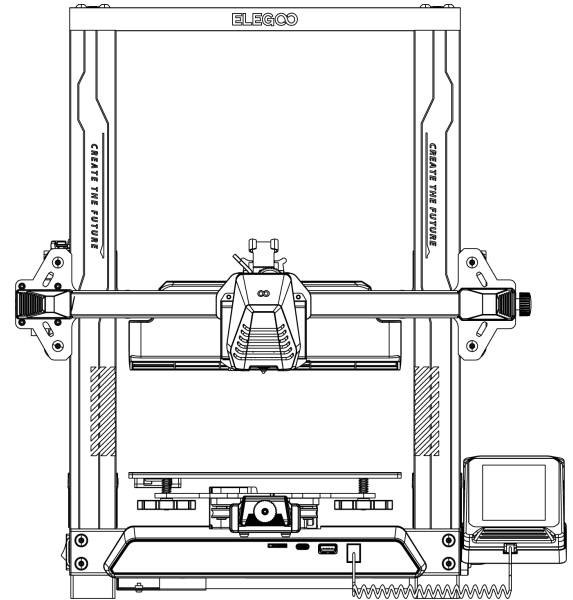
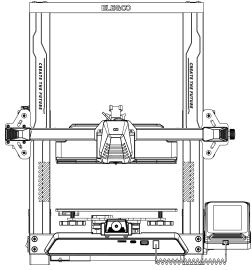


User Manual for NEPTUNE 4 PRO 3D Printer



Pictures are only for illustration purpose, please take actual product as standard.



Thank you for choosing ELEGOO product!

For your convenience, please read this instruction manual carefully before use, the cautions and tips in this manual can help you better avoid incorrect installation and use.

For questions or problems not covered in this manual, please contact us at this email address:
3dp@elegoo.com.

ELEGOO team is always ready to provide you with quality service.

To give you a better experience of our products, you can also gain knowledge of the operation of the equipment in the following ways:

- 1.The instruction manual:You can find related instructions and videos in the U disk.
- 2.ELEGOO official website: www.elegoo.com You can go to our official website to find the relevant operating instructions for the machine and contact information.

Cautions

1. Do not place the printer in vibrating or other unstable environments, as the shaking of the machine will affect the print quality.
2. Do not touch the nozzle and heatbed when the printer is working to prevent high-temperature scald and personal injury.
3. After printing, please take advantage of the residual temperature of the nozzle and clean the filaments on the nozzle with the help of tools. Do not touch the nozzle directly with your hands during cleaning to avoid scald.
4. Please do product maintenance frequently, and regularly clean the printer body with a dry cloth to wipe away dust and sticky print material under the situation of power off.
5. 3D printers contain high-speed moving parts, so be careful not to get your hands caught.
6. Children must be supervised by adults when using the machine to avoid personal injury.
7. In case of emergency, please cut off the power directly.

Contents

Machine Parameters -----	1
Machine Structure Diagram -----	2
Packing List -----	3
Machine Installation -----	4
Operation Screen Introduction -----	8
Auto Leveling -----	10
Model Test -----	11
Resume Printing Description -----	12
Software Installation -----	13
LAN Printing -----	15
Troubleshooting Guide -----	17
Circuit wiring -----	18

Machine Parameters

Print Parameters

Print Principle: FDM (Fused Deposition Modeling)

Build Size: 225X225X265(mm³)

