

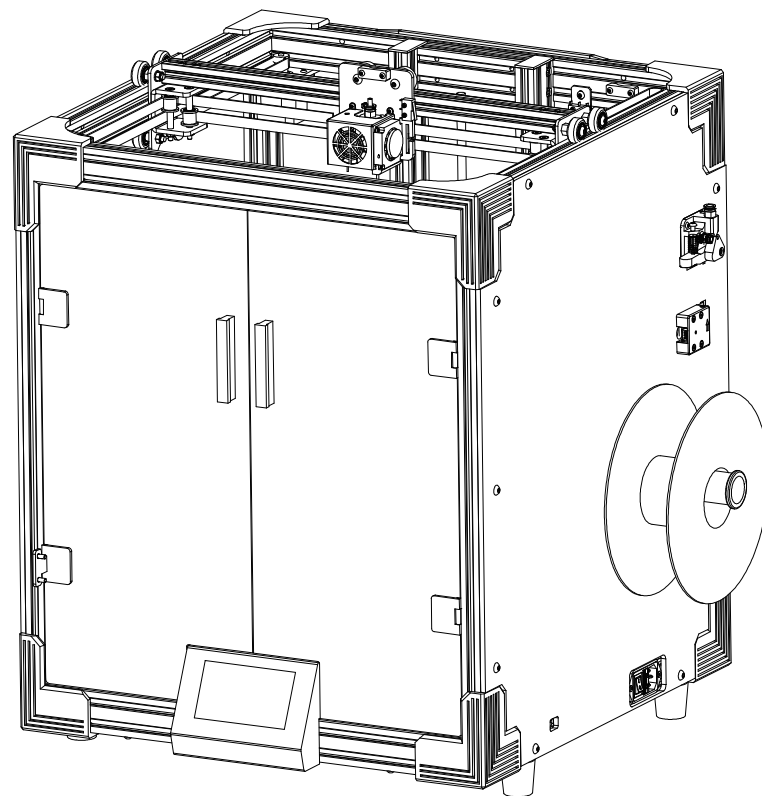


CREALITY

3D Printer User Manual

3D打印机使用说明书

Ender-6



V1.2

Content 目录

Dear Consumers,
Thank you for choosing our products. For the best experience, please read the instructions before operating the Printer. Our teams will always be ready to render you the best services. Please contact us via the phone number or e-mail address provided at the end when you encounter any problem with the Printer.
For a better experience in using our product, you can also learn how to use the Printer in the following ways:
View the accompanied instructions and videos in the Storage card.
Visit our official website www.creality.com to find relevant software/hardware information, contact details and operation and maintenance instructions.

尊敬的创想三维用户：
感谢您选择、使用创想三维的产品。为了您使用方便，请您在使用之前仔细阅读该说明书，并严格按照说明书的指示进行操作。
创想三维团队时刻准备为您提供优质的服务。在使用过程中无论遇到什么问题，请按照说明书结尾所提供的电话、邮箱与我们进行联系。
为了您能够更好地体验我们的产品，您还可以从以下方式获取设备操作知识：
随机使用说明：你可以在存储卡内找到相关使用说明及视频。
创想三维官网：www.cxsw3d.com 您可以登陆创想三维官网寻找相关软硬件、联系方式、设备操作、设备保养等信息。



Notes

使用须知



Assemble the 3D Printer

组装 3D 打印机



Use the 3D Printer

使用 3D 打印机

Level the Heated Bed

调平

Load Filament

装料

Start Printing

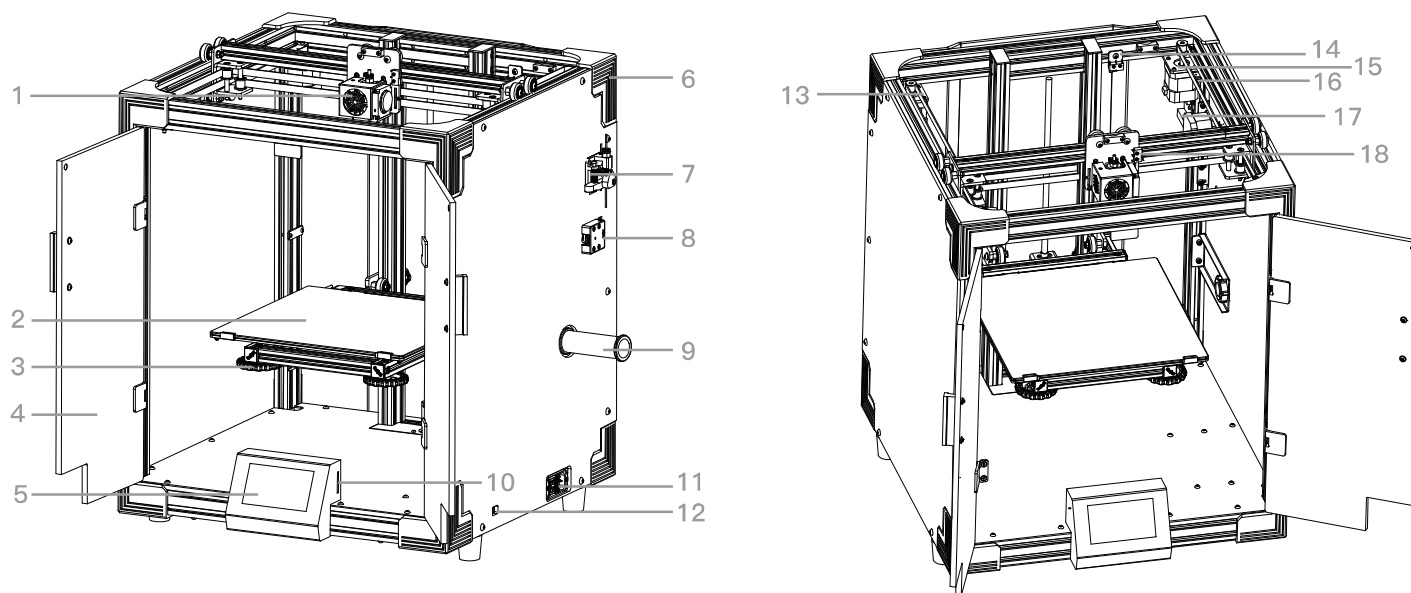
开始打印

NOTES 使用须知

1. Do not use the printer any way other than described herein in order to avoid personal injury or property damage.
2. Do not place the printer near any heat source or flammable or explosive objects. We suggest placing it in a well-ventilated, low-dust environment.
3. Do not expose the printer to violent vibration or any unstable environment, as this may cause poor print quality.
4. Before using experimental or exotic filaments, we suggest using standard filaments such as ABS or PLA to calibrate and test the machine.
5. Do not use any other power cable except the one supplied. Always use a grounded three-prong power outlet.
6. Do not touch the nozzle or printing surface during operation as they may be hot. Keep hands away from machine while in use to avoid burns or personal injury.
7. Do not wear gloves or loose clothing when operating the printer. Such cloths may become tangled in the printers moving parts leading to burns, possible bodily injury, or printer damage.
8. When cleaning debris from the printer hotend, always use the provided tools. Do not touch the nozzle directly when heated. This can cause personal injury.
9. Clean the printer frequently. Always turn the power off when cleaning, and wipe with a dry cloth to remove dust, adhered printing plastics or any other material off the frame, guide rails, or wheels. Use glass cleaner or isopropyl alcohol to clean the print surface before every print for consistent results.
10. Children under 10 years of age should not use the printer without supervision.
11. This machine is equipped with a security protection mechanism. Do not manually move the nozzle and printing platform mechanism manually while booting up, otherwise the device will automatically power off for safety.
12. Users shall comply with related nation and region's laws, regulations and ethical codes where the equipment or produced prints by it is used, and users of our product shall not use aforesaid products to print any end-use products, objects, parts or components or any other physical prints that violate the national or regional laws, regulations and ethical codes where herein referred product and produced prints by it is located.

- 1、请勿尝试任何使用说明中没有描述的方法来使用本机，避免造成的意外人身伤害和财产损失；
- 2、请勿将本机放置在易燃易爆物品或高热源附近，请将本机放置在通风、阴凉、少尘的环境内；
- 3、请勿将打印机放置在振动较大或者其他不稳定的环境内，机器晃动会影响打印机打印质量；
- 4、建议使用厂家推荐耗材，以免造成挤出头堵塞和机器损坏；
- 5、请勿在安装过程中使用其他产品电源线代替，请使用本机附带的电源线，电源插头需接插在带有地线的三孔插座；
- 6、请勿在打印机工作时接触喷嘴以及热床，以防止出现高温烫伤，造成人身伤害；
- 7、请勿在操作机器时佩戴手套或缠绕物，以防可动部件对人身部件造成卷入挤压和切割伤害；
- 8、在打印完毕后及时利用喷头的余温借助工具将喷头上的耗材清理干净，清理时请勿直接用手触摸喷头，以防出现烫伤；
- 9、常做产品维护，定期在断电的情况下，用干布对打印机做机身清洁，拭去灰尘和粘结的打印材料、导轨上的异物；
- 10、年龄在10岁以下的儿童，请勿在没有人员监督的情况下使用本机，以免造成人身伤害；
- 11、本机设有安全保护机制，请勿在开机状态下手动快速移动喷头及打印平台机构，否则设备会自动断电关机保护；
- 12、使用者应遵守设备打印产品与设备所在地及相应国家及地区法律、法规，恪守职业道德，严禁使用我司产品打印有违设备打印产品与设备所在地及相应国家、地区法律禁止的任何产品或物件。

Introduction 设备简介



1 Nozzle Kit | 喷头套件

2 Printing Platform | 打印平台

3 Bed Leveling Nut | 调平螺母

4 Front Door | 前门

5 LCD Screen | LCD显示屏

6 Corner Protector | 护角

7 Remote Extruder | 远端挤出机

8 Filament Detector | 断料检测

9 Filament Holder | 料架

10 Storage Card Slot | 存储卡卡槽

11 Power Cable Connection | 电源组合开关

12 Voltage switching switch | 电压切换拨动开关

13 X Axis Motor | X轴电机

14 Z Axis Limit Switch | Z轴限位开关

15 Y Axis Motor | Y轴电机

16 Y Axis Limit Switch | Y轴限位开关

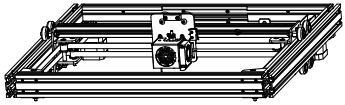
17 Printhead transfer PCB board | 喷头转接PCB板

18 X Axis Limit Switch | X轴限位开关

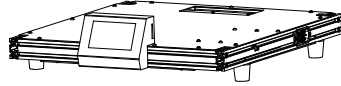
Parameters 设备参数

Basic Parameters 基本参数	
Model 型号	Ender-6
Printing Size 成型尺寸	250*250*400mm
Molding Tech 成型技术	FDM
Nozzle Number 喷头数量	1
Slice Thickness 切片层厚	0.1mm-0.4mm
Nozzle Diameter 喷嘴直径	Standard 0.4mm 标配0.4mm
Precision 打印精度	±0.1mm
Filament 打印材料	1.75mm PLA
File Format 切片支持格式	STL/OBJ/AMF
Working Mode 打印方式	Storage card offline 存储卡脱机
Slice Software 可兼容切片软件	Creality Slicer/Cura/Repetier-Host/Simplify3D
Power Supply 额定电压	Input 输入:AC115/230V 50/60Hz Output 输出:DC 24V
Total Power 额定功率	350W
Bed Temp 热床最高温度	≤100°C
Nozzle Temp 喷嘴最高温度	≤260°C
Resume Print 断电续打	Yes 支持
Filament Detector 断料检测	Yes 支持
language Selection 中英切换	English 中文
Operating System 电脑操作系统	Windows XP/7/8/10 MAC/Linux
Printing Speed 打印速度	≤180mm/s,Normal 正常为 60mm/s

