



FlashDLPrint Help

Contents

This document is only applicable to Flashforge slicing software FlashDLPrint

Catalog

1. Software Introduction.....	1
2. Software-applicable Printer:	1
2.1 Software Acquisition.....	1
2.2 Software Installation and Start-up.....	1
3. Exploring FlashDLPrint.....	2
3.1 Machine Type Selection.....	2
3.2 FlashDLPrint Menus.....	2
3.3 Icon Explanation.....	3
3.3.1 Loading.....	3
3.3.2 Views.....	4
3.3.3 Move.....	5
3.3.4 Rotate.....	5
3.3.5 Scale.....	6
3.3.6 Cut.....	6
3.3.7 Supports.....	8
3.3.8 Print:	12
3.4 Layered Preview.....	15
3.5 File Menus.....	16
3.6 Edit Menus.....	18
3.7 Print Menus.....	22
3.7.1 Connect Machine.....	22
3.7.2 Disconnect.....	25

Catalog

3.8 View Menus.....	25
3.9 Help Menus.....	25
4. Print Operation.....	27
4.1 Generating the sliced file.....	27
4.2 Methods of printing.....	28
5. Help and Support.....	30

Software-applicable Printer

1. Software Introduction

There are three type printers:

Flashforge Hunter/ Flashforge Foto/Flashforge Focus

2. Software-applicable Printer:

2.1 Software Acquisition

● Method 1

To get the installation package from the USB stick in the toolkit.As shown in Figure 1.

 FlashDLPrint_2.2.1_...	16,362,506	16,362,506	WinRAR ZIP 压缩文件	2022/1/12 14:43
 FlashDLPrint_2.2.1_...	21,319,047	21,319,047	WinRAR ZIP 压缩文件	2022/1/12 14:43

Figure 1 Software installation package

● Method 2

Open the link below to download the installation package:

<https://www.flashforge.com/>

Support---Download Center---Flash DLPrint Download---Choose the software version---Download

2.2 Software Installation and Start-up

1. Decompress the zipped file or start the installation program, and then install the software according to the prompts.
2. Start the software with the start menu shortcut or by clicking the software icon.As shown in Figure 2.



Figure 2 FlashDLPrint Software icon

3. Exploring FlashDLPrint

3.1 Machine Type Selection

After starting FlashDLPrint, you need to select the target machine type first.

When you start FlashDLPrint a dialog box will pop up. Just need to select printer type in the machine type list and click [OK]. You can also change the machine type via clicking [Print]--[Machine type].As shown in Figure 3.

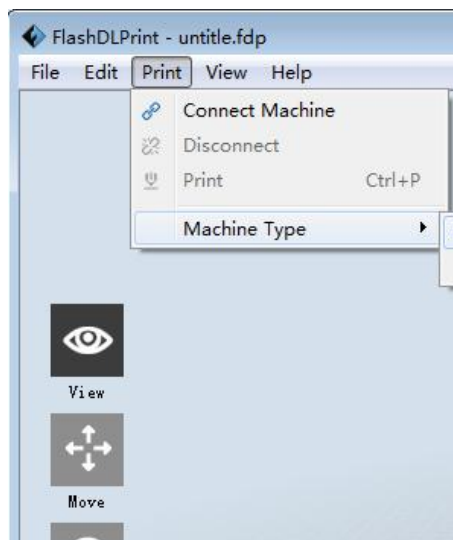


Figure 3 Model selection interface

3.2 FlashDLPrint Menus

The main interface consists of menu bar, icon bar, build platform, machine state and tiered preview bar.As shown in Figure 4.

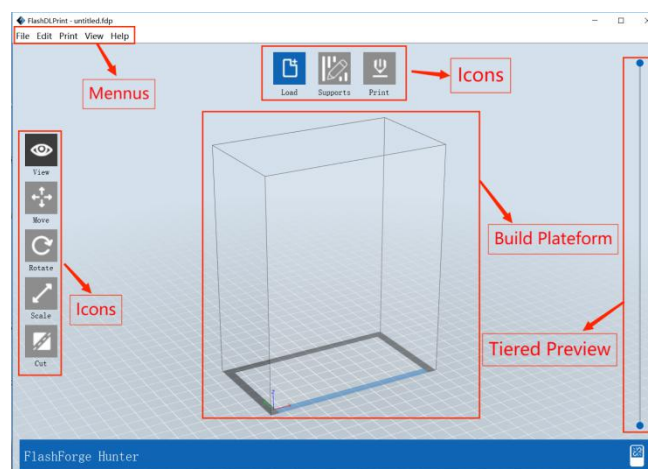










Figure 4 Software main interface

Exploring FlashDLPrint

3.3 Icon Explanation

	Load files;
	Enter the support edit mode;
	Print: Set print parameters, output print files.
	View FlashDLPrint home screen from one of six viewing angles;
	Move model around on XY-axis; shift+click to move along Z axis;
	Turn and rotate your model;
	Scaling the size of your object;
	Cut the model into several parts.

3.3.1 Loading

You can load a model file or Code file into your FlashDLPrint by the following six methods:

- Method 1: Click the Load icon on the main interface. Then select the object file.
- Method 2: Select the file for loading and drag the file to the main interface of the software.
- Method 3: Click [File]--[Load File]. Then select the object file for loading.
- Method 4: Click [File]--[Examples] to load the example files
- Method 5: Click [File]--[Recent Files] to load the files opened recently.
- Method 6: Select and drag the target file to the icon of FlashDLPrint.

Exploring FlashDLPrint

Note: 3MF/STL/OBJ/FDP, ways to store 3D models, are supported by FlashDLPrint for editing.

3.3.2 Views

① Changing views

Change model views by moving, rotating, scaling.

a. Drag:

Click the [View] icon and then you can move the object by the following three methods:

- Method 1: Hold down the left mouse button and drag.
- Method 2: Hold down the mouse wheel and scroll up and down.
- Method 3: Hold down the Shift key, hold down the right mouse button and drag.

b. Rotate:

Click the [View] icon and then you can rotate the object by the following two methods:

- Method 1. Hold down the right mouse button and drag.
- Method 2. Hold down the Shift key, hold down the left mouse button and drag.

c. Scale

Rotate the mouse wheel to enlarge or shrink the build plate.

② Set View

Allow users to view the object on the build plate. Six views are under the view menu, that is, bottom view, top view, front view, back view, left view and right view.

- Method 1: Click the [View] button, there are six views in the drop-down list.
- Method 2: Click the [View] icon on the left, click it again and a sub menu will appear with six views for selecting.

③ Reset View

Allow users to reset views by the following two methods:

- Method 1: Click the [View] menu and select [Home View]

Exploring FlashDLPrint

- Method 2: Click the [View] button on the left, click it again and you will see the viewing options, you can click [Reset].