Print Precision: ±0.1mm

Nozzle Diameter: 0.4mm

Print Speed: 30~500mm/s

Temperature Parameters

Ambient Environment Temperature: 5°C~40°C

Maximum Temperature of Nozzle: 300°C

Maximum Temperature of Hotbed: 110°C

Software Parameters

Slicer Software: Cura

Input Format: STL、OBJ

Output Format: Gcode

Connection Type: U Disk, LAN

Power Supply Parameters

Power Input: 100-120V/220-240V

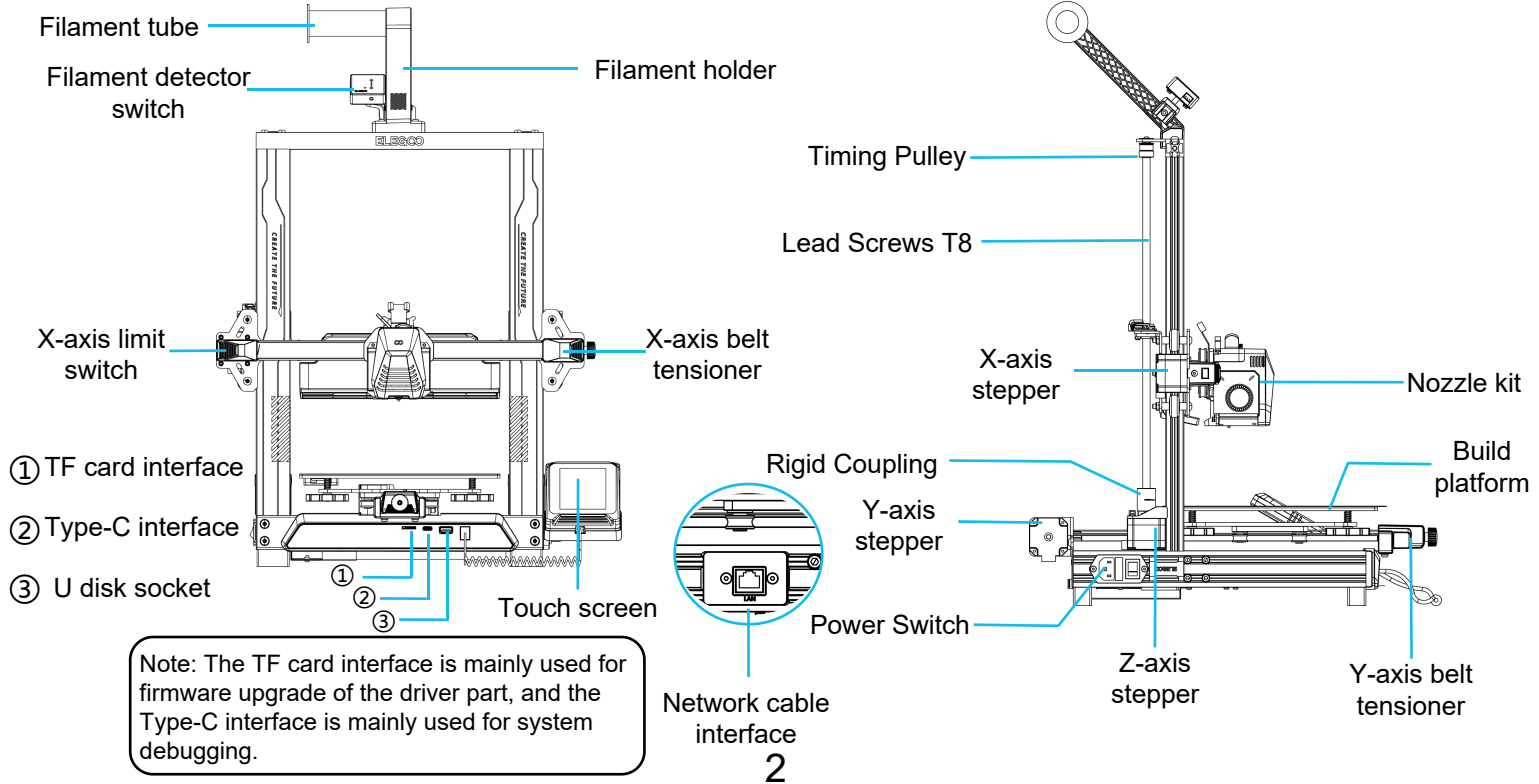
Power Output: 24V

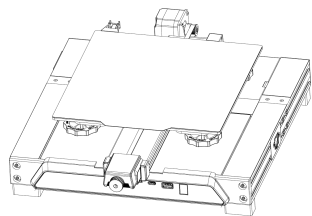
Physical Parameters

Machine Size: 475*445*515mm

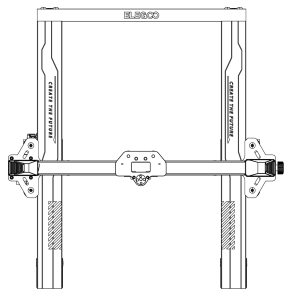
Net Weight: 8.9kg

Machine Structure Diagram





01



02



03



04



05



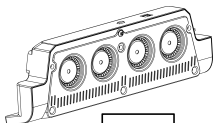
06



07



08



09



10



11

Fasteners



(HM5*45) 4pcs



(PM4*45) 3pcs



(PM4*20) 3pcs



(PM4*18) 2pcs



(PM3*16) 2pcs



(PM3*8) 4pcs



(PM4*8) 1pcs

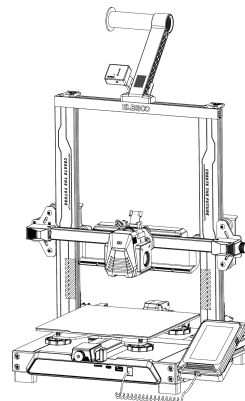


(HM4*M3*3) 1pcs

Tools



(1.5 / 2.0 / 2.5 / 3.0 / 4.0)

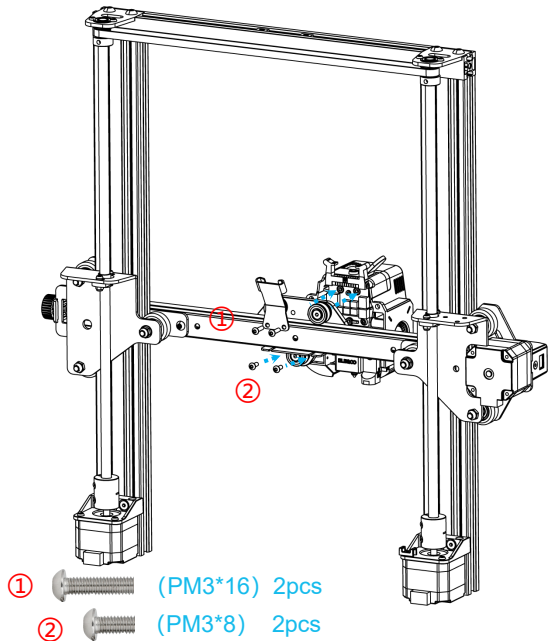


ELEGOO 3D Printer

Machine Installation

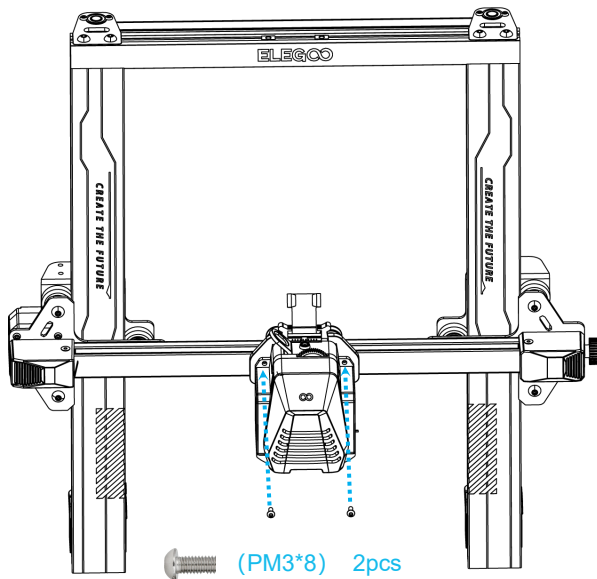
Attached U disk with an installation instruction video.

