



## X40 3D Printer Quick Start Guide

### INTRODUCTION

Thank you for purchasing this X40 3D Printer! This printer uses the FFF (Fused Filament Fabrication) method of printing. It features a metal frame, open structure design and heated build platform. It can print 1.75mm ABS, PLA, Metal fill, Wood fill, and other filament types with melting points below 250°C (Default hot end). The machine with independent dual extruders can print at a speed up to 150mm/s and 300x300x400mm printing area. It can print from sliced g-code files stored on a micro SD™ card or from our App (Poloprint Pro). It supports auto-leveling, automatic shut-down, with a 4.3-inch touch screen, a removable and a heated build plate.

### CUSTOMER SERVICE

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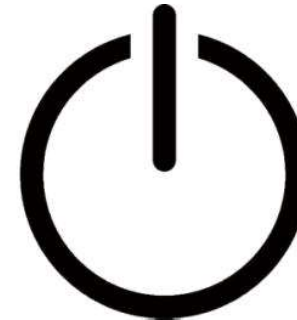
## NOTES



The temperature of the nozzle parts and platform can reach 250°C. It is forbidden to touch while the printer is printing or cooling.



**Children are not allowed**



**Pay attention to the voltage**

Please check whether the input voltage value of the switching power supply meets the standard of the country or region.



**Prevent pinching and cutting**

Please pay attention to the sharp edges and corners of the profile.



**Keep clean and dry**



**Safe operation**

If something goes wrong with the machine, please contact our after-sales service.

# PARTS LIST



1x frame base



1x Z/X Gantry  
Assembly



2x 200g  
Filament



1x Power Cord



1x USB cable



1x Plier  
1x glue stick



1x Metal Scraper



2x Positioning  
Block



No.1 Bag:  
1x 4.0mm L Wrench  
4x M5X25 Screw



No.2 Bag:  
1x WIFICAM  
1x T-Nut  
1x M3x45 Screw  
1x 2.5mm L Wrench



No.3 Bag:  
2x T-shaped Metal sheet  
8x M4\*6 Screw  
8x T-Nut



No.4 Bag:  
2x Holder Base  
4x M4\*6 Screw  
4x T-Nut



No.5 Bag:  
2x Filament Roll



No.6 Bag:  
2x Brush Module  
4x M3\*6 Screw  
1x 2.0mm L Wrench



No.7 Bag:  
1x TF card, Reader  
1x Y end stop sensor  
2x Runout sensor  
1x Y end stop cable  
1x thermistor  
2x Brush



No.8 Bag:  
10\* Cable ties  
1x 1.5mm L wrench  
1x 3mm wrench  
1x 5.5-7 Wrench  
1x 8-10 Wrench

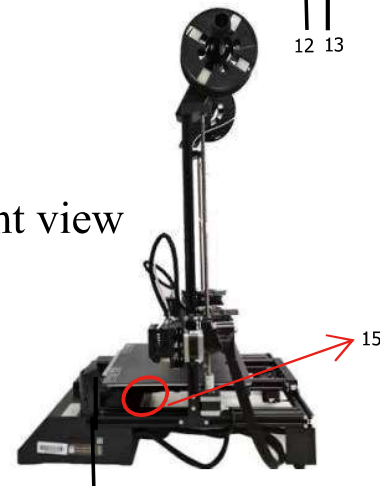
# OVERVIEW



Left view



Right view



1. Left X End Stop Sensor
2. Proximity
3. Left Extruder
4. Start Button
5. Touch Screen

6. Wi-Fi Camera Module
7. Build Platform
8. Nozzle brush
9. Right Extruder
10. Right X End Stop Sensor

11. Filament Holder
12. Power Interface
13. Power switch
14. TF slot
15. Voltage regulator switching

# Step 1: Open the accessory box and get the frame base

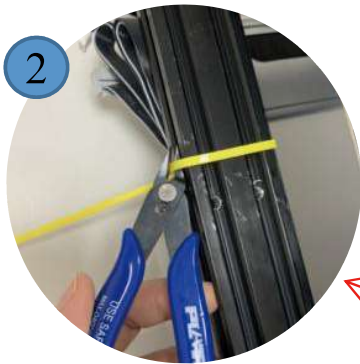
1. Cut the tie on the frame base.
2. Tear off the tape and make sure the platform does not move.
3. Check that the four Leveling Nuts are not falling off. Tighten them.



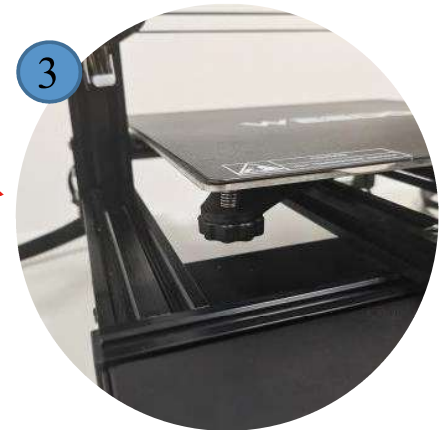
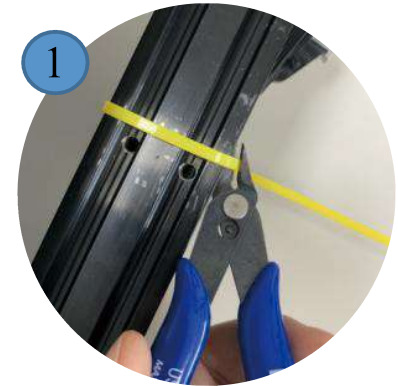
1x 3D  
printer  
Frame  
base



