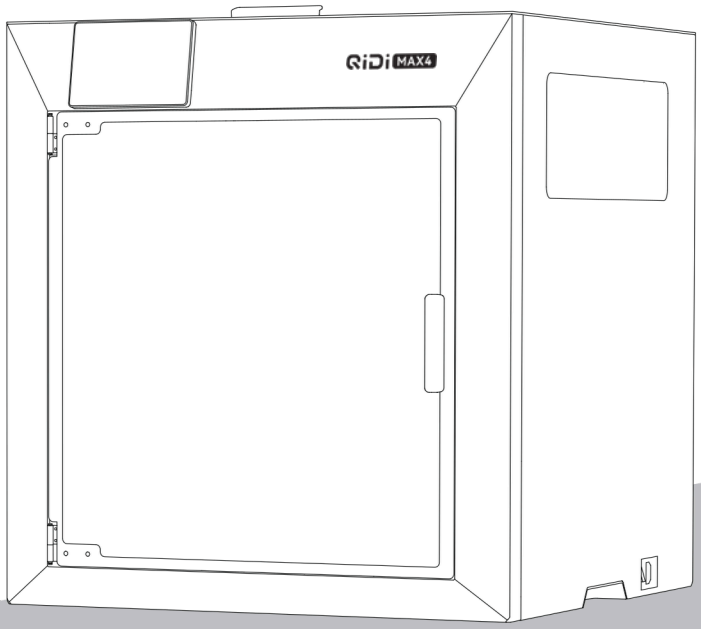
MAX4

before using this product

Quick Start Guide



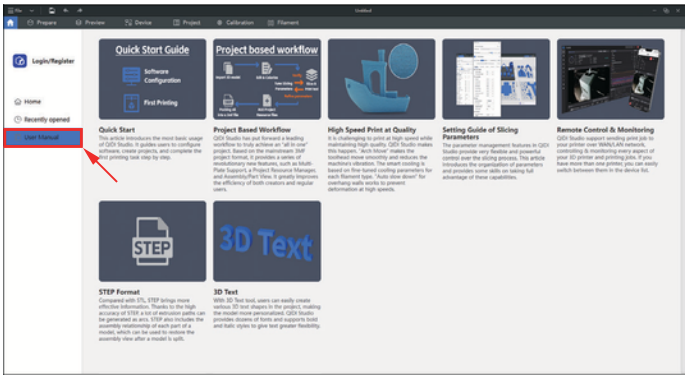
All pictures are for illustrative purposes only, actual product may vary due to product optimization.

