Table of Contents

ERYONE

USER GUIDE V1.1

Name: High Speed FDM 3D Printer Model:
Thinker X400

1. Safety Precautions

1.1 Environmental and Installation Safety

Ventilation and Temperature/Humidity

·Use the printer in a well-ventilated, dry environment; avoid enclosed spaces.

·Recommended operating temperature: 15–30°C; humidity: 10–90% non-condensing.

·Ensure proper ventilation for the fully enclosed acrylic shell to prevent heat buildup.

Placement

·Place the printer on a stable, sturdy surface to avoid tilting or shaking.

·Ensure sufficient space around the device (dimensions: 685 × 634 × 810 mm).

·Keep away from flammable materials (e.g., paper, alcohol).

1.2 Electrical Safety

Power and Grounding

·Use the original power cord (input voltage: 85–264V AC). Do not use

extension cords or multi-outlet adapters.

·The device’s peak power consumption is 800W; ensure the power outlet has sufficient capacity.

·In emergencies, press the emergency stop switch or turn off the air switch to cut power.

High Voltage Warning

·Do not disassemble the printer’s circuitry. Repairs must be performed by professionals.

·Avoid touching internal cables or electronic components while the device is operating.

1.3 High-Temperature and Mechanical Safety

Nozzle, Heated Bed, and Chamber Heating (Optional) High-Temperature Warning

· The nozzle can reach up to 350°C (optional), and the heated bed up to 120°C. Direct contact may cause severe burns.

·When chamber heating is enabled, the chamber can reach up to 70°C. Avoid touching the metal structure to prevent burns.

·Always wear heat-resistant gloves when handling the heated bed or removing models.

·Wait at least 30 minutes after printing before touching the nozzle or heated bed to ensure cooling.

High-Speed Moving Parts Risk

·Maximum print speed: 500 mm/s; acceleration: 10,000 mm/s². Keep fingers, hair, and clothing away from moving parts.

·Pause printing or ensure the device is fully stopped before making adjustments.

1.4 Filament and Printing Safety

Filament Selection

·Compatible materials include PLA, ABS, TPU, carbon fiber-reinforced materials, etc. Adjust printing temperatures according to the material (refer to the device parameter table).

·Ensure proper ventilation when printing high-temperature materials (e.g., ABS, ASA).

Filament Handling Precautions

·Use wire cutters to trim the filament end at a 45° angle for smooth

feeding.

·Enable filament runout and knot detection to avoid printing interruptions.

1.5 Model Removal and Maintenance

Safe Model Removal

·Use the included scraper to gently pry the model from the magnetic flexible PEI sheet. Avoid excessive force to prevent damage.

·If the model adheres too tightly, slightly bend the PEI sheet to assist removal.

Cleaning and Maintenance

·Regularly clean nozzle residue with a steel brush to prevent clogging.

·Replace the activated carbon filter periodically to maintain air filtration efficiency.

·When not in use for a long time, disconnect the power supply and store in a dry environment.

1.6 Special Groups and Emergencies

Children and Pet Safety

·Keep children and pets away from the printer during operation to prevent contact with high-temperature parts or moving mechanisms.

·Store small tools (e.g., hex wrenches, needles) properly to avoid accidental ingestion.

Emergency Handling

·If the device emits smoke, unusual noise, or experiences electrical faults, press the emergency stop switch immediately and contact technical support.

·For filament clogs, use a needle to clear the nozzle or refer to the manual for hardened steel nozzle replacement.

1.7 Product Label Information

1.

ERYONE Thinker X400 3D Printer Product Label Information

- Voltage range: 85–264V AC

- Frequency: 50/60Hz
- Power consumption: 200–350W (operating), 800W (peak)
- Net weight: 58.5 kg
- Manufacturer: Shenzhen Eryone Technology Co., Ltd.
- Address: Building A406, Huafeng International Robotics Industrial Park Phase II, Guxing Community, Xixiang Avenue, Bao'an District, Shenzhen, Guangdong, China

Certifications:

MA (China Metrology Accreditation)

ROHS (EU Restriction of Hazardous Substances)

UKCA (UK Conformity Assessed)

CE FC (EU CE and FCC Electromagnetic Compatibility Certification)

Made in China

2.

Indicates the heated bed voltage: 110–120V

3.

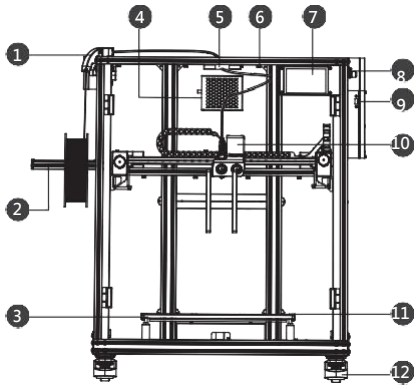
Indicates the heated bed voltage: 220–240V

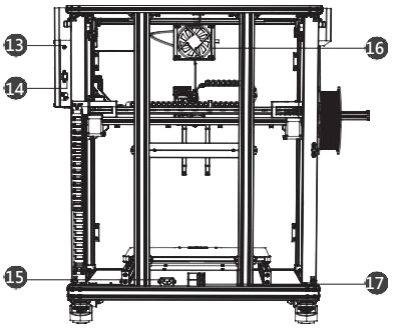
4.

Warns against placing heavy objects on the acrylic surface to prevent cracking or deformation.

2. Device Introduction

2.1 Appearance Overview





1. PTFE Tube Holder
2. Filament Holder
3. Heated Bed
4. Activated Carbon Filter Box
5. Camera
6. LED Light
7. Display Screen
8. Emergency Switch
9. USB Port
10. Extruder
11. Textured PEI Sheet
12. Rollers
13. Antenna Port
14. Ethernet Port
15. Power Cord Port
16. Fan
17. Air Switch

2.2 Device Parameters

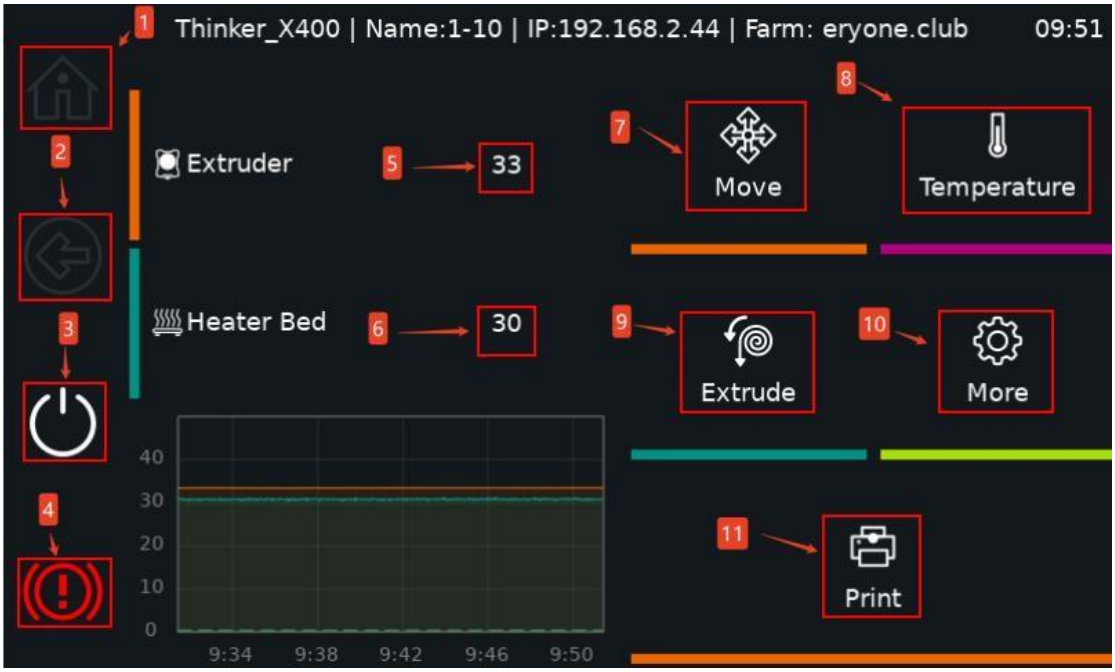
Machine Model	Thinker X400 High-Speed 3D Printer
Print Volume	400 x 400 x 400 mm
Extruder	Single Direct Drive Extruder
Nozzle	Default 0.4mm, supports 0.2mm, 0.6mm, 0.8mm, 1.0mm
Nozzle Type	1 × 0.4mm Hardened Steel Nozzle (includes a spare)
Filament Diameter	1.75mm
Nozzle Temperature	Up to 300°C (standard), up to 350°C (optional)
Heated Bed Temperature	Up to 120°C
Chamber Heating	300W (Standard)
Chamber Temperature	Up to 60°C(with one),ambient 25°C
Supported Filaments	PLA, PETG, TPU, ABS, ASA, PP, PC, PA-GF, PA-CF, glass/carbon fiber-reinforced
Print Speed	Up to 500 mm/s

Acceleration	10000mm/s²
Flow Rate	Up to 35mm³/s
Print Precision	0.1-0.3mm
Layer Height	0.08-0.32mm
Print Bed	Magnetic Flexible Dual-sided PEI Sheet
Leveling Method	4 Independent Z-Axes, 25-Point Auto Bed Leveling
Display	5-inch Capacitive Touch Screen
Enclosure	Fully Enclosed Transparent Acrylic Shell
Air Filtration	High-Efficiency Activated Carbon Filter
Firmware	Klipper
Software	Cluster 3D Printing Production Management Software
Noise Level	50-60dB
Printing Methods	Ethernet, USB, Wi-Fi
Monitoring Camera	Supported
Filament Runout Detection	Supported
Filament Knot Detection	Supported

Emergency Stop Switch	Supported
Lighting	Supported
Device Dimensions	685 x 634 x 810 mm
Packaging Dimensions	830 x 725 x 1070 mm
Net Weight	58.5 kg
Gross Weight	74 kg
Power Supply	85-264 VAC，50/60 Hz
Power Consumption	800W (peak), 200–350W (operating)
Slicing Software	Orca Slicer
Supported File	STL, STEP
Certifications	CE/FCC/ROHS/CMA
Supported Languages	Chinese/English

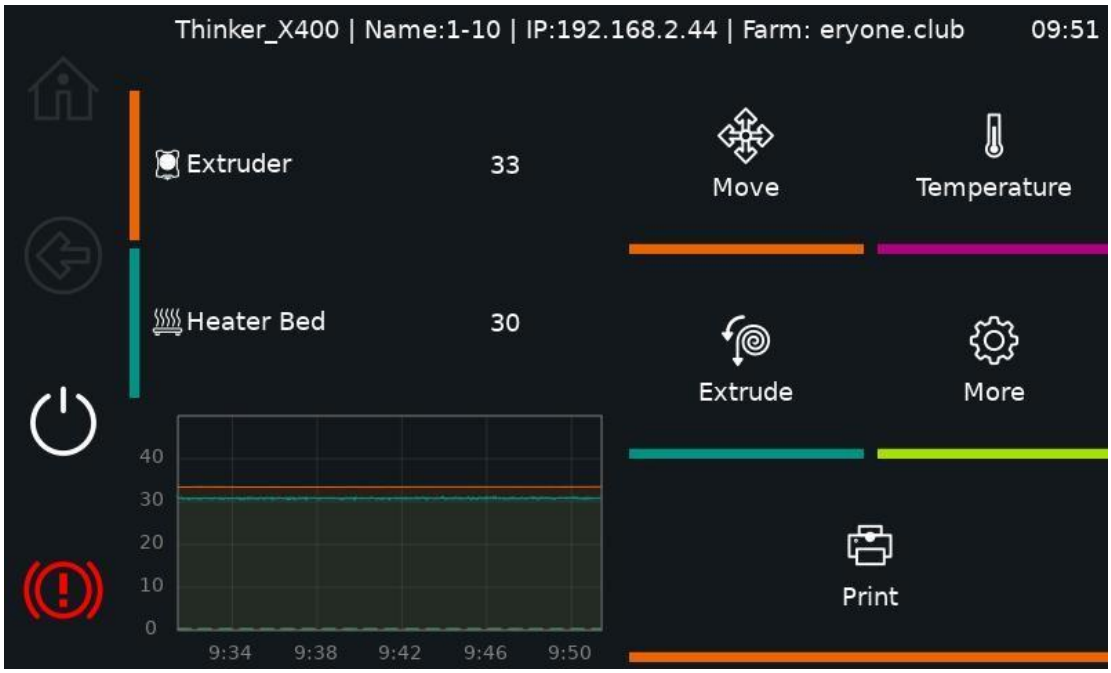
3. Printer Screen Operation Guide

The functions of the buttons on the home page are as follows:



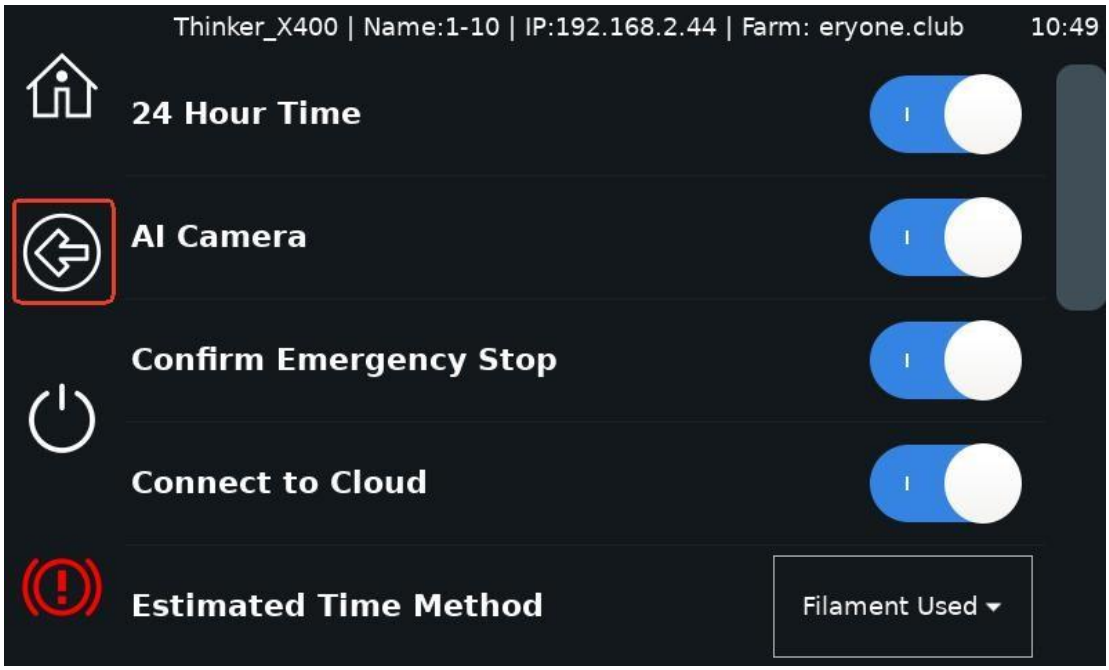
3.1 Home Page

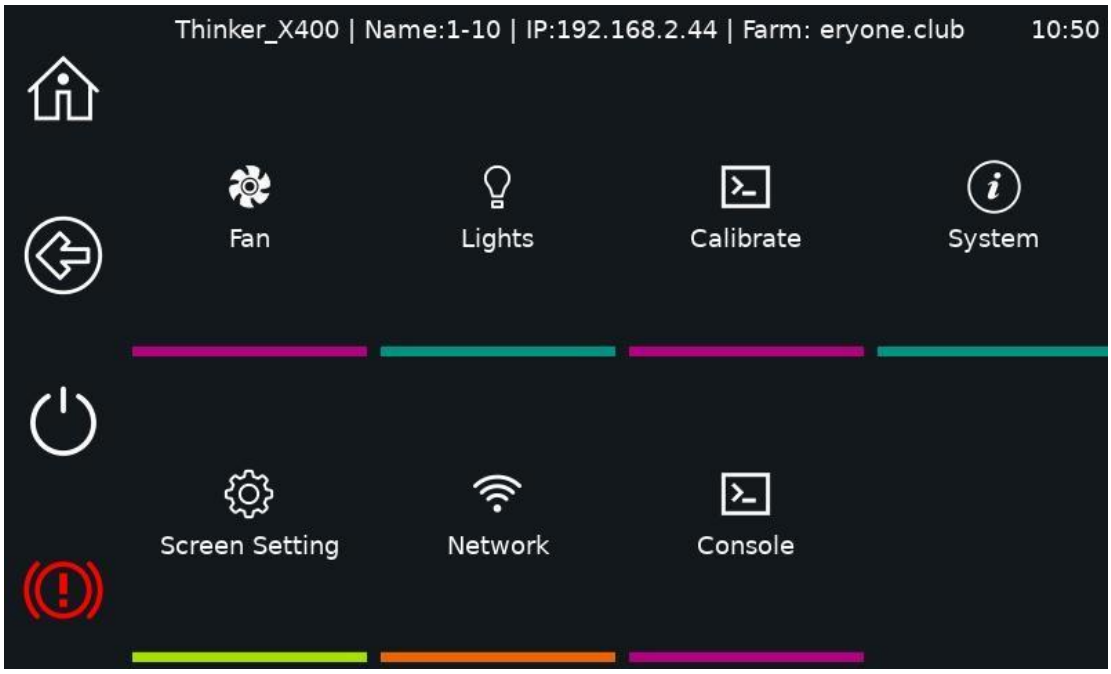
① Home Button: Returns to the home page.



3.2 Back

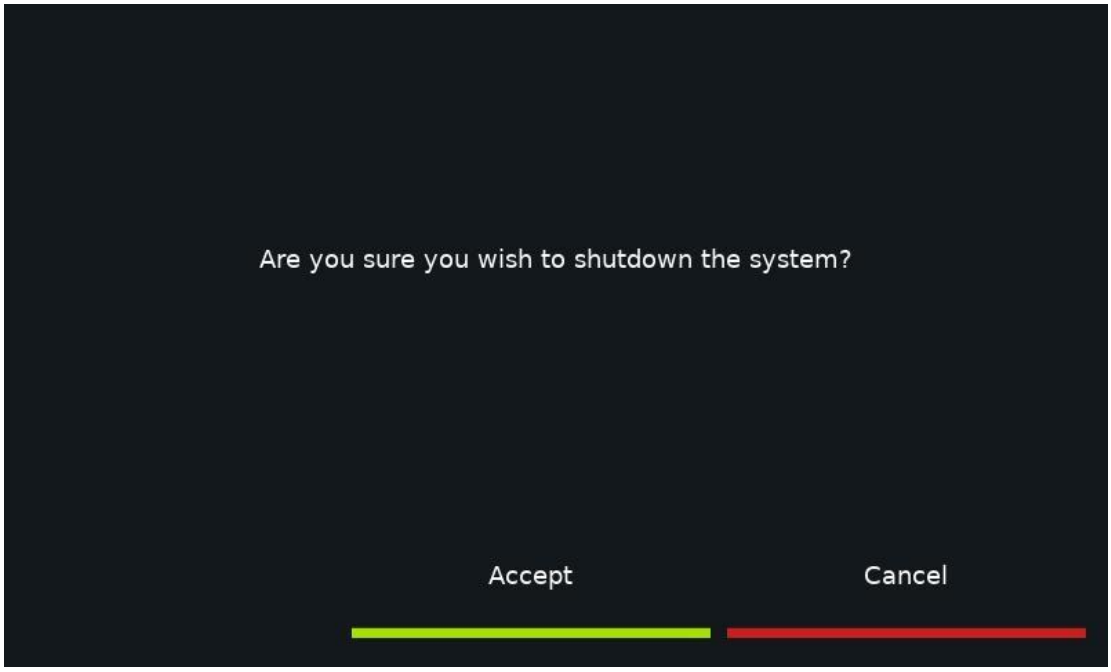
② Back Button: Returns to the previous page.





3.3 Shut Down

③ Shutdown Button: Powers off the system.

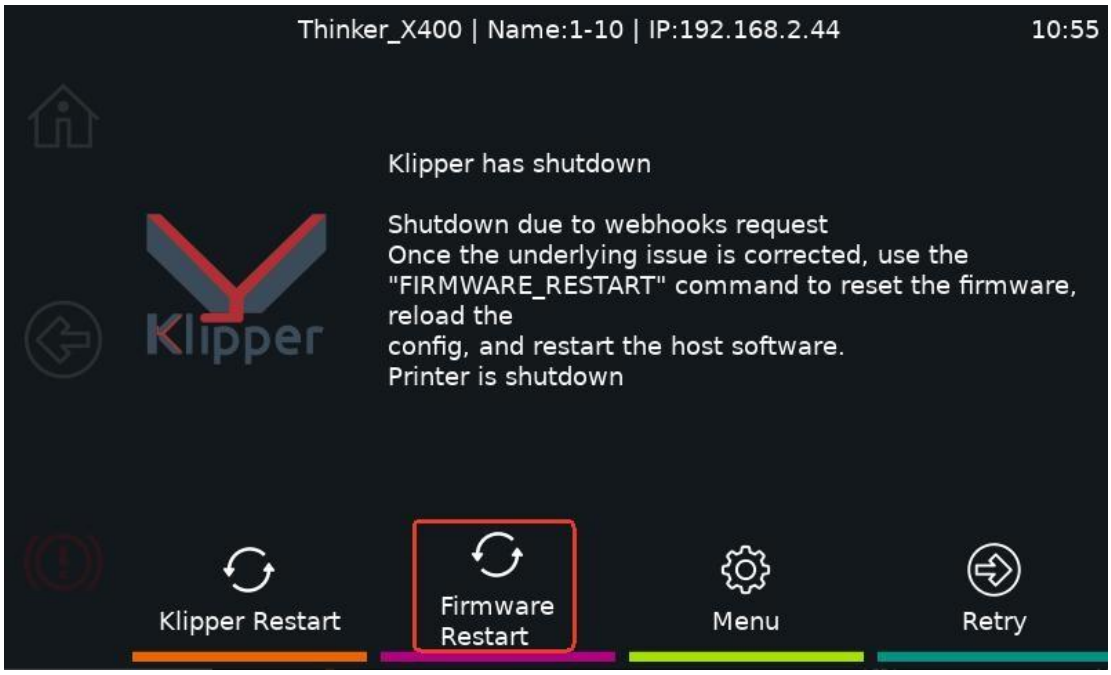


Note: After shutdown, press the emergency switch on the printer's right side. To restart, rotate the emergency switch back.

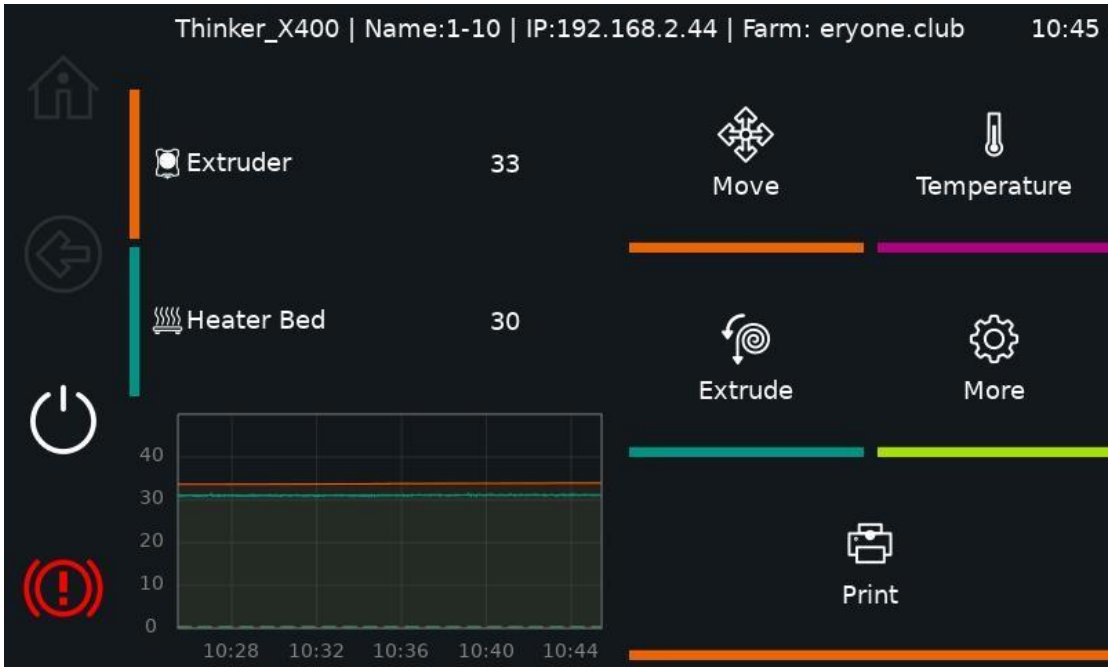
（This shutdown button is designed to reduce the risk of the machine malfunctioning, similar to the hot-plugging of a USB flash drive. Of course, you can also shut down the machine directly by tapping the emergency switch on the right side of the machine. We simply recommend that you do the above to turn off the printer.）

3.4 Emergency Stop

④ Emergency Stop Button: Halts printer operation.

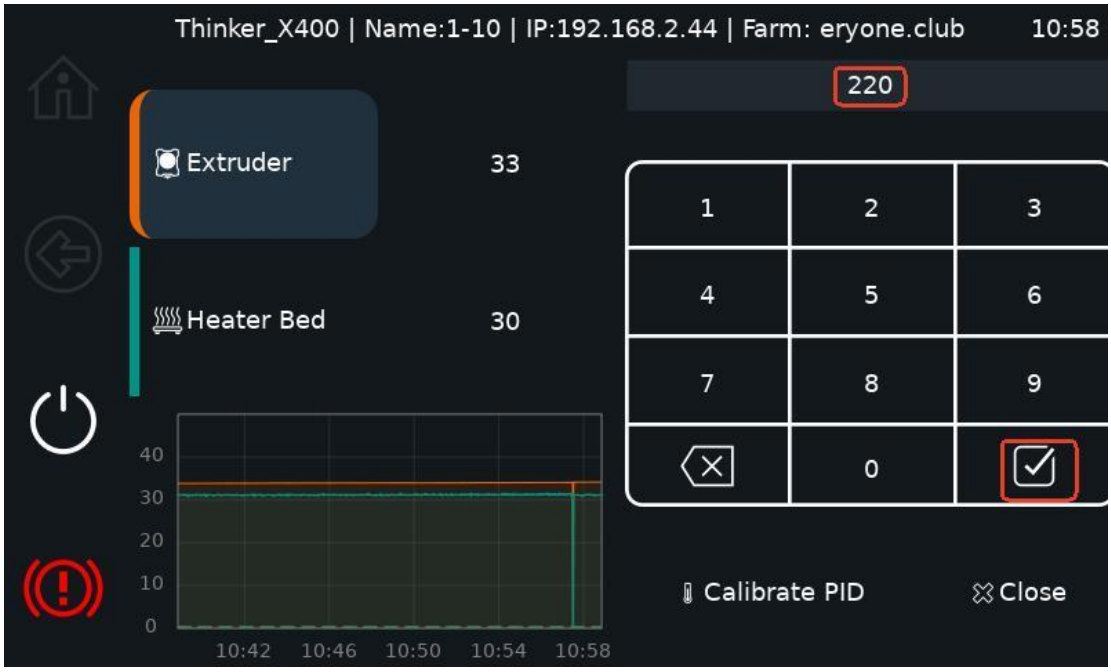


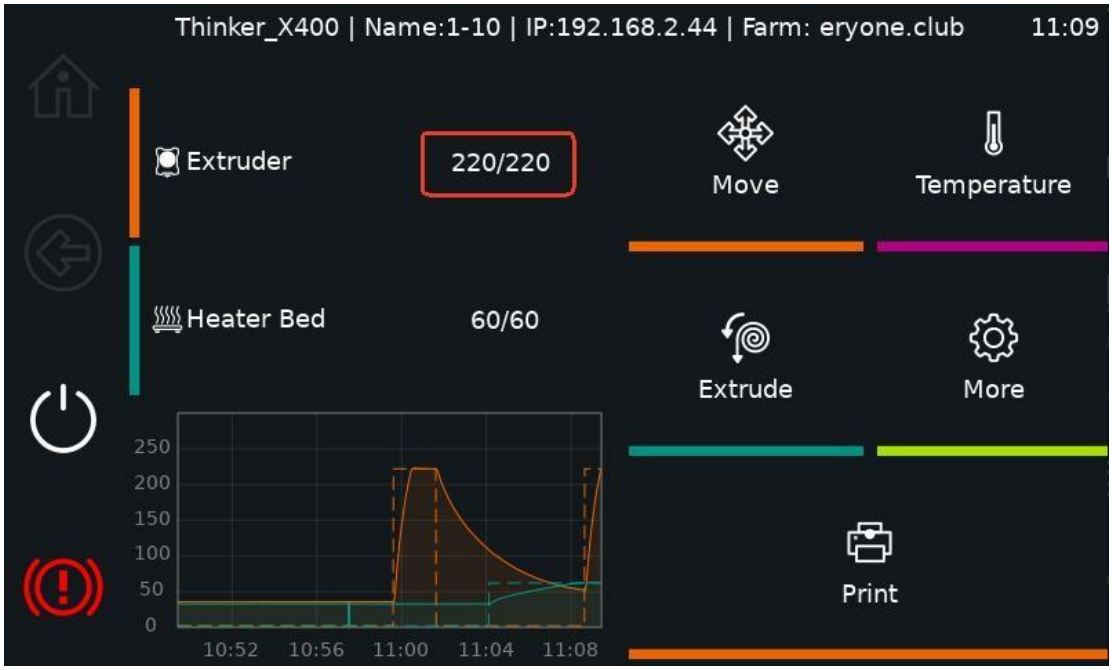
After clicking on it, wait for a while, then you can go back to the main interface.



3.5 Nozzle Temperature Setting

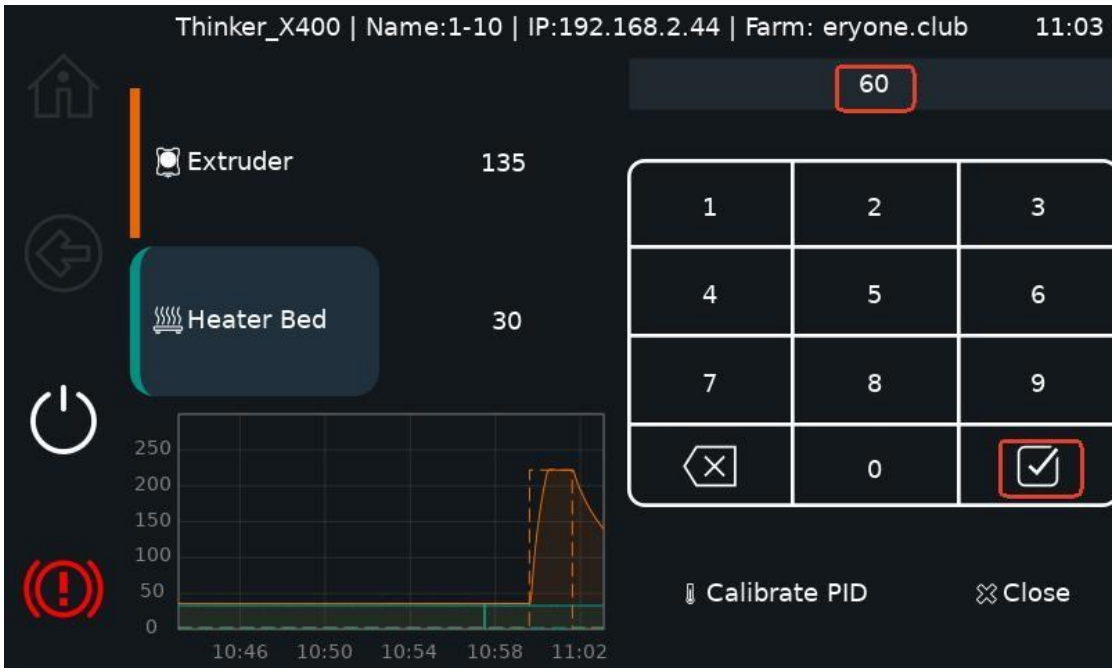
⑤ Nozzle Temperature Button: Sets the nozzle temperature (max 300°C).

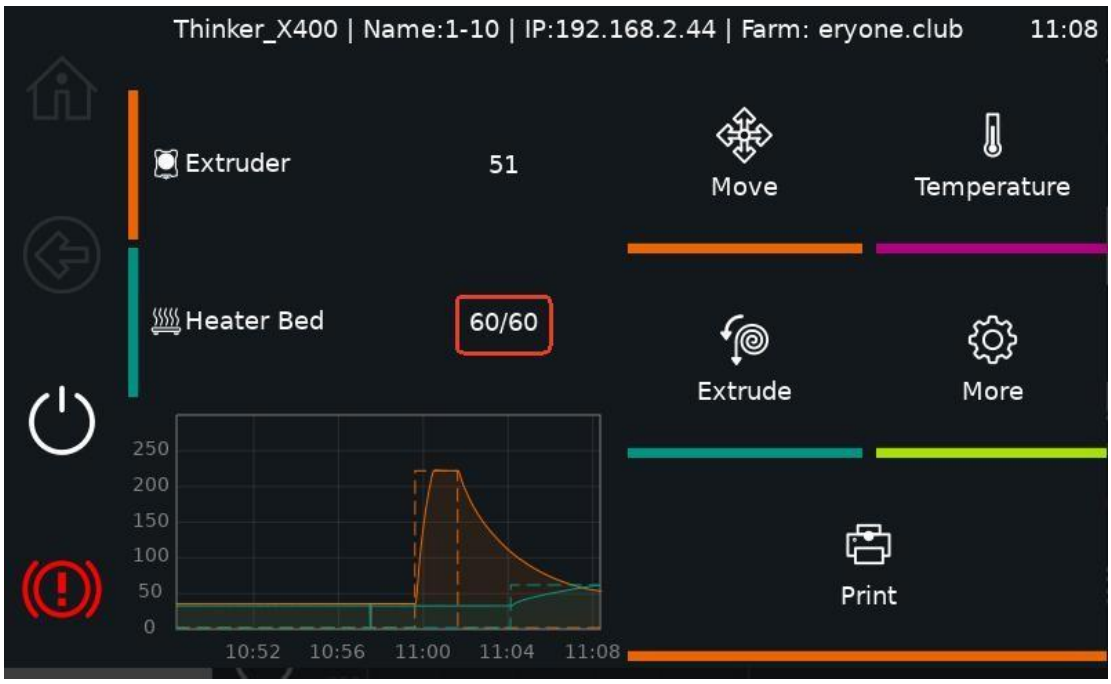




3.6 Heated Bed Temperature Setting

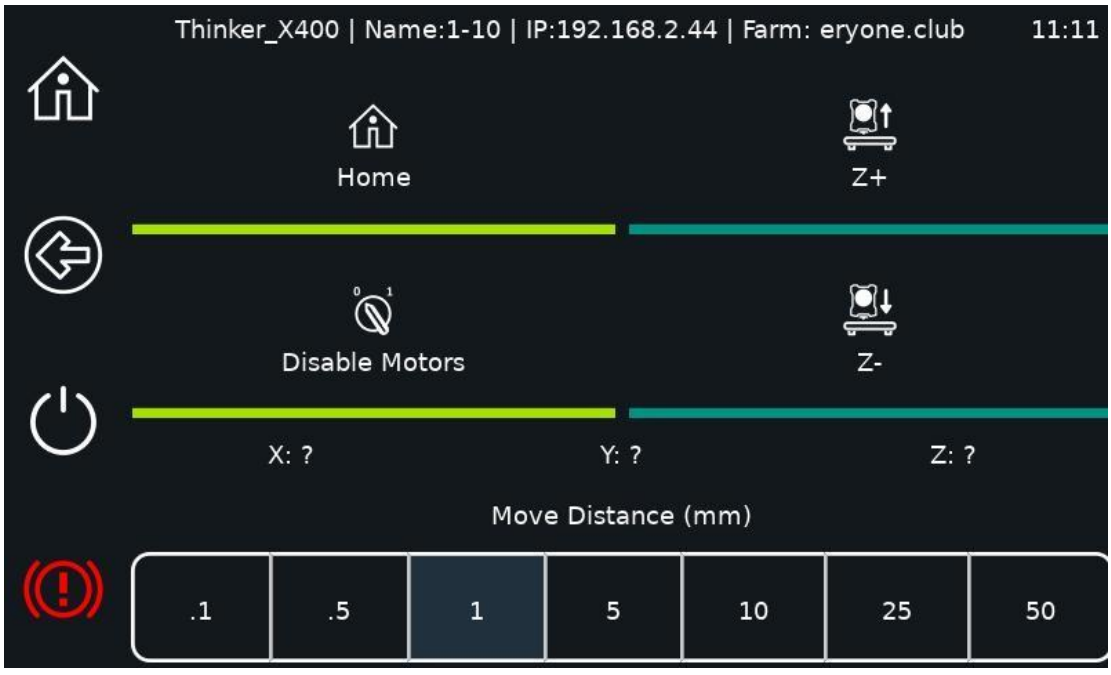
⑥ Heated Bed Temperature Button: Sets the bed temperature (max 120°C).



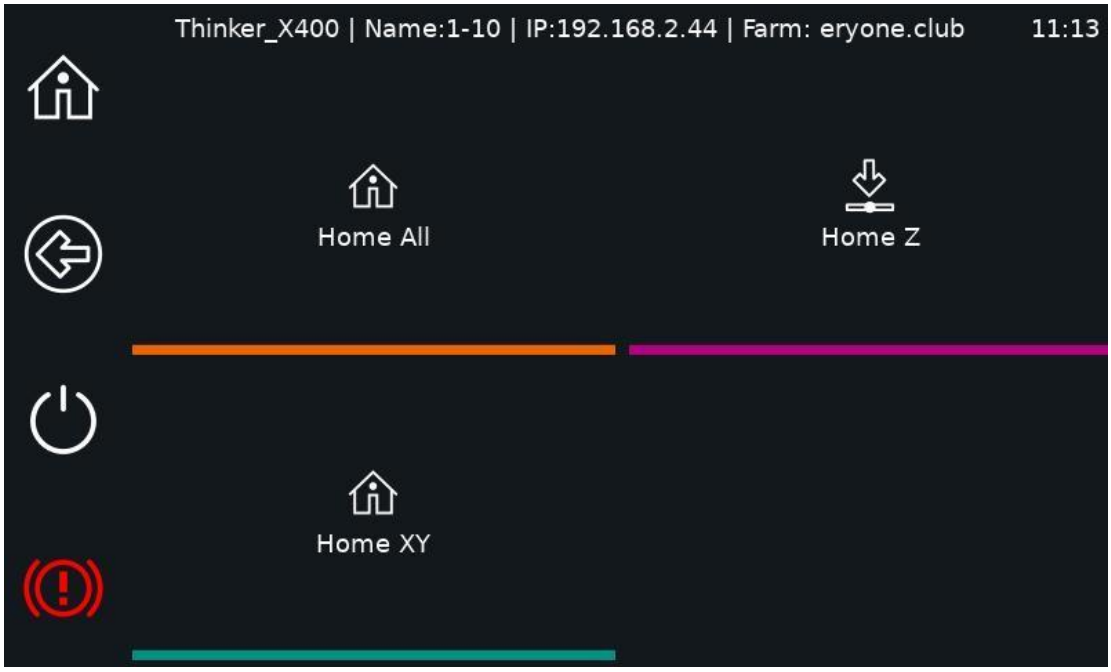


3.7 Movement

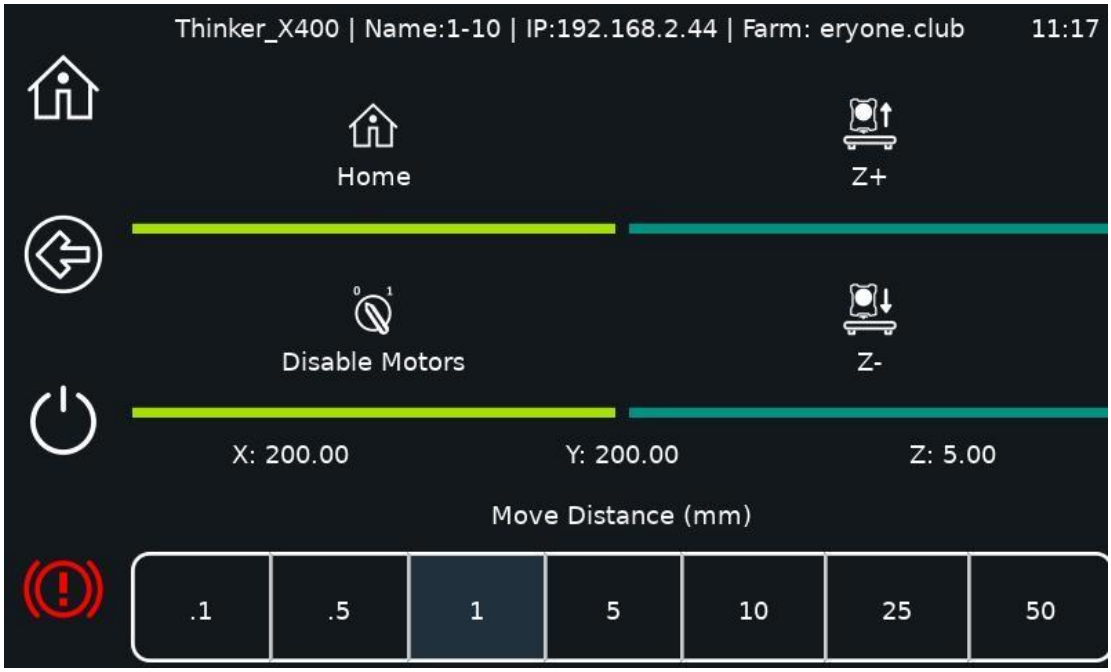
⑦ Click "Move" jump to the move page



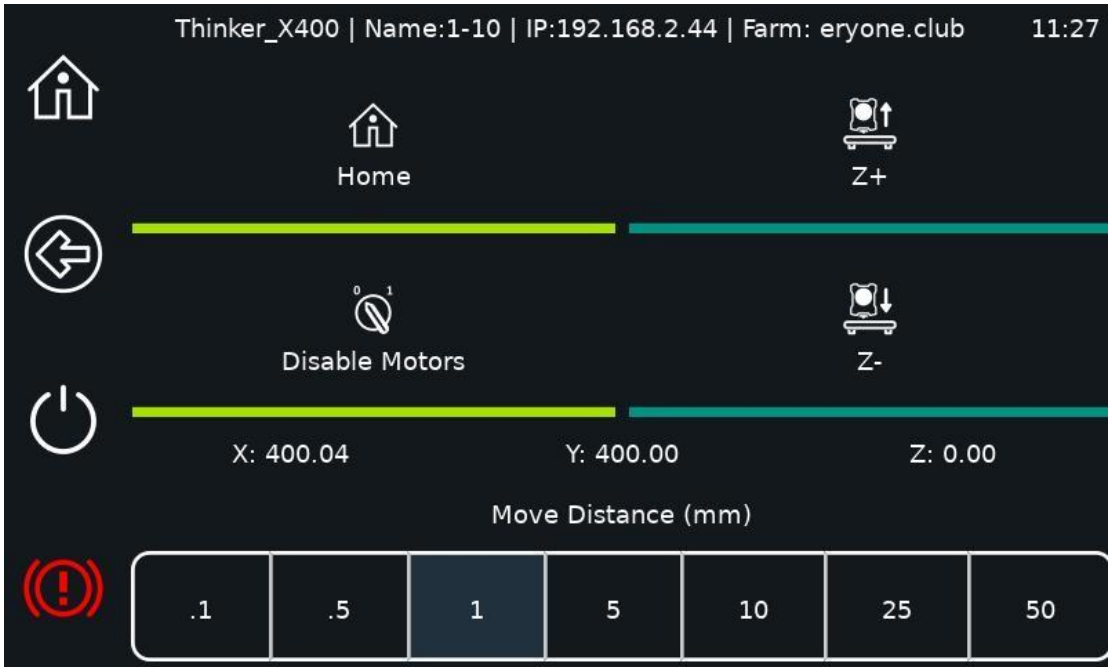
Home (click "Home" jump to the home page)



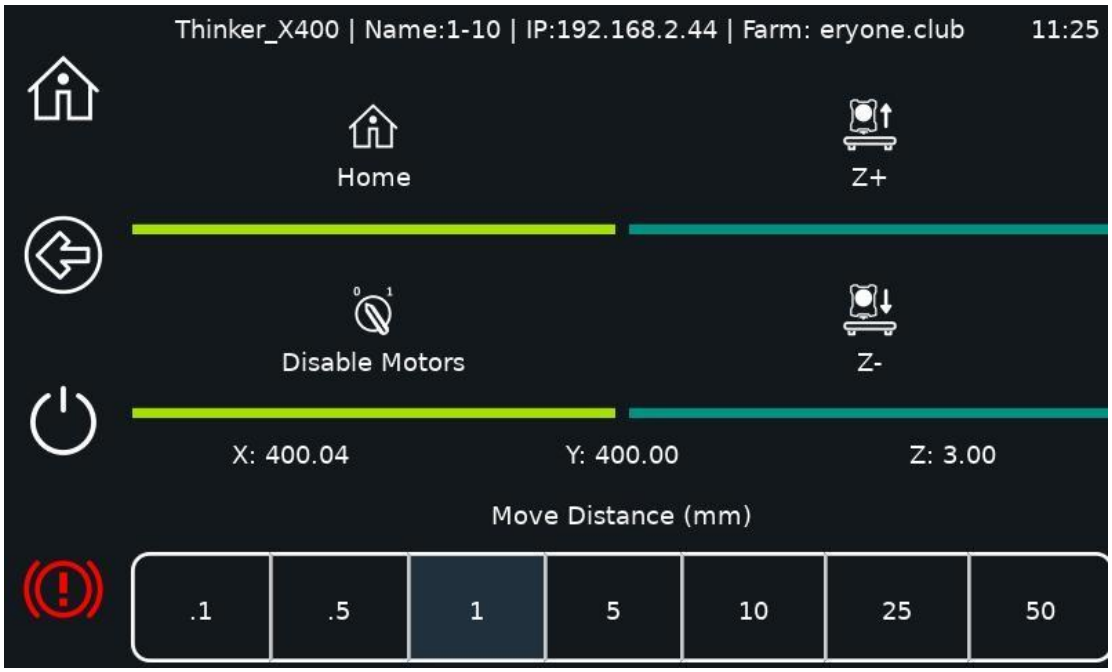
Home All: this function moves the X, Y, and Z axis to their predefined home positions. (X: 200, Y: 200, Z: 3).



Home XY Axis : This function moves the X and Y axes to their predefined home positions.(X: 400.04 Y: 400.00 Z: 0)



Home Z-axis : This function will move the Z axis to its predefined home position. (X: 400.04 Y: 400 Z: 3), The Z-axis can only be homed after the X and Y axes have been homed.

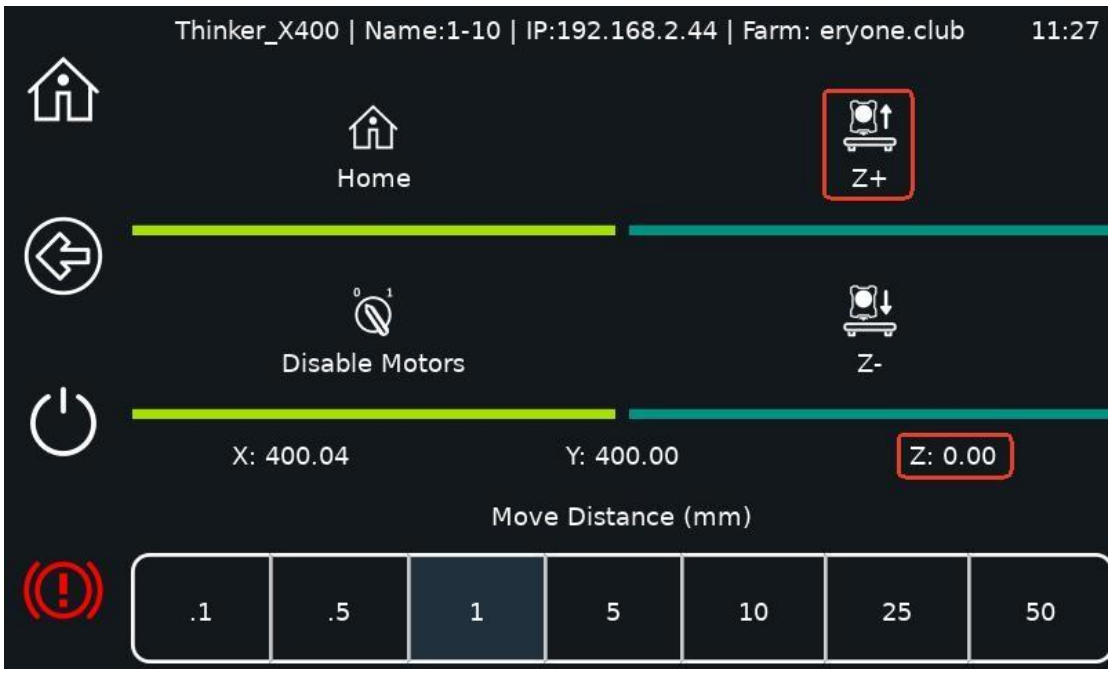


Note: For the above operation, if there is no other command during the

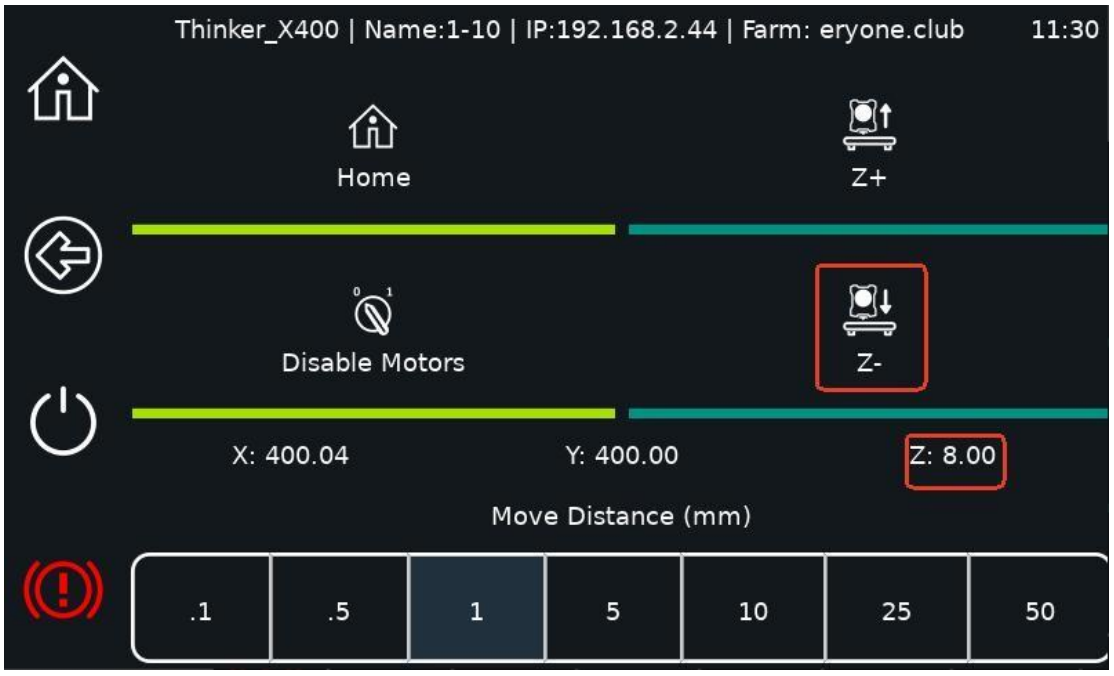
two-minute period, the printer will automatically shut down the motor.

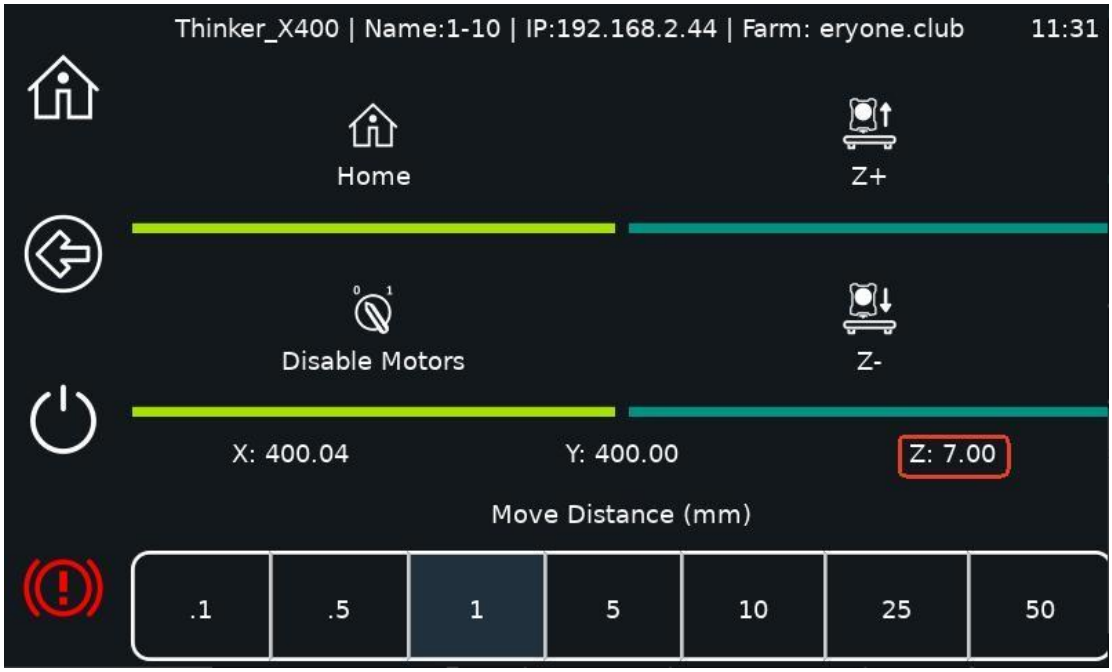
Shut down the motor: click on shut down to manually move the extruder in the X and Y axis direction.

Z+: Adjusts the extruder height. Please click the number next to "Z", then click "Z+" to raise the nozzle height.



Z-: Please click the number next to "Z", then click "Z-" to decrease the nozzle height.



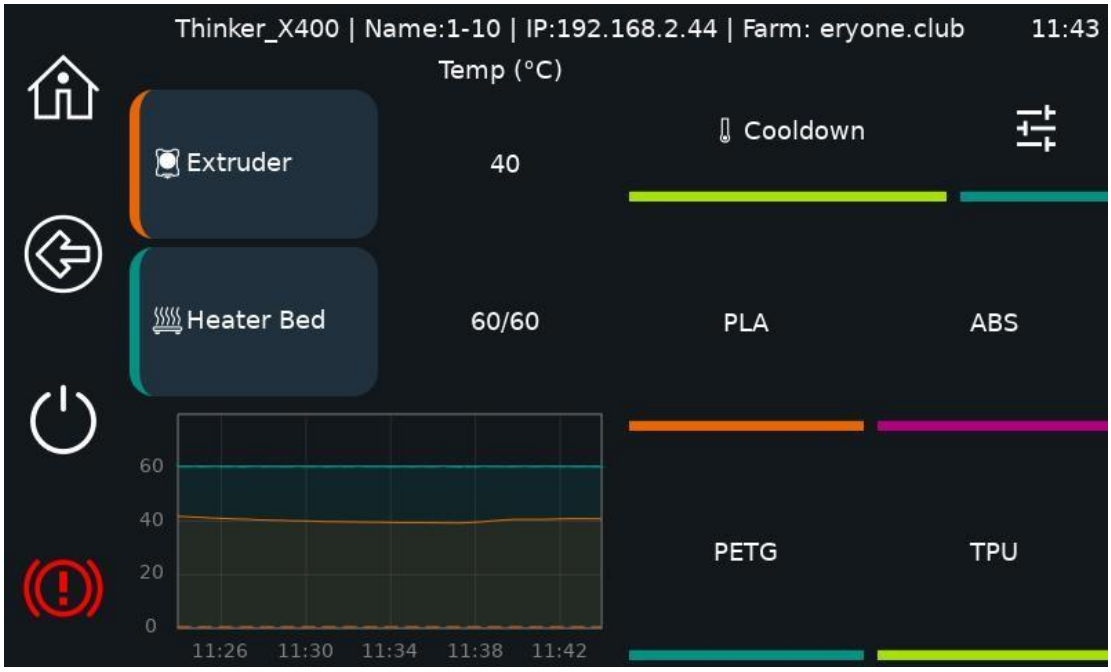


Note: If you need to adjust the extruder raised position, please perform a home operation first, and then click “Home All”.

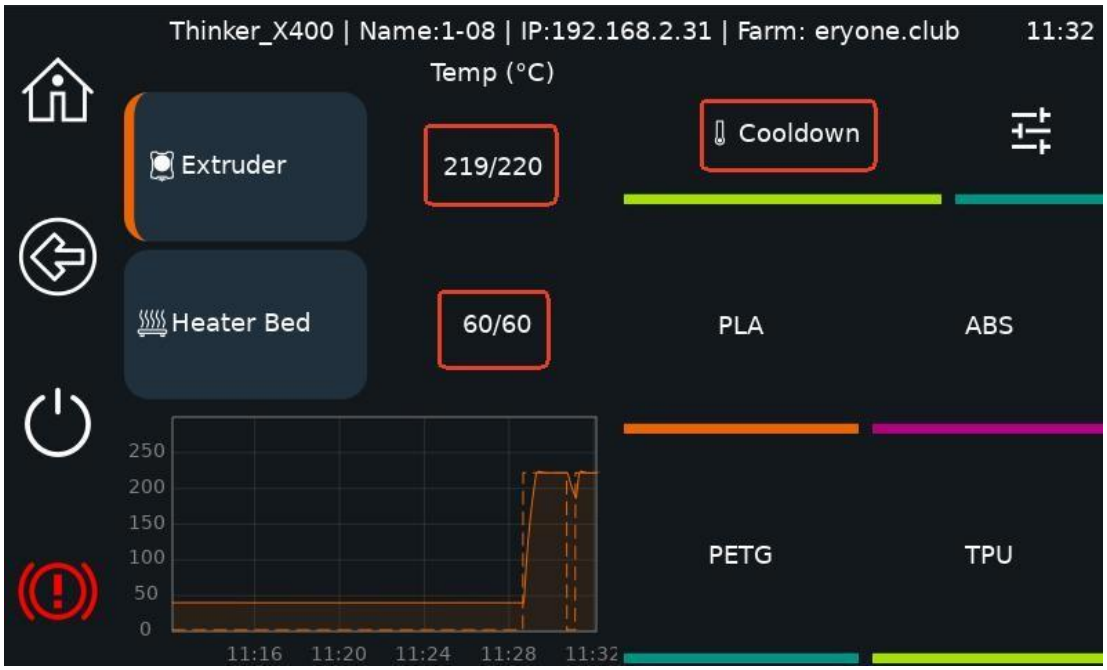

Thinker_X400 | Name:1-10 | IP:192.168.2.44 | Farm: eryone.club
11:35
Home All
Home Z
Home XY
Warning
Make sure there is no mode on the Bed?
Continue
Cancel

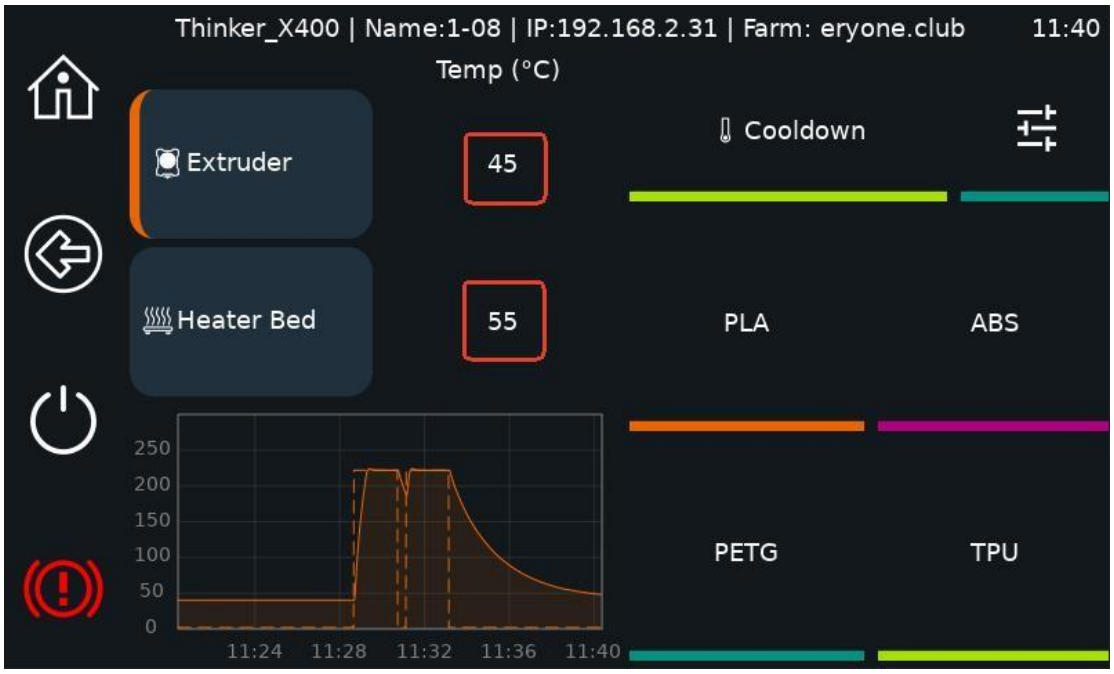
3.8 Temperature

⑧ Temperature Button: Adjusts nozzle and bed temperatures.



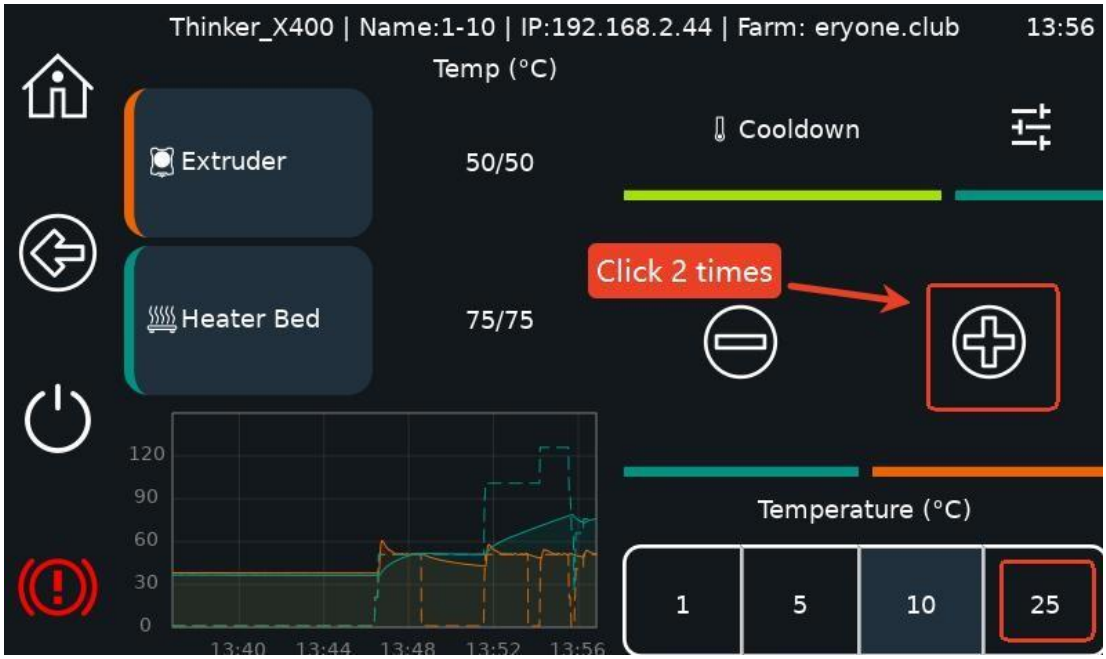
Cooldown: Gradually reduces temperatures to ambient levels.



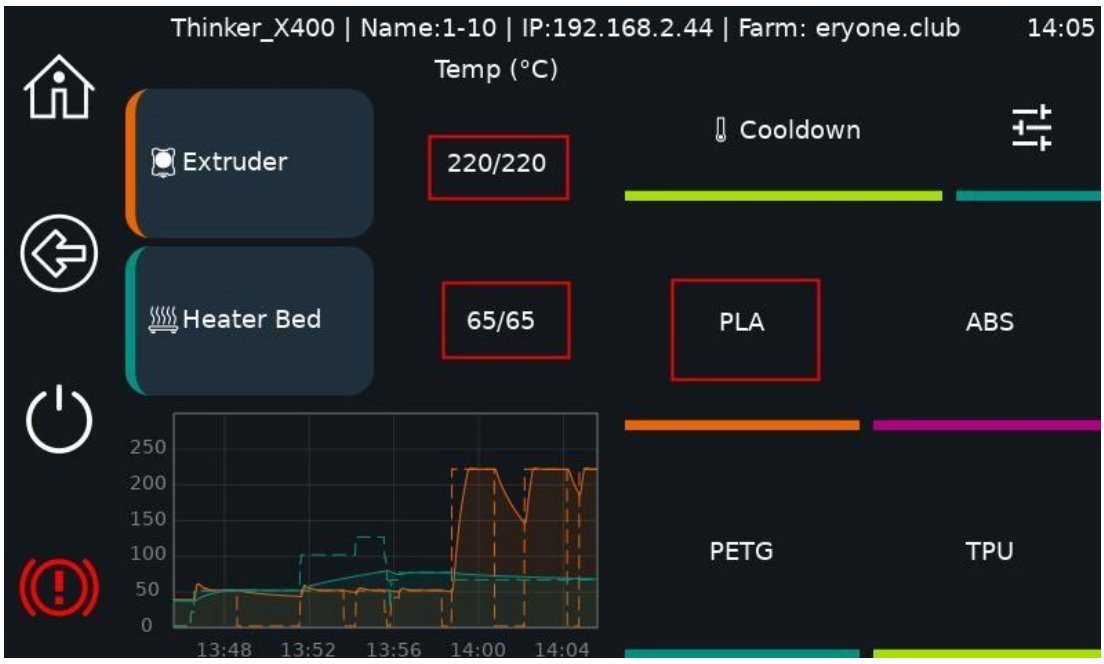


 ：Adjust the temperature of the nozzle and the heatbed (Select the temperature you want to adjust, select the value you need to adjust in the lower right, and finally click on the〝+〞and〝-〞button.)

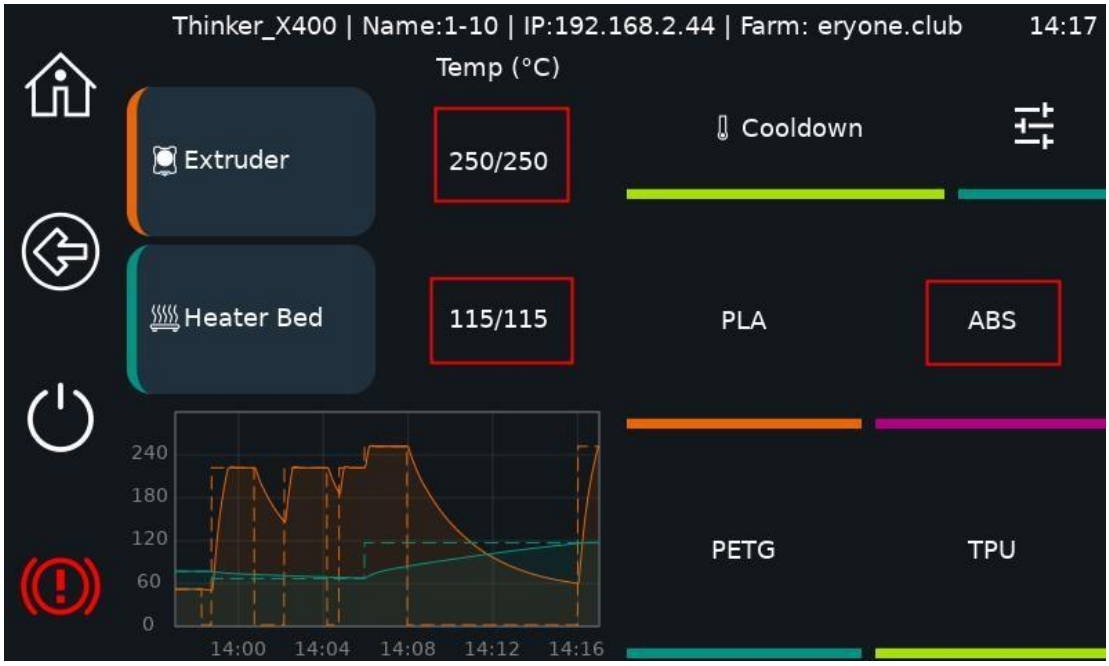
For example: to heat the nozzle to 50℃, you need to click 2 times〝+〞button.



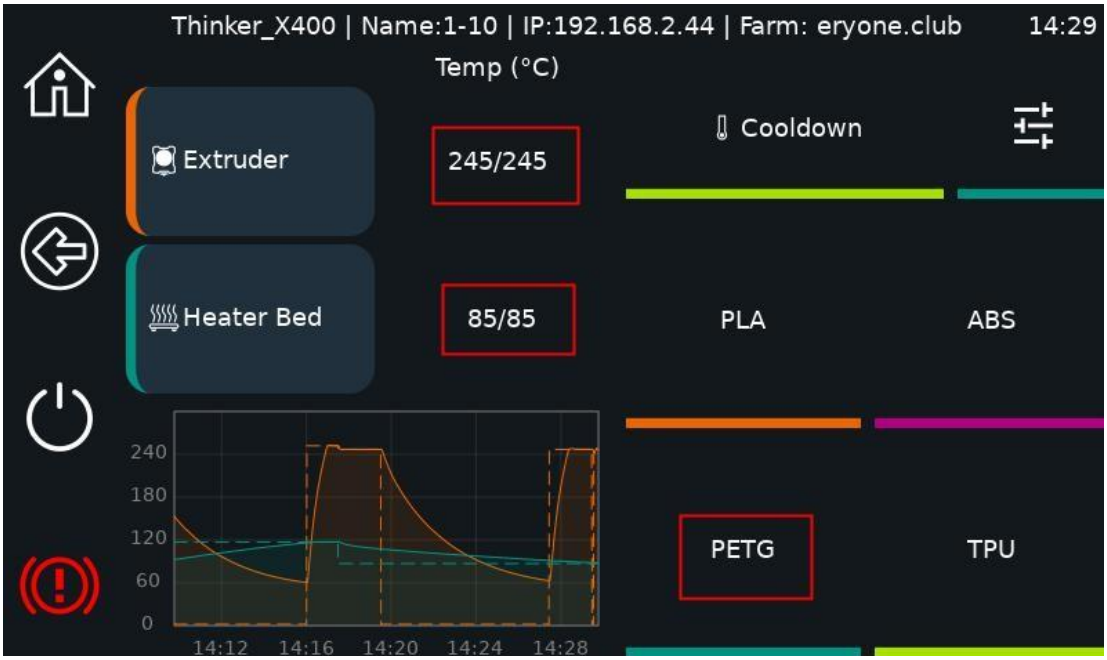
PLA: Nozzle heated to 220°C, heatbed heated to 65°C.



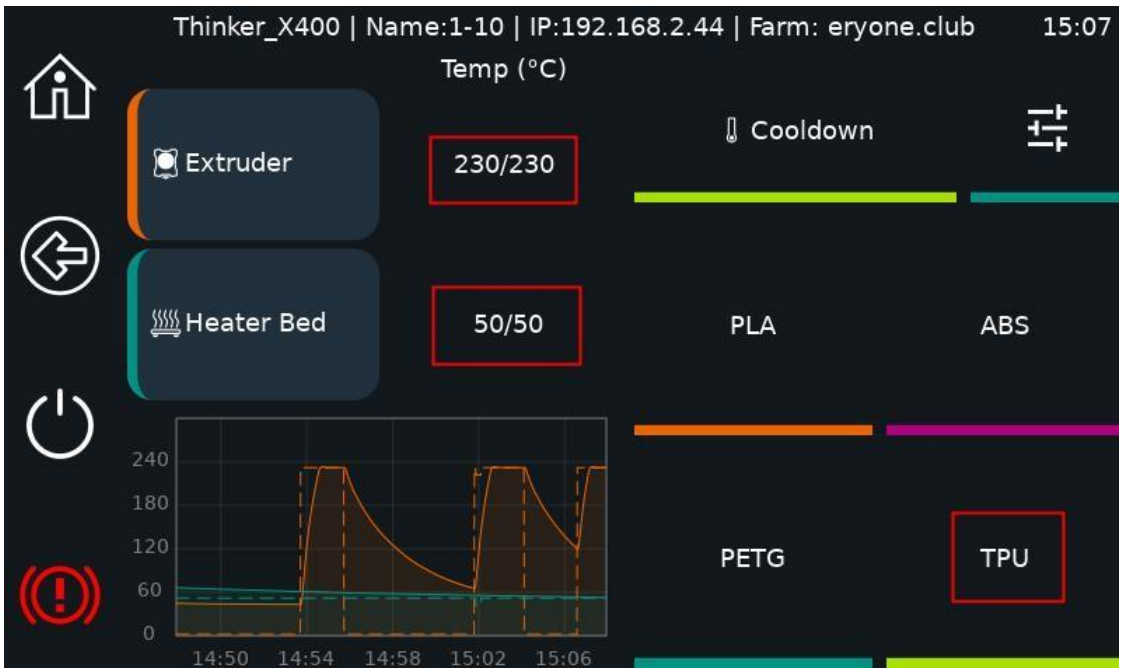
ABS: nozzle heated to 250°C, heatbed heated to 115°C.



PETG: nozzle heated to 245°C, heatbed heated to 85°C.

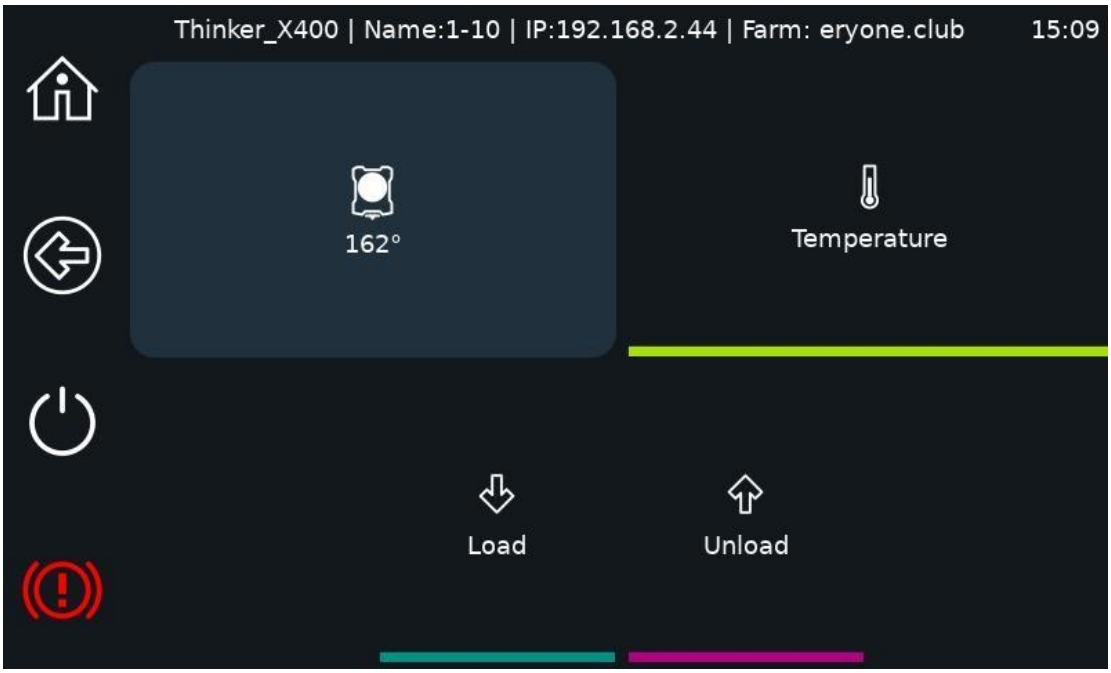


TPU: nozzle heated to 230°C, heatbed heated to 50°C.

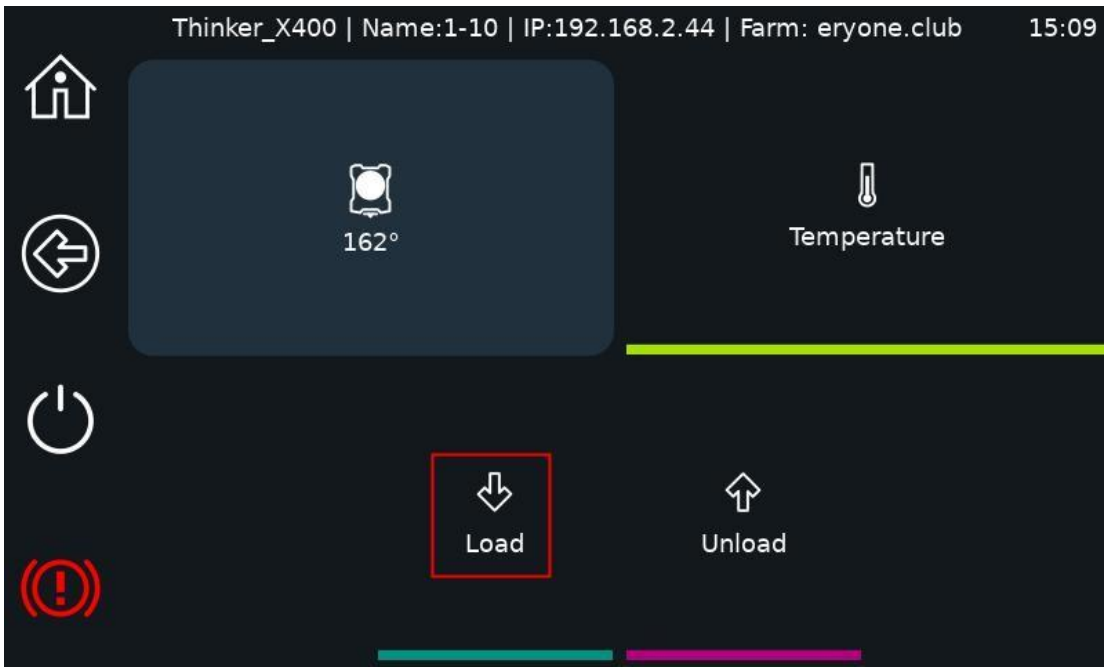


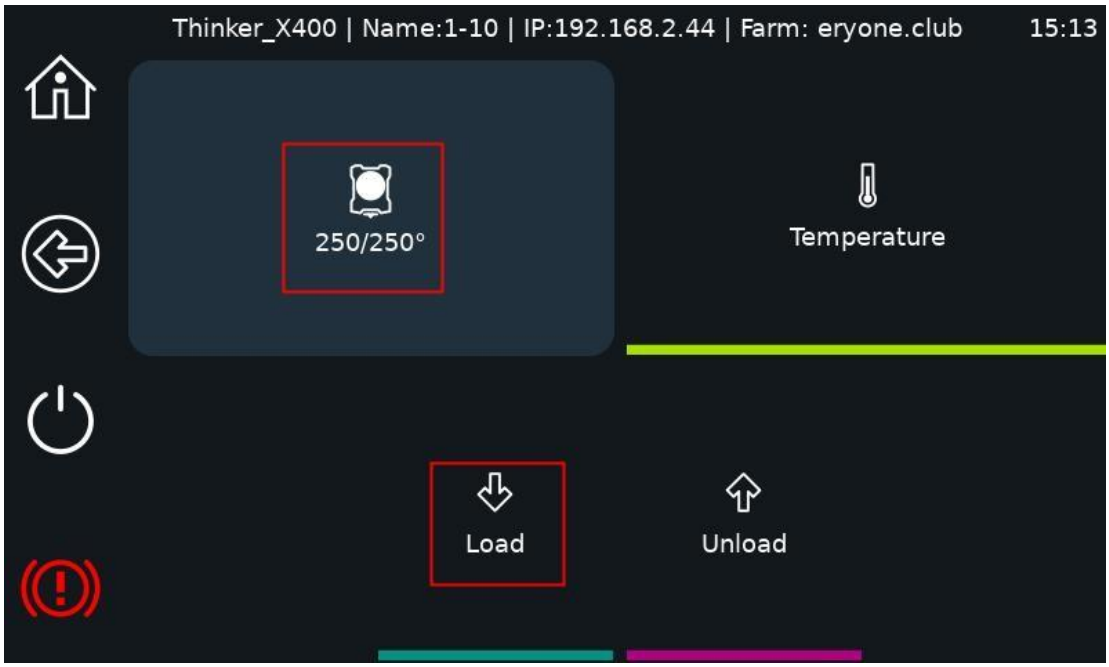
3.9 Extrusion

⑨ Extrude: Loads or unloads filament.

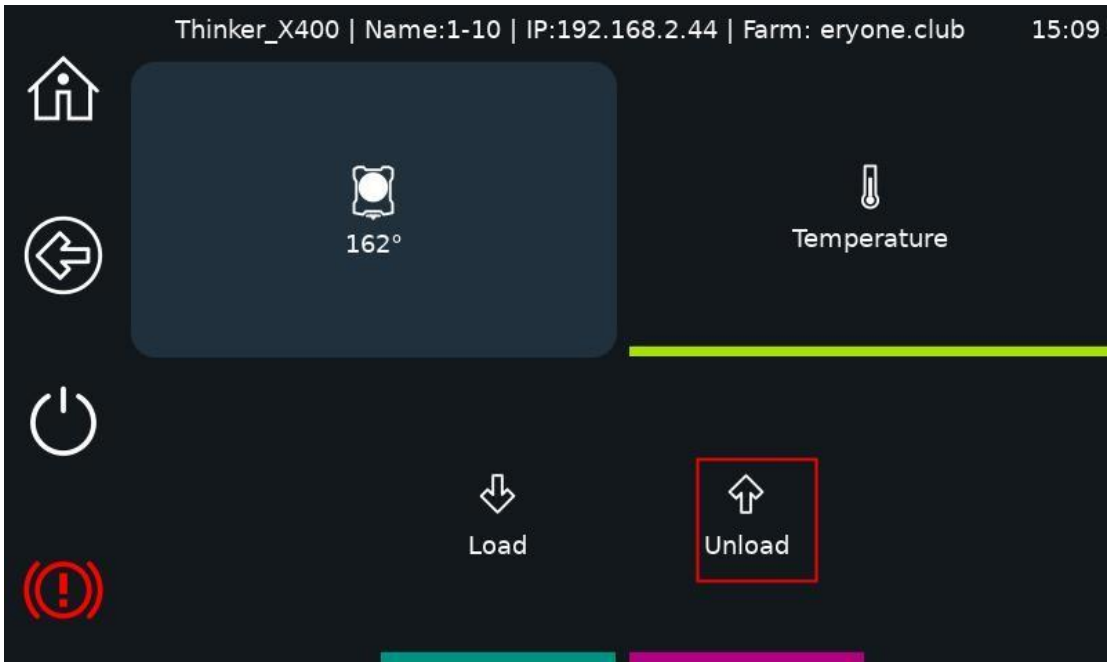


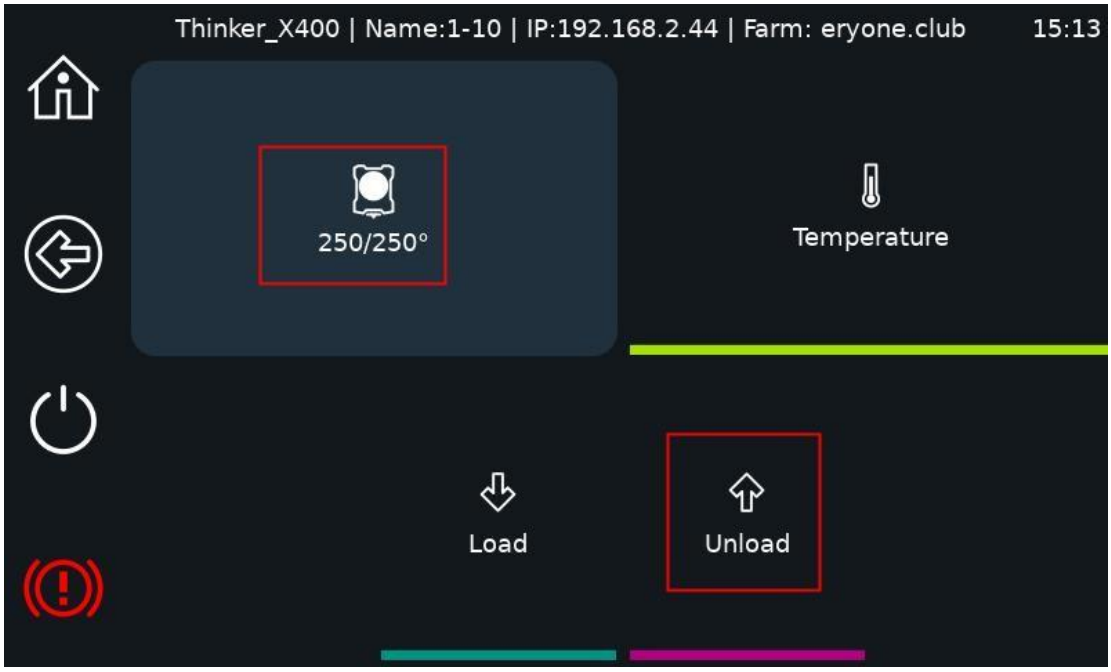
Load filament: nozzle heated to 250°C for loading.





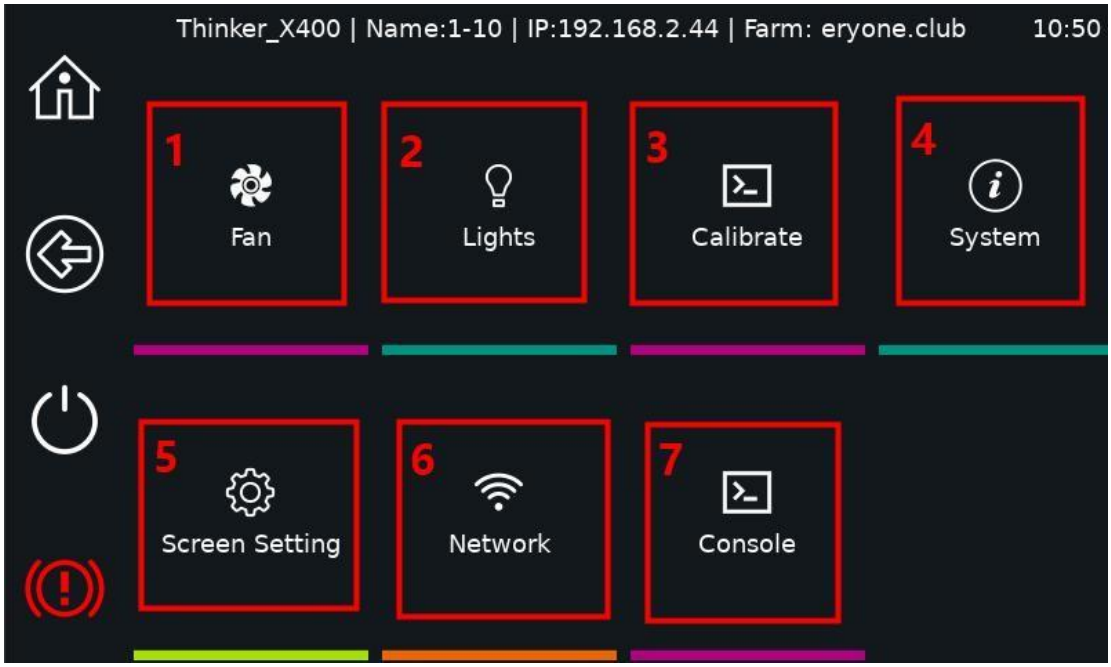
Unload filament: nozzle heated to 250°C to unload.





