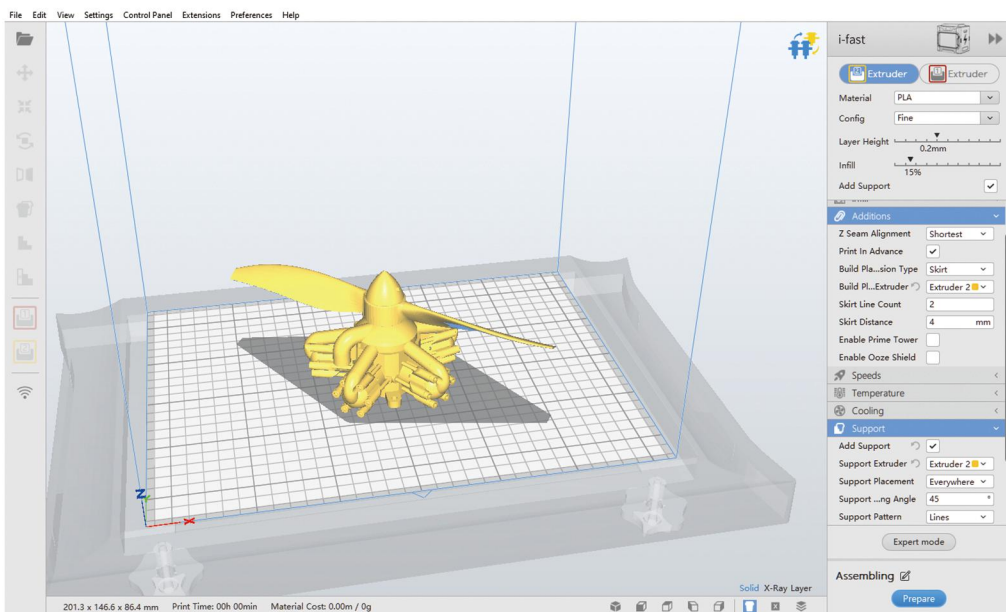![QIDI TECHNOLOGY 启迪科技]

i-fast

Slicer operation process

NOTICE: QidiPrint slicer does not support i-fast printing via USB cable,support ethernet connection printing.

For Windows users

① Insert the USB flash drive into the computer.

② Create a new folder on the computer desktop, copy the USB flash drive software to the new folder.

i-fast

1.Start-Up Guide
2.Slicer software
3.Test file
4.Leveling
5.The step of pass through the filament
6.Extruder calibration
7.Common issues
8. LAN print
9.Change Extruder
10.Camera usage
11.Use and clean up the glue stick
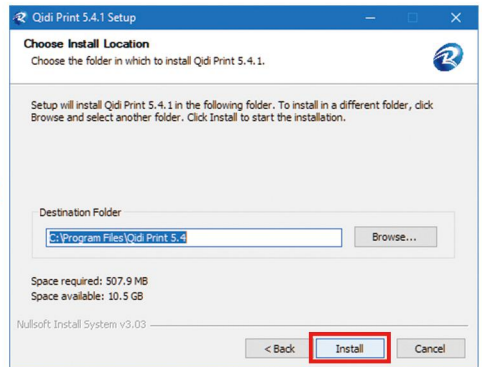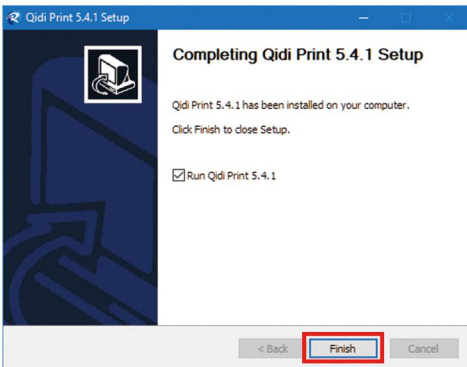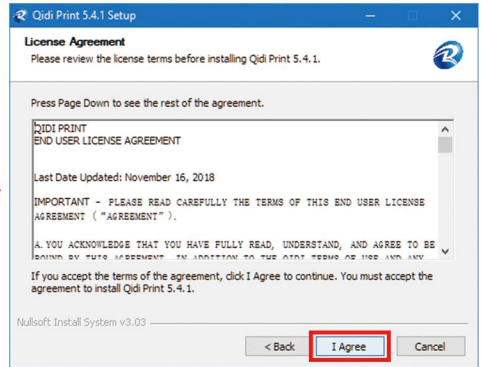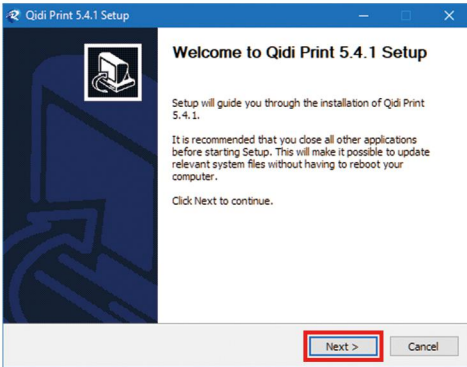12.Continue printing
13.Printer profile for Simplify 3D

Name

MacOS
Windows

Qidi Setup 5.4.1.exe
i-fast (Software).pdf
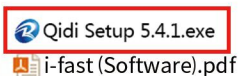
③ Double click to run the installer, install the software as below pictures.

 Double click

Choose the printer type "i-fast" .