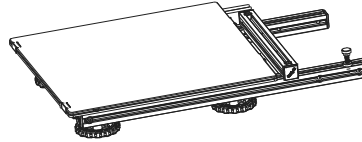
Parts List 零部件清单



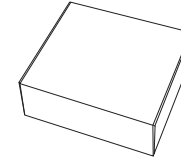
1 Top Components x 1
顶部组件



2 Base Frame x 1
底座



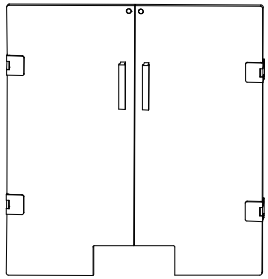
3 Printing Platform x 1
打印平台



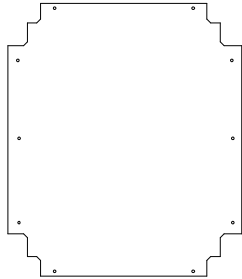
4 Tool Box x 1
工具包



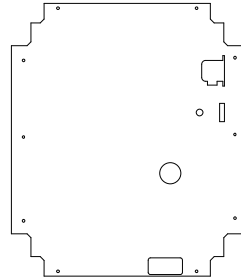
5 Filament x 1
耗材



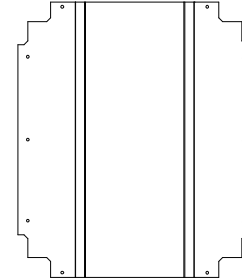
6 Front Door x 1
前门



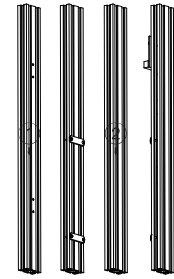
7 Left Seal x 1
左侧封板



8 Right Seal x 1
右侧封板



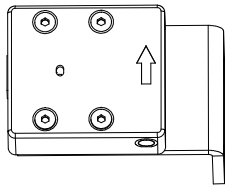
9 Rear Seal x 1
后部封板



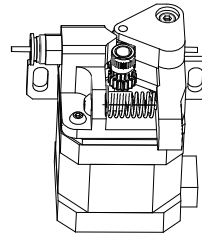
10 Profile x 4
型材



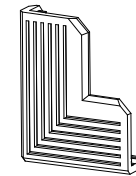
11 Z-Axis Components x 1
Z轴组件



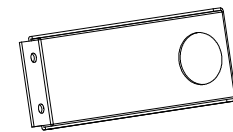
12 Blank Detection Kit x 1
断料检测套件



13 Extruded structural components x 1
挤出机构组件



14 Corner Protector x 8
护角

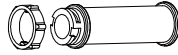


15 Spool Holder x 1
料架

Tool list 工具包清单



16 M5*25 Sems Screw x 8
M5*25组合螺丝



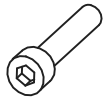
17 Spool & Nuts x 1
料管及料管螺母



18 Hex keys, Wrench x 1
& Screwdriver
扳手和螺丝刀



19 Socket Spanner x 1
套筒扳手



20 M4*16 cup head x 6
screw
M4*16圆柱头螺钉



21 Diagonal Pliers x 1
剪钳



22 M5*45 Sems Screw x8
M5*45组合螺丝



23 Nozzle Cleaner x 1
通针



24 Storage Card & x 1
Card Reader
存储卡和读卡器



25 Spare Blue clip x 2
备用蓝色线夹



26 Pneumatic joint x 2
气动接头



27 Nozzle x 2
喷嘴



28 M4*10 Socket Countersunk x 8
Head Screws
M4*10内六角沉头



29 Cable Ties x 1
扎带



30 Spade x 1
铲刀



31 Power Adapter x 1
电源线



32 M5*20 Sems Screw x6
M5*20组合螺丝



33 Filament Detector x 1
Line
断料检测线



34 Y Motor Wire x 1
Y电机线



35 E Motor Wire x 1
E电机线

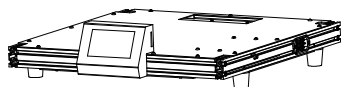


36 M5*20 Hexagon Socket x 30
Button Head Screws
M5*20内六角平圆头螺丝

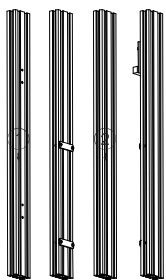
1

Install Profile 安装型材

Take out the bottom component, install four profiles, and install according to the position of the profile digital label and the direction of the arrow.
取出底部组件，安装四根型材，按照型材数字标签位置和箭头方向安装。



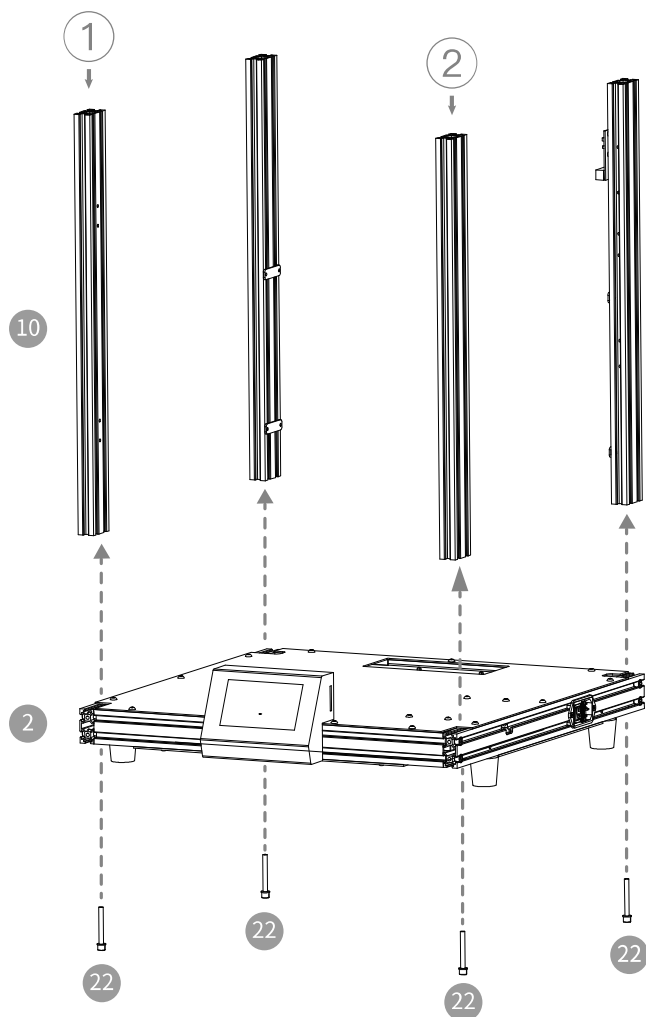
2 Base Frame x 1
底座



10 Profile x 4
型材

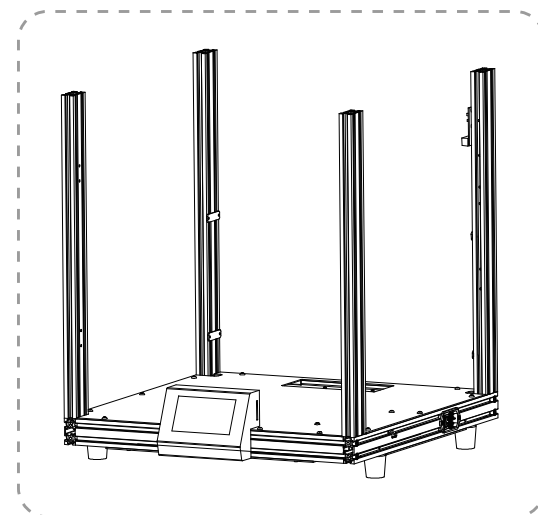


22 M5*45 Sems Screw x4
M5*45组合螺丝



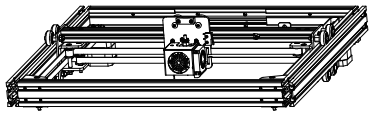
When install profiles, please refer to the marked number on the profiles to find the related position and install them based on the direction of arrow, then tighten the screw from the bottom.

安装型材，请按照型材上标注的数字，按相应的位置和箭头方向安装，底部螺丝向上锁紧。



2

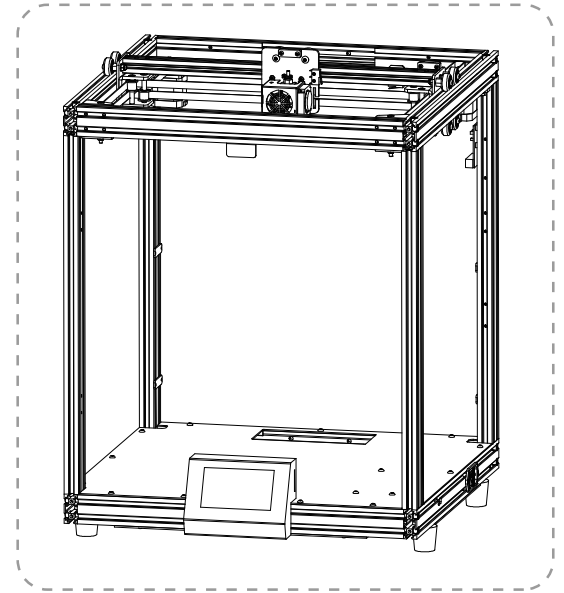
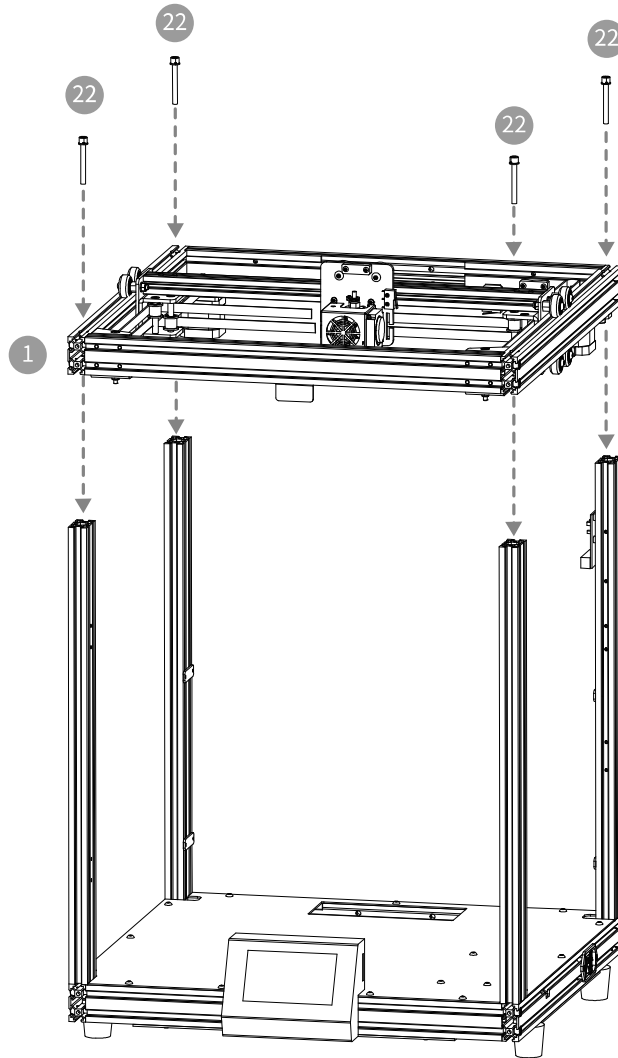
Install Top Frame 安装顶部框架



1 Top Components x 1
顶部组件



22 M5*45 Sems Screw x4
M5*45组合螺丝



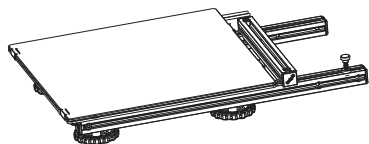
3

Install the printing platform

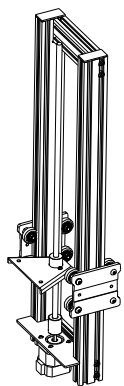
安装打印平台



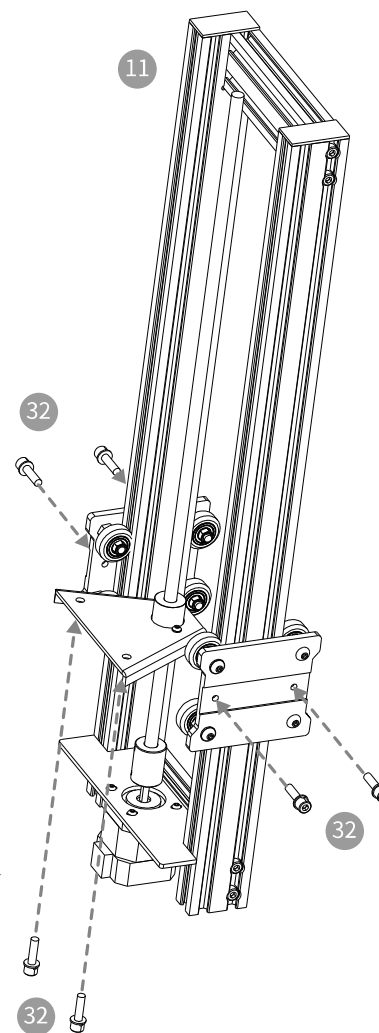
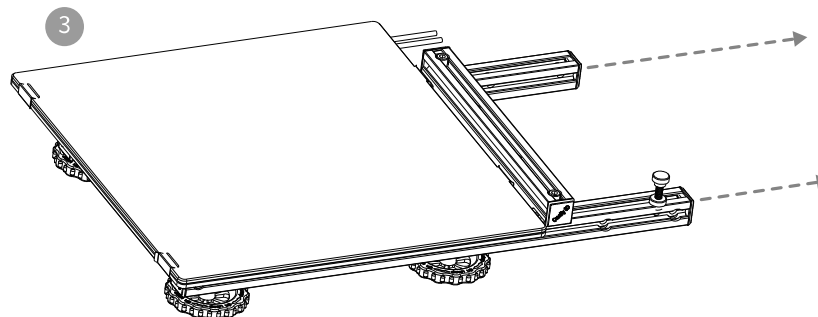
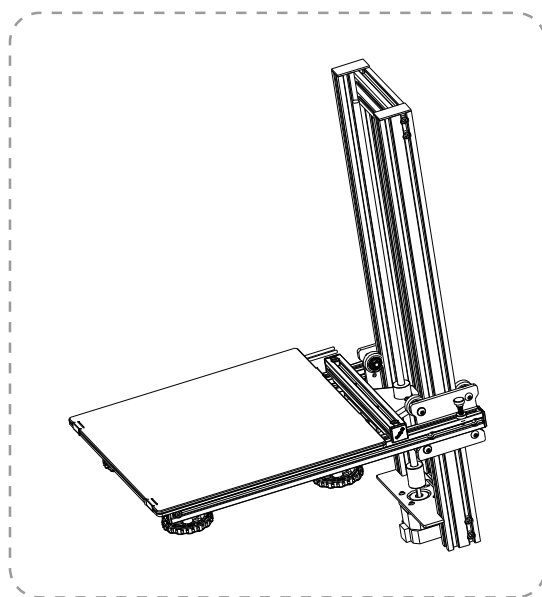
32 M5*20 Sems Screw x6
M5*20组合螺丝



