



 YUCERA

# DJ89 PLUS

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## 3D Printer User Manual

V6.0

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.

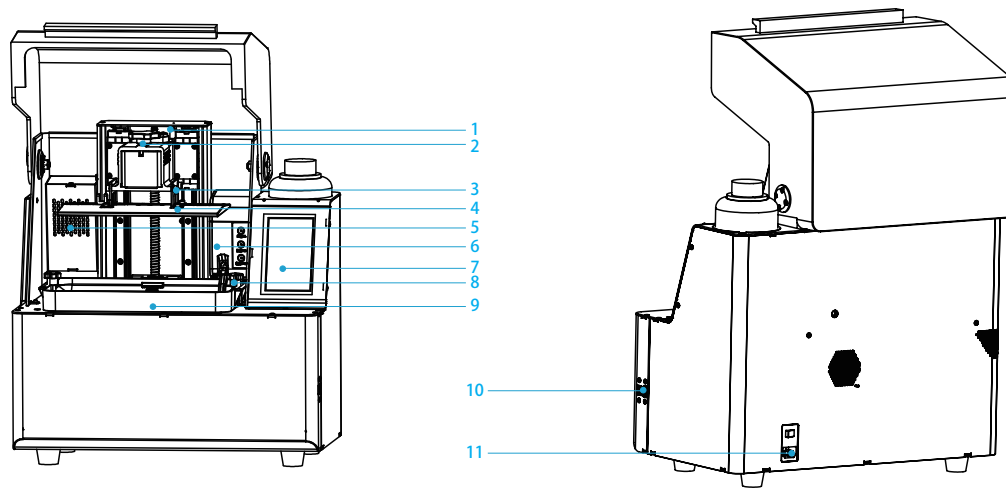
For a better experience in using our product, you can also learn how to use the printer in the following ways:

View the accompanied instructions and videos in the U disk.

## NOTES

- 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 Please use recommended resin for not to damage the machine.
- 5 Do not use any other power cable except the one supplied. Always use a grounded three-prong power outlet.
- 6 Please do not open the plastic cover during usage, otherwise the printing will be interrupted.
- 7 Do not wear cotton gloves when operating the printer, avoiding the burns, injury and machine damage caused by the moving parts.
- 8 Please wait a moment after the print is finished. And please wear gloves to take out the print by tools.
- 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.
- 10 Children under 10 years should not use the printer without supervision.
- 11 This machine is equipped with a security protection mechanism. Do not manually move the nozzle or printing platform mechanism manually while booting up, otherwise the device will automatically power off for safety.
- 12 Users should comply with the laws and regulations of the corresponding countries and regions where the equipment is located (used), abide by professional ethics, pay attention to safety obligations, and strictly prohibit the use of our products or equipment for any illegal purposes. Piocreat will not be responsible for any violators' legal liability under any circumstance.

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1 Limit switch

2 Platform screws

3 Leveling screw

4 Building platform

5 Heating device

6 Feeding module

7 Touch screen

8 Tank screws

9 Resin vat

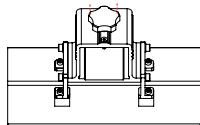
10 USB port

11 Power port

### Basic Parameters

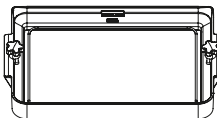
Model	DJ89 PLUS
Automatic feeding	Support
Molding chamber heating	Support, temperature range 20-35°C
Print method	U disk/ WIFI
XY axis accuracy	29μm
Z-axis resolution	0.01-0.1mm(layer thickness
Print speed	60mm/h
Special resin	Castable Wax Resin, Dental model resin, Common rigid photosensitive resin, Standard resin, High hardness, High toughness, Biocompatible Resin.
Light source configuration	UV integrated lamp bead (wavelength 405nm)
Operation system	Win7 or above X64, Mac
Nominal power	600W
X/Y-axis resolution	7680*4320
Print size	228 x 128 x 100mm (length x width x height)
Machine size	450 x 290 x 500mm (length x width x height)
Package size	611 x 386 x 666mm (length x width x height)
Machine weight	21.75KG
Gross weight	26.28KG

