

# **Phrozen Shuffle 2019 / Shuffle Lite User Guide**

Thank you for purchasing Phrozen products!

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- Phrozen Printing Toolkits Box
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  - Metal Scraper \* 1 pc
  - Funnel \* 1 pc
  - Gloves \* 1 set
  - AC Power Cord \* 1 pc

※If you have any missing component or problems, please contact the

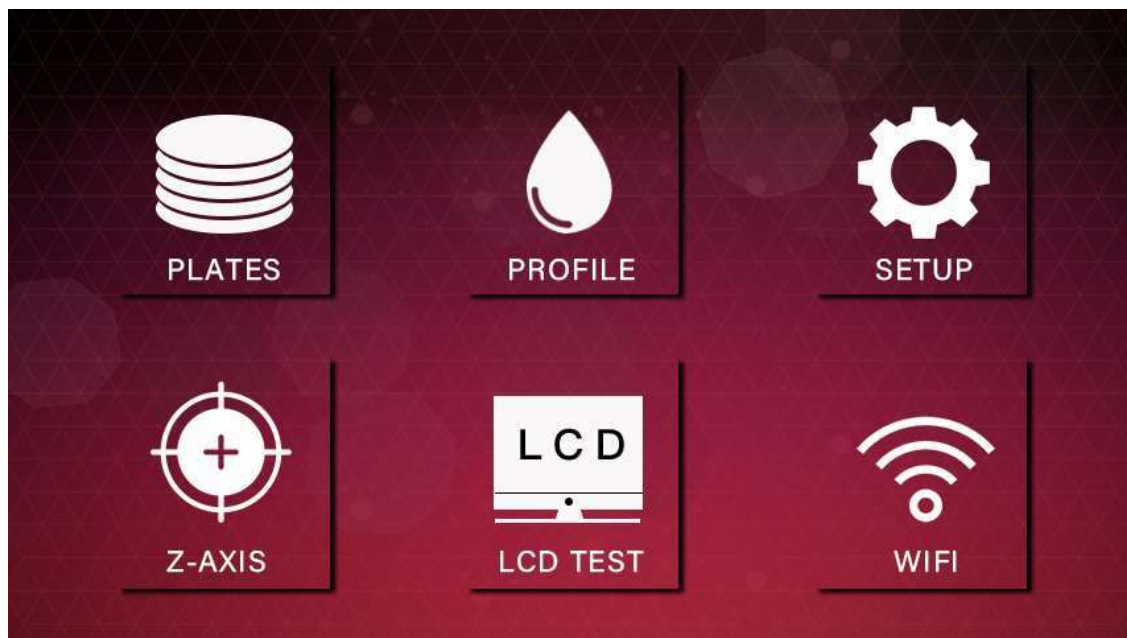
Phrozen team directly

## BEFORE YOU START...

- Plug-in AC Power Cord and turn on the button.



Phrozen OS will be ready in 45 secs.



## CALIBRATION

**Z-axis calibration is an essential process to make your 3D prints successfully printed with good quality, please do start your printing process after a proper Z-axis calibration.**

**Step 1** → Take off the resin vat and make sure no objects on the LCD.



**Step 2** → Put 1 piece of A4 paper on the LCD platform.



**Step 3** → Loosen 4 screws on both sides of the build platform.

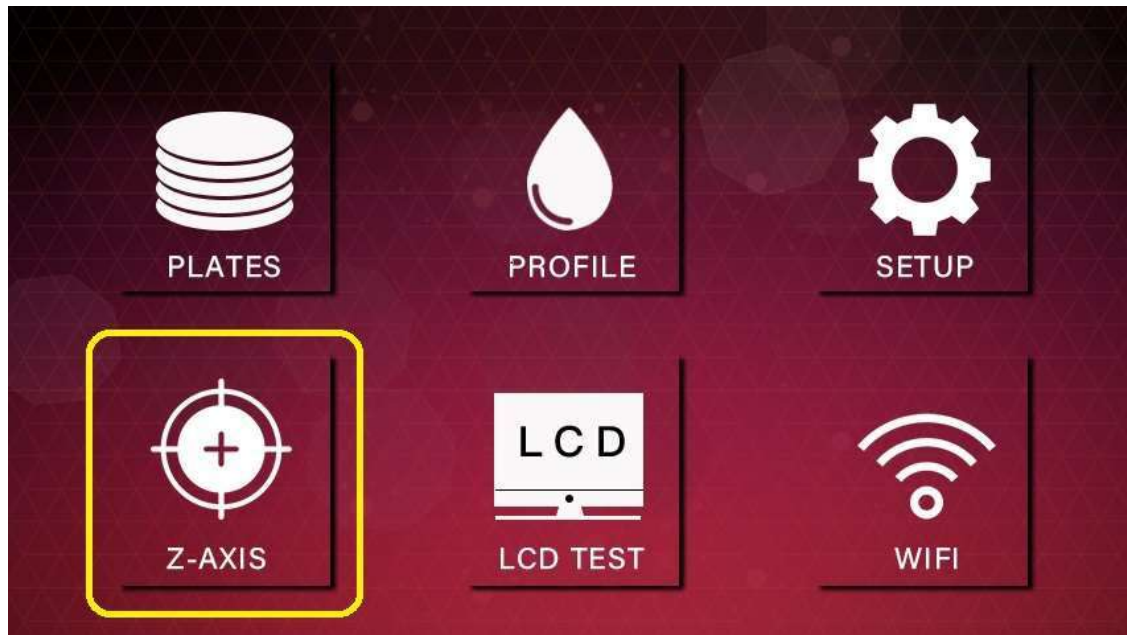


### ➤ Tips

Gently pull the build platform to see if it's moveable and well-loosened.



Step 4→ Click 【Z-AXIS】 button to start the calibration process.



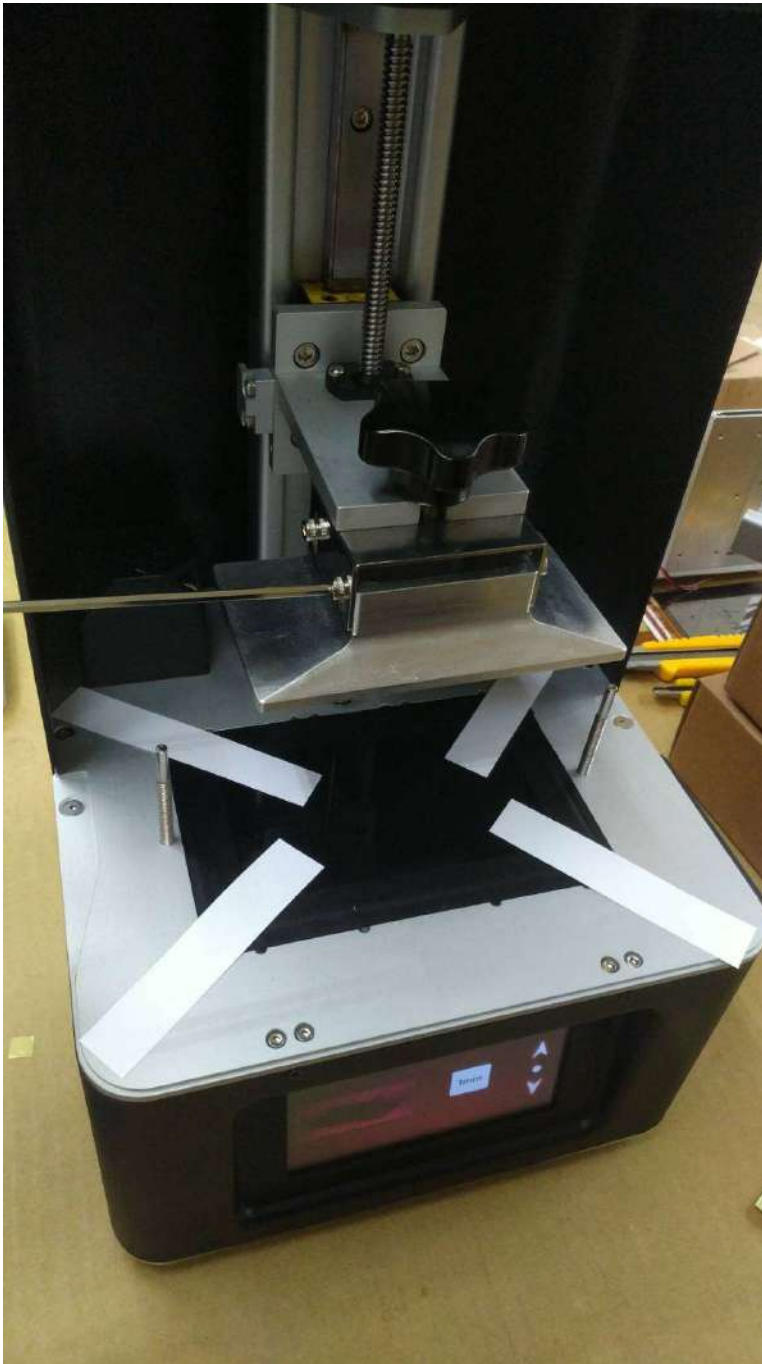
Step 5→ Click the manual dot icon at the right side.



