BRESSER® T-REX²

3D printer

Art. No. 2010600

Quickstart Guide

⚠ WARNING!

- **Hot surfaces! Do not touch the heat nozzle and the construction platform in operation!**

- **Danger! Moving parts in printer may cause injury. Do not wear gloves or other sources of entanglement in operation!**

More informationen, updates or software

Visit our website using the following QR code or weblink to find additional information, available updates or software for this product or realted accessories:

www.bresser.de/P2010600

After Sales Support / Service

We offer an individual service for this product beyond the purchase. If you have any problems with the product, our support team will be happy to assist you.

For a smooth process, please keep the following information handy for possible inquiries:

• Warranty/Service card
• Article number and Product description
• Date of purchase and dealer

Contact details:

e-Mail: **service.3d@bresser.de** (preferred communication)
Internet: **www.bresser.de/c/de/service**
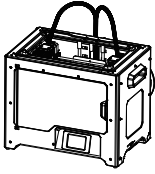Phone*:   **00 800 – 63 43 7000**

Service hours:

Monday to Friday (except national public holidays)   9:00 a.m. to 3:00 p.m. CET

* free hotline throughout Europe

Warranty

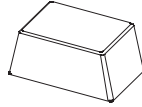Please refer to the separate warranty & service card for any warranty information.

Set contents

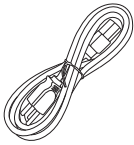|		
3D printer	Filament spool	Top cover

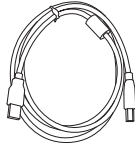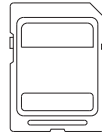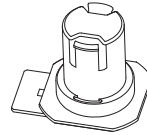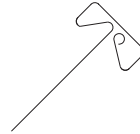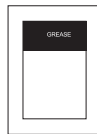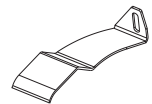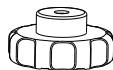|				
3D printer	Filament spool	Top cover	Service card	Quickstart guide
Power cable	USB cable	SD card	Spool holder	Build tape
Screwdriver	Stamping wrench	Allen wrench	Pin tool	Scraper
PTFE tube	Guide tube	Grease	Glue stick	Anti-oozing plate
Levelling card	Levelling nut			
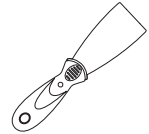
Unpacking

This 3D printer set was packed with care. Please follow the unpacking steps laid out below.

⚠ CAUTION!

- **Remove the package and take out accessories carefully! Do not use force!**

- **Do not tear off the yellow adhesive tape around the nozzle. It has thermal insulation and high temperature resistance characteristics.**
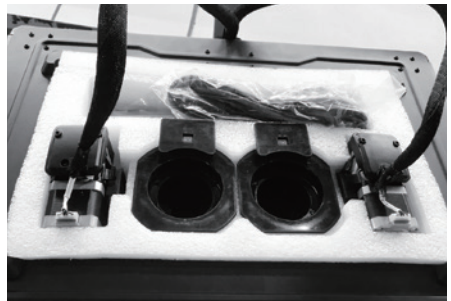

1. Open the box and remove the top foam piece.

2. Firmly grasp the two side handles of the 3D printer. Lift it out of the carton and place it on a stable and plane surface.
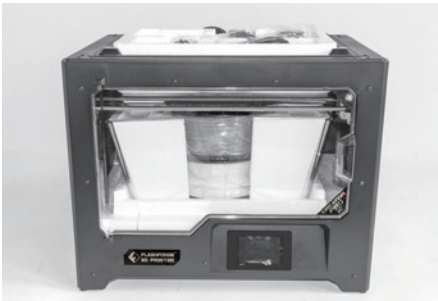
3. Remove the packaging bag and then remove the tape and plastic wrap for protecting the front door.


4. The accessories are placed in a foam shape in the printer's top opening. Take out all accessories except the two extruders which are alraedy cable connected with the printer.