### 3. Package List



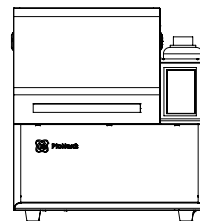
1

Print platform |



2

Resin vat |



3

3D printer |

#### Tool list



1 U disk x 1



2 Screwdrivers x 1set



3 Brush x 1



4 Plastic blade x 1



5 Resin filter x 4



6 Metal blade x 1



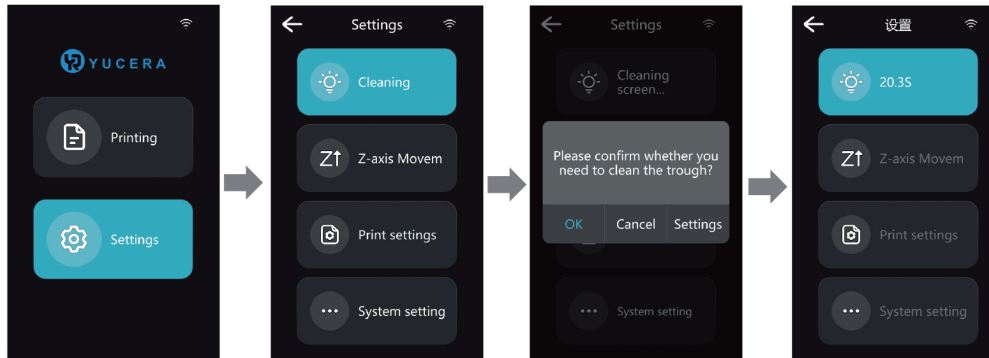
7 Power cord x 1



8 Disposable latex gloves x 1

Tips: the above accessories are for reference only, in kind prevail!

## 4. Interface Information



- Screen clearing:** material tank cleaning;
- Z-axis movement:** Back to Zero and leveling;
- Print settings:** printing parameters, device control, feeding system and Pre-Heat;
- System settings:** set WALN, set language and region, upgrade firmware version (local upgrade & network upgrade); view device information, restore factory settings.

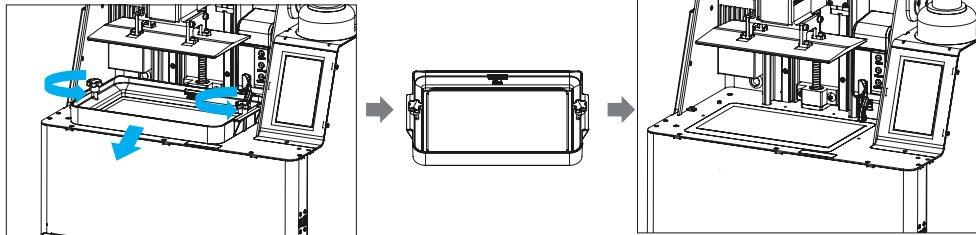


Note: Check whether the light source is normal when clearing the screen. The UI is only for reference only and shall be subject to the actual UI.

## 5. Level Platform



Note: The printing platform has been leveled at the factory. If it needs leveling due to transportation or other reasons, please follow the steps below to adjust the printing platform.

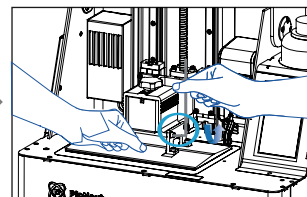
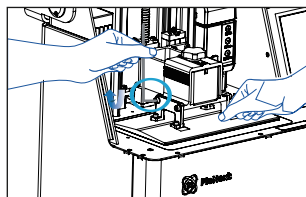
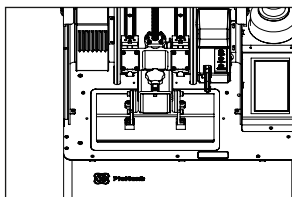
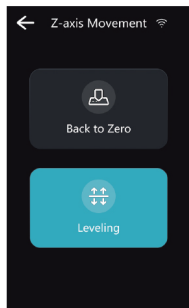


1. First raise the platform, then loosen rubber screws on the left and right sides of the resin vat, and take out the resin vat.