Double click
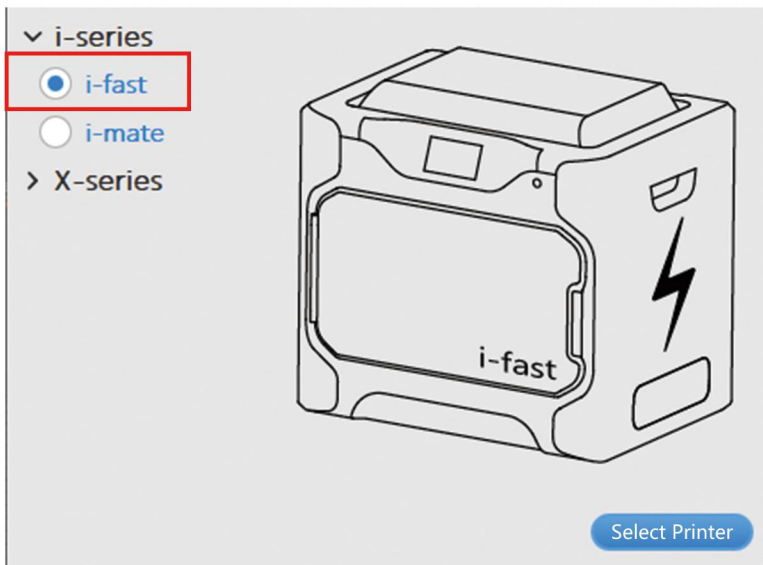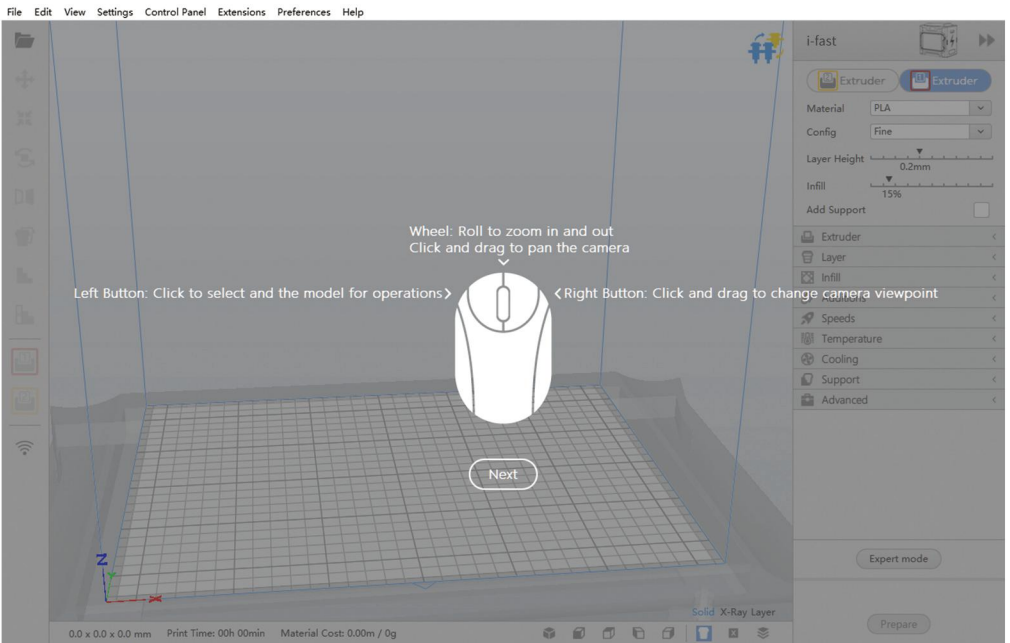
（A）Introduction of Mouse Function

Left Button: Click to select and the model for operations.

Wheel: Roll to zoom in and out
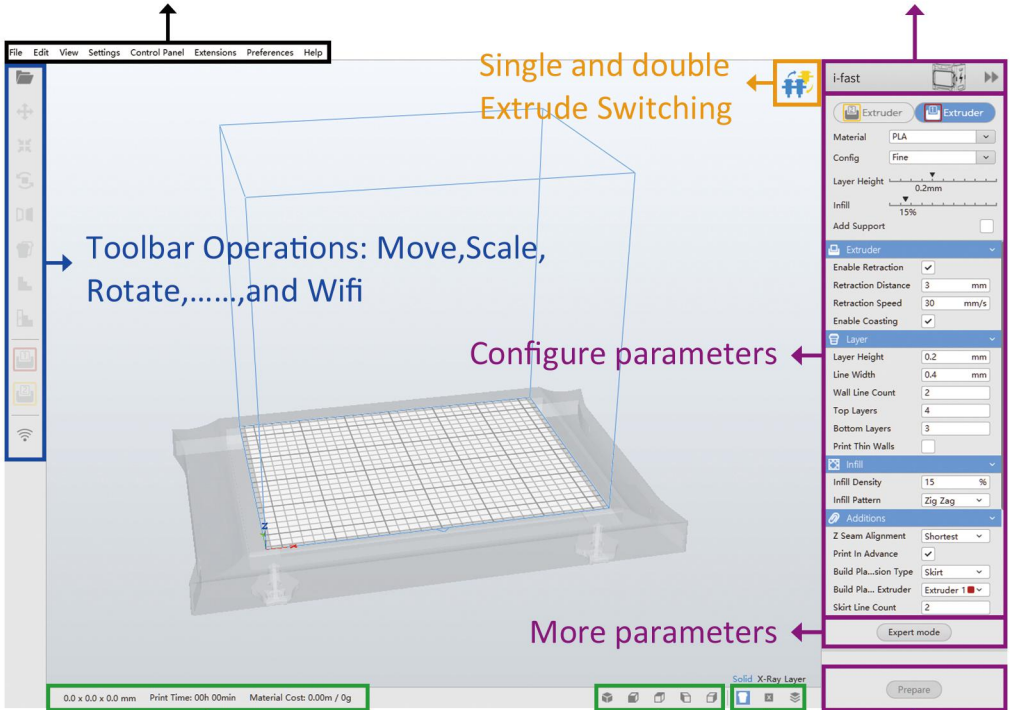
Click and drag to pan the camera.

Right Button: Click and drag to change camera viewpoint.

（B）Icon function introduction

Menubar: Includes Control Panel,
Configure Qidi,First Run Wizard,
Factory setting……

Select the machine

Single and double
Extrude Switching

Toolbar Operations: Move,Scale,
Rotate,……,and Wifi

Configure parameters

More parameters

Model size and print
information

Camera position View

After importing the model and
adjusting the parameters,click
on this button to slice

（C）First print

① Select your print type.

② Select your material type.

③ Select your printing precision(layer height).

④ Select an infill density.

⑤ Click the checkbox to enable print support.

⑥ Click prepare to slice your model.

