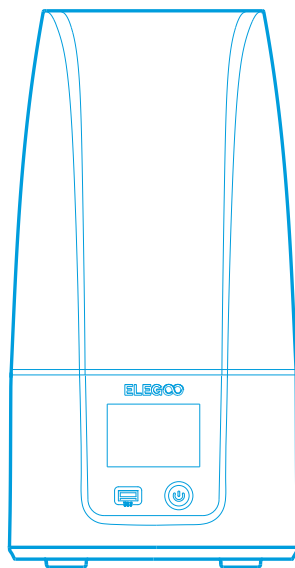


ELEGOO

● **Mars 4**
3D Printer



User Manual

Thank you for purchasing ELEGOO brand products.

V1

After receiving the product, please confirm whether the equipment is intact and the accessories are complete. If there is any damage or missing, please timely contact us at 3dp@elegoo.com. (To ensure the performance of each product, each product will undergo strict printing tests before leaving the factory. There may be some slight scratches when you receive the product, which is normal, please rest assured to use.)

Notice:

- Please keep the 3D printer and its accessories out of the reach of children.
- Please fill the resin tank no less than 1/3 of its volume, but do not exceed the MAX line position.
- Please place the printer in a dry environment and protect it from rain and moisture.
- If you run into an emergency during use, please turn off the power supply of the 3D printer first.
- Please use the printer indoors and avoid direct sunlight and a dusty environment.
- Please keep the original packaging box for 30 days for return/exchange (only ELEGOO original packaging boxes are accepted).
- If the printing fails, you need to clean the excess cured resin in the resin tank and change the resin, otherwise, it may cause damage to your printer.
- When operating the 3D printer, please wear a mask and gloves to avoid direct skin contact with the photopolymer resin.
- If the release film in the resin tank is whitened, scratched, or has no elasticity, the printing failure rate is high, please replace the release film in time.
- Please use 95% (or higher) ethyl alcohol or isopropyl alcohol to wash your model unless you are using water washable resin.
- Please note that the Mylar tape surrounding the screen is not completely airtight. In case of resin drips during use, it is crucial to promptly clean them to prevent resin infiltration and potential screen damage.
- To maintain the cleanliness, durability, and protective performance of the LCD screen, it is necessary to timely replace parts under the following conditions: aged or damaged tape, corrosive damage, and damaged release film.
- If you have any problems with the printer, please contact us at 3dp@elegoo.com. Please do not disassemble or modify ELEGOO 3D printers by yourself, otherwise, the warranty will expire, and damage caused by personal operating errors need to pay for repairs.