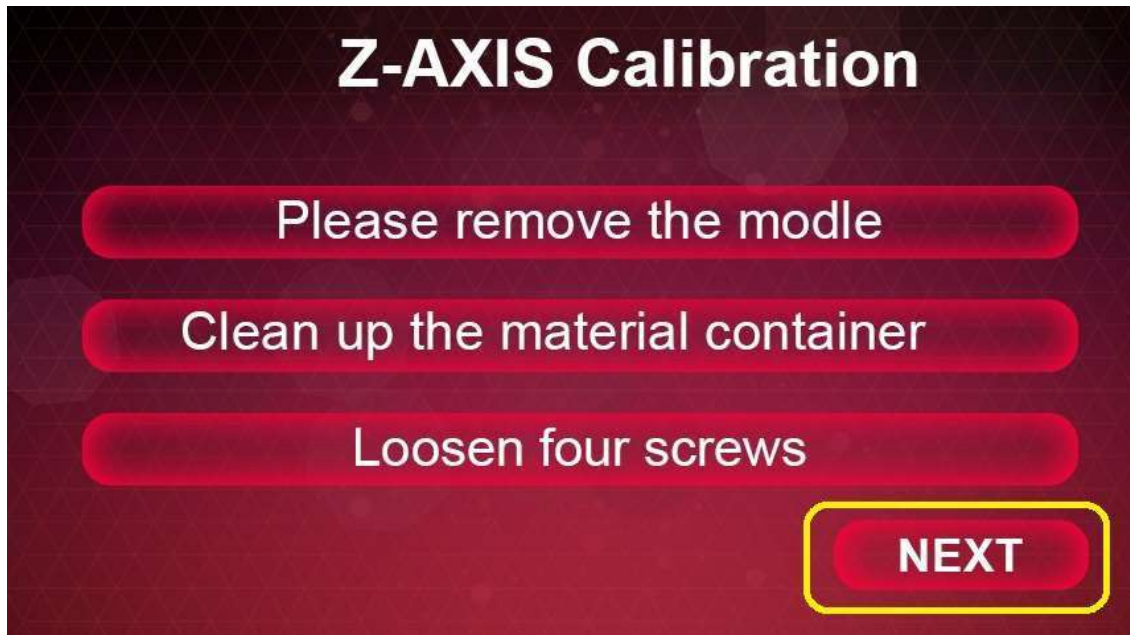


**Step 6** → Loosen 4 screws on both sides of the build platform.

➤ **Tips** Gently pull the build platform to see if it's moveable and well-loosened.



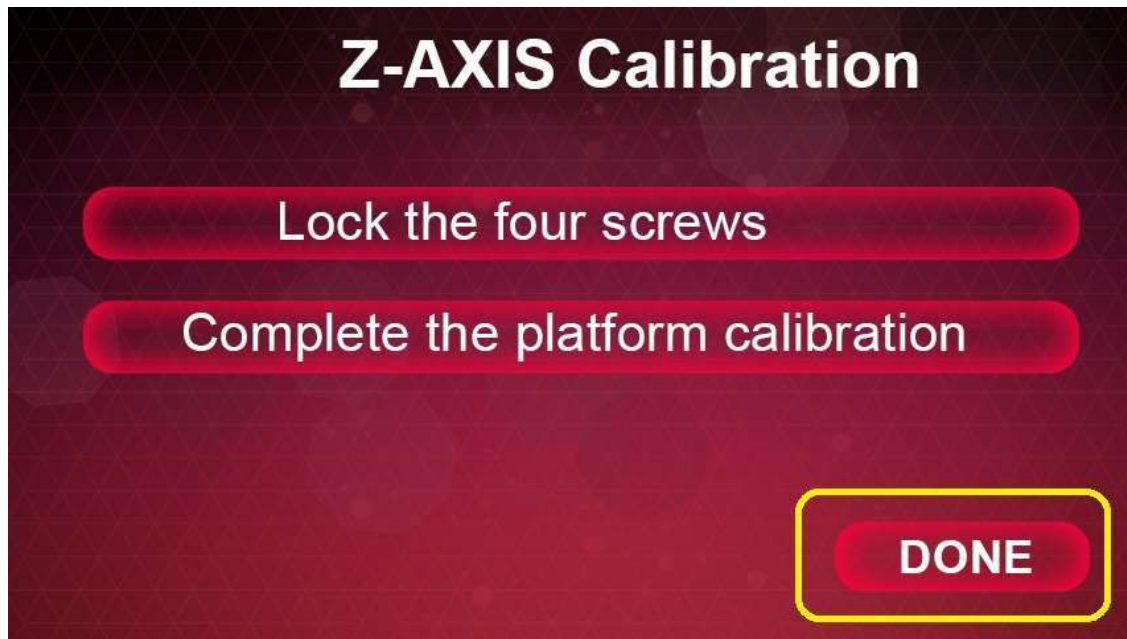
**Step 7**→ Click 【NEXT】 , kindly wait the build platform down to the BOTTOM.



**Step 8**→ Tighten the screws with slightly pressing the build platform to make sure the A4 paper is still and IMMOVABLE.



**Step 9**→ Click **【DONE】** , kindly wait the build platform back to the top.





# UPLOAD PRINTING FILES

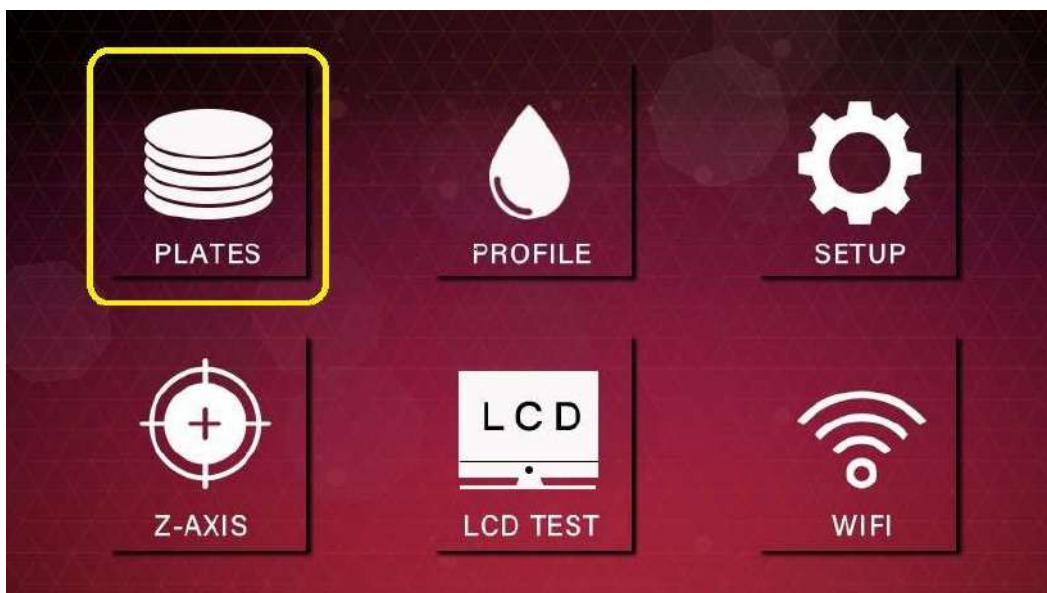
USB connection method:

Step 1➔ Make sure the printing file in your USB has been sliced to .phz or .zip format.