1x pliers



**Tips: Do not cut the  
cables on the host!**



**Tips: There are slight scratches on the aluminum profile because the machine has been installed and tested before leaving the factory, Which is a normal phenomenon.**

## Step 2: Install the Z/X Gantry onto the base



No.1 Bag:

1x 4.0mm L  
Wrench

4x M5X25  
Screw

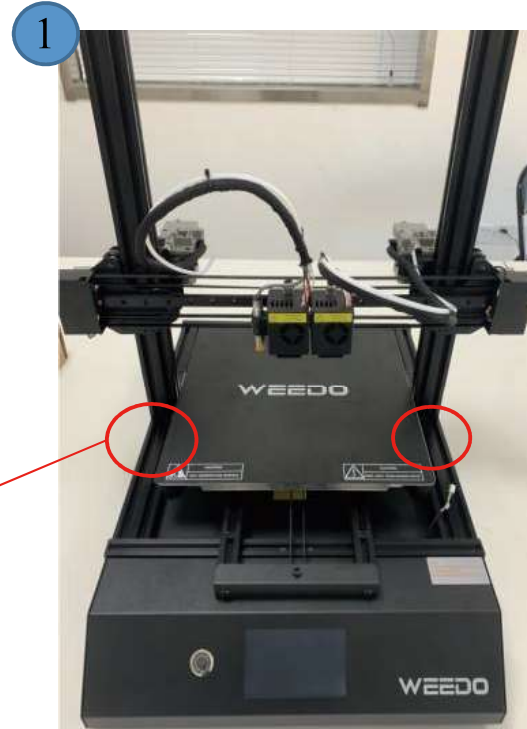


2. Take a foam on the right side of the base.



4. Pour the base to the right, pluck the wire above the screw hole with your finger.

**Tips:** Be careful not to let the screw through the wire during installation and press the sprinkler line when moving the machine.



1. Place the Z/X Gantry above the base.

**Tips:** If the right extruder pneumatic coupling falls off, it needs to be retwisted with a wrench.



3. Screw the M5X25 into the hole with an L-shaped 4.0mm wrench.

**Tips:** If it's deformed, you can align the Gantry with the base so that the screw goes into the screw hole.



5. Adjust the direction of the wrench, insert the short side, tighten all screws forcefully.

## Step 3: Install T-shaped fixtures on both sides of the printer



No.2Bag:

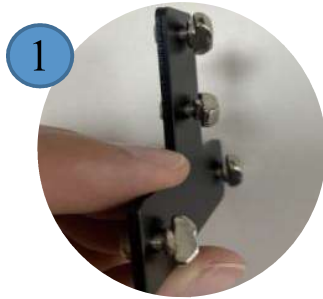
1x 2.5 mm L Wrench

No.3Bag:

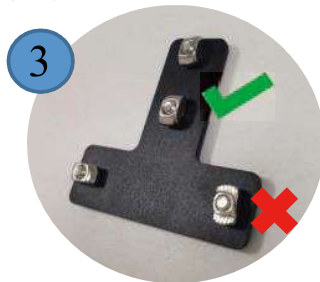
2x T-shaped Metal  
sheet

8x M4\*6Screw

8x T-Nut



1. Install screws and T-nuts on T-shaped fixtures by hand.

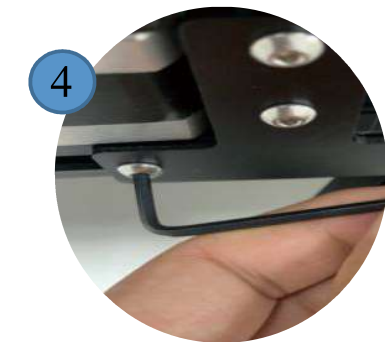


3. Screw the four screws on the T-shaped fixture into the aluminum profile, rotate the T-nut to 90-degrees.

**Tips:Pay attention to the installation direction of T-nut.**



2. Insert the long side of the 2.5mm L-shaped wrench into the screw cap.



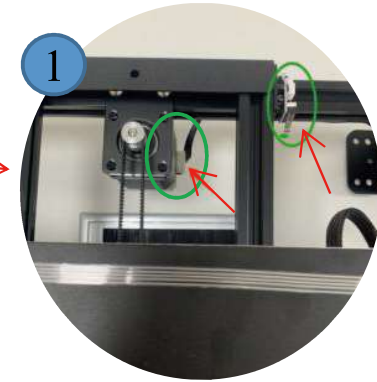
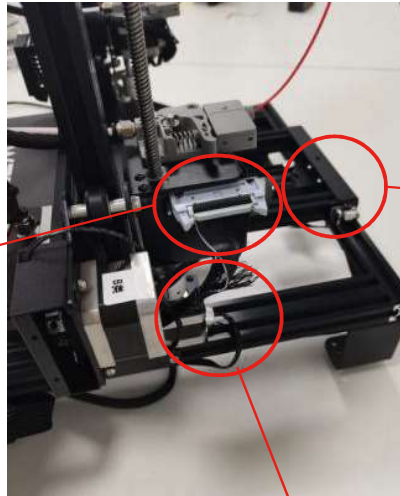
4. Adjust the L-shaped wrench and insert the screw cap with the short side to tighten all screws.

