不负责。

Equipment Introduction

设备简介



1 Corrugated pipe 波纹管

2 Profile cover 型材盖

3 Printing platform 打印平台

4 Leveling nut 调平螺母

5 Front door 前门

6 Display screen 显示屏

7 PTFE Tubing 铁氟龙管

8 Filament detecting kit 断料检测组件

9 Spool holder 料架及料管筒

10 Storage card slot 存储卡卡槽

11 Nozzle kit 喷头套件

12 Power supply 电源

13 USB port USB接口

14 TF card socket (dedicated for display upgrade)
TF卡插口(显示屏升级专用)

Equipment Parameters

设备参数

Basic Parameters 基本参数	
Model 型号	Sermoon D1
Printing Size 成型尺寸	280*260*310mm
Molding Tech 成型技术	FDM
Nozzle Number 喷头数量	1
Slice Thickness 切片层厚	0.1mm-0.4mm
Nozzle Diameter 喷嘴直径	Standard 0.4mm 标配0.4mm
Precision 打印精度	±0.1mm
Filament 打印材料	PLA
File Format 切片支持格式	STL/OBJ/AMF
File Transfer 打印方式	USB/Storage card 联机或存储卡脱机
Slice Software 可兼容切片软件	Creativity Slicer/Cura/Repetier-Host/Simplify3D
Rated Voltage 额定电压	Input 输入:AC100-240V 50/60Hz Output 输出:DC 24V
Total Power 额定功率	350W
Bed Temp 热床最高温度	≤100°C
Nozzle Temp 喷嘴最高温度	≤260°C
Resume Print 断电续打	Yes 有
Dual Z-Axis 双Z轴	Yes 有
Language 语言	Chinese/English 中/英
Operating System 电脑操作系统	Windows XP/Vista//7/8/10 MAC/Linux
Printing Speed 打印速度	≤180mm/s,Normal 正常为 30-60mm/s

Tool List 工具包清单

 1 Rack x 1 料架	 2 Spool & Nuts x 1 料管及料管螺母	 3 Hex keys, Wrench & Screwdriver x 1 扳手和螺丝刀	 4 Cable ties x 6 扎带
 5 Spade x 1 铲刀	 6 Nozzle cleaner x 1 通针	 7 Open-ended wrench x 1 22号开口扳手	 8 Storage card & Card reader x 1 存储卡和读卡器
 9 Diagonal pliers x 1 剪钳	 10 Power cable x 1 电源线	 11 Spare nozzle x 1 备用喷嘴部件	 12 Grease x 1 润滑脂 Purpose: Lubricating bearings 用途: 润滑轴承用途
 13 M6 socket spanner x 1 M6套筒扳手	 14 Crepe Paper x 1 美纹纸	 15 100mm PTFE Tubing (Spare Part) x 1 100mm铁氟龙管(备品)	 16 550mm PTFE Tubing x 1 550mm铁氟龙管
 17 Filament x 1 耗材	 18 M5*8 hexagon flat round head screw x 2 M5*8内六角平圆头螺钉		

Tips: The above accessories are for reference only, please refer to the physical accessories! 注意: 以上配件仅供参考, 请以实物为准!

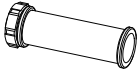
1

Install the Material Pipe and Power Cord

安装料管、电源线

1. Open the front door, manually turn on the side of barrel with nut, go across the door plank and rack (as the figure shows), lock tight the nut and fix on the rack; 2. Connect the power wire to start device.

