

TG-17

Intelligent 3D Pen



3D打印笔使用说明书

一、安全提示

- 1、请勿在浴室、洗手池附近或其他容易接触水的地方使用本产品，否则可能会引发触电！使用完毕请及时拔掉电源。
- 2、3D打印笔笔尖为高温区域，为避免烫伤，使用时严禁触摸陶瓷喷头。
- 3、本产品适用于6岁以上人群使用，儿童需要在成年人监护下使用。

二、注意事项

- 1、本产品采用可拆卸笔头设计，笔头损坏后可以更换。
- 2、严禁摔打或用笔头敲击硬物，严禁将异物塞入进料孔或笔头。
- 3、本产品仅适用直径1.75mm的PCL、PLA、ABS耗材。
- 4、本产品在初次使用时，若喷头产生少许烟雾，属于正常现象,不影响使用。
- 5、为测试本产品的性能是否合格，出货前会进行全检，因此喷头内会有部分耗材残留，属于正常现象，请放心使用。
- 6、产品连续出料8分钟后会自动暂停，进入保护状态，如需继续使用，按一次“挤出按键”即可再次使用。
- 7、在使用非本公司附赠的耗材时，请根据所购耗材的使用温度来设定打印笔的加热温度，否则会导致笔头堵塞。
- 8、打印笔使用完成后，请将耗材从打印中退出，若再次使用需要将耗材前端融化的部分剪掉，否则会造成喷嘴堵塞。

三、使用说明

1、接通电源

请将打印笔正确连接至电源适配器，当显示屏有字符显示时，设备进入待机状态。

2、耗材种类选择/预热

按“耗材选择”键，可在PCL/PLA/ABS三种耗材模式之间切换。耗材模式选择完成后，按一次挤出按键，此时红色LED灯亮，设备进入预热状态，当红色LED灯变成绿色时，预热结束。

3、装载耗材

预热完成后，将耗材插入打印笔尾端进退料口内，按一次“挤出按键”马达开始输送耗材，待喷头有耗材挤出即表明装载成功。

4、打印温度/速度调节

在使用过程中，可以点按“温度按键+/-”调整打印笔头温度，按“速度按键+/-”调节打印速度。

温度调整：同质耗材因不同颜色会有不同熔点（见温度微调说明）。

速度调整：本产品设有5个速度档位，1档最慢，5档最快。

5、更换/退出耗材

在3D打印笔进料过程或者待机状态下，且LED灯为绿灯时，长按“退料按键”3秒，耗材会自动退出，在退料过程中点“退料按键”可停止退料。

6、停止使用

在停止使用3D打印笔前，必须将耗材全部退出，再断开电源。否则会影响本商品下次正常使用。

四、耗材处理

加载耗材前，需保证耗材断面整齐，并没有膨胀，若不符合要求，则需要将该段耗材剪断，并保持耗材断面整齐。



五、更换耗材说明

加载耗材前，需保证耗材断面整齐，并没有膨胀，若不符合要求，则需要将该段耗材剪断，并保持耗材断面整齐。

ABS转为PLA耗材

- 1、先卸载ABS耗材。
- 2、然后将PLA耗材插入打印笔，再次点按“挤出按键”，开始清洗喷嘴，清洗时间为1分钟。
- 3、拔下DC 5V电源线，冷却喷嘴3-5分钟。
- 4、冷却完成后，再次接通电源，选择“PLA”耗材模式。
- 5、按一次挤出按键”，红色LED灯亮，设备进入预热，当红色LED灯由红转绿，预热结束，再次按“挤出按键一次，则可以开始使用切换的PLA耗材。

PLA转为PCL耗材

- 1、先卸载PLA耗材。
- 2、然后将PCL耗材插入打印笔，再次点按“挤出按键”，开始清洗喷嘴，清洗时间为1分钟。
- 3、拔下DC 5V电源线，冷却喷嘴3-5分钟。
- 4、冷却完成后，再次接通电源，选择“PCL”耗材模式。
- 5、按一次挤出按键”，红色LED灯亮，设备进入预热，当红色LED灯由红转绿，预热结束，再次按“挤出按键一次，则可以开始使用切换的PCL耗材。