④ Show Model Outline

Click [View]--[Show Model Outline], it will highlight the yellow border of the object

⑤ Show Steep Overhang

Click [View]--[Show Steep Overhang]. When the intersection angle between the model surface and horizontal line is within the overhang threshold value, the surface has steep overhang and it becomes red in the software. Overhang threshold value could be set as needed. The default value is 45 degree.

3.3.3 Move

Select the object and move the object by the following two methods:

- Method 1: Click the [Move] icon on the left. Long press the left mouse button and drag to adjust the location of the model in XY direction. Long press the Shift key and the left mouse button, drag to adjust the location of the model in Z direction. The distance and the direction of the movement shall be displayed.
- Method 2: Click the [Move] button on the left and then enter the distance value. Click [Reset] to reset distance values.

For many models, hold on Ctrl+A, select all models, and click [On Platform], then take the bottom model as the reference and put it on the bottom plate; Click [On Platform Separately], then all models are placed on the bottom plate.

Note: Users shall click [Center] and [On Platform] after the location adjustment to ensure the model(s) be within the build area and on the build platform. If a specified position is needed, only click [On Platform].

3.3.4 Rotate

Select the target object and rotate the object by the following two methods:

- Method 1: Click the [Rotate] icon on the left and three mutually perpendicular

Exploring FlashDLPrint

rings appear around the object. Click one ring and rotate on the present axis, you will see the rotation angle and direction in the center of circle. In this way, you could make the model rotate on X/Y/Z axis.

- Method 2: Click the [Rotate] icon on the left, and then enter into rotating angel values in X/Y/Z axes positioning. Click [Reset] to reset rotating angel values.

For many models, you can choose to rotate each model individually.

3.3.5 Scale

Select the target object and scale the object by the following two methods:

- Method 1: Click the [Scale] icon on the left, hold down the left mouse button and scale the model. The corresponding values will display near the object.
- Method 2: Click the [Scale] icon on the left and then enter into scale values in X/Y/Z axes positioning. Click the [Maximum] button to get largest size possible for building. Click [Reset] to reset the size of model.

Note: If the [Uniform Scaling] radio button is clicked, it will scale the model in equal proportion when changing value in any positioning of the model. Otherwise it will only change the value of the corresponding positioning.

3.3.6 Cut

Left-click on the model to select it and double-click on the [Cut] icon to set the cut plane. The direction and position are available for setting.

① **Draw with Mouse:** As shown in Figure 5.

Draw the cutting line according to the user's requirements, and the system will automatically generate the cutting surface. Rotate the viewing angle and you can see the cutting surface.

Exploring FlashDLPrint

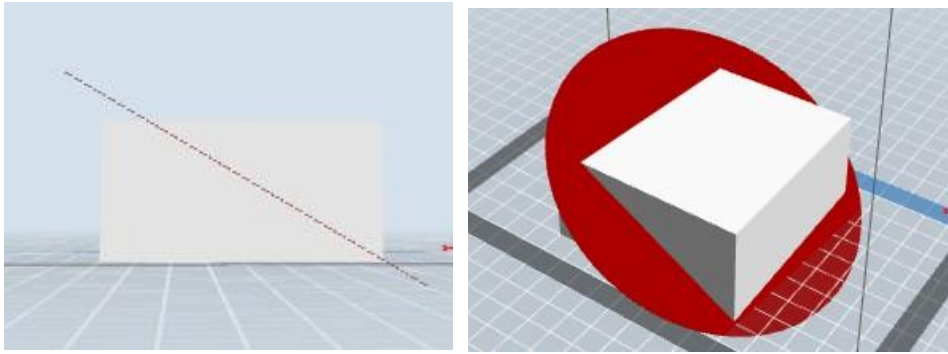


Figure 5 Mouse drawn cutting interface

② **X Plane**:As shown in Figure 6.

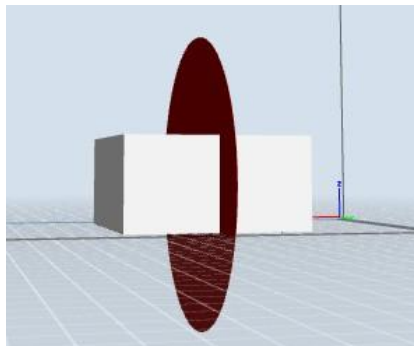


Figure 6 X plane cutting interface

③ **Y Plane**:As shown in Figure 7.

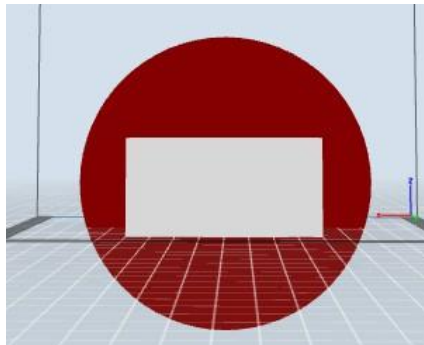


Figure 7 Y plane cutting interface

④ **Z Plane**:As shown in Figure 8.

Exploring FlashDLPrint

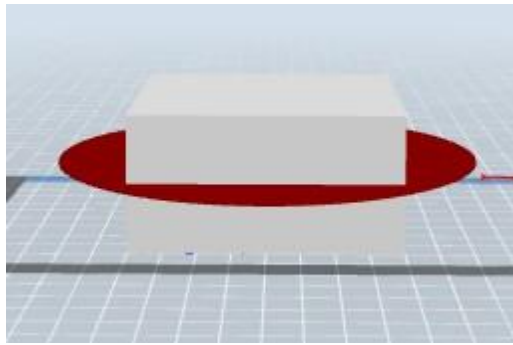


Figure 8 Z plane cutting interface

3.3.7 Supports

After loading the model, click [Edit]--[Supports] or click the Supports icon directly, then you will enter the support edit mode. Click [Back] to exit when you finish editing. As shown in Figure 9.

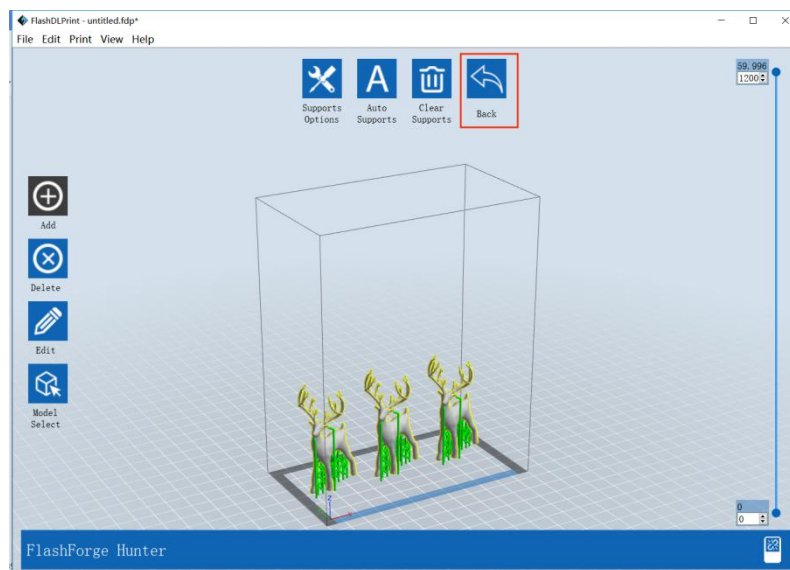


Figure 9 Support operation interface

① Supports Options

Click the [Supports Options] icon to pop up the supports options box. The support type is only [Columnar] support. When selecting profile, some models have other options in addition to [General] options. You can also customize the support parameters and save them as fixed configurations.

