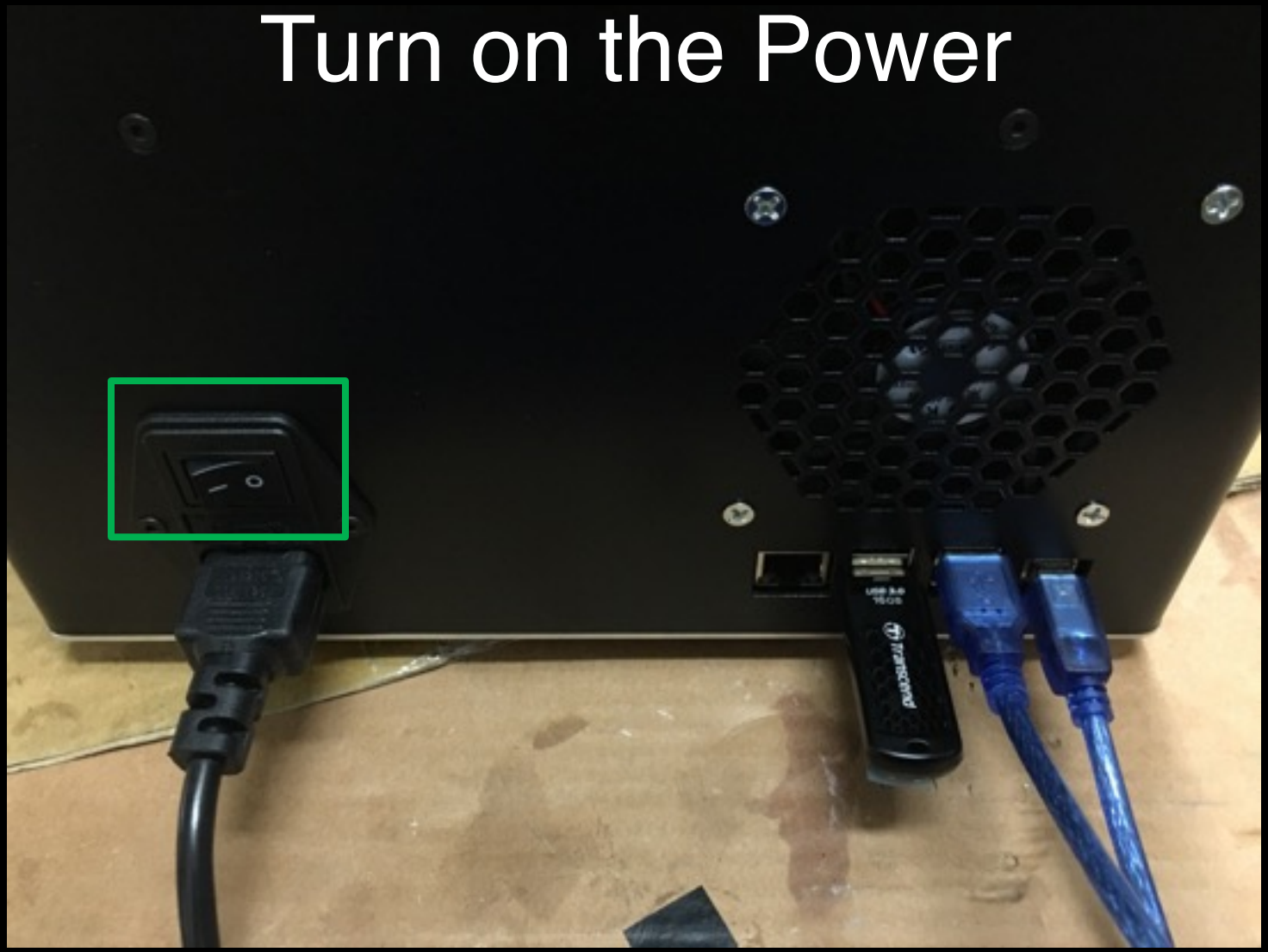
Phrozen
Shuffle User Manual

Calibration and Print

1.Connect Power wire and USB connector

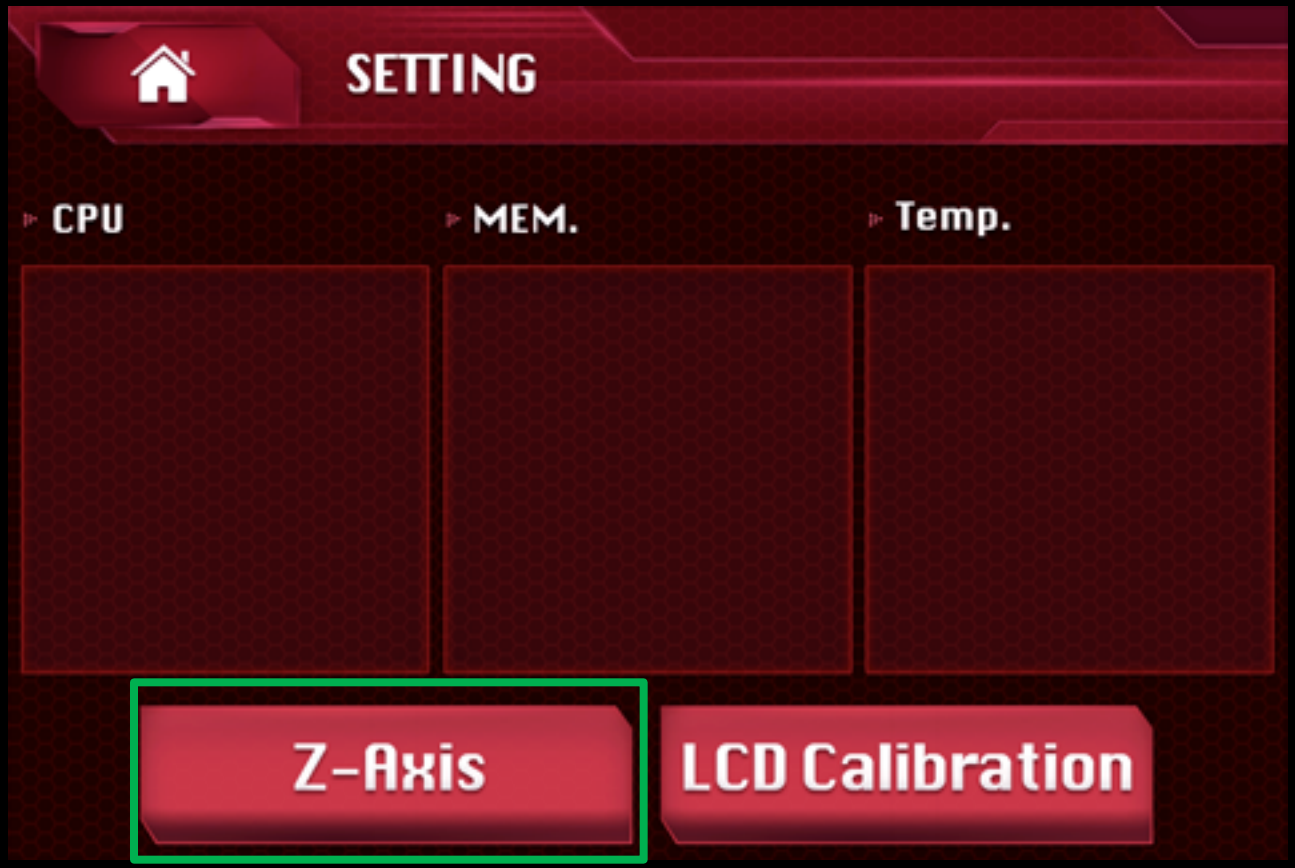
Put USB in and Turn on the Power