ABS转为PCL耗材

- 1、先卸载ABS耗材。
- 2、然后将PCL耗材插入打印笔，再次点按“挤出按键”，开始清洗喷嘴，清洗时间为1分钟。
- 3、拔下DC 5V电源线，冷却喷嘴3-5分钟。
- 4、冷却完成后，再次接通电源，选择“PCL”耗材模式。
- 5、按一次挤出按键”，红色LED灯亮，设备进入预热，当红色LED灯由红转绿，预热结束，再次按“挤出按键一次，则可以开始使用切换的PCL耗材。

六、温度微调说明

- 1、使用ABS、PLA耗材时，听到喷嘴有“啾啾”声响，表明温度过高，此时可使用“材料选择/温度按键-”键进行温度下调，调整幅度为8~15℃。
- 2、使用ABS、PLA耗材时，如遇到大量气泡，表明温度偏高，此时可使用“材料选择/温度按键-”键进行温度下调，调整幅度为3~8℃。
- 3、使用ABS、PLA耗材时，当发现挤出材料表面色泽暗淡无光，电机声明显有吃力感，表明温度偏低，此时可使用“材料选择/温度按键+”键进行温度上调，调整幅度为5~10℃。
- 4、使用PLA材料时，遇挤出时材料太稀导致滴淌，表明温度过高，此时可使用“材料按键/温度按键-”键进行温度下调，调整幅度为10~15℃。
- 5、使用PLA材料时，遇挤出时材料太稀导致滴淌，表明温度过高，此时可使用“材料按键/温度按键-”键进行温度下调，调整幅度为10~15℃。
- 6、正常出料应为光滑圆润无气泡（偶有气泡）。

七、常规故障排除

在使用过程中遇到下述现象，请按表内所述做简单处理，如仍然无法排除故障，请与购买处联系。

故障现象	故障原因	故障排除方法
液晶屏幕不亮	电源适配器故障	更换适配器
	电源线损坏	更换电源线
红色闪烁LED显示ERR	打印笔头损坏	更换打印笔头
	打印笔头损坏	
喷嘴无法挤出耗材	挤出速度过慢	调高挤出速度
	模式选择错误	选择正确的耗材模式
	马达打滑	退出耗材，并剪去有咬痕的耗材
	耗材无法加载	将耗材断面切平整，参考说明书图示
	出料有气泡	温度过高，调整加热温度
PCL功能故障	耗材堵塞	调高打印笔温度和速度清洗喷嘴，并用手辅助挤出耗材
	PLA耗材残留在管道内	重新通电将“PCL”切换到“PLA”菜单，并选择“PLA”将温度设定到最高上限，然后用PCL耗材清洗喷嘴。
	挤出不顺畅	
	无法挤出	
PLA功能故障	挤出形状不规则	重新通电功能切换到“ABS”菜单，将温度设定到最高上限，然后用PCL耗材清洗喷嘴。
	喷嘴堵塞	
	ABS耗材残留在管道内	
	出料不顺畅	
	喷嘴堵塞	

八、包装清单

（包装中的物品在某些国家/地区可能与不同）

3D打印笔	电源适配器	耗材	DC5V电源线	说明书	手指保护套	临摹画册	临摹片	打印笔支架
1	1	2	1	1	2	1	1	1

九、规格参数

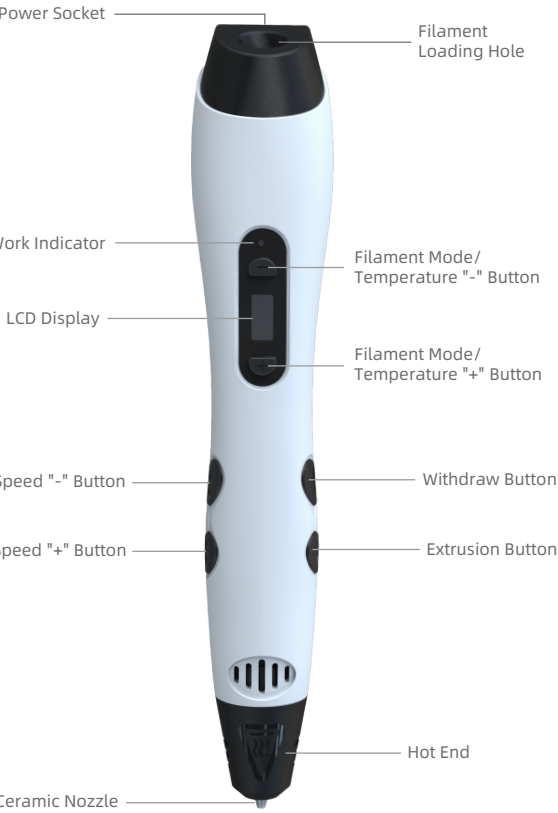
适配耗材	ABS/PLA/PCL Φ1.75mm
工作温度	PCL 60°C-100°C
	PLA 160°C-210°C
	ABS 180°C-210°C
电源输入	DC 5V/2A 10W
电源适配器	AC 100-240V 50/60Hz
产品尺寸	170(L) * 30(W) * 38.8(H)mm
包装尺寸	200(L) * 118(W) * 75(H)mm
净重	67g
毛重	510g

