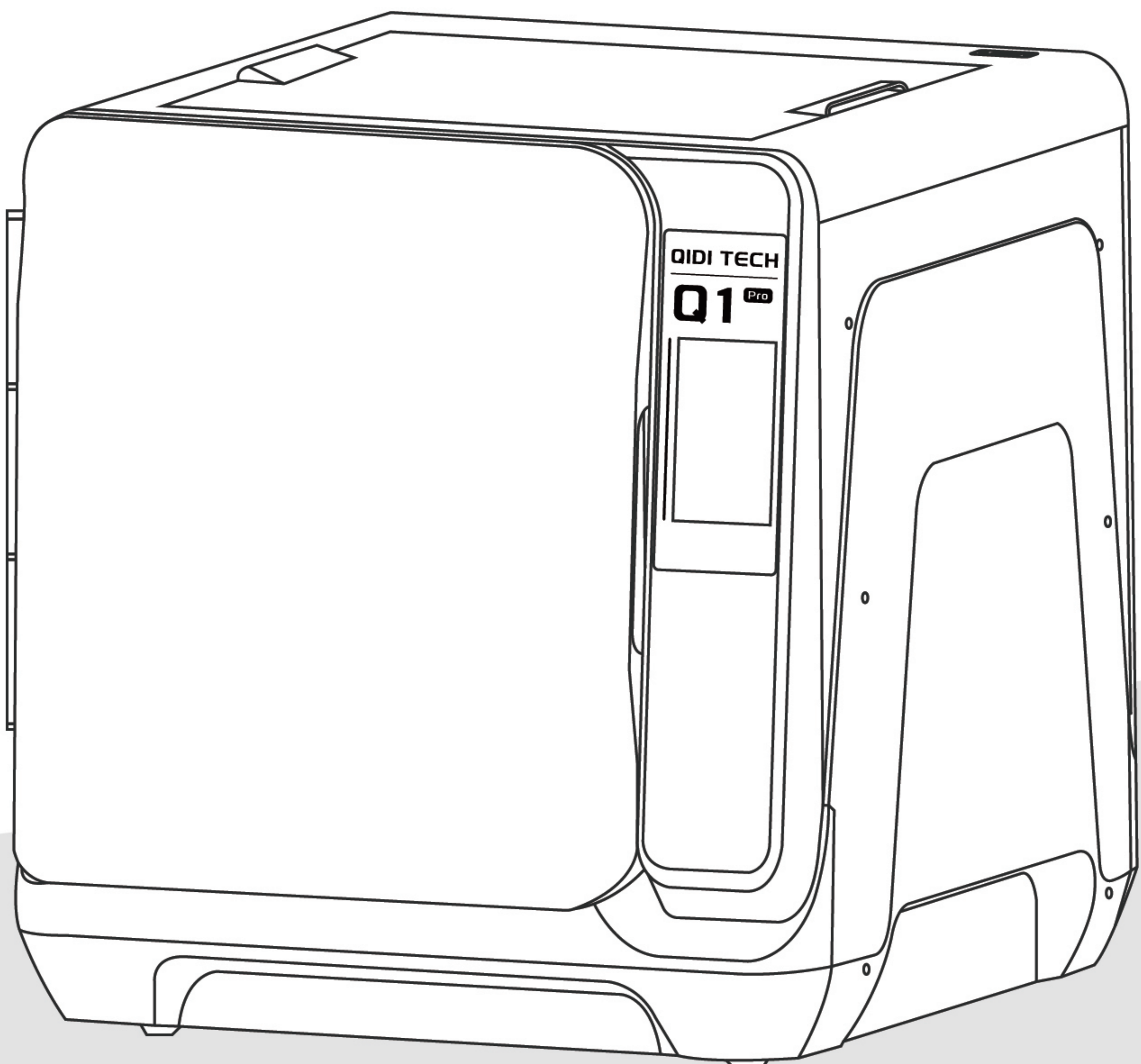


Q1 Pro

Quick Start Guide

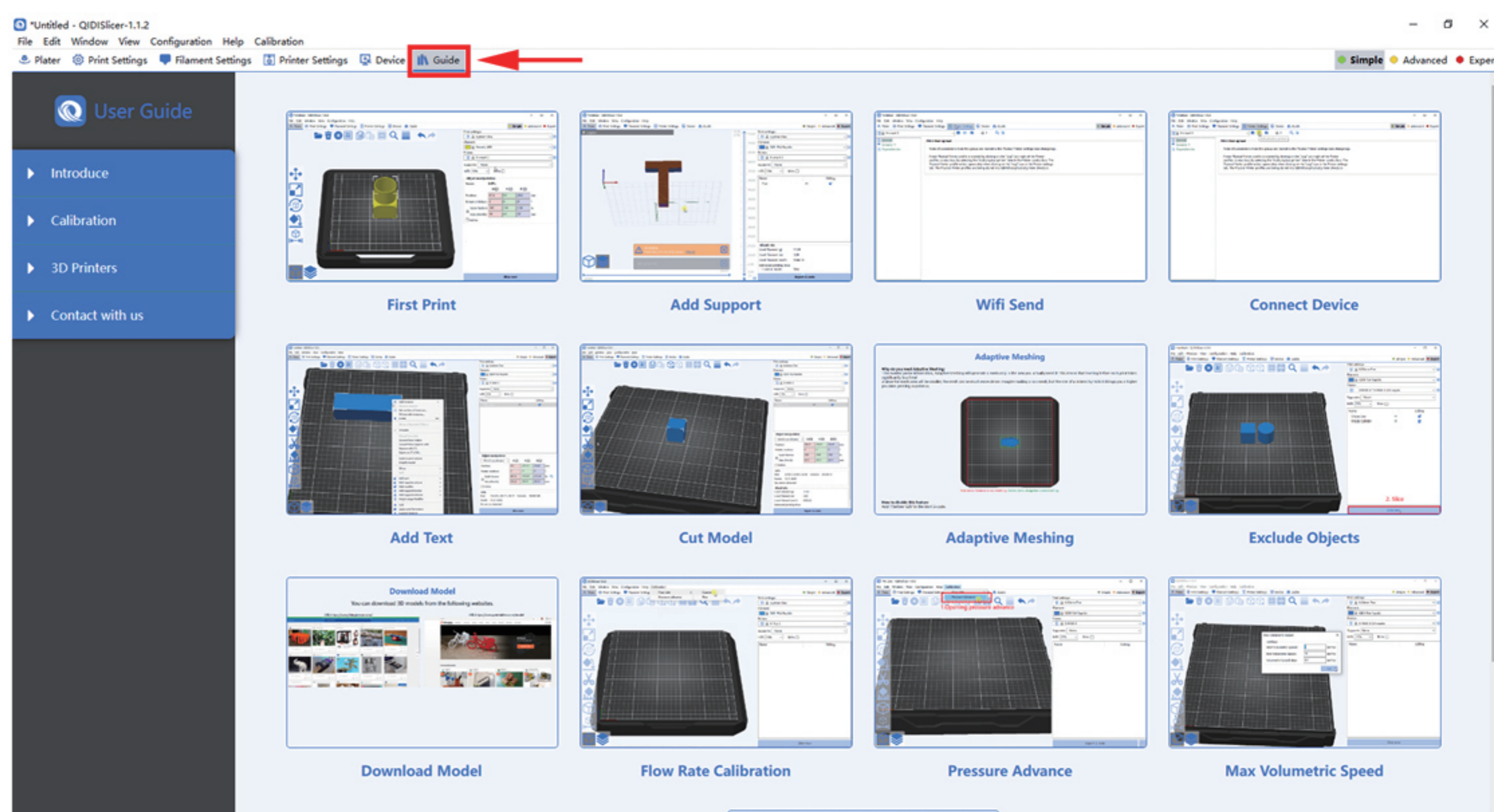


Usage Notice

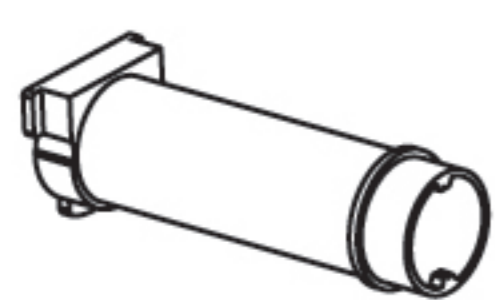
- Do not place the machine in flammable and explosive materials or near high heat sources, please place the machine in a ventilated, cool and dust-free environment.
- Ensure the machine is powered off (unplug power cord) before performing maintenance or modifications.
- Before connecting the power, please follow the power setup instructions to ensure that the voltage is correct.
- Never reach inside QIDI printer while they are in operation.
- Children should be under constant supervision when using QIDI products.
- The printer contains high-speed moving parts, so be careful of hands pinching.
- There is a potential risk of burns: the print head of the QIDI printers can reach temperatures above 300 °C, while the hot bed can reach temperatures above 100 °C. Do not touch either of these parts with your bare hands.
- Do not place the printer in a vibrating or other unstable environment. Otherwise the shaking of the machine will affect the printing quality.
- After printing, use the residual temperature of the print head to clean the filament around the nozzle with the dedicated tools in time. Do not touch either of these parts with your bare hands.
- Perform routine maintenance for your product by using a dry cloth to clean the printer body when it is turned off. Additionally, remove any dust, bonded printing materials, or foreign objects that may accumulate on the optical axis. Regular lubrication is necessary for the linear shaft and Z axis screws.
- If the machine is in standby mode for a long time, please unplug the power of it.
- If the machine is not used for a long time, please pay attention to protect the printer from dust and damp.
- There are manuals, slicer software and other related information in the USB flash drive. (The information in the USB flash drive may not be the latest. You can obtain the latest information by contacting the After-sales Service marked at the end.)
- Modifying system files and installing unofficial plugins means that the customer is waiving their expectations of official support. They will be solely responsible for the security and safety of their printer. Any firmware issues arising from these modifications will not be covered under warranty. If you need to recovery the factory system files, you need to purchase the EMMC-Adapter additionally.

QIDISlicer

There is QIDISlicer slicing software in the USB flash drive. After installing and operating it, you can learn how to use the software in the Guide.



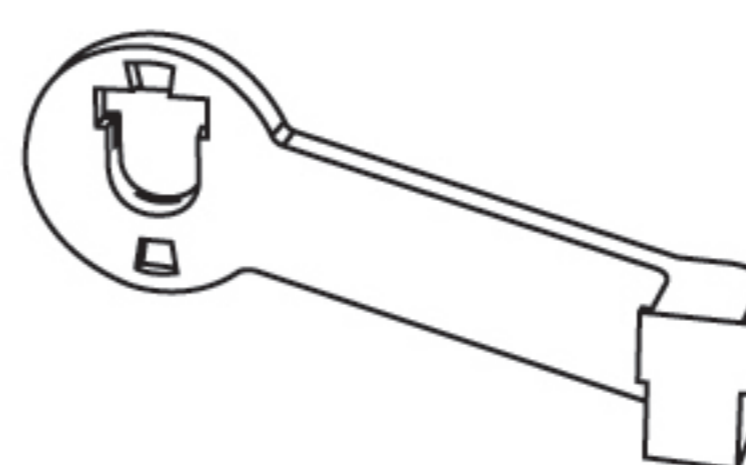
Accessory List



Filament
Spool Holder



Holder Cover



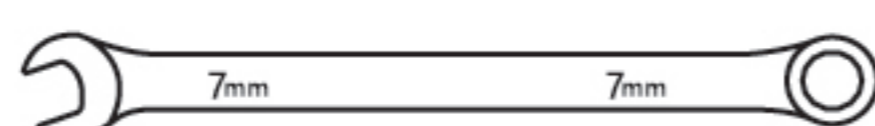
Filament Extension
Bracket



Power Cord



Scraper



7mm
Spanner



Flat Head
Screwdriver



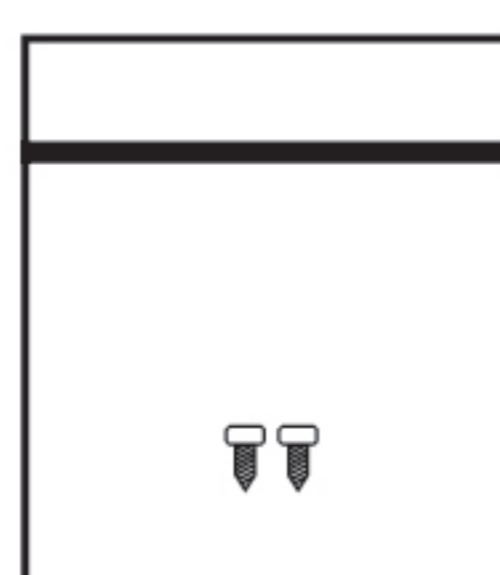
Allen Key H1.5
Allen Key H2
Allen Key H2.5



0.4mm Nozzle
Cleaning Tool

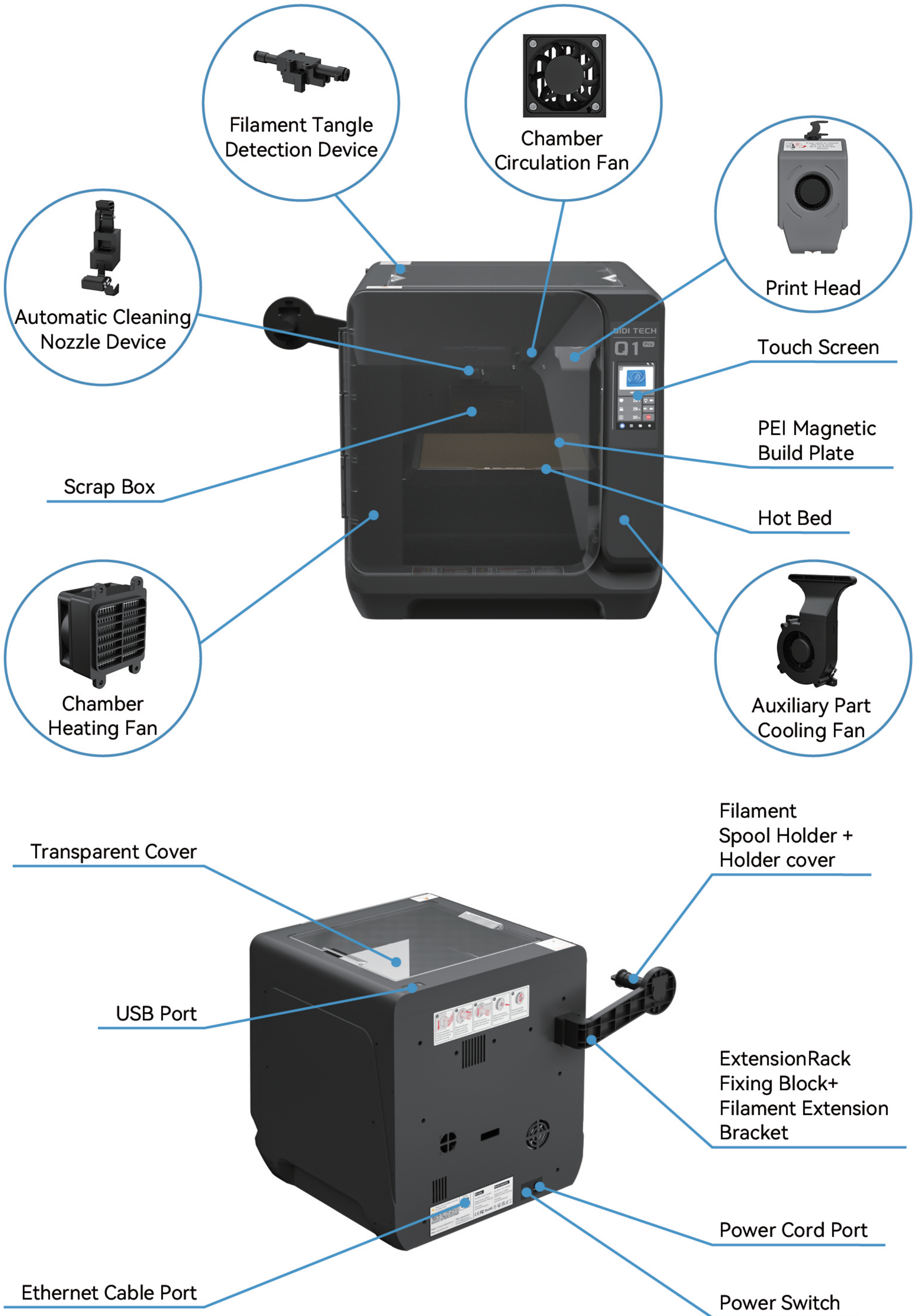


USB 2.0
Flash Drive



Spare Parts Kit

Printer Introduction



Starting Up

Remove the upper foam and take out the printer.



