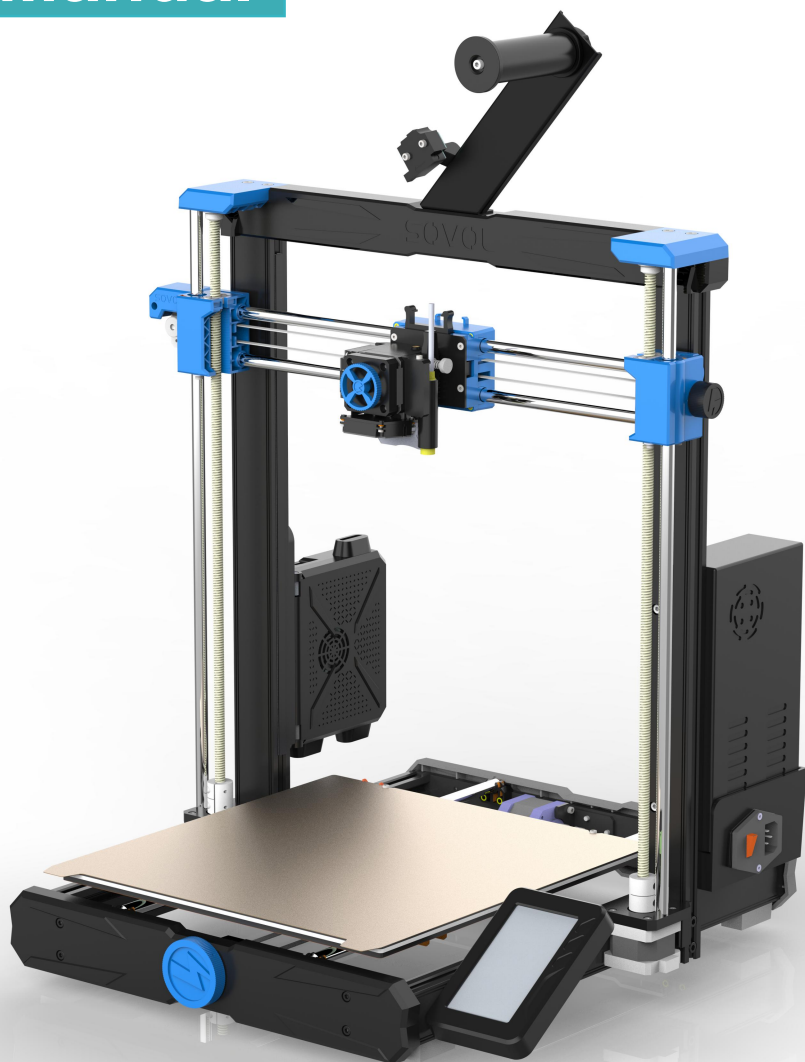


SOVOL

SV06-PLUS

User Manual

V1.0



Dear customers,

Thank you for choosing Sovol printers! Sovol is committed to providing excellent machines to 3D printing enthusiasts all over the world. This manual is designed for SV06 Plus owners to start their SV06 Plus printing journey. We still recommend all the SV06 Plus owners to read the manual carefully even if you are familiar with the 3D Printing technology, as there are lots of important information about the SV06 Plus for you to learn and help you get better printing experience. In this manual there are some tutorials can be found on official website and group you can scan the QR-codes.



sovol official user group



sovol official website

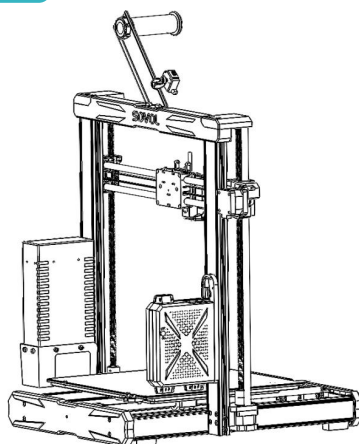
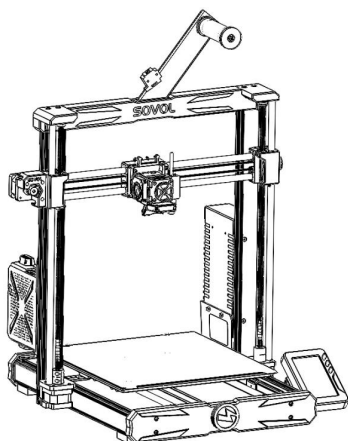
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Notice



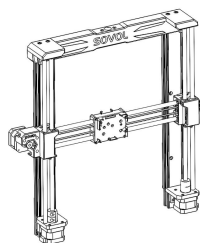
- Do not use the printer by any way except as otherwise described herein to avoid personal injury or property damage.
- Do not place the printer in an environment with heavy vibration or other unstable factors. Printer shaking will affect printing quality.
- Do not place the printer near inflammables and explosives or heat sources.
- Keep the printer in a well-ventilated, cool and dust-free place.
- It is suggested to use the materials recommended by manufacturer in order to avoid machine damage.
- Do not use any power cord other than the accompanied one. Use grounded three-phase power outlet.
- Do not wear cotton gloves while operating the printer. This type of fabric may be wound in the printer's motion parts, which can cause burns, personal injury, or printer damage.
- Wait for a moment after printing to remove the prints.
- It is not recommended to use third-party firmware or motherboard; otherwise, the warranty will be void.
- Clean the printer frequently. Prior to cleaning, turn off the power supply; use a dry cloth to wipe off dust, adhesive printed plastic or any other materials from the frame, rail or wheels. Use glass cleaner or isopropyl alcohol to clean printer surface.
- Children below 10 years old shouldn't use the printer alone.
- Do not move the nozzle and printing mechanism with your hands during printing.
- Users shall abide by relevant laws and regulations of the countries and regions where the printer is placed (used) and professional ethics, perform safety obligations, and do not use our product or device for any illegal purpose. In no case shall Sovol bear any legal responsibilities for anyone breaching laws.

