Facebook QR Code

KINGROON

Shenzhen Qi Pang Technology Co., Ltd
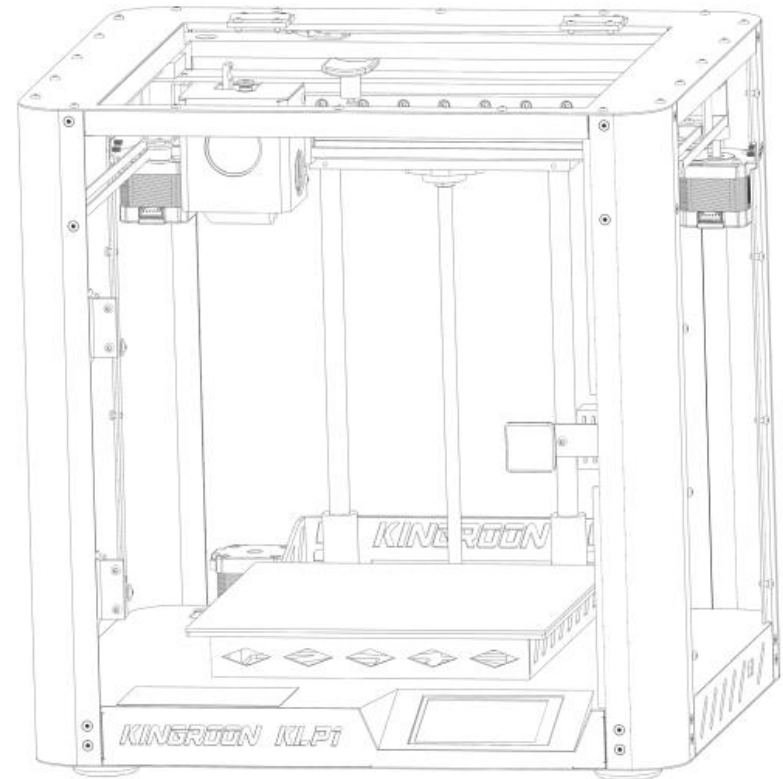
Email: Aliexpress:susie@kingroon.com

Alibaba: joan@kingroon.com

Amazon:jerry@kingroon.com

A402, 4th Floor, Building A.B, Donghaiwang Industrial Zone,

No.369 Bulong Road, Ma'antang Community,

Bantian Street, Longgang District, Shenzhen

Facebook/YouTube：KingRoon 3D Printer

KINGROON
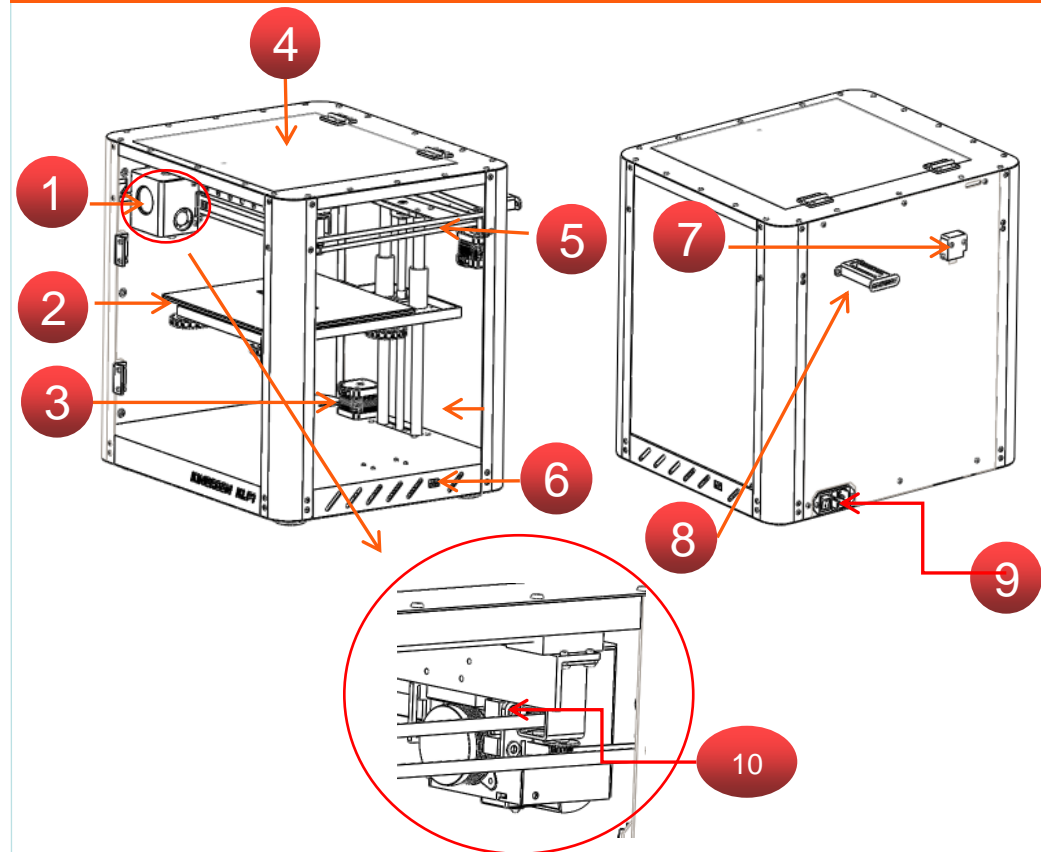
KLP1-FDM 3D Printer User Manual

catalogue

Please note thatIn：
order to use this product correctly, please read this manual carefully