⑦ Save the file or use Wifi to send the file.
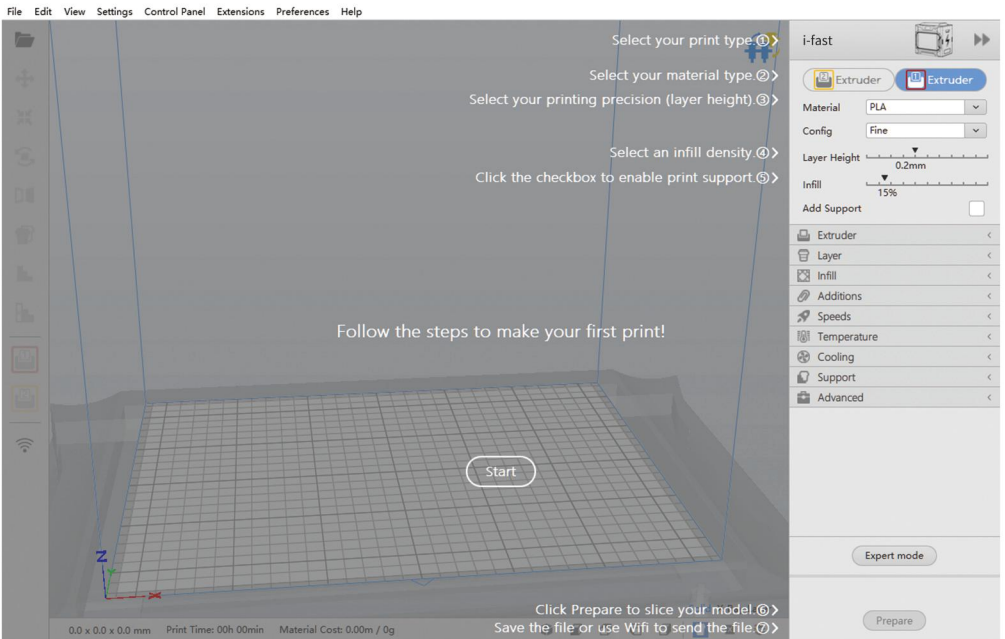
（D）Addition Feature Instruction

1. Adding the support manually

The operation of adding the support manually. First, please click the model, and add support tools manually in the toolbar on the right side of the main interface .

Here you can set the basic parameter for support (including the support size, support type, support density), then click on the model to add support part where you want to add on the model.Then click the done.
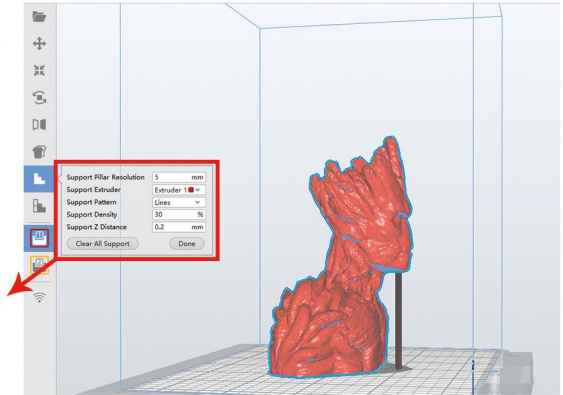
2. Support Blocker

Cick the model then click the support blocker ,click on the part of the model that does not need the support, and the support will not be automatically added to this part.

28
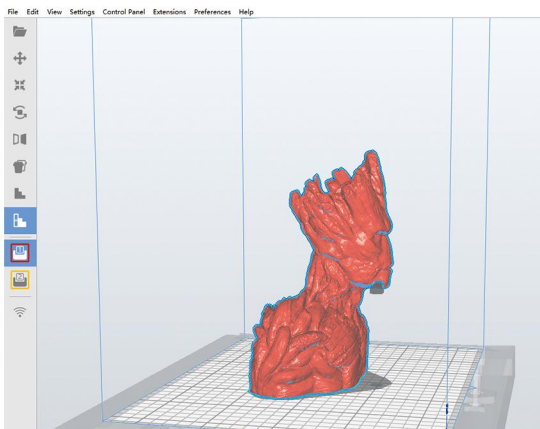
3. The function of the fan

Chamber loop

Enables the chamber looping fans while printing.

Cooling	
Enable Print Cooling	✔
Chamber loop	✔
Support	‹
Advanced	‹

Build Volume Temperature

The temperature of the environment to print in. If this is 0, the build volume temperature will not be adjusted.

Build Plat...tial Layer	60	°C
Build Vo...perature	0	°C

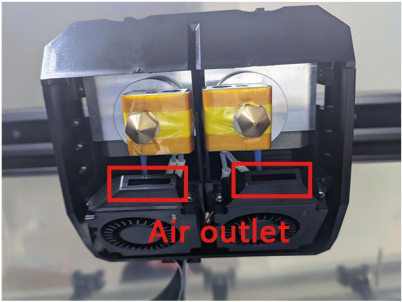| Cooling	
Enable Print Cooling	✔
Chamber loop	✔

Enable Print Cooling

Enables the print cooling fans while printing. The fans improve print quality on layers with short layer times and bridging.

Affects

• Fan Speed

Cooling	
Enable Print Cooling	✔
Chamber loop	✔
Support	‹
Advanced	‹

Expert mode

Build volume fan

Air filter

Air outlet

4. Expert model

Click on expert mode,and you can choose more option to adjust the effect of printing model.

