LUGOLABS

LUGO G3

Quick Start Guide

LUGOLABS

* Important notice.

:: Firmware version 1.05 has some error.

A. Preheat

- When you activate preheat, it has two processes.

1. Heat up the bed until it reaches half the target temperature.
2. Heat nozzles and rest of bed temperature.

While process.1 , the motors are not working.

B. Z-offset

- It was supposed to be saved in EEPROM, but it is not working.

The error is showing value is saved, but actually, it is not.

*These error is fixing now so we will share it as soon as possible.

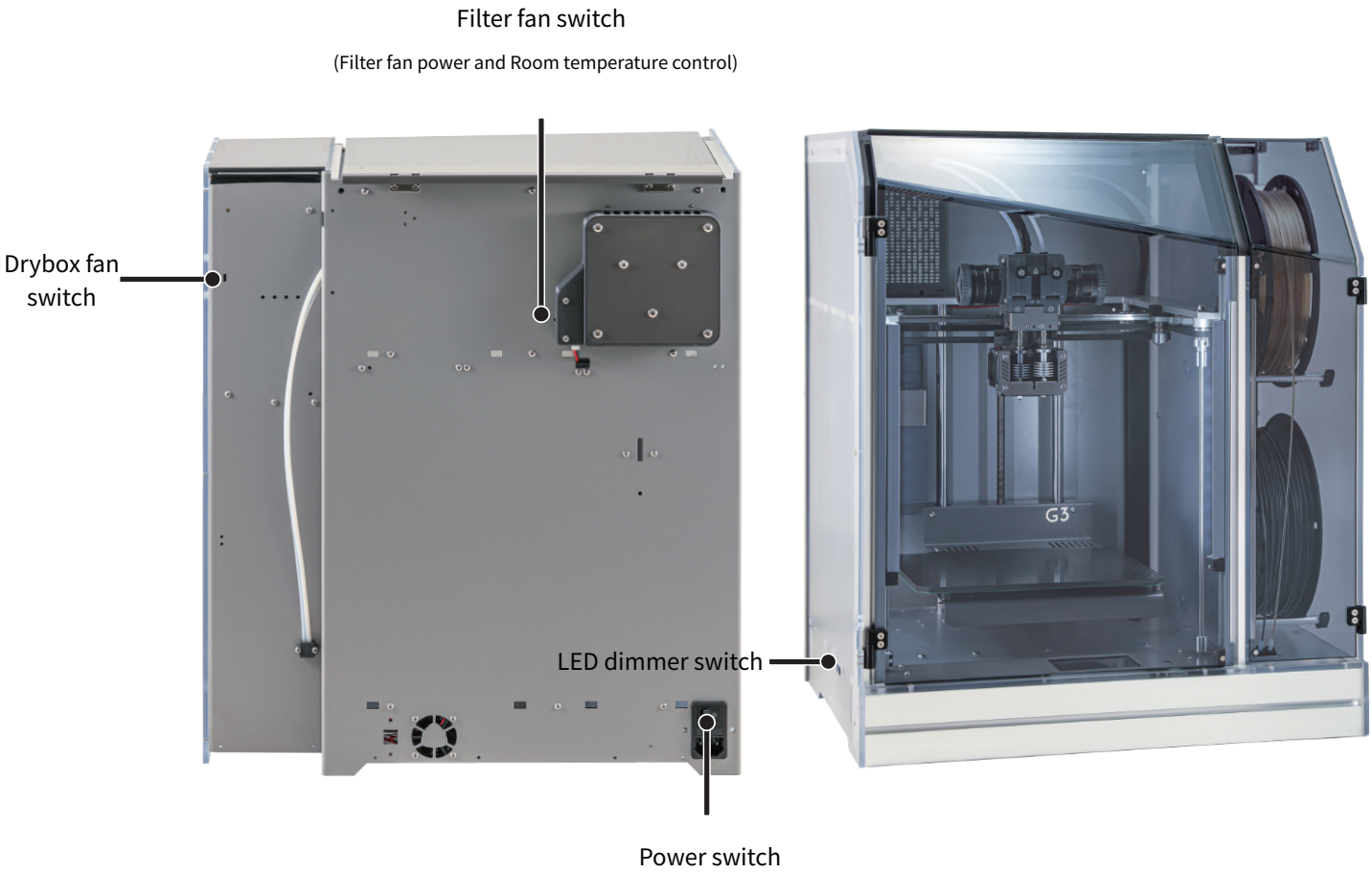
:: LUGO cura 4.1.2

Updates will come up soon.