Remove the power cord from the top cover foam and connect it to the printer. Switch on the printer and proceed with the on-screen instructions to complete the unpacking and loading the filament.



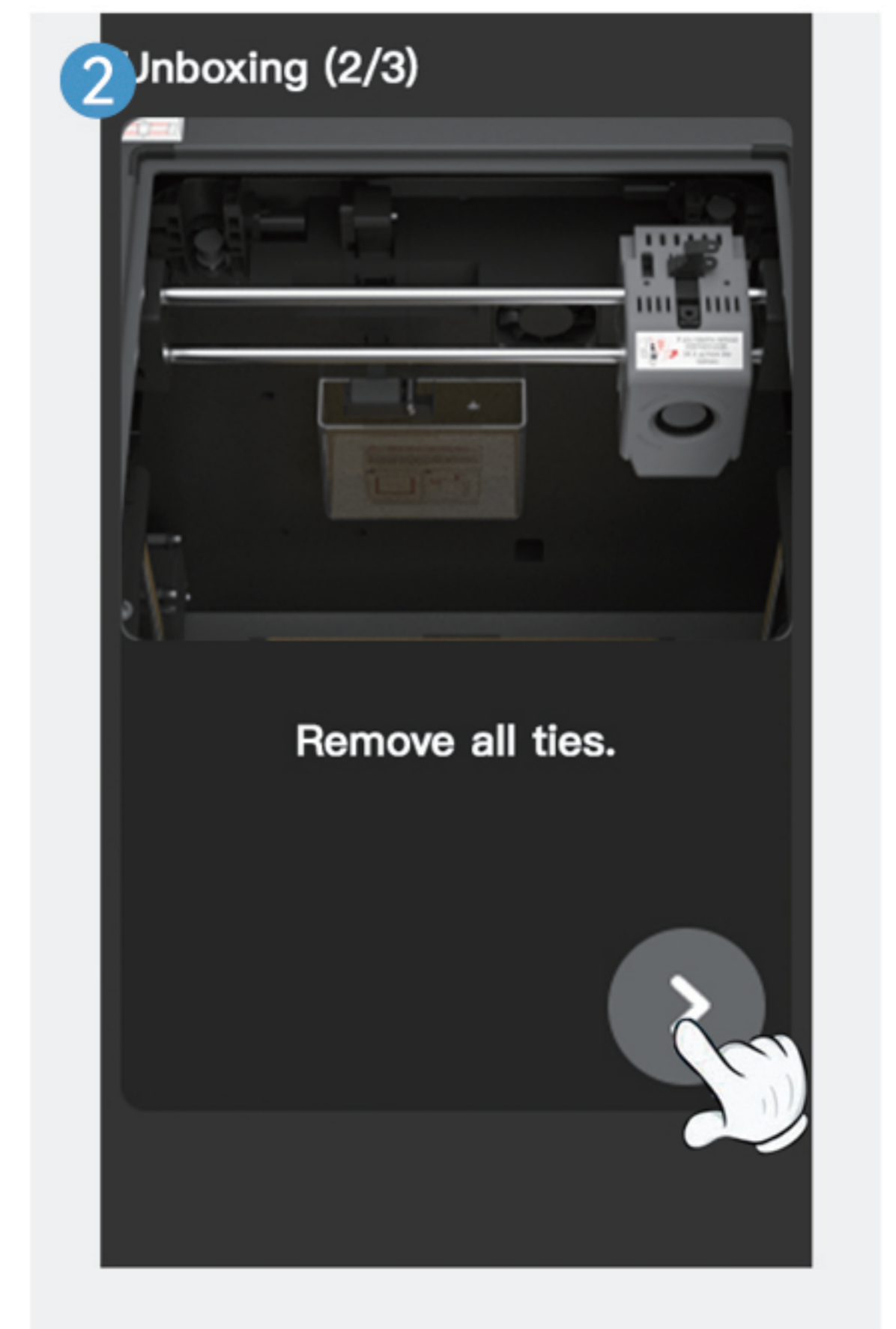
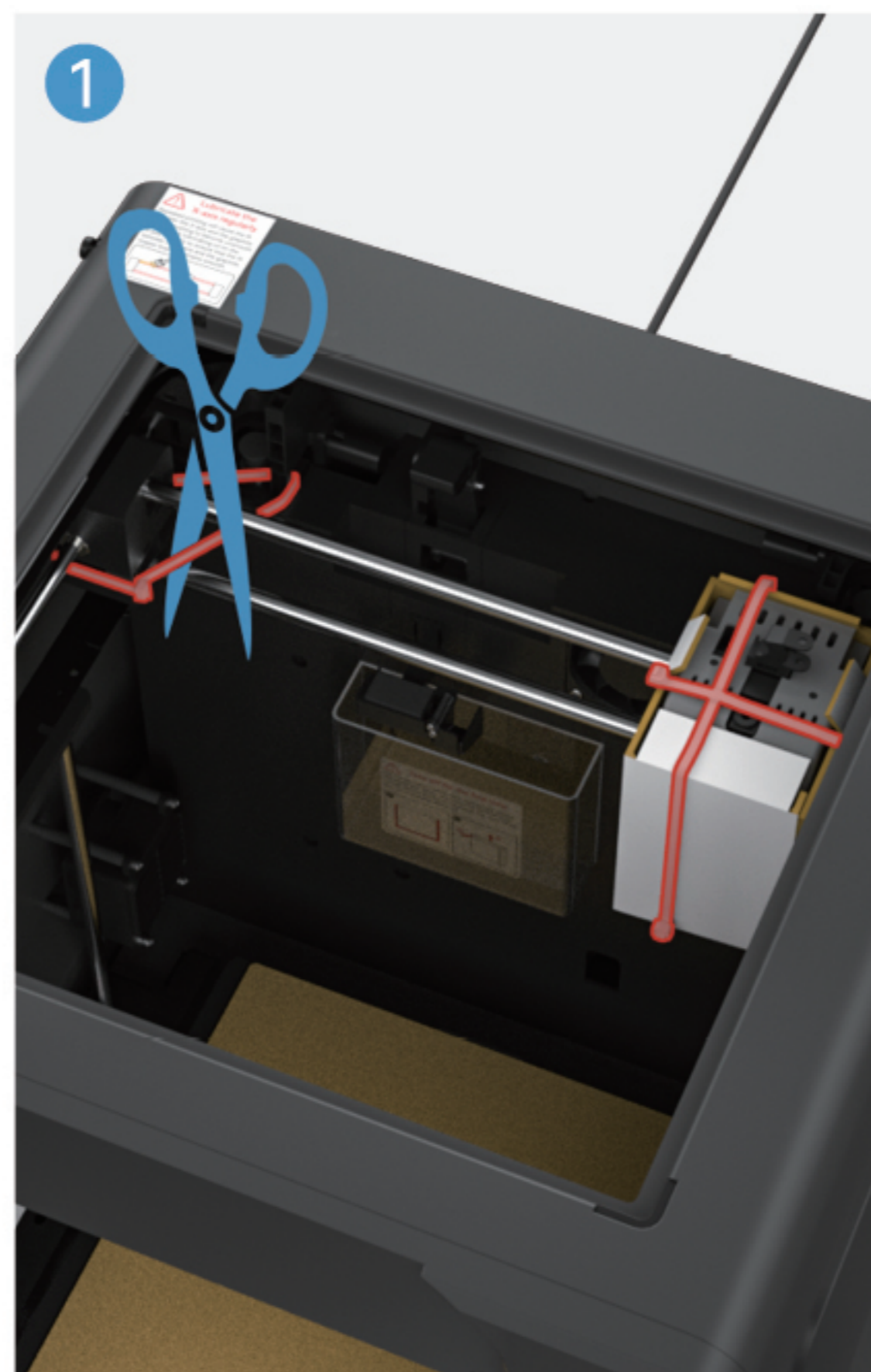
Language

Please select your preferred language and click on the next step.

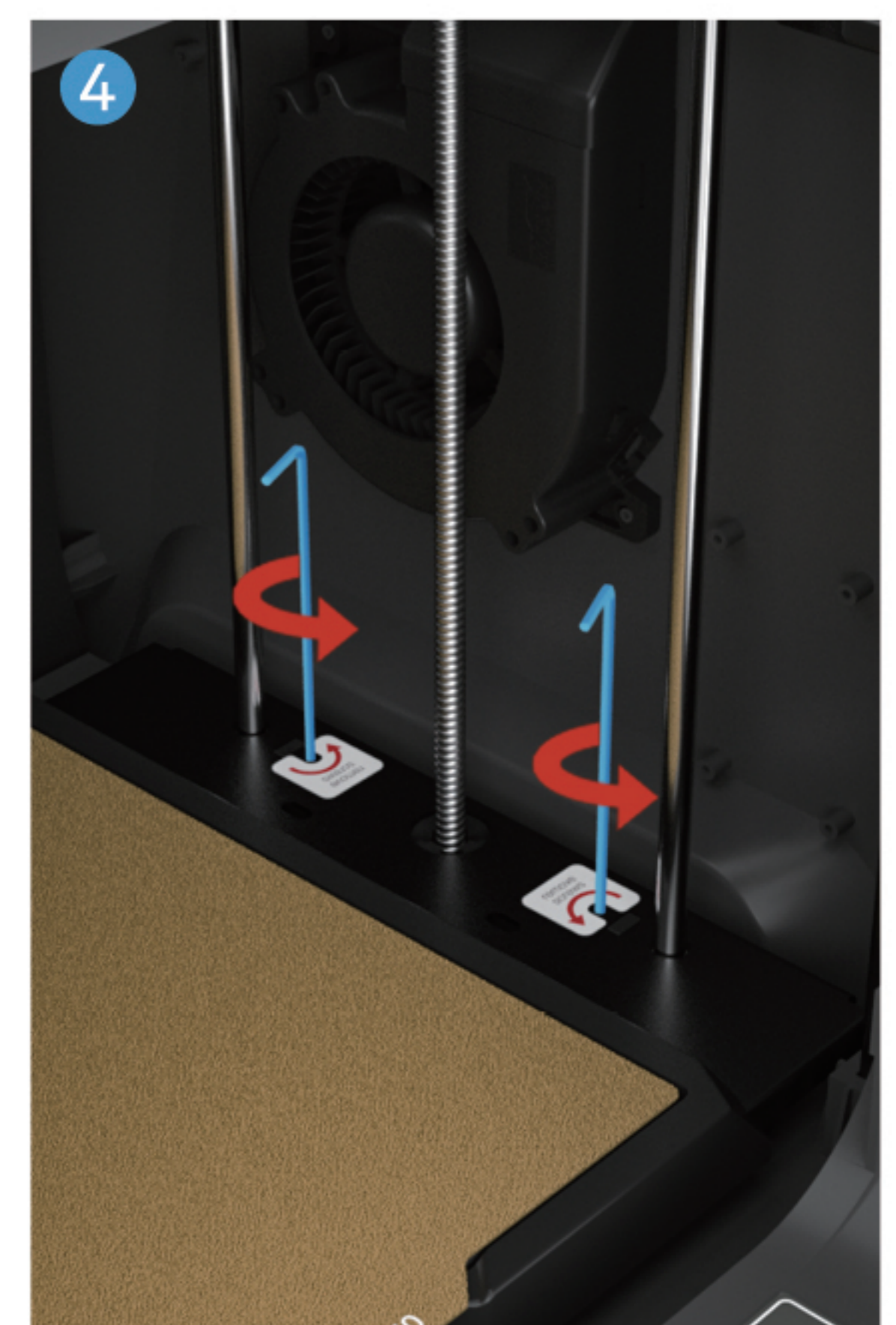
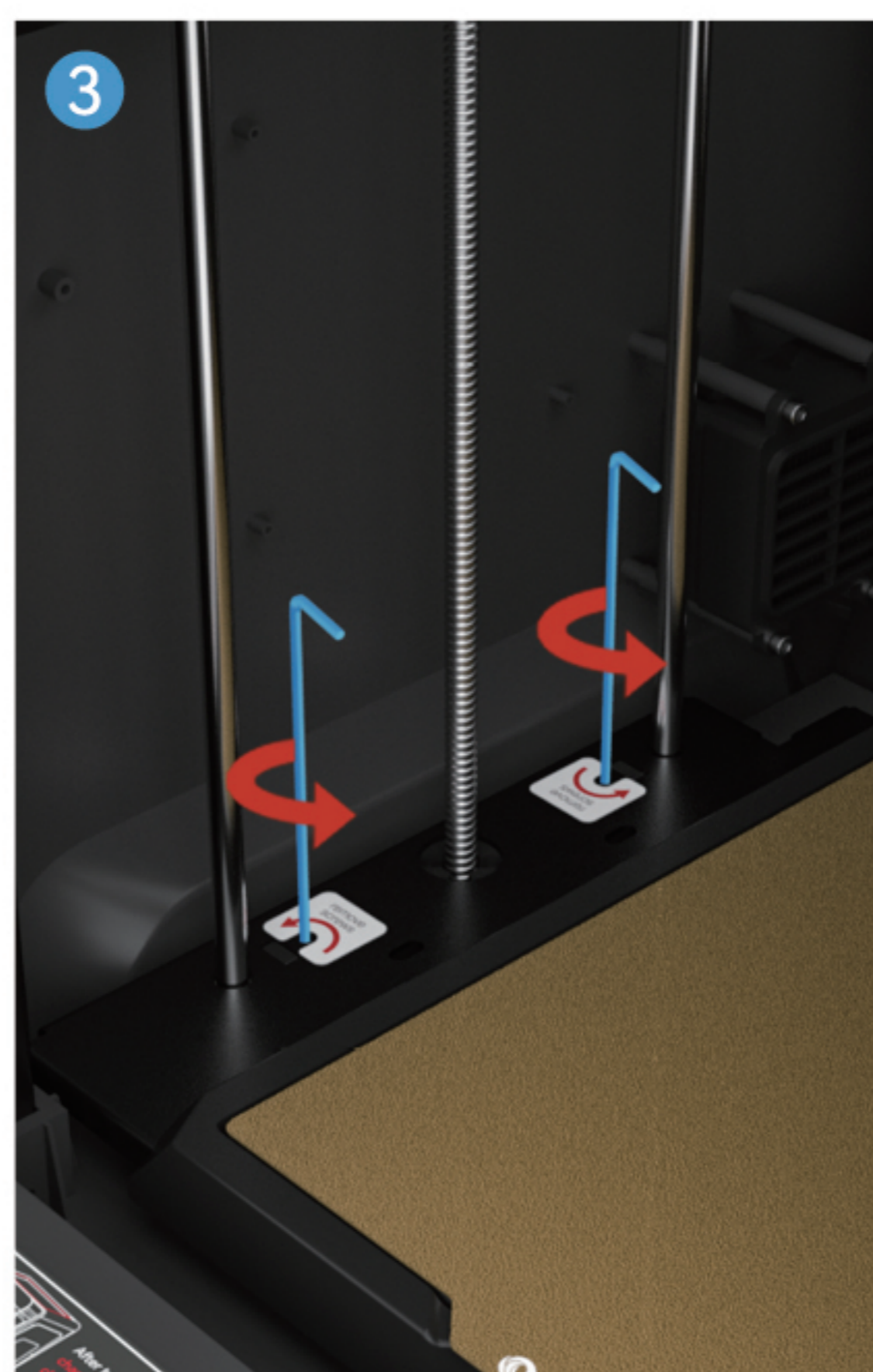