5. Carefully take the extruder out of the foam shape. Avoid the nozzle touching the desk to prevent from scratching it.
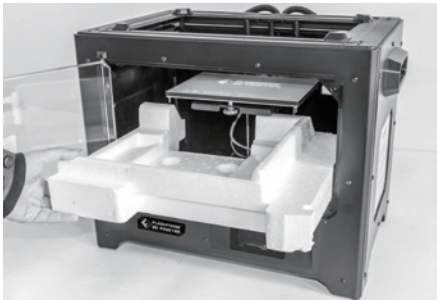

6. Remove the foam shape. Use a scissors to cut the two ties on both sides of the x-axis guide rail and remove them.
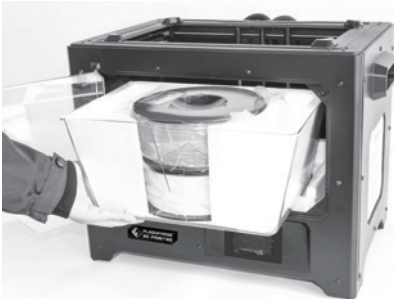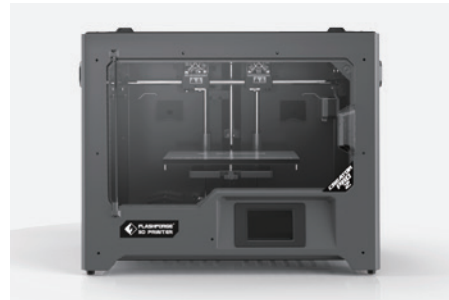

7. Open the door and take out the printer's top cover lid. Take the filament out of the lid.

8. Hold the printing platform on both sides and lift it up slowly to facilitate the removal of the foam piece below.
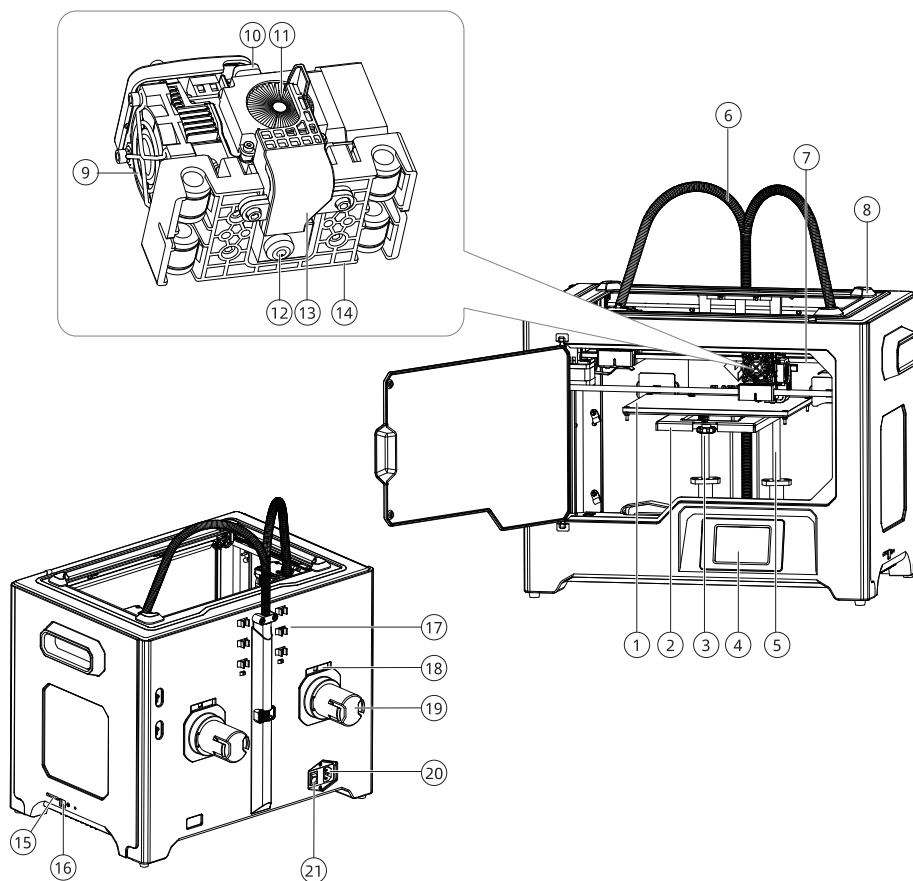

9. Take the foam piece out of the printer's bottom. Slowly press the platform downwards by hand to the lowest position for easy subsequent installation.