- There are some inconvenience features or interface.

add better settings and better user interface.

1. Swiches (power, LED, heaters)



Filter fan

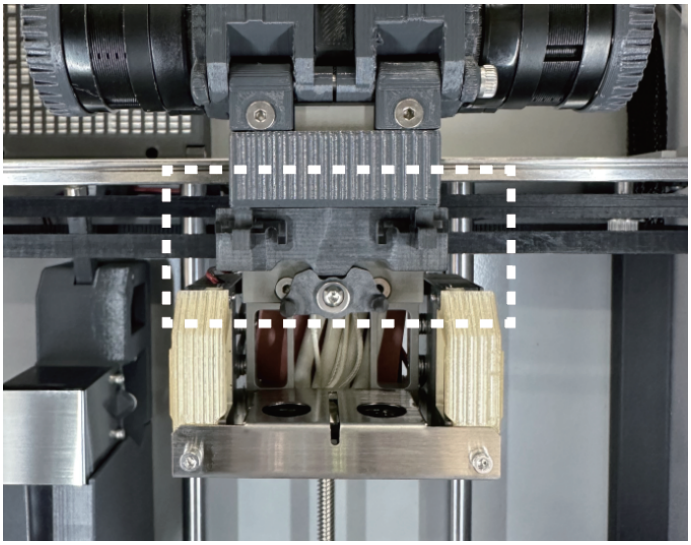
- **Red(Weak):** Materials which should not use cooling : ABS...etc
- **Green(Normal) :** Materials which require cooling but easy to warp : PETG...etc
- **Blue(Turbo) :** Materials which require strong cooling : PLA...etc

Dry box fan for hot air

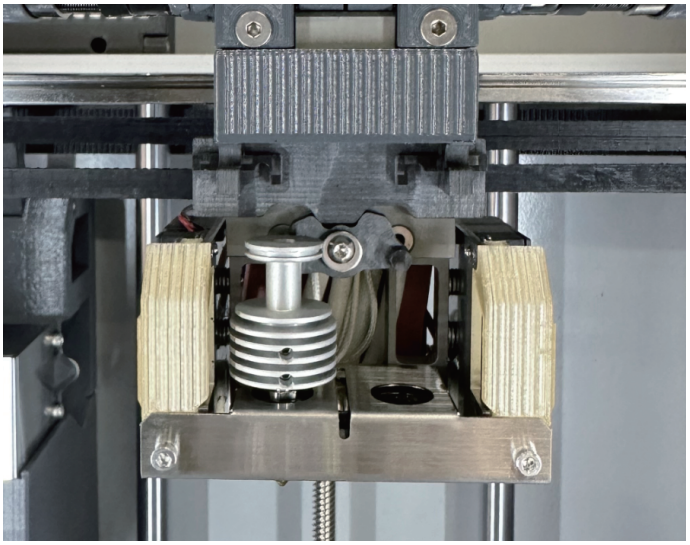
- **Red(Weak):** Lower than 65C thermal resistance materials : PLA...etc
- **Green(Normal) :** Lower than 85C thermal resistance materials : PETG...etc
- **Blue(Turbo) :** Higher than 85C thermal resistance materials : ABS...etc

02. Nozzle installation.

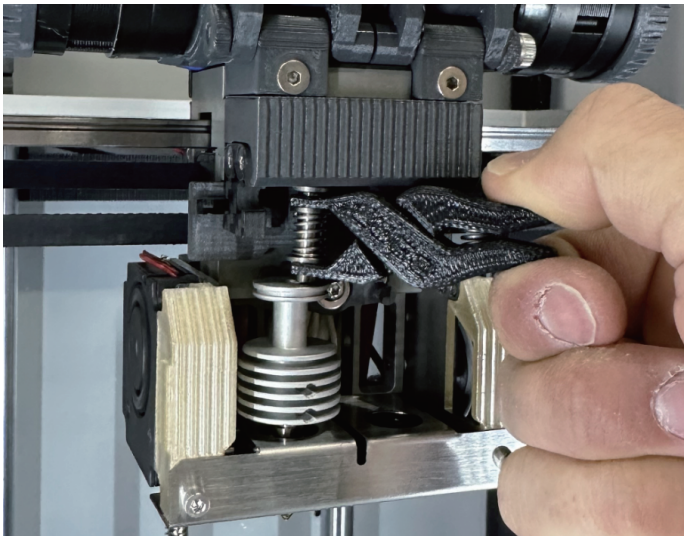
❶ Set a neutral position for the Daul-switch-bar.