Contents

Packing List 01

Printer Introduction 02

3D Printer Tech Specs 04

Leveling 05

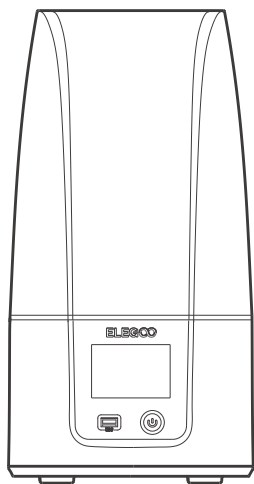
Test Printing 08

Software Installation and Setup 09

FAQ 14

Machine Maintenance 16

Warranty Statement 17



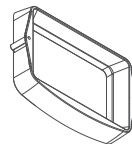
Mars 4 3D Printer



USB Air Purifier



Build Plate



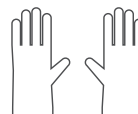
Resin Tank



U Disk



Mask



Gloves



Funnel



Backup Screws



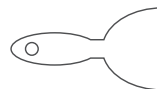
User Manual



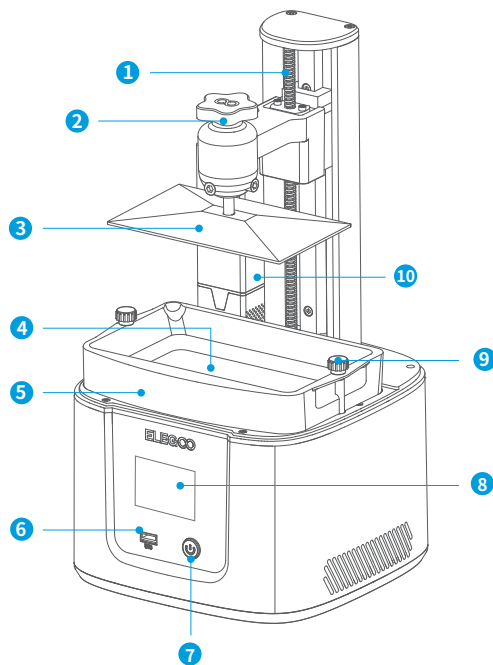
Adapter



Tool Kit



Scraper



1
Z Axis

2
Screw Knob

3
Build Plate

4
LCD Display Screen

5
Resin Tank

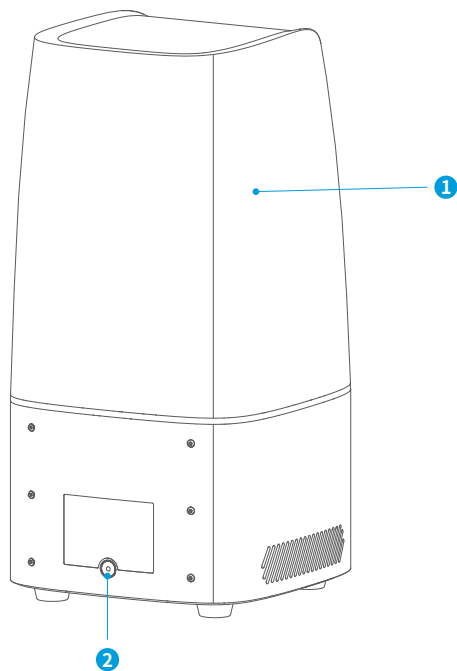
6
USB Interface

7
Switch

8
Touch Screen

9
Screw Knob

10
USB Air Purifier



1
Anti-UV Cover

2
DC Socket

Printing Parameter

- System: EL3D-3.0.1
- Operation: 3.5-inch Touch Screen
- Slicer Software: CHITUBOX & Voxeldance Tango
- Connectivity: USB Interface

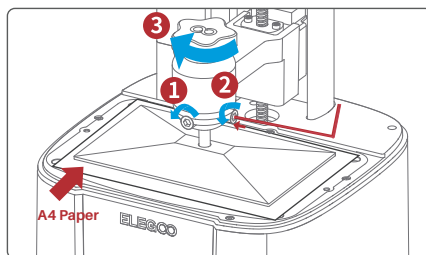
Hardware Specification

- Dimension: 227mm(L)*227mm(W)*438.5mm(H)
- Build Volume: 153.36mm (L)*77.76mm (W)*175mm (H)
- Package Size: 605mm(L)*270mm(W)*285mm(H)
- Gross Weight: 7.3KG
- Net Weight: 5.5KG

Printing Specification

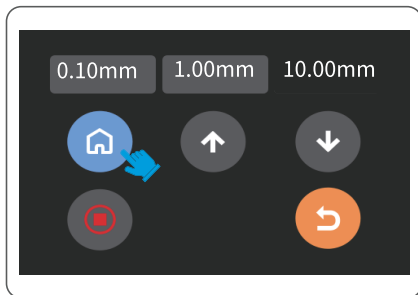
- Technology: MSLA Stereolithography
- Light Source: COB (wavelength 405nm)
- XY Resolution: 18*18um (8520*4320)
- Z-axis Accuracy: 0.02mm
- Layer Thickness: 0.01-0.2mm
- Printing Speed: MAX 70mm/H
- Power Requirements: 100-240V 50/60 Hz 24V 3A

1. Remove the resin tank, lock the screw knob (3) of the build plate, and then loosen the 2 fixing screws (1 2) of the build plate until the build plate can move freely. (See Picture 1)

