**FLASHFORGE®**
3D PRINTER

Foto 13.3

Quick Start Guide

⚠ **WARNING**

1. When the glass over the LCD screen cracks, stop printing immediately, otherwise the crack will expand and cause more serious damage.
2. The maximum tank volume is 3 liters. Note that moderate resin must be added so its level will be between the upper and lower marker lines in the tank.
3. The correct way to cut off power supply is to turn off the power switch of the printer.
4. Do not cut off the power abruptly during printing to avoid mechanical damage.

This guide is only applicable to FLASHFORGE Foto 13.3 3D printer

Three screws A, B and C indicated in the picture should not be loosened, otherwise the printing will fail!
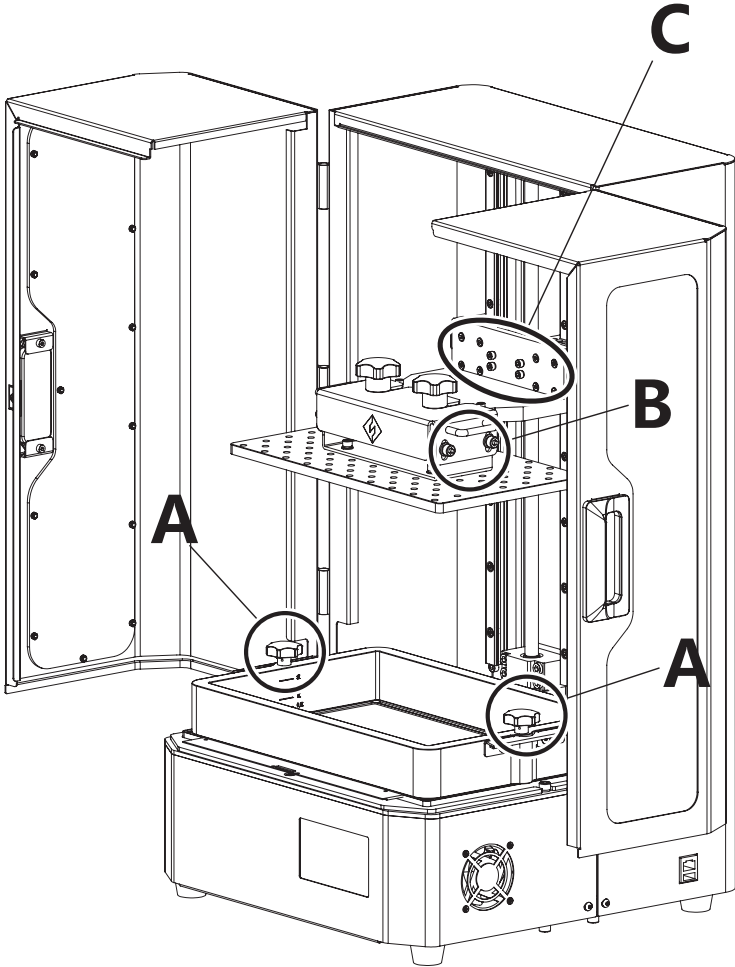
Foreword

Note   **Each 3D printer has undergone a printing test before leaving the factory. If there are residual consumables in the feed resin tank or slight scratches on the printing platform, it is normal and will not affect the use.**

Dear customer:

Thank you for choosing and using the products of Flashforge Technology. Thank you for your great support and help. The product quality and performance of Flashforge Technology are excellent. For your convenience, please read the manual carefully before use, and strictly follow the instructions of the manual. The entire Flashforge Technology team is always ready to provide you with the best quality service. No matter what problems you encounter during use, please contact us according to the telephone and email provided at the end of the manual.

In order for you to experience our products better, you can also obtain equipment operating knowledge from the following channels:

Quick Starter Guide

Please unpack it carefully, you can take out the attached quick start guide from the top layer of foam. The quick start guide will help you get familiar with the device as quickly as possible and successfully complete the first printing experience.

Notice

Safety tips: Please make sure to read the following safety tips carefully

Work Environment Safety

◆ Keep your work place tidy.
◆ Do not operate in the presence of flammable liquids, gases or dust.
◆ Children and untrained personnel should not operate the equipment alone.

Environment Requirements

◆ Temperature: RT 15-30℃
◆ Moisture: 20%-70%

Place Requirements

◆ The device must be placed in a dry and ventilated environment. The distances 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.

Electrical Requirements

◆ Be sure to ground the device; do not modify the plug of the device. (Ungrounded/ incorrectly grounded/modified plugs will inevitably increase the risk of leakage)
◆ Do not expose the device to humidity and hot sun. (Wet environment will increase the risk of leakage/exposure will accelerate the aging of plastic parts)
◆ Do not abuse the power cord, and be sure to use the power cord provided by Flashforge.
◆ Do not use the device during thunderstorms. If you do not use the device for a long time, please turn off the device and unplug the power cord.

Personal Safety

◆ Please don't direct touch the photopolymer resin with hands.
◆ Please put on gloves and masks during operation.
◆ Please don't look at the light source directly.
◆ Do not operate the device while you are tired or under the influence of drugs, alcohol or medication.

Cautions

◆ Operate the device in a well-ventilated environment
◆ Do not leave the device unattended for long
◆ Do not make any modifications to the device
◆ Do not operate the device in bright light.
◆ Never use the device for illegal activities.
◆ Never use the device to make any food storage vessels.
◆ Never use the device to make any electrical appliance.
◆ Never put the model into your mouth.
◆ Do not remove the models with force.