5. Z-axis shifting

The extruder is too close to the platform,resulting in printing failure. Set Z offset 0.2 to increase the distance between the extruder and the platform by 0.2mm.
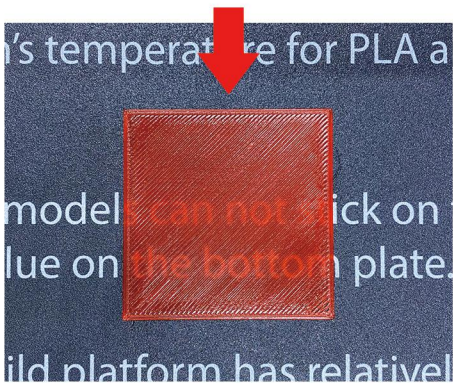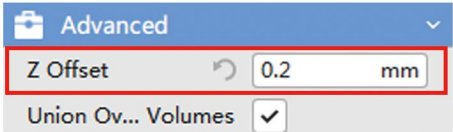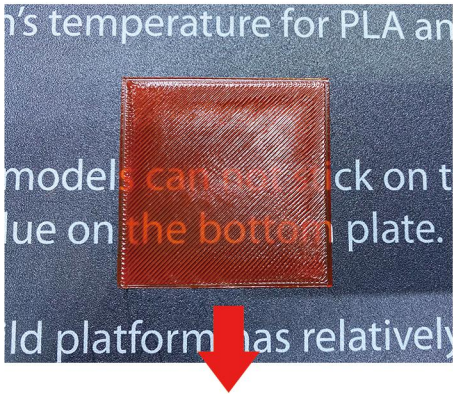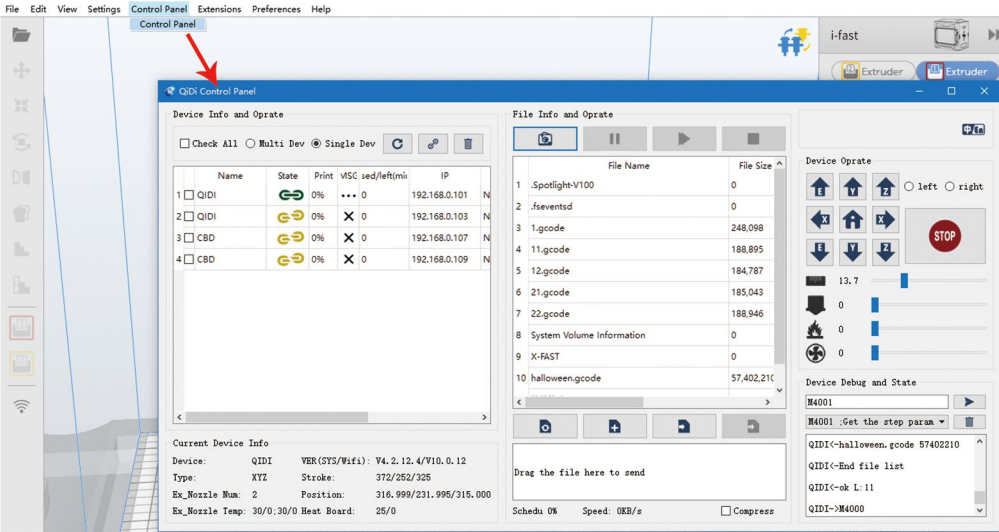
The extruder is too far to the platform,resulting in printing failure. Set Z offset -0.2 to reduce the distance between the extruder and the platform by 0.2mm.
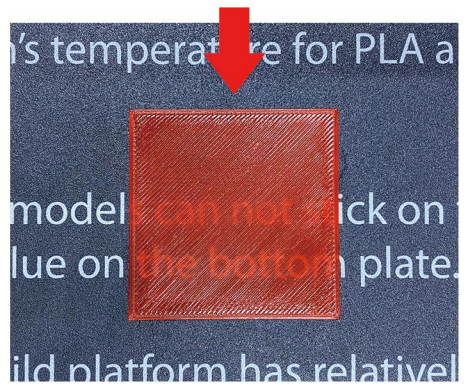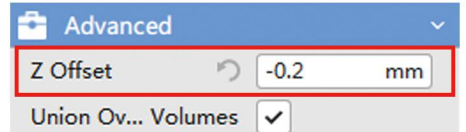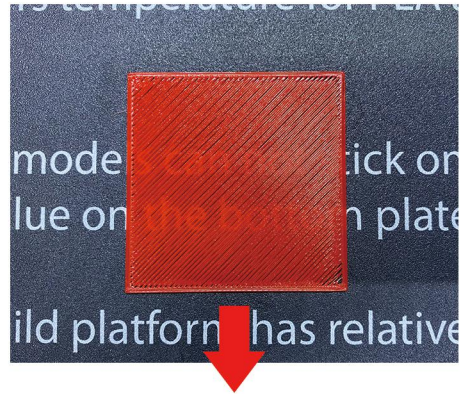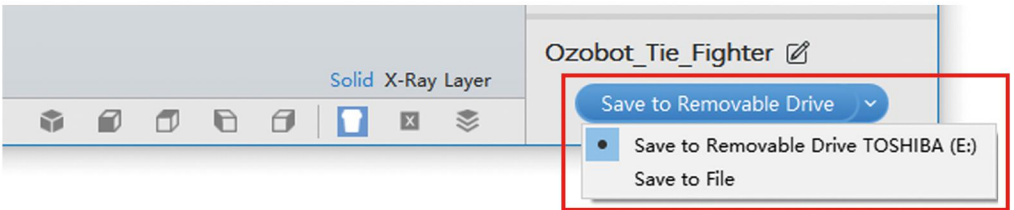
6. Control Panel

You can remotely control the printer and view the current status of the printer.
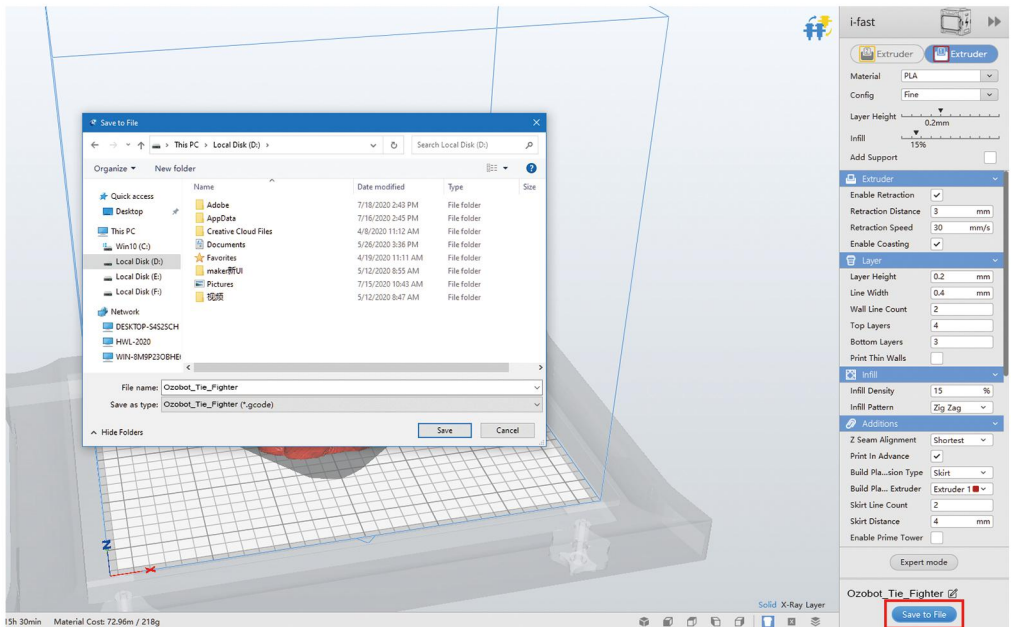
Save the gcode file