10. Unpacking is completed. It is recommended to keep the packaging material for further transportation or storage.

1. Printing platform
2. Platform support
3. Leveling nut
4. LCD panel
5. Z-axis guide rail
6. Extruder cable bunch
7. X-axis guid rail

8. Slot
9. Nozzle cooling fan
10. Spring presser
11. Main cooling fan
12. Nozzle
13. Turbofan baffle
14. Extruder bracket

15. SD card slot
16. USB cable input
17. Guide tube buckle
18. Spool holder slot
19. Spool holder
20. Power input
21. Power switch

Assempling the extruder
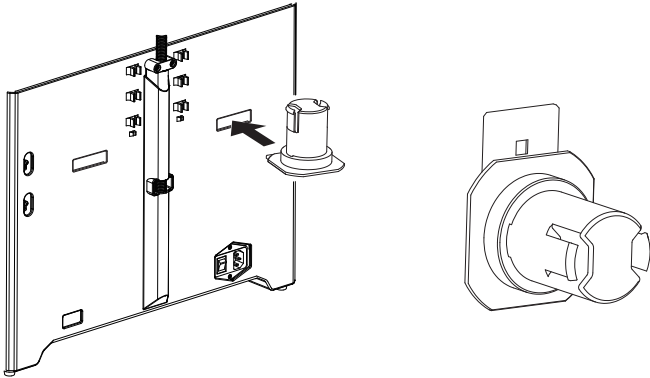
1. Lower the platform and place the dual extruder on the extruder seat.

2. Take the M2.5 Allen wrench from the tool bag and four M3 bolts from the accessory kit.

3. Adjust the extruder above the extruder bracket to align the holes for the bolts.

4. Fix the extruder onto the extruder bracket by screwing in the M3 bolts as shown.

Holes for bolts

Extruder

Extruder bracket
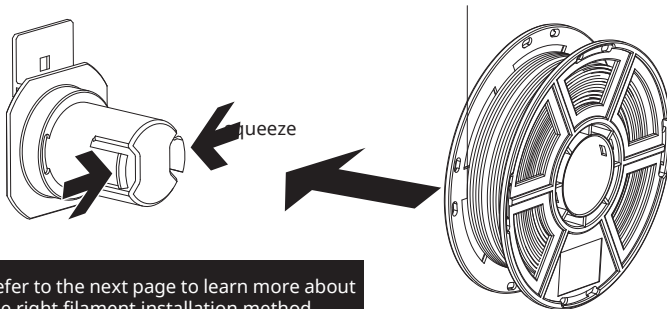
Bolts
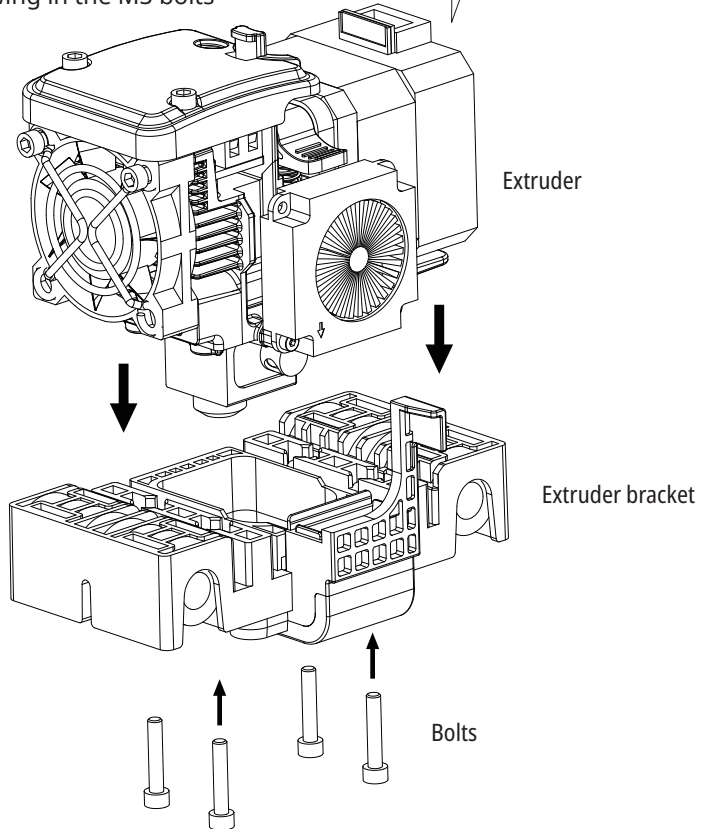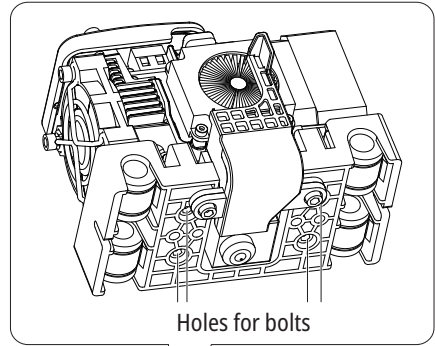
1. Level the spool holder and insert it with its plate facing forward into the corresponding opening at the printer's backside.
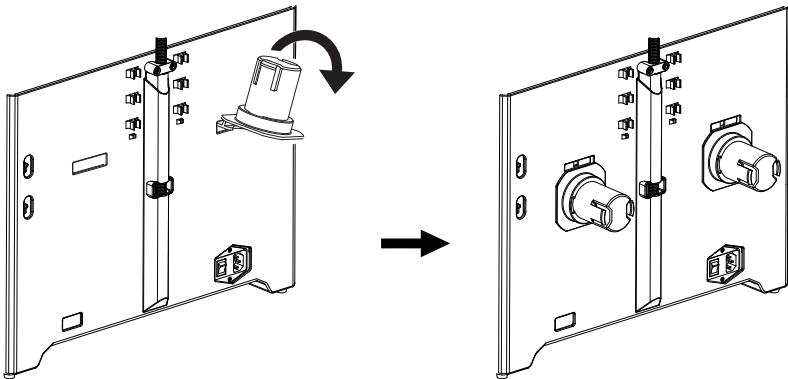
2. Turn down the spool holder to make the holder bottom cleave to the printer's backside.