When the mouse moves over the parameter option name and hovers, corresponding

Exploring FlashDLPrint

comments will appear for users to understand.

A. General setting:As shown in Figure 10.

- Overhang threshold: the default value is 15°, the highest value is 60°,the lowest value is 15°.
- Post space: this highest is 20.0 mm. The lowest is 1.0 mm
- Raise height: when adding supports, raise model up to certain distance, the lowest height is 0. The highest is 100 mm.
- Cross connection: cross connection between supports to increase supports intensity.
- Y-shaped connection: Y-shaped connection between supports to increase supports intensity, thus reducing inner support and save resin.
- Import:Support parameters can be imported into the support configuration file.
- Export:Support parameters can be exported and saved as a configuration file.

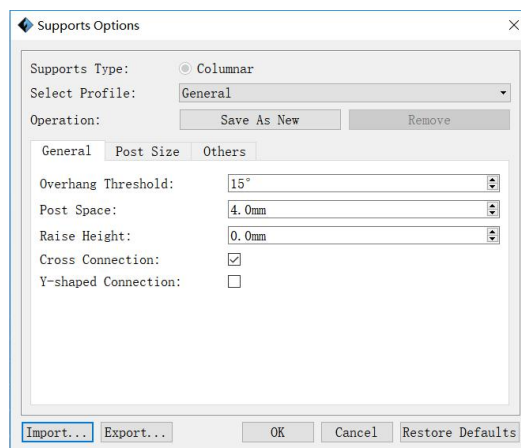


Figure 10 General setting interface

B.Post size setting:As shown in Figure 11.

- Tip diameter: supports tip diameter, the smallest is 0.25 mm, and the biggest is 2.00 mm.The setting parameter of the tip diameter cannot exceed the post diameter, otherwise it cannot be displayed.
- Tip Length:The length of tip slope.
- Post diameter: The larger the diameter of supports the stronger it will be, the more difficult to remove. The smallest is 0.25 mm, and the biggest is 2.00 mm.

Exploring FlashDLPrint

- Bottom Diameter: The smallest is 0.25 mm, and the biggest is 1.00 mm.
- Base Contact Number: The contact point numbers for inner support's bottom.
- Base diameter: the diameter of bottom post, the highest is 3 mm, the lowest is 0.25 mm.
- Base height: the height of the support at the bottom of the bold part, the highest height is 5 mm, the lowest height is 0.

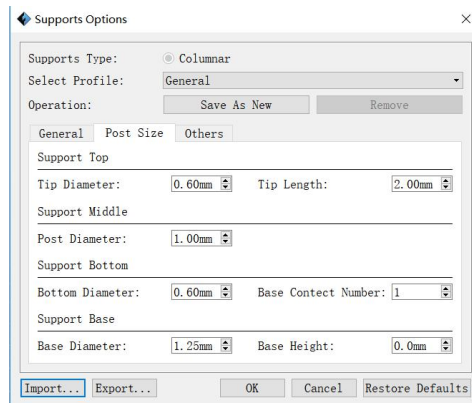


Figure 11 Pillar size interface

C.Other setting: As shown in Figure 12.

- Enable tip ball: tip ball will increase contact area between supports and models, the bigger the tip diameter is, the more solid the contacting with model will be, but more difficult to remove.
- Bottom support only: generate supports at the bottom of the model only.
- Bottom thickness: used to judge which part of the bottom needs generating supports. The thinnest is 0.1mm, the thickest is 150.0mm.
- Exterior only: generate supports which can contact with build plate only.

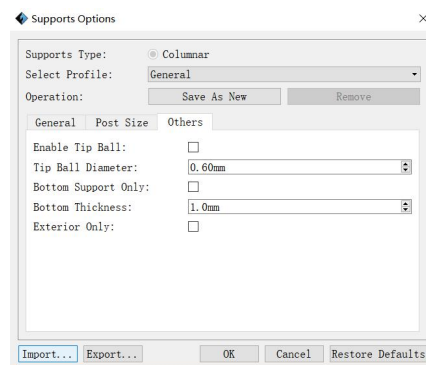


Figure 12 Other settings interface

Exploring FlashDLPrint

②Auto Support

Click [Auto Support], FlashDLPrint can automatically determine the position and number of support, and generate support. If model already has support created by FlashDLPrint, FlashDLPrint will delete the support first and generate new one.

If click automatic support again (whether modifying support parameter or not), and it will prompt whether to delete the previous support. If choose no, the support will be added on the original basis. As shown in Figure 13.

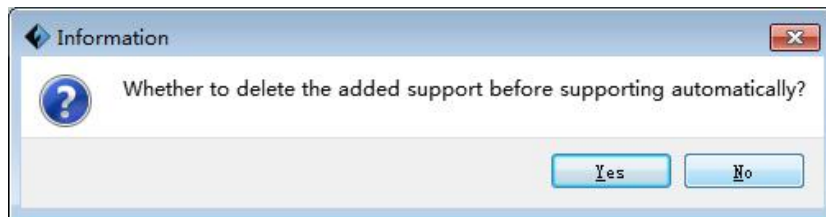


Figure 13 Support prompt interface

③Add

Manually add support. If the support is wrong with some error, it will be highlight in red; If the support is right, it will show green.

When added supports manually, horizontal connections are automatically added.

Drag the layered preview bar on the right to observe the support addition of each layer.

As shown in Figure 14.

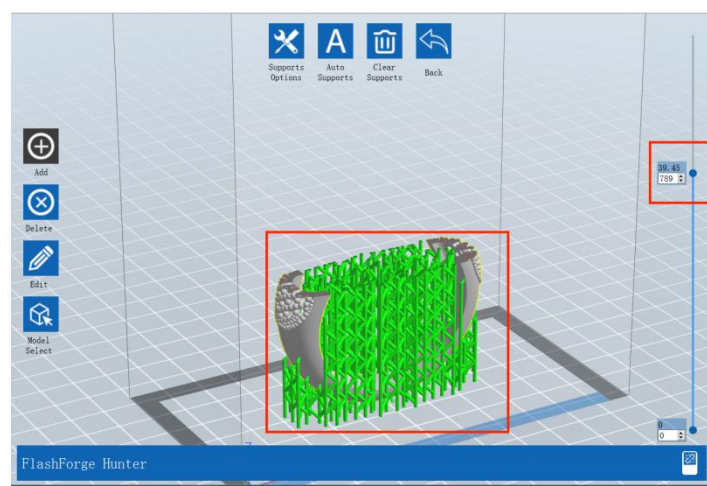


Figure 14 Layered preview support

Exploring FlashDLPrint

④ Delete

Manually add support. If the support is chosen, it will be highlight in blue.