Photopolymer Resin Requirements

◆ Please store the photosensitive resin solution in a dark and dry environment. Please place it in a place out of the reach of children. Please ensure that the label surface of the bottle is facing the eye-catching direction.

Photopolymer Resin Storage

◆ Unused photopolymer resin needs to be stored in a dark, dry, cool place, and out of the reach of children. Ensure the bottle body logo faces in an eye-catching and visible direction.

Legal Notice

◆ The user has no right to make any changes to this manual.
Flashforge Technology will not be responsible for any safety accidents caused by customers disassembling or modifying the equipment by themselves. Without the permission of Flashforge no one may modify or translate this manual. This manual is protected by copyright, and Flashforge reserves the right of final interpretation of this manual.
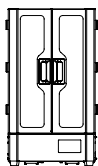
First edition (March 2021)
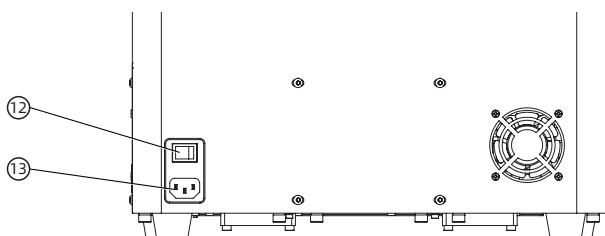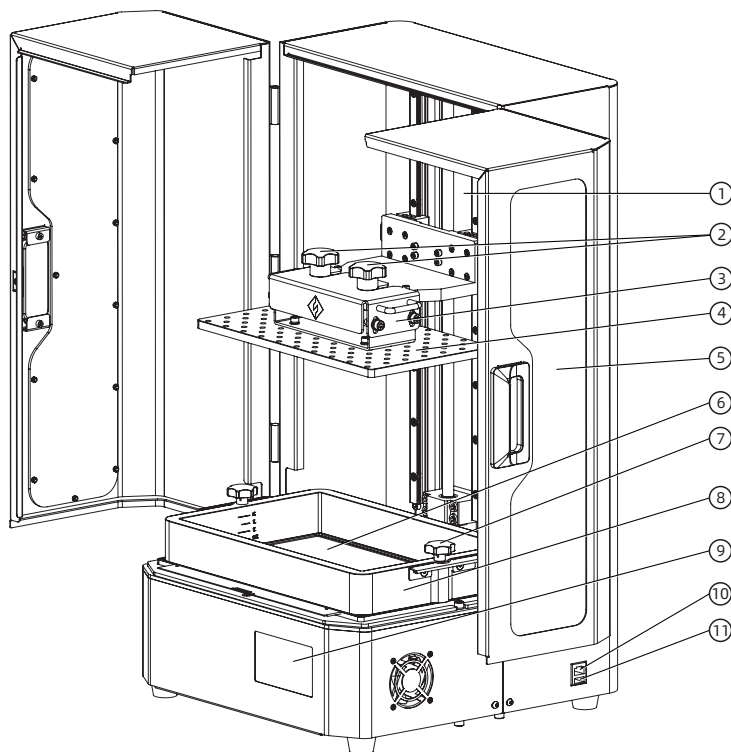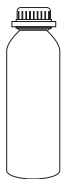
1. Z-axis   2. Platform Tighten Knob   3. Leveller   4. Build Plate

5. Light Shield   6. LCD   7. Box Tighten Knob   8. Resin Box

9. Touched Screen   10. Ethernet   11.USB Stick Port

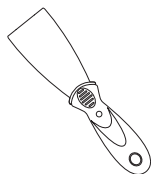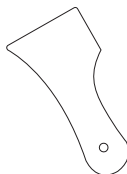12. Power Switch   13. Power Slot

Accessory Box

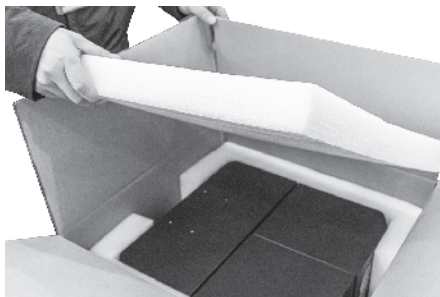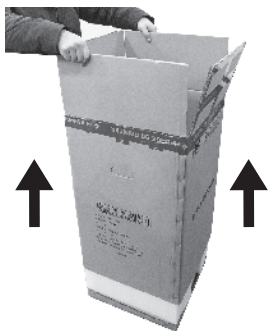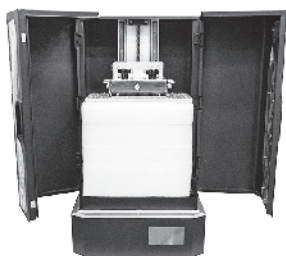|			
3D Printer	**Resin**	**Power Cable**	**Quick Start Guide**
After-sales Service	**Metal Scraper**	**Plastic Scraper**	**Brush**
Rubber Glove	**USB Stick**	**Wrench Accessory Kit**	**Tweezers**
Soft Cloth	**Filter**	**Diagonal Pliers**	
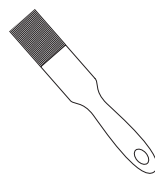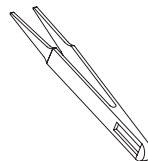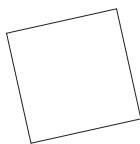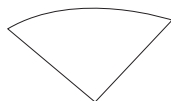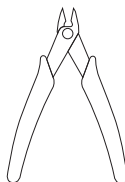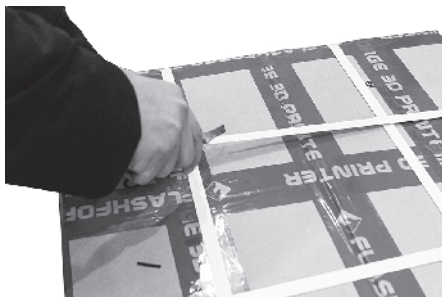
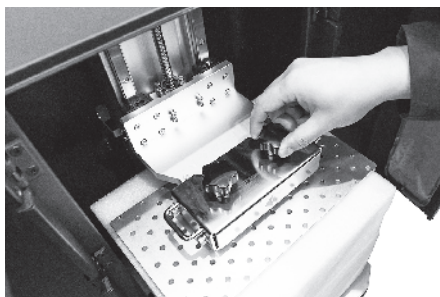1. Cut the tie to open the box.

