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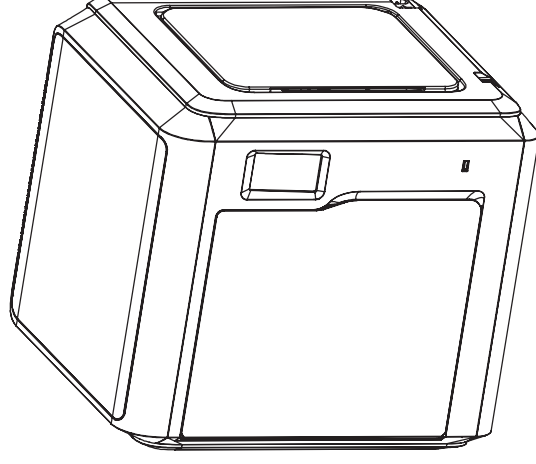
EN/CN-A04

Adventurer 4 Pro / 冒险家4 Pro

User Guide

用户使用手册

中文P28



This guide is only applicable to FLASHFORGE Adventurer 4 Pro 3D printer
本手册仅适用于闪铸科技 冒险家4 Pro 3D打印机

Personal Safety

- ◆ Do not touch the nozzle and build plate during printing.
- ◆ Do not touch the nozzle and plate after printing to avoid high temperature scald or mechanical damage!
- ◆ Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.
- ◆ Do not operate the device while you are tired or under the influence of drugs, alcohol or medication.



Keep body parts away from moving parts **Warning crushing of hands**



Hot surface
Do not touch



Keep this area clear

Notice

Safety Notice: please read and strictly follow all the safety warnings and notice below.

Note: Every printer has been tested before leaving factory. It is normal and will not be of trouble if there are filament residue remaining in the extruder or slight scratches on the plate.

Work Environment Safety

- ◆ Keep your work place tidy.
- ◆ Do not operate device in the presence of flammable liquids, gases or dust, which will cause fire in the high temperature generated by the equipment.
- ◆ Keep device out of children and untrained people's reach.

Electrical Safety

- ◆ Always use the device with a properly grounded outlet. Do not refit device plug. Ungrounded / improperly grounded / refitted device plugs will increase the risk of leakage of electricity.
- ◆ Do not use device in damp environment or under the burning sun. Damp environment will increase the risk of leakage / exposure to the sun will accelerate the aging of plastic parts.
- ◆ To avoid device damage, please use the power supply provided by Flashforge.
- ◆ Avoid using the device during a thunderstorm.
- ◆ In case of uncertain accident, please unplug the device if you do not use it for long.
- ◆ When grounding, plug the power cord into the three-in-one socket and connect to the external grounding wire through the grounding terminal of the three-in-one socket.
- ◆ Check and replace the fuse: To prevent electric shock, please be sure to turn off the power switch and unplug the power cord before checking or replacing the fuse.
- ◆ Replace the fuse: Open the fuse box of the three-in-one socket and replace the fuse with the fuse of 5*20, T10AL250V specification.

Environment Requirements

- ◆ Temperature: RT 15-30°C; moisture: 20%-70%.

Place Requirements

- ◆ The device must be placed in a dry and ventilated environment. The distance of the left, right and back side space should be at least 20cm, and the distance of the front side space should be at least 35cm. Device storage temperature: RT 0-40°C.

Reference

Name	Adventurer 4 Pro
Extruder quantity	1
Printing precision	±0.1 mm (test of 100mm cube)
Position precision	X/Y axis: 0.011 mm; Z axis: 0.0025 mm
Layer thickness	0.1~0.4 mm
Build volume	220 x 200 x 250 mm
Nozzle diameter	0.4 (default) 0.6/0.3 mm (optional)
Printing speed	10~300mm/s
Highest extruder temperature	265°C
Filament type	ABS/PLA/PC/PETG/ PLA-CF/PETG-CF
Power supply	AC100~240V/DC 24V/ 13.3A, 320W
Device size	500(L)*470(W)*550(H)mm
Printing connection	USB Disk/ Wi-Fi/ Ethernet
Filament running out reminding	√
Print bed	PEI flexible steel platform
Remote camera watching	√
HEPA 13 Air filter	√

Filament Requirements

- ◆ It's recommended to use the filaments offered by Flashforge, or from the brands accepted by Flashforge. Due to the different properties of filaments, you need to modify printing parameters when using those which are not offered by Flashforge.





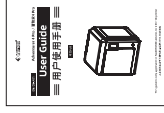
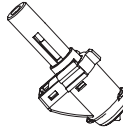

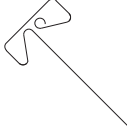


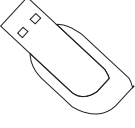
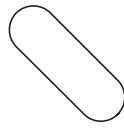
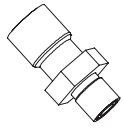

Filament Storage

- ◆ All polymers degrade with time. Do not unpack filament until necessary. Filament should be stored in clean and dry conditions.