Equipment Parameters

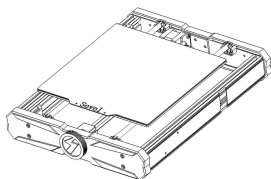


Model	SV06-Plus
Software language	English
Printing method	TF card and USB cord
Type	FDM
Number of nozzles	1
Printing size	300*300*340mm
Recommended printing speed	≤150mm/s
Printing accuracy	±0.1mm
Nozzle diameter	0.4mm (Replaceable)
Nozzle temperature	≤300°C
Hot bed temperature	≤100°C
Applicable filament	PLA/ ABS/ PETG/ TPU/ WOOD/ Carbon Fiber
Diameter of filament	1.75mm
File format supported	G-code
Voltage	Input: 115/230V 50/60HZ Output: 24V
Operating system	Windows, Linux, Mac
Power supply	500W/24V

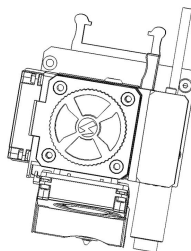
Package List



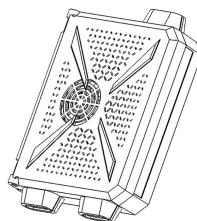
Gantry



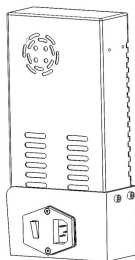
Base



Extruder kit



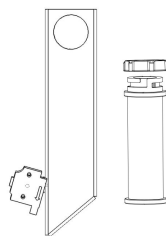
Control box



Power supply



Touch screen



Filament holder

Tool box



M3X5*3



M4X12*3



M5X10*2



M4X20*2



M5X50*4



Toolkit



Scraper knife



Spare nozzles



Power cord



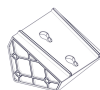
Ribbon



Nozzle cleaner



TF card/card reader

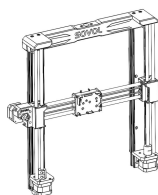


screen bracket

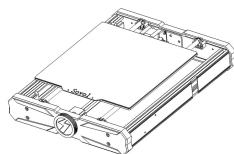


Cutting nippers

- 1 Install gantry on the base with 4 M5X50 screws, and tighten the screws.



Gantry

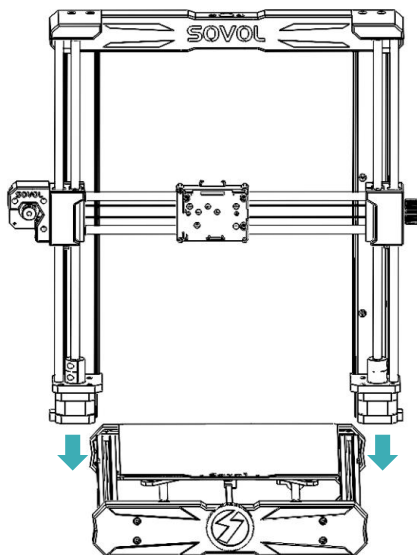


Base

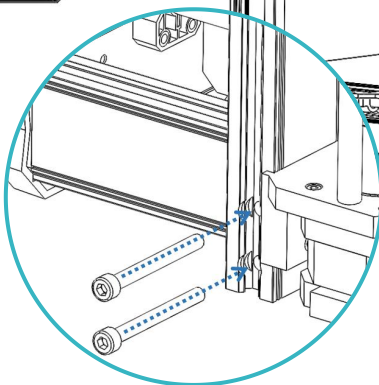
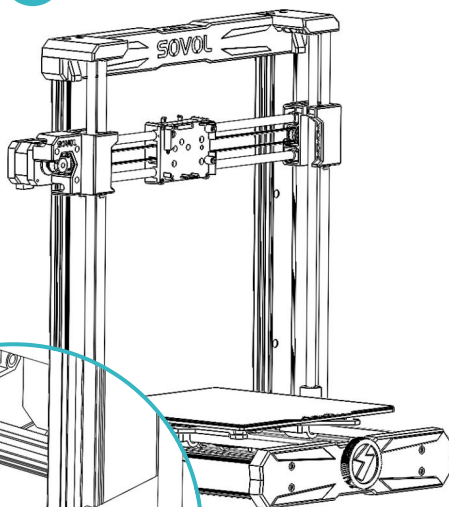


M5X50*4

1

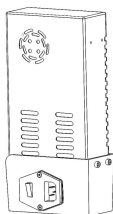


2

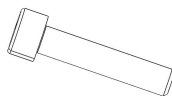




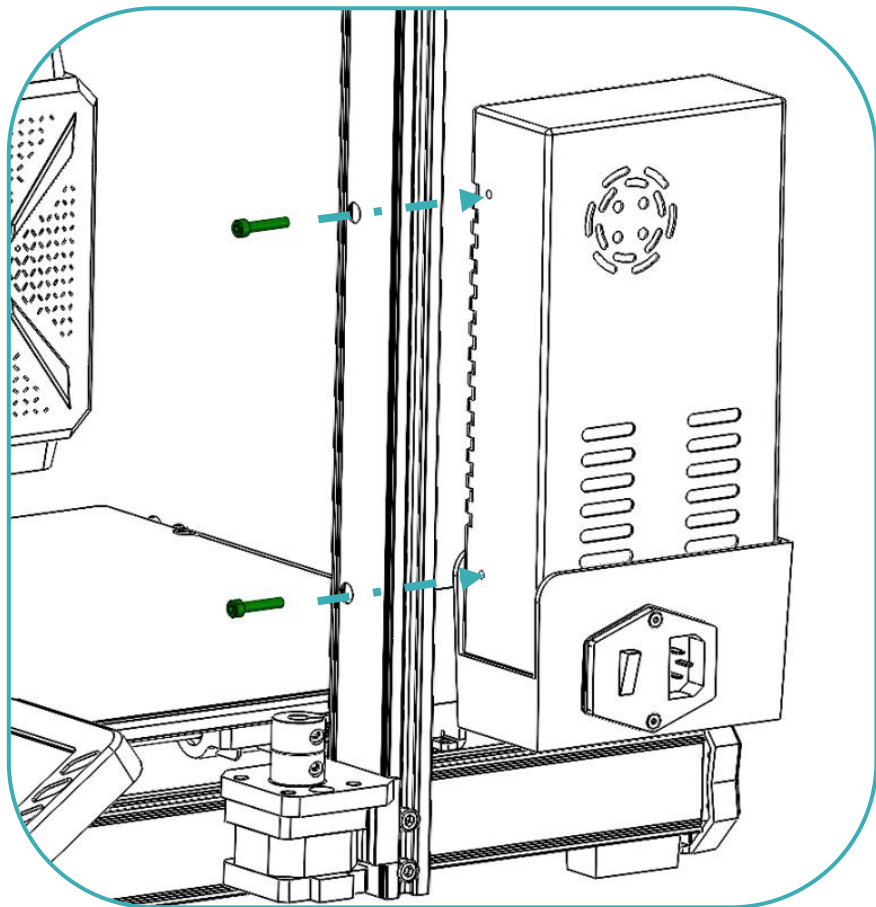
- 1 Install power supply to the right profile of the gantry with 2 M4X20 screws and tighten the screws.