Method 1: When the USB flash drive is inserted into the computer, the gcode file can be save to the USB flash drive or the computer.
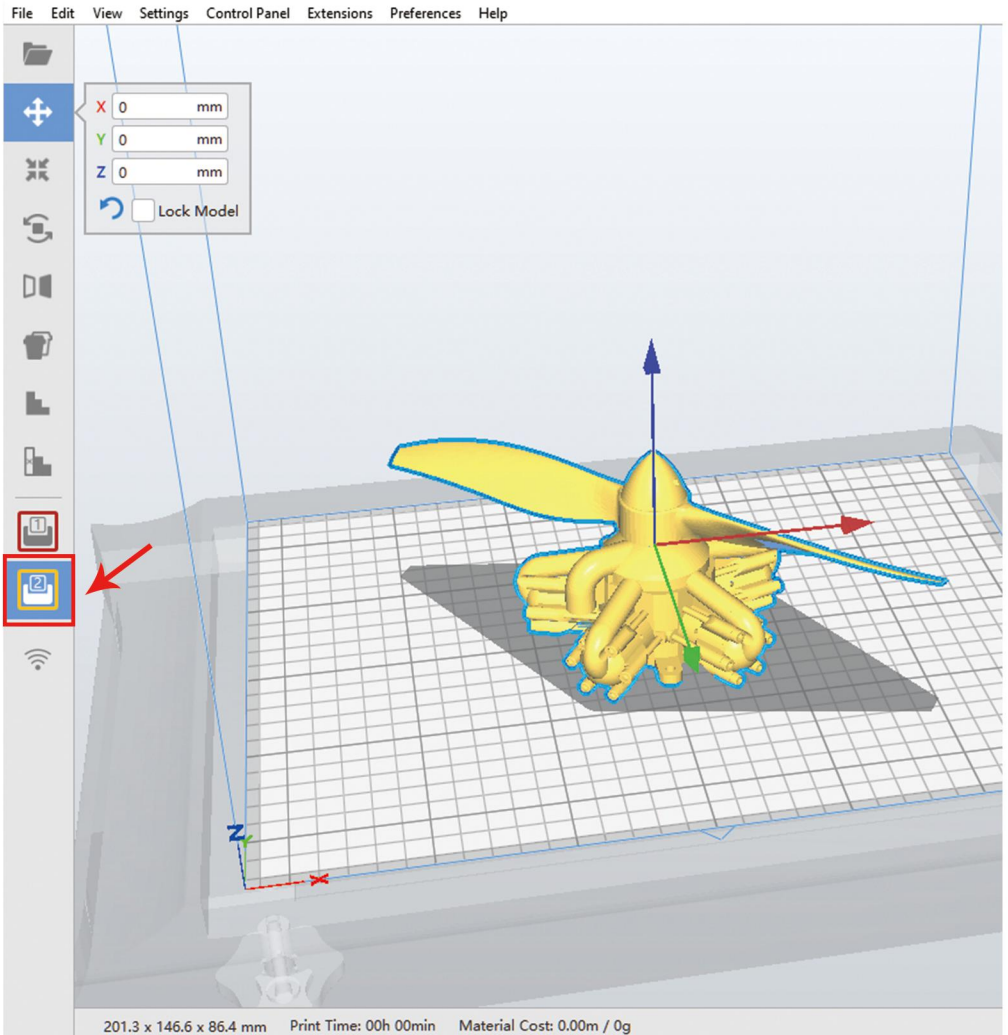

Method 2 : When the USB flash drive isn't inserted into the computer, the gcode file can be saved to the computer.
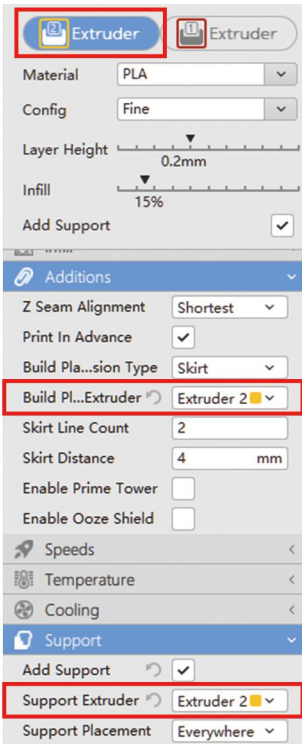
Extruder 2 printing

1. Load the single color model , then click the model and select the Extruder 2.
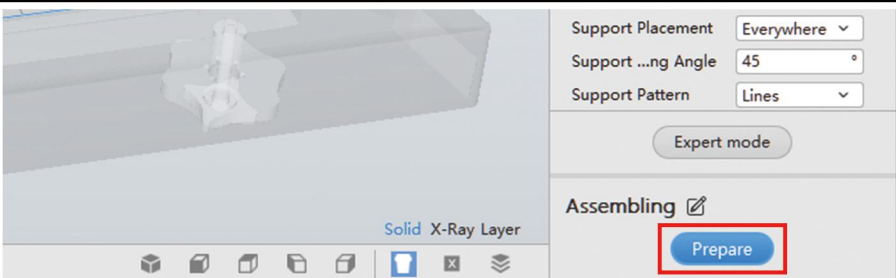
2. Click "Setting" , select "Extruder 2" and set the printing parameters.