1. DESCRIPTION

1、Extruder	6、110V/220VSwitching switch
2、Hot bed	7、Filament exhaustion sensor
3、Z-axis motor	8、Filament holder
4、PMMA	9、Power switch/socket
5、belt	10、BELT TENSIONER

1. DESCRIPTION

420mm

400mm

420mm

420mm
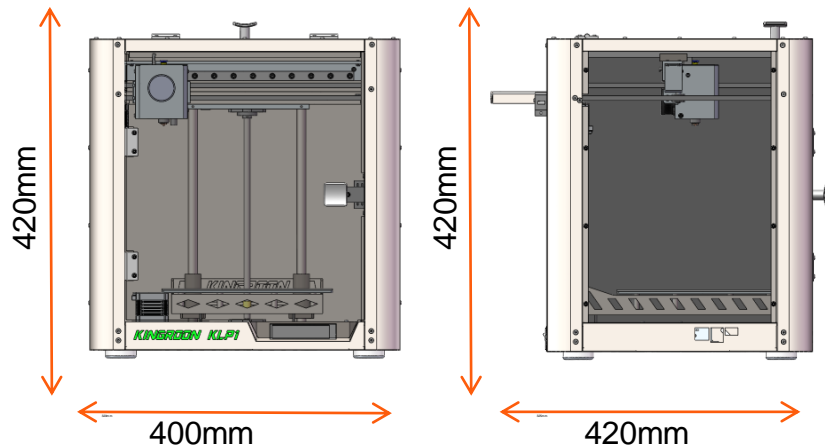
Model	KLP1
Forming Technology	FDM melt deposition
Nozzle Diameter	0.4mm
Material of nozzle	Hard steel
Printing accuracy	0.05-0.3mm
Filament diameter	1.75mm
Support filament	PLA/WOOD/TPU
Maximum nozzle temperature	≤200 C
Maximum temperature of hot bed	≤100 C
Maximum movement speed	≤500mm/s
Maximum printing speed	≤350mm/s
Recommended printing speed	200mm-350mm/s
Printing method	Web/USB drive
file format	STL/Obj/Gcode

system requirements	Win7-10/Mac/Linux
Slicing software	Cura/Slice/Host...
Building board	Flexible steel plate
firmware	Klipper
power	300W
supply voltage	110V-220V
POWER	24V12.5A300W
Filament exhaustion sensor	support
Automatic leveling	support
Touch screen	support（TF35/Mini12864）
Drive free USB camera	support（optional）
Product weight	~14kg
Product size	400*420*420mm
Print Size	210*210*210mm

2. Packing accessories

KLP1整机

filament support

door plank 4PCS

handle 2PCS

eMMC card reader

wrench

U disk

power line

combination cut pliers

Hexagon wrench
1.5mm 2.0mm 2.5mm 3.0mm

data line

Touch Pen
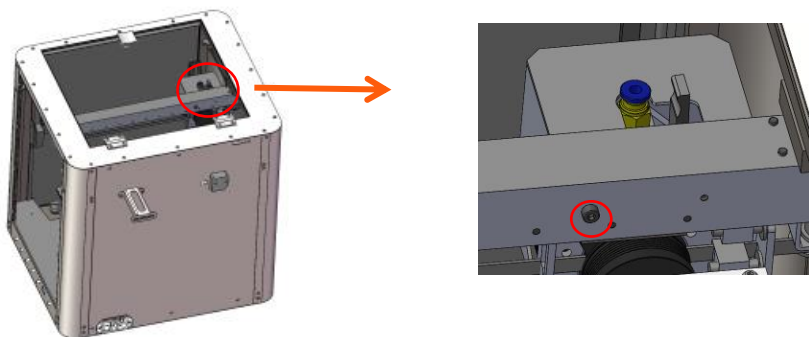(3.5 touch screen)
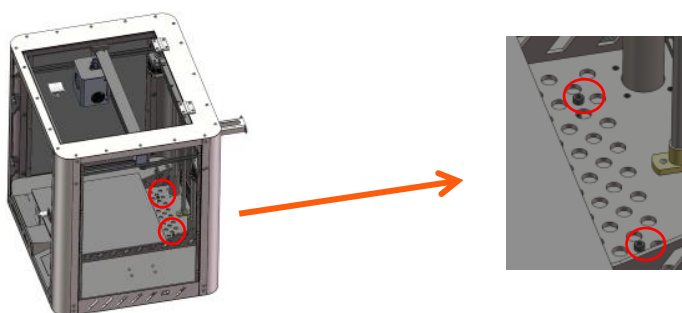
M3*6-22PCS
M4*6-2PCS