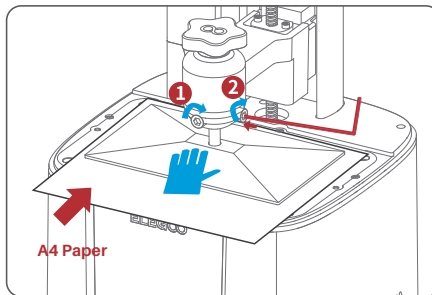


(Picture 1)

2. Place a leveling card between the build plate and the LCD screen, then click "Move Z axis to zero" (See Picture 2). After the printer stops moving, press the top of the build plate with one hand, and lock the fixing screws (1 2) with the other hand. (See Picture 3)

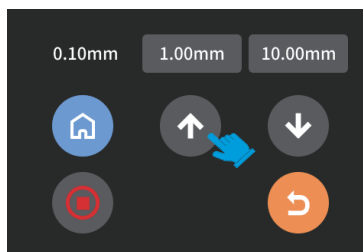
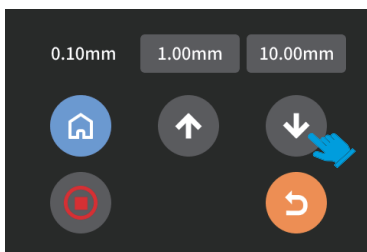


(Picture 2)



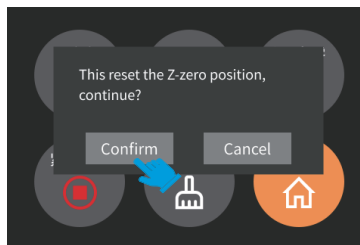
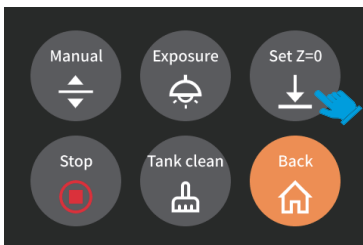
(Picture 3)

3. Pull the leveling card. If you find there is a slight resistance during this process, you can go directly to step 5. (Note: If there is no resistance when pulling out the leveling card, please click the Z-axis "down" button (in steps of 0.1mm) until there is a slight resistance to pull the leveling card. If there is too much resistance or the leveling card cannot move, please click the Z-axis "up" button (in steps of 0.1mm) until there is slight resistance to pull the leveling card.) (See Picture 4)



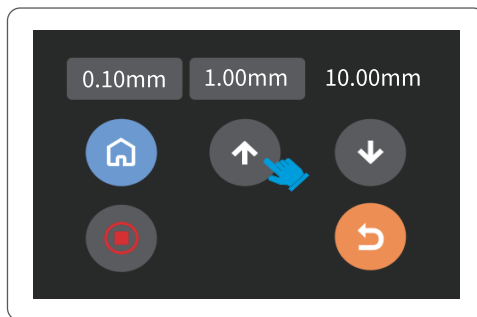
(Picture 4)

4. After completing the above operations, back to the previous menu, and click "Set Z=0", then a confirmation pop-up window will appear in the interface, click "Confirm" to complete the setting. At this time, the current Z-axis position is reset to the new initial height of the first printing layer. (See Picture 5)



(Picture 5)

5. Click back to the "Manual" page, and click the Z-axis "up" button to raise the Z-axis by a certain distance.
(about 100mm) (See Picture 6)



(Picture 6)

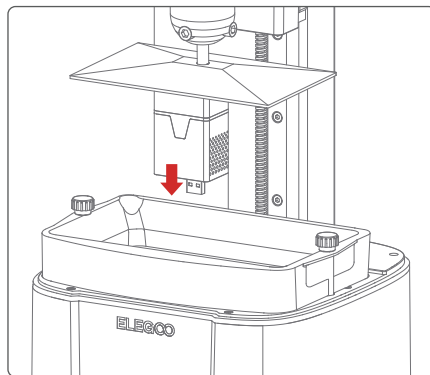
6. Take away the leveling card, and click the "Tool" - "Exposure" - "Next" buttons to test the LCD screen and LED light source. If the LCD can display "ELEGOO TECHNOLOGY www.elegoo.com", then the 3D printer works perfectly. At this time, the leveling is completed, install the resin tank and ready for printing. (See Picture 7)