Unboxing

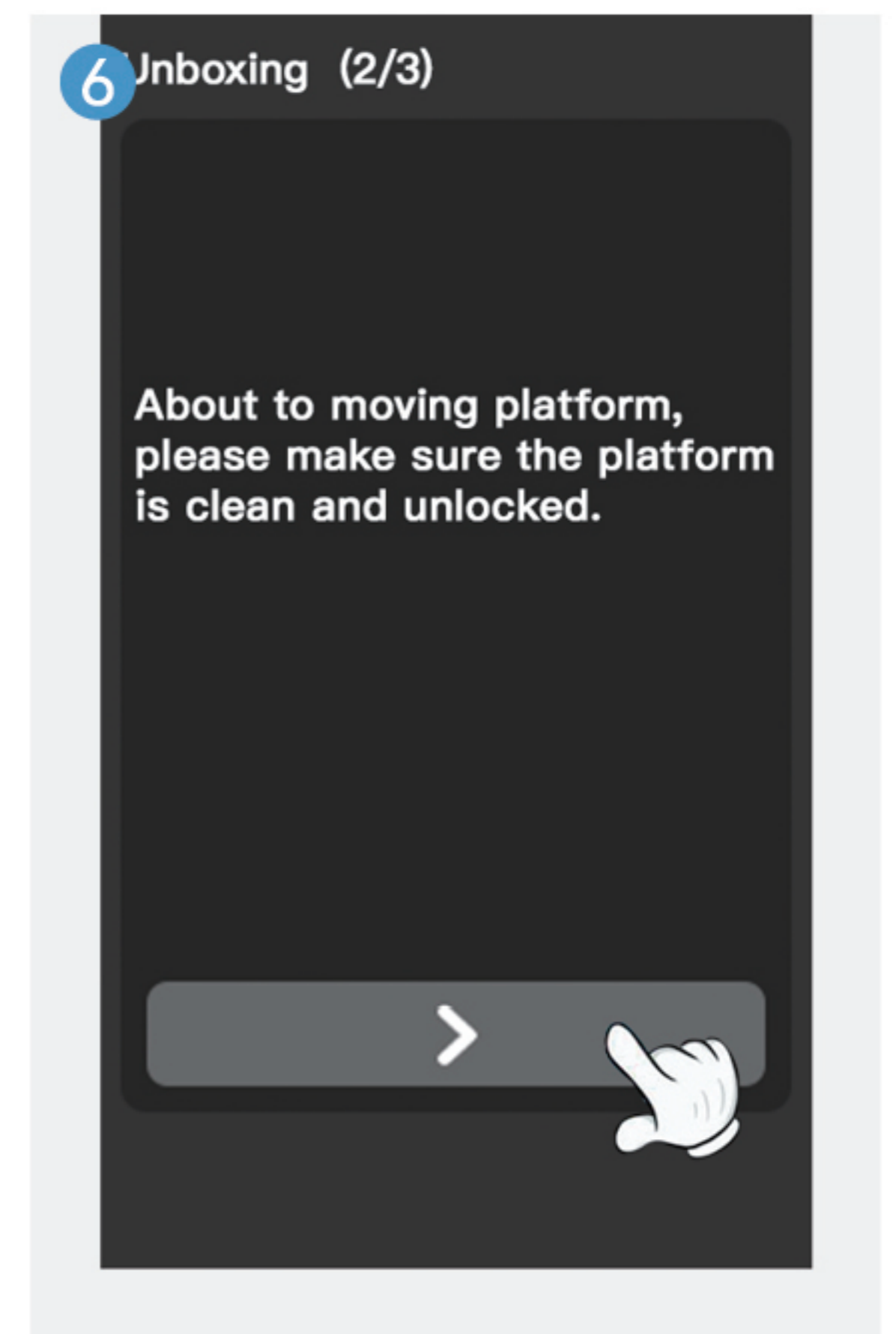
Follow the on-screen instructions to remove the ties fastening the extruder and X-axis, discard the cardboard, and proceed to the next step.



Follow the on-screen instructions to remove the four screws securing the printing platform in place.

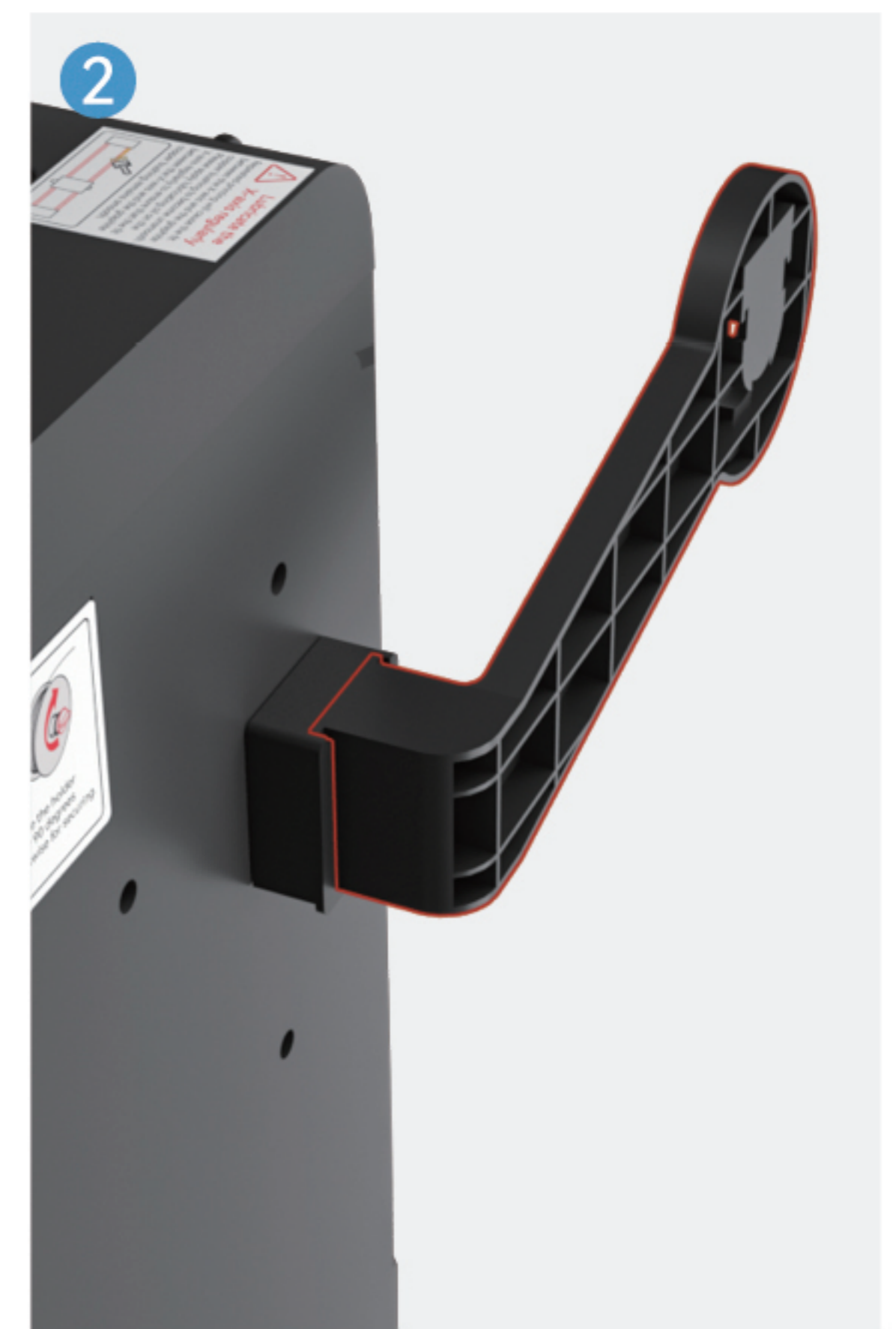
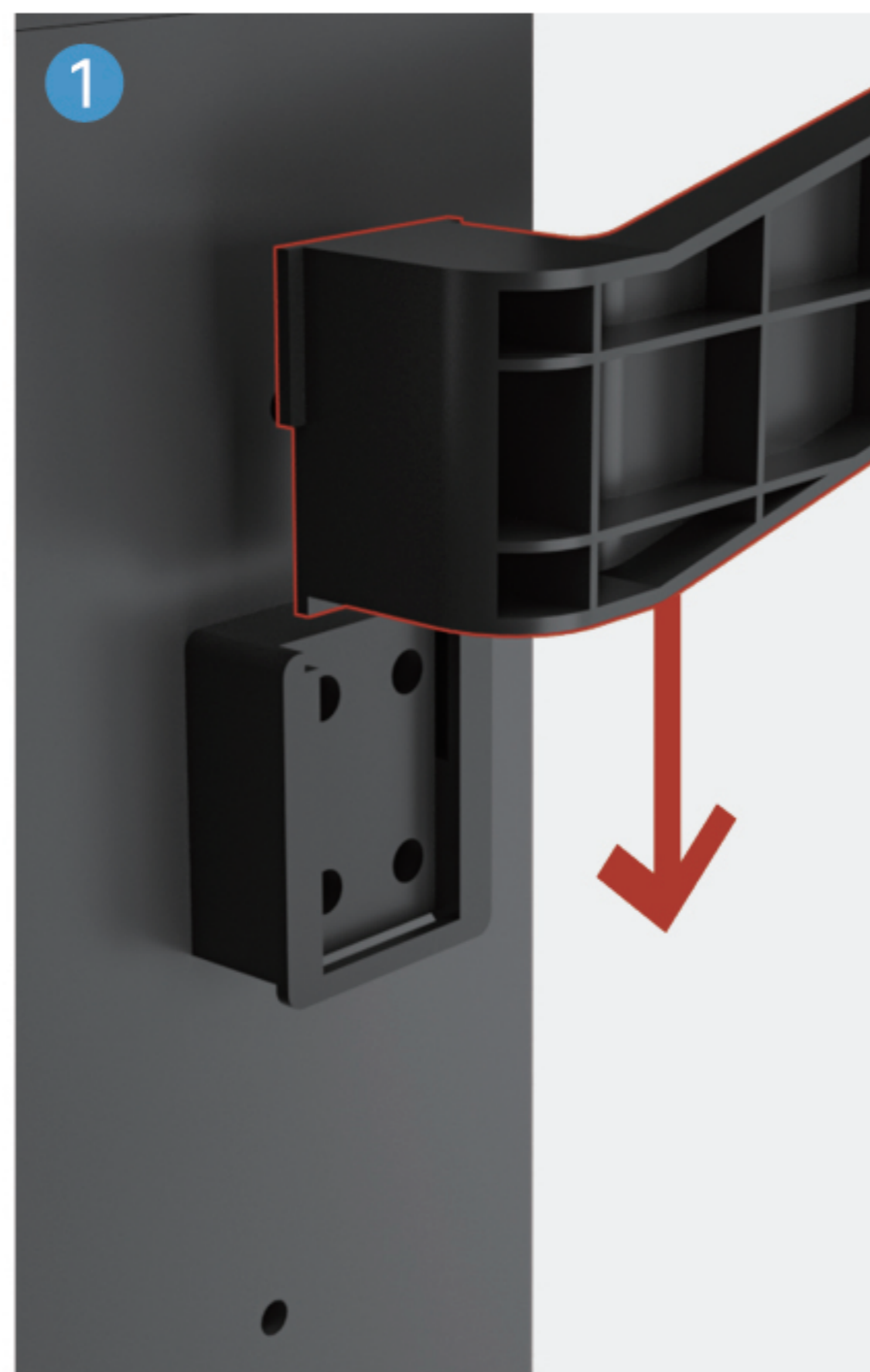


Click Next. Make sure the print bed is unlocked and clear of any debris before proceeding.



Load Filament

Take out the corresponding accessories from the top cover foam and install them according to the sticker instructions on the back of the machine. Install the filament extension bracket onto the extension bracket fixing block.

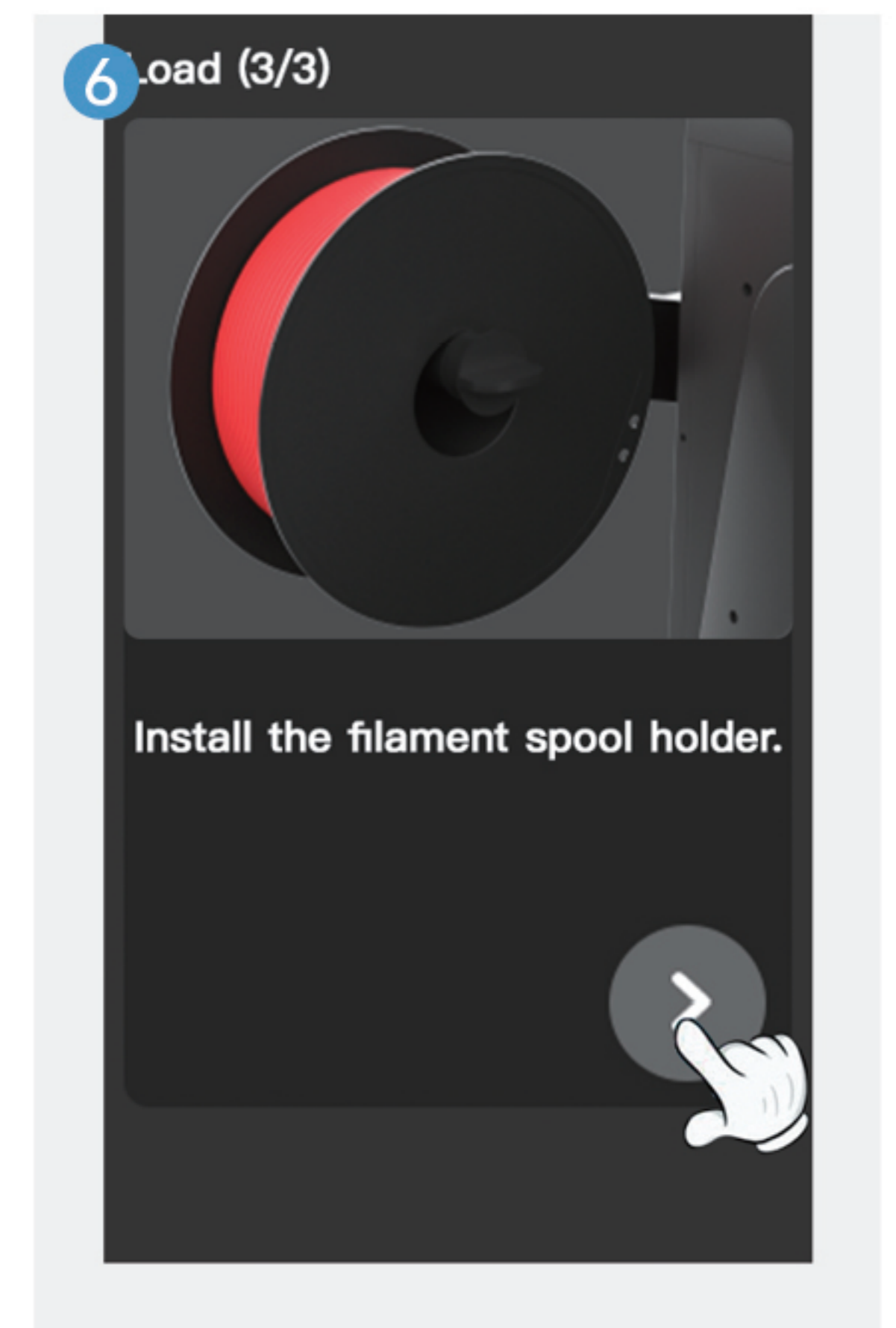


You can refer to the sticker tips on the back of the machine to install the filament holder on the filament extension bracket.