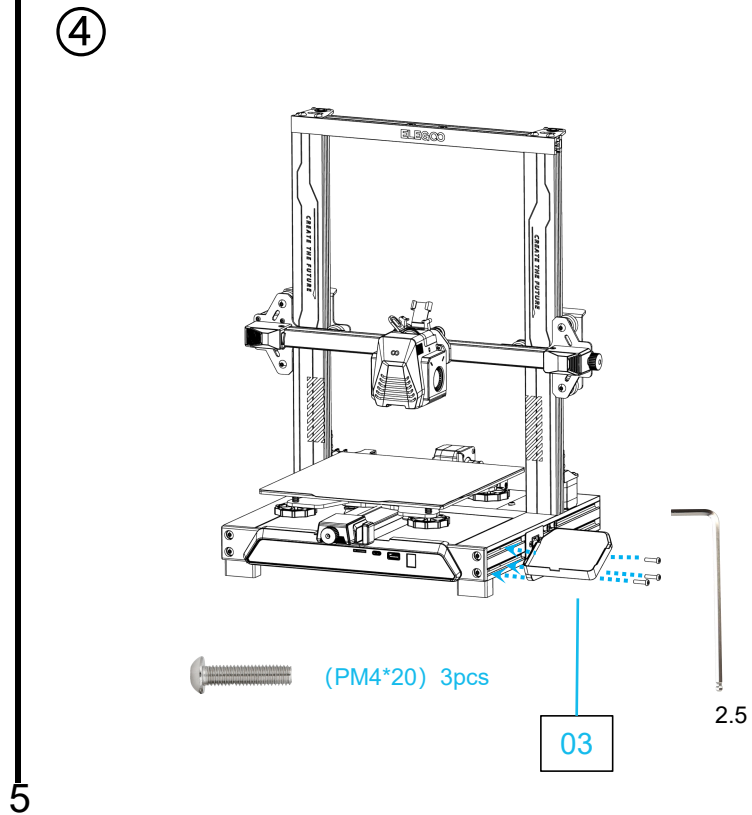
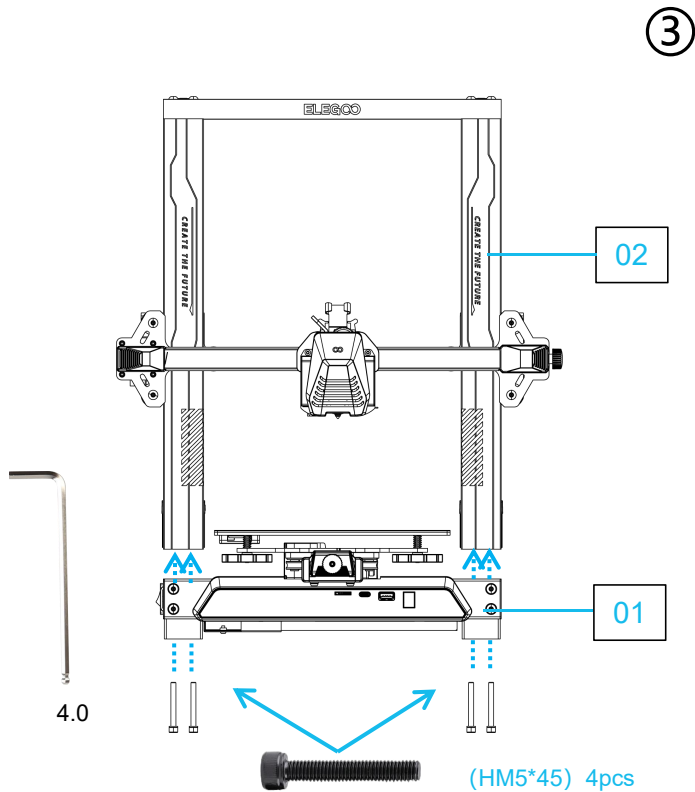
Print head installation: Use two M3x16 screws to fix the print head through the holes of the cable fastener; two M3x8 screws to fix the underside of the print head.