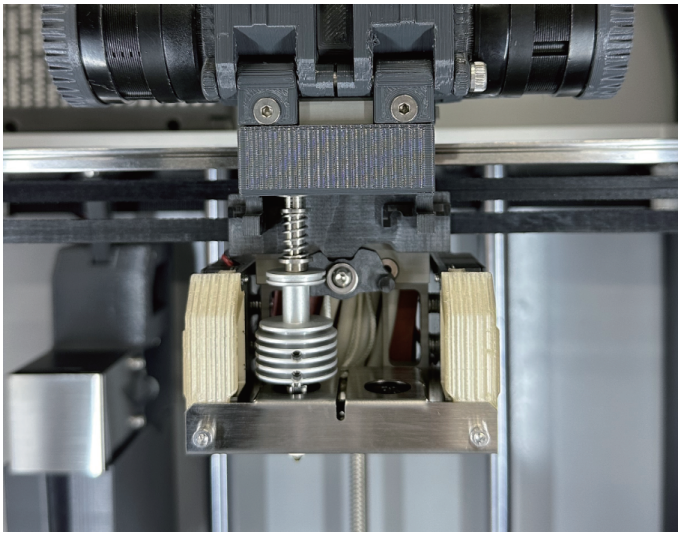
❷ Install a left nozzle.



❸ Grab the nozzle topper with topper-pli-er(printed tool)

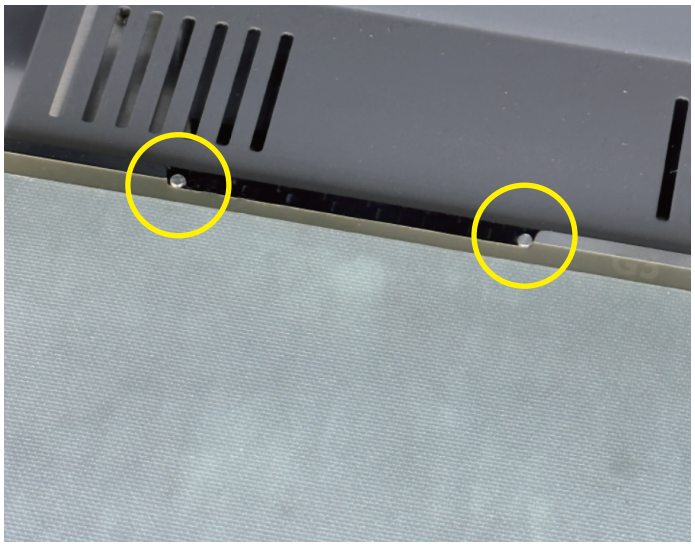


❹ Same as the right nozzle but after the bed levelling.



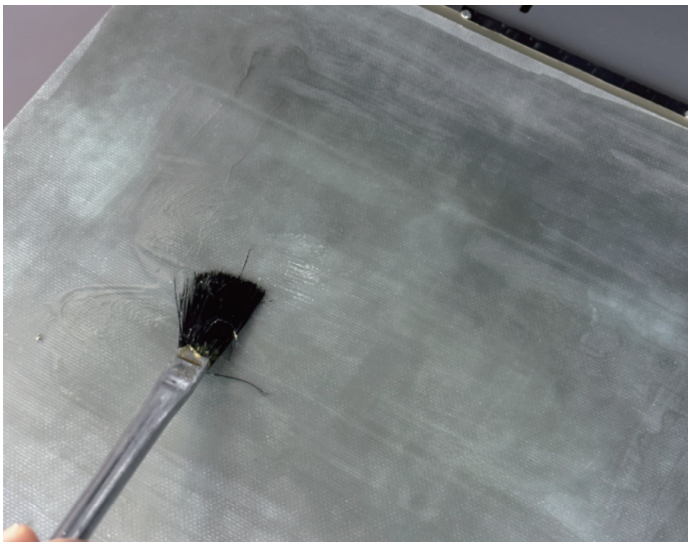
03. Bed plate installation.

❶ Clean the bed surface(carbon) and install the steel plate with the magnet.