- 1、打开前门，料管有螺母的一端手动拧开，穿过门板和料架（如图）再拧紧螺母固定在料架上；
- 2、接上电源线即可启动设备。



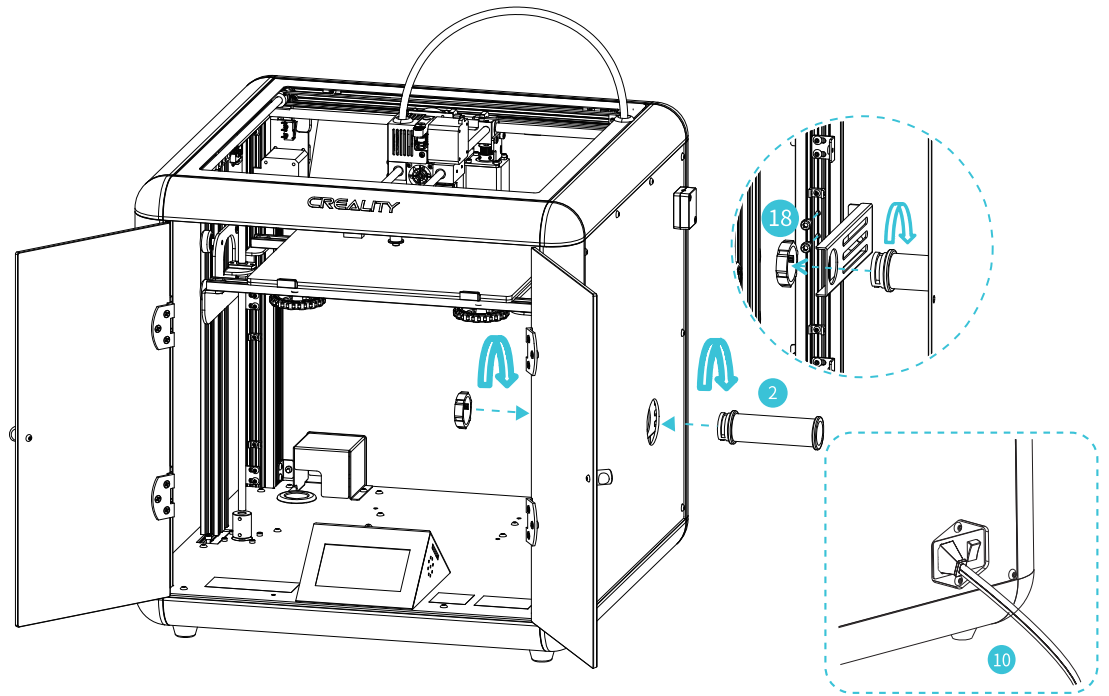
- 2 Spool & Nuts x 1
料管及料管螺母



- 10 Power cable x 1
电源线



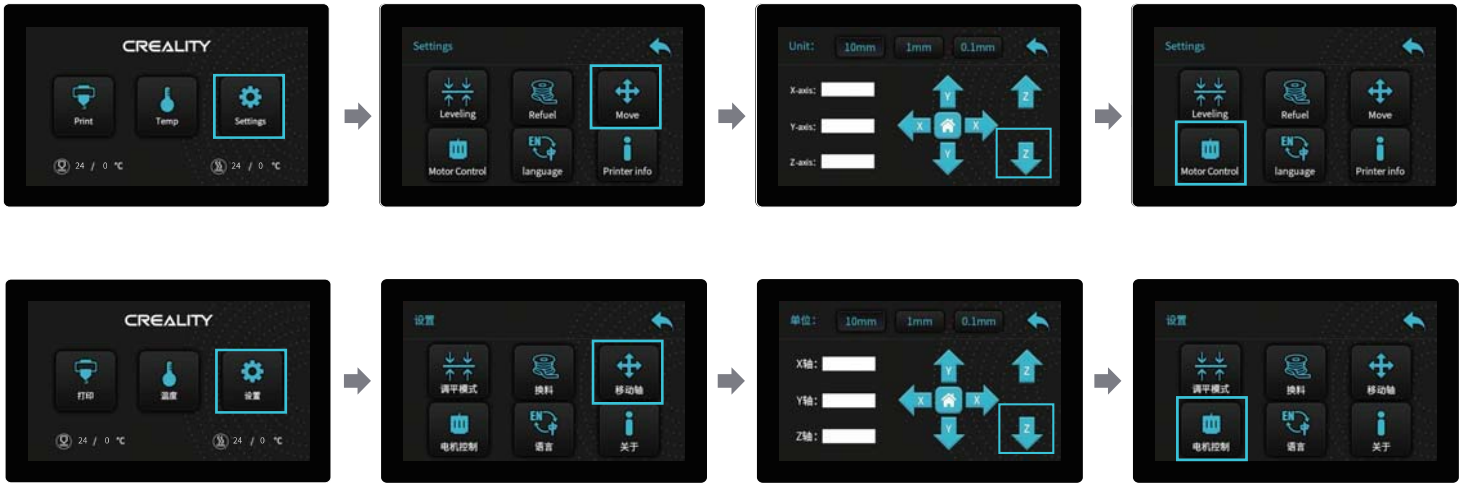
- 18 M5*8 hexagon flat round
head screw x 2
M5*8内六角平圆头螺钉



2

Bed Leveling 调平平台

For the first leveling :Set the Z-axis → move down 10mm → remove the motor ;
初始调平:设置移动轴Z轴→向下移动10mm→解除电机;