**Tips:Get the 2.5mm L wrench ready, it will be used in the next step.**

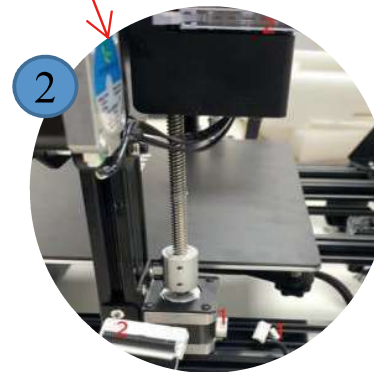
## Step 4: Connect the Y and Z Motor Cable and Extruder Cable



2. Plug the motor cable and sprinkler cable on both sides of the printer respectively.



1. Connect the Y Motor Cable on the back of the host, check the Y end stop sensor is installed properly.



**Tips: Make sure the cables are connected and fastened.**



# Step 5: Install the WIFICAM module



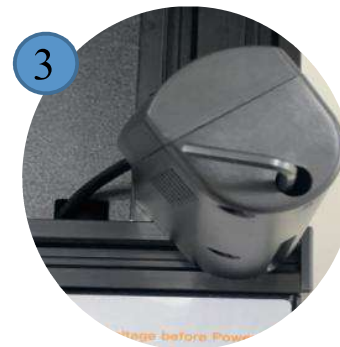
- No.2Bag:  
1x WIFICAM  
1x 2.5mm L Wrench  
1x M3x45 Screw  
1x T-Nut



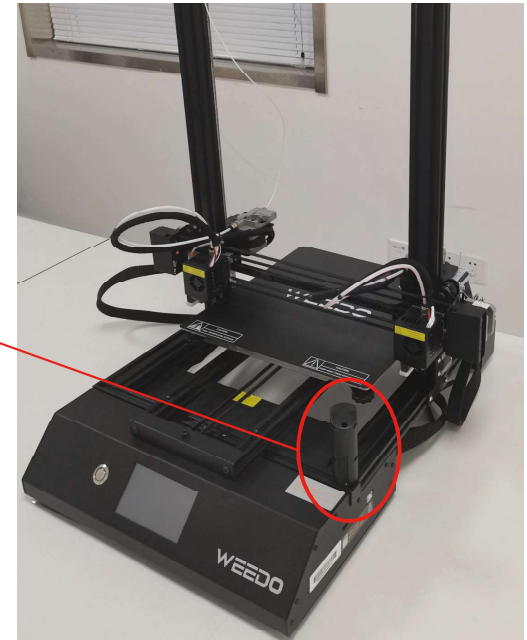
1. Insert the M3X45 screw into the WIFICAM module with the long edge of the L-shaped wrench.



2. Screw the T-nut on the M3X45 screw by hand.



3. Connect the cable to the WIFICAM module, Install the WIFI module on the front right.



**Tips: Hide the cables so the platform won't scratch them**

## Step 6: Install the Filament Holder



No.4/5 Bag:

2x Filament Roll

2x Filament Holder

4x M4\*6Screw

4x T-Nut



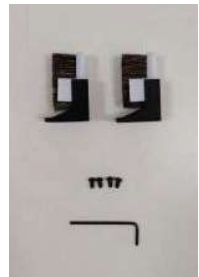
1. Screw the Round tube to the filament holder.



2. Install the filament holder to the top beam, about 9 inches apart between two holders.

**Tips:** The filament holder installation location shown below is recommended by WEEDO X40 users. If your machine has limited space, you can also install the holder on the aluminum profile bar at the top of the printer.

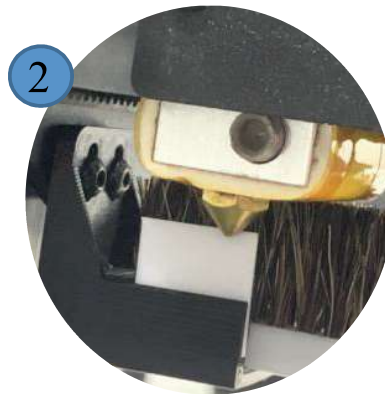
# Step 7: Install the Nozzle Brush



- No.6Bag:
- 2x Brush Module
- 4x M3\*6Screw
- 1x 2.0mm L Wrench



1. Install the Nozzle brush module to the printer.



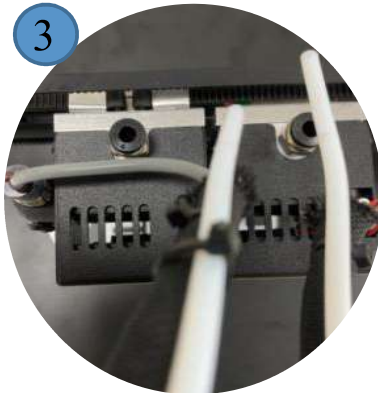
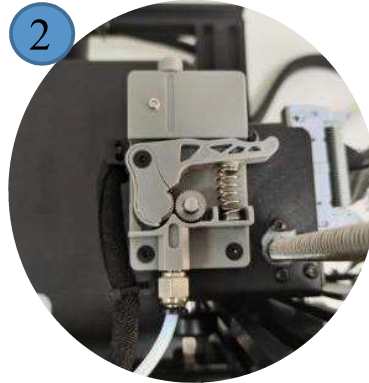
2. In the installation progress, the brush module can be adjust up and down, **make sure the brass nozzle is about 1mm under the white Teflon sheet, Teflon sheet can wipe the nozzle slightly.**