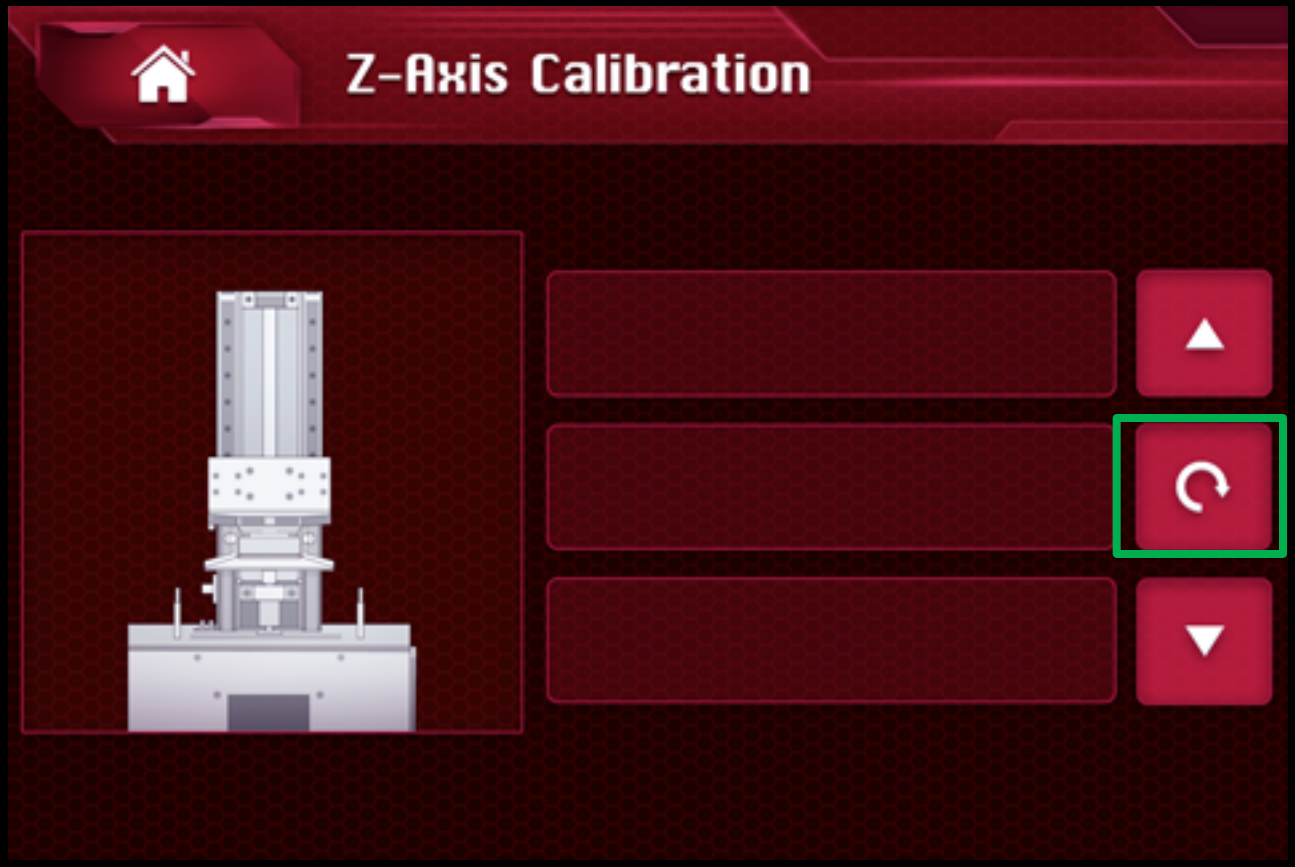
Wait for Booting

1.2 Run Z-calibration

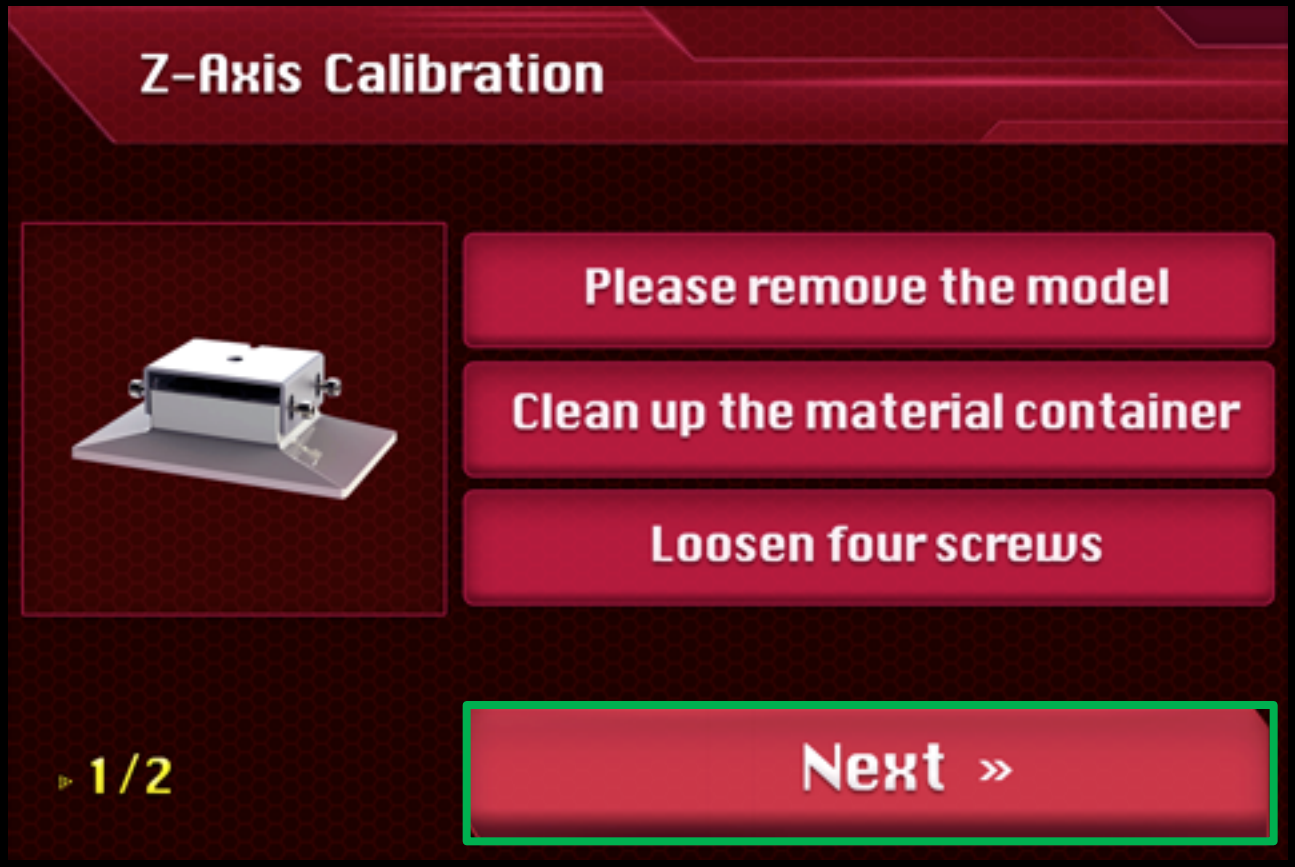
Press Z-Axis



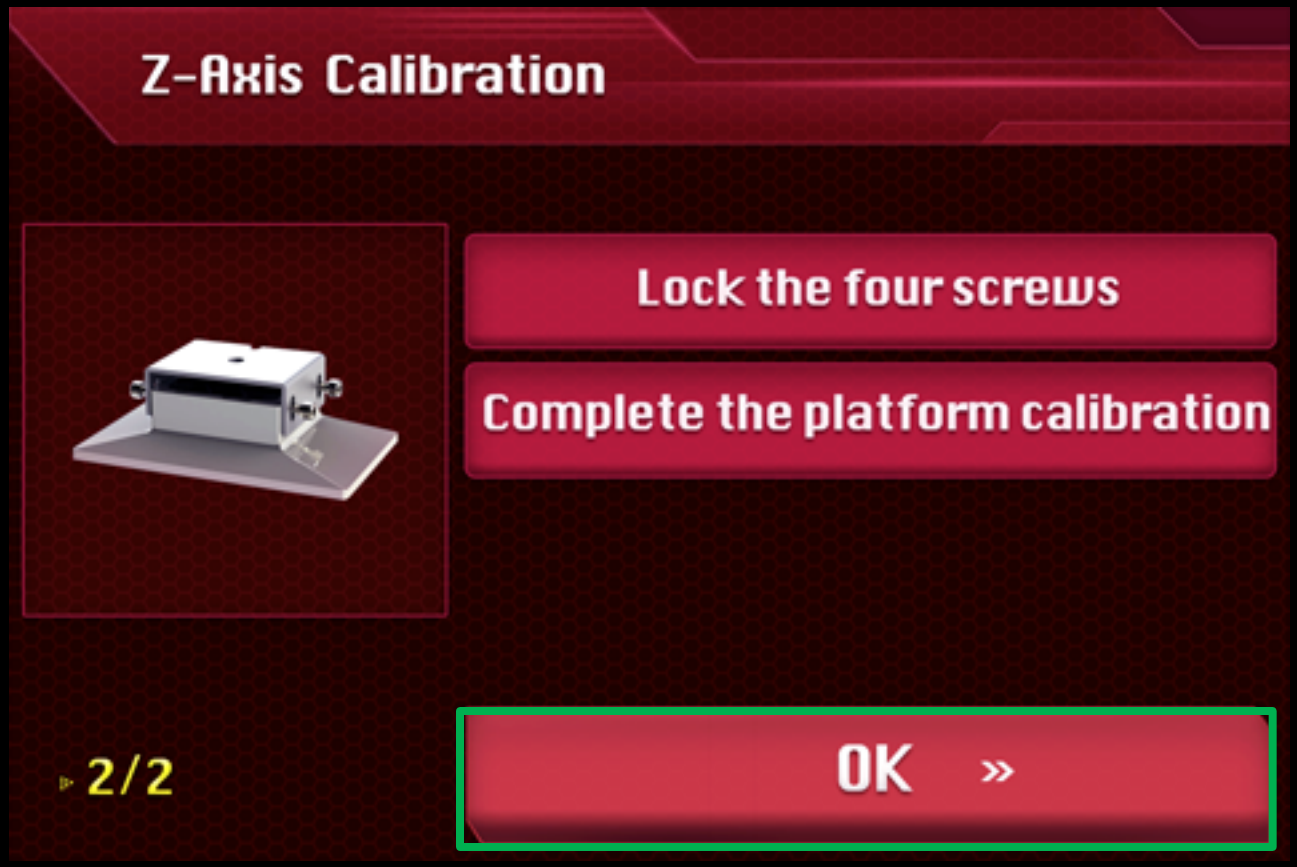
Press the Calibration Button