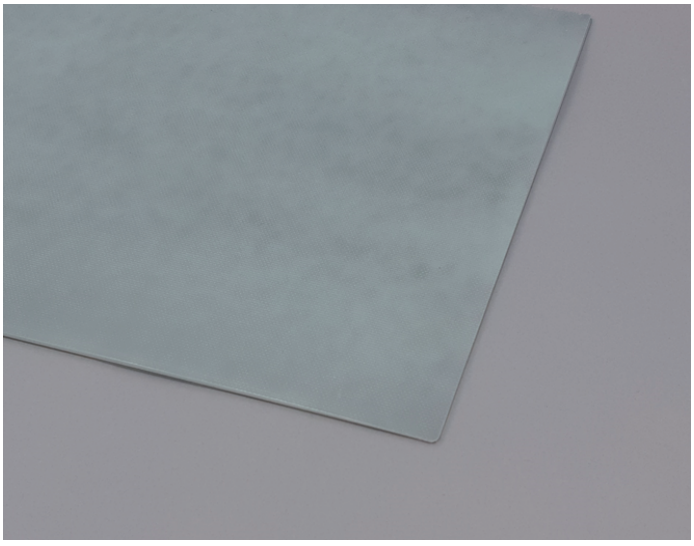


Small dust between the bed surface and steel plate makes an uneven bed levelling issue.

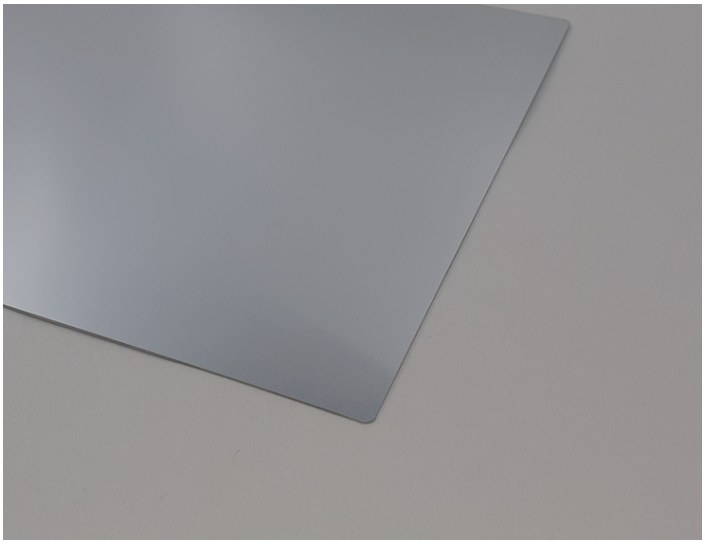
❷ The standard printing plate is an epoxy sheet on a steel plate. It attaches very well with PLA and TPU, but other materials like ABS or PA need adhesive glue.



❸ After the printing process, easy to take off the output with a bending steel plate or use a scrapper. Scrapper doesn't damage the epoxy plate, so this plate has a long lifecycle.

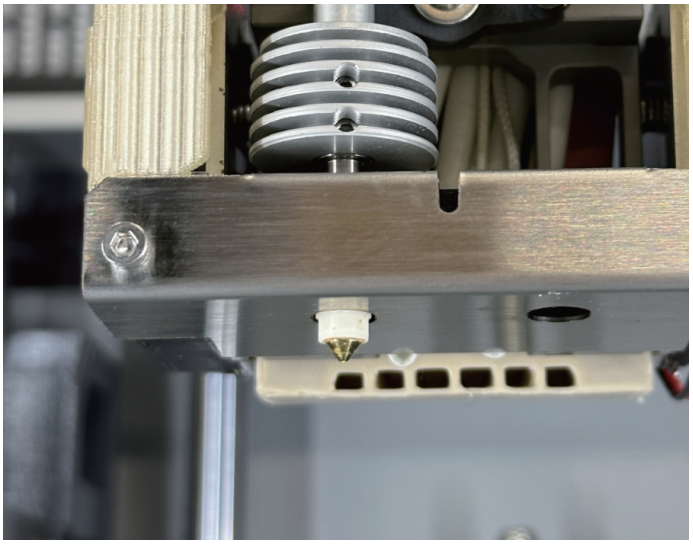


※For high temperature printing, use a stainless plate. (nozzle: over 320C, Bed: over 140C)
You had better use adhesive glue according to the printing material.