十、售后服务

非人为损坏的情况下，保修一年，使用非原装品牌耗材或未按使用说明书正确操作导致损坏，将不在保修范围内。

TG-17

Intelligent 3D Pen



3D Printing Pen User Manual

I Safety Tips

1. Do not use this product in the bathroom, sink or other places where have water, otherwise it may cause electric shock! Please unplug the power supply in time after use.
2. To avoid burns, please do not touch the ceramic nozzle during use.
3. This product is suitable for adult and children over 6 years old, children can use it under adult supervision.

II Precautions

1. The pen tip of this product is detachable and can be replaced after it is damaged.
2. Do not drop or hit other hard objects with the nozzle. Do not insert foreign objects into the loading hole or nozzle.
3. The product uses PCL, PLA, ABS filaments with the diameter of 1.75 ±0.02mm.
4. During the first use, if the nozzle produces a little smoke, normal and does not affect the use.
5. In order to ensure the quality, each pen is tested in the factory before delivery. As a result, there may be residue in the nozzle, but it should not affect normal use.
6. The product will automatically pause after 8 minutes of continuous extrusion and enter the protection state. If you need to continue using it, press the Extrusion Button once to use it again.
7. When using filaments that are not provided by our company, please set the temperature of the printing pen according to the recommended temperature of the purchased filaments, otherwise the nozzle will be blocked.
8. After the printing pen is used, please withdraw the filament from printing pen. If you need to use it again, you need to cut off the melted part of the front of the filament, otherwise the nozzle may will be blocked.

III Instructions For Use

1. **Turn on the power**
Please connect the printing pen to the power adapter correctly, when there are characters on the display, the device enters the standby state.
2. **Select Filament/Preheating**
Press the Filament Mode "+" Button, the LCD screen will display "PCL", "PLA" or "ABS" . Press the Extrusion Button, the red LED light is on, and the device enters the preheating mode, when the red LED light turns from red to green, the preheating ends.
3. **Loading Filaments**
After preheating, insert the filaments into the Loading hole at the top of the printing pen and press Extrusion Button. The motor starts to load filament into pen. When filament is extruded from the nozzle, it indicates that the loading is successful.
4. **Printing Temperature/Speed**
During use, press "Temperature +/-", "Speed/+-" to adjust the printing temperature and printing speed.
Temperature adjustment
The same filament will have different melting points due to different colors. (Please refer to "Temperature Adjustment Instructions").
Speed adjustment
This product has 5 speed gears, the first gear is the slowest, and the five gear is the fastest.
5. **Replace/Unload Filament**
When the LED light is green, press Withdraw Button for 3 seconds, the filaments will be

unloaded automatically. Press Withdraw Button again and the unloading will stop.

6. Finish Printing

When finishing printing, you must clear all filaments, and then disconnect the power. Otherwise it will affect the normal use of this product next time.

IV Filament Loading

Before loading the filament, make sure that the end of the filament is neat and not swollen. If it is not, you need to cut the filament and keep the end neat.



V Instructions for replacing filament

In the process of using the printing pen, if you want to replace different types of filament, please follow the steps below, otherwise the nozzle will be blocked.

ABS to PLA

1. Unload ABS filament first.
2. Then insert the PLA filament into the printing pen, press the "Extrusion button" to start cleaning the nozzle. The cleaning time is 1 minute.
3. Unplug the DC 5V power cord and cool the nozzle for 3-5 minutes.
4. After cooling is complete, turn on the power again and select "PLA" mode.
5. Press the "Extrusion button" once, and the red LED lights up, and the device will preheat. When the red LED turns from red to green, the preheating ends, press the "Extrusion button" again to start using the switched PLA filament.