filament 10m

0.4mm Hard rigid nozzle
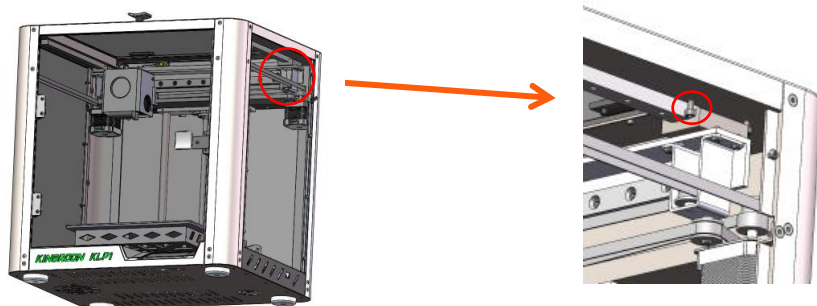
Step 1
Remove the fixing screws on the Y-axis.

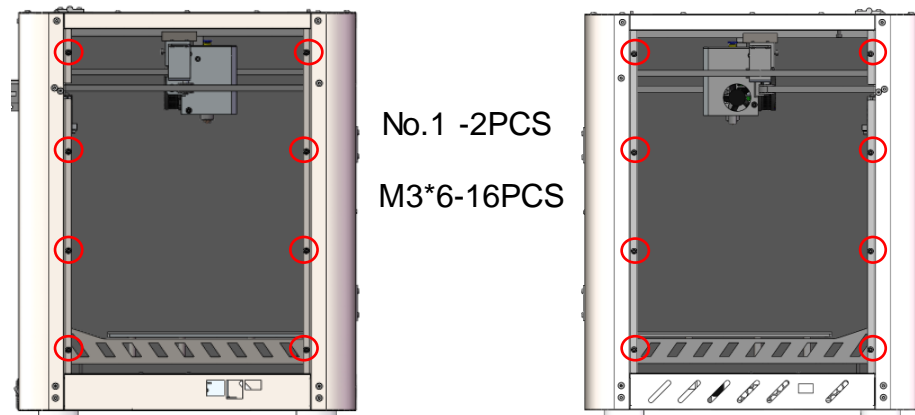**Step 2**
Remove the fixing screws on the X-axis.

Step 3
Remove the fixing screw on the Z-axis.

No.1 -2PCS

M3*6-16PCS

Step 4
Tear off the protective film on board 1 and use 16 M3 * 16 screws to secure the two boards on the left and right sides of the machine.

No.2 -1PCS

M4*6-1PCS

M3*6-4PCS
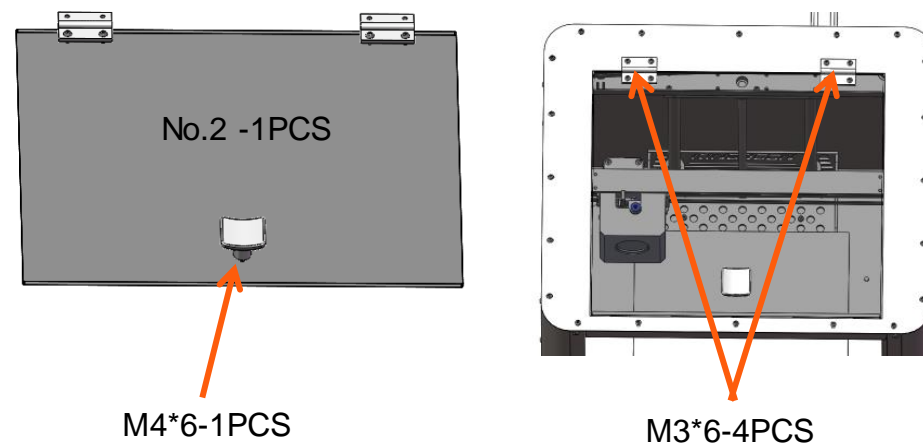
Step 5
Tear off the protective film on board 2 and use one M4 * 6 screw to secure the handle to board 2.Use 4 M3 * 6 screws to secure the No.2 board to the top of the machine.
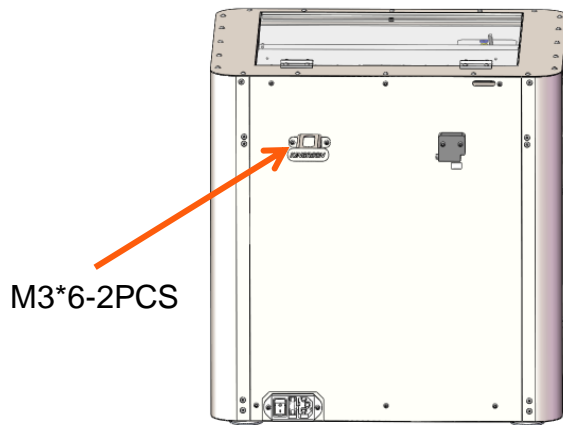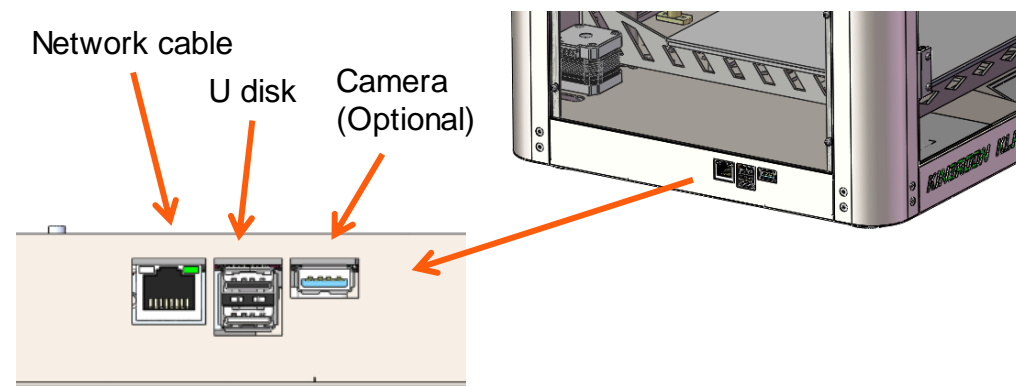
3. Assembly Tutorial