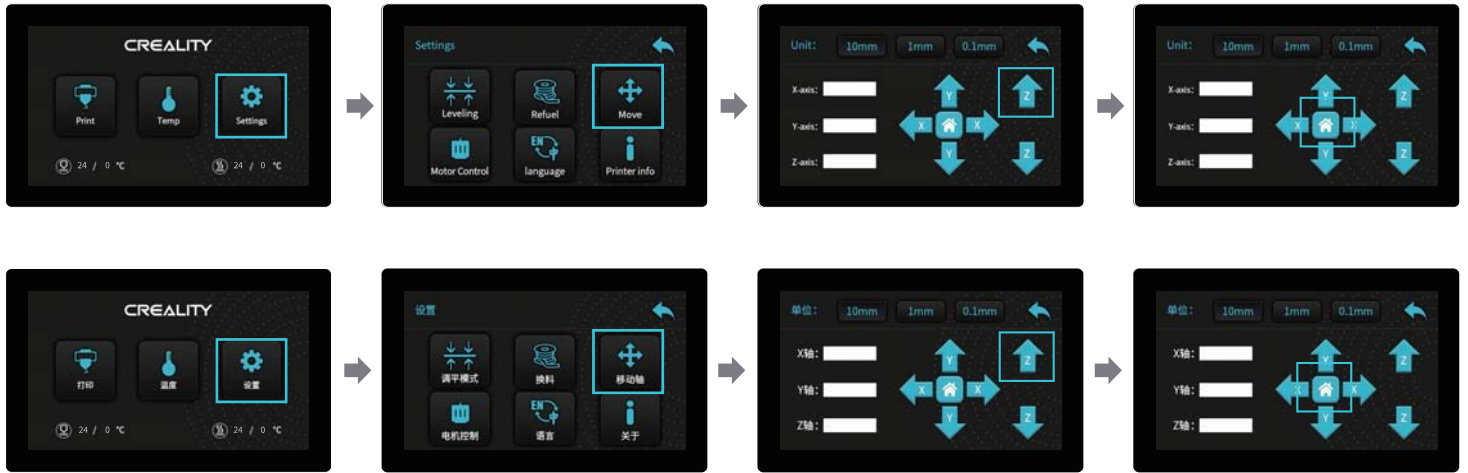


Note: The UI information is only for reference, the actual UI may be different.
注意:界面仅供参考,实际以UI为准。

3

Bed Leveling 调平平台

Press the printing platform to the bottom → move up 10mm in Z-axis → return the motor to zero.
用手将打印平台压到底部 → 再设置Z轴向上移动10mm → 电机回零;

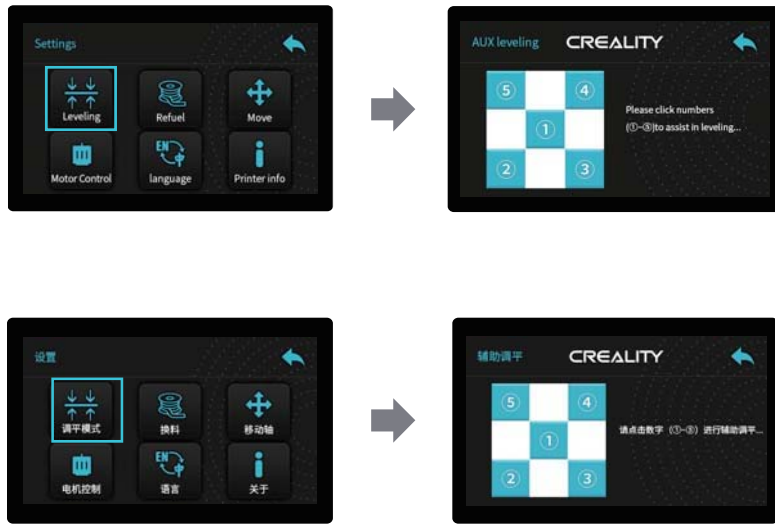


Note: The UI information is only for reference, the actual UI may be different.
注意: 界面仅供参考, 实际以UI为准。

4

Bed Leveling 调平平台

“Leveling”— Aid-leveling and click ①/②/③/④/⑤.
调平模式→辅助调平，点击数字①/②/③/④/⑤。

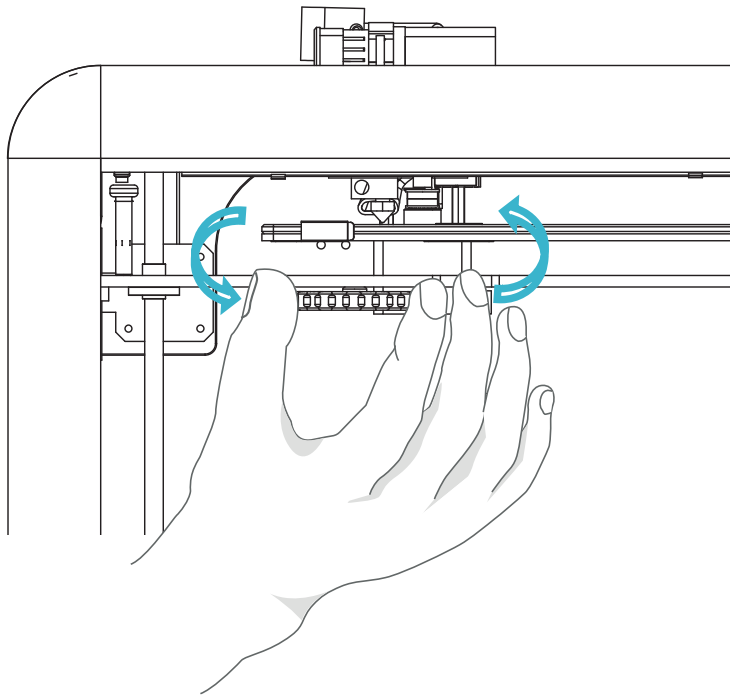


Note: The UI information is only for reference, the actual UI may be different.
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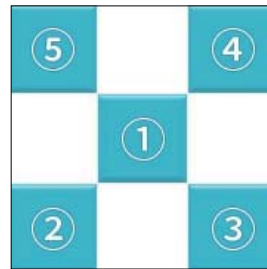
5

Move the nozzle near the top of the leveling screw, twist the screw left or right to make the distance between the nozzle and the platform is as thick as a piece of A4 paper. Leveling the four corners in order, click ① to verify whether the gap between the nozzle and the platform is proper or not.