Power supply

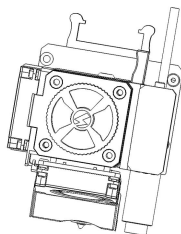


M4X20*2

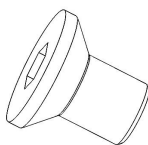




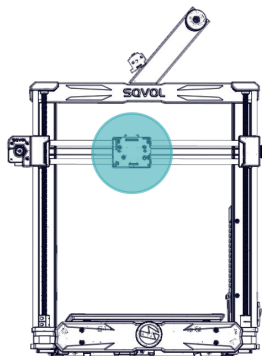
- 1 Install the extruder kits on the sliding base via 3 M3X5 screws and tighten the screws.



Extruder kits

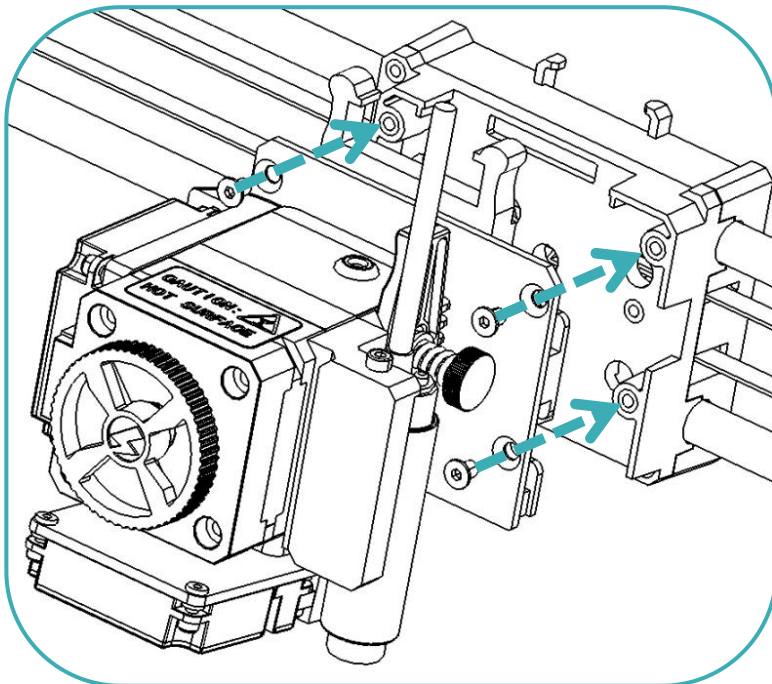


M3X5*3

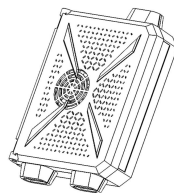


Install it here

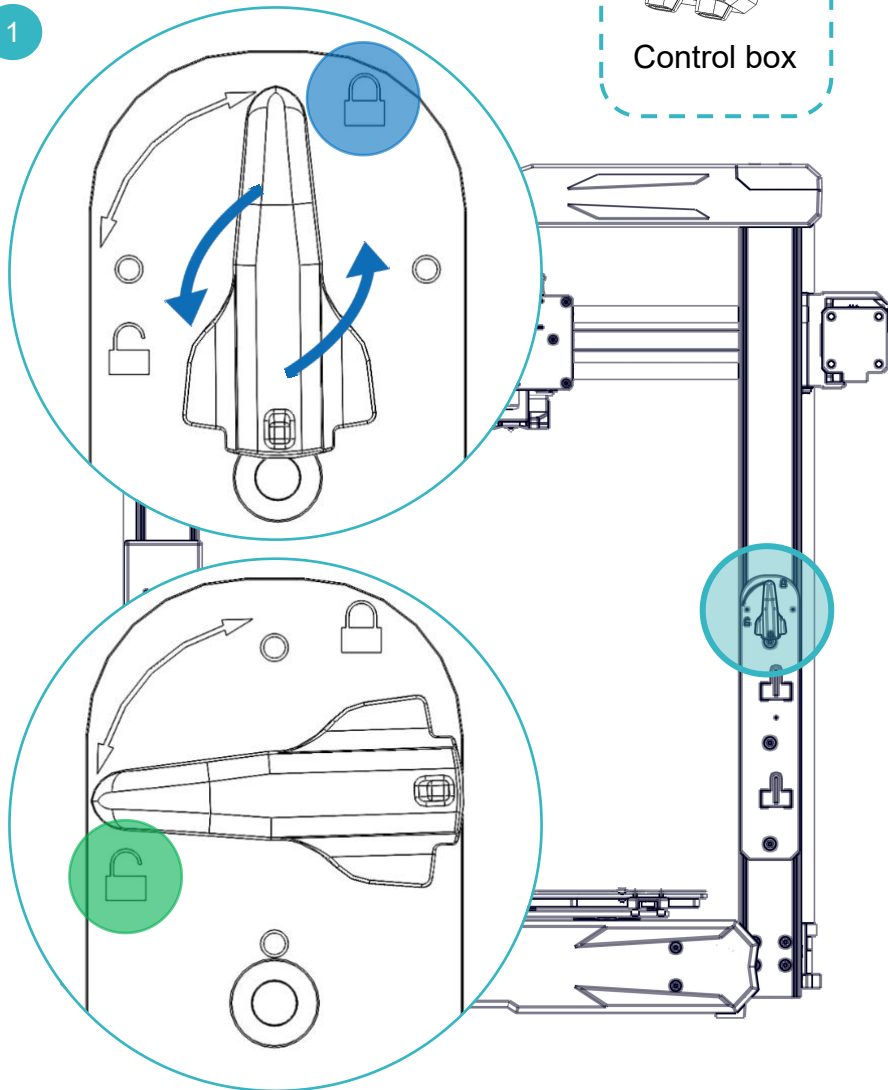
1



- 1 Please turn the aircraft switch on the control box hanging plate to the left from locked state to unlocked state.

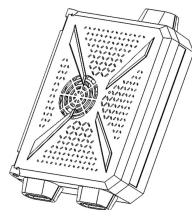


Control box



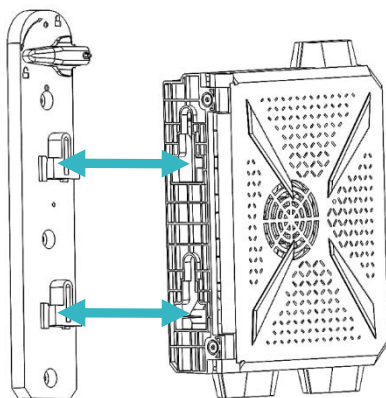


- 2 Install control box on the hanging plate.
- 3 Press the entire control box downward to lock it to hanging plate.
- 4 Re-rotate the aircraft switch to  lock position.