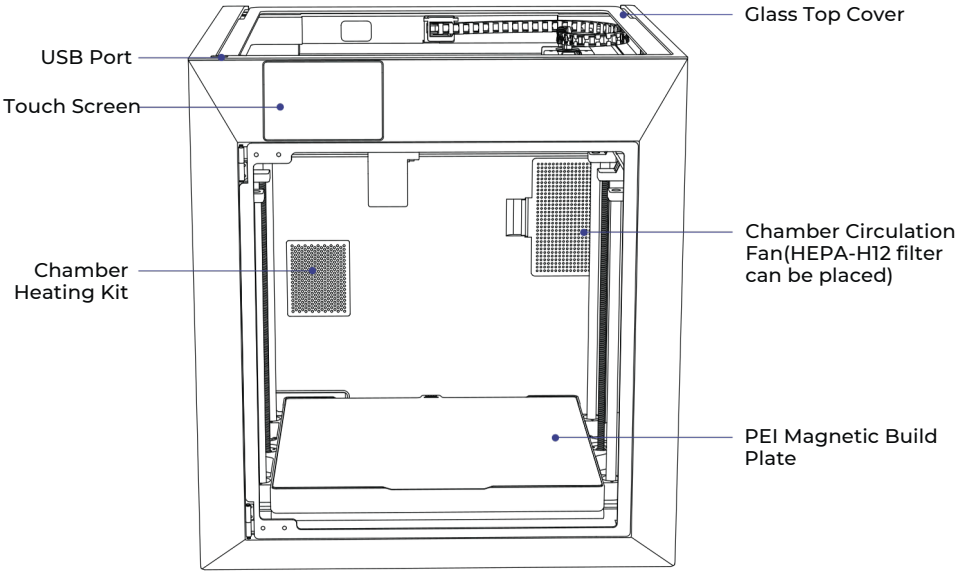
Usage Notice

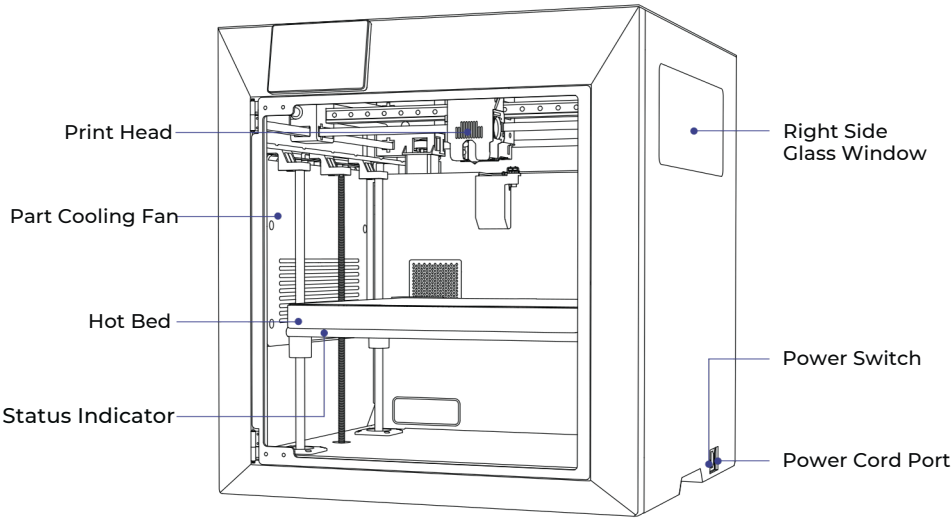
- Do not place the machine near flammable or explosive materials or high-temperature sources. Please place the machine in a ventilated, cool, and low-dust environment.
- Ensure the machine is powered off (unplug power cord) before performing maintenance or modifications.
- Before applying power to the machine, check that the voltage is correct.
- Never reach inside QIDI printers 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.
- Regular maintenance of the printer is essential. When the printer is powered off, use a dry cloth t clean the printer body, removing dust, residual filaments, and foreign objects from the optical axe
- The linear guides and Z-axis lead screws require periodic cleaning and lubrication.
- 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 or installing non-official plugins constitutes a voluntary waiver of official technical support. Users assume all risks associated with such actions, including firmware malfunctions, system failures, or other issues, which are explicitly excluded from warranty coverage. To restore the original system state, perform a "Factory Reset" via the settings interface

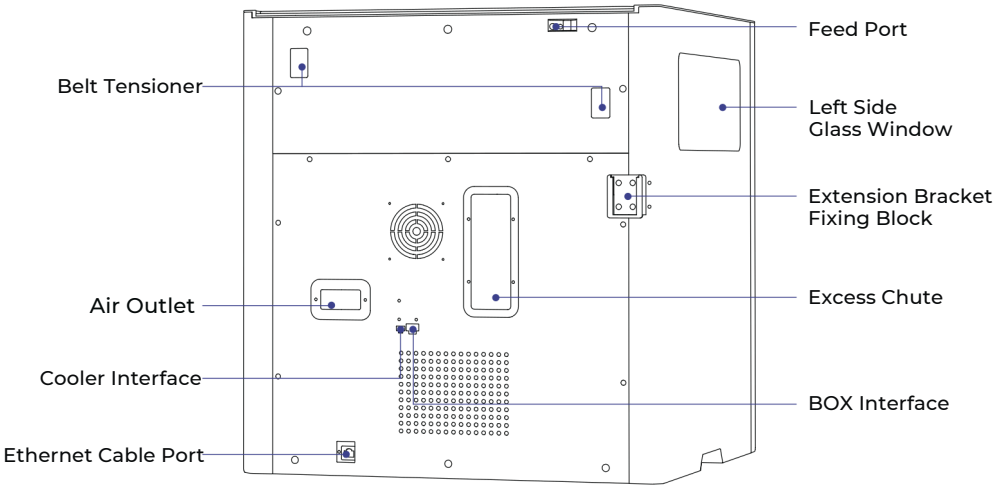
QIDI Studio

There is QIDI Studio slicing software in the USB flash drive. After installing and operating it, you can learn how to use the software in the User Manual.