移动喷嘴至螺丝上方附近。拧动螺丝，调节打印平台喷嘴使二者处于刚好贴合状态，间距约为0.1mm（一张A4纸的厚度）。按顺序调平四个角，点击①号，测试平台中间间隙是否合适。



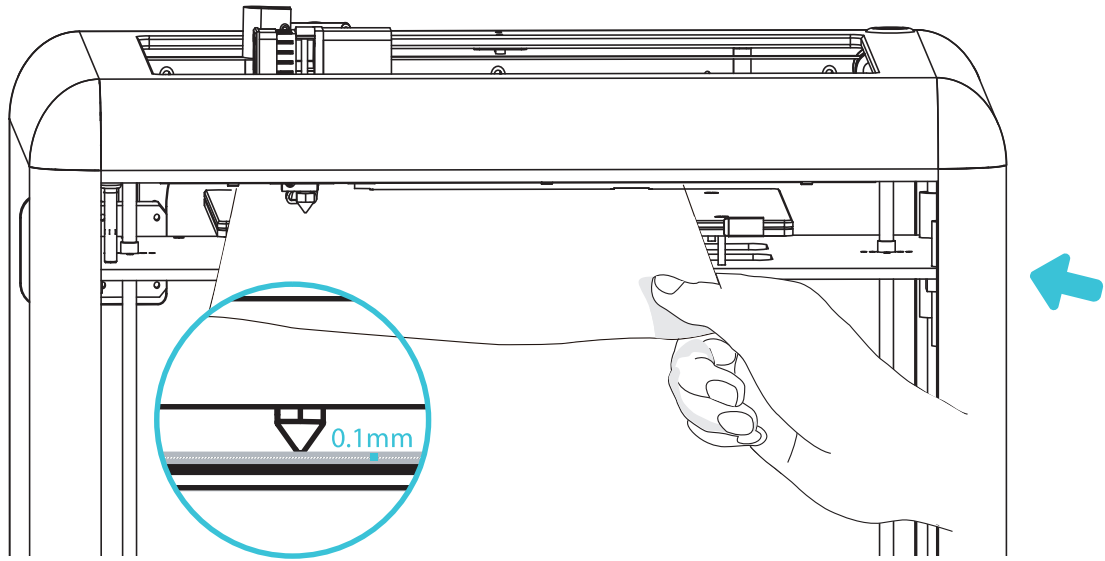
⚠		
		<p>⊗</p> <p>The nozzle is too far away from the platform, so the consumables can not adhere to the platform. 喷嘴离平台太远，耗材无法粘附在平台上。</p>
		<p>✓</p> <p>Filament are extruded evenly, just sticking on the platform. 耗材挤出均匀，刚好贴在平台上。</p>
		<p>!</p> <p>The nozzle is too close to the platform, and the filament are not extruded enough, even scraping the platform. 喷嘴离平台太近，耗材挤出不足，甚至刮坏平台。</p>



6

Use a piece of A4 paper (standard printer paper) to assist with the adjustment, making sure that the nozzle lightly scratches the paper. Complete the adjustment of the screw on all 4 corners. Repeat above steps 1-2 times if necessary. Keep adjusting until there is slight resistance on the A4 paper from the nozzle.

我们可以利用一张A4纸辅助调平,使喷嘴刚好能在A4纸上产生划痕。依次完成四个角上调平螺丝的调节。不断调整直到在拉动A4纸时能感受到来自喷嘴的轻微阻力。



Note: You may paste the masking tape on the printing platform to enhance the adhesion between the fuse and the platform, and prevent edge warping.

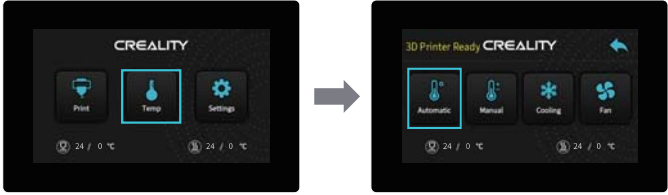
注意:可以根据需要将美纹纸粘贴在打印平台上,增加熔丝与平台的粘附力,防止翘边。

7

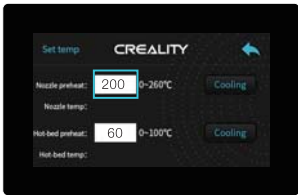
Preheating

预热

Method 1



Method 2



方法1



方法2



Note: The UI information is only for reference, the actual UI may be different.
注意：界面仅供参考，实际以UI为准。

8

Install Teflon Tube and Consumables 装铁氟龙管、耗材

1. Fix the A-end of the Teflon tube to the quick connector of the material break detection, and then use two ties to tie the Teflon tube to the corrugated tube;
2. When you wait for the temperature to rise, hang the consumables on the On the rack.