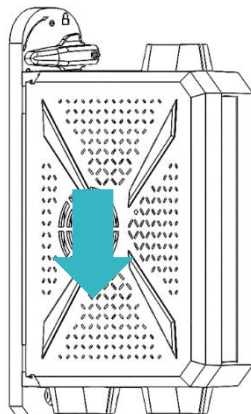


Control box

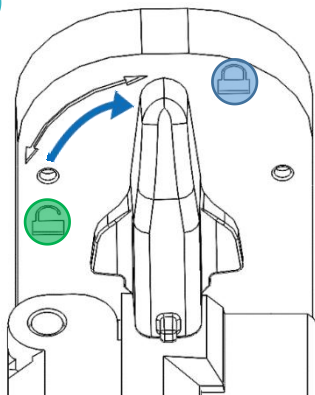
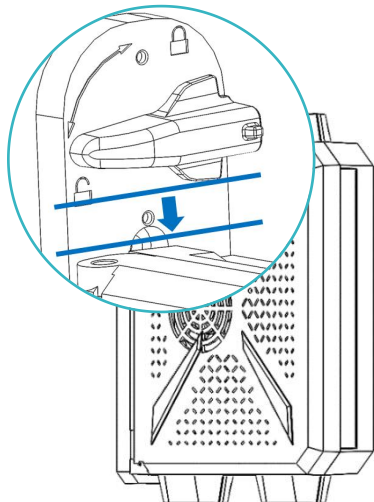
2



3

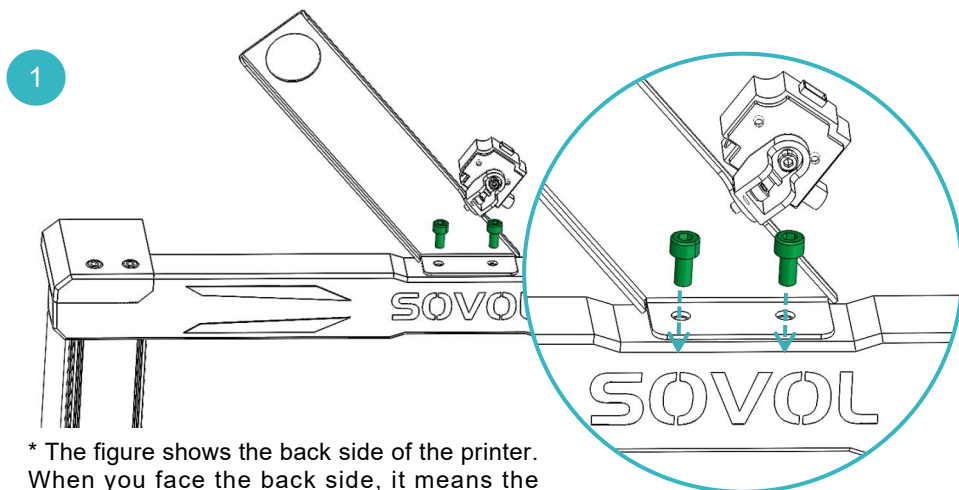
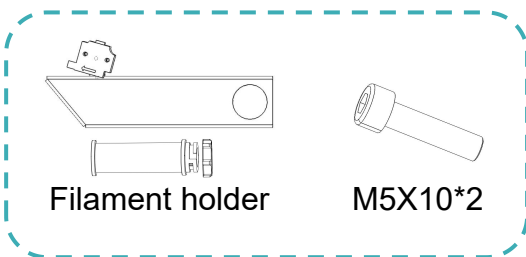


4

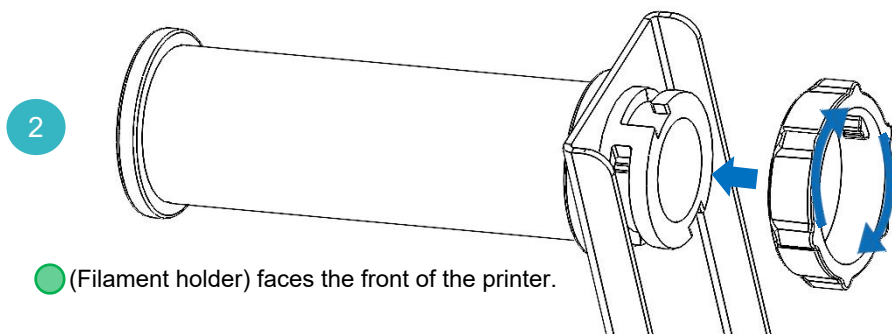


1 Install filament plate to the top of the machine with 2 M5X10 screws.

2 Install filament barrel.



* The figure shows the back side of the printer. When you face the back side, it means the filament holder faces to the left side.



● (Filament holder) faces the front of the printer.

Assembly

Install touch screen

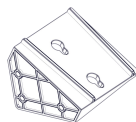


1 Mount the touch screen bracket to the profile on the right of the base via 3 M4X12 screws.

2 Mount the touch screen on the bracket, push and pull it downward, and fix it in the groove.



Touch screen

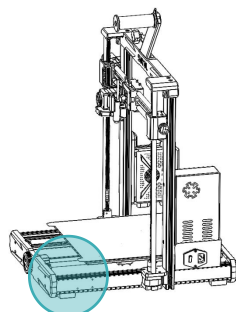
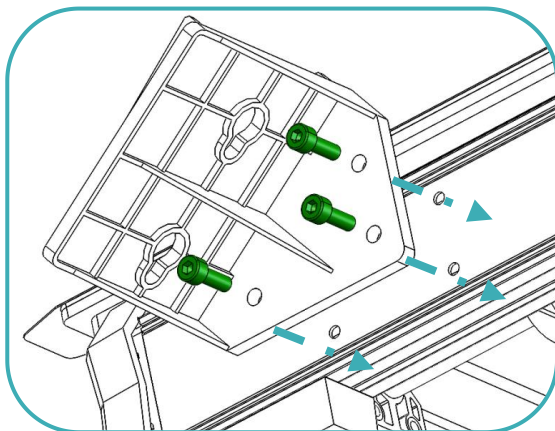