3 Printing Platform x 1
打印平台



11 Z-axis components x 1
Z轴组件



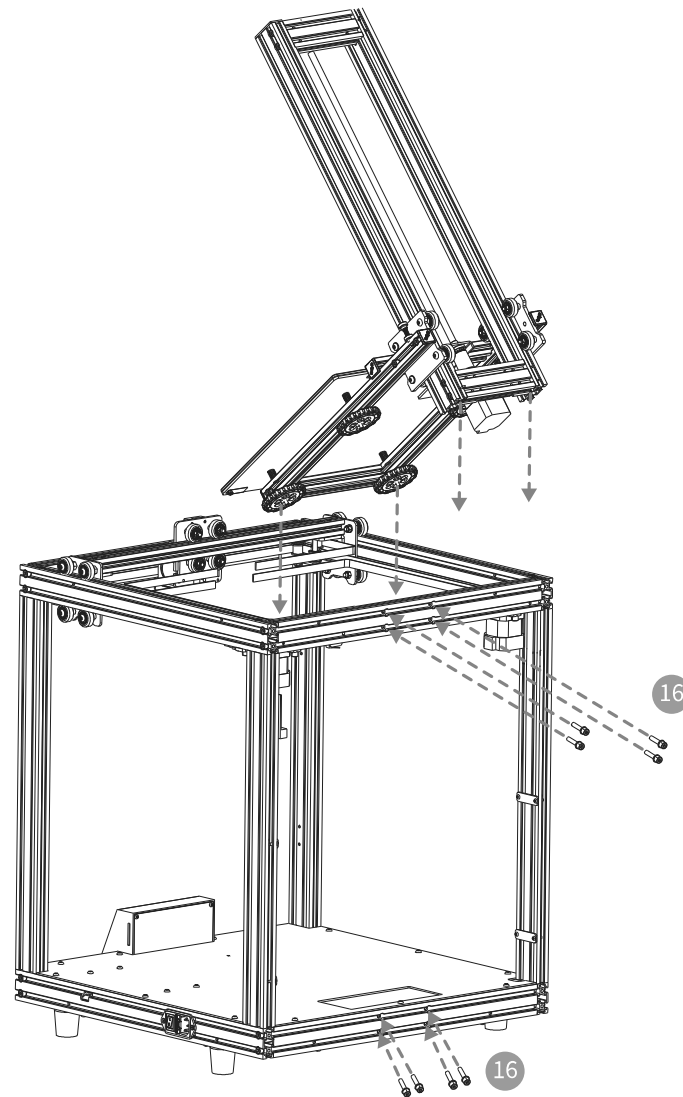
4

Install the Z axis assembly

安装Z轴组件

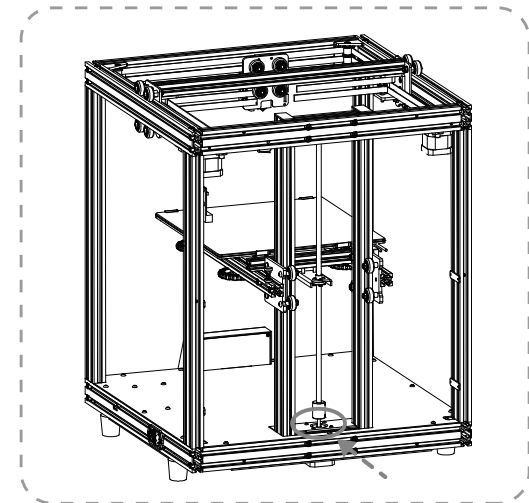


16 M5*25 Sems Screw x 8
M5*25组合螺丝



Notes: If the T-type screw is inclined, please slightly loosen the 4 screws on the Z-axis motor and make the screw rod vertical through moving the T-nut connector to, and then tighten the screws on the motor.

注意: 如果T型丝杆有倾斜现象, 请稍微松开Z轴电机的4个固定螺丝, 并用手上下移动T型螺母连接件, 使丝杆趋于垂直, 然后再锁紧电机固定螺钉。



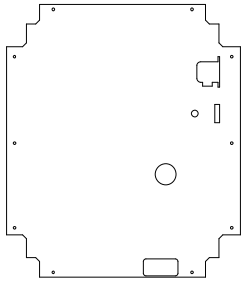
5

Install Right Seal 安装右侧封板

The rubber pad at the bottom of machine will be slightly deformed under stress.

If this happens when you install the acrylic plate, please loosen the foot pad first, and then lock them after installing the acrylic board.

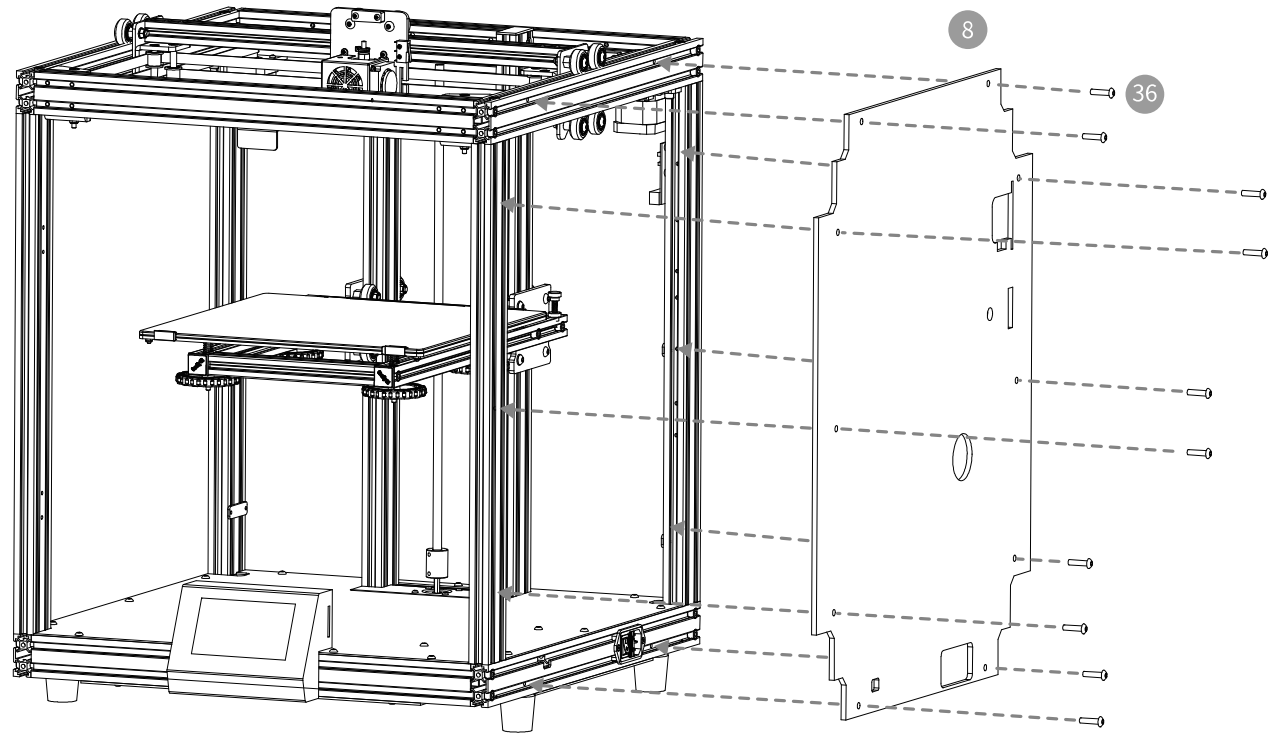
由于底部橡胶垫在受力情况下会有微小变形, 安装亚克力板时如出现和橡胶垫陷入部分干涉, 可先将脚垫微松, 安装完亚克力板后再锁紧脚垫。



8 Right Seal x 1
右侧封板



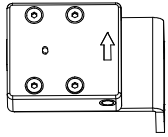
36 M5*20hexagon socket x 10
button head screws
M5*20内六角平圆头螺丝



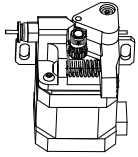
6

Installation Of Extruder, Material Detection, Material Rack

安装挤出机、断料检测、料架



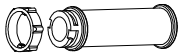
- 12 Blank Detection Kit x 1
断料检测套件



- 13 Extruded structural x 1
挤出机构组件



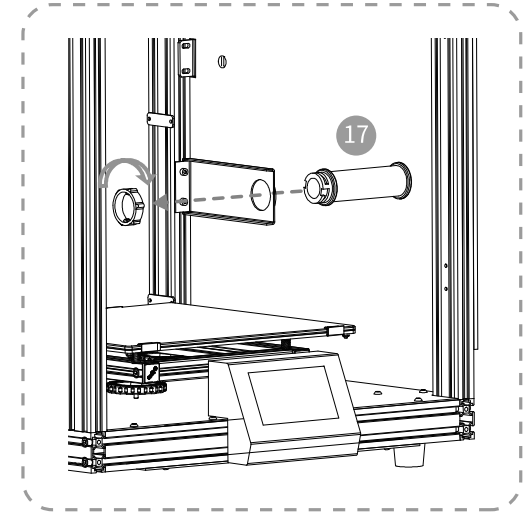
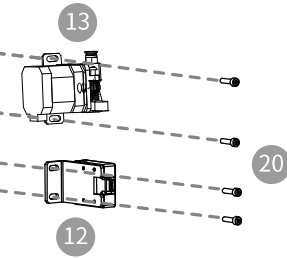
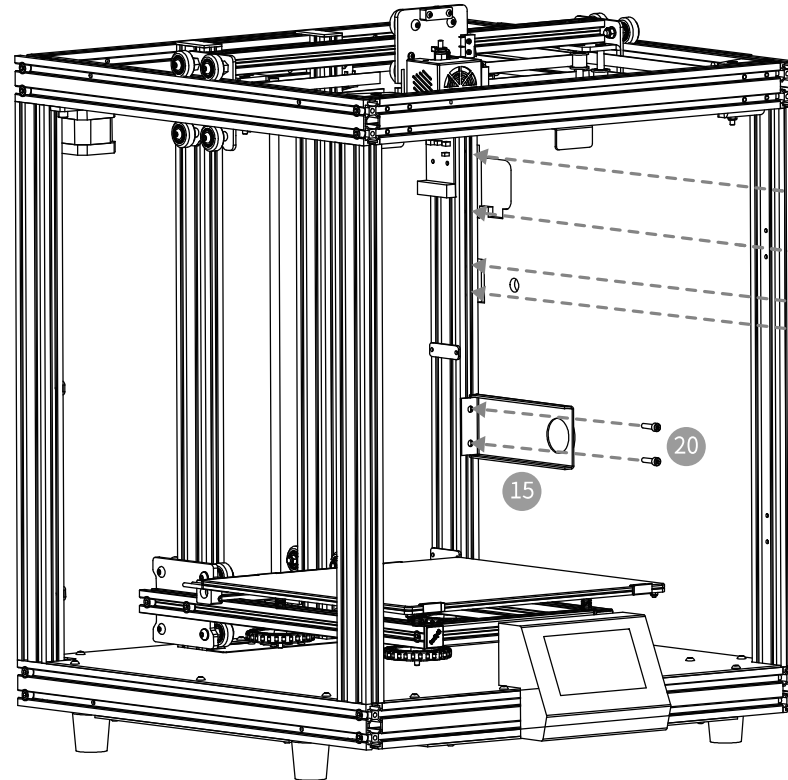
- 15 Spool Holder x 1
料架



- 17 Spool & Nuts x 1
料管及料管螺母



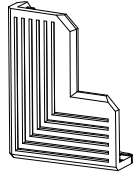
- 20 M4*16 cup head screw x 6
M4*16圆柱头螺钉