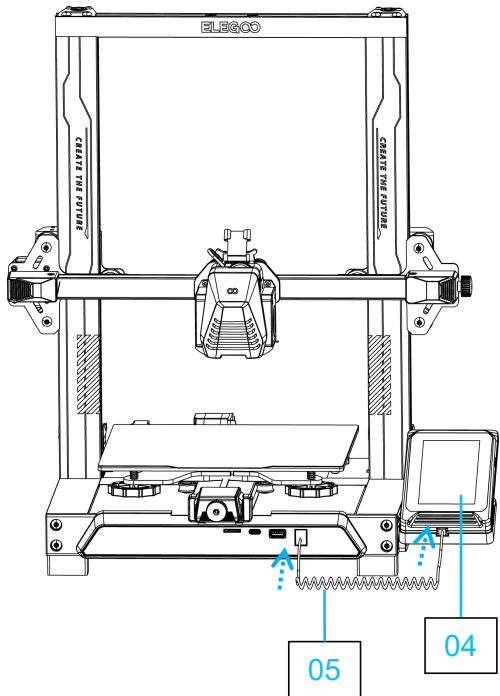
①

②

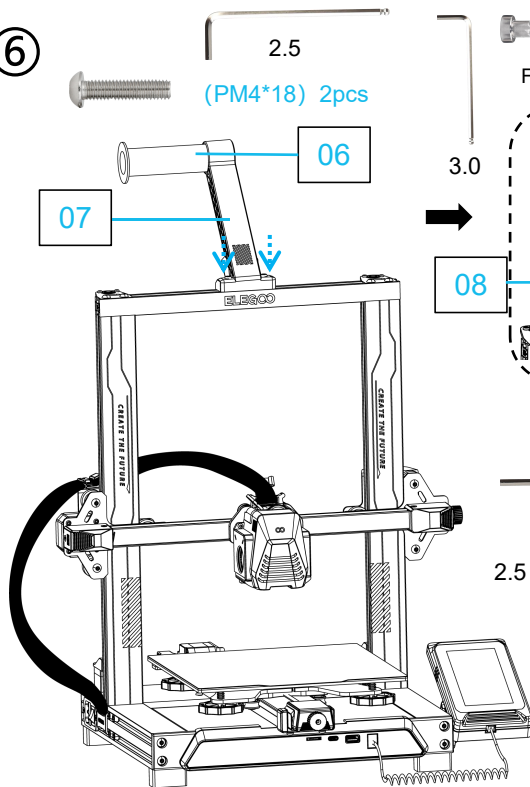




5

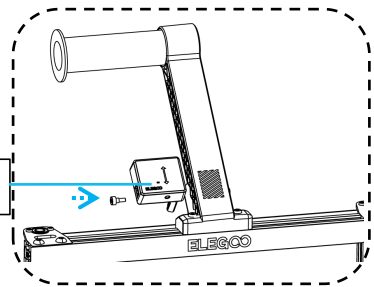


6

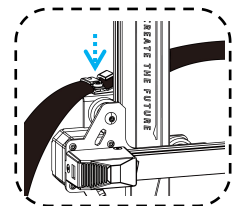


- (PM4*18) 2pcs
- (HM4*M3*3) 1pcs

Filament detector installation:



Cable clamp installation:



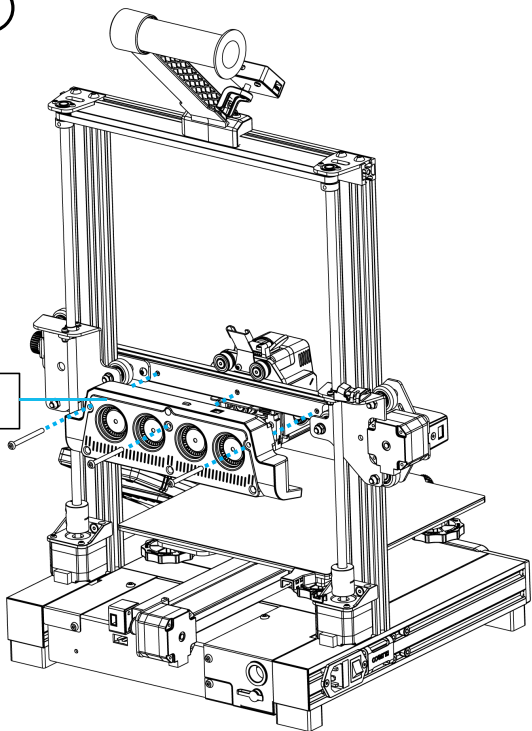
- (PM4*8) 1pcs

When installing, you need to organize the cables and fold them together to install and fix them.

6

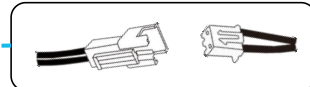
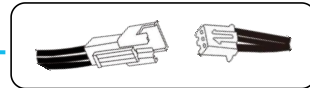
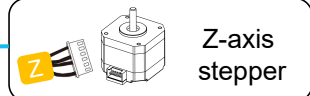
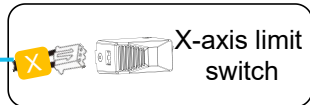
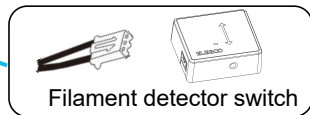
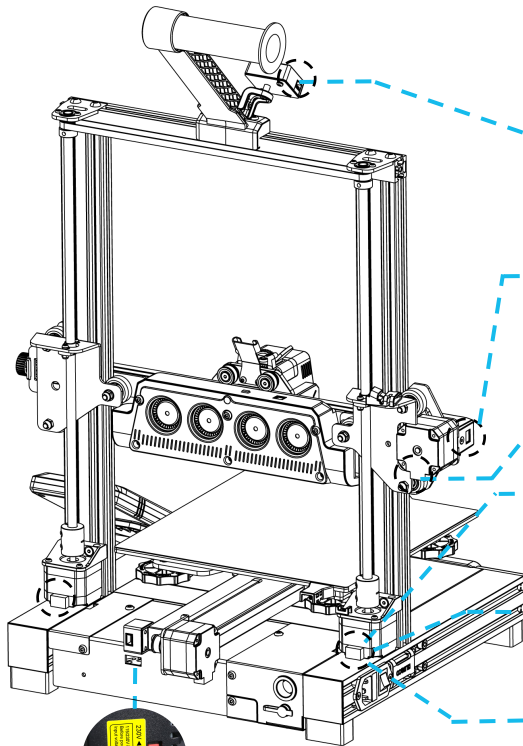
7