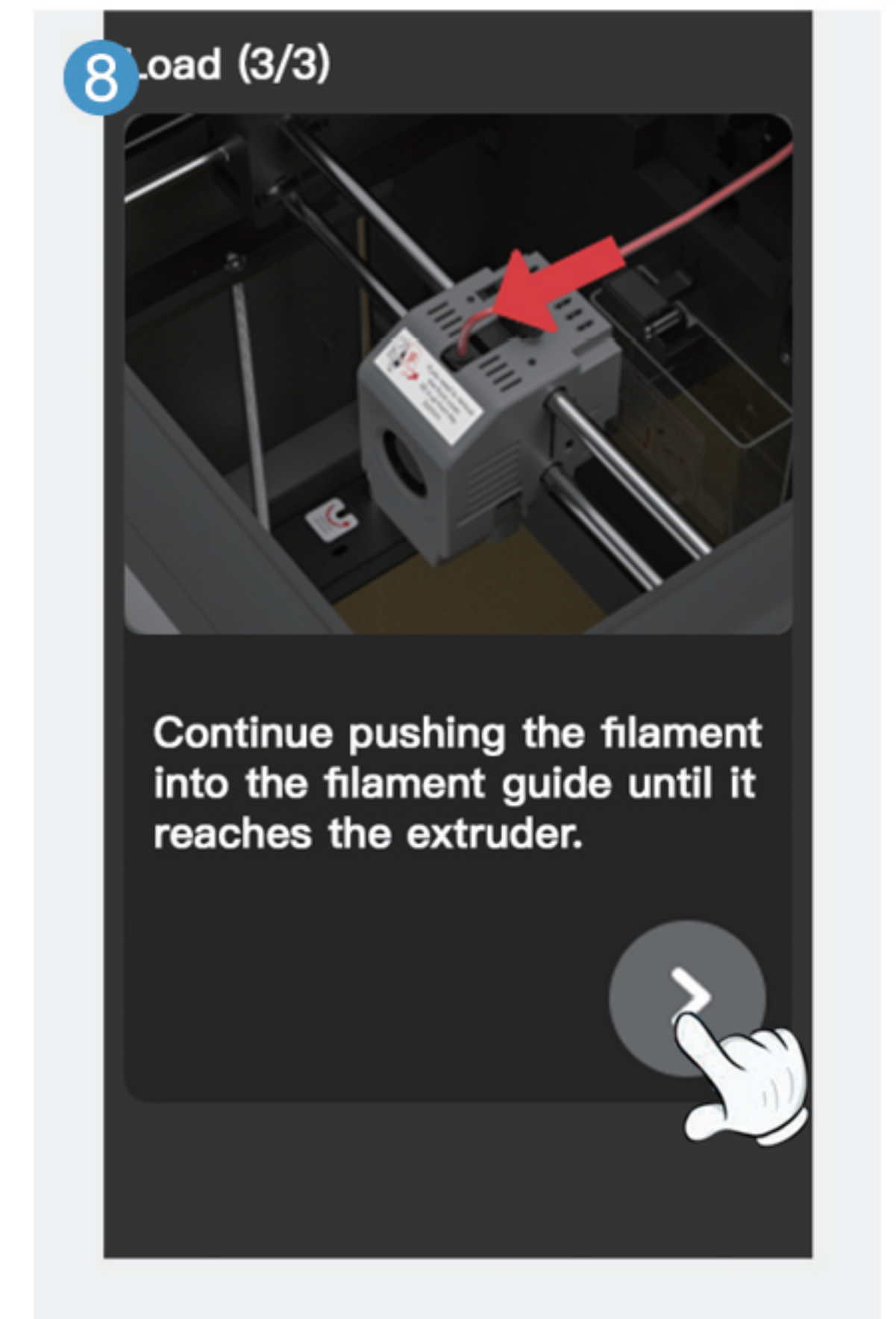
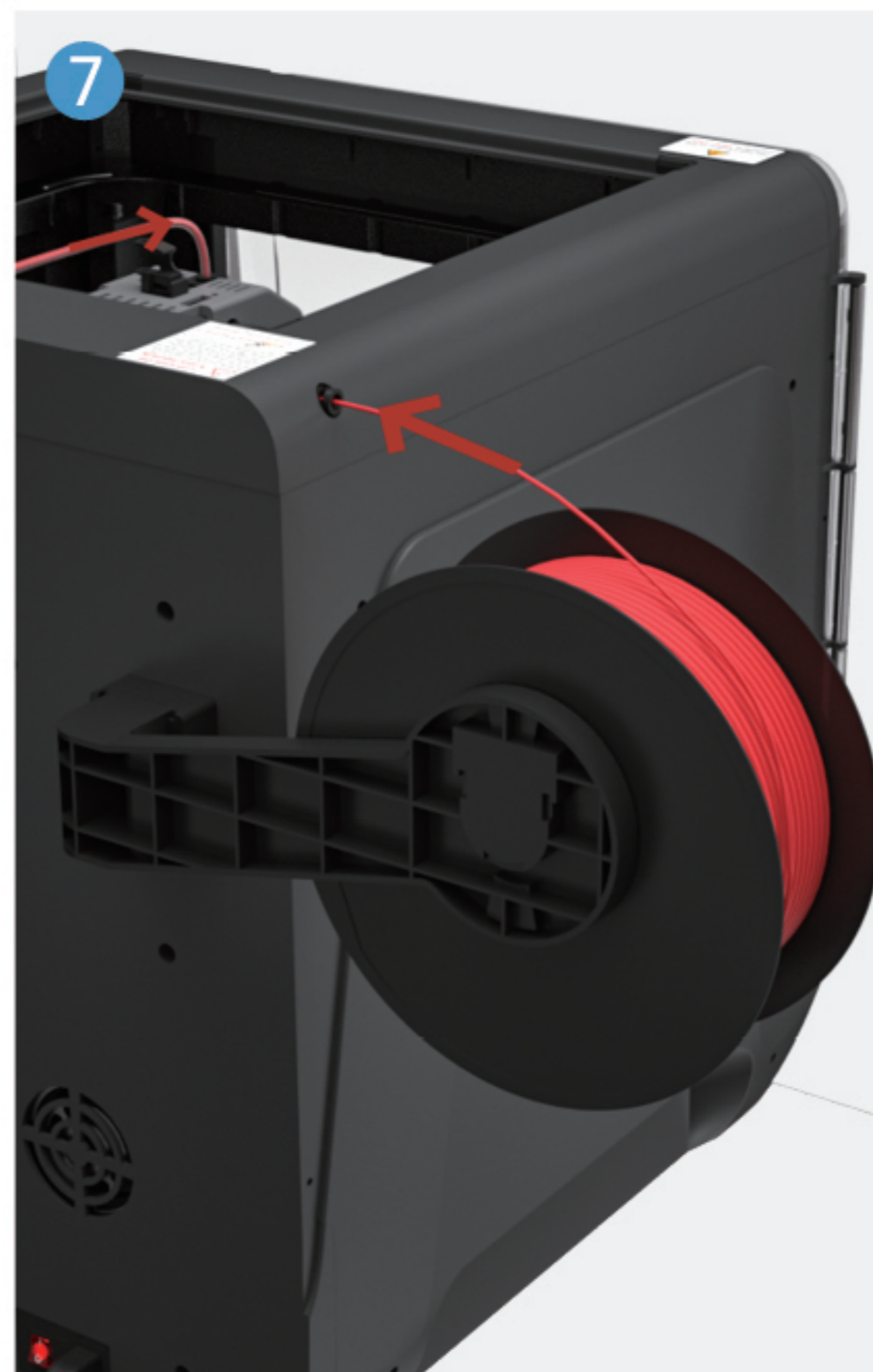
Place the filament on the filament holder and click Next.

Note: It is recommended to install the filament holder cover to prevent filament from falling off of it.

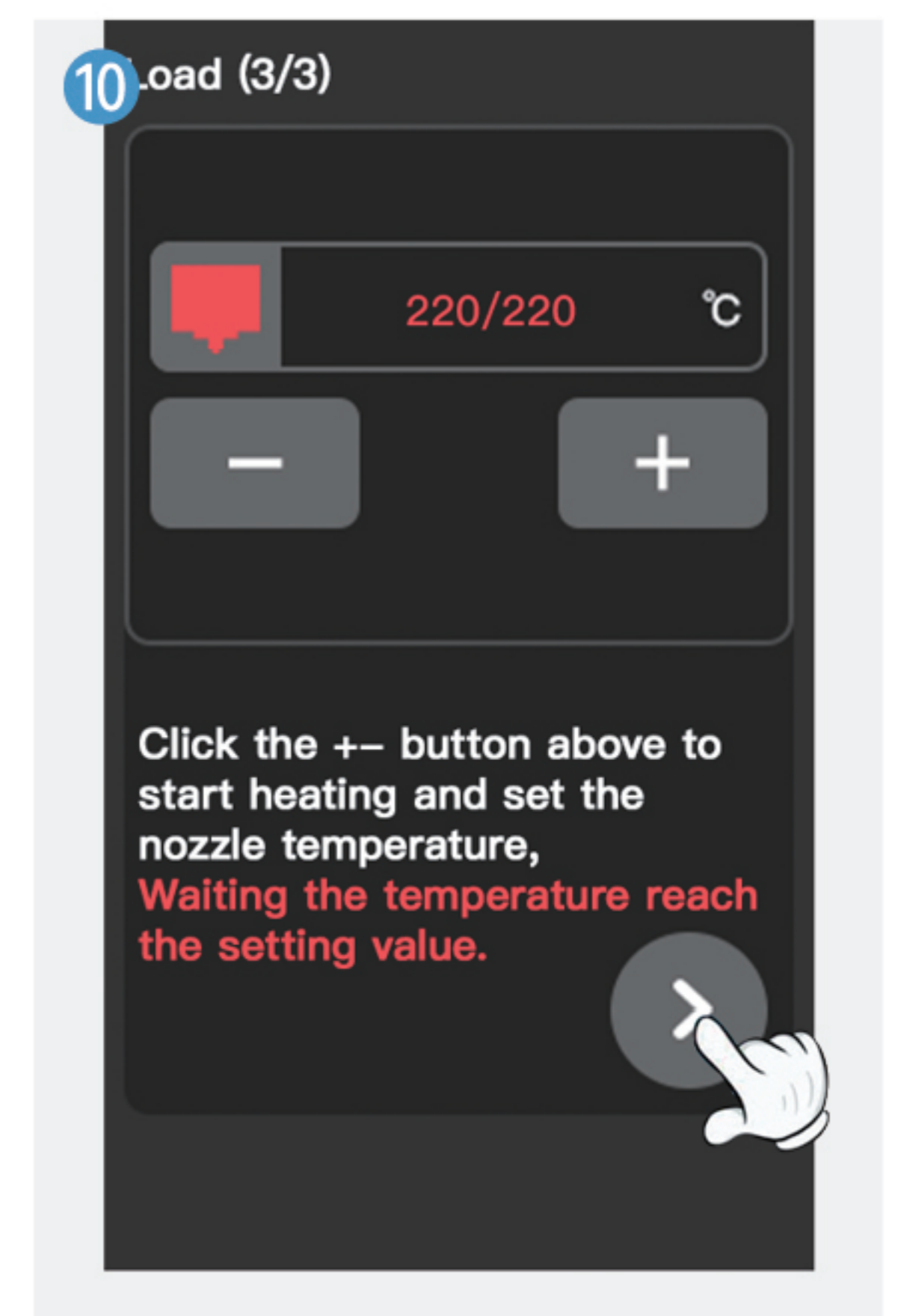
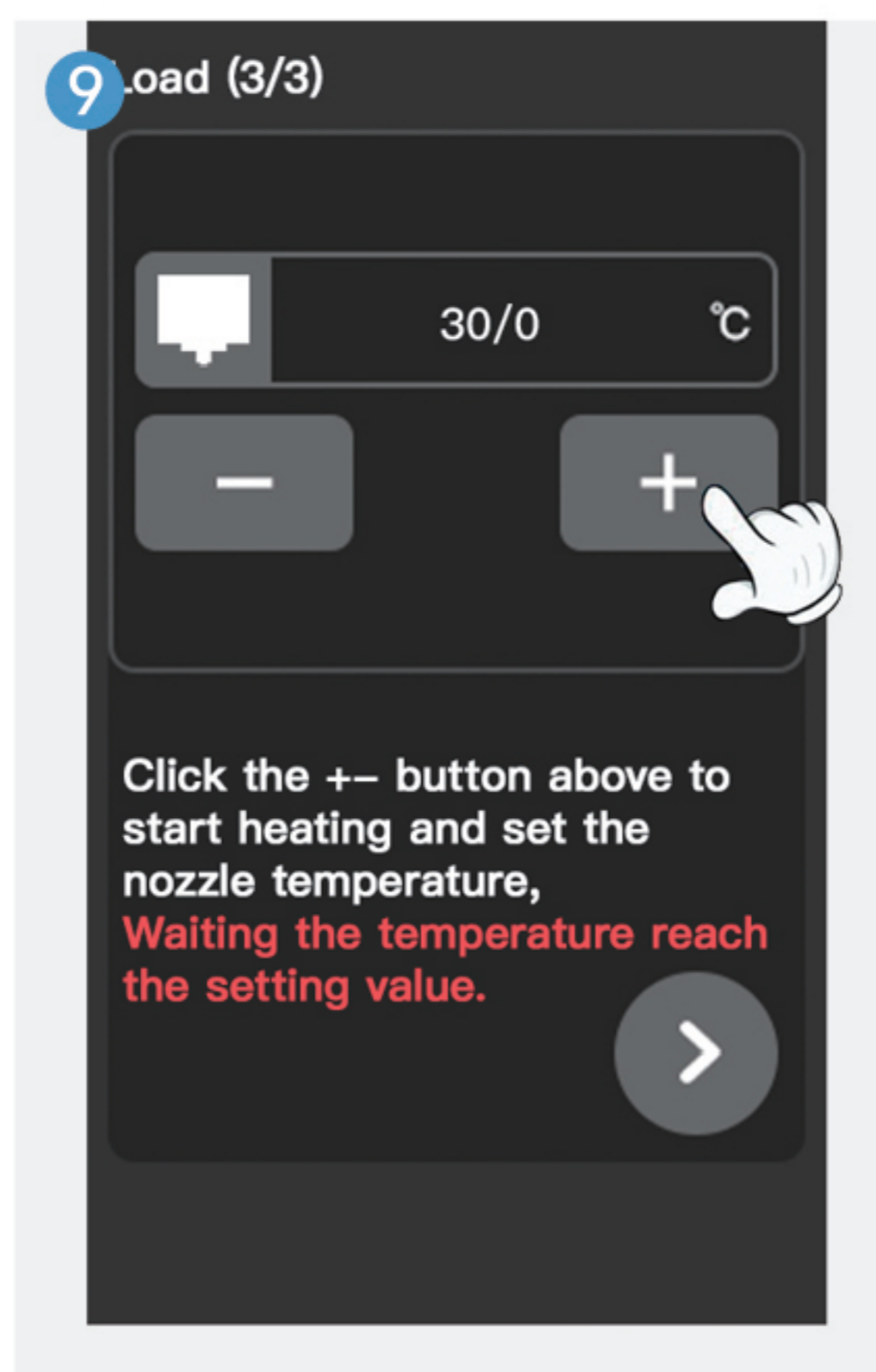


According to the on-screen prompts, insert the filament from the filament tube to the nozzle.

Make sure the filament enters the nozzle, then click Next.

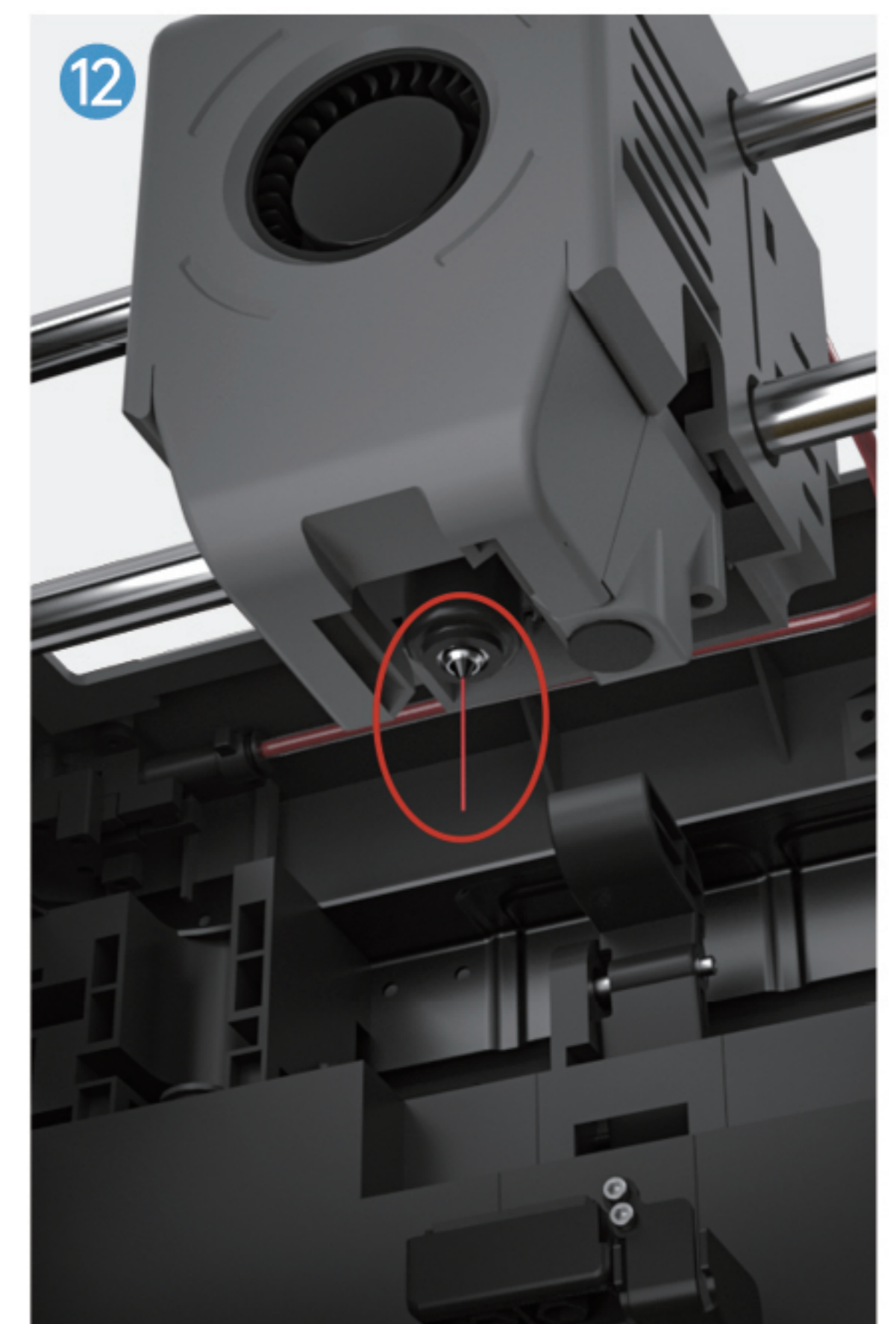


Press the “+”-”button to set the print temperature. Waiting the temperature to reach the preset value and then click Next.