2. Take out the top foam.

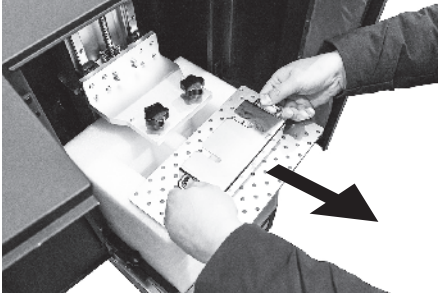3. Lift up and remove the outer box.

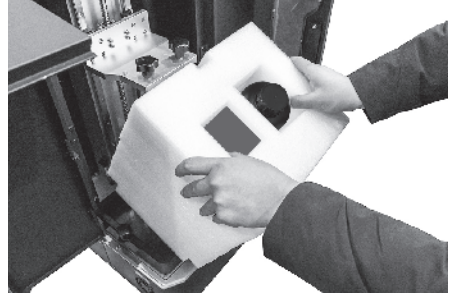4. Remove the foam on both sides.

5. Open the front door of the device and prepare to take out the foam inside.

6. Loosen the platform fastening knob.
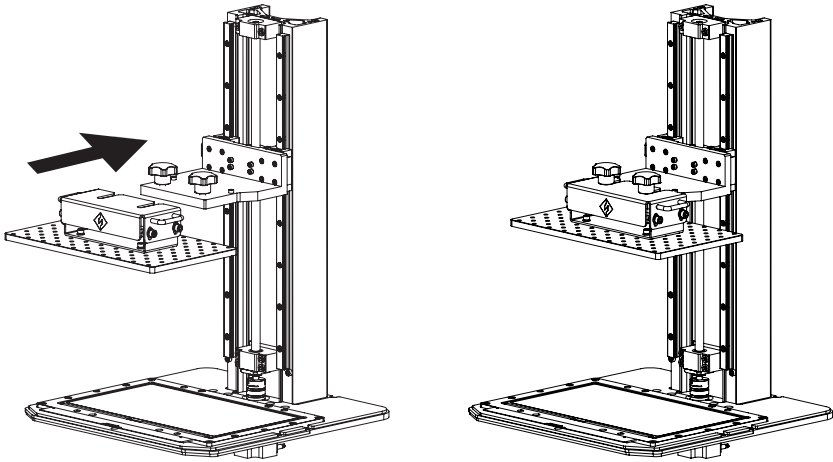
7. Take out the molded platform.

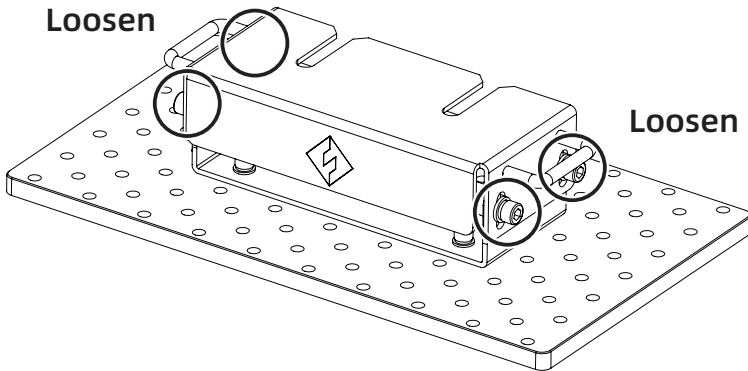8. Remove the foam. Note that there is a bottle of resin and a tool box inside the foam cotton.


9. Complete.

1. Confirm that the printing platform is clean. Install the platform as shown in the picture: fit it on the Z-axis and fasten it with hand-screw nuts.Confirm that there is no misalignment in the installation of the platform and that it is not loose when moved manually.