No.3-1PCS
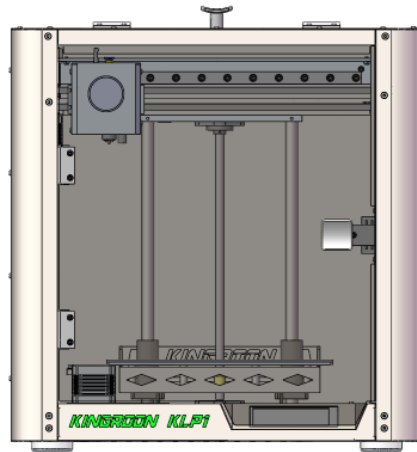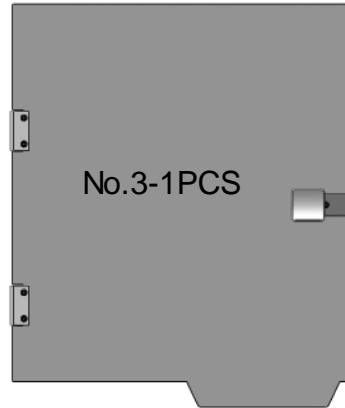
Step 6
Tear off the protective film on board 3 and use one M4 * 6 screw to secure the handle to board 3.Use 4 M3 * 6 screws to secure the 3rd board to the front of the machine.

M3*6-2PCS

Step 7
Fix the filament holder to the back of the machine using M3 * 6 screws.

4. configure network

Network cable

U disk

Camera (Optional)

Step 1
1. Network cable connection: Insert the network cable and power cord to power on and turn on. (Please note: Before starting the machine, please confirm the local voltage requirements and switch between 110V/220V)
2. 2. WIFI connection: Use a USB flash drive to configure WIFI, open the (wpa_supplicant wlan0. conf) file in the USB flash drive, modify the 2.4GZ WIFI account password, insert the USB flash drive into the machine before starting up, and then power on the USB flash drive. (Note that the distance between the machine and the router cannot exceed 5 meters)It is strongly recommended to use a network cable to connect your printer and router.
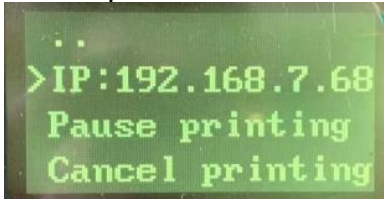
```
country=GB
ctrl_interface=DIR=/var/run/wpa_supplicant GROUP=netdev
update_config=1

network={
    ssid="Your WIFI name"
    psk="Your WIFI password"
    key_mgmt=WPA-PSK
}
```

Step 2

12864 display screen: Press the OK button on the knob, move the arrow cursor to IP, and once the network is successfully connected, the complete IP address can be displayed.