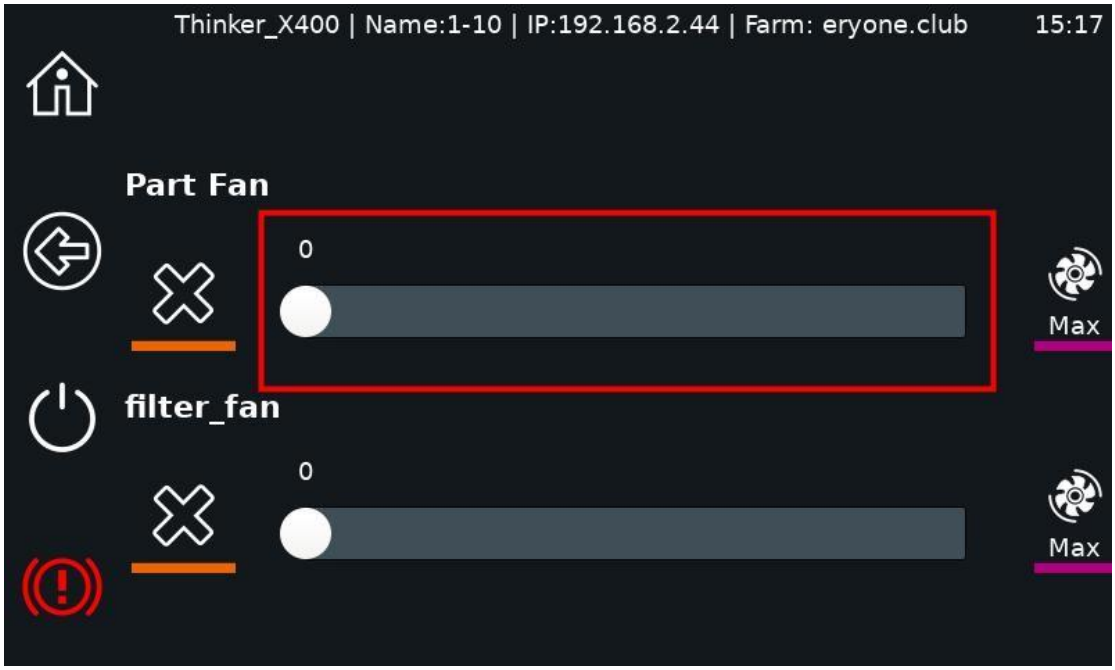
3.10 More Settings

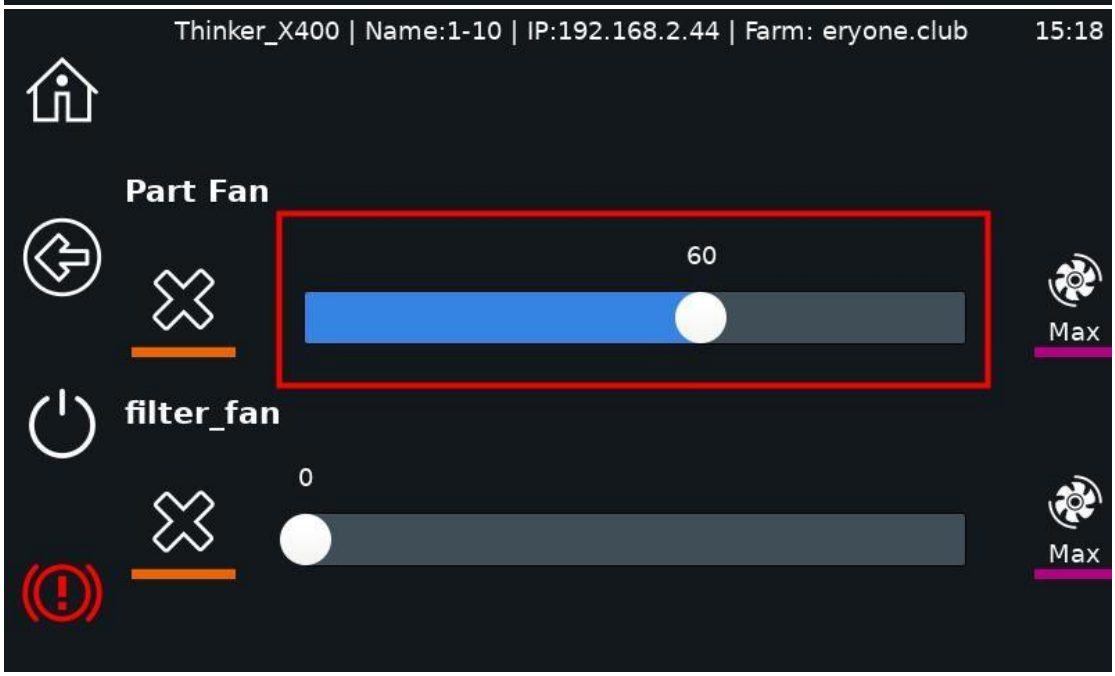
⑩ More Settings Button: Accesses advanced options.

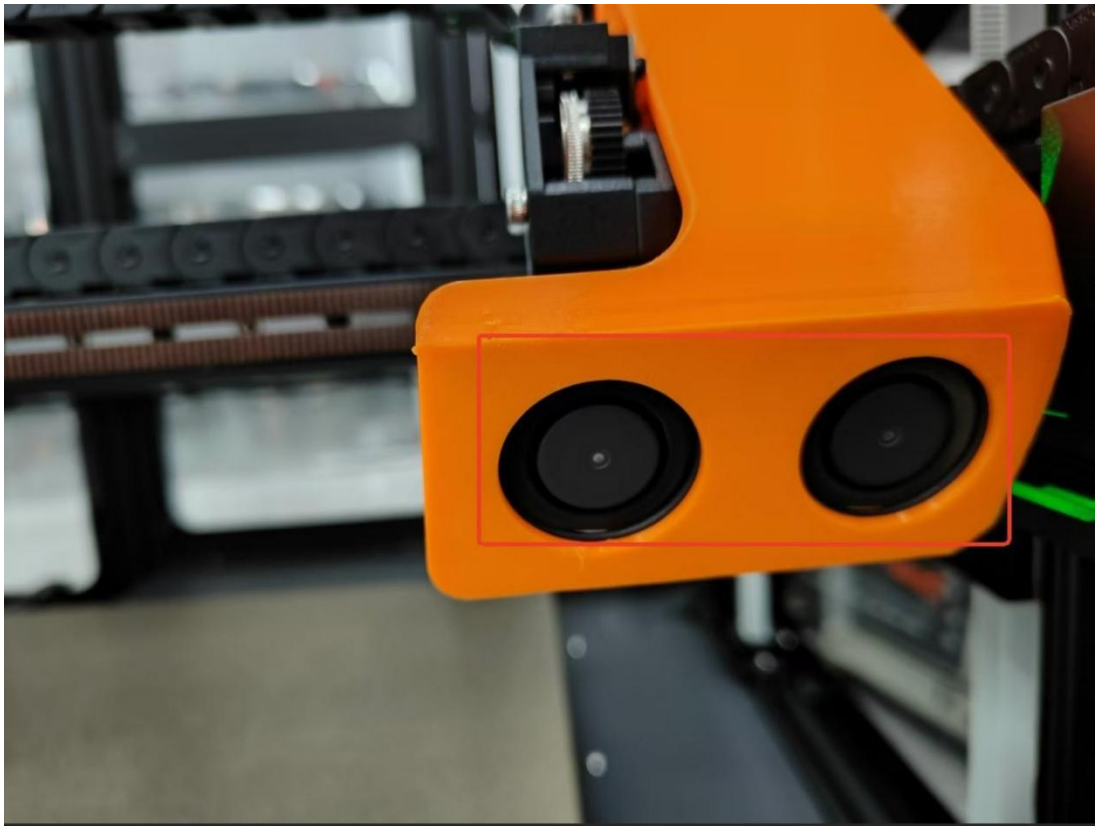


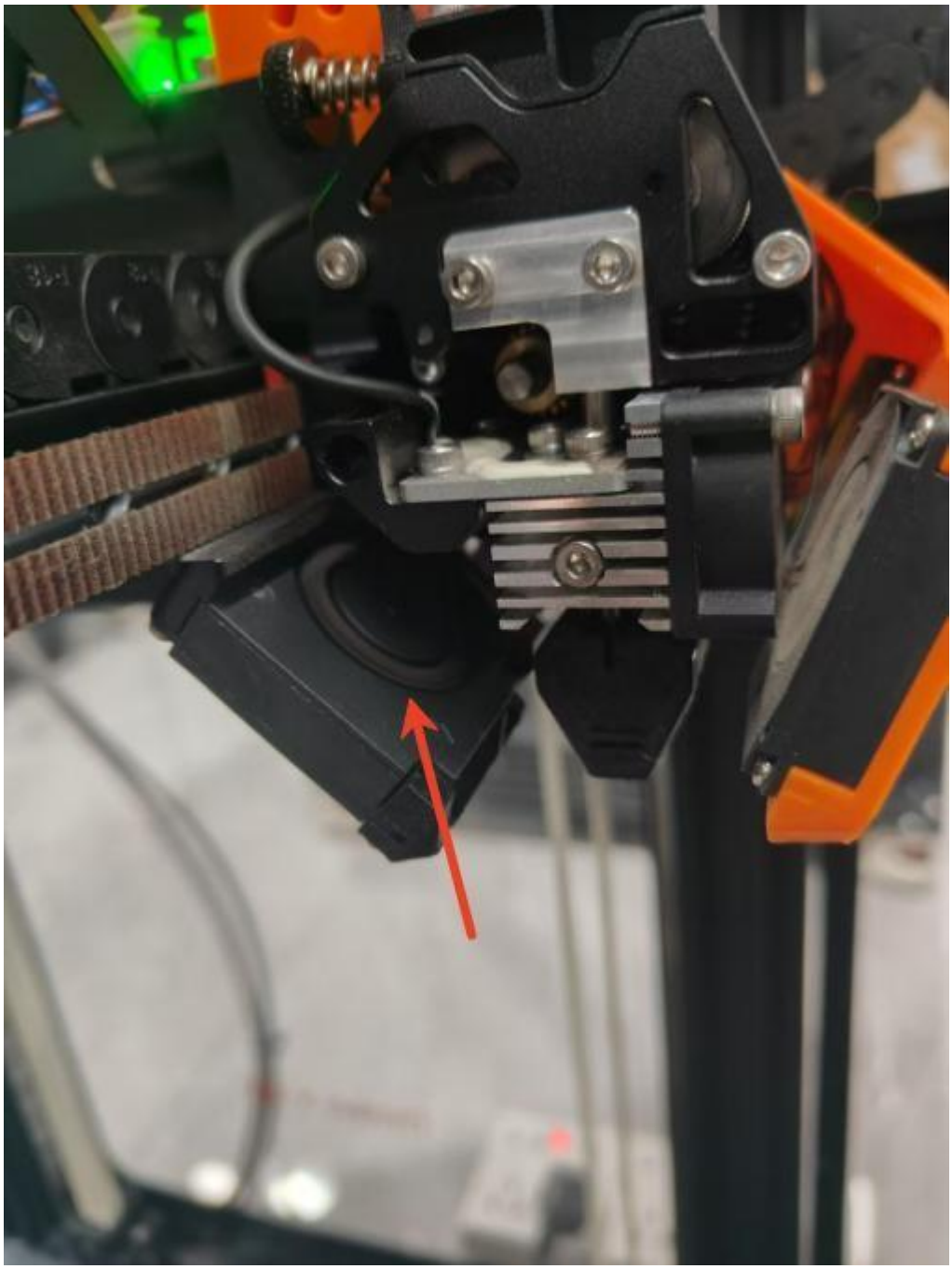
3.10.1 Fan

1. Fan Control: Adjusts fan speed.



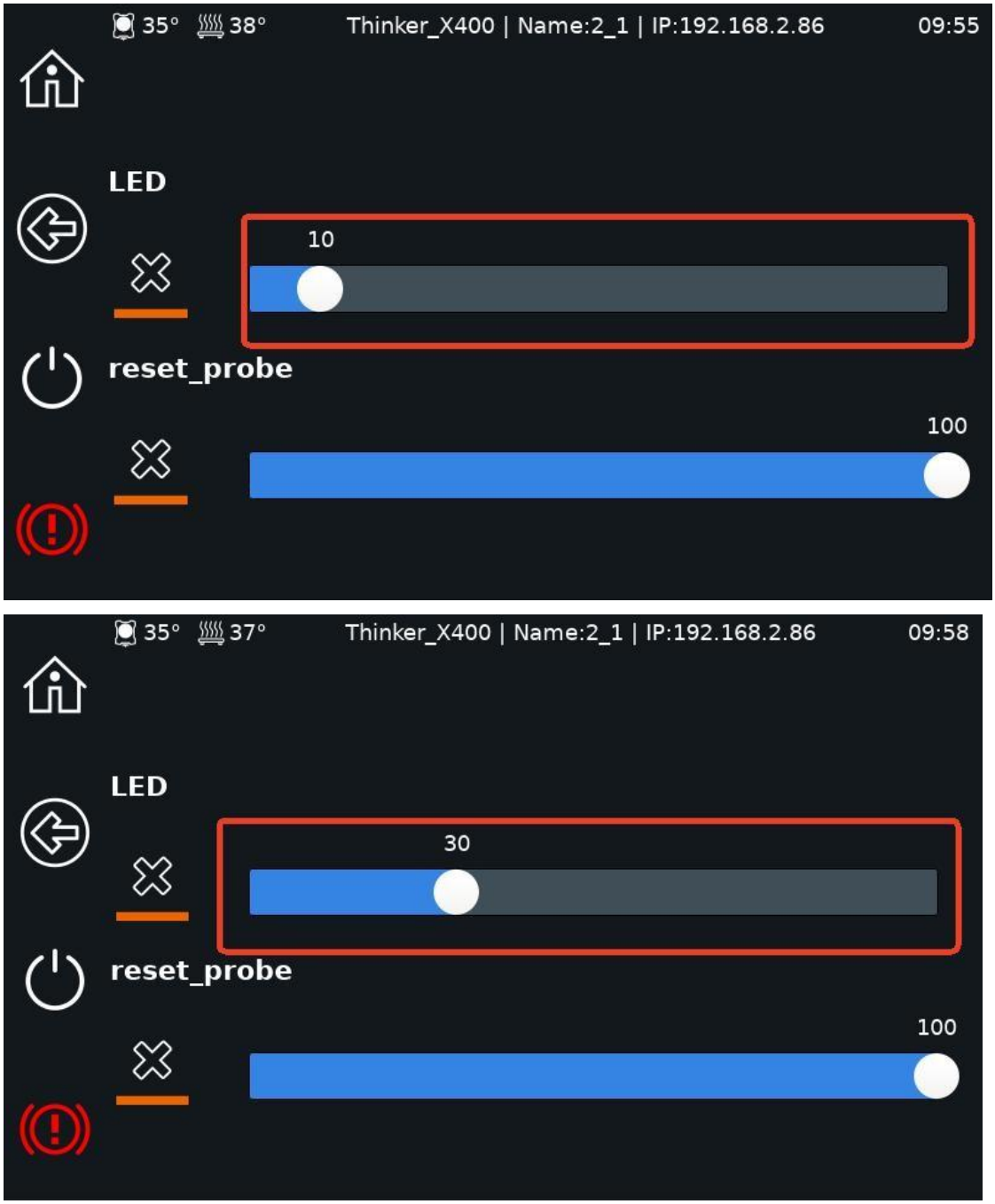






3.10.2 LED

2. LED Brightness: Adjusts light intensity.



3.10.3 Calibration

Calibration: Performs nozzle, bed, and resonance tests.

All Calibration: Click to perform Resonance Calibration, Heating PID Calibration, Heating PID Calibration BED, and Z-axis Tilt Calibration tests.

Heating PID Calibration: calibration test for nozzle extrusion temperature, can be performed when the extrusion temperature is unstable.

Heating PID Calibration BED: calibration test to stabilize the temperature of the heat bed, can be performed when the heat bed is unstable.

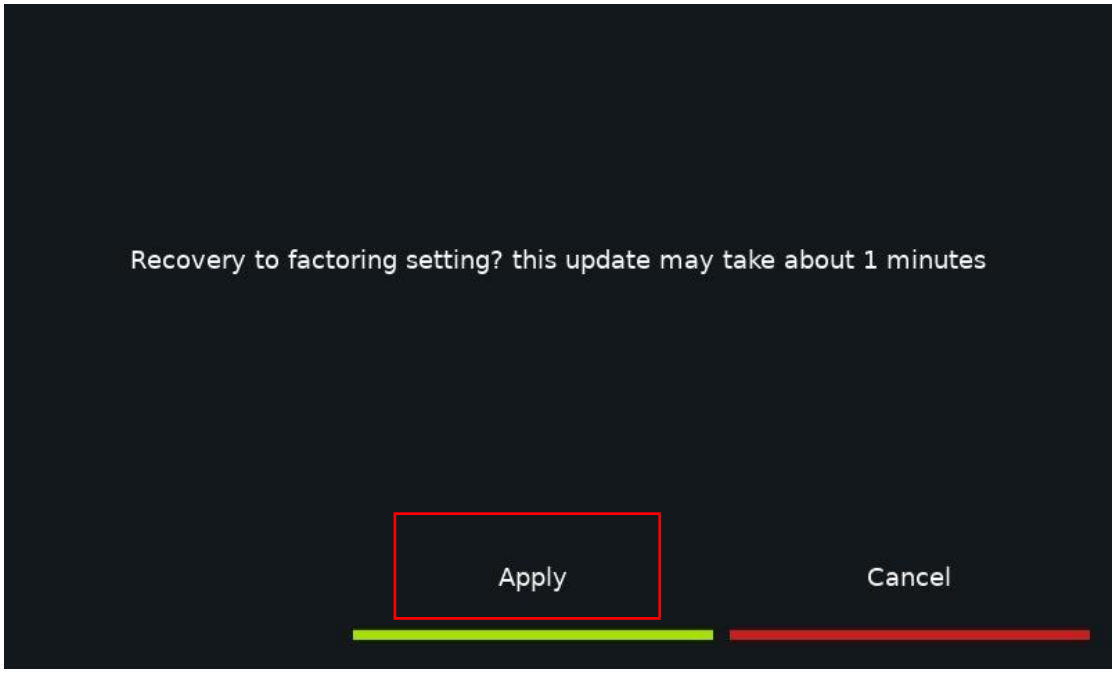
Z-**axis Tilt Calibration**: Z-axis leveling test for the nozzle to detect the height of the PEI metal plate Resonance Calibration: resonance test for X and Y axis, can be performed when the vibration pattern of the printed model is obvious. Z-axis leveling test for metal plate height.

Resonance calibration: Resonance test for X and Y axes, can be performed when the vibration pattern of the printed model is obvious.

3.10.4 System

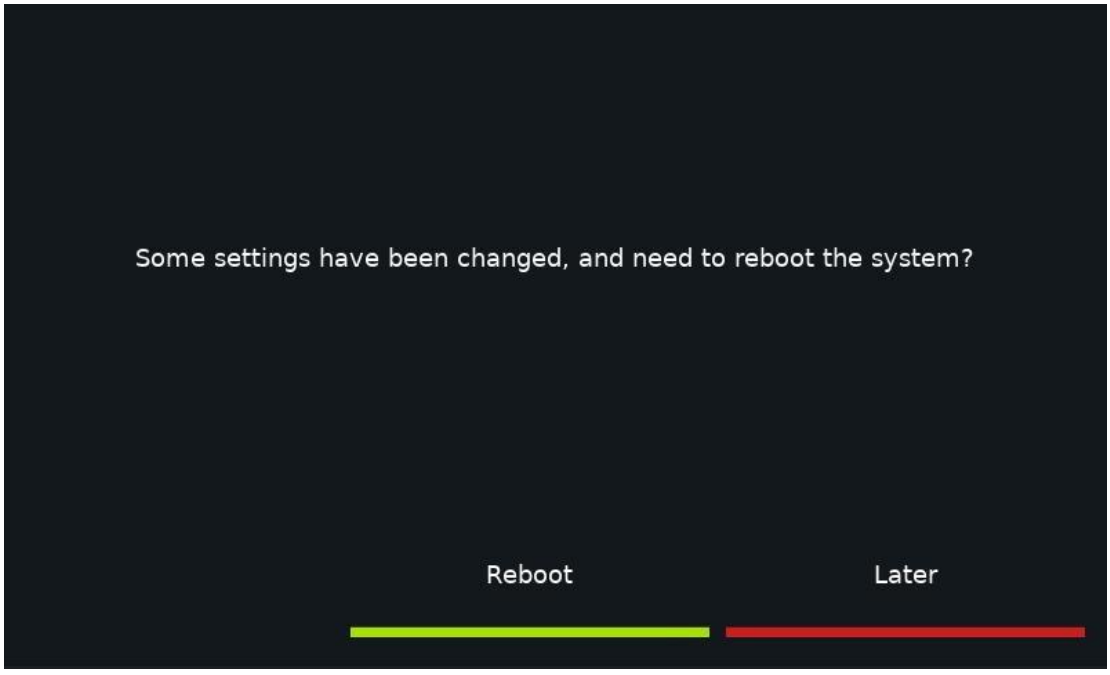
Firmware Update： Updates the printer's firmware.

It takes about 5-10 minutes to update the firmware.



Wait 5-10 minutes after clicking to complete the update.

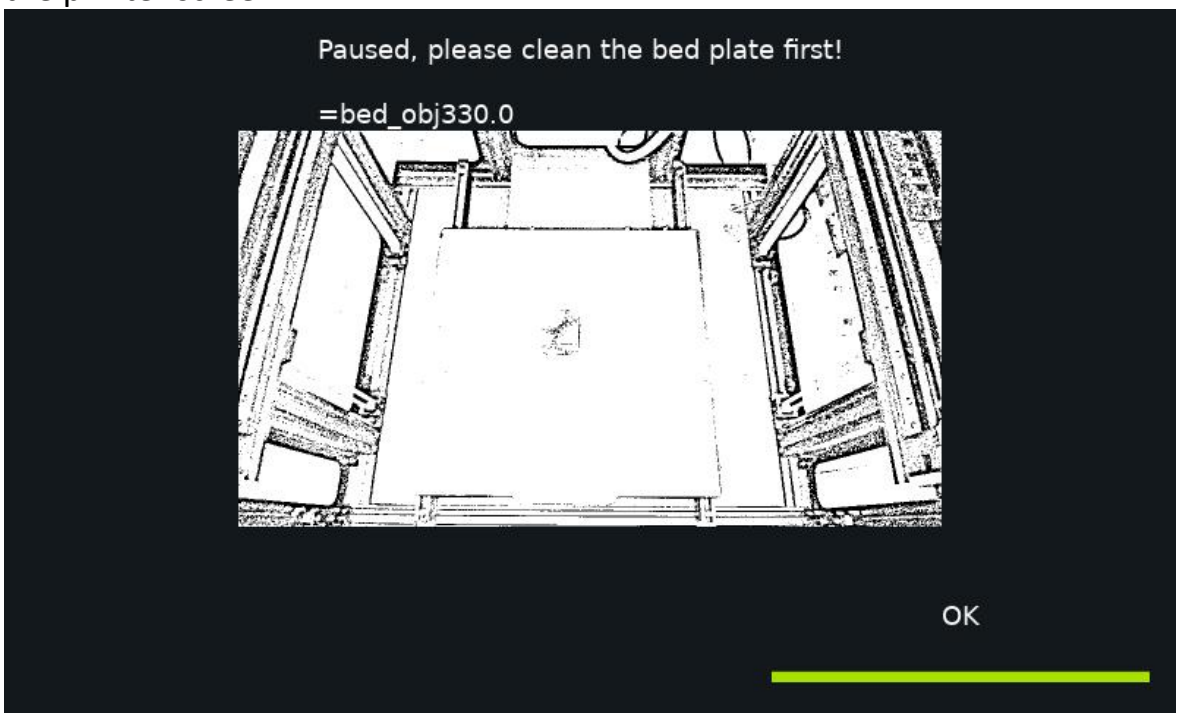
Note: After updating the firmware, a prompt box to roboot the printer will appear when you return to the main interface, and the system will be the latest version after rebooting, otherwise, the version will remain as the previous state.



3.10.5 Display Settings

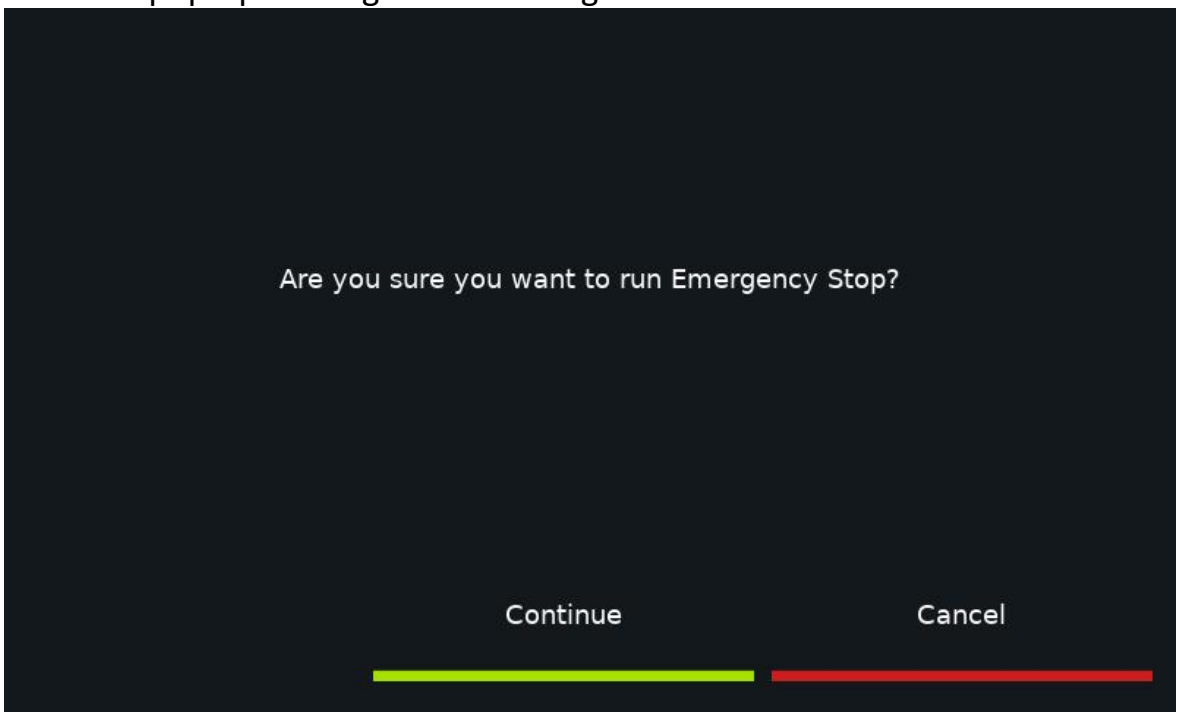
1.24 Hour Time: 24-hour day is used to display the time.

2.AI Camera: When the model on the PEI sheet is not removed and the printer starts a new print job, the AI Camera recognizes the model through the camera and pauses the print job while a picture of the model appears on the printer screen.



3.Chamber heating：Click to toggle the chamber heating module.

4.Emergency stop to be confirmed: click on the emergency stop button to receive a pop-up message after turning it on.

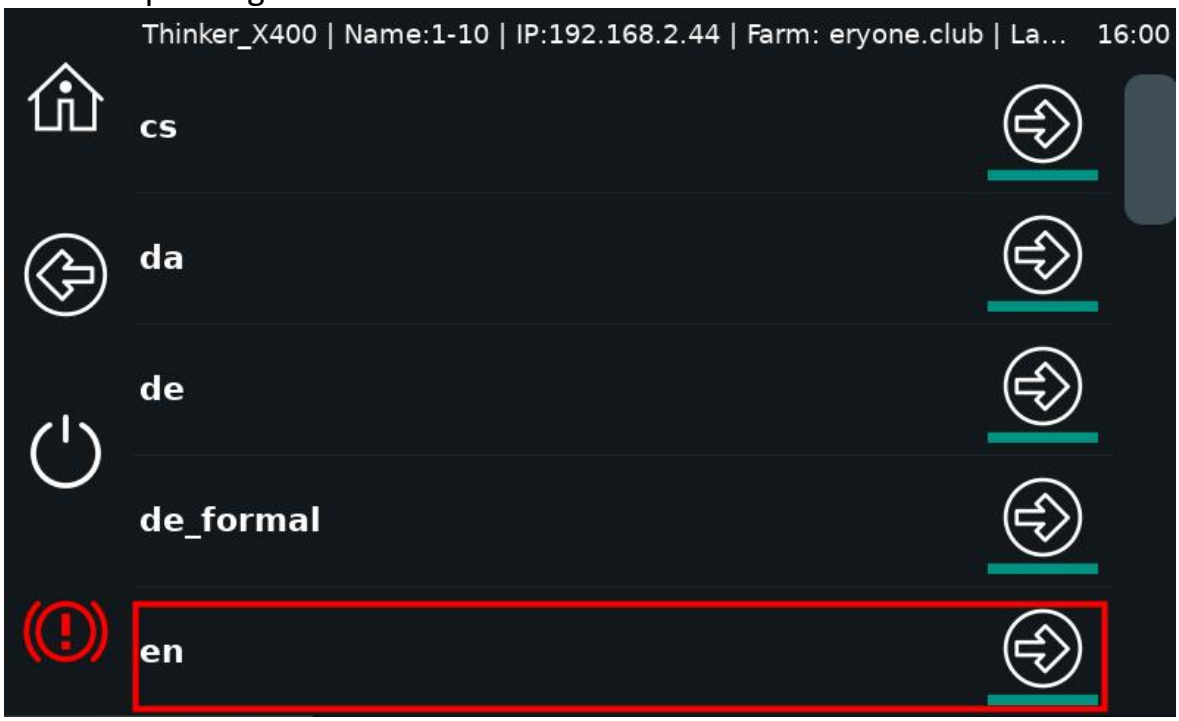


5.Connect to Cloud：Click to connect to eryone.club

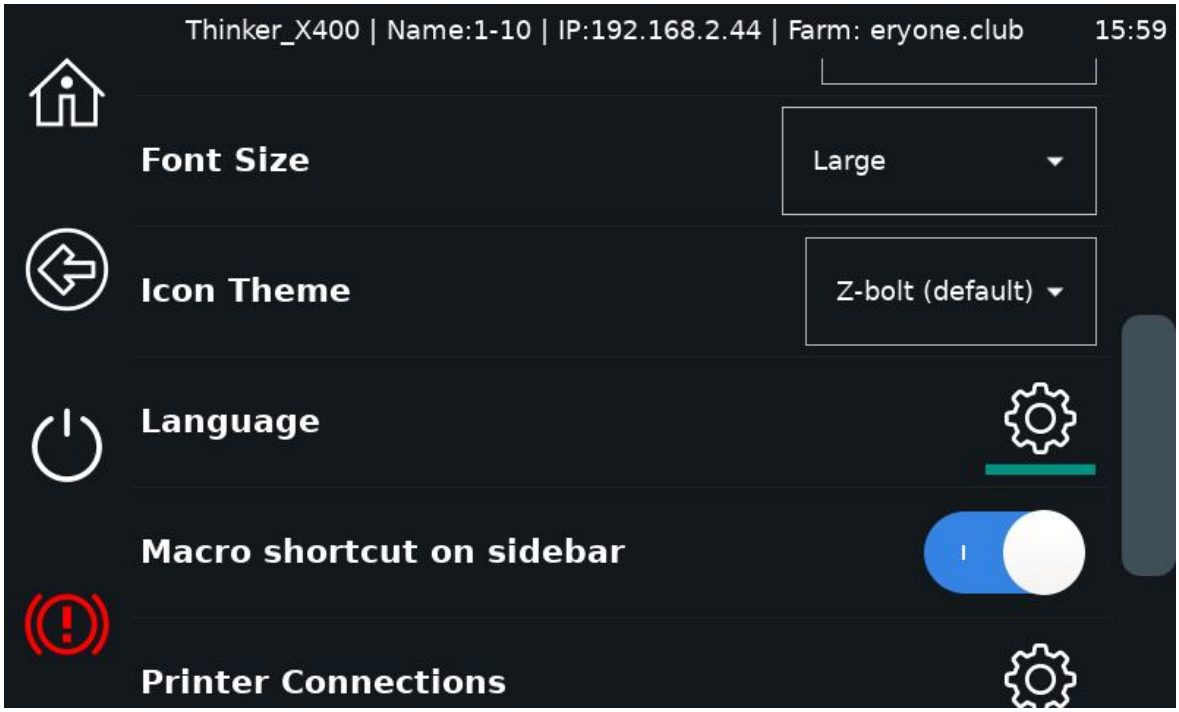
6.Estimation of remaining time: 4 types: “Auto”, ‘File’, “Used Supplies”, “Slice File”. 4 calculation methods to predict the remaining printing time.

7.Font size: Change the font size.

8.Language: Select the interface language according to your own preference. For example: English



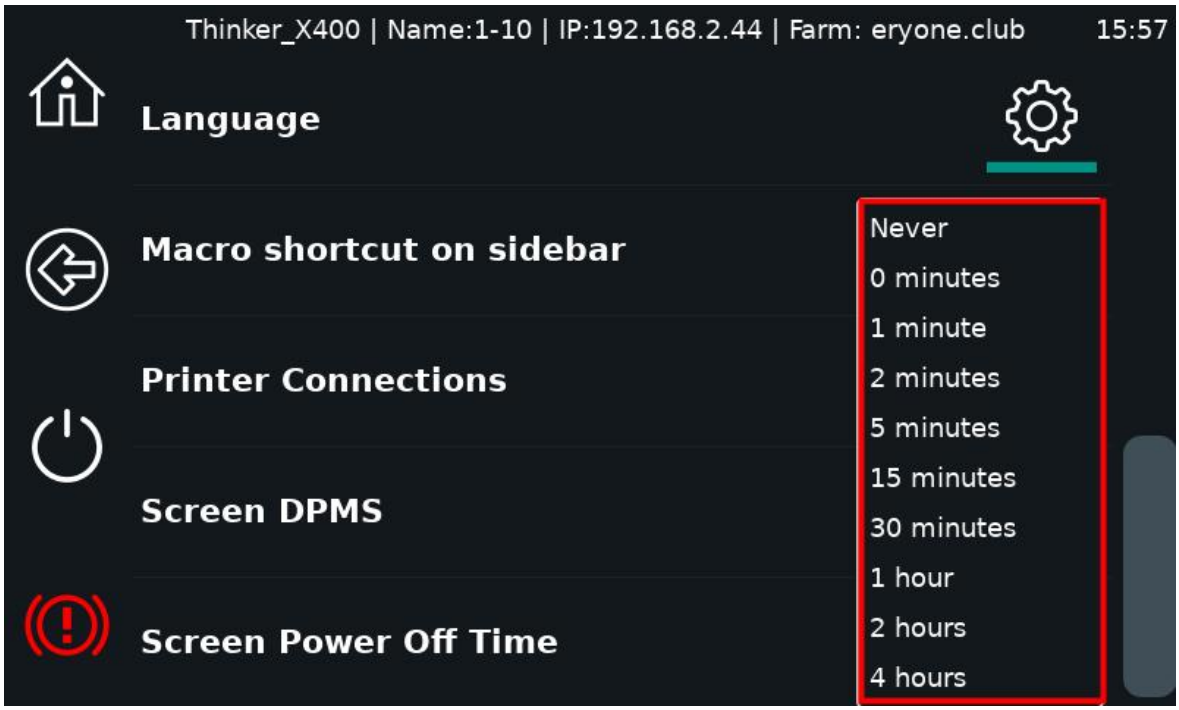
9.Macro shortcut on sldebar: Show Sidebar Shutdown Button.



10.Printer Connections:multiple network printers can be added per LCD.

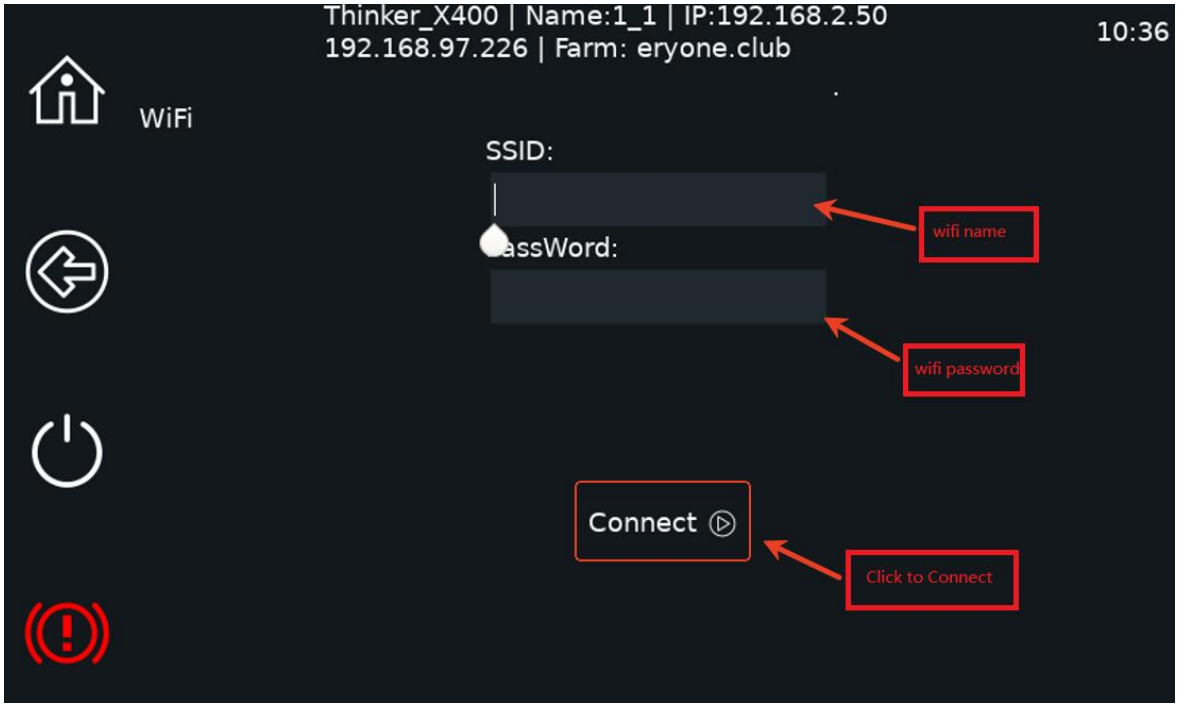
11.Screen DPMS：Turn on the LCD will automatically black screen standby.

12：Screen Power Off Time：selectable screen hibernation time.



3.10.6 Network Settings

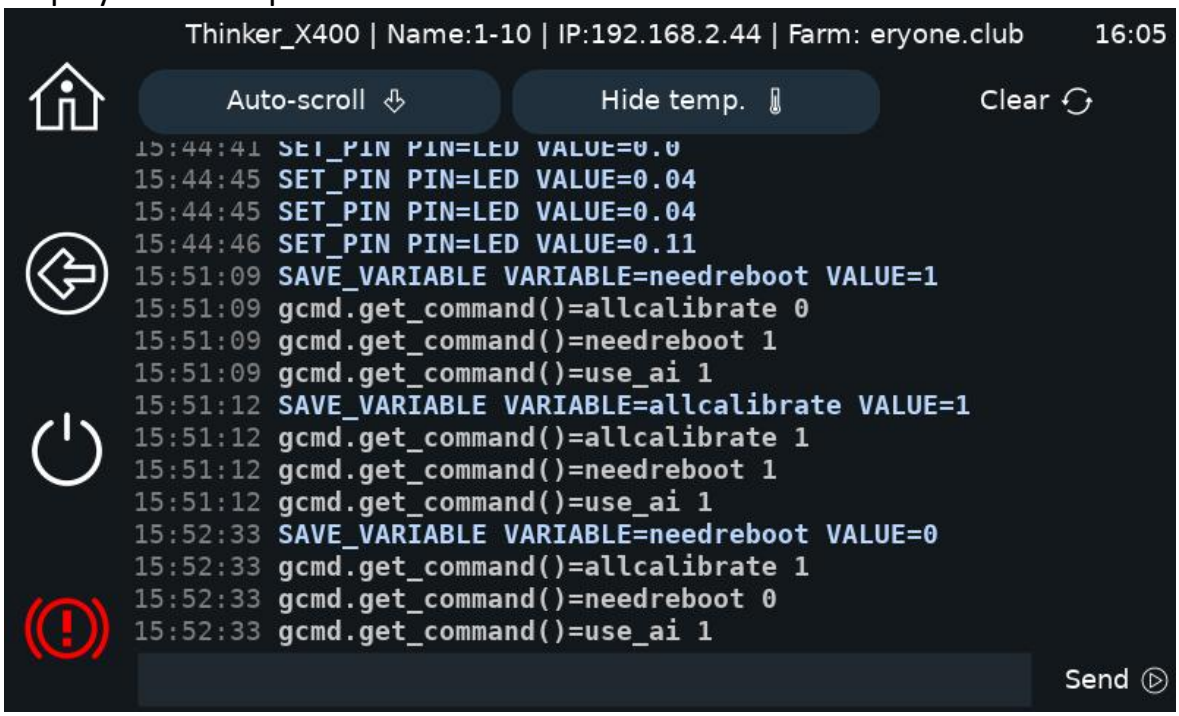
Configures Wi-Fi (2.4GHz only)



Note: The Wifi name cannot be entered in Chinese characters.

3.10.7 Console

Displays detailed print information and commands.



“G28”： Home All
“BED_MESH_CALIBRATE”： Heatbed Calibration
“UNLOAD_FILAMENT”： Unload Filaments
“LOAD_FILAMENT”： Load Filaments
Modify machine name： “N + the name you want”

3.11 Print

⑪（Click to jump to the Print Cache page）

①:Sort by name

②:Sort by date

③:Delete all model files

④:Refresh file

⑤:Modify file name

⑥:Delete files

⑦:Print file

4、Orca-Slicer Software Brief Guide

Note: Make sure you have read the Quick Start Guide and successfully completed your first print before reading!

Printing of 3D models requires preview slicing by slicing software before printing.

4.1 Pre-Print Preparation

1. Obtain a 3D model file (STL/STEP/OBJ).
2. Import the file into Orca-Slicer.
3. Adjust parameters (recommended: use Eryone's default settings).
4. Preview and slice the model.
5. Export the sliced file to a USB drive or send it to the printer via network.

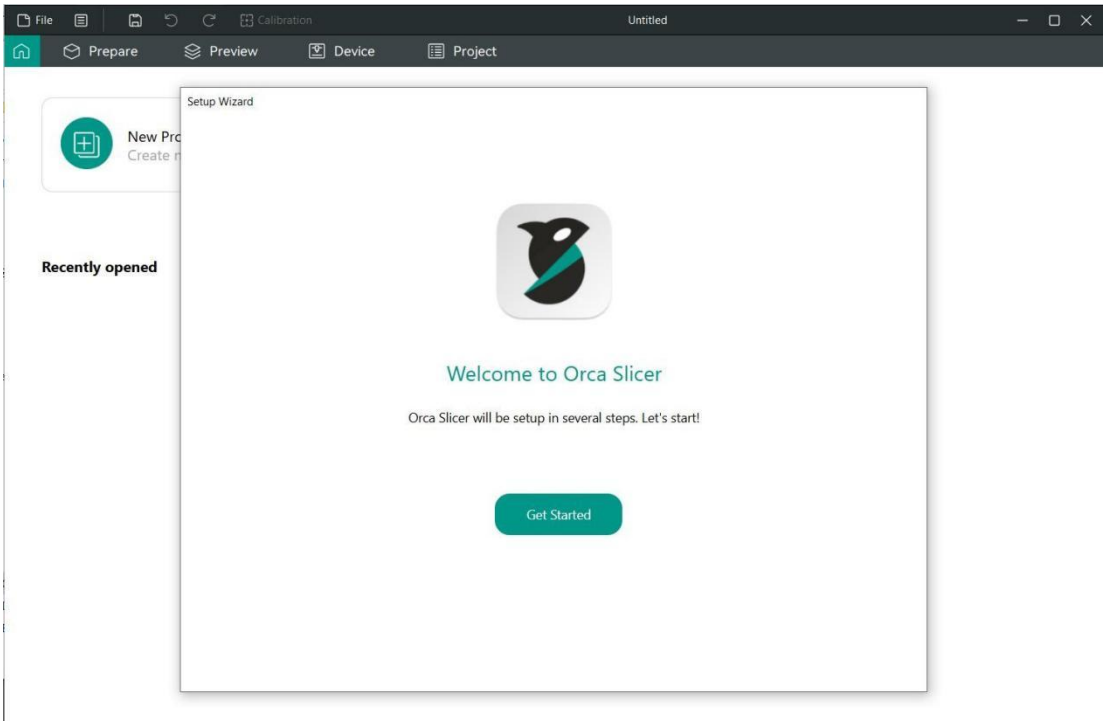
4.2 Download Link

https://drive.google.com/drive/folders/1htD4KUY9WmH9W7UyBleRF0uzNoNothT1?usp=drive_link

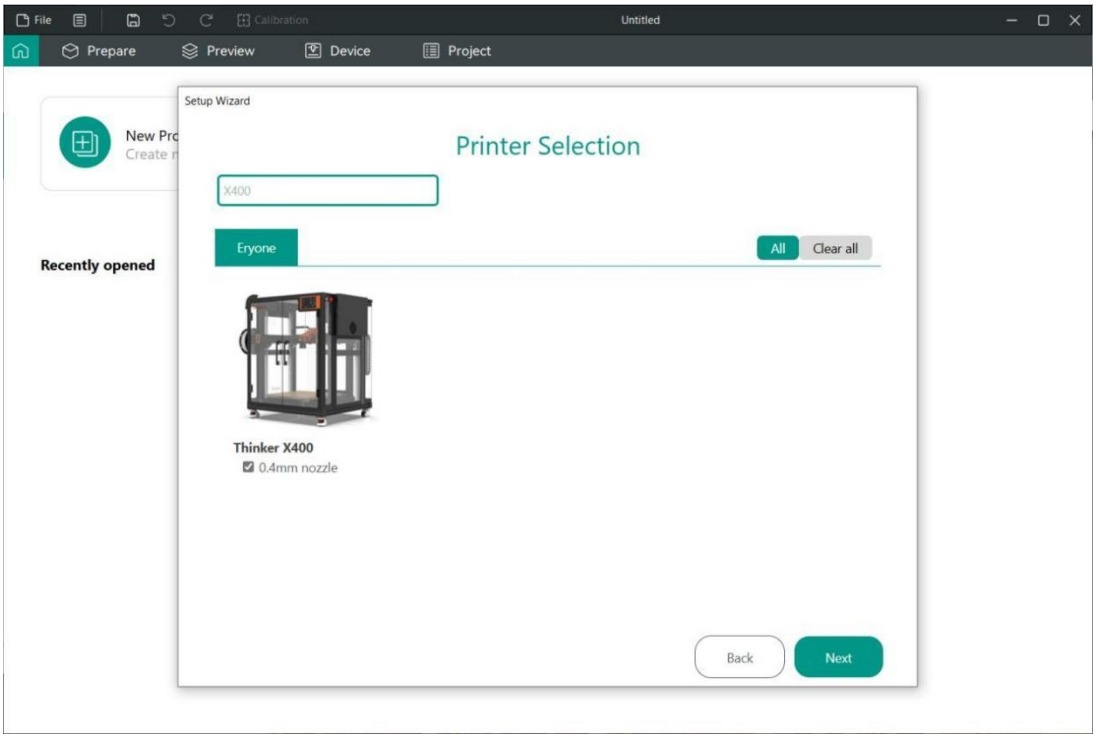
Download Orca-Slicer to ensure that you have the official Eryone print parameters for your supplies.

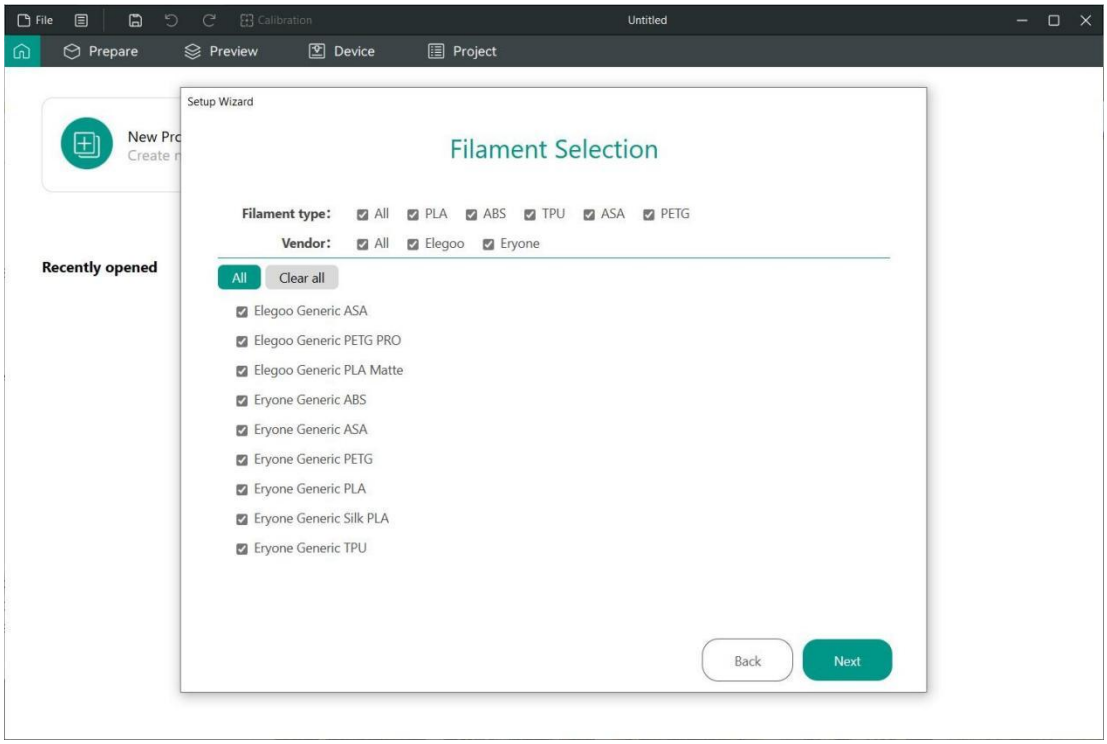
4.3 How to Use Orca-Slicer

1. Install and open Orca-Slicer.

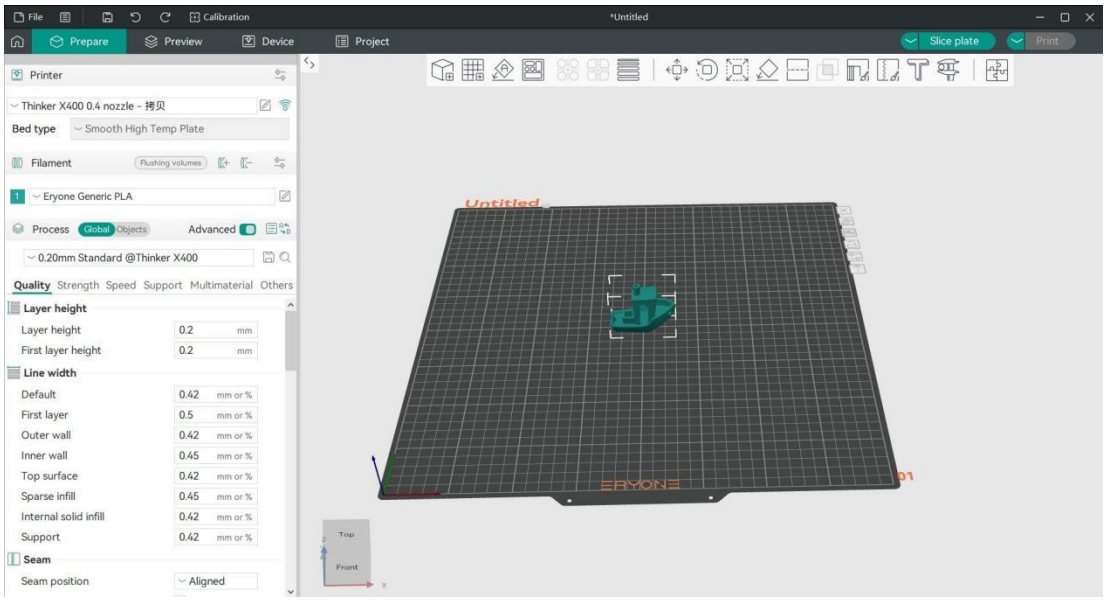


2. Select "Thinker X400" and enable Eryone’s filament parameters.

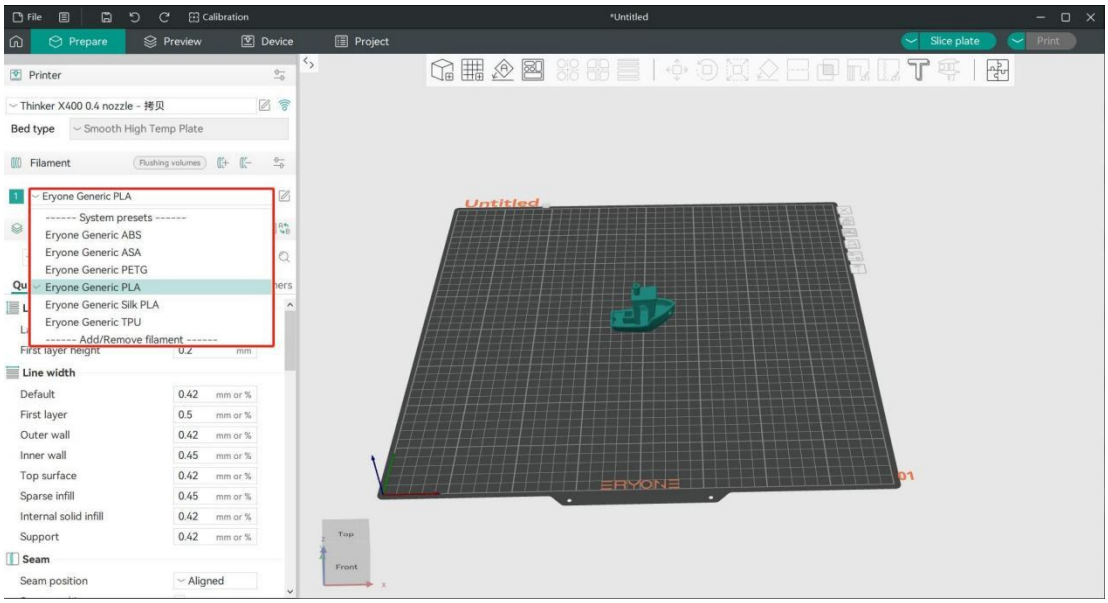




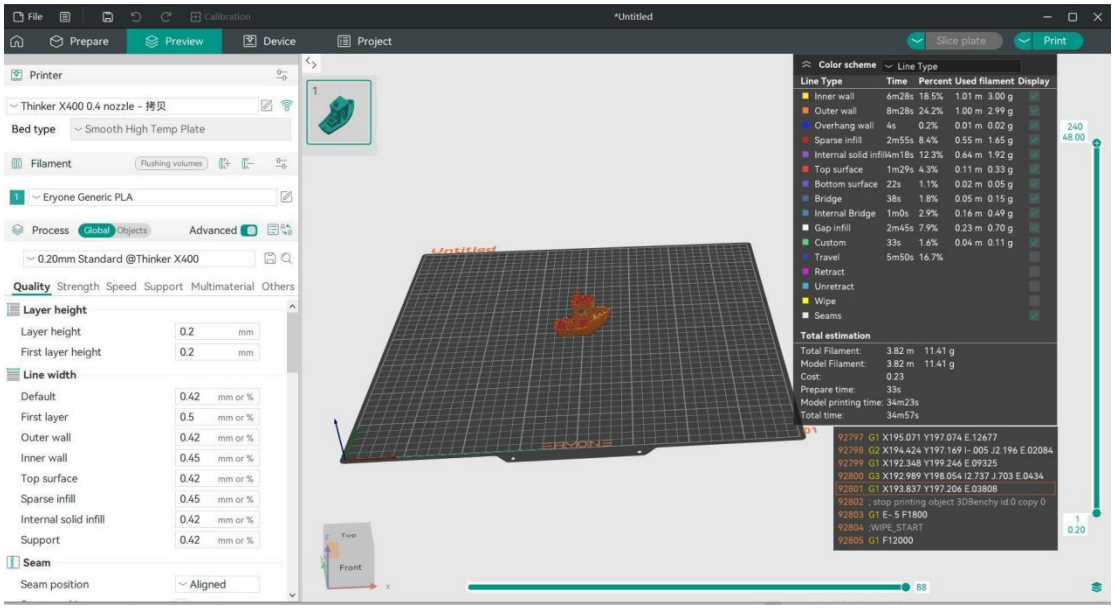
3. Import the model file.

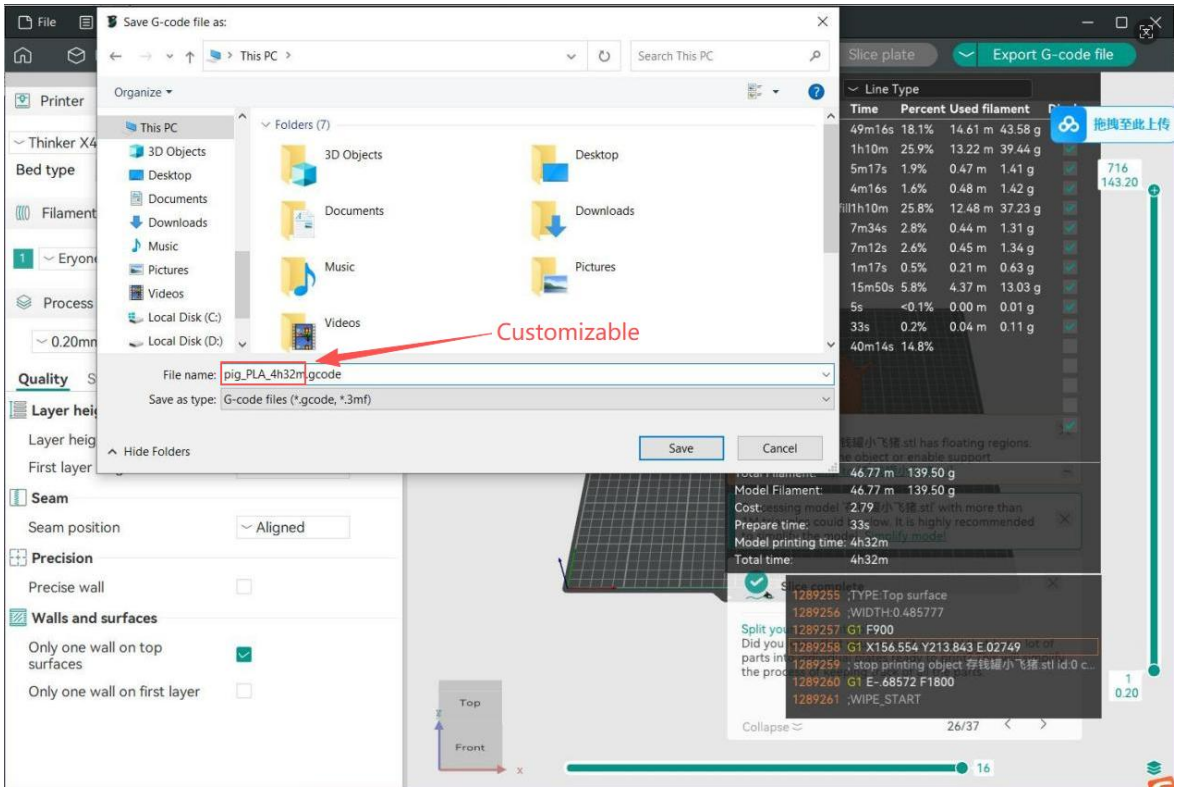


4. Configure settings and slice the model.

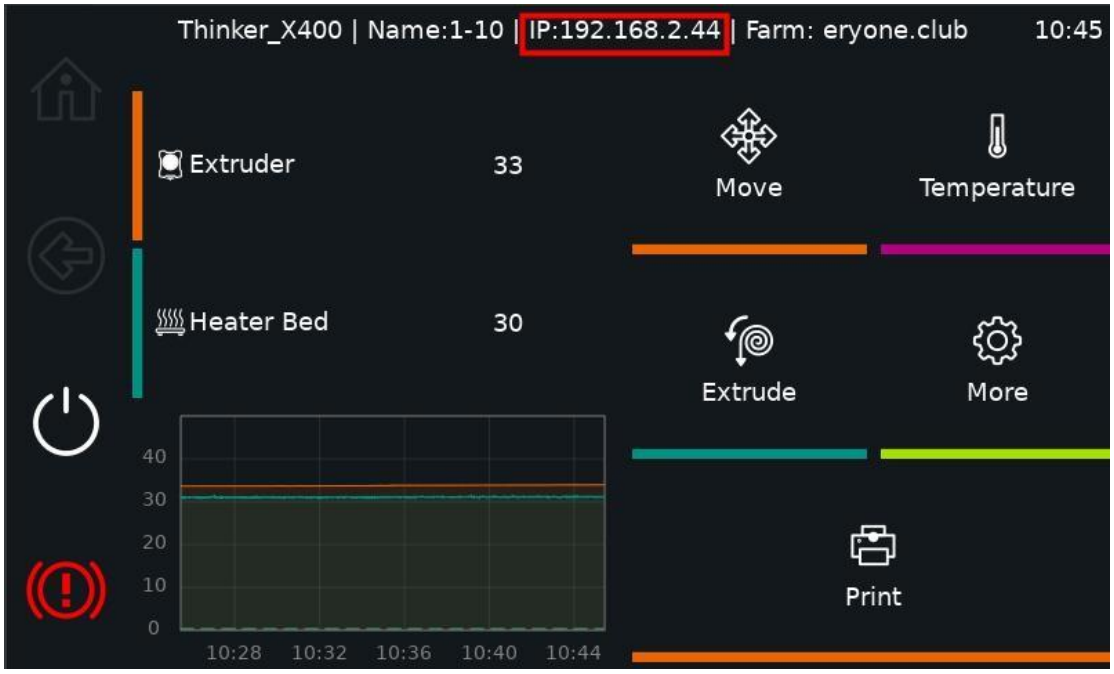


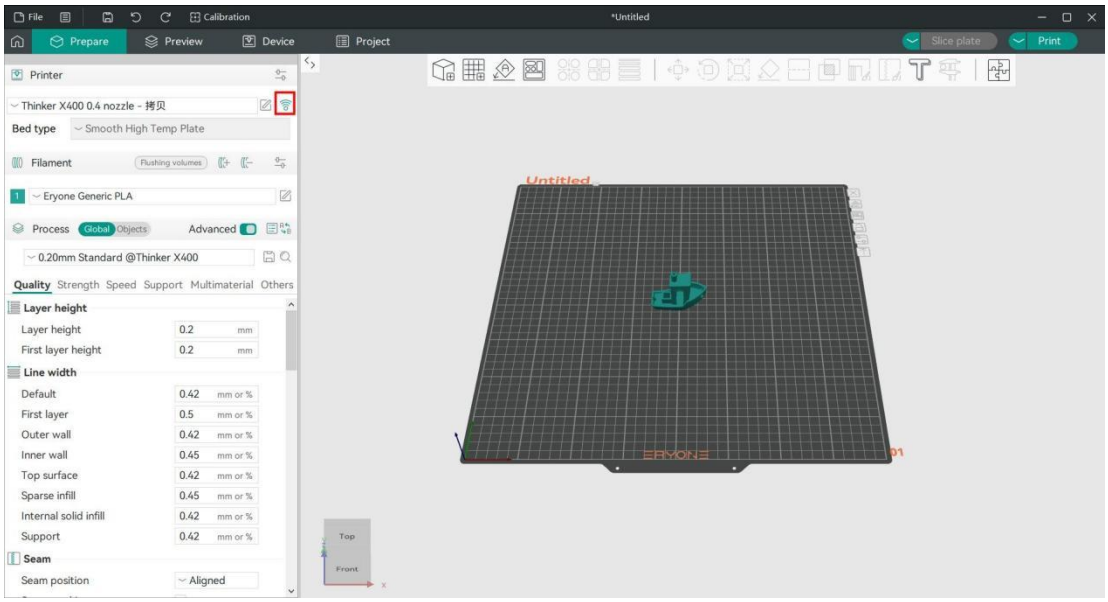
5. Method 1: Preview and export the slice file as a gcode file, transfer the file to a USB flash drive, and then insert the USB flash drive into the printer to print it.

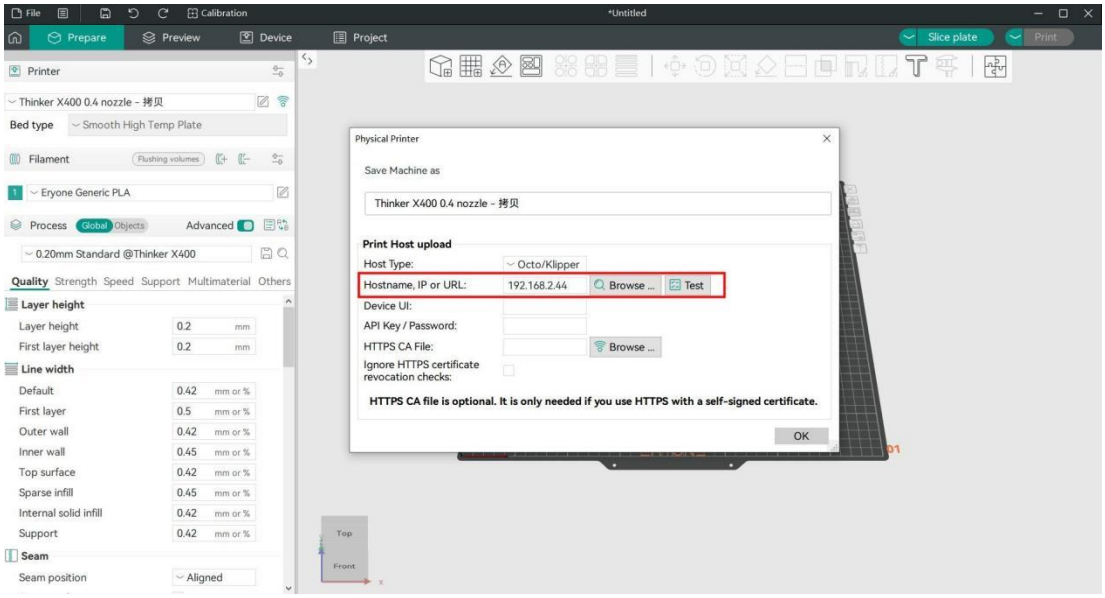


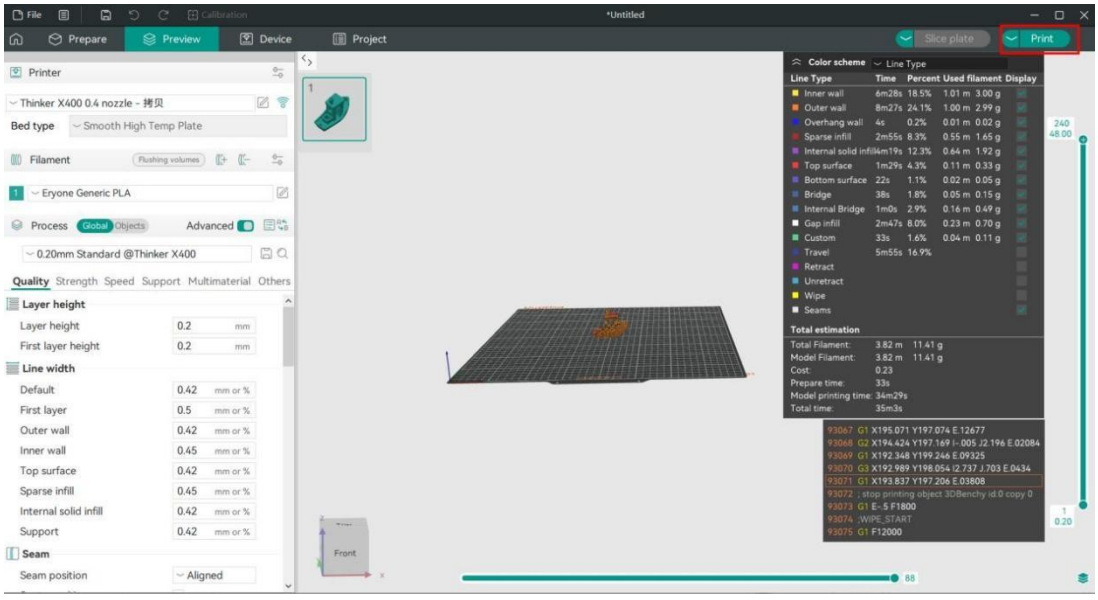


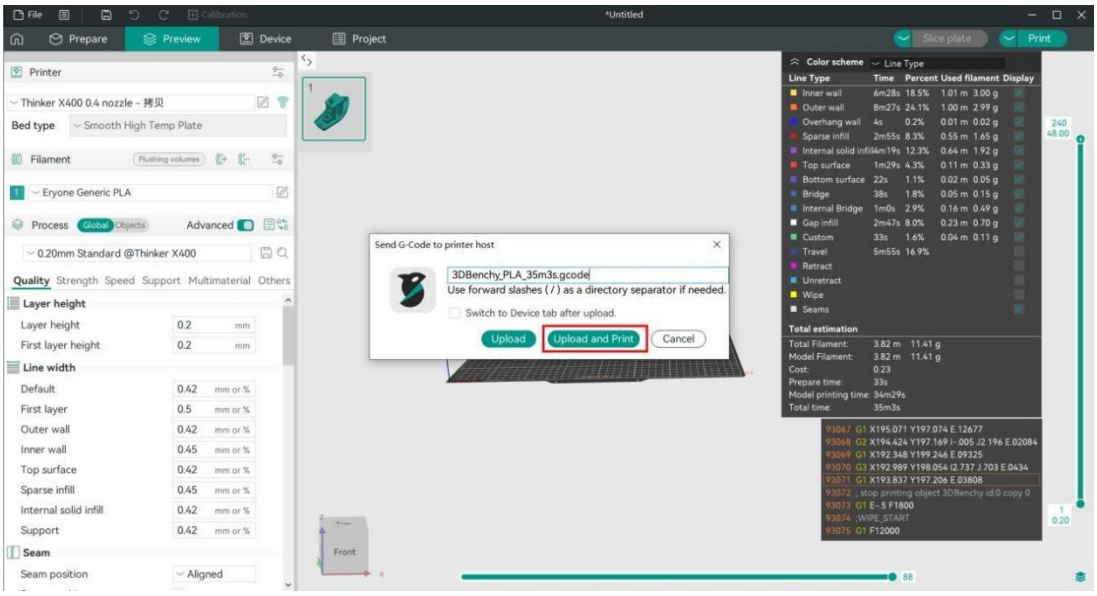
Method 2: In a LAN environment, you can connect to the network, enter the IP address to preview the model, and select “Print” to upload it directly to the printer for printing.




File
Calibration
*Untitled
Prepare
Preview
Device
Project
Slice plate
Print
Printer
Thinker X400 0.4 nozzle - 拷贝
Bed type
Smooth High Temp Plate
Filament
Flushing volumes
Eryone Generic PLA
Process
Global
Objects
Advanced
0.20mm Standard @Thinker X400
Quality
Strength
Speed
Support
Multimaterial
Others
Layer height
Layer height 0.2 mm
First layer height 0.2 mm
Line width
Default 0.42 mm or %
First layer 0.5 mm or %
Outer wall 0.42 mm or %
Inner wall 0.45 mm or %
Top surface 0.42 mm or %
Sparse infill 0.45 mm or %
Internal solid infill 0.42 mm or %
Support 0.42 mm or %
Seam
Seam position Aligned
Untitled
ERYONE
Top
Front


File
Calibration
*Untitled
Prepare
Preview
Device
Project
Slice plate
Print
Printer
Thinker X400 0.4 nozzle - 拷贝
Bed type
Smooth High Temp Plate
Filament
Flushing volumes
Eryone Generic PLA
Process
Global
Objects
Advanced
0.20mm Standard @Thinker X400
Quality
Strength
Speed
Support
Multimaterial
Others
Layer height
Layer height 0.2 mm
First layer height 0.2 mm
Line width
Default 0.42 mm or %
First layer 0.5 mm or %
Outer wall 0.42 mm or %
Inner wall 0.45 mm or %
Top surface 0.42 mm or %
Sparse infill 0.45 mm or %
Internal solid infill 0.42 mm or %
Support 0.42 mm or %
Seam
Seam position Aligned
Physical Printer
Save Machine as
Thinker X400 0.4 nozzle - 拷贝
Print Host upload
Host Type: Octo/Klipper
Hostname, IP or URL: 192.168.2.44
Browse ...
Test
Device UI:
API Key / Password:
HTTPS CA File:
Browse ...
Ignore HTTPS certificate revocation checks:
HTTPS CA file is optional. It is only needed if you use HTTPS with a self-signed certificate.
OK
Top
Front

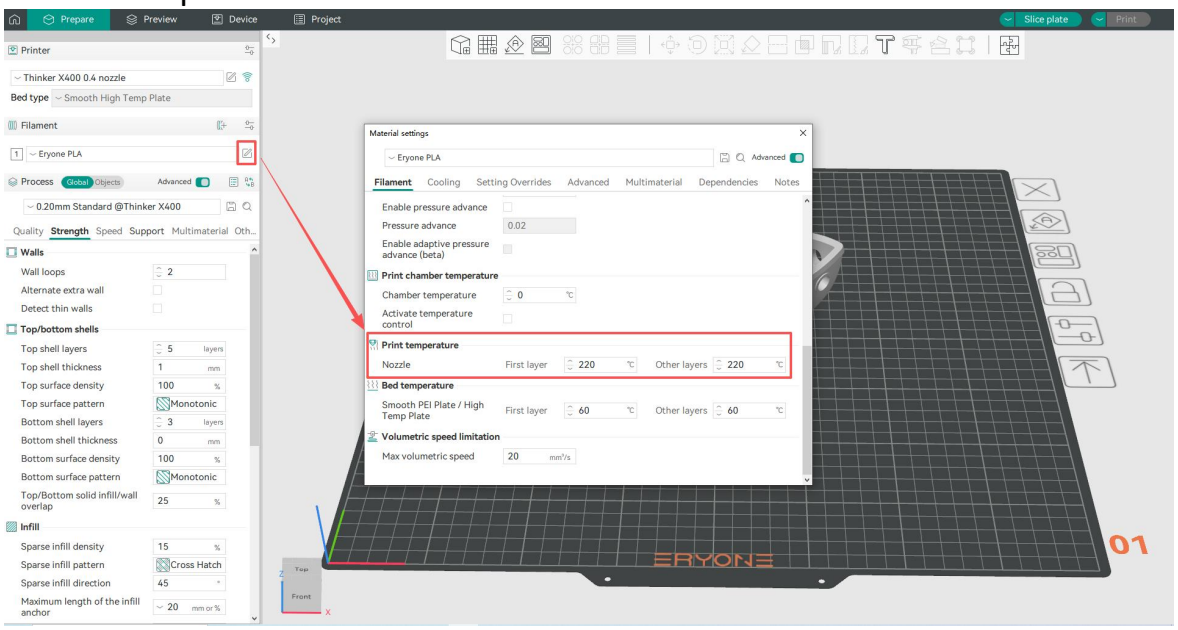

File
*Untitled
Prepare
Preview
Device
Project
Slice plate
Print
Printer
Thinker X400 0.4 nozzle - 拷贝
Bed type
Smooth High Temp Plate
Filament
Flushing volumes
Eryone Generic PLA
Process
Global
Objects
Advanced
0.20mm Standard @Thinker X400
Quality
Strength
Speed
Support
Multimaterial
Others
Layer height
Layer height 0.2 mm
First layer height 0.2 mm
Line width
Default 0.42 mm or %
First layer 0.5 mm or %
Outer wall 0.42 mm or %
Inner wall 0.45 mm or %
Top surface 0.42 mm or %
Sparse infill 0.45 mm or %
Internal solid infill 0.42 mm or %
Support 0.42 mm or %
Seam
Seam position Aligned
Color scheme
Line Type
Line Type Time Percent Used filament Display
Inner wall 6m28s 18.5% 1.01 m 3.00 g
Outer wall 8m27s 24.1% 1.00 m 2.99 g
Overhang wall 4s 0.2% 0.01 m 0.02 g
Sparse infill 2m55s 8.3% 0.55 m 1.65 g
Internal solid infill 4m19s 12.3% 0.64 m 1.92 g
Top surface 1m29s 4.3% 0.11 m 0.33 g
Bottom surface 22s 1.1% 0.02 m 0.05 g
Bridge 38s 1.8% 0.05 m 0.15 g
Internal Bridge 1m0s 2.9% 0.16 m 0.49 g
Gap infill 2m47s 8.0% 0.23 m 0.70 g
Custom 33s 1.6% 0.04 m 0.11 g
Travel 5m55s 16.9%
Retract
Unretract
Wipe
Seams
Total estimation
Total Filament: 3.82 m 11.41 g
Model Filament: 3.82 m 11.41 g
Cost: 0.23
Prepare time: 33s
Model printing time: 34m29s
Total time: 35m3s
93067 G1 X195.071 Y197.074 E.12677
93068 G2 X194.424 Y197.169 I-.005 J2.196 E.02084
93069 G1 X192.348 Y199.246 E.09325
93070 G3 X192.989 Y198.054 I2.737 J.703 E.0434
93071 G1 X193.837 Y197.206 E.03808
93072 ; stop printing object 3DBenchy id:0 copy 0
93073 G1 E-.5 F1800
93074 ;WIPE_START
93075 G1 F12000
Front