1. 把铁氟龙管的A端固定在断料检测的快速接头，然后用两根扎带将铁氟龙管绑在波纹管上；
2. 当您等待温度上升时，把耗材挂在料架上。



17 Filament | 耗材 x 1



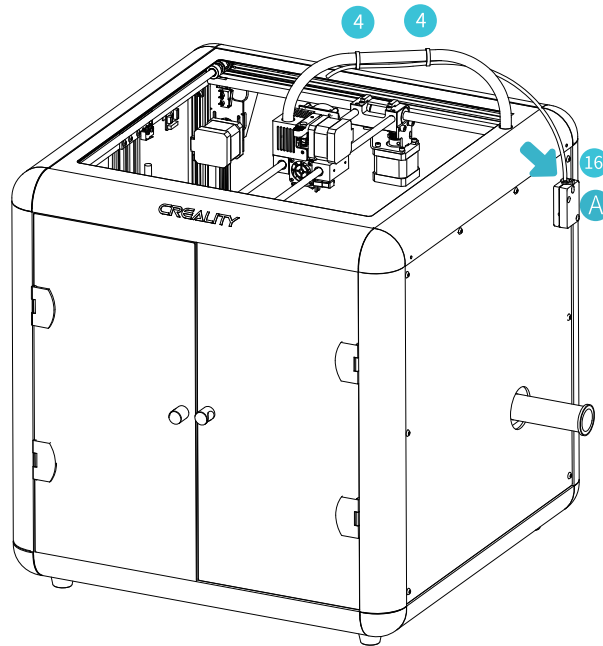
9 Diagonal pliers x 1
剪钳



16 550mm PTFE Tubing x 1
550mm铁氟龙管

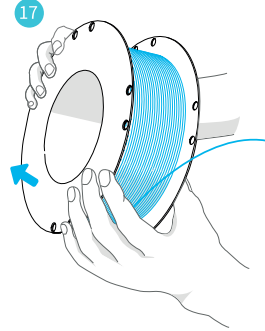
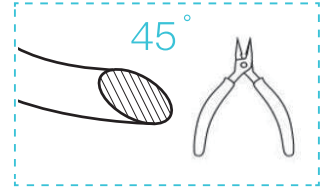


4 Cable ties x 2
扎带



For smoother printing, the end of the filament should be placed as shown above.

为了顺利完成打印，耗材的末端位置应如图所示。

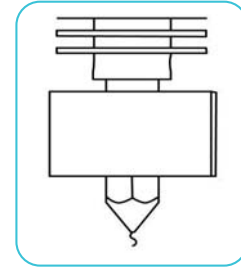
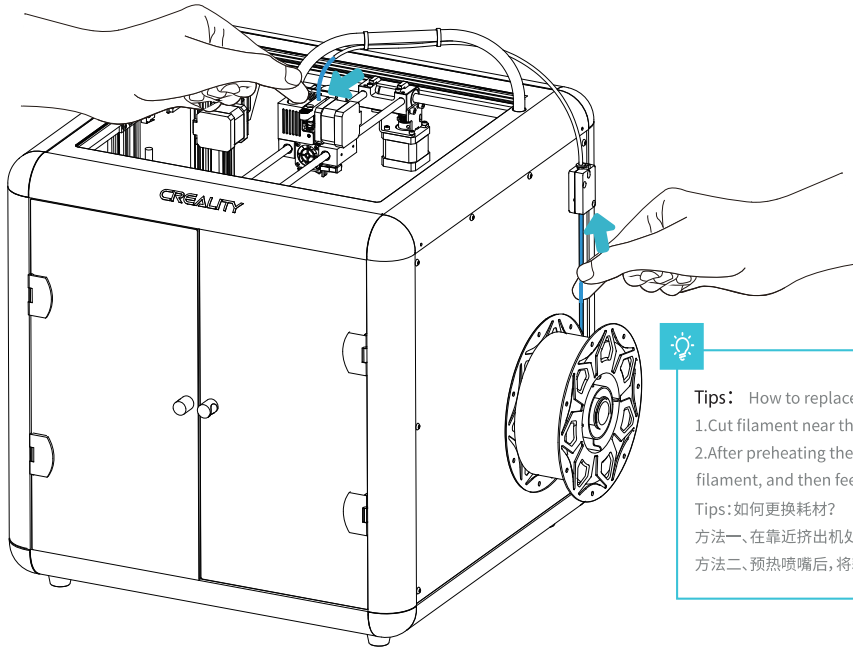


9

Load Filament 装料

Put the filament into the filament detector, pass through the pftf tubing, When the temperature reaches at the target temperature pressing the extruder spring Insert the filament into the extrude small hole till the nozzle position. When the filament comes out from the nozzle it means the filament has been loaded successfully.