3.5 Touch screen: Click on Settings, WIFI, and successfully connect to the network to display the complete IP address.

Step 3

Open a computer browser on the same router and input the IP address to enter the Fluidd operation interface. The Fluidd operation interface can be modified in the language settings interface. Currently, the webpage supports English/ Čeština /简体中文/繁體中文 /Deutsch/Español/Français/Italiano/

Magyar/Nederlands/Portugues/Русский язык/Українська Мова/한국어/العربية اللغة /日本語。

显示屏支持English。

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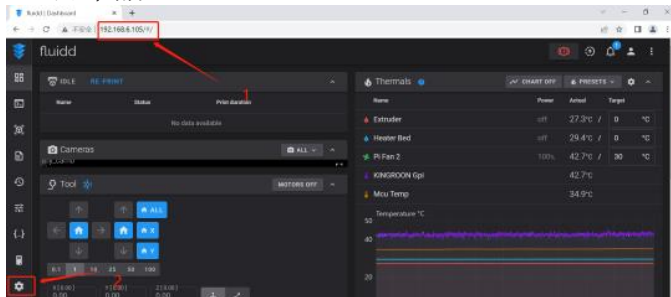
Step 4

Web page: Macros option, click on offset z_ The offset button will move the printer to the center position of the hot bed, place a piece of A4 paper above the hot bed, adjust it up and down using the Manual Probe, adjust the distance between the nozzle and 0.1mm (there is some resistance when pulling the A4 paper), and click ACCESS to save after the adjustment is completed.Click on automatic leveling for 36 point leveling.
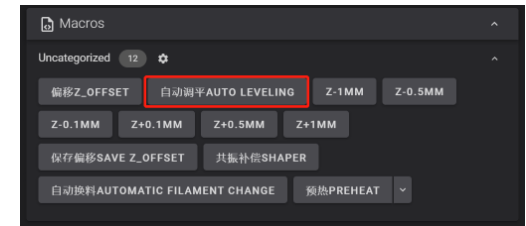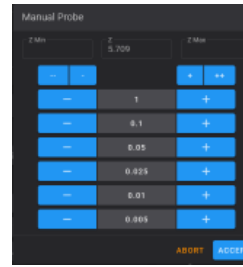
3.5 Touch screen: Click on Configuration, Z calibrate, Start, wait for the extrusion head to move to the middle of the hot bed, select the distance to move, and then click on Lower Nozzle to move the nozzle distance. Adjust the distance between the nozzle and 0.1mm (there is some resistance when pulling A4 paper). After the adjustment is completed, click on ACCESS to save.


Click on Bed Mesh, Callrate to perform a 36 point leveling, wait for the leveling to complete, and then click Save.
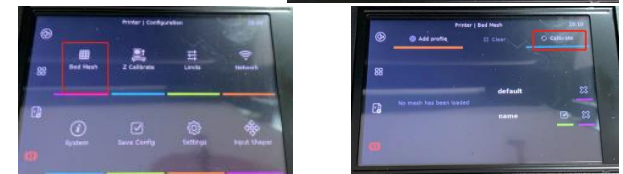

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5. Leveling

12864 display screen: Click on Level, Z_ Offset, Probe, wait for the extrusion head to move to the middle of the hot bed. Use the Probe to adjust up and down, adjust the distance between the nozzle and 0.1mm, and click Save to save after the adjustment is completed. Then click on Auto_ Perform 36 point automatic leveling at level.
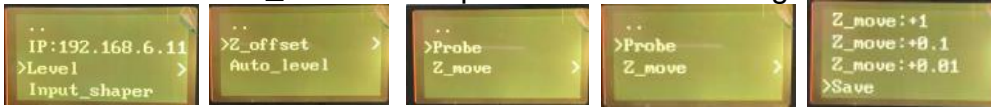
Step 5
Preheat the extruder and load the filament.On the webpage side: Macros option, click on the preheating function, wait for the printer to automatically return to zero before loading the high-speed printing filament. Please pass the high-speed printing filament through the filament exhaust sensor and then feed it into the extruder.Tool option, change the Extrude Length to 100mm, and then click EXTRUDE,Wait for the nozzle to have filament extrusion.
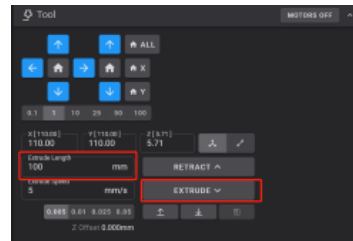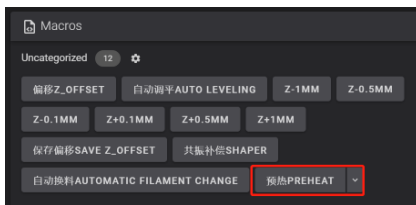

3.5 Touch screen: Click on Actions, Extract, Temperature, PLA, wait for the temperature to reach the target temperature, and extrude a 100mm filament.