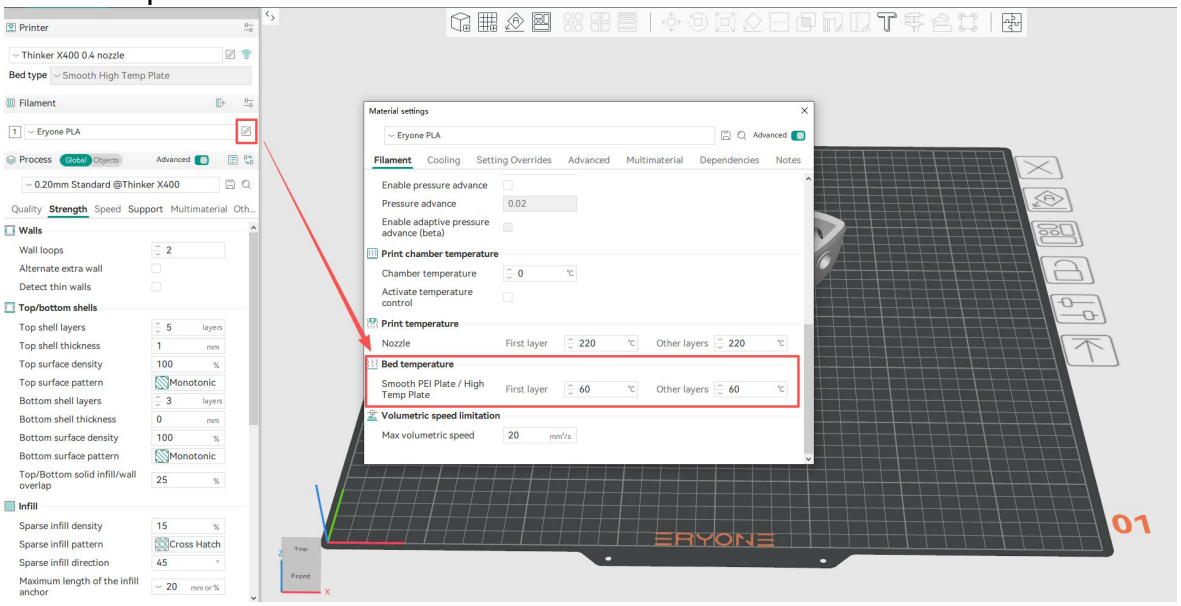
4.4 Custom Parameter Settings

4.4.1 Temperature Settings

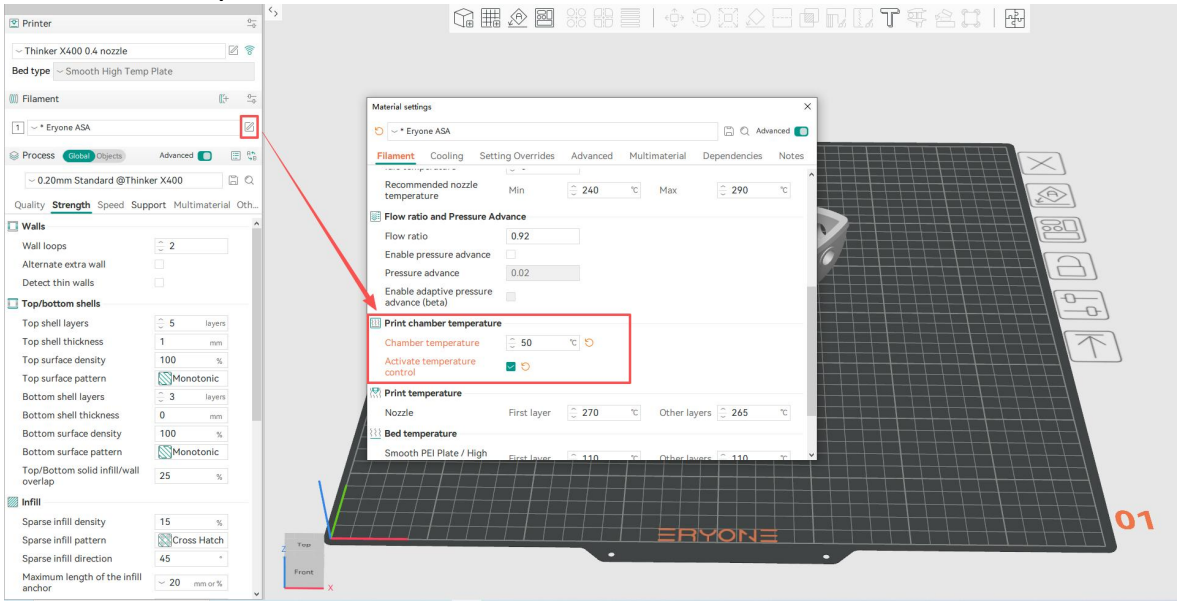
Nozzle Temperature



Bed Temperature

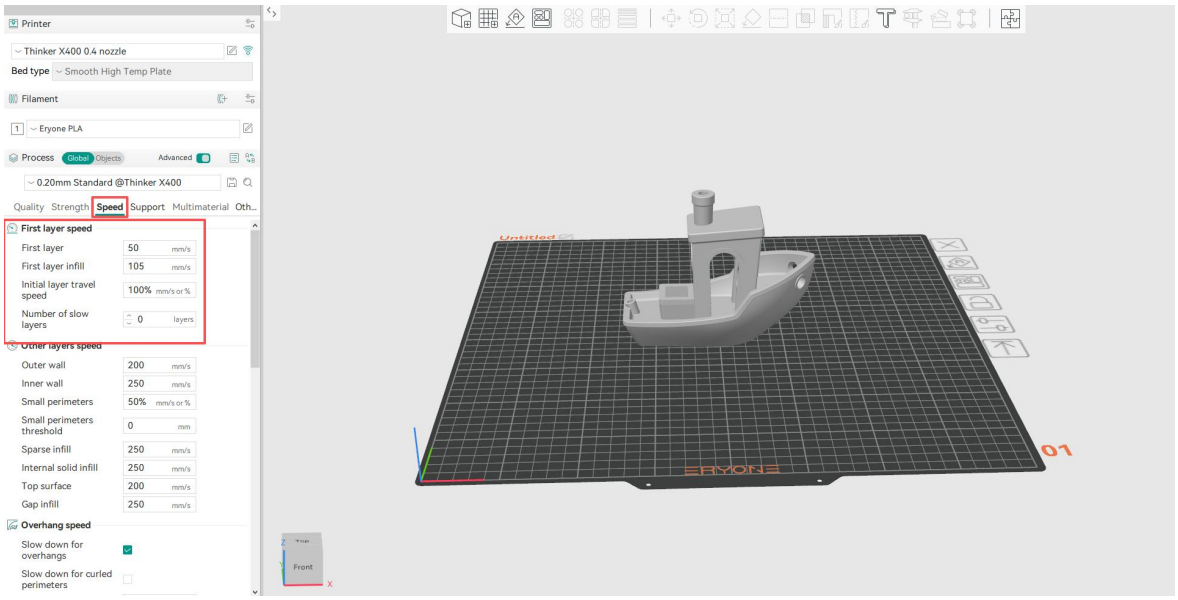


Chamber Temperature

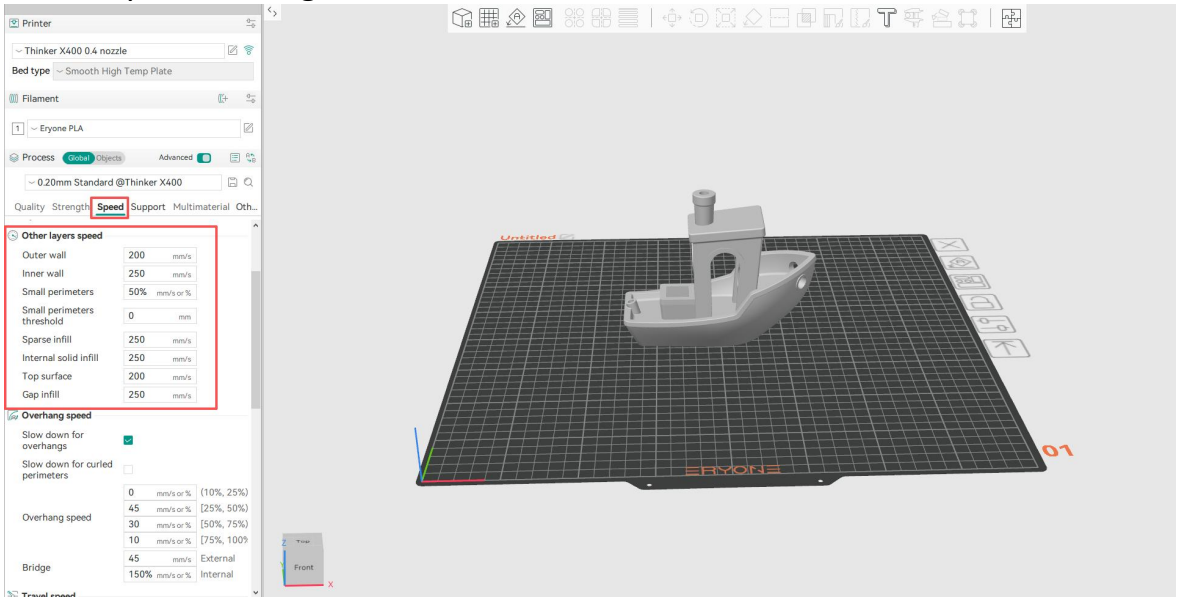


4.4.2 Speed Settings

First Layer Speed

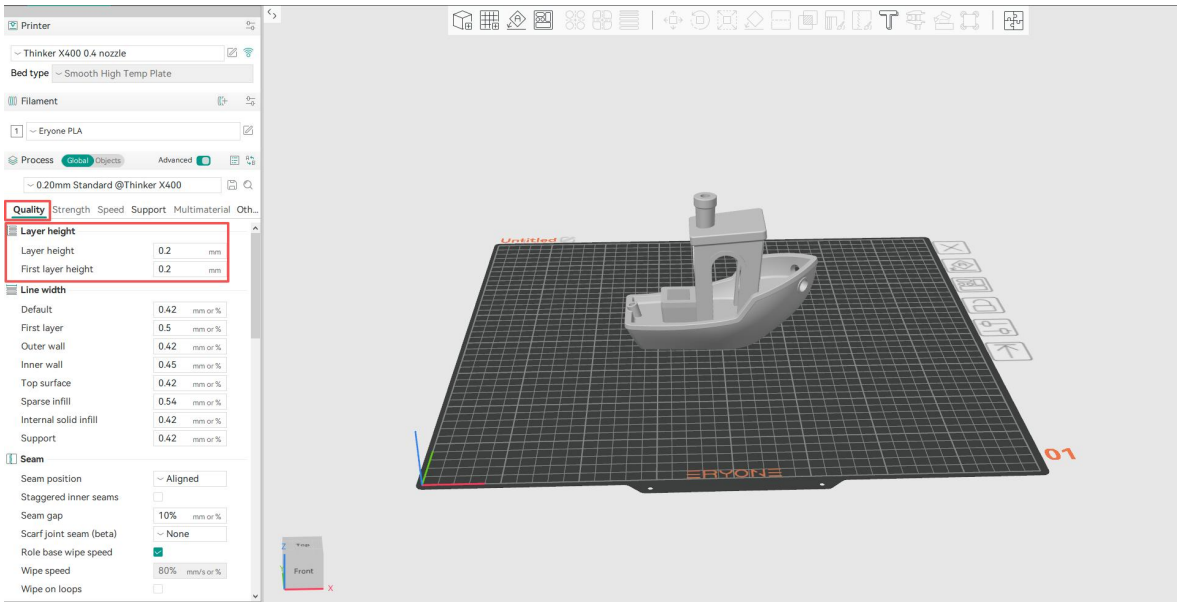


Other Speed Settings

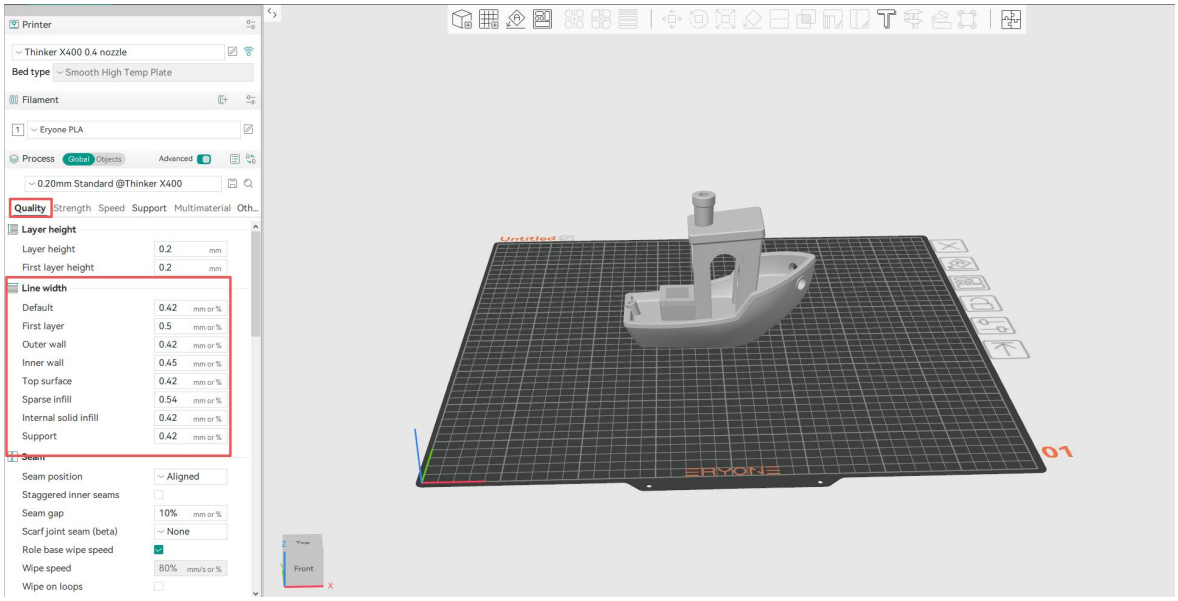


4.4.3 Layer Height & Line Width

Layer Height

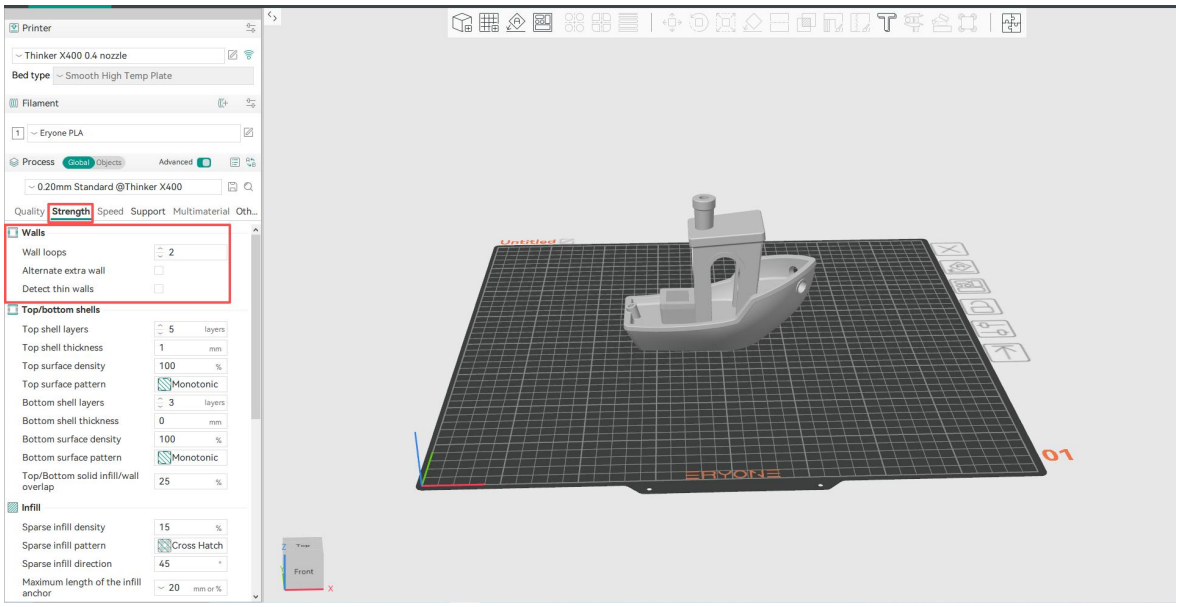


Line Width

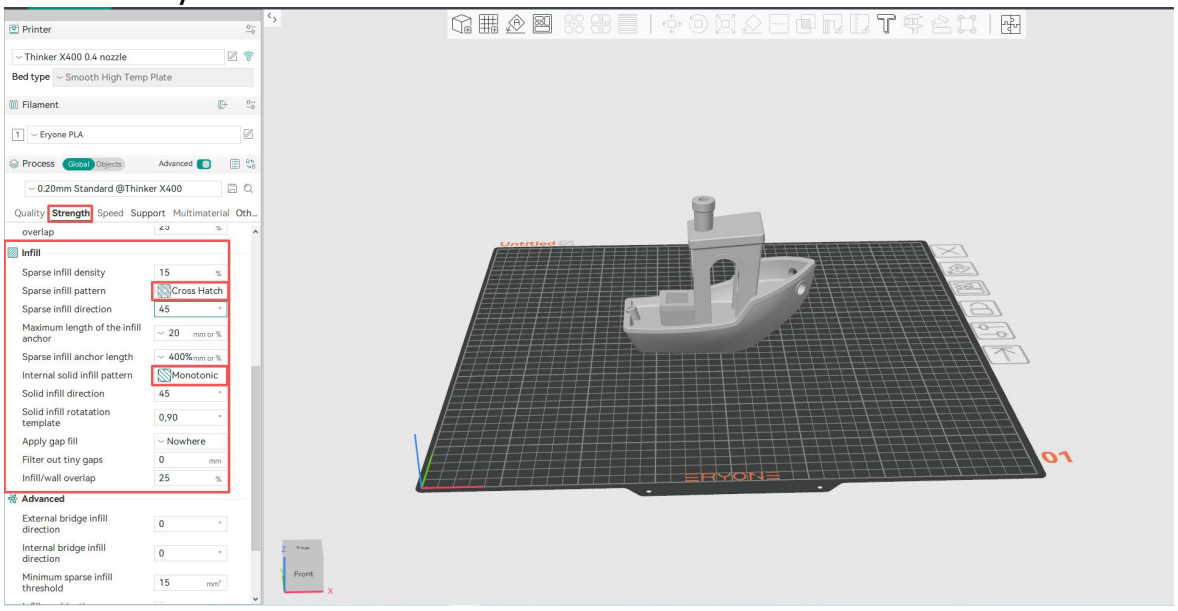


4.4.4 Walls & Infill

Wall Count

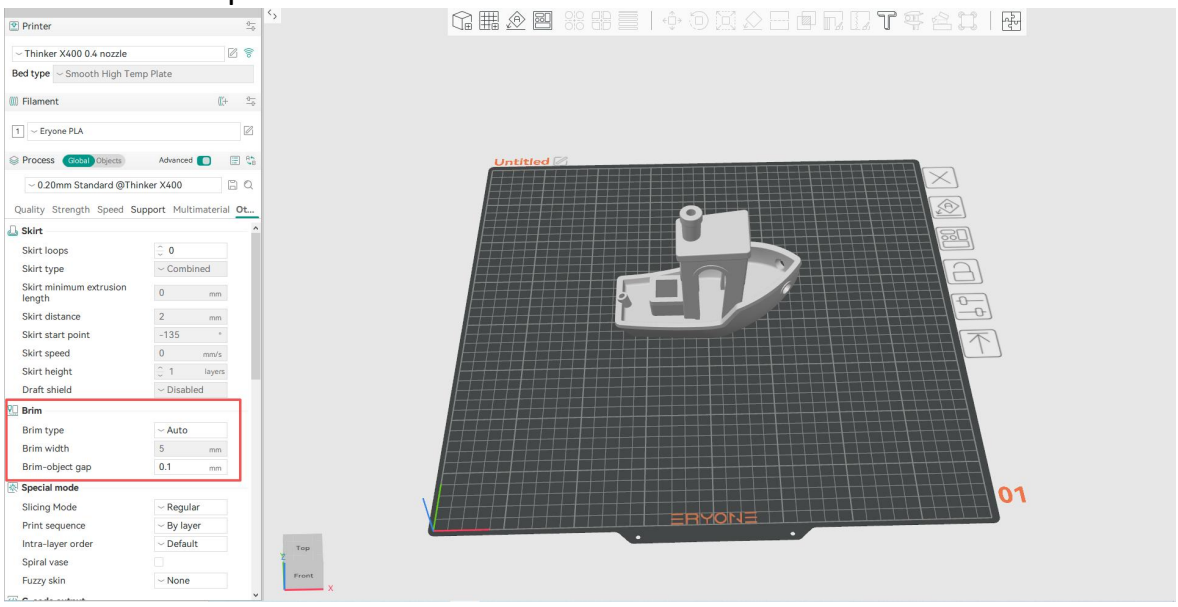


Infill Density & Pattern



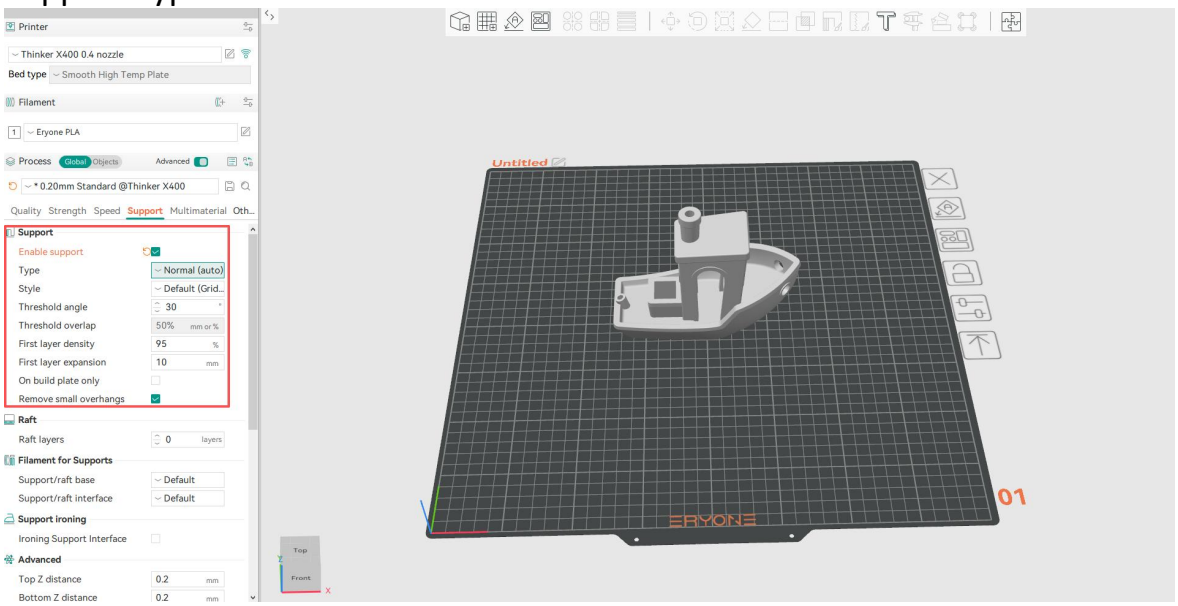
4.4.5 Skirt

Brim Size & Gap



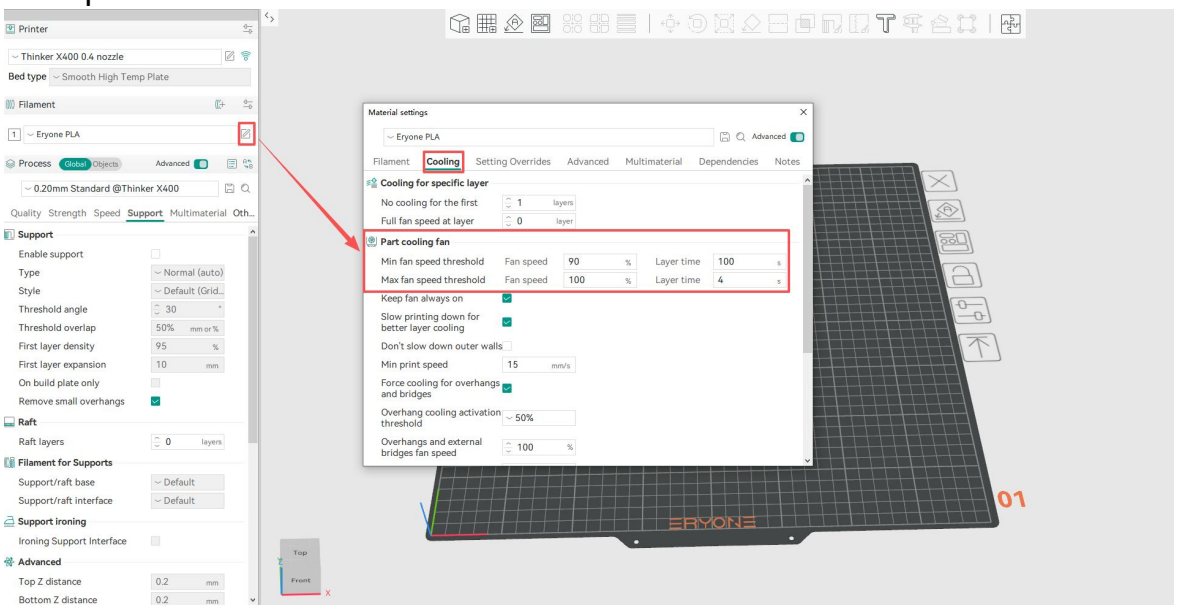
4.4.6 Support

Support Type



4.4.7 Cooling

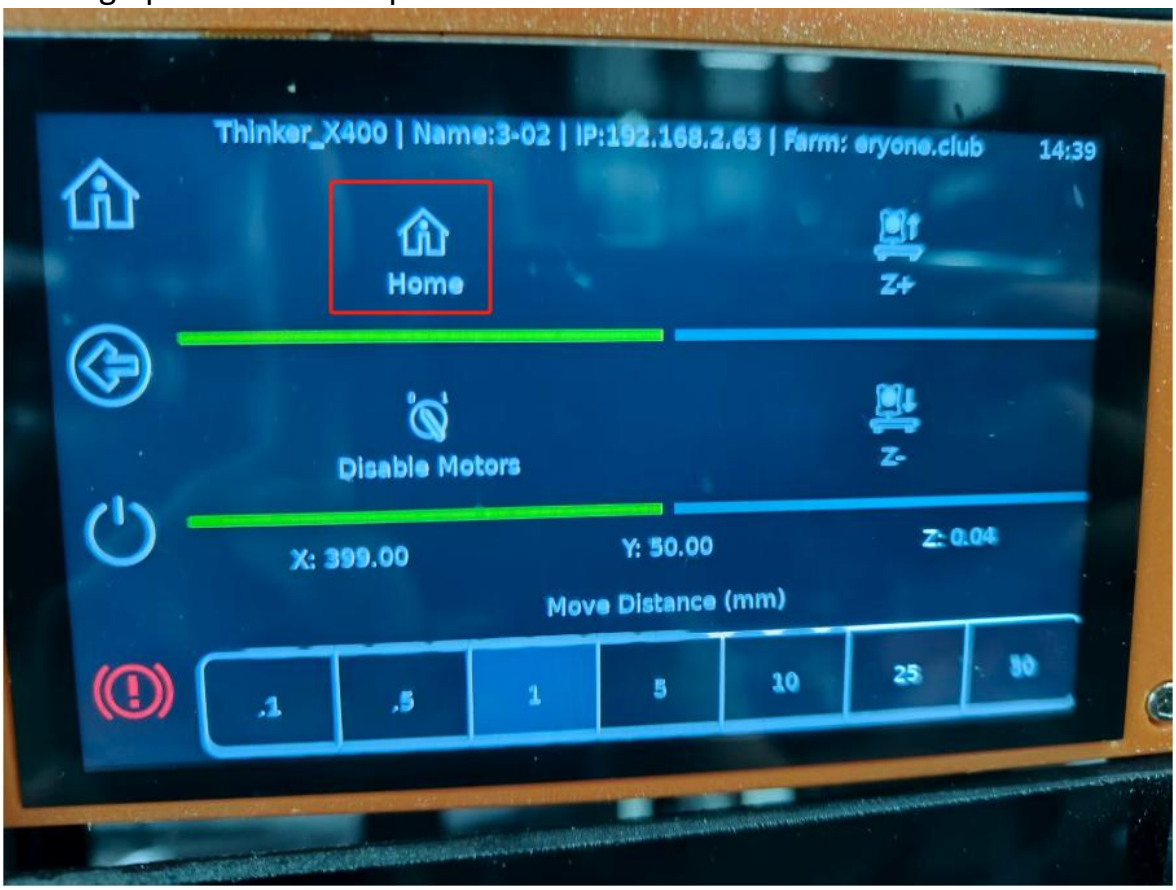
Fan Speed



5.Chamber Heating Module

5.1 Install Thermistor Wiring

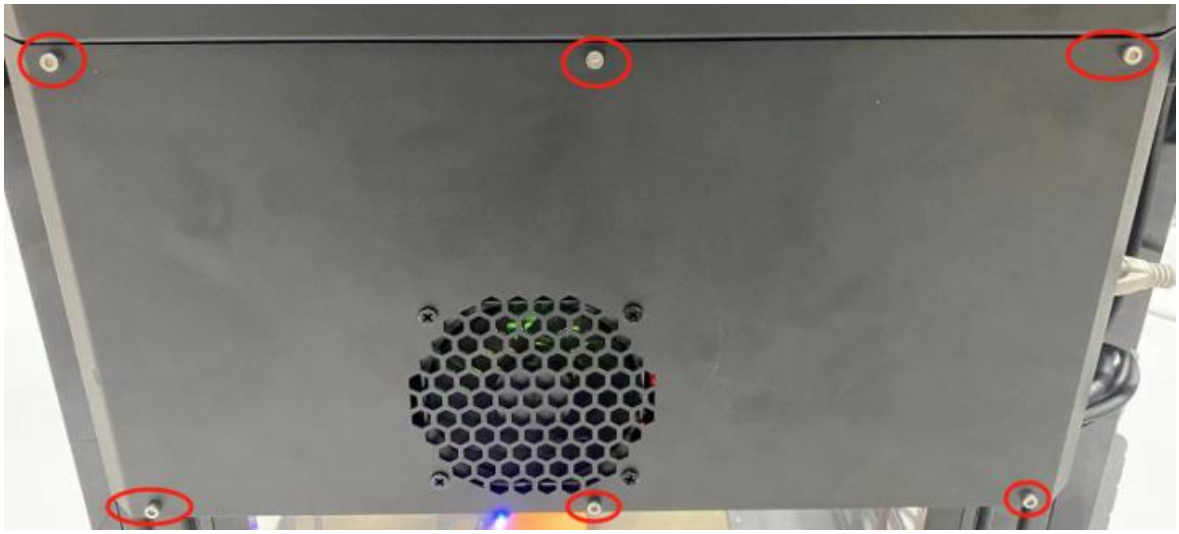
Installation steps:
1.Power on the machine and click "Home" on the screen. Wait for the homing operation to complete.



2.Install the mounting bracket on the right-side internal panel as shown in the diagram, using an H2.5 screwdriver.

3. Open the mainboard cover on the right side.

Note: Disconnect the fan connector on the mainboard cover first.



4.Install the thermistor wiring.

Thermistor wire

The terminal is inserted into the corresponding interface of THO

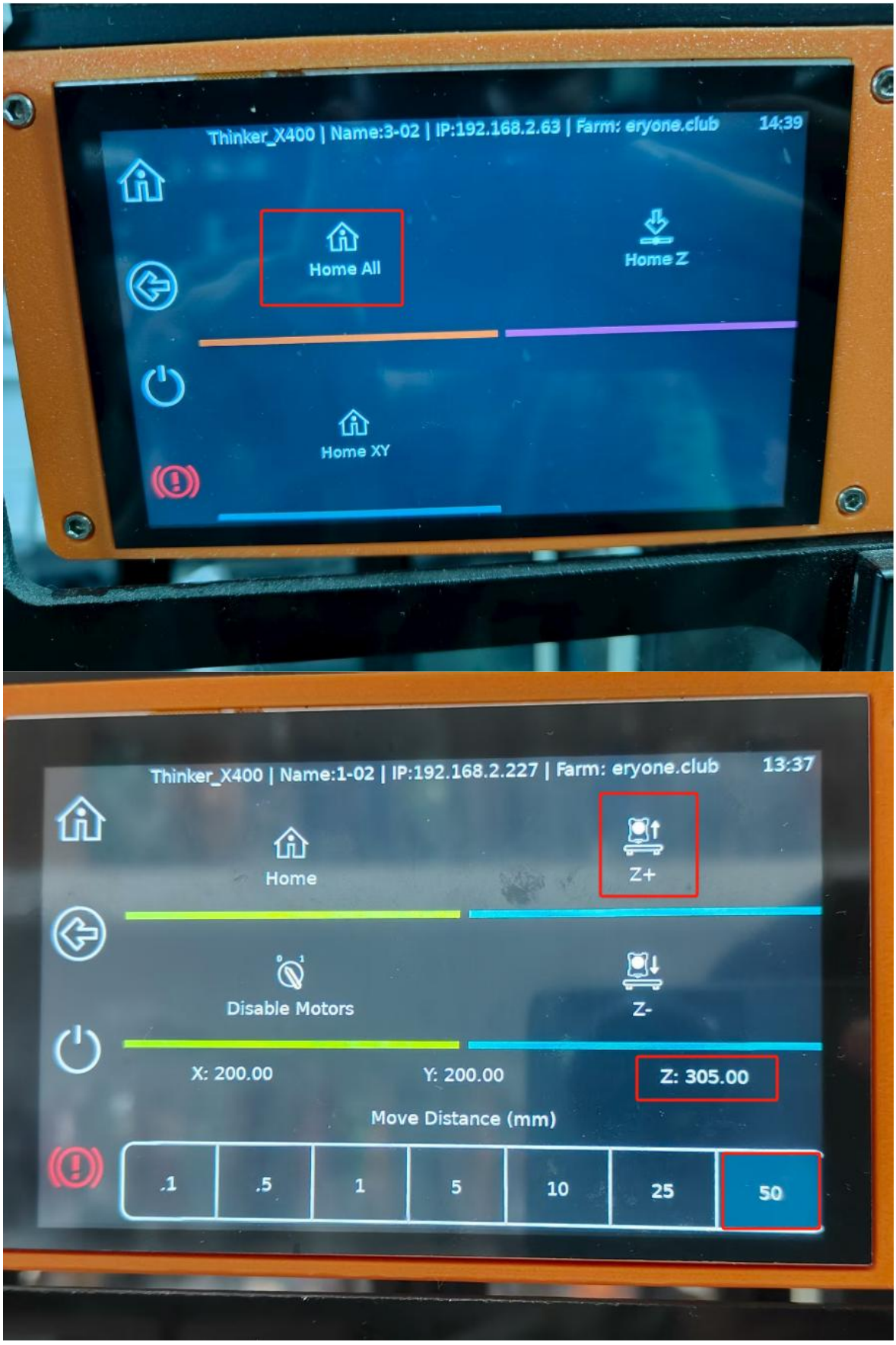
The thermistor black head is inserted from this hole, which is on the left side of the motherboard

The resistor blackhead emerges 1cm from the fixing part

5.2 Install Chamber Heating Module

Installation steps:

1.Raise the print head to 305mm height and wait for the Z-axis to reach 305mm.



2.Power off the machine and unplug the power cable.

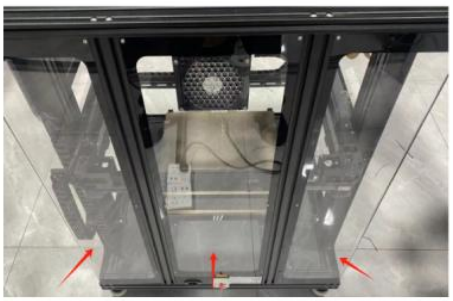
Important: The power cable must be disconnected.

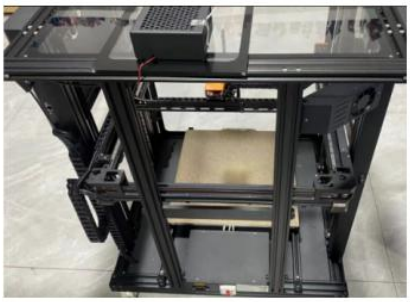
1.Hit the emergency button

2.Unplug the power cord

3.Remove screws from the three acrylic panels at the rear of the machine.

Note: The middle panel should be rotated 270° and placed on top of the machine. Use an H2.5 screwdriver. Be careful with the acrylic edges (`they're sharp`).

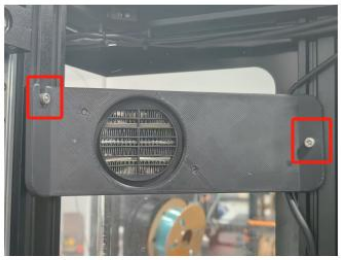




4.Install the chamber heating module.

The chamber heating module is about 3 fingers away from the top of the machine

M4X12 screws and nuts

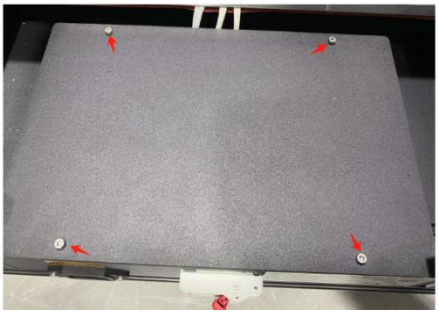


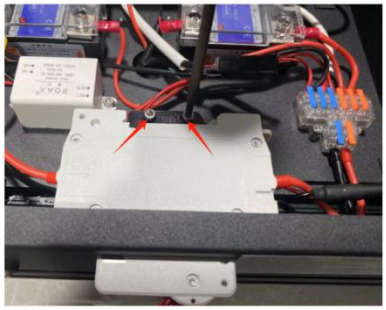
Tighten the screw on the right side first, then tighten the screw on the left side

5.3 Install AC Wiring (thick cable)

Installation steps:

1. Open the power box and remove the screws from the circuit breaker bracket using an H2.5 screwdriver.



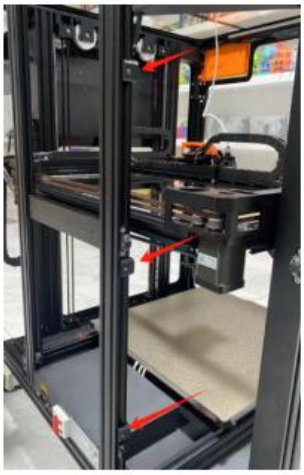


2.Install the AC cable (thick) into the profile slot, securing it at three evenly

spaced points as shown in the diagram. Use an H2.5 screwdriver

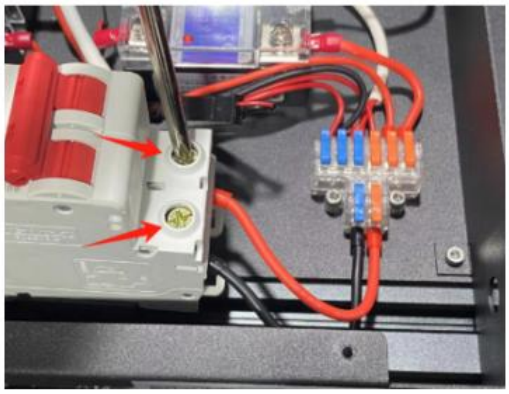
AC wiring harness fixings

3 fixed at equal intervals



Insert the AC line (thick line) into the profile groove

3.Route the AC cable (thick) through the power box hole and connect it to the circuit breaker terminal as shown. Use a Phillips screwdriver.

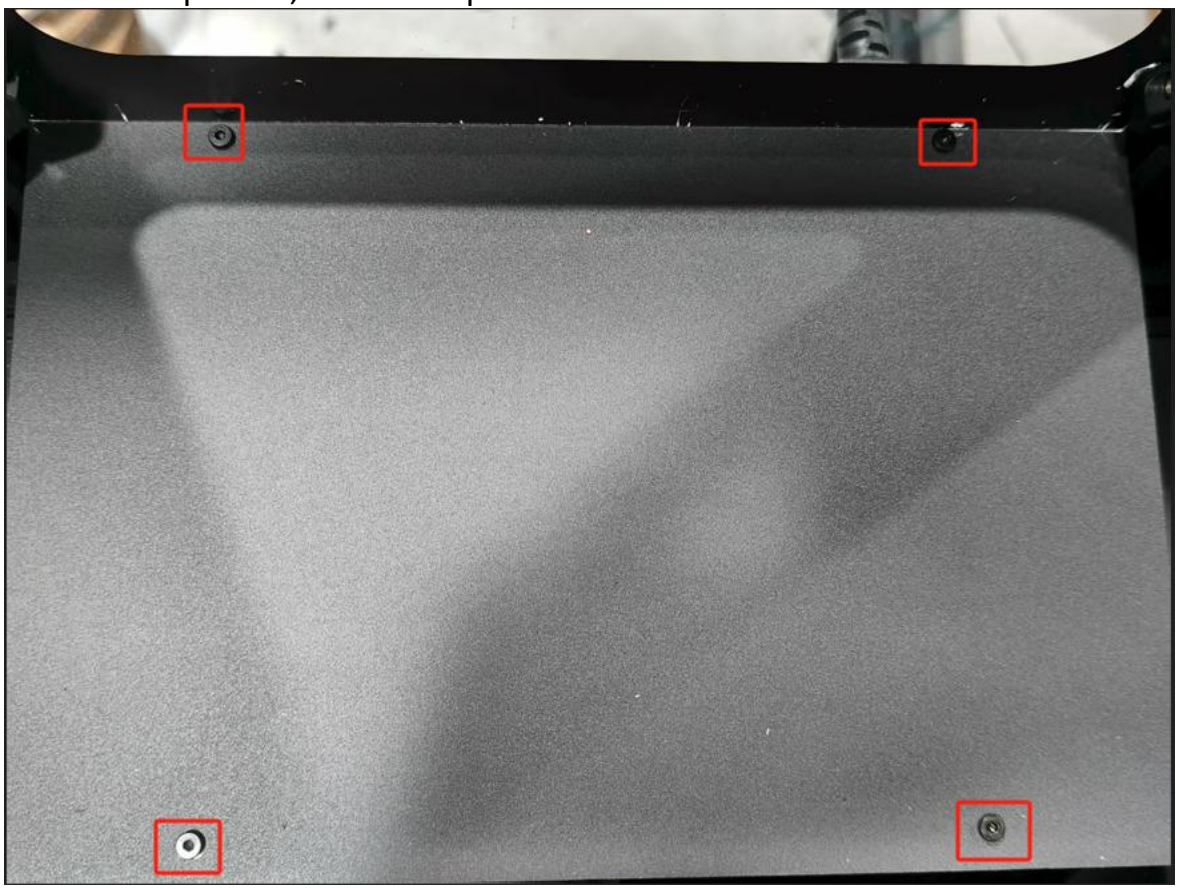


Use a large Phillips screwdriver to tighten

Wiring must be done as shown in the diagram

Important: After tightening, the cable should not be pullable.

4.After completion, install the power box cover back



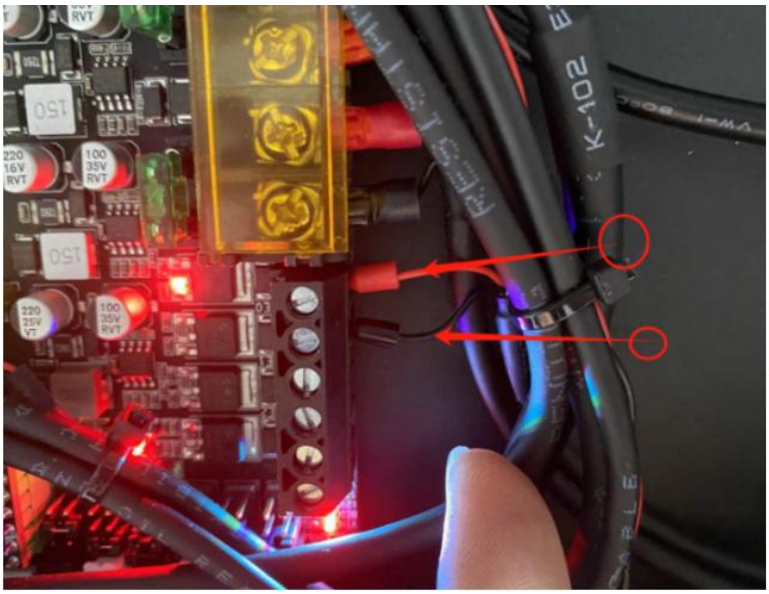
5.4 Install Chamber Heater Wiring (thin cable)

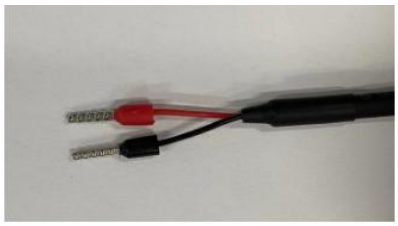
Installation steps:

1.Route the chamber heater wiring (thin cable).

The chamber heater cable (thin wire) passes through the top cable itself, fixed with a cable tie and then passed into the lower bus port

2.Connect the chamber heater terminal



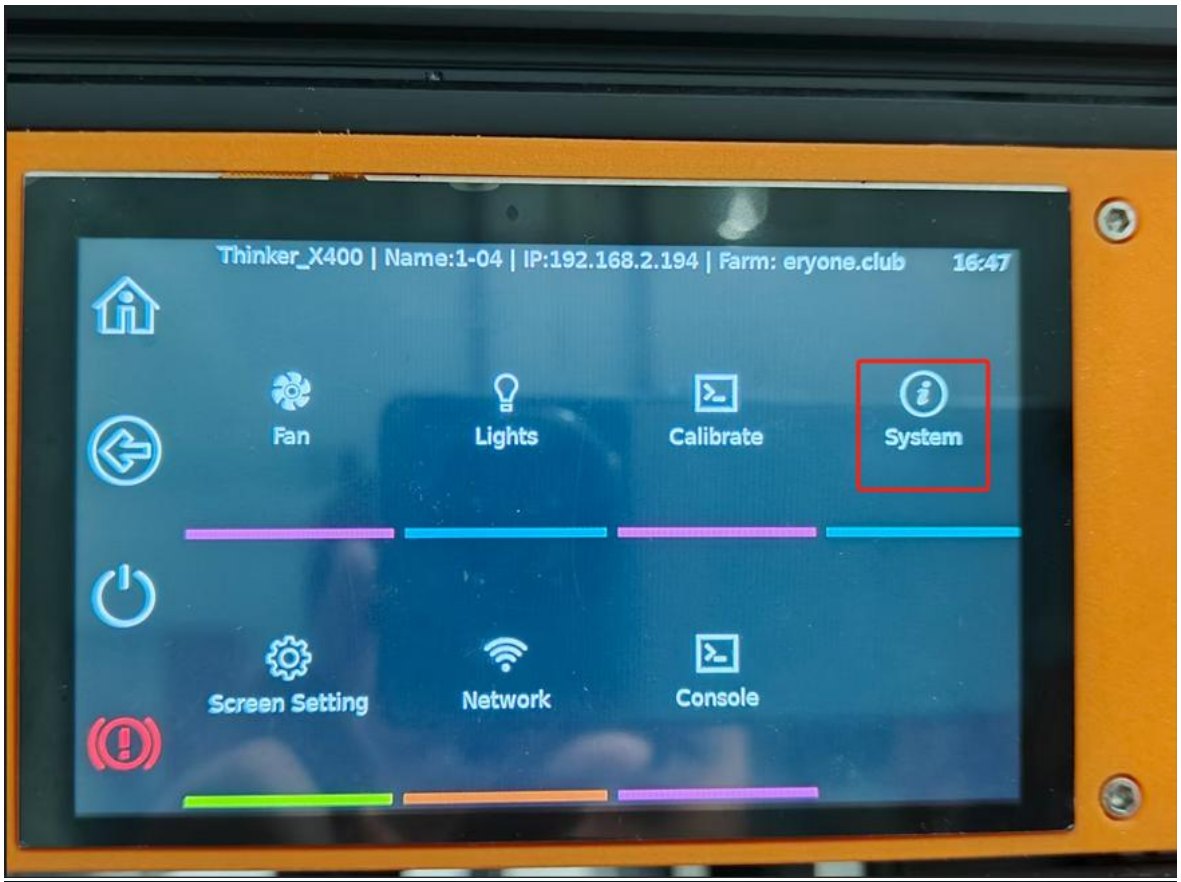


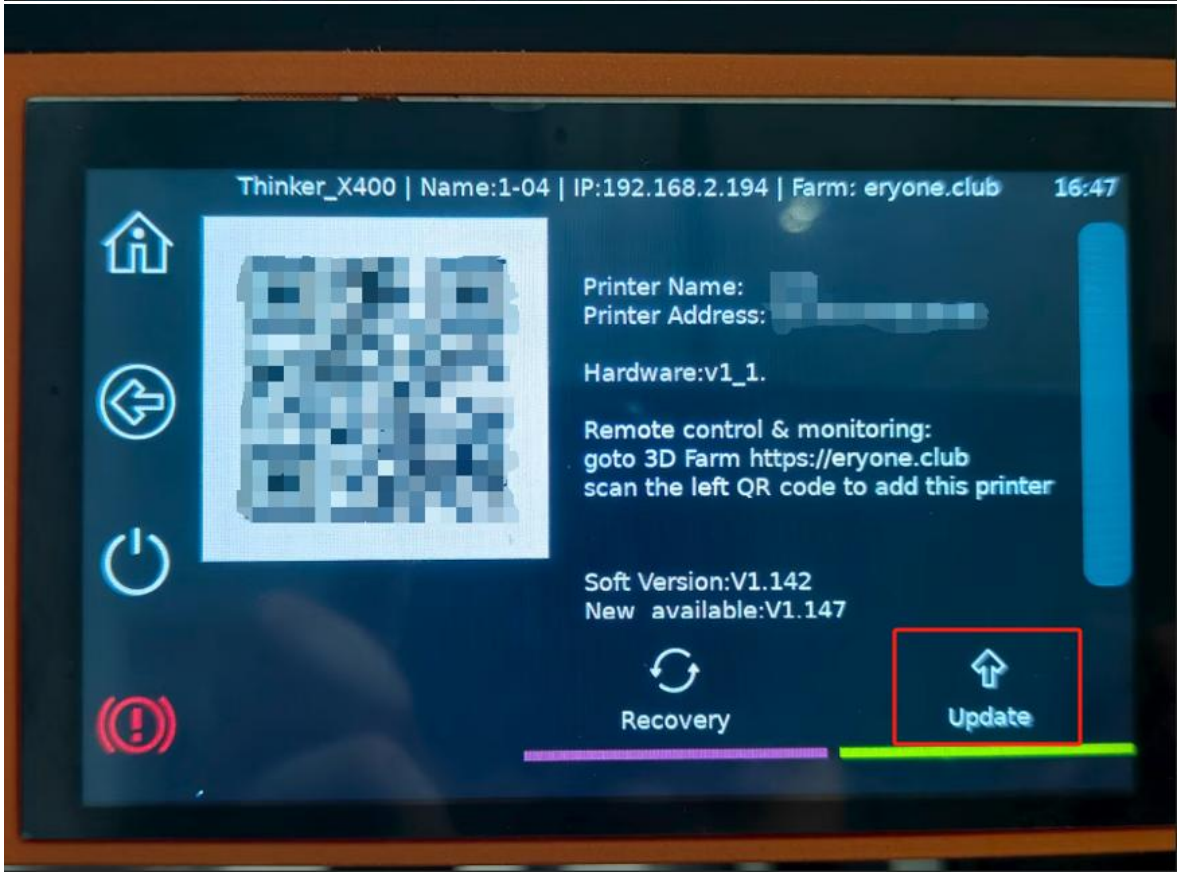
Use a flat-blade screwdriver to fix it.
It must be fixed as shown in the left picture, with the red line on the top.

3.Install the motherboard cover on the right side
4.Install the back panel acrylic sheet

5.5 Enabling the Chamber Heating Function in Software

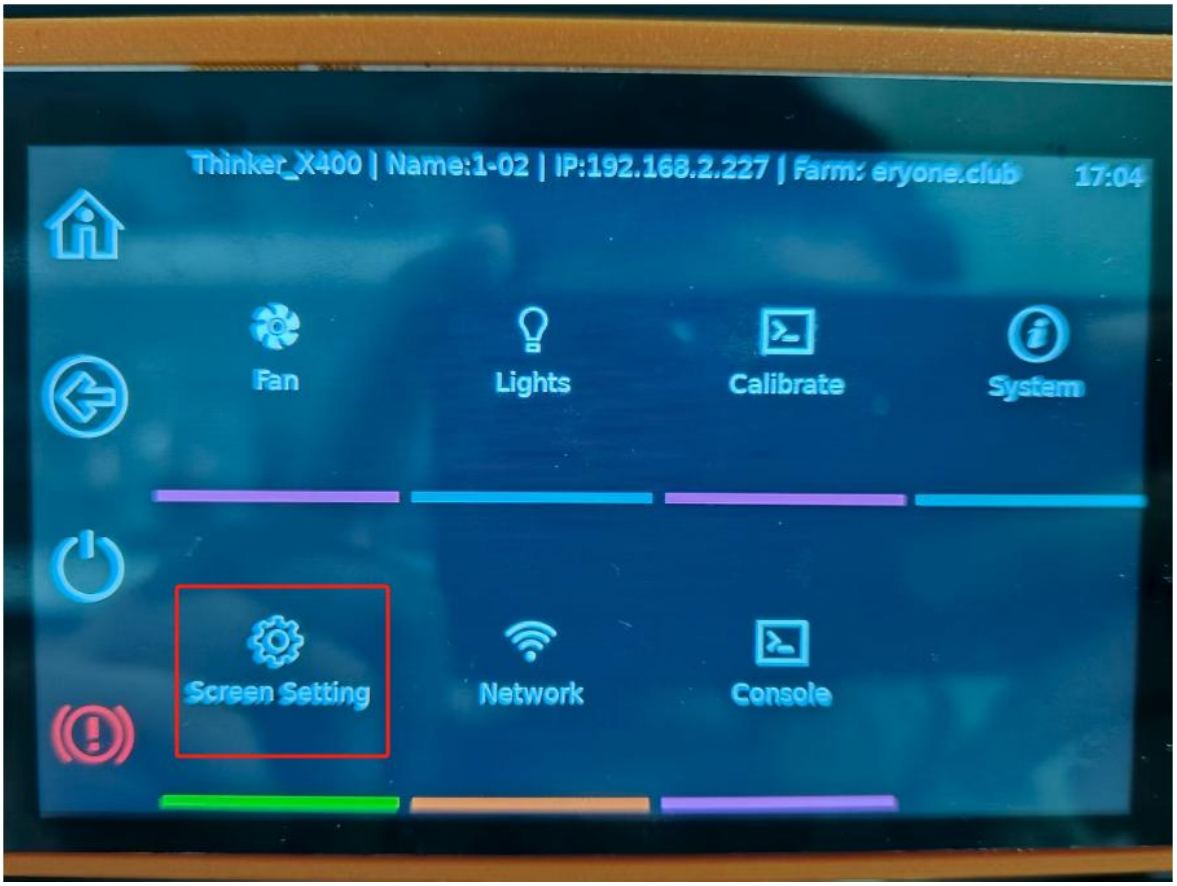
Installation steps:
1.Power on the machine and update the printer firmware
First, upgrade the printer's system firmware.

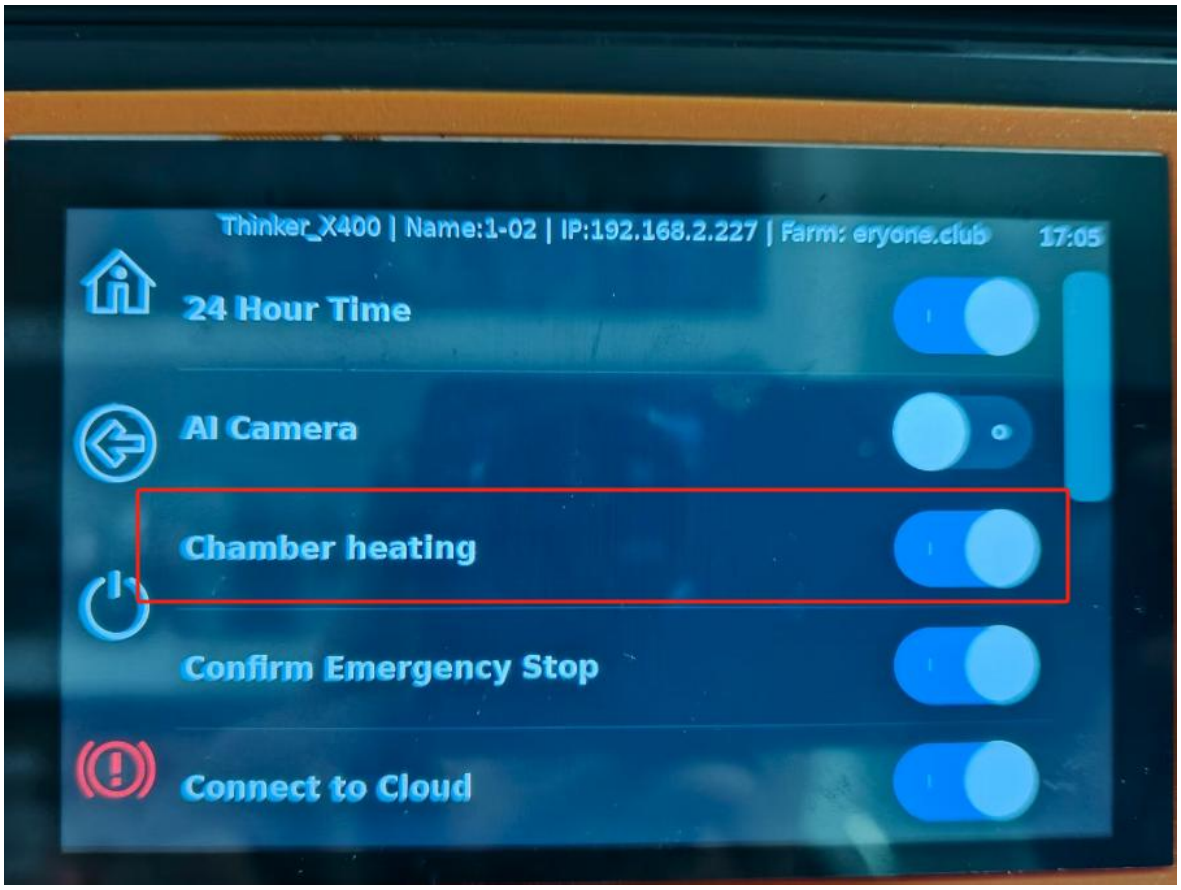




After the update is complete, restart the machine.

2.Enable the chamber heating function in the settings menu
Navigate to the settings interface and activate the chamber heating feature.





Setup is now complete. The system is ready for use.

How to turn on the chamber heater during printing. For details, please refer to Section 4.4.1 Temperature Settings.

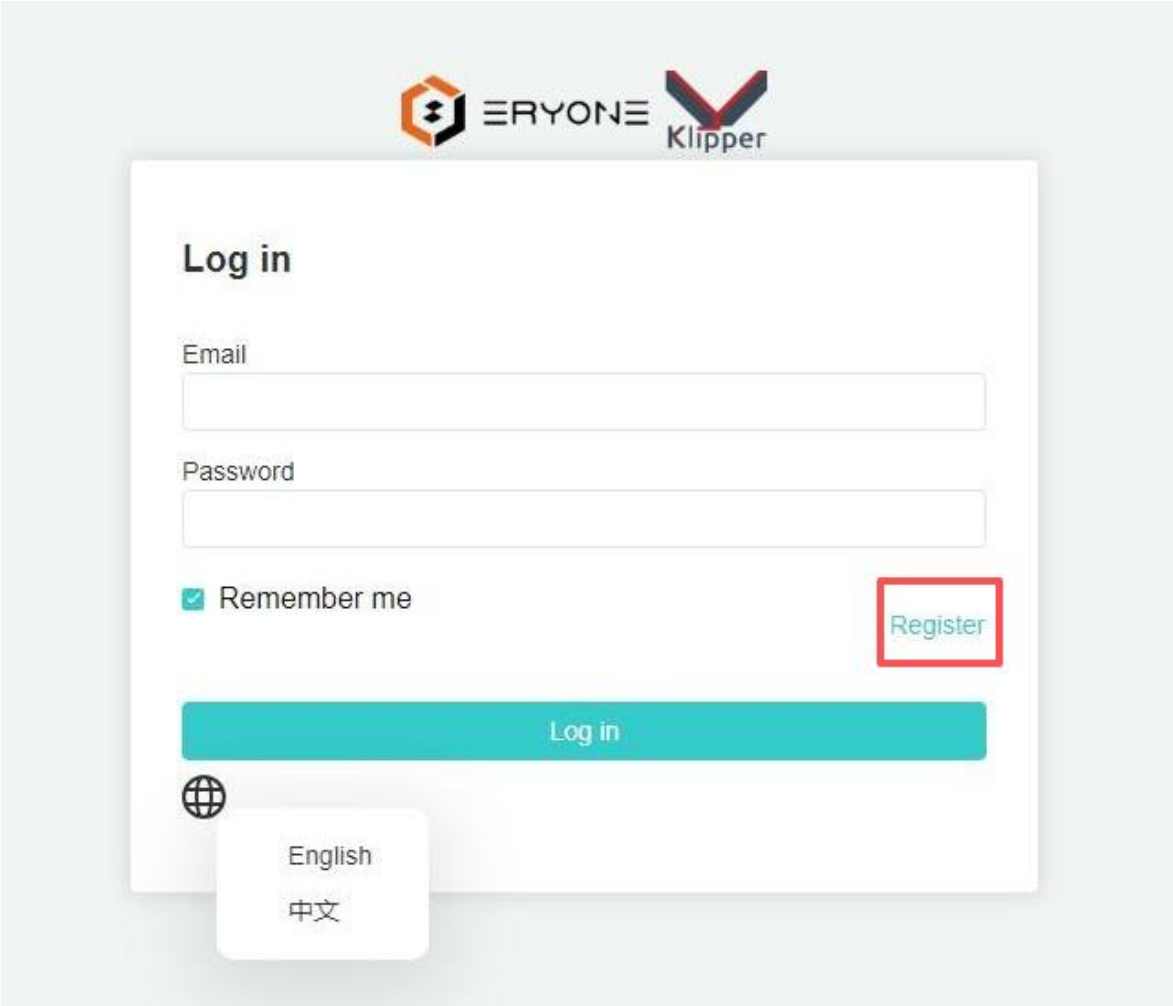
6.Farm Management Software

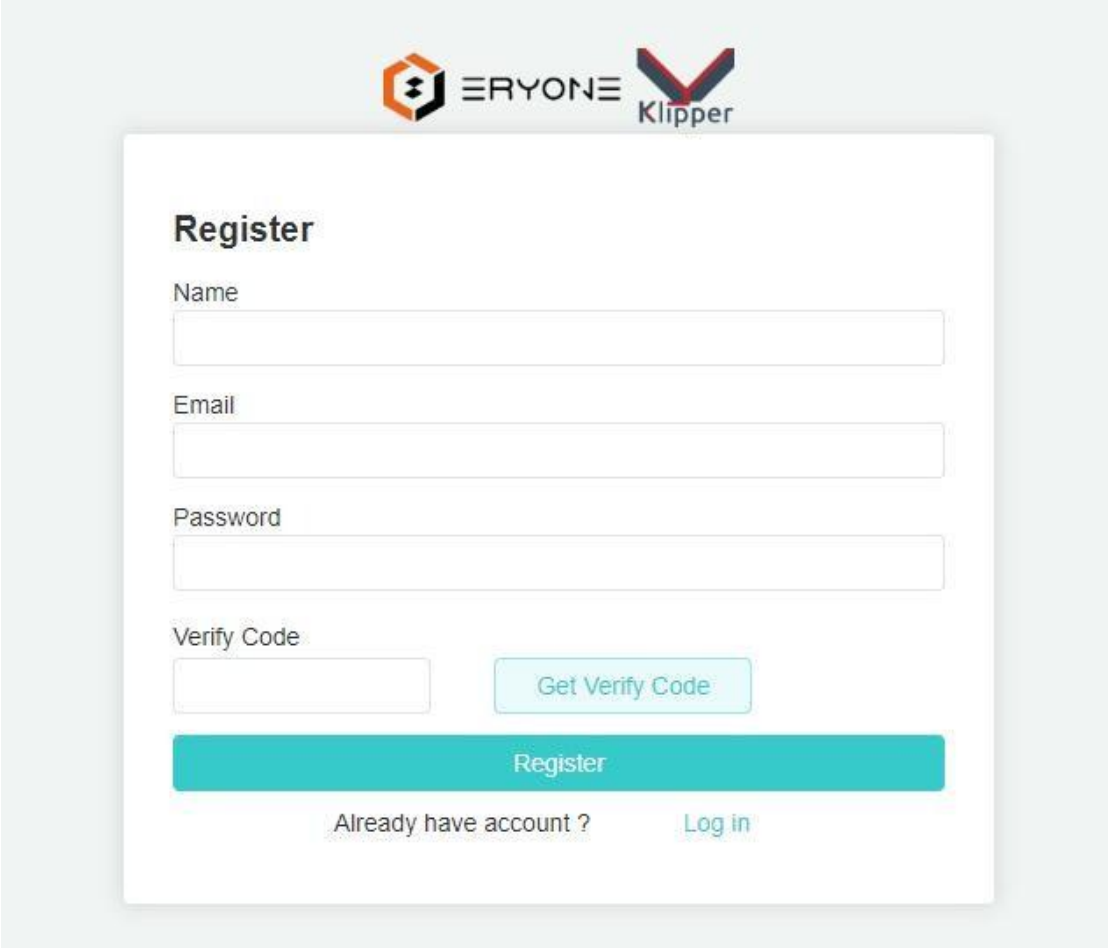
6.1 Account Registration

Procedures:

1. Visit eryone.club.

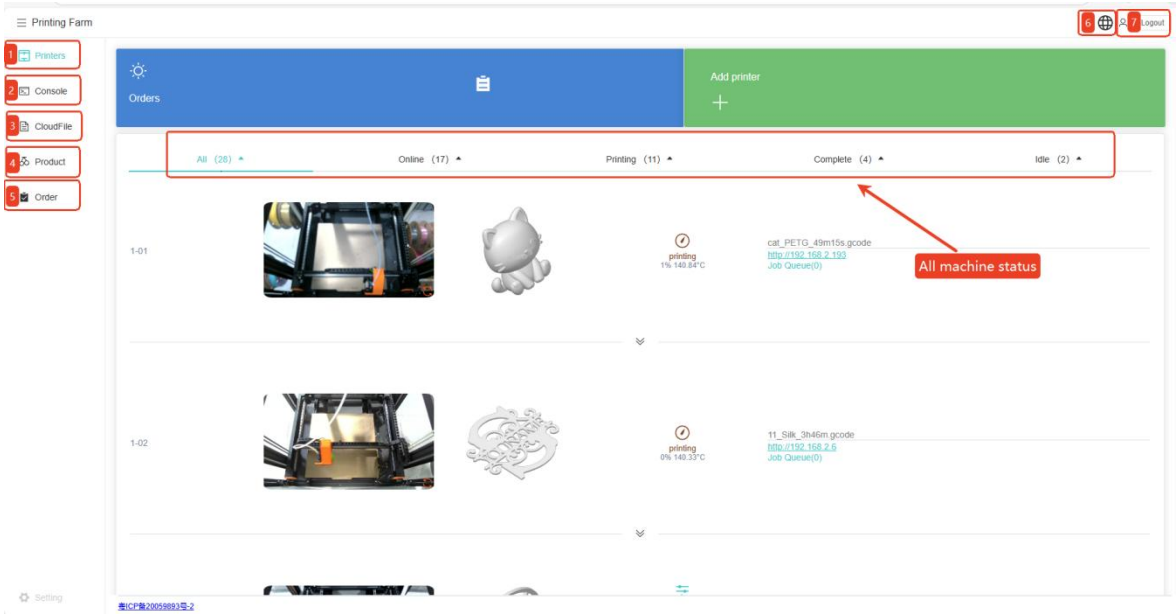
2. Register or log in with a Google account.





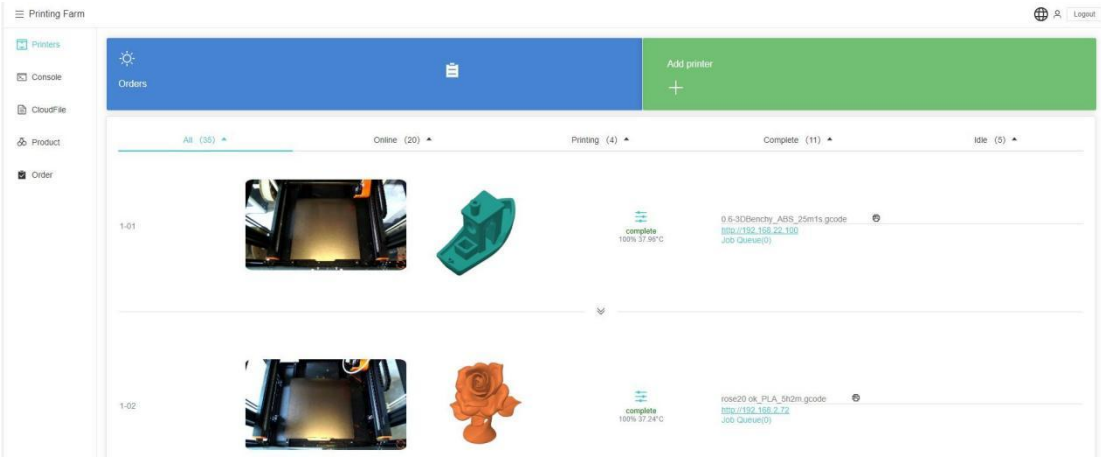
3. Return to the Login after registering

6.2 Interface Functions

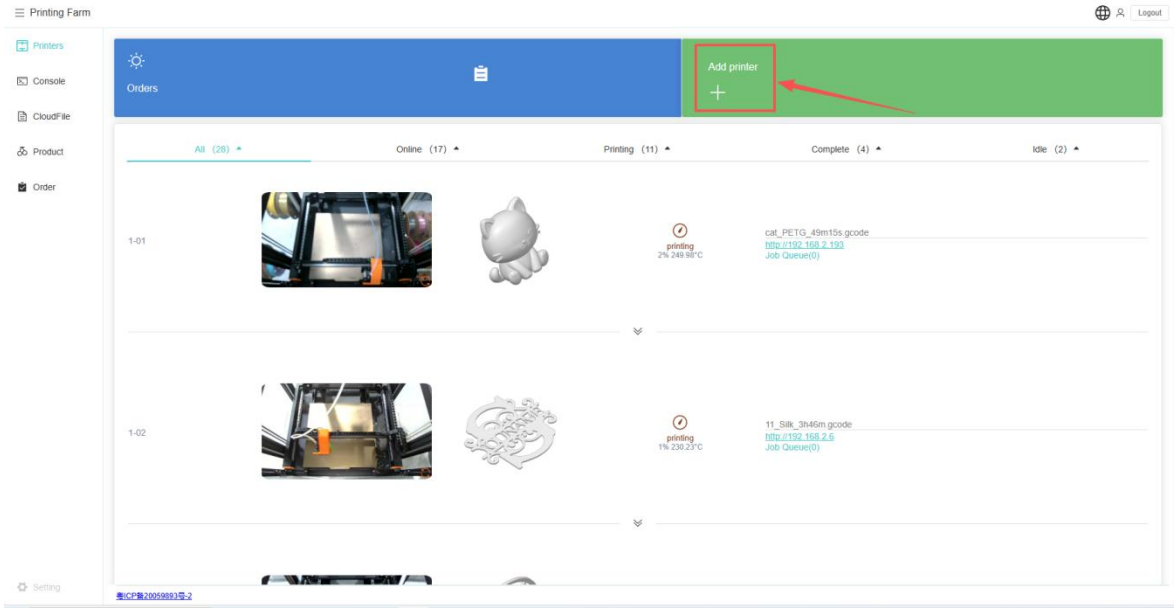


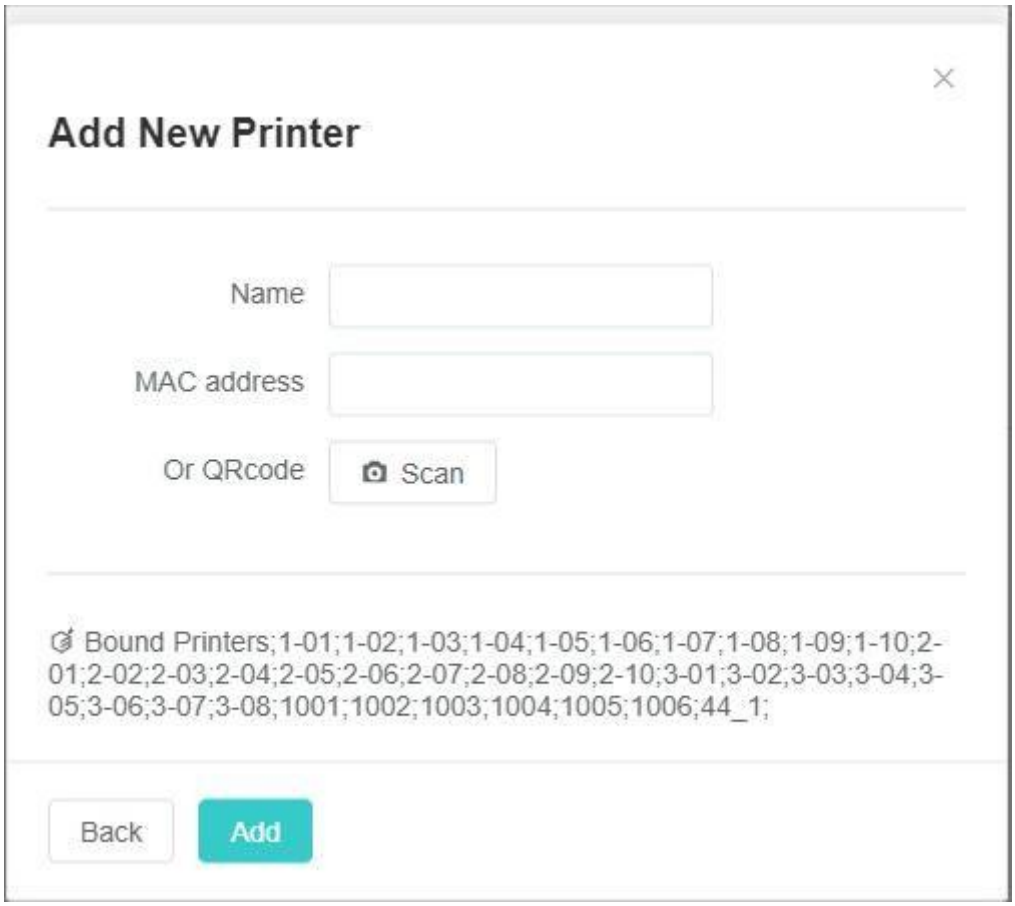
6.2.1 Printers

View printer status



How to add new printers?



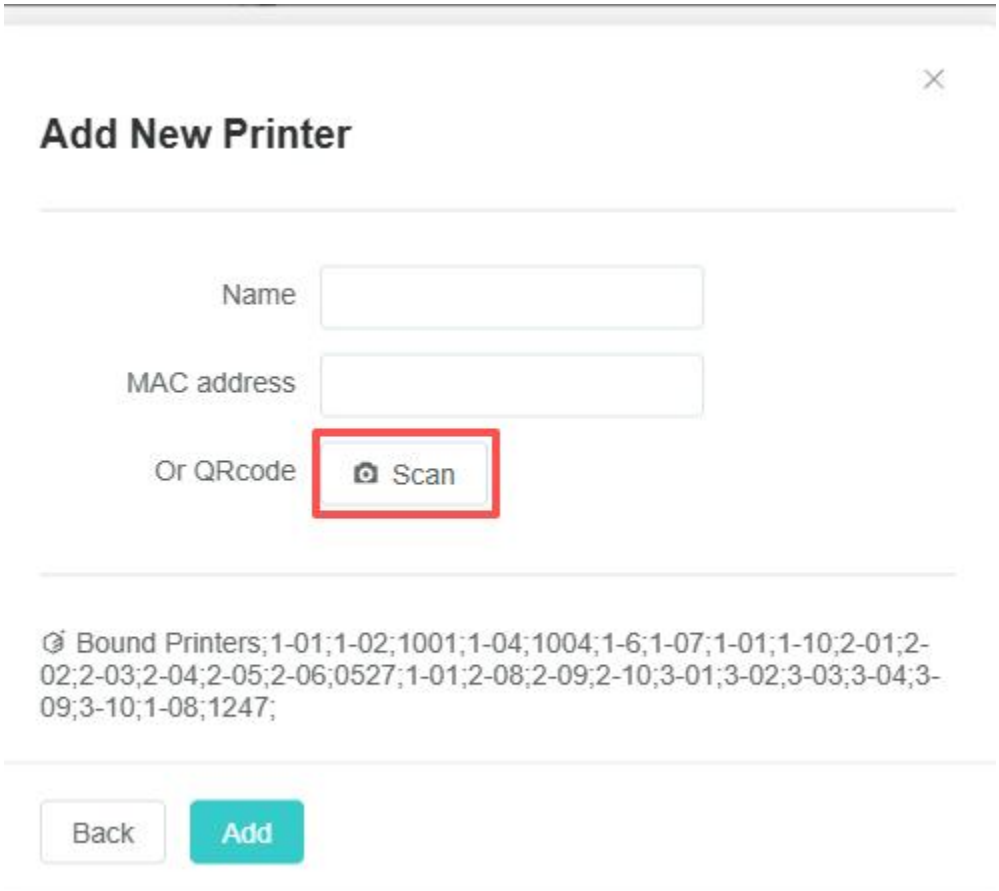


The printer number and MAC address can be found in the printer's more settings - system, as shown in the image.

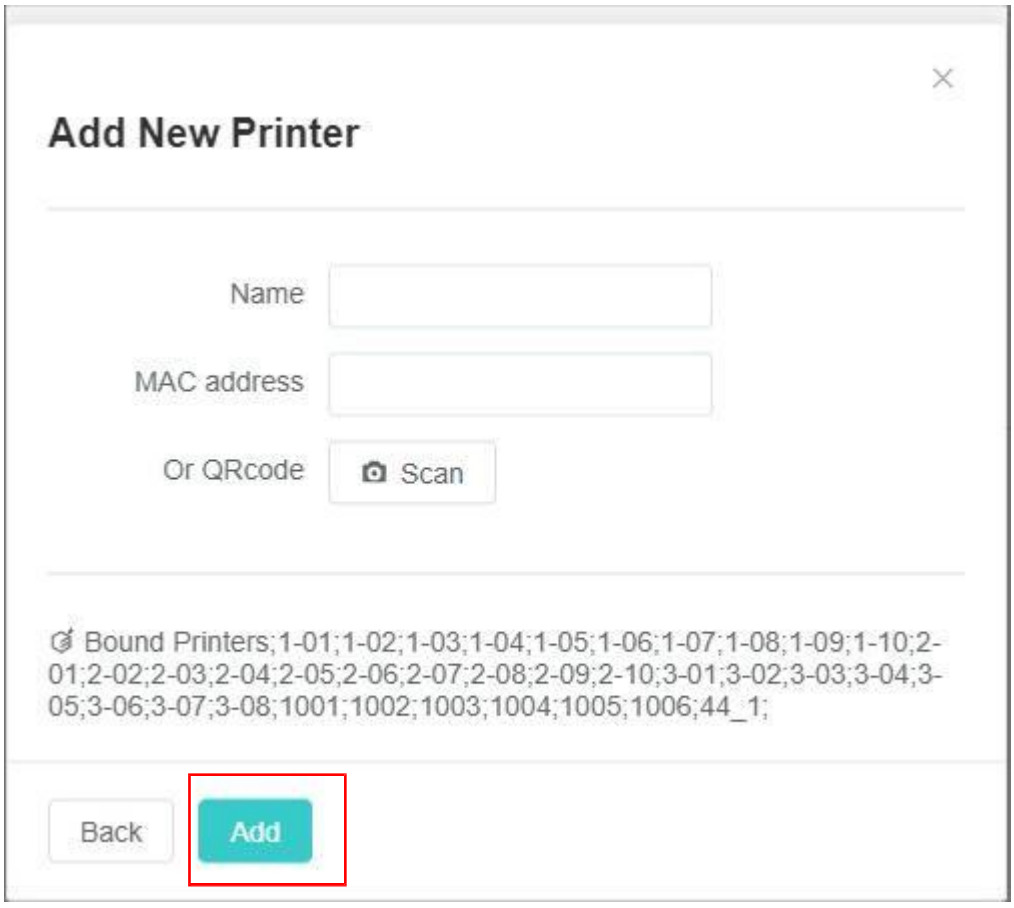

Thinker_X400 | Name:1-10 | IP:192.168.2.44 | Farm: eryone.club 10:45
Extruder 33
Heater Bed 30
Move
Temperature
Extrude
More
Print
40
30
20
10
0
10:28
10:32
10:36
10:40
10:44
Thinker_X400 | Name:1-10 | IP:192.168.2.44 | Farm: eryone.club 10:50
Fan
Lights
Calibrate
System
Screen Setting
Network
Console

Of course you can also scan the QR code to add a

printer!

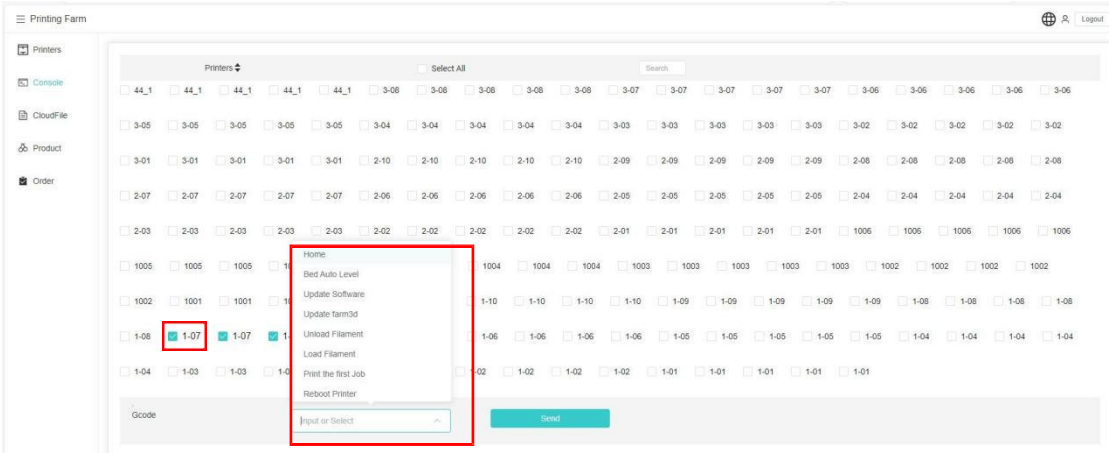


Click Add again to add a printer.



6.2.2Console

Send commands (e.g., homing, firmwareupdate)



Load Filament： Load filament

Print the first job： Perform the first print job Reboot Printer：

Restart the printer

Shutdown Printer： Turn off the printer. Emergency

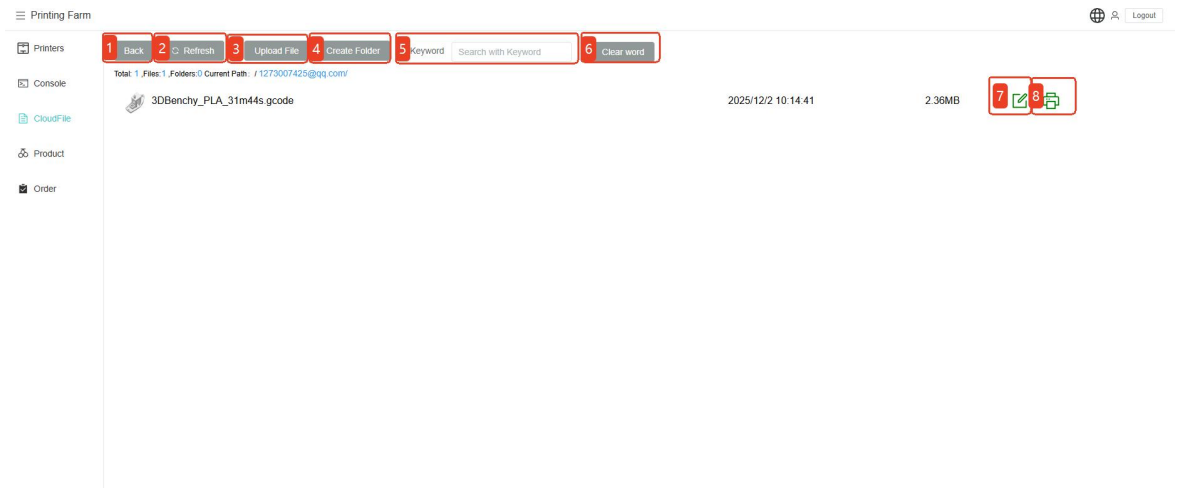
Stop： Emergency stop

Upload Klippy.log： Upload Log Restart

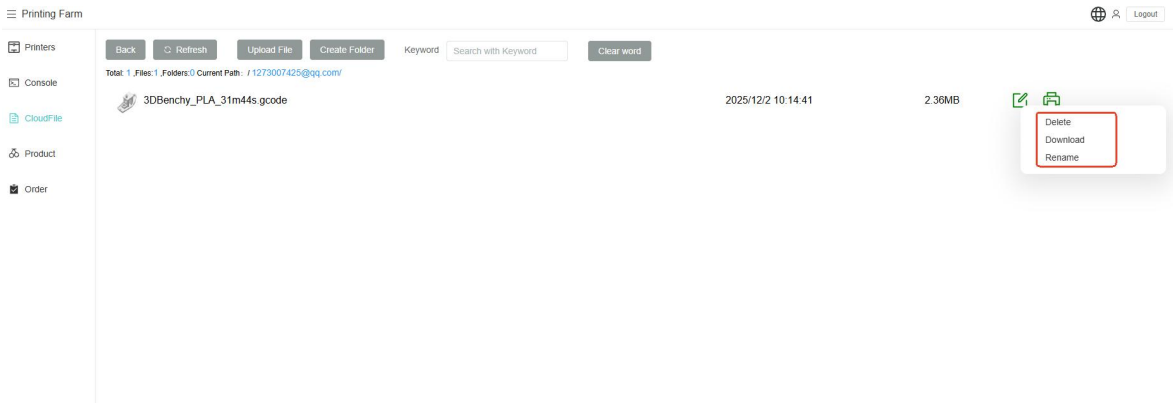
Kipper Screen： Restart Screen

6.2.3Cloud Files

Manage sliced files.



1. Return: return to the previous level
2. Refresh: Refresh the file
3. Upload File: Import a file
4. New folder: create a folder
5. Keyword: You can search gcode files by keyword.
6. Reset search: clear the search keywords
7. ：Click to select “Delete,” “Download,” “Rename.”

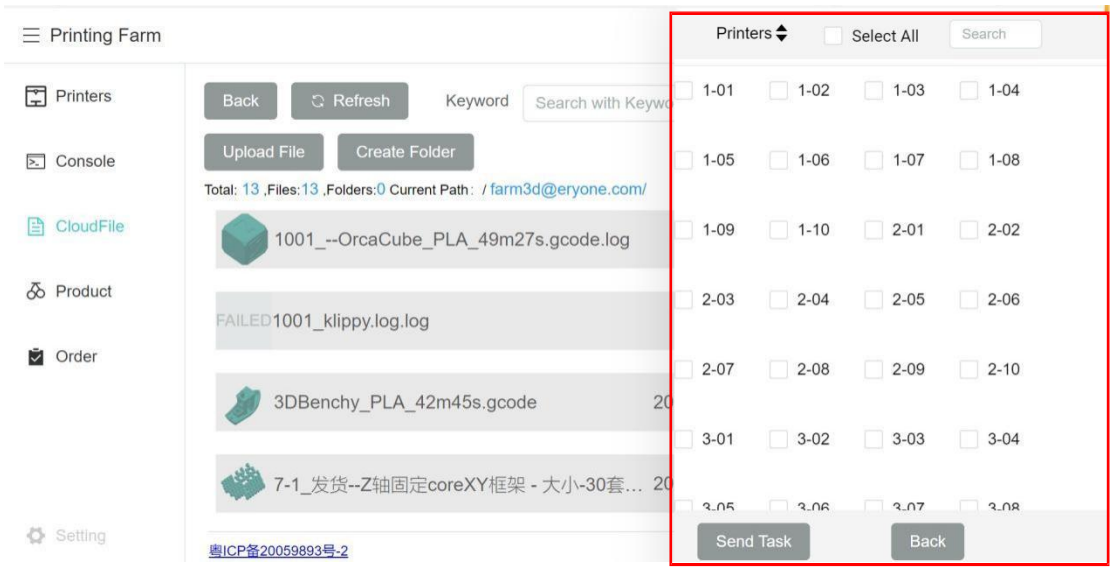


Delete: delete the gcode file

Download: download the gcode file

Rename: Rename the gcode file

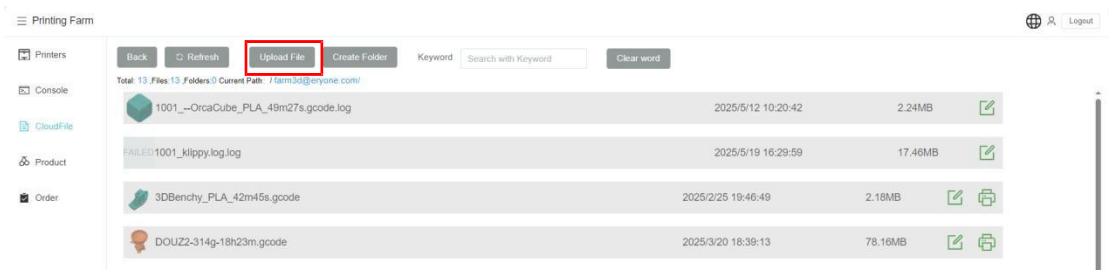
8. ： Click to send this file to the printer.



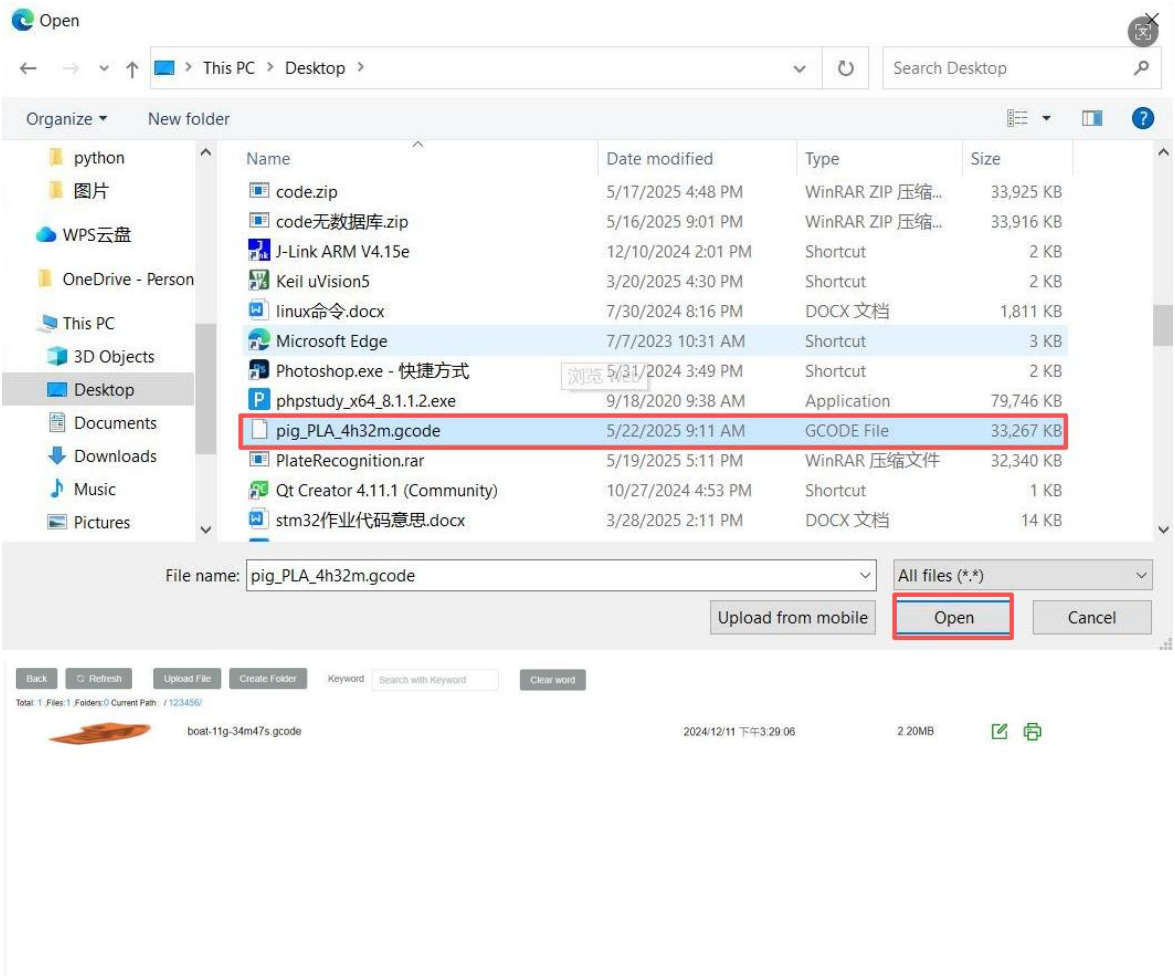
How to upload and print a file?

Such as：

Click “Upload File”

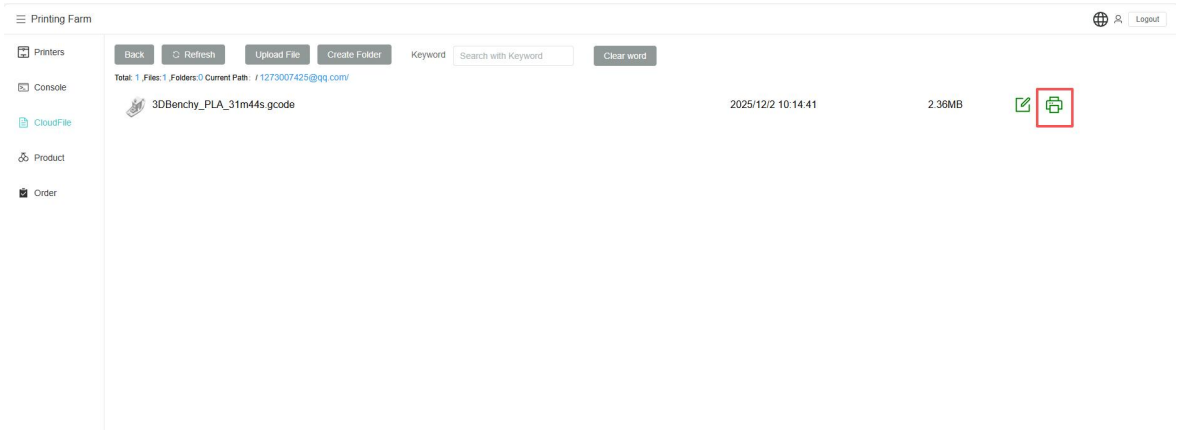


Select the gcode file you want to upload

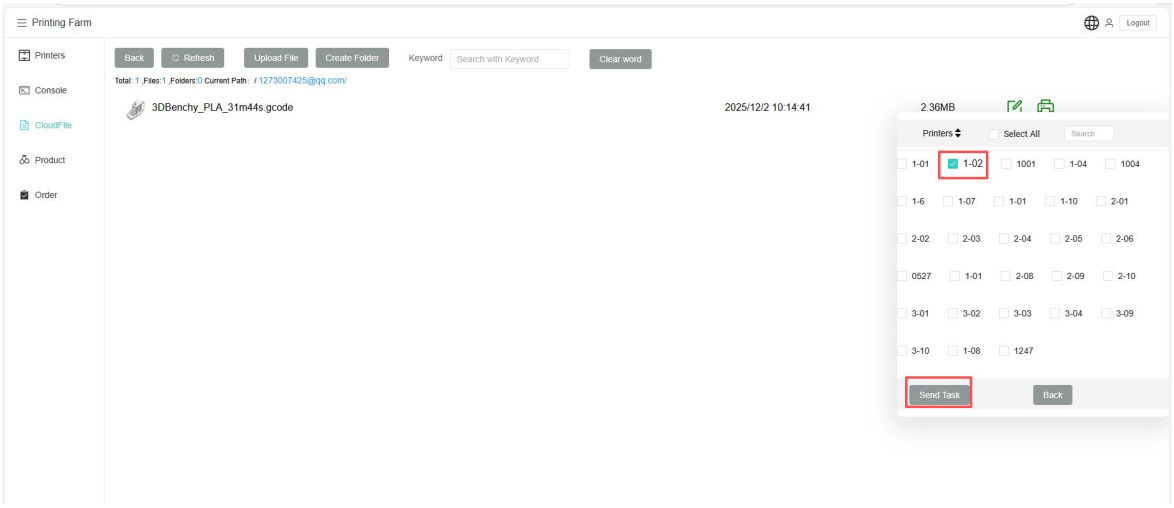


So it's uploaded to the cloud.