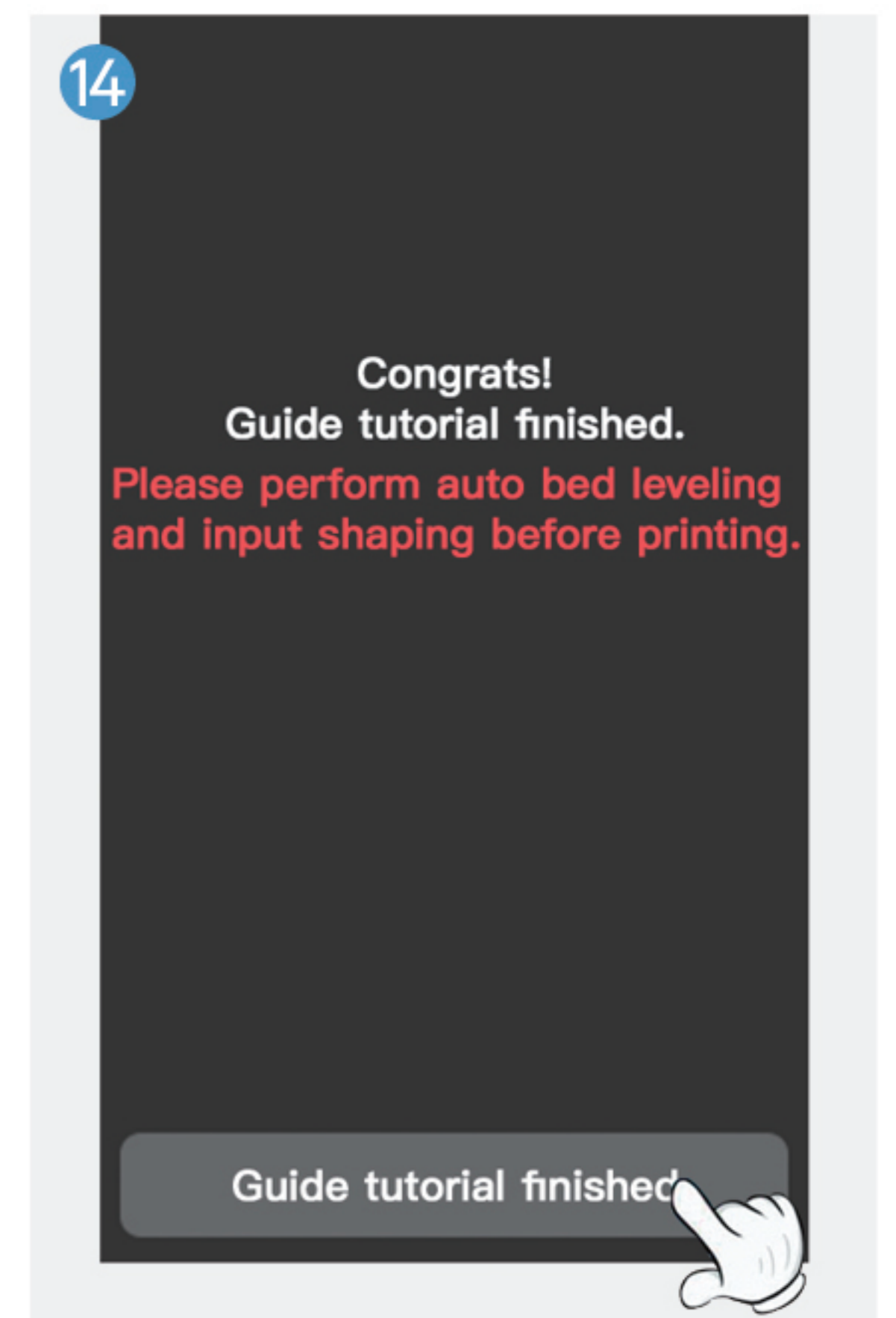
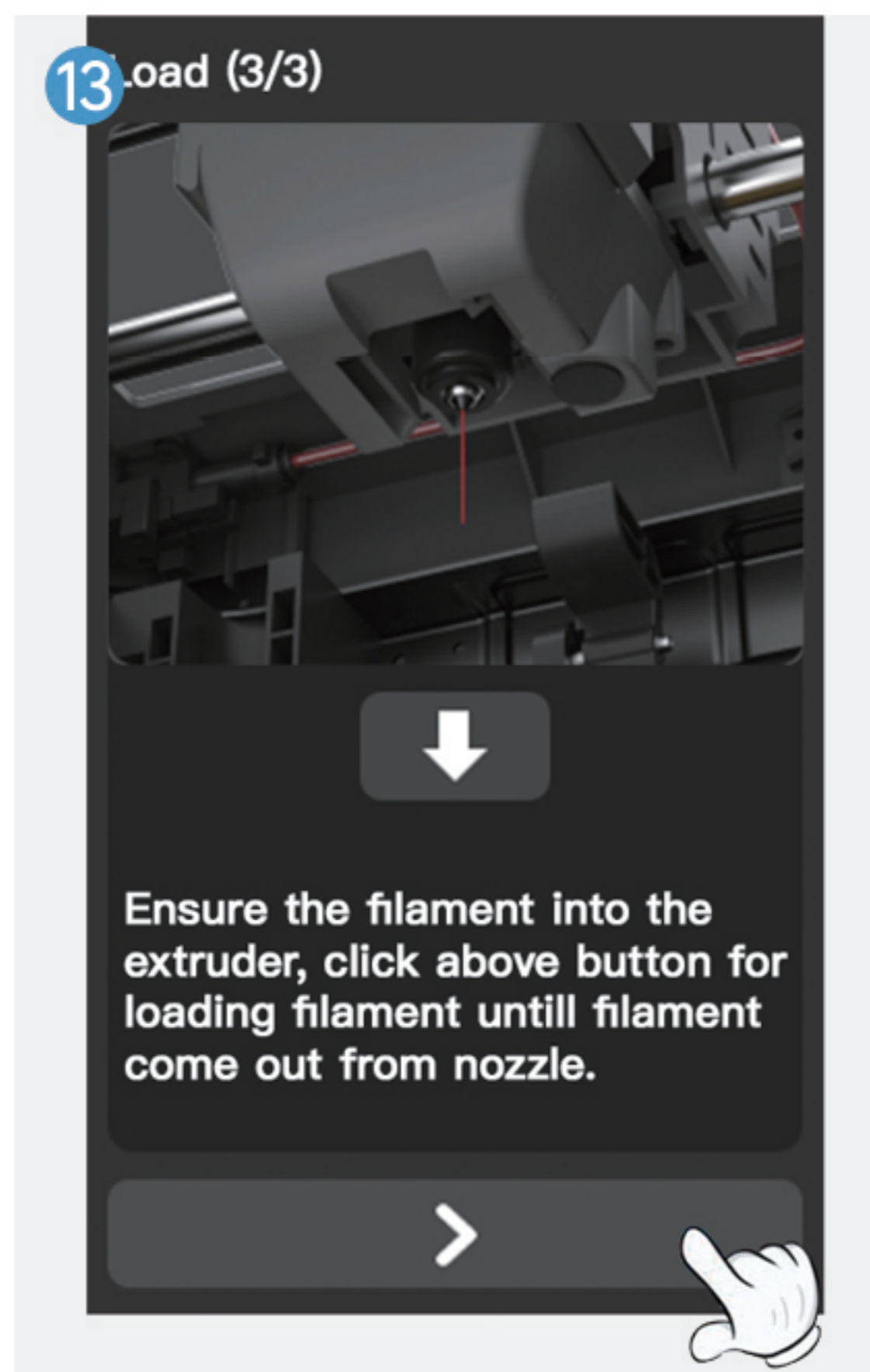
Click the downwards button and allow the filament to extrude from the nozzle.

Notice: If no filament are extruding on multiple attempts, please check that the filament is entering the print head correctly.



Click Next and finish the start guide.

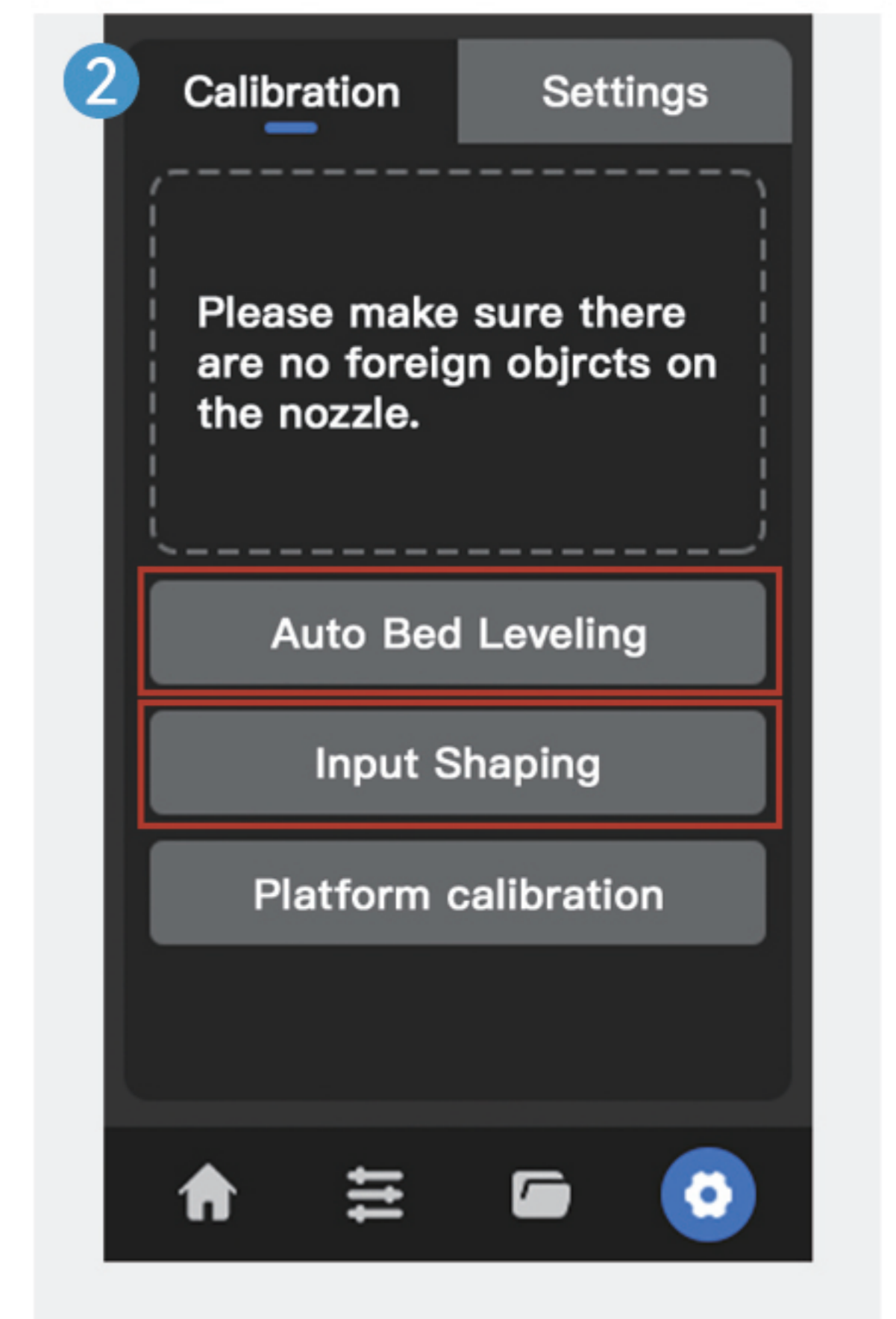
Note: Before printing for the first time, please perform Auto Bed Leveling and Input Shaping.



First Printing

Please perform automatic bed leveling and input shaping before the first print to make the printing better.

Note: Please do not use the platform calibration function before consulting with after-sales support or logging into the official Wiki to learn how to use it.

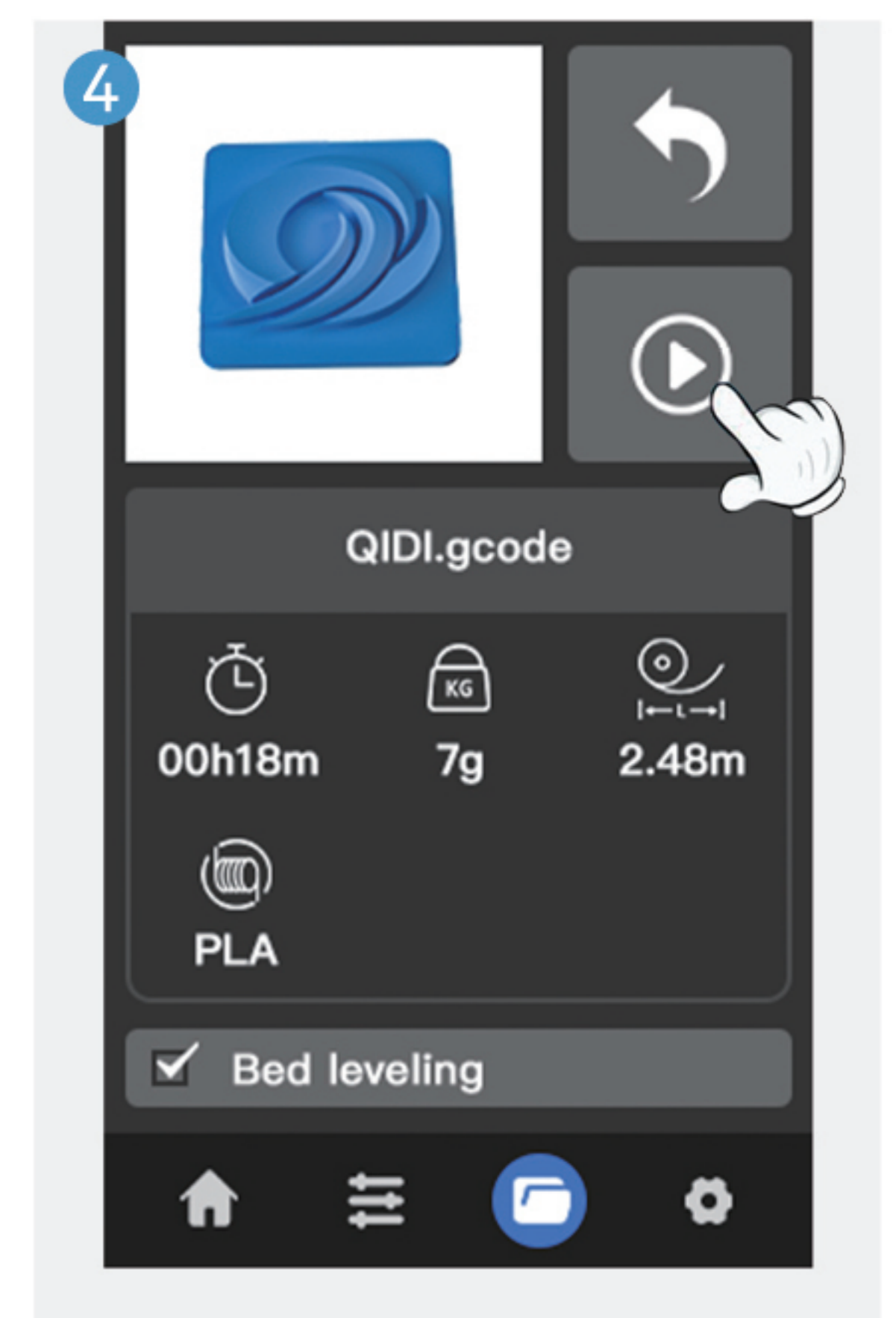


Click the button to start printing.