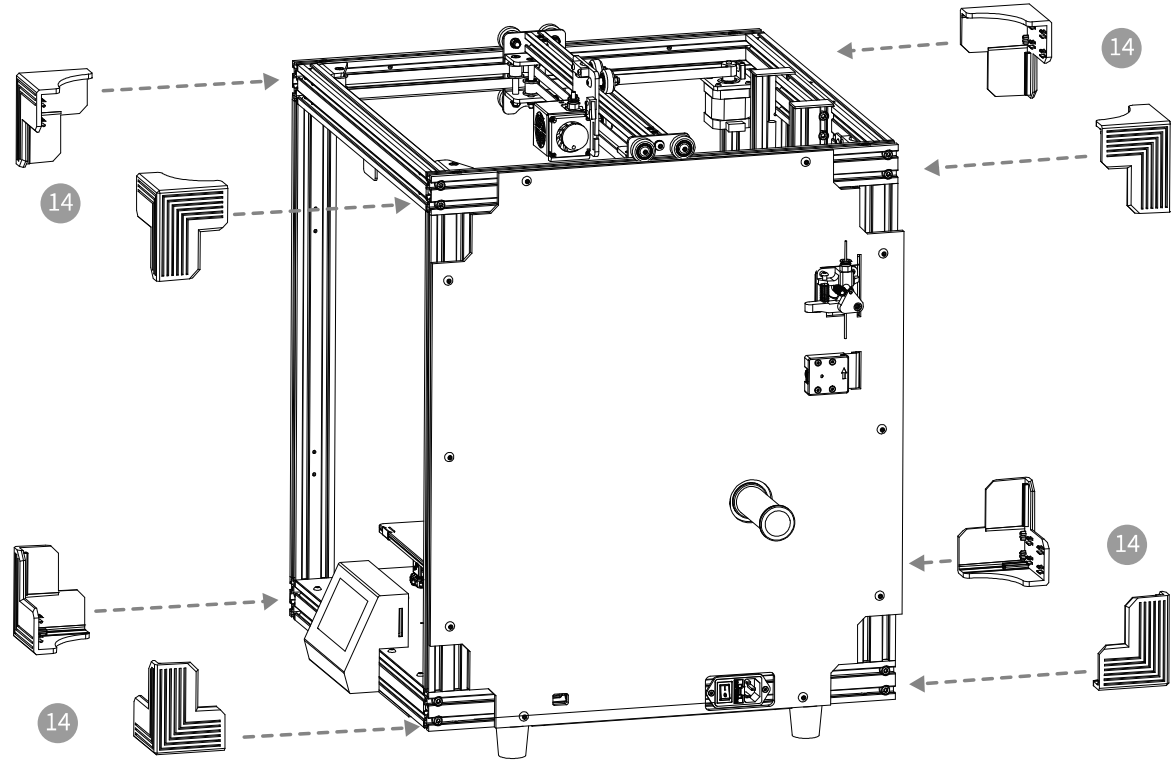
7

Install Corner Protector

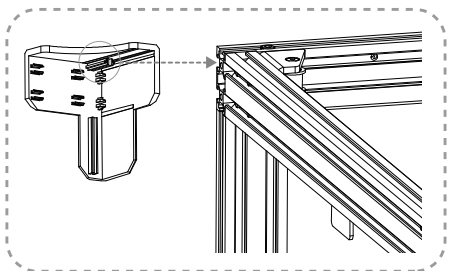
安装护角



14 Corner Protector x 8
护角



Notes: The corner protector has two different card positions. If it is not suitable during installation, please replace with another installation.
温馨提示: 护角有两种不同卡位, 安装时如不合适, 请更换另一种安装。



8

Cable Connection 1 设备接线1

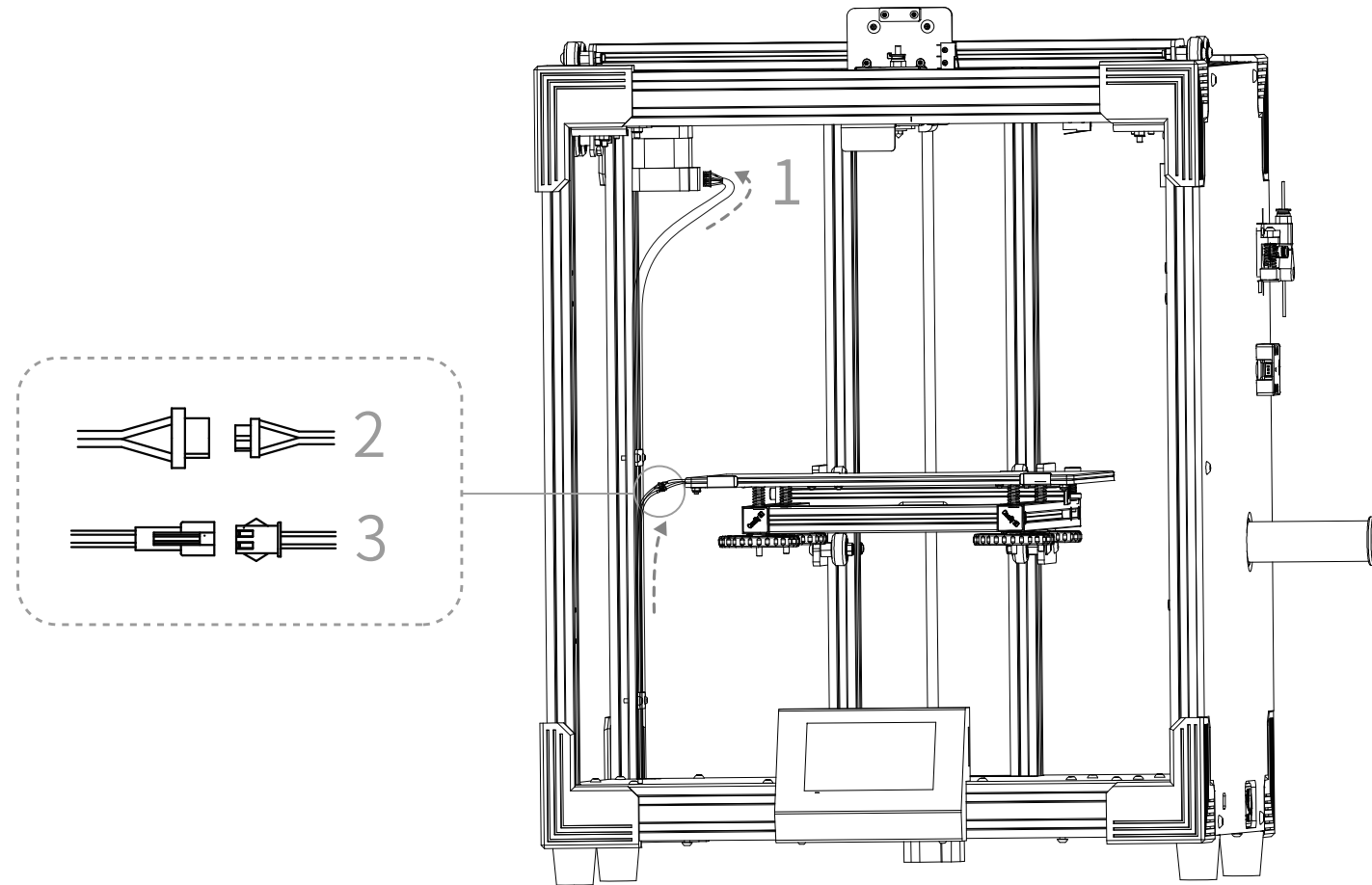
1 Connect X axis motor line 2 Connect hot bed heating line 3 Hot bed temperature sensing line

1 连接X轴电机线 2 连接热床加热线 3 热床温感线

Follow the yellow label on the 6pin (4-wire) port to connect the X-axis motor cable 按照6pin (4线) 端口上黄色标签提示连X轴电机线

Follow the yellow label on the 2pin (2-wire) port to connect the hotbed docking connector 按照2pin (2线) 端口上黄色标签提示连接热床对接接头

Connect the connector corresponding to the number of pins 连接对应针数的接头



9

Cable Connection2 设备接线2

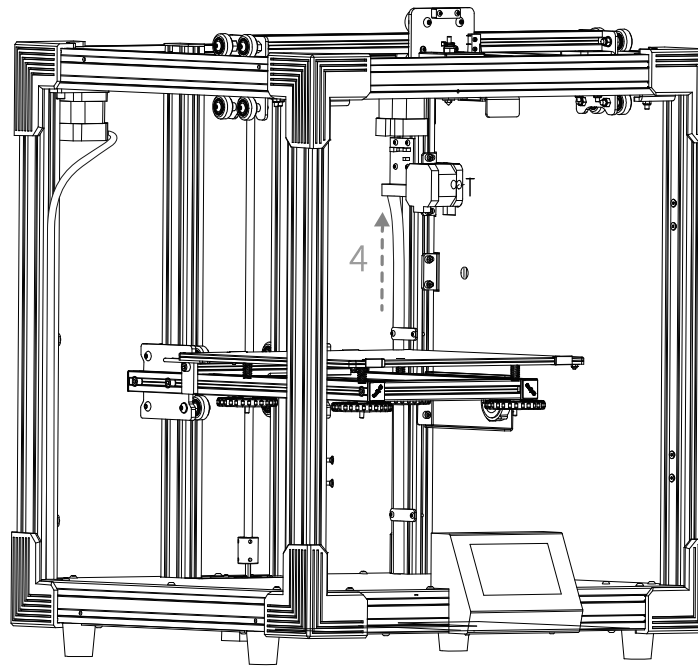
4 Connect the right nozzle transfer cable (wire) 5 Connect the breakout detection line, Y motor line, E motor line and other adapter plate lines
 4 接右侧喷嘴转接线(排线) 5 接断料检测线、Y电机线、E电机线等转接板线

Please insert each connection line in the corresponding position according to the line label
 请按线标指示将各连接线插在对应位置

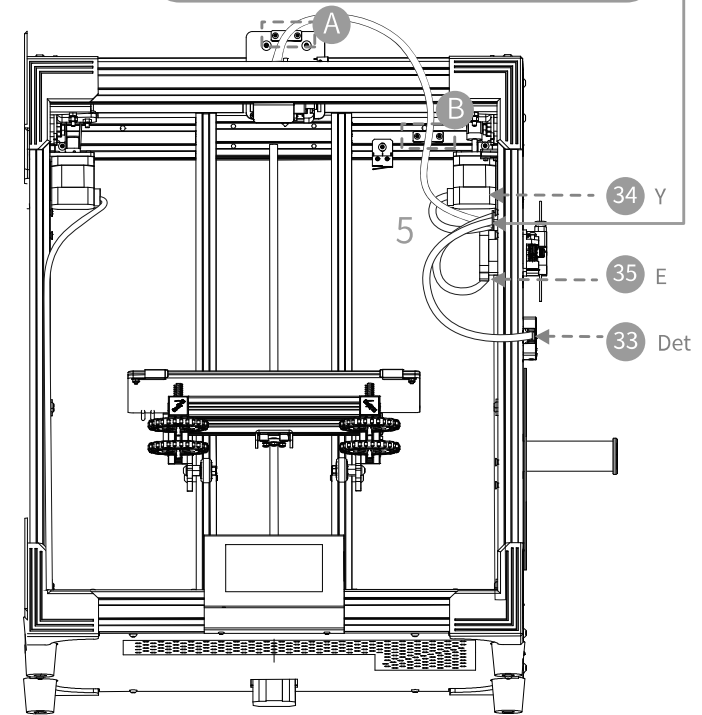
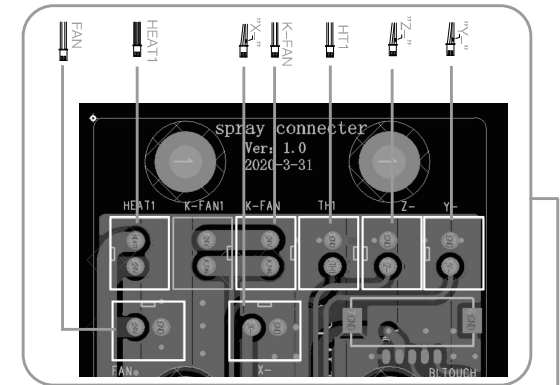
33 Filament Detector x 1
 Line
 断料检测线

34 Y Motor Wire x 1
 Y电机线

35 E Motor Wire x 1
 E电机线



Loosen the screws at A and B in the figure, and press the corrugated tube into the hold-down block to prevent them from hanging down on the Hotbed.
 将图示A、B两处的螺丝拧松，将波纹管压在压紧块内，以便防止线材垂于热床板上。