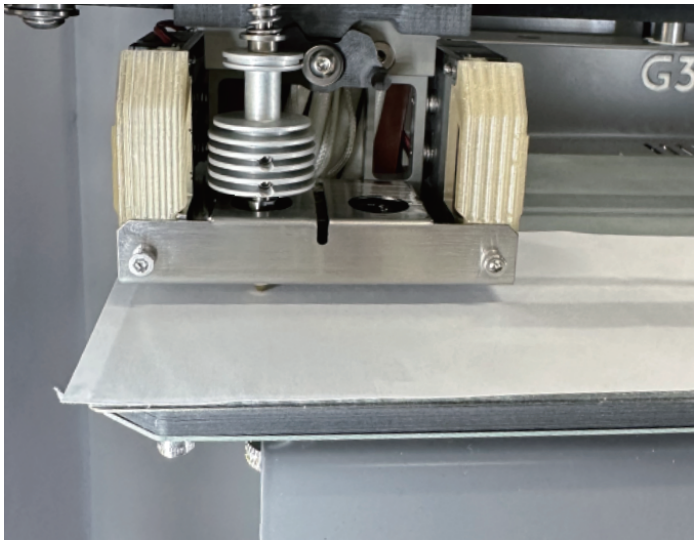
04. Bed levelling.

1. Install the left nozzle and check the end of the nozzle tip. Because if a melted filament remains at the end of the nozzle, bed levelling will not be precise.

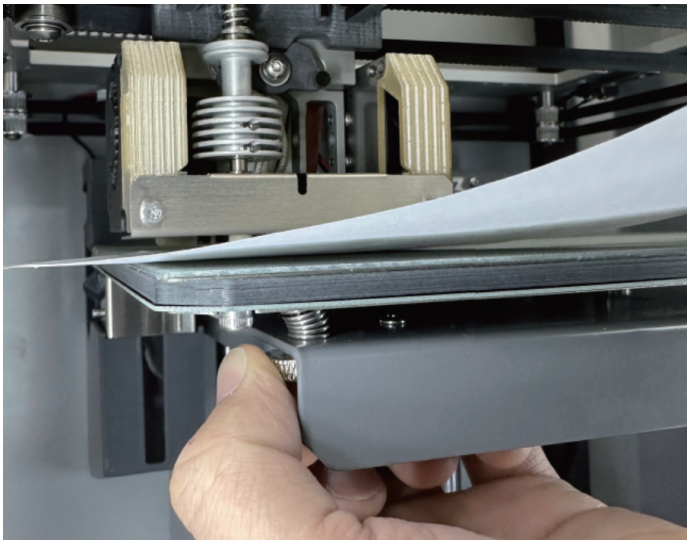


2. Get into the levelling menu, and touch 'Position 1'.

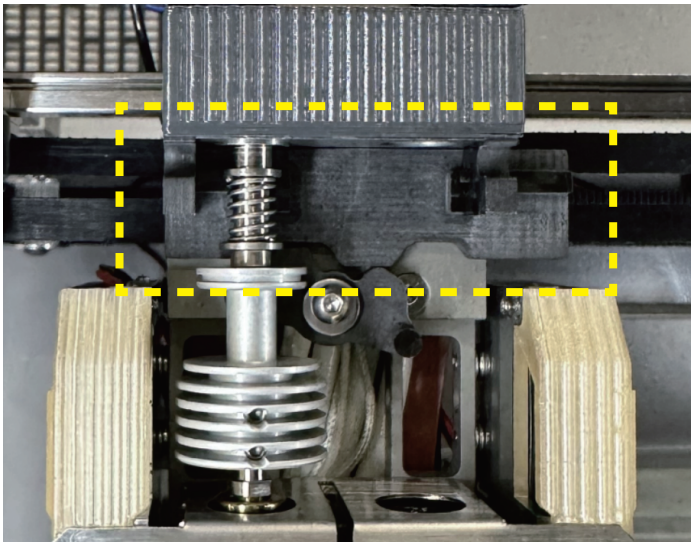
3. Install regular paper between the printing plate and the nozzle tip.