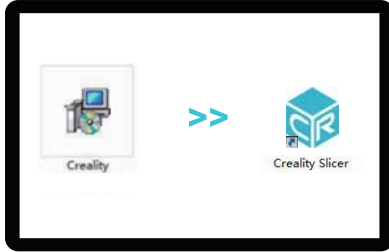
将耗材穿过断料检测器，再穿过 铁氟龙管，当温度达到目标温度时，按住挤出机弹簧，将耗材插入挤出机小孔直至喷嘴位置，等看到喷嘴处有耗材流出即表示耗材已经装载完成。

**Tips:** How to replace the filament?

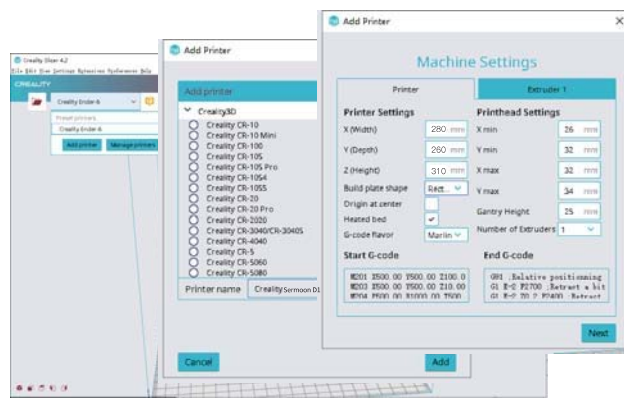
1. Cut filament near the Extruder and slowly feed in the new filament to the material tube.
2. After preheating the nozzle, push the filament a little forward and quickly withdraw the filament, and then feed in the new filament.

Tips: 如何更换耗材?

- 方法一、在靠近挤出机处将耗材剪断，将新耗材缓缓送入，直到耗材被送入导料管为止。
- 方法二、预热喷嘴后，将耗材往前推进一下后，迅速抽出耗材，将新耗材送入。



1. Double click to install the software. | 安装软件
2. Double click to open the software. | 打开软件



3. Select language→Next→Select your machine→Next→Finish.

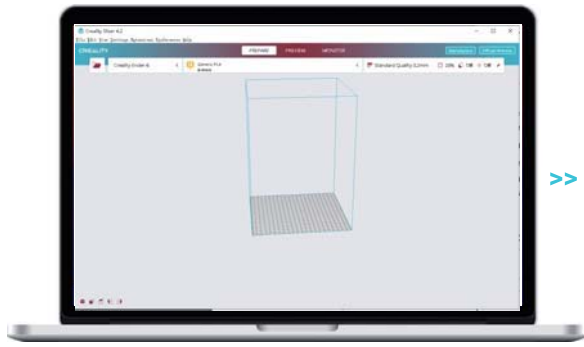


3. 依次选择语言→Next→选择对应机型→Next→Finish, 完成设置。

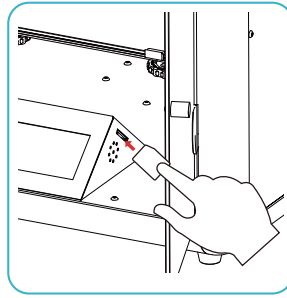


4. Open Creality 3D slicer → Load (Read file) → Select file.

打开创想三维切片软件→Load (读取文件) →选择文件。



5. Generate G-code, and save the gcode file to storage card.
生成 G 代码→保存到存储卡



6. Insert the storage card→ Print
→ Select the file to be printed.
插入存储卡→点击打印控件→
选择要打印的文件



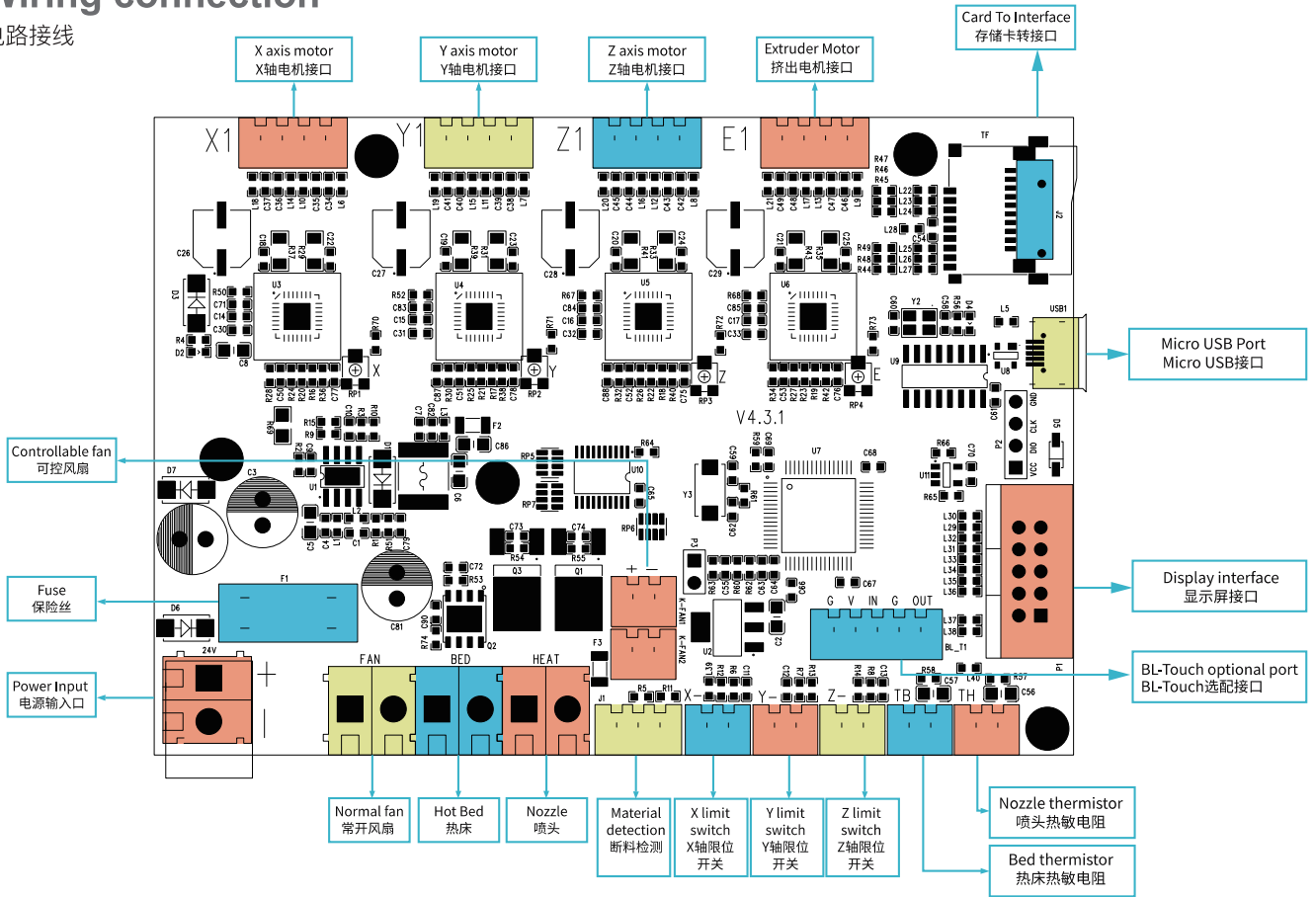
File names must be Latin letters or numbers, not Chinese characters or other special symbols
文件名需为拉丁字母或数字, 不能为汉字或其他特殊符号