Loosen

Loosen

2. Loosen the four M6 screws in the upper-adjustment block of the platform assembly. Note that there are two screws on the both sides of the upper adjustment block.
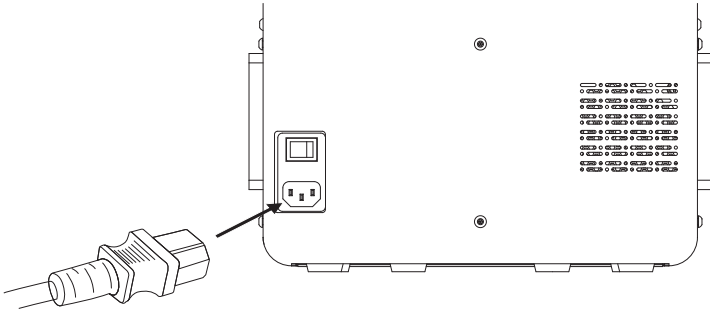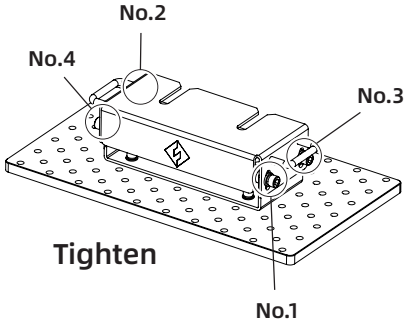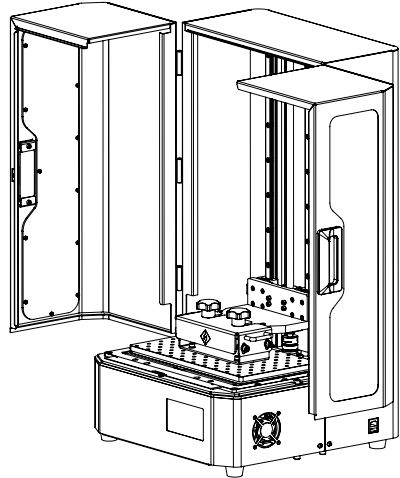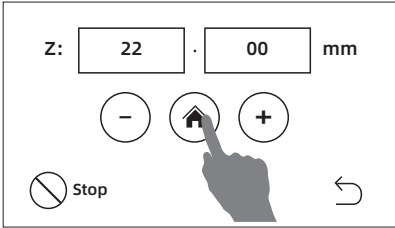
3. Connect the power cable to the adapter, insert the output of the power adapter into the power inlet port on the back of the printer. Turn on the switch.
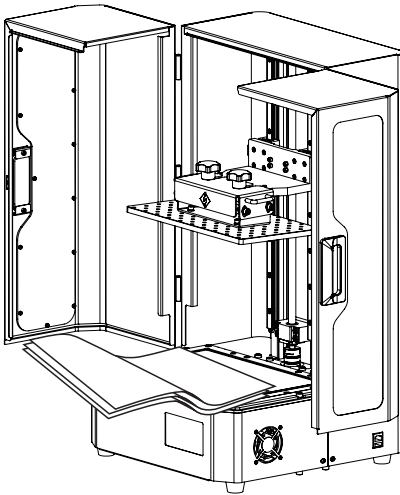
4. Place 3 sheets of A4 paper over the printer screen.
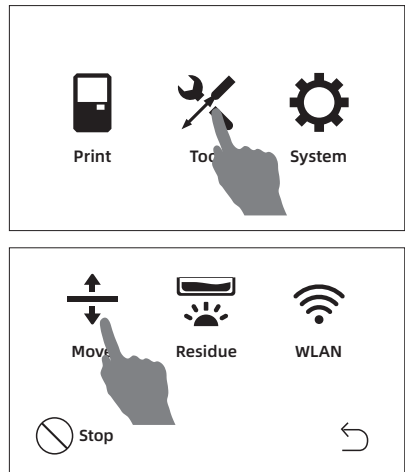
5. Click on [Tools] in the main interface, and then click on [Z-axis Move].

Z: 22 . 00 mm

⊖ ⌂ ⊕

Ⓢ Stop ↩

No.2

No.4

No.3

Tighten

No.1

6. Click on [Reset] to reset the Z-axis and lower the platform to the zeroposition. When the platform is lowered to the bottom, tighten the four M6 screws No.1-4 in sequence according to the figures shown.

Z: 22 . 00 mm

⊖ ⌂ ⊕

Ⓢ Stop ↩
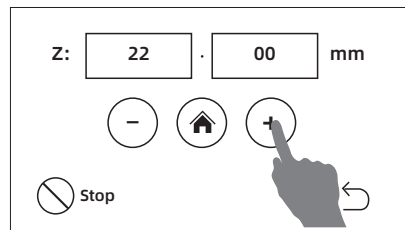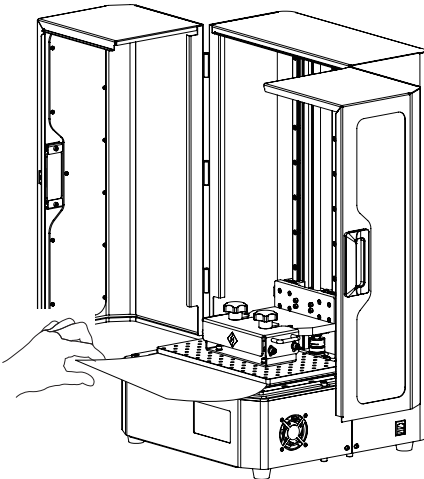
7. Pull the A4 paper back and forth. Make sure some resistance can be felt during pulling.