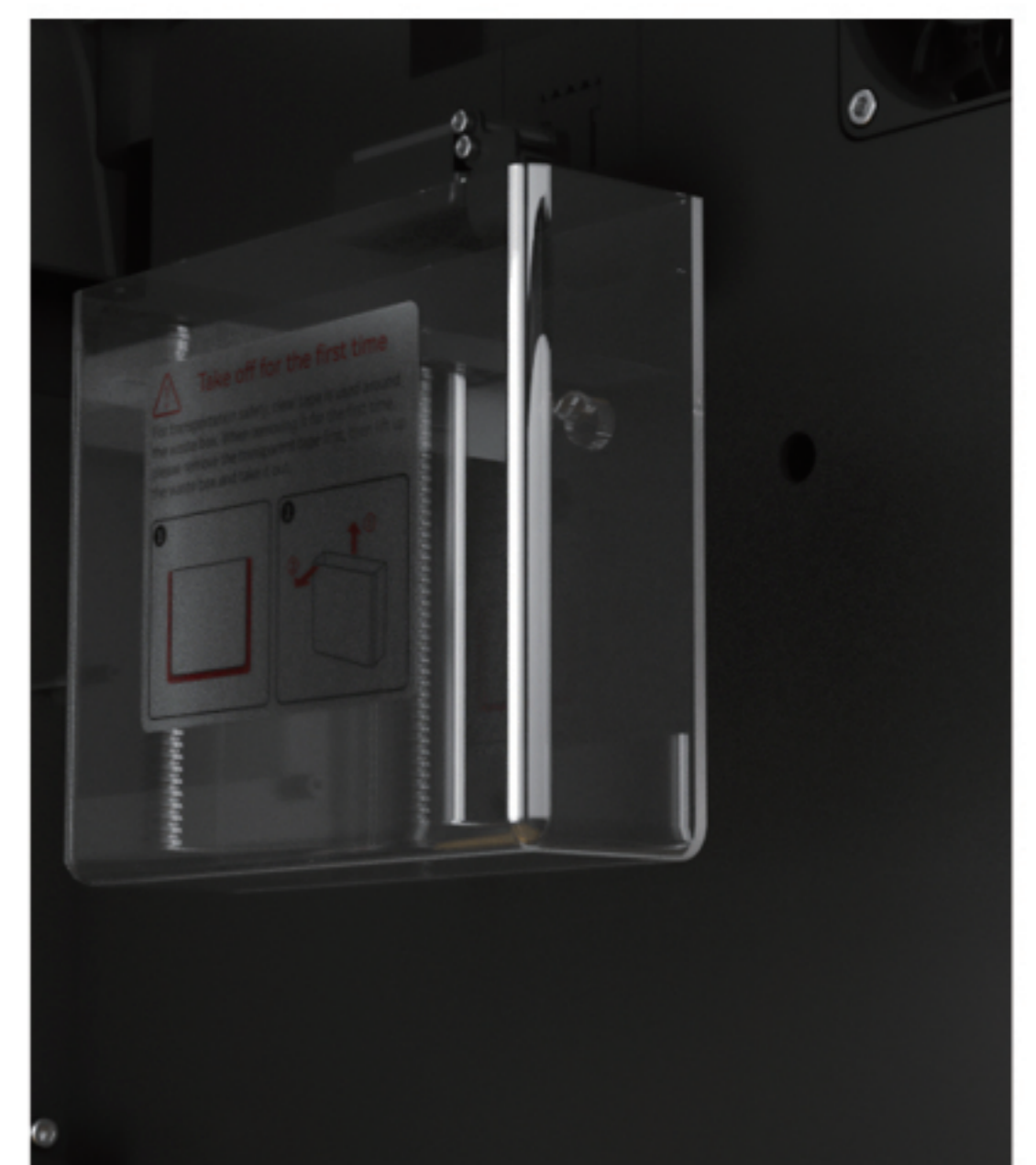
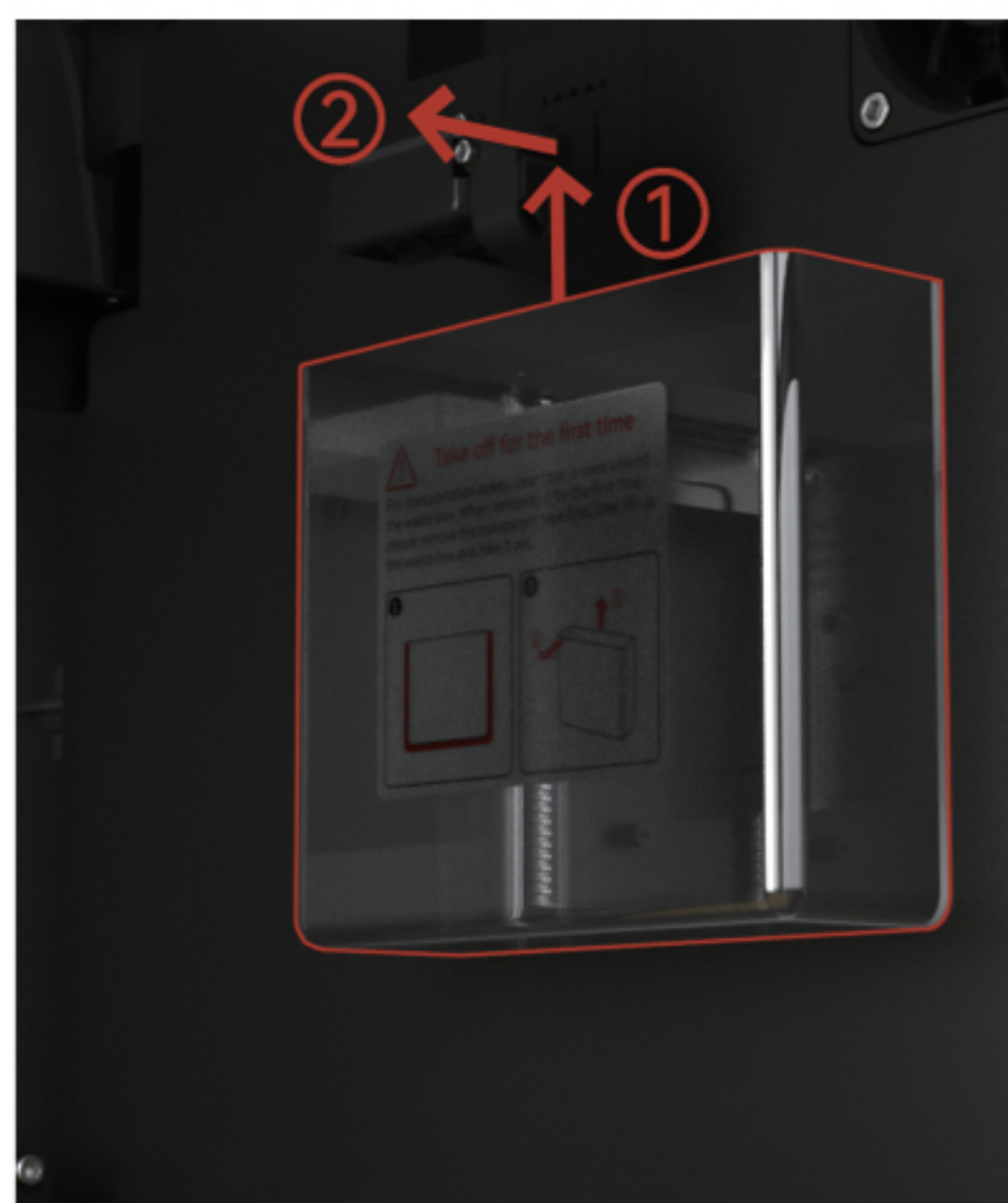
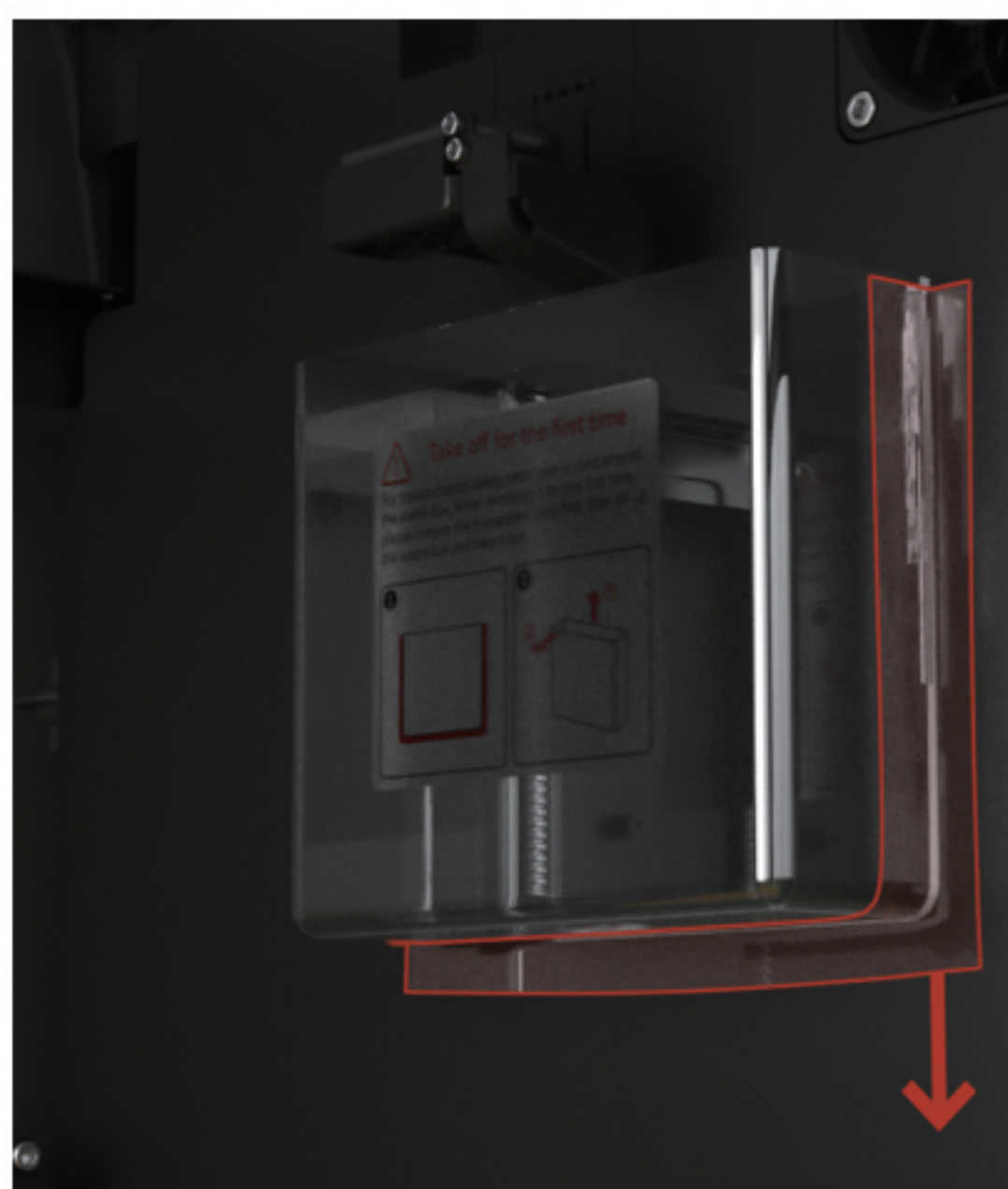
Note: Built-in models use PLA Rapido filament by default.

When printing filaments such as PLA/TPU, it is recommended to open the top cover and front door of the printer to prevent the machine chamber temperature from being too high, causing the filaments to soften and clog the nozzle.

After turning on chamber heating, please close the printer cover and front door to keep the chamber airtight.

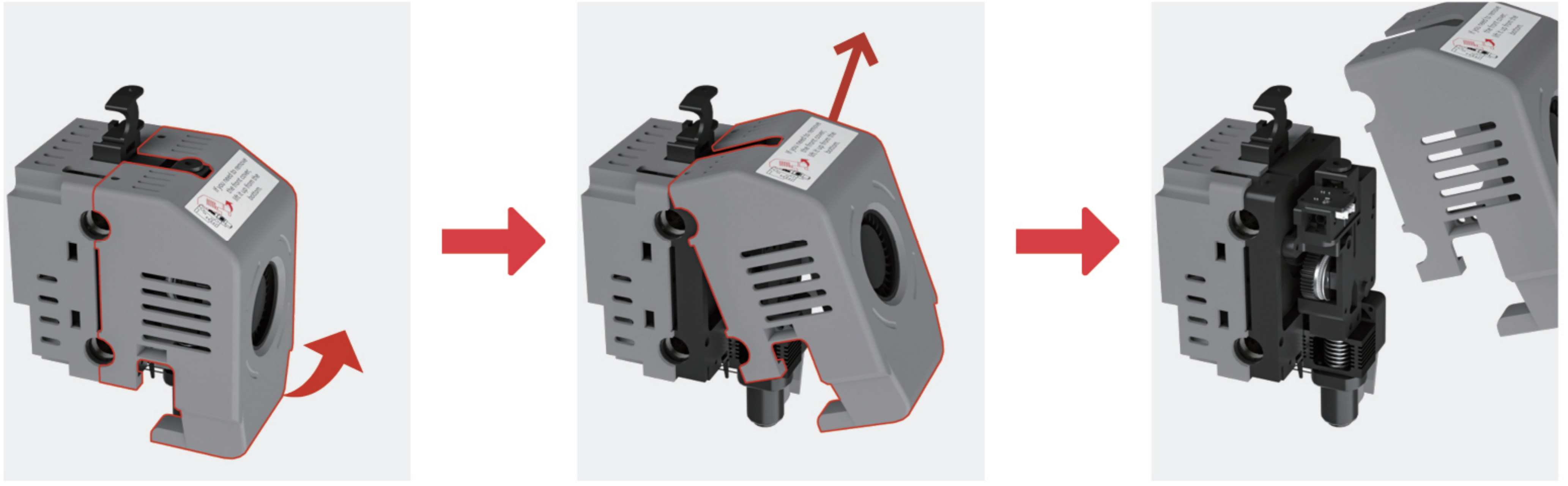


Removing The Scrap Box For The First Time



For transportation safety, transparent tape is used around the scrap box. When removing it for the first time, please remove the transparent tape first, then lift up the scrap box and take it out.

How To Remove The Print Head Front Cover



There is a buckle structure on the top of the front cover of the nozzle, please do not take it out directly. Please lift it from the bottom upward and remove the front cover of the nozzle.

Introduction To Machine UI

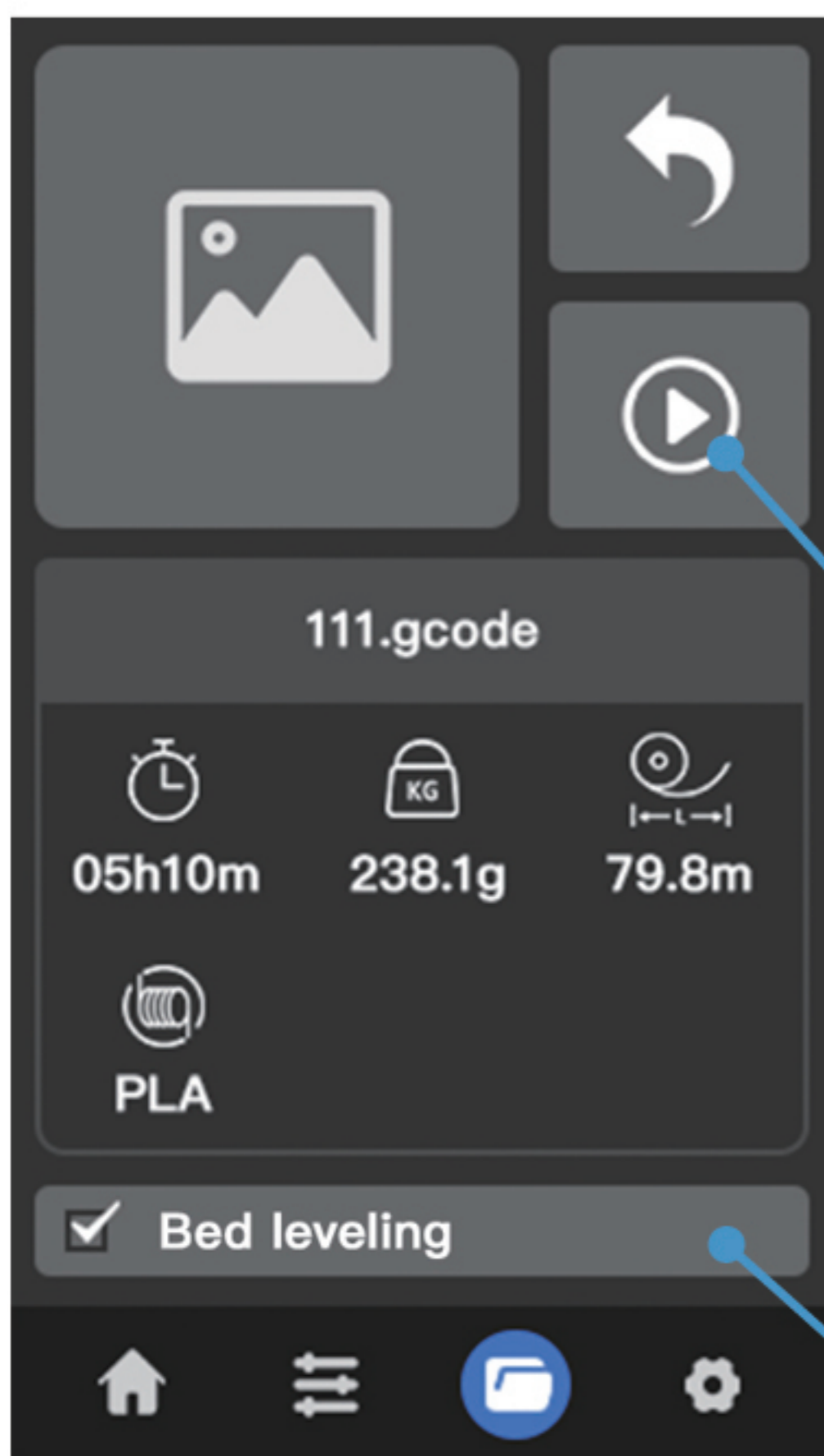
Note: There might be a delay in executing screen commands, and it's necessary to wait for the printer to finish the current action before proceeding. Avoid tapping the screen repeatedly.