Legal Notice

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- ◆ FLASHFORGE CORPORATION MAKES NO WARRANTY OF ANY KIND WITH REGARD TO THIS DOCUMENT, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.
- ◆ FCC Notice
This device complies with part 15 of the FCC rules. Operation is subject to the following two conditions: [1] This device may not cause harmful interference, and [2] this device must accept any interference received, including interference that may cause undesired operation.
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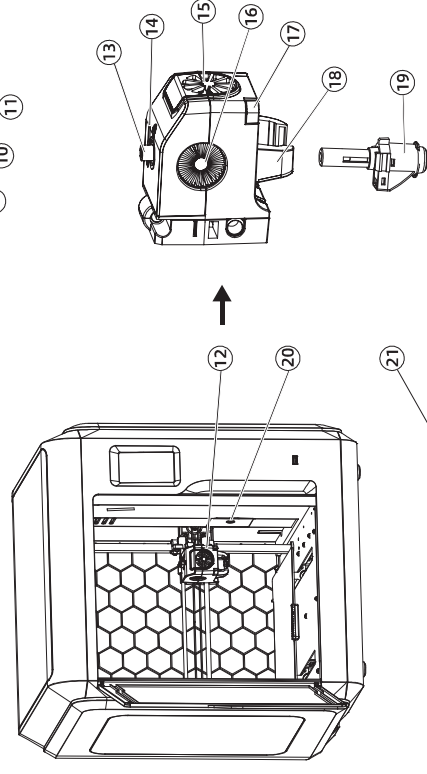
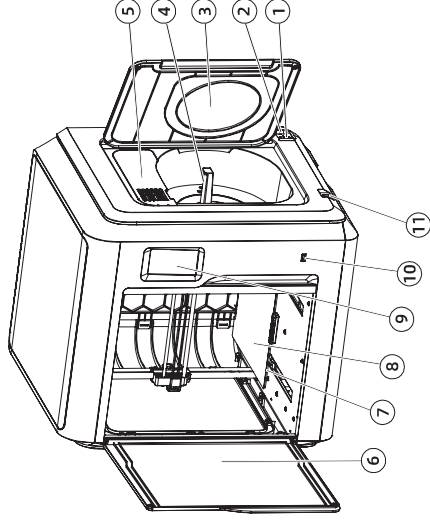
1.2 Packing Specification

	3D Printer		Filament		Power Cable		After-Sales Service Card
	User Guide		0.6-265 Nozzle		Screwdriver		Unclogging Pin Tool
	Allen Wrench		Grease		USB Disk		Leveling Card
	Filament Guide Tube Joint		Glue Stick				

Chapter 1 Adventurer 4 Pro

1.1 Component Introduction

1. Power switch
2. Power socket
3. Filament cover
4. Spool holder
5. Filament intake cover
6. Front cover
7. Platform base
8. Build plate
9. Touch screen
10. USB
11. Ethernet input

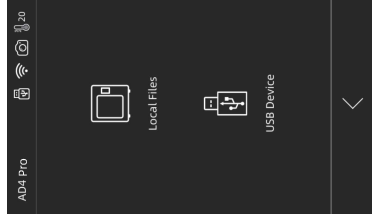
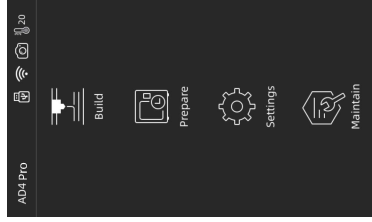


12. Extruder
13. Filament guide tube joint
14. Cable slot
15. Fan for cooling extruder
16. Fan for cooling model
17. Buckle
18. Air duct
19. Nozzle
20. Camera
21. Air filter

Chapter 2 Introduction of User Interface

Note The interface layout may change whenever there is an upgrade of firmware. The functions below are only for demonstration purposes.

2.1 Build



- Read print file from local memory card
- Read print file from the USB stick

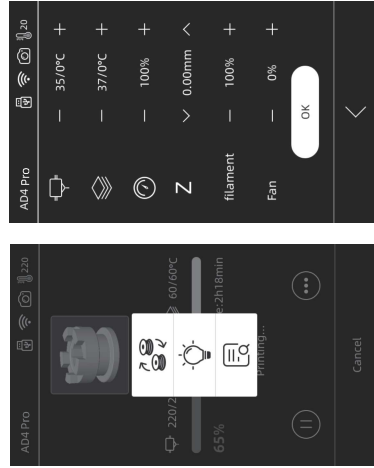
Details

- Extruder temperature
- Time used
- Speed
- Copy the file to the local memory card
- Build plate temperature
- Amount and type of filaments required
- Layer thickness

Interface

- Pause /Resume printing
- Check more parameter settings and details

1. Click [Build], and then choose the path to read the print file.



- ### More Settings
- You can change filaments
 - The switch of LED light
 - Adjust printing parameters: extruder temperature / platform temperature / printing speed



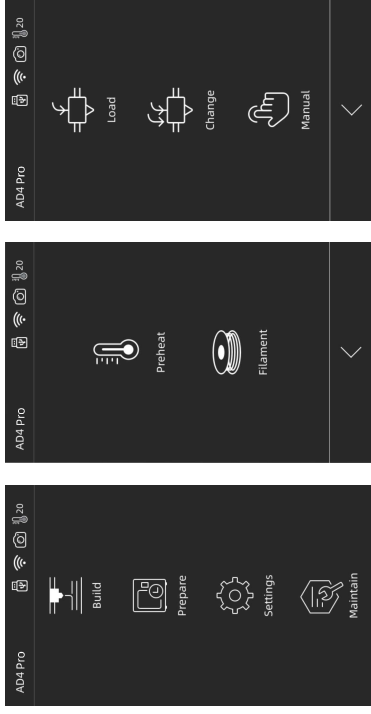
2. File list

- Tap model file: for file details.
- Long press model file: multi-selecting mode on.
- The finished prints will be marked.

- Z:** Used when the distance needs to be adjusted between the first printed layer and the extruder. The up and down arrows indicate that the extruder moves upward or downward.
- Fan:** The fan for cooling the model. Wind speed can be adjusted for printing different filaments.

Click OK to save and apply the changed parameters.