⑤ Edit

Edit support. If the support is chosen, it will be highlight in blue.

Select the pillar part and drag it by long pressing the left mouse button to change the pillar position.

Select the tip part and drag it by long pressing the left mouse button to change the tip position.

⑥ Model Select

Choose one model to edit support.

⑦ Clear Support

Clear all the support.

3.3.8 Print:

As shown in Figure 15.

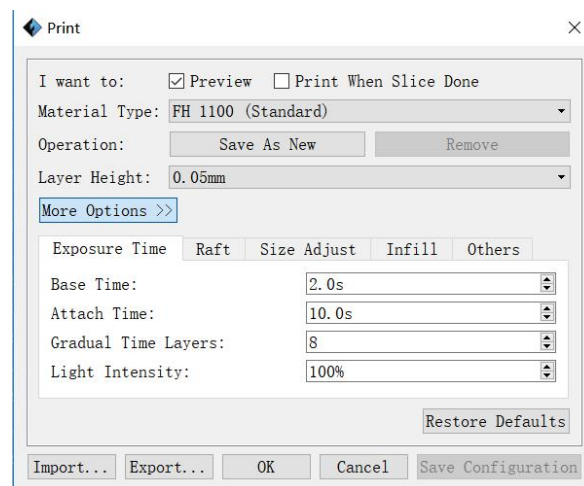


Figure 15 Print interface

① Preview:

Choose to enter preview interface or not.

If this option is checked, the print preview interface will be automatically entered after slicing. On the left side of the software, you can see the sliding bar of the

Exploring FlashDLPrint

number of model layers. You can control the number of display layers of the model by sliding up and down. The printing time of the model and the estimation of consumables can be seen in the upper right corner of the software. Click the [Print] button to start connecting the printer; Click the [Back] button to return to the main interface of the software.

② **Print when slice done:**

Print or not when slice done

- Material type: Choose according to the type of model
- Save as new: To custom the material type and remember this choice.
- Remove: Clear the custom material type.
- Layer height: To set the height of each layer while printing, the default value is 0.025 mm, optional values are 0.05 mm. Higher the value is, lower printing precision and higher speed the model has, and vice versa. Values can be selected from 0.01 mm to 0.2 mm

③ **Exposure time**

- Base Time: To set expose time to solidify a layer of photopolymer resin.
- Attach Time: To set the expose time that solidify the attached a layer of photopolymer resin.
- Gradual Time layers: The number of layers from the base plate time to the model forming time.
- Light intensity: According to the sensitivity of light to adjust the light intensity. (For some models, there is no [Light intensity] option.)

④ **Raft:**

Mode: You can set the Base plate mode, Bevel edge and Disable.

Shape: The shape of the base plate can be selected. Model projection is the projection shape of the model on the base plate.

Thickness: Thickness of base plate.

Margin: Width of base plate extending outward .

Exploring FlashDLPrint

⑤ Size adjust

- X adjust: According to the previous printing error to adjust the x-axis size.
- Y adjust: According to the previous printing error to adjust the x-axis size.
- Outline compensation: According to the size error of the previously printed model to adjust the overall size.

⑥ Infill

- Fill Density: Fill ratio.
- Shell Thickness: To set the shell thickness value between 1mm to 10mm.
- Infill Thickness: To set the infill thickness value between 0.5mm to 5mm.

⑦ Others

- Engrave model names on Raft: The name of the model appears on the raft when printed.
- Space between support and model: Set the space between support and model.

When the slicer is finished, three options will appear. As shown in Figure 15. Click [SVG option] can choose SVG render mode to select preview mode. As shown in Figure 16. When printing large models and complex models, it is convenient to preview rough images to reduce the burden on the computer CPU. This option does not affect the printing of the model.

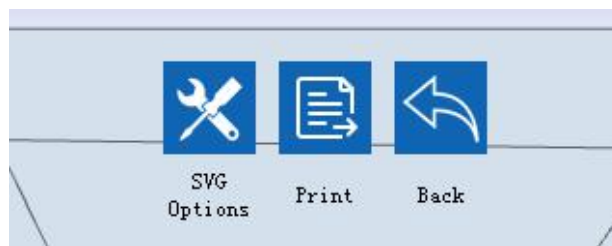


Figure 16 Interface after slicing

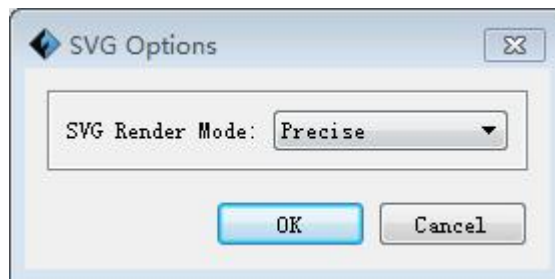


Figure 17 SVG option interface

Exploring FlashDLPrint

⑧Import

Import configuration files for print parameters from folders.

⑨Export

Export and save print parameters as a configuration file.

3.4 Layered Preview

There is a layered preview bar on the right side of the interface, which can view the section of the model at a certain layer, as shown in figures 18 and 19. The preview bar can be pulled from the top to the bottom or from the bottom to the top. The display numbers are: the number above is the height and the number below is the number of layers.