➤ **Tips** Please name your printing file with **ONLY EN ALPHABET**.

Step 2➔ Insert your USB into the socket at the back of the printer.

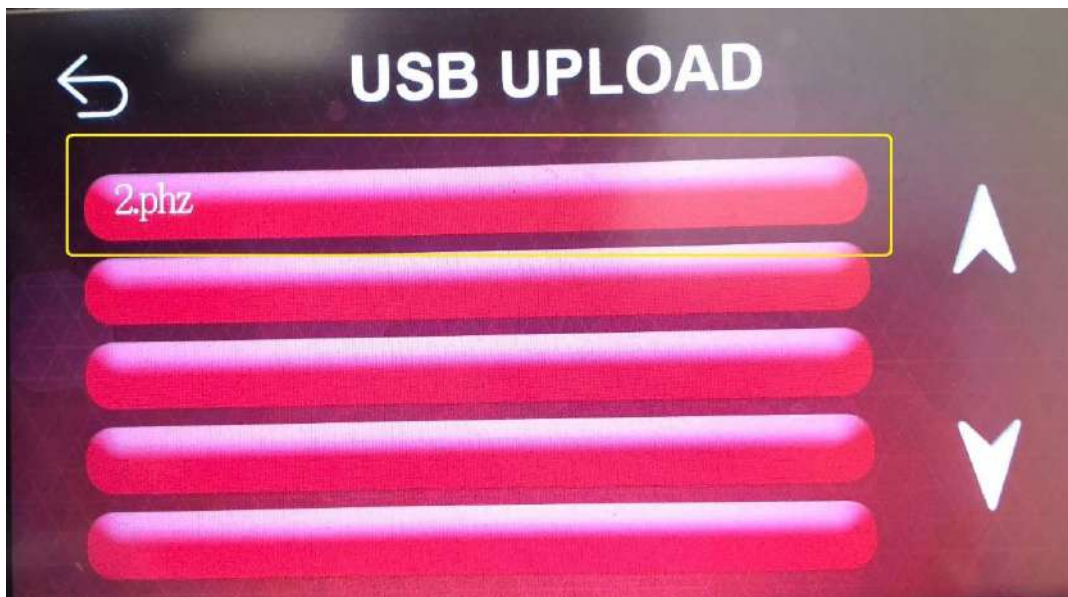
Step 3➔ Click 【PLATES】 .



Step 4➔ Click USB icon at the top of the screen.



Step 5➡ Choose your printing file to start uploading process.



Step 6➡ The file will be displayed on the PLATES screen



Step 7➔ After entering the preview screen, please double check the file you are going to print and click ✓.

Step 8➔ Before starting to print, please make sure that there is no object around the stage and resin tank to avoid the LCD panel being crushed.



# Printing

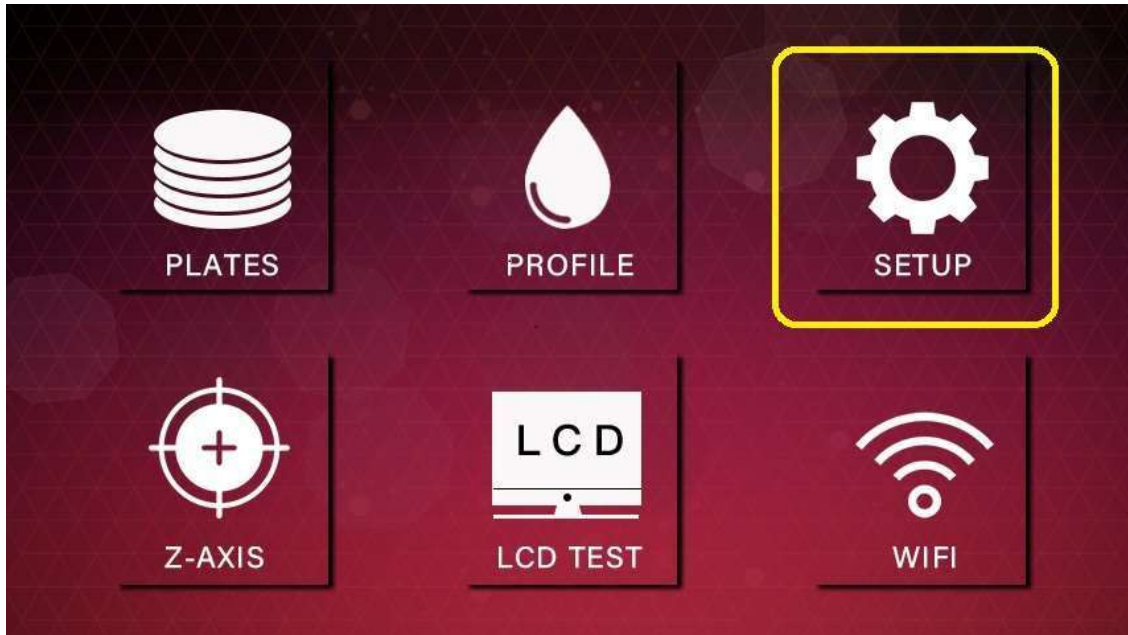
- Pour in resin



- **Tip 1** Always wear gloves, goggles, long-sleeved clothing during your printing process.
- **Tip 2** Resin is a kind of chemical material, if feeling any uncomfortable during using it or, moreover, accidentally eating it, please go to the nearest medical unit asap for further help.
- **Tip 3** Always wash out completely if any contact between resins and your body, furthermore, if feeling any uncomfortable, please go to the nearest medical unit asap for further help.
- **Tip 4** **KEEP THE RESIN SAFELY AWAY FROM CHILDREN.**
- **Tip 5** Please shake the resin properly before using it.
- **Tip 6** Kindly keep the resin capacity below 1/2 height of the resin vat.
- **Tip 7** Always stir the vat-stored resin properly before starting your printing process.
- **Tip 8** Make sure there's **NO OBJECT ON THE LCD OR IN RESIN VAT** except resin.
- **Tip 9** Kindly keep your printing environment under 25°C.
- **Tip 10** If refilling resins is required during printing process, please refill the resin during the UV light off with platform raising-up.
- **Tip 11** Always clean the resin immediately if it spills out.

## Shutdown

Step 1➡Touch the screen operation: click SETUP.



Step 2➡After clicking, follow the instruction below:

Step 3➡① Setup→ ② Shutdown→ ③ √→ ④ Please turn off the Power Switch



# **AFTER PRINTING PROCESS**

**PLEASE KINDLY FOLLOW THE ENVIRONMENT PROTECTION RULES IN YOUR LOCAL AREA WHILE YOU DO THE CLEANING PROCESS AFTER PRINTING.**

## **1. Clean Your Prints**

**Step 1➔** Take off your print slightly from the build platform with metal scraper.

➤ **Tips** Always wear gloves and be aware of any danger operations with the metal scraper.

**Step 2➔** Clean your prints by Phrozen Wash/IPA/95% alcohol until no resin on your print.

➤ **Tips** Phrozen Wash➔ <https://reurl.cc/8lOv0o>

➤ **Tips** Ultra-sonic Clear➔ <https://reurl.cc/Gklj43>

**Step 3➔** Post cure your print by Phrozen Cure/405nm UV light.

➤ **Tips** Phrozen Cure➔ <https://reurl.cc/NaEQQq>

## **2. Tidy Up Your 3D Printer**

(a) Safely shutdown your Phrozen 3D printer

➤ **Tip** ALWAYS SHUTDOWN YOUR 3D PRINTER FIRST before you clean the build platform & resin vat for avoiding static electricity damaging your printer.