2. As shown above.

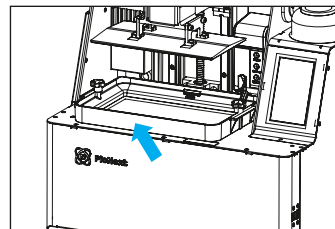
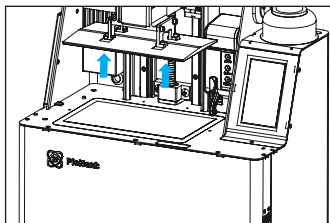
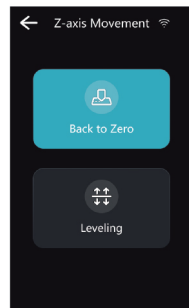
## 5. Level Platform

If the platform does not stick to the print screen, do as the following:



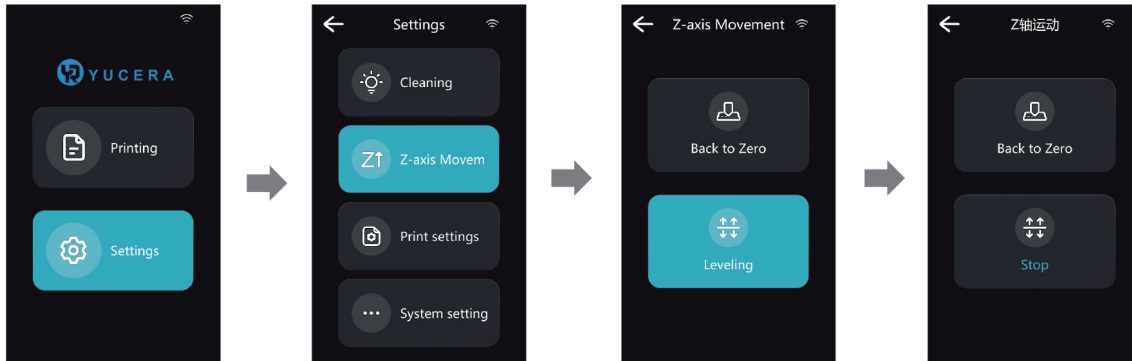
1. After unscrewing the leveling screws, press “Leveling” to keep the platform and the print screen parallel.

2. Gently press the platform and tighten 4 screws clockwise, and the platform can be leveled successfully.



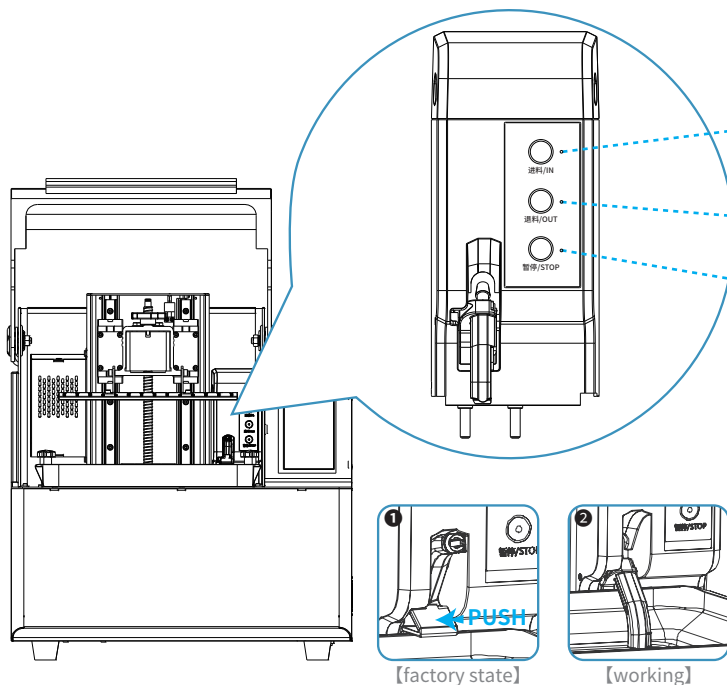
3. Press “Auto-homing”, move up the z-axis to a proper position, and then tighten the fixing screws at both ends of the resin vat.

## 5. Level Platform



Note: The UI is only for reference only and shall be subject to the actual UI.