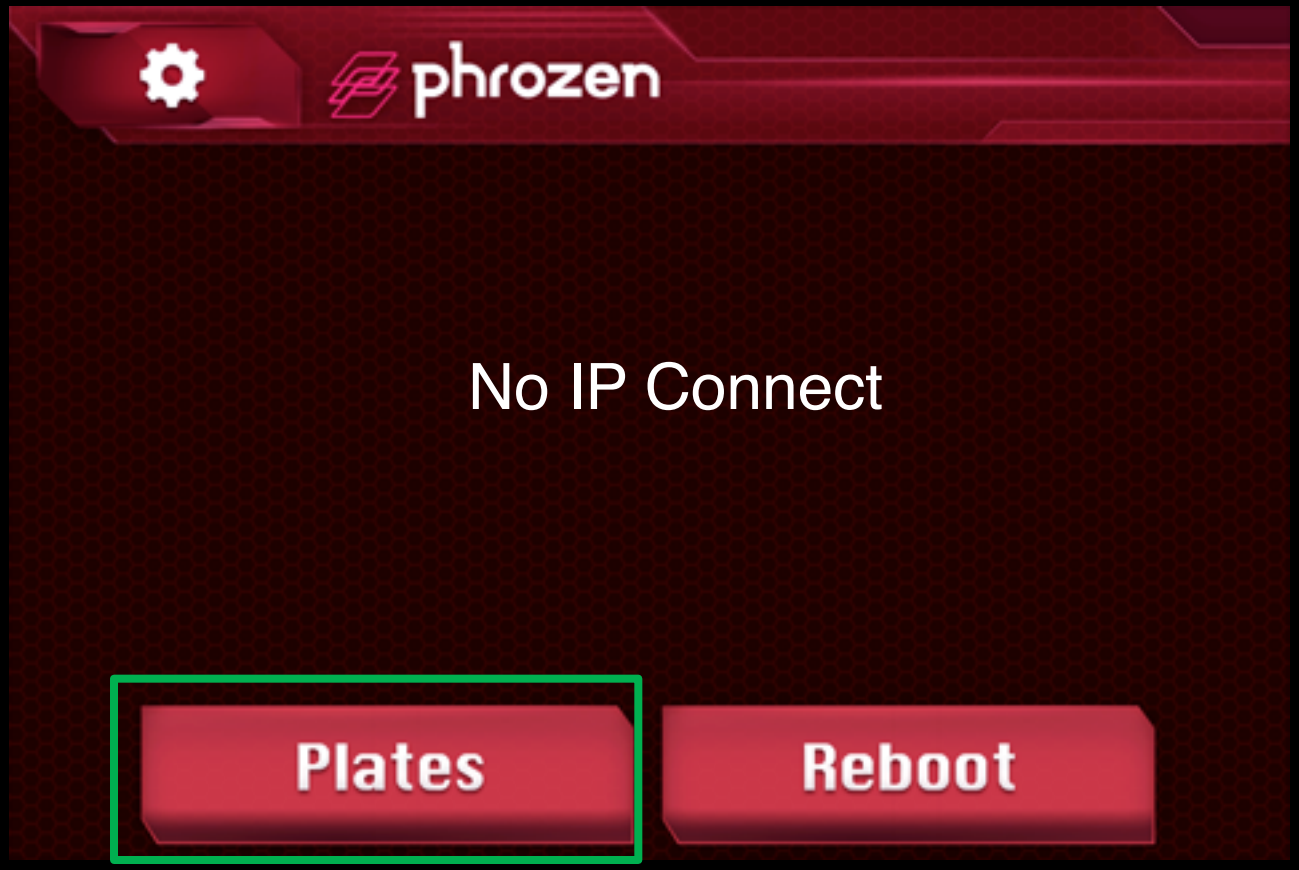
Check the follow and Press Next



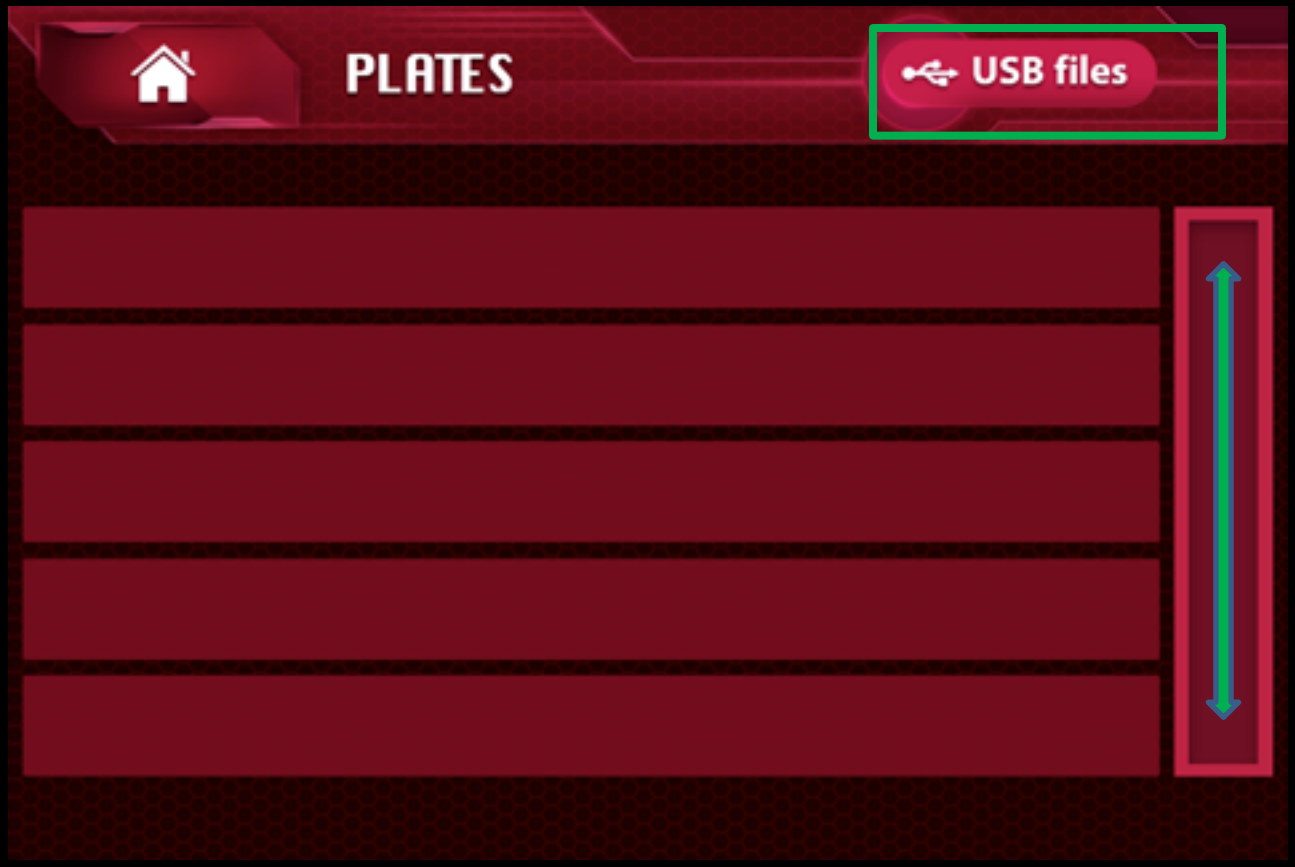
Done


Z-Axis Calibration
Lock the four screws
Complete the platform calibration
2/2
OK »