(b) Clean the build platform

**Step 1➔** Take off your print slightly from the build platform with metal scraper.

➤ **Tips** Always wear gloves and be aware of any danger operations with the metal scraper.

**Step 2➔** Clean your build platform by Phrozen Wash/IPA/95% alcohol until no resin on the platform.

**Step 3➔** Dry the model by placing it in a cool place more than 30 minutes.

(c) Clean the resin vat

**Step 1➔** Store your used resin with a whole black, well-sealed bottle in a dark and cool place.

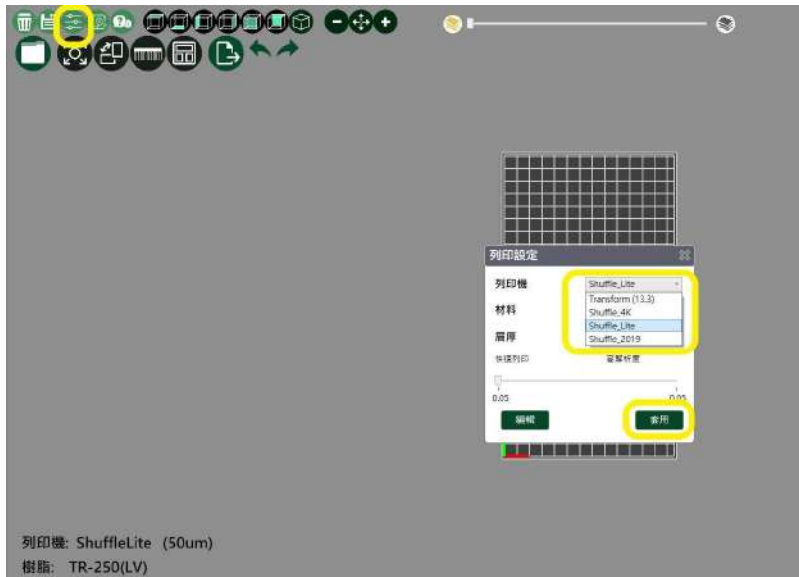
- **Tip 1** Funnel, filter paper and plastic scraper will be the helpful toolkits to store your resins.
- **Tip 2** Always keep new resin and used resin stored in separated container.

**Step 2➡** Clean your resin vat by Phrozen Wash/IPA/95% alcohol until no resin on the resin vat.

# PZSlice Pro Software Operation

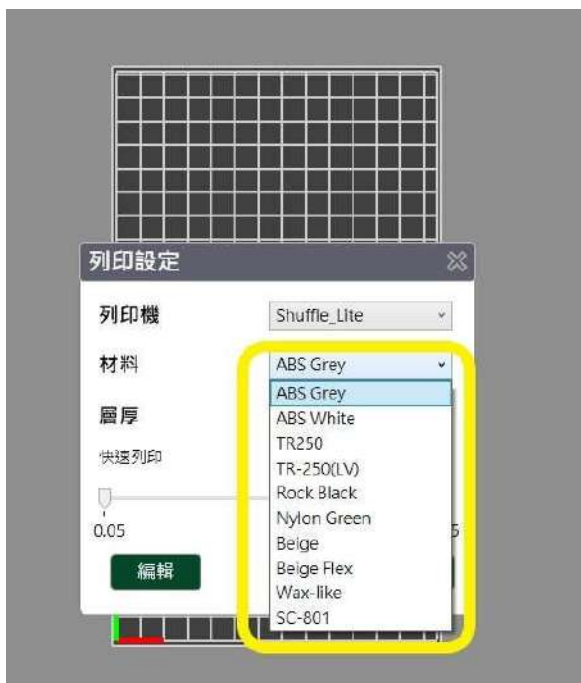
## 1.Basic setting

Step 1➡ Machine type

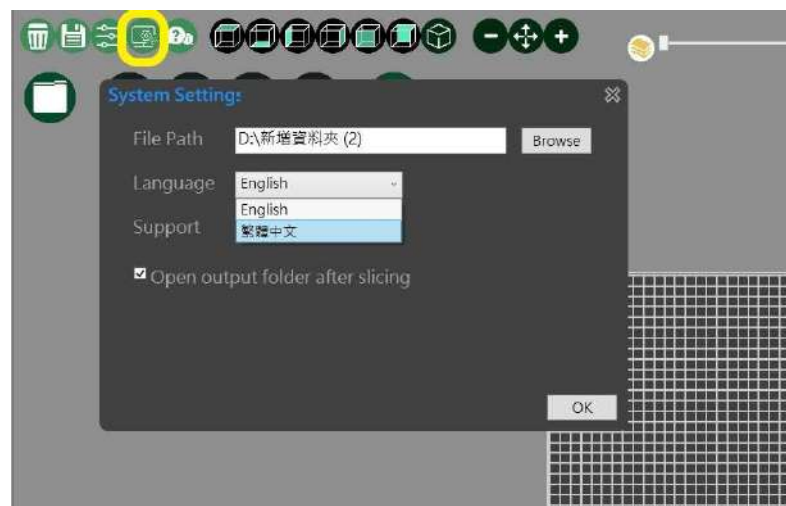


Step 2➡ Select layer thickness (\*advice 50um)

Step 3➡ select 『Apply』



Step 4➡ Choose language

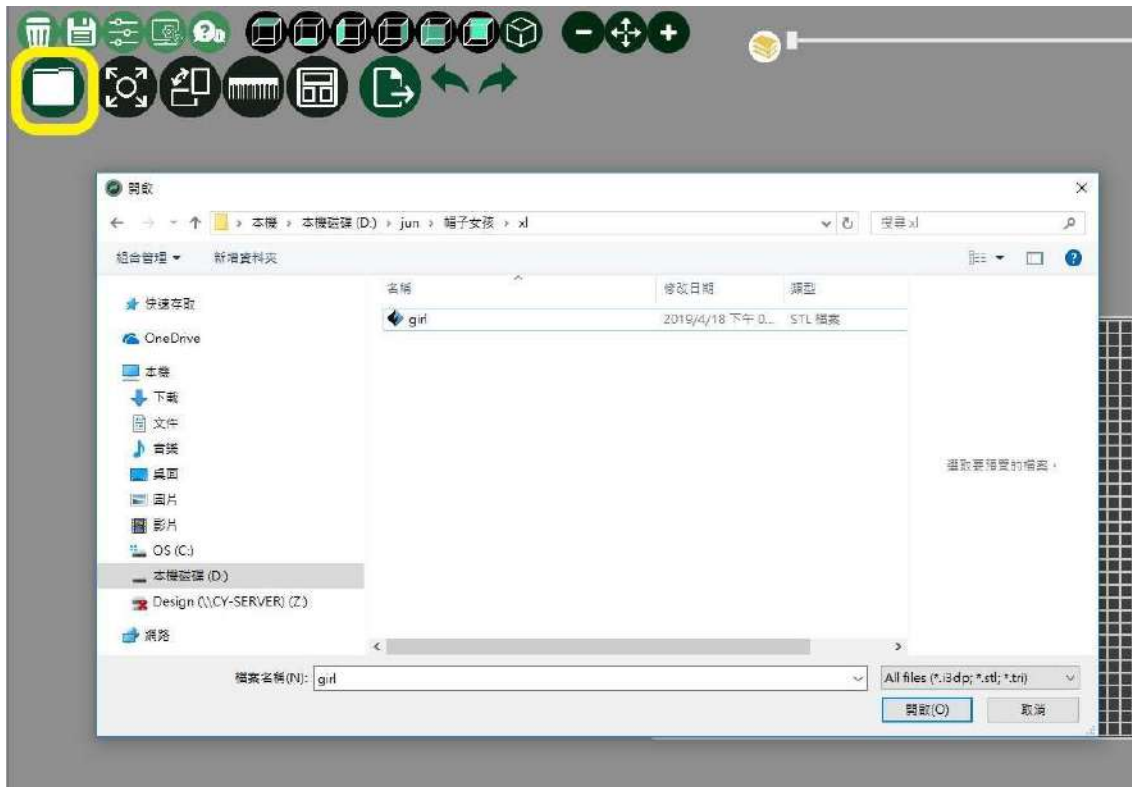


## 2.Import file

**Step 1**→ Select the upper left file icon

**Step 2**→ Choose the file to import

※Mobile window: The middle mouse button can move the screen, and the right mouse button can rotate the screen in 3D.