(Picture 7)

1. Model Printing

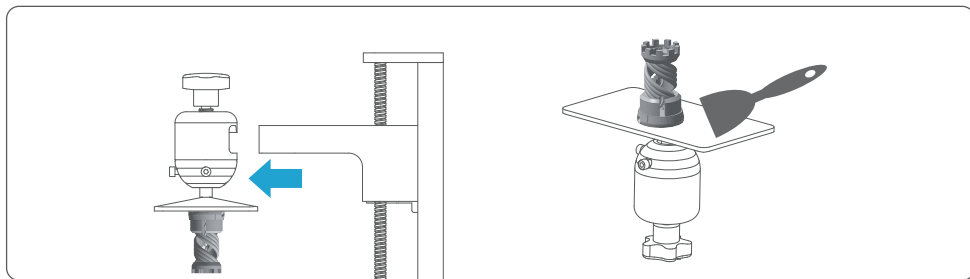
Plug the USB air purifier into the USB port (See Picture 8), then slowly add resin to the resin tank (do not exceed the MAX line height). Cover the printer and then insert the U disk into the printer and select the pre-sliced test model for printing.



(Picture 8)

2. Model Processing

After the printing is completed, wait until the resin on the build plate stops dripping, then loosen the screw knob of the build plate to remove it and remove the model with a scraper. You can use ELEGOO's cleaning and curing machine to post-process the model. (See Picture 9)



(Picture 9)

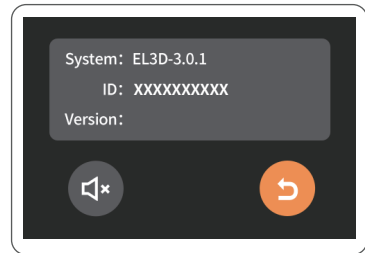
The printer can install and use CHITUBOX and Voxeldance Tango slicing software in the USB flash drive, here we take Voxeldance Tango as an example.

1. Install Voxeldance Tango

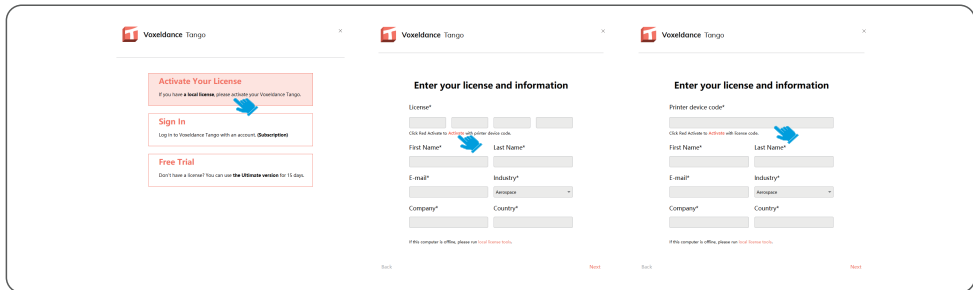
Select the right version of slicing software on the USB flash drive and install it on your computer.

2. How to Use Voxeldance Tango

2.1 Once the installation is complete, run the Voxeldance Tango software, select "Activate your license" - "Activate with printer hardware code" (See Picture11); Press "Settings" - "System" on the machine to view the machine "ID" (See Picture 10), and fill in the 10-digit "ID" into the "Printer Hardware Code" column of the software, and fill in other relevant information to complete the software activation.



(Picture 10)



(Picture 11)

2.2 Click File-Open File, and then open your own 3D model file (stl. format), You can control and change the viewing angle, size, and position of the model by left-clicking on the model, and use the options on the upper menu.