## Step 8: Check before Power On

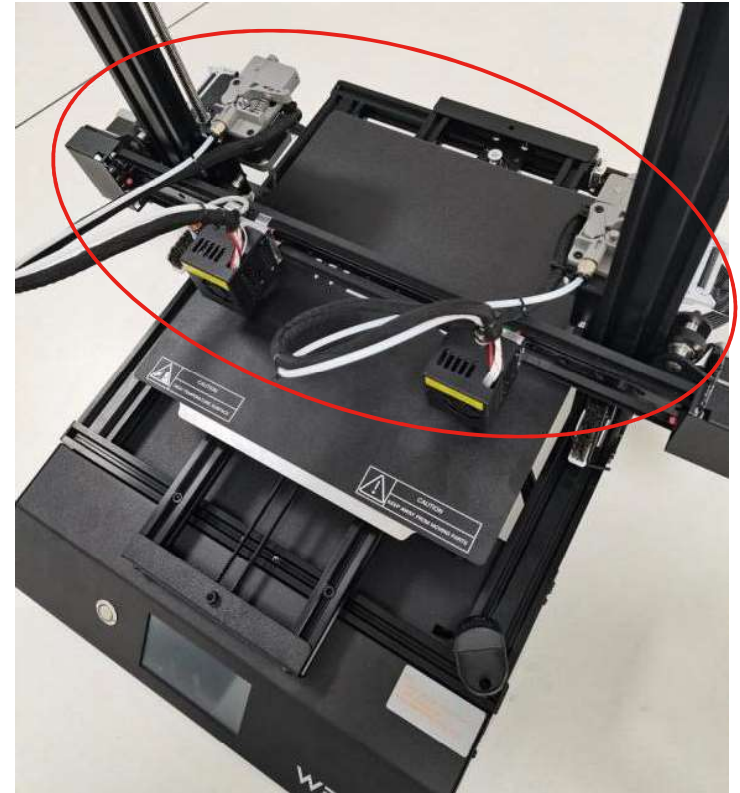


1. Press and hold the black plastic edge on the connector.

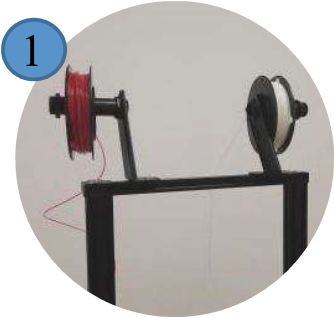


2. Insert the Teflon tube to the bottom, the insert distance is about 3.5 CM.

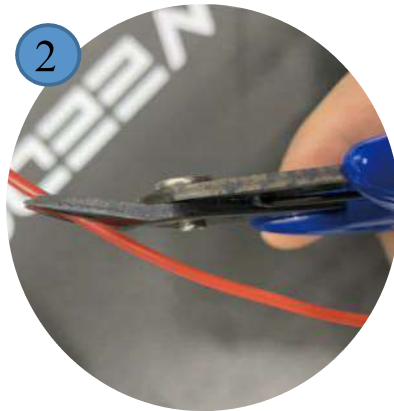
**Tips:** Be sure to insert the Teflon tube into the bottom, so it does not fall off.



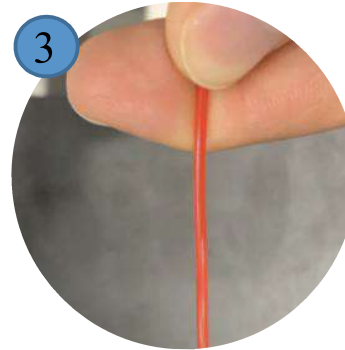
## Step 9: Load the filament



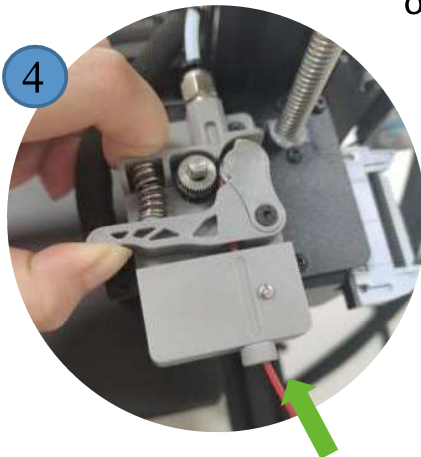
1. Hang the filaments on the filament holder.



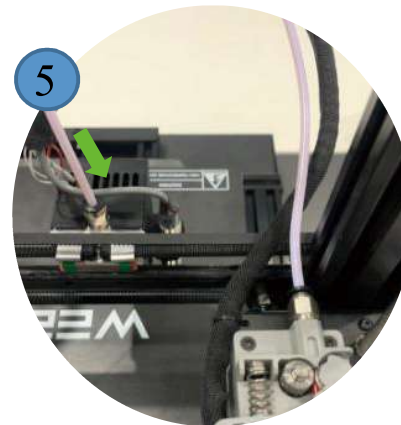
2. For better printing, cut a 45-degree slope at the end of filament with pliers.