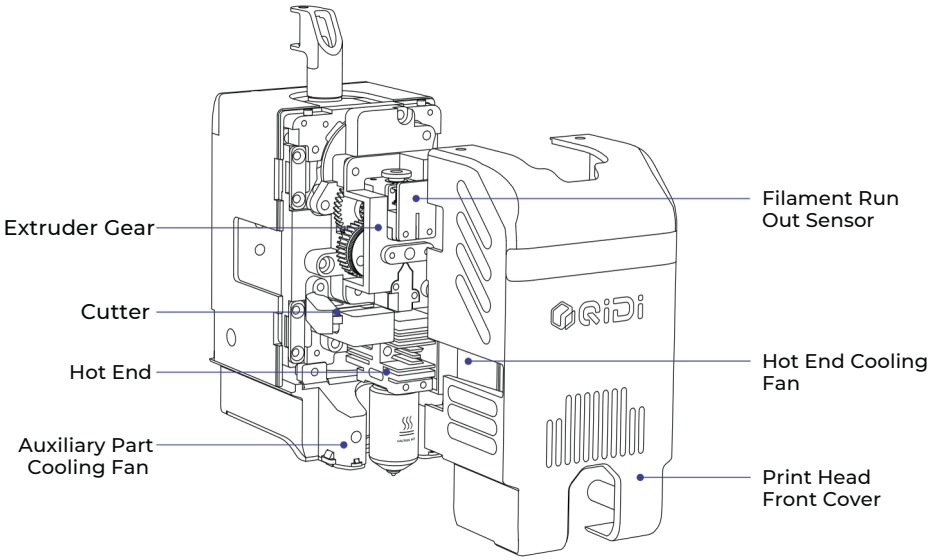



Glass Top Cover
USB Port
Touch Screen
Chamber Circulation Fan(HEPA-H12 filter can be placed)
Chamber Heating Kit
PEI Magnetic Build Plate

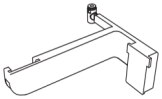

Print Head
Right Side Glass Window
Part Cooling Fan
Hot Bed
Power Switch
Status Indicator
Power Cord Port