Touch screen bracket



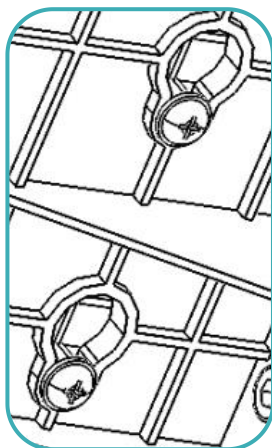
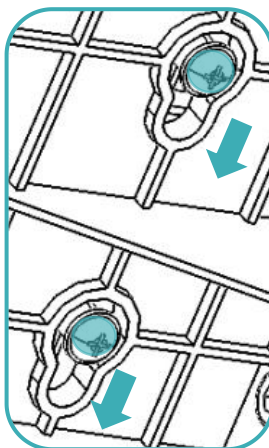
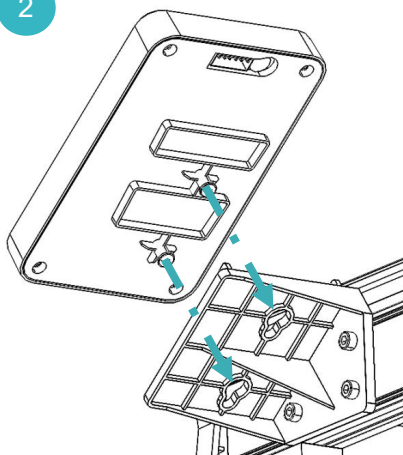
M4X12*3

1



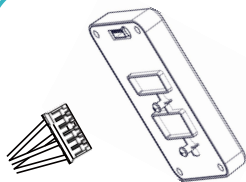
Install here

2

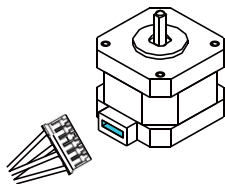


Assembly

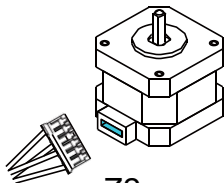
Connect cable >>>



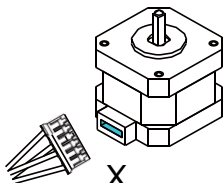
Touch screen



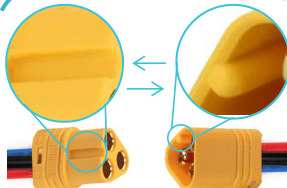
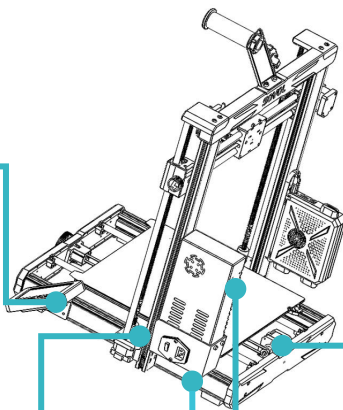
Y



Z2



X



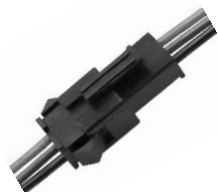
Power supply



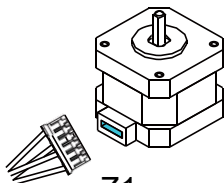
* Please select correct input voltage to match your local power supply (230V or 115V).