3. Straighten the end of the filament.



4. Press the handle of extruder to pull filament pass through.



5. Pull filament into the wire tube.

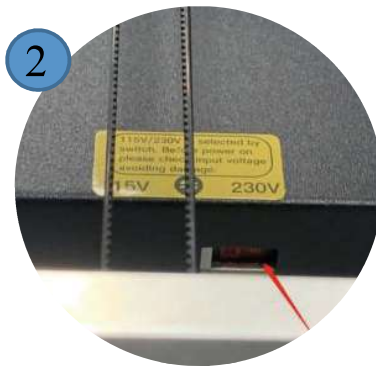


**Tips: Ensure that the wire is inserted into the Heated Aluminum Block.**

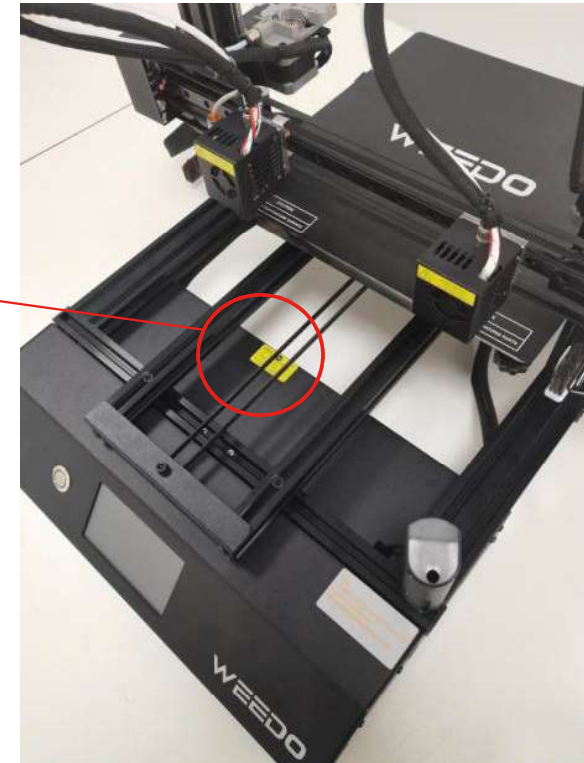
## Step 10: Check the tightness of the belt and the Voltage



1. Press the belt with your hand, and the belt has a certain degree of elasticity.



2. There is a voltage switch button on the back of the printer chassis. Use the wrench to toggle the switch to the RIGHT local voltage Before powered on.



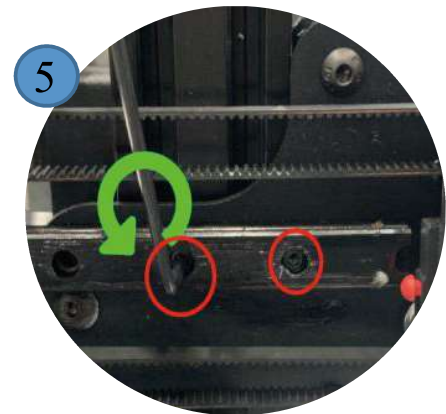
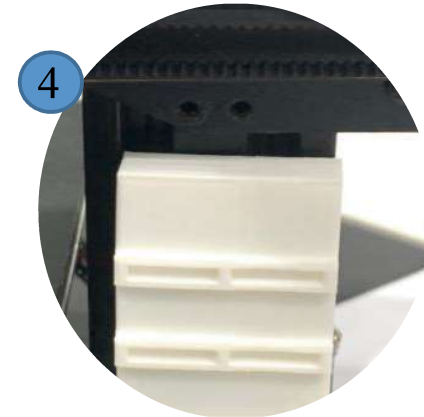
**Tips:** Check the tightness of the belts in the X and Y directions on the machine. The machine may cause changes in the tightness of the belts during transportation. Too loose and too tight belt will have an impact on model printing. Belt adjustment can be viewed on our wiki website: [www.weedo3dprinter.com](http://www.weedo3dprinter.com)

# Step 11: Check the Z/X Gantry Assembly is horizontal

1. Place two positioning blocks on the left and right sides of aluminum profiles.
2. Use two fingers to turn the left and right coupling on the Z motor at the same time.
3. Let Z/X Gantry Assembly move down and touch the positioning block of 3D printing.
4. If one side of Z/X Gantry Assembly touches the positioning block and the other side does not
5. Use the 2.5mm L-shaped Wrench loosen the two screws, rotate the coupling and let the Z/X Gantry Assembly touch the 3d printed block, and then tighten the two screws.



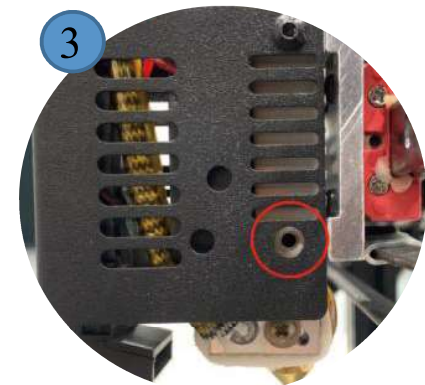
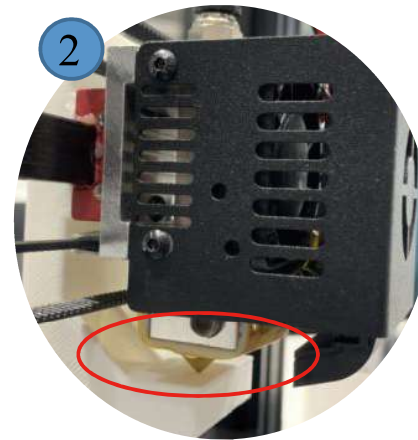
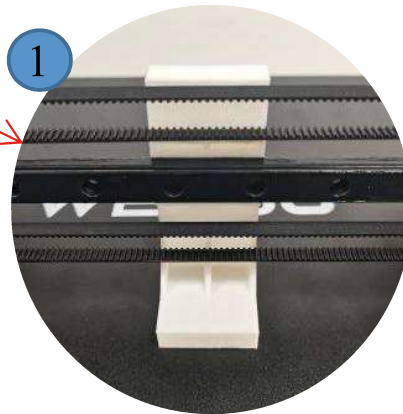
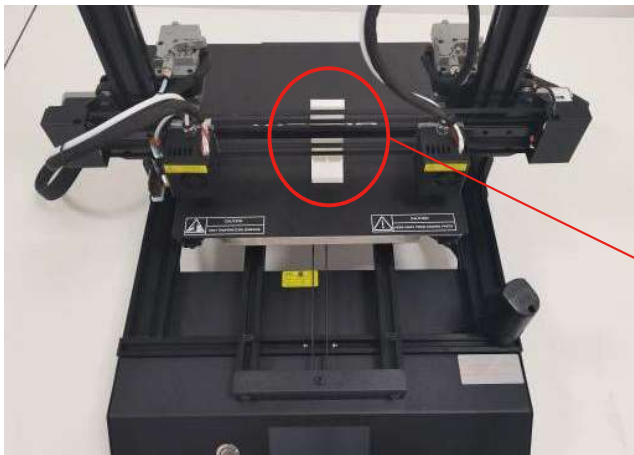
2x Positioning  
Block



**Tips:** The machine has been fully tested before leaving the factory, and in the process of transportation and installation, it may cause to be out of level.