10

Cable Connection3 设备接线3

6 Connect the Z-axis motor cable 7 Connect the power cable
6 连接Z轴电机线 7连接电源线



Caution

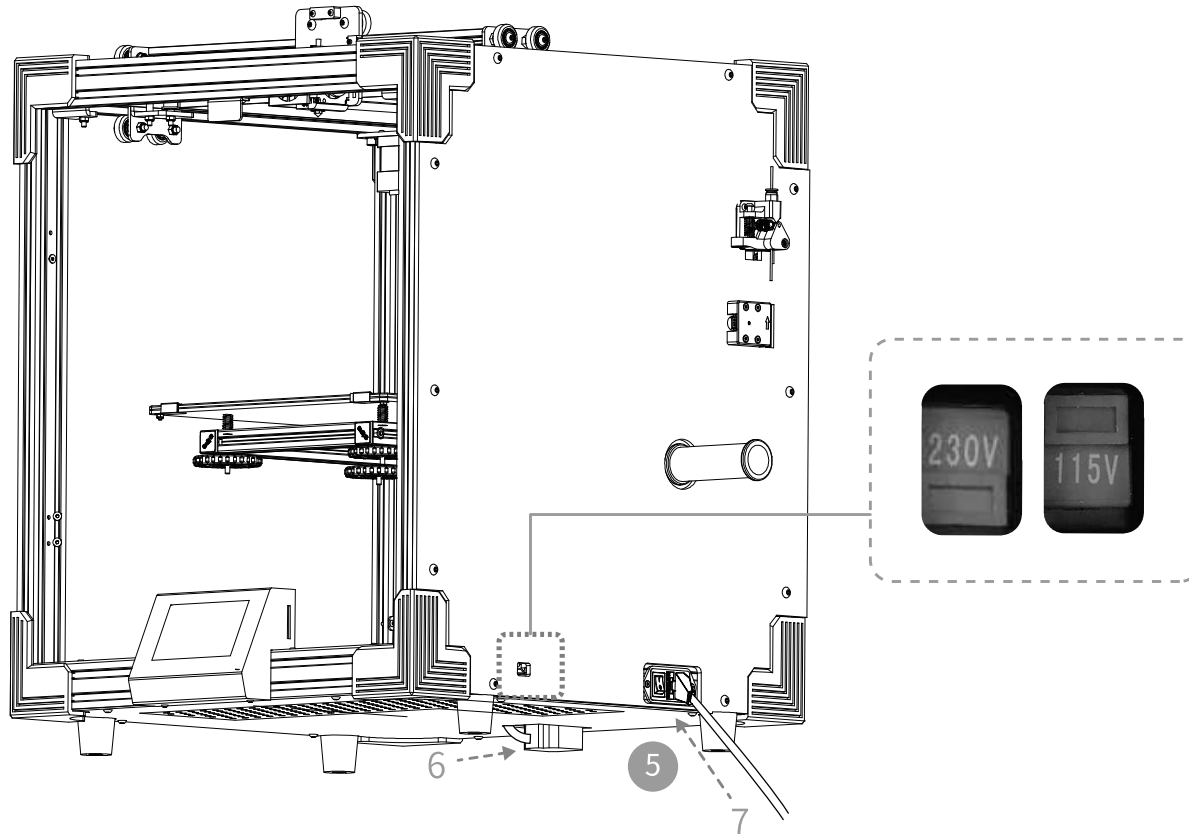
- Select the correct input voltage to match your local mains (115/230V)
- Damage can occur if voltage is set incorrectly.
- Connect the power cord and turn the power switch to 1 to turn it on.
- 选择正确的输入电压以匹配您的本地电源（115/230V）
- 如果电压设置不正确，可能会造成损坏。
- 连接电源线并将电源开关拨至1档即可开机



Do not connect or disconnect the cables when the machine is powered on.
当机器通电时，请勿连接或断开连接线。



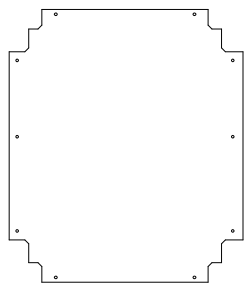
5 Power Adapter x 1
电源线



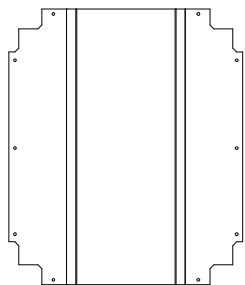
11

Install the left seal and rear seal

安装左侧封板、后部封板



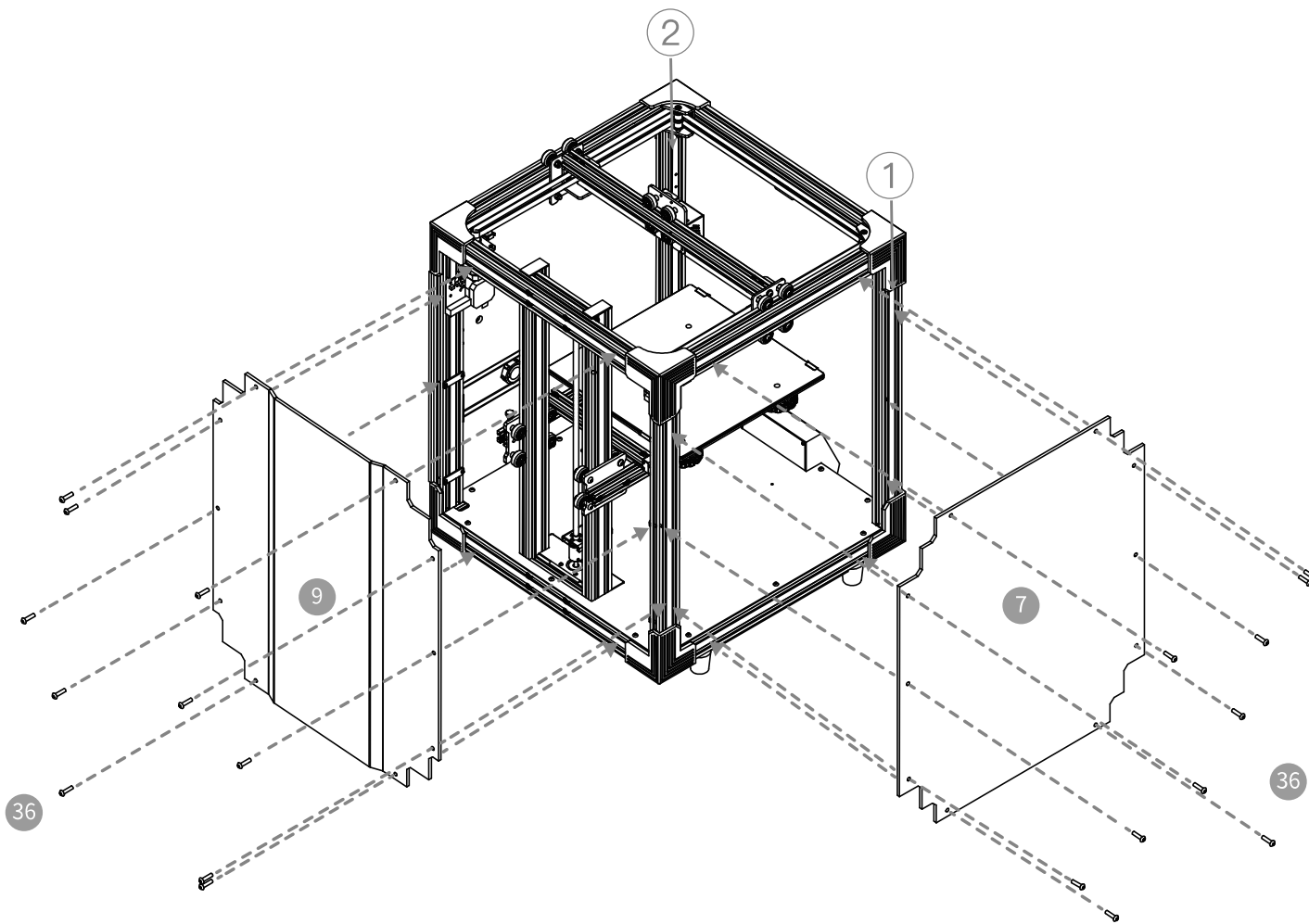
7 Left Seal x 1
左侧封板



9 Rear Seal x 1
后部封板



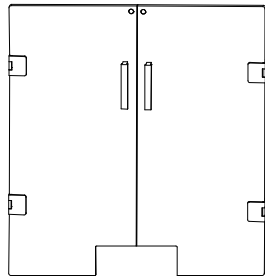
36 M5*20 Hexagon Socket
Button Head Screws
M5*20内六角平圆头螺丝



12

Install Front Door

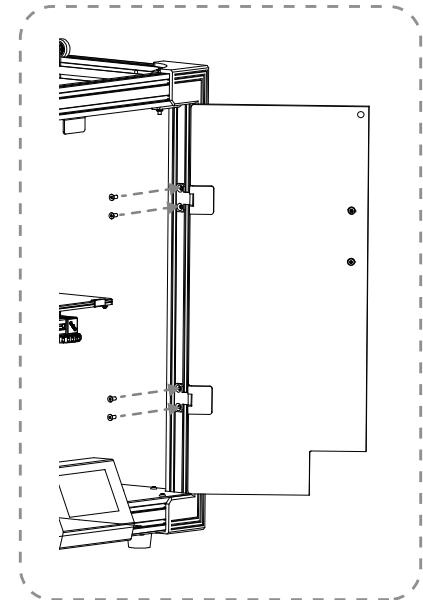
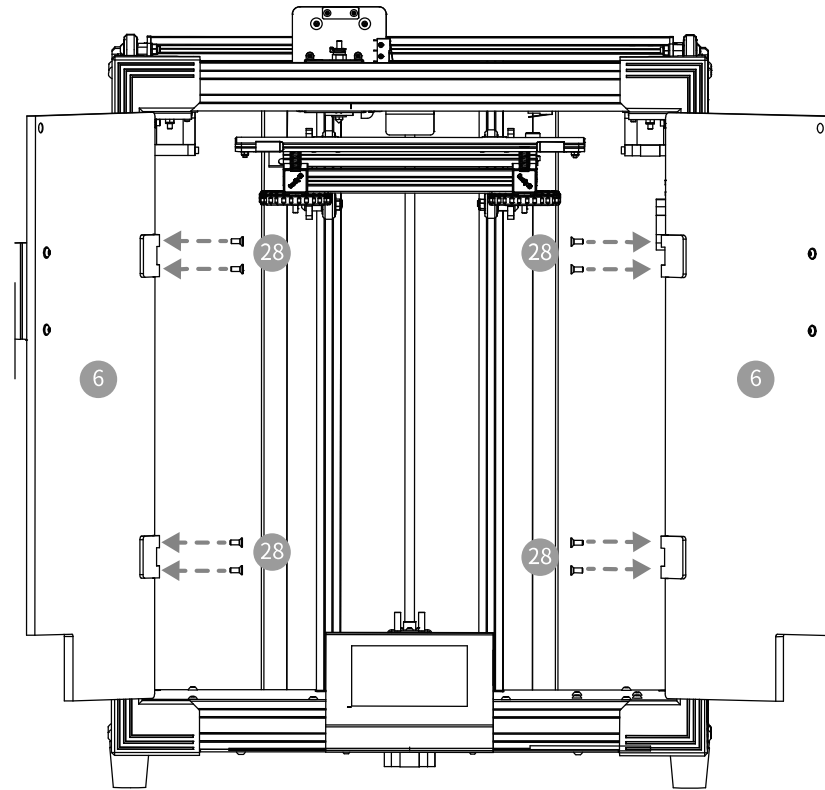
安装前门



6 Front Door x 1
前门



28 M4*10 Socket x 8
Countersunk Head Screws
M4*10内六角沉头



After installation, to ensure each V-wheel is well combined with the profile. Please check as follows before printing.

1. Z-axis: Check whether the 8 pieces of V wheels is idling;
2. X-axis: Check whether the 4 pieces of V wheels on the nozzle mounting plate are idling;
3. Y-axis: Check whether the 4 pieces of V wheels on the left and right sides of the mounting plate are idling;

If there is idling, please adjust the eccentric nut.