Squeeze

Refer to the next page to learn more about the right filament installation method.

3. Squeeze the spool holder top and put the filament spool onto the holder.
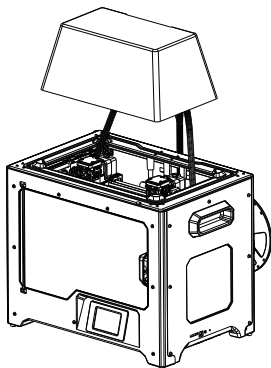
1. The filament spool must be oriented corectly (see below illustrations)

2. After the guide tube fixation is completed, press the left spring presser of the extruder, put the filament vertically into the left filament intake from the other end of the guide tube.

Guide tube buckle

Limited seat

Lock the guide tube with R-shape buckles.
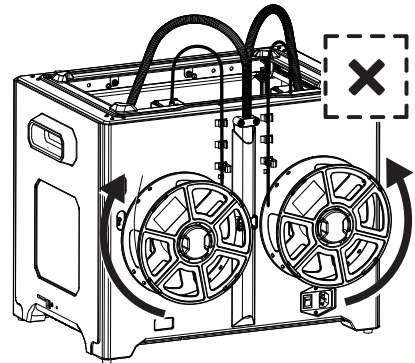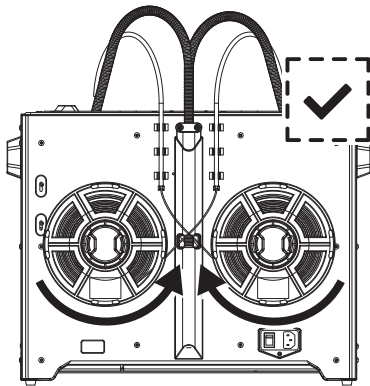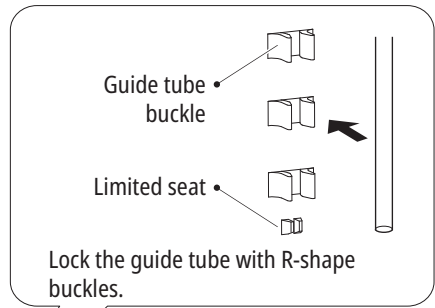
NOTE: Pay attention to extend the guide tube to the inside of the spool to prevent the filament from being wrapped outside the spool.
Make sure that the two filament strands are installed in crossed position.

Fix the anti-oozing plate by two M3x8 screws.