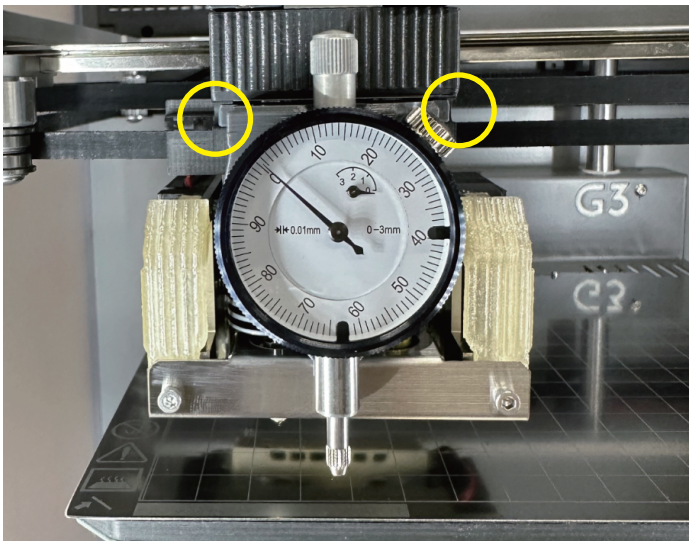
4. Rotate the bed levelling nut until the nozzle, and the bed bite a paper a little.(Move the paper well but feel it is grabbing a little)



5 When the nozzle offset sets well with paper, push the Dual-switch-bar to the right-hand direction to lift the left nozzle.

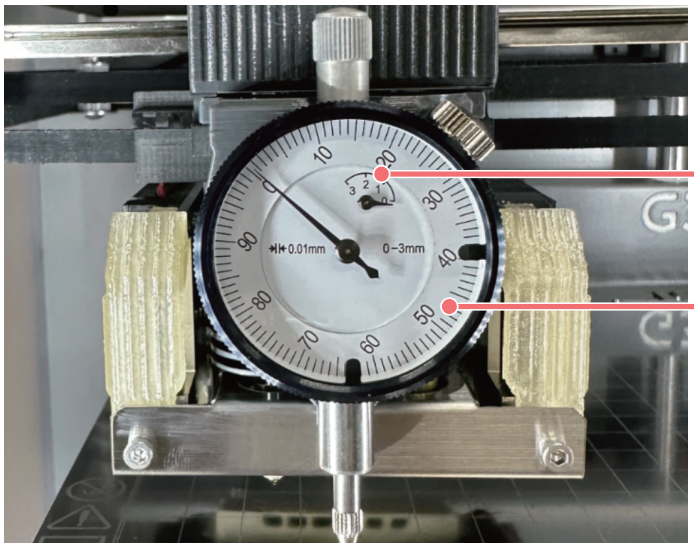


6 Install the levelling gauge in front of the head.



7 Touch the 'Position 1' icon and read the measure in the gauge.

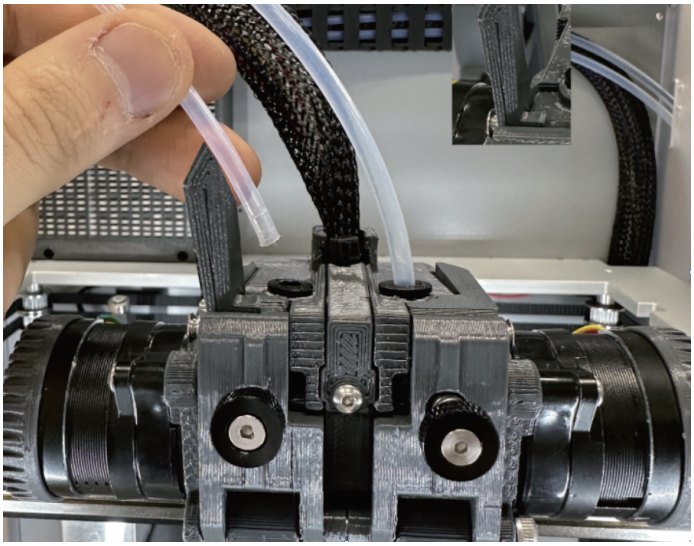
8 Position 2,3,4 should be done for the same measure in the gauge.
(*Have to repeat this job at least twice.)



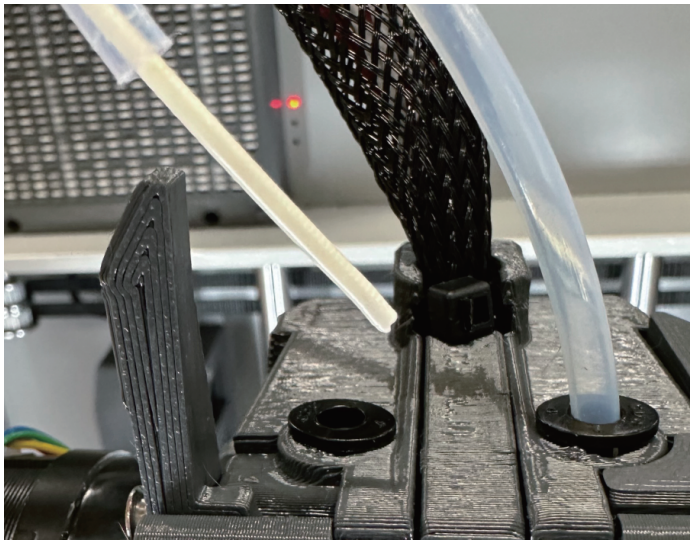
05. Filament installation.