安装完后为确保各V轮与型材良好接触,在打印前请进行如下检查:

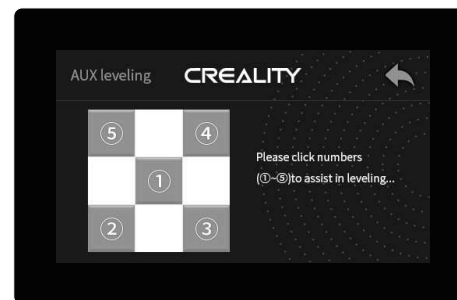
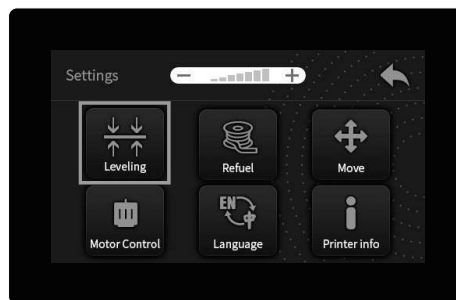
- 1、Z轴:用手轻转8个V轮检查是否有空转情况;
- 2、X轴:检查喷嘴安装板的4个V轮是否有空转情况;
- 3、Y轴:检查左右两侧安装板的4个V轮是否有空转情况;

如有空转,请通过调节偏心螺母使每个V轮在用手轻转时均不出现空转。

13

Bed Leveling 调平平台

Choose setting_leveling model- Aid- leveling,clicking number ①/②/③/④/⑤
选择设置→调平模式→辅助调平，点击数字①/②/③/④/⑤。

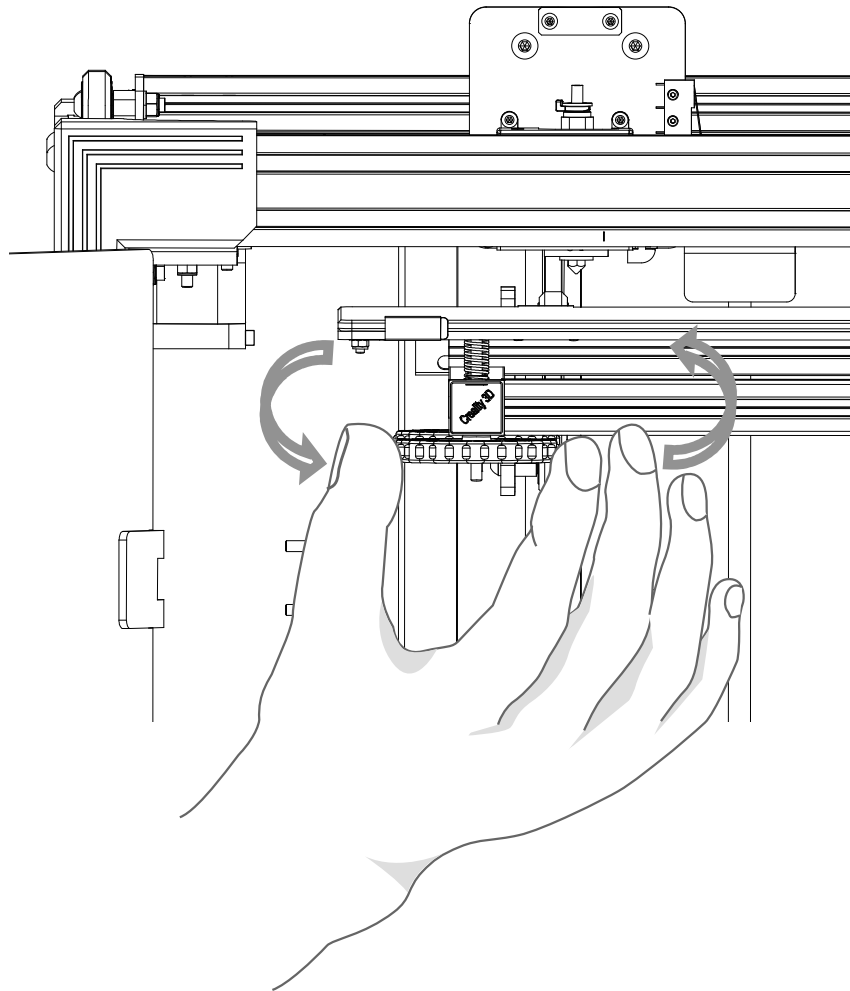


Note: The UI information is only for reference, the actual UI may be different.
注意：界面仅供参考，实际以UI为准。

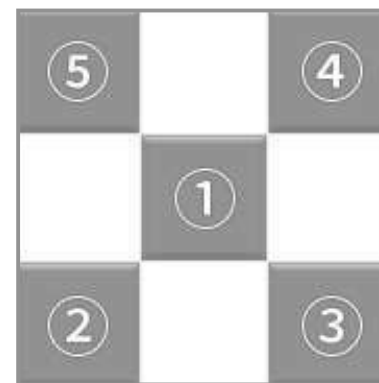
14

Move the nozzle the front/left leveling screw and adjust the platform height by turning the knob underneath (The thickness of a piece of A4 paper).

移动喷嘴至调平螺母上方附近。拧动螺母，调节打印平台喷嘴使二者处于刚好贴合状态，间距约为0.1mm（一张A4纸的厚度）。按顺序调平四个角，点击①，测试平台中间间隙是否合适。



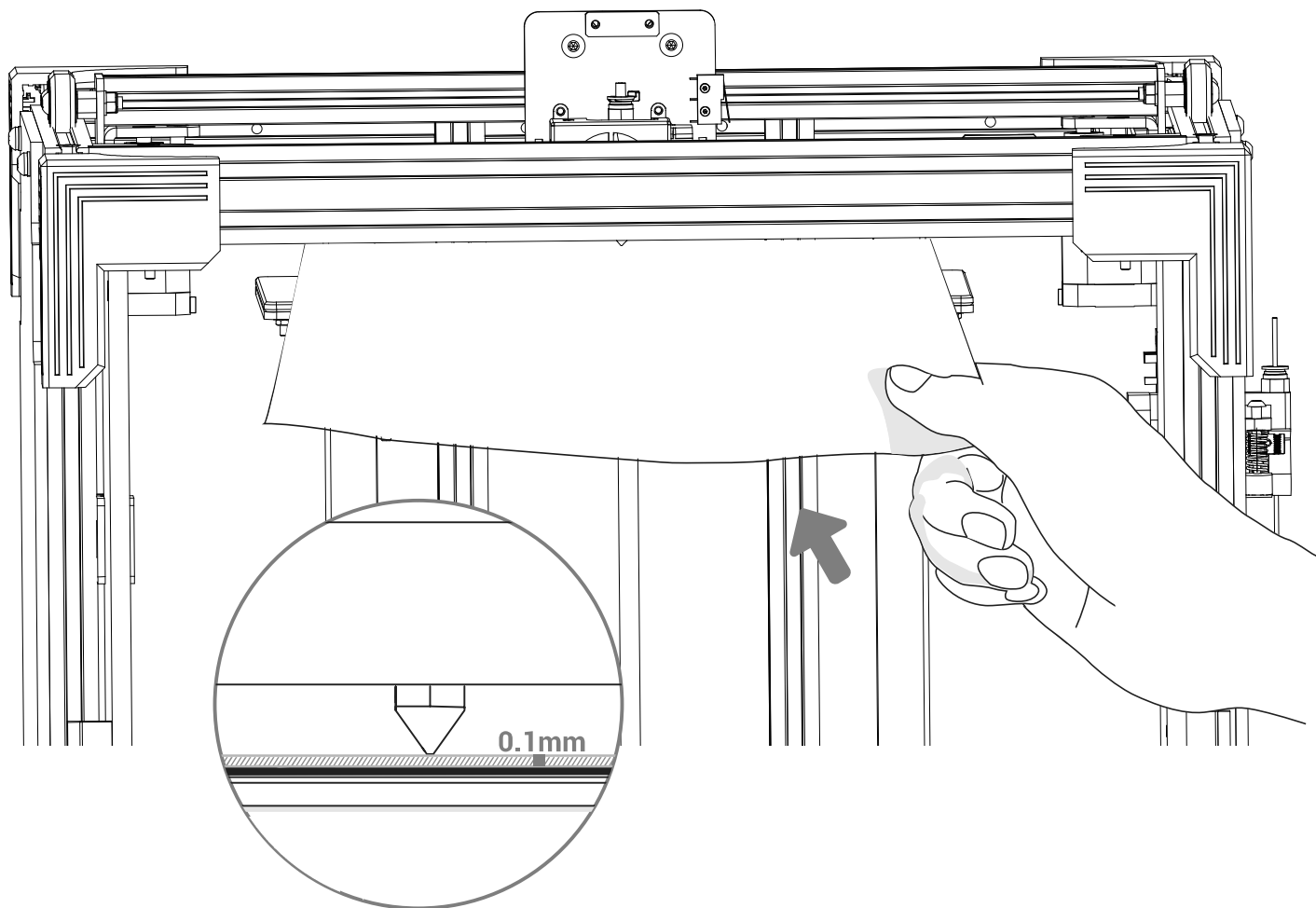
		!
		⊗ The nozzle is too far away from the platform, so the consumables can not adhere to the platform. 喷嘴离平台太远，耗材无法粘附在平台上。
		✓ Filament are extruded evenly, just sticking on the platform. 耗材挤出均匀，刚好贴在平台上。
		! The nozzle is too close to the platform, and the filament are not extruded enough, even scraping the platform. 喷嘴离平台太近，耗材挤出不足，甚至刮坏平台。



15

Use a piece of A4 paper (standard printer paper) to assist with the adjustment, making sure that the nozzle lightly scratches the paper. Complete the adjustment of the screw on all 4 corners. Repeat above steps 1-2 times if necessary. Keep adjusting until there is slight resistance on the A4 paper from the nozzle.

我们可以利用一张A4纸辅助调平，使喷嘴刚好能在A4纸上产生划痕。依次完成四个边上调平螺母的调节。不断调整直到在拉动A4纸时能感受到来自喷嘴的轻微阻力。

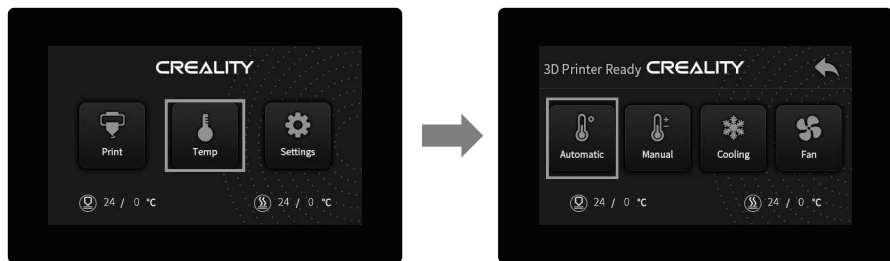


16

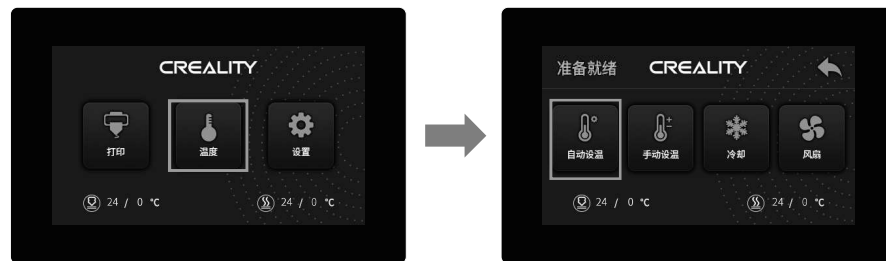
Preheating

预热

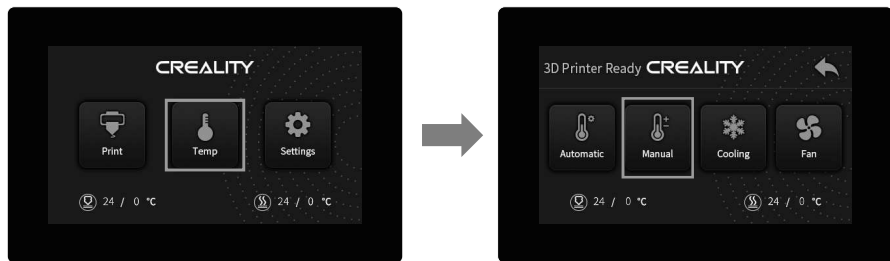
Method 1



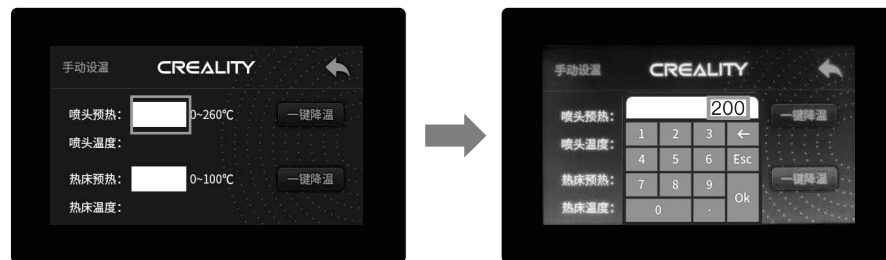
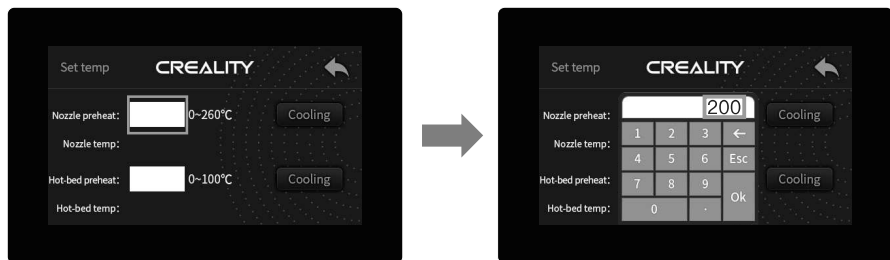
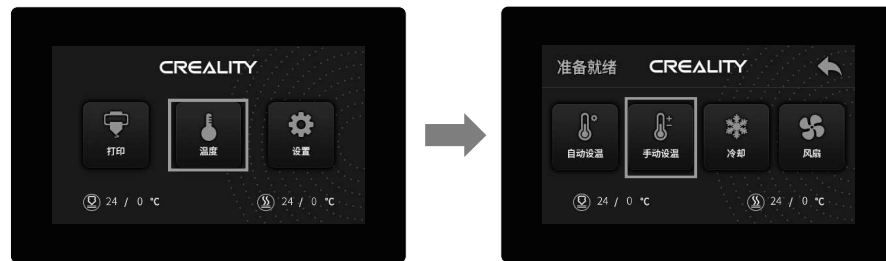
方法1



Method 2



方法2



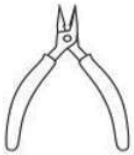
17

When you wait for the temperature to rise, hang the filament over the Filament Holder.