## 6. Guidance on the use of the feed system/module



### Interface Definition |

- 【 /IN】 : click to suck in the resin, and then stop when the resin level rises to the sensing height; click again to stop it;
- 【 /OUT】 : click to perform resin extraction, and click again to stop.
- 【 /STOP】 : click to stop the module functioning;

### Instructions for the LEDs |

1. The LED is always ON to indicate that the functionality is being performed;
2. LED3 is always ON to indicate that the module is not working;
3. When in [Automatic Mode], LED1 is always on when feeding, LED2 is always on when returning, and all three LED lights are flashing when the feeding is full and paused;



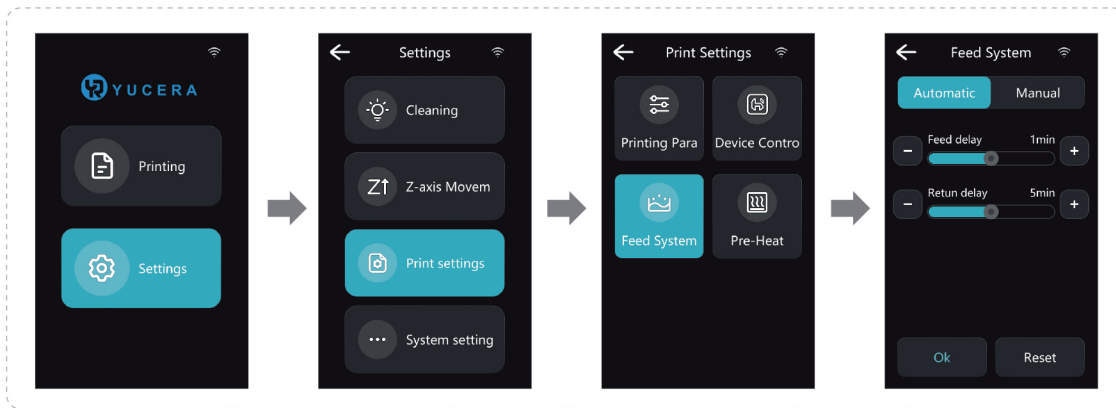
### Notice |

- ① Before opening [Auto Mode], please make sure that the resin bottle and tank levels are normal.
- ② If there is no response when clicking /OUT], you must click the button again to stop.

## 6. Guidance on the use of the feed system/module

**【Automatic Mode】** : The system defaults to turning off automatic feeding. Select this mode to sense the resin feeding process in real-time during printing, can set the feeding time according to your preference. After printing, it begin to return the material, be available to setting return the material time.

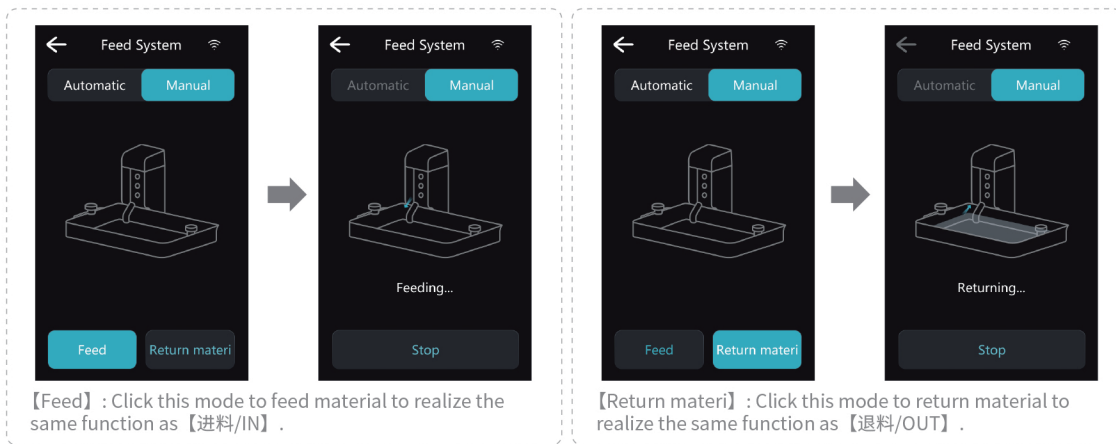
Feed delay can be set 【0-2min】  
Return delay can be set 【0-10min】