09



(PM4*45) 3pcs

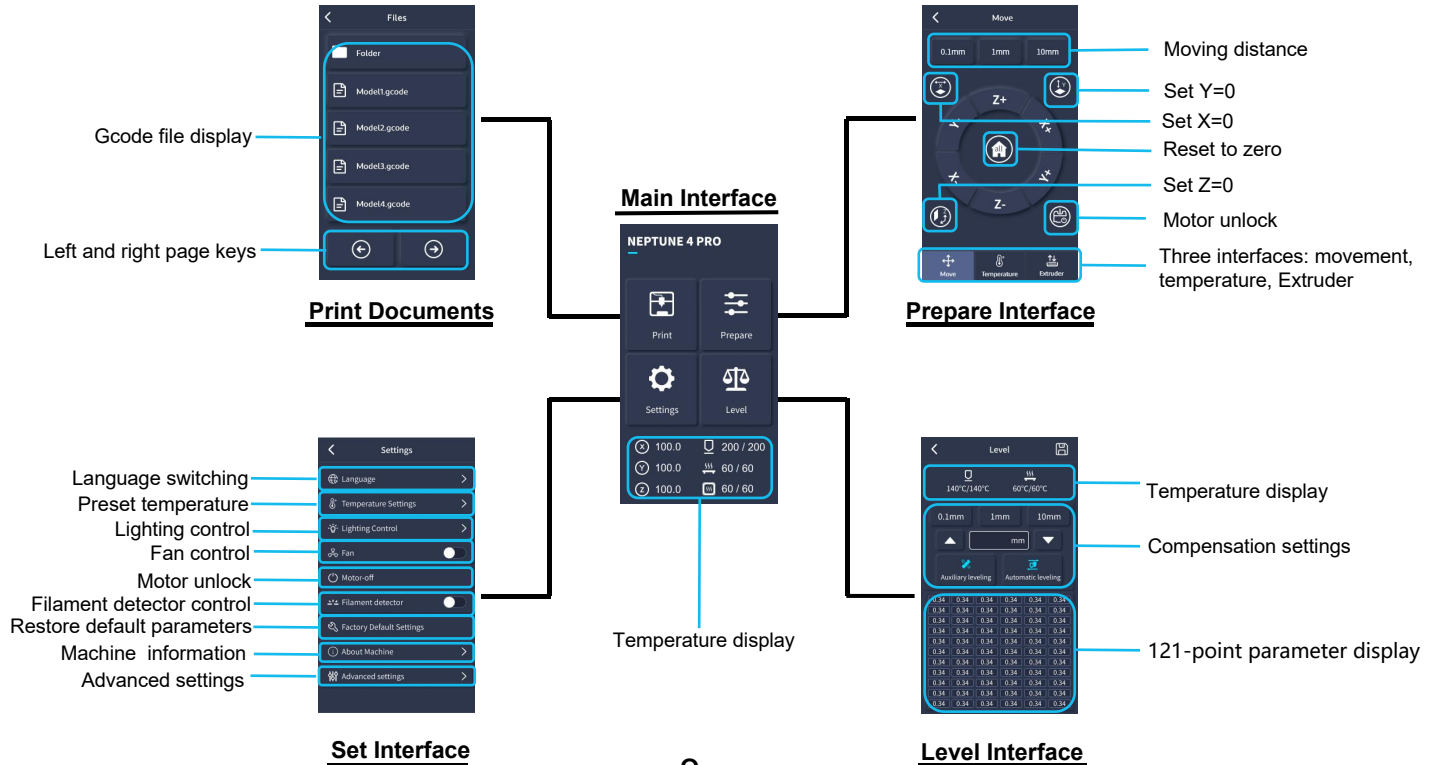
8



7

Please adjust the voltage to match the local voltage before use.

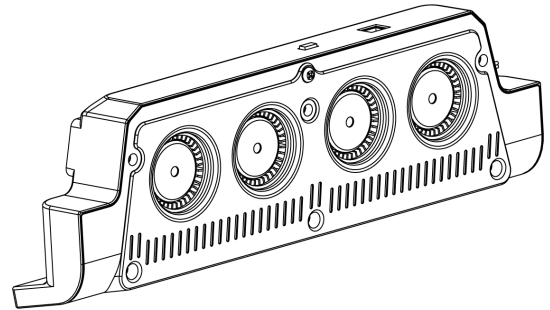
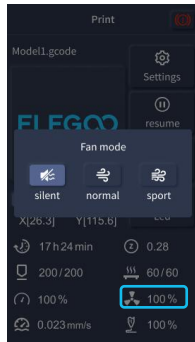
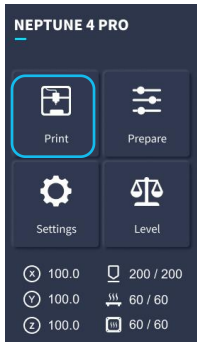
Operation Screen Introduction



Instructions for use of the rear cooling fan:

Users can click the fan icon to adjust the air outlet status of the rear cooling fan during the printing process.

The fan has three modes: silent / normal / sport, please adjust according to the printing situation, as shown in the picture below.



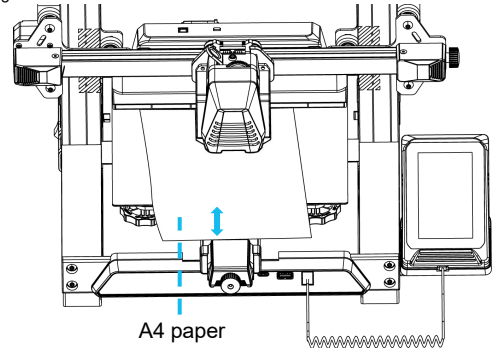
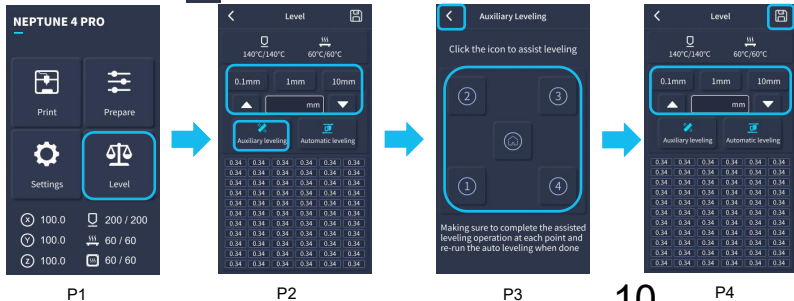
Rear cooling fans can be turned off during silent printing.