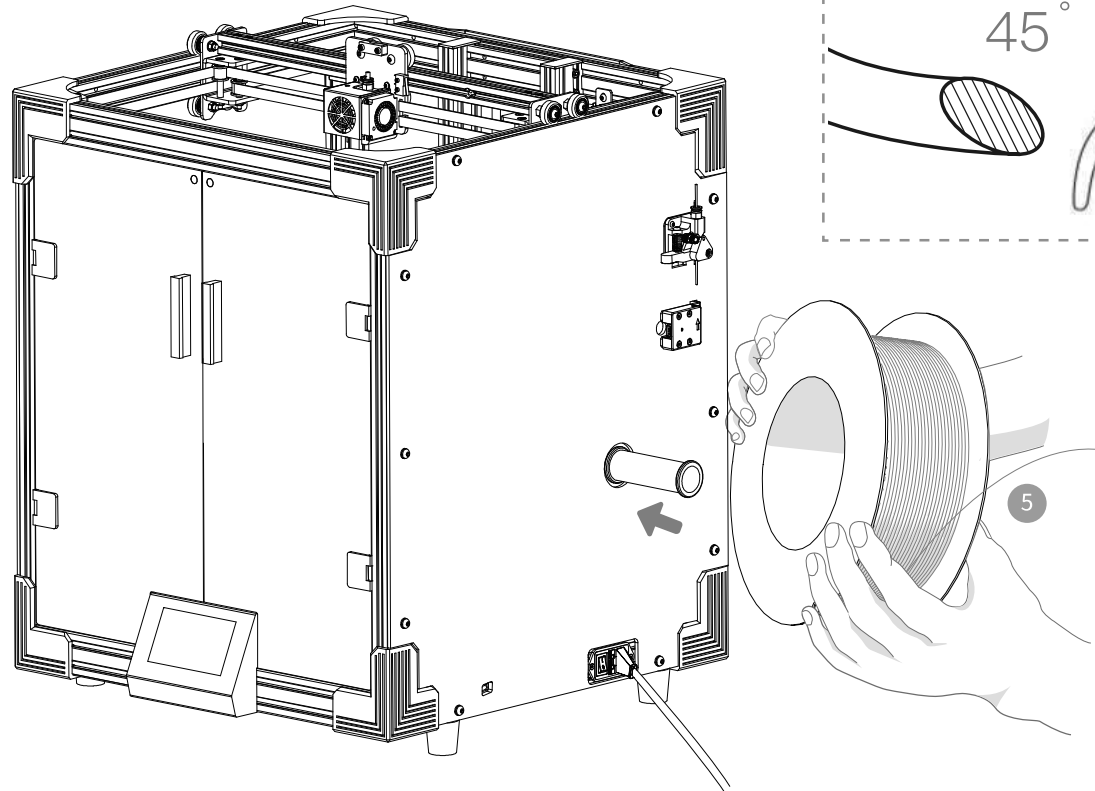
当您等待温度上升时,把耗材挂在料架上。



5 Filament x 1
耗材

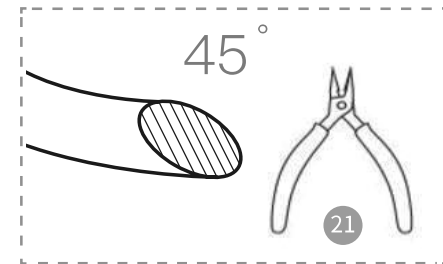


21 Diagonal Pliers x 1
剪钳



For smoother Load Filament , the end of the filament should be placed as shown below.

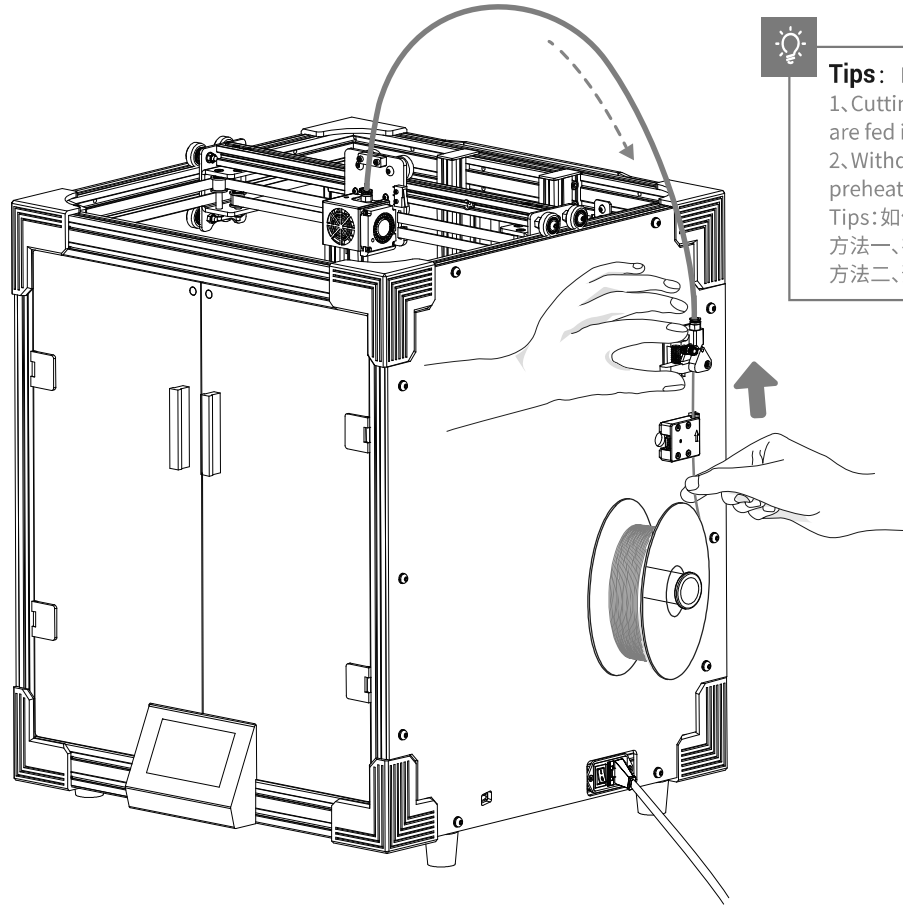
为了顺利完成装料,耗材的末端位置应如图所示。



18

Load Filament 装料

When the current temperature reaches the target temperature, connect the Teflon tube to the extruder, pass the consumables through the material detection test, insert the extruder holes into the nozzle position, and wait for the consumables to flow out of the nozzles .
当前温度达到目标温度时,将铁氟龙管接入挤出机后,将耗材通过断料检测,插入挤出机小孔直至喷嘴位置,等看到喷嘴处有耗材流出即表示耗材已经装载完成。

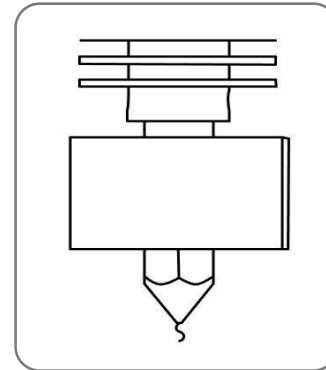


Tips: How to Replace the Filament?

1. Cutting filament near the Extruder and slowly feed new filament until they are fed into the new filament.
2. Withdrawing the filament quickly and feeding the new filament after nozzle preheated and filament pushed a little forward.

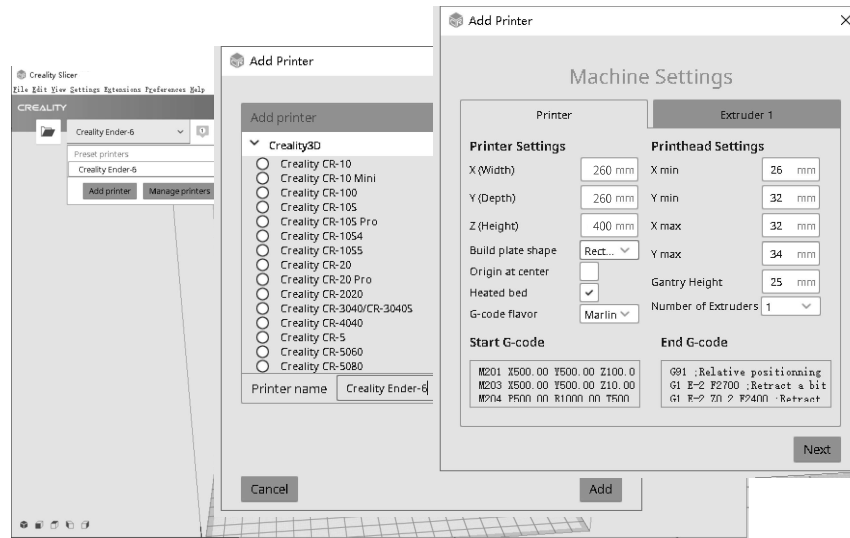
Tips: 如何更换耗材?

- 方法一、在靠近挤出机处将耗材剪断,将新耗材缓缓送入,直到耗材被送入导料管为止。
方法二、预热喷嘴后,将耗材往前推进一下后,迅速抽出耗材,将新耗材送入。

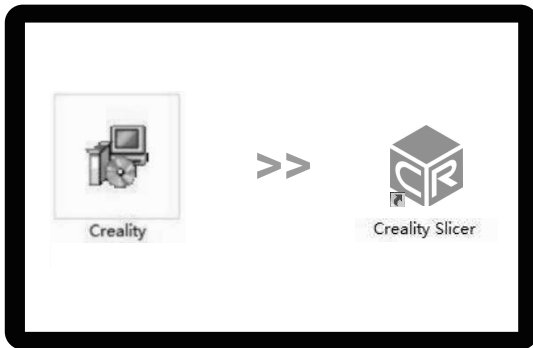


19

Start Printing 开始打印



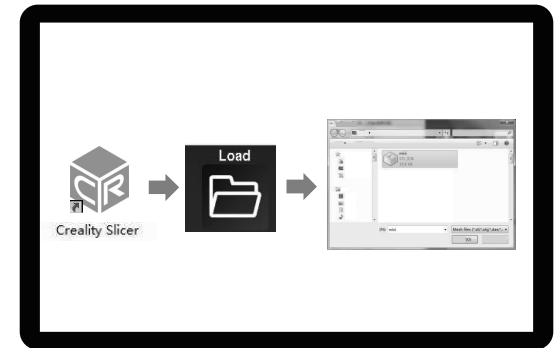
3. Select language→Next→Select your machine→Next→Finish.



1. Double click to install the software. | 安装软件
2. Double click to open the software. | 打开软件



3. 依次选择语言→Next→选择对应机型→Next→Finish, 完成设置.



4. Open Creativity 3D slicer → Load (Read file) → Select file.
打开创想三维切片软件→Load (读取文件)→选择文件。

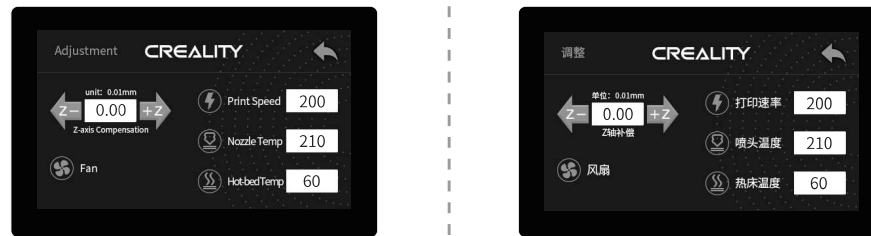
20

Start Printing

开始打印

This machine can print at a fast speed, but it is recommended to print at normal speed! Notes: the temperature of the nozzle is set according to the printing speed. Take PLA as an example:

本机器支持高速打印, 但建议以正常速度打印! 注意: 不同速率时, 喷嘴打印温度需相应调整设置, 创想配送PLA推荐设置参数:



print speed 打印速率	100%	200%	300%
Print temperature 打印温度	Around 200°C 200°C左右	Around 210°C 210°C左右	Around 220°C 220°C左右

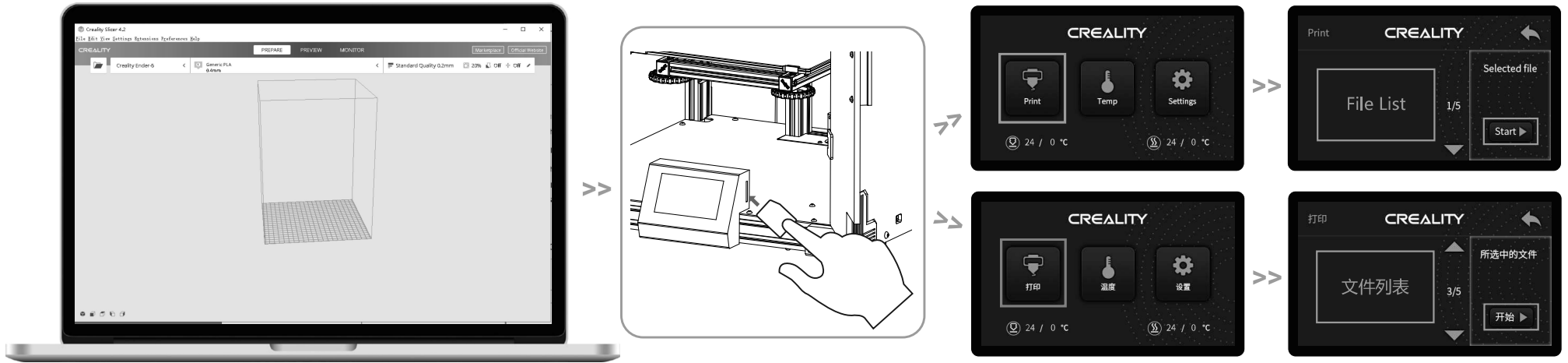
The printing temperature is different owing to the variety of PLA filaments. Please refer to the actual situation.