2.2.2 Filament



Load/Change/Manual



Load

Choose [Load], extruder will be heated to set temperature, then follow the instruction to finish loading. Note that fast-slow loading is automatically applied, just place the filament in the extruder gear. Do not push the filament into the tube. You may hear noise when the loading is fast.



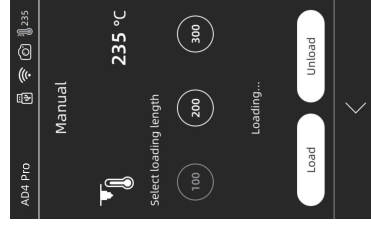
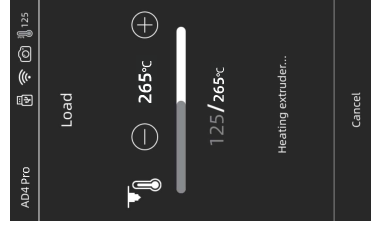
Change

Click on [Change], the extruder will be heated up to the preset temperature. Pull out the filament according to the instruction. Insert new filament in the filament intake until some resistance is felt. New filament coming out of extruder indicates a successful replacement.



Note

The extruder will be heated to the highest temperature by default during automatic filament feeding and withdrawing. Actually, the extruder heating temperature can be adjusted according to the used filament when in practical use.



Manual

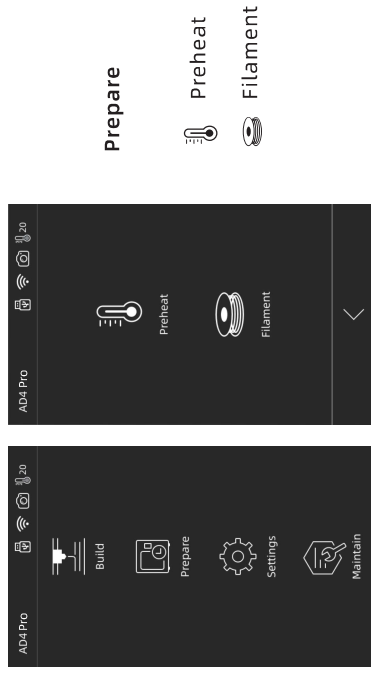
Click on [Manual], extruder will be heated up to preset temperature. Choose filament length, and choose [Load/Unload].



Note

Note that manual mode should be preferred when there is remaining filament in the tube.

2.2 Prepare



Prepare

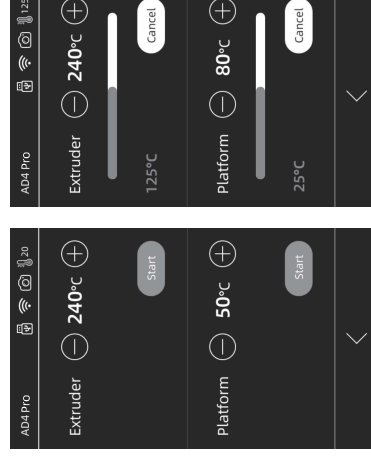


Preheat



Filament

2.2.1 Preheat



Tap   to set preheat temperature.

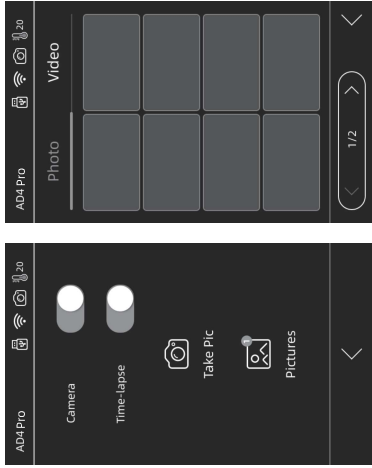
Long press   to set preheat temperature speedily.

Turn ON/OFF the extruder or platform preheat

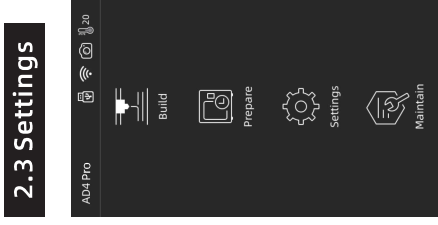
Extruder highest preheat temperature: 265°C (It's up to the chosen extruder)

Platform highest preheat temperature: 110°C

Temperature can be adjusted anytime during heating.



Camera: Remote monitoring. Turn on the camera during printing, and turn on time-lapse, and time-lapse video can be recorded in the memory disk; it can be found in [Pictures]; choose [Take Pic], the live scene is saved as images;



2.3 Settings

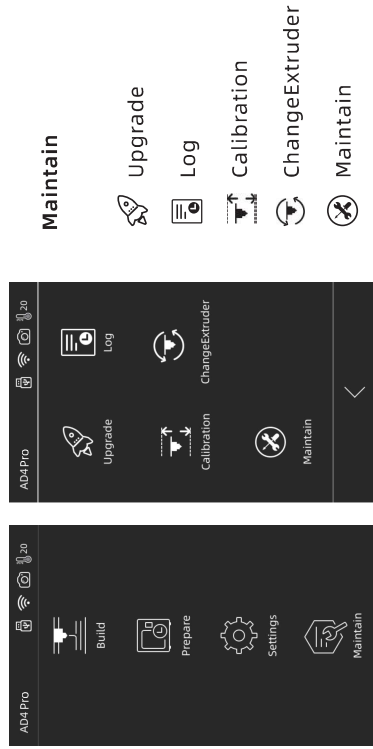


- Brightness:** Adjust the screen brightness;
- Light:** turn on/off the light on the extruder;
- FilamentDetect:** filament check sensor is on/off;
- Buzzer:** Turn on/off the sounds of device startup and screen click;
- PrinterName:** User can name the device;
- About:** information of this device;
- FactoryReset:** this device is restored to factory setting.