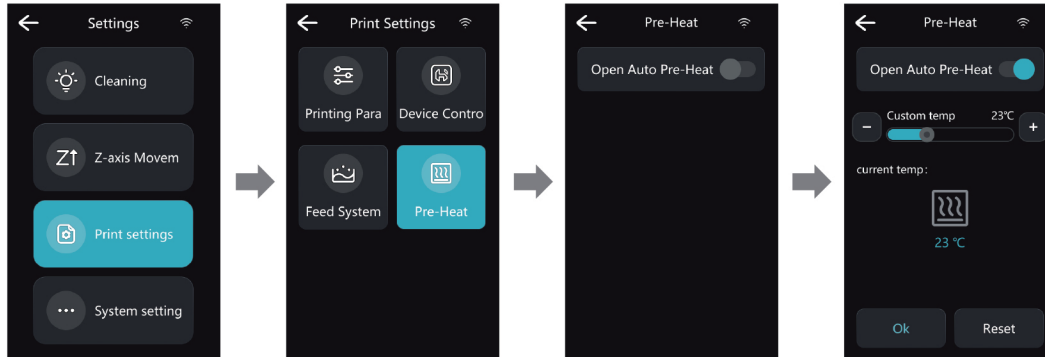
**【Manual Mode】** : Select this mode to control the resin liquid level during the printing process, and perform feeding and unloading operations.

Exit the function from the manual mode interface, and the system defaults the automatic feeding function to be off.

Single max feeding time 【8 min】  
Single max running time 【15 min】



## 7.Guidance on the use of Pre-Heat

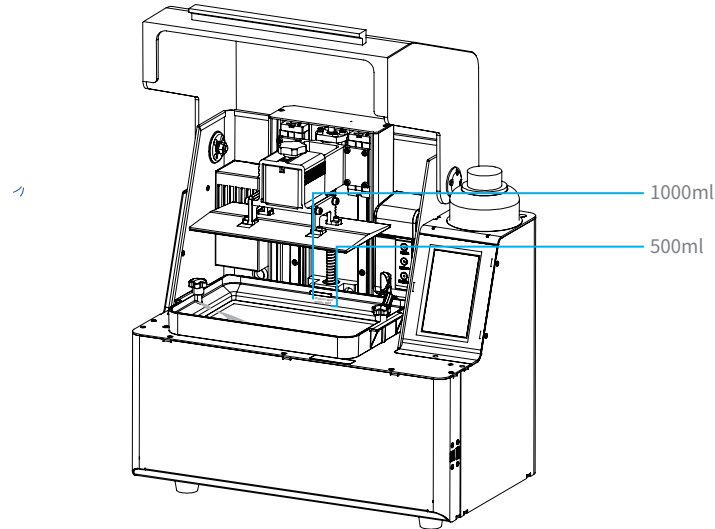


【Open Auto Pre Heat】: Turn on this function to detect the temperature of the printing area in real time for heating during the printing process. You can customize the temperature according to the printing environment requirements, and then click OK to start the heating device of the forming room.

After reaching the set temperature, the device stops working, the heating device continues if detected the temperature of printing area is lower than the set temperature.

## 8. Load Resin

Pour the UV photosensitive resin into the resin vat. The slot capacity is 500ml/1000ml.

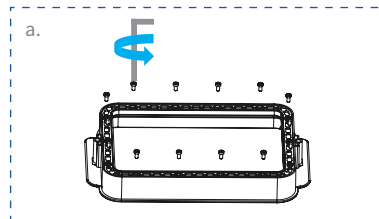


DJ89PLUS can automatically feed in and feed out materials. Please see the video for details.

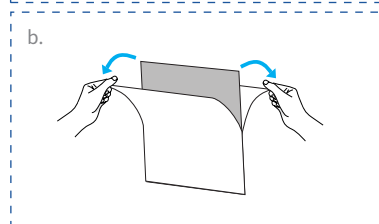


Caution : Resin may cause skin irritation or an allergic skin reaction. Please wear gloves before use to avoid direct contact with the skin.

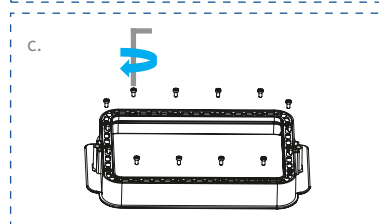
### Installation steps



a. First, remove the 14 screws at the bottom of the vat and take down the old release film.