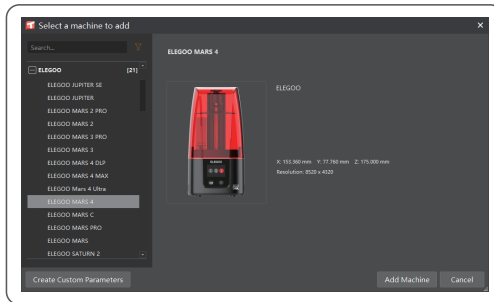
Elegoo Voxeldance Tango

Other operations:

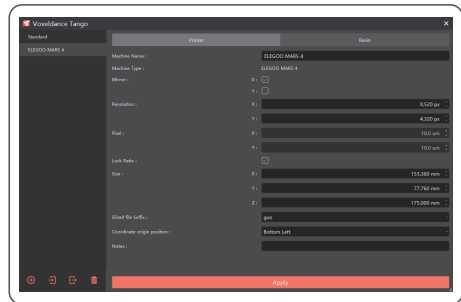
- 1) Click on the model, left-click and long-press the center point of the model, and drag the model to the position you want.
- 2) Scroll the mouse wheel to zoom in or zoom out the model.
- 3) Long press the right mouse button and rotate to see different perspectives of the model.

3. Voxeldance Tango Setting

3.1 Click "Parameter Settings" and choose ELEGOO Mars 4 as your default printer. (See [Picture 12](#))



(Picture 12)



(Picture 13)

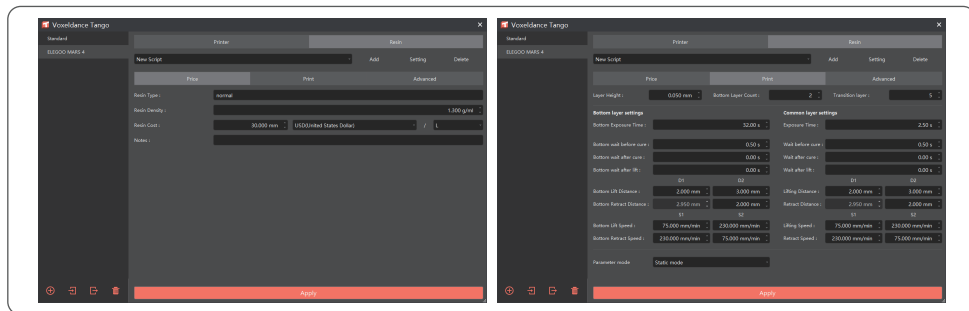
3.2 Build Volume

You don't need to change the default parameters ([See Picture 13](#)), and X indicates the maximum print size in the X-axis direction, and so on.

3.3 Resin Parameter (See Picture 14)

Resin Density: 1.1g/ml

Resin Cost: You can input the real price of the resin you purchased, and the slicing software can calculate the resin costs for each model you print.



(Picture 14)

3.4 Parameters (See Picture 14)

Layer Height: The thickness of each printed layer, the recommended height is 0.05mm, but you can set it from 0.01-0.2mm. The higher thickness you set, the longer time it will take for exposure of each layer.

Bottom Layer Count: The setting number of initial printing layers. If the number of bottom layers is n, the exposure time of the first n layers is the exposure time of the bottom layer, the default setting is 2.

Exposure Time: The exposure time for normal printing layers. The default exposure time is 2.5 seconds, and the thicker the printing layer setting is, the longer time it will take.

Transition Layers: The number of transition layers after the bottom layer to make it stickier between layers. Except for the exposure time, other parameters of the transition layer are the same as the normal layer.

Bottom Exposure Time: The setting of bottom layer exposure time. Properly increasing the bottom layer exposure time can help to increase the stickiness between the printing model and the build platform; the default setting is 32 seconds. The longer the setting time, the stickier the bottom layer will be on the build platform.