M3x8

Make sure that the nozzle touches the anti-oozing plate properly when installed. The distance between the nozzle and the plate can be adjusted manually. After printing, scratches on the plate surface can be visible. This is not a failure but normal.

Install the top cover when printing ABS. Remove the top cover when printing PLA.

General settings

Loading/Unloading the filament

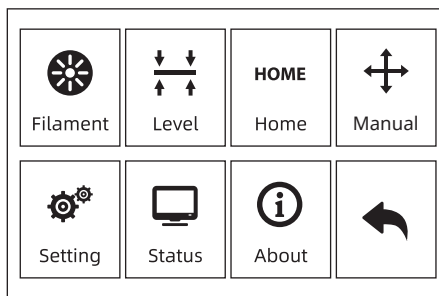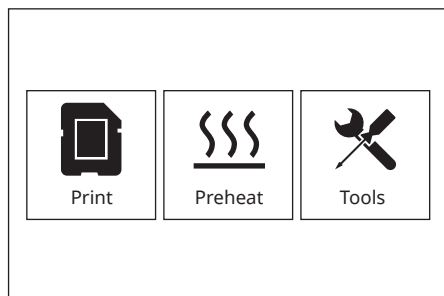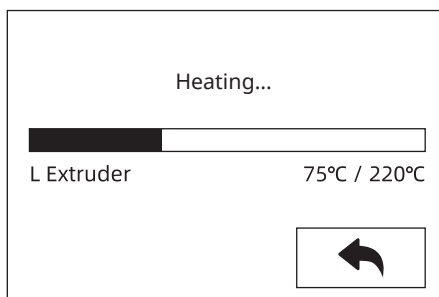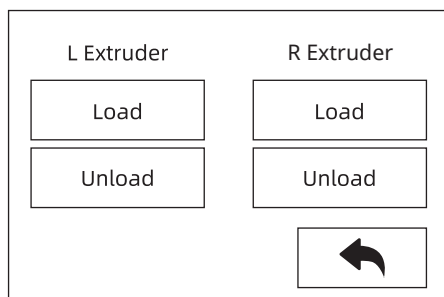|		
Print	**Preheat**	**Tools**

Filament	Level	HOME / Home	Manual
Setting	Status	About	

1. Tap on [Tools] > [Filament]

L Extruder	R Extruder
Load	Load
Unload	Unload

Heating...

L Extruder   75℃ / 220℃

2. Tap on [Load] to start the extruder heating up. After the target temperature is reached, manually insert the filament into the filament feeding wheel. When the filament is ejected from the nozzle, it indicates that loading is completed.
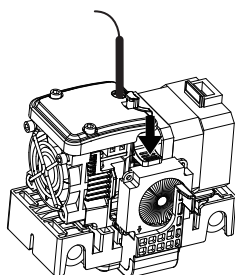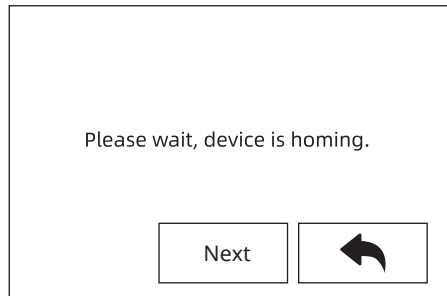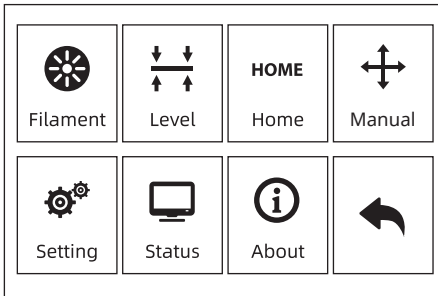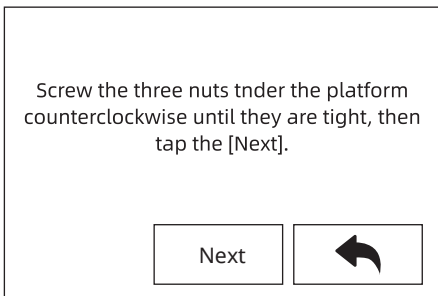

2. Tap on [Unload] to start the extruder heating up. After the target temperature is reached, manually feed out a part of filament from the nozzle. Then at the same time press down the spring presser and quickly pull out the filament.