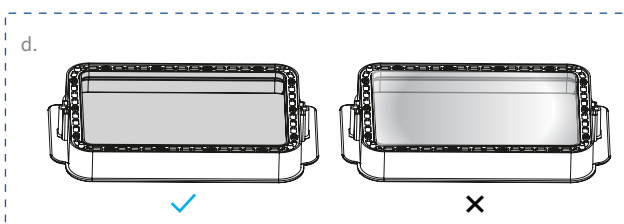


b. Gently remove the protective film on the front and back of the release film.



c. Use the release film fixing plate to press the release film into the bottom of the vat, and tighten the screws diagonally across from each other one at a time. (Note: Make sure there are no debris between the fixing plate and release film)

d. Make sure the release film is flat and tight after installation. (Note: If not flat or loose, please check whether the screws are locked or the release film is abnormal)



### Parameters



尺寸:198mm\*286mm  
(Size)



厚度:0.15mm  
(Thickness)



透光率:95%  
(Light Transmittance)

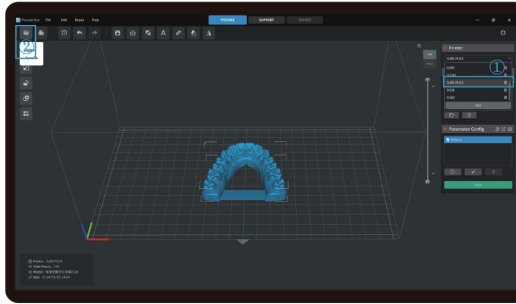
■ Tips: ① The diagram is a reference for the film change procedure, please refer to the physical product; if there are excess edges after installation of the release film, you will need to cut them off.

② It is recommended to replace the release film when it has been used for more than 200 hours.

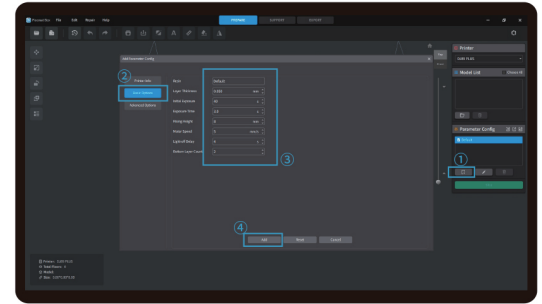
## 1. Slice



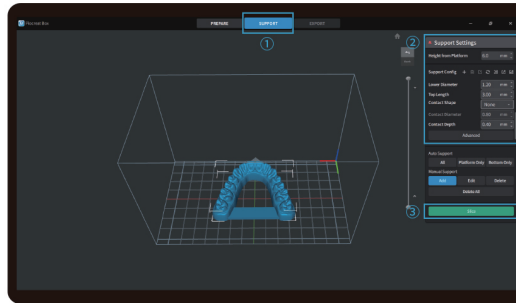
Piocreat BOX



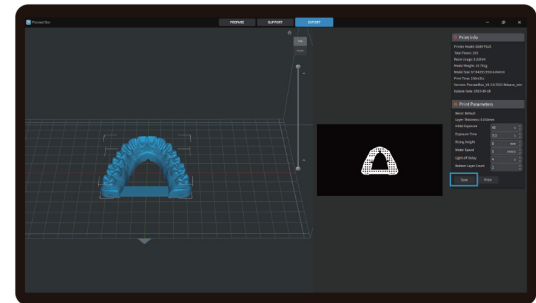
1. Open the Piocreat BOX slicing software.  
→ ①Click the right printer column to select the device model  
→ ②And click "OPEN" on the top left of the interface to import the model file;



2. Setting Printing Parameters (If use Default-Parameters,skip this step)  
→ ①Click the "Add" icon in the Parameter Configuration  
→ ②Click the Basic Setting Option  
→ ③Set the appropriate parameters → ④Click "Add"



3. Add bracket to the model (skip steps ① and ② if no bracket is added).  
→ ①Click the icon above → ②Set the corresponding parameters  
→ ③Click the slice;

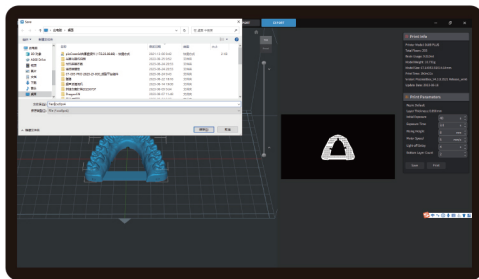


4. Waiting for the auto slicing to complete  
(you can adjust the print parameters as required).  
→ Click "Save" icon to save the sliced file.  
(\* slicing tutorial see the official website slicing video [www.piocreat3d.com](http://www.piocreat3d.com))

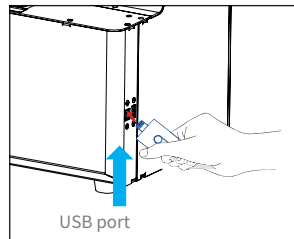


Note: The published UI of slicing software shall prevail for the interfaces of Piocreat BOX .