8. Click on "+" to raise the platform 200-300 mm to complete the leveling.

1. Confirm that the LCD screen and resin box are clean.

2. Take out the resin box and place it carefully on the screen. Pay attention to the orientation of the pouring port and install it in the direction shown on the right.
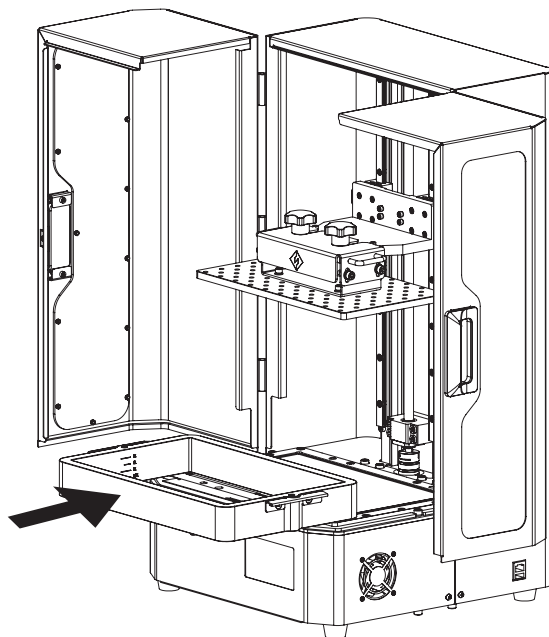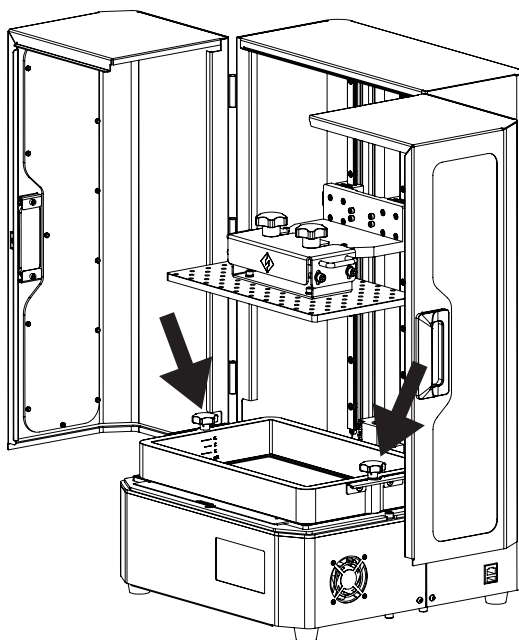
3. Tighten the screws on both sides.

No misalignment and looseness in installation
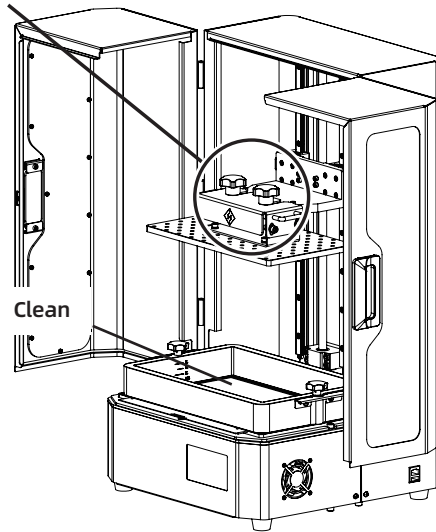
Clean

4. Confirm that LCD screen, build plate and solution box are clean.
5. Make sure that the resin box and platform are installed in alignment and that they are not loose when moved by hand.
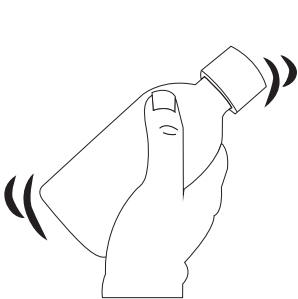
6. Shake the resin to mix itwell.
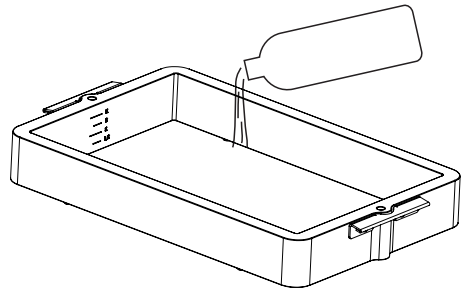
7. Pour the resin into the solution box. Note that level shall not exceed or be lower than the mark lines in the resin box. Close the light shield after all above preparatory steps.

| Print | Tool | System |

File list

🦌 Model-01 ⟫

🦌 Model-02 ⟫

🦌 Model-03

🦌 Model-04 ↩

📄 Model-01

◈ 1000

⏳ 3 h 49 min

◈ 0.05 mm
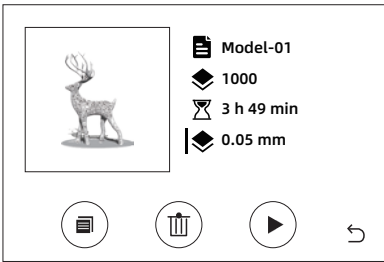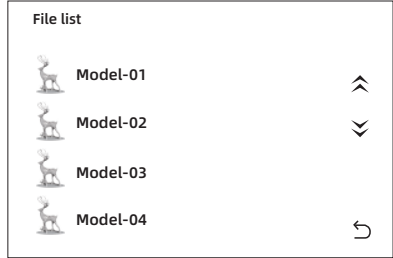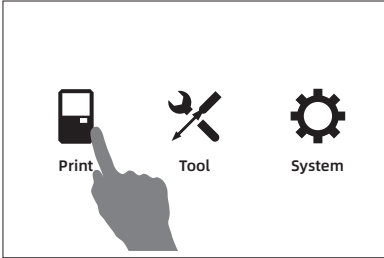
9. Click [Print] to enter the model list. Click the model file to start printing.

1. When the printing is finished, a notification will be displayed.Click [OK], open the light shield, take out the build plate, drain the remaining resin, and shovel the model off with a scraper.

   Note: There will be uncured resin on the model when printing is just finished. Please note that the model must be dried before being processed.