1. Set the appropriate dry box heats according to the material.

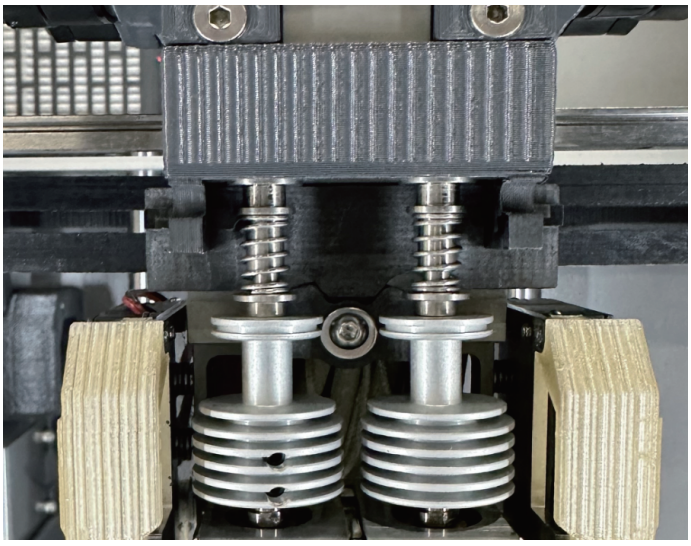
2. Take off the tube at the top of the print head. (Put the tube out while you press the black circle shape fitting.)



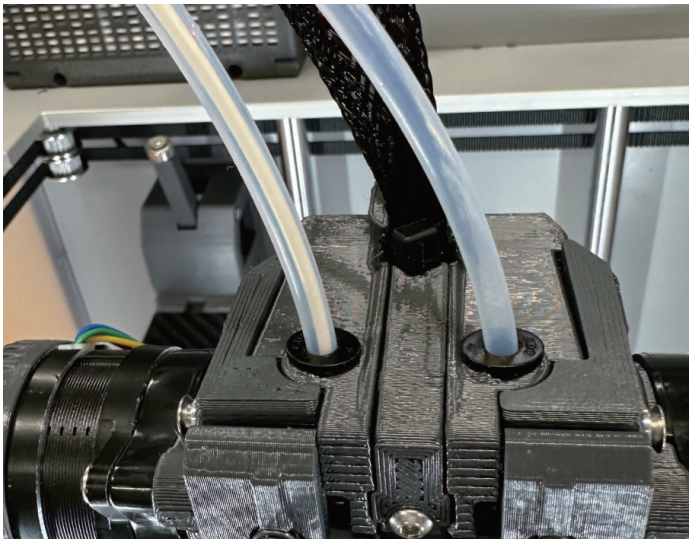
3. Put a bobbin in the dry box and insert the filament in the tube below. Push the filament until it comes out of the other side of the tube.



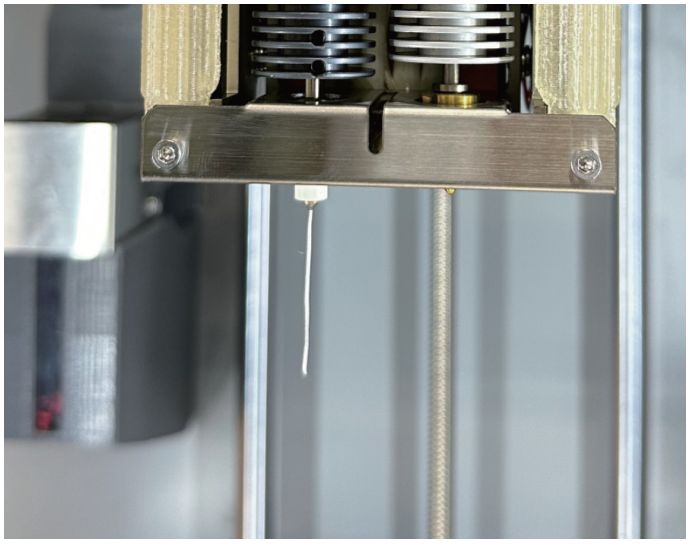
4. Set the nozzle temperature following the installed material. And make a Dual-switch-bar to the 'Neutral position'.