Home Page

- Last Printed: Click to open the last printed file
- Extruder Temperature: Click to jump to the control menu
- Heating Bed Temperature: Click to jump to the control menu
- Chamber temperature: Click to jump to the control menu
- Navigation Bar-Home Page
- Navigation Bar-Control
- Navigation Bar-File List
- Show whether connected to the network
- Show whether USB flash drive is inserted
- Light: Click to turn ON/OFF the machine light
- Sound: Click to turn ON/OFF the machine prompt sound
- Emergency Stop: Click to end all processes and restart the firmware
- Navigation Bar-Settings

The screenshot shows a mobile application interface for a printer. At the top is a blue header with the text 'Home Page'. Below the header is a central display area showing a blue circular logo and the text 'QIDI.gcode'. Underneath the logo are three temperature readouts: '220 °C', '40 °C', and '32 °C'. To the right of these readouts are three toggle switches for 'Light', 'Sound', and 'Emergency Stop'. At the bottom is a navigation bar with four icons: a home icon, a control icon, a file list icon, and a settings icon. Blue lines connect text labels to specific UI elements.

Files List



Local Files: Click to display the print files in the machine
PS: You can open the "Machine IP + :10088" web page or connect to the printer through QIDISlicer for management

Start Printing

Bed Leveling: Before printing, the machine automatically adjusts to keep the printing platform and the nozzle relatively level
PS: Automatic leveling is integrated, it is recommended to turn it on



Print Menu

File Preview

File Name

Printed Time

Extruder Temperature:
Click to set the nozzle temperature preset value

Hot Bed Temperature:
Click to set the preset hot bed temperature value

Chamber Temperature:
Click to set the chamber temperature preset value

Printing Speed:
Click to set the printing speed

Extruder Flow Rate:
Click to set the filament flow rate

Z-Axis Compensation:
Click to set the Z-axis compensation value

Back to previous

Click to pause/resume printing

Click to stop printing

Print Progress

Remaining printing time
(Approximate estimated value by firmware)

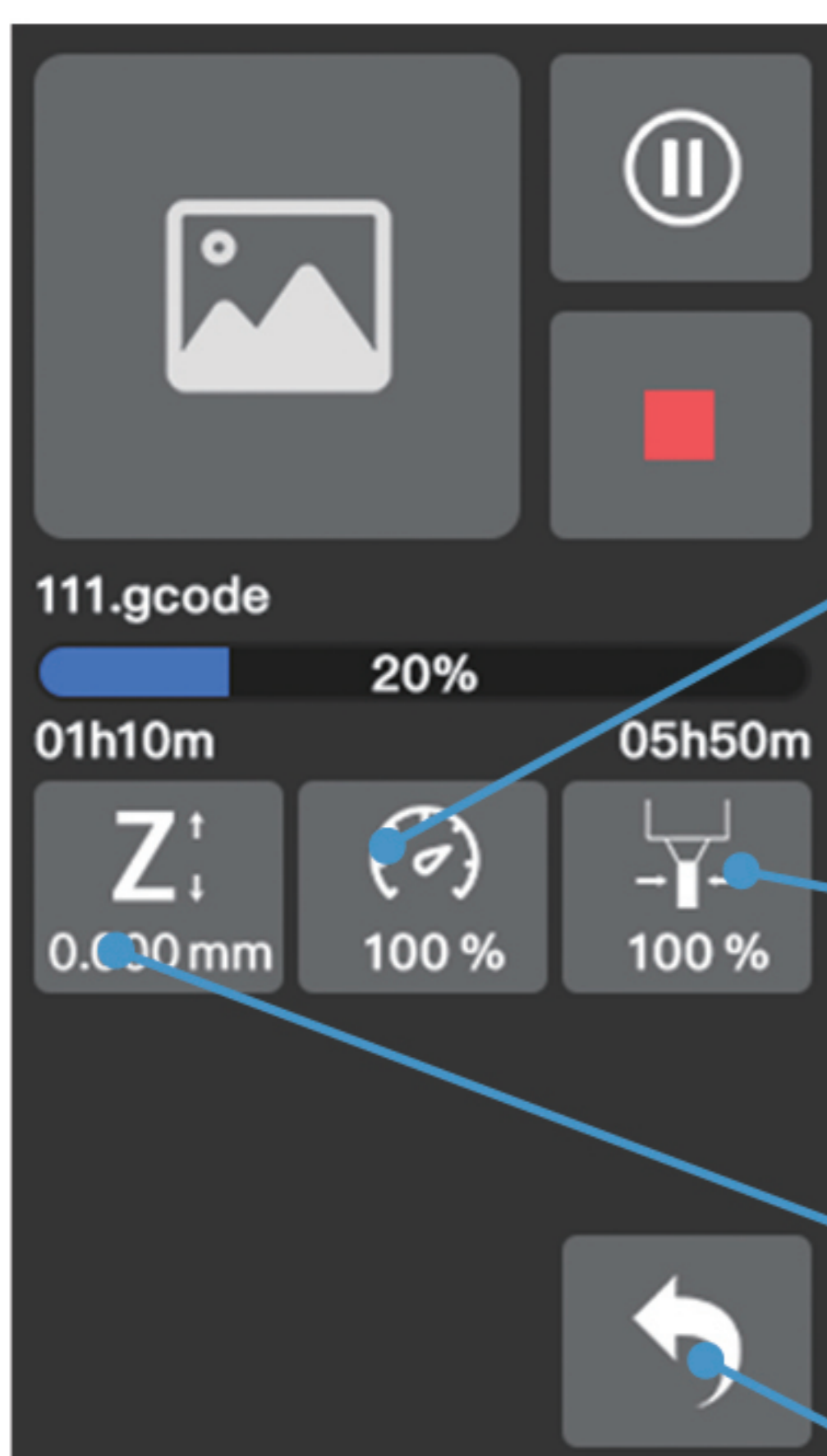
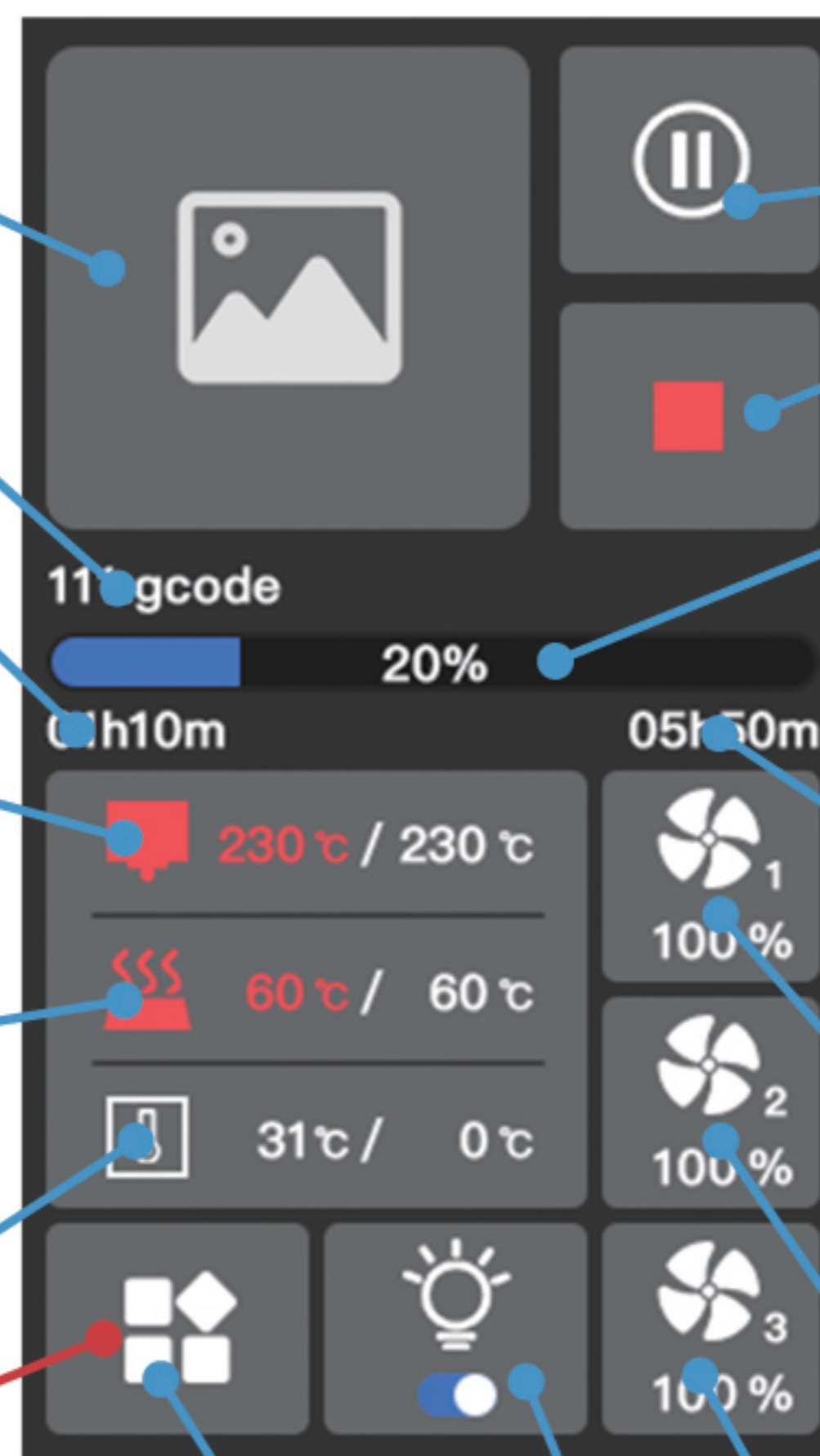
Cooling Fan: Click to set fan intensity

Auxiliary Cooling Fan:
Click to set fan intensity

Chamber Circulation Fan:
Click to set fan intensity

Light: Click to turn ON/OFF the chamber light

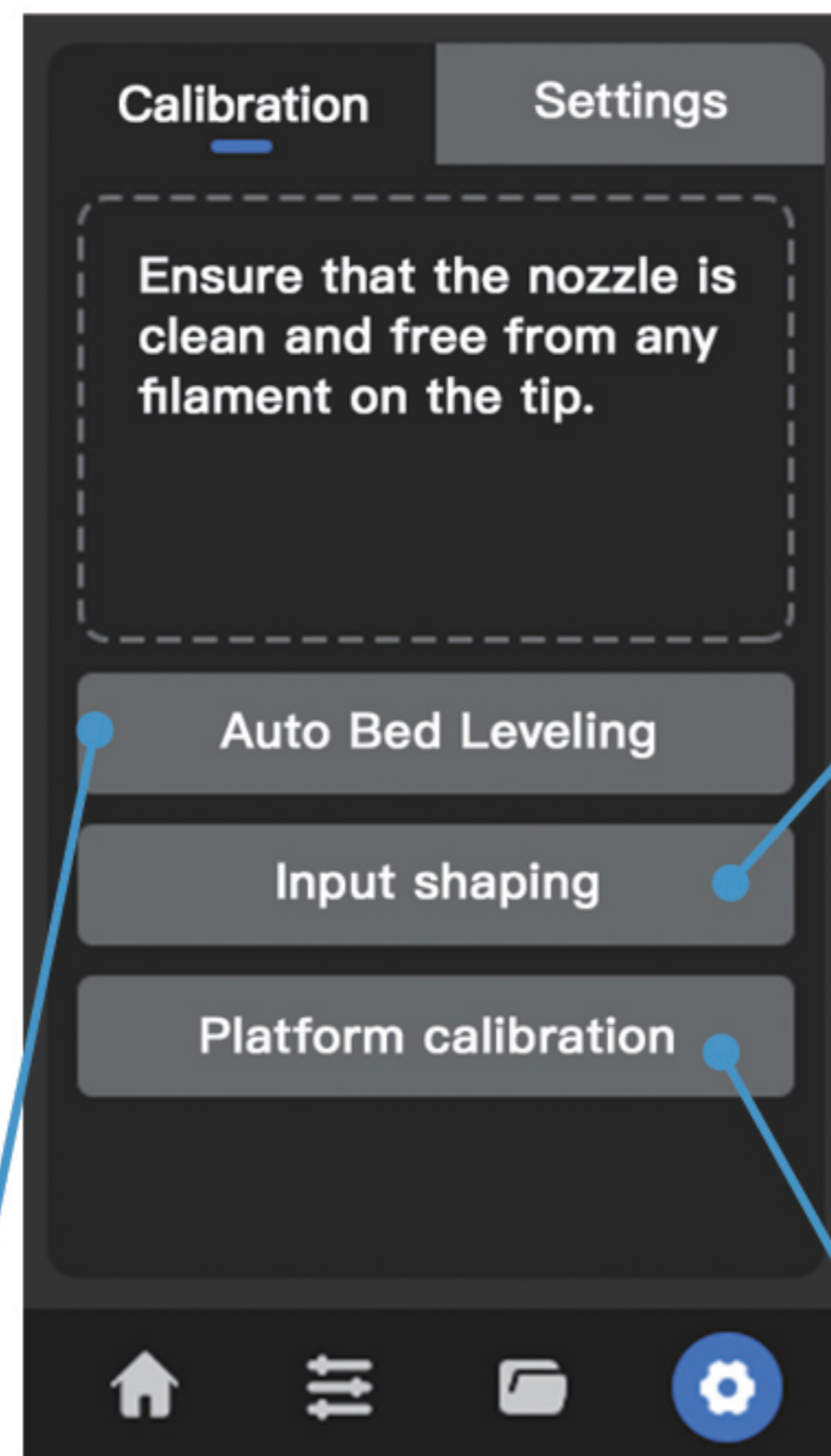
More: Click to jump to more settings menu



Settings-Calibration Settings

Auto Bed Leveling: The machine automatically picks up points on the platform and sets the compensation value to keep the printing platform and the nozzle relatively level

PS: It has been integrated into the hot bed leveling in the file details interface and is enabled when the hot bed leveling is not turned on



Input Shaping: The machine automatically adjusts and measures to reduce vibration and jitter when printing and improve stability
PS: After belt adjustment and other similar operations, input shaper needs to be re-compensated

Platform Calibration: Manually adjust the nut under the printing platform to keep the printing platform and the nozzle relatively level
PS: When the printing platform is too tilted, causing automatic leveling compensation to be invalid, the platform needs to be recalibrated

Control-Manual Movement

Click to set the distance of a single click

Click to move the extruder (Y-axis direction)
PS: After unlocking the motor, it needs to be reset to home position before it can be used normally

Click to move the extruder (X-axis direction)
PS: After unlocking the motor, it needs to be reset to home position before it can be used normally