2. Small models are cleaned in an ultrasound device filled with alcohol, while the large models are rinsed in a drum with alcohol.
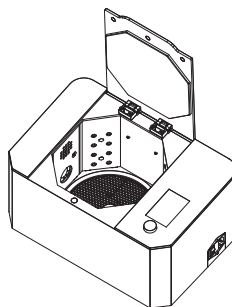
3. After cleaning, dry the model with a dust-free cloth or with an air gun. Put it in the curing box to solidify it again.

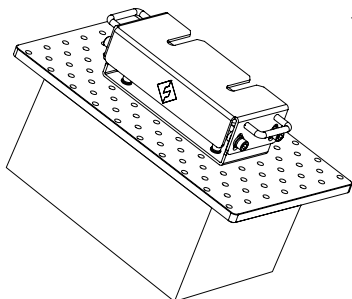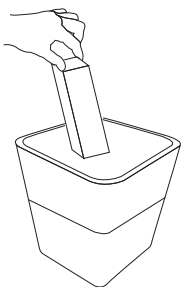5. Clean the device with dust-free cloth and alcohol. Turn off the device.

Note:
1) Take extra care when installing and uninstalling the platform, for it's heavy and might damage LCD screen if were to fall.
2) In the cases of long printing process, regular observations are required. Stop printing when flawed or fallen models appear.
3) Keep the environment clean and dust-free.
4) For novice to do the leveling, please reconfirm the installation and leveling gaps.

4. After filtering the resin, pour it into the resin recycling bottle (separate packing of the new resin is recommended).
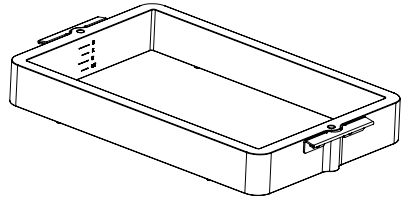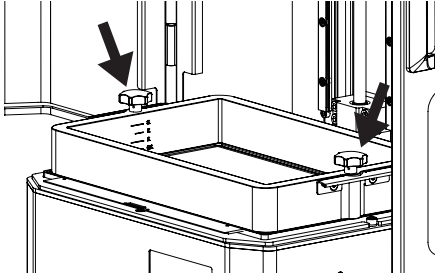
1. Loosen the screws indicated in the picture and take out the resin box. Remove the remaining resin and clean the box.
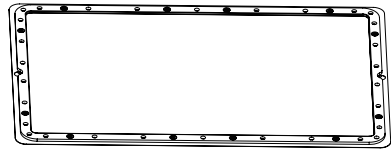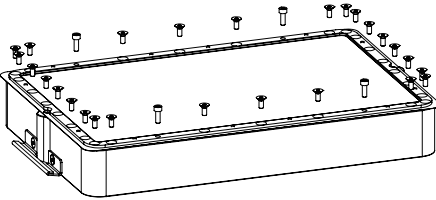
2. Turn the box up side down and loosen the screws on the base. Take out the FEP membrane module to be replaced.

3. Clean the bottom of the resin box and the screws, and prepare a new module. Note: Do not touch and leave fingerprints on the membrane which will affect printing.
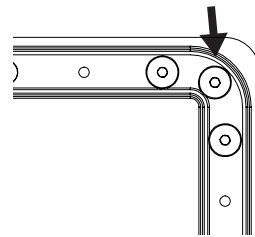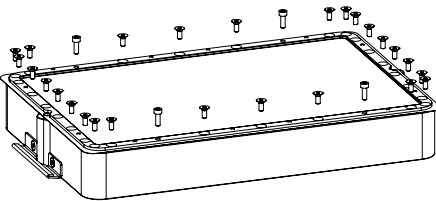
4. Place the FEP membrane at the bottom of the resin box.

5. Tighten the screws on the four corners first.
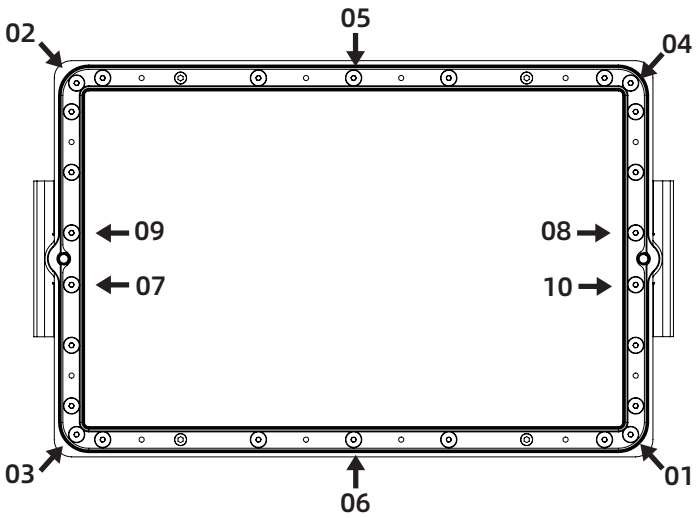
6. Tighten the M4*12 countersunk screws from 1 to 10. Please do it in a diagonal order.
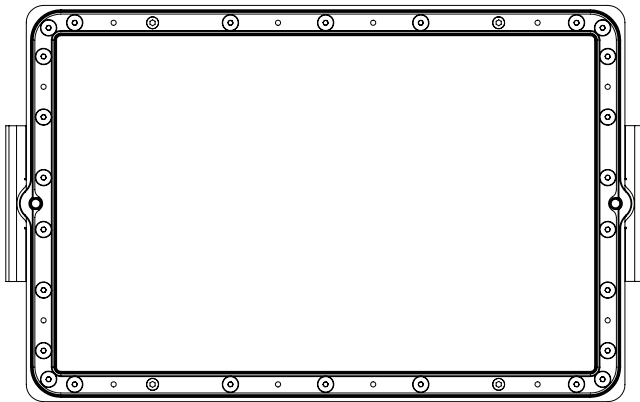
7. Cut off excess FEP membrane (dark part) to finish the replacement. Please double check if the resin box is polluted with dirt, fingerprints, etc. If so, it needs to be cleaned again.