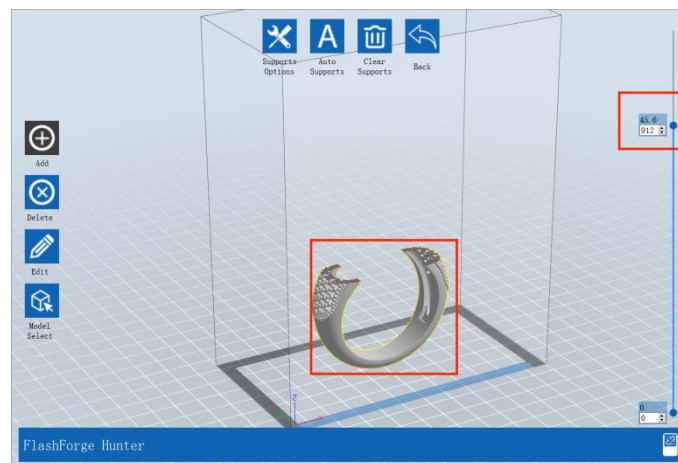


Figure 18 Start at the top

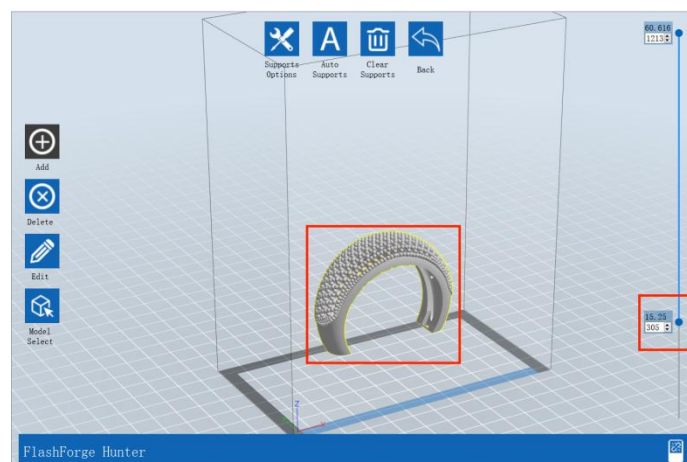


Figure 19 Start at the bottom

Exploring FlashDLPrint

3.5 File Menus

① New Project

Click [File]--[New Project] or use the shortcut key Ctrl + N, can build a blank project. If there is an unsaved modification on previous project, then it will inform you whether the modification needs to be saved or not. As shown in Figure 17. Click [Yes] will save the modification, while click [No] will abandon it. If click [Cancel] or close tool tip, then it will cancel the new project.

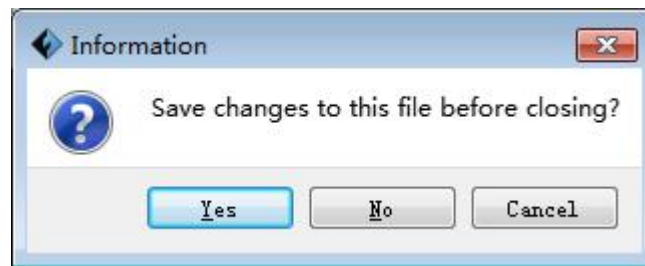


Figure 20 Save prompt interface

② Saving

After finishing the model edit and adjustment, there are two ways below to save all models in the scene.

- Method 1: Click [File]--[Save Project] in the menu bar or use the shortcut Ctrl+S to save the file as a project file with the “.fdp” suffix, all models in the scene (include support) are independent. After reloading the files, extruder configuration information and model position will be the same as the configuration during saving.
- Method 2: Click on [File]--[Save as...] to save the model as project file .fdp or .3mf and .stl and .obj. For .3mf, .stl and .obj, models are integrated as one (include support part). If load it again, only the position of the model was saved, not included the printing parameters. Click [File] - [Save As] - [Save All], and all models in the software will be saved as a file; Click [File] - [Save As] - [Save Selected] to save only the selected model.

Exploring FlashDLPrint

③ Preferences

Click [File]--[Preferences] in the menu bar, and there are [General] and [Print] options, As shown in Figure 21、22. You can select the interface language, font size, automatic layout newly-imported model, merge newly-important project file, print window type, and whether to check for updates at start up .

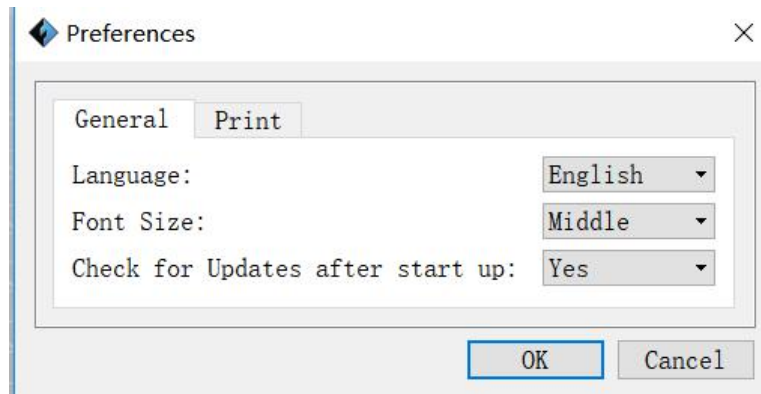


Figure 21 General preference setting interface

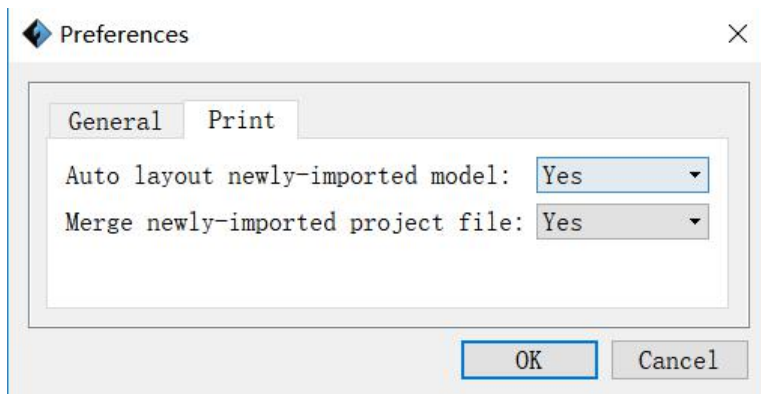


Figure 22 Print setting interface

- Language: The software supports several languages, namely, Chinese (simplified Chinese and traditional Chinese), English, French, Korean, Japanese and so on.
- Font Size: Set the font size.
- Check for Update after start up: It is used to preset if it is necessary to activate the online automatic update function, if choose yes, every time when you open software, it can online detect if it is a new version software, once new version found, it will reminds users to download and install new version firmware.
- Auto layout newly-imported model: Set Yes or No.

Exploring FlashDLPrint

- Merge newly-imported project file: When Yes is selected, the same software interface can import and display different FDP files at the same time.

④ File list

After clicking, file list window appears on the interface, and all models can be seen. After clicking the model, the corresponding file name of the model will be checked.

3.6 Edit Menus

① Undo

Allows users to undo the recent edits by the following two methods:

- Method 1: Click [Edit]--[Undo].
- Method 2: Press the shortcut Ctrl+Z.

② Redo

Allows users to redo the most recent edit you have undone to your model file by the following two methods:

- Method 1: Click [Edit]--[Redo]
- Method 2: Press the shortcut Ctrl+Y.

③ Empty Undo-stack

To clean up the recorded operating steps so as to release the memory.

④ Select All

By the following two methods, you could select all models in the scene. (When models are too small to be seen or out of viewing scope, please click [Center] and [Scale] buttons to adjust the model.)

- Method 1: Click [Edit]--[Select All].
- Method 2: Press the shortcut Ctrl+A.

⑤ Duplicate

Select the object and duplicate the object through the following two methods:

- Method 1: Click [Edit]--[Duplicate]
- Method 2: Press the shortcut Ctrl+V

Exploring FlashDLPrint

⑥ Delete

Select the object and delete the object through the following two methods:

- Method 1: Click [Edit]--[Delete]
- Method 2: Press the shortcut Delete

⑦ Auto Layout All

After importing one or more models,click [Edit]-[Auto Layout All],select placement rules and placement intervals. All models will be placed automatically according to the selected auto placement rules. The interface is shown in Figure 23.