## Step 12: Check the Left hot end and Right hot end at the same height

1. Install the positioning block on the linear guide.
2. Move the left and right extruder to the positioning block, and check whether the installation height of the hot end is the same.
3. If the height is not the same, you can loosen the fixing screw of the hot end on the right with 2.5mm L-shaped wrench and readjust the height of the hot end so that the height of the two hot end is the same.



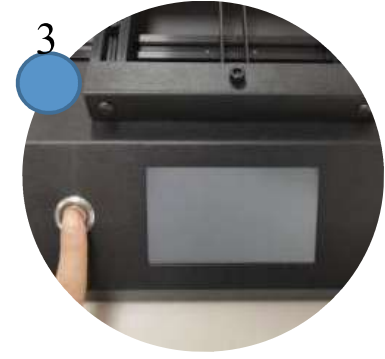


# Printer calibration

## Step 1: Turn On The printer



1. Plug the power cord into the socket.
2. Press the switch from 0 to 1.



3. Click the metal switch on the front panel.

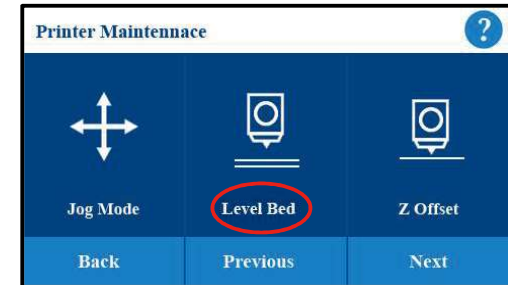
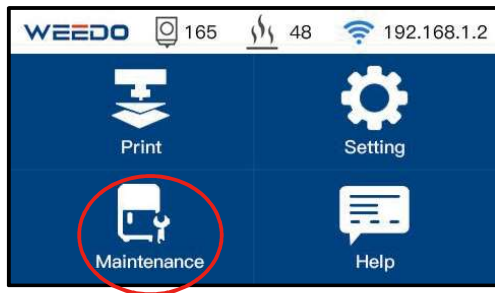


4. Select the language you need.

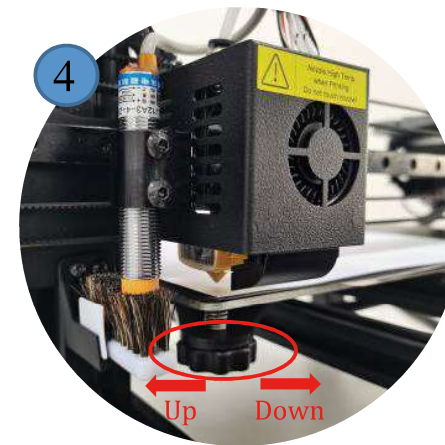
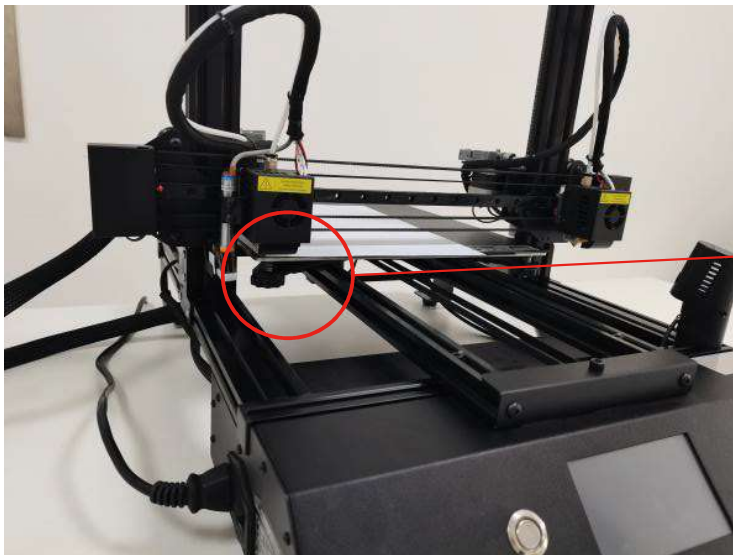
**Tips: Please unplug the 3D Printer if it will not be in use for a while.**

## Step 2: Bed Leveling

1. After the self-test is completed, you will enter the main interface. Perform the bed leveling,
2. Click on 'Maintenance'--'Next'--'Level Bed'.