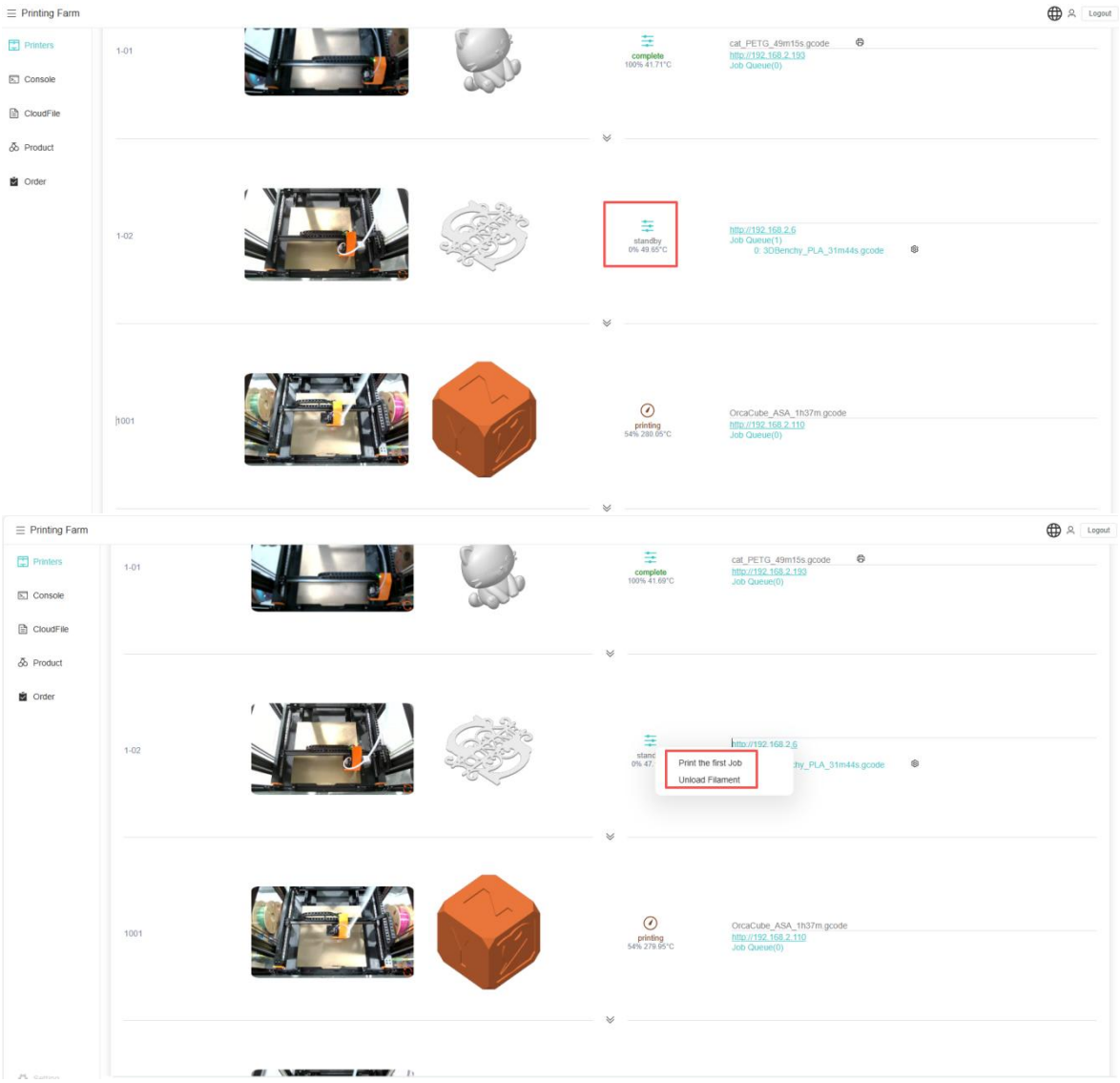
The next step is clicking the 



Select the printer you need to print to, then click Send Job.



Come back to the printer and click on the Settings button on the right hand side.

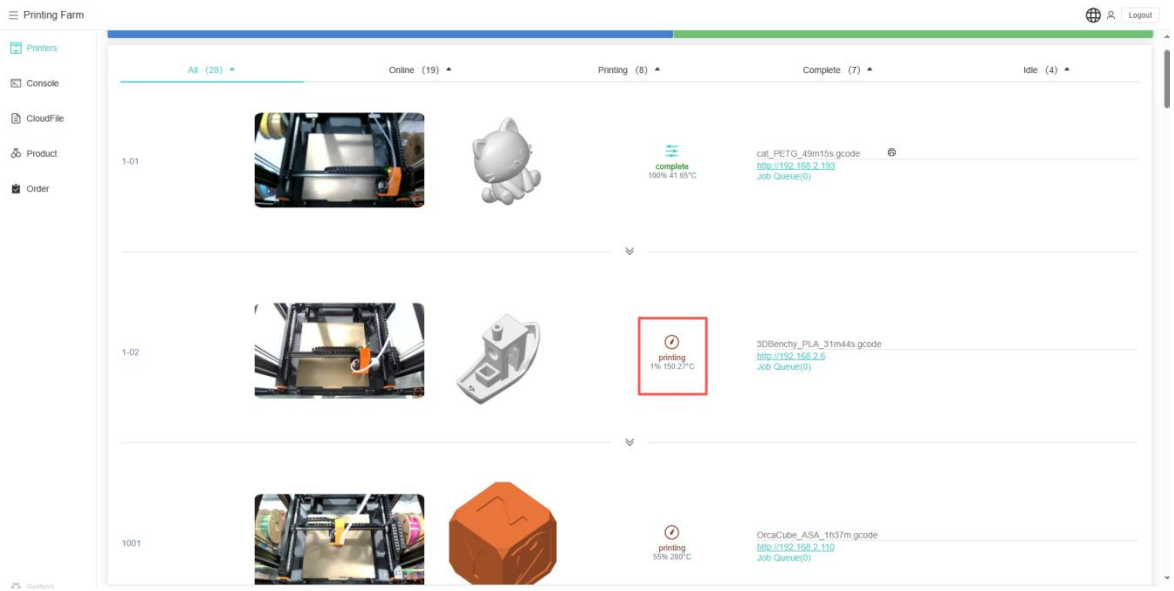


Printing the first job: the first job in the print queue

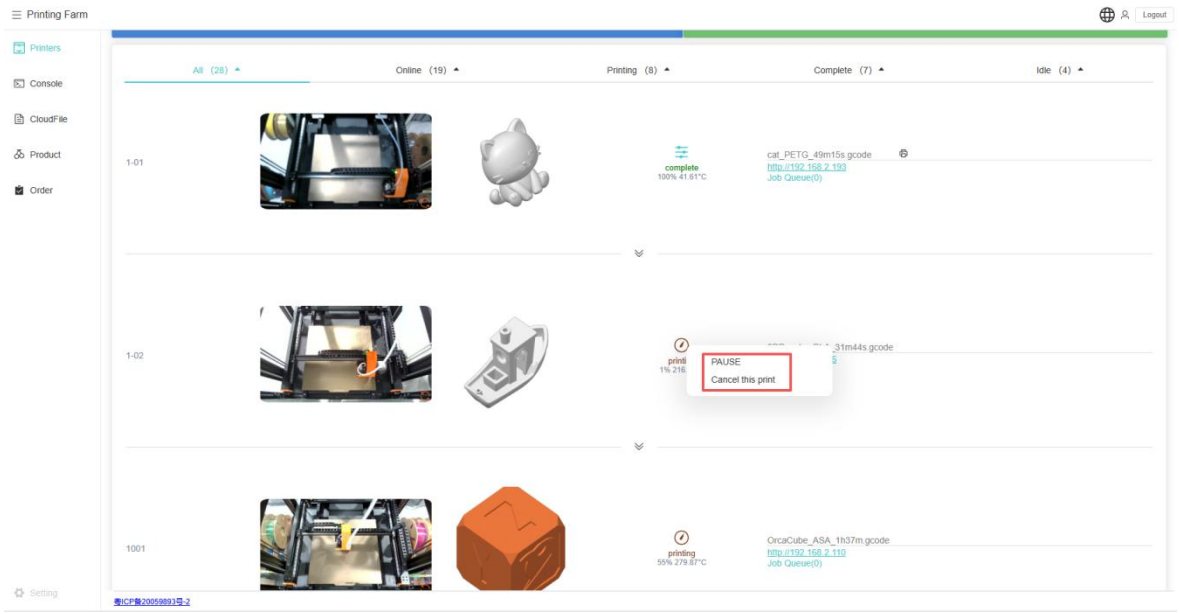
Changeover preparation: unloading filaments

We can start printing by selecting “Print first job”

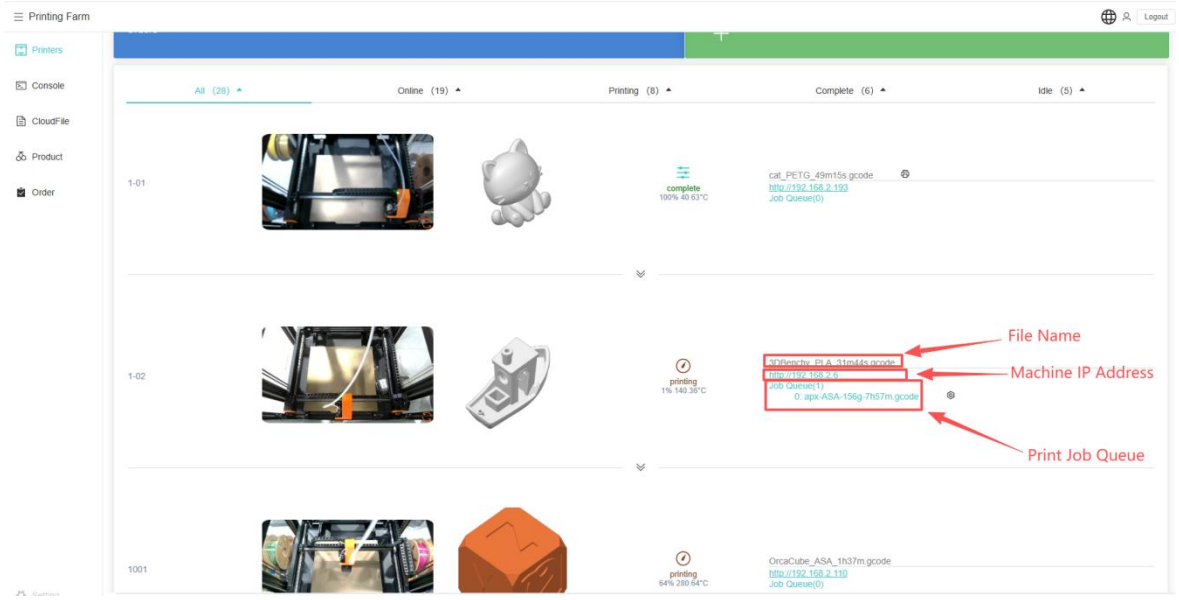
Here you will see the Printing prompt.



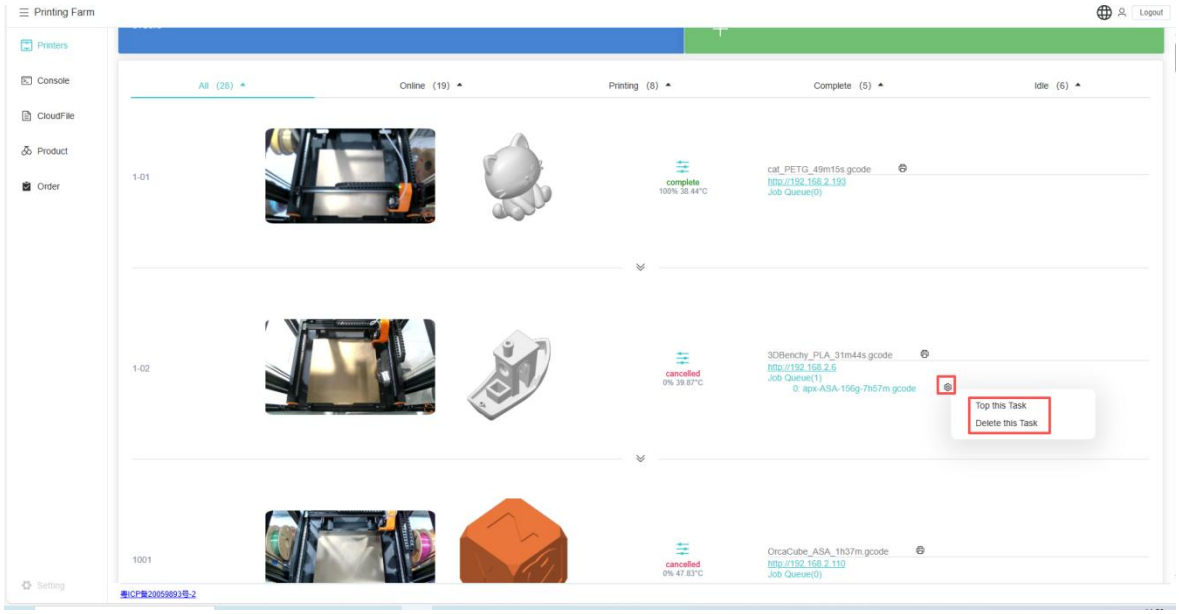
Clicking also gives you the option to pause or cancel printing.



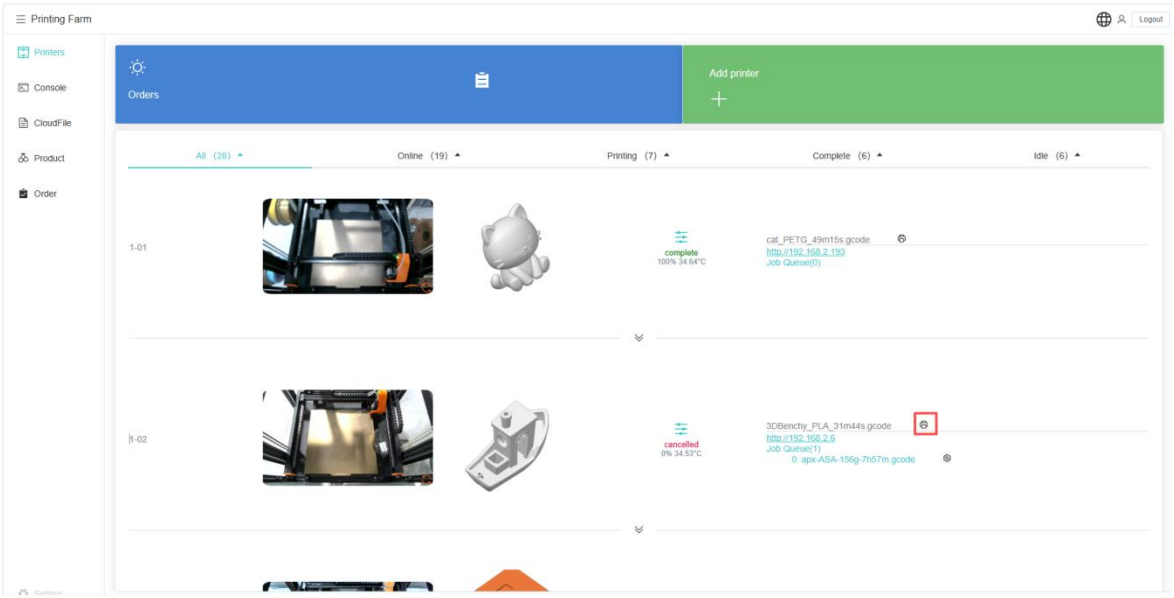
The right button functions as shown below：

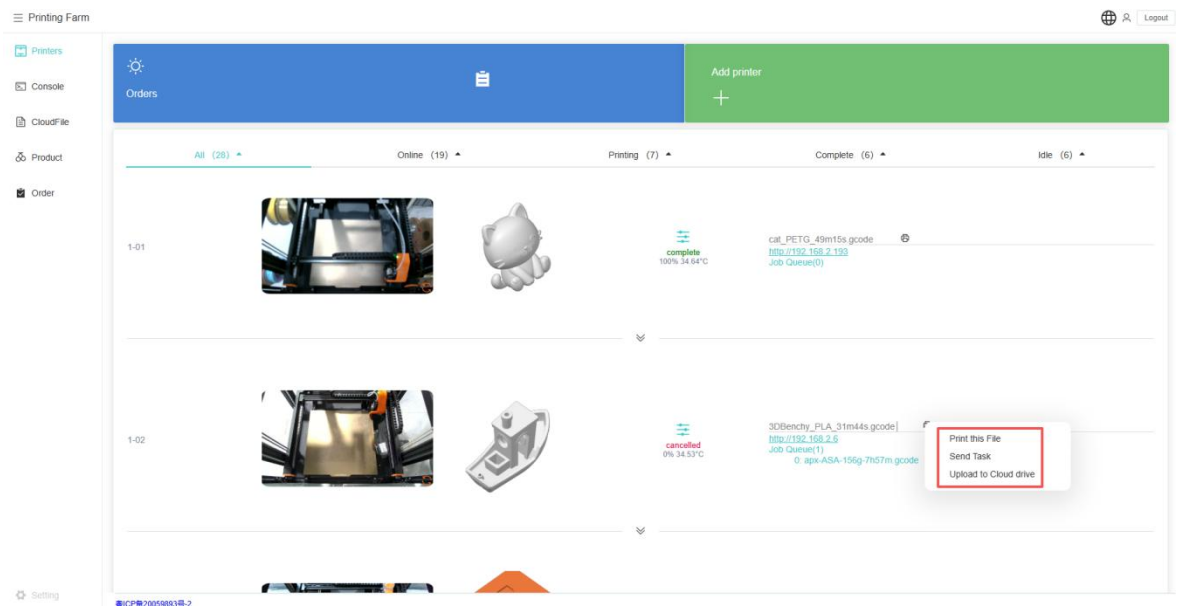


When printing more than one job, you can adjust the order of the print store and cancel the printing of the document, as shown in the figure.



When you want to reprint, upload to the print queue, or upload to a cloud drive for a file that is at the end of a print job, you can click the button to the right.



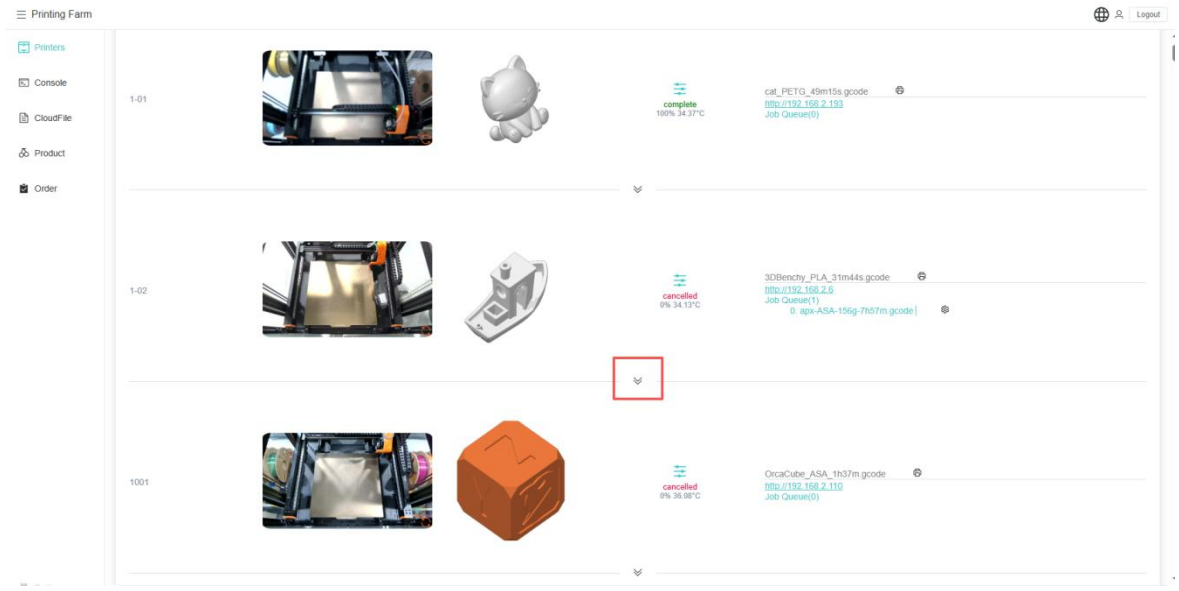


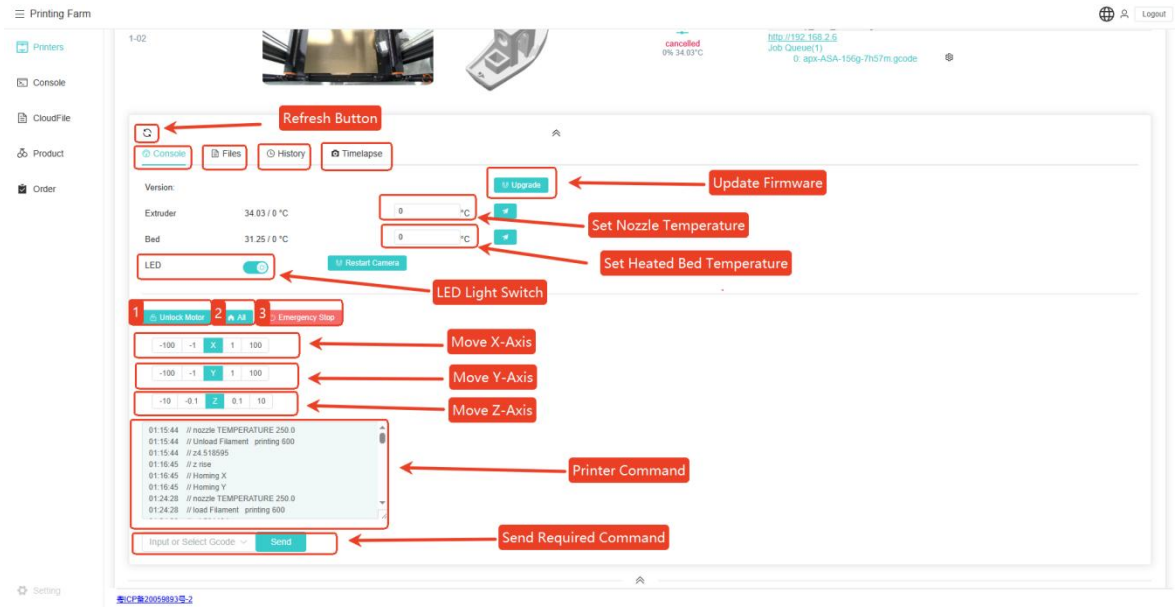
Print this file: reprint

Send Task: send this file to the print queue

Upload to Cloud: upload this gcode file to the cloud file

Click”⩔”to expend





：Refresh Button

File: Files in the printer History: Files in

the history

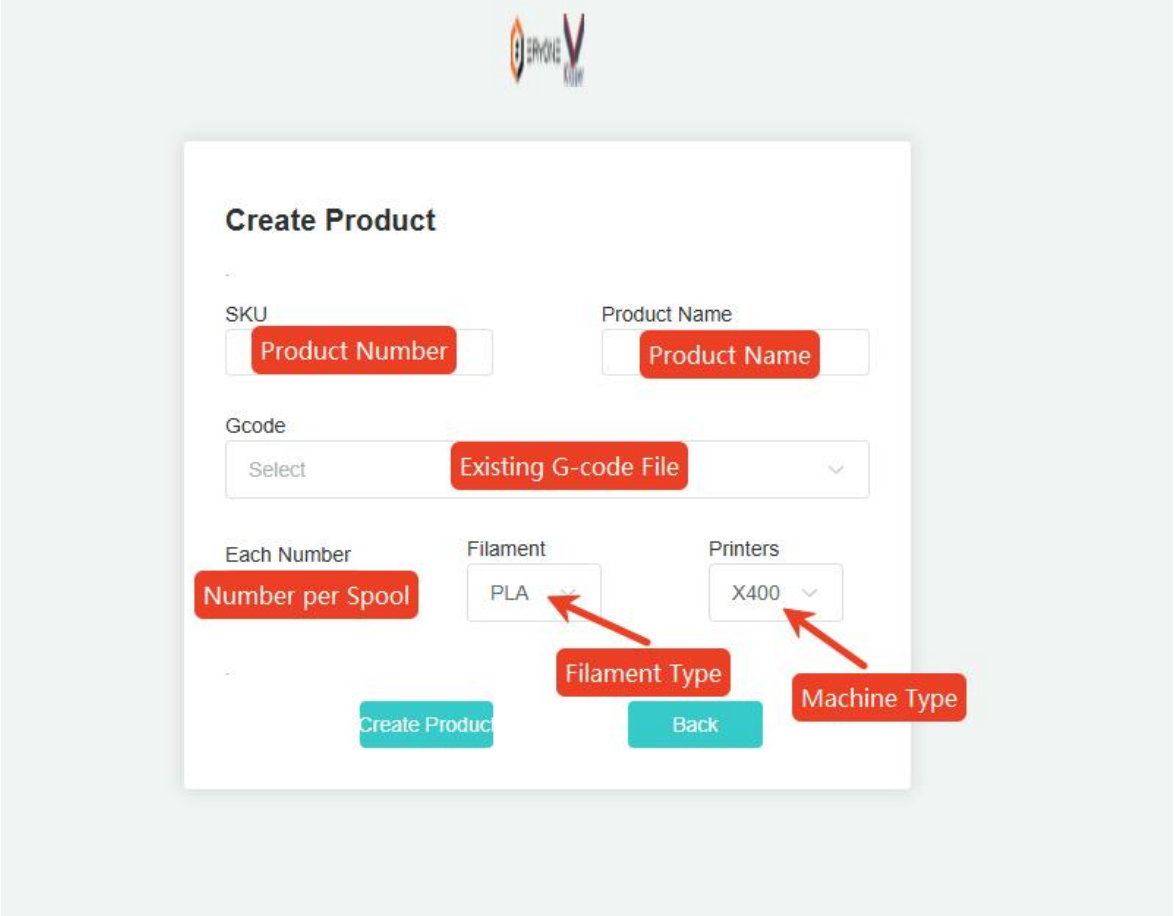
Photography: Files in the time-lapse photography

1. Unlock motor: tool head can be moved manually
2. All: X, Y, Z axis reset (X: 200 Y: 200 Z: 3)
3. Emergency Stop: stops all printer commands.

Note: Unlock Motor, All, and Emergency Stop functions are not enabled when a print job is available.

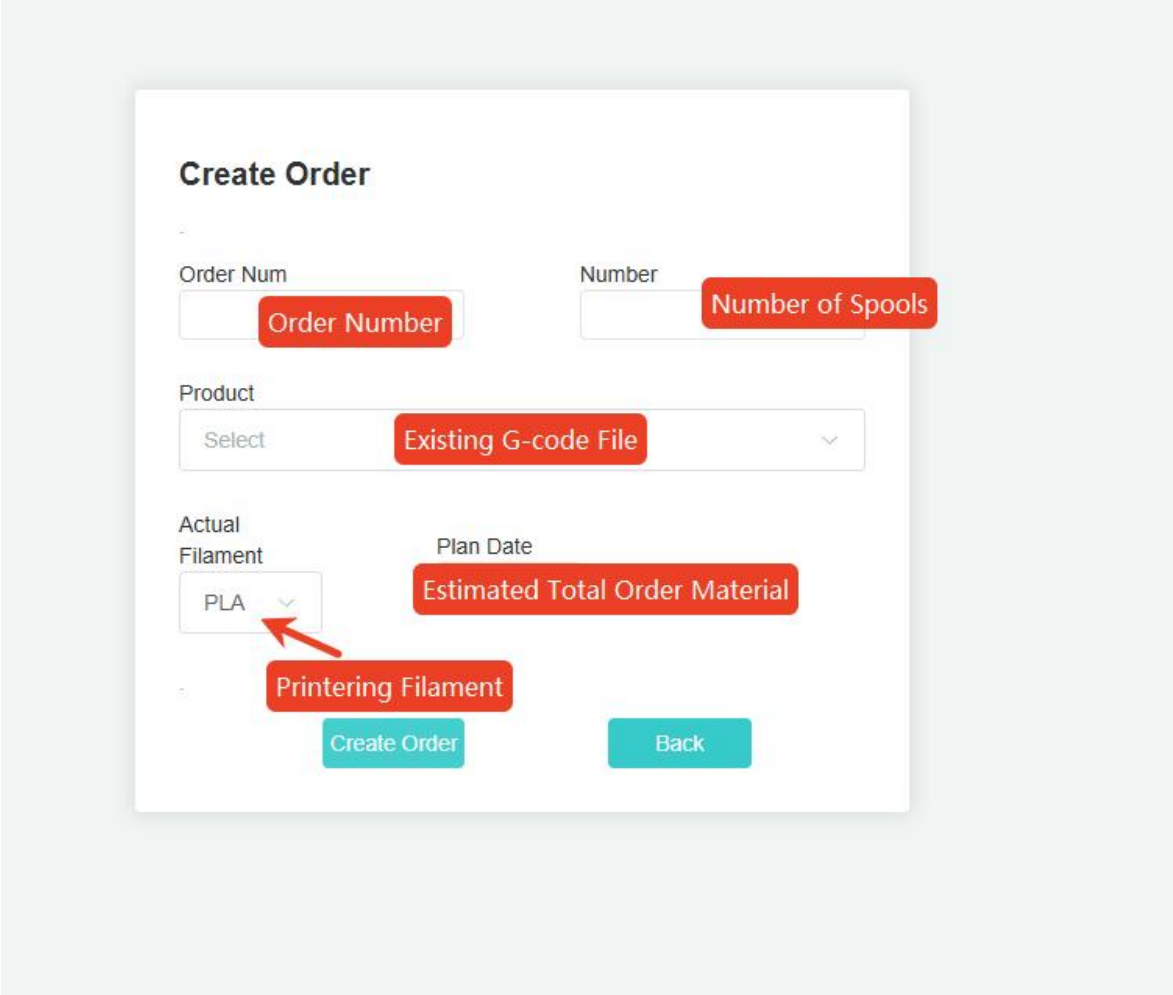
6.2.4 Products

Create and track projects.



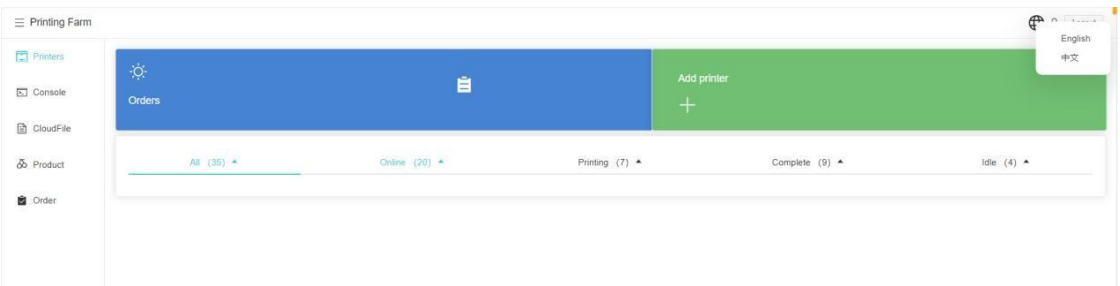
6.2.5 Orders

Create an new order



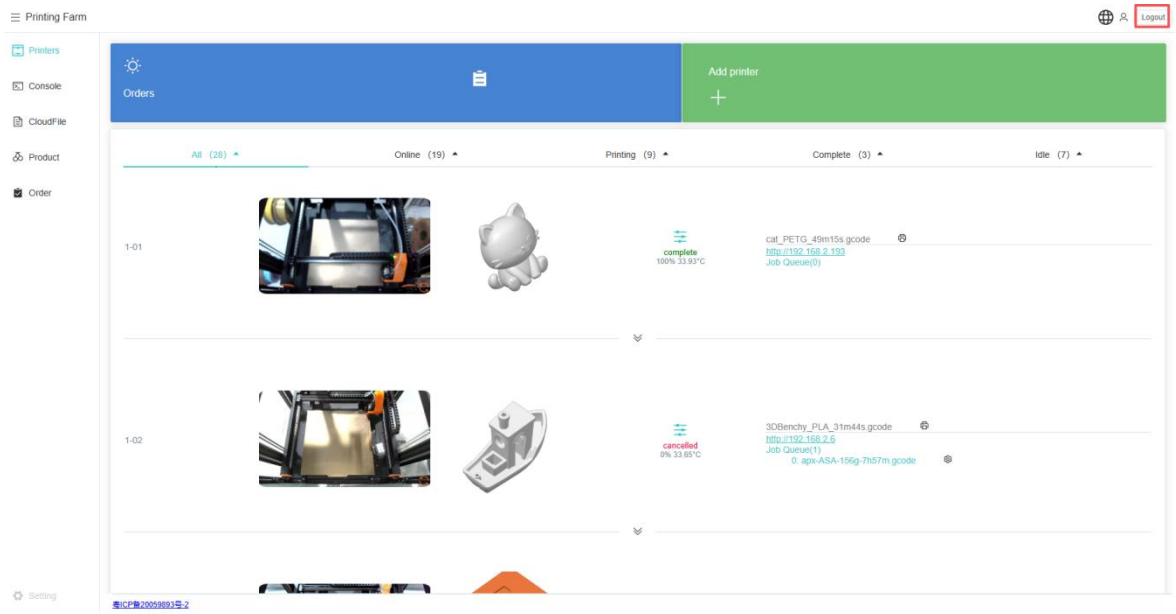
6.2.6 Language

Switch between Chinese and English.



6.2.7logout

Click to log out of the account.

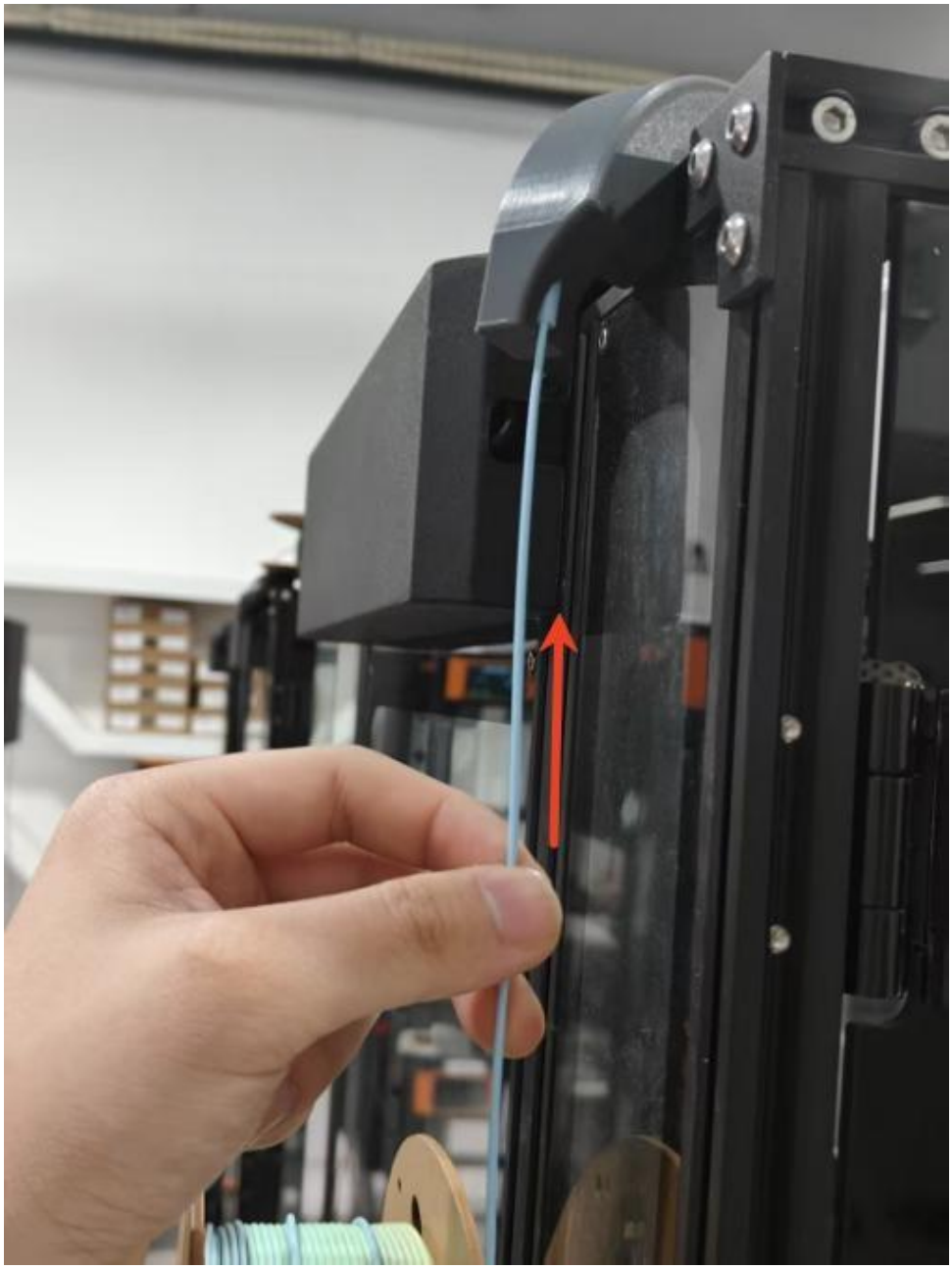


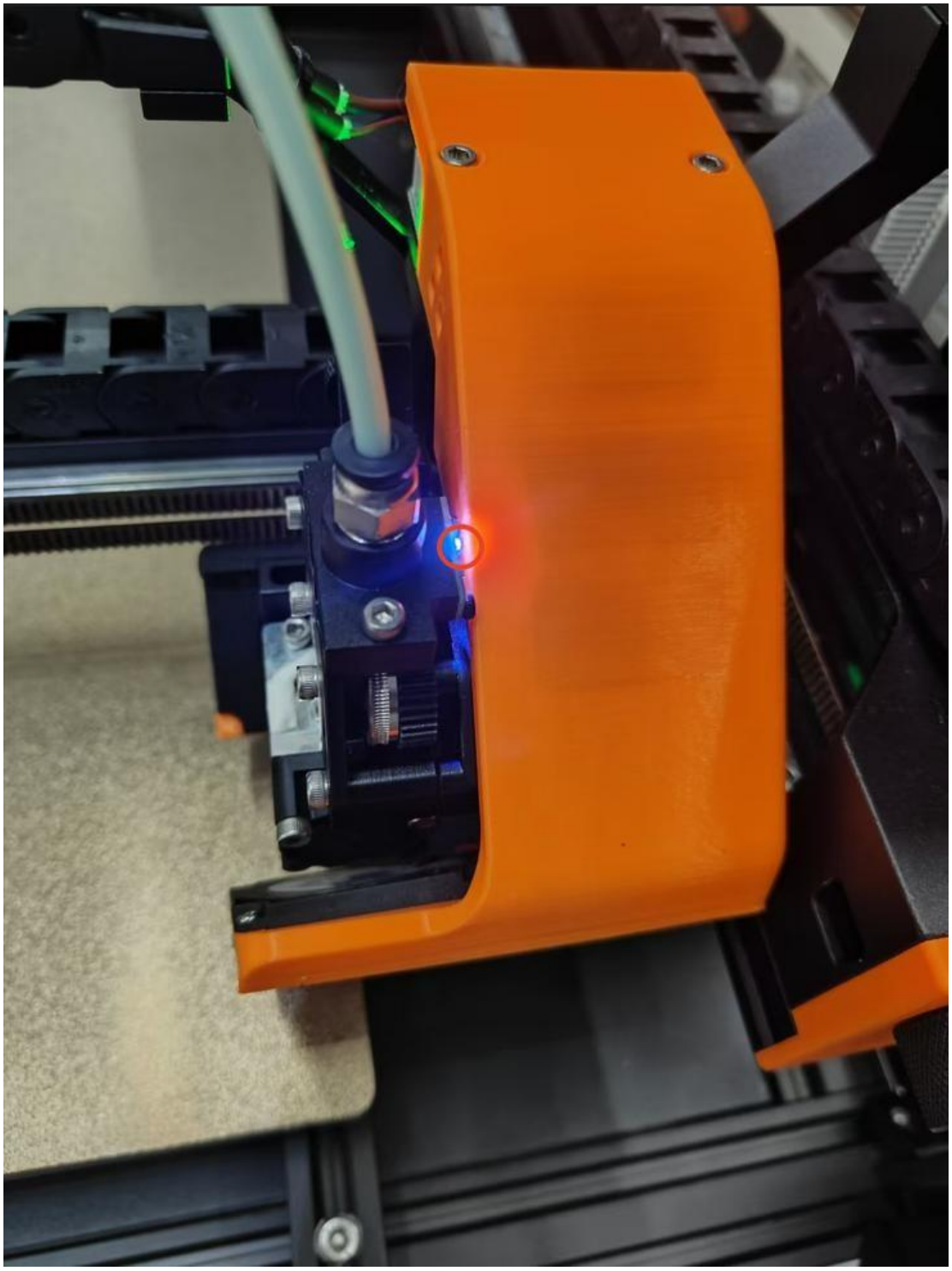
7.Printing Guide

7.1 Loading Filament

Procedures

Step 1：Insert filament into the PTFE tube until the LED turns blue.

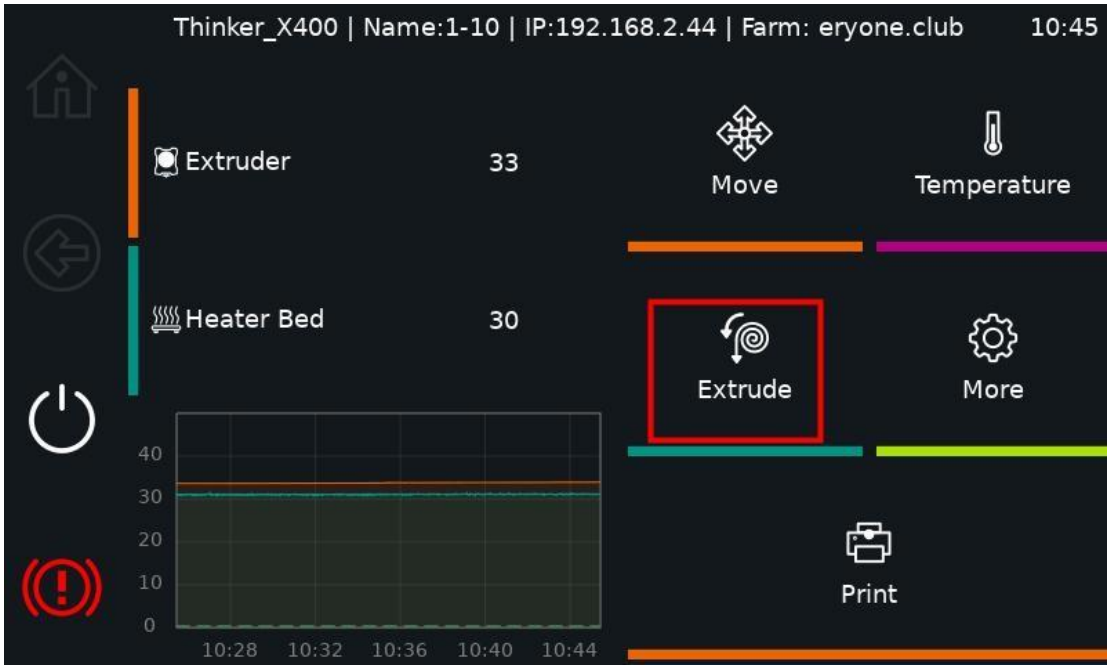




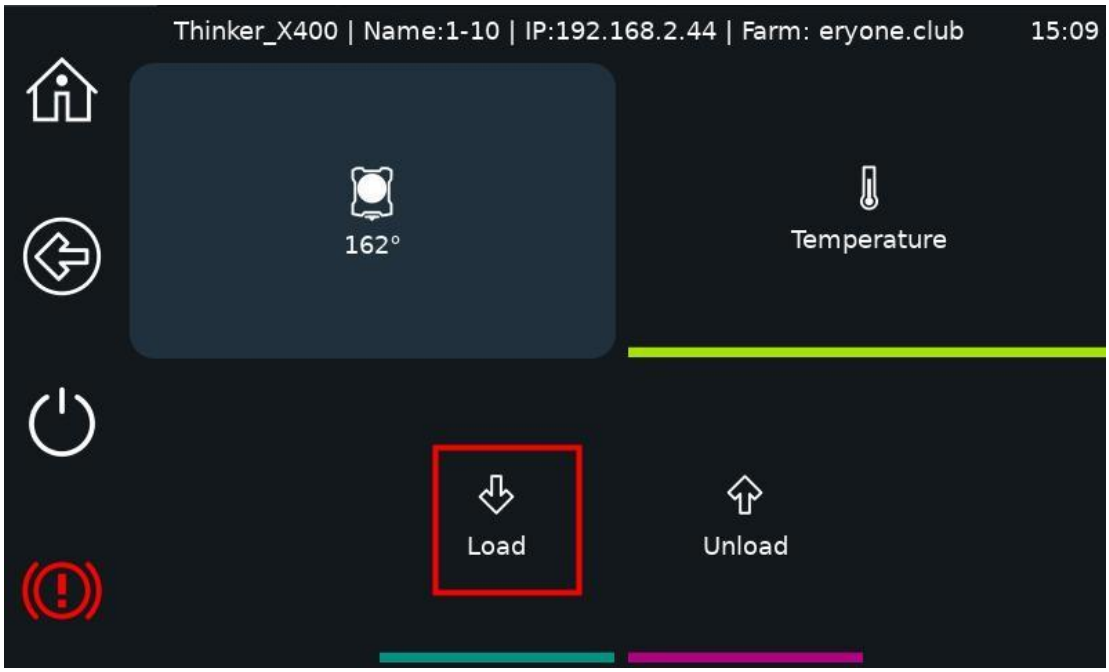
If the blue LED does not appear, it is possible that the wire on the breakage detection board has fallen off, simply replace the board with another breakage detection board.

Alternatively, you can feed the material manually.

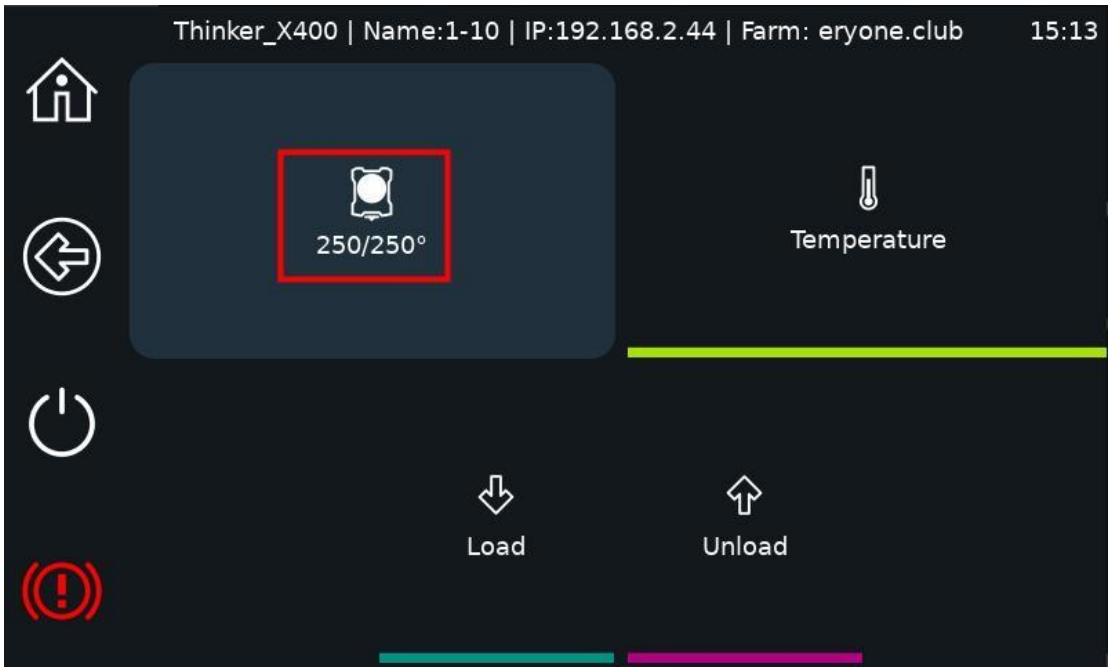
Click on the “Extrude” button.



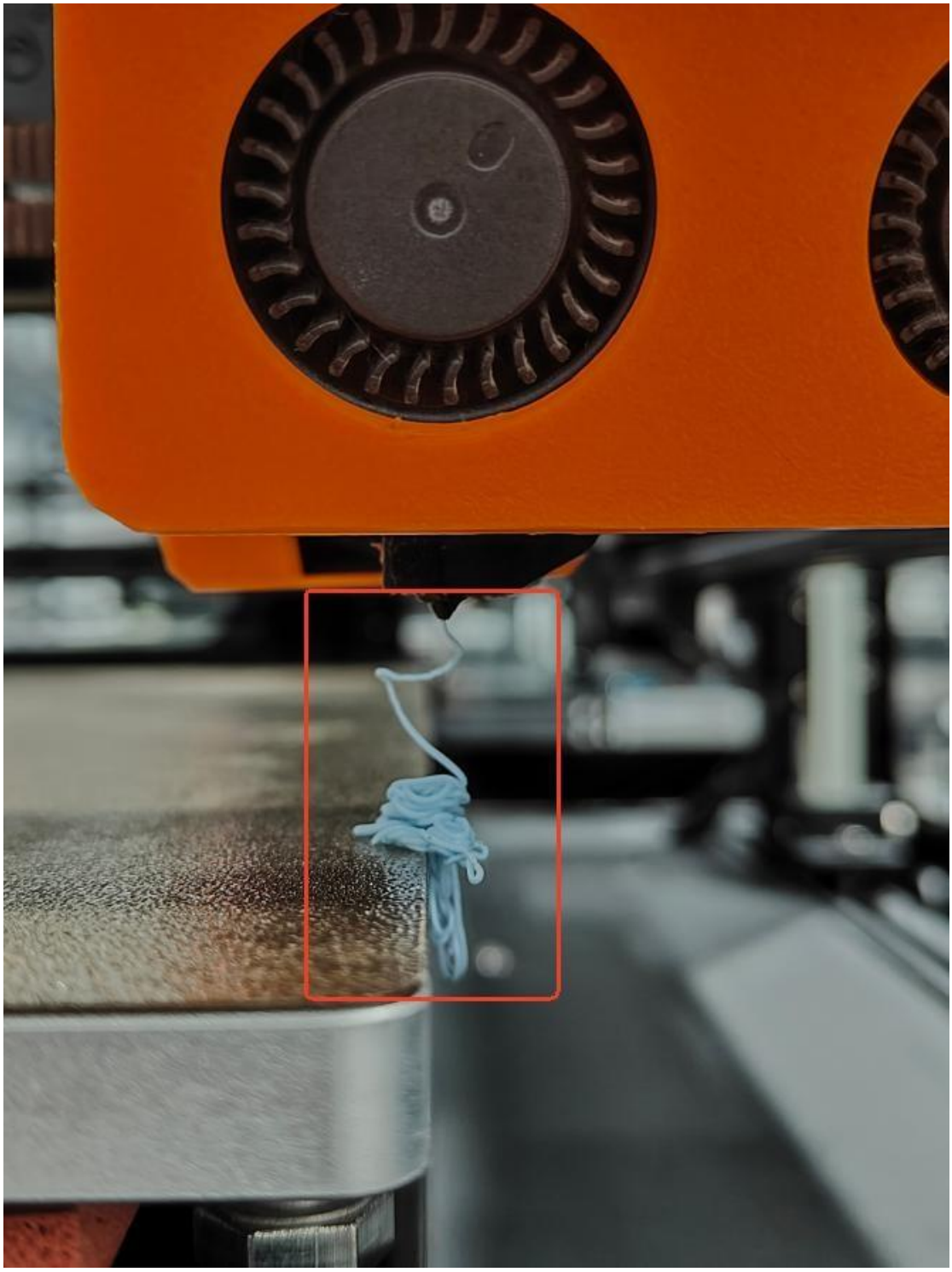
Click"Load Filament"



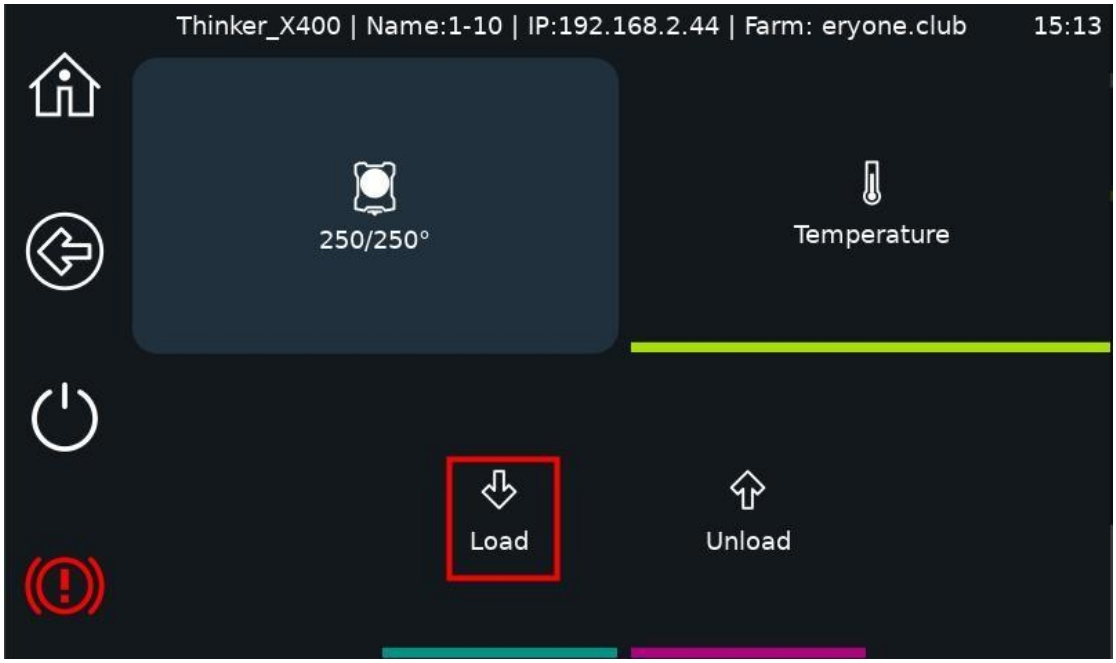
Step 2: Wait for the nozzle to heat to 250°C.



Step 3：Observe extrusion to ensure proper feeding.



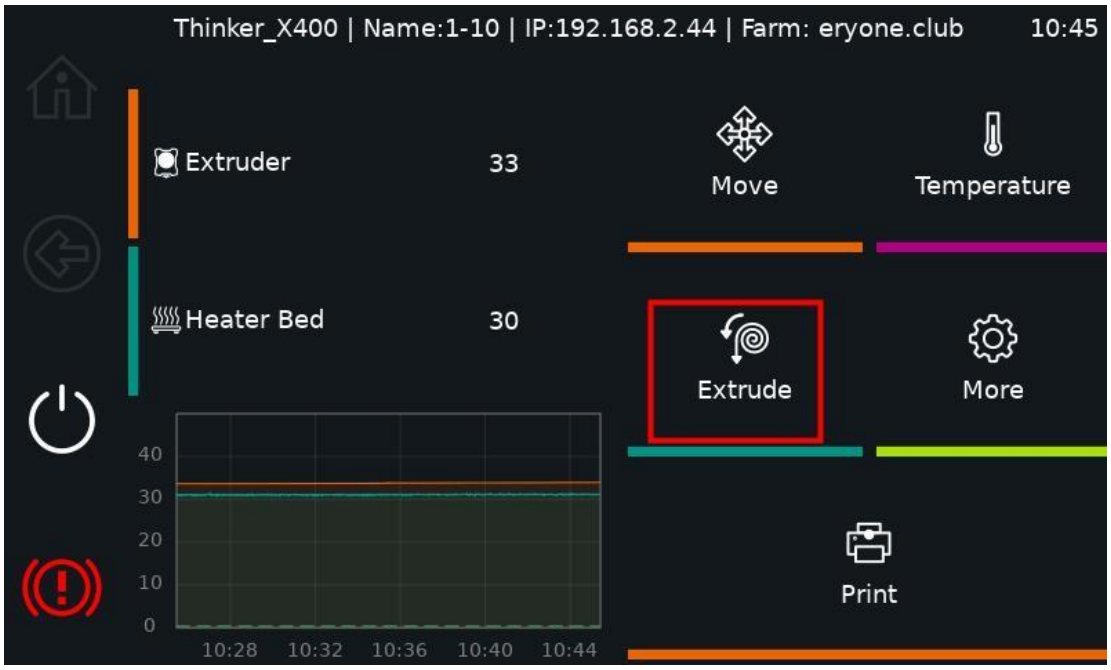
Step4:Ifthefilamentisnotspitout,click“LoadFilament” on the screen to try feeding again.

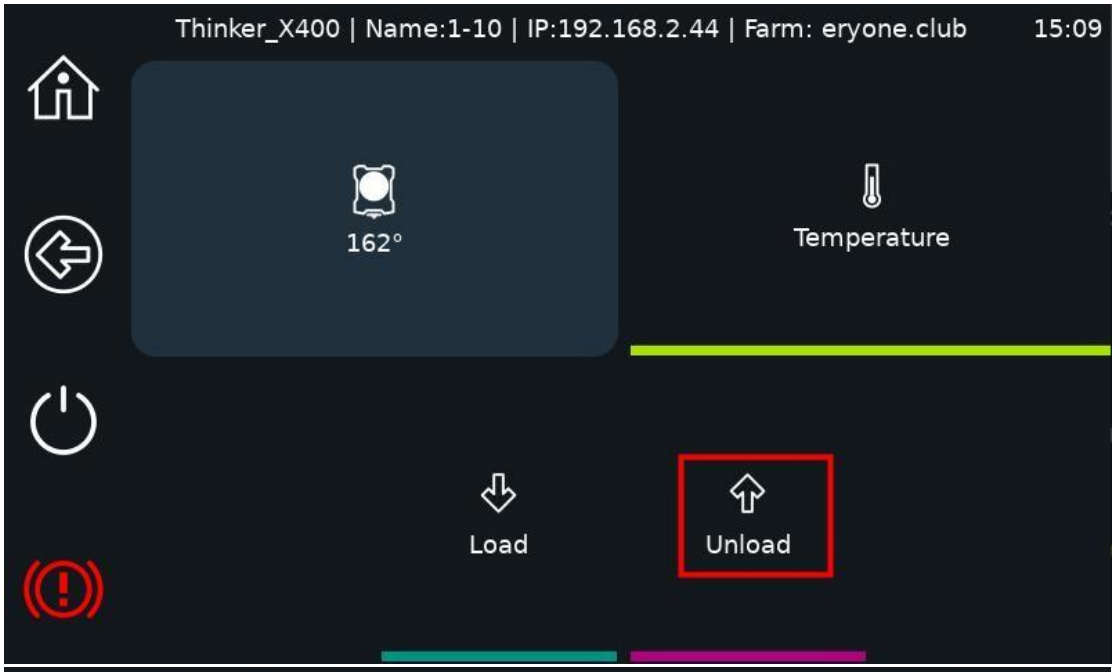


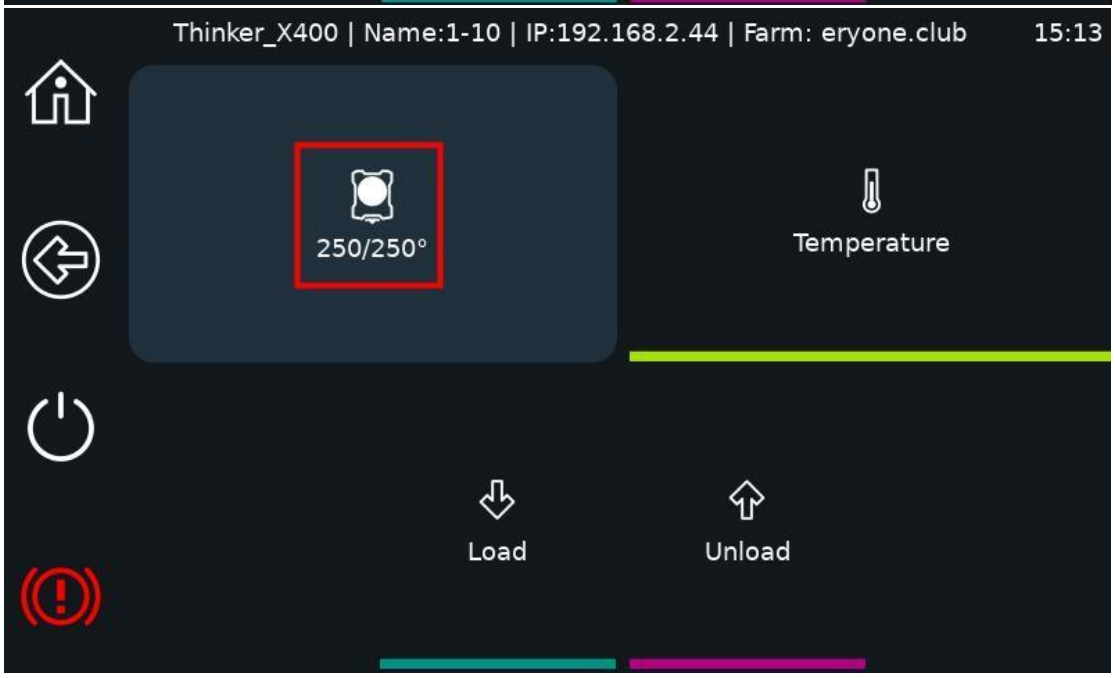
7.2 Changing Filament

Procedures

Step 1：Click on the Extrude button on the screen and select "Unload" The nozzle will automatically start to heat up to 250°C and draw back the filaments.

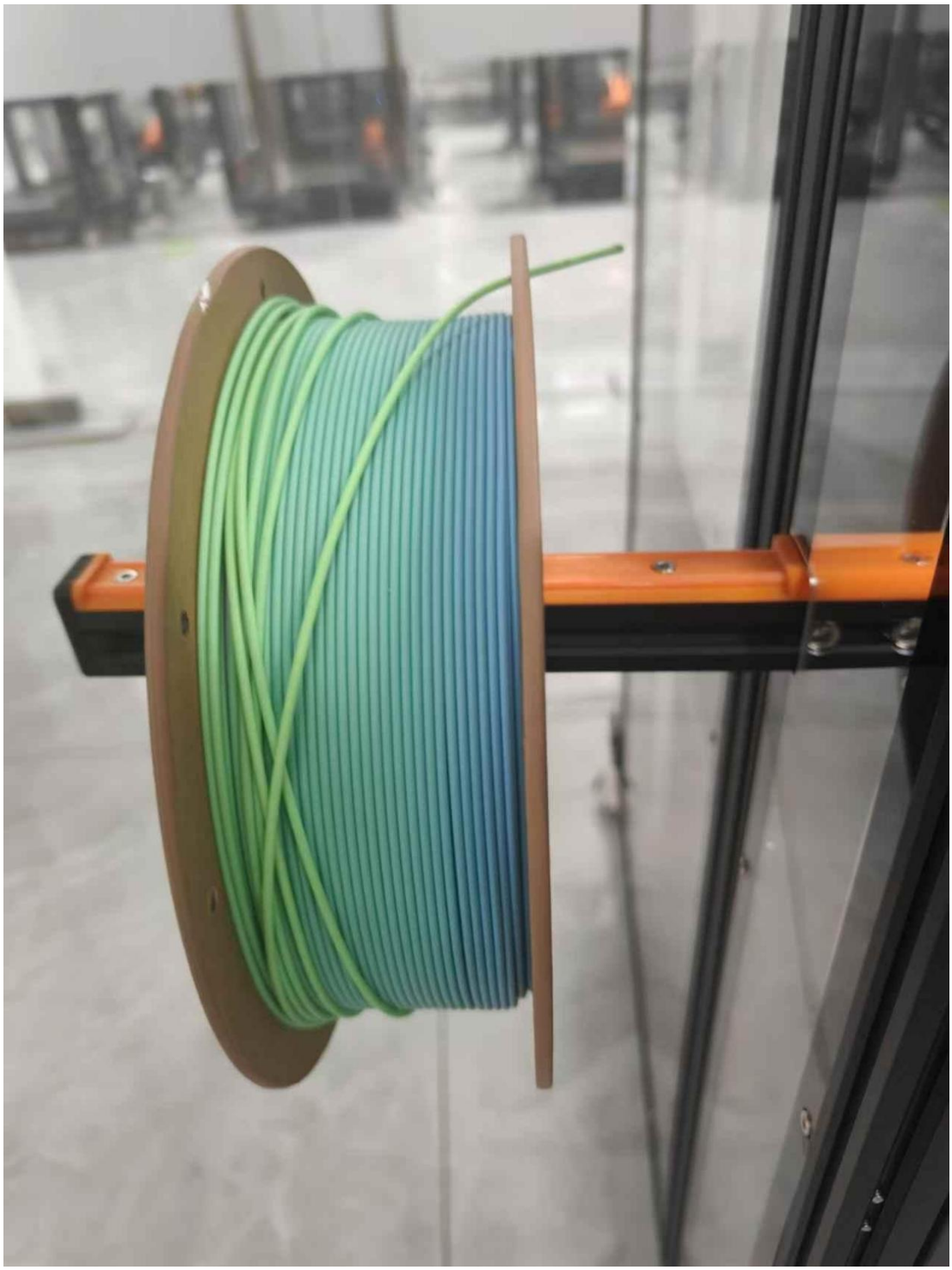




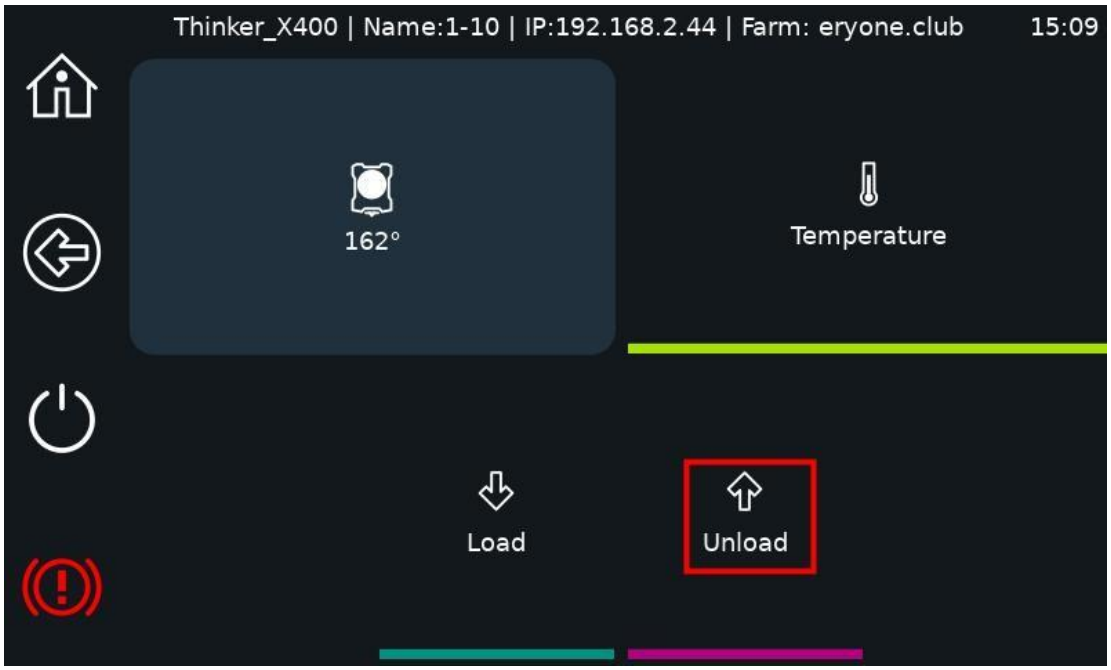


(Ifyouneedtoreplacethefilamentsinthemiddleofprinting or if you don't have any filaments and need to replace the filaments, clickonSettings, findthechangebutton, andthen do the above)

Step 2：Manually remove the filament.



Step 3: If you did not remove the filament, click “Unload ” again and pull out the filaments again.

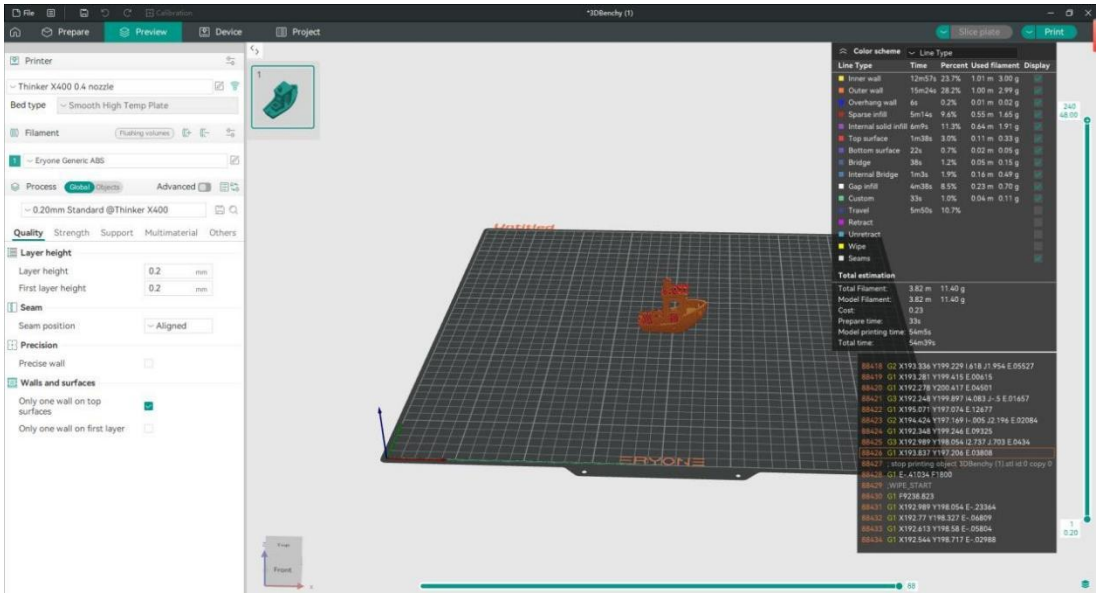


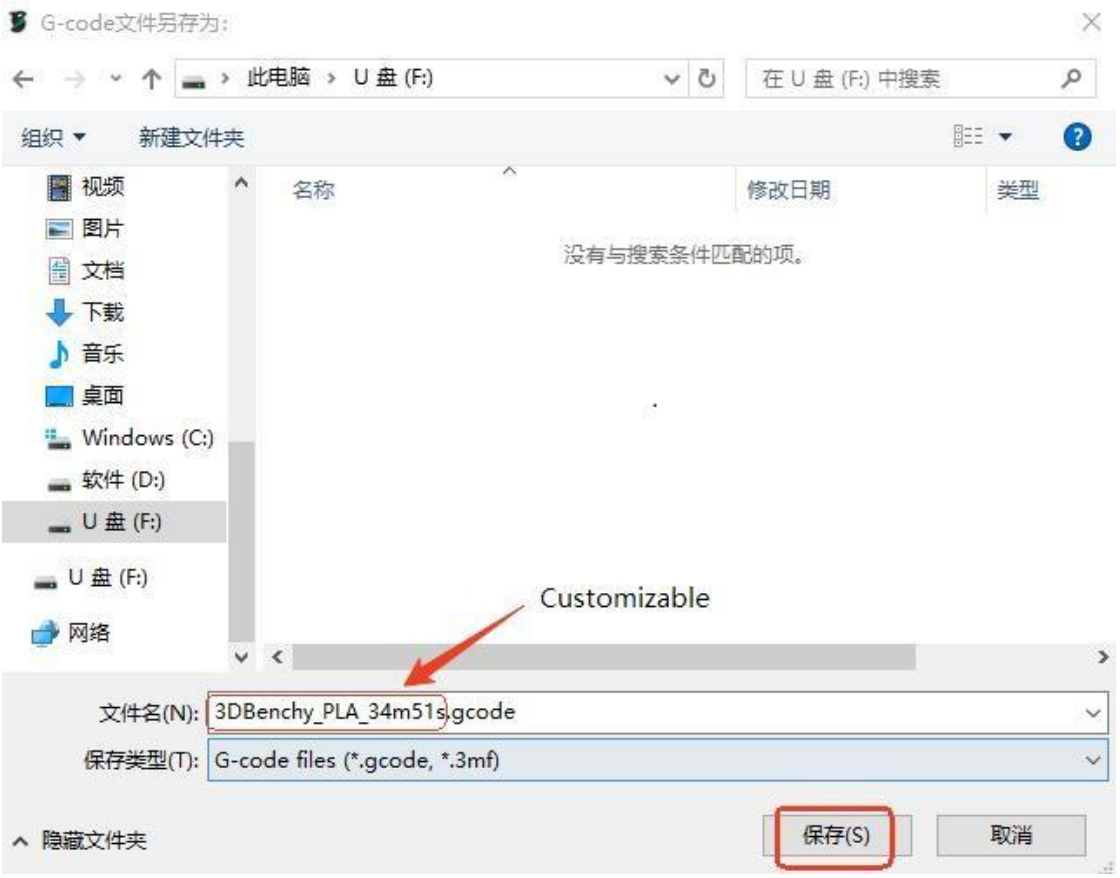
Step 4: Just take out the other roll of filaments and load it. For operational details, see: Loading Printing Filaments (7.1)

7.3 Printing from USB

Procedures

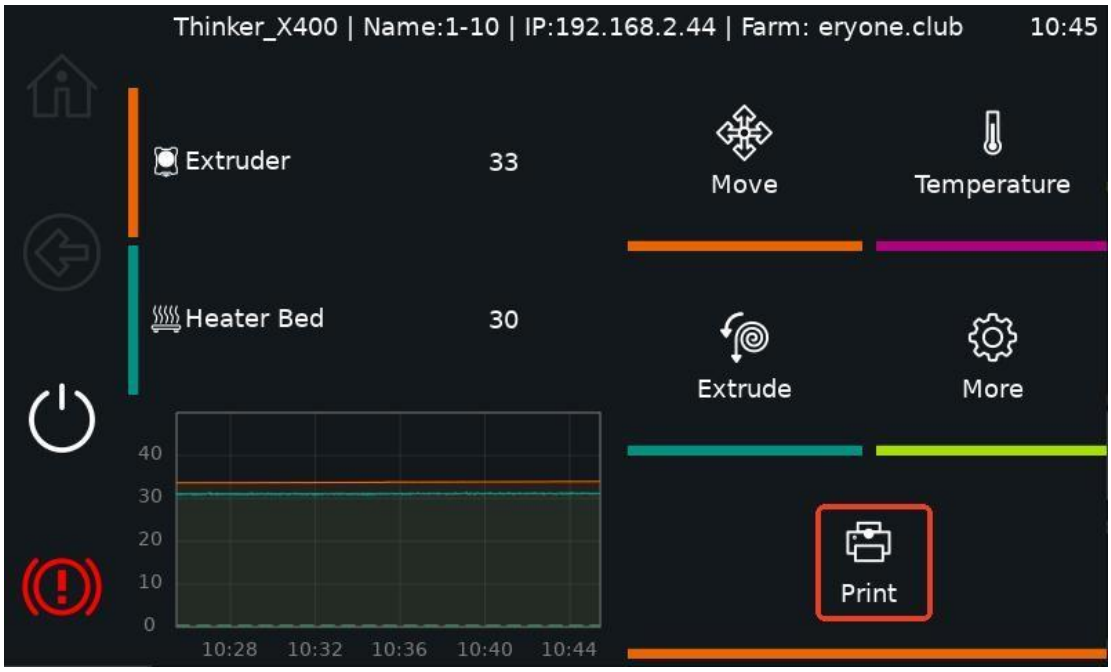
Step 1：Save the sliced file to a USB drive.





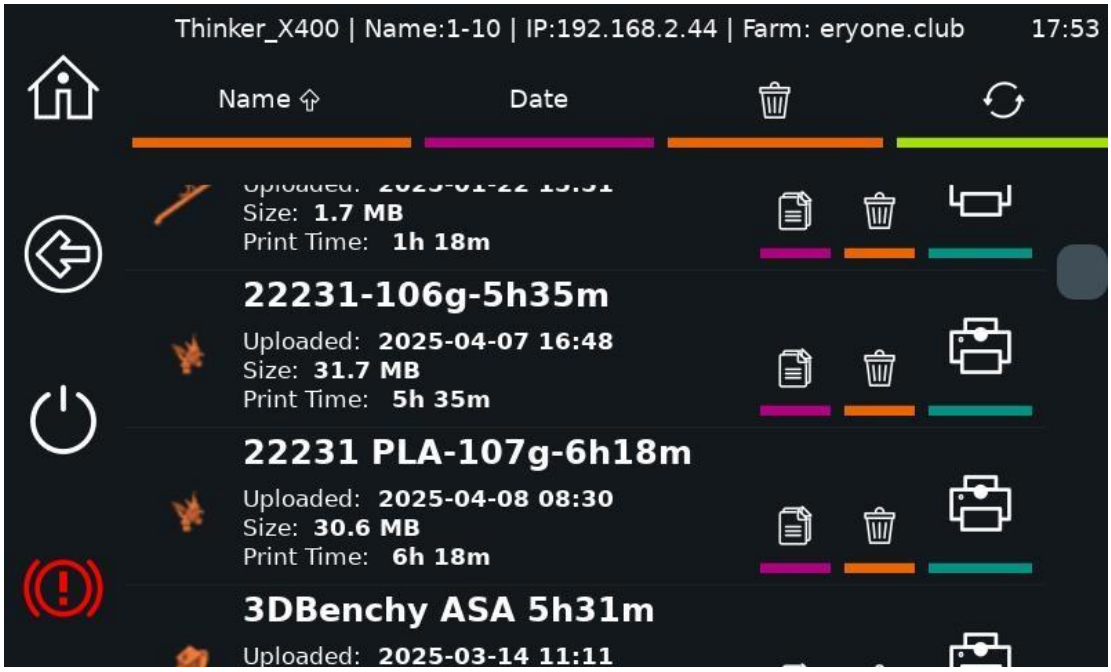
Step 2：Insert the USB into the printer.

Step 3: Click the Print button on the screen to jump to the Print Cache page.

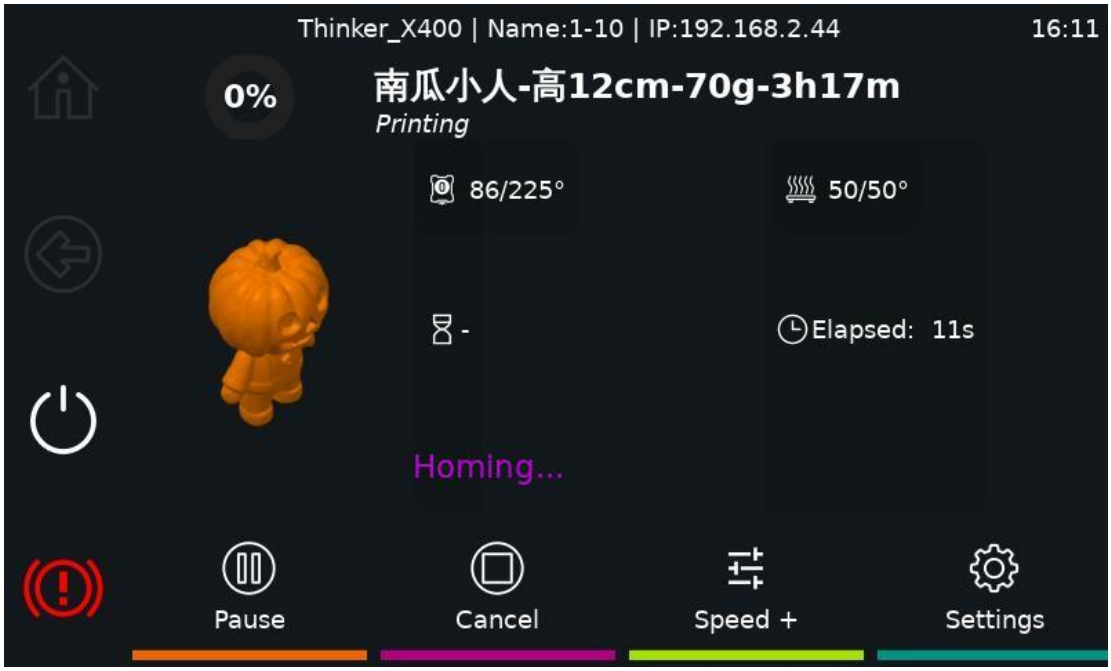


Step4:ClicktheRefreshbuttononthescreenandtheUSBflash drive folder appears.

Step5:ClickintotheUSBflashdrivefileandselectthemodel you want to print.



Step 6: Click the Print button and start printing the model.



Note:

The small fan next to the heat sink will be turned off when the nozzle temperature falls below 42°C

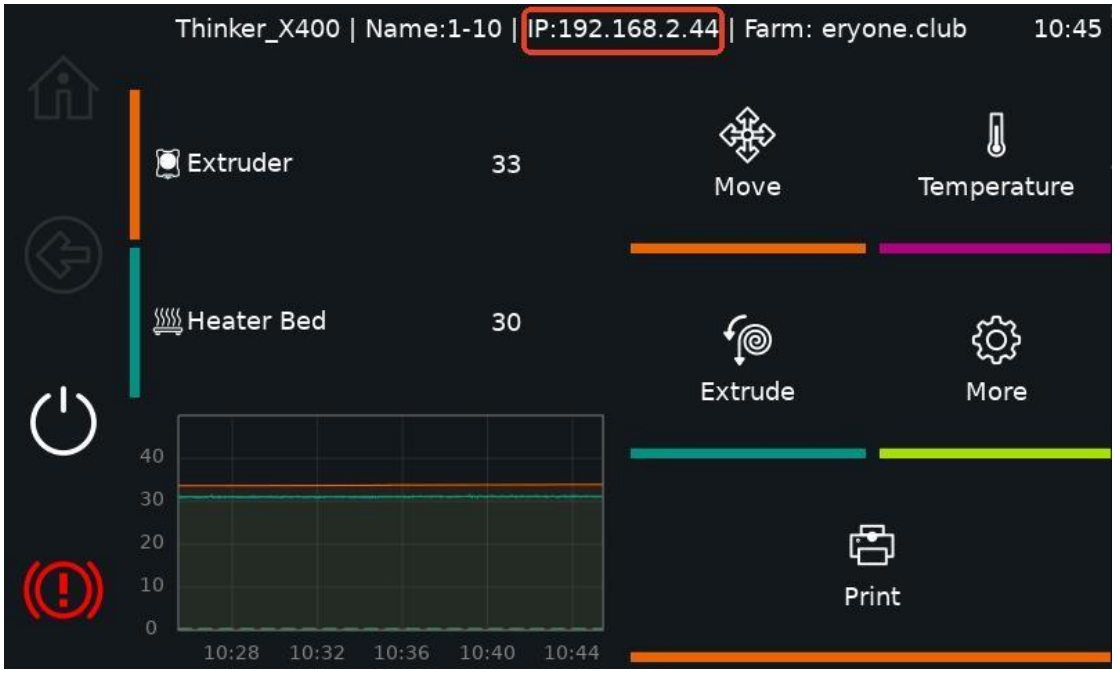
The fan in the activated carbon filter box will be turned off when the heat bed temperature falls below 45°.

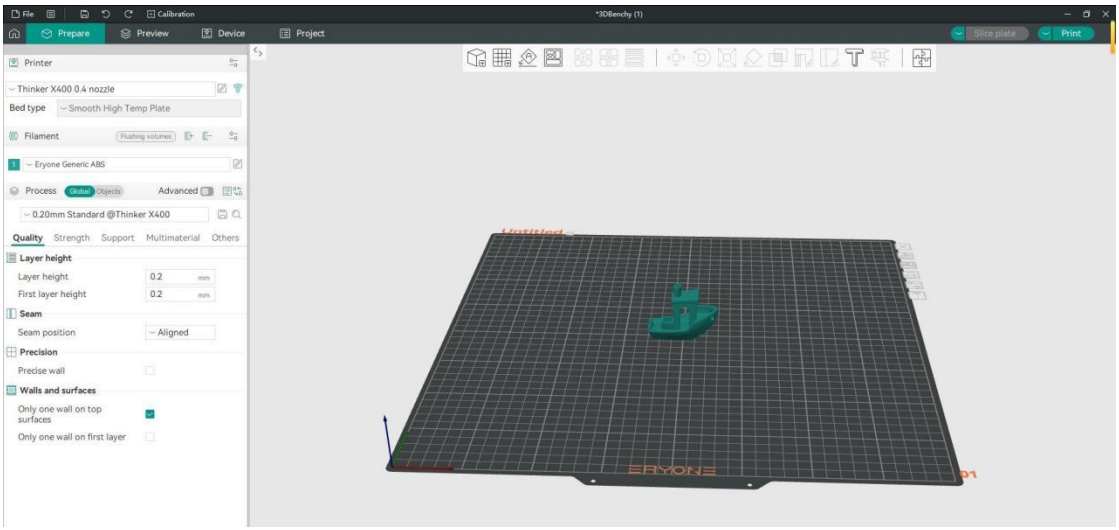
7.4 Network Printing

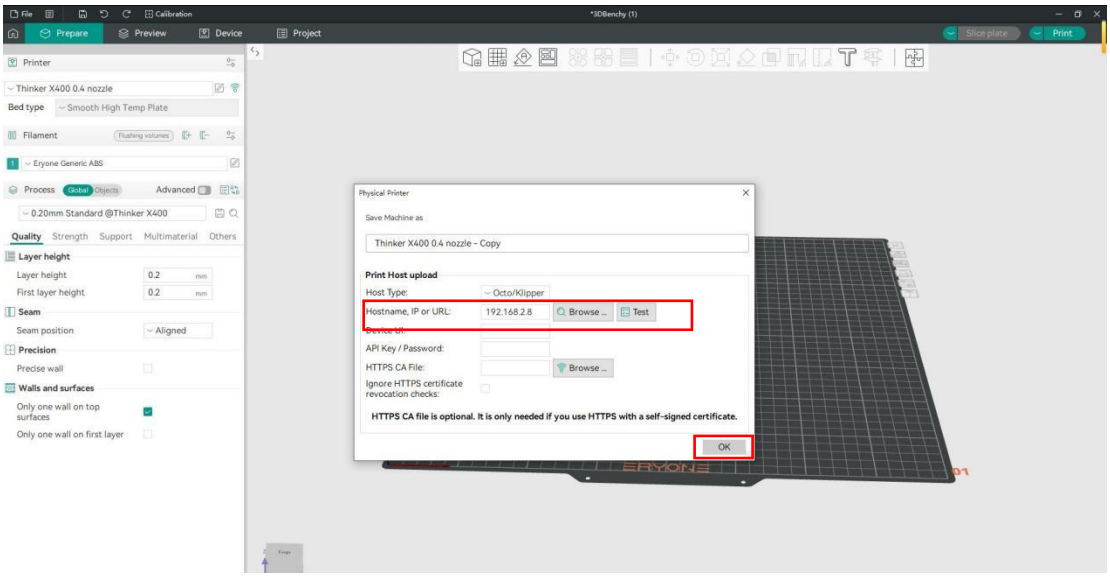
InaLANenvironment,theslicingsoftwareOrca-Slicercansend sliced files directly to the printer via IP address.