The following functions are included in [Settings]: Move, Network, Fan, Language, Status, Camera, Brightness, Light, FilamentDetect, Buzzer, PrinterName, About, FactoryReset.

- Move:** to move the extruder left or right, (note that the noise is normal if it moves past the farthest point of the left side), and to move the build plate back and forth, (note that the noise is normal if it moves past the farthest point of the front side);
- Network:** connect device to hot spot/WLAN/Flash Cloud/Polar Cloud;
- Fan:** to turn on/off the fan;
- Language:** select language;
- Status:** including device temperature, X/Y/Z position, etc.

2.4 Maintain



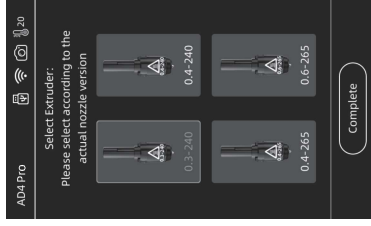
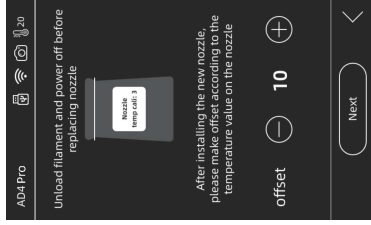
2.4.1 Upgrade

When the device is connected to the network, it will be prompted to upgrade when the new firmware is released;

2.4.2 Log

When the equipment has abnormal movements, the problem can be fed back to the official after-sales team of Flashforge by copying the log.

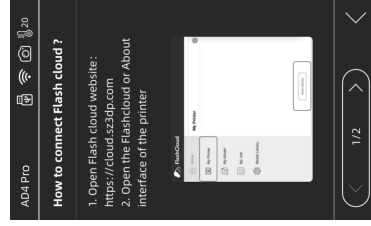
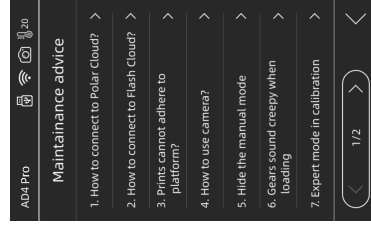
2.4.4 ChangeExtruder



After installing a new nozzle, please set the compensation value according to the temperature the replaced nozzle adopts to; the actual deviation range of the extruder: -10 ~ 30. Click [next] to enter the extruder selection interface. Select the new nozzle to be installed and the maximum temperature during preheating will be set according to the selected nozzle. Please ensure that the installed nozzle is the same as the selected nozzle type, and click [complete] to return to the maintenance interface.

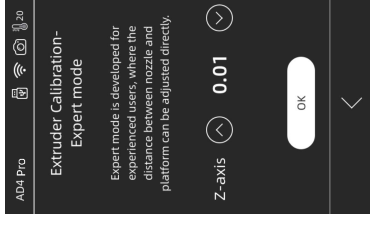
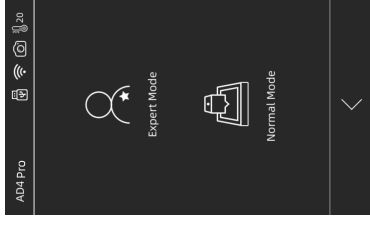
! Note if a different nozzle is replaced, the default maximum temperature of preheating will change to the temperature of the replaced nozzle.

2.4.5 Maintain

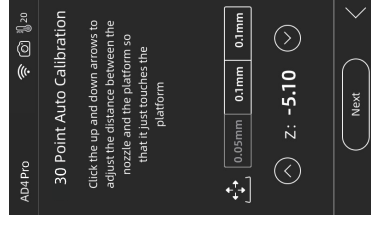


In case of errors or unclear operation, please check and operate according to the maintenance suggestions first.

2.4.3 Calibration

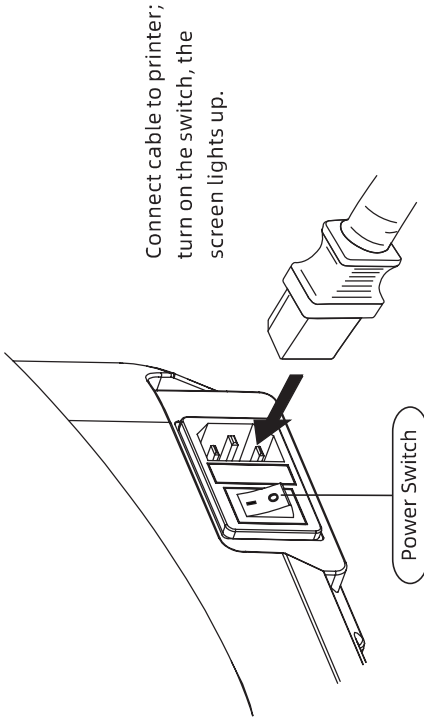


It is necessary to calibrate the distance between the nozzle and the platform after the first use or replacement of the nozzle; Expert mode is for experienced users to directly calibrate the distance. Click (⬅️) to make extruder move upwards, Click (Ⓞ) to make extruder move downwards.