6. Vibration compensation

Step 6
Macros option, click on the vibration compensation shaper, and wait for the vibration frequency data.Note: During the vibration compensation process, the printer will generate vibration noise in the vibration compensation shaper.
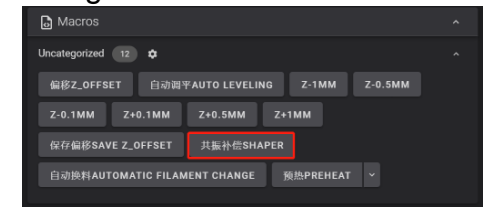
Step 7Jobs option, print Pressure Advance Calibration, wait for pressure advance calibrationAfter printing, observe the most complete line, and the value on the right is the pressure advance number.
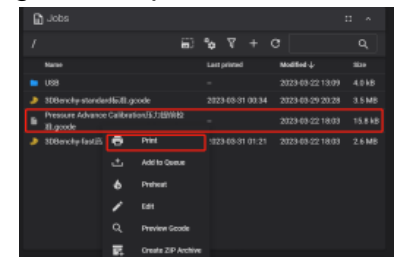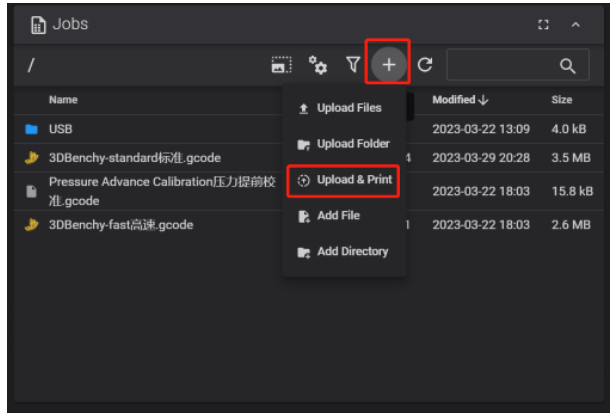

Step 8Open MKS in the configuration file_ THR.cfg, modify the pressure in line 45_ AdvantageAdvance the pressure data, then save and restart it in the upper right corner. It is recommended to perform the following steps every time the consumables are replacedPerform a pressure pre calibration once.
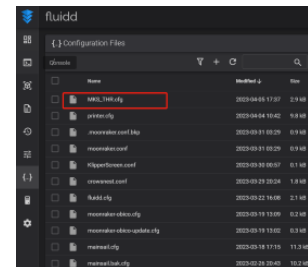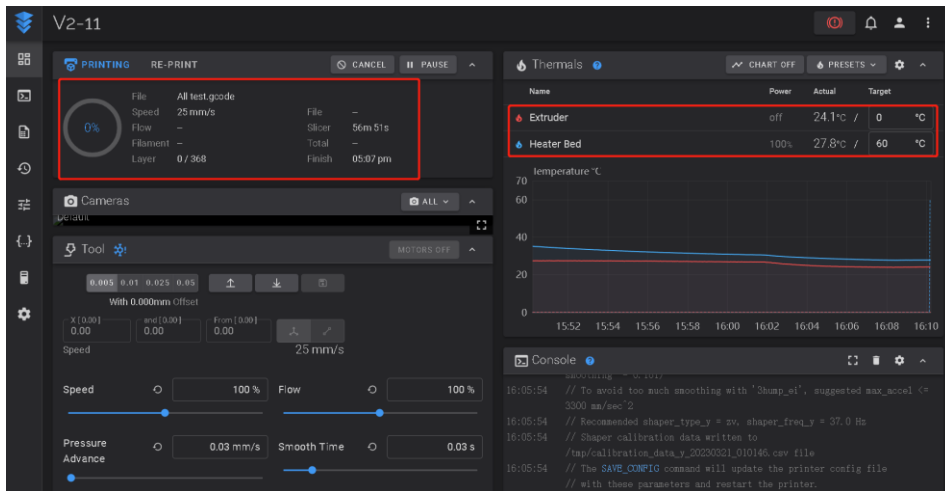
Step 9
Jobs option, click+to upload and print the file.

Step 10
Wait for the hot bed and nozzle to heat up to the specified temperature before printing begins.

Step 1: Find the cura slicing software on the USB drive and install it according to the instructions as follows
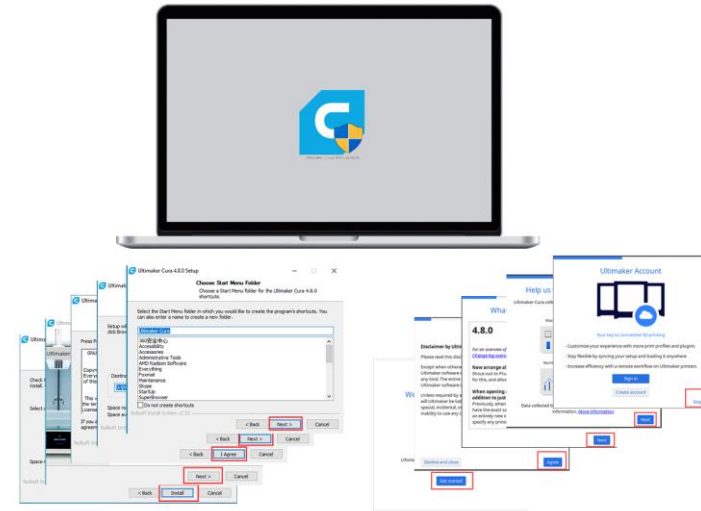
Step 2: Import the slicing configuration file from the USB drive into Cura

1.Place the "KIINGROON_KLP1" folder in the "share\cura\resources\quality" directory under the cura5.1 installation path.