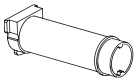
Print Head Introductio



Machine Accessorie

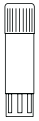


Filament Extension Rack And Pneumatic Head



Filament Spool Holder

Holder Cover



Glue Stick

Power Cord

Ethernet Cable

USB 2.0 Flash Drive

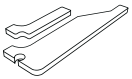
Flat Head Screwdriver

Spare Parts Kit

Lubricant Oil

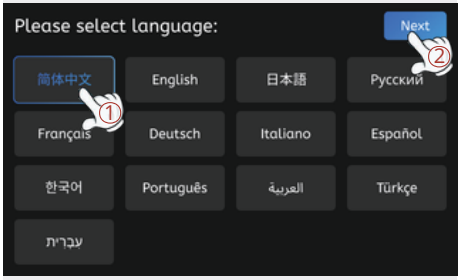
7mm Spanner

Scraper

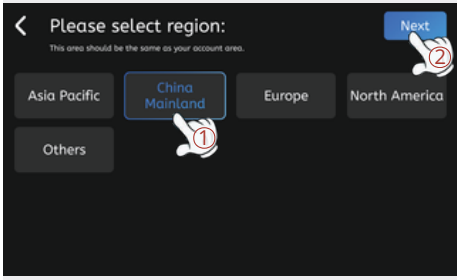


Upper Cover Sponge Adhesive Replacement Part

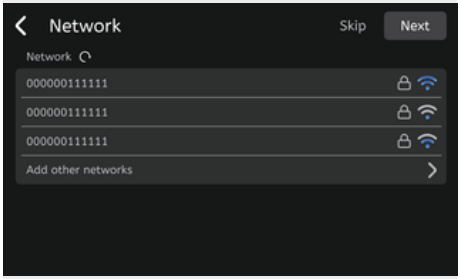
Basic Settings



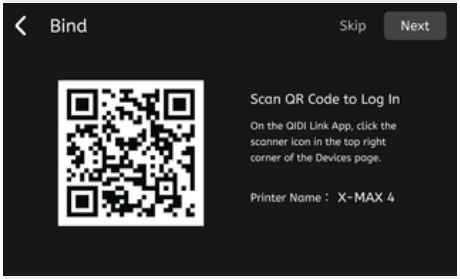
Please select your preferred language and click 'Next' to continue.



Please select your region and then click 'Next' to continue.



Please select your network and then click 'Next' to continue.



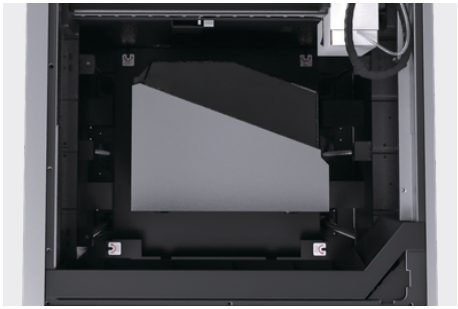
Download the QIDI Maker mobile APP from the app store and complete the registration. In the QIDI Maker mobile APP, click the scan icon at the top right corner of the device page, and scan the QR code on the printer screen to complete the printer binding.

Unboxing

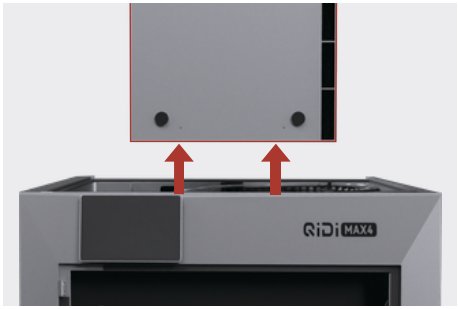
If there is no QIDI BOX, you can skip the step of ‘Remove QIDI BOX’and‘Remove QIDI BOX supports’.

Remove the foam and accessory box from the chamber.

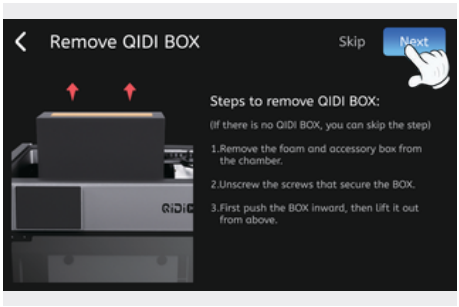
Unscrew the screws that secure the QIDI BOX.



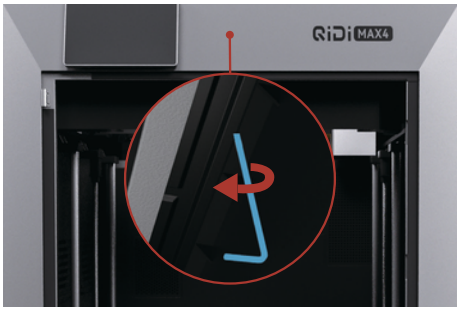
First push the QIDI BOX inward.



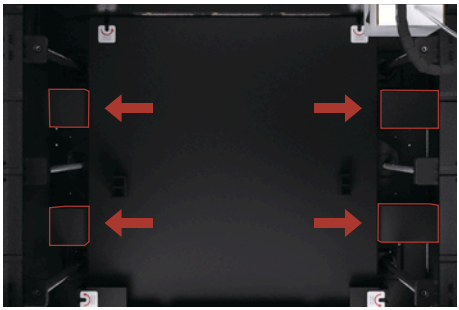
Then lift QIDI BOX out from above.