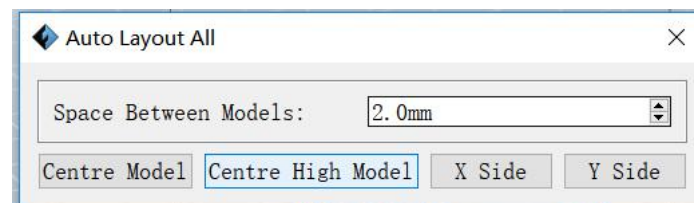


Figure 23 Auto Layout placement interface

- Centre Model:After selecting [Center Model] placement rule, the loaded model will be automatically placed according to the center model, as shown in Figure 24.

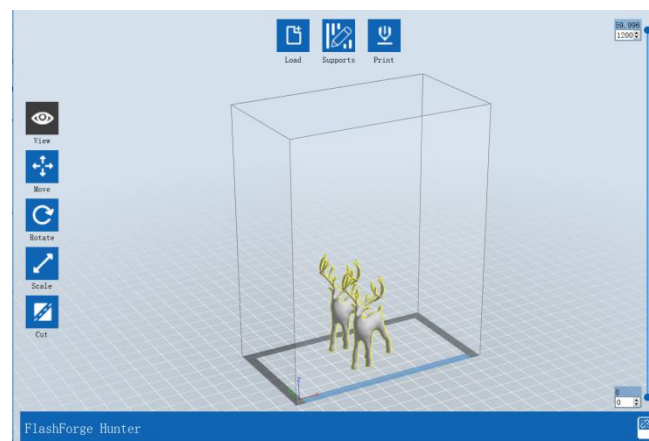


Figure 24 Centered Model

- Centered High Model:After selecting [Centered High model], the loaded model will be automatically placed according to the middle and higher model, as shown in Figure 25.

Exploring FlashDLPrint

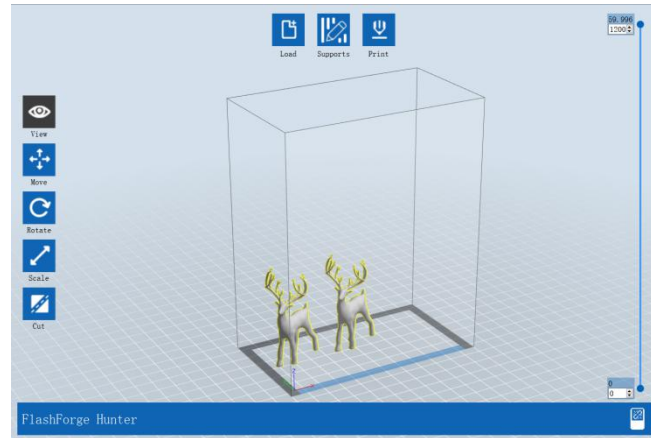


Figure 25 Centered High Model

- X Side : After selecting [X Side] placement rule, the loaded model is automatically placed close to the X-side, as shown in Figure 26.

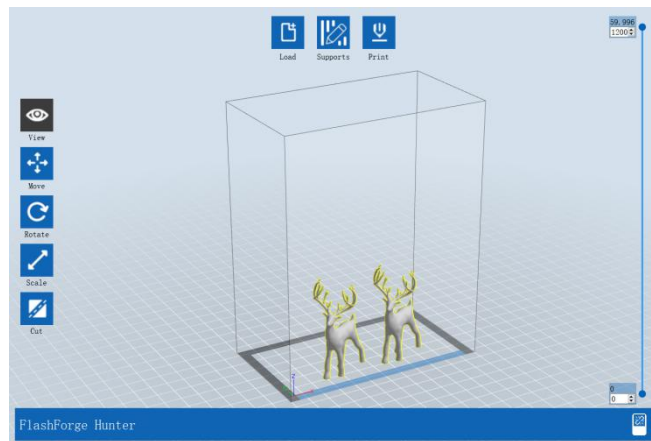


Figure 26 X Side

- Y Side : After selecting [Y Side] placement rule, the loaded model is automatically placed close to the Y-side, as shown in Figure 27.

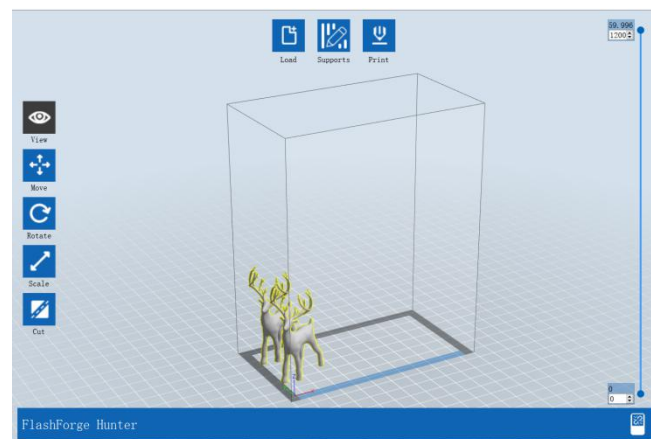


Figure 27 Y Side

Exploring FlashDLPrint

⑧ Mirror Models

You can flip the model mirror according to the X, Y and Z directions.

⑨ Repair Models

Click [Edit]--[Repair Models] to repair models.

⑩ Supports

Click [Edit]--[Supports] to enter supports setting interface.

⑪ Extrat shell

When selecting model, click [Edit]-[Extract shell] and set the extraction parameter ,
As shown in Figure 19.The precision refers to the roughness of the inner surface of the model. Then click [OK] and get a hollow model.

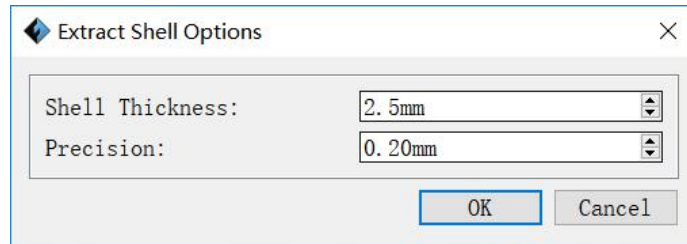


Figure 28 Shell drawing options interface

For big model, it recommend users to do [Extract shell] then add support to avoid interior collapse while printing.

⑫ Leading hole

Leading hole on model, uncured resin inside the hollow model can flow out through the holes.Click [Leading hole], enter the hole interface.As shown in Figure 29.