The procedure is as follows:

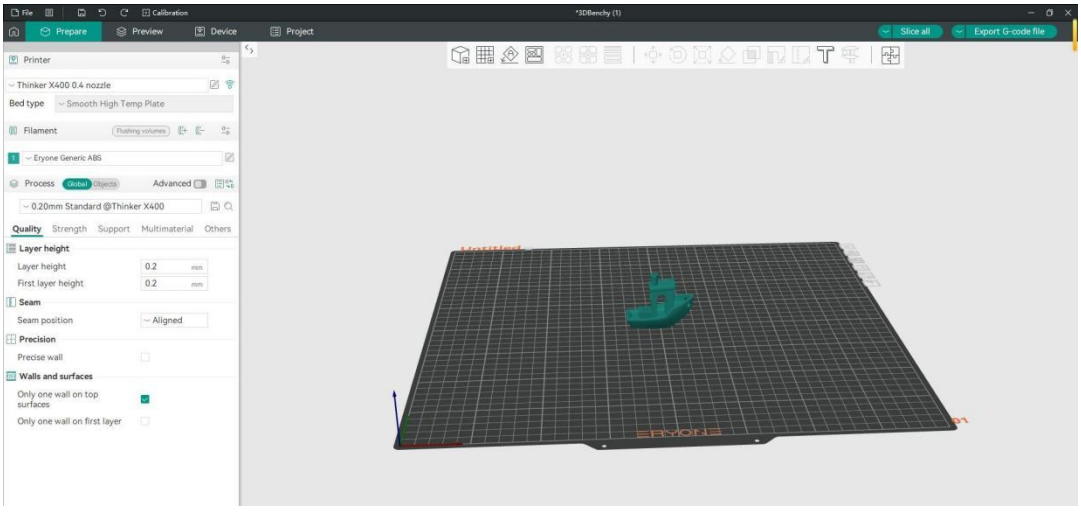
1.Importthe3Dmodel,setthe parametersandclickthe Wi-Fi button, and enter the IP address of the printer in the IP address field.



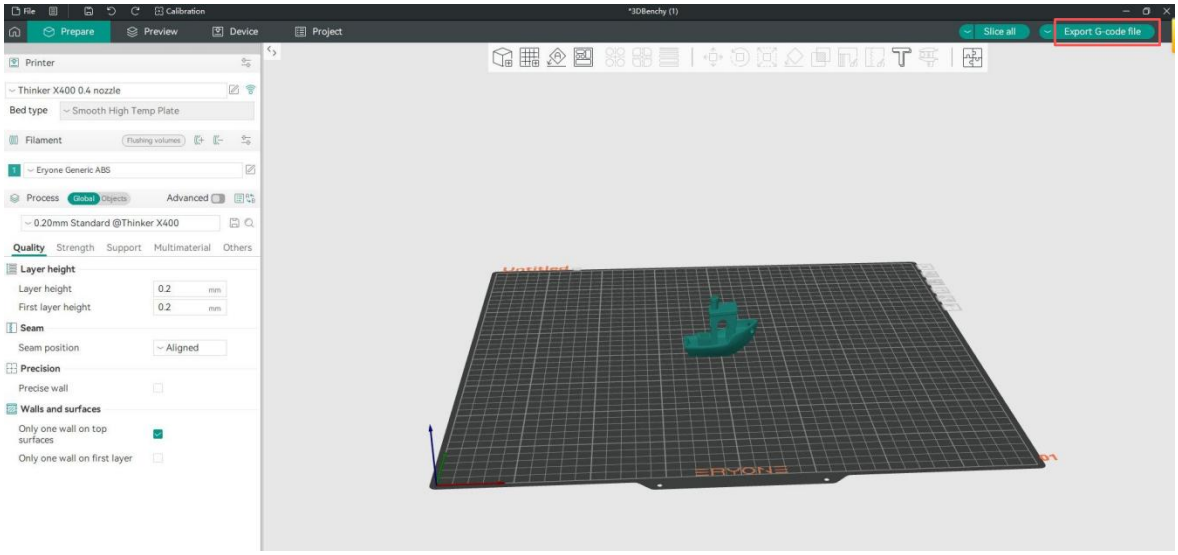


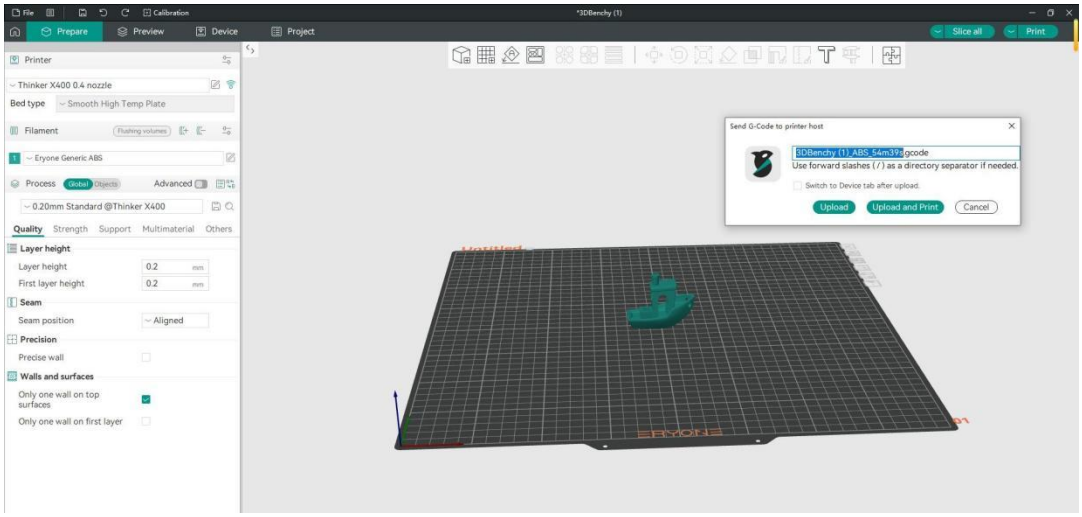


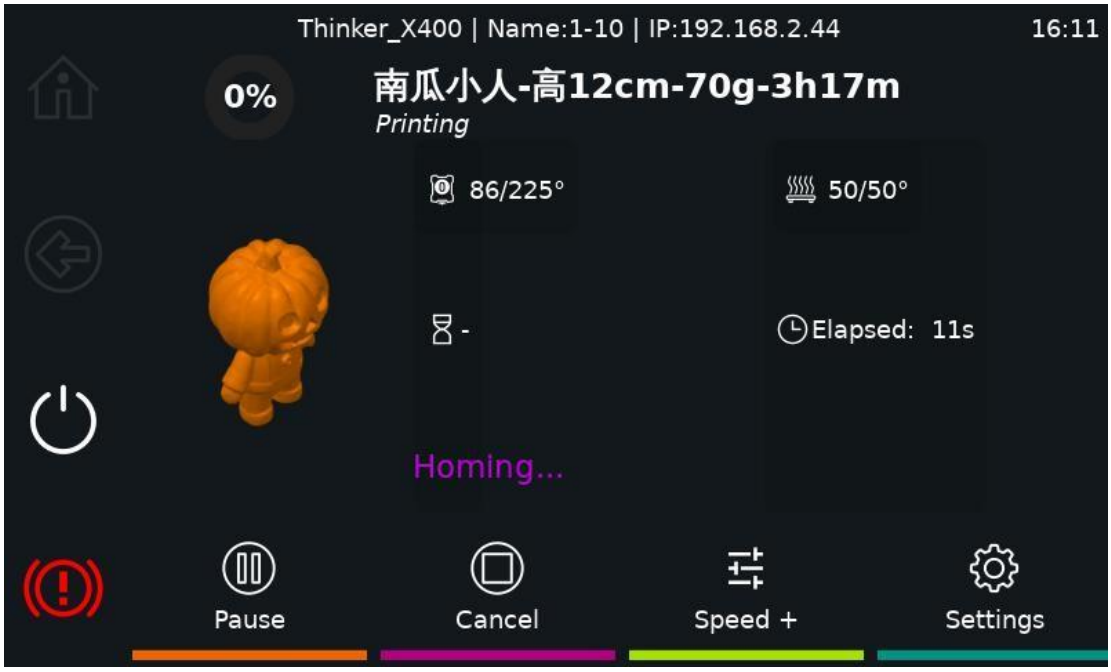
2.Click the Slice button



3.Click on the Print button after slicing the model and select “Upload and Print” in the pop-up window. The file will be sent to the printer, and printing will begin.







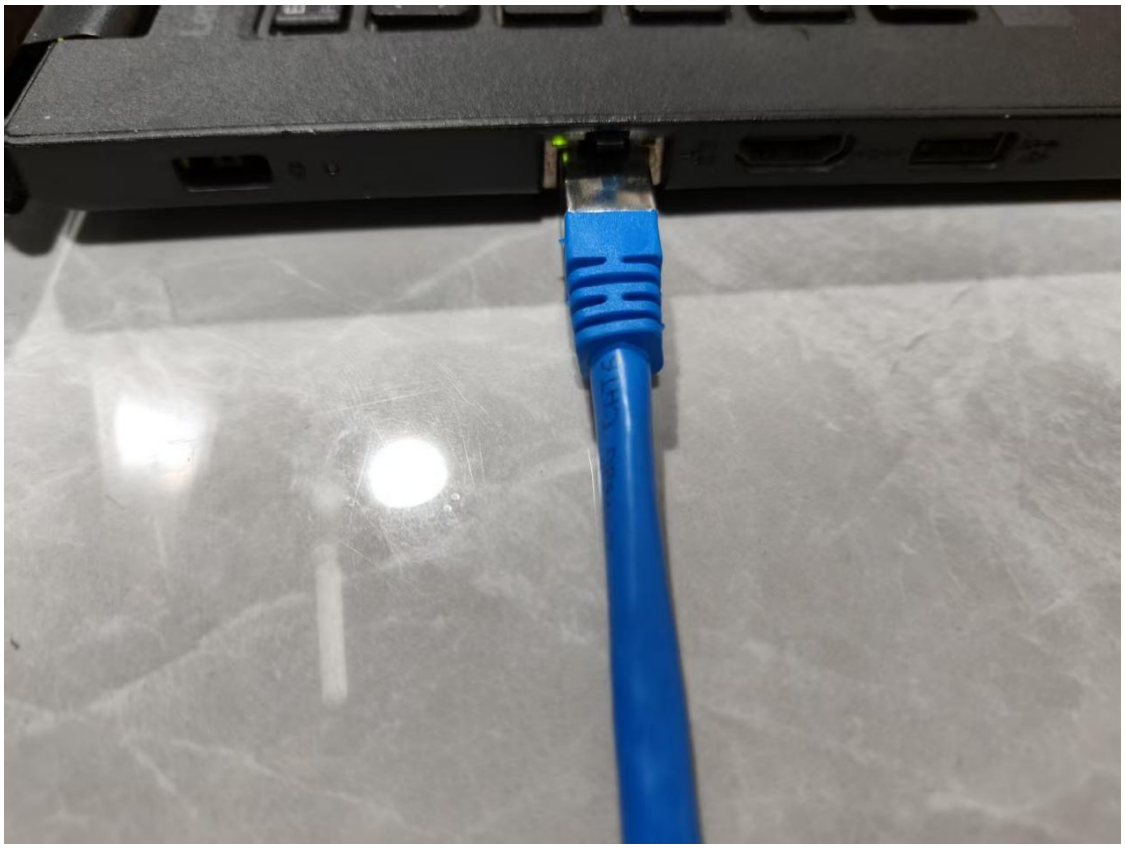
7.5 Using a computer to print directly

If the printer is not in a LAN environment, you can also choose to use the direct plug a cable into the computer and the printer, and then send the model to the printer through the IP address.

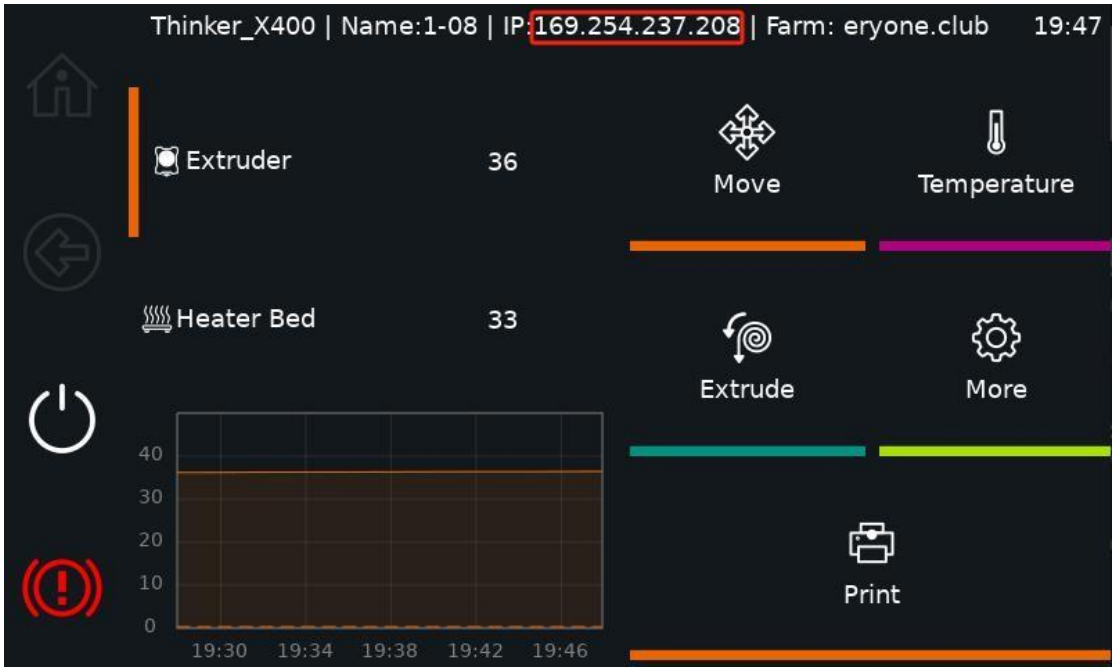
The procedure is as follows.

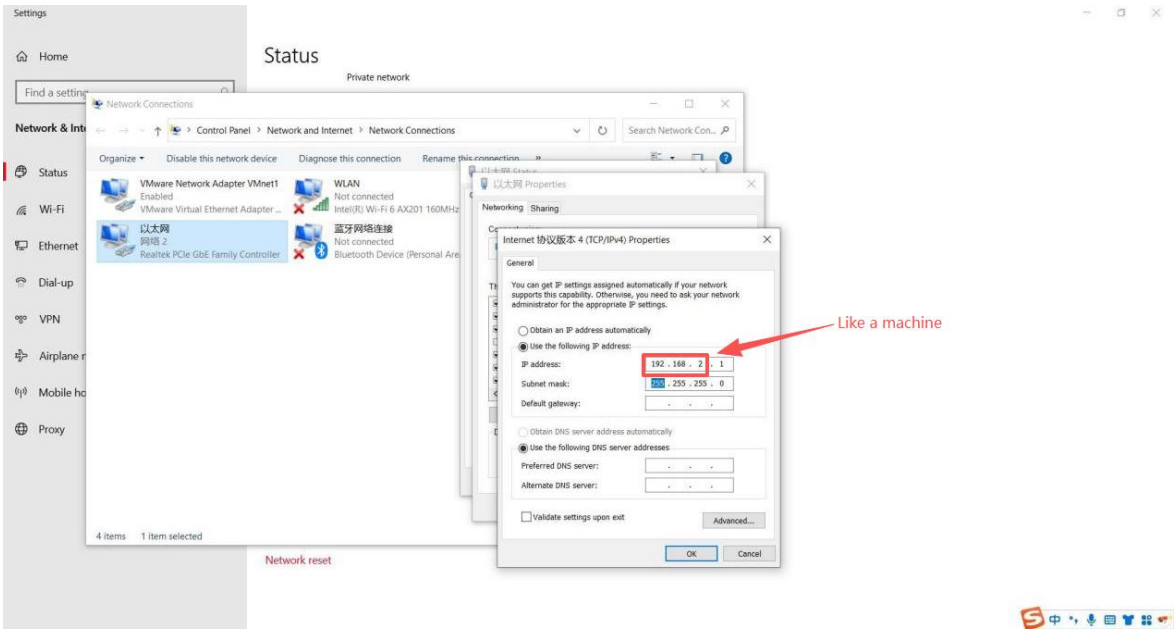
1.Turn on the printer

2.Prepare a cable and plug both ends into the computer and the printer.

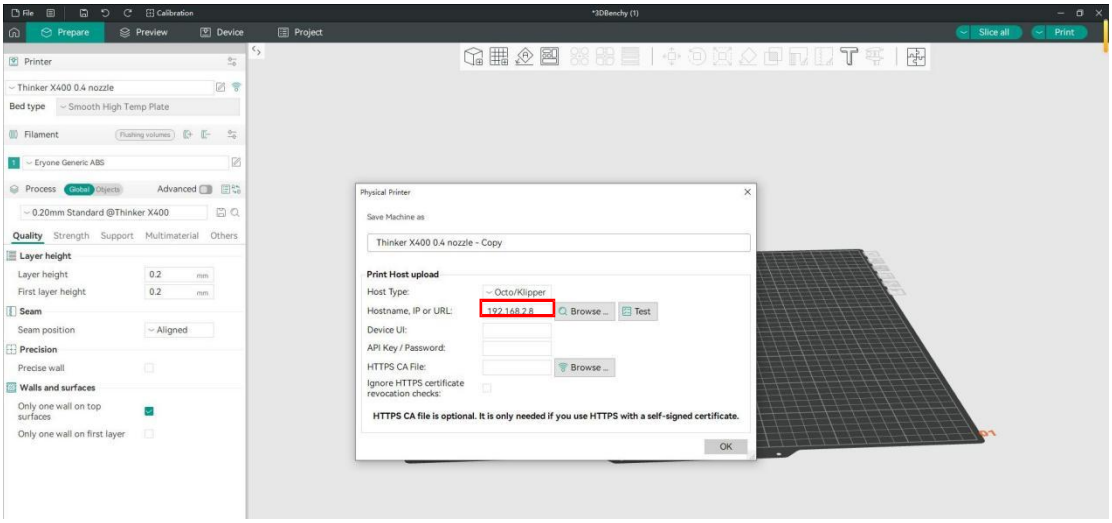


3.The printer will be assigned an IP address, and you need to change the IP address of your computer to be in the same network segment as the IP of the printer.

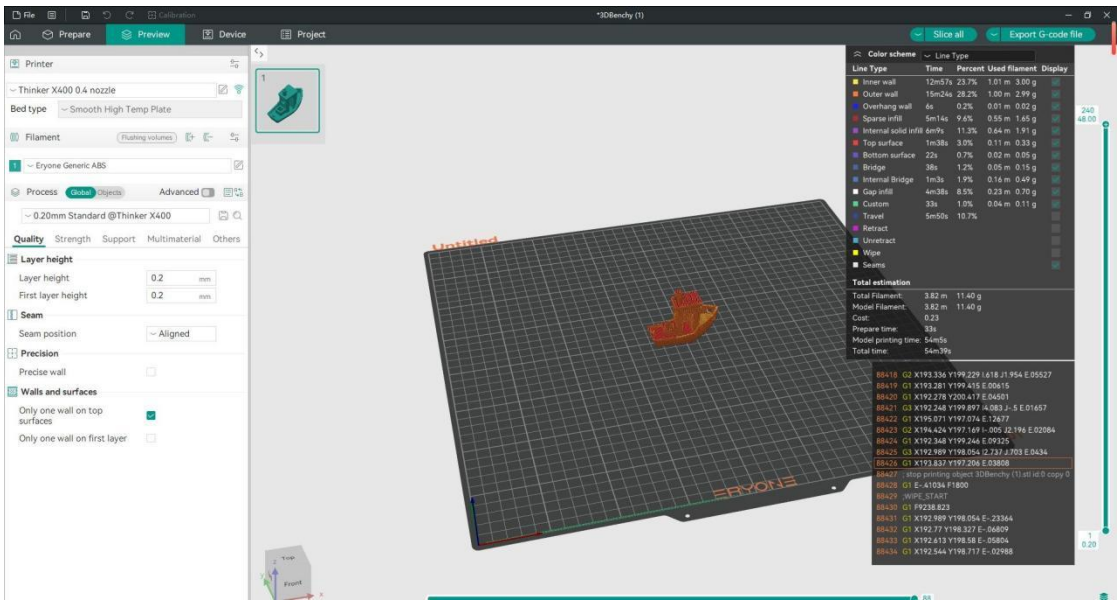




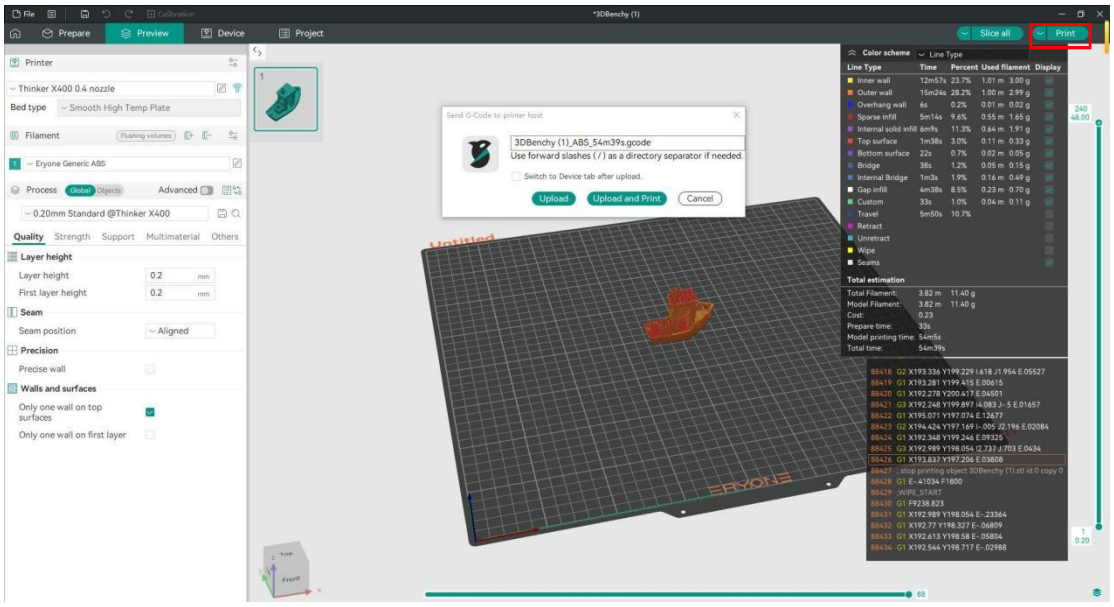
4.Open Orca-Slicer, import the model file and enter the IP address of the machine.



5.Parameterize and slice



Just click to upload and print the model.



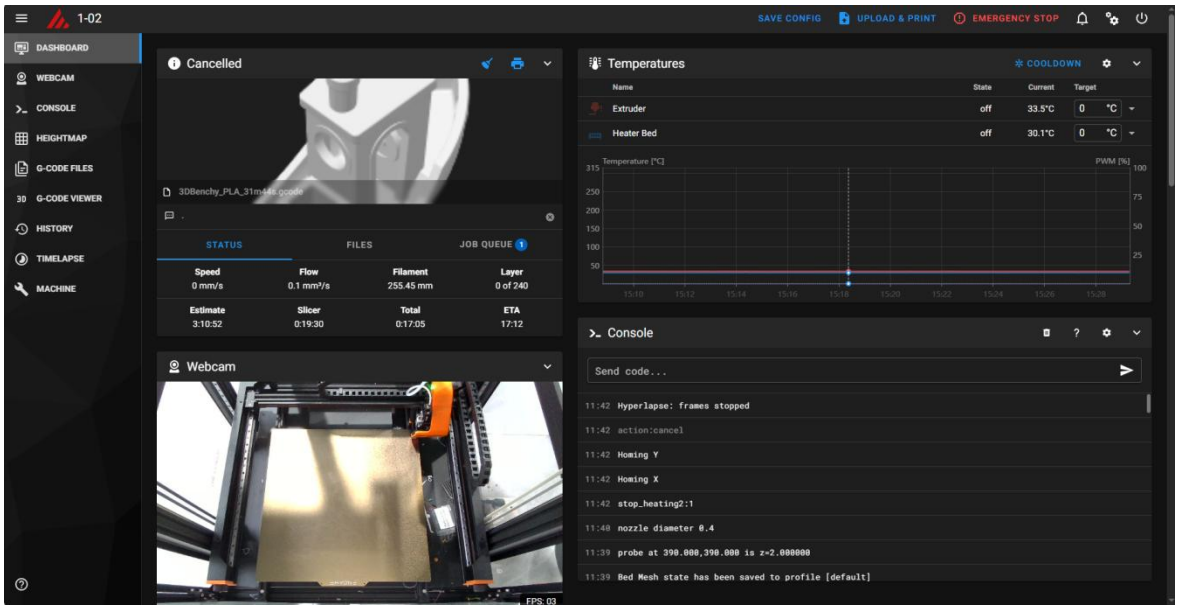
Note:

The small fan next to the heat sink will be switched off when the nozzle temperature falls below 42°C.

The fan in the activated carbon filter box will be switched off when the temperature of the heat bed falls below 45°.

7.6 Remote Operation

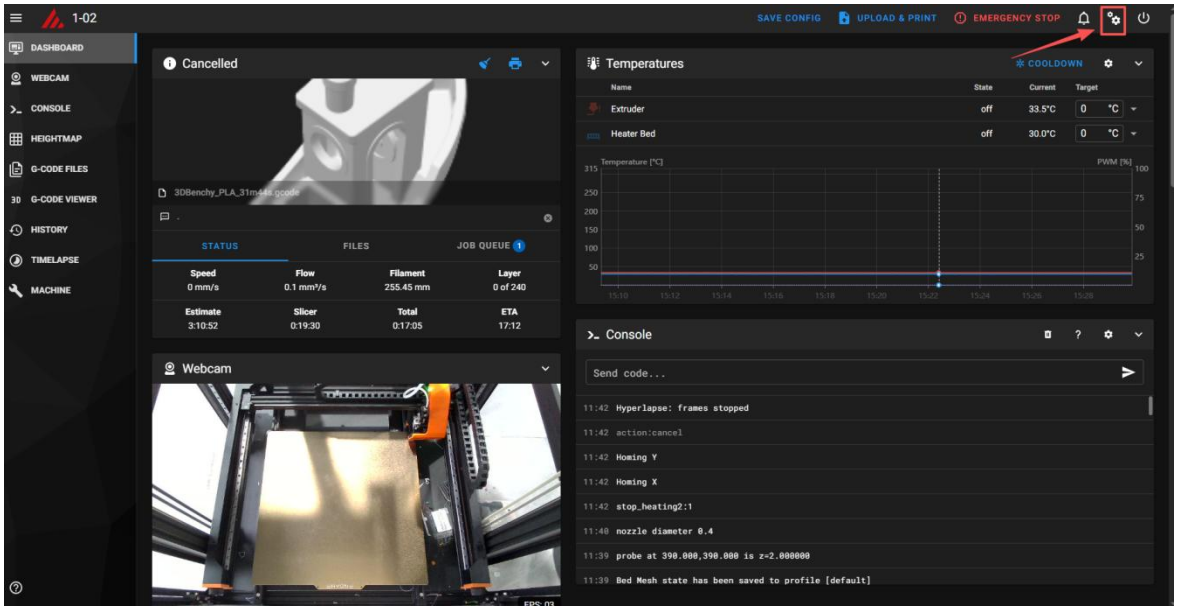
When your printer is on a LAN with your PC/mobile, you can enter the IP address of the printer on your PC/mobile to remotely view the printer's status information and send commands to operate the printer.



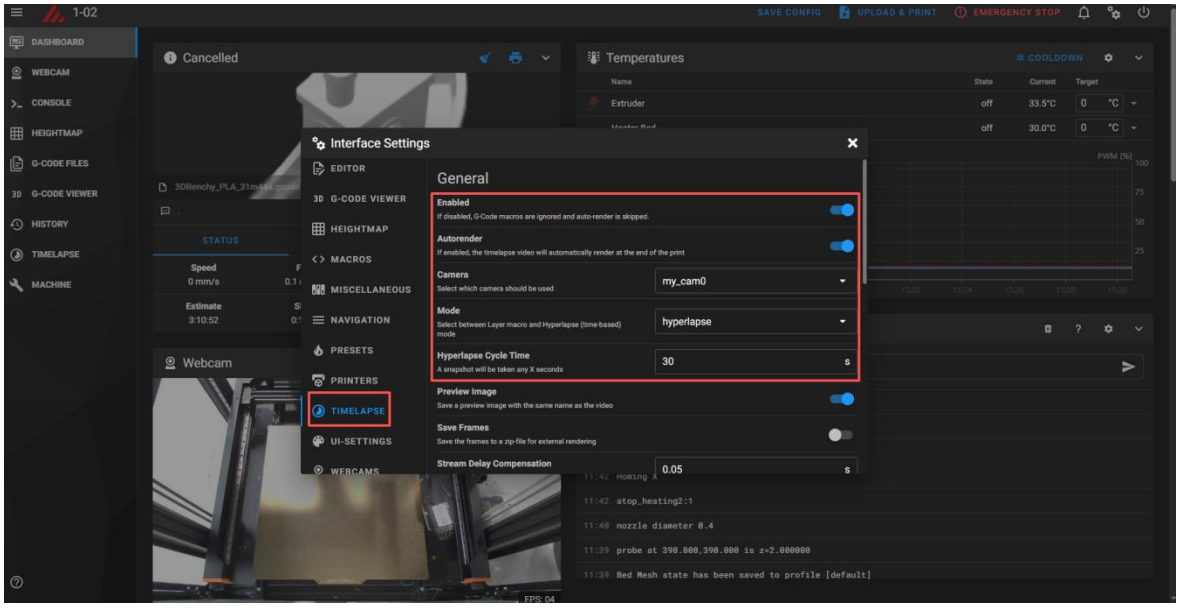
7.6.1 Time-lapse Photography

Turning on time-lapse photography Procedure：

1. Click on Settings



2. Just click on Time-lapse and enable it.



Suggestion: one 40-second snap for documents up to 24 hours old, one 80-second snap for documents up to 48 hours old, and so on.

8.Troubleshooting

8.1 Clogging Issues

How to check the clogged part of the printer:

Clogging is a common problem in 3d printing, when your printer can no longer extrude the filaments, you need to confirm which part of the problem

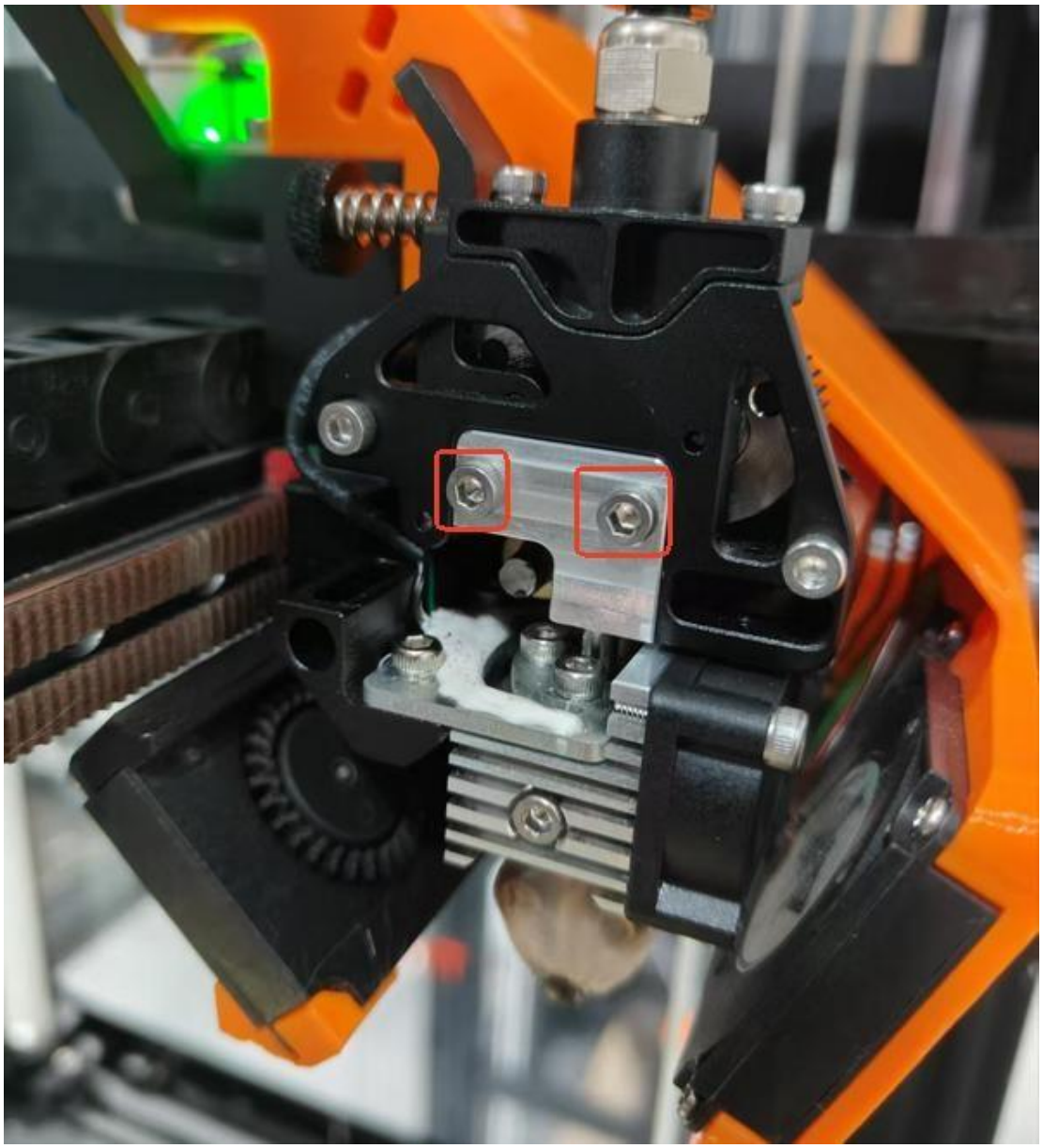
Clogging situation:

When you insert the filaments into the extruder and execute the feed command, the gears on the extruder make a strange noise and the nozzle is not extruded, then there is indeed a clogging phenomenon!

8.1.1 Clogged extruder feed piece

Remove the 2 screws next to the extruder and take out the feed

piece.

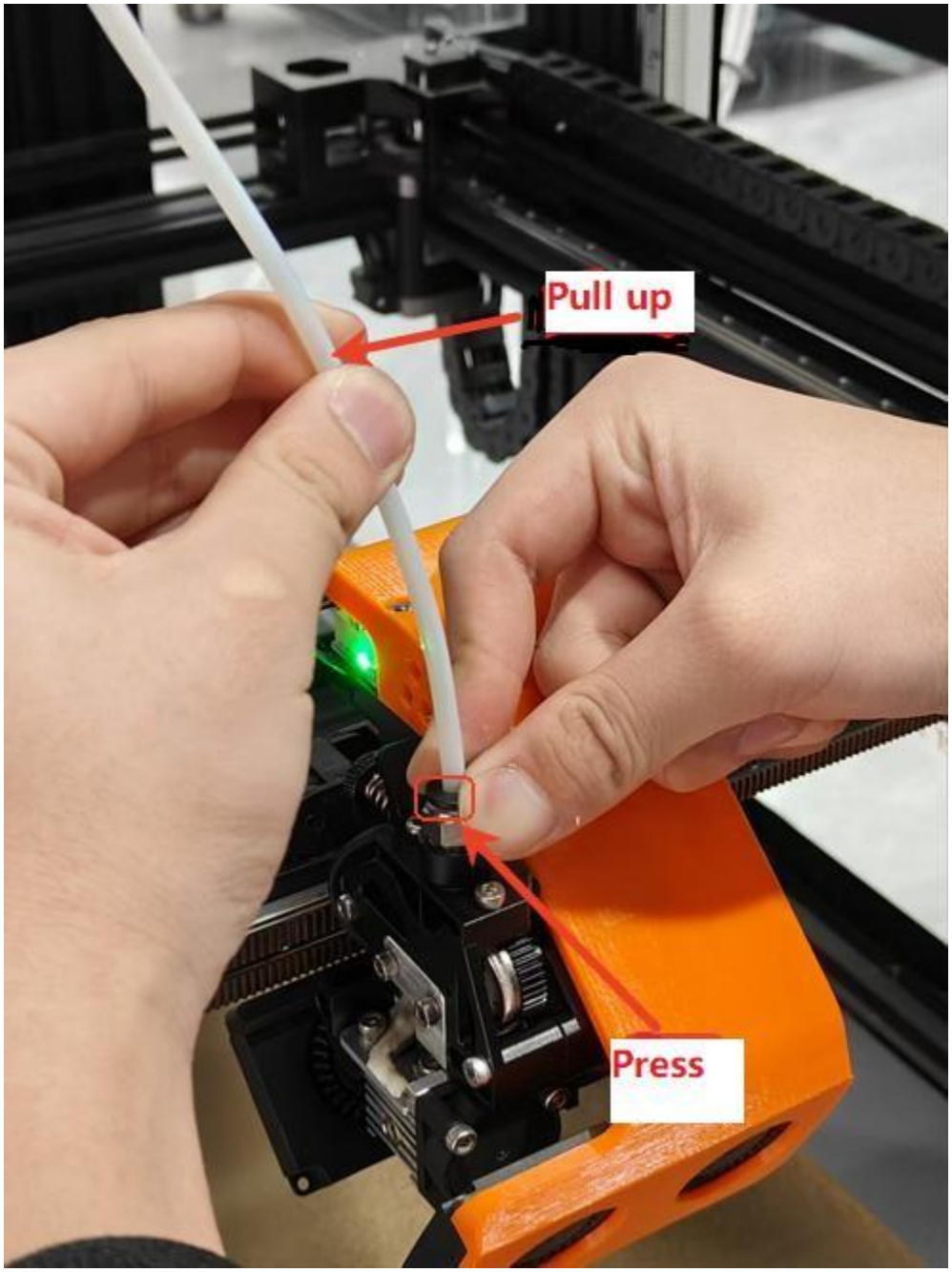


You can visualize the filament chips in the feeding port, use tools (e.g.

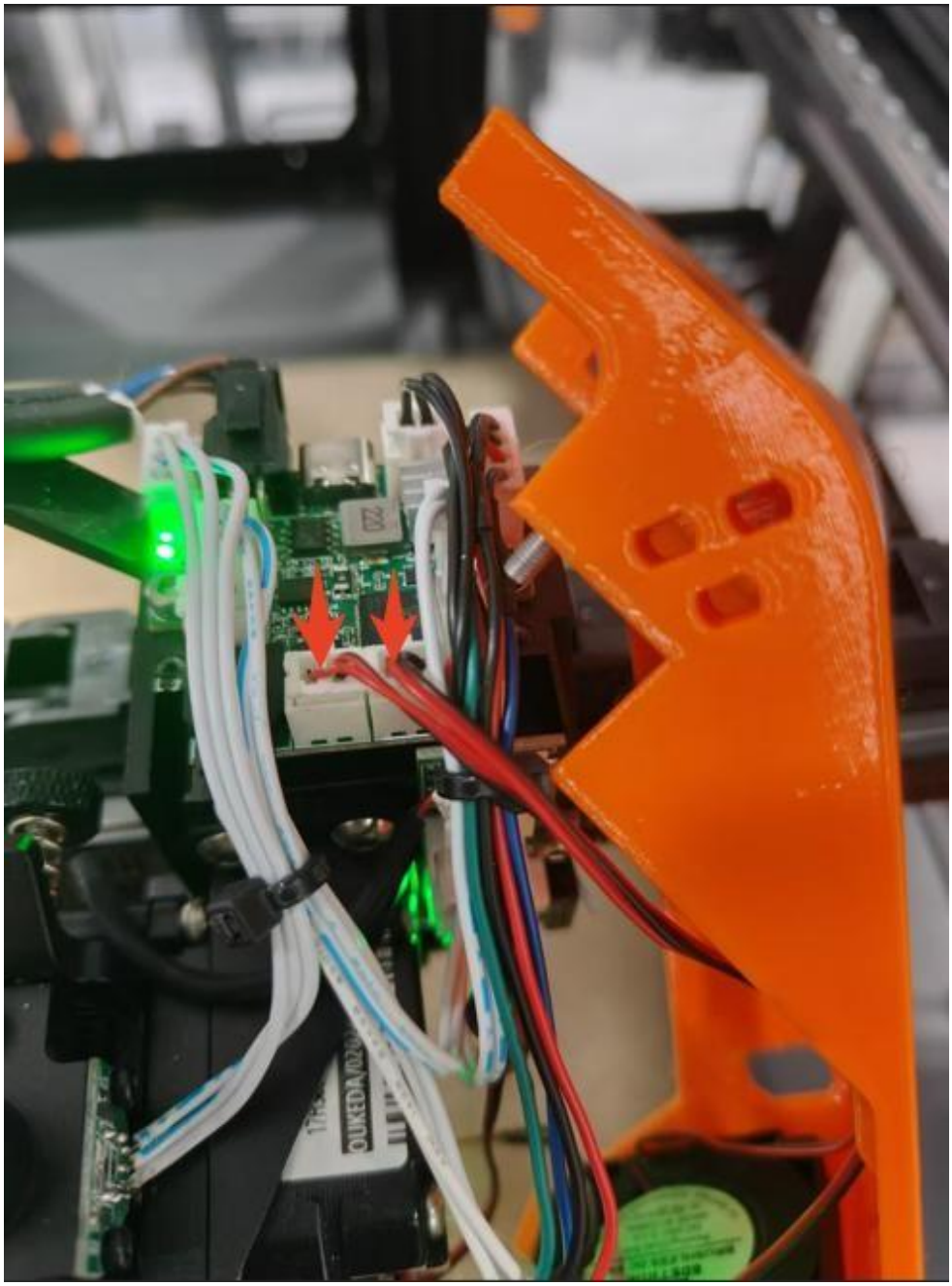
1.5mm hexagonal wrench) to poke them out.

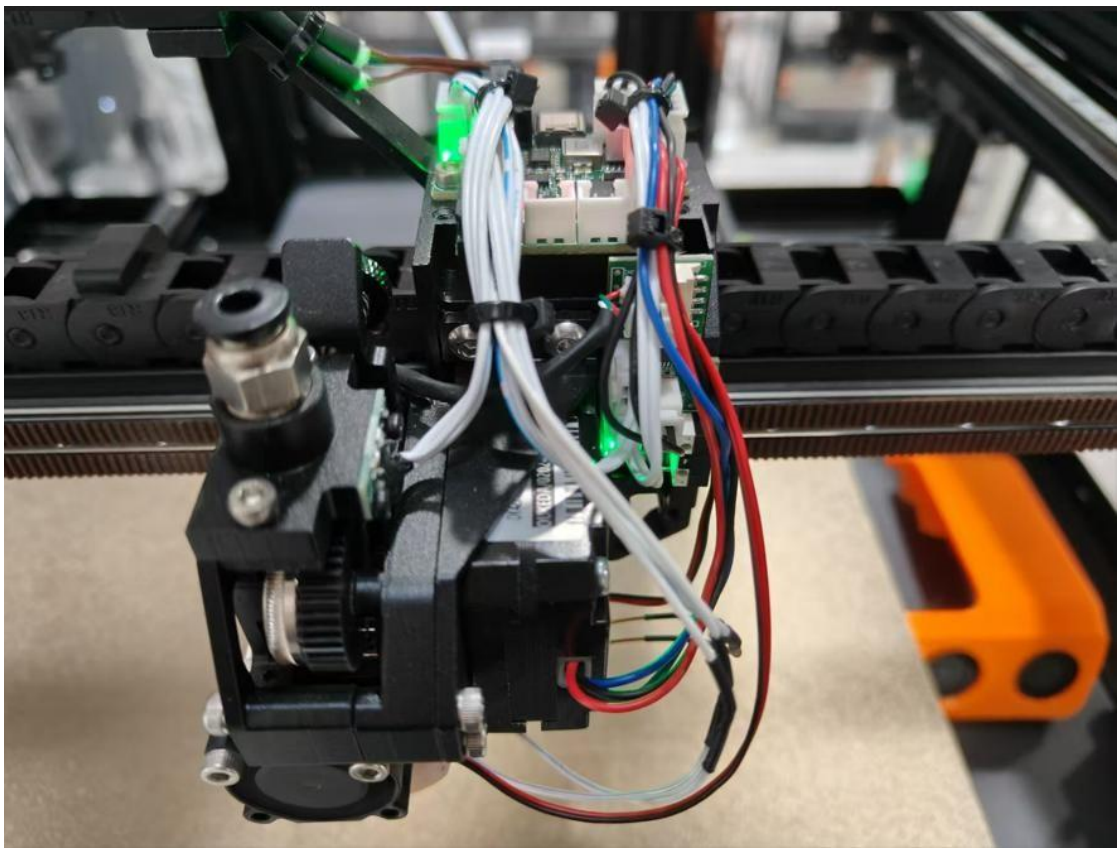
8.1.2 A blockage in the larynx

1. Pull out the Teflon feed tube

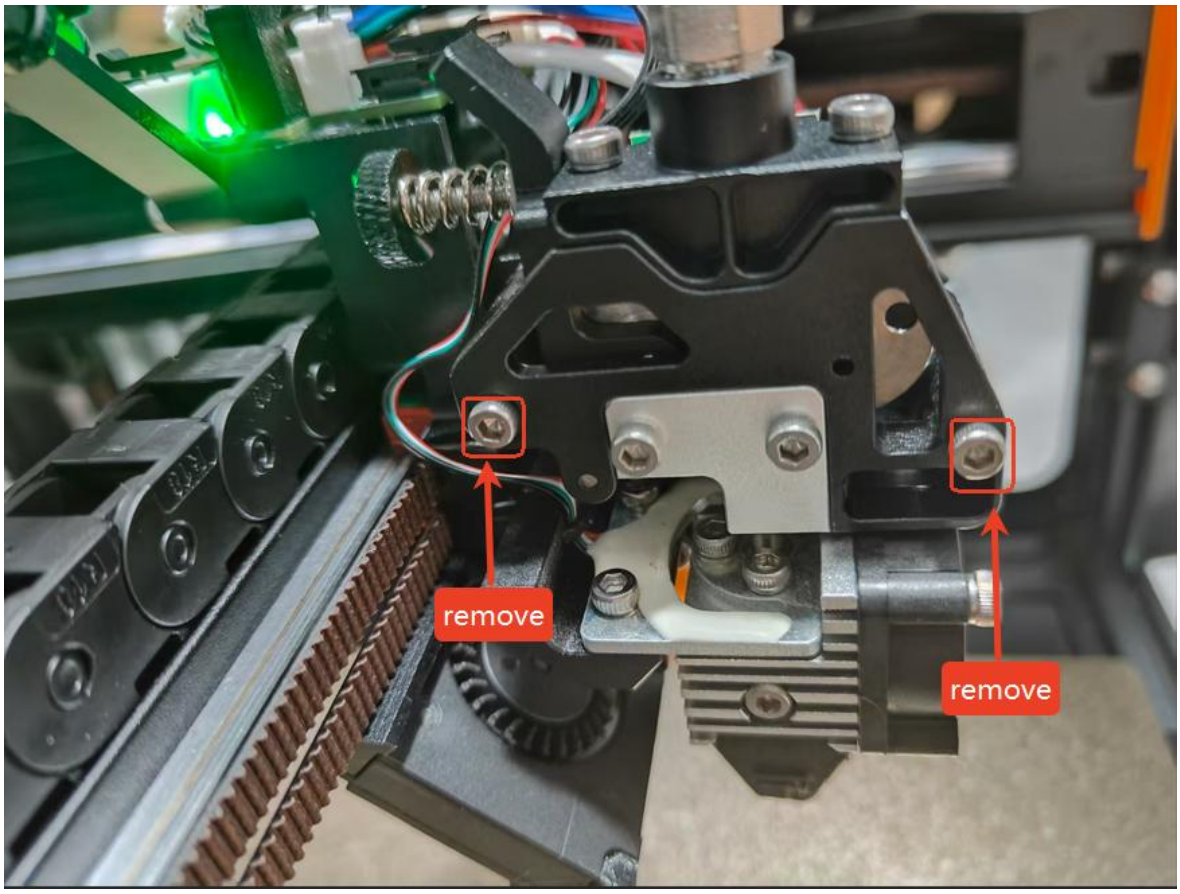


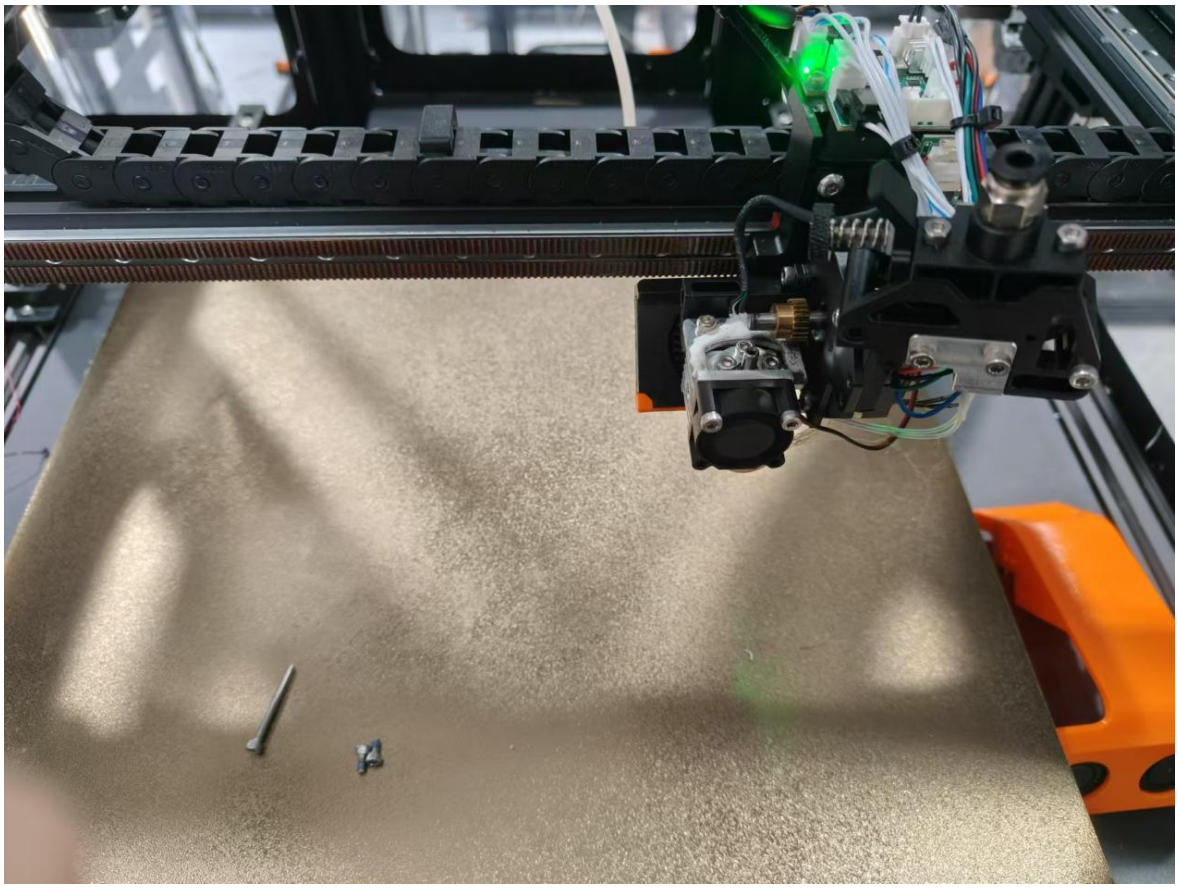
2. Loosen the 2 screws of the extruder bracket cover and slowly pull out the fan cable (Note: Do not damage the cable or the port) Take away the extruder bracket cover.



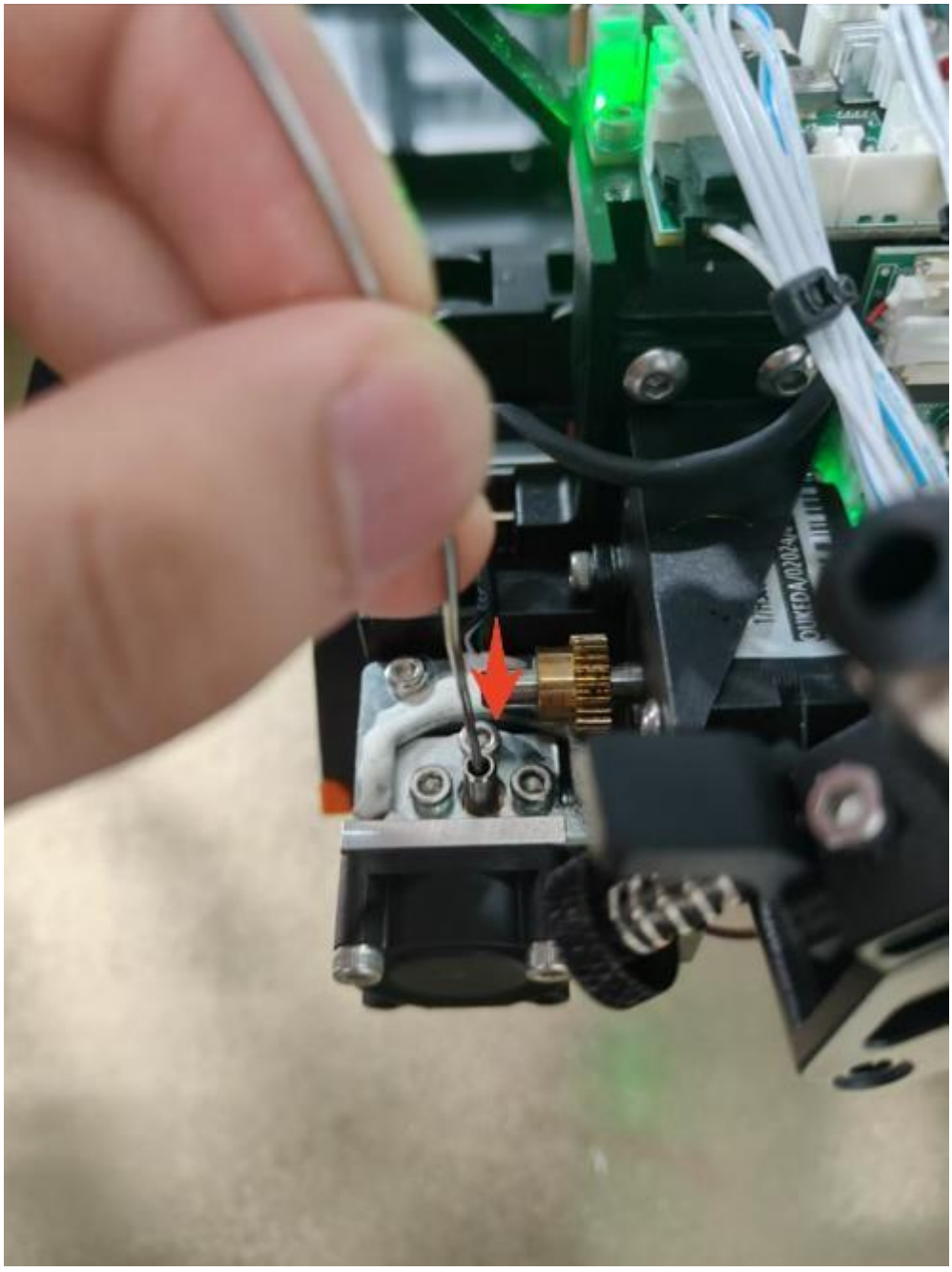


3. Remove the 3 screws holding the extruder in place and move the extruder to one side.


remove
remove

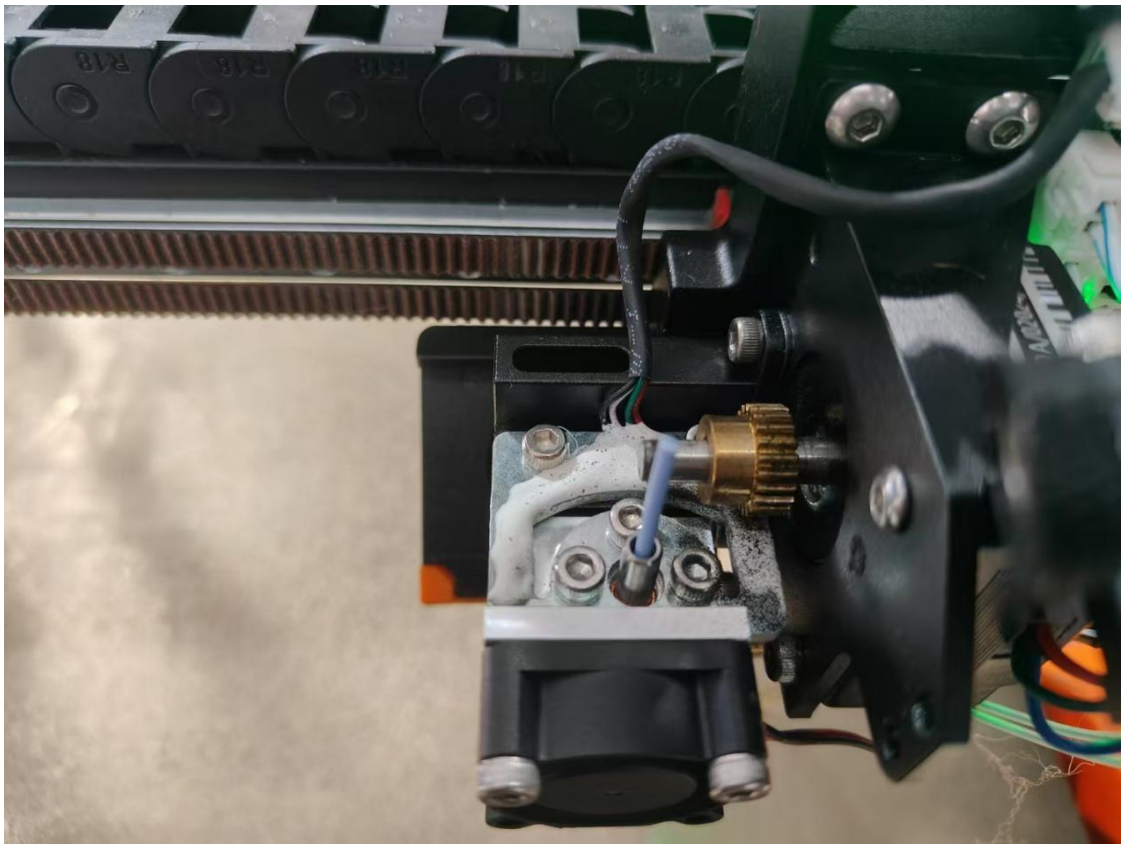


4. Observe the nozzle to see if any filaments are broken off inside the nozzle. When it is not clear if there is filament inside the nozzle, insert a long-through needle into the top of the extruder, press down, and feel if there is too much resistance (filament chips may be adhering to the inner wall)

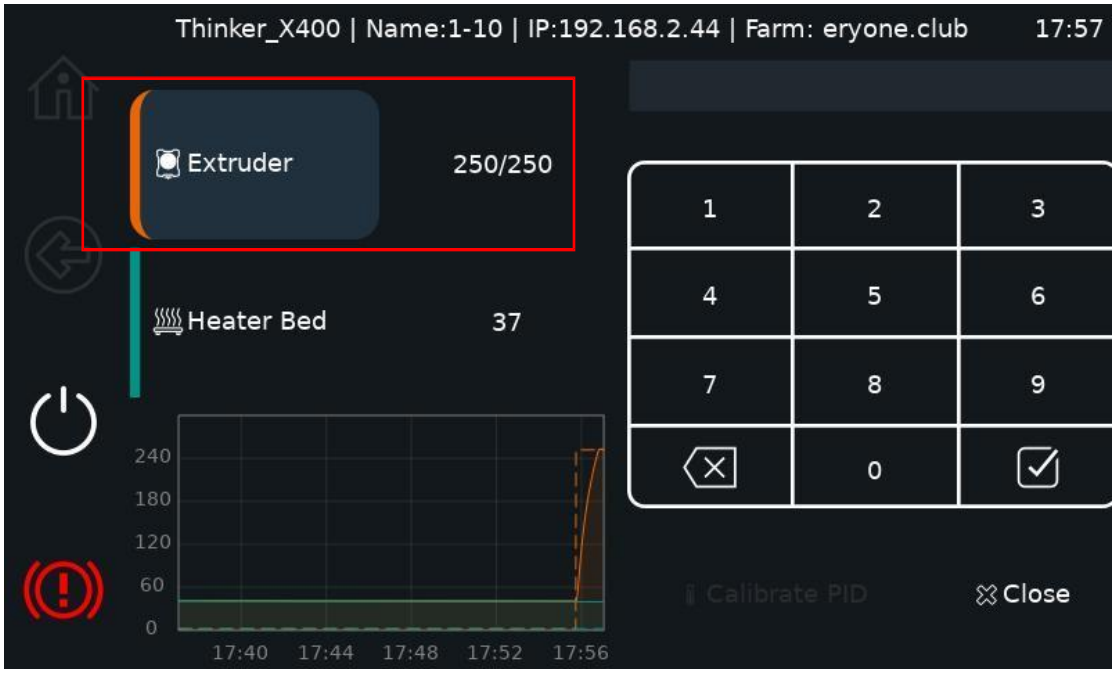


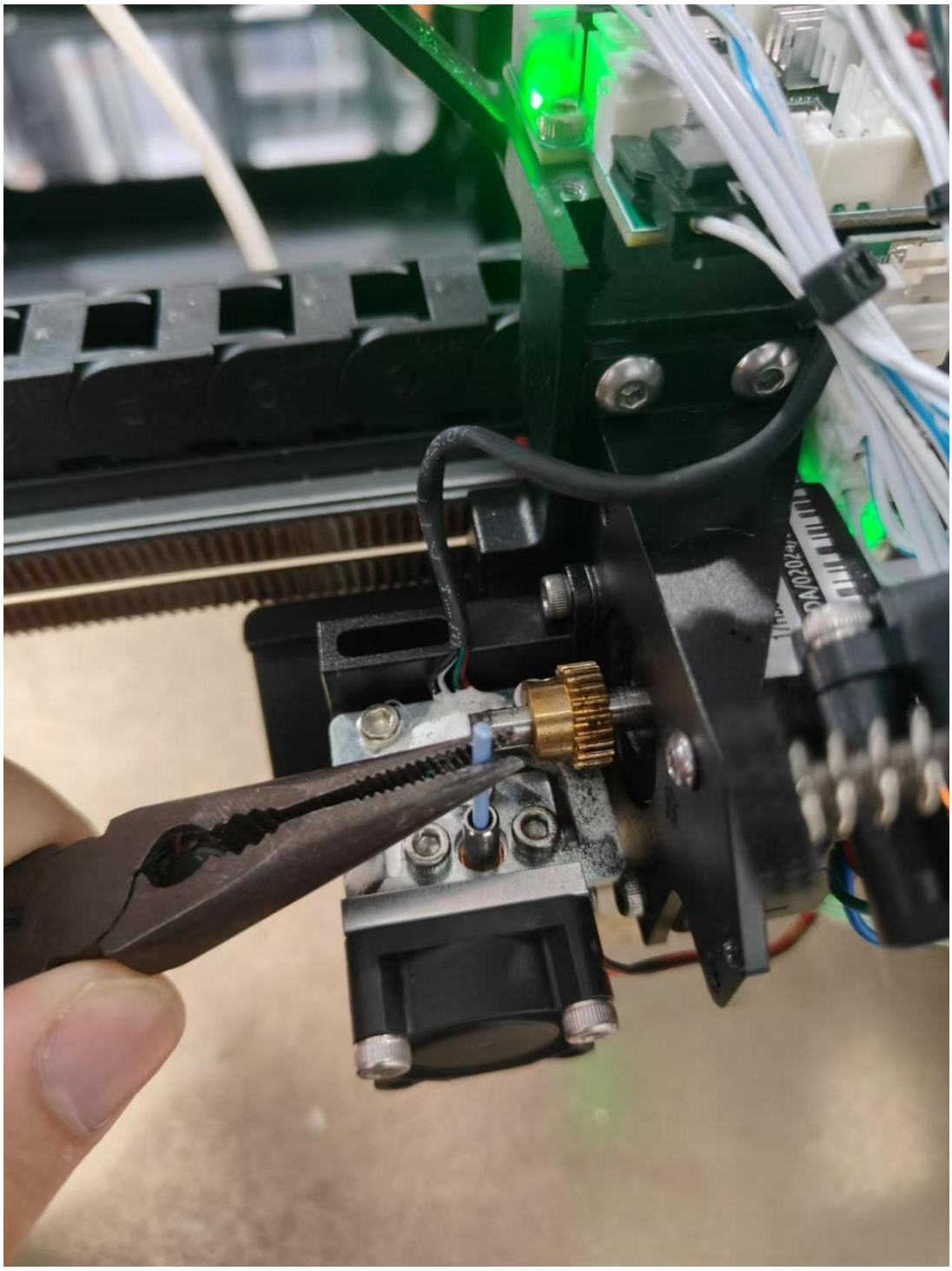
Circumstances of the blockage of filaments：

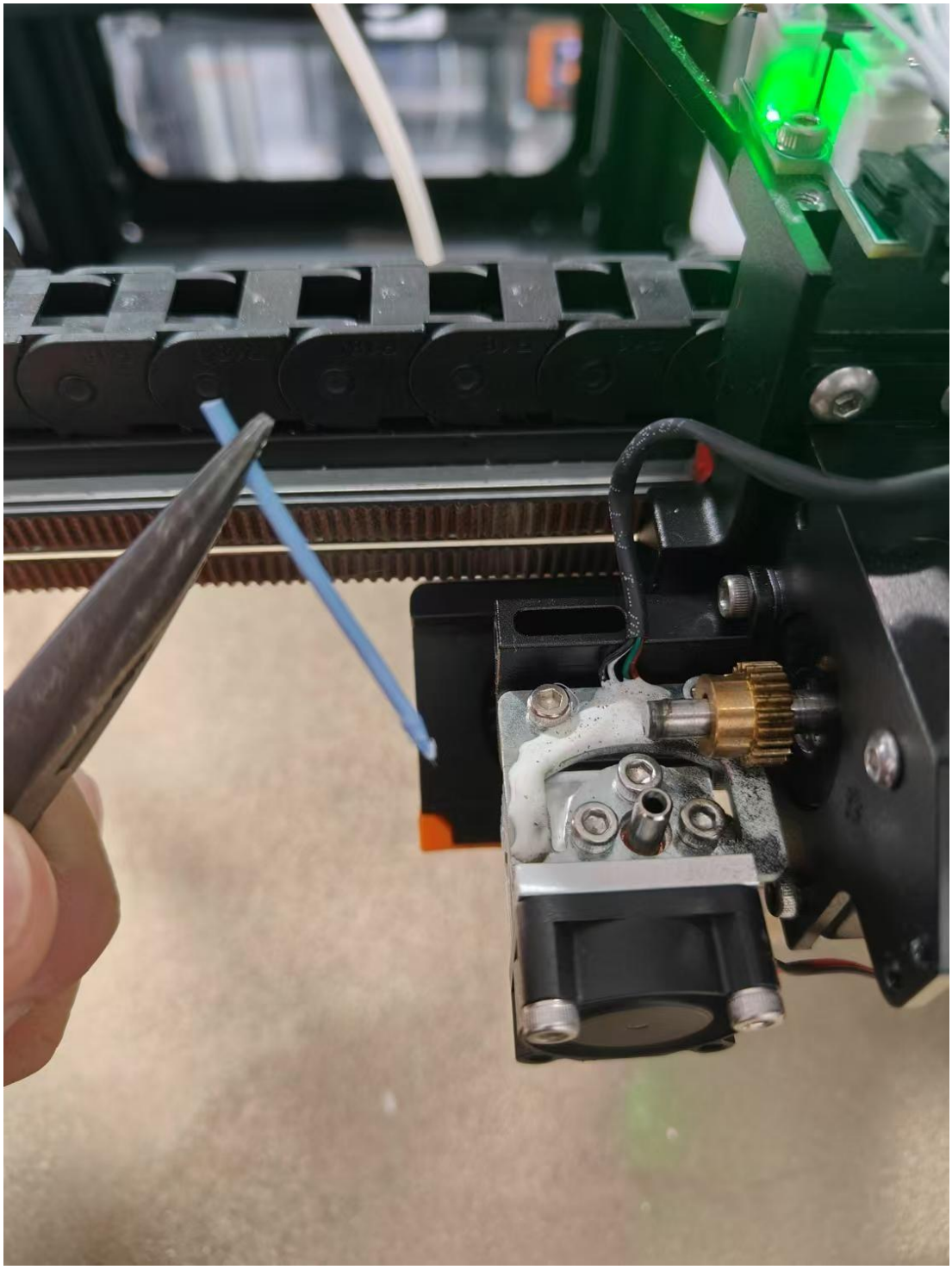
Situation 1：



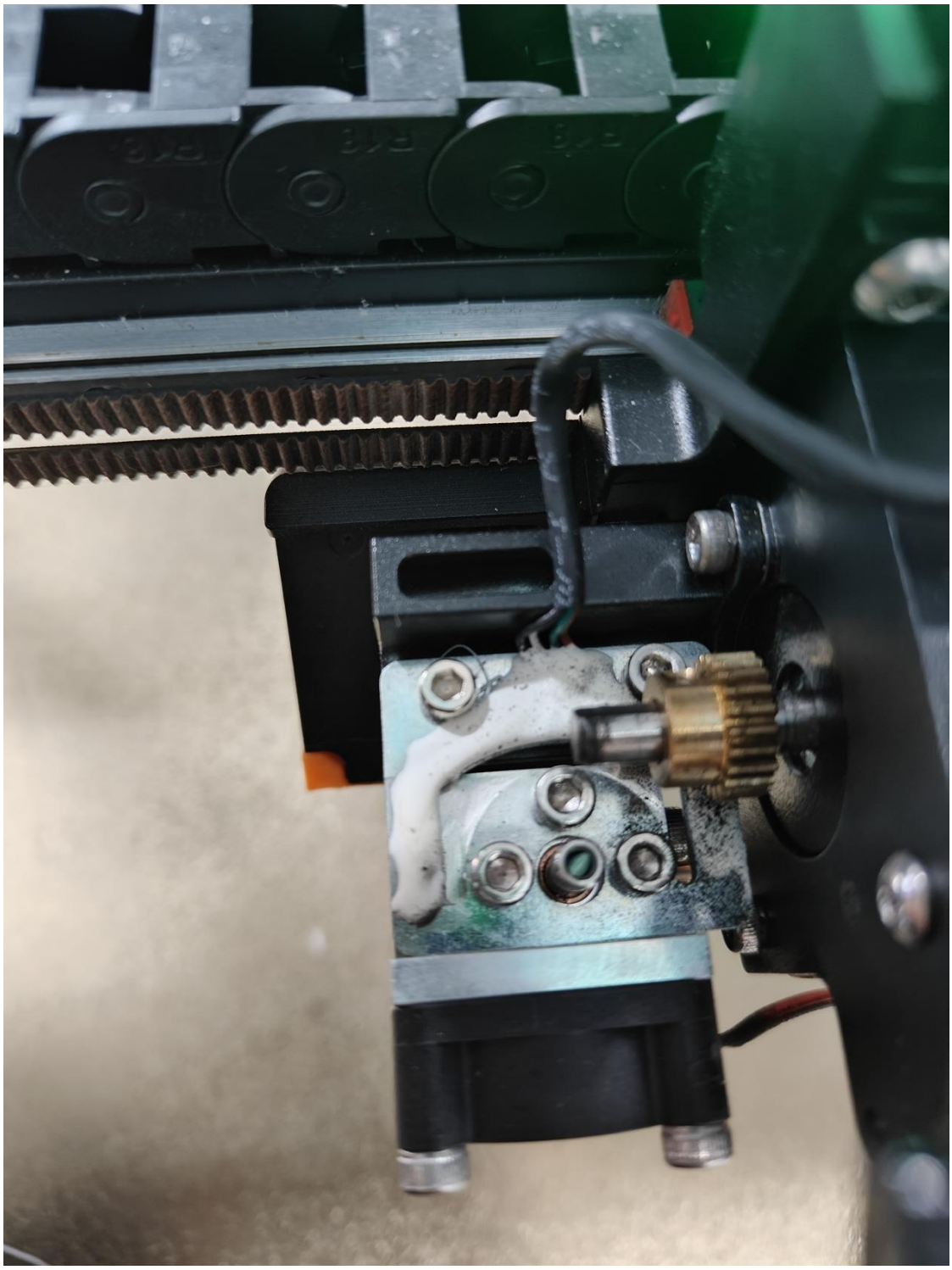
Treatment: Heat the hot end to 250°C, use sharp-nosed pliers to pull out the filament.





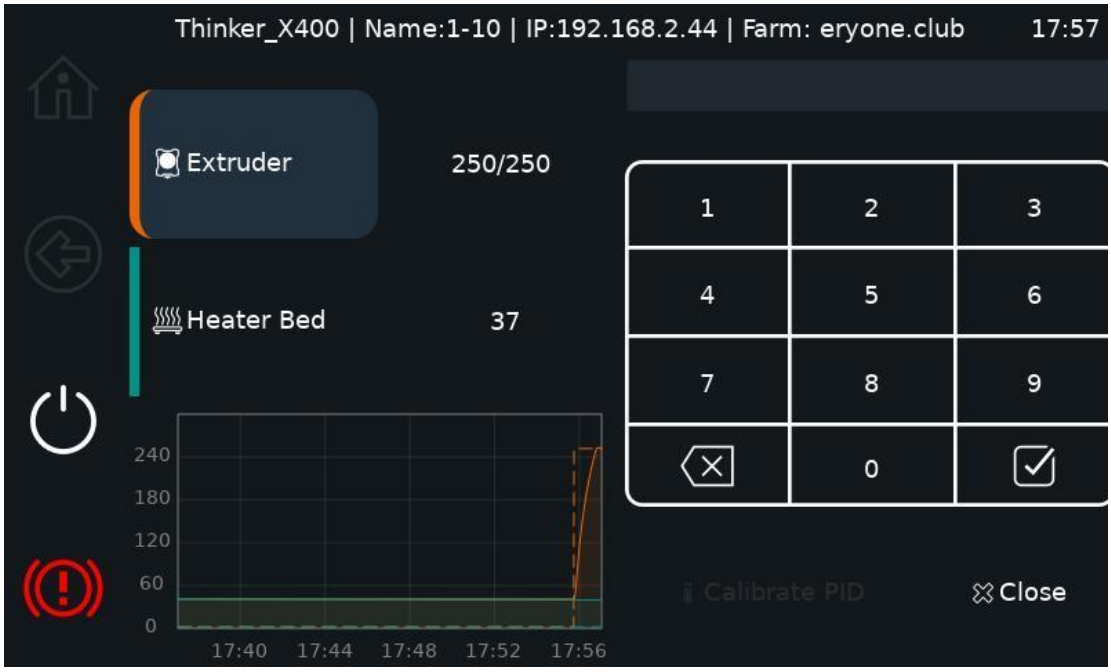


Situation 2：

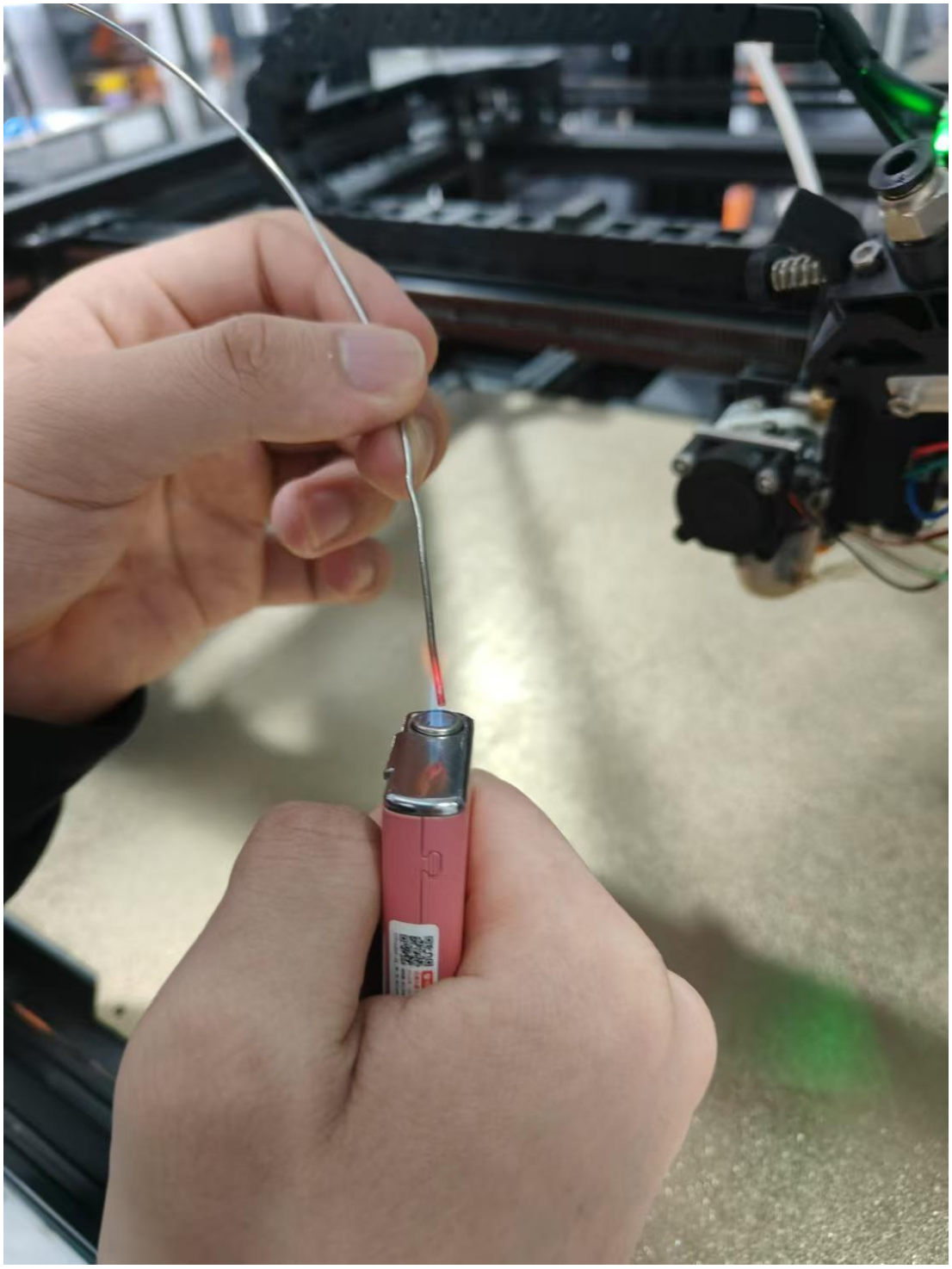


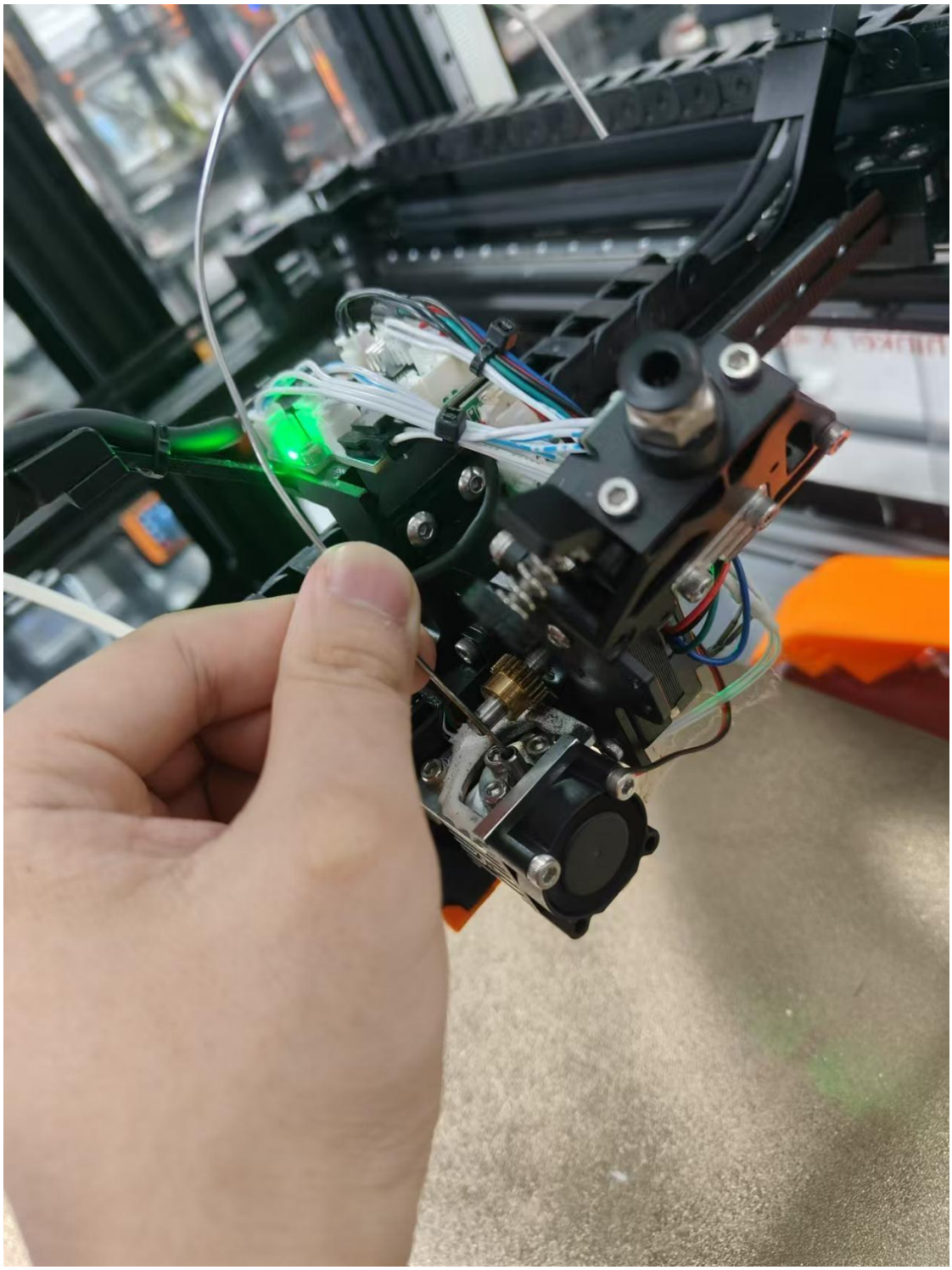
Treatment：

1. Heat the hot end to 250°C



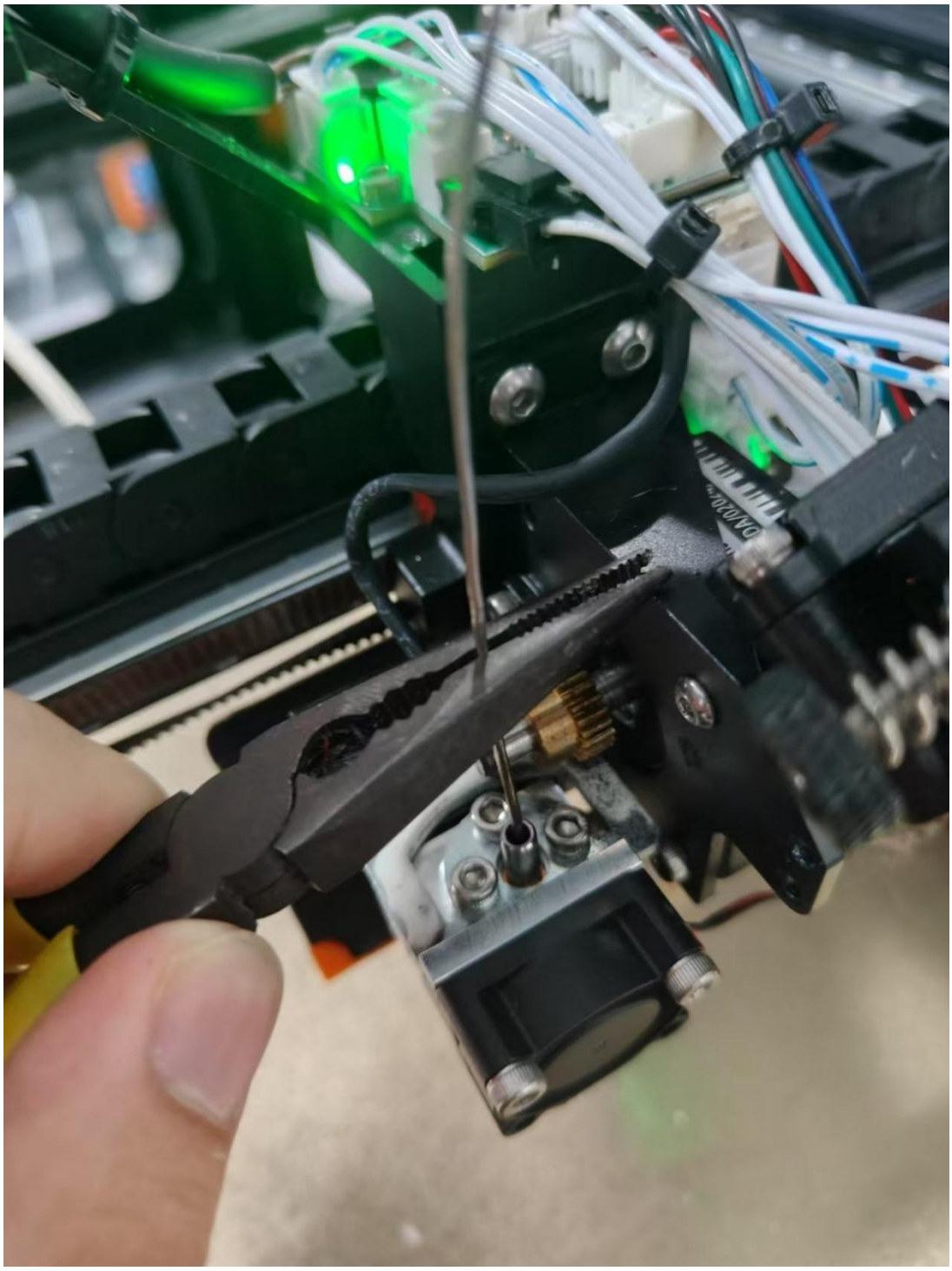
2. Use a lighter to heat the lancet until it turns red, insert the lancet from the top of the hot end, press down and tilt it 30°, and wait for about 30 seconds.