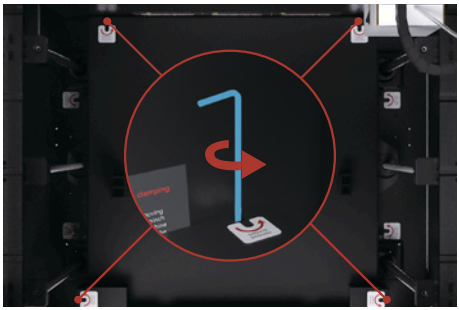
After confirmation, click 'Next'.



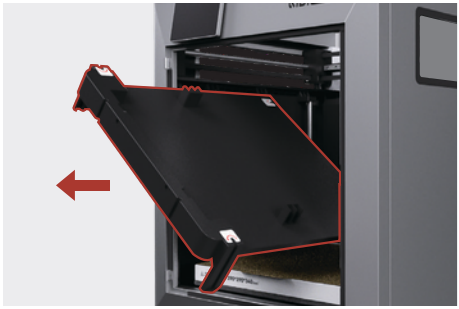
Unscrew the screws on the support piece above the QIDI BOX and remove it.



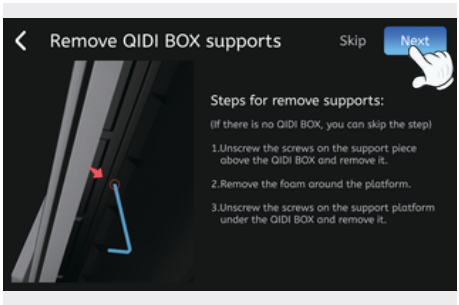
Remove the foam around the platform.



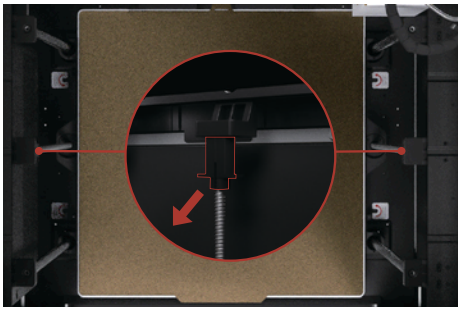
Unscrew the screws on the support platform under the QIDI BOX and remove it.

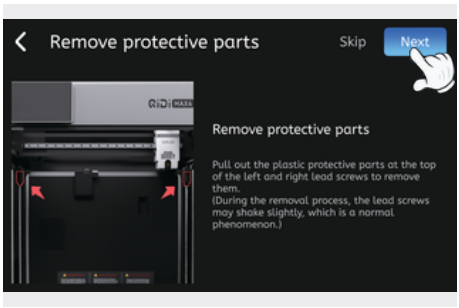


Lift the QIDI BOX fixing bracket, rotate it by a certain angle, then remove it from the front door.

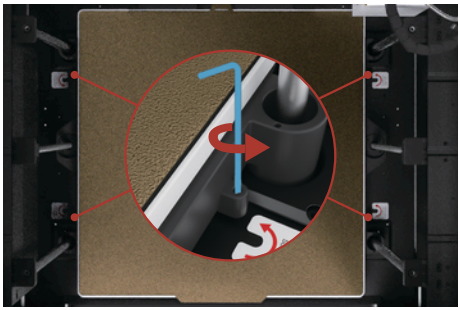


After confirmation, click 'Next'.



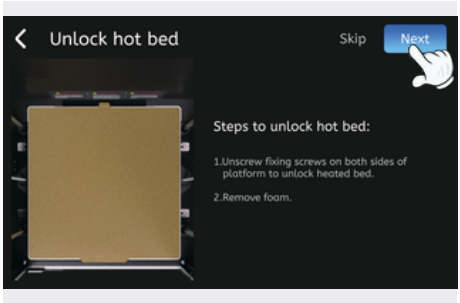


Follow the on-screen prompts to remove the lead screw protective covers on both left and right sides
After confirmation, click 'Next'.