Auto Leveling

When first running the machine, the distance between the platform and the nozzle needs to be calibrated in the leveling mode, which is about the thickness of a piece of A4 paper .

- When the printer is powered on, select **【Level】** .
- Each axis of the printer automatically returns to the home position, after entering the leveling page, place a piece of A4 paper between the nozzle and the platform, and click the compensation value to adjust the distance between the nozzle and the platform (See Picture 2), and push and pull the A4 paper, when there is friction generated, the center point calibration can be completed. Click on the auxiliary leveling **【🔧】** , calibrate the 4 points of the platform with the A4 paper by hand-twisting nuts, and push and pull the A4 paper, when the paper can be pulled out but not pushed in, the auxiliary leveling can be completed.
- After completing the auxiliary leveling, enter the automatic leveling **【🔄】** for automatic calibration.
- The machine will enter the heating state:the nozzle is heated to 140°C, the hot bed is 60°C.(Please preset the hot bed temperature according to the temperature of the consumables to achieve a more accurate leveling value.)
- After reaching the preset temperature: start the 121-point automatic calibration.
- After the leveling is completed, set the Z-axis compensation: place a piece of A4 paper between the nozzle and the printing platform. Click the compensation value and push and pull the A4 paper to complete the compensation and leveling when friction is generated.
- Click the save icon to save. **【💾】**

Note that the leveling sensor only detects the metal platform plate, for example, replacing the glass platform for leveling will not produce detection effect, which will cause the nozzle to squeeze the platform.



Model Test

Print Head Feeding Check

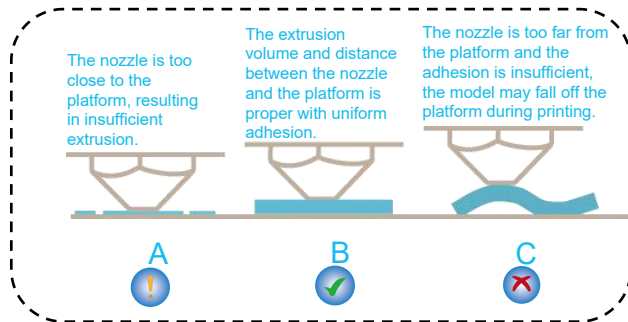
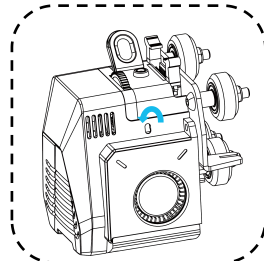
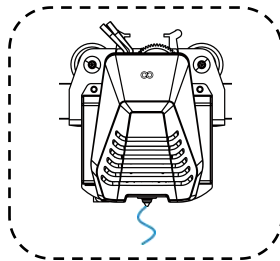
- 1) First push the filaments to the bottom of the print head.
- 2) Click **【Prepare】** - **【Extruder】** , click **【Load】** , the temperature of the nozzle will be automatically heated to 200°C.
- 3) After the nozzle is preheated to 200°C, click the feed to extrude the filaments from the nozzle.
- 4) Clean the melted filament of the nozzle before printing.

Notice: Consumables with different hardness have different requirements for the spring strength. The spring strength of the extruder can be adjusted with an Allen wrench. When turning counterclockwise, the spring strength is increased, and the spring strength is decreased clockwise.

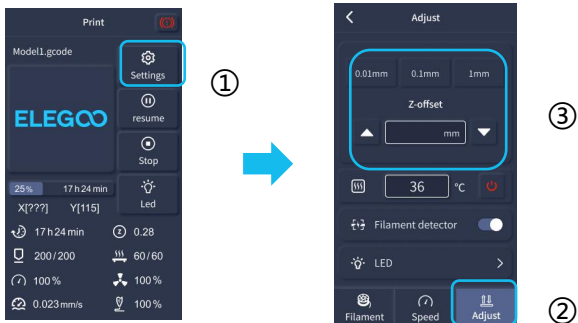
Start printing

- 1) Insert the U disk into the printer's USB port.
- 2) Click **【Print】** on the main menu and select the model file.
- 3) When the nozzle and the heatbed reach the preset temperature, the X, Y, Z axis will return to zero, and then start printing.

Notice: When printing the test model, please observe the first layer printing. In cases A and C, the compensation settings are not properly adjusted. Compensation adjustments can be made during printing to adjust the distance between the nozzle and the platform. In case B, the nozzle and the platform have reached a proper printing distance and can continue printing.



As shown in the picture:



When fine-tuning, please switch the moving distance to 0.01mm or 0.1mm to prevent the nozzle from extruding the platform excessively or filament hanging in the air.

Resume Printing Description

Power Loss Recovery: If you want to continue printing because of a sudden power outage or accidentally turn off the power of the machine, this function does not need to be set manually. When the printer is reconnected to the power supply and turned on, just click resume to continue. (Please note that the PEI platform has a better adhesion effect when it is heated, but it will cool down if the power is turned off for too long, causing the model fall off easily, and the resume printing cannot be completed.)

Filaments Detection: This function is to remind the user to replace the filaments before continuing printing when the model is half-printed, which effectively prevents the model from being scrapped due to insufficient consumables.

Software Installation

Tip: Copy the data in the U disk to the computer for saving.