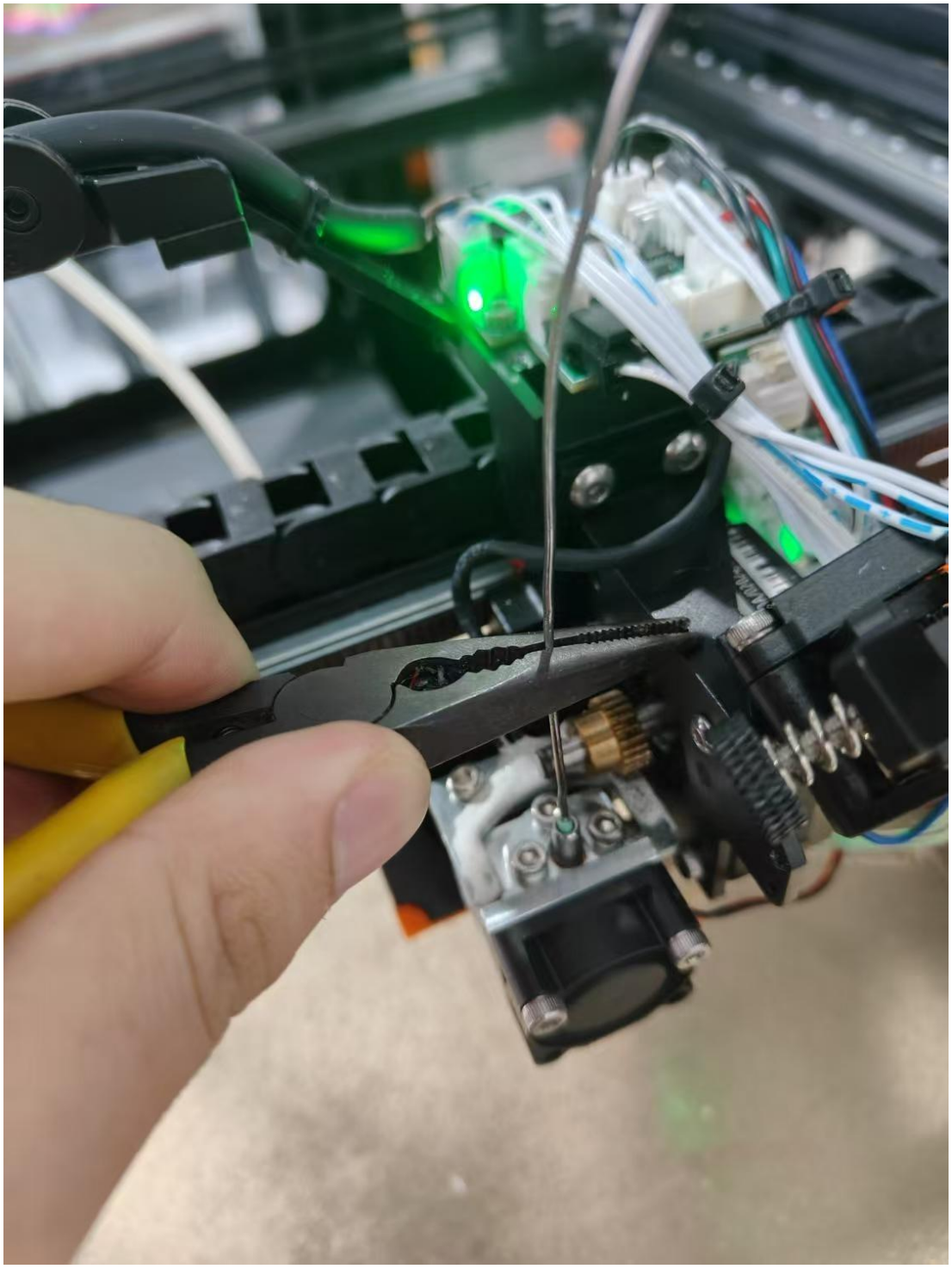




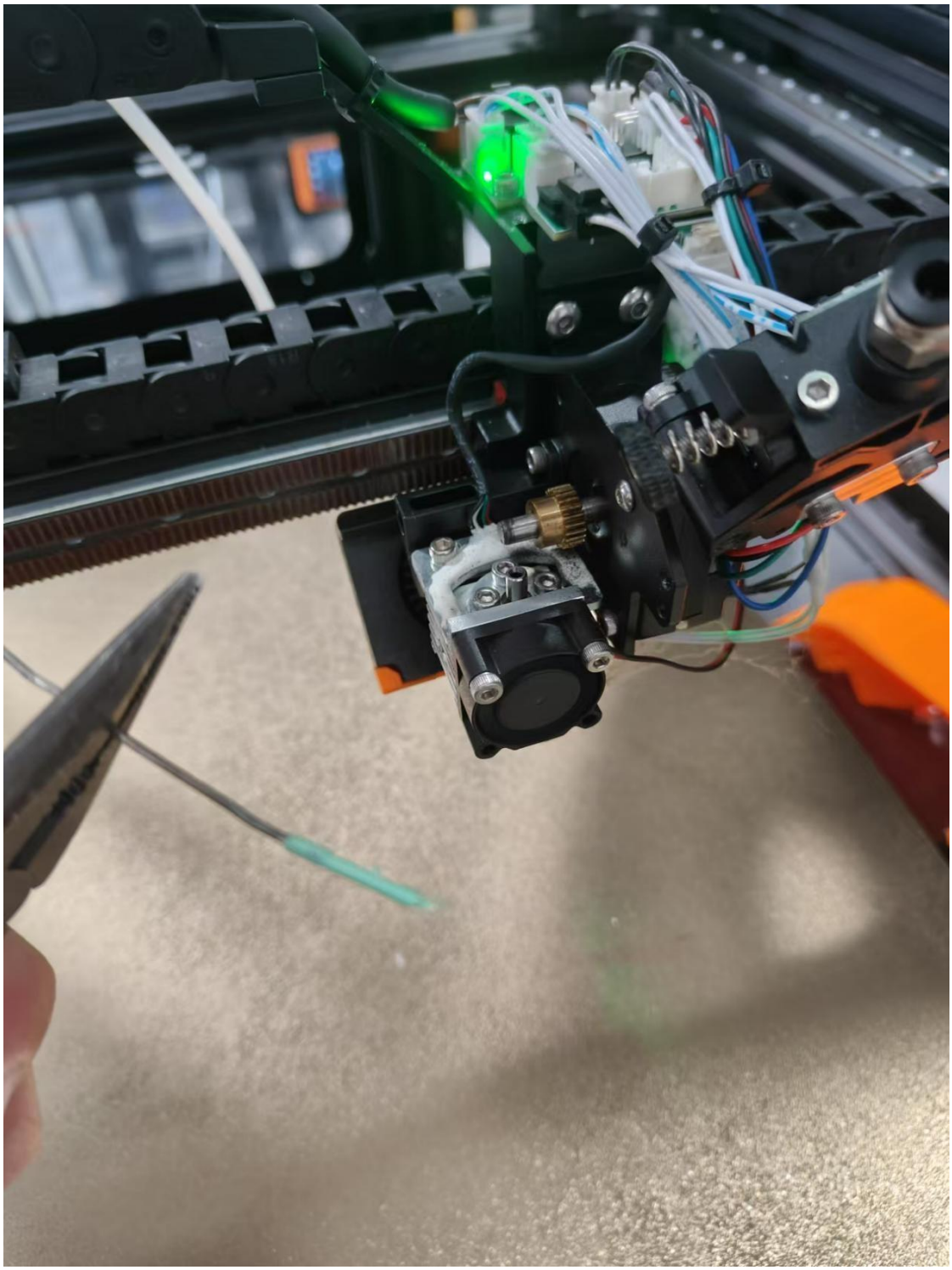
3. Use a pair of sharp-nosed pliers to hold the long through-needle, with the tip of the sharp nipple on one end, and use leverage to pull the long through-needle slowly

upward.





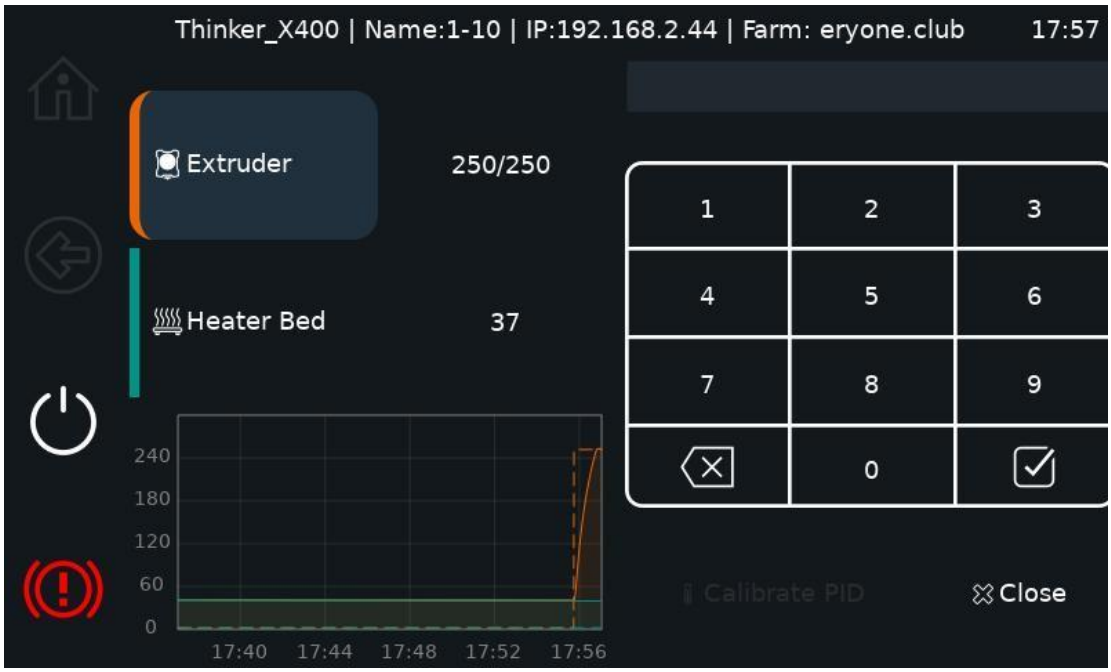
If this method works, the filaments inside the hot end will be attached to the long-through pins and be carried out.

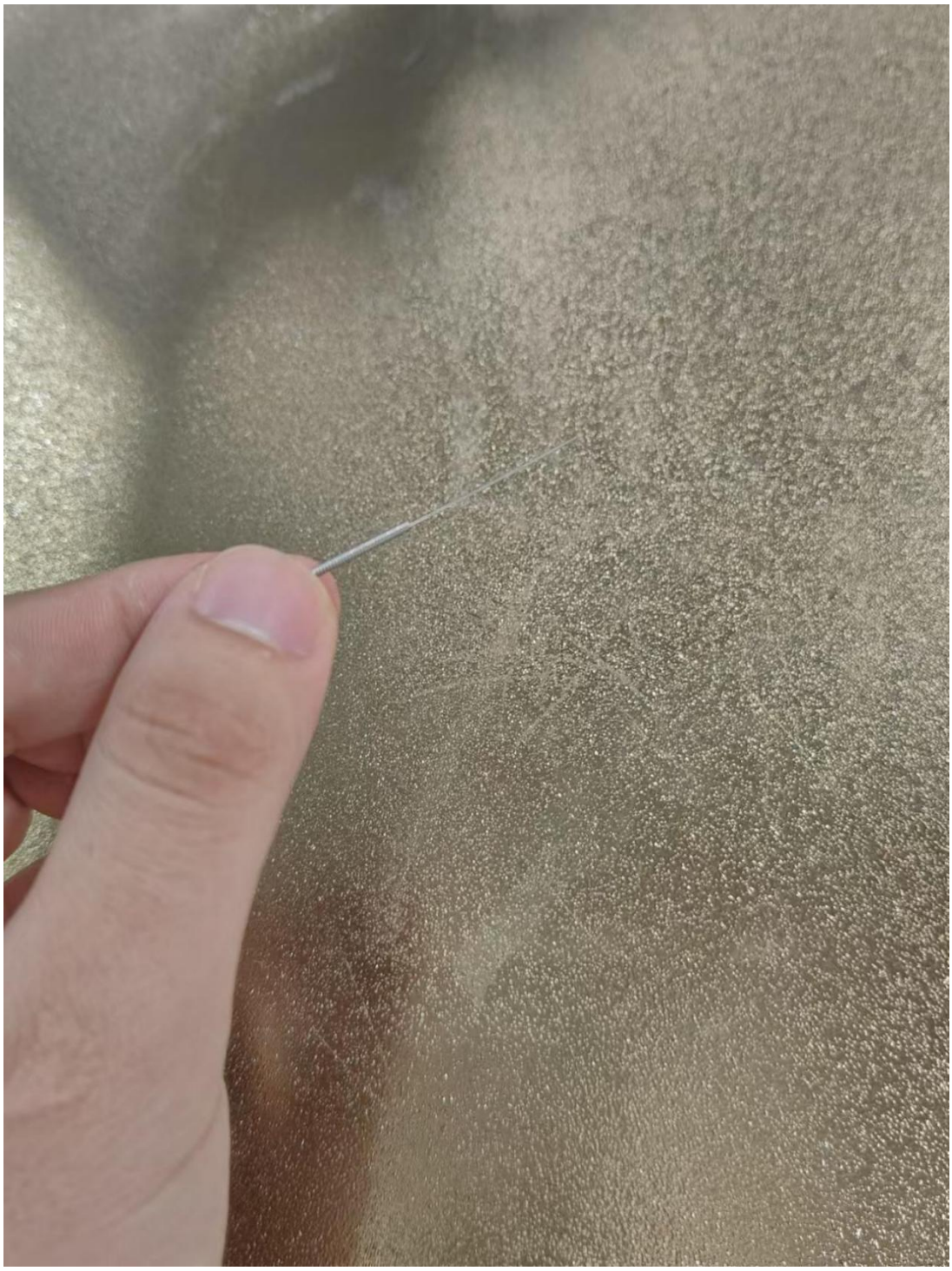


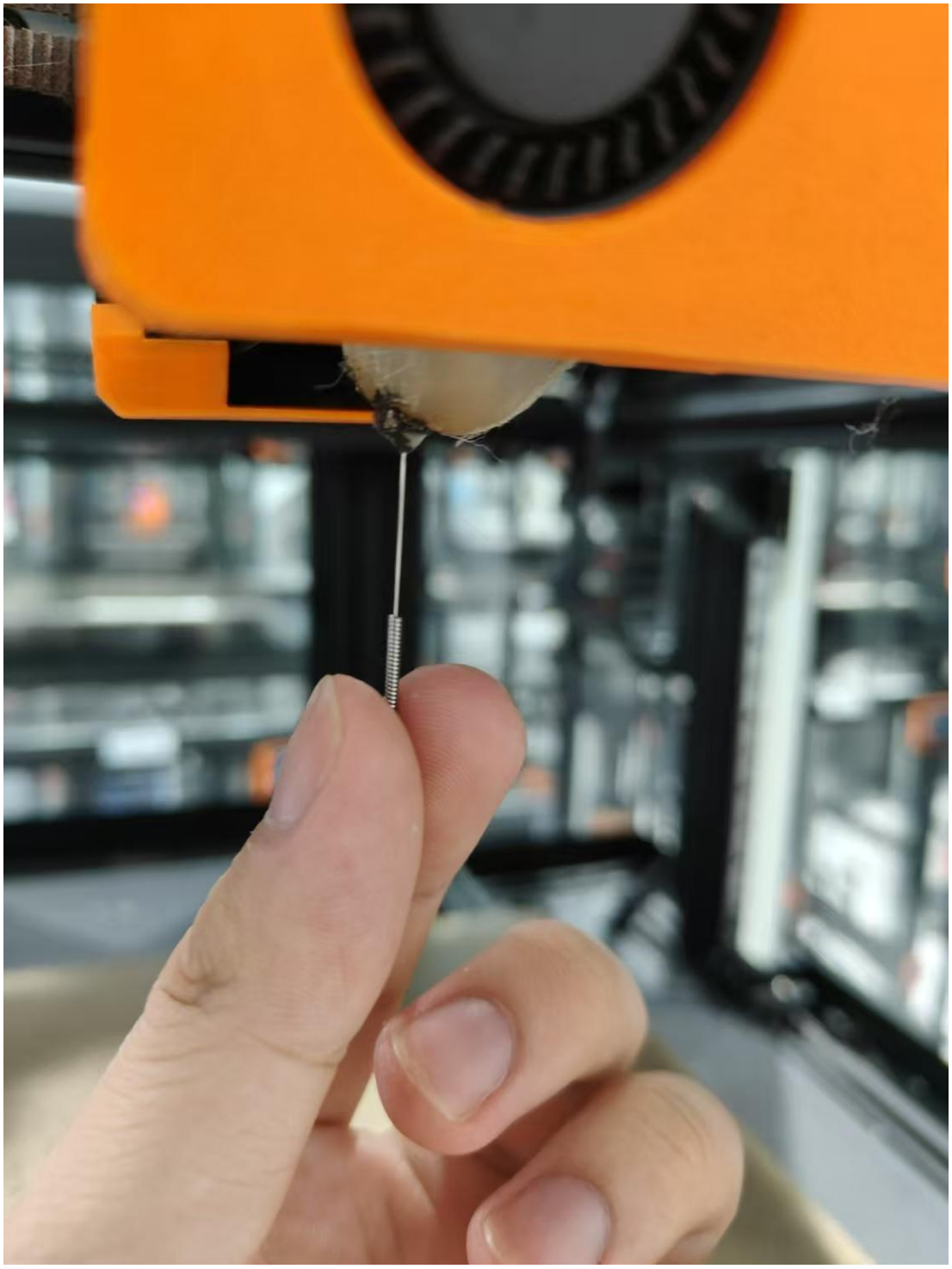
8.1.3 Clogged nozzle

Treatment: Heat the nozzle to 250°C, insert it into the tip of the nozzle using the unclogging needle, and then pull it out. Repeat the process

several times.



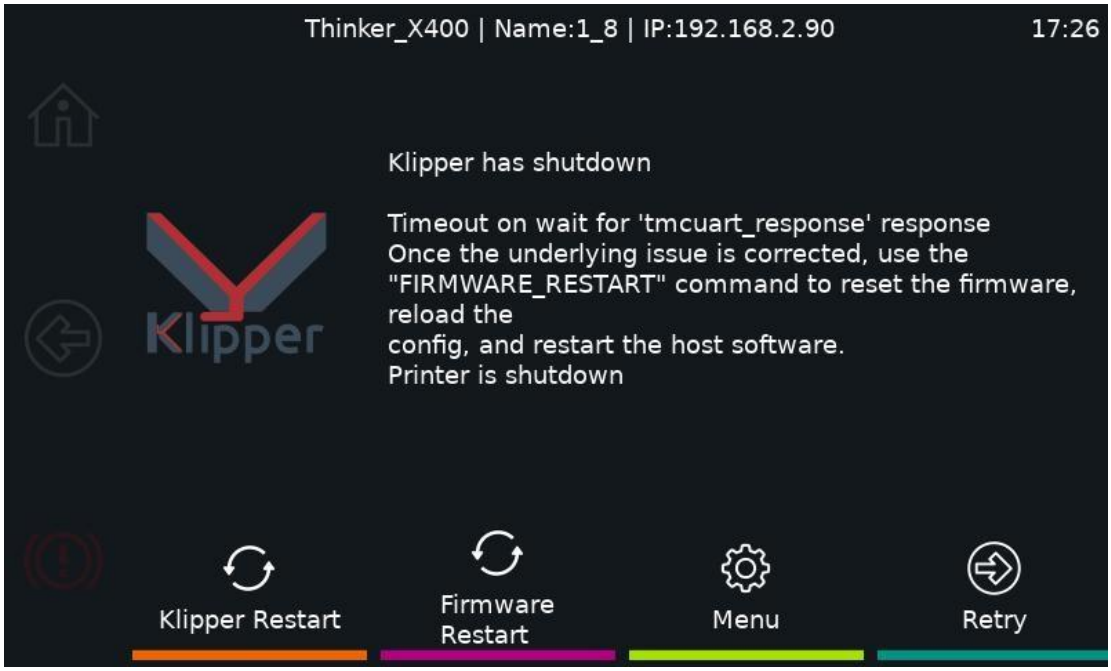




While the above method will fix the vast majority of clogs, in some cases the nozzle is indeed damaged and you can simply replace it.

8.2 Common Errors

8.2.1 Communication Timeout



Reason: The file is too large resulting in high CPU usage

Solution: It is recommended to use Eryone's default parameters for printing.

8.2.2 Temperature Anomaly

Reason:

1. Damage to the heating wire leads to

2. There is no silicone sleeve, resulting in a large deviation of the nozzle temperature within a short period of time leading to an error report

3. Broken heating pad

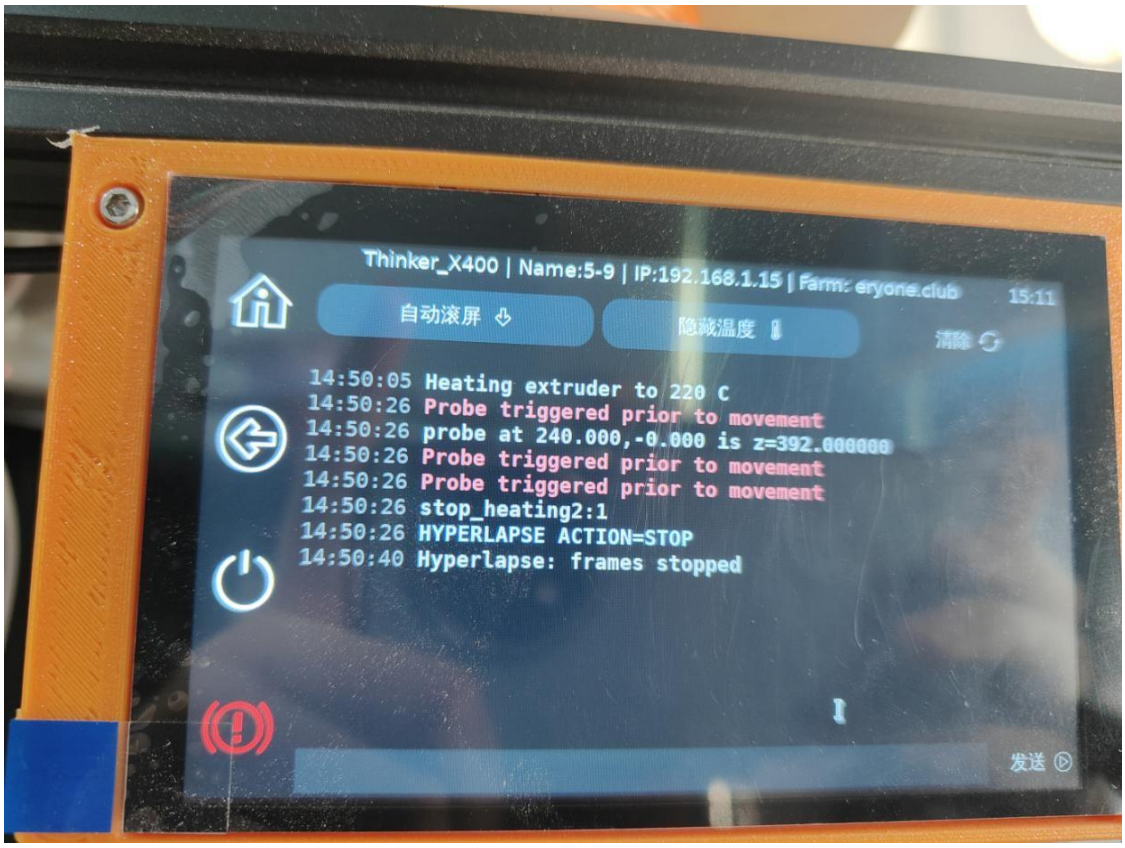
Solution:

1. Take a new one

2. Install a silicone sleeve

3. Change a new heating pad

8.2.3 Auto-Canceled Prints



Reason:

1. 4-point leveling Z-axis distance calibration deviation is large, resulting in canceled printing

2. The nozzle does not detect the heatbed

Solution:

1. Check and adjust the belt tension.

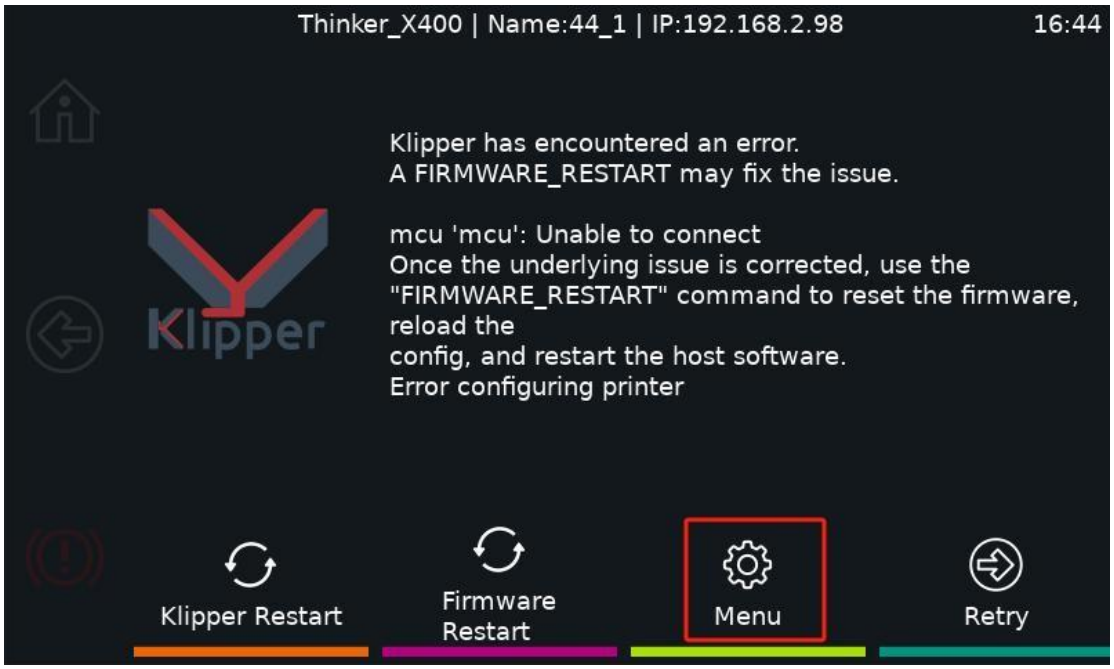
2. Click “Zero”.

8.2.4 Nozzle scratches PEI board surface

Cause: Problem with pressure sensor

Solution: Restart the printer and perform a Z-axis tilt calibration test

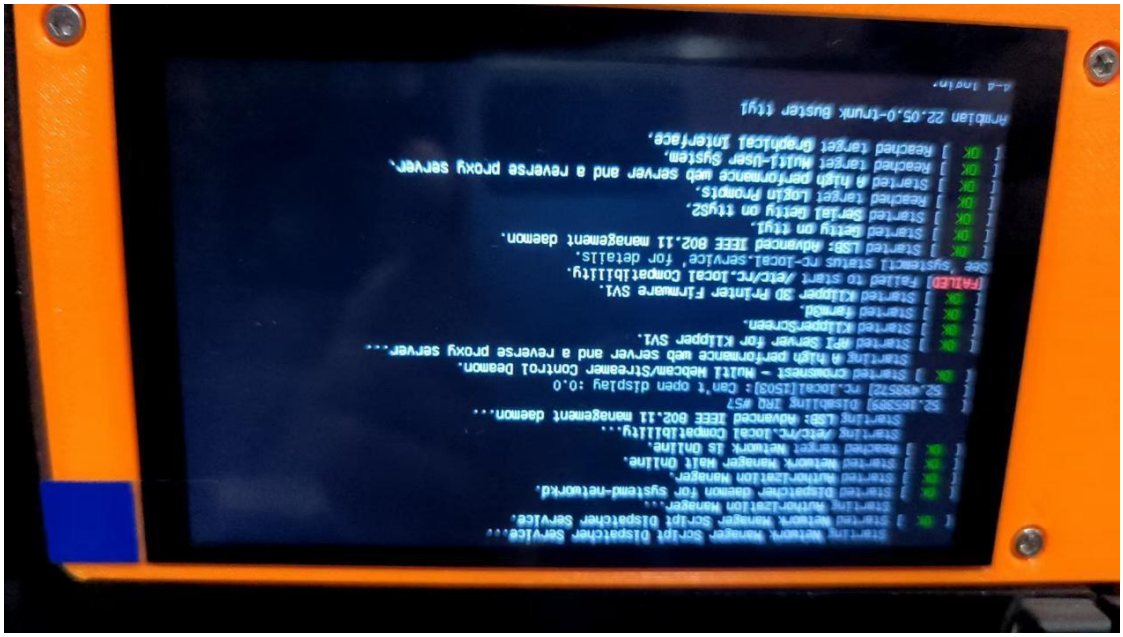
8.2.5 Boot Up Error



Reason: Poor contact on MCU motherboard

Solution: Turn off the computer and wait for a while before rebooting.

8.2.6 Screen won't turn on properly



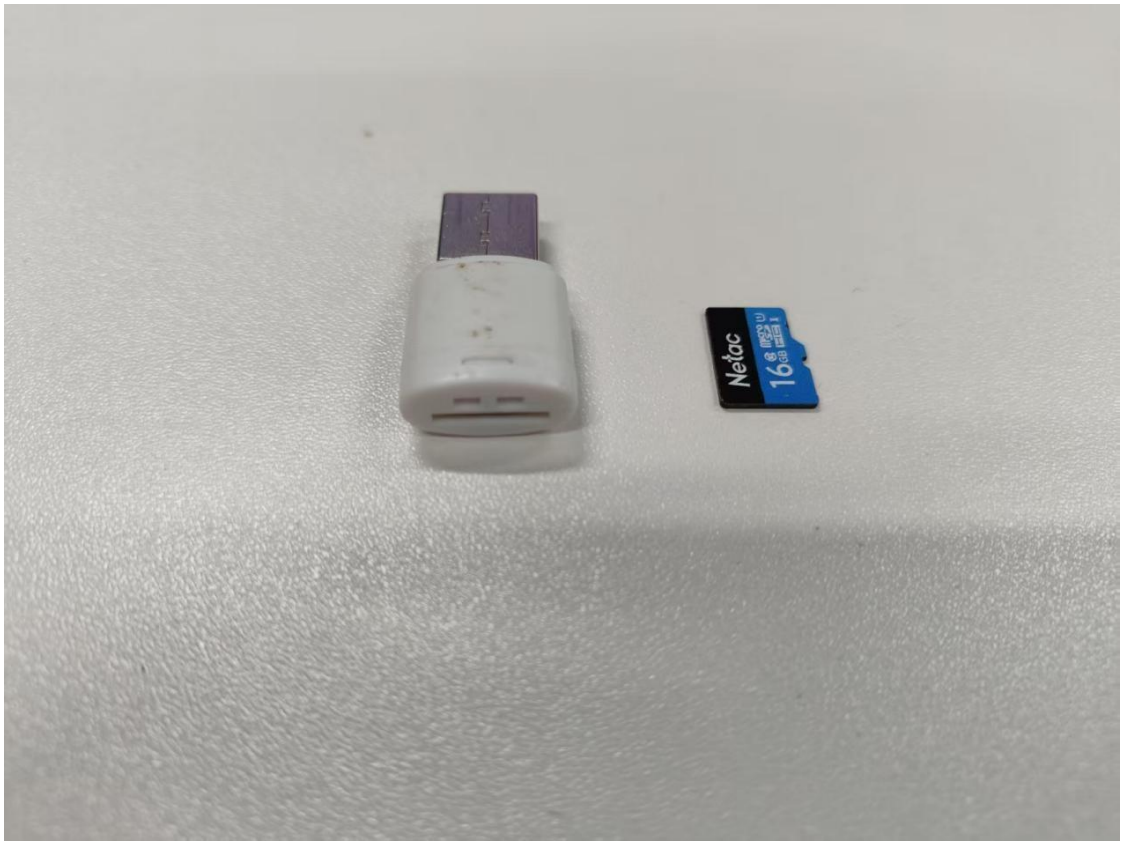
Cause: System files are missing

Solution: Reinstall the system

Operation Steps:

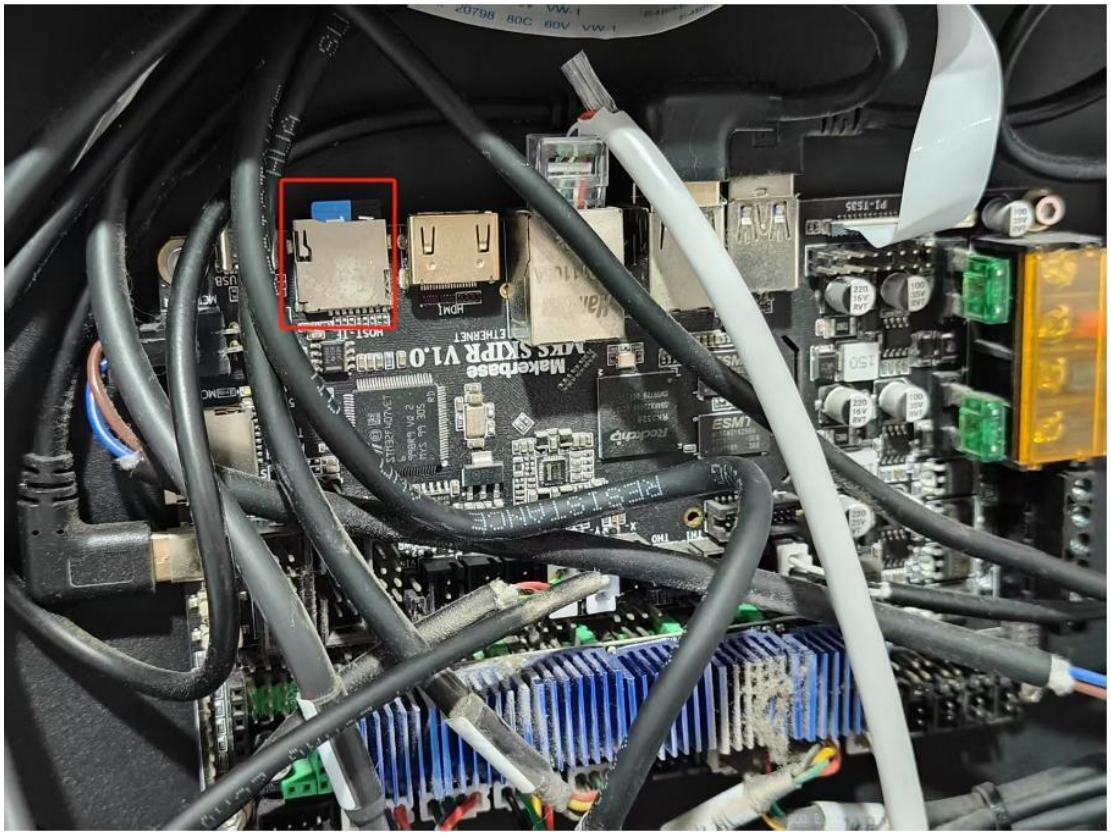
Step 1:

Prepare an SD card and a card reader.

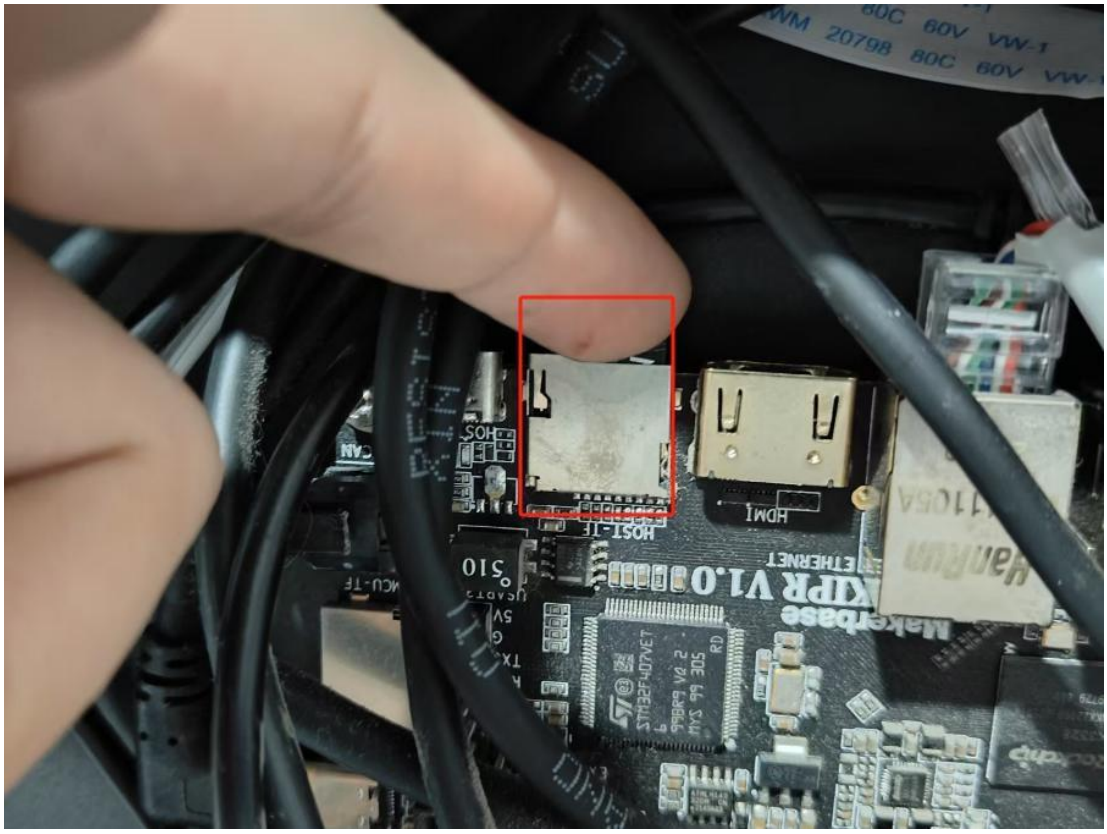


Requires user-provided card reader

SD card in the SD card slot on the motherboard.



Remove by finger pressure.



Step 2:

Download the machine firmware image file and burning software balenaEtcher

Machine firmware download URL:

https://drive.google.com/drive/folders/1htD4KUY9WmH9W7UyBleRF0uzNoNothT1?usp=sharing

Burning Software Download Address:

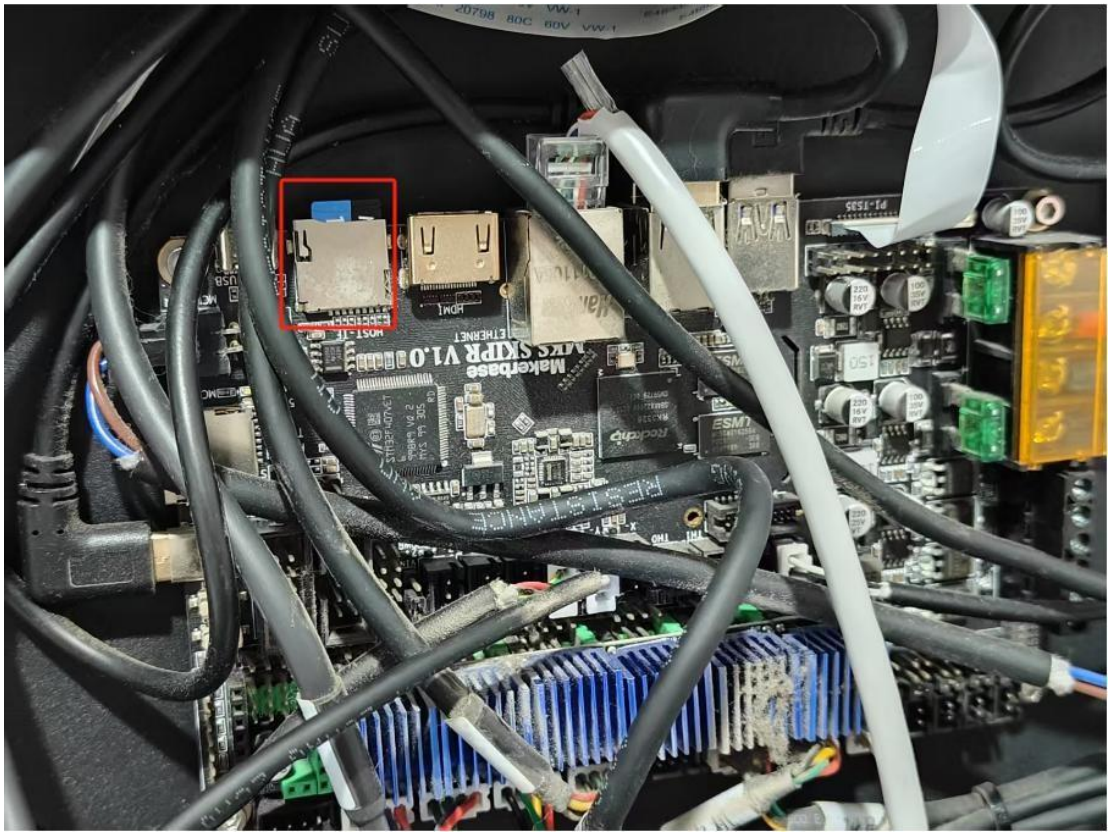
https://etcher.balena.io/

Step 3:

Burn the downloaded image file to the SD card.

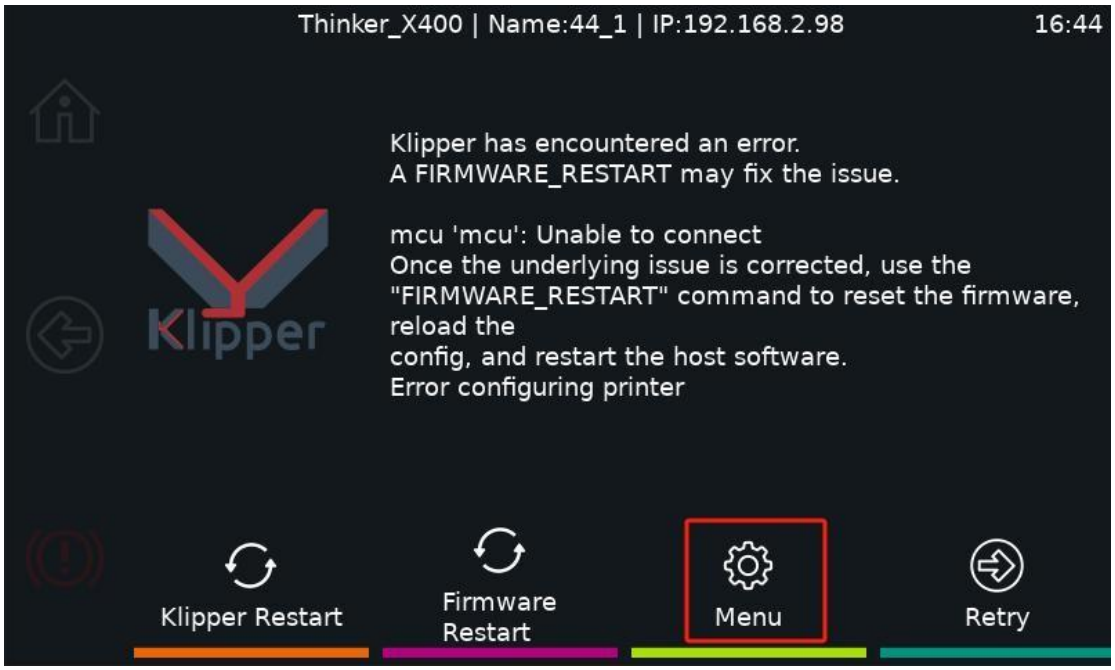
Step 4:

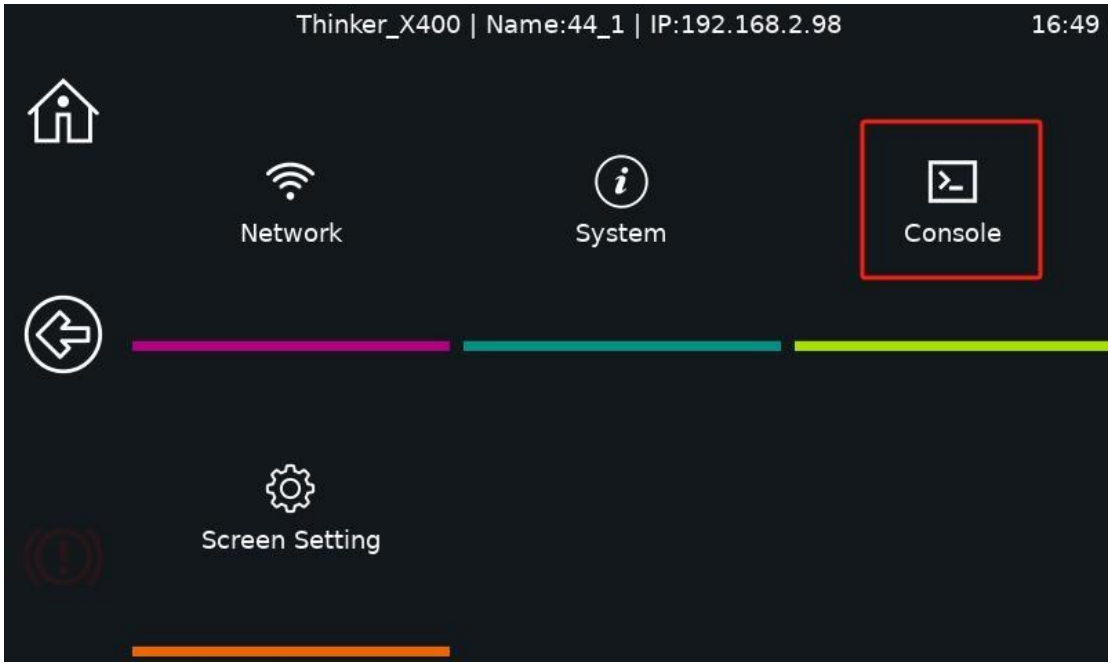
Insert the burned SD card back into the SD card slot of the printer.

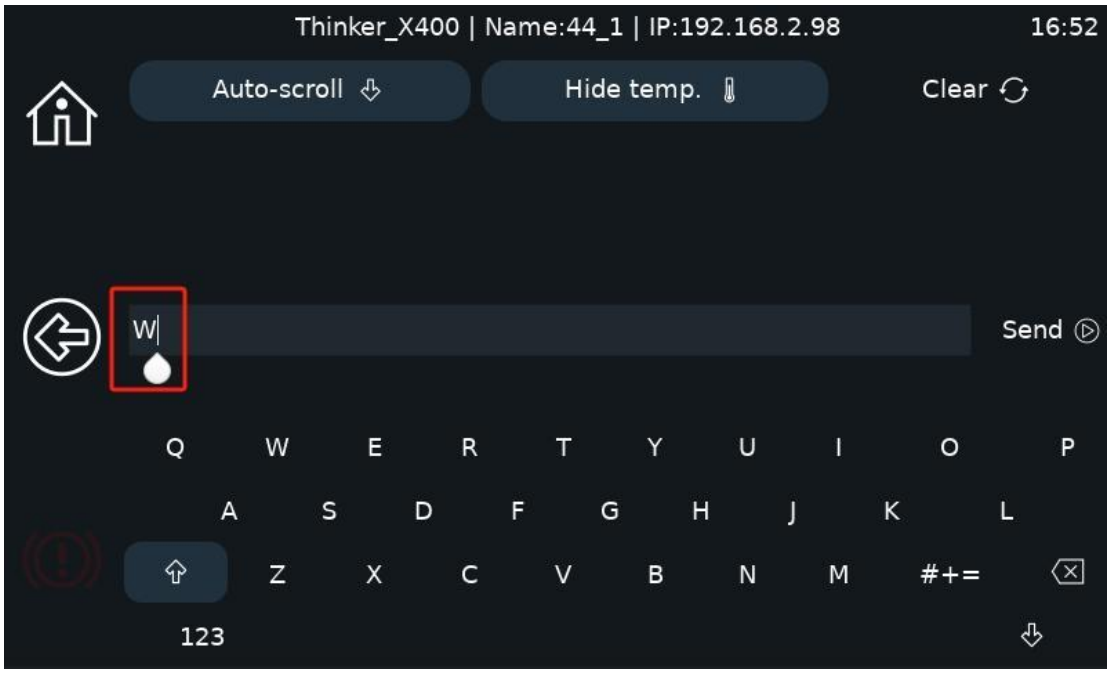


Step 5:

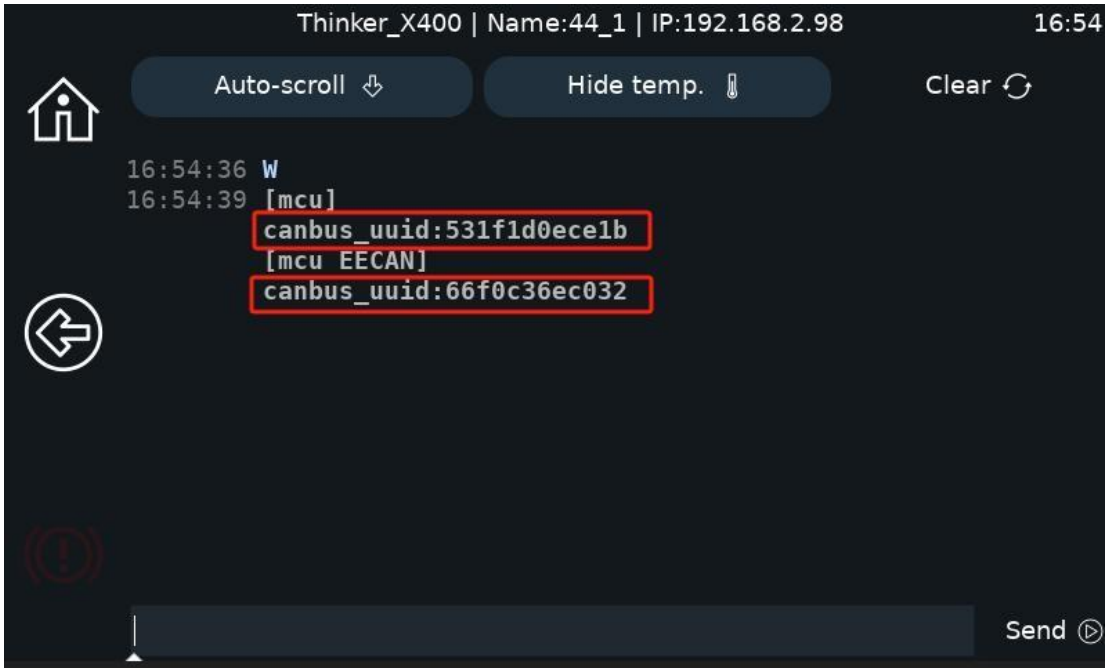
Start the printer and output a capital “W” on the console.





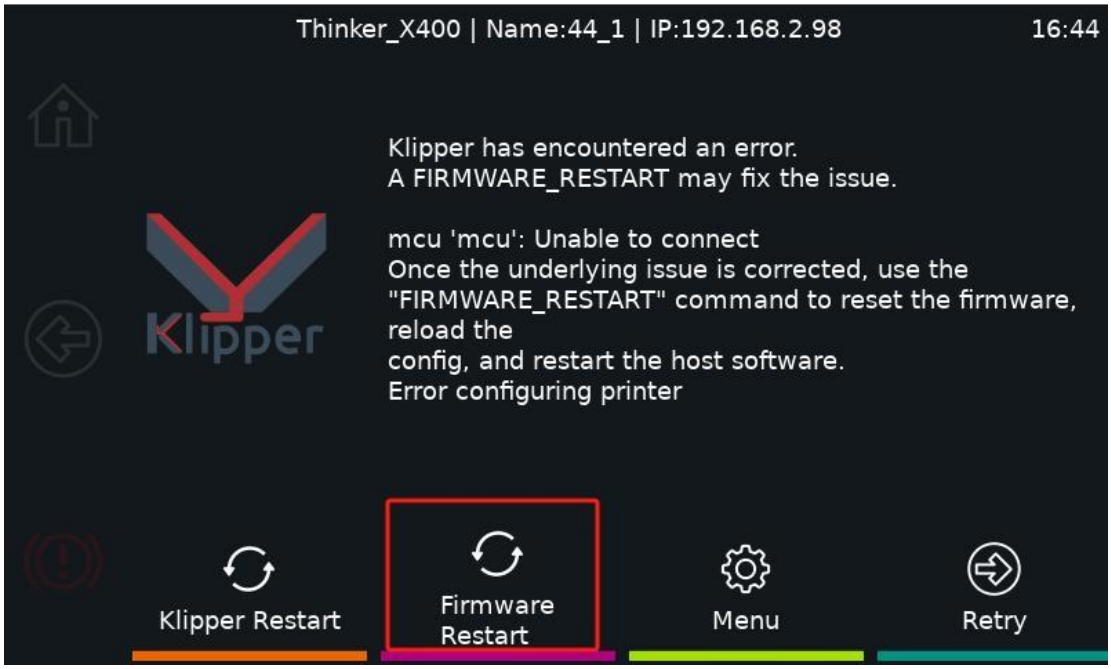


The printer will fetch the 2-line ID. if the console does not fetch the 2-line ID, you will need to turn off the printer and repeat step 5 until the 2-line ID appears.



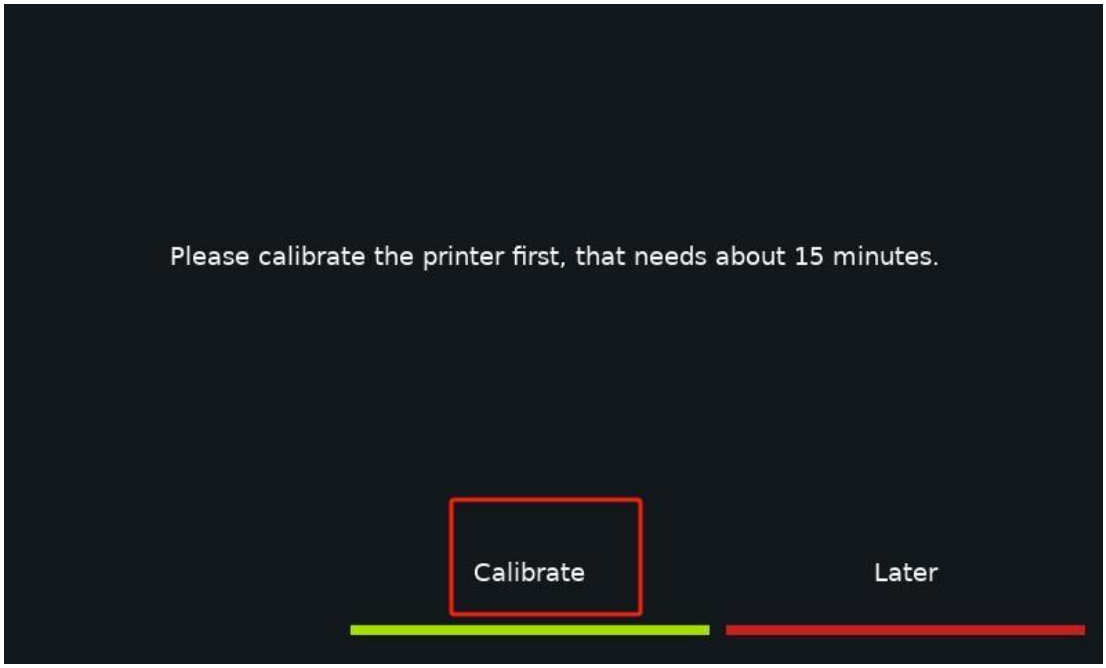
Step 6:

Return to the main page and click Firmware Restart.



Step 7.

After clicking on it, a pop-up window will appear, it needs to be calibrated for 15 minutes, and after calibration, it can be used normally.


Please calibrate the printer first, that needs about 15 minutes.
Calibrate
Later

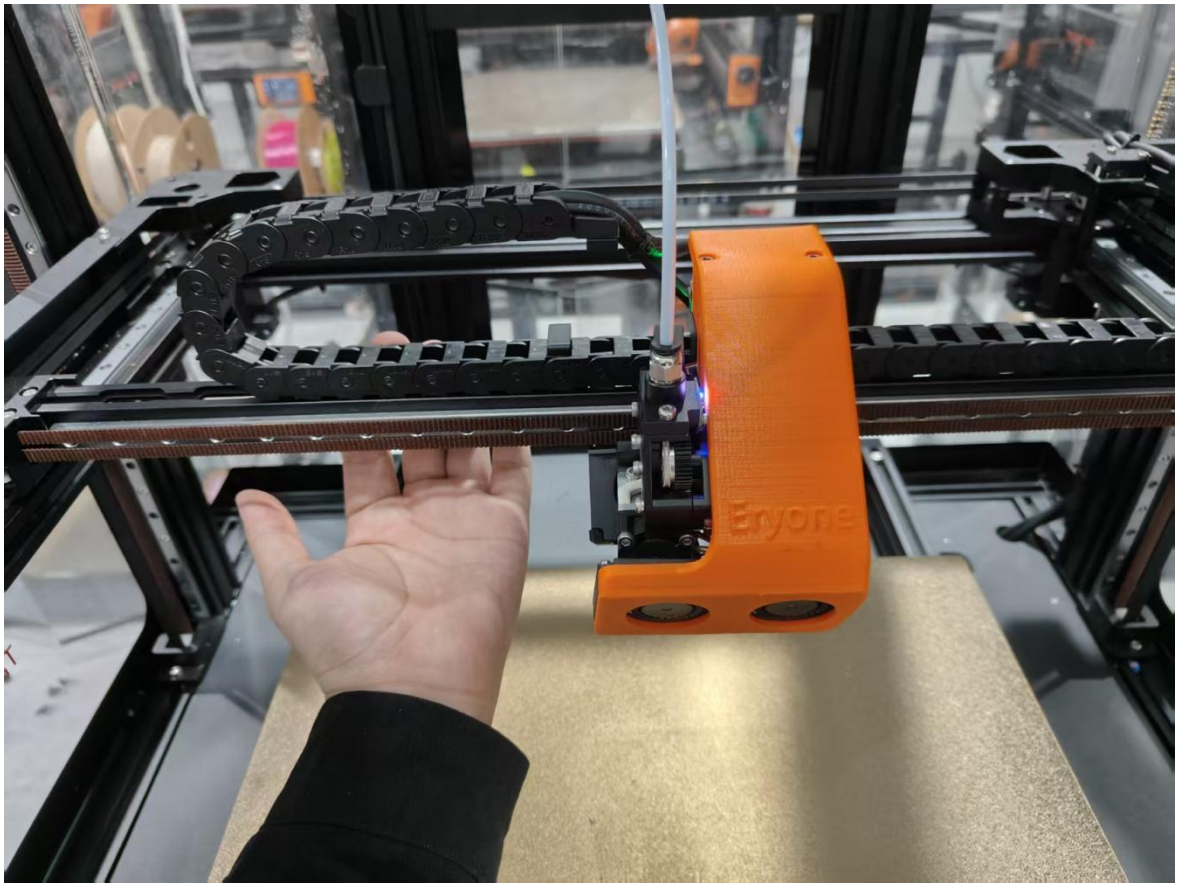
9.Regular Maintenance

When you see that the belt of X and Y axis is loose and elastic when you touch it with your fingers, you need to tighten the belt again.

Adjustment method: loosen the 4 screws on the belt of X and Y axis, then push the extruder back and forth on the X axis slowly until the belt is tight, then you can screw back the screws.


3
4


Eryone

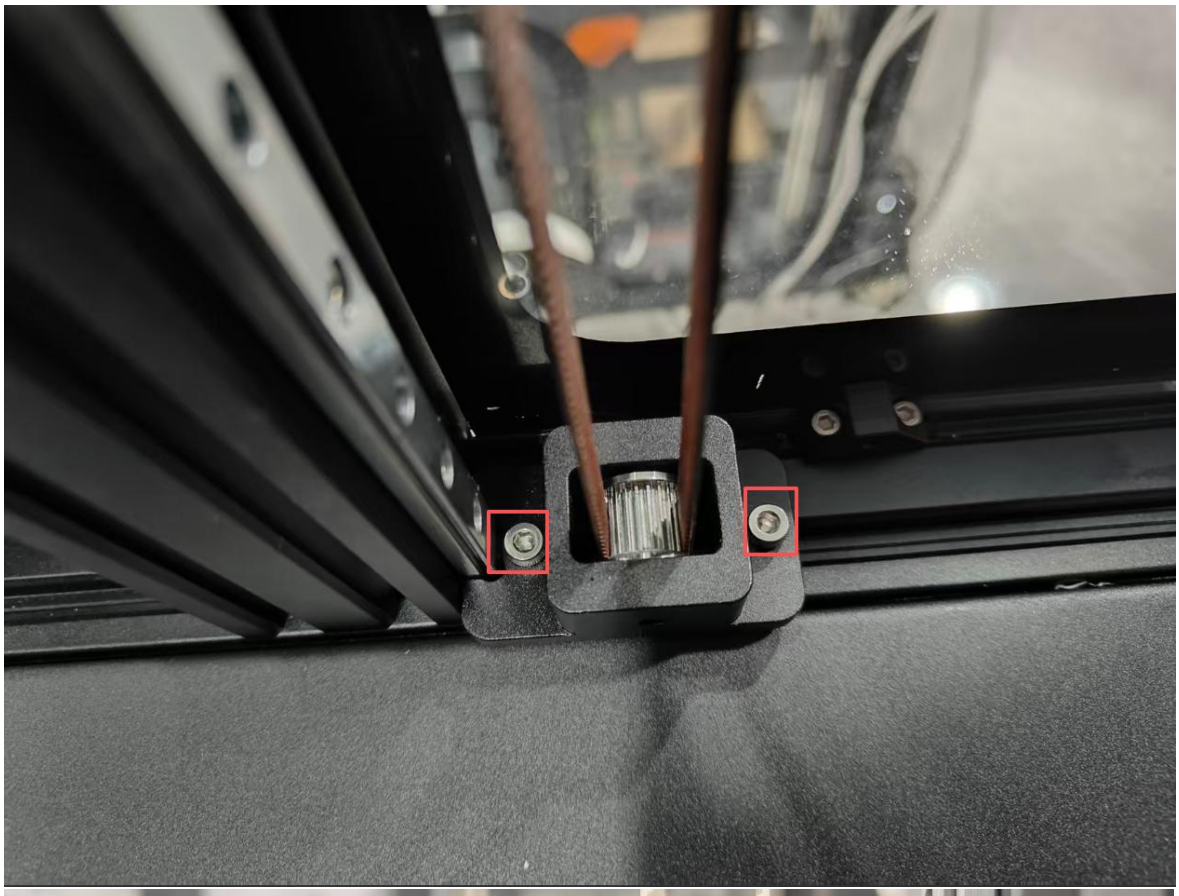

Eryone

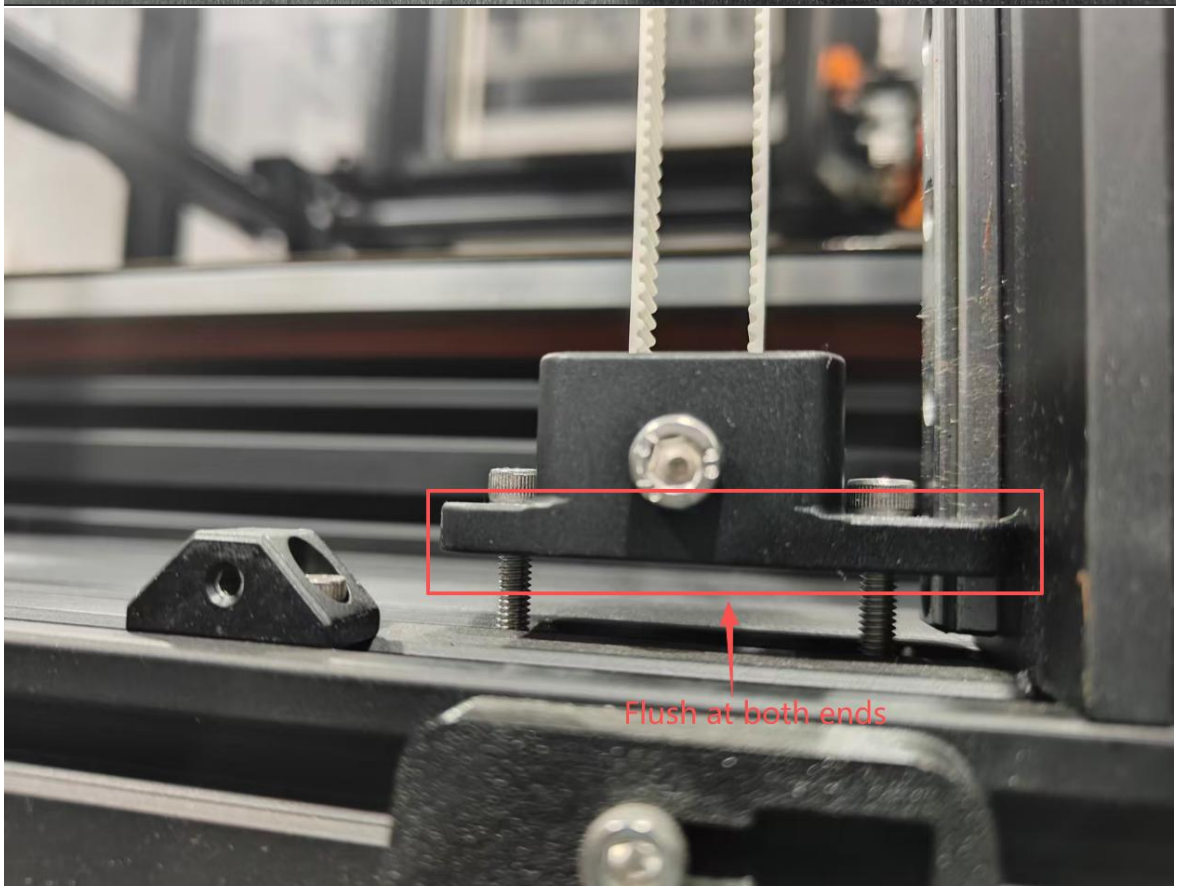
9.2 Z-axis belt

When you play for a period of time, use your fingers to press the two ends of the belt, feel the tightness of the belt, to make appropriate adjustments (the force between the two belts just contact can be)

Adjustment method: use 3mm Allen wrench to turn the 2 screws next to the belt.


GATES
POWER GRIP
GT3
GATES
POWER GRIP
GT3





9.3 Fan Cleaning

Clean dust and debris every six months.

9.4 Filter Replacement

Replace the activated carbon filter every three months.

9.5 Silicone Sock Replacement

Replace if worn to maintain temperature stability.

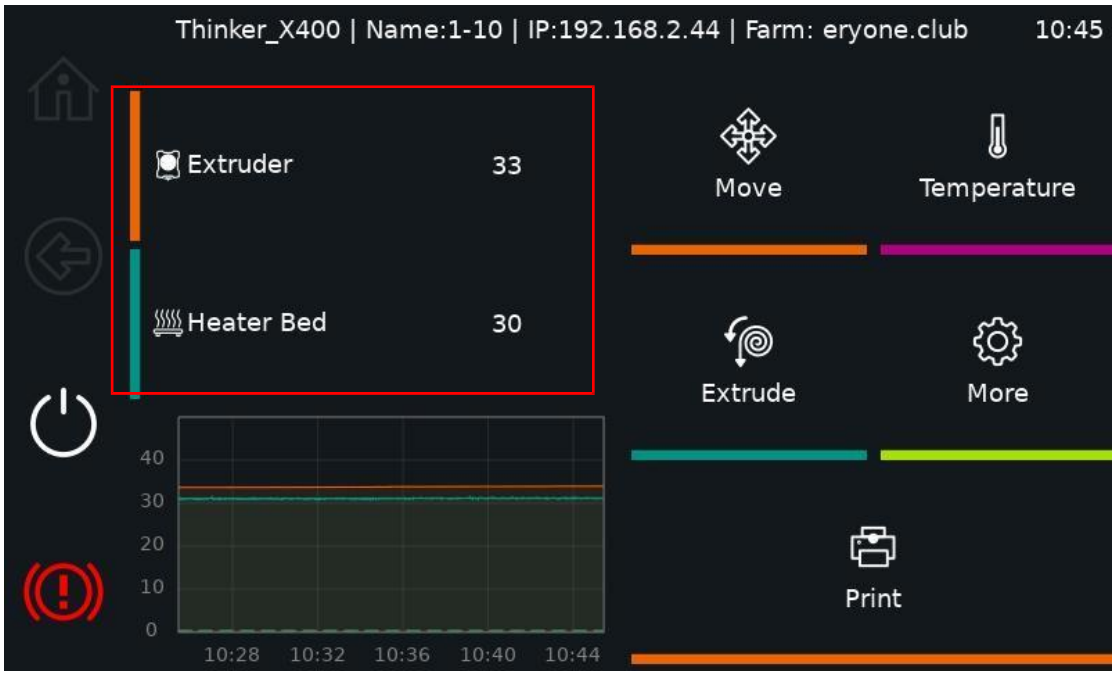
10.Part Replacement Guide

10.1 Nozzle Replacement

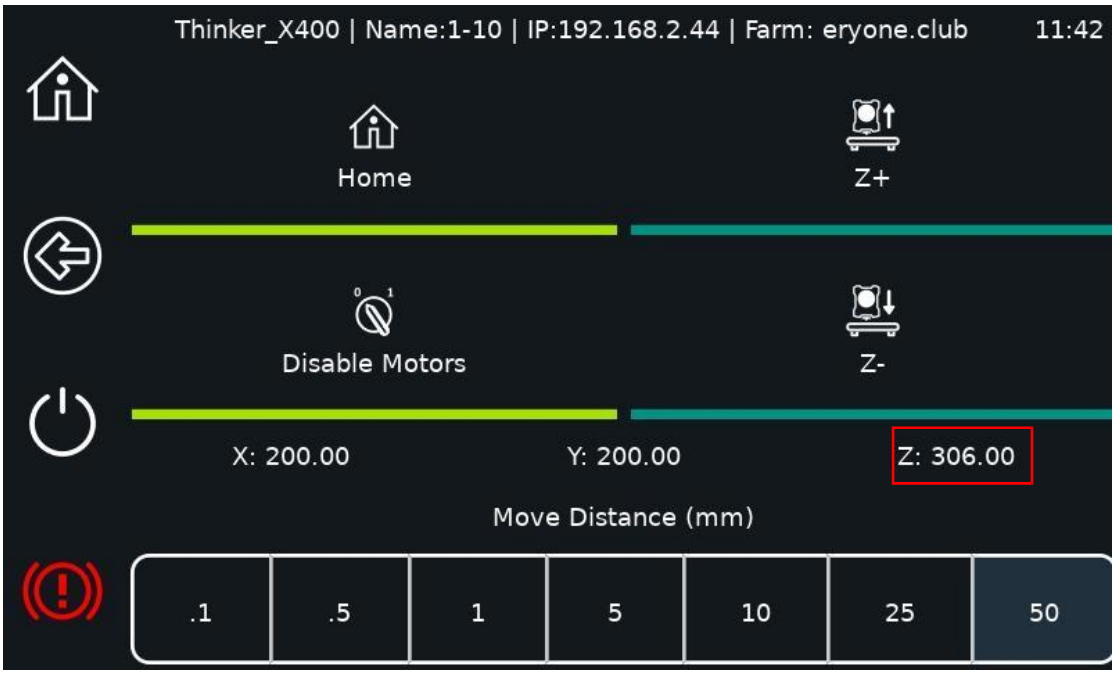
When the nozzle is worn out or clogged beyond repair, you can replace the nozzle with a new one.

Replacement procedure：

① Before replacing the nozzle, please reduce the nozzle temperature to room temperature to prevent burning when replacing the nozzle.



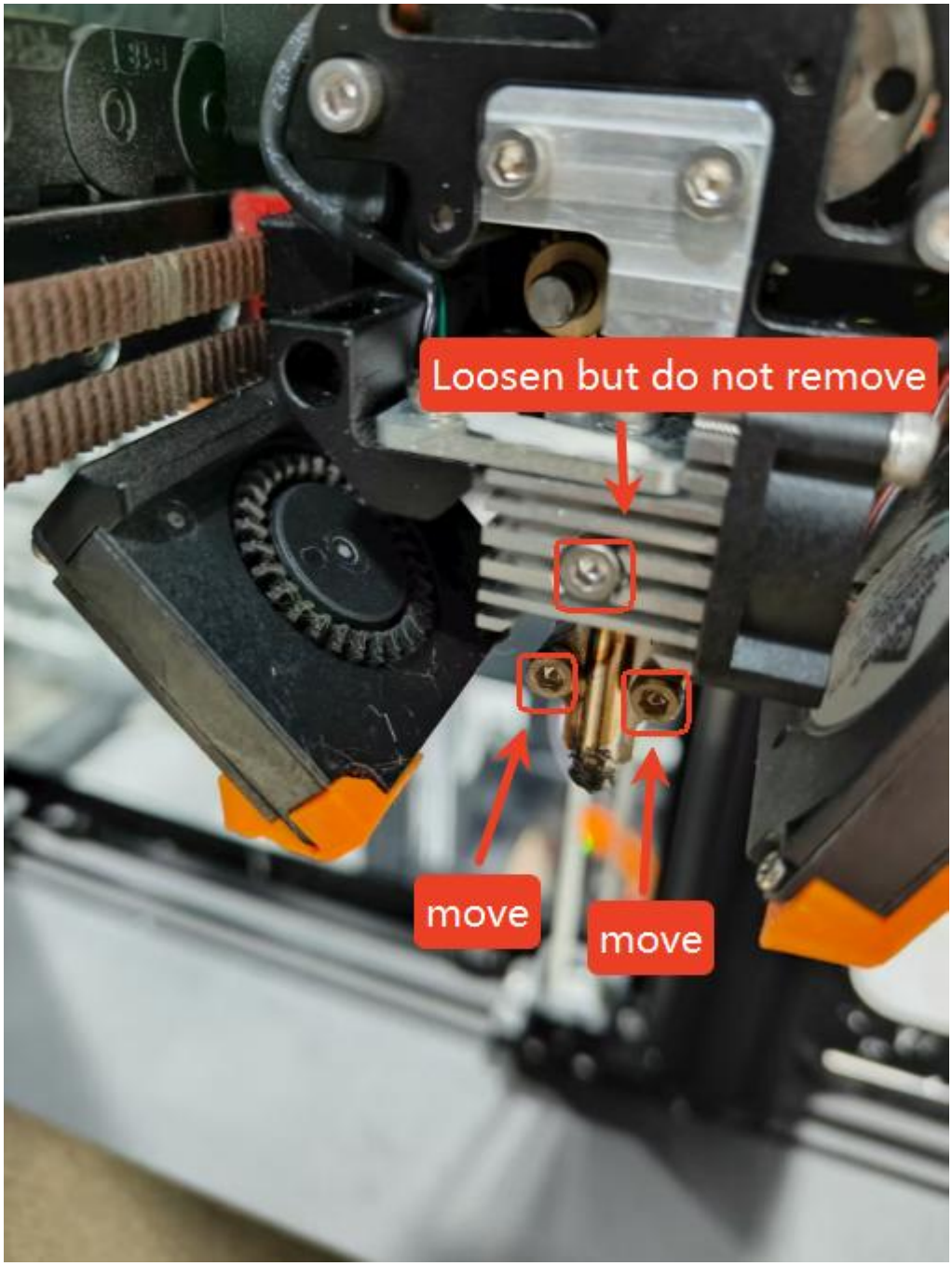
② Move the Z-axis up about 150mm or so to make sure there is room for a change.



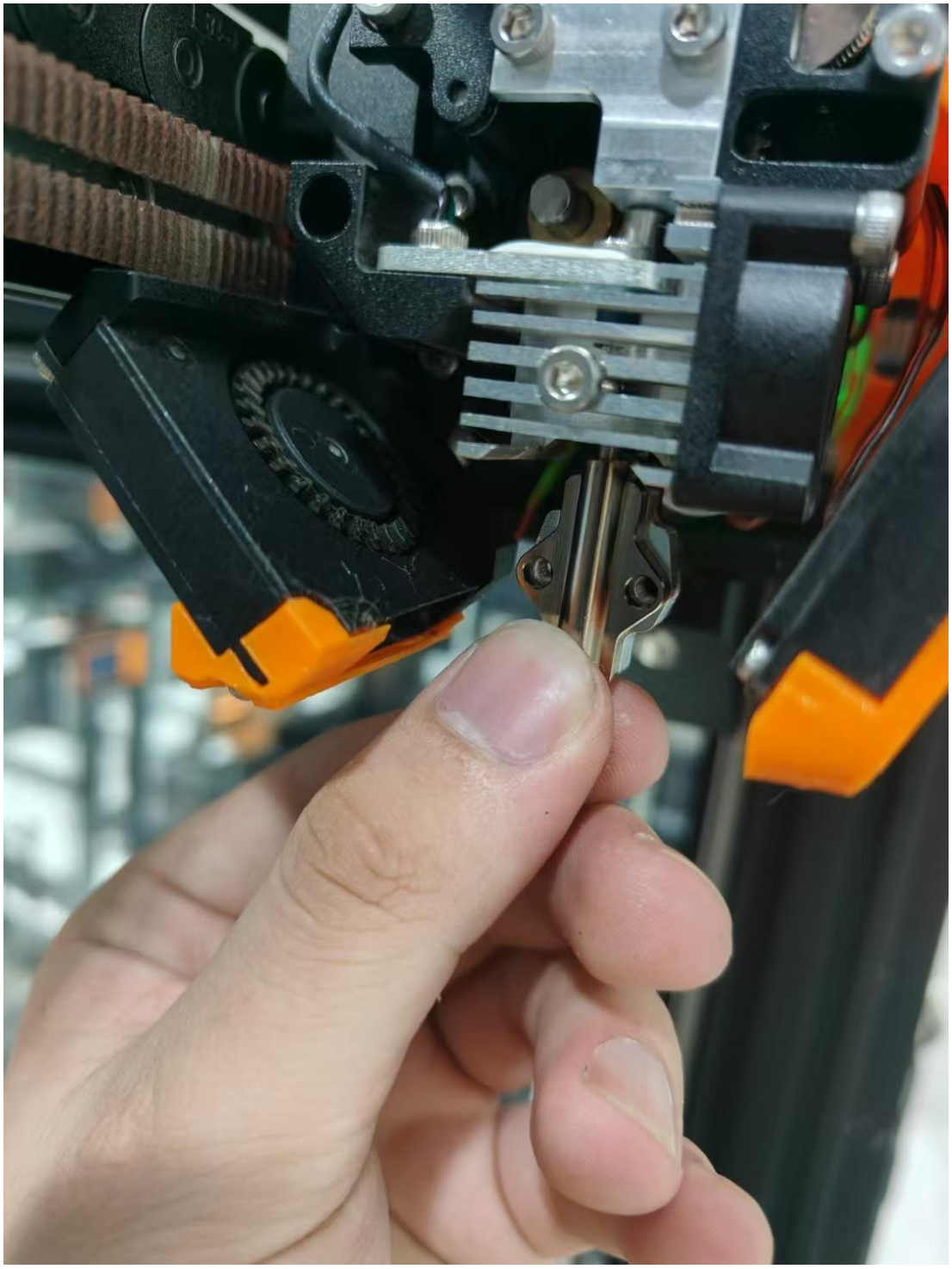
③ Remove the silicone sleeve from the hot end.

④Use a 2.5mm Allen wrench to remove 2 screws and loosen 1 screw on

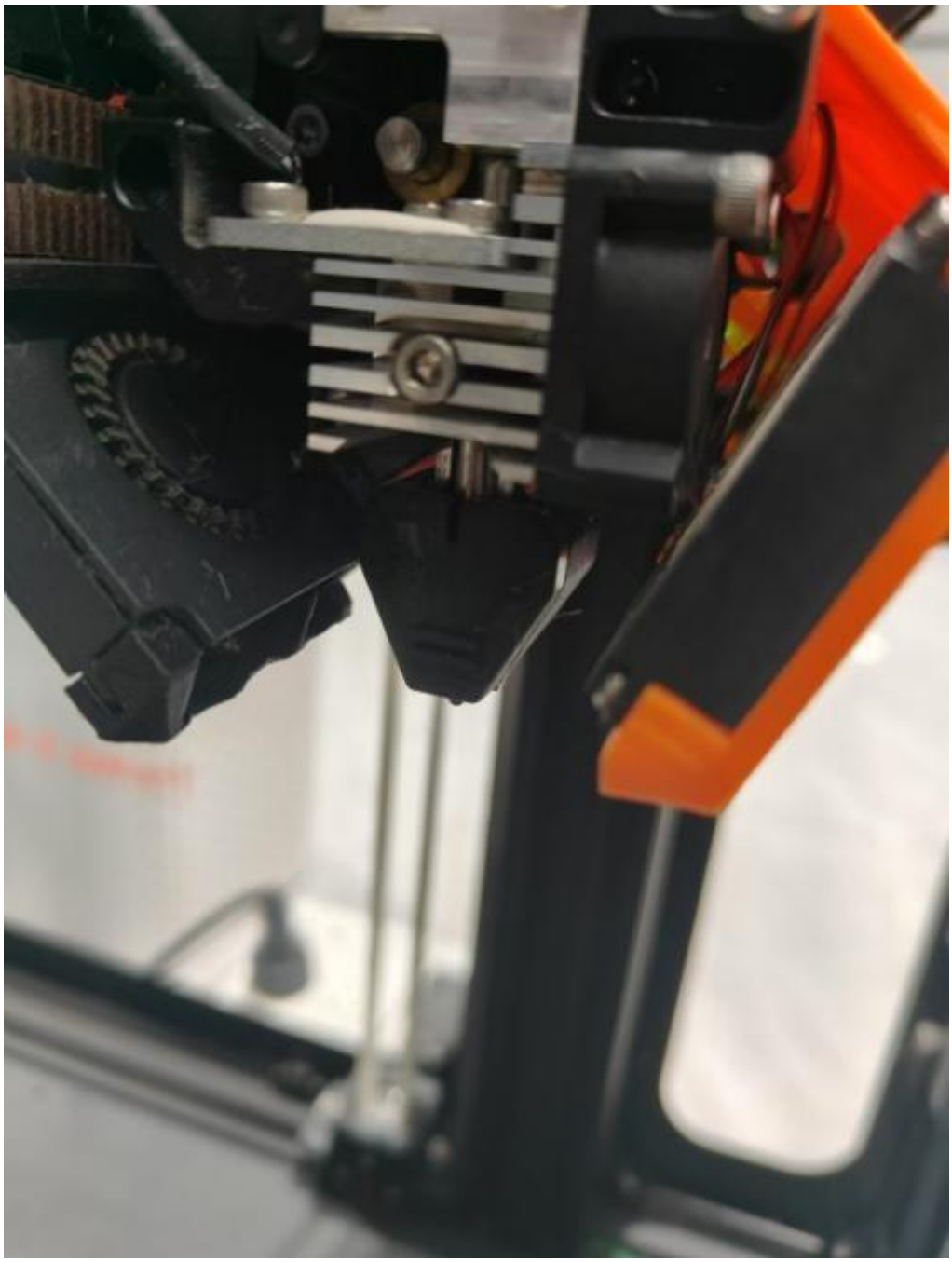
the heat sink, remove the old nozzle.



⑤Take the new nozzle, put the smooth end against the hot end, use a 2.5mm allen wrench to reinstall the 2 screws back in, and tighten the screws on the heat sink.



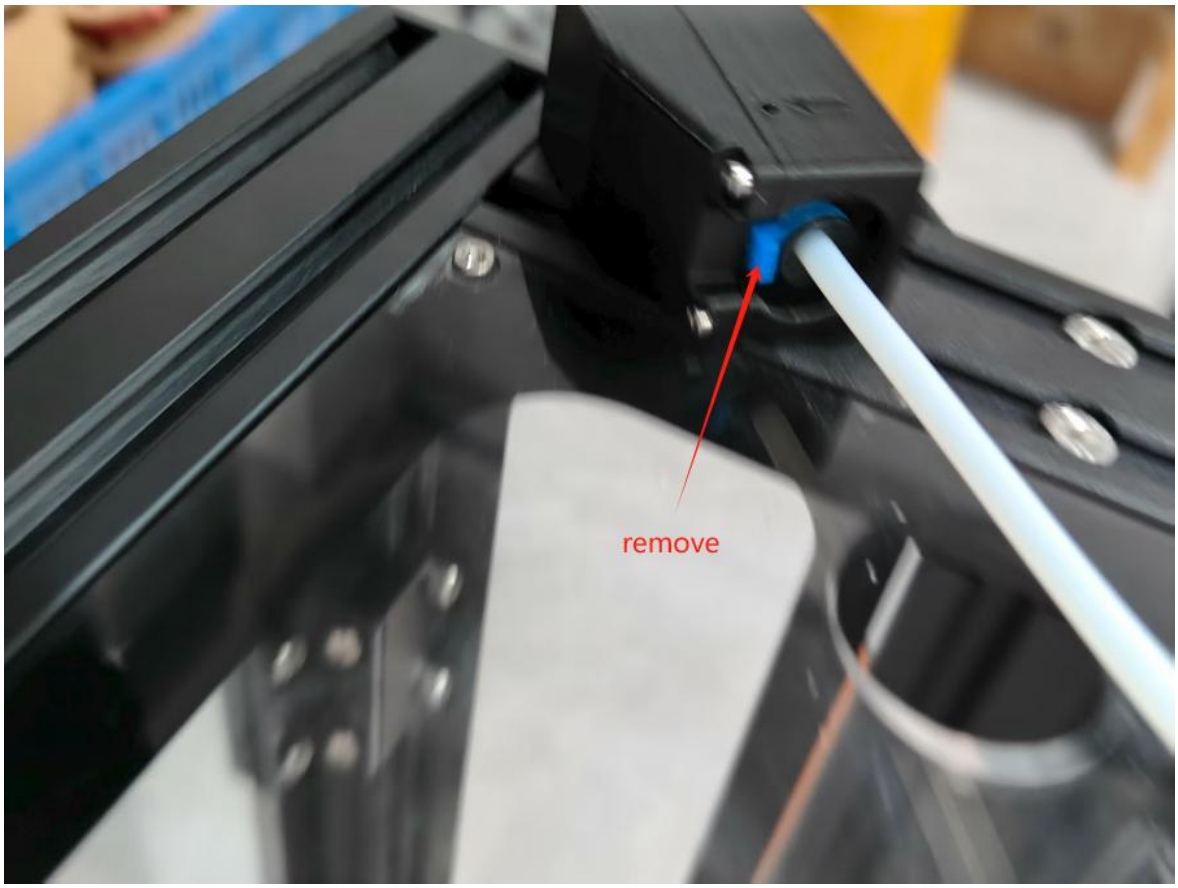
Ⓐ Put back the silicone sleeve.