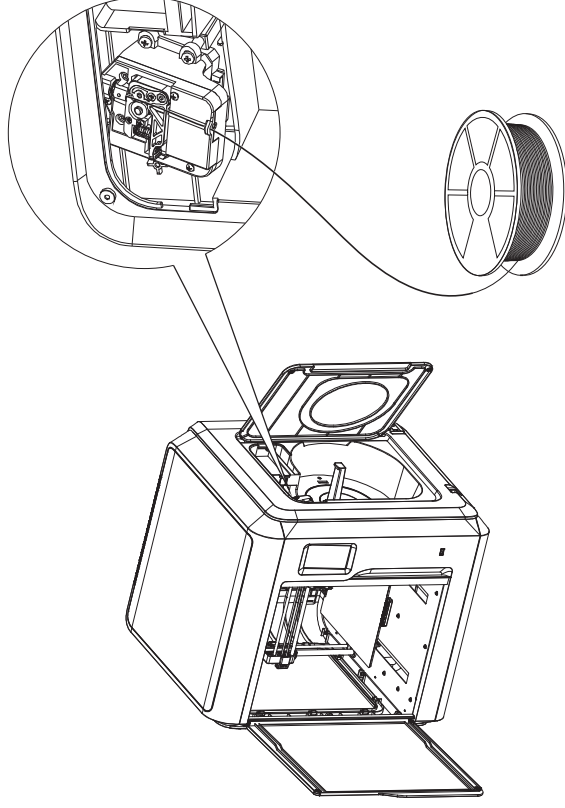


Normal Mode: extruder calibration and multi-point leveling offset are included. Click on [Normal Mode] to start pre-calibration. The first point is to calibrate the initial distance between the extruder and the platform. Click on the up and down arrows to adjust the Z-axis deviation value. You can also sense if there is slight resistance by pulling A4 paper between them to decide the appropriate distance. After calibrating the first point, please follow the on-screen prompts to continue to complete the multi-point automatic leveling.

Chapter 5 Print



1. Connect to power.

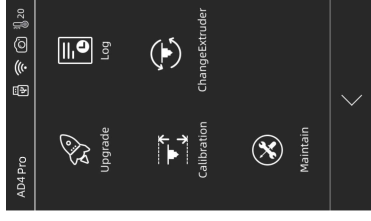


2. Load Filament: open the filament cover on the right side, insert the filament into the filament intake, push filament into the feeding wheel until some resistance is felt. Please make sure filaments are in the feeding wheel. Tap [Prepare]-[Filament]-[Load]. Follow the instruction, filament coming out of the nozzle indicates a success.

Chapter 3 Software Installation

Find the FlashPrint installation package in the USB disk and select the version corresponding to your system to install.
Or you can download it from <https://www.flashforge.com/download-center>.

Chapter 4 Preparation of Device

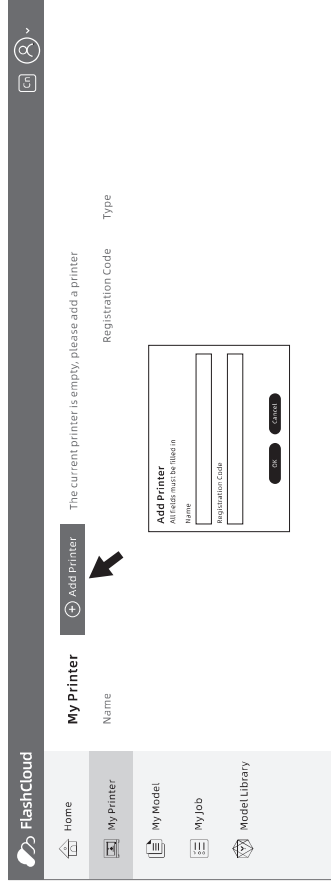


The equipment has been leveled and calibrated before delivery, but due to transportation or other influences, the distance between nozzle and platform may change. It is recommended to conduct [Calibration] after unpacking.

This step is optional, please refer to the interface function introduction before operation.

Method 3: Cloud FlashCloud

- Open FlashCloud website (<https://cloud.sz3dp.com>) to register an account. After the mailbox is activated, you can log in and use it; after logging in.

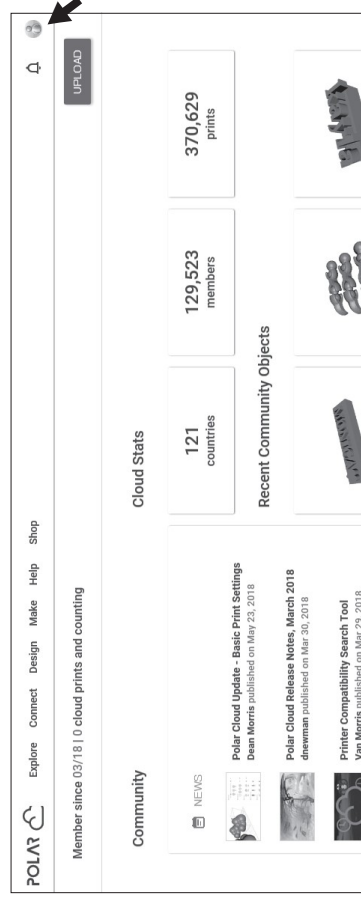


- Click [My Printer] - [Add Printer].

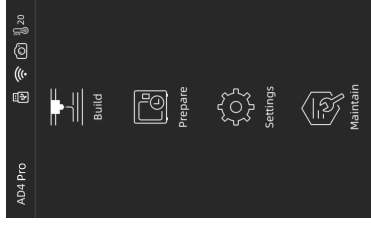
Fill in the registration number (Registration Code) on page and name the printer. After clicking OK, the information will appear in the FlashCloud interface of the printer.

Polar Cloud

Register the Polar Cloud account in <https://Polar3d.com>.



Inquire Polar Cloud PIN code. Turn on the Polar Cloud switch and enter account number and PIN after connecting Adventurer 4 Pro to network.