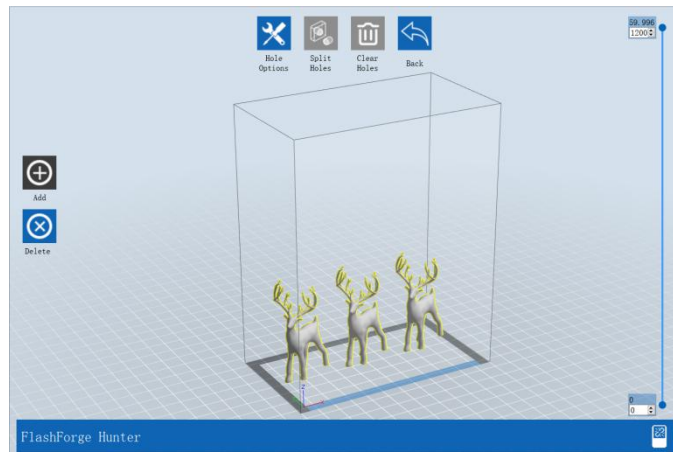


Figure 29 Punching interface

Exploring FlashDLPrint

Click [Hole option], you can set shape, hole diameter and depth,as shown in Figure 30.Change [Restrict hole direction] to help users to add holes in one specific direction.

Click [Add] to add holes to the model, which will be displayed in green. Click [Delete] to delete the added hole.



Figure 30 Punching options interface

After leading holes on model, click [Split Holes] to leave the part of holing as a model on the platform.Users can print them as plugs to fill back into the model.

Click [Clear Holes] and all the holes will be cleared.The holes will be displayed on the model as cylinders of the same shape. After slicing, the holes can be seen through the scroll bar on the left side.

3.7 Print Menus

3.7.1 Connect Machine

There are two ways to connect your computer to the printer: Ethernet or WiFi. (Some machine types do not have WiFi connection function. See the parameter introduction of each model for details).

Note: The machine icon on the bottom right displays the connection status: Connected Disconnected.

Connected: As shown in Figure 31.



Figure 31 Connection status interface

Exploring FlashDLPrint

Disconnected: As shown in Figure 32.



Figure 32 Interface of unconnected state

- Method 1: USB/Ethernet connection

A.First, connect the USB or Ethernet cable to the port in the rear of the printer;

B.Turn on your printer and start FlashDLPrint.

C.Press Info in System on the screen. There is an IP address in the about interface.

D.Click [Print] - [Connect] in the menu bar, as shown in Figure 33.In the pop-up connect machine dialog box, as shown in Figure 34.Select USB cable / Ethernet as the connection mode, input IP and port, such as 10.33.23.166, and the port is 8899.

E.Click Connect, and "Machine status: Ready" will be displayed at the bottom of the software interface. Prove that the connection is successful.

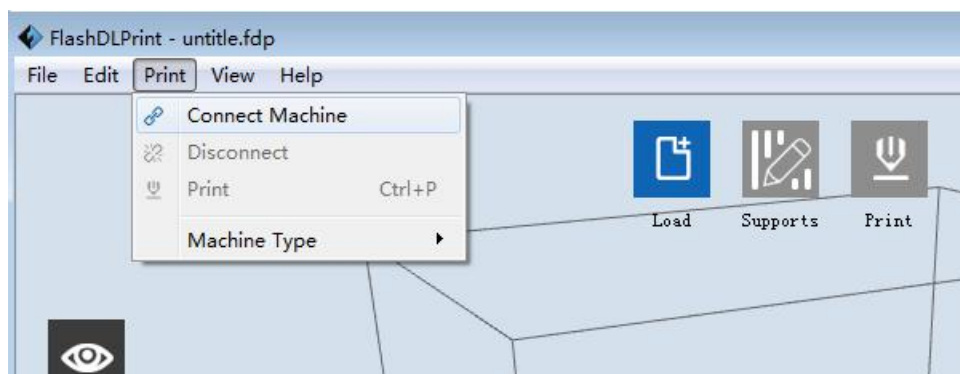


Figure 33 Connection interface

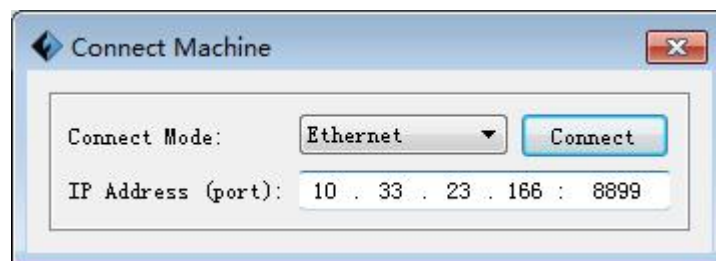


Figure 34 Ethernet connection machine interface

If the option of Flashforge Hunter or Foto 3D Printer is not found, click [Connect Machine] to obtain the option of this model, and then click [Connect] to connect the printer.

If this printer model still does not appear after re-scanning, it means that the driver of

Exploring FlashDLPrint

the software is not installed (normally, the driver will be installed automatically when the software is installed).If this happens, you will need to install the driver manually.

Read on: manually install the driver

The method of manually installing the driver is as follows:

Step 1: open the root directory of the software (such as C:\Program Files(x86)\Flash forge\ FlashDLPrint)

Step 2: open the driver folder in the root directory, find the driver software corresponding to the computer system, and click install.(there are two installation packages: dpinst_amd64.exe corresponds to 64-bit Windows system, dpinst_x86.exe corresponds to 32-bit Windows system, please choose according to your needs).

- Method 2: Connect Via WiFi (Some machine types do not have WiFi connection function. See the parameter introduction of each model for details)

1.Turn on printer.

2.Turn on Wi-Fi on the Hunter. Tap [Tools]-[Setting]-[WiFi]-[WiFi ON].

3.Connect Hunter with an available WiFi signal, which is also connected by your computer.

4.Click [Print]-[Connect Machine], it will pop up box, then select Wi-Fi in the Connect mode. Type in “192.168.191.2” and 8899 in IP address, click [Connect]. As shown in Figure 35, 36.

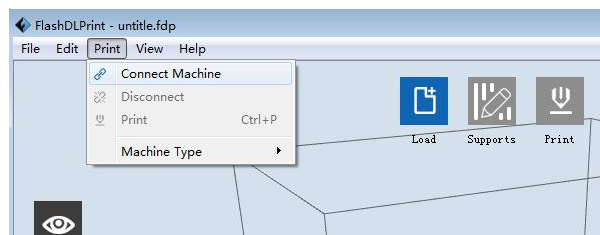


Figure 35 Connection interface

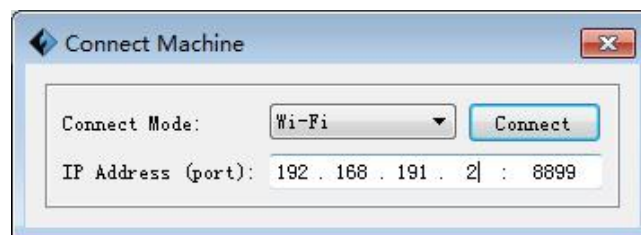


Figure 36 Wi-Fi connection machine interface

Exploring FlashDLPrint

Click [Connect]. If “Connected” is shown, it means connect successfully.