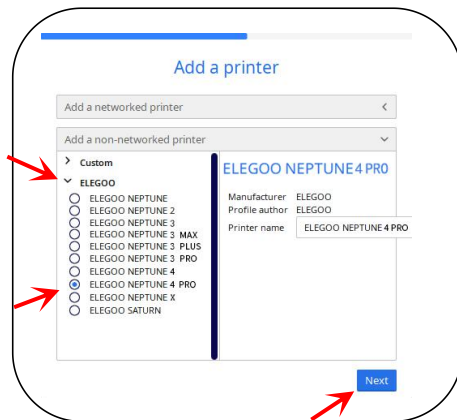
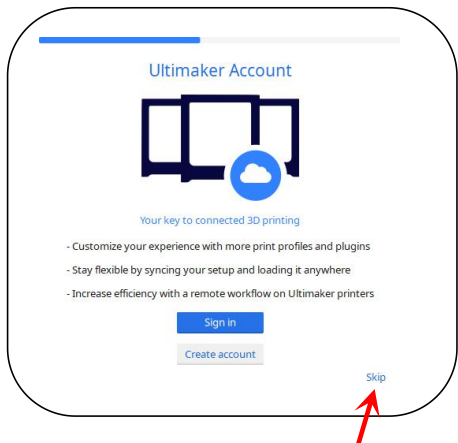
Our slice software is modified form Cura open source slice software, in order to better match with our company's machines for printing and meet the needs of our customers.

The software installation steps are as follows:

Open the attached U disk file and select the path \ Software and Software Drivers folder \ ELEGOO Software folder \ Double-click the ELEGOO-Cura application to install it.

Follow the prompts in the installation process to the next step.

Finally, select the corresponding model of our company as shown below to complete the settings.



Instructions for Use

Import model

- Move
- Zoom
- Rotate
- Mirror image
- Model setting
- Support structure interception

Print settings

- Profiles: 0.06, 0.15, 0.2, 0.2, 0.3, 0.4, 0.6
- Default
- Infill (%): 0, 20, 40, 60, 80, 100
- Gradual infill
- Support
- Adhesion

Object list

- EN1 30x30x30
- 30.0 x 30.0 x 30.0 mm

1 hour 7 minutes

10g · 3.48m

Save as TFT file

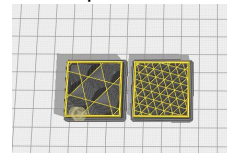
Save to File

Preview image function

Other operation tips:

- ① Scroll the middle mouse wheel to zoom the viewpoint, and hold down the middle wheel to move the platform position.
- ② Press and hold the right mouse button to move the mouse to change the viewpoint.
- ③ Click the right mouse button will bring up a pop-up selection.

Model setting: When printing multiple models, you can configure individual slice settings for the specified model.



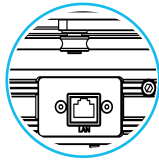
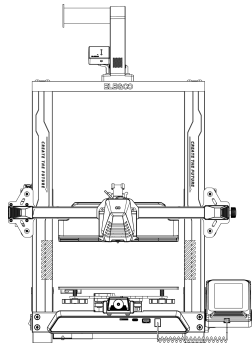
Support structure interception: You can set the intercept region on the model so that the set region does not generate support structure.

Preview image function: Gcode files saved in TFT file format can use to preview the model image in the selection file on the printer, which can identify the printed file more visually.

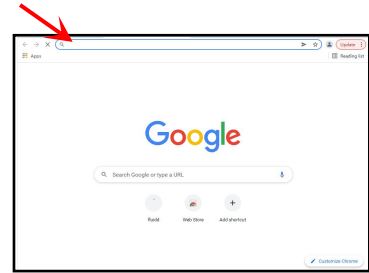
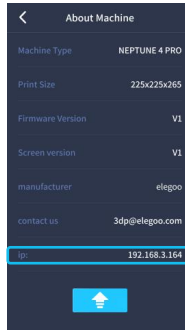
LAN Printing

After the device is plugged into the network cable, power on the device and check the IP address through the on-screen information. It is recommended to use Google Chrome to access.

- Note that the machine and the computer can only be connected to the LAN of the same network segment, and make sure that the circuit wiring port on the machine has already connected, otherwise the access will fail.



Network cable interface



- Use Google Chrome to enter the IP address of the device, e.g. 192.168.211.164, and enter it via the Enter key to access the page.

- After successful access, you will enter the control interface below the picture

The screenshot shows the PrusaSlicer control interface. Red boxes highlight the following sections:

- Movement control:** Located at the top left, it includes buttons for 'Home', 'Print', 'Pause', and 'Cancel', along with a 'Speed' slider and 'Pressure Advance' settings.
- Fans and output:** Located in the middle left, it includes a 'Print Fan' slider and a 'Fan 1' dropdown menu.
- Printer limit:** Located at the bottom left, it includes a 'Printer Limits' section with 'Minibody' and 'Acceleration' sliders.
- Temperature display:** Located at the top right, it features a graph showing 'Temperature °C' over time, with a red line for the nozzle and a blue line for the bed.
- Console:** Located in the middle right, it displays a list of G-code commands being executed.
- Task list:** Located at the bottom right, it shows a list of tasks to be printed.

Movement Control: control the movement of each axis, and can set compensation after leveling.

Fan and Output: control to turn on the printhead fan and lighting.

Printer Limit: the maximum acceleration control of the printer, normally no need to change the settings.

Temperature Display: display the machine temperature heating condition, and the preheating printhead temperature and hot bed temperature can be set in advance.

Console: G-code commands can be sent to run the machine.

Task List: drag the G-code file of the Elegoo Cura slice to the task list here for printing.