Software Operation

FlashDLPrint

FlashDLPrint.exe

1. Install and run the FlashDlprint.exe program.

Load   Supports   Print

2. Click Load, select the model file.

Set Position

View	
Move	X: 0.00mm
	Y: 0.00mm
	Z: 0.00mm

On Platform Separately

On Platform   Center

Reset

View
Move
Rotate
Scale
Cut
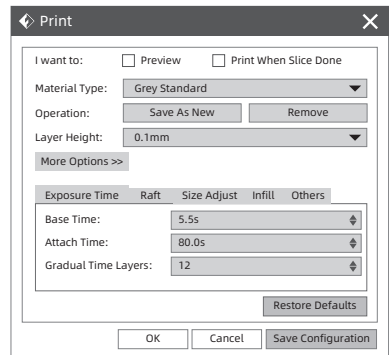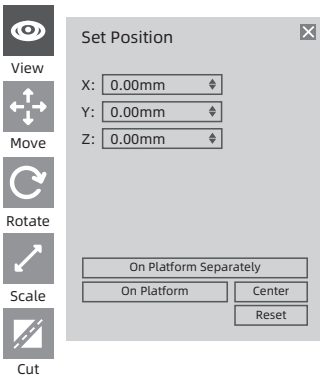
3. Use movement and rotation to place the model in an appropriate position. The model should not be lower than the network surface of the bottom plate.

Print

I want to:	☐ Preview	☐ Print When Slice Done
Material Type:	Grey Standard	
Operation:	Save As New	Remove
Layer Height:	0.1mm	
More Options >>		

Exposure Time | Raft | Size Adjust | Infill | Others

Base Time:	5.5s
Attach Time:	80.0s
Gradual Time Layers:	12

Restore Defaults

OK   Cancel   Save Configuration

4. Click Print, and a print window pops up. (Generally just adjust "layer thickness", "bottom number", "exposure time", "bottom exposure time", etc.)
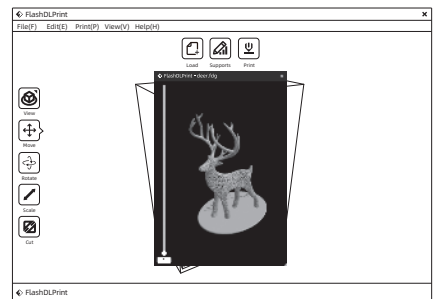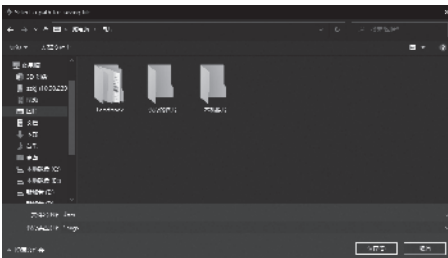
5. Click [OK], select the file type ".svgx ", select the save location, and click [Save S].


Slicing model ...

6. At this point, "Slicing..." will be displayed at the bottom of the interface. , after the section is completed, the interface changes into the section preview interface.

CHITUBOX

1. Install and turn on the ChiTuBox64.exe program.

CHITUBOX V1.8.1

Open Project

Save ProJect

Open...

Save As...
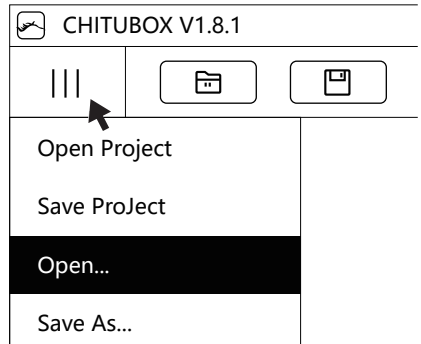
2. Click the 【Open...】in the menu at the upper left corner to select the model files.
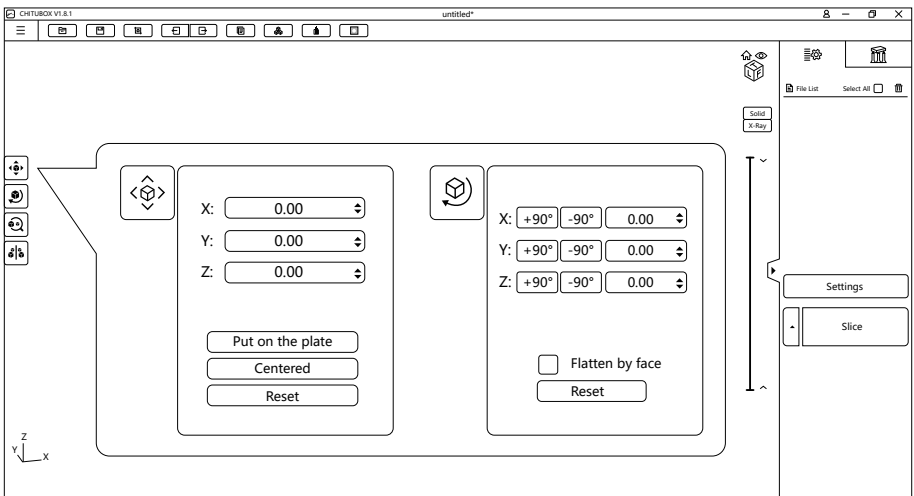
3. Move the model to the right position through movement and rotation. The model cannot be lower than the mesh surface above the raft.