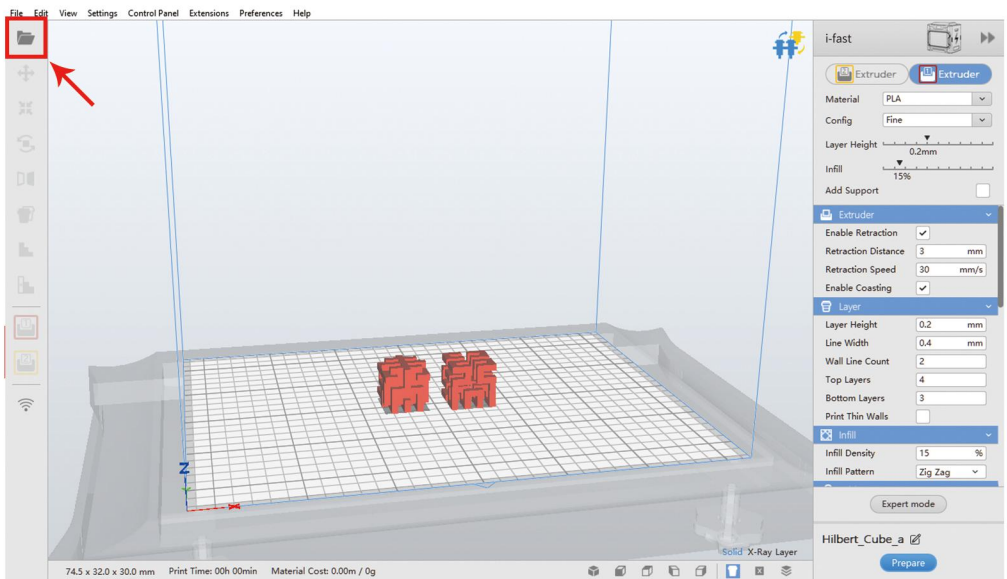**When print with the left extruder, please select "Extruder 2"**

Choose the "Extruder 2" for support extruder as well.

3. Click "Prepare" to generate the gcode file , save the file to Removable Driver (U-disk). Insert the U-disk into the 3d printer and start to print.
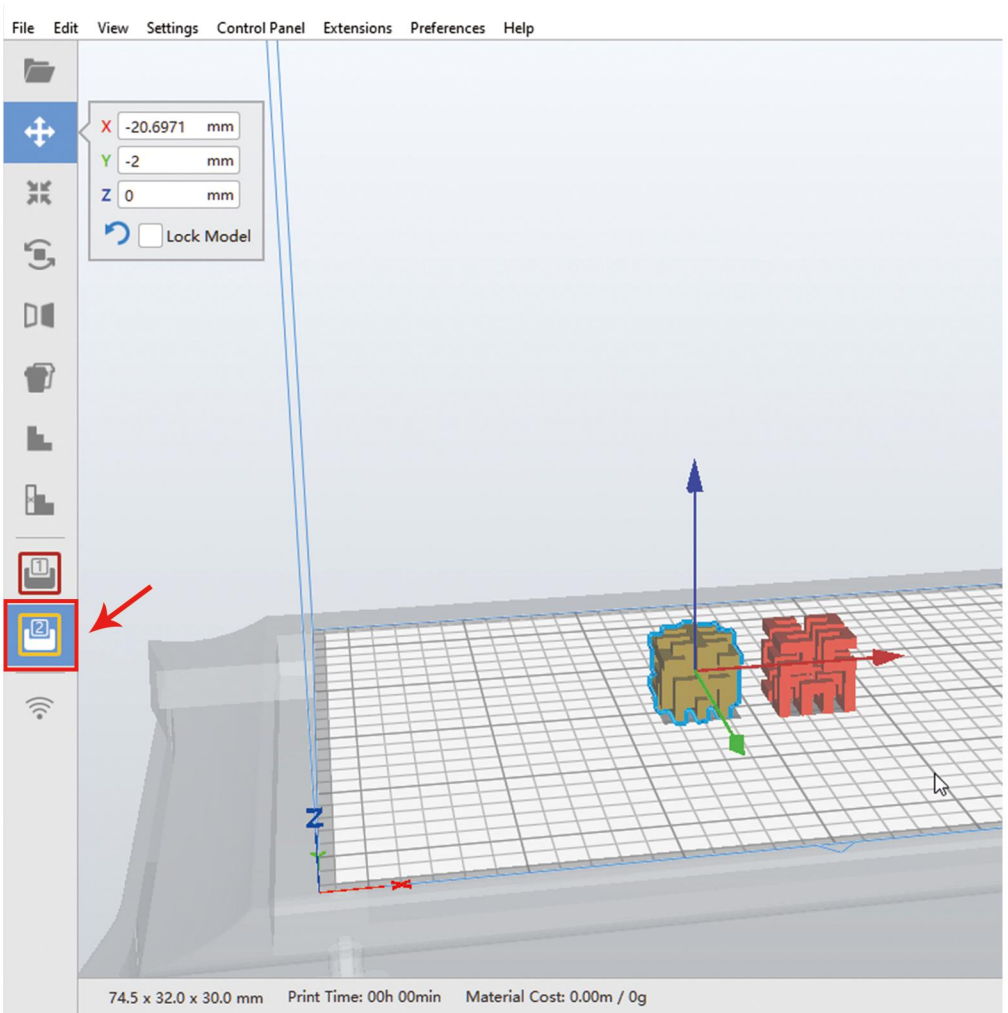
Double color printing
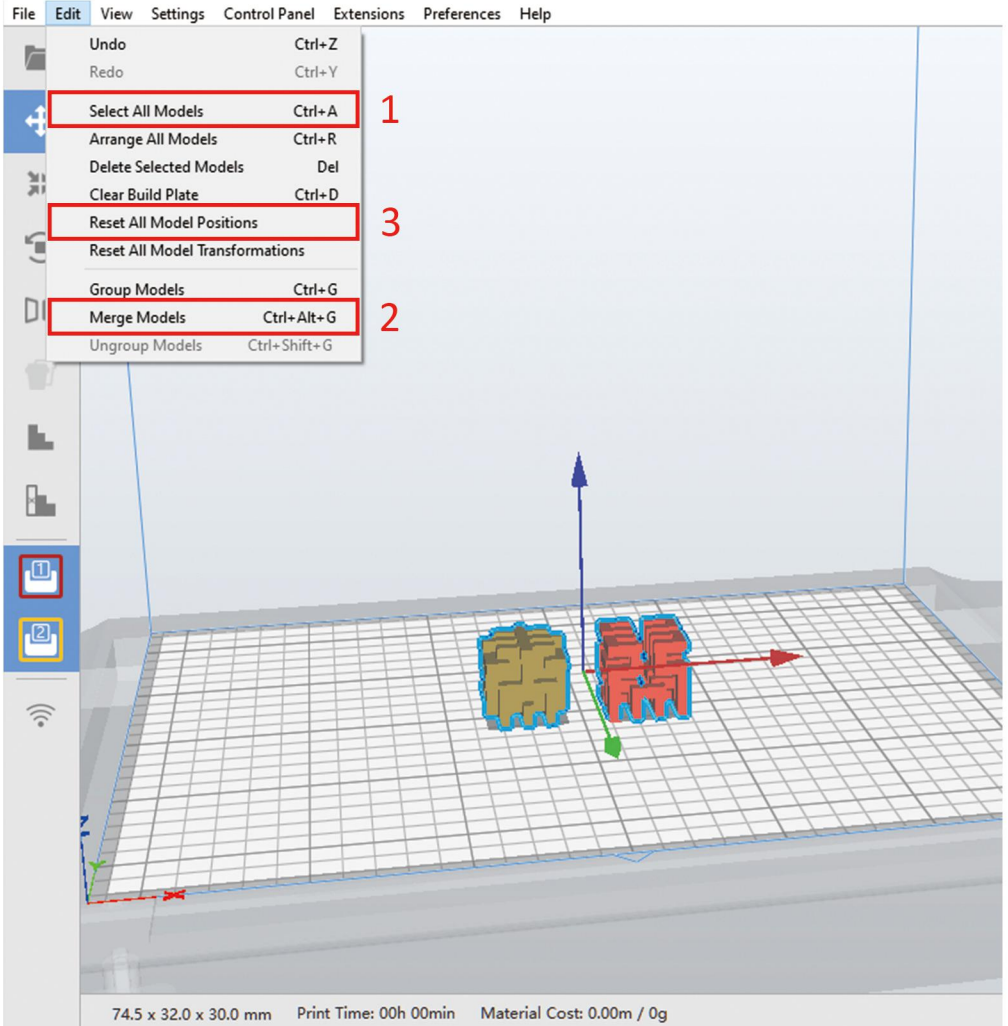
1.Load the double color model.