Wait After Lift: After printing platform is lifted, the time difference between the printing platform starts to stationary and starts to return, the default setting is 0 seconds.

Wait Before Cure: After the build platform moves to the printing surface, the time difference between the build platform starting to stationary and starting to exposure, the default setting is 0.5 seconds.

Wait After Cure: The time difference between the end of the exposure and the start of the build platform to leave the printing surface, the default setting is 0 seconds.

Bottom Wait After Lift: When printing the bottom layer, the time difference between the build platform starting stationary and starting to return to the printing surface after lifting, the default setting is 0 seconds.

Bottom Wait Before Cure: When printing the bottom layer, after the build platform moves to the printing surface, the time difference between the build platform starting stationary and the start of exposure, the default setting is 0.5 seconds.

Bottom Wait After Cure: When printing the bottom layer, the time difference between the end of the print exposure and the start of the build platform to leave the printing surface, the default setting is 0 seconds.

Bottom Lift Distance: During the bottom printing process, the distance that the build platform leaves the printing surface each time, the default setting is 2+3mm.

Lifting Distance: In the normal layer printing process, the distance that the build platform leaves the printing surface each time, the default setting is 2+3mm.

Bottom Retract Distance: During the bottom printing process, the retract distance of the build platform, do not change if not necessary.

Retract Distance: In the normal layer printing process, the retract distance of the build platform, do not change if not necessary.

Bottom Lift Speed: During the bottom printing process, the moving speed of the build platform away from the printing surface each time, the default setting is 75+230mm/min.

Lifting Speed: In the normal layer printing process, the moving speed of the build platform away from the printing surface each time; the default setting is 75+230mm/min.

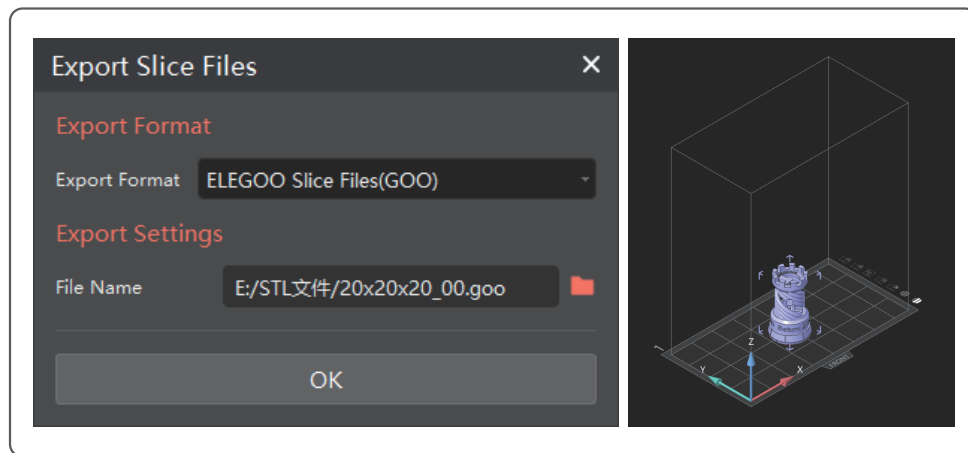
Bottom Retract Speed: During the bottom printing process, the moving speed of the build platform is close to the printing surface; the default setting is 230+75mm/min.

Retract Speed: In the normal layer printing, the moving speed of the build platform is close to the printing surface; the default setting is 230+75mm/min.

Parameter Mode: The default static mode allows the printer to print according to the parameters set in the slicing software, or you can choose the high-speed mode or smooth mode, the printer will dynamically adjust the printing parameters according to the complexity of the model to improve the printing quality and printing speed.

4. Save the Model

After setting up all the parameters, click "Slice", and once it's done, click "Save" to export the sliced file and copy it to U Disk; then insert the U disk into your printer, and start printing. (See Picture 15)



(Picture 15)

1. Model doesn't stick to the build plate

Bottom layer exposure time is too short, please add more time.