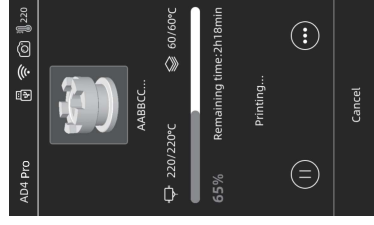
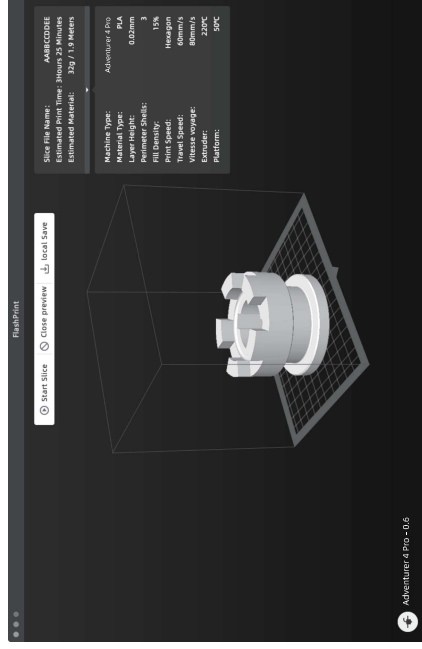
Note

When the user wants to use the browser to view images, the printer and PC must be in an intranet (that is, the printer and PC connect to the same router).

3. Model File Transfer

Method 1: Wi-Fi Connection

Tap [Settings]-[Network]-[WiFi], operate according to the instruction. Open Tap [Settings]-[Network]-[WiFi], then click [Machine Type], select [FlashForge Adventurer 4 / 4 Pro]. You can try to enter the IP address or scan it automatically. The IP address can be viewed in [settings] - [about].



Import stl or obj file into the slicer; after slicing, the printer will heat up and start printing automatically.

Method 2: USB Device

Files can be read in USB disk. Insert USB disk and select the files to print.

Chapter 6 Q&A

Q1. How to unclog the nozzle?

Method1: Tap [Preheat], heat up the nozzle to the set temperature. Once completing heating, press the filament guide tube joint and pull out the filament guide tube. Check to see whether the filament is bent or filament's cross-section is smooth. If not, cut it smooth, install the guide tube and filament back. Tap [Load].

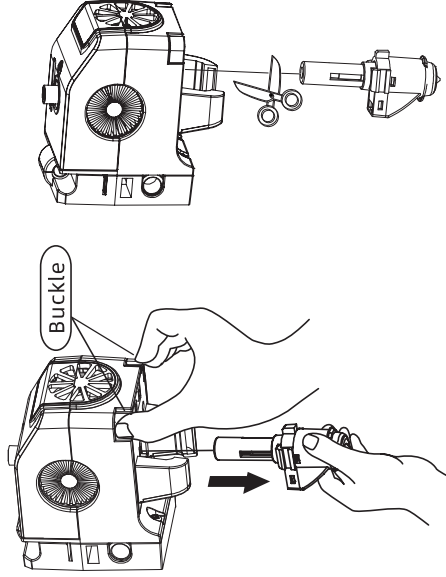
Method2: If method 1 does not work out, use an unclogging pin tool to unclog filament.

Method3: If method 1&2 do not work out, please replace the nozzle.

Q2. How to replace the nozzle?

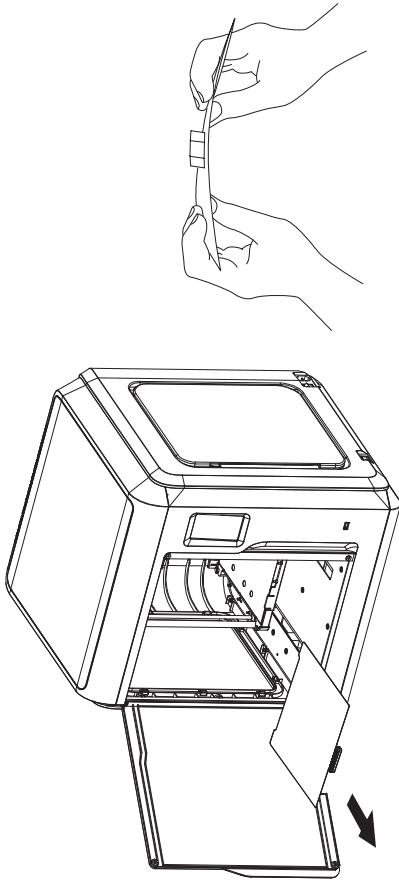
▲ Note Power off before replacing nozzle! No power on operation!

1. Press the left and right clips and pull out the nozzle.
2. Push in the filament through the filament intake manually, making it long enough to be cut off;
3. Rotate the filament spool anti-clockwise manually, making filament retreat a little;
4. Press the left and right clips, install the new nozzle. Make sure nozzle slot and bottom of extruder are on the same level.
5. Tap [Prepare] -- [Load], filament coming out of the new nozzle indicates successful replacement.



4. Model Removal

Adventurer 4 Pro: Take out the removable build plate, and bend the plate to get the model



▲ Note

Nozzle and build plate are still hot after finishing printing, please wait for them to cool down before you operate.

The back side of the build plate is designed exclusively for PETG. Please use the back when printing with PETG.

Please remove models after the platform has cooled down. If models are removed when the platform is not completely cooled down, bubbles will occur on the surface of the platform.

It is recommended to take the platform to the outside of the equipment for model removal, otherwise the model debris will remain in the equipment. Please keep the inside of the printer clean.

Q6. Can we use other brand filament which is not produced by Flashforge?