1.3 Home page-Lets Print

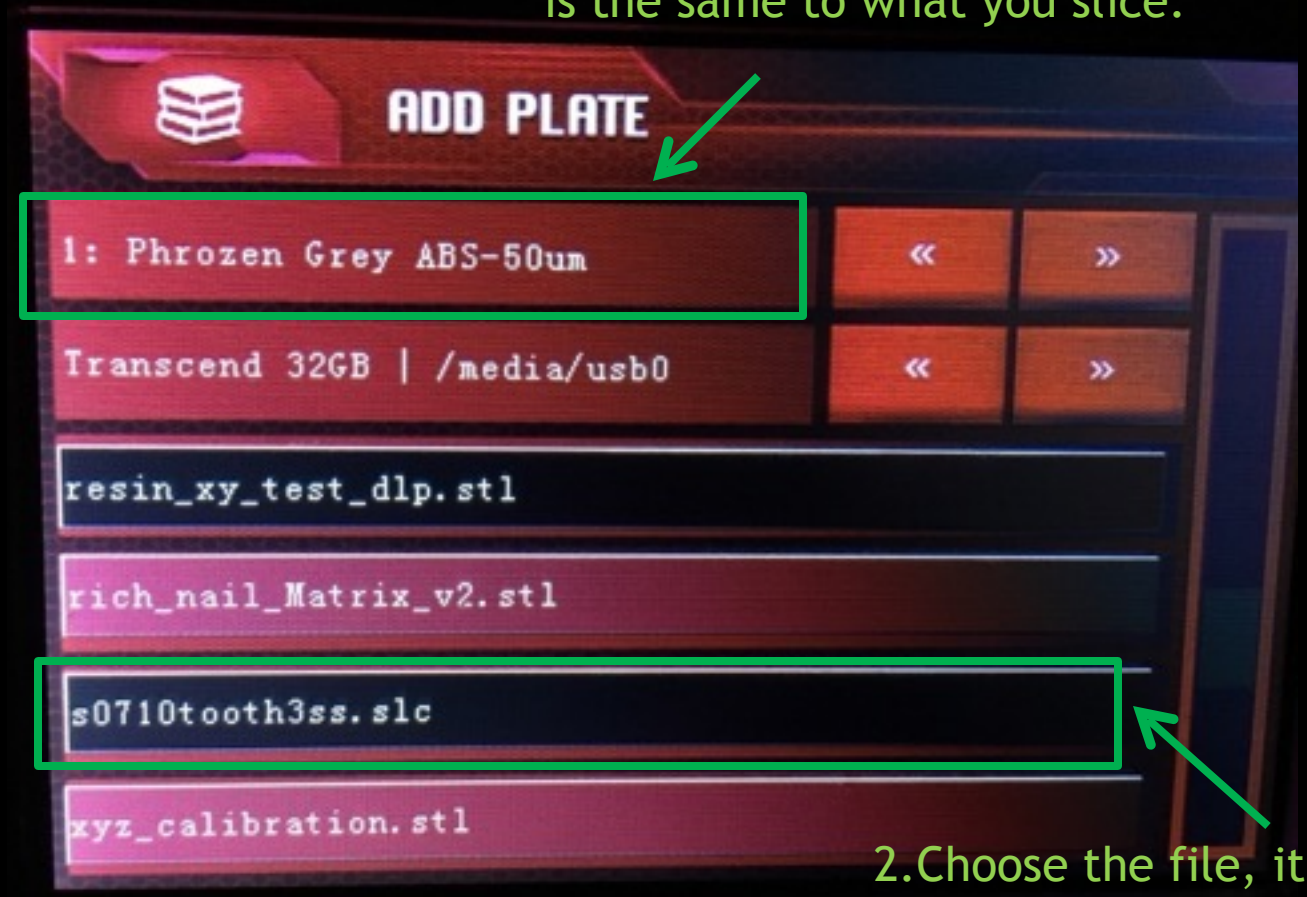


1.4 Print Plates



1.5 Add File from USB

1.Choose the resin profile you want.
If use SLC or ZIP file, please make sure layer thickness is the same to what you slice.



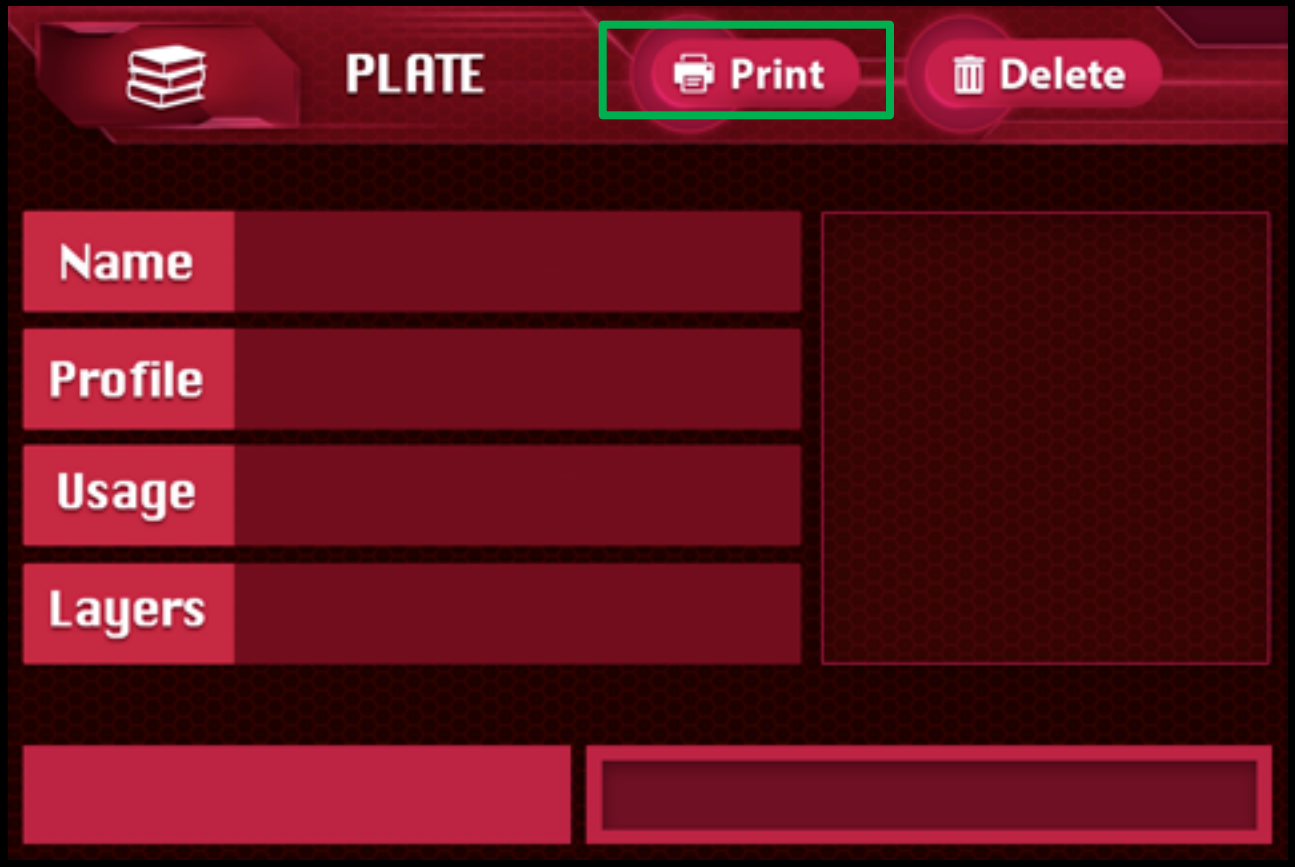
2.Choose the file, it support STL (under 100MB)

SLC (No Limit)

File Upload
Upload Com s0710tooth3ss.slc
profile: Phrozen Grey ABS-50u
path: /media/usb0
OK