✳ Filament	↓↓↑↑ Level	HOME Home	✛ Manual
⚙ Setting	🖵 Status	ⓘ About	↩

Please wait, device is homing.

Next ↩

1. Tap on [Tools] > [Level] to start leveling. The printer will finish homing first.

Screw the three nuts tnder the platform counterclockwise until they are tight, then tap the [Next].

Next ↩

2. After stoping movement of extruder and platform, tighten the three nuts below the platform counterclockwise.

IMPORTANT NOTE: This needs to be done to avoid scratches to the build plate by the extruder!

Please adjust the front thumb screw under Platform when stop.
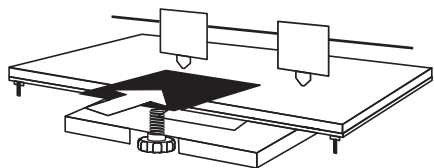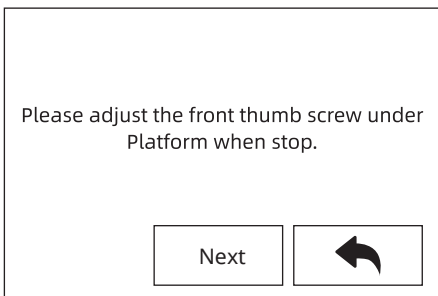
Next ↩

3. Choose one extruder and move it to the first nut by hand. Place a paper under the extruder and tighten the nut to reduce the distance between extruder and platform. Gently move the paper and feel the friction. If the paper can be moved with gent friction, the distance between extruder and platform is suitable. Finish the initial placement and repeat this step for the secend and third nut.

NOTE: A small distance between extruder and platform causes removing printed objects hard, while a big distance causes adhesion fails or wrapping.

Z-axis calibration

Print	Preheat	Tools

Filament	Level	HOME Home	Manual
Setting	Status	About	
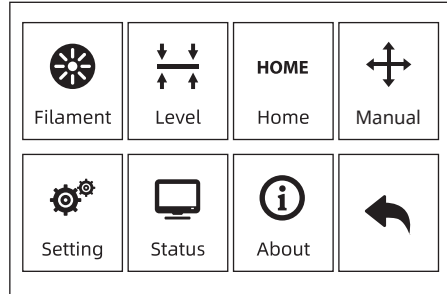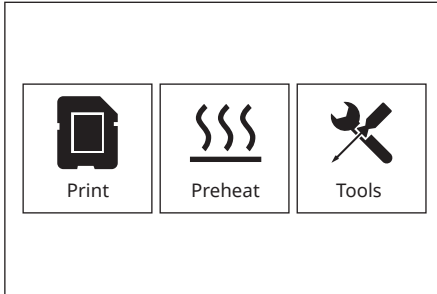
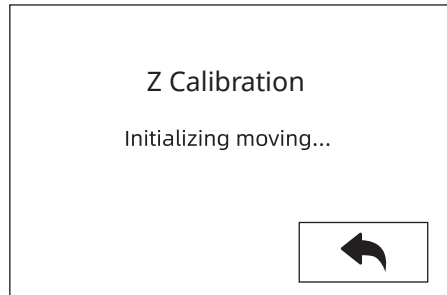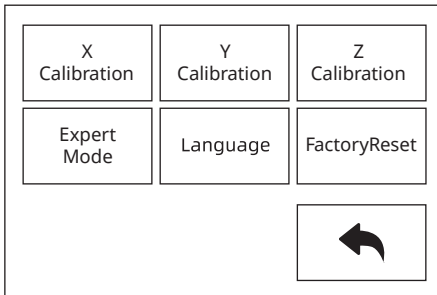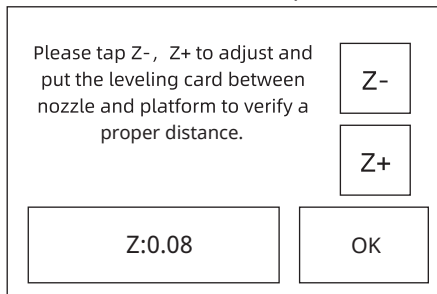1. Tap on [Tools] > [Setting] > [Z calibration]. The printer uses a compensation layer mechanism. Instead of manually adjusting the installation positions of the left and right nozzles, a program is used to calculate the height difference between the two nozzles.