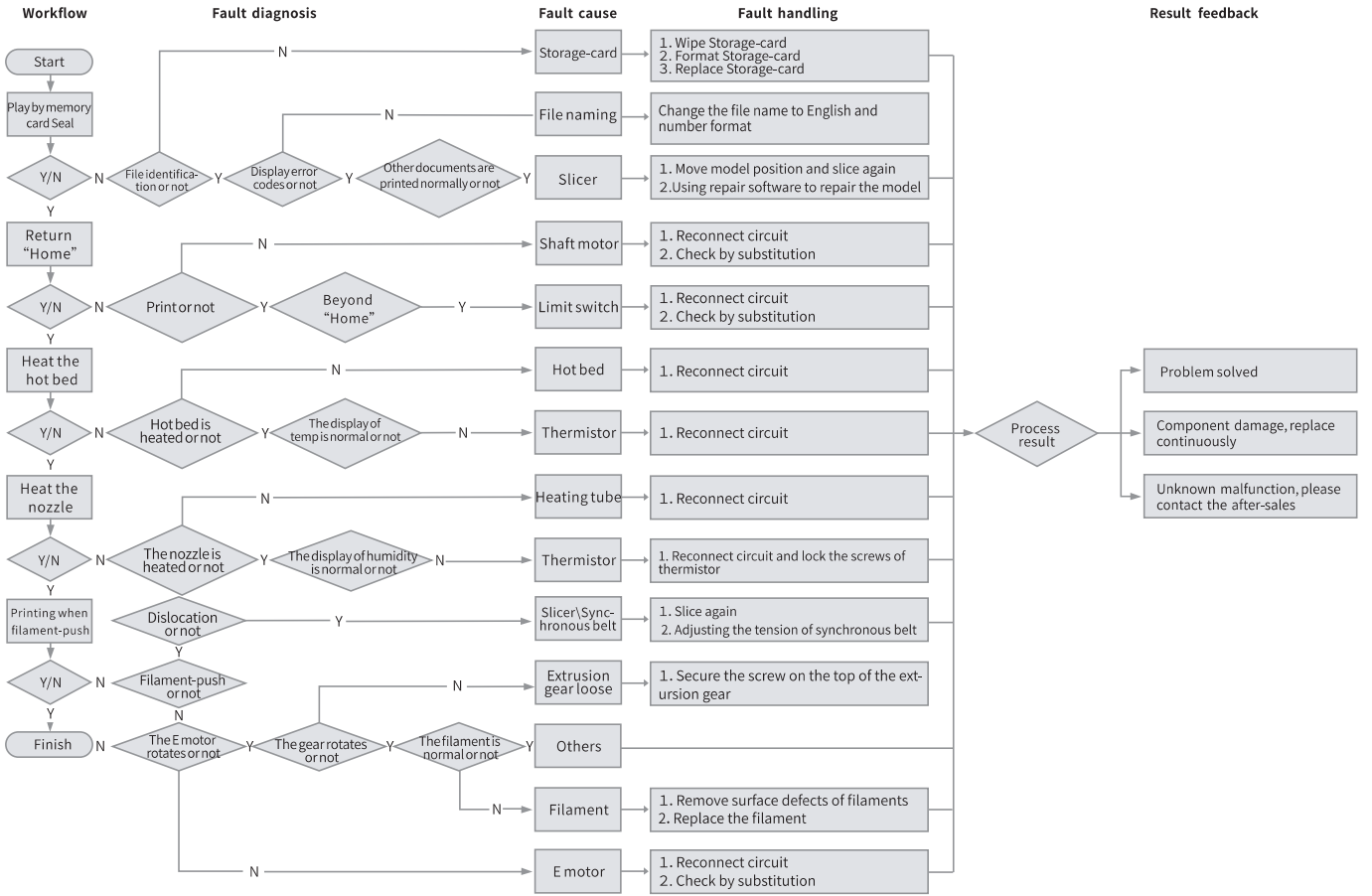
Notes: For details on the software instructions, please refer to the slicing software manual in the memory card!
温馨提示: 软件使用说明详情, 请见存储卡内切片软件使用手册!