2. Combine model

Click the model, and select the correct extruder for each model in the toolbar **(red color is for Extruder 1, yellow color is for Extruder 2).**

3. Click the "Select All Models" in the "edit", then click "Merge Models" and "Reset All Model Positions".

4. Set the parameter of the 1 and 2 Extruder.

Extruder 1

Extruder 2

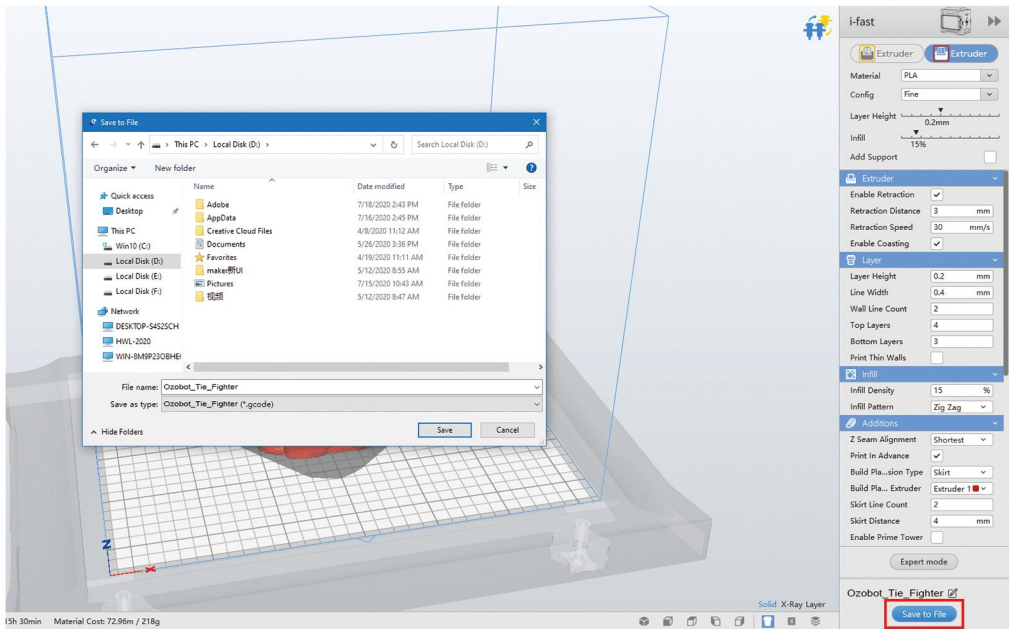Once you set the parameter of the left one , the right one will synchronized changed , except the setting of infill , speed , temperature .
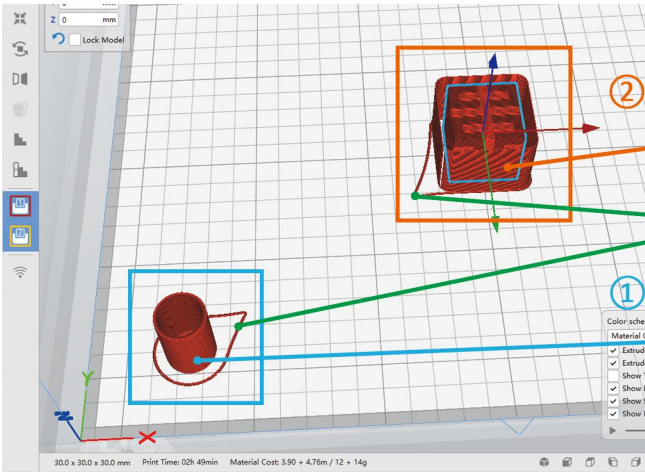
5. Save the gcode file.