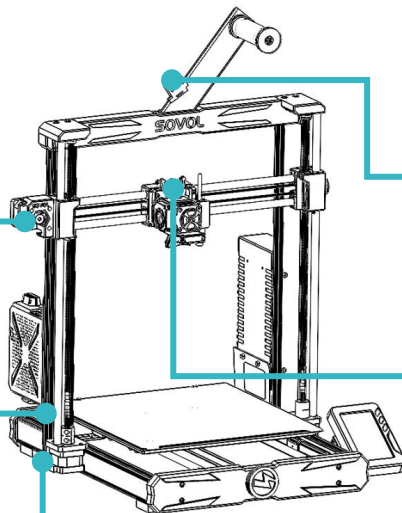
Filament runout sensor part-2



Filament runout sensor part-1



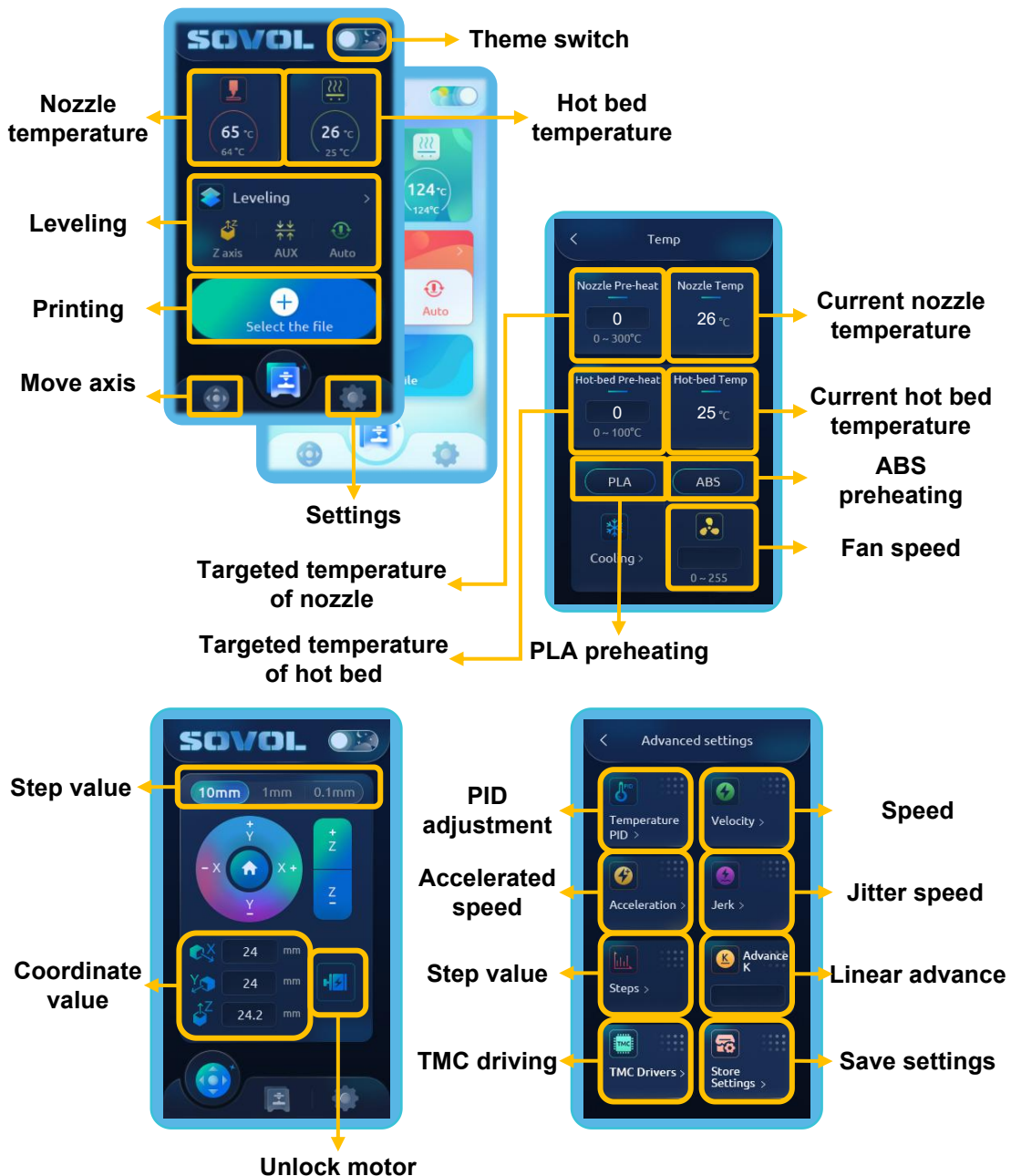
Z1

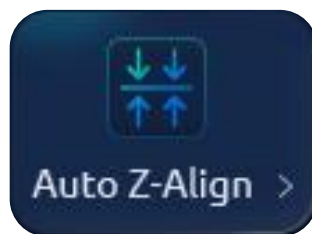
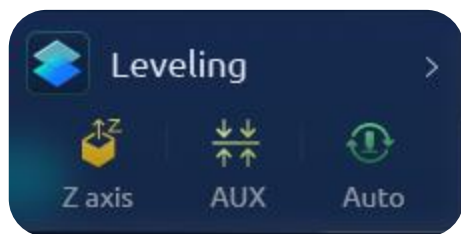


Extruder kits



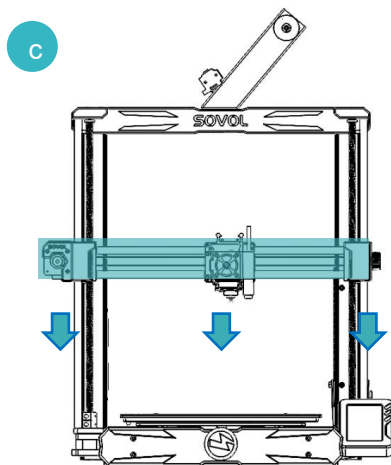
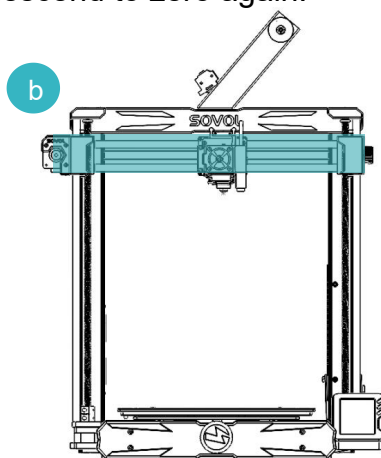
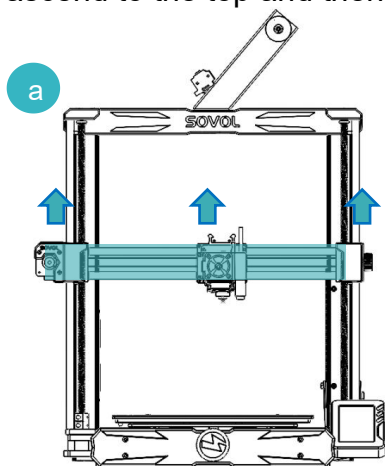
Information of touch screen





1

Click the “Leveling” on the main interface, the machine will auto home first. After the machine stops, click “Auto Z-axis Alignment”, and the whole X-axis beam of the machine will ascend to the top and then descend to zero again.



It is quite normal, if noise produces after the machine hits the top. Please wait patiently until it goes down.



This step is not required for leveling per time but it is required when the whole X-axis is not horizontal enough.

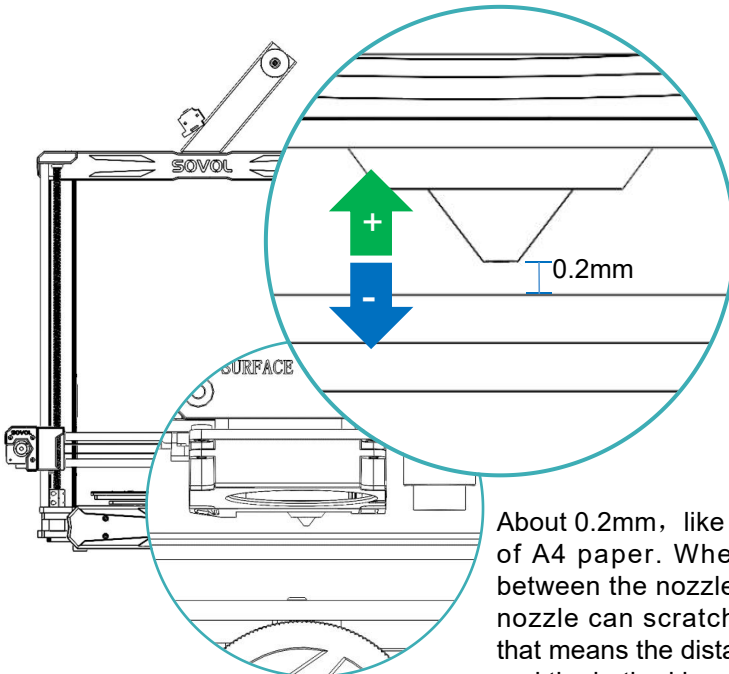


2

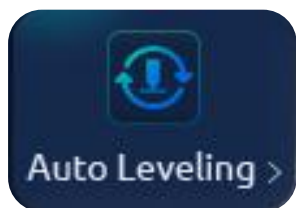
After the machine stops, adjust the Z offset value in order to adjust the distance between nozzle and hot bed.



Remember to click “Save” after leveling.



About 0.2mm, like the thickness of a piece of A4 paper. When you drag the paper between the nozzle and the hotbed, if the nozzle can scratch on the paper slightly, that means the distance between the nozzle and the hotbed is suitable.