### 3. Hollow setup

Step 1➔ Select the icon- Support mode

Step 2➔ Choose advanced function

Step 3➔ Adjust the height of the base to 1mm

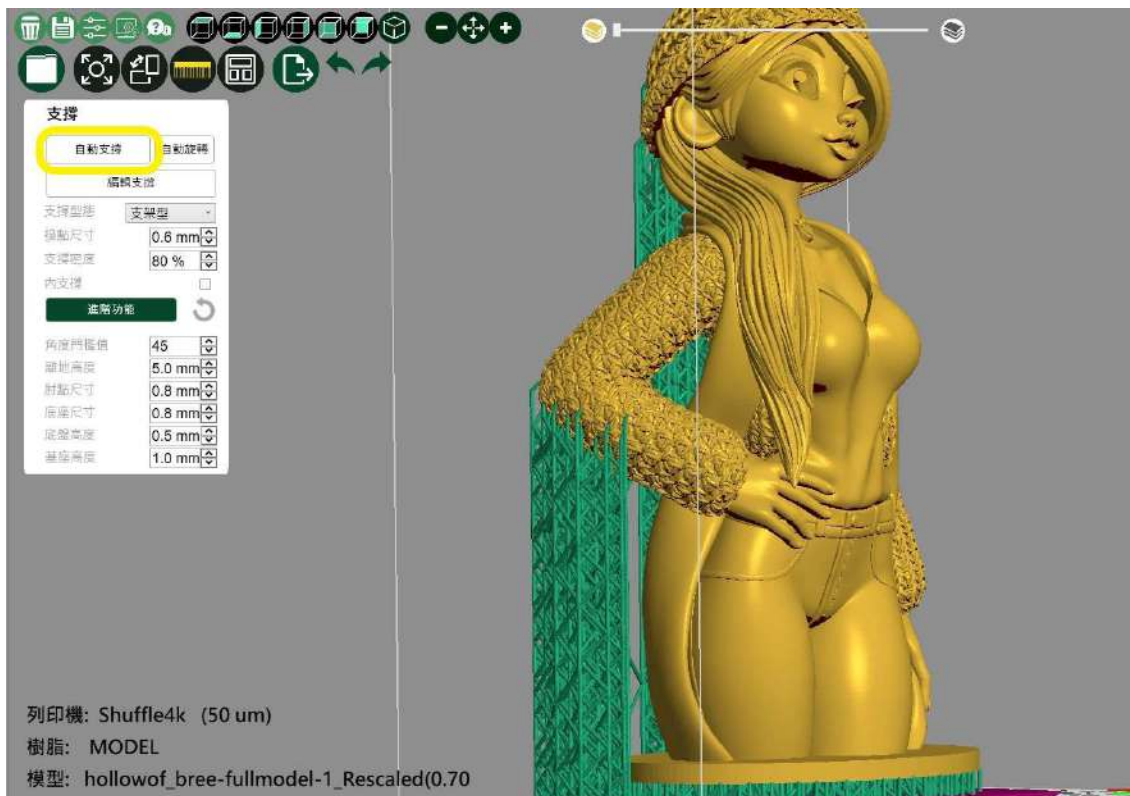
Step 4➔ Hollow out





#### 4. Adjust the support type to the bracket type

Step 1 → Generate all

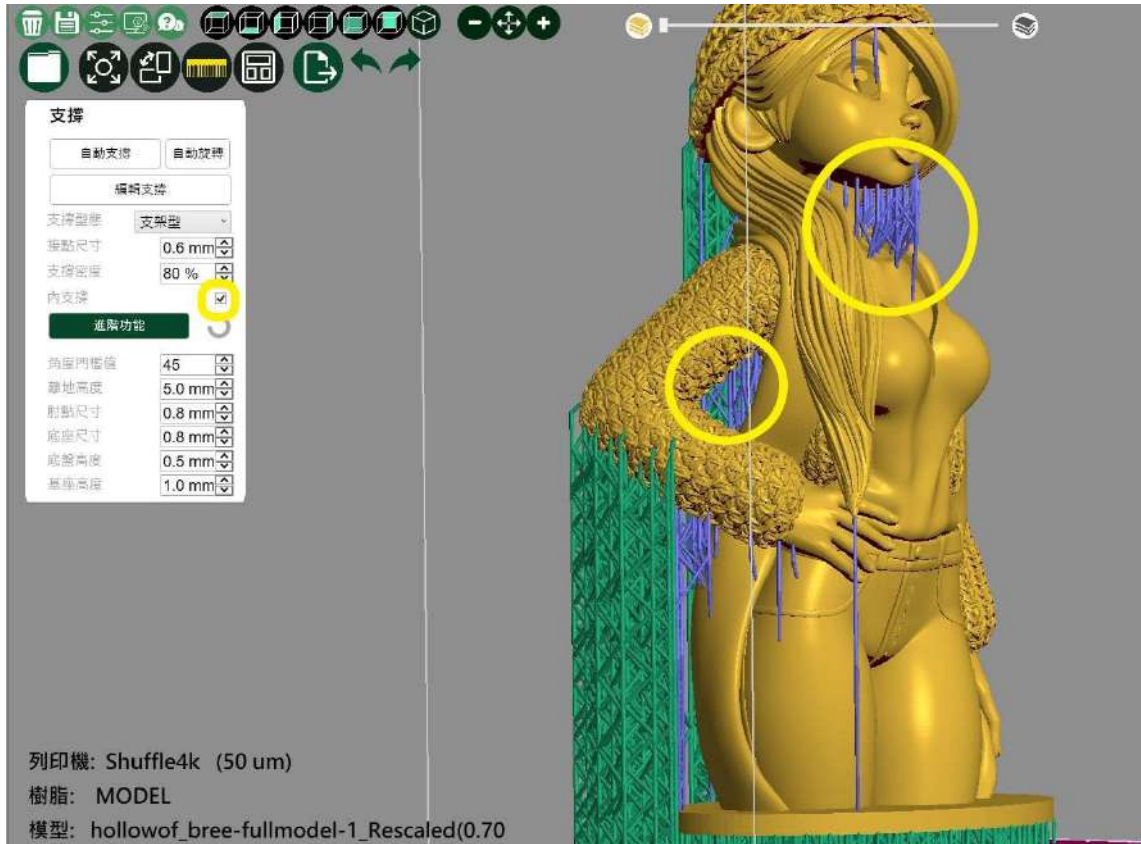


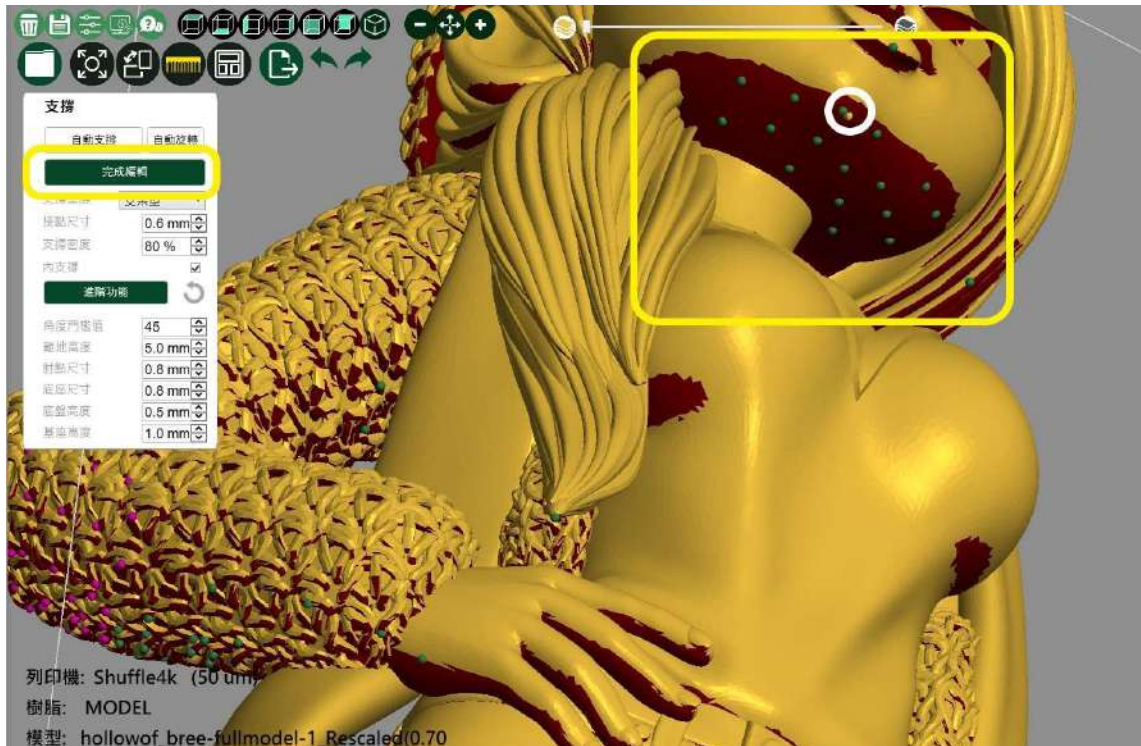
Step2 → Support type



## 5. Check the internal support function

Internal support function - for example, the model itself has a base, the automatic support is the support between the base and the platform; if the inner support is selected, the following place will be added.





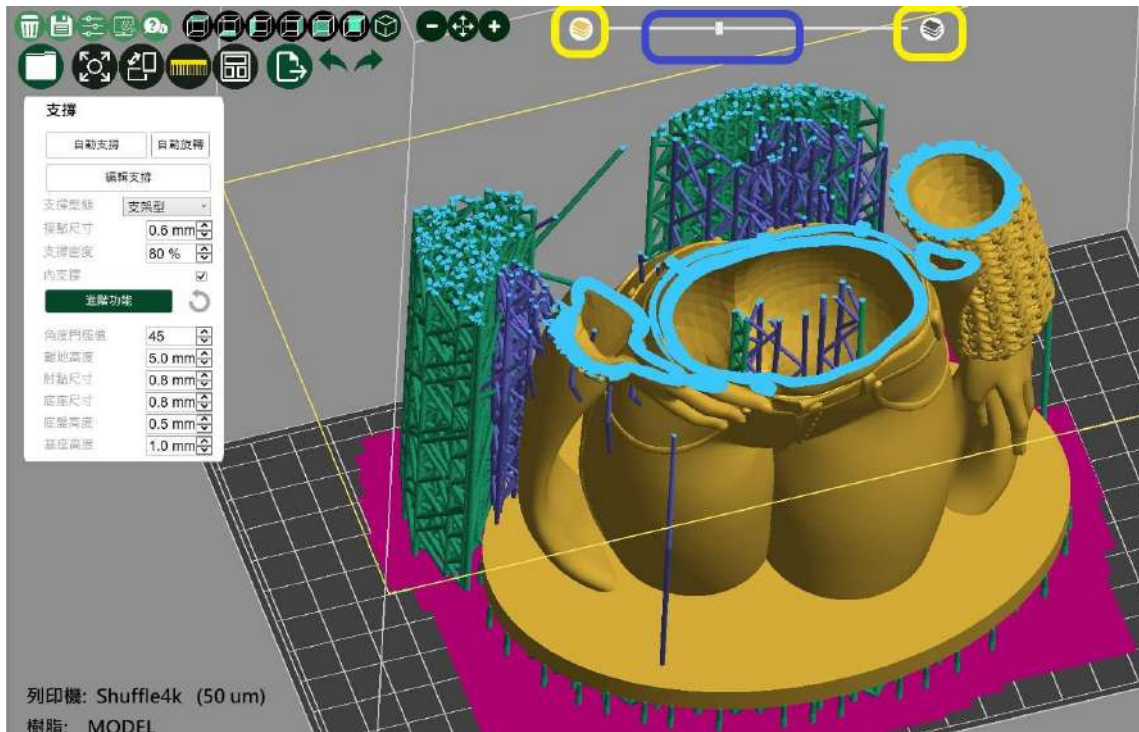