Wiring connection

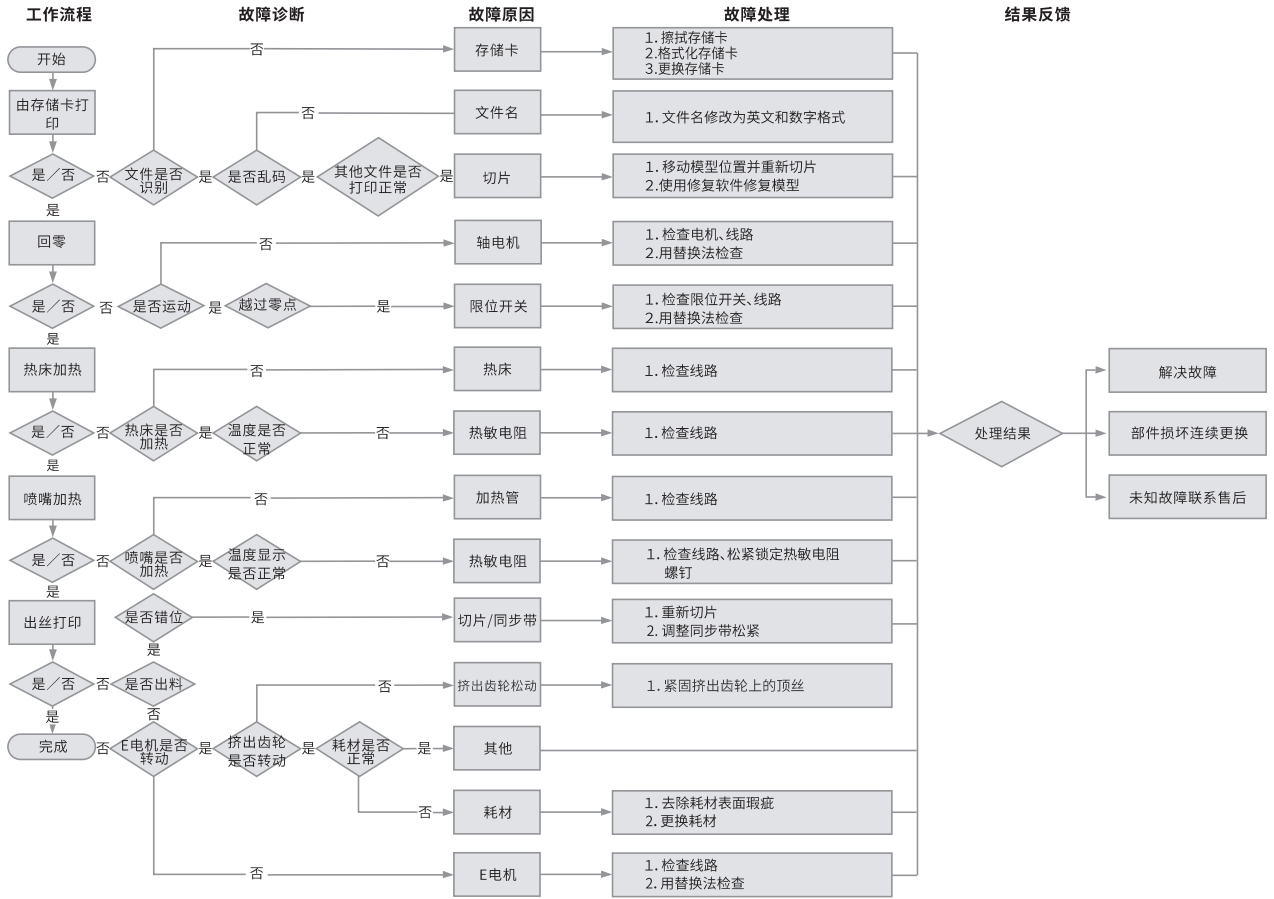
电路接线



Trouble shooting



故障检修



Due to the differences between different machine models, the physical objects and the final images can differ. The final explanation rights shall be reserved by Shenzhen Crealty 3D Technology Co., Ltd.

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