PLATES
USB files
1. s0710tooth3ss.slc
2. s0710tooth3ss.slc

1.6 Press “Print”to start

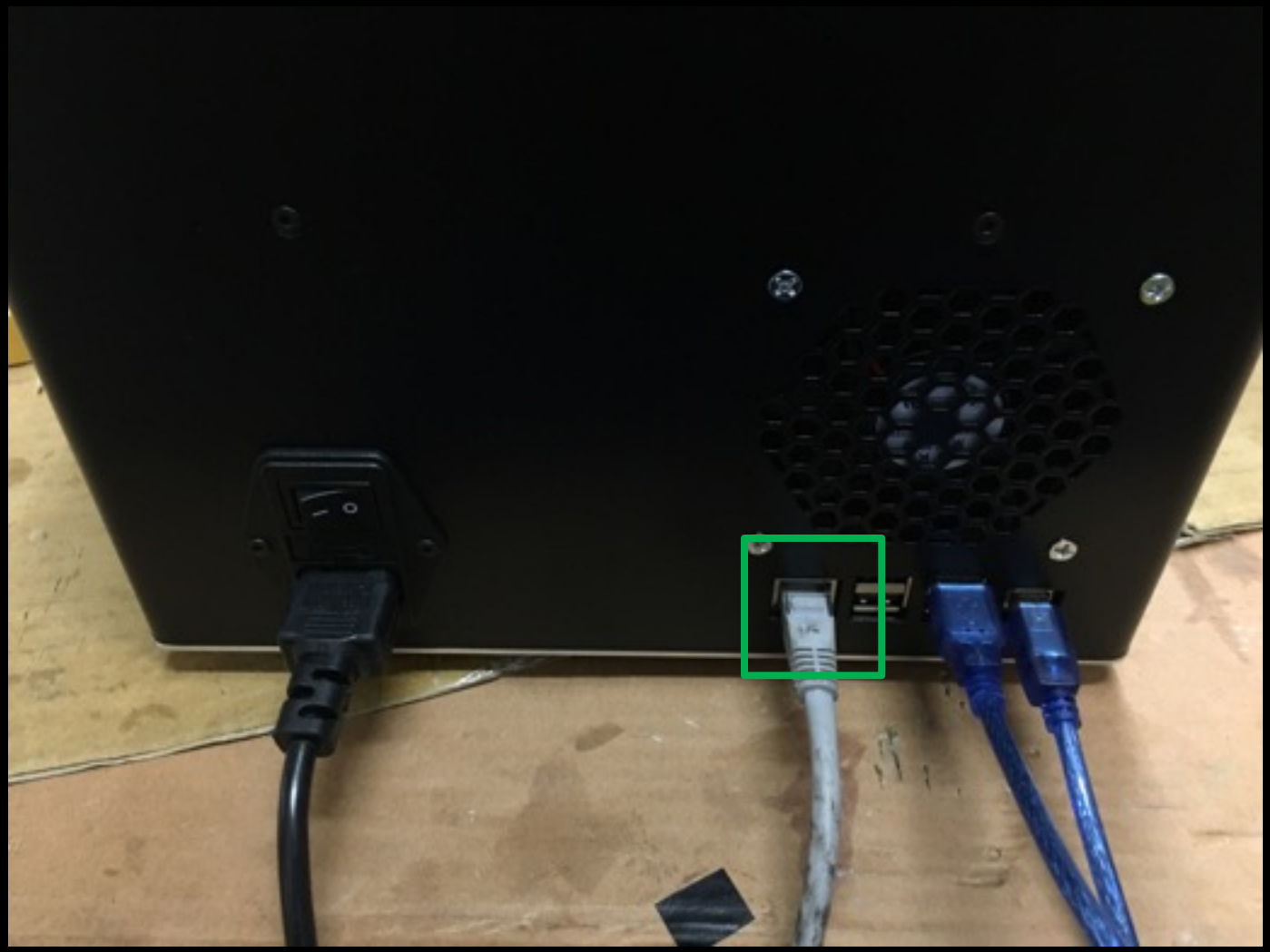


1.7 If want to Stop or Pause

1. “Pause Print” means Z-axis will not move and stop everything
2. “Stop Print” means Z-axis will move up to Z200 and stop everything