Zeroing the coordinates of the extruder and printing platform

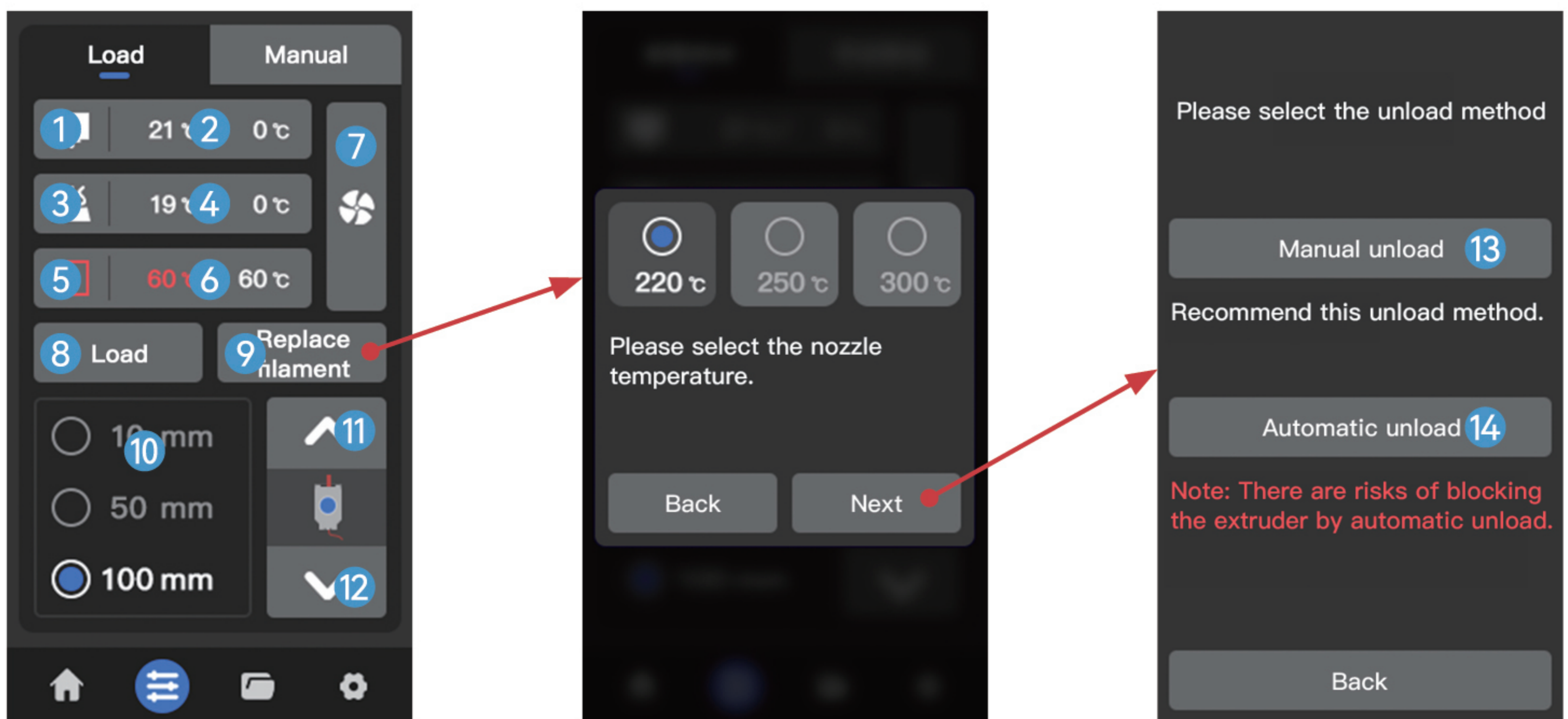


Display the current coordinates of the extruder and printing platform
PS: After unlocking the motor, it needs to be reset to home position before it can be used normally

Unlock The Motor: After clicking, the motors of the extruder and printing platform are unlocked and can be moved directly by hand
PS: Resetting to zero will lock the motor and no longer supports direct movement by hand

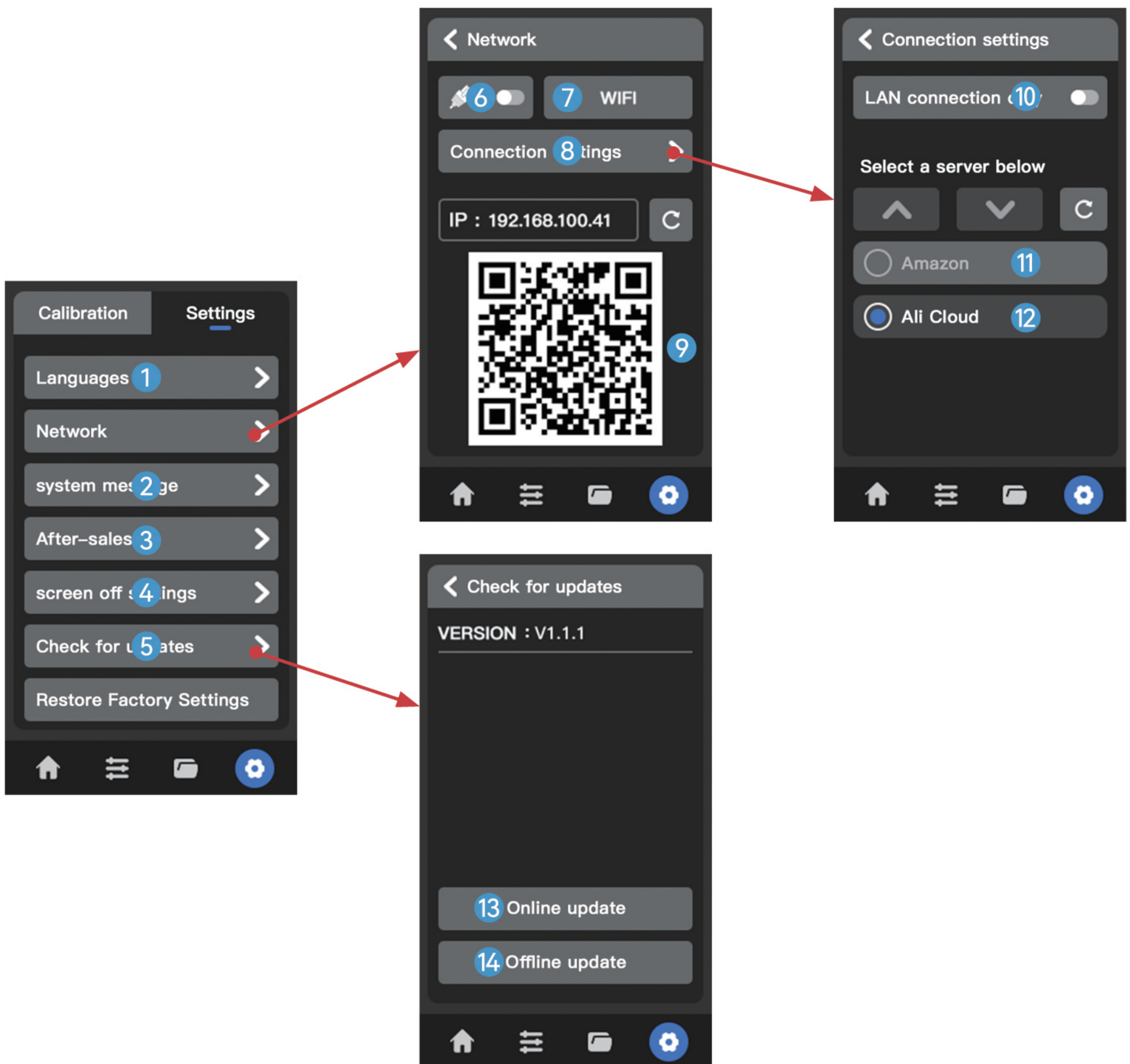
Click to move the printing platform (Z-axis direction)
PS: After unlocking the motor, it needs to be reset to home position before it can be used normally

Control-Load Filament



1. Extruder Temperature: Click to turn ON/OFF the extruder heater.
 2. Extruder Temperature Preset Value: Click to set the preset value.
(the left side show the current temperature, the right side show the preset value)
 3. Hot Bed Temperature: Click to turn ON/OFF the hot bed.
 4. Hot Bed Temperature Preset Value: Click to set the preset value.
(the left side show the current temperature, the right side show the preset value)
 5. Chamber Temperature: Click to turn ON/OFF the chamber heater.
 6. Chamber Temperature Preset Value: Click to set the preset value.
(the left side show the current temperature, the right side show the preset value)
 7. Fan: Click to jump to the fan setting menu.
 8. Load: Click to enter the filament loading process.
 9. Replace Filament: Click to enter the process of replacing filament.
 10. Click to set the extrusion/retraction distance of a single filament.
 11. Click to control the filament to retract.
- PS: Before use, the extruder needs to be heated to the required print temperature of the filament.
12. Click to control the filament to extrude downwards.
- PS: Before use, the extruder needs to be heated to the required print temperature of the filament.
13. Manual Unload: Cut off the filament and wait for the machine to automatically squeeze out the remaining filament in the extruder.
 14. Automatic Unload: Wait for the machine to automatically extrude the filament downward for a period, and then pull out the filament.
- PS: This method has a certain probability of extruder clogging.

Settings-General Settings



1. Language: Set UI language.
2. System Message: export system logs, system error restart, etc.
3. After-Sales: description of after-sales.
4. Screen Off Settings: Setting up printer sleep time.
5. Check For Updates: update firmware.
6. Ethernet Cable Connection: Turn on when connecting the printer with an Ethernet cable.
7. WIFI : search for WIFI and connect.
8. Connection Settings: Set up server, set up only LAN connection.
9. QR Code: Cooperate with QIDI Link APP to connect to the printer on your mobile phone.
10. LAN Connection Only: Printer information is uploaded to the server via LAN only, not through the Internet. Once turned on, printer details are transmitted solely via LAN.
11. Amazon: It is recommended to use this server when the location is not in China.
12. Ali Cloud: It is recommended to use this server when the location is in China.
13. Online Update: update firmware through the network PS: Internet connection is required.
14. Offline Update: Firmware update through the update file in the USB flash drive.

Filament Guide For Beginners

QIDI Filament 1		ABS Rapido	PLA Rapido	PETG-Tough	UltraPA
Preparation	Necessity Of Drying	✗	✗	✗	✓
	How To Dry	/	/	/	60°C 4-6h
	Nozzle Material	Bimetal Nozzle	Bimetal Nozzle	Bimetal Nozzle	Bimetal Nozzle
	Nozzle Size	All Size	All Size	All Size	0.4/0.6/0.8 mm
	Dry Box	✗	✗	✗	Need to maintain humidity ≤ 15%
	Print With Enclosure	✓	✗	✗	✓
Slicer Parameter	Print Speed	260 mm/s	260 mm/s	180 mm/s	80 mm/s
	Chamber Temperature	50 °C	/	/	/
	Nozzle Temperature	250-280 °C	200-230 °C	240-270 °C	280-300 °C
	Build Plate Temperature	100 °C	60 °C	80 °C	80 °C
	Cooling Fan	30%	100%	60%	20%
Post-processing	Annealing Needs	80-90 °C 6-8 hours	✗	✗	70-90°C 6-8 hours

QIDI Filament 2		ABS-GF25	PA12-CF	PAHT-CF	PET-CF
Preparation	Necessity Of Drying	✓	✓	✓	✓
	How To Dry	70°C 4-6h	100-120°C 4-6h	100-120°C 4-6h	100°C 4-6h
	Nozzle Material	Bimetal Nozzle	Bimetal Nozzle	Bimetal Nozzle	Bimetal Nozzle
	Nozzle Size	0.4/0.6/0.8 mm	0.4/0.6/0.8 mm	0.4/0.6/0.8 mm	0.4/0.6/0.8 mm
	Dry Box	Need to maintain humidity ≤ 15%	Need to maintain humidity ≤ 15%	Need to maintain humidity ≤ 15%	Need to maintain humidity ≤ 15%
	Print With Enclosure	✓	✓	✓	✓
Slicer Parameter	Print Speed	200 mm/s	200 mm/s	200 mm/s	200 mm/s
	Chamber Temperature	45 °C	/	/	/
	Nozzle Temperature	250-270 °C	280-300 °C	280-320 °C	280-320 °C
	Build Plate Temperature	100 °C	80 °C	80 °C	80 °C
	Cooling Fan	20%	15%	15%	10%
Post-processing	Annealing Needs	80-90 °C 6-8 hours	80-100 °C 6-8 hours	90-130 °C 6-8 hours	90-130°C 6-8 hours

Generic Filament		ABS	PETG	PLA	TPU 95A
Preparation	Necessity Of Drying	✗	✗	✗	✗
	How To Dry	/	/	/	/
	Nozzle Material	Bimetal Nozzle	Bimetal Nozzle	Bimetal Nozzle	Bimetal Nozzle
	Nozzle Size	All Size	All Size	All Size	0.4/0.6/0.8 mm
	Dry Box	✗	✗	✗	✗
	Print With Enclosure	✓	✗	✗	✗
Slicer Parameter	Print Speed	220 mm/s	120 mm/s	200 mm/s	60 mm/s
	Chamber Temperature	45 °C	/	/	/
	Nozzle Temperature	240-280 °C	240-270 °C	200-230 °C	220-260 °C
	Build Plate Temperature	100 °C	80 °C	60 °C	60 °C
	Cooling Fan	30%	60%	100%	100%
Post-processing	Annealing Needs	80-90 °C 6-8 hours	✗	✗	✗

Tips

1. Some other brands of ABS filaments are less heat resistant and it is recommended to set the chamber temperature no more than 55 degrees Celsius. Otherwise the filaments may be soften in advance and cause clogging.
2. If the filaments do not stick to the print platform:
 - 1) Please check if the nozzle is far away from the print plate, you can adjust the platform upward by Zoffset adjusting function.
 - 2) Because of the different ambient temperatures in different regions, the temperature of the heat bed can be increased appropriately to increase the adhesion of the filaments.
 - 3) If above all can not work , please contact the after-sales service for assistance.

Specifications

Machine Name		Q1 Pro
Body	Print Size (W*D*H)	245*245*240 mm
	Dimensions	477*467*489 mm
	XY Structure	CoreXY
	X Axis	10mm High hardness linear hollow steel shafts
	Z Axis	Dual Independent Lead Screw Motors
	Shell	Plastic
	Chassis	Steel
	Motor	42-48 High-Speed Motor
Print Head	Print Head Temperature	≤ 350°C
	Extruder Gear	Hardened Steel Gears
	Transmission Ratio	8.9: 1
	Hot End	Ceramic Plate Heating Hot End Only Need 52s Heating From 20°C To 220°C
	Temperature Measurement Unit	Thermocouple
	Nozzle	Bimetal Nozzle
	Nozzle Diameter	0.4mm
Filament Diameter	1.75mm	
Hot Bed	Printing Platform	Aluminum Substrate Heating Bed
	Printing Plate	PEI Magnetic Build Plate
	Hot Bed Temperature	≤ 120°C
Speed	Printing Speed	250-600mm/s
	Maximum Printing Acceleration	20000mm/s ²
Cool Down	Hot End Cooling Fan	Closed-Loop Control
	Model Cooling Fan	Closed-Loop Control
	Auxiliary Part Cooling Fan	Closed-Loop Control
	Motherboard Fan	Closed-Loop Control
	Chamber Circulation Fan	Closed-Loop Control
	Chamber Temperature	60° C Independent Chamber Heating
Filament	Recommended Filament	PLA, ABS, ASA, PETG
	Compatible Filament	TPU,PA, PC, Carbon/ Glass Fiber Reinforced Polymer
	Seal Print	Compatible

Sensor	Filament Tangle Detection	Support
	Filament Run Out Sensor	Support
	Automatic Leveling	Support
	Resonance Compensation	Support
Power Supply	Voltage	100-240 VAC, 50/60Hz
	Rated Power	350W+300W(Chamber Heating)
Electronics	Display Screen	4.3 Inch 272*480 Touch Screen
	Storage	32G EMMC and USB2.0 Flash Drive
	Camera	Camera (Up to 1080P) Timelapse Supported
	Motion Controller	Dual-Core Cortex-M4
	Application Processor	Quad-Core 1.5GHz Cortex-A53
	Extruder Independent Processor	Dual-Core Cortex-M0+
WIFI	Wifi Frequency Bands	2.4 GHz
	Transmitter Power (EIRP)	18 dBm (MAX)
	Protocol	IEEE 802.11b/g/n
Software	Slicer	QIDI Slicer and other third-party software, such as Ultimaker Cura, Simplify3D, PrusaSlicer, Orca etc.
	Operating System	Windows、 MacOS、 Linux



Scan QR to receive our latest product updates and latest news.

Official Website: www.qidi3d.com

If you need support, please feel free to contact us:

E-mail address: Q1Ams@qidi3d.com

Q1support@qidi3d.com

Skype ID: [Q1support@qidi3d.com](https://www.skype.com/people/Q1support@qidi3d.com)



Please visit the QIDI Tech official Wiki for more machine usage and maintenance tutorials.

<https://wiki.qidi3d.com/en/home>