3

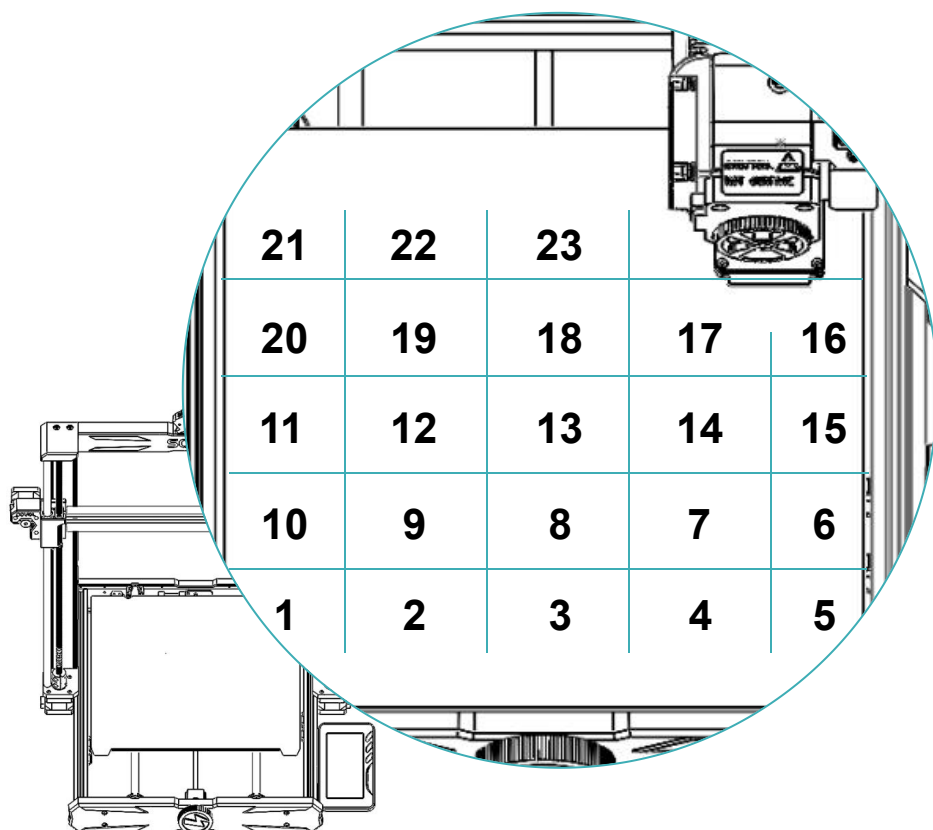
Click the “Auto Leveling” icon after finishing adjustment, and the machine will enable 25-point detection.



Remember to click “Save Settings” after detecting.



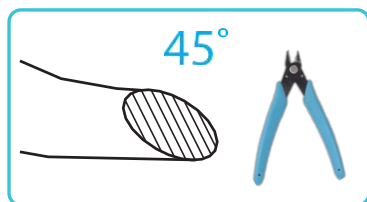
After clicking “Auto Leveling”, the nozzle will rise to 120°C and the hot bed will rise to 60°C. Please wait patiently and avoid scalding.



Load filament



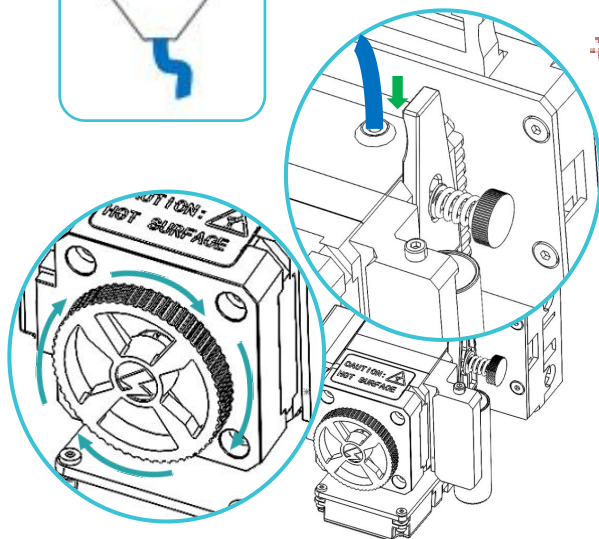
- 1 Click the temperature icon → select preheat PLA/ABS on the main interface.
- 2 When the temperature reaches the target value, cut the front end of filament at a 45° bevel and insert it into the feed port for about 20mm. Hold it downward with your hand and turn the wheel in a clockwise direction until filament could be seen extruding out of the nozzle.



Axis of movement

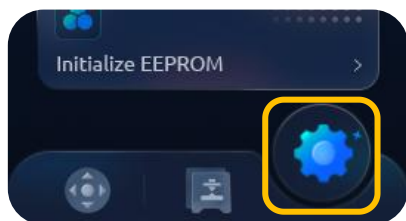


Unlock motor



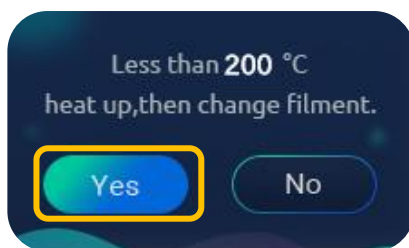
Unlock motor, if there is certain resistance and difficult to turn when turning the wheel, please unlock the motor.
Steps for motor unlocking:
Main interface → “Move axis”
→ “Unlock Motor”.

Replace filament



1

Main interface → Click the gear icon to enter the setting interface → Click “Refuel”.



2

Enter “50” and click “Retreat”. If the nozzle temperature is too low, it will prompt you to heat up. Please click “Yes”.

3

Wait until the temperature rises to the target value, click “Retreat” again, the machine will withdraw to the feed port automatically, then insert new filament to start printing.