**Step1**➔Select "Edit Support"

**Step2**➔The support will be converted to contact point mode; at this time, can manually add the support by pressing the left mouse button at the color change of the model. After clicking the left button to select the contact point to be removed,

**Step3**➔After completing the editing support, please select "Edit Support" once.

## 6. Simulation check support slice

※After selecting the moving direction of the model slice, left-click and hold the middle square to move left and right to view the simulated slice





## 7.Export Slice

Step1→ Select the output slice file

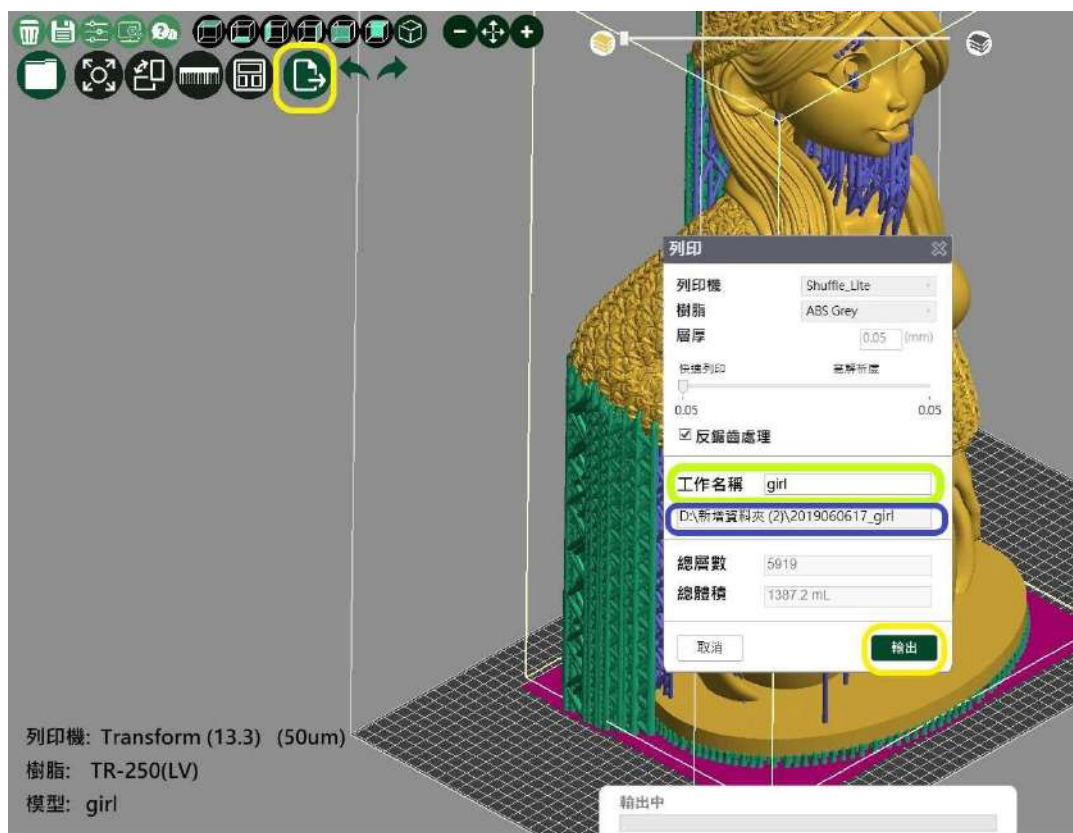
Step2→ Check if the parameters are correct

Step3→ The model name can be changed at this time.

It is suggested to name it in short English.