10.2 PTFE Tube Replacement

Replacement steps：

Take out the feed tube retainer



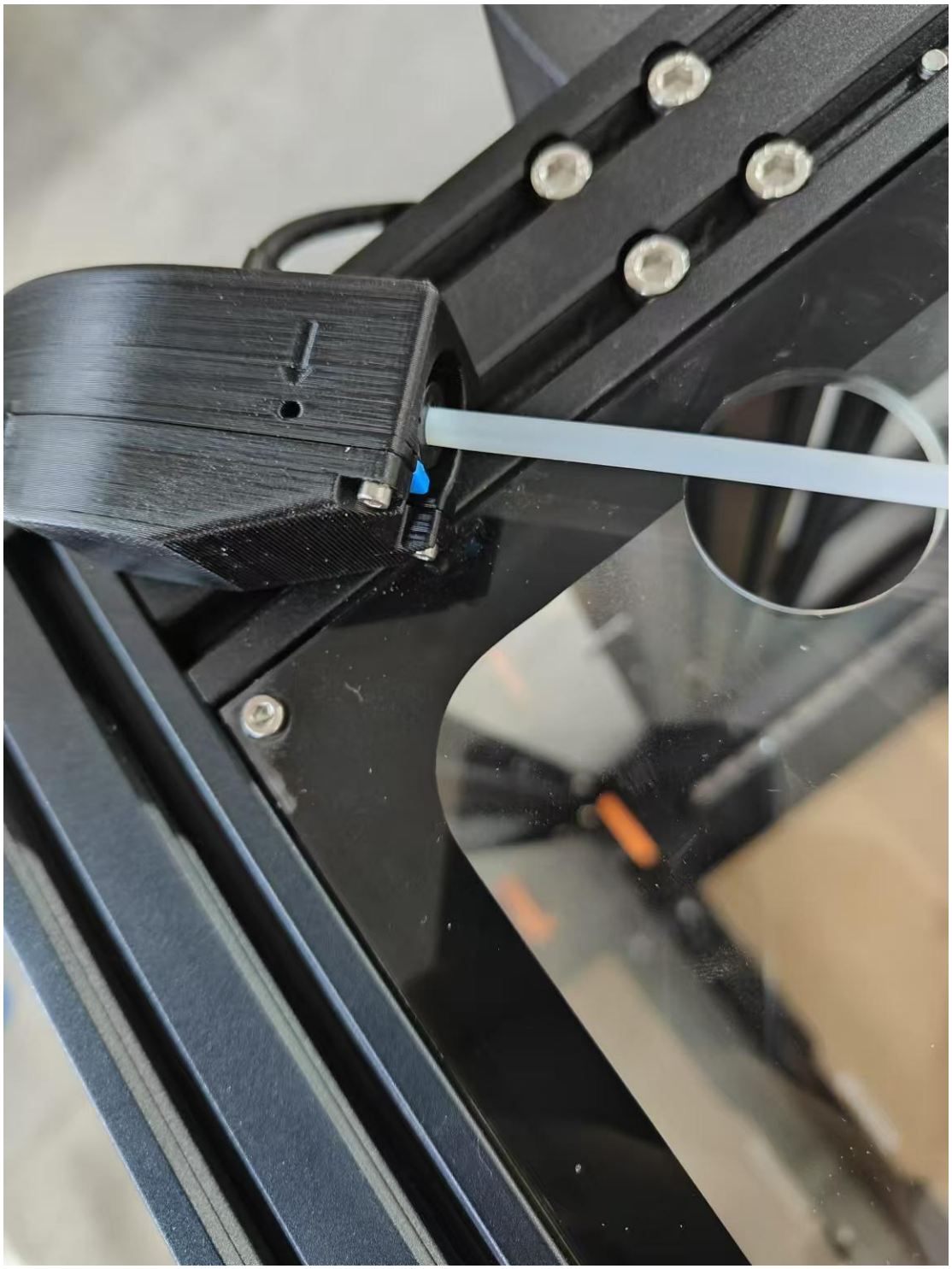
Use a 1.5mm Allen key to insert into the upper hole.

③Hold the plug of the pneumatic connection with one hand and pull

out the PTFE tube with the other hand.

④Insert a new PTFE tube until it is flush with the Teflon catheter seat port

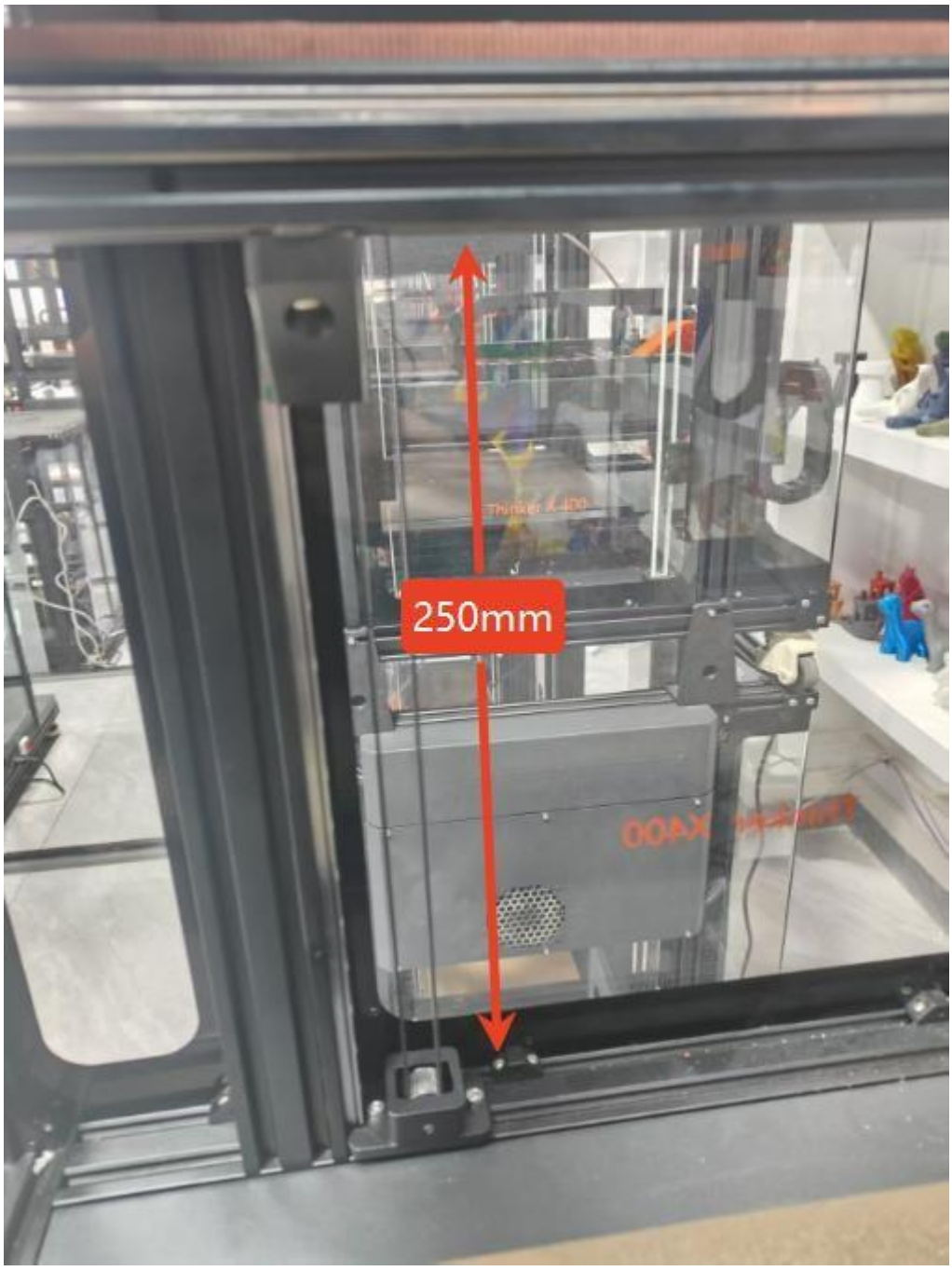
⑤To install the return tube retainer, pull out the 1.5mm Allen wrench.



10.3 Z-Axis Belt Replacement

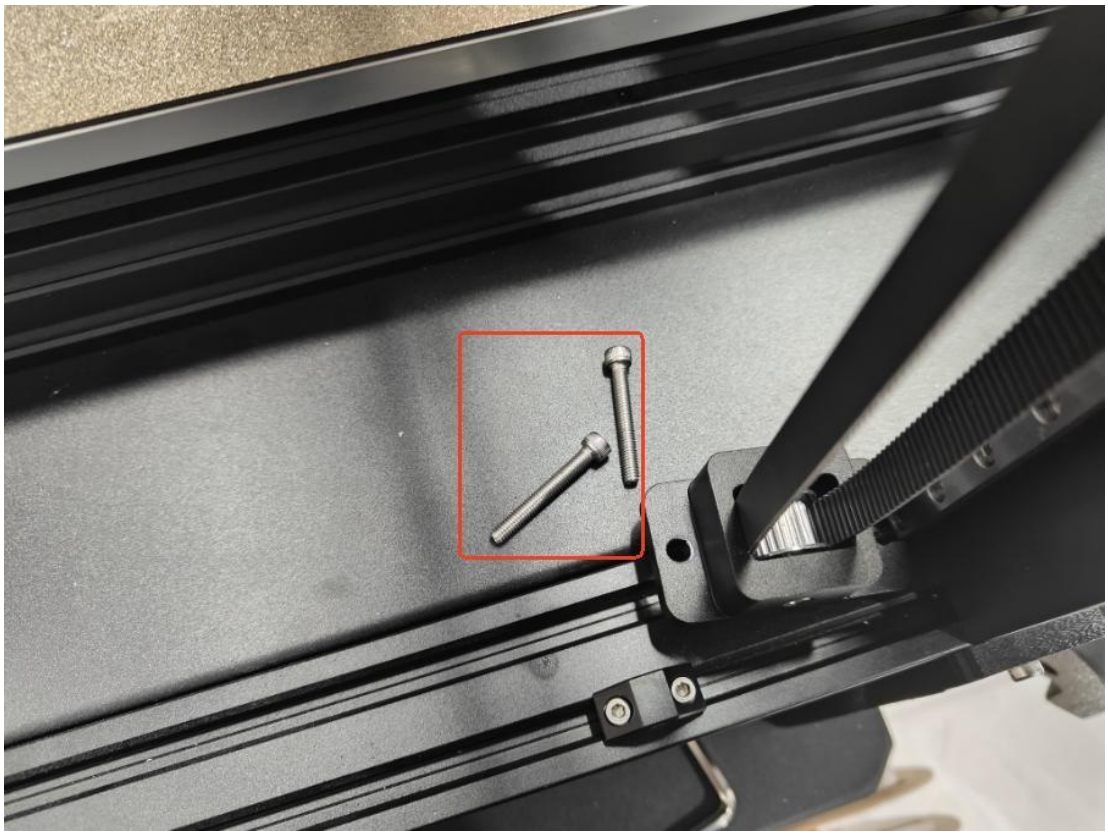
Replacement steps：

1. Raise the Z-axis 250mm upwards (make sure there is enough space to remove the screws)



2. Removal of acrylic panels

3. Remove the 2 screws from the lower belt holder.



4. Remove the 4 screws from the belt head retainer.

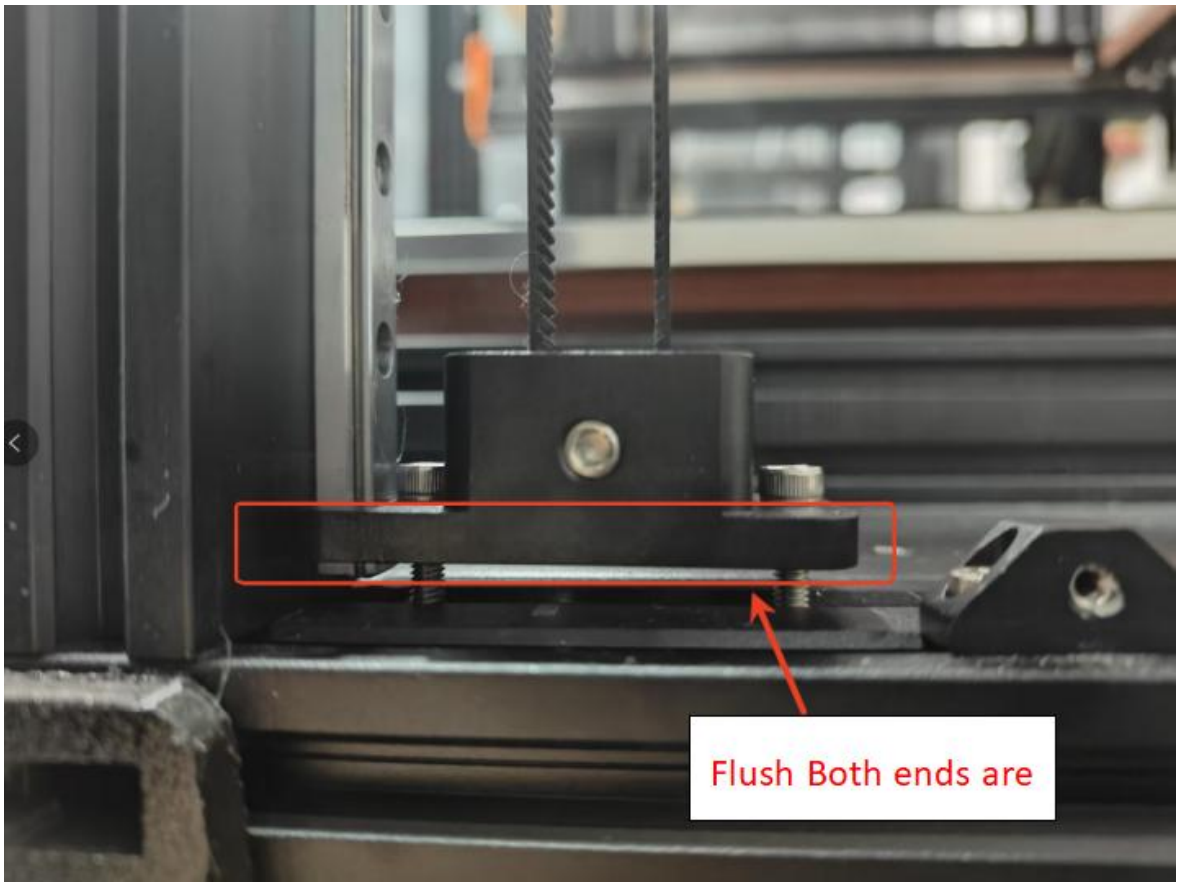
5. Remove the top cover of the belt head retainer and pull out the belt head.

6. Remove the old belt from the top and bottom belt retainers.

7. Take out a new belt, put the upper and lower ends of the belt back to the belt fixing parts respectively.

8. Adjust the length, tuck both ends of the belt head back into the buckle and fasten.

9. Screw the lower belt fixture until both ends are flush, squeeze both ends of the belt by hand, and the force between the two ends of the belt is just enough to touch it.



10. Unscrew the four screws of the rubber head fixing piece.

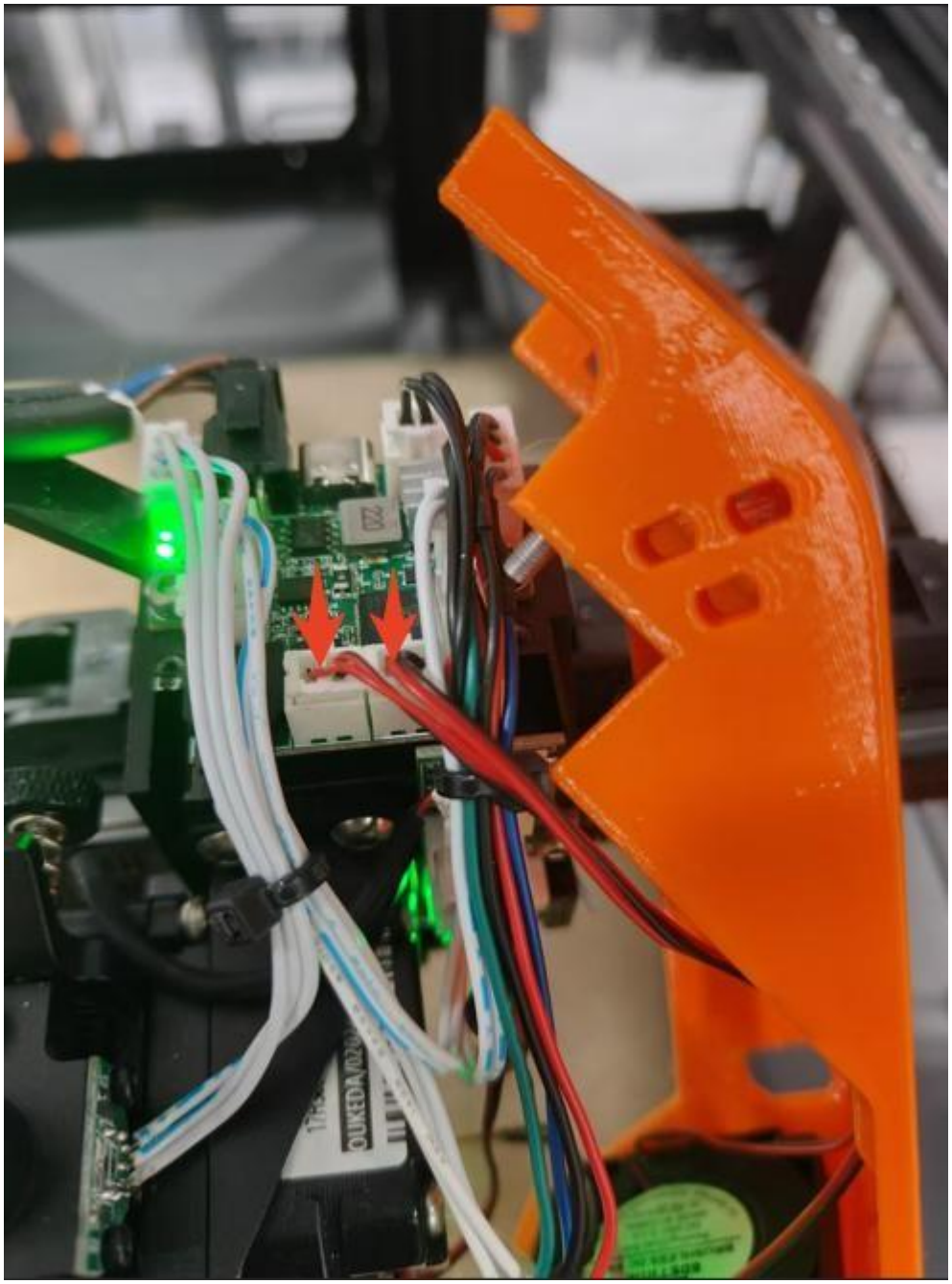
11. Reinstall the acrylic panels.

12. Click the Z-axis tilt test.

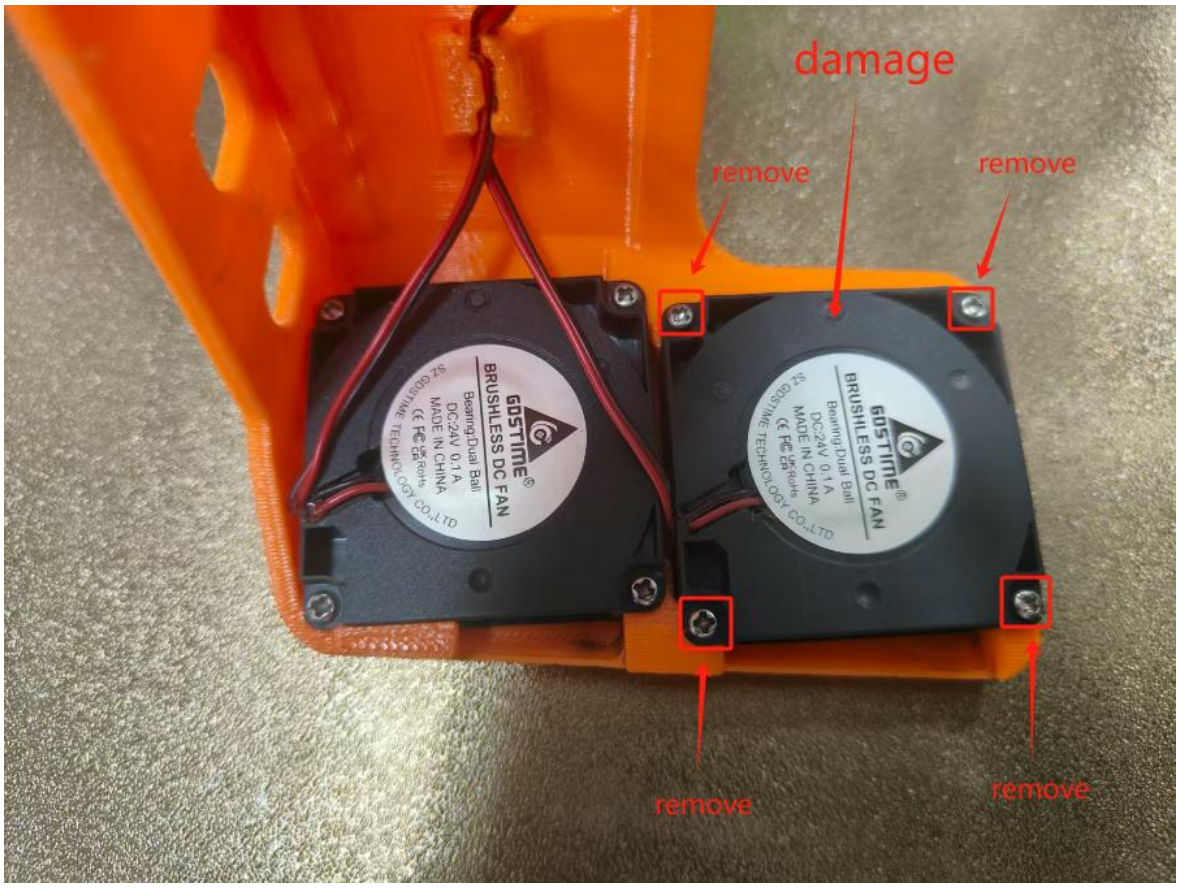
10.4 Fan Replacement

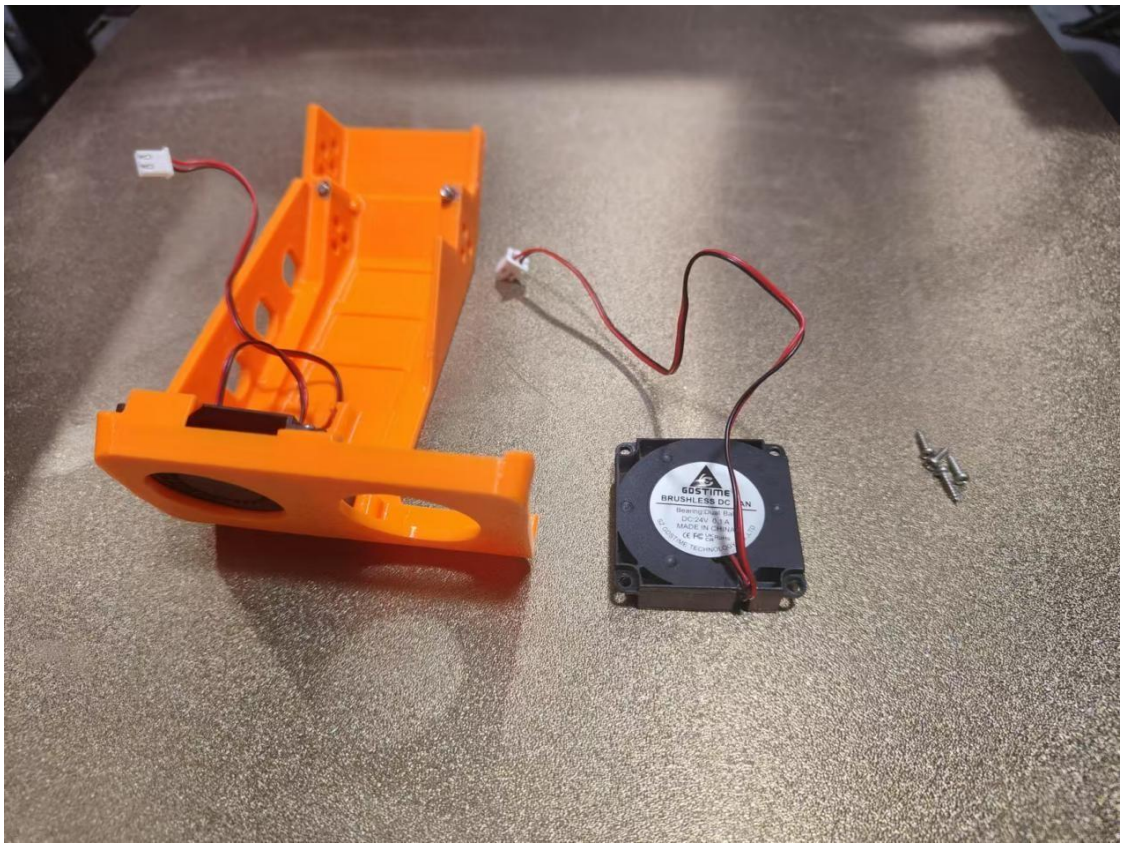
Replacement steps:

1. Loosen the 2 screws on the extruder bracket cover, slowly pull out the fan cable (caution: do not damage the cable or port) and take out the extruder bracket cover.

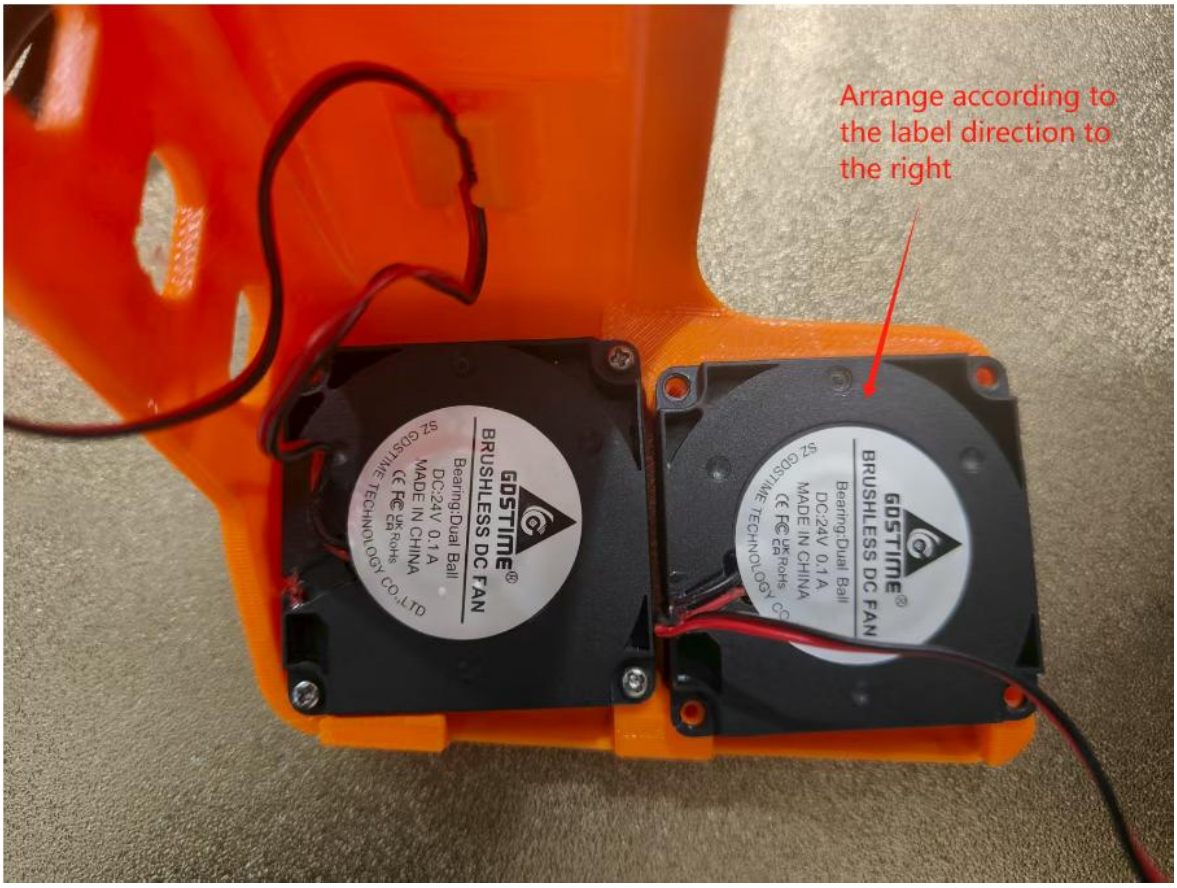


2. Remove the 4 screws that hold the fan in place and take the defective fan off.





3. Just put the new fan back in.



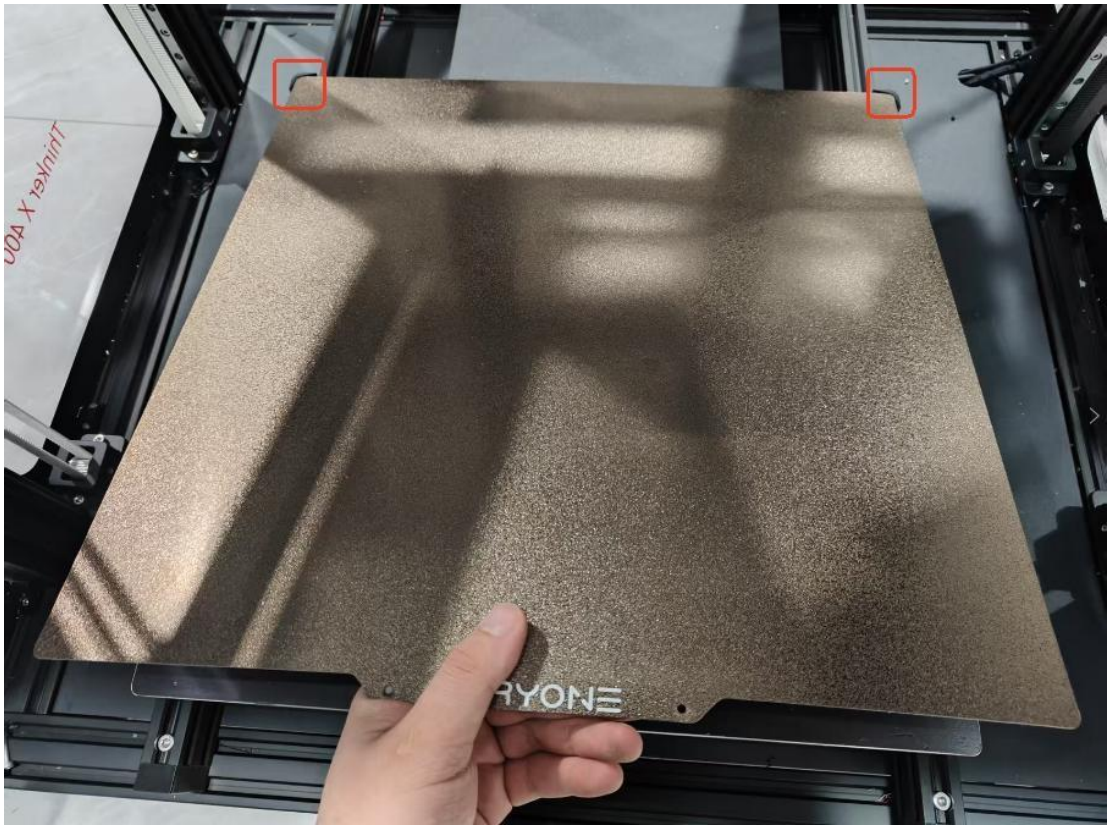
10.5 PEI Sheet Replacement

PEI metal plates are filaments and prolonged use can cause some of the PEI on the surface to lose adhesion, which can cause prints to fall off. This is the time to consider a new PEI sheet.Replacement steps.

1. Prepare a new PEI sheet.

2. Remove the old PEI sheet.

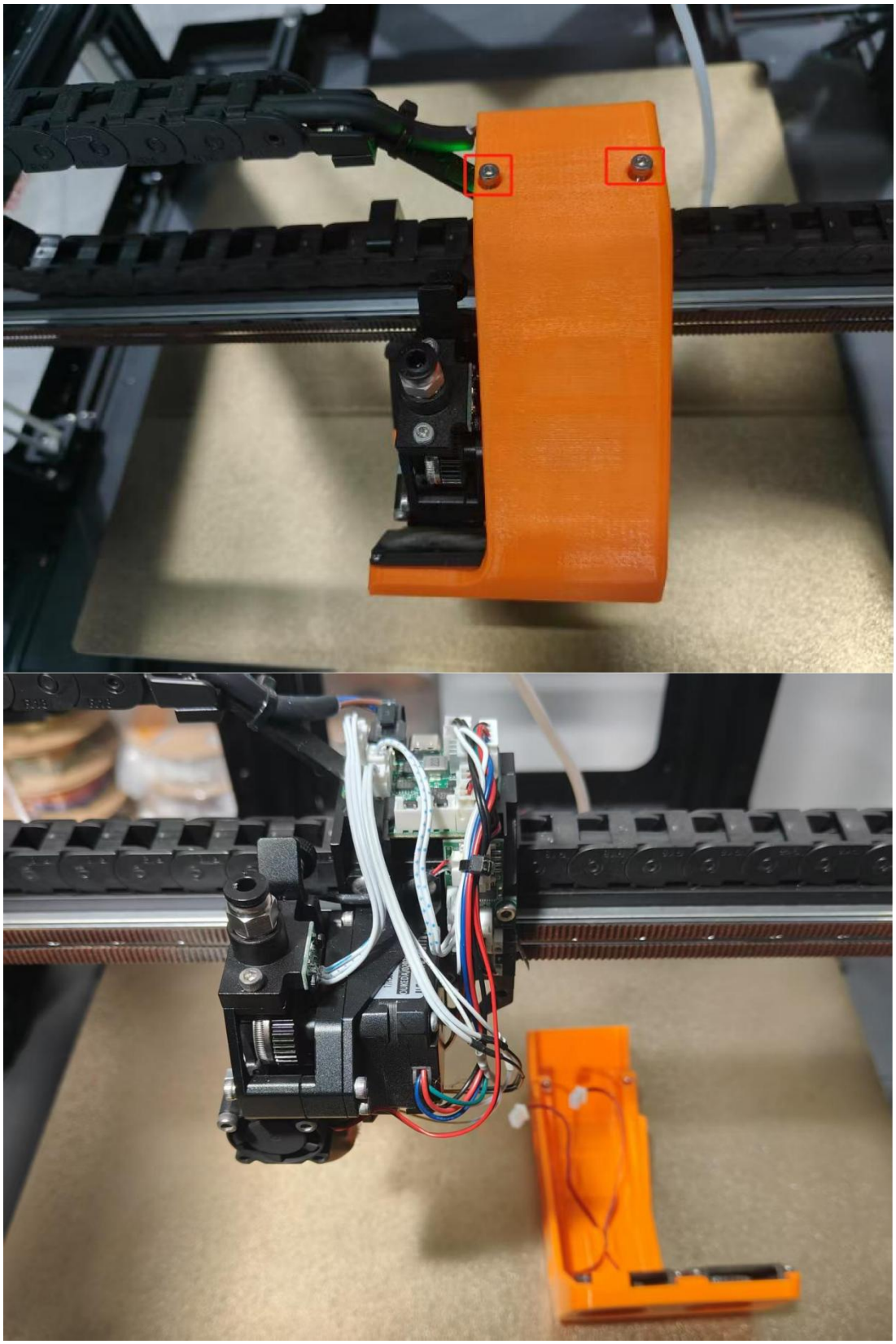
3. Push the new PEI sheet to the corners of the edge so that the two sides fit perfectly.



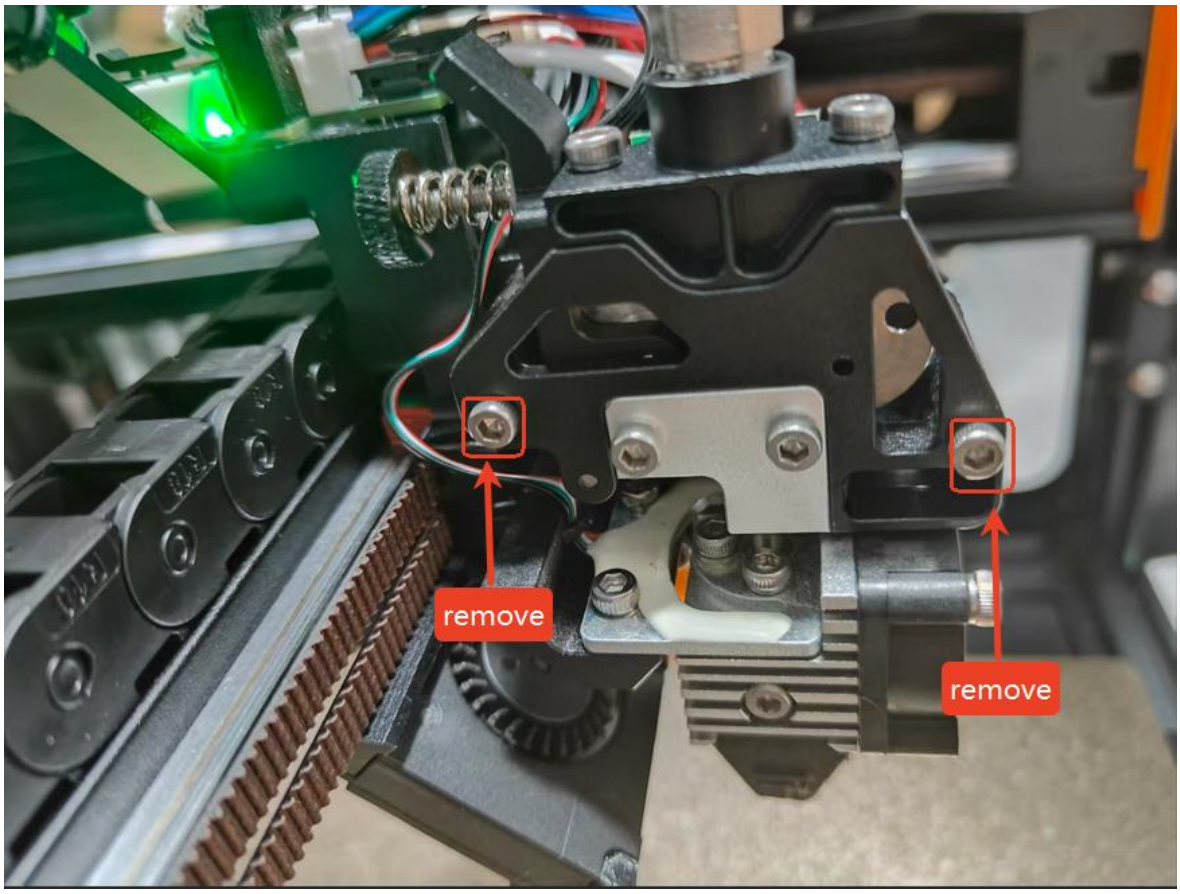
10.6 Replacement of motor

Removal steps.

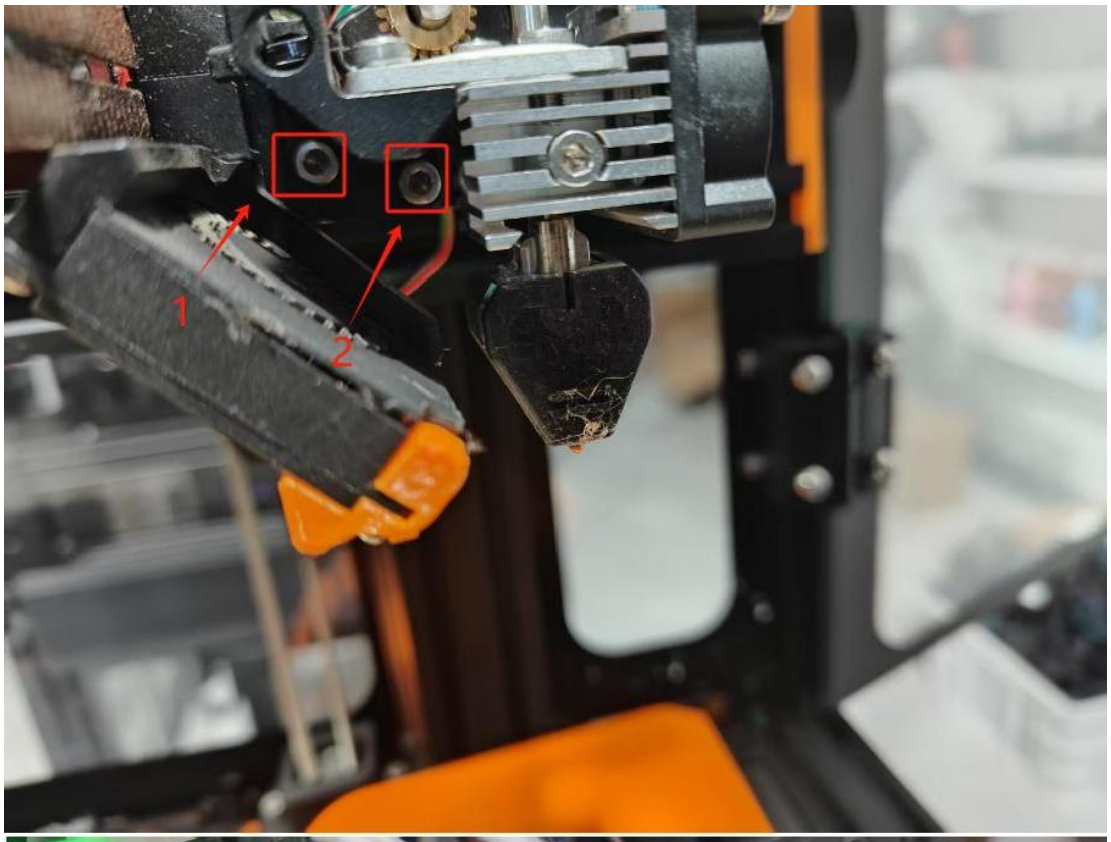
1. Remove the 2 screws on the extruder bracket cover and take away the extruder bracket cover.

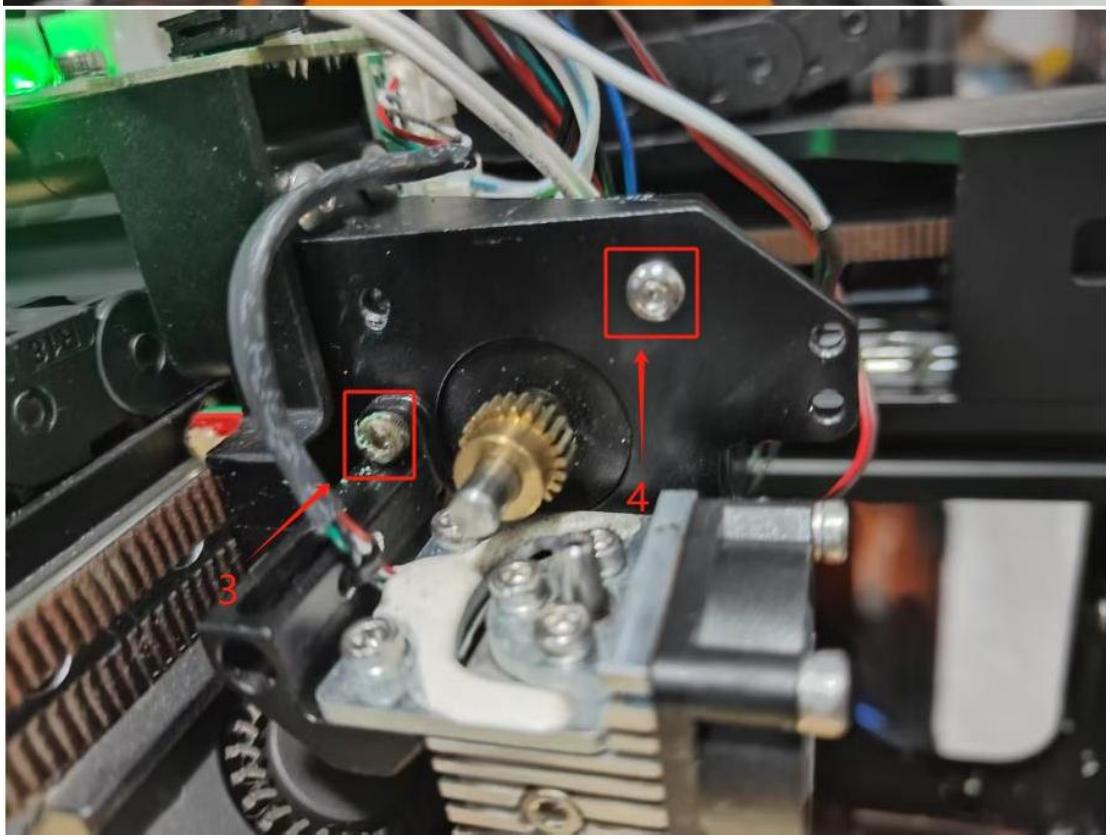


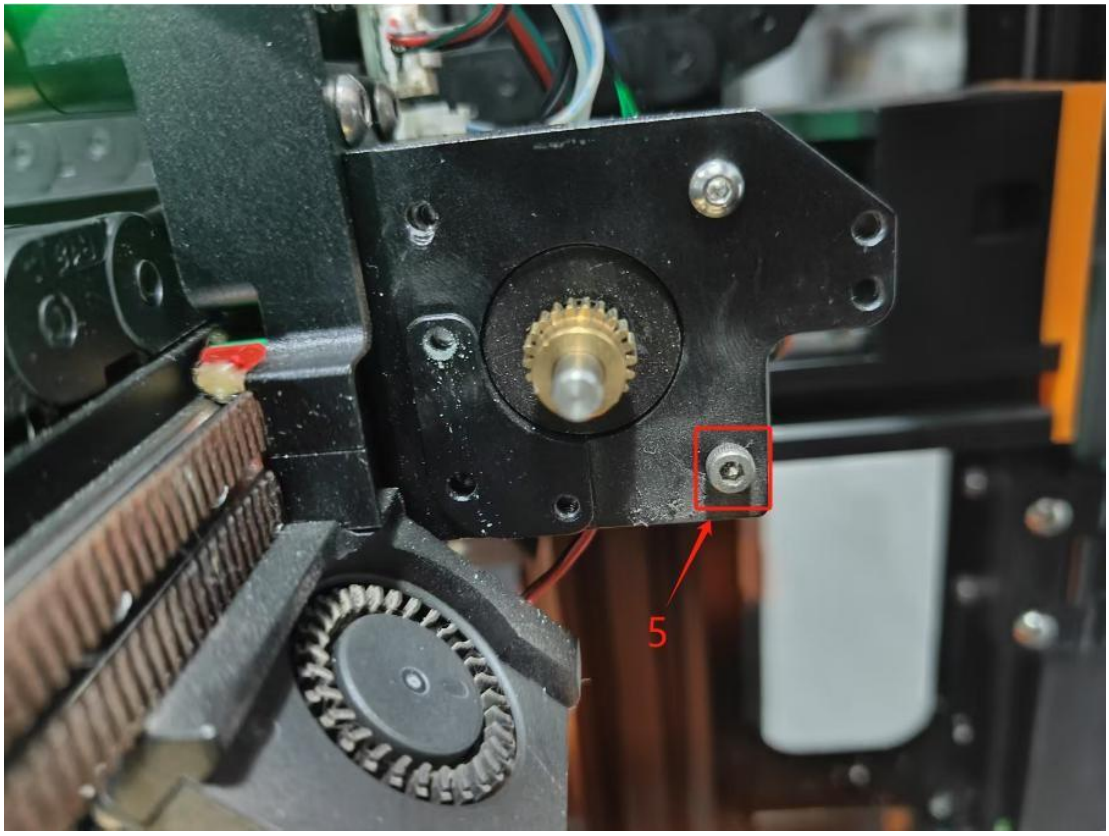
2. Remove the 2 screws on the extruder.



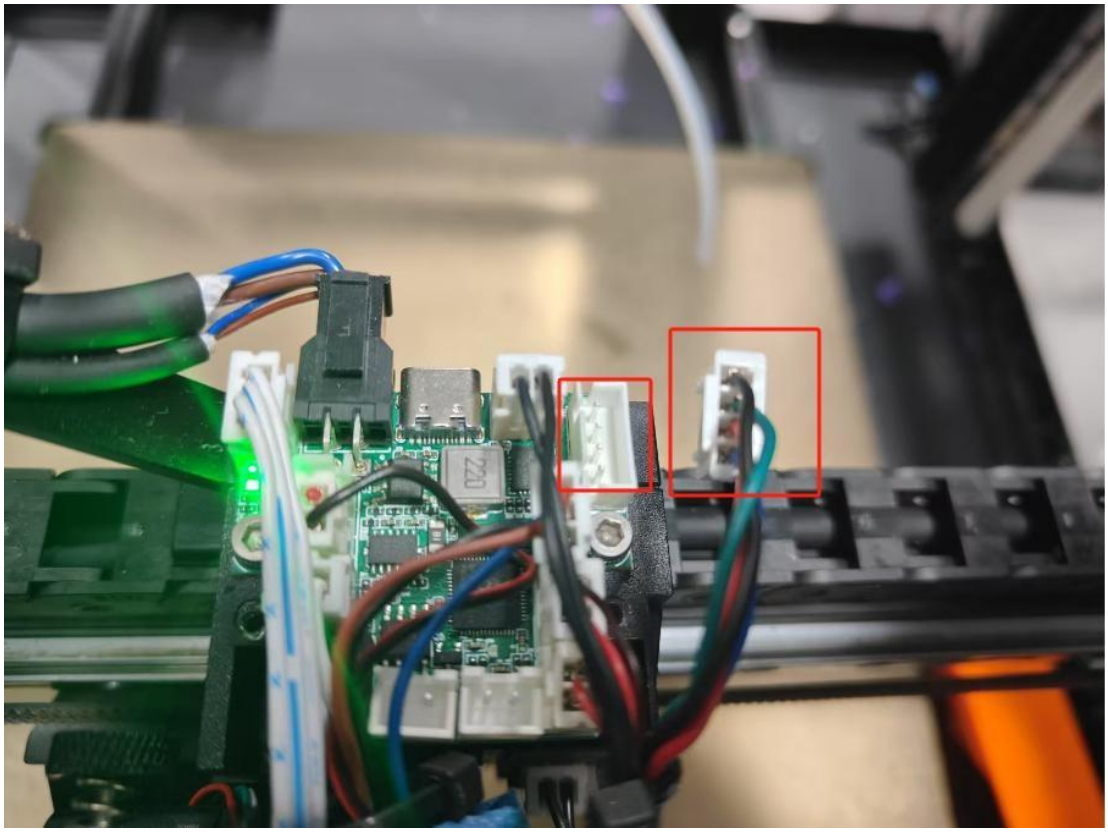
3. Remove the 5 screws that hold the motor in place.


1
2


3
4

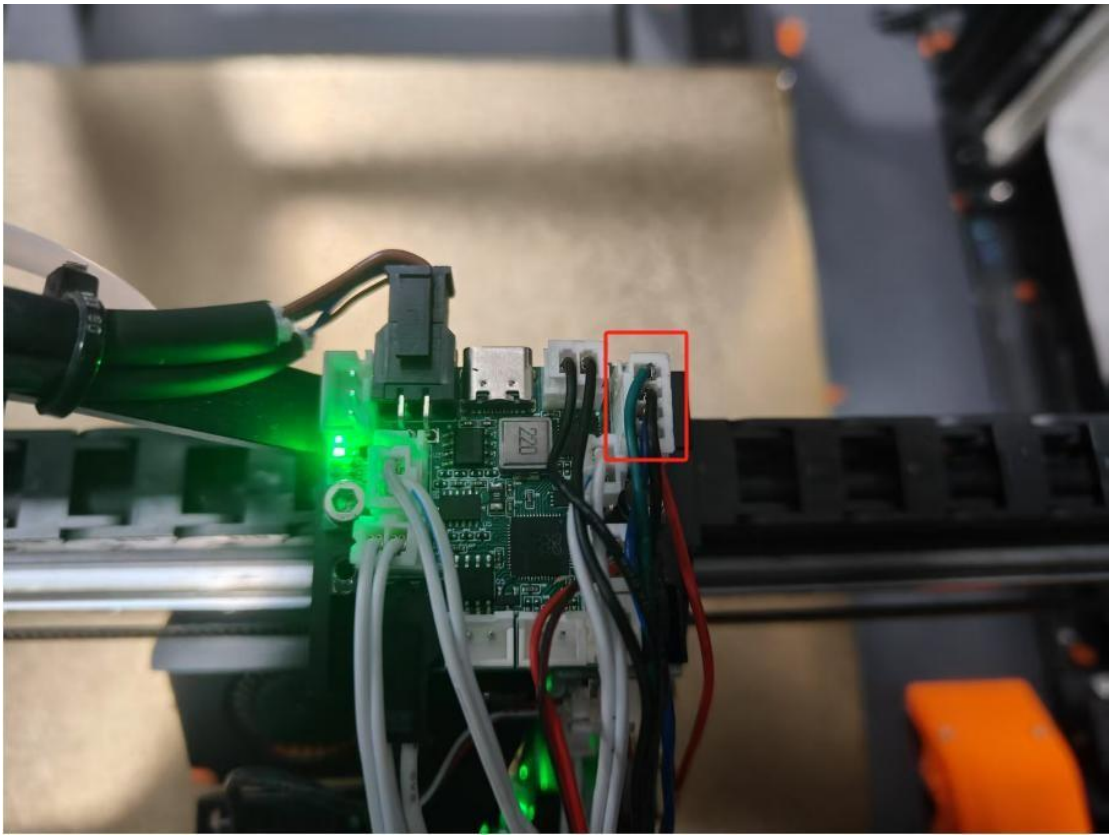


4. Unplug the motor wires from the terminals.

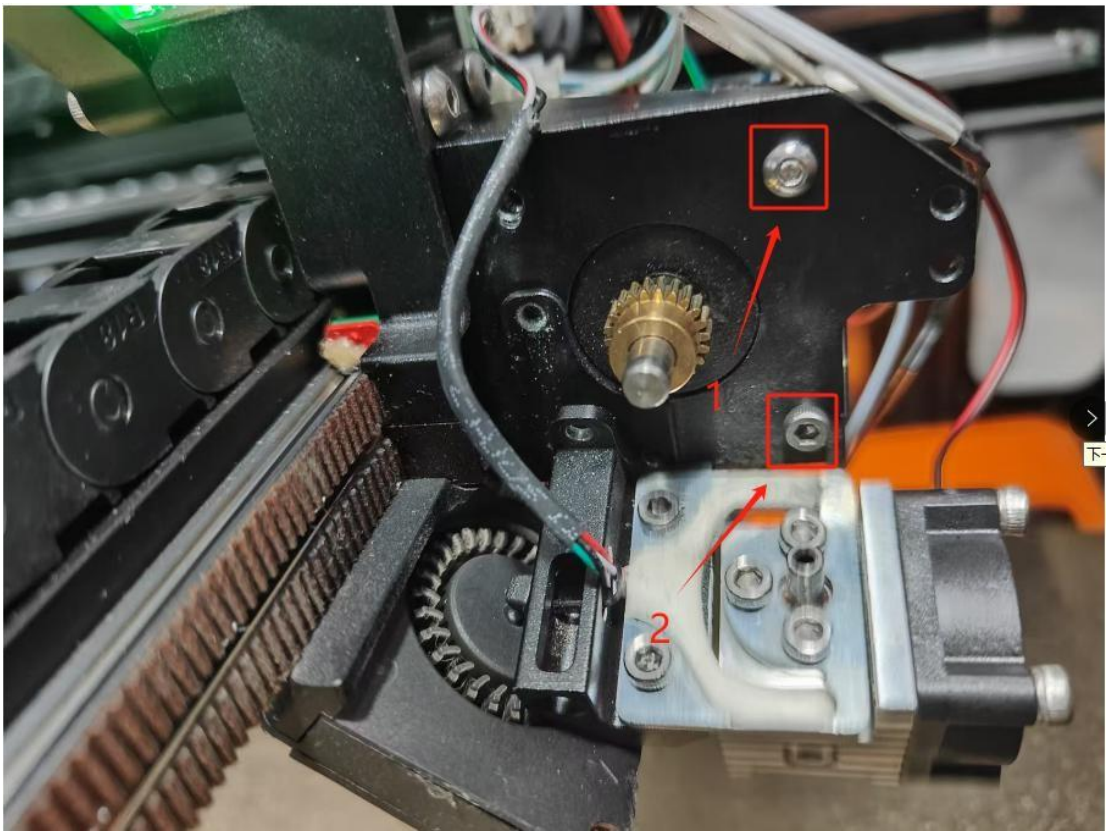


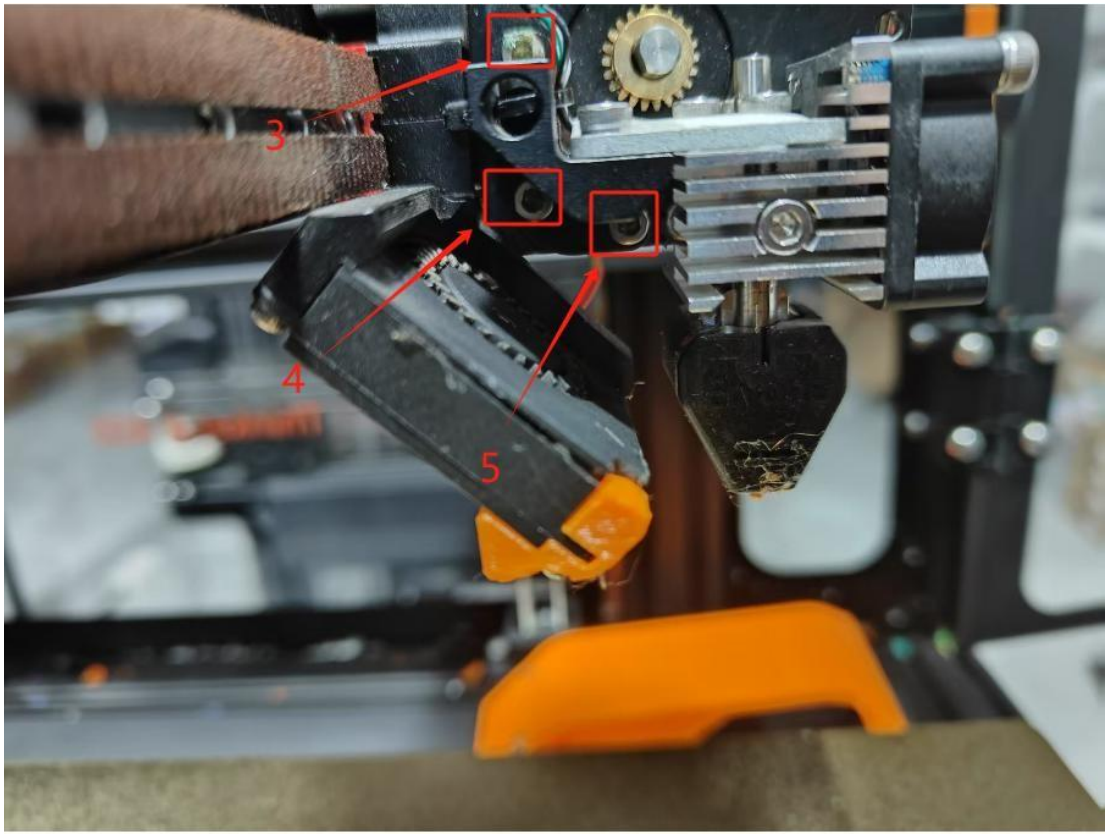
Assembly Steps:

1. Take out the new motor and plug the motor wires back into the terminals

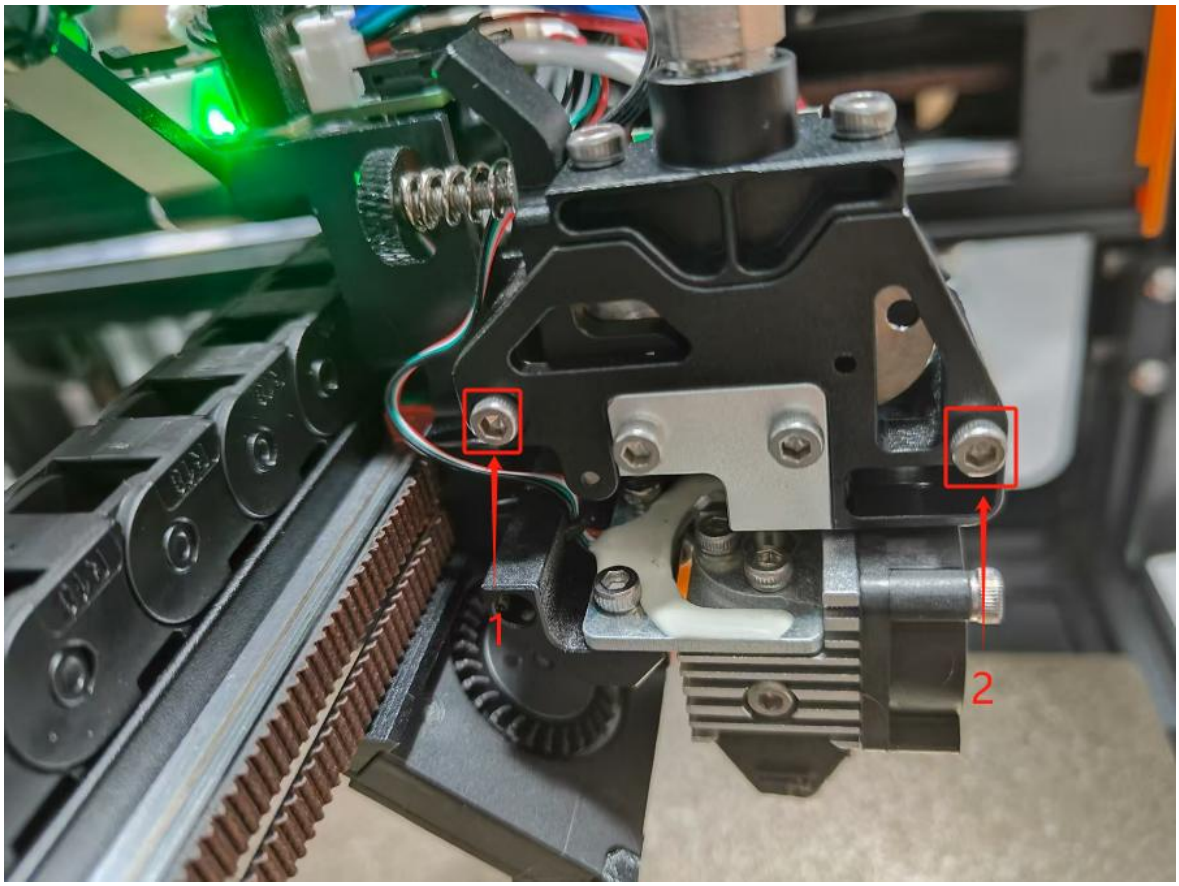


2. Put the motor through the hole and tighten the 5 screws that secure the motor.

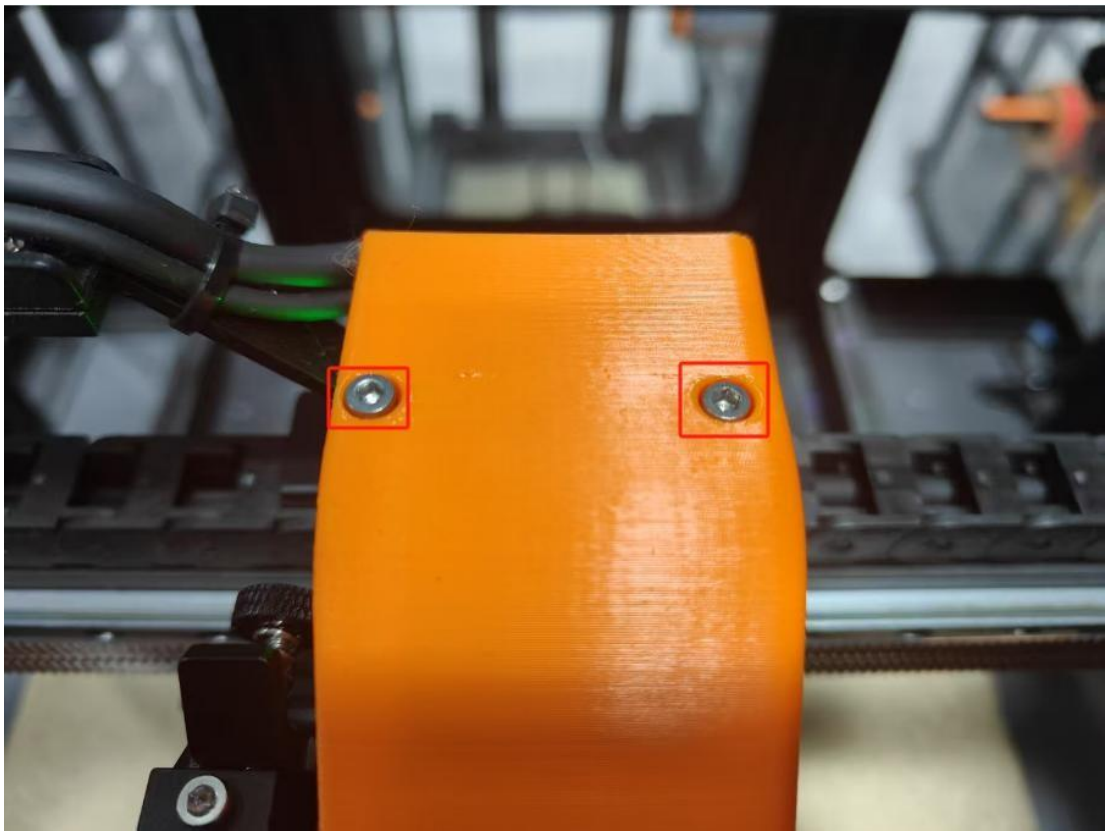




3. Tighten the 2 screws on the extruder.



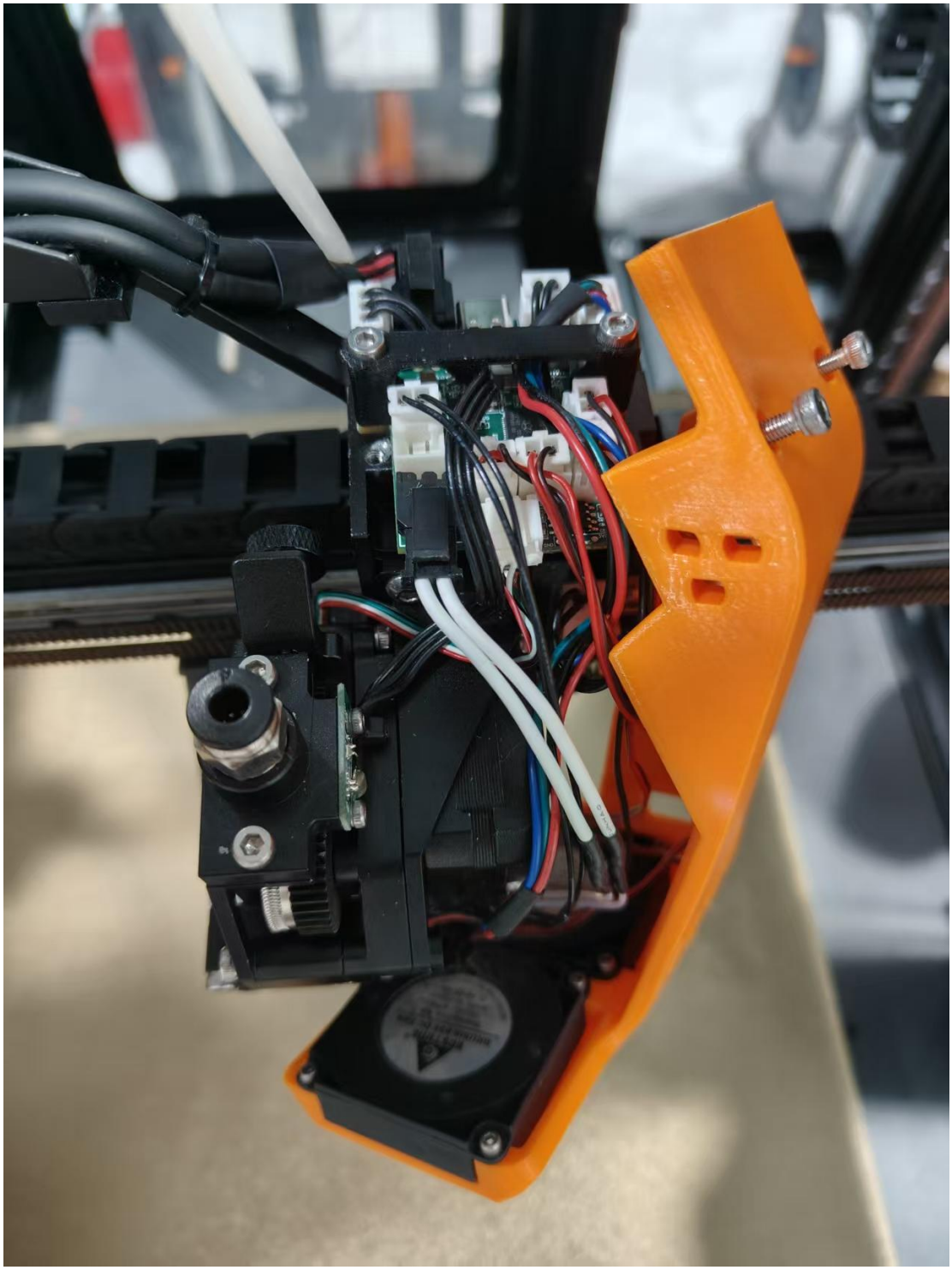
4. Replace the extruder bracket cover and tighten the 2 screws on the extruder bracket cover.

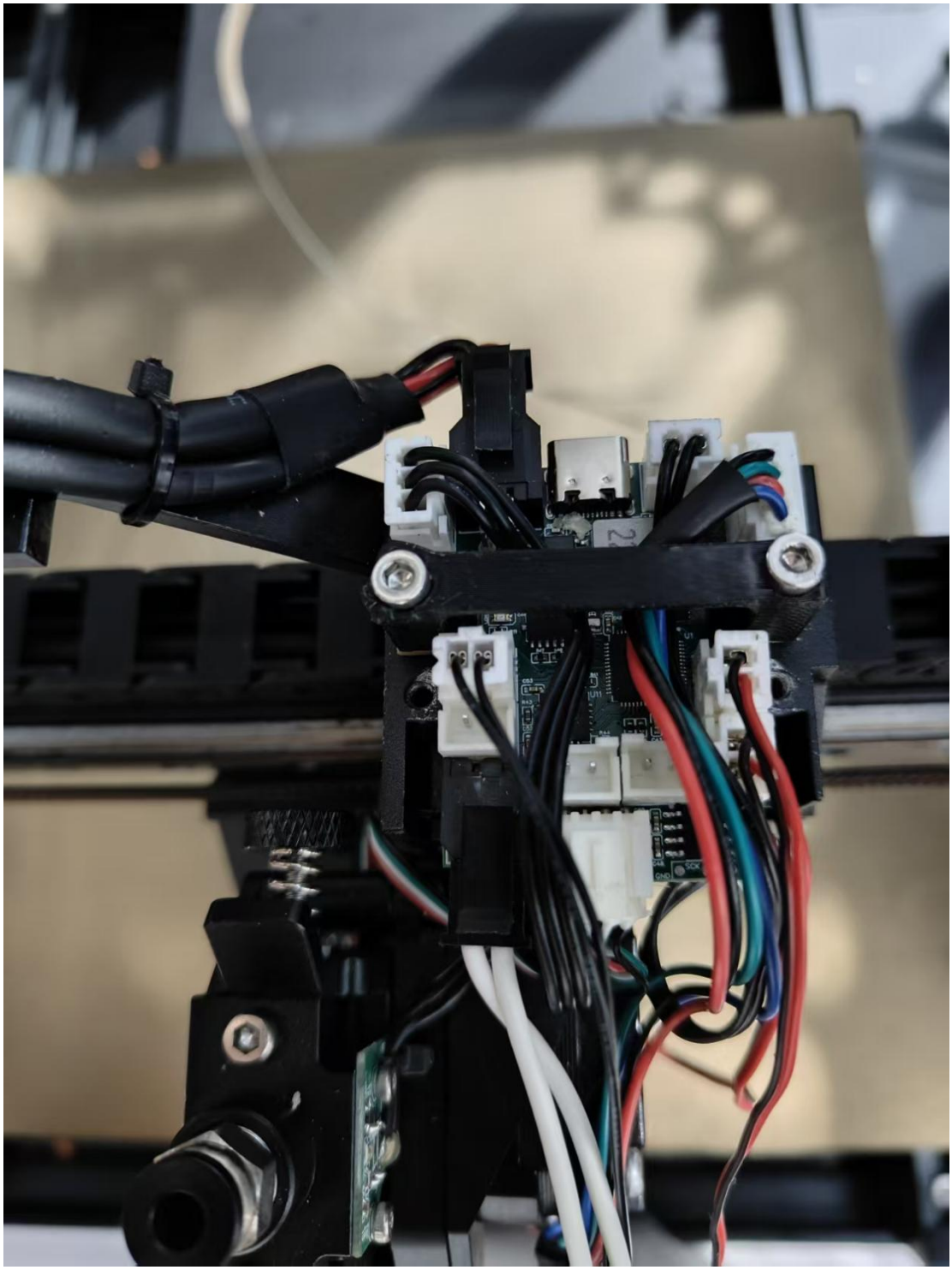


10.7 Replacing the hot end assembly

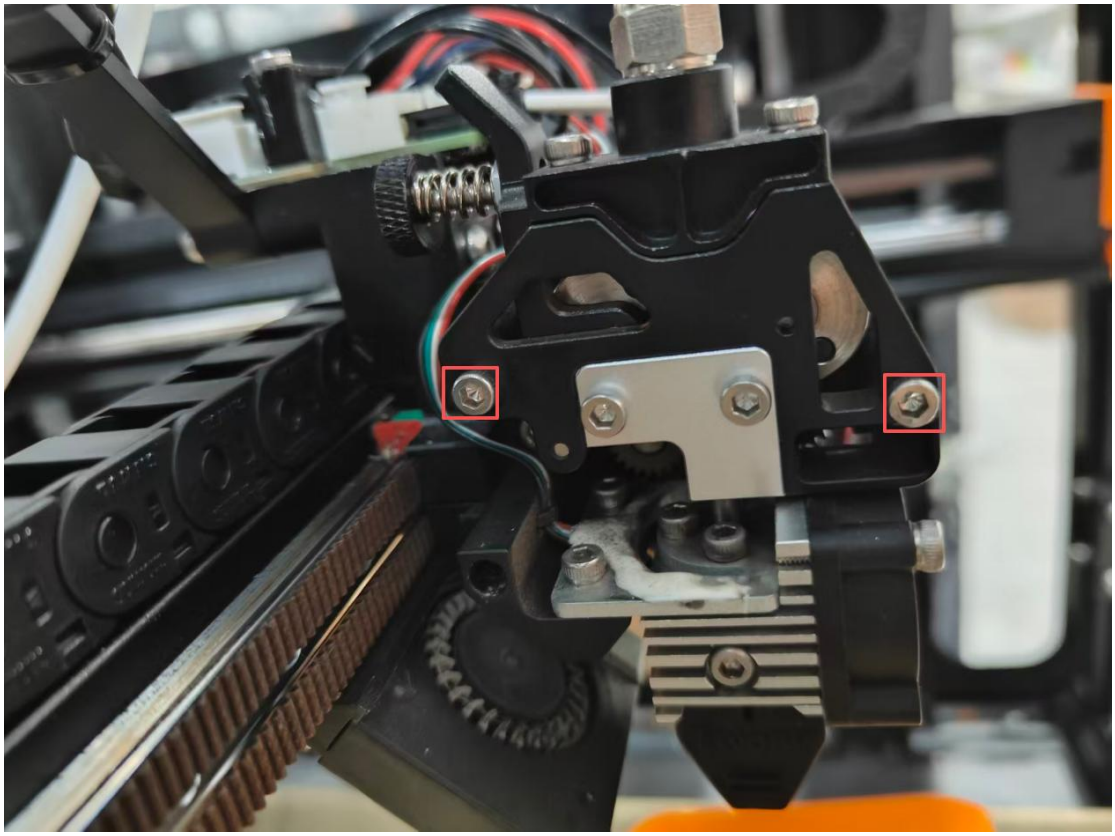
Installation steps：

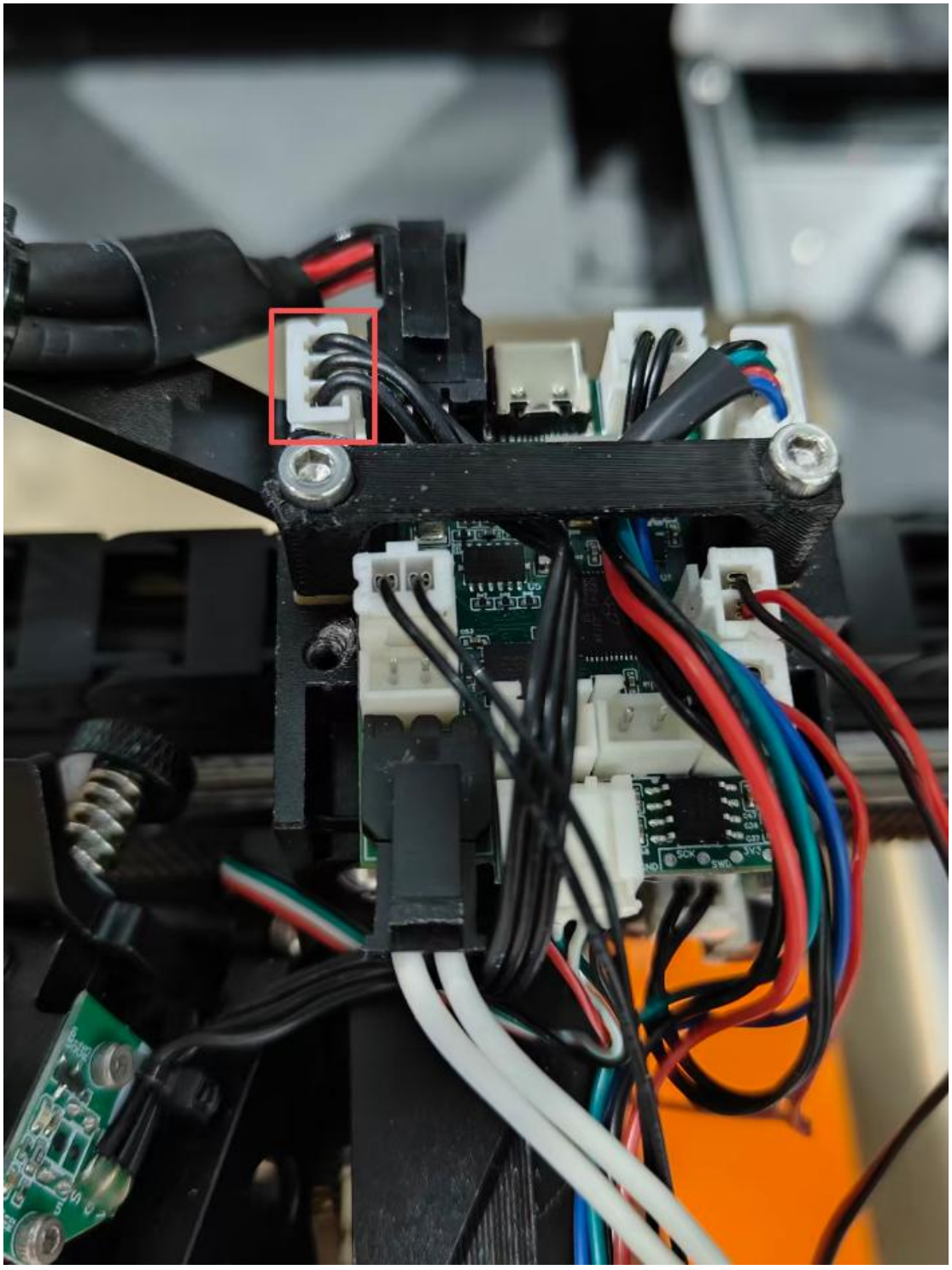
1.Remove the extruder support cover and fan cable terminal.



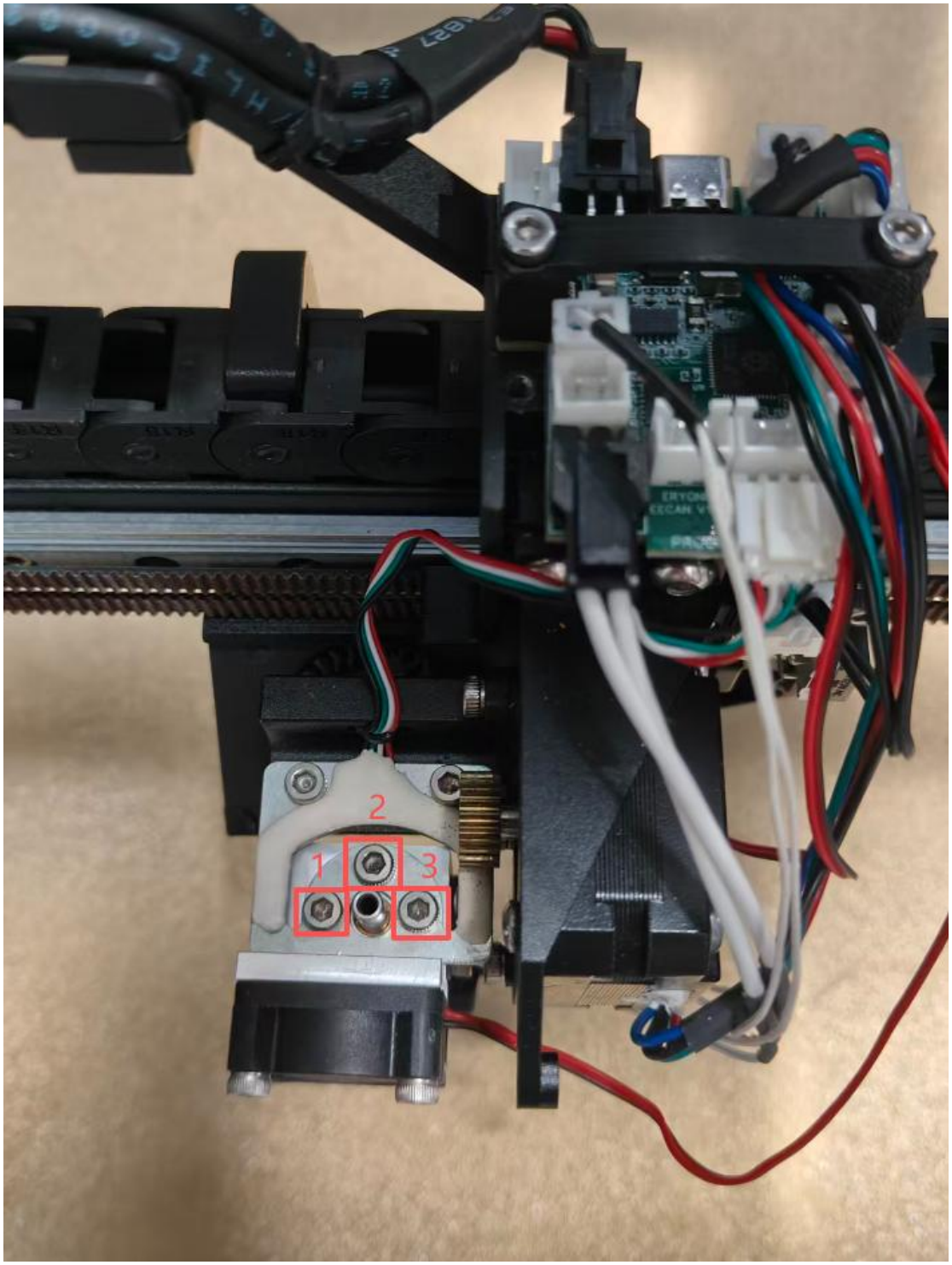


2.Remove the extruder wheel module and the filament runout sensor cable.