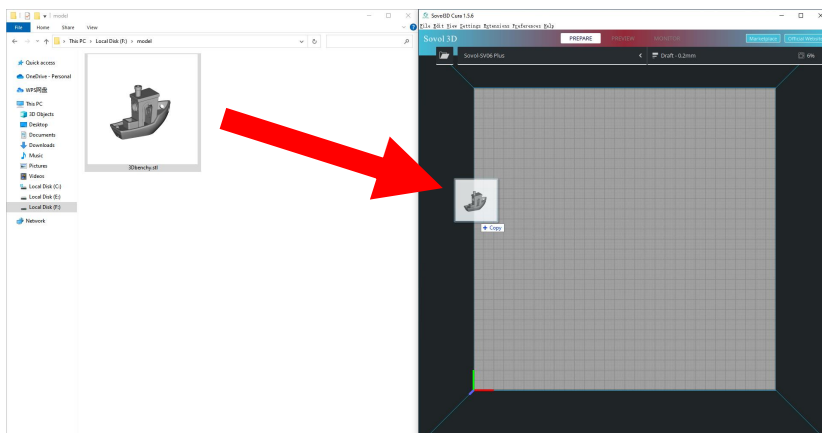


Sovol3D_Cura-1.5.6-win64

1 Double click the file “Sovol-Cura” installed in the TF card.

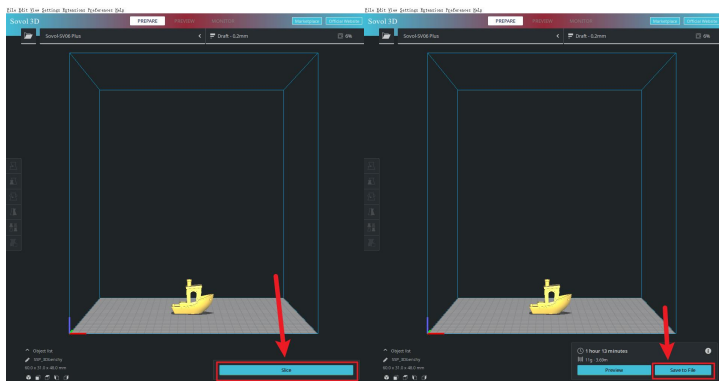


2 Select to add SV06-Plus.



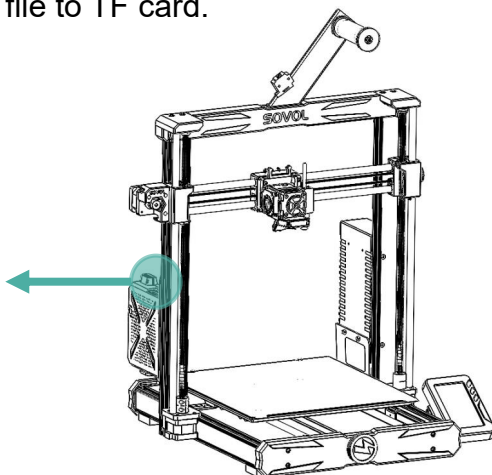
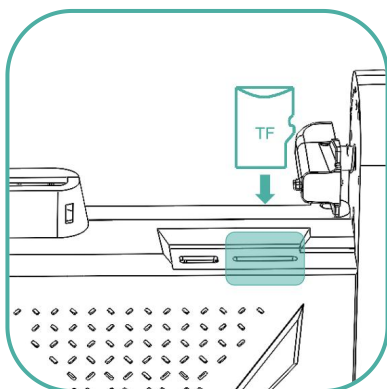
3 Select to add the model you want to print.

Printing



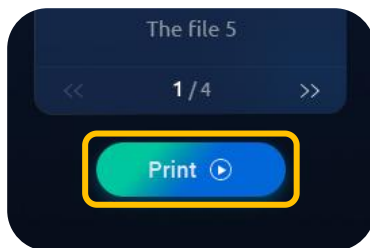
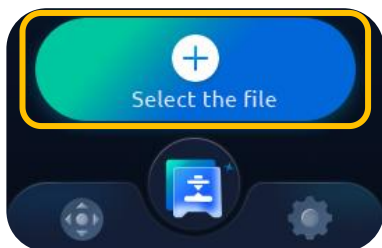
4

Click slice and save the file to TF card.



5

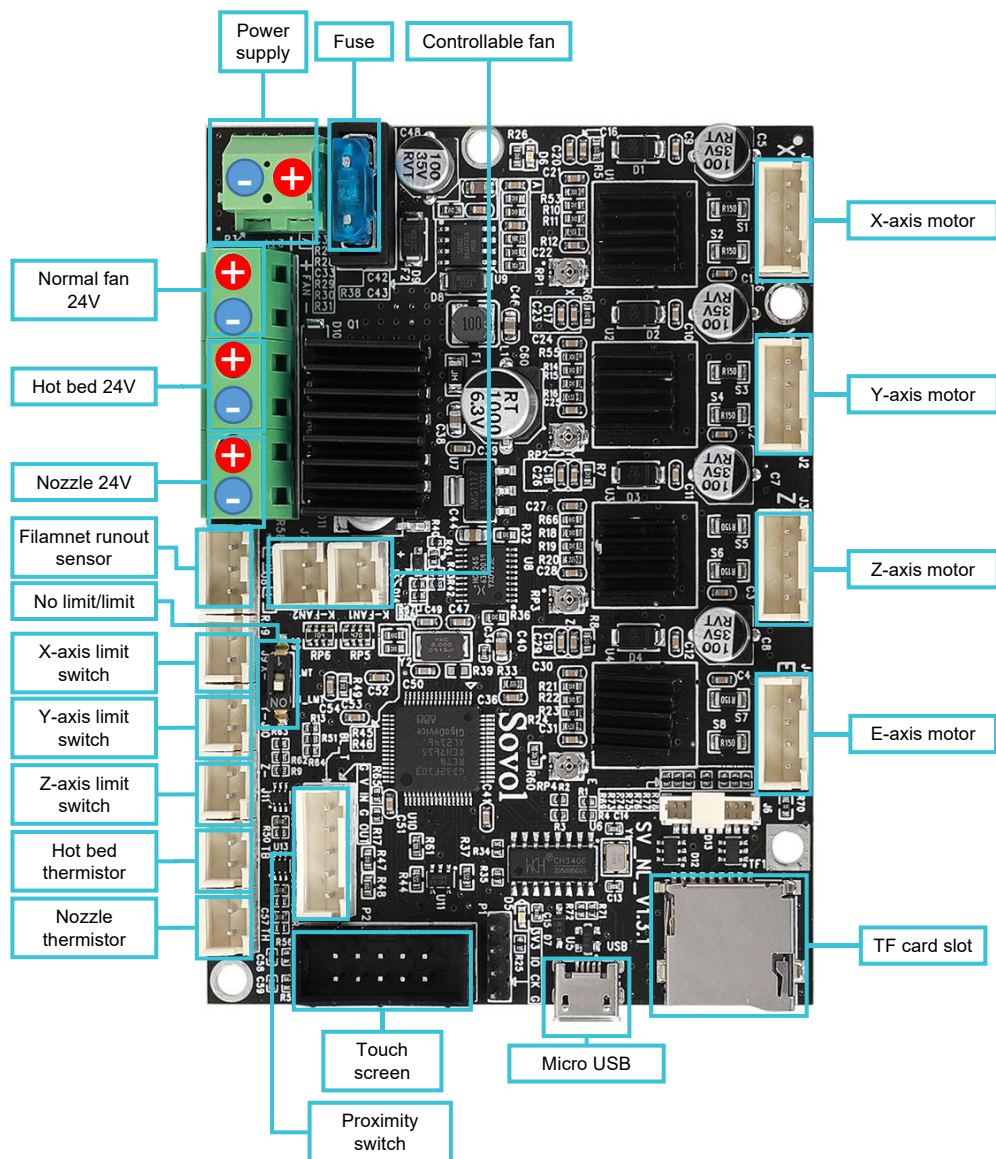
Insert the TF card into the card slot on the control box.



6

In the interface → Click “Select Files” → Select files to print.

Mainboard





sovol official user group



sovol official website

SHENZHEN Lian Dian Chuang Technology CO.,LTD.

Official website: sovol3d.com

E-mail: info@sovol3d.com