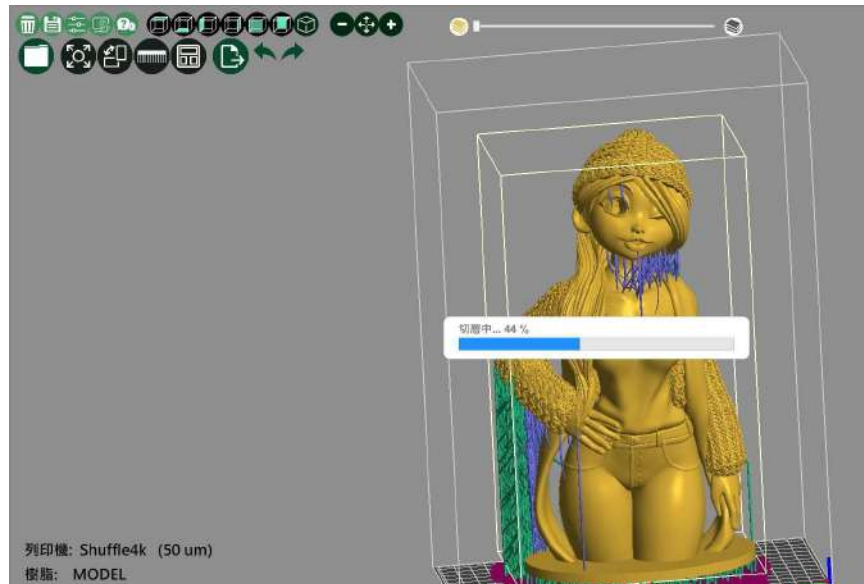
Step4→ The storage location is preset and cannot be changed here.

Step5→ Select output after confirmation



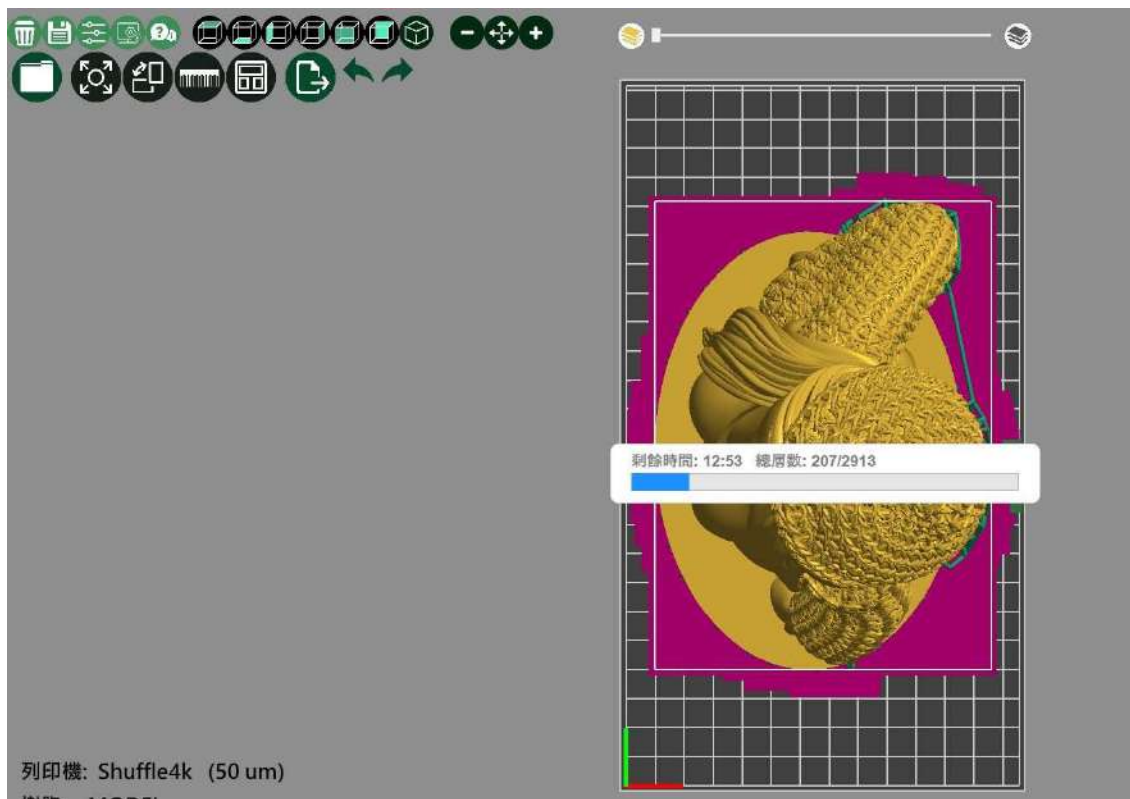


※Please do not use non-English name for the file name



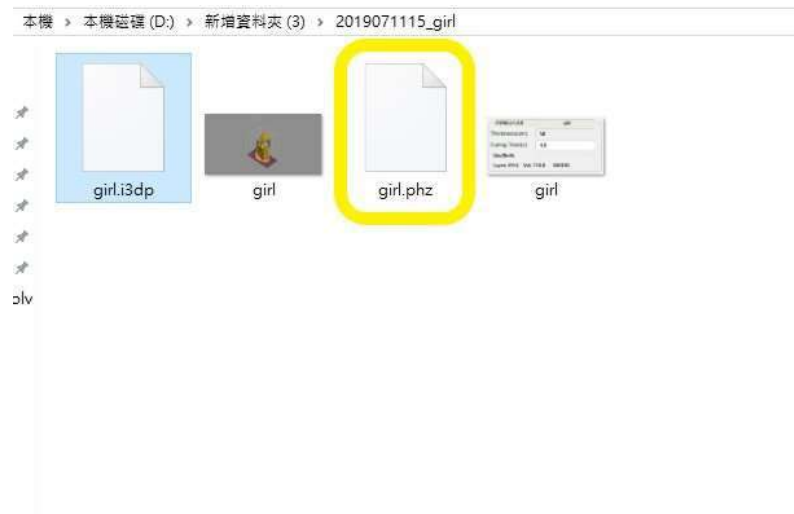
※Please do not use non-English name for the file name

※After selecting the output, the software will slice, and there is a progress bar at the bottom right. If the file is too large, the progress bar will repeat the same %, please be patient.



## 8.File storage

After opening the file storage location, save to .php file to the USB.



## Phrozen Software



## CHITUBOX User Guide

More Phrozen Printers are now on the built-in list in ChituBox  
Download now to try it NOW (for free) :  
<https://www.chitubox.com/download.html>

- 1.After the CHITUBOX software is supported, the STL file is exported and then sliced with special software
- 2.Use CHITUBOX slice and save it to zip file

**※ It should be the same slice thickness as the resin profile.**

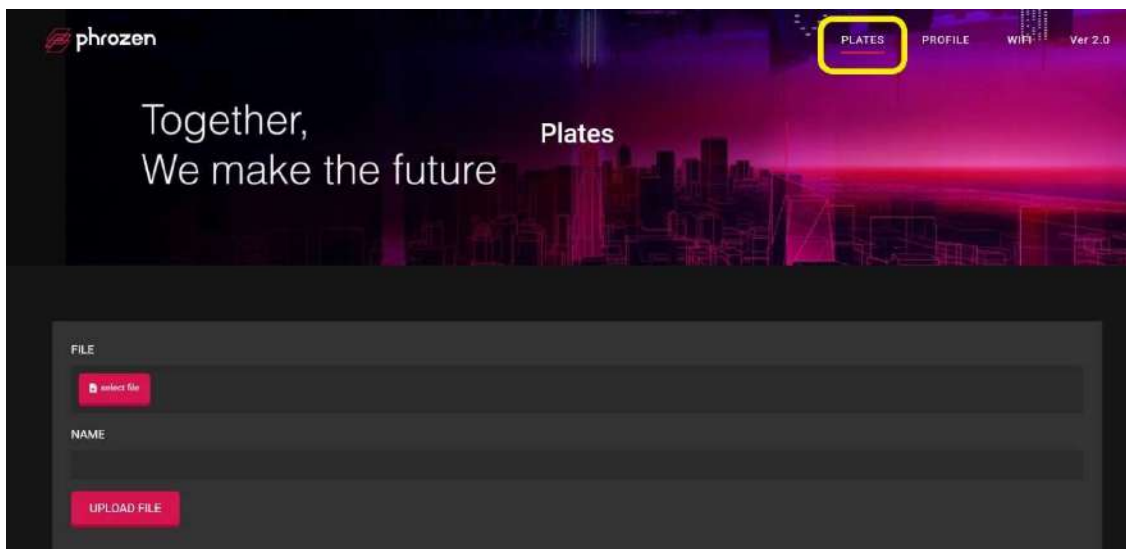
# Phrozen Shuffle 2019/Lite via Internet