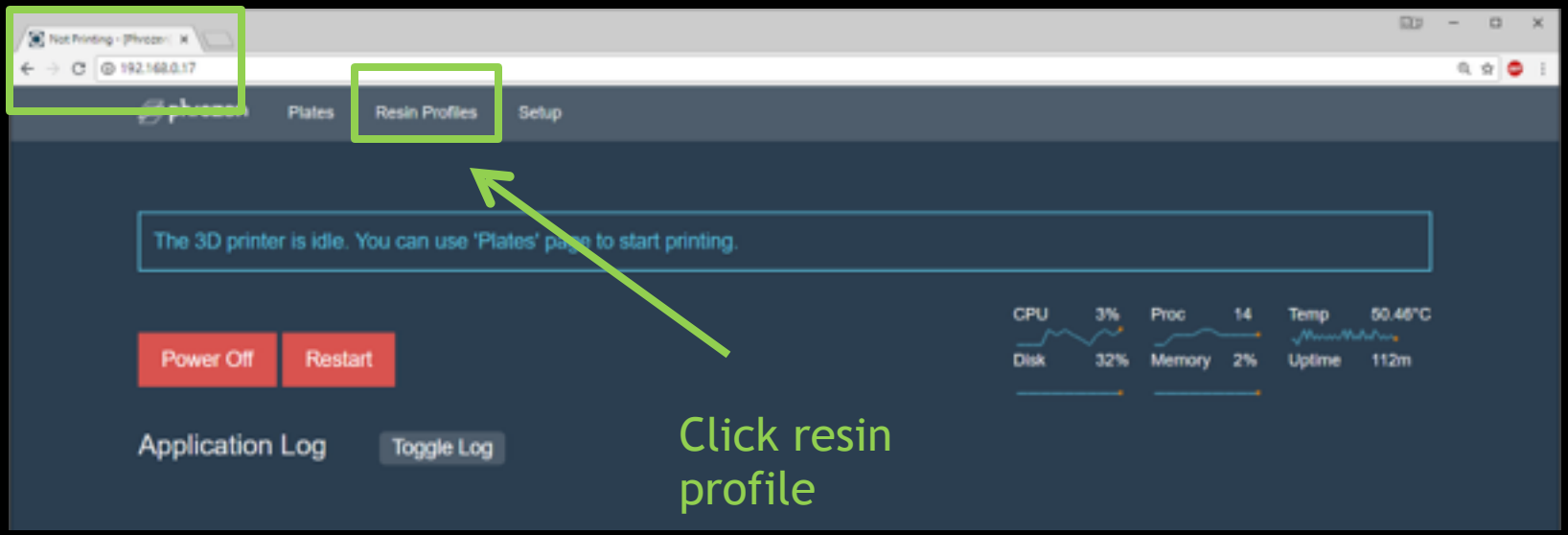
Resin Profile Change

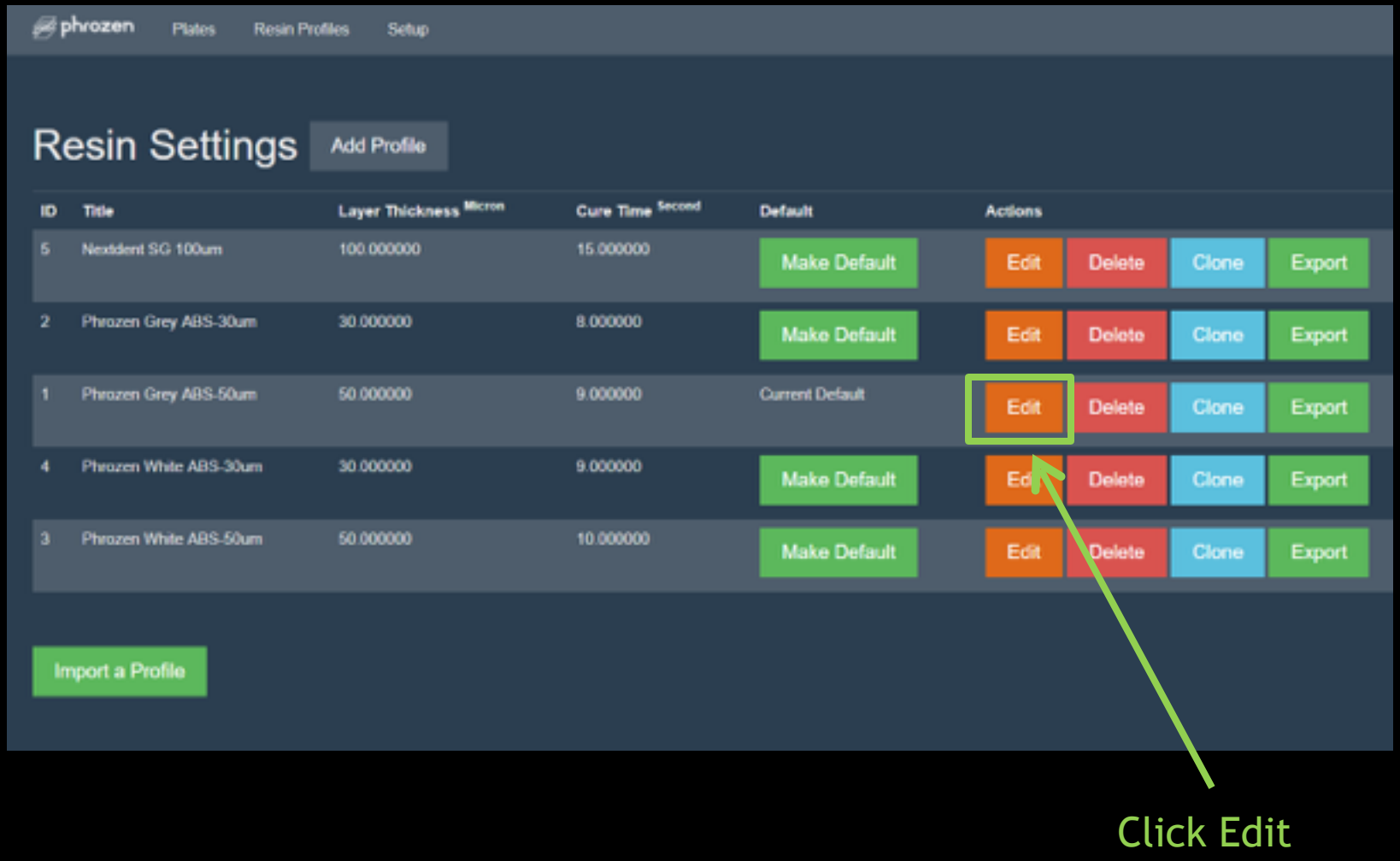
2.1 Connect LAN wire and LAN router



2.2 Open google chrome

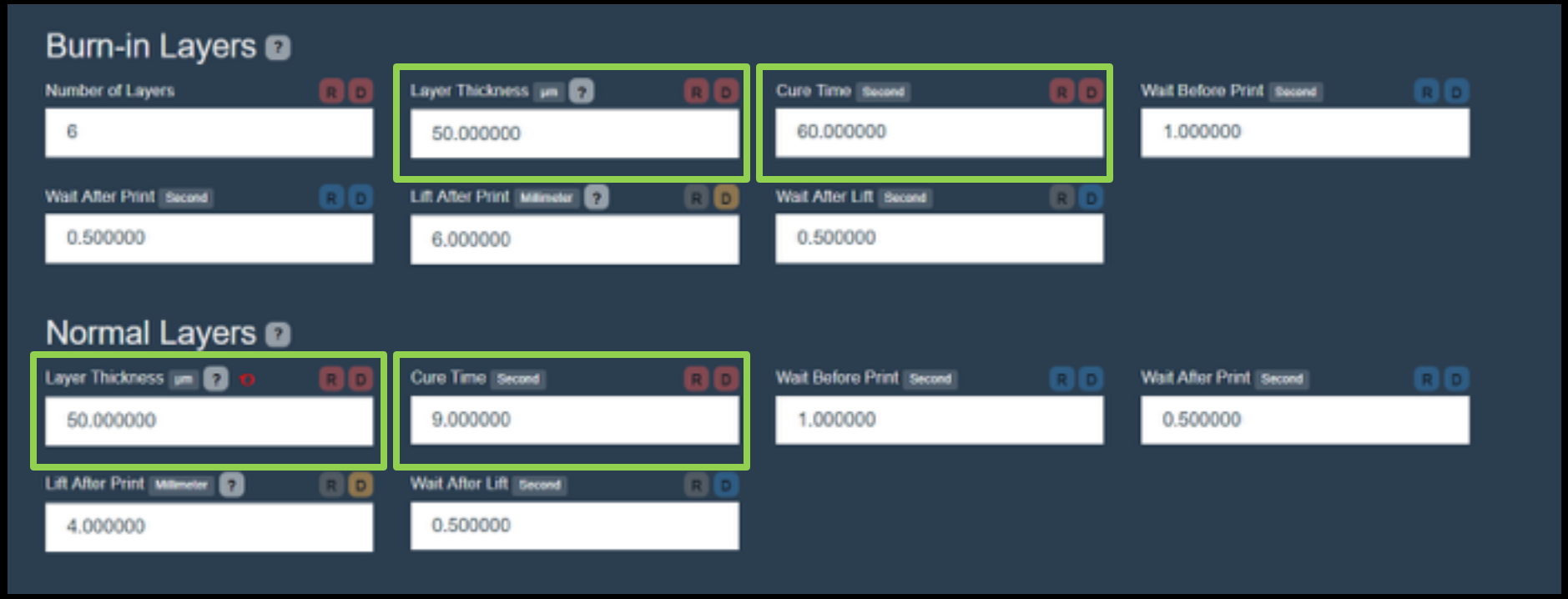
2.3 key in the IP (Make sure you are in the same network)




phrozen
Plates
Resin Profiles
Setup
Resin Settings
Add Profile
ID
Title
Layer Thickness Micron
Cure Time Second
Default
Actions
5
Nextdent SG 100um
100.000000
15.000000
Make Default
Edit
Delete
Clone
Export
2
Phrozen Grey ABS-30um
30.000000
8.000000
Make Default
Edit
Delete
Clone
Export
1
Phrozen Grey ABS-50um
50.000000
9.000000
Current Default
Edit
Delete
Clone
Export
4
Phrozen White ABS-30um
30.000000
9.000000
Make Default
Edit
Delete
Clone
Export
3
Phrozen White ABS-50um
50.000000
10.000000
Make Default
Edit
Delete
Clone
Export
Import a Profile