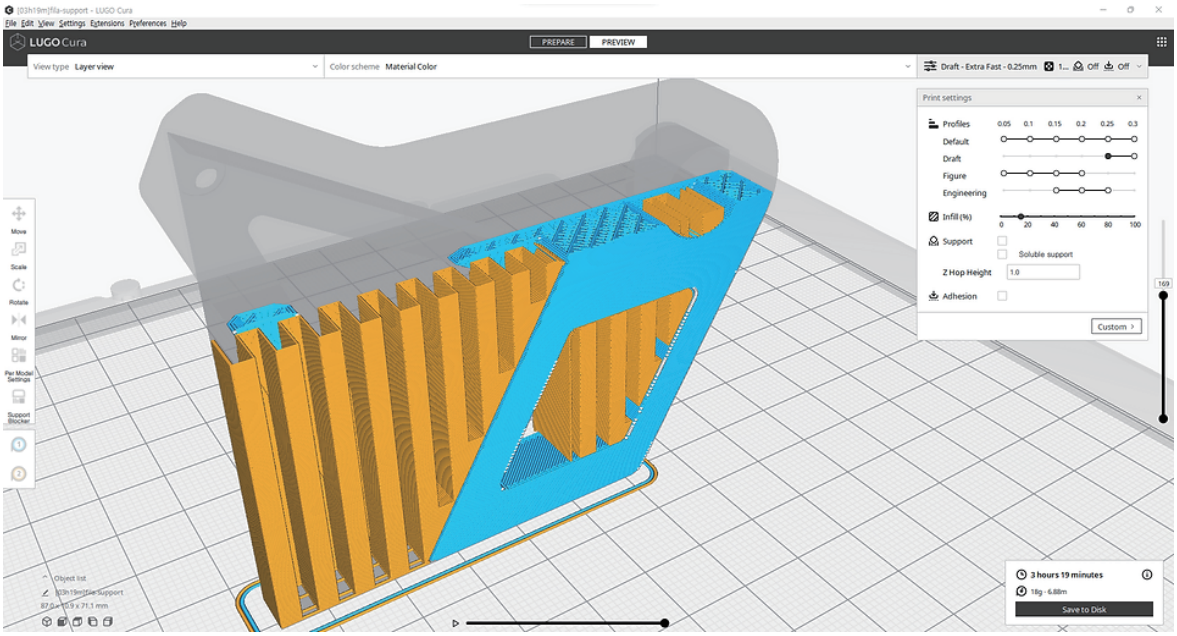
5 Open an extruder lever on the top and insert filament as much as you can. When it stops going inside, then close the lever.



6 Rotate the 'Feeding wheel' under direction. Until melted material comes out at the end of the nozzle.



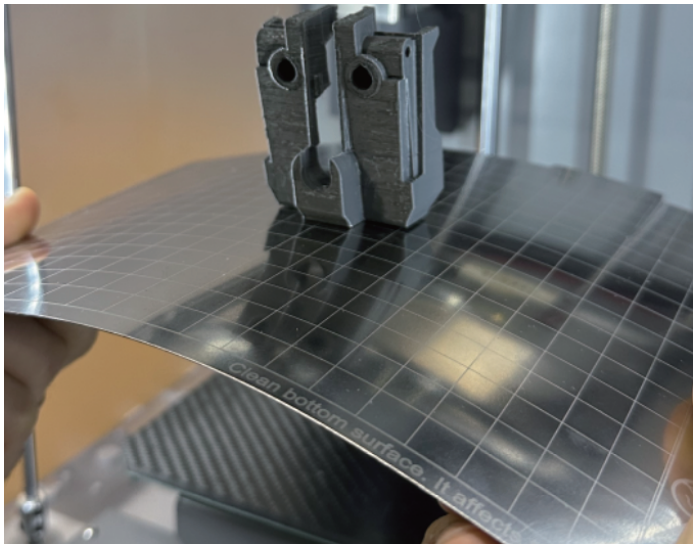
06. Slice with LUGOcura.



Install file and manual download : https://www.lugolabs.xyz/lugocura

07. Remove part after the printing.

1. Take off the printing plate and bend.



2. Use scrapper.