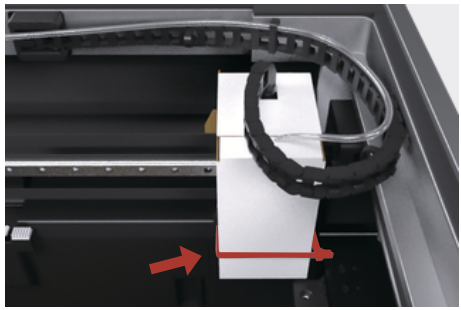


Follow the on-screen prompts to unscrew the screws that secure the hot bed.

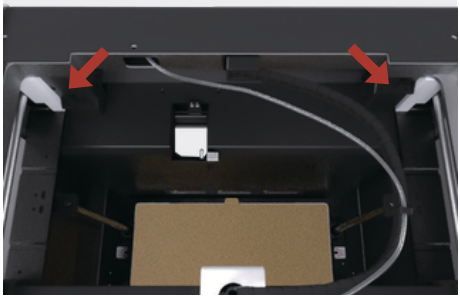
Remove the foam between the hot bed and the inner wall.



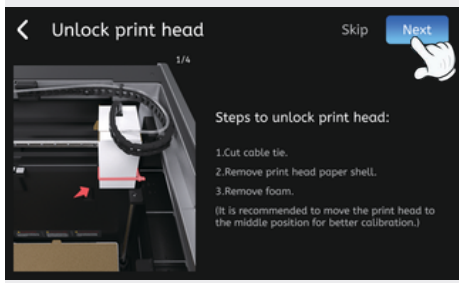
After confirmation, click 'Next'.



Follow the on-screen prompts and cut the cable tie and remove the cardboard.



take out the foam that protects the X-axis on both sides.

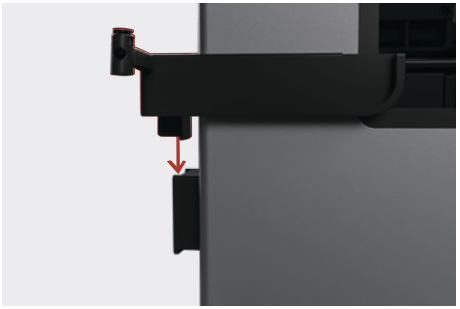


After confirmation, click 'Next'.

After confirming that all packaging materials have been completely removed and there is no debris o the platform, click "Next" and wait for the self-inspection and calibration to finish.

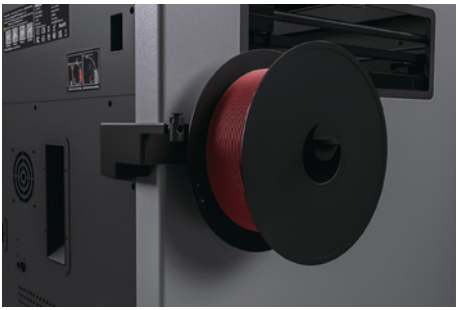
Load Filament

Take out the corresponding accessories from the accessory box.

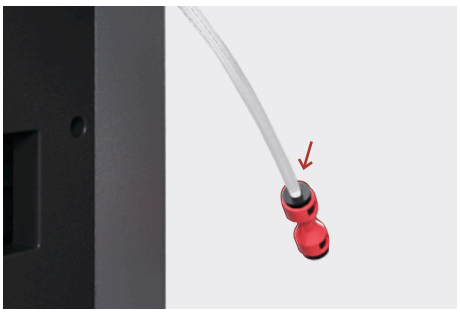


Install the filament extension rack and pneumati head on the extension bracket fixing block.

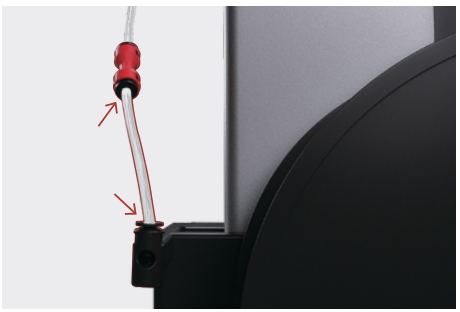
Install the filament spool holder on the filament extension rack.