Method 1 : When the USB Pen Drive is inserted into the computer, the gcode file can be saved to the USB Pen Drive or the computer.
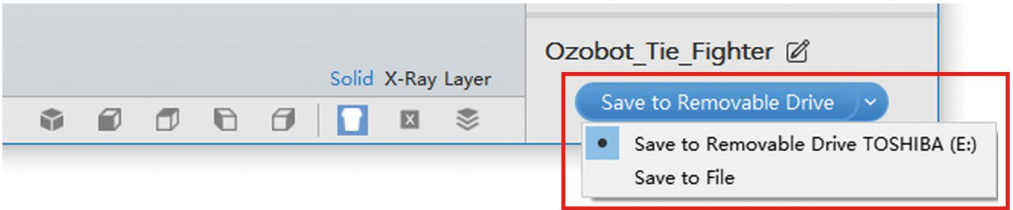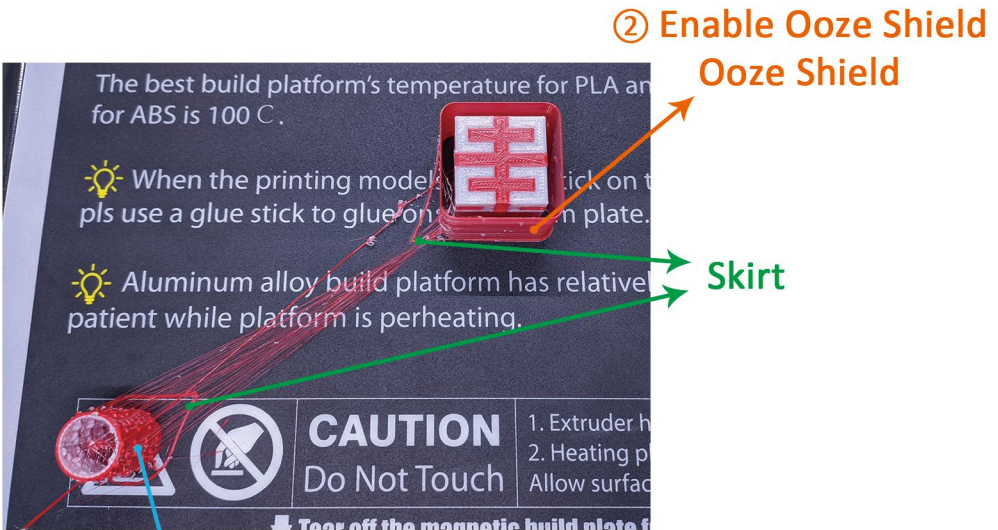

Method 2 : When the USB Pen Drive isn't inserted into the computer, the gcode file can only be saved to the computer.

Virtual Graph:

Enable ...e Tower ✓ ①

Enable ... Shield ✓ ②

② Enable Ooze Shield
Ooze Shield

Skirt

① Enable Prime Tower
Prime Tower

30.0 x 30.0 x 30.0 mm   Print Time: 02h 49min   Material Cost: 3.90 + 4.76m / 12 + 14g

The effect diagram when print out：

② Enable Ooze Shield
Ooze Shield

The best build platform's temperature for PLA an...
for ABS is 100 ℃.

When the printing model ...tick on t...
pls use a glue stick to glue on ... plate.

Aluminum alloy build platform has relative...
patient while platform is perheating.

Skirt

CAUTION
Do Not Touch

1. Extruder h...
2. Heating p...
Allow surfac...

Tear off the magnetic build plate f...

Prime Tower
① Enable Prime Tower

Adding printer profile for simplify 3D

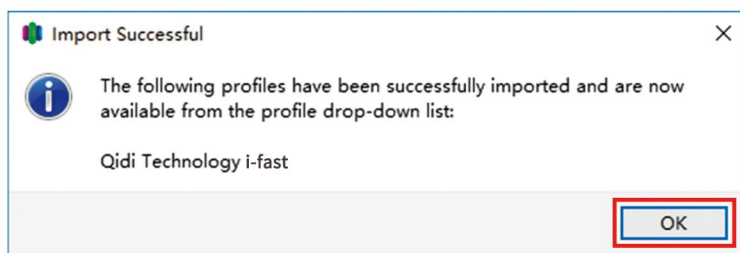1. Open Simplify3D, select "import FFF profile" in the File section.
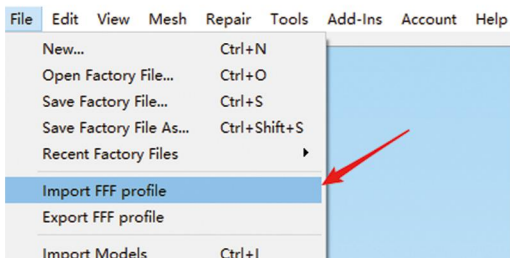
2. Import the i-fast printer profile for Simplify 3D from the USB flash drive that we provided.
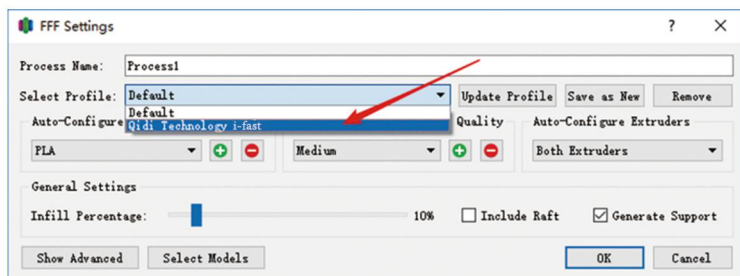

3. The message pops up when import successful.

4. Open the FFF setting, choose "Qidi Technology i-fast" that we just added in the select profile section.

Thank you!