X Calibration	Y Calibration	Z Calibration
Expert Mode	Language	FactoryReset

Z Calibration

Initializing moving...

2. Tap [Tools] > [Setting] > [Z calibration]. The printer uses a compensation layer mechanism. Instead of manually adjusting the installation positions of the left and right nozzles, a program is used to calculate the height difference between the two nozzles. The extruder and platform will return to the zero position first, select any extruder to calibrate. The sytem is waiting until the temperature is cooled down to 50 ° C to prevent the nozzle from scalding the build tape.
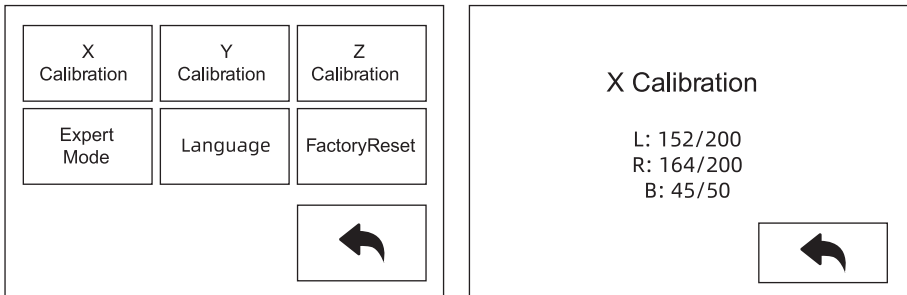
Please tap Z-，Z+ to adjust and put the leveling card between nozzle and platform to verify a proper distance.

Z–

Z+

Z:0.08

OK

NOTE: Do not turn the nuts under the platform during Z-axis calibration.

3. Follow the on-screen instructions and insert the leveling card between the nozzle and the platform. Tap on [Z-] or [Z+] to adjust the appropriate spacing. The adjustment range is sliding leveling paper. If you feel a little frictional resistance, it indicates that the distance between the nozzle and the platform is appropriate. When on extruder is adjusted, it will be switched to another extruder for calibration.
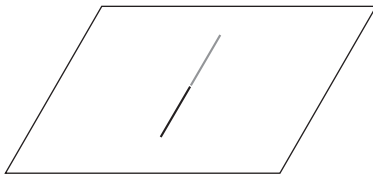
X-axis calibration is used to adjust the consistency of the two extruders in the X-axis direction to prevent misalignment during printing.

IMPORTANT NOTE: Make sure that the filament has been inserted into the extruder before starting the x-axis calibration.

X Calibration	Y Calibration	Z Calibration
Expert Mode	Language	FactoryReset

X Calibration

L: 152/200
R: 164/200
B: 45/50

1. Tap on [Setting] > [X Calibration], or continue the X-axis calibration after the Z-axis calibration is completed. After the machine initialization movement is completed, the nozzle and the platform will be heated. At this time, please ensure that the filament has been inserted into the extruder.
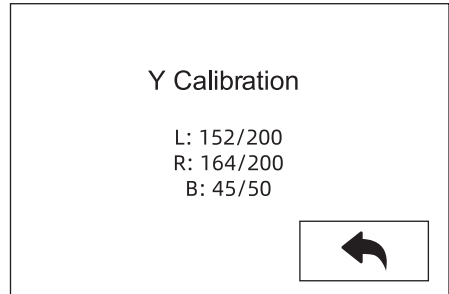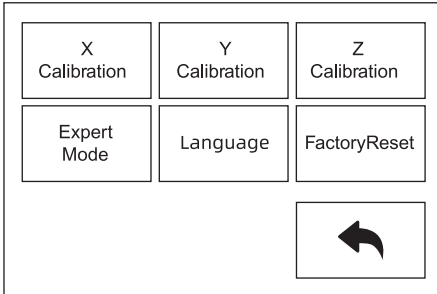
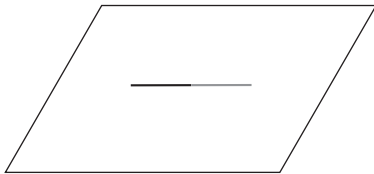2. After heating, left and right extruders print a line one by one.

Please tap X-, X+ to adjust and verify make sure the lines are aligned.