Model bottom has very small contact with the build plate and please add more bottom layers.

2. Model layer breakage

Printer is shaking during printing.

Release liner film is very loose due to long-time usage and need to be changed.

Build plate or resin tank is not fastened.

3. Abnormal Screen Exposure

If your printer doesn't work please contact us at 3dp@elegoo.com.

and as to better help and solve problems for you, please add your order ID in your email.

4. Printing failure

If the model was not completely printed or failed, there might be some residues left in the resin, which can be filtered out using a funnel when you save the rest resin back into its sealed bottle.

If you don't filter out the residues the build plate may cause damage to the LCD screen when you're printing next time.

As to the residual resin on the build plate and tank, you can clean and wipe them up using tissues.

5. Why do I receive an error message for residue detection when starting a print

First, check if the resin tank and build plate are properly secured. Then, try printing again. Avoid touching or causing vibrations to the machine during the self-check process before printing to prevent sensor calibration issues. If the error persists, clean the resin tank or filter the resin for any tiny foreign objects.

6. Why do I get resin insufficient or exceeding maximum volume error when starting a print

At the beginning of the print, the mechanical sensor detects the remaining resin in the tank. To ensure smooth printing, the resin level must be above one-third of the tank volume. Additionally, the resin level should not exceed the MAX line to prevent leakage. If the required resin amount for the model exceeds the current resin level in the tank, a pop-up message will prompt for resin refilling. If you encounter abnormal errors, recalibrate the device through the self-check process. Remember not to touch or vibrate the machine during self-check to avoid affecting sensor calibration.

7. How to adjust the printing speed

The release speed of the printer is fixed, with two modes available: fast and slow. However, regardless of the mode, the first 50 layers are always printed at a slower speed to ensure a higher success rate. The actual printing speed per layer also depends on the settings of the slicing parameters, such as layer thickness, exposure time, and wait time. Changing these parameters will alter the actual printing speed.

8. What should I do if resin leaks into the machine

Due to the nature of tilted release motion, it is not possible to achieve a completely sealed printing area. To address this, we have implemented several protective measures. When the sensor detects resin exceeding the MAX line, the print will stop, and a pop-up window will appear as a warning. There is a groove design below the build plate, where a small amount of leaked resin can flow into without affecting the machine. However, if a significant amount of resin spills occur, please disconnect the power promptly and open the front panel of the machine for cleaning.

- Please do not use sharp or pointy tools to scrape the resin tank to avoid damaging the release liner film.
- Please clean up the resin tank before changing the resin to another color.
- Before and after printing, clean the build plate with paper towels or alcohol to ensure that there are no bumps or burrs on the build plate.
- Before each printing, daily check the exterior of the machine and all mechanical parts for any obvious damage, defects, or abnormalities.
- Try to keep the printing environment at 25-30 degrees Celsius when printing, and ventilate the printing room as much as possible to facilitate heat dissipation of the machine and resin odor volatilization.
- If the Z-axis keeps making friction noise, please add some lubricant to the lead screw. Please check and apply lubricant grease at least every 2-3 months, and increase the frequency of application as the printing frequency increases.
- If you don't use the printer in the next 48 hours, please pour the remaining resin from the resin tank back into the resin bottle and seal it well. If there is any residue, please use a filter to filter it out.
- The release film is a wearing part, please replace it regularly according to the machine prompts to ensure the success rate of printing.
- Please be careful when removing the printing platform to prevent damaging the LCD screen. The service life of the screen is about 2000+ hours and will decrease with increasing printing frequency. Do a good job of daily screen cleaning, and unplug the machine in time after printing. If there is a screen exposure problem or service life has seriously affected the print quality, please replace the screen in time.

● ELEGOO printers are covered by a warranty starting from the date of receipt. The warranty periods for different components may vary. For detailed information, please visit our official website at <https://www.elegoo.com/pages/refund-policy>.

● The free warranty does NOT include problems caused by self-disassembly and improper use, and wear and tear of the machine housing, etc.

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