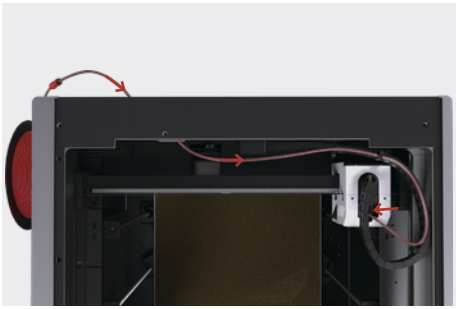
Place the filament on the filament spool holder.
Note: We recommend installing the filament holder cover to prevent filament from falling off.



Install the Dual-Head pneumatic head on the PTFE tube.

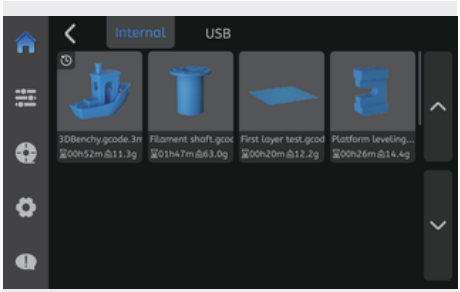


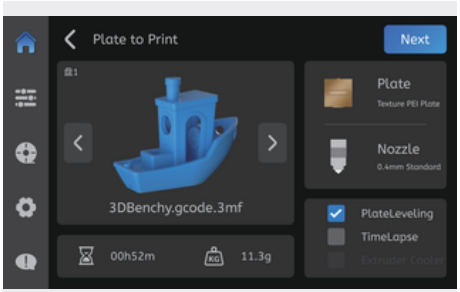
Connect the 110mm PTFE tube to the Dual-Head pneumatic head and the pneumatic head on the filament extension rack.



Feed the filament through the pneumatic head and keep pushing until it fully enters the extruder and can no longer be pushed.

First Printing





Click the button to start printing.

*Pre-saved models files use PLA Rapido filament by default.

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 softened 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 b Z-offset adjusting function.
   2) Because of the different ambient temperatures in different regions, the temperature of the hea 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.

Filament Guide for Beginner

QIDI Filament 1		ABS Rapido	PLA Rapido	PETG-Tough	UltraPA
Preparation	Necessity Of Drying	Opt ional	Optional	Optional	✓
	How To Dry	70 ℃ 8 h	55 ℃ 8 h	65 ℃ 8 h	60 ℃ 4-6 h
	Nozzle Material	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide
	Nozzle Size	All Size	All Size	All Size	0.4/0.6/0.8 mm
	Dry Box	Optional	Optional	Optional	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 ℃			
	Nozzle Temperature	250-280 ℃	200-230 ℃	240-270 ℃	280-300 ℃
	Build Plate Temperature	100 ℃	60 ℃	80 ℃	80 ℃
	Cooling Fan	30 %	100 %	60 %	20 %
Post-processing	Annealing Needs	80-90 ℃ 6-8 h	✗	✗	70-90 ℃ 6-8 h

QIDI Filament 2		ABS-GF25	PA12-CF	PAHT-CF	PET-CF
Preparation	Necessity Of Drying	✓	✓	✓	✓
	How To Dry	70 ℃ 4-6 h	100-120 ℃ 4-6 h	100-120 ℃ 4-6 h	100 ℃ 4-6 h
	Nozzle Material	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide
	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 ℃	/	/	/
	Nozzle Temperature	250-270 ℃	280-300 ℃	280-320 ℃	280-320 ℃
	Build Plate Temperature	100 ℃	80 ℃	80 ℃	80 ℃
	Cooling Fan	20 %	15 %	15 %	10 %
Post-processing	Annealing Needs	80-90℃ 6-8 h	80-100℃ 6-8 h	90-130℃ 6-8 h	90-130℃ 6-8 h