Click Edit

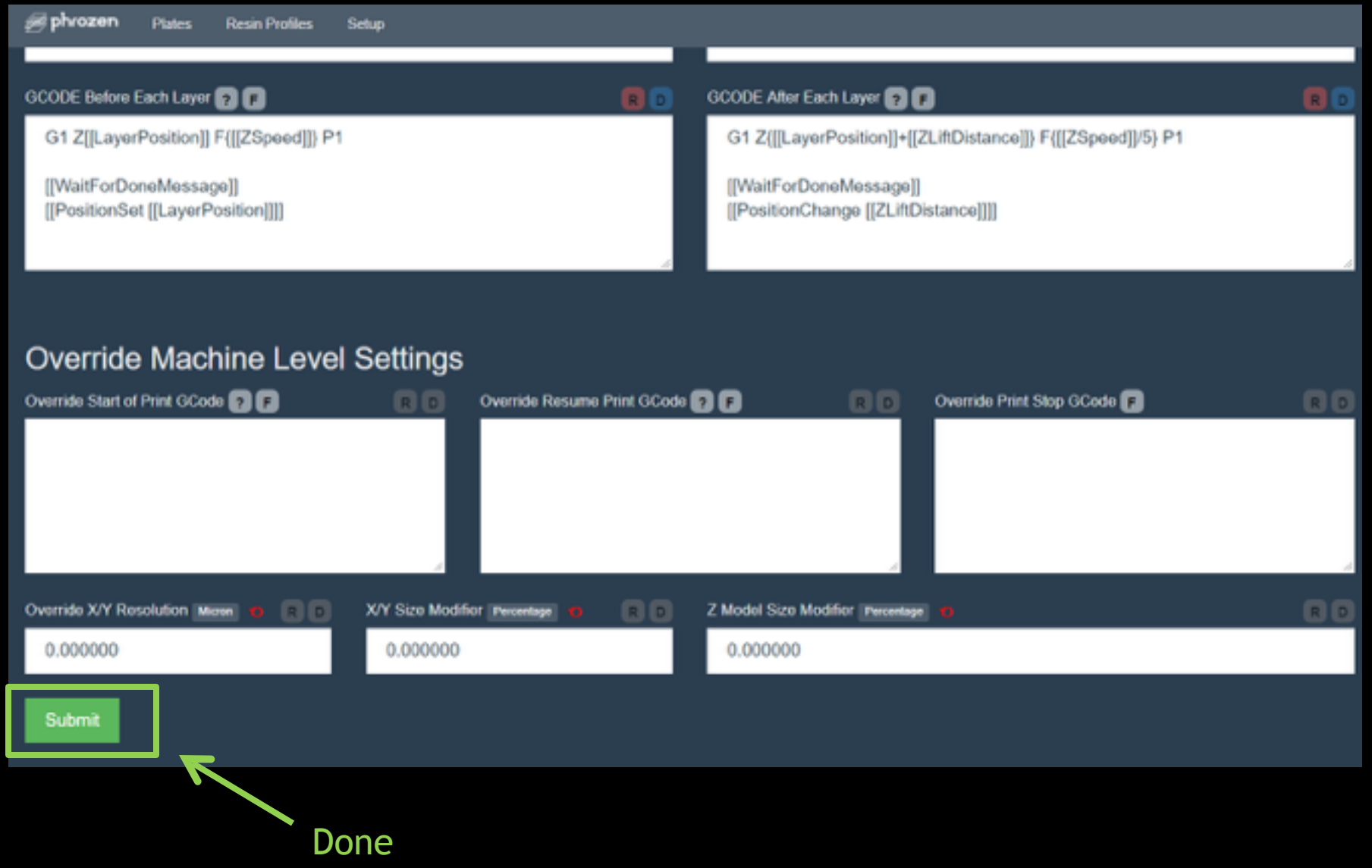
2.4 Cure time and Thickness Setup



2.5 Motor Speed Setup

The speed is for Normal Layer

The speed is for Burn-in Layer


phrozen
Plates
Resin Profiles
Setup
GCODE Before Each Layer
G1 Z[[LayerPosition]] F{[[ZSpeed]]} P1
[[WaitForDoneMessage]]
[[PositionSet [[LayerPosition]]]]
GCODE After Each Layer
G1 Z{[[LayerPosition]]+[[ZLiftDistance]]} F{[[ZSpeed]]/5} P1
[[WaitForDoneMessage]]
[[PositionChange [[ZLiftDistance]]]]
Override Machine Level Settings
Override Start of Print GCode
Override Resume Print GCode
Override Print Stop GCode
Override X/Y Resolution
Micron
0.000000
X/Y Size Modifier
Percentage
0.000000
Z Model Size Modifier
Percentage
0.000000
Submit
Done

SLC Slicer

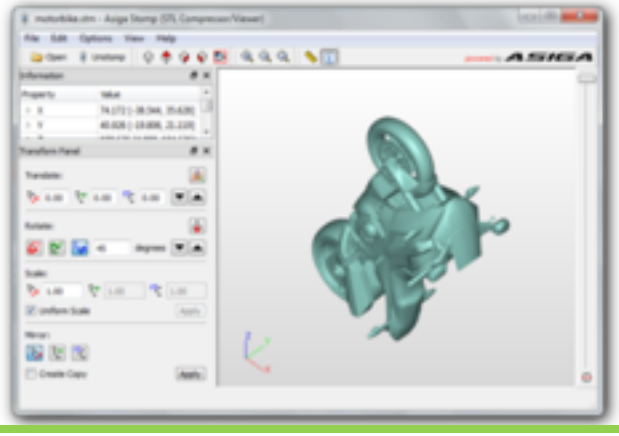
3.1 Download Stomp Slicer

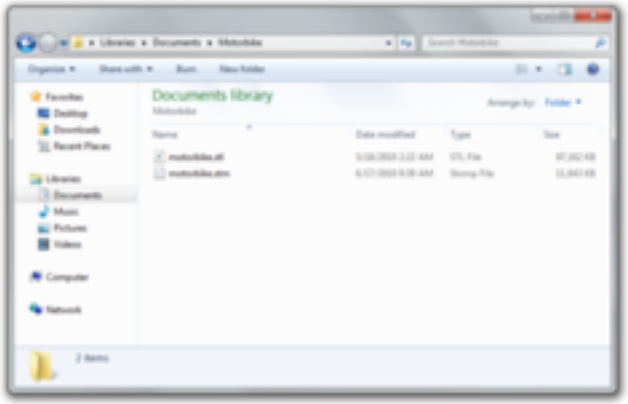
https://www.asiga.com/products/software/

Composer | QuoteServer | Stomp | Sleece

Stomp

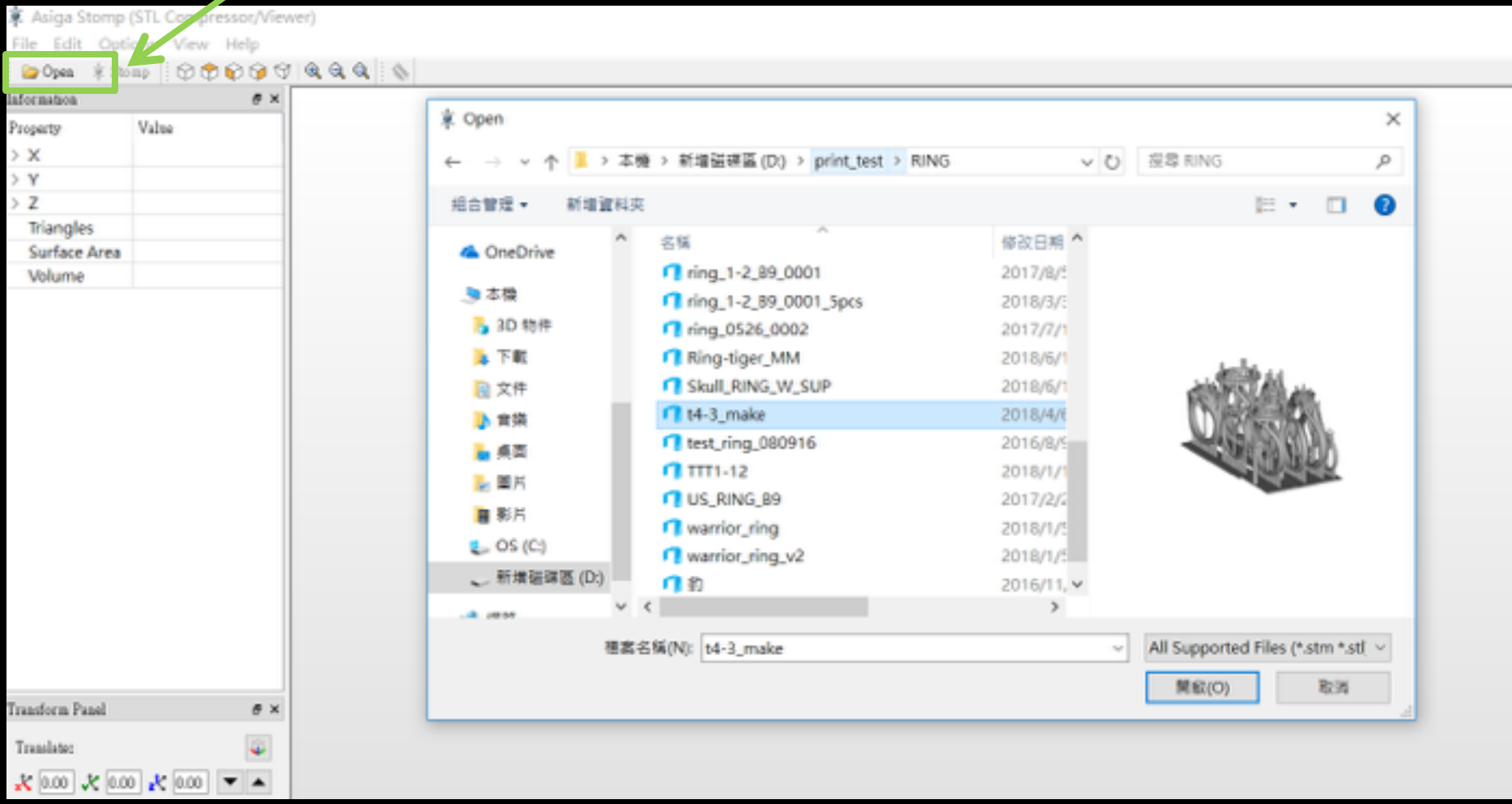
Stomp is a powerful STL compression package, compressing STLs down to 20% of their original size. You can also assess, view, rotate and mirror STL files easily and intuitively.