Settings			✕

Default

foto 13.3

foto 8.9

foto 6.0

FLASHFORGE Standard Resin Grey for 0.1mm ▼

| Machine | Resin | Print | Gcode | Advanced |

Layer Height： 0.1 mm

Bottom Layer Count： 1

Exposure Time： 8

Exposure Time： Linear ▼

Exposure Time： 6 s

Bottom Exposure Time： 80 s

Light-off Delay： 0 s

Bottom Light-off Delay： 0 s

Bottom Lift Distance： 10 mm

Lifting Distance： 10 mm

Bottom Lift Speed： 65 mm/min

Lifting Speed： 65 mm/min

Retract Speed： 150 mm/min

4. Click the [Settings] and the pop-up window will appear. Generally, it is enough to adjust the 'Layer Height', 'Bottom Layer Count', 'Exposure Time', and 'Bottom Exposure Time'.
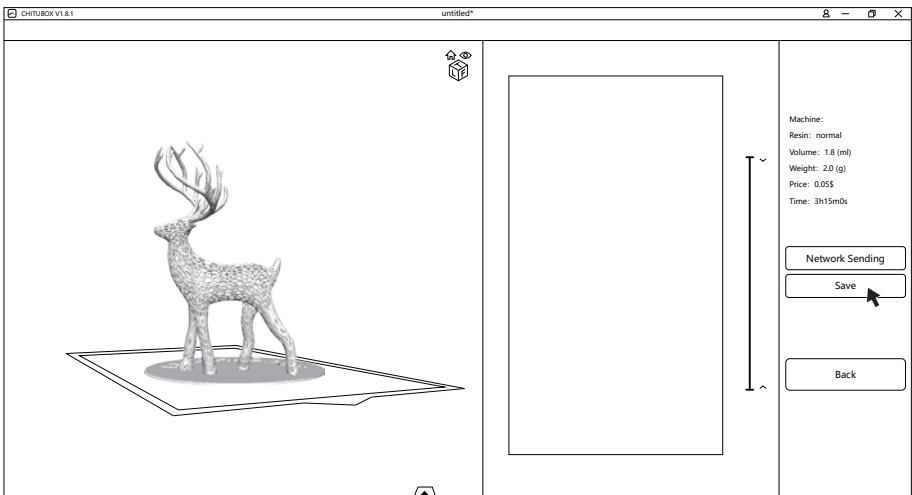
5. After all parameters being set, click the [Slice] and a tip 'Slicing' will show at the bottom right of the interface. When the slicing is done, a preview interface will display.

6. Click the [Save] to save the file type as '.svgx' ; choose the folder and click [Save].
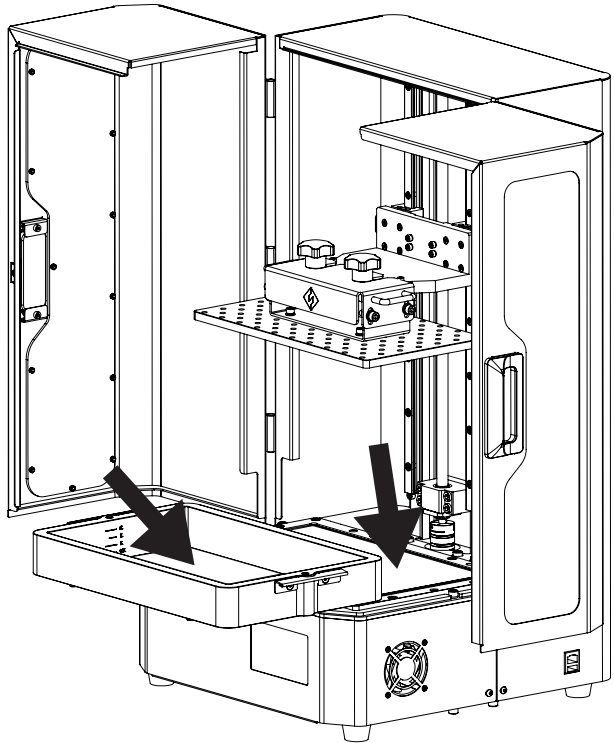
◆ Please keep two parts shown in the picture below clear without dust and fingerprint.
◆ Do not pour the used residual resin back to the resin bottle.
◆ The waste resin can be poured into the sealing bag for sealing and then be exposed to the sun until the resin solidifies.
◆ If the print doesn't work for quite a long time, please pour the residual resin in the resin box into a closed container and keep it away from light. If a solidified model falls into the residual resin, please take it out as soon as possible.

FLASHFORGE®
3D PRINTER

Follow us

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FCC Statement

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.

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

NOTE: 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.

Radiation Exposure Statement

To comply with FCC RF exposure compliance requirements, this grant is applicable to only mobile configurations. The antennas used for this transmitter must be installed to provide a separation di stance of at least 20cm from all persons and must not be co-located or operating in conjunction with any other antenna or transmitter.