3. Prepare an A4 paper. The nozzle will test 4 points on the platform.

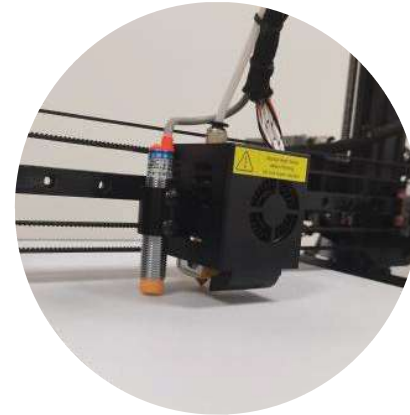
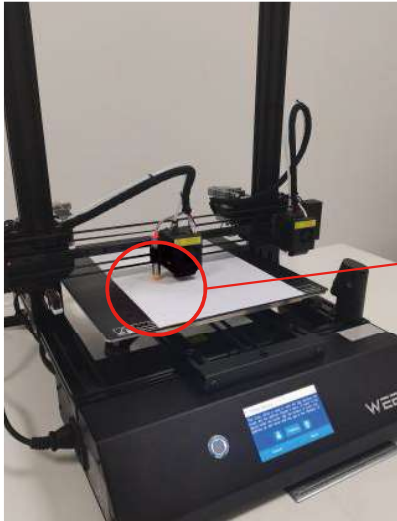


4. At each point, adjust the nut to allow the distance between the nozzle and the platform is the thickness of A4 paper. **Make sure the paper doesn't move smoothly.**

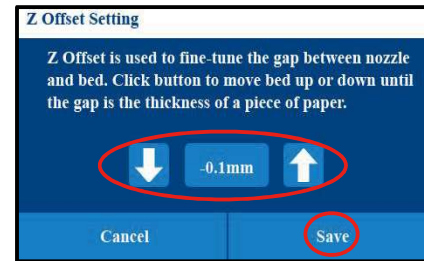
**Tips:** This operation is to ensure that the platform is horizontally balanced.

## Step 3: Z-Offset

1. Set the gap between the nozzle and the platform. Prepare an A4 paper.
2. Click on 'Maintenance'---'Next'--'Z Offset'.



3. Click the 'Up' or 'Down' button in the Z Offset interface, then the nozzle will move in the direction accordingly. Ensure that the gap between the nozzle and the platform is a distance of the thickness of A4 paper.



4. When the gap between the nozzle and the platform is adjusted, click 'Save'.

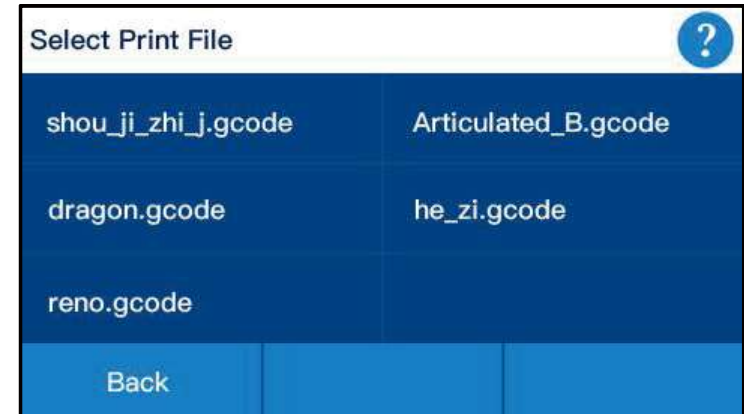
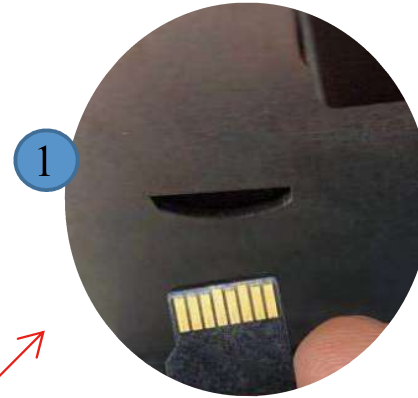
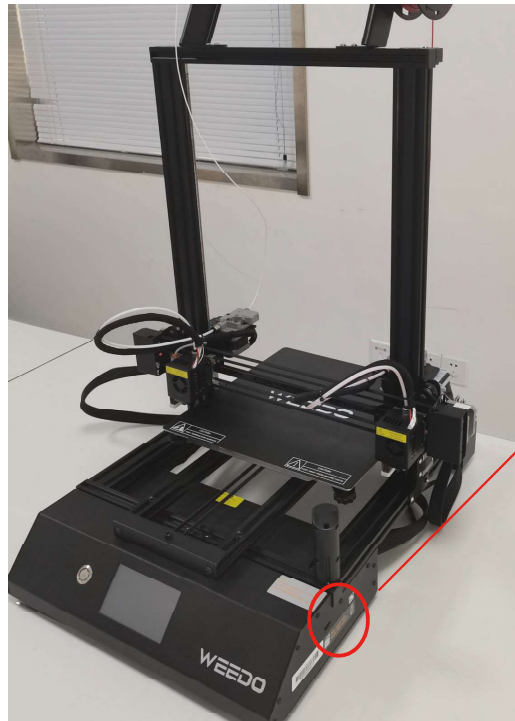
**Tips:** The figures on your machine may be different from the picture shown. The Damage will be caused to nozzle and print circuit if the distance between the nozzle and the build plate is too narrow.

# Printing test

1. The card has a test model that we prepared for you before delivery.
2. Please select the file in the TF card for printing.



No.7Bag:  
1x TF card



**Tips: Please make sure that the metal of the TF card faces up to prevent damage to the machine motherboard. Don't let it fall.**

# XY Offset Setting

Required in replacing the nozzle or two-color modules that are not aligned

## Step 1: Nozzle Coarse tune

1. Loading two-color filament in the left and right nozzle, which is easy to observe.
2. Set XY Coarse X to 3(353), Y to 3(0)
3. XY Offset Fine Tune X to 5(0), Y to 5(0)

Nozzle X Offset Coarse Tune

Print the file NozzleCoarseTune.gcode  
Select the number on the block with the smallest deviation between the upper and the lower layers and Save

1(351) 2(352) 3(353) 4(354) 5(355)

Cancel Save

Nozzle Y Offset Coarse Tune

Select the number on the block with the smallest deviation between the two vertical layers, and save

1(-2) 2(-1) 3(0) 4(1) 5(2)

Cancel Save

Nozzle XY Offset Fine Tune

Print the file NozzleFineTune.gcode  
Select the number on the block with the smallest vertical deviation and click Save.