2. Place the "KIINGROON_KLP1. def. json" file in the "share\cura\resources\definitions" directory in the installation path.

3. Place the "KIINGROON_KLP1_extruder_0. def. json" file in the "share\cura\resources\extruders" directory in the installation path.

4. Place the "KIINGROON_KLP1. stl" file in the "share\cura\resources\meshes" directory of the installation path.

5. Close all open CURA software and add KLP1 after reopening.

Step 4: Open cura, select a printer that is not connected to the network, and select KLP1 from KINGROON.If the model is not available, please check if the previous step is correct.
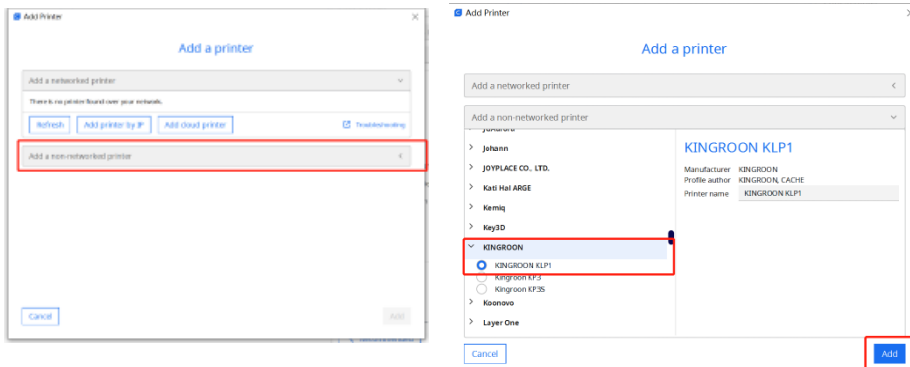
Step 5: Select the language you need and restart Cura
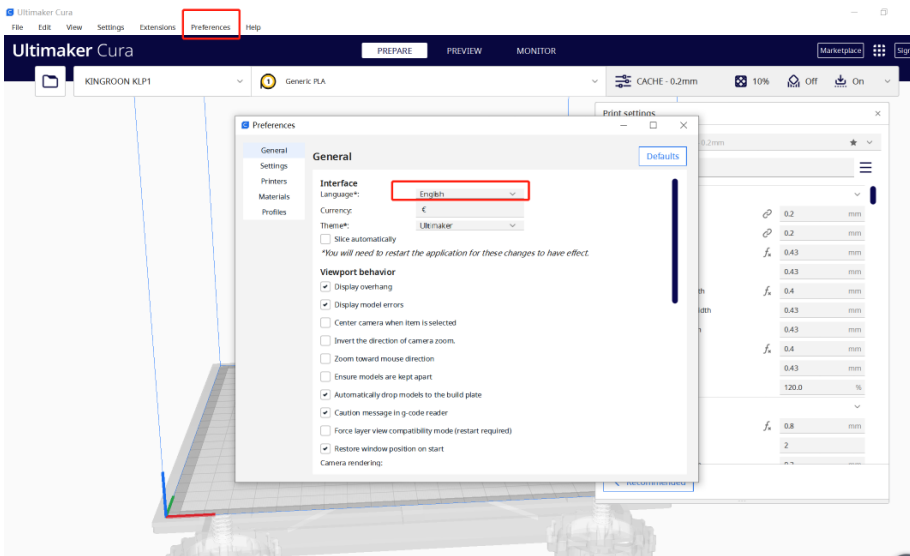
Step 6: Load the model and start slicing.
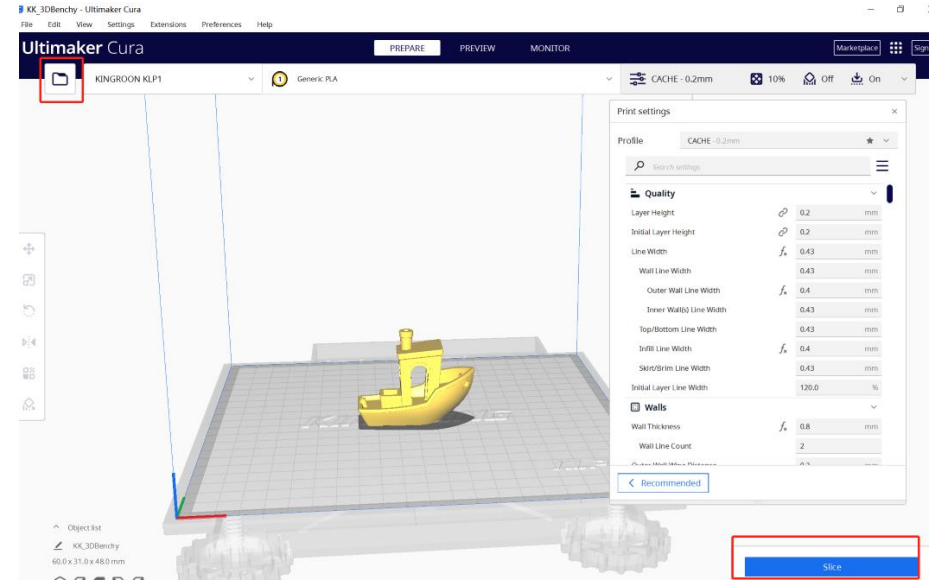
Kingroon has configured all parameters,

You can directly save the Gcode to a USB drive for printing,

Alternatively, you can directly upload Gcode for printing on the webpage.