打印温度会存在些许差异, 请根据实际打印情况适当调整。

21

Start Printing

开始打印



5.Generate G-code, and save the gcode file to storage card.

生成 G 代码→保存到存储卡

6.Insert the storage card→ Print → Select the file to be printed.

插入存储卡→点击打印控件→选择要打印的文件



File names must be Latin letters or numbers, not Chinese characters or other special symbols

文件名需为拉丁字母或数字，不能为汉字或其他特殊符号

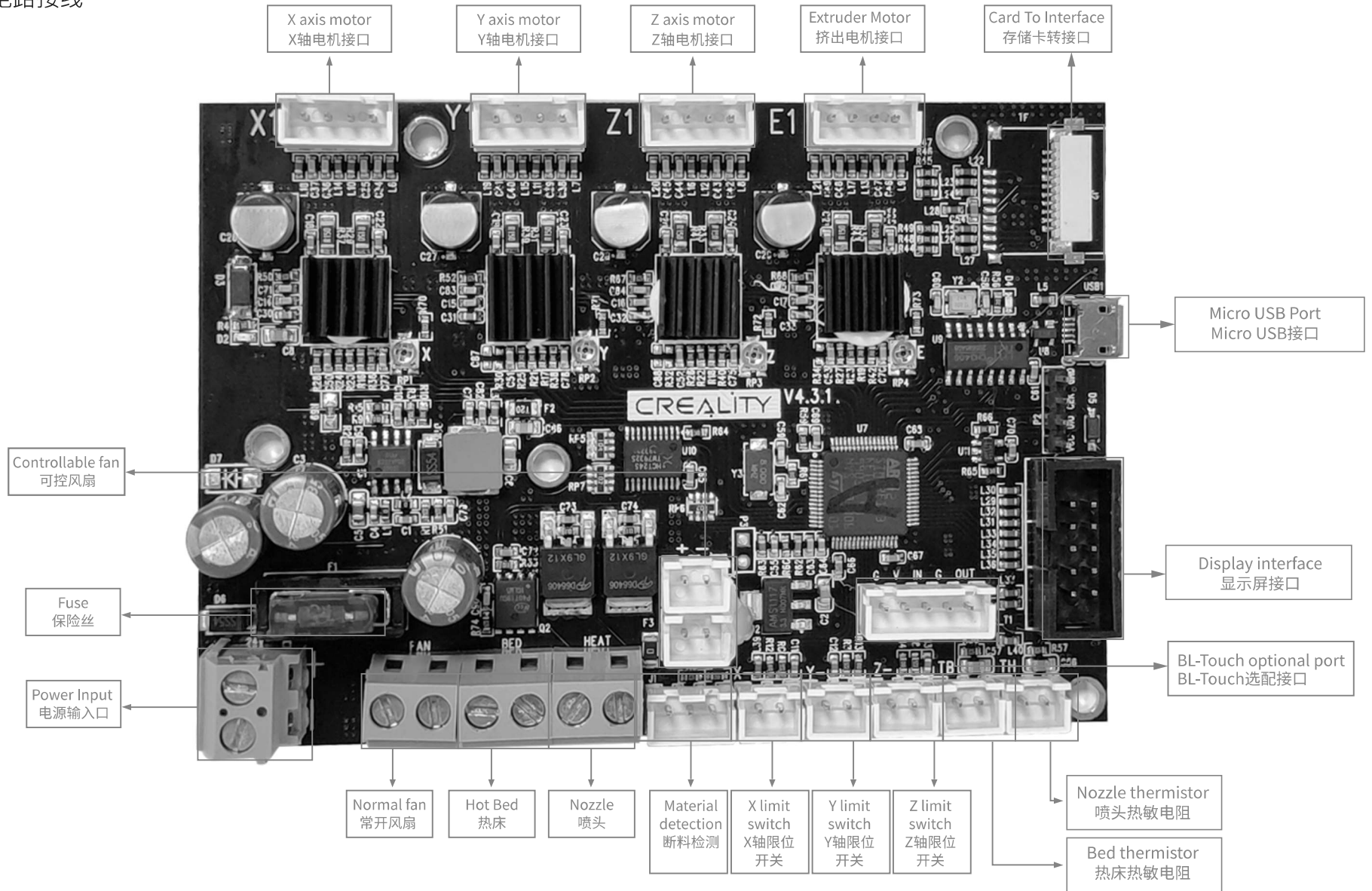


Notes: For details on the software instructions, please refer to the slicing software manual in the memory card!

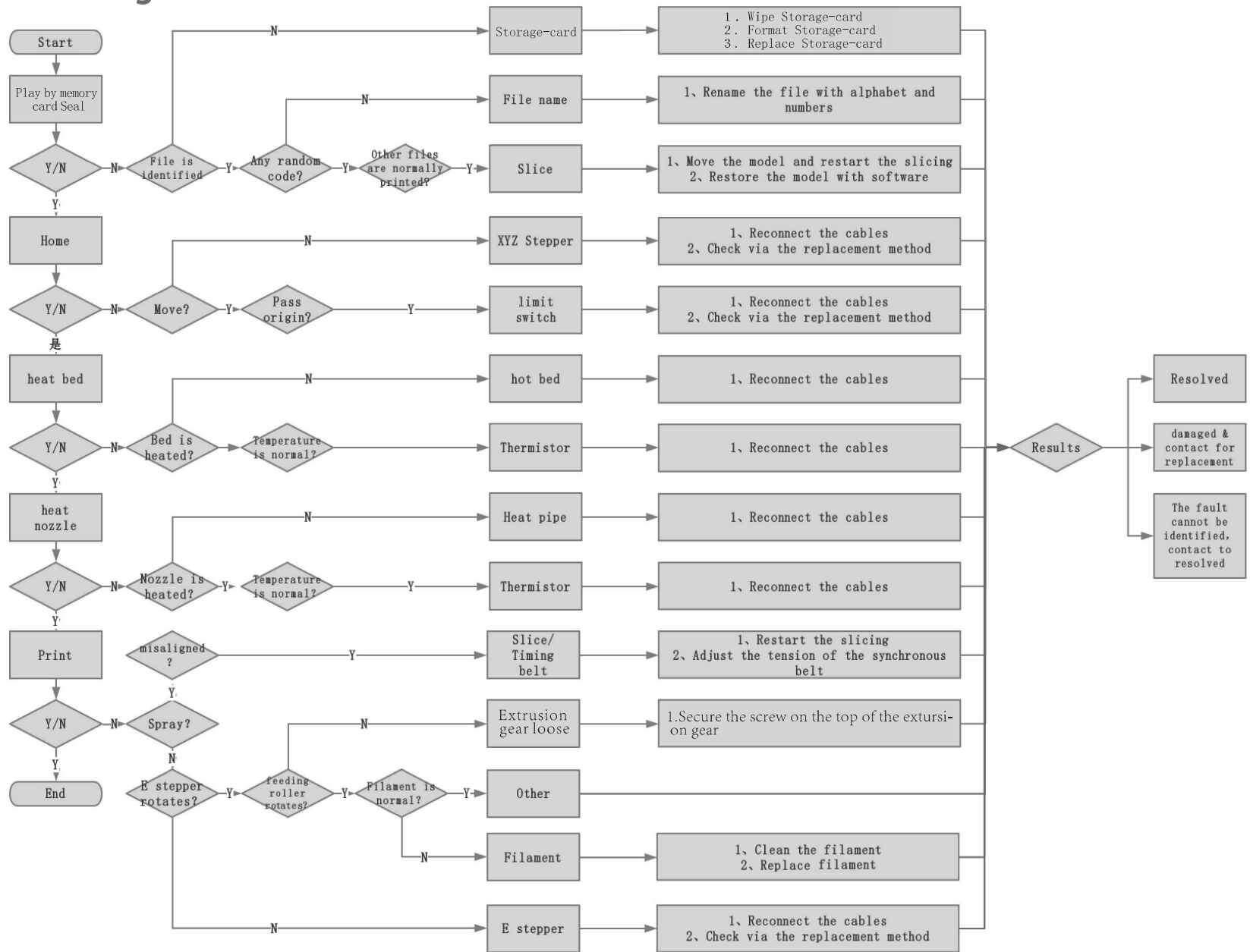
温馨提示：软件使用说明详情，请见存储卡内切片软件使用手册！

Circuit Wiring

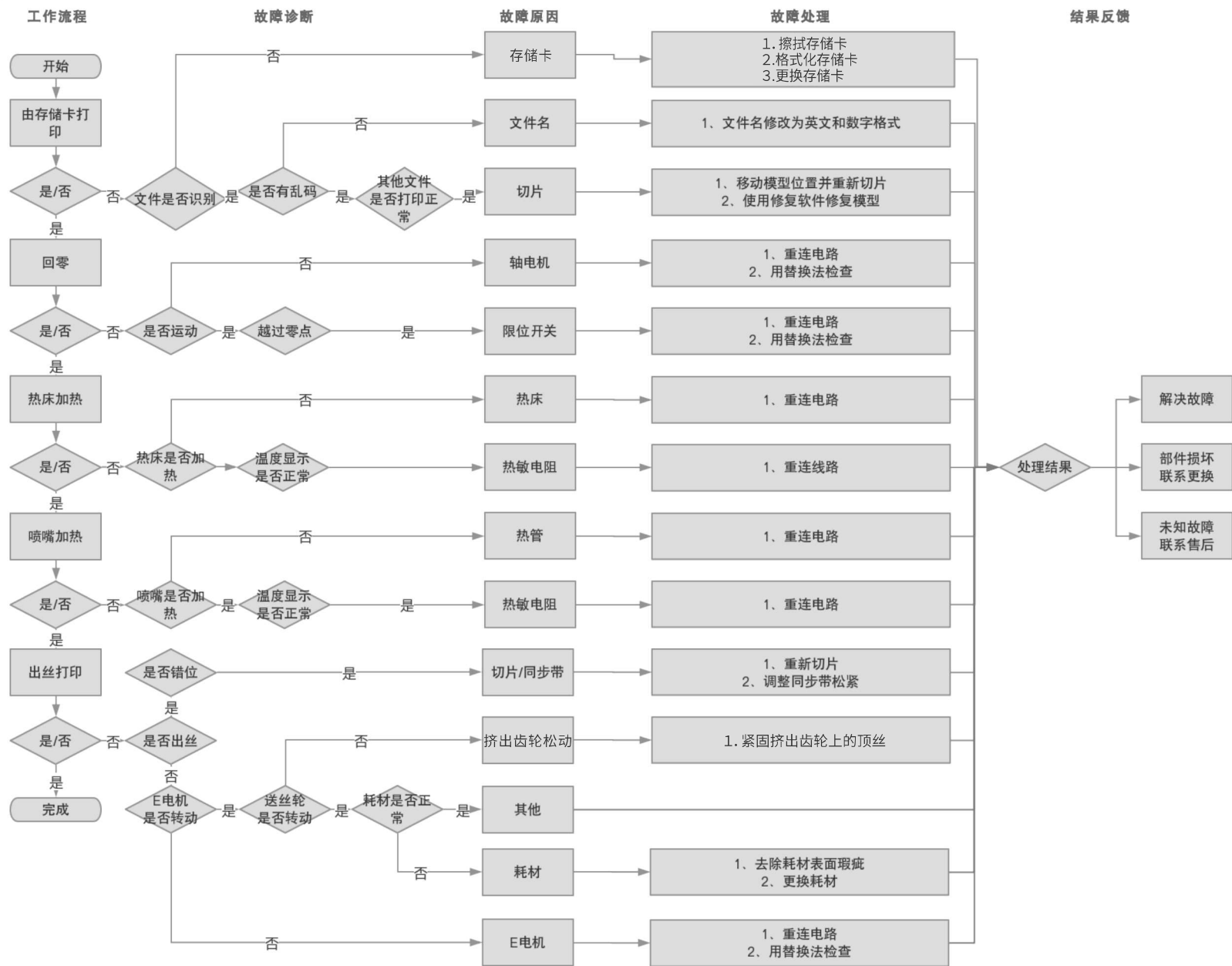
电路接线



Trouble-shooting



故障检修



Due to the differences between different machine models, the physical objects and the final images can differ. The final explanation rights shall be reserved by Shenzhen Creality 3D Technology Co., Ltd.

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