PLA to PCL

1. Remove PLA filament first.
2. Then insert the PCL filament into the printing pen, and press the "Extrusion button" again to start cleaning the nozzle. The cleaning time is 1 minute.
3. Unplug the DC 5V power cord and cool the nozzle for 3-5 minutes.
4. After cooling is complete, turn on the power again and select "PCL" mode.
5. Press the "Extrusion button" once, the red LED light is on, and the device will preheat. When the red LED turns from red to green and the preheating is over, press the "Extrusion button" again to start using the switched PCL filament.

ABS to PCL

1. Unload ABS filament first.
2. Then insert the PCL filament into the printing pen, and click the "Extrusion button" again to start cleaning the nozzle. The cleaning time is 1 minute.
3. Unplug the DC 5V power cord and cool the nozzle for 3-5 minutes.
4. After cooling is complete, turn on the power again and select "PCL" mode.
5. Press the "Extrusion button" once, and the red LED lights up, and the device will preheat. When the red LED turns from red to green, the preheating is over, press the "Extrusion button" again to start using the switched PCL filament.

VI Temperature adjustment instructions

1. When using ABS and PLA filaments, you hear a "cracking" sound from the nozzle, indicating that the temperature is too high. At this time, you can use the "Material Selection/Temperature Button -" to lower the temperature, and the adjustment range is 8-15°C.
2. When using ABS and PLA filaments, if you encounter a lot of bubbles, it indicates that the temperature is too high. At this time, you can use the "material selection/temperature button -" to adjust the temperature, and the adjustment range is 3-8°C.
3. When using ABS and PLA filaments, if the surface color of the extruded material is dim and dull, the sound of the motor is obviously strenuous, indicating that the temperature is low. At this time, you can use the "material selection/temperature button +" to adjust the temperature. The range is 5-10°C..
4. When using PLA filament, the material is too thin and dripping during extrusion, indicating that the temperature is too high. At this time, you can use the "material button/temperature button -" to adjust the temperature, and the adjustment range is 10-15°C.
5. When using PCL filament, the filament is too dry or is discharged slowly during extrusion, indicating that the temperature is too low. At this time, you can use the "material selection/temperature button +" to increase the temperature, and the adjustment range is 5-10°C.
6. The normal discharge should be smooth and round without bubbles (occasionally with bubbles).

VII Common Troubleshooting

If you encounter the following fault during use, please do a simple treatment as described in the table. If the fault still cannot be eliminated, please contact the seller.

Fault phenomenon	Fault cause	Solution
LCD screen does not light up	The power adapter is faulty	Replace the adapter
	The power cord is damaged	Replace the power cord
Flashing red, LED screen displays ERR	The nozzle is damaged	Replace the nozzle
Nozzle can not extrude filament	Extrusion speed is too slow	Increase the extrusion speed
	Wrong mode selection	Select the correct filament mode
	Motor is slipping	Remove the filament and cut out the filament with bite marks.
	Filament cannot be loaded	Cut the section of the filament flat, refer to the illustration in the manual
	There are bubbles in the extruded material	The temperature is too high, adjust the heating temperature
	Nozzle is clogged	Increase the temperature and speed of the printing pen to clean the nozzles, and use your hands to push the filament

PCL function failure	PLA filament remain in the conduit	Turn on the power again, switch "PCL" to the "PLA" mode and set the highest temperature, then use PCL filament to clean the nozzle.
	Extrusion is not smooth	The power-on function switches to the "ABS" mode, sets the highest temperature, then cleans the nozzle with PCL filament.
	Can't squeeze out	
	Irregular extrusion	
PLA function failure	Clogged nozzle	Turn on the power again, switch "PLA" to the "ABS" mode, set the highest temperature, then clean the nozzle with PLA filament.
	ABS filament remain in the conduit	
	Irregular extrusion	
	Clogged nozzle	

VIII Packing list

(the items in the package may be different in some countries/regions)

3D Printing Pen	Power Adapter	Filament	DC5V Power Cord	Instruction	Finger protector	Copy picture album	Copy mat	Printing pen holder
1	1	2	1	1	2	1	1	1

IX Specifications

Print Material	ABS/PLA/PCL Φ1.75mm
Nozzle Temperature	PCL 60°C-100°C
	PLA 160°C-210°C
	ABS 180°C-210°C
Power Input	DC 5V/2A 10W
Power Adapter	AC 100-240V 50/60Hz
Product Size	170(L) * 30(W) * 38.8(H)mm
Package Size	200(L) * 118(W) * 75(H)mm
Net Weight	67g
Gross Weight	510g