Generic Filament		ABS	PETG	PLA	TPU 95A
Preparation	Necessity Of Drying	Optional	Optional	Optional	Optional
	How To Dry	70 ℃ 8 h	65 ℃ 8 h	55 ℃ 8 h	70 ℃ 8 h
	Nozzle Material	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide	Bimetal Nozzle/ Tungsten Carbide
	Nozzle Size	All Size	All Size	All Size	0.4/0.6/0.8 mm
	Dry Box	Optional	Optional	Optional	Optional
	Print With Enclosure	✓	✗	✗	✗
Slicer Parameter	Print Speed	220 mm/s	120 mm/s	200 mm/s	60 mm/s
	Chamber Temperature	45 ℃	240-270 ℃	200-230 ℃	
	Nozzle Temperature	240-280 ℃	80 ℃	60 ℃	220-260 ℃
	Build Plate Temperature	100 ℃	60 %	100 %	60 ℃
	Cooling Fan	30 %			100 %
Post-processing	Annealing Needs	80-90 ℃ 6-8 h	✗	✗	✗

Specifications

Machine Name		MAX4
Body	Print Size (W*D*H)	390*390*340mm
	Printer Dimensions	558*578*612mm
	Package Dimensions	700*710*750mm
	Gross Weight	40kg
	Net Weight	49.5kg
	XY Structure	CoreXY
	X Axis	High Hardness Linear Guide Rail Automatic Belt Tensioning
	Z Axis	Dual Independent Lead Screw Motors 12mm linear shafts and screws
Print Head	Print Head Temperature	≤370℃
	Extruder Gear	Direct Extruder Hardened Steel Dual Gears
	Hot End	Ceramic Ring Heating, Multi-metal
	Nozzle	Bimetal Nozzle
	Nozzle Diameter	0.4mm (0.2/0.6/0.8mm Optional)
	Filament Diameter	1.75mm

Hot Bed	Printing Platform	Aluminum Silicone Heating Bed
	Printing Plate	Dual-Sided Textured PEI Plate
	Hot Bed Temperature	≤120℃
Speed	Max Speed of Tool Head	600mm/s
	Acceleration	≤20000mm/s^2
Fan	Activated Carbon Air Filter	3-in-1 Air Filter: G3 Pre-Filter+ H12 HEPA+Coconut Shell Activated Carbon
	Hot End Cooling Fan	4-Pin PWM Fan with RPM Feedback
	Part Cooling Fan	4-Pin PWM Fan with RPM Feedback
	Auxiliary Part Cooling Fan	4-Pin PWM Fan with RPM Feedback
	Motherboard Fan	Closed-Loop Control
	Chamber Circulation Fan	Closed-Loop Control
	Chamber Temperature (PTC Heater)	2nd Gen Up to 65°C Independent Chamber Heating
Filament	Supported Filament	PLA, ABS, ASA, PETG, TPU, PA, PC, Carbon/Glass Fiber Reinforced Polymer, etc.
	Filament Cutter	Yes
Sensor	Filament Clog Detection	Yes (For Use with QIDI BOX)
	AI Camera Detection	Yes
	Resonance Compensation	Yes
	Filament Tangle Detection	Yes (For Use with QIDI BOX)
	Filament Run Out Sensor	Yes
	Automatic Leveling	Loadcell Sensor Integrated into the Hot End
	Power Loss Recovery	Yes
Power	Voltage	100/240 VAC, 50/60Hz
	Rated Power	150W+550W(Chamber Heating)+700W(Hot Bed)
Electronics	Display Screen	5 Inch 800*480 Touch Screen
	Storage	32G EMMC and USB2.0 Flash Drive
	Camera	Low Framerate Camera (Up to 1080P) Timelapse Supported
Signal	Connectivity	Wi-Fi: 2.4GHz/Ethernet/USB
Software	Slicer	QIDI Studio and other third-party software, such as Orca, PrusaSlicer etc.
	File Formats for Slicing	STL, OBJ, 3MF, STEP (.stp/.step), etc.
	Operating System	Windows、MacOS、Linux