### 2. Print



1. Generate .cxdlpv4 file, and save the file to U disk.



2. Insert the U disk → press the print button.

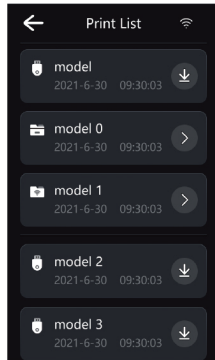
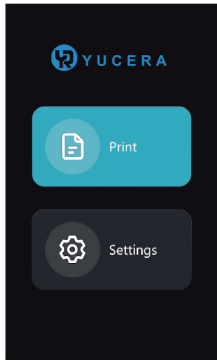


Note: The UIinterface is for reference only,and shall be subject to the actual UI.

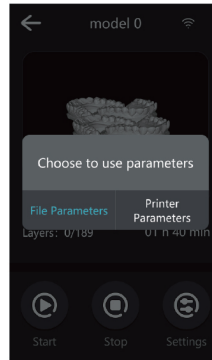


Warning: During the printing process the machine can't be shaken, so as not to avoid influencingaffect the printing quality.

## 10.USB Disk Printing



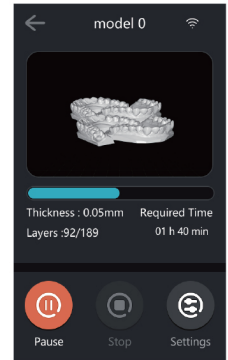
1. Select USB disk files;



2. Choose to use parameters;



3. Press "Start" button

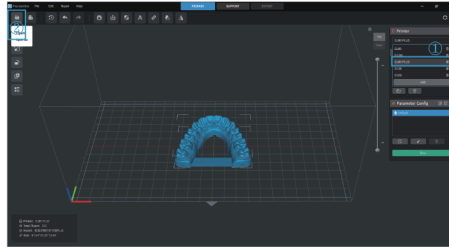


4. Printing...

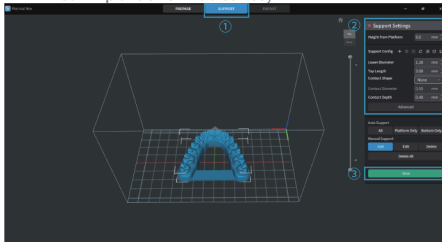
## Slice



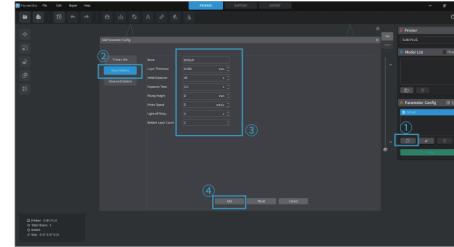
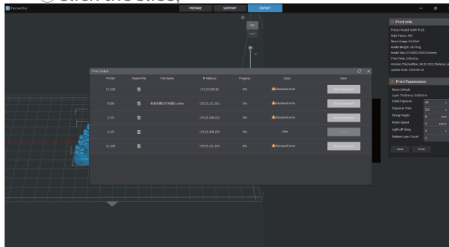
Piocreat BOX