1(-0.4) 2(-0.3) 3(-0.2) 4(-0.1) 5(0)  
6(+0.1) 7(+0.2) 8(+0.3) 9(+0.4) 10(+0.5)

Cancel Save

Nozzle XY Offset Fine Tune

Print the file NozzleFineTune.gcode  
Select the number on the block with the smallest horizontal deviation and click Next.

1(-0.4) 2(-0.3) 3(-0.2) 4(-0.1) 5(0)  
6(+0.1) 7(+0.2) 8(+0.3) 9(+0.4) 10(+0.5)

Cancel Next

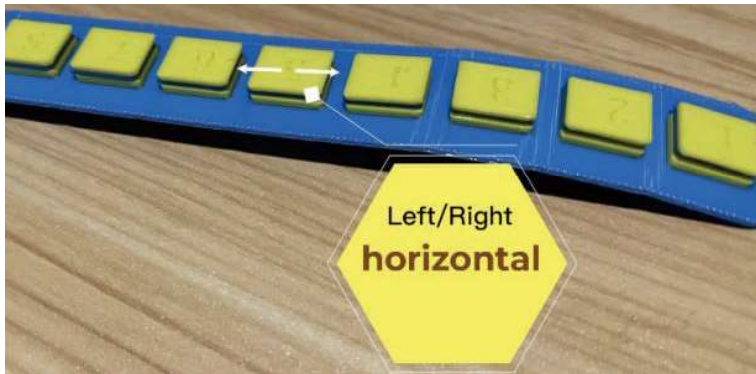
4. Print the two-color test file in the TF card, the file name is **NozzleCoarseTune.gcode**.
5. At the end of the printing, observe the 5 test blocks and select the one with the smallest X and Y deviation as shown in the following figure: select 3



5. Set the X to 3(353) and Y to 3(0) (This depends on your printing.)

## Step 2: Nozzle Fine Tuning

1. Print the **Gcode NozzleFintune.gcode** and set the XY Fine Tune
2. Find the small offset in X (the horizontal direction) and Y(the vertical direction), in the example printing the X Y smallest offset is both 3.



Nozzle XY Offset Fine Tune

Print the file NozzleFineTune.gcode  
Select the number on the block with the smallest horizontal deviation and click Next.

1(-0.4)	2(-0.3)	3(-0.2)	4(-0.1)	5(0)
6(+0.1)	7(+0.2)	8(+0.3)	9(+0.4)	10(+0.5)

Cancel **Next**

Nozzle XY Offset Fine Tune

Print the file NozzleFineTune.gcode  
Select the number on the block with the smallest vertical deviation and click Save.

1(-0.4)	2(-0.3)	3(-0.2)	4(-0.1)	5(0)
6(+0.1)	7(+0.2)	8(+0.3)	9(+0.4)	10(+0.5)

Cancel **Save**

# FAQ

## **Question 1:** What if the nozzles clog?

**Error Diagnosis:** Check the feedrate, temperature, and tube insertion.

**Solution:** Dredge the nozzle, please remove the fan above the nozzle, and then heat the nozzle to 230°C and carefully pull out filament with pliers. Set the parameters of TPU, and insert the Heat Break. Reinsert or replace Hotend. If the problem still cannot be solved, you can search website: [www.weedo3dprinter.com](http://www.weedo3dprinter.com).

## **Question 2:** What if the nozzle can't heat?

**Error Diagnosis:** Disassemble the Extruder and Hotend, check whether the Temperature Sensor and Thermistor are inserted properly, loose and falling off.

**Solution:** Reinsert or replace Temperature Sensor, Thermistor or Hotend.

## **Question 3:** What if the platform can't be heated?

**Error Diagnosis:** Disassemble the motherboard of frame base, check the Temperature Sensor and Thermistor are inserted properly, loose and falling off.

**Solution:** Reinsert or replace Temperature Sensor or Thermistor .

## **Question 4:** What if WIFI doesn't work?

**Error Diagnosis:** The network is not properly configured. Check the router and the connection of the cable of WIFI.

**Solution:** Check whether the router is 2G or 4G. Configure the network according to the unpacking guide. Reinsert the cable of the WIFICAM.

**Question 5:** What if the machine is deformed or falling off for transportation?

**Error Diagnosis:** Examine the problem area

**Solution:** Replace the parts.

**Question 6:** What if model does not stick to platform or difficult to remove?

**Solution:** If the gap between the nozzle and the platform is too large, the model will not stick to the platform. If the nozzle clearance is too small, the model will adhere too tightly to the platform. Please use Z Probe Offset to adjust the gap between the nozzle and the platform, or stick it on platform with a glue stick.

**Question 7:** What if the hotend can't be Auto Home or Auto Bed Leveling?

**Solution:** Please use the height adjustment function of the Proximity Sensor to lower the height. If the problem still cannot be solved, please replace the Proximity Sensor.

**Question 8:** What if something goes wrong with the display screen?

**Solution:** Check the motherboard, replace the firmware.

**Question 9:** What if the model fails to print?

**Error Diagnosis:** Check slicing software settings.

**Solution:** View software professional documentation.