Adventurer 4 Pro supports ABS, PLA, PC, PETG, PLA-CF, PETG-CF, etc., which have different ingredients. Adventurer 4 Pro tests out default settings like temperature and filament output to ensure the best printing quality. Other brands of filaments can be used with the parameters adjusted. Because the required temperature between different materials is slightly different, it is recommended to clean the previous filaments before using new filaments, otherwise it is easy to cause extruder blockage.

Q7. Is Adventurer 4 Pro compatible with all kinds of AC power input?

Adventurer 4 Pro is equipped with a built-in 24V/13.3A power supplier, suitable for 100V-240V input voltage.

Q8. Is Adventurer 4 Pro capable of turning itself off automatically after printing job is finished?

No.

Q9. What kinds of file formats does Adventurer 4 Pro support?

Input: 3MF/STL/OBJ/FPP/BMP/PNG/JPG/JPEG Files.
Output: GX/G files.

Q10. Does Adventurer 4 Pro support other cloud platforms besides FlashCloud?

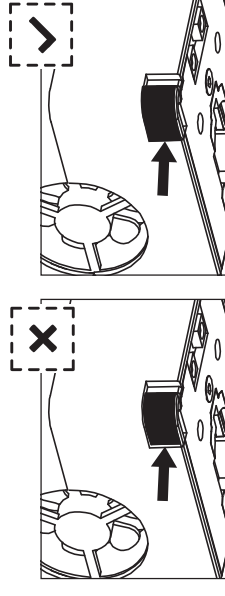
Yes, Adventurer 4 Pro interface is open up to all other cloud platforms.

Q11. Is the ABS printing safe?

ABS filament will give off certain poisonous gas when heated up, please put the printer in well-ventilated condition when printing ABS. We suggest using non-toxic PLA filament when printer is near children.

Q12. How to solve edge warping and weak adhesion?

- Method1: Heating up the platform can increase adhesion between platform and model.
- Method2: Adding raft to model when slicing in FlashPrint.
- Method3: Apply solid glue to platform before printing.
- Method4: Use extruder calibration in expert mode or leveling calibration to reduce the distance between the nozzle and the platform.
- Method5: Make sure the platform is flat. Complete 9-point leveling suggested.
- Method6: Apply extruder calibration to reduce the gap.

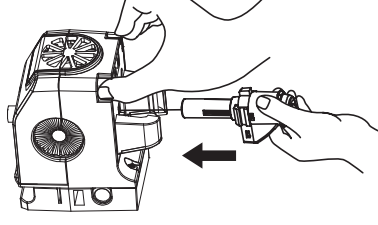


Improperly installed with seam

Properly installed with no seam

Whether the extruder assembly is in place is judged as follows:

1. When installed, the extruder must be pushed to the end;
2. Check whether the installation is in place:
 - ① Touch the black buckle and the lower shell of the white extruder, make sure no hollows are felt;
 - ② Observe to make sure there is no large gap in the joint of the black buckle and the lower shell of the white extruder.



Q3. Do we need to calibrate the extruder after replacing nozzle?

Yes, small errors may occur because of the calibration. To keep best printing quality, you need to calibrate it again.

Q4. What can I do if no filament comes out of the extruder after I choose the file and the extruder moves normally?

1. Check the filament guide tube, make sure the filament has been pushed into the extruder; if not, please tap [Load] till filament comes out;
2. Check whether the extruder is clogged, if so, please refer to Q1.

Q5. How to solve if the distance between nozzle and platform is too large (far away) or too small (that they collide)?

1. Tap [Maintain]--[Calibration];
2. The printer starts pre-calibrating. The first point is to calibrate the initial distance between the extruder and the platform (see Z-axis deviation value). Click the up and down arrows to adjust the Z-axis deviation value. With the help of the leveling card, you can feel if there is any slight resistance to decide the appropriate distance.
3. When the extruder is still unable to properly print a large size model after calibration, or when the model fails to be printed due to uneven platforms, please continue using this function. The machine will calibrate the remaining 8 points. After calibration is completed, the software will automatically calculate a compensation mean to compensate. When each point is being calibrated, the user can also adjust the Z-axis deviation by clicking the up and down arrows. After compensation is completed, the value is memorized and the extruder goes back to zero.

Q19. How to connect to Polar Cloud?

1. Open Polar Cloud website, and log in account. <https://polar3d.com>;
2. Click in Cloud Account on the right top corner, roll down the page to find PIN code;
3. Open Polar Cloud on the printer, enter account number and PIN code;
4. Turn on the switch and connect to Polar Cloud.

Q20. How to connect to FlashCloud?

1. Open FlashCloud website: <https://cloud.sz3dp.com/login.html>;
2. Open FlashCloud interface or about on the printer;
3. Add the printer on FlashCloud website, enter name and registration code of printer;
4. Turn on the FlashCloud switch to connect the printer.

Q21. How to use camera?

1. Turn on camera to watch live video on the Cloud ;
2. Time-lapse function will take 100 pictures during printing and makes a video.

▲ Note Pictures can contain up to 10 models, while videos 20 models.

Q22. Operation of movement

1. When the length is not selected, press the button to start the movement, and release the button to stop the movement;
2. When the length is selected, press to start the movement, release will not stop the movement until the corresponding length is reached.

▲ Note Pay attention to the distance when it moves along the side to avoid hitting the border.

Q23. Noise in the gear when loading filaments?

The printer adopts fast-slow loading, make sure there is no remaining filament in the guide tube.

Q24. What is expert mode in calibration?

In expert mode, the distance can be adjusted directly for experienced users. Details can be found in the calibration instructions for expert mode.