After using the above two methods to connect to the printer, you can directly transfer the sliced model files to the printer for printing.

3.7.2 Disconnect

Click [Print]--[Disconnect] to disconnect your PC and Hunter.

3.8 View Menus

① View

Select different views to convert the view angle of the interface.

② Show Model Outline

Click show model outline, and the border line will be displayed on the outside of the model.

③ Show steep overhang

After clicking, you can select whether to display the steep surface of the model, and you can select to display the steep surface of different angles by setting the steep threshold. This function can help judge whether to add support.

3.9 Help Menus

① First Run Wizard

Click [Help] - [First Run Wizard] in the menu bar to view the function introduction

② Help Contents:

Click [Help]--[Help Contents], you can read the help contents.

③ Check for Updates:

Click [Help]--[Check for Update] to detect the available updates online.

④ About FlashDLPrint :

Click [Help]--[About FlashDLPrint], the software information box will pop up. The contents include the current software version and copyright information.

Exploring FlashDLPrint

⑤ Feedback:

Feedback on FlashDLPrint can be sent to the pop-up window. Your valuable comments will be sent to the email address of the flash casting technician.

4. Print Operation

4.1 Generating the sliced file

Double-click [FlashDLPrint] icon to open FlashDLPrint software. As shown in Figure 37.



Figure 37 Software icon

Click [Print]-[Machine Type] and select printer type.

Click [Load] icon, select .stl 3D files shown as follow:



Figure 38 Load Icon

Click [Edit]-[Surface to platform], select on surface to contact the model and double click. After finished click [back] button, double click [Move] icon, then click [on platform]-[Center] icon..

Note: If the model is in the correct position, there is no need to do this step.

If multiple models are loaded, the colors of the selected model and the unselected model are different for easy identification, as shown in Figure 39.

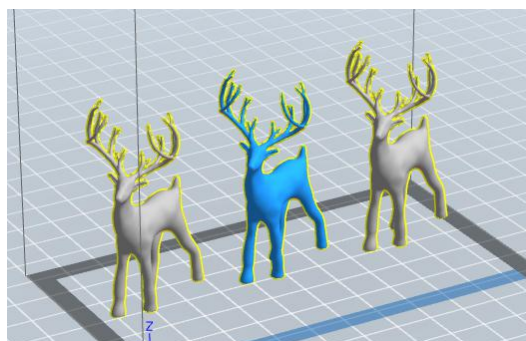


Figure 39 When multiple models are selected, the selected model is highlighted

Print Operation

Click [Print] icon to set the printing parameters. The default parameters is shown below.

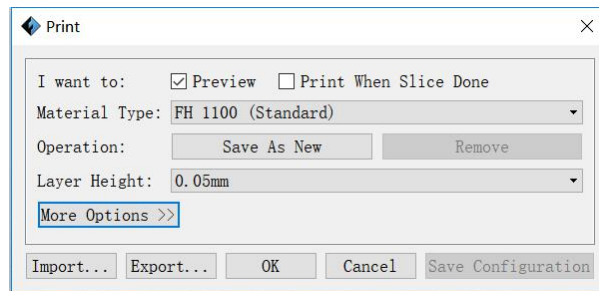


Figure 40 View the default parameter interface

Note: This parameter is recommended for the first users.

You can also use the [Import...] to import print parameters.

Click [OK], choose the file store path, and generate .svgx file.

Now, svgx file is generated. We will operate printing next. As shown in Figure 41.

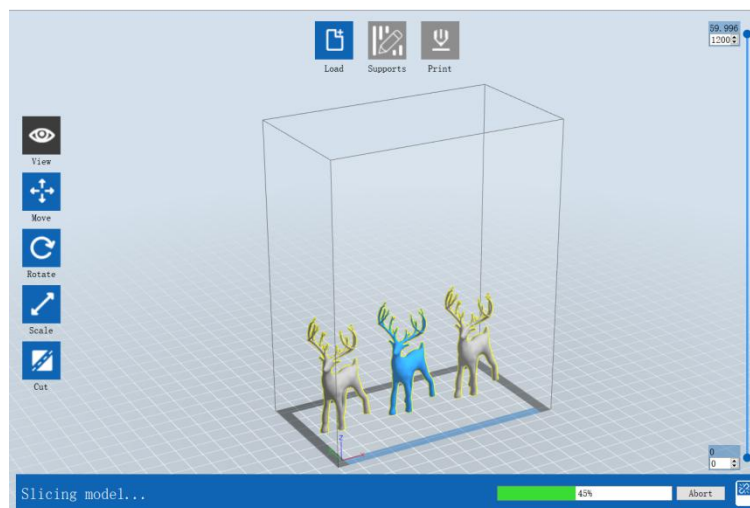


Figure 41 Print interface

4.2 Methods of printing

After generating the slice file, click "open the folder" in the lower right corner, as shown in Figure 42, and you can directly find the location of the file. We can import the model file into the device for printing. There are three printing methods available, namely, printing from USB flash disk, USB / Ethernet cable and WiFi connection.



Figure 42 Show folder after slicing

Print Operation

● **Printing from USB stick**

1. Click [Print], and a printing options screen will show up.
2. Click [OK], and save the gcode file in the USB stick.
3. FlashDLPrint will begin slicing the 3D model.
4. After slicing the object, take the USB stick from the computer. Insert it into the USB stick slot on the Hunter or Foto.
5. Tap [Print] and then tap the middle USB stick icon.
6. A list of file(s) will show up, press the file that you would like to print, then tap [Yes].
7. The printer will now enter preheating phase and will start printing once it finishes preheating.

● **WiFi connection printing:** (Note: some machine types do not have WiFi connection function, see the parameter introduction of each model for details)

After connecting the printer and the computer through wireless WiFi, open the slice file in the FlashDLPrint software, click the [Print] button in the upper right corner of the software to start printing, which is consistent with the printing method of USB connection.

No matter which of the above printing methods is adopted, be sure to close the shading door during printing to avoid external dust and light affecting the printing effect.

● **Pause Printing:**

With this button, you can pause printing in the middle of printing, and then resume printing from the pause. Stop printing: stops the printer. Once you click the stop button, all modes currently printing will be canceled. Once the printer stops running, printing means that recovery cannot be performed. After you use the stop function, you need to restart printing.

5. Help and Support

You can visit our official website to search for solutions of problems; you can also contact us by phone or email. We put official videos on Youtube. You can also ask the sales representative for Flashforge dental solutions and related videos. We welcome your valuable comments on our products.

After-Sale Service Hotline: 0086-0579-82273989

Email: support@ff3dp.com

Company Address: No. 518 Xianyuan Road, Wucheng District, Jinhua City, Zhejiang Province, China