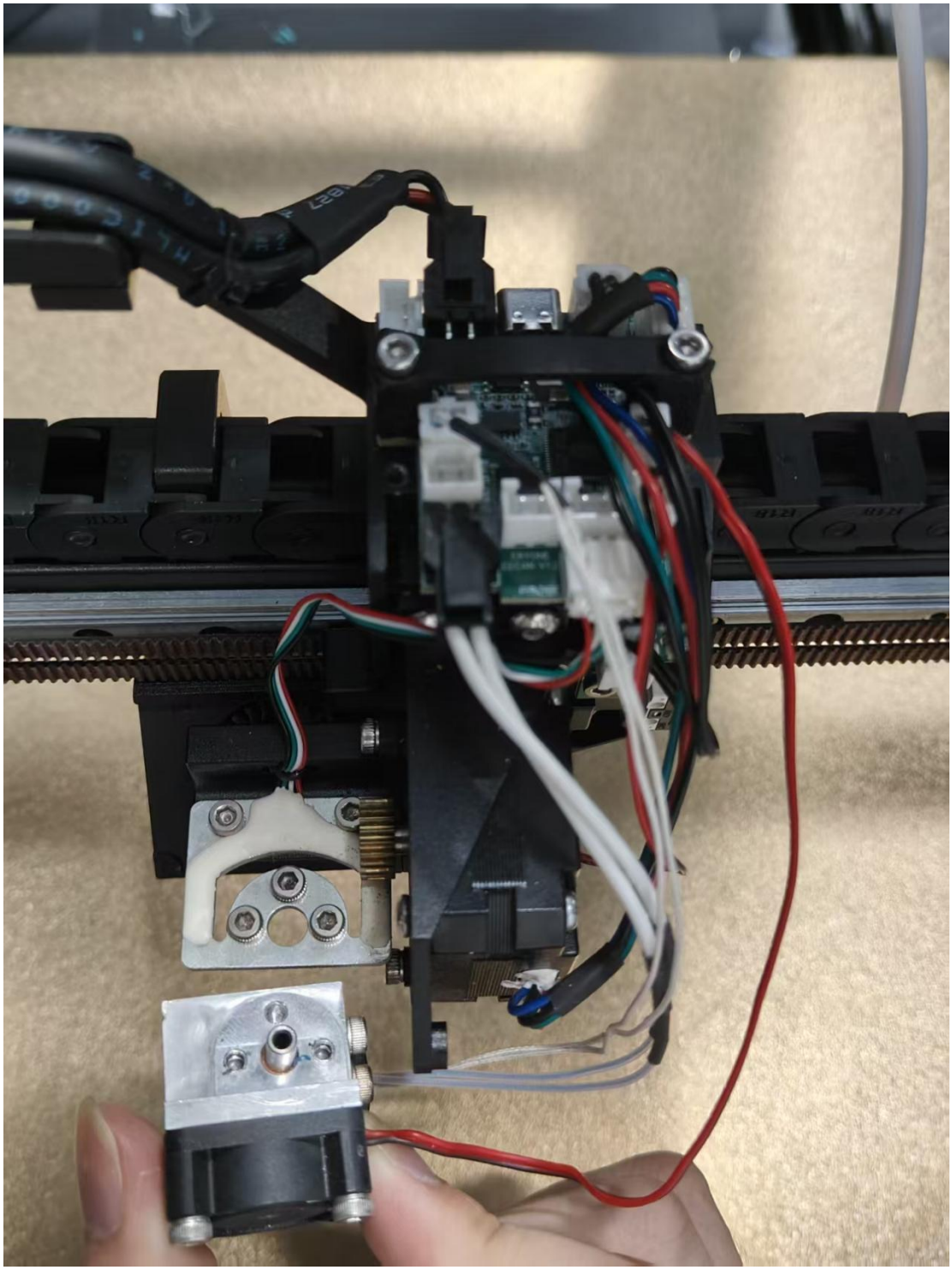


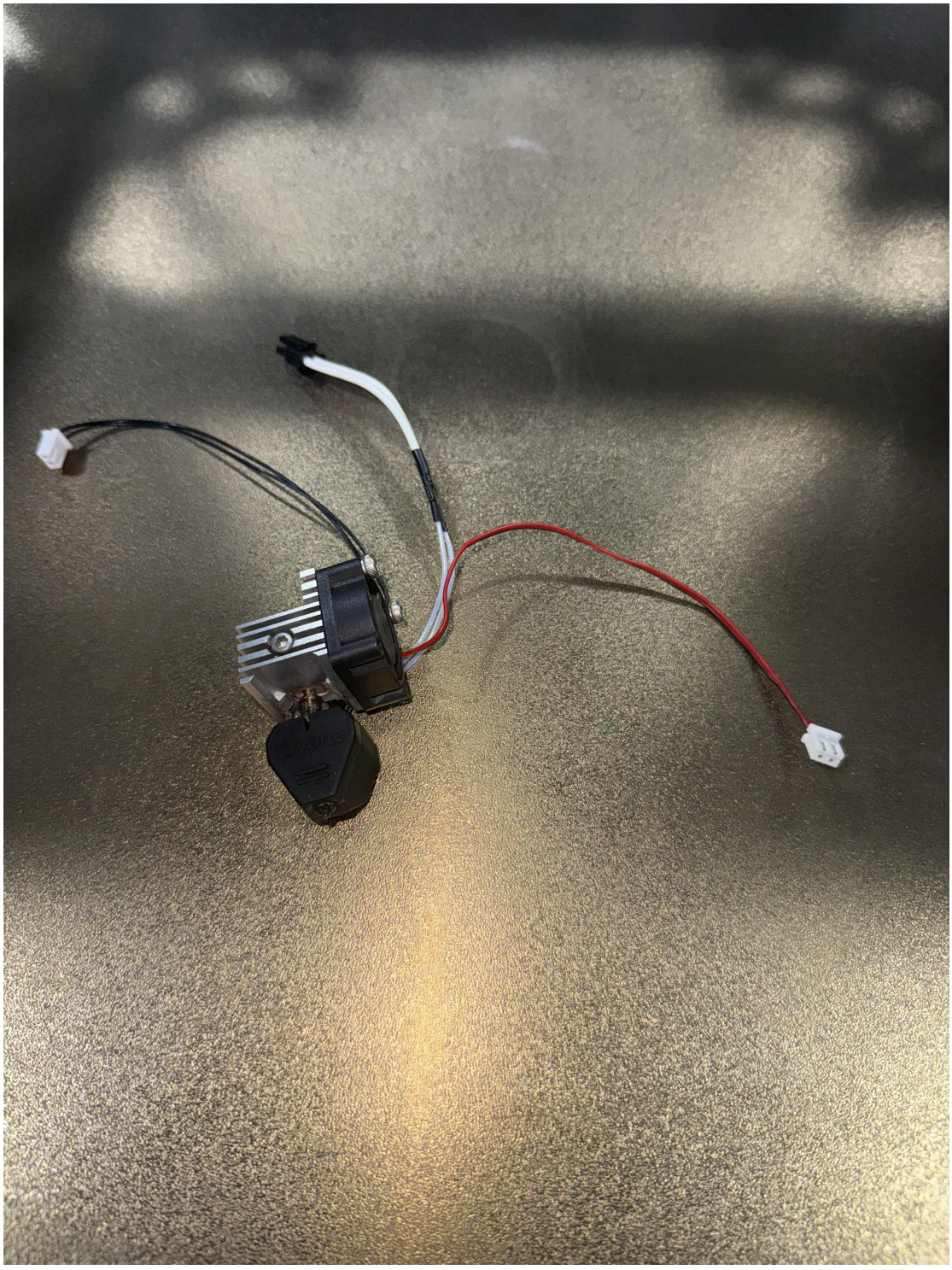


3.Remove the three screws securing the heat sink



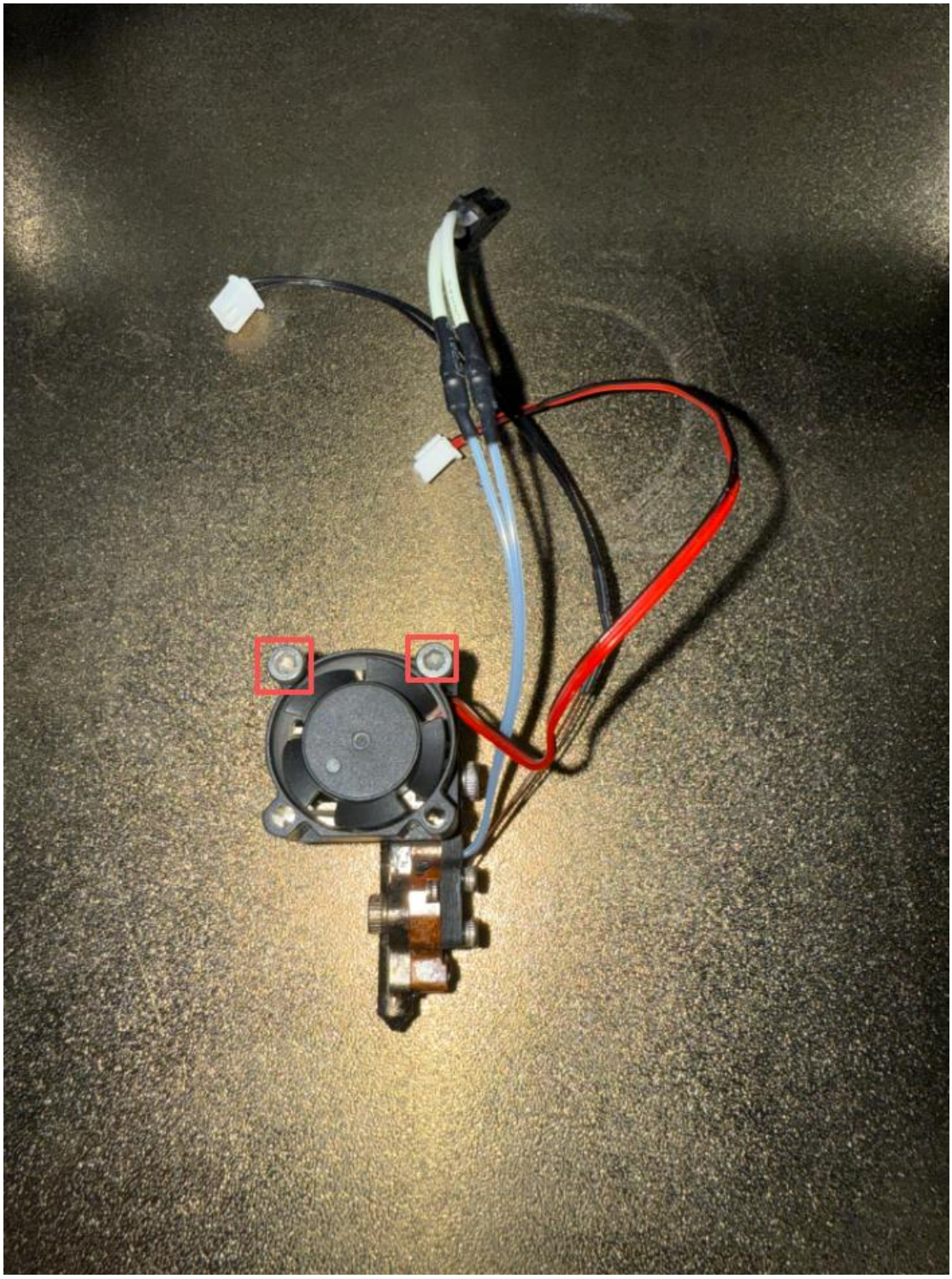
4.Disconnect the cables from the hot end.

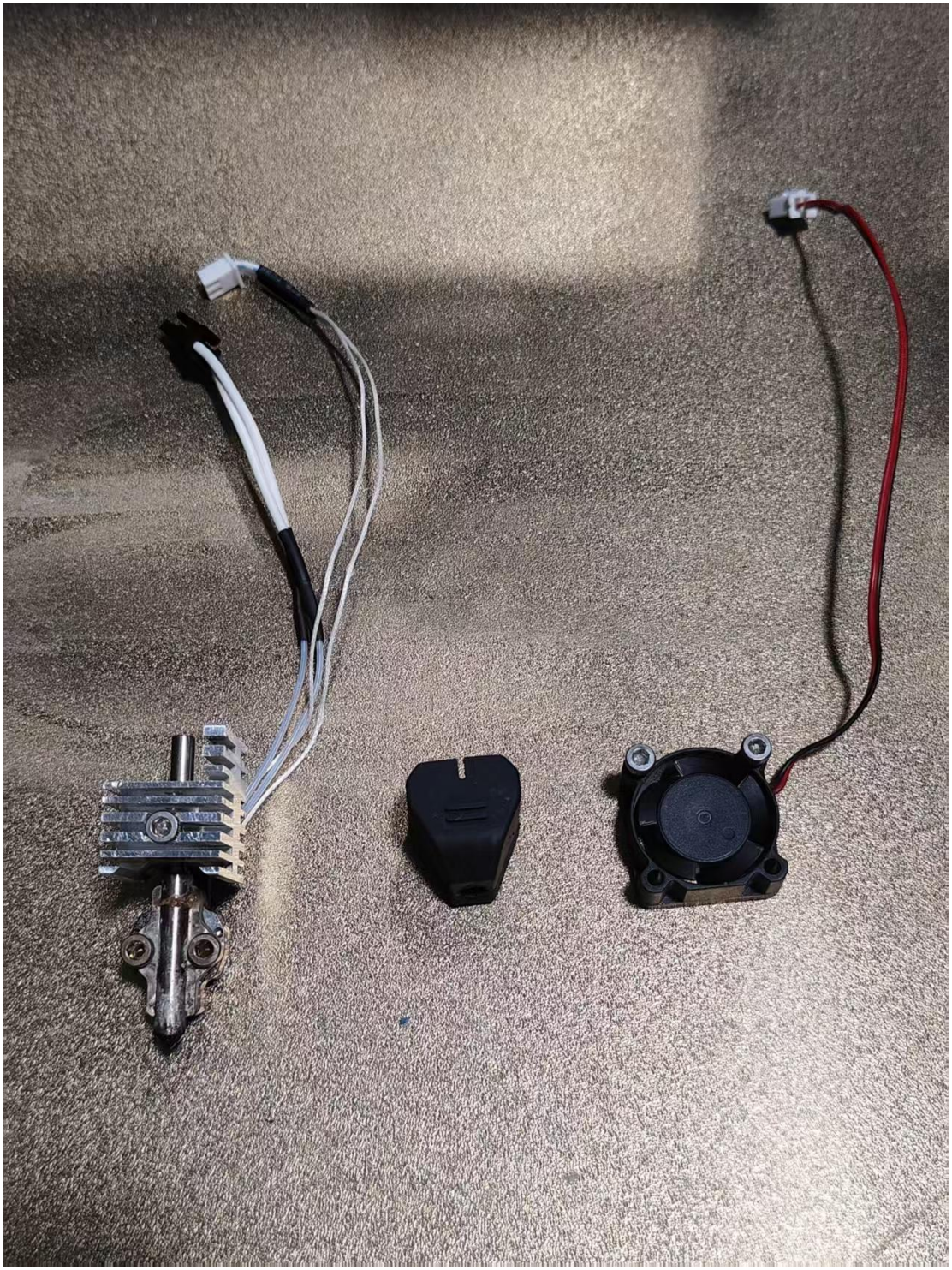




5.Remove the silicone sleeve.

6.Remove the heatsink fan.



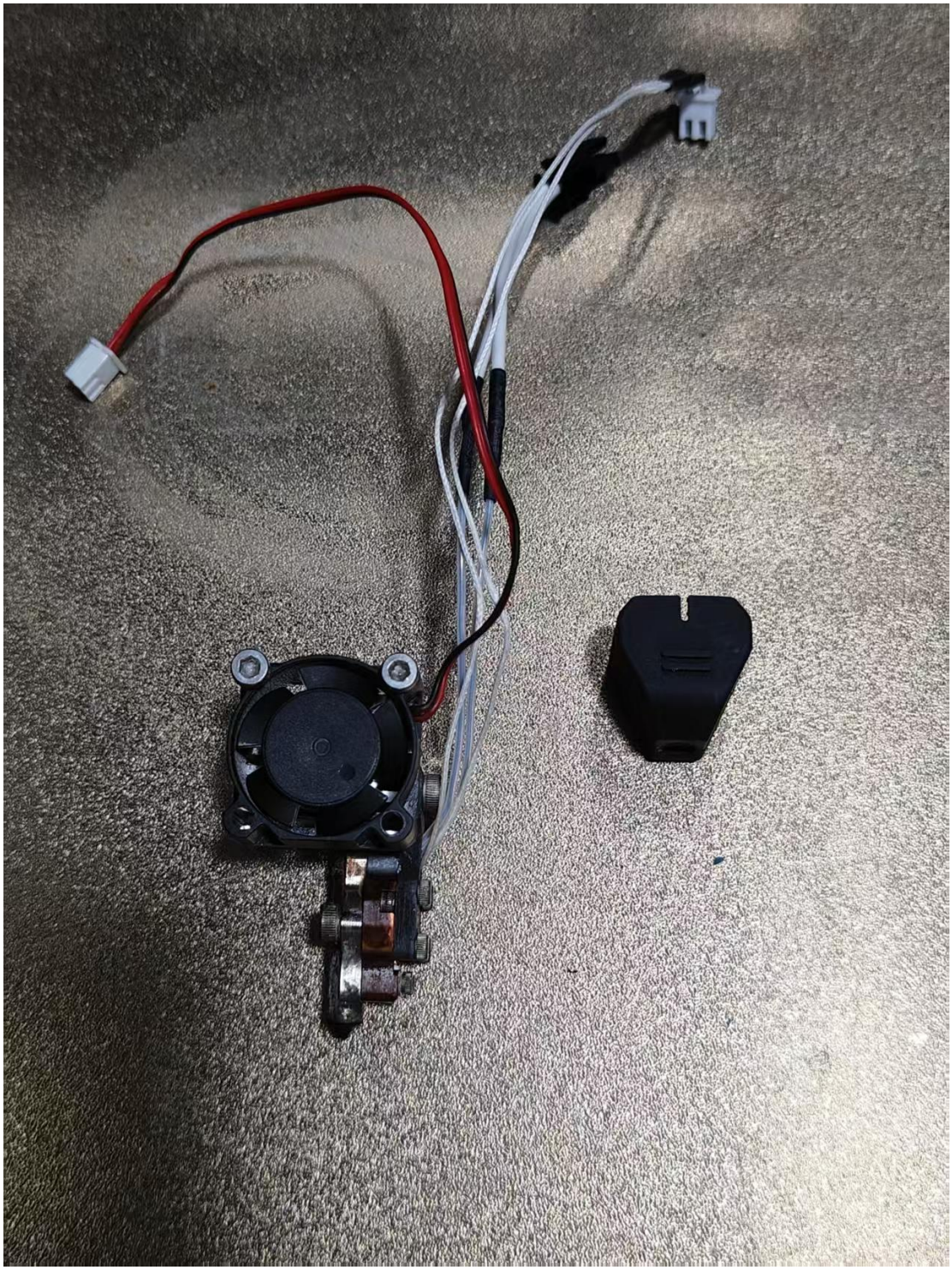


7.Remove the nozzle.

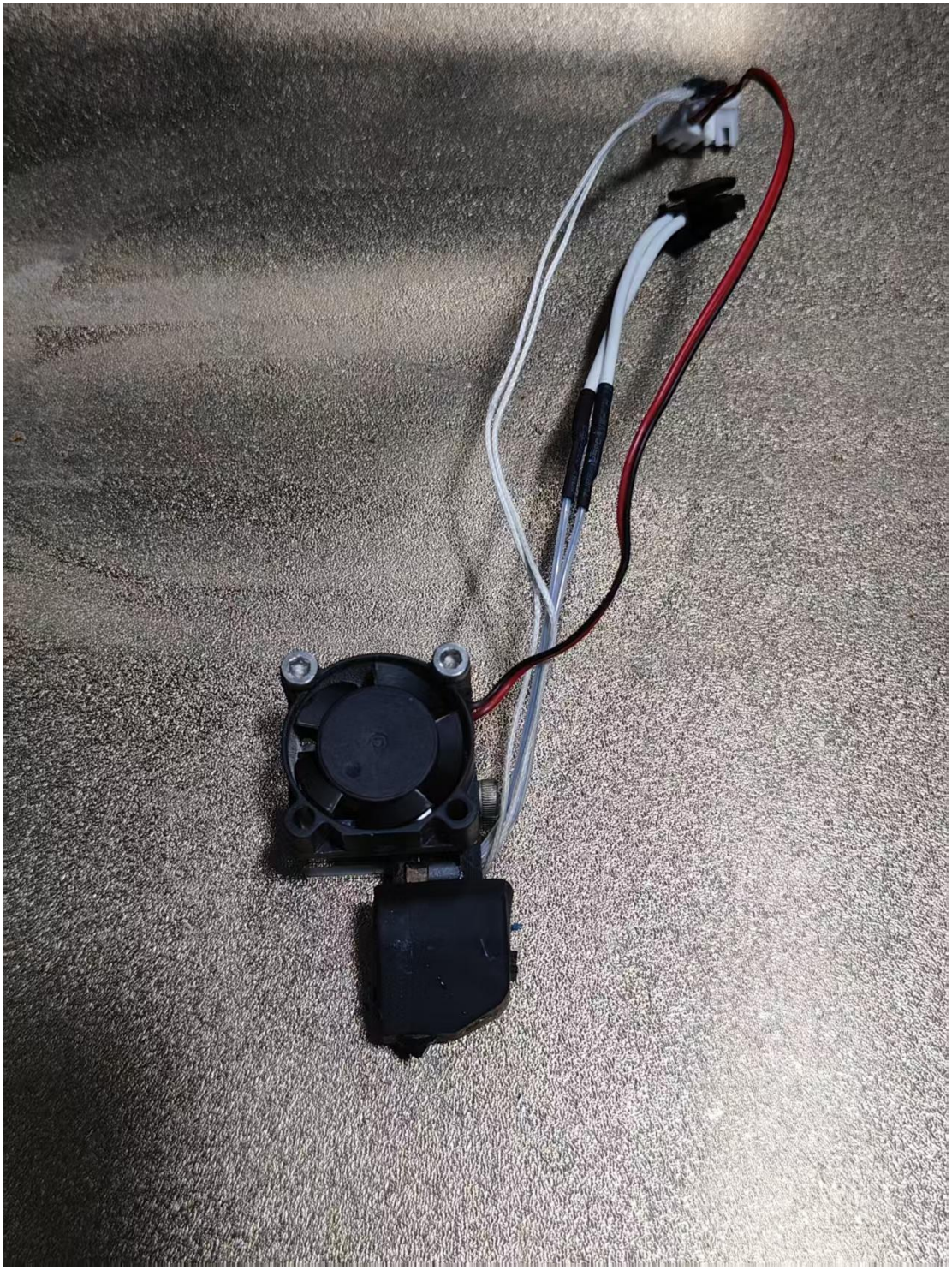
8.Take out the new extruder heating module.

9.Install the nozzle.

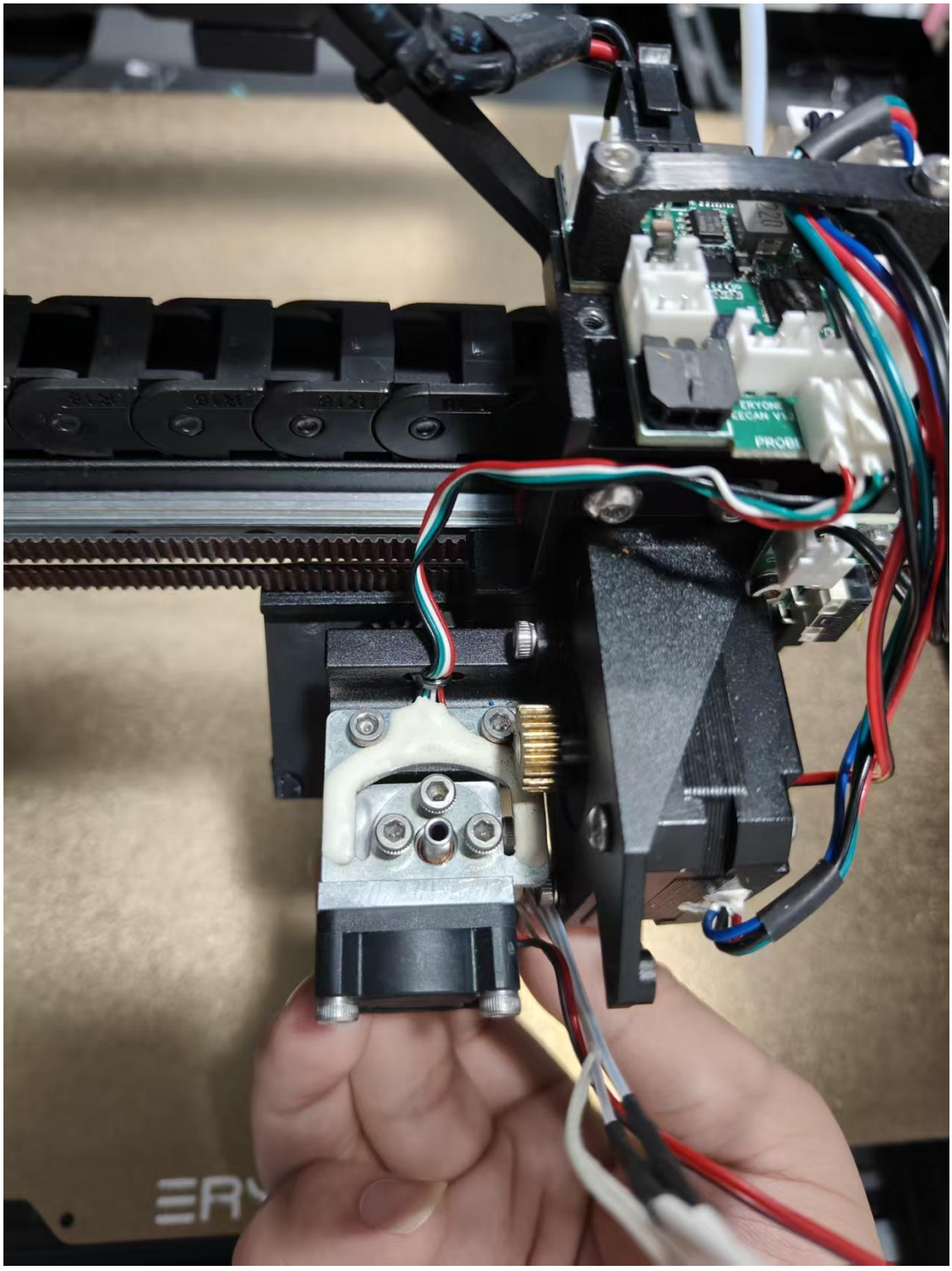
10.Install the heatsink fan.



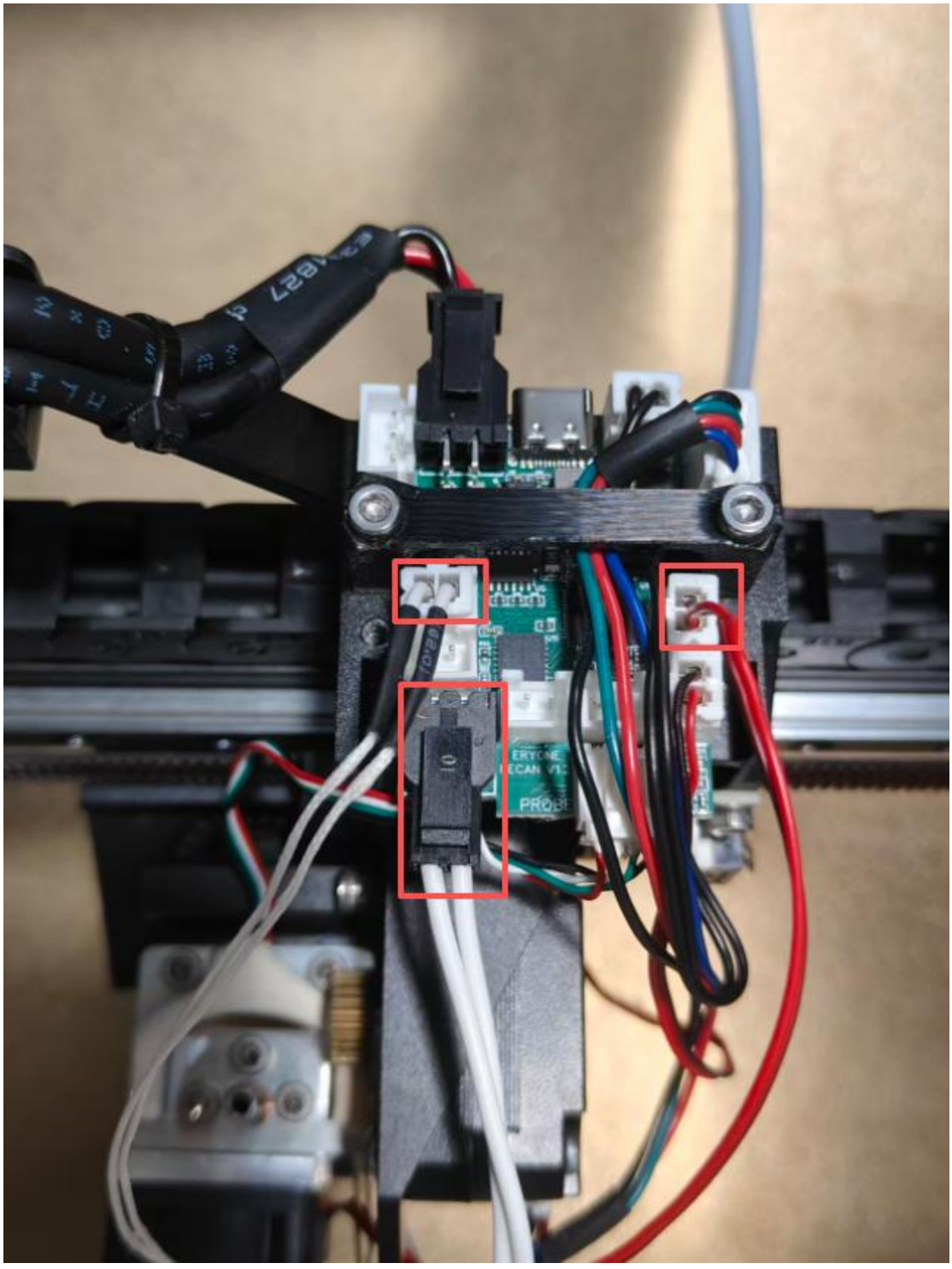
11.Install the silicone sleeve.



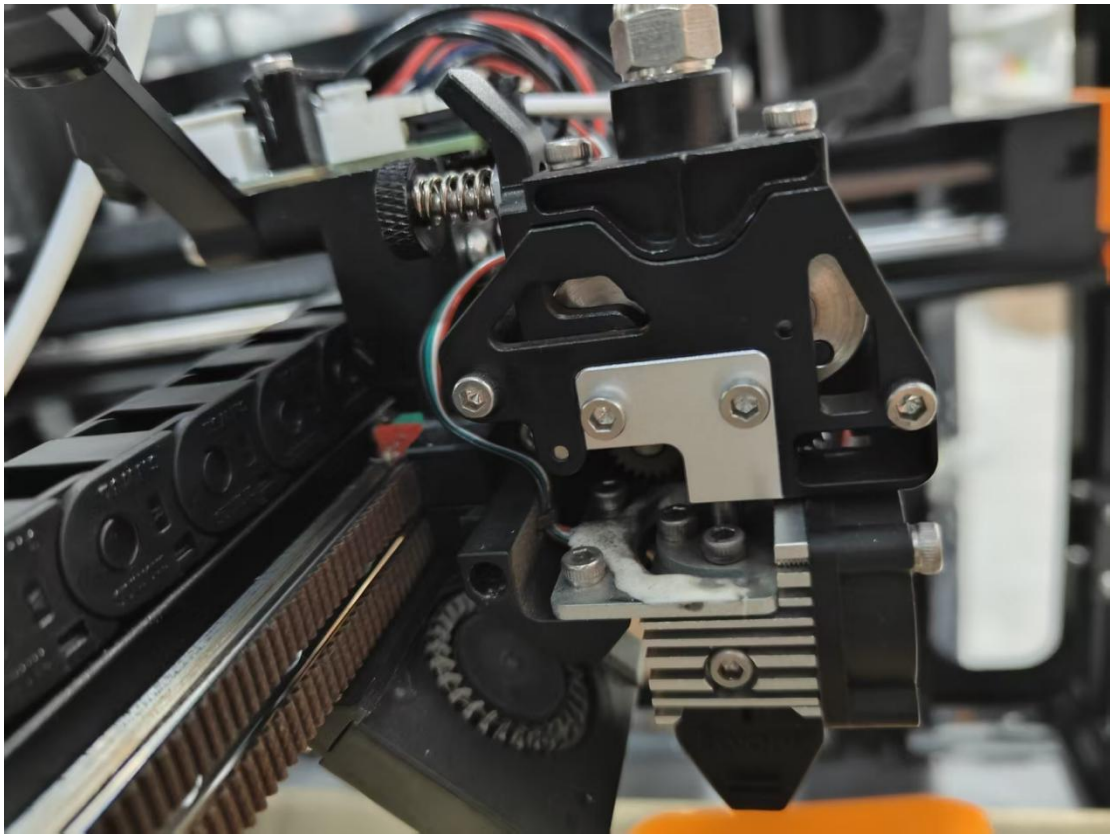
12.Reinstall the entire hot end assembly.

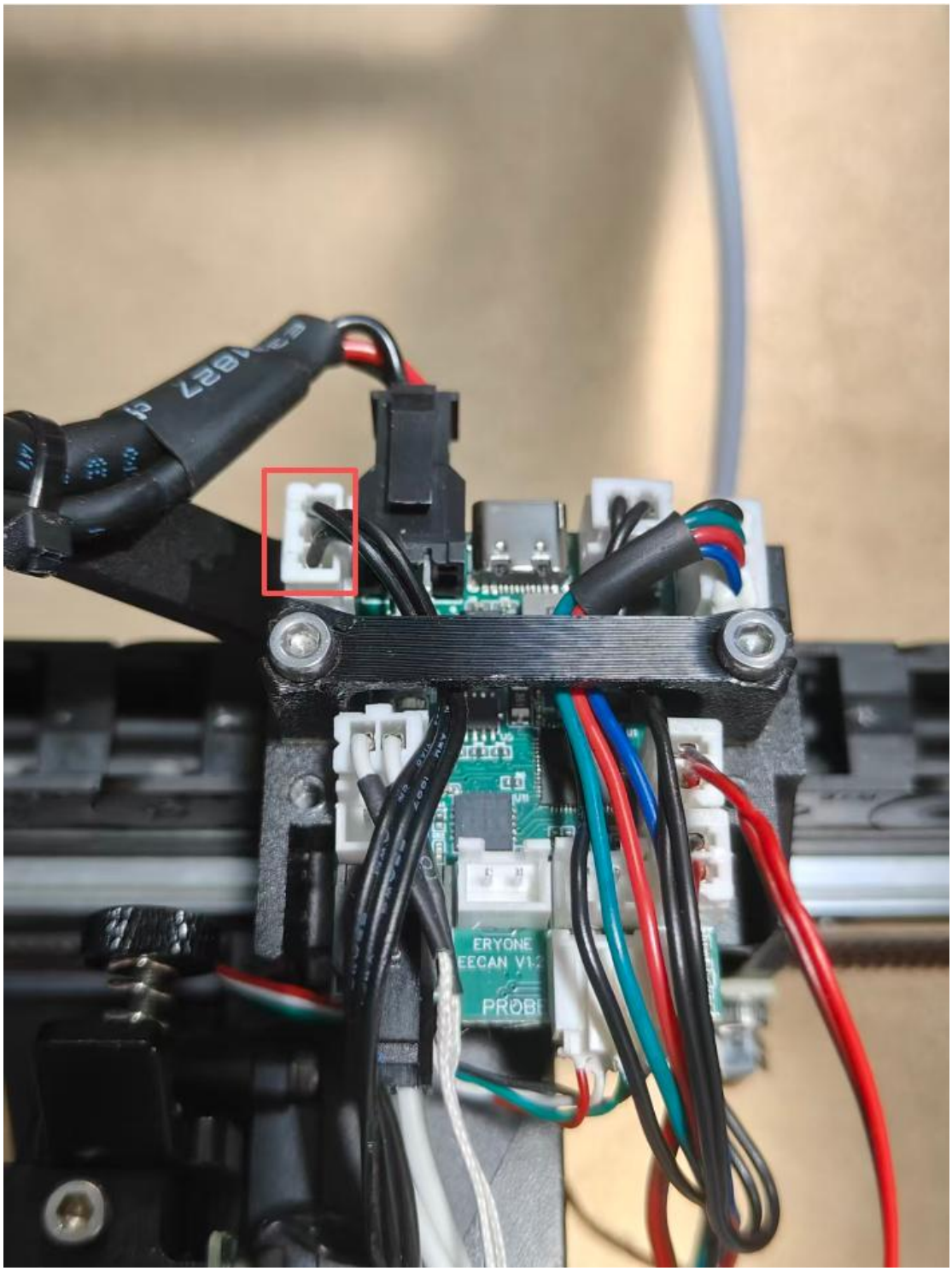


13.Plug the hot end cables back into the Canbus board.

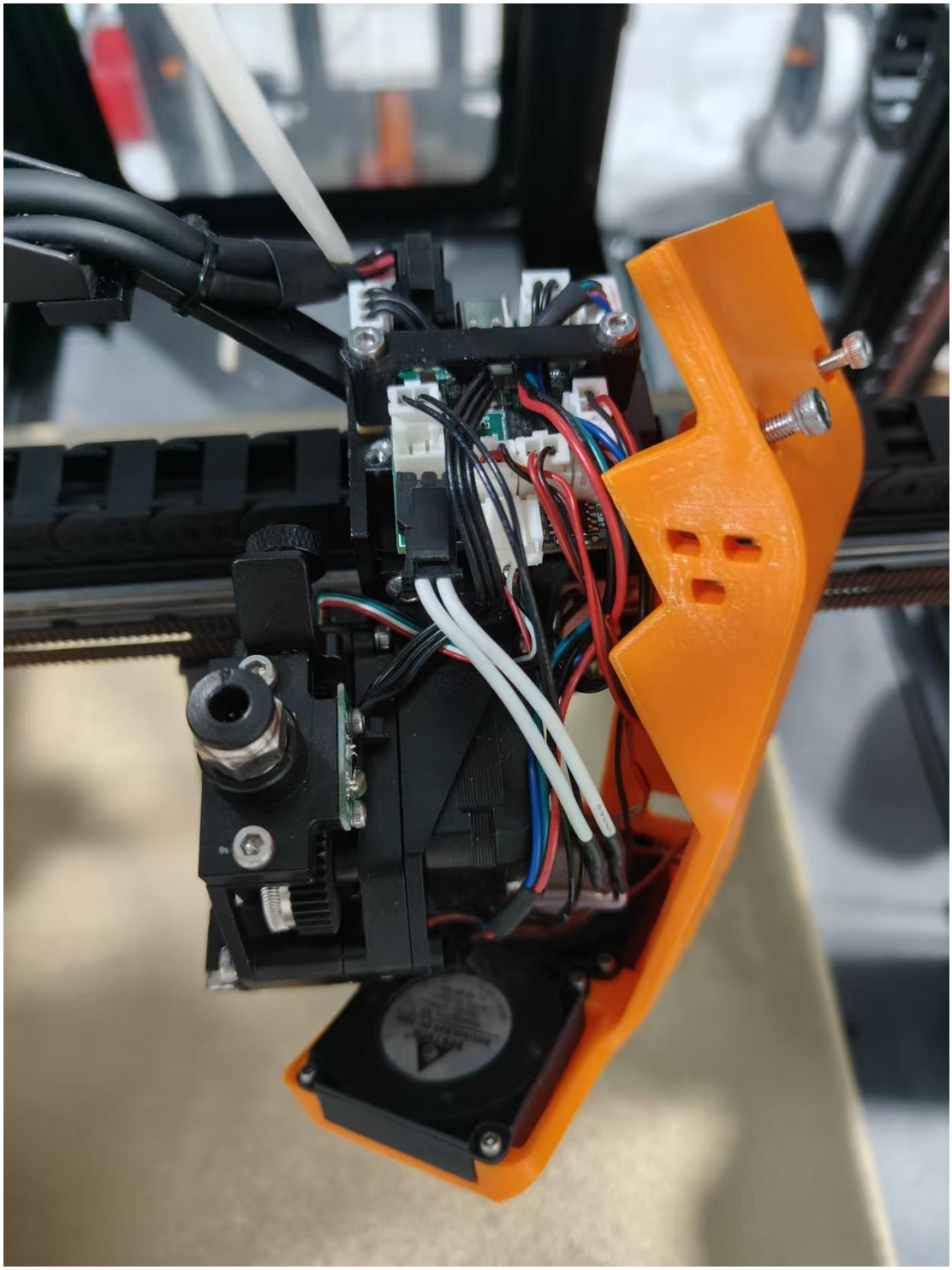


14.Reinstall the extruder wheel module and plug the cables back in.

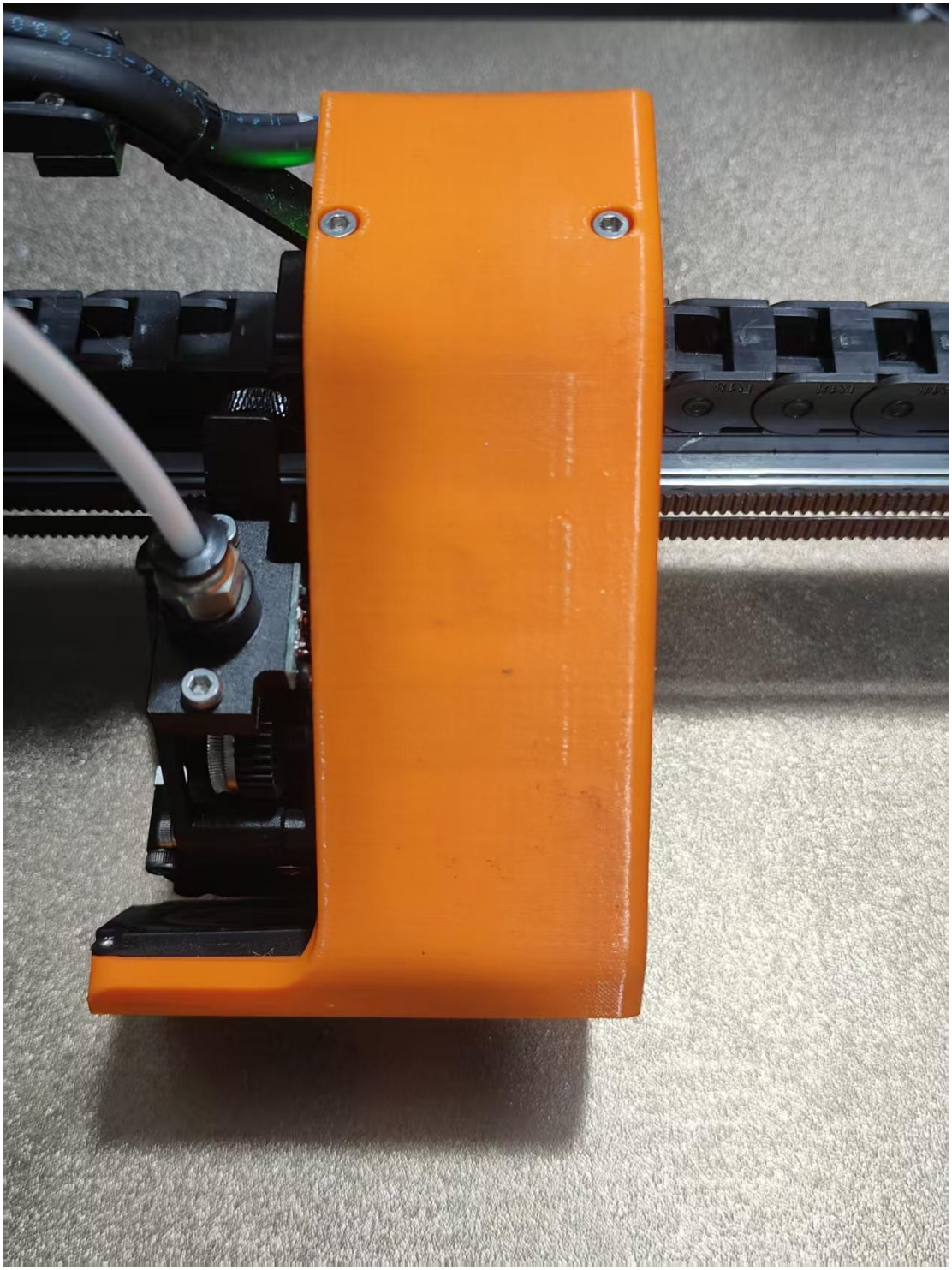




15.Reinstall the extruder bracket cover.

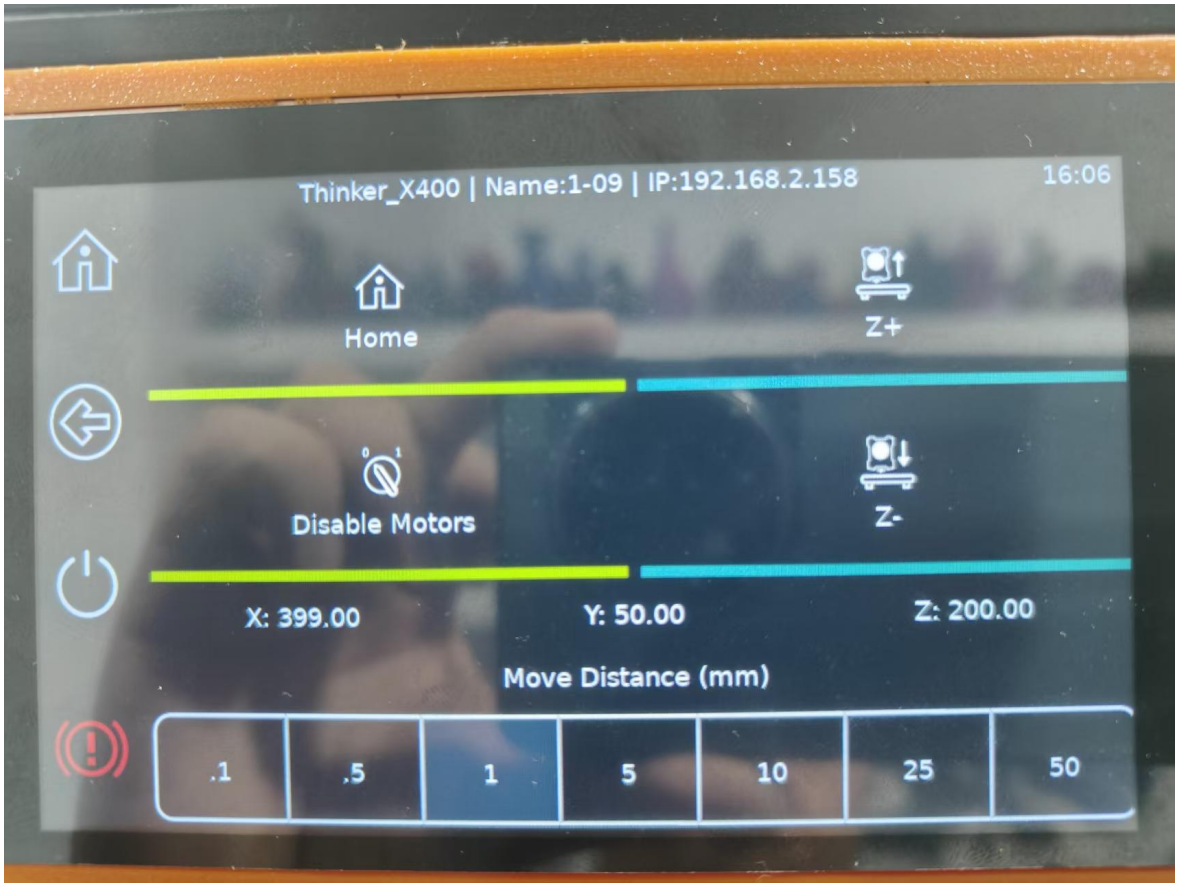


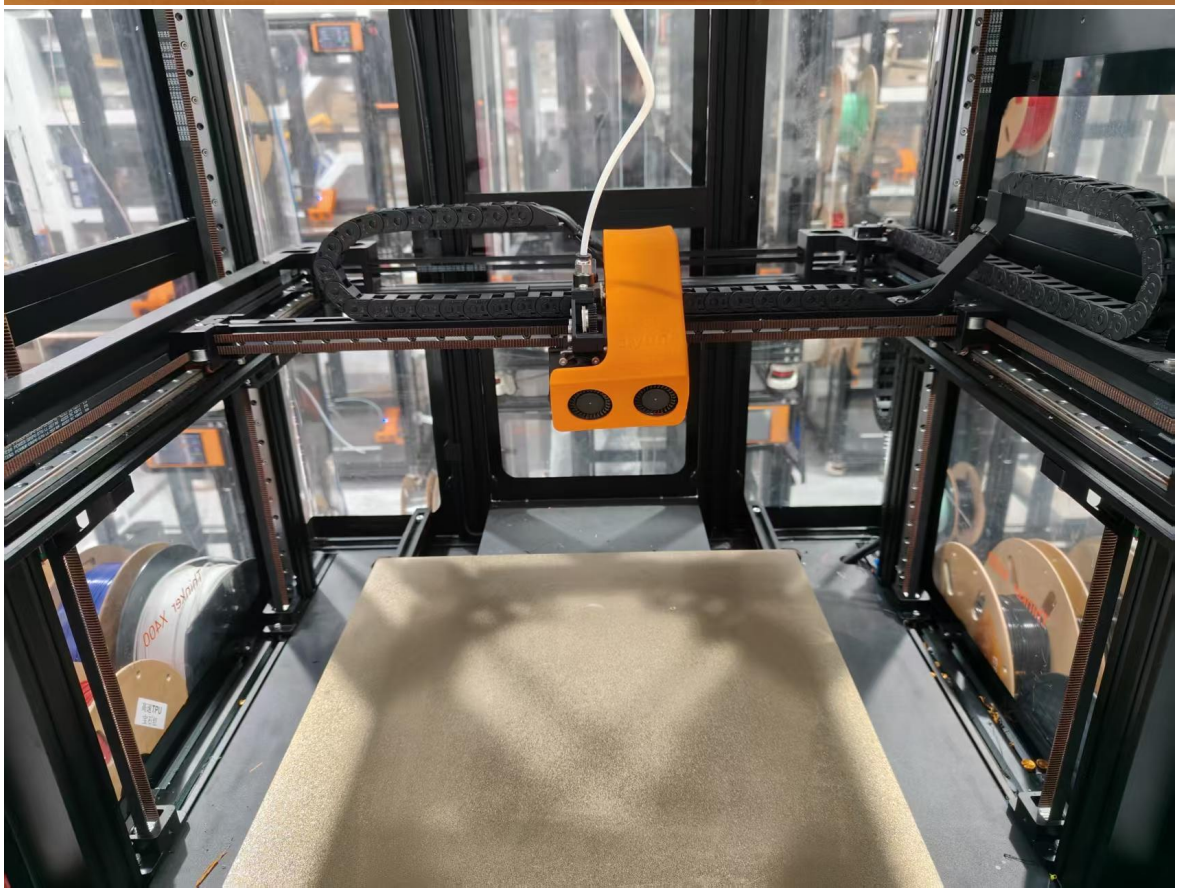

Elryone



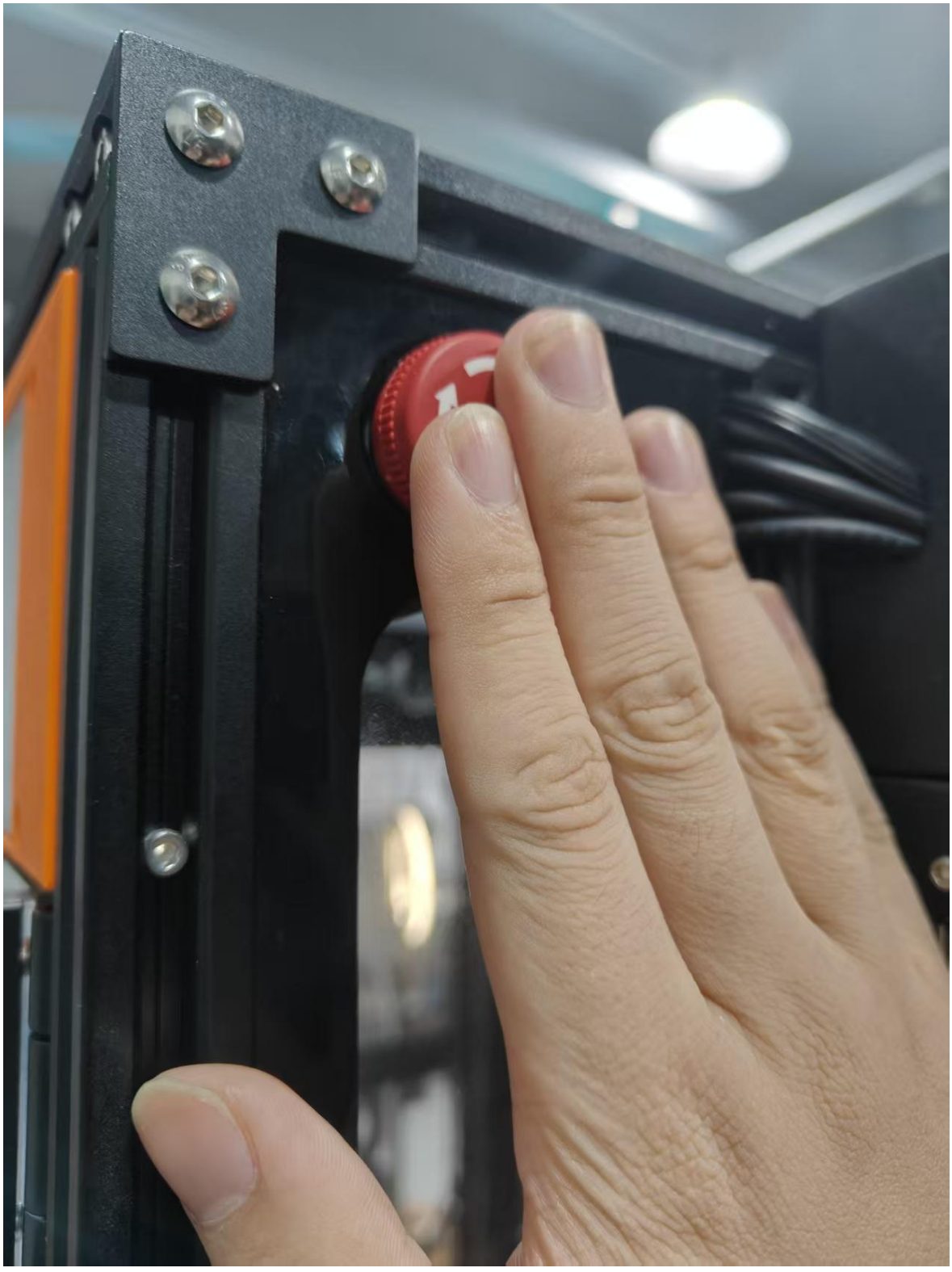
10.8 Replacing the Heated Bed

1.Lift the Z-axis by 200mm (for ease of operation)





2.Power off the Thinker X400 and disconnect it from the power source.

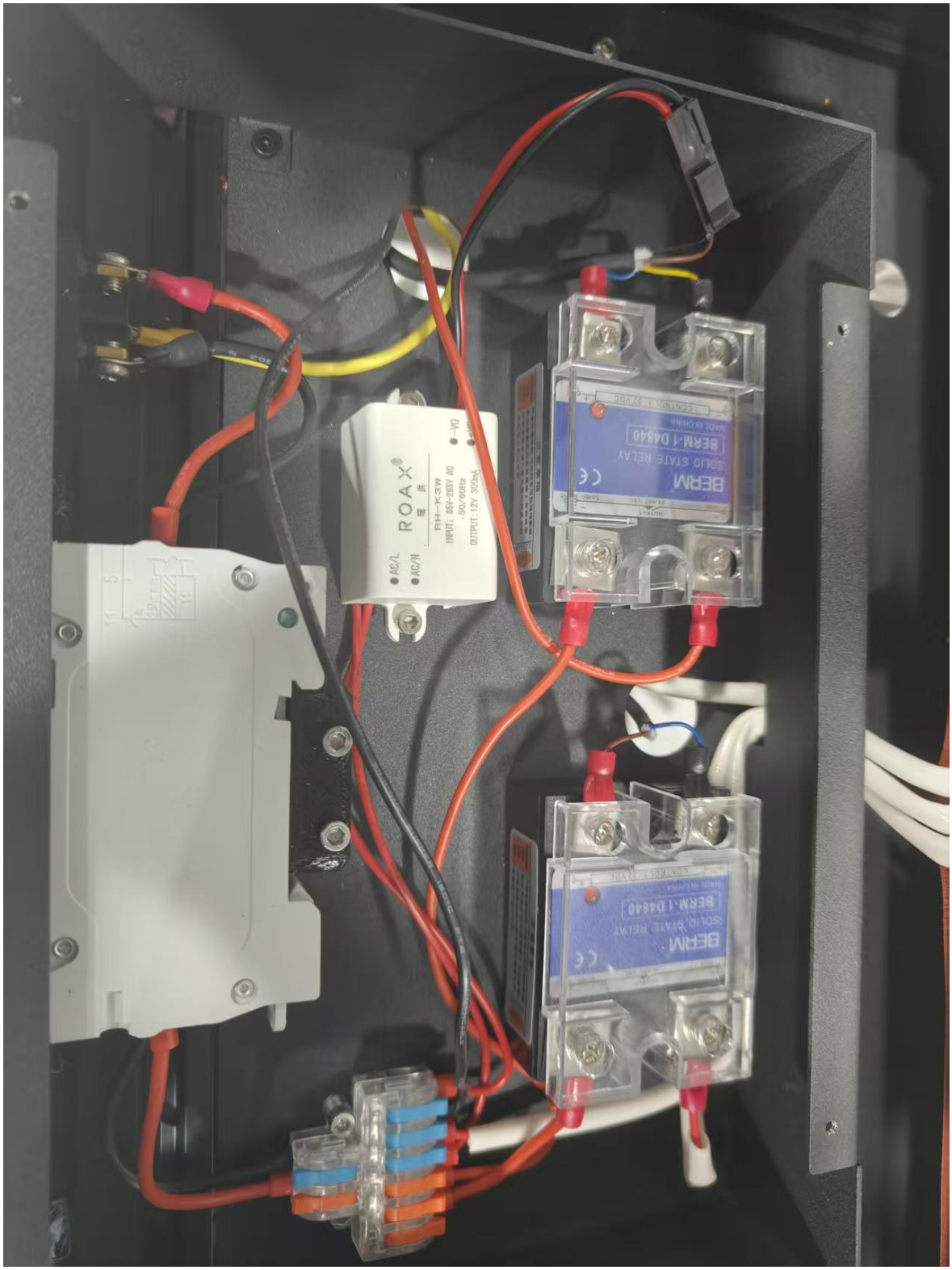


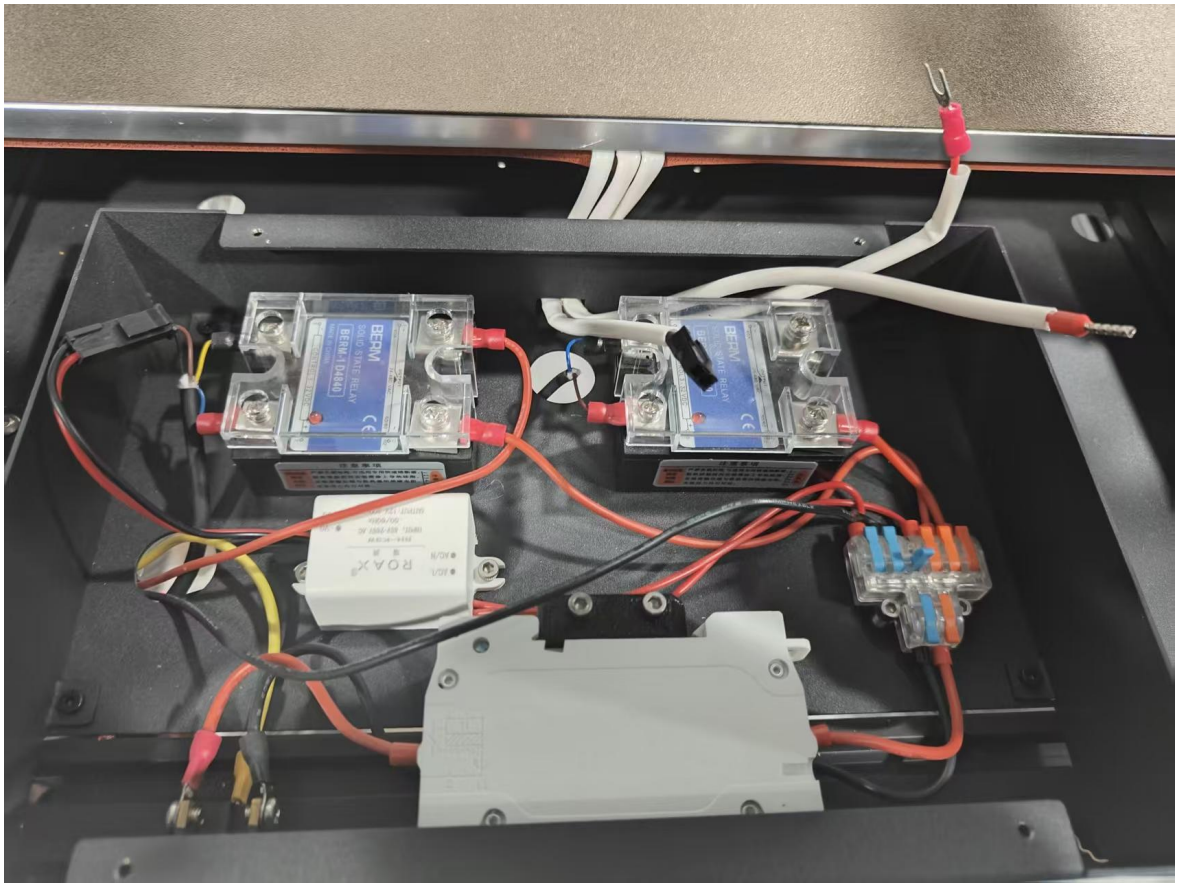
3.Remove the acrylic back panel and place it on top of the machine

Note: Handle with care to avoid damaging the fan cable.

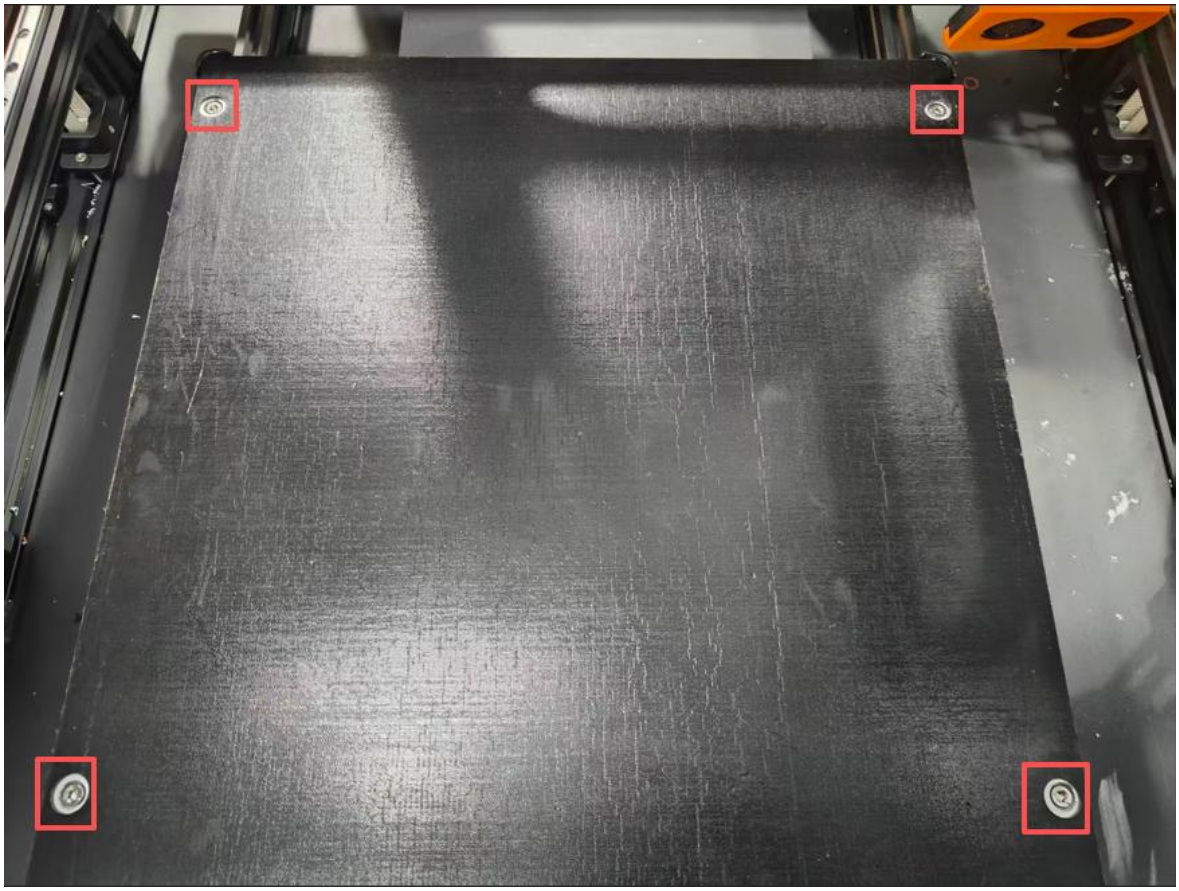
4.Remove the power supply cover.

5.Disconnect the three white cables from the heated bed

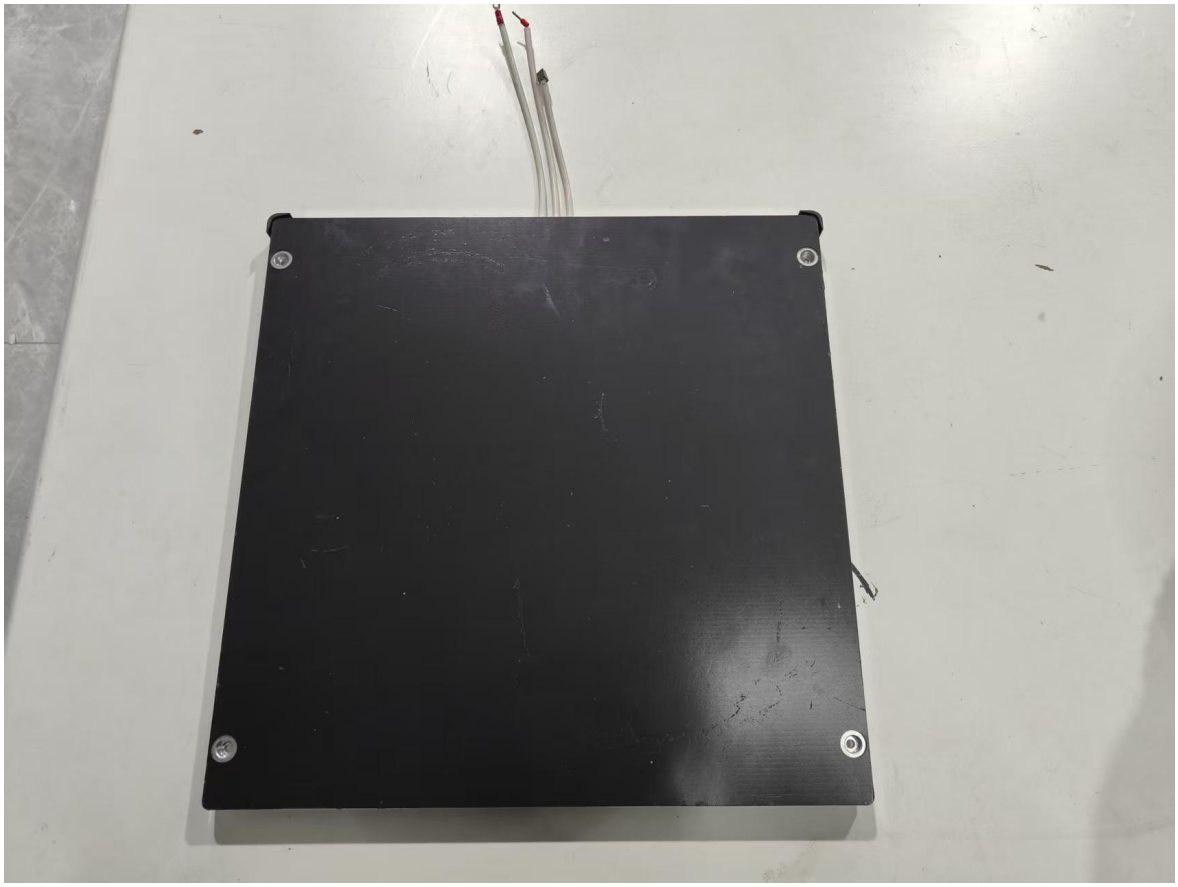

ROAX
AC/L
AC/N
BERM
SOLID STATE RELAY
BERM-1 D4840



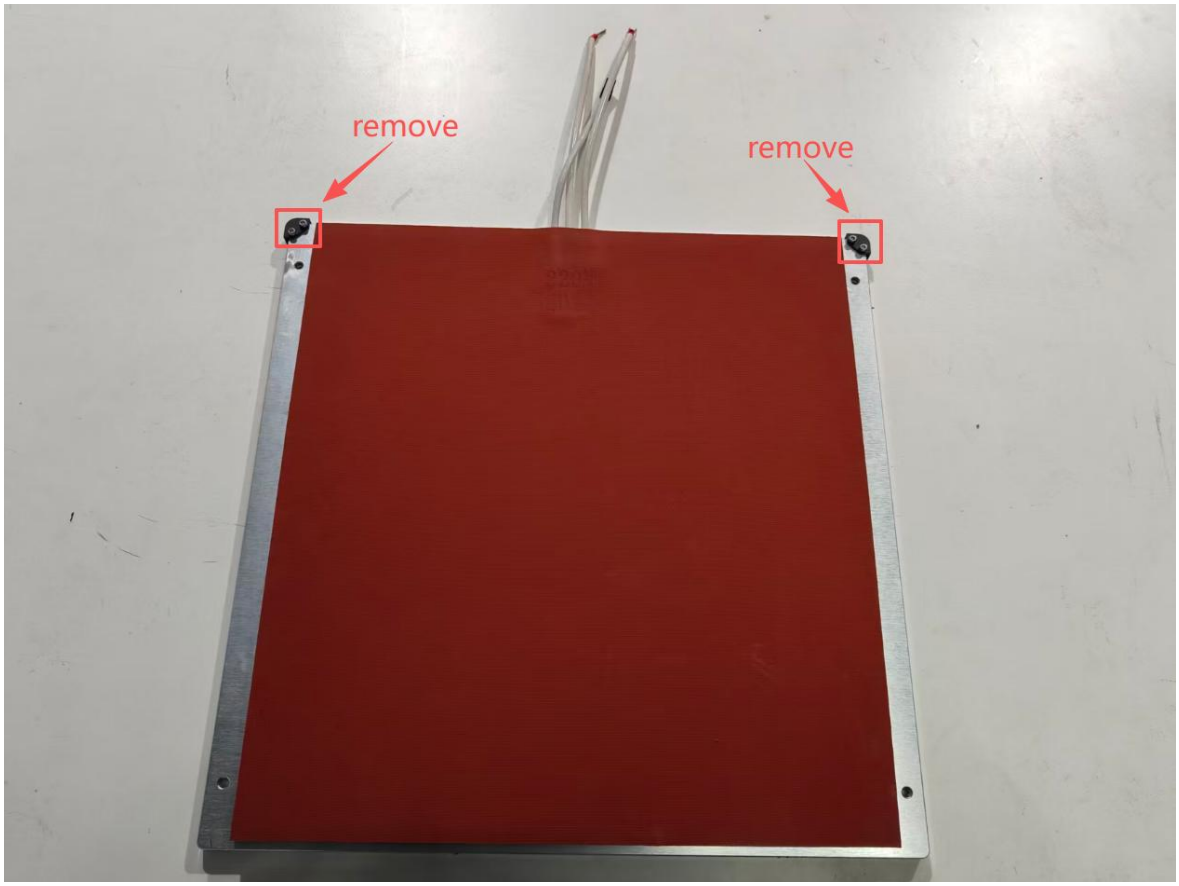
6.Remove the four screws securing the heated bed



7.Remove the heated bed and set it aside

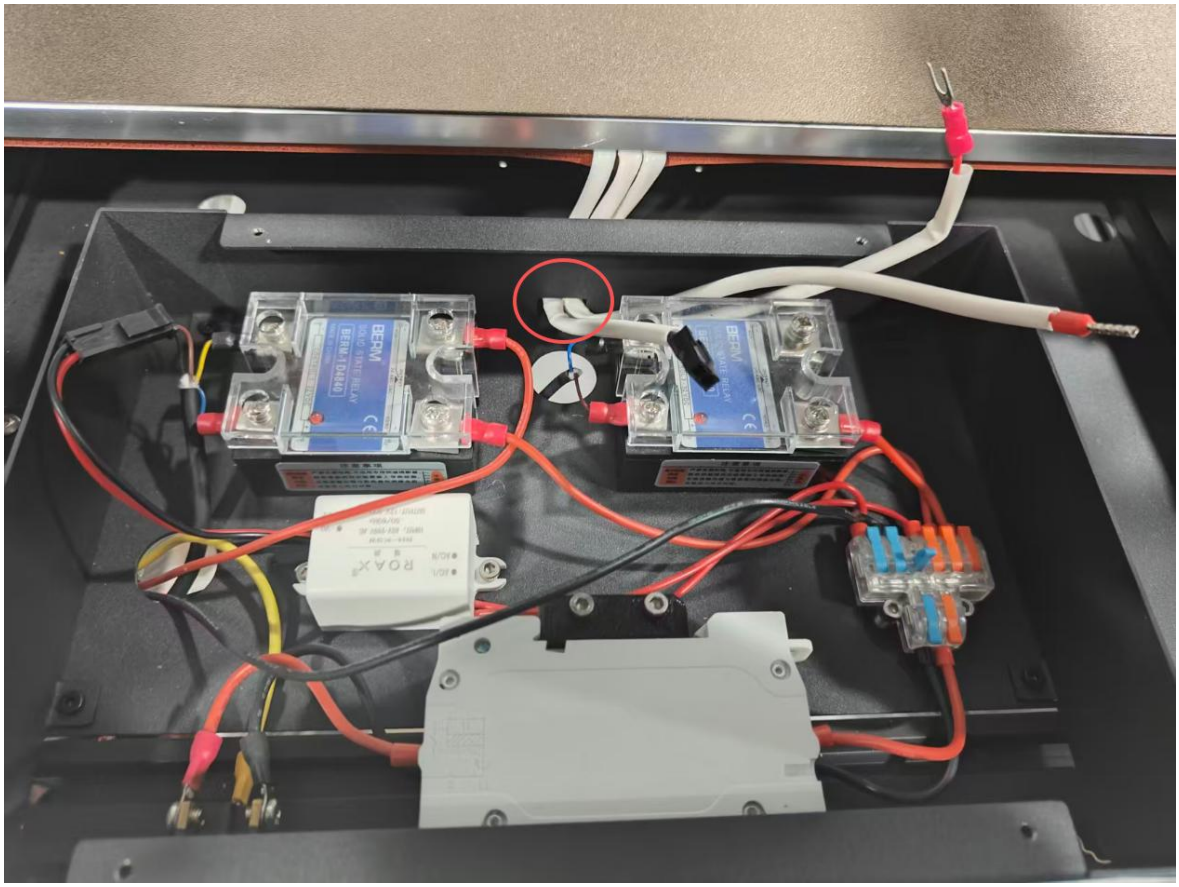


8.Remove the blocking plate that secures the PEI plate.

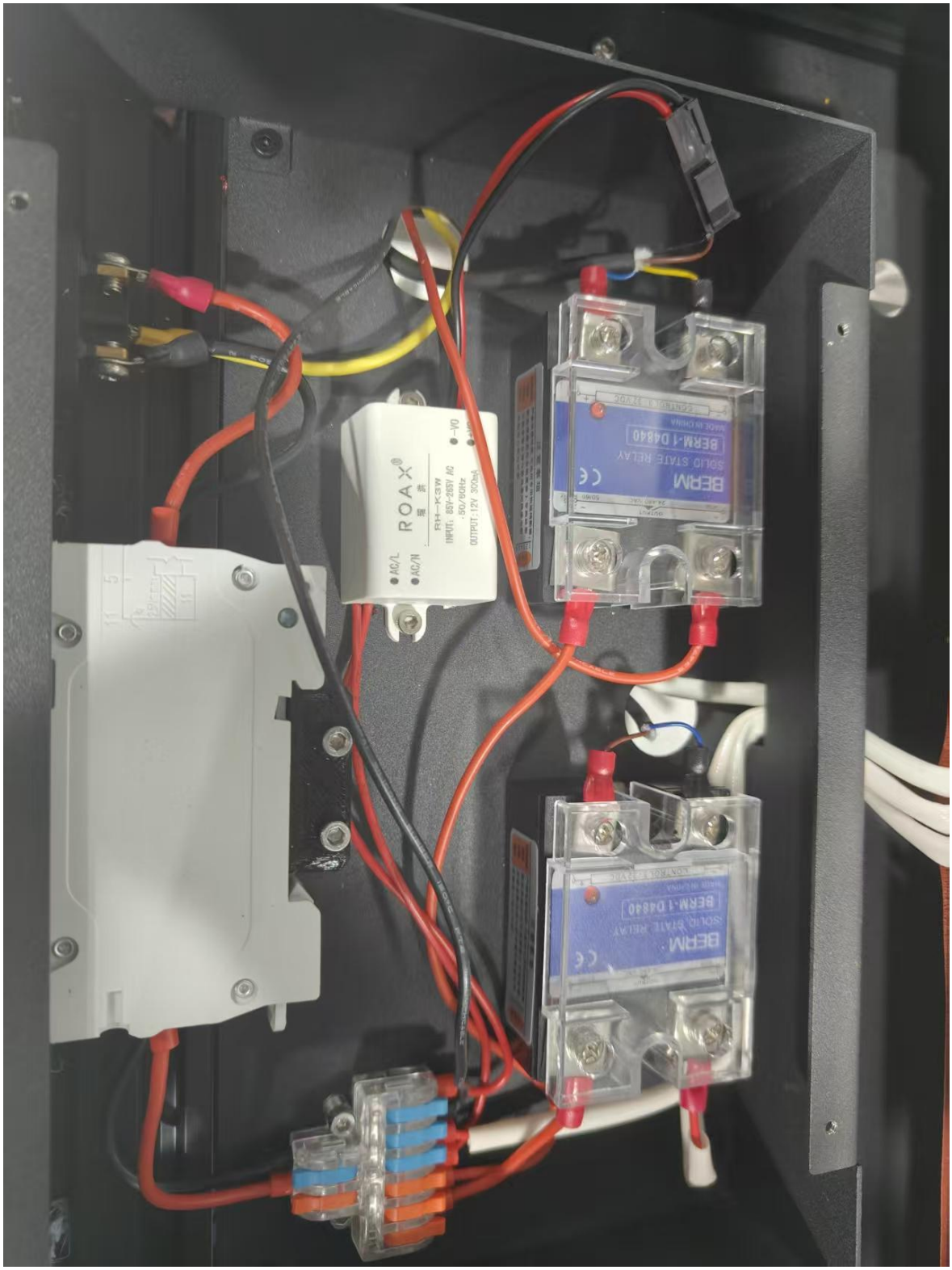


9.Take out the new heated bed and install the PEI plate baffle on the new heated bed

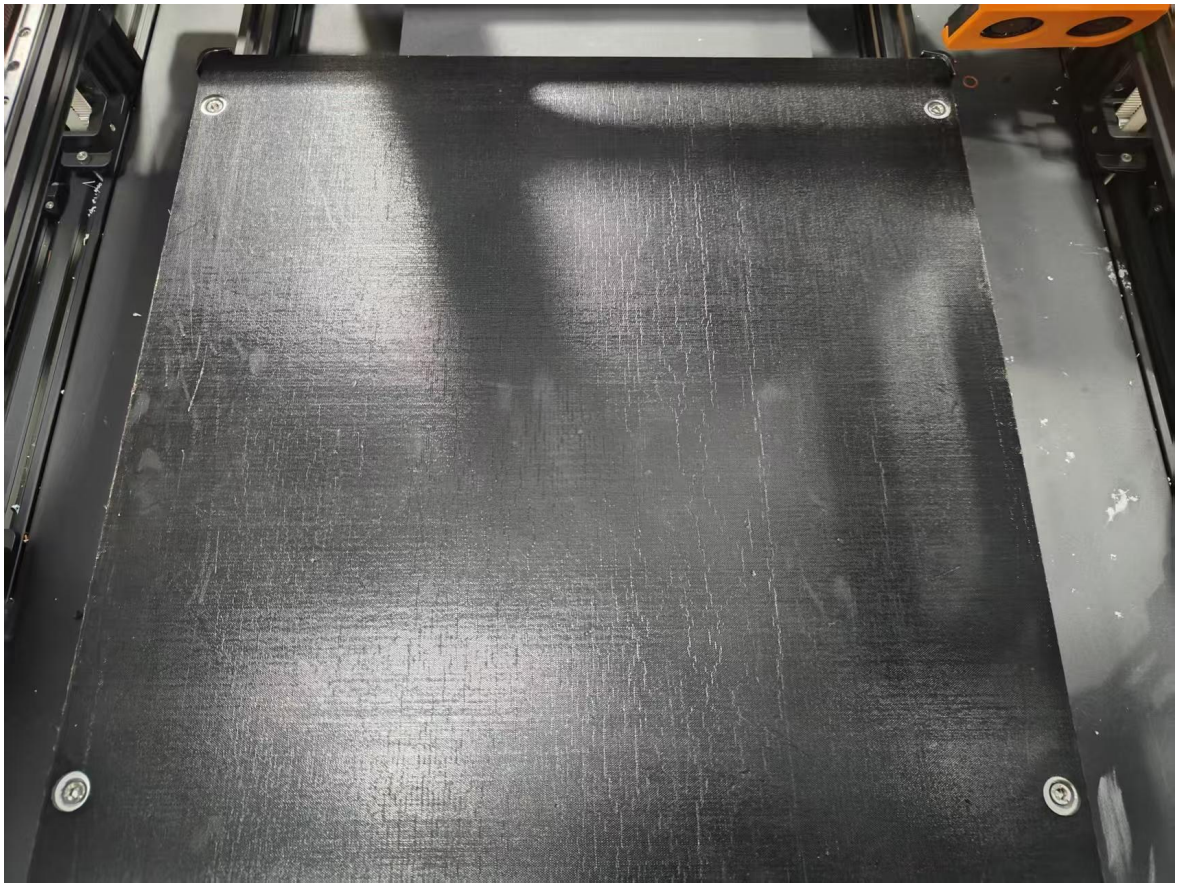
10.Route the heated bed cable through the power supply box opening and position the bed over the corresponding holes.



11.Reinsert the cable into its port



12.Reinstall and tighten the screws that secure the heated bed

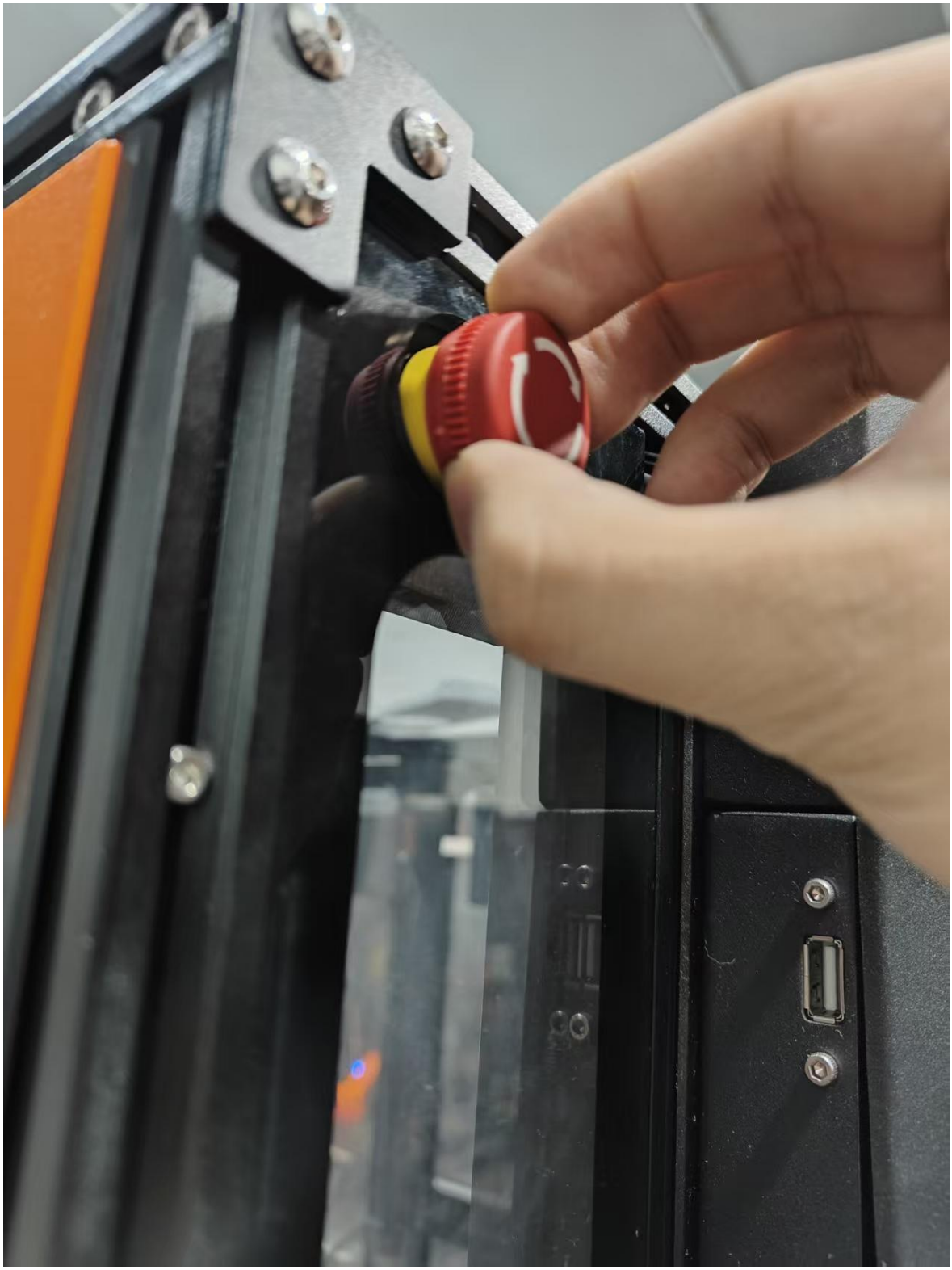


13.Place the power supply cover back on and tighten the screws.

14.Reinstall the acrylic back panel

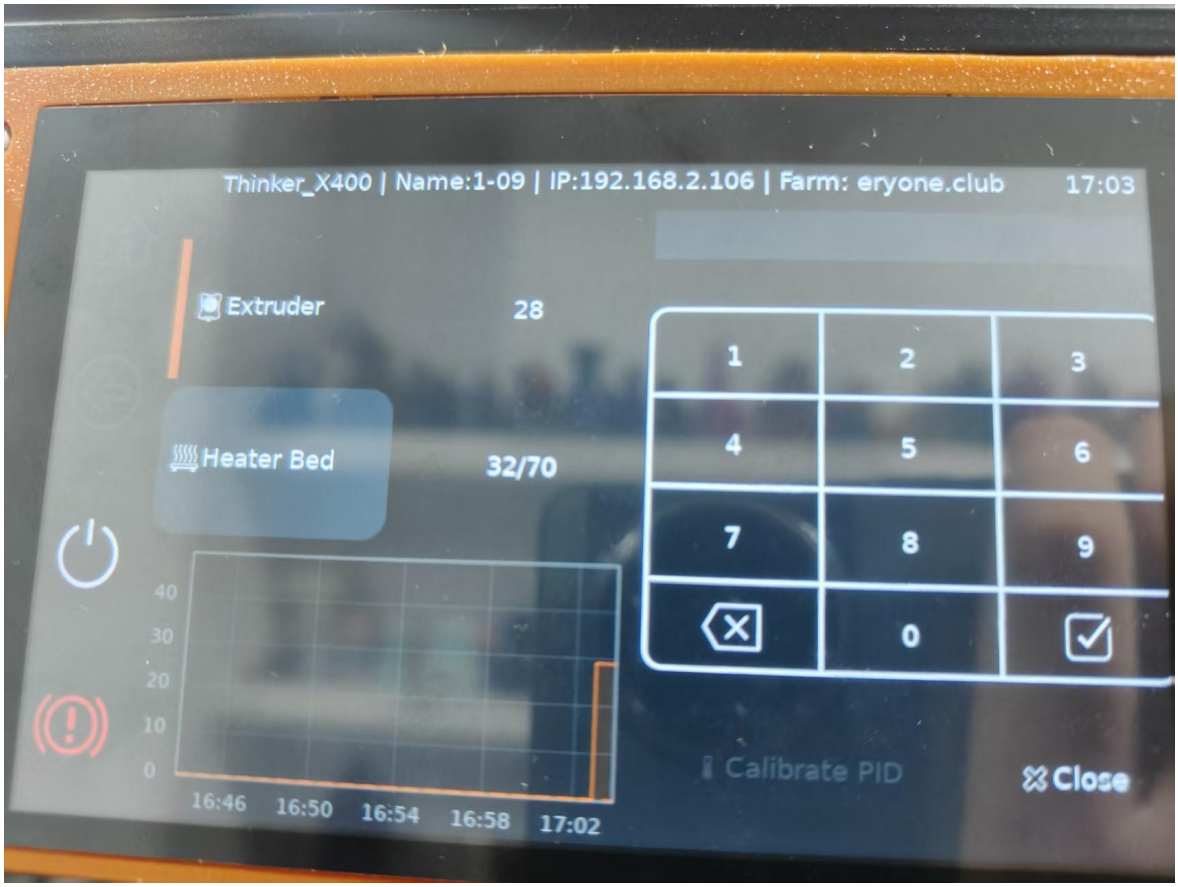
15.Reconnect the power cable to the Thinker X400 and power it on


CAUTION
110V-120V
ERYONE
DELIXI



16.Once the main interface is successfully loaded, perform a standalone heated bed test. If it heats up without any issues, the machine is ready for normal use


Thinker_X400 | Name:1-09 | IP:192.168.2.106 | Farm: eryone.club
17:03
Extruder
28
Move
Temperature
Heater Bed
33
Extrude
More
40
30
20
10
0
16:46
16:50
16:54
16:58
17:02
Print


Thinker_X400 | Name:1-09 | IP:192.168.2.106 | Farm: eryone.club
17:03
Extruder
28
Heater Bed
32/70
1
2
3
4
5
6
7
8
9
0
40
30
20
10
0
16:46
16:50
16:54
16:58
17:02
Calibrate PID
Close


Thinker_X400 | Name:1-09 | IP:192.168.2.210 | Farm: eryone.club
13:43
Extruder
35
Move
Temperature
Heater Bed
70/70
Extrude
More
50
40
30
20
10
0
13:26
13:30
13:34
13:38
13:42
Print

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Douyin

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