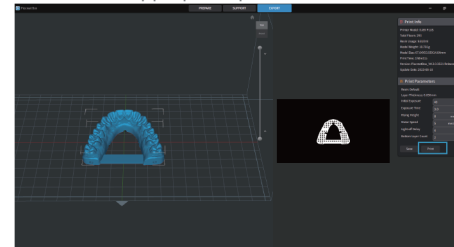
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3. Add bracket to the model (skip steps ① and ② if no bracket is added).  
 →①Click the icon above →②Set the corresponding parameters  
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2. Setting Printing Parameters (If use Default-Parameters, skip this step)  
 →①Click the "Add" icon in the Parameter Configuration  
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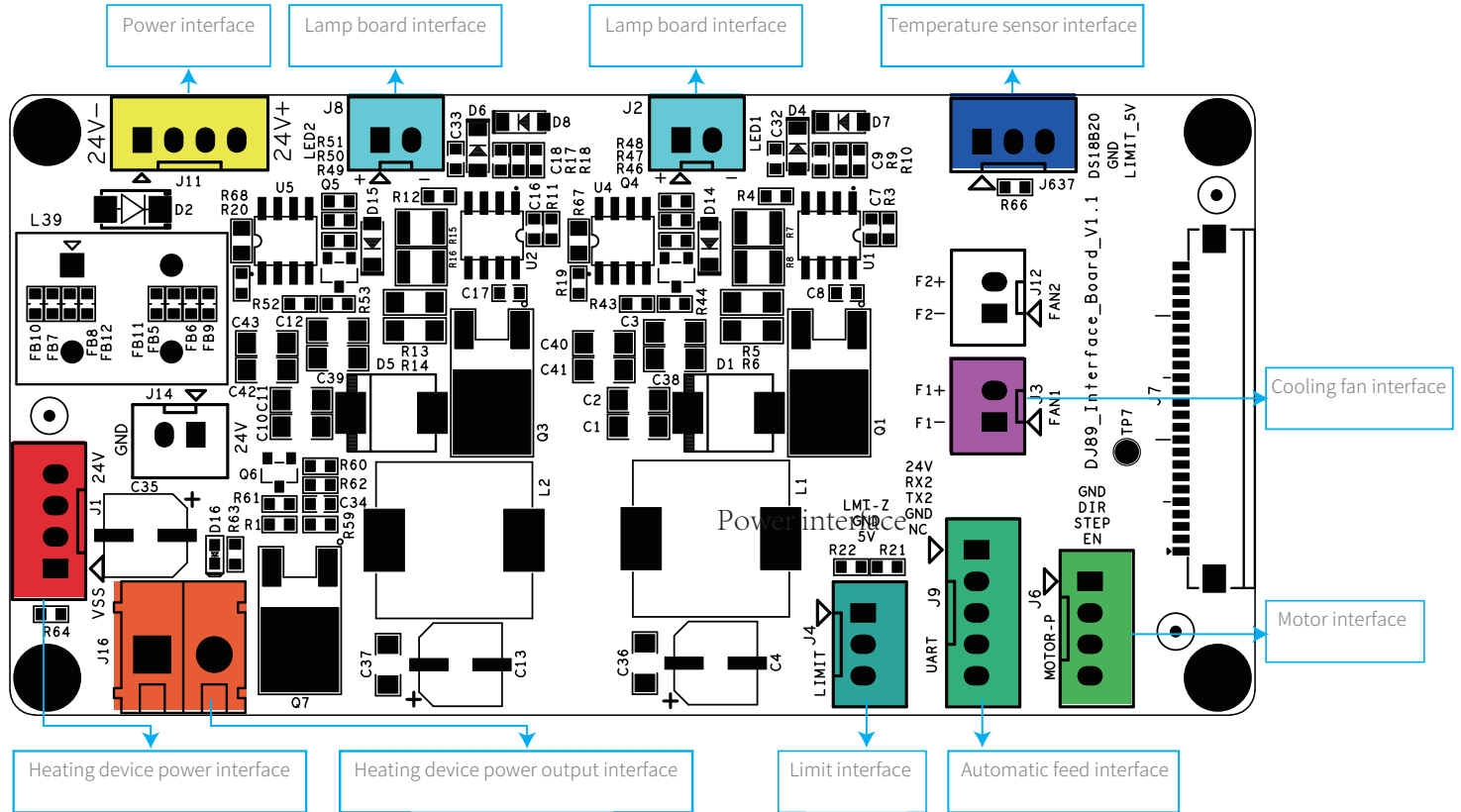
4. Waiting for the auto slicing to complete (you can adjust the print parameters as required).  
 →Click "Print" icon to use WIFI-printing (\* slicing tutorial see the official website slicing video [www.piocreat3d.com](http://www.piocreat3d.com))

5. Select the file on the machine to initiate printing when the transfer is complete.



Note: Make sure the Piocreat BOX and the printer are connected to the same WiFi.

## 12. Wiring Connection



Adapter board circuit wiring diagram

## 13.Troubleshooting