Troubleshooting Guide

A stepper of the X/Y/Z axis is not moving or making a noise when zeroed

- ① The stepper cable is loose. Please recheck the wiring connection.
- ② The corresponding limit switch does not trigger properly, please check whether there is any interference in the movement of the corresponding shaft and whether the limit switch wire is loose.

Nozzle kit extrude anomaly

- ① Check that the extruder stepper cable is not loose.
- ② Check whether the set screw of the extruder gear is locked to the motor shaft.
- ③ The heat dissipation of nozzle kit is not enough, make sure that the nozzle kit's cooling fan is working properly.
- ④ For clogged nozzles, try briefly heating the nozzle to 230°C and squeezing the filaments by hand to remove the clog, or use a fine needle to unclog the nozzle while it is warming up.

Model does not stick to the platform or warpage

- ① The key to whether the model can stick to the platform is the filaments are attached to the platform when printing the first layer. When printing the first layer, if the distance between the nozzle and the platform is more than 0.2mm, it will seriously reduce the model's attachment to the platform, so it needs to be adjusted.
- ② Set up the build platform attachment in Cura, and select the attachment type **【Brim】**, which will help to enlarge the attachment surface and prevent warping and other problems.

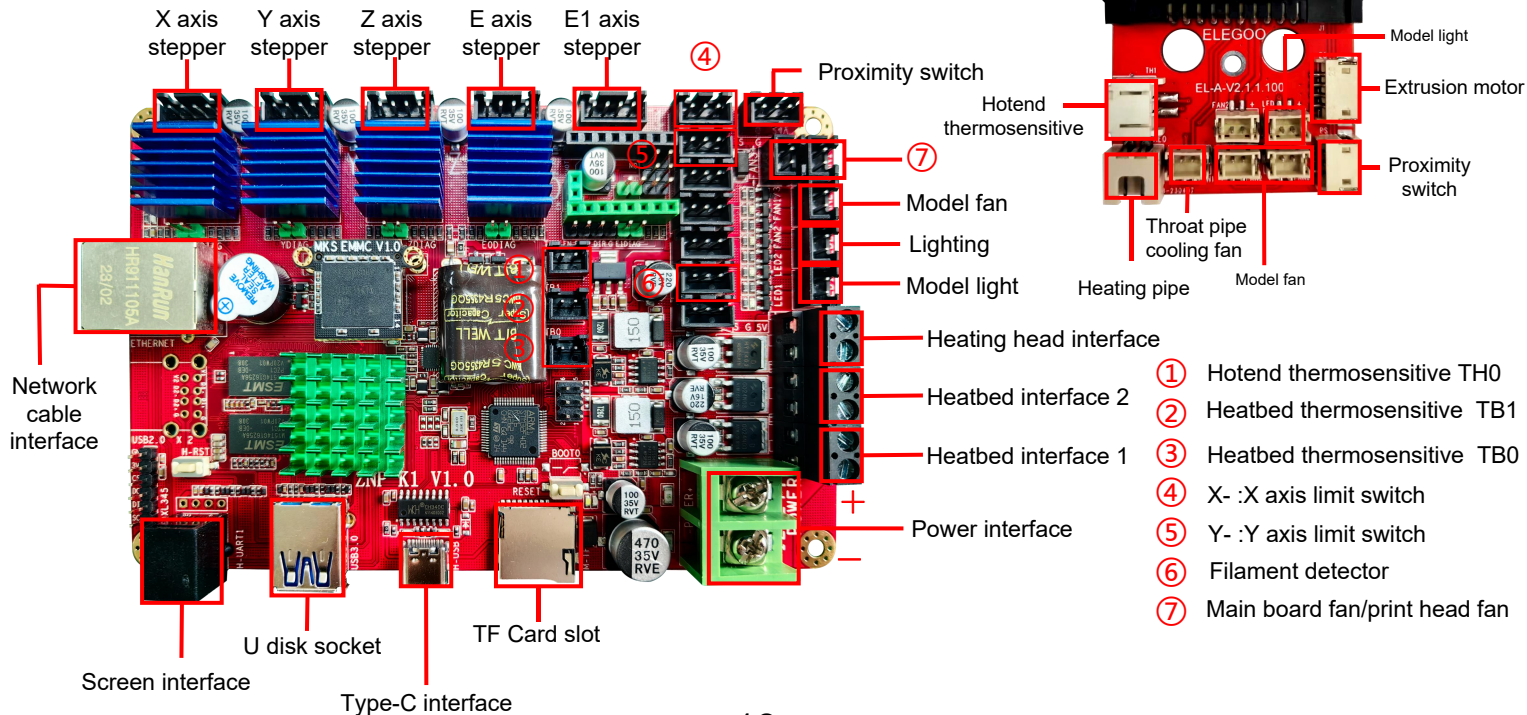
Model misalignment

- ① The travel speed or print speed is too fast. Please try to reduce the speed.
- ② The belt of X/Y axis is too loose or synchronizer pulley is not securely tight.
- ③ Drive current is too low.

Severe wire drawing

- ① Insufficient retraction distance, set the retraction distance larger when slicing
- ② If the retraction speed is too slow, set the retraction speed higher when slicing.
- ③ When slicing, tick the box "Z Hop When Retracted" and set the "Z Hop height" to about 0.25mm.
- ④ Print temperature is too high, which causes the filaments to become sticky.

Circuit wiring



After-sales service registration card
售后服务登记卡

Date of purchase

购买日期： _____

Place of purchase

购买地点： _____

Printer

机器： _____

S/N

序列号： _____

Fault description

故障描述： _____

Contact

联系人： _____

Phone number

电话号码： _____

Address

地址： _____



ELEGOO official website: www.elegoo.com