## 1.Upload Printing Files via Internet

**Step 1**➔ Connect your 3D printer to the internet via Ethernet Cable or WiFi.

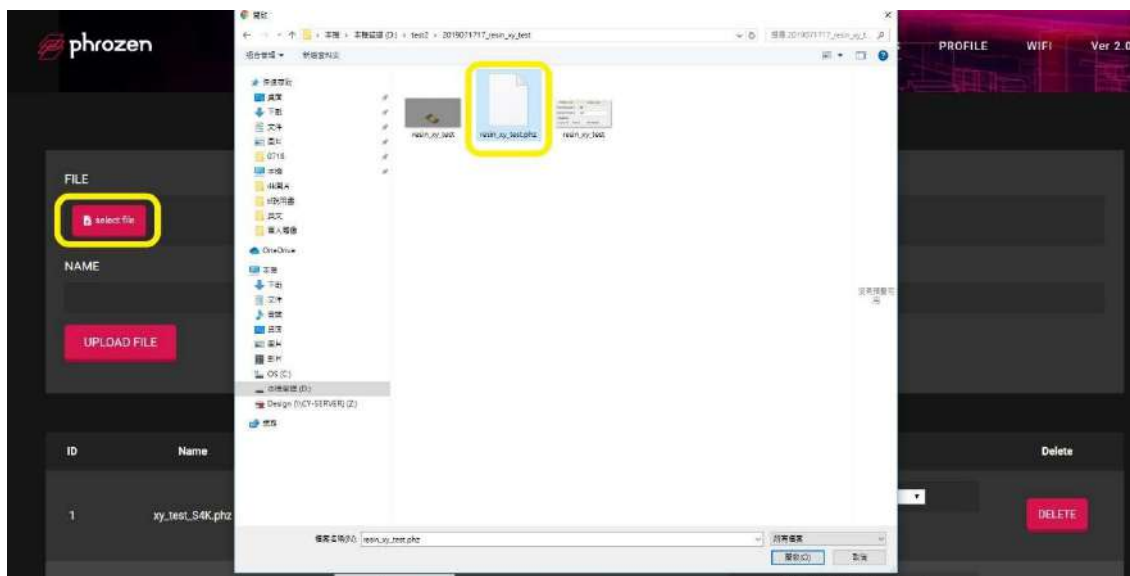
**Step 2**➔ Input the IP address showed at the top of Phrozen OS display on your web browser.

**Step 3**➔ Click 【PLATES】 of the navigation bar.



**Step 4**➔ Select your printing file (.phz or .zip format) and upload it.

➤ **Tips** Please name your printing file with **ONLY EN ALPHABET**.



## 2. Resin profile setting

**Step 1** ➔ Connect your 3D printer to the internet via Ethernet Cable or WiFi.

**Step 2** ➔ Input the IP address showed at the top of Phrozen OS display on your web browser.

**Step 3** ➔ Click **【PROFILE】** of the navigation bar

**Step 4** ➔ Add new resin profile by inputting name and profile setting

➤ **Tip 1** Check Phrozen Resin profiles of all models here!

➔ <https://reurl.cc/0zy6Xk>

➤ **Tip 2**

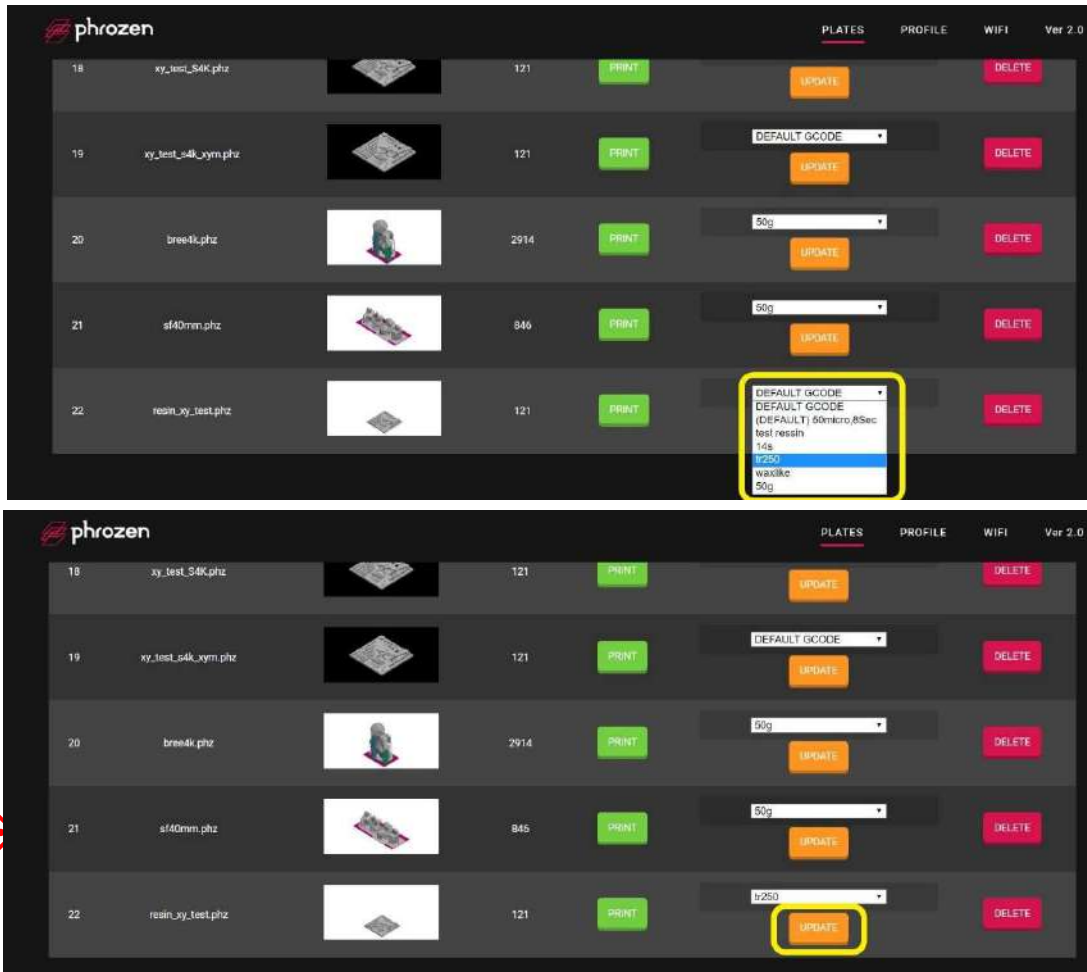
➔ 1 second = 1000 ms

➔ 1 um = 0.001 mm

➤ **Tip 3** Please name your resin profile with **ONLY EN ALPHABET**.

➤ **Tip4** Choose the resin profile which is ready to print and **UPDATE**





## CONTACT US

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After-sale Service: [sales@phrozen3d.com](mailto:sales@phrozen3d.com)

Online After-sale Service: [www.facebook.com/Phrozen3DP](https://www.facebook.com/Phrozen3DP)

Official Facebook Group:

EN: [www.facebook.com/groups/775284745970028](https://www.facebook.com/groups/775284745970028)

JP: <https://www.facebook.com/groups/1364329960379257>

Prints Gallery: [www.instagram.com/phrozen3dp](https://www.instagram.com/phrozen3dp)