X- 0.00 X+

Verify

OK
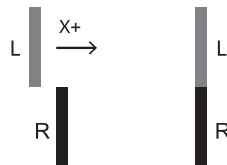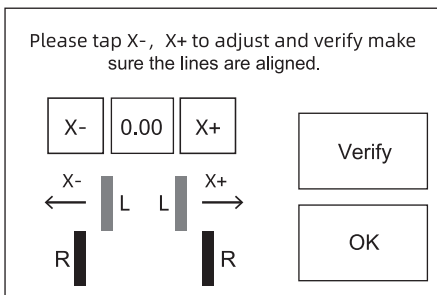
3. According to the actual printed lines, click X-, X + to adjust the bias of the extruders and remove the printed lines; tap the verify button, the left and right extruders will print the lines again to see if the lines coincide, if they coincide, it means that the X-axis calibration is completed, if they are inconsistent, continue to adjust, until it coincides.
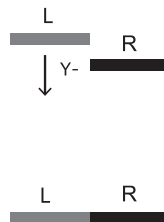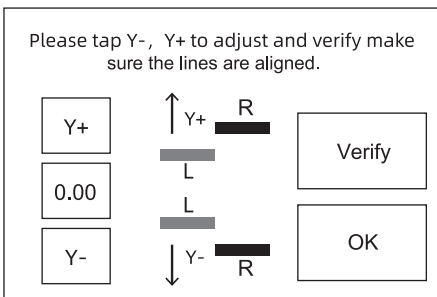
Y-axis calibration is used to adjust the consistency of the two extruders in the Y-axis direction to prevent misalignment during printing.

X Calibration	Y Calibration	Z Calibration
Expert Mode	Language	FactoryReset

Y Calibration

L: 152/200
R: 164/200
B: 45/50

1. Tap [Setting]-[Y Calibration], or continue the Y-axis calibration after the X-axis calibration is completed. After the machine initialization movement is completed, the nozzle and the platform will be heated. At this time, please ensure that the filament has been inserted into the extruder.

2. After heating, left and right extruders print a line one by one.

Please tap Y-, Y+ to adjust and verify make sure the lines are aligned.

Y+

0.00

Y-

Y+

R

L

L

Y-

R

Verify

OK

L

R

Y-

L   R

3. According to the actual printed lines, click Y-, Y + to adjust the bias of the extruders and remove the printed lines; tap the verify button, the left and right extruders will print the lines again to see if the lines coincide, if they coincide, it means that the Y-axis calibration is completed, if they are inconsistent, continue to adjust, until it coincides.

First print

After installing, loading filament and calibrating, it start your first print.
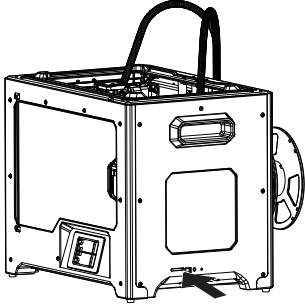
1. Insert the SD card to the side of machine.
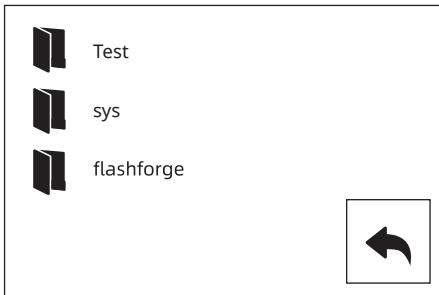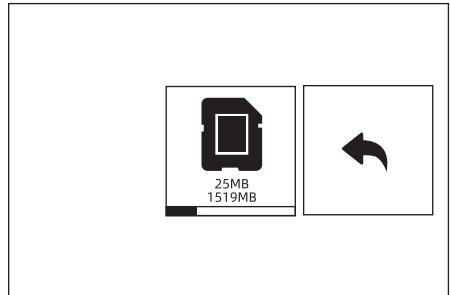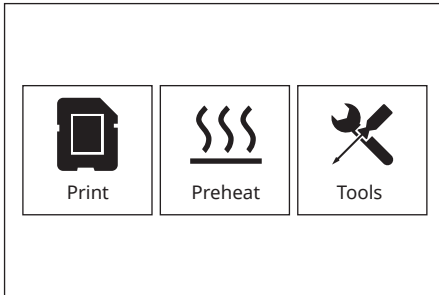
2. Tap on [Print] > [SD card] > [Test]. Choose a test file from the folder for a first print.

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