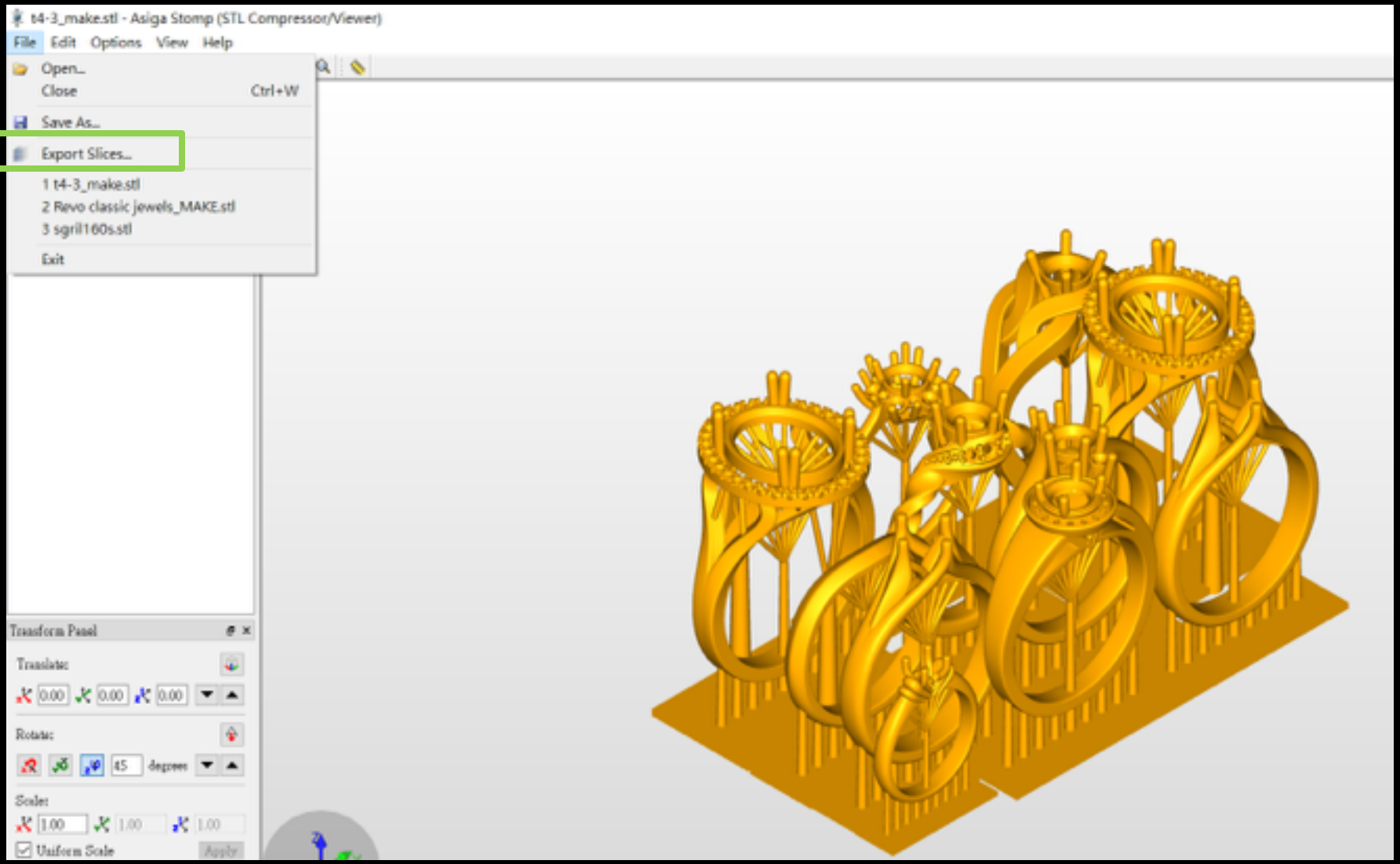
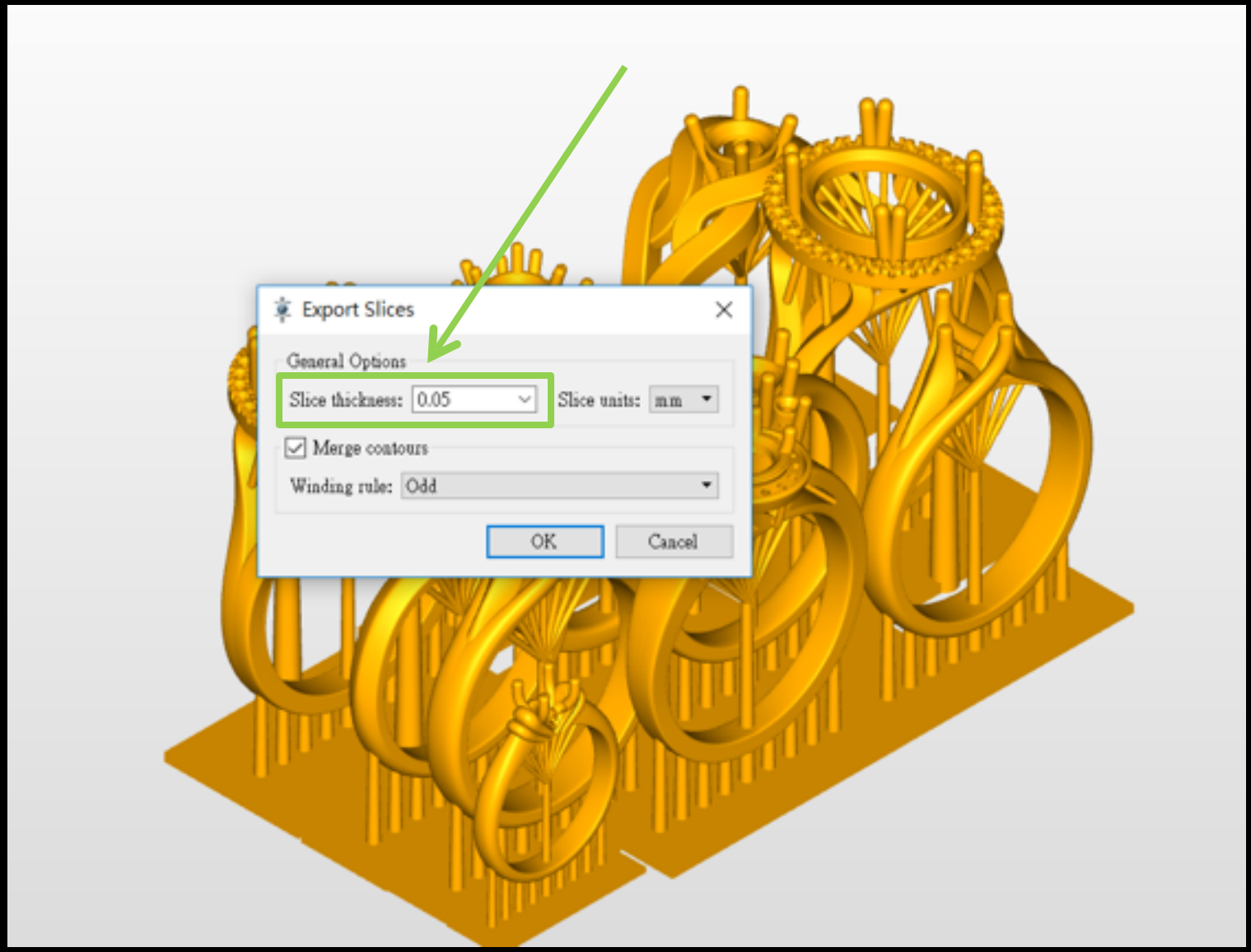




FREE! Download NOW for

Windows (32-bit) stomp-1.0.7-win32.exe	13.9 MB
Windows (64-bit) stomp-1.0.7-win64.exe	14.4 MB
Mac OS X (64-bit) stomp-1.0.7-x86_64.dmg	19.0 MB


Open STL
Asiga Stomp (STL Compressor/Viewer)
File Edit Options View Help
Open
Stomp
Information
Property
Value
X
Y
Z
Triangles
Surface Area
Volume
Transform Panel
Translate:
0.00
0.00
0.00
Open
本機 > 新增磁碟區 (D:) > print_test > RING
搜尋 RING
組合管理
新增資料夾
OneDrive
本機
3D 物件
下載
文件
音樂
桌面
圖片
影片
OS (C:)
新增磁碟區 (D:)
名稱
修改日期
ring_1-2_89_0001
ring_1-2_89_0001_5pcs
ring_0526_0002
Ring-tiger_MM
Skull_RING_W_SUP
t4-3_make
test_ring_080916
TTT1-12
US_RING_89
warrior_ring
warrior_ring_v2
豹
檔案名稱(N): t4-3_make
All Supported Files (*.stm *.stl
開啟(O)
取消


t4-3_make.stl - Asiga Stomp (STL Compressor/Viewer)
File
Edit
Options
View
Help
Open...
Close
Ctrl+W
Save As...
Export Slices...
1 t4-3_make.stl
2 Revo classic jewels_MAKE.stl
3 sgril160s.stl
Exit
Transform Panel
Translate:
0.00
0.00
0.00
Rotate:
45
degree
Scale:
1.00
1.00
1.00
Uniform Scale
Apply

Choose layer thickness - Done