Q25. How to set printing parameters during printing?

Set printing parameters in the printer. Note that adjustments might be delayed to take effect, or improper adjustments will affect printing quality, please set it with caution.

Q13. Is it a must to add a raft before printing the model?

Not necessarily. More filaments come out of the nozzle when printing the raft, higher success rate there will be. When the plate is heated, the adhesion between the model and the platform increases, which makes the model adhere to the platform well when printing, and also increases the success rate.

Q14. After replacing the nozzle, printer status indicates that extruder temperature is 300°C, and the fan is also working. Why is this happening?

Note: Note that the temperature setting in the slicer file might not match the highest temperature of the replaced nozzle.

Errors:

Errors in temperature displaying indicate that the new nozzle is not properly installed, and the extruder temperature cannot be read by the sensor. Please plug out and install the extruder again, make sure that the extruder is pushed to the end, and the buckle and bottom of extruder are on the same level. Refer to Q2.

▲ Note Power off when replacing the nozzle.

Q15. The extruder makes out chug noise and no filament comes out of the extruder, what is the problem and how to solve?

Filament has not loaded into extruder, which is most likely because the extruder is clogged or filament guide tube is not properly installed. Check the guide tube joint first, if it's normal, refer to Q1 for resolution.

Q16. What is the difference between filament loading, filament replacement and manual mode?

Load: only load filament into the extruder ;
Change: first unloading and then loading filament, from fast to slow ;
Manual: slow loading.

▲ Note it is recommended to use manual mode during testing the nozzle unloading filaments. Not recommended for loading filaments. If it is used, please select the maximum length.

Q17. Adventurer 4 Pro starts printing when the distance between extruder and build plate is still large, causing filament unable to stick to plate.

Calibrate the printer again or finish Homing again before giving it another go.

Q18. Printing files cannot be found when using USB driver?

USB driver file is not correct. Adventurer 4 Pro only supports FAT32 file system, please format USB driver into FAT32 file system.

Chapter 7 Support and Service

Flashforge team is on standby and ready to help you with any challenges you may have with your 3D printer. If the issues or questions are not covered in this User Guide, you can seek for solutions on our official website or contact us via telephone.

There are solutions and instructions to common issues that can be found in our knowledge base. Have a look first as most basic questions are answered there.
<http://www.flashforge.com>

The Flashforge support team can be reached by e-mail or phone between the working hours of 8:00 a.m. to 5:00 p.m. PST Monday through Saturday. In case you contact us during off-duty time, your inquiry will be answered the following business day.

Note: Because of changing different filament the extruder may be blocked. It's not owing to quality issue, and outside the scope of 400 hours life. If users encounter this problem, please contact our after-sale department and finish clean work according to their instruction.

Facebook Official Group Address: Flashforge Official User Group
Email: support@flashforge.com
Address: No.518 XianYuan Road, Jinhua City, Zhejiang Province, China



Q26. Wi-Fi connection failure?

1. Please check if there are any special characters in the Wi-Fi hotspot name, if there are any, please modify them and try again;
2. Check your password for special characters, and if so, try again after you have modified it.

Note Make sure the password is entered correctly.

Q27. Firmware update

Please do not disconnect the network during download or update to prevent update failure.

Q28. Turn on the printer with white screen and no firmware

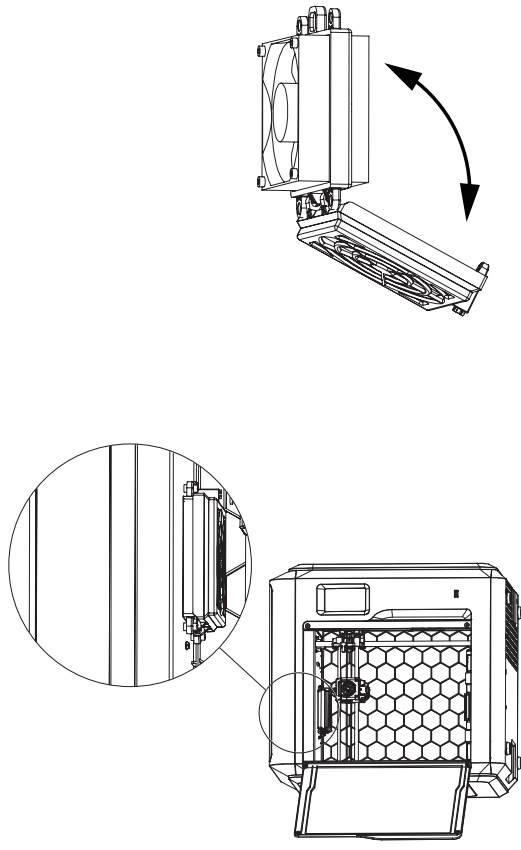
1. If you hear the power-on sound, change the screen or the wiring;
2. If you cannot hear the power-on sound, please contact the supplier.

Daily Maintenance Instructions:

When the printer is not used for a long time, apply grease on the guide rail, do it regularly every other month. Put filaments in the drying box to prevent moisture.

If it is used frequently, it is recommended to replace HEPA filter cotton once every 2 weeks.

Replace as follows:



1. Open the front door of printer, and find the air filter device indicated in the picture.

2. Open the air filter cover, put in a new cotton filter, and close the filter cover.

FCC Statement

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

Caution: Any changes or modifications to this device not explicitly approved by manufacturer could void your authority to operate this equipment. This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

RF Exposure Information

This equipment complies with FCC radiation exposure limits set forth for an uncontrolled environment. This equipment should be installed and operated with minimum distance 20cm between the radiator and your body.