If you have any questions, please contact KINGROON customer service.

We will solve the problem for you as soon as possible,

You can also join Facebook discussion groups.

1.Do not operate the motherboard and adapter board while powered on.
2. Non professional players are not allowed to change the configuration
file at will.
3. After the machine is powered off, it cannot be turned on for 2 minutes.
Due to the fact that Klipper runs on a Linux system, the KLP1 motherboard is designed
with a capacitor that stores power. The capacitor provides temporary power support
during a power outage, achieving a soft shutdown of the Linux system and saving data,
effectively extending the system's lifespan. Therefore, it cannot be powered on
immediately after a power outage. It is necessary to wait for the capacitor's power
consumption to complete before powering on. This process takes approximately 1-2
minutes.
4. When the filament exhaust sensor detects that the filament is used up, it will
automatically trigger the automatic exit filament function. Do not power off or operate the
machine when the automatic exit filament function is running. This process takes 10
minutes. When the target temperature of the extruder is O, the remaining filament can
be pulled out. If there is resistance, please apply a little force to quickly pull out.The
automatic exit filament function using the Macros option also
5. For better printing results, please use kingroon high-speed printing filaments or
third-party high-speed printing filaments. Using third-party ordinary printing filaments
may cause other problems requires the above process.
6. The default factory setting for the drive is non high-speed mode. If the printing
speed is above 300mm/s, please turn on high-speed mode. Stealthchop_ Threshold:
99999 changed to Stealthchop_ Threshold: 0 to enable high-speed mode.
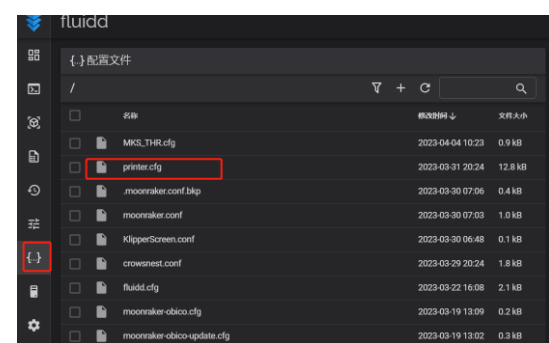
Note: Each 3D printer has been tested before leaving the factory. If there is a little filament remaining in the nozzle or a slight scratch on the printing platform, it is normal and it will not affect the performance.

Safe Working Environment

The KINGROON 3D Printer should be equipped with an original transformer or power supply. Otherwise, the machine could be damaged or even cause a fire.Always place the printer on a stable base where it cannot fall of tip over.Please ensure the printer is far away from flammable gas, liquid and dust while it is being operated. (The high temperature generated by the operation of the printer may react with the dust, liquid or flammable gases in the air, which may cause a fire.)The ambient temperature recommended for using the printer is 10℃-30℃, and the humidity 20%-70%. Using the print outside theses ranges may cause poor printing results.Please never expose the printer to moisture or heat. Never use the printer during an electrical storm. The printer is for indoor-use only.If you are not suing the printer for a long time, please turn off the printer and unplug the power cord.

Safety Manual

1. When the printer is working, DO NOT TOUCH the heat generating parts,NOT even with gloves, as the extreme heat can melt the gloves causing severe burns. WARNING: THE NOZZLE TIP CAN HEAT TO 260C AND THE PRINT BED CAN HEAT TO 100℃.
2. DO NOT TOUCH any working parts while printer is printing. The nozzle tip and other mechanical parts will run at high speed. Contact with any running parts may cause damage and injury.
3. When printing with PLA or Wood materials ensure the printer is in a well ventilated environment, due to the fumes released by the plastic materials.
4.NEVER allow children or untrained people to operate the printer.

Daily Maintenance

Please do dust removal maintenance and lubricate the printer every month. If you are not using the printer for a long time, please remove the filament and keep the storage environment dry, dust-free. The printer should place in a temperature-stable environment. The sudden drop in temperature can affect the printing quality. When the print nozzle is squeezing, please make sure there is enough space between the nozzle and the platform; otherwise the nozzle will be blocked.
1.Clean/Maintain the print platform, replace the tape if used.
2.Preheat the nozzle and extrude a small amount of filament.
3.While the nozzle is still hot, use a steel brush on it to clean any excess filament.
4.Preheat the print bed and level it.