



SHAREBOT

BIG

QUICK START GUIDE

Version 21/02/2019

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Your new Sharebot BIG

Sharebot BIG introduces a lot of new features in the resin 3d printer panorama:

- Pixel size 0,137mm;
- Resolution 4K 3840x2160px;
- Printing area 468x239 mm Z 340mm;
- Resin tank with Fep 100uM;
- Sw slicing Pyramis;
- 7" lcd interface;
- Lan;
- Wifi;
- Door security switch;
- Dimension (W) x (D) x (H) 820 × 490 x 740 mm;
- Weight 66Kg;

We hereby declare that the product above is in compliance with the essential requirements of the following:

Low Voltage (LV) Directive 2009/95/EC, 2014/35EU.

Electromagnetic Compatibility Directive(EMC), 2004/108/EC,2014/30/EU.

Restriction of the use of certain hazardous substances (RoHS) Directive, 2011/65/EU

Commission Regulation (EU) No. 453/2010 and IEC 60950-1 Safety of ITE

Technical Documentation is stored at the manufacturer's address below.

Sharebot Srl
Via montello, 18
23895 Nibionno (LC)
Italy



Safety Guidelines

Read the instructions carefully. Keep this document for future reference. Follow all warnings and instructions marked on the product.

- Operate on a table or flat, stable surface, ensuring that the machine cannot fall and is level;
- Do not operate outdoors;
- Do not allow resin or any liquids to get inside the chassis, wipe up any liquid spills immediately;
- Do not use solvents to clean the printer as they may damage the screen. Use a little detergent and warm water to clean any resin spills;
- Disconnect the printer from the power before storage or when not used for a long period of time. This 3D printer is connected to the electrical network with an input of 110 or 240 V AC, 50/60 Hz;
- Do not allow anything to rest on the power cord. Do not locate this product where people will walk on the cord;
- If an extension cord is used with this product, make sure that the total ampere rating of the equipment plugged into the extension cord does not exceed the extension cord ampere rating. Also, make sure that the total rating of all products plugged into the wall outlet does not exceed the fuse rating;
- Do not overload a power outlet, strip or receptacle by plugging in too many devices;
- Use the product only with the supplied power cable. If you need to replace the power cable, make sure that the new power cable meets the following requirements: detachable type, UL listed/CSA certified, VDE approved or its equivalent, 4.5 meters (15 feet) maximum;
- In case of malfunction, disconnect the printer immediately from the power;
- Do not attempt to fix this product by yourself, as opening or removing covers may expose you to dangerous voltage points or other risks. Refer all repairs to qualified service personnel. Please send an email to your national supplier or contact

technical service at: info@sharebot.it

- Keep the printer and resins out of the reach of children;
- Printer requires two people to lift it from the packaging;
- The resin is an irritant to skin and eyes. Always wear gloves when coming into contact with the liquid resin. Always use in a well ventilated room;
- Resins are classified as irritants, not harmful, but in exceptional circumstances people can be sensitive to the resin and develop a skin irritation or rash. Avoid this possibility by always wearing gloves and avoid breathing fumes;
- The printer should be operated on a stable and level surface, preferably away from direct ambient light;

Unplug this product from the wall outlet and refer servicing to a qualified service personnel if:

- The power cord or plug is damaged, cut or frayed;
- Liquid has been spilled in the machine;
- The machine was exposed to rain or water;
- The machine has been dropped or the case has been damaged;
- The machine does not operate normally after following the operating instructions;

Package Contents

First of all, check that there are no damages to the machine and that all items listed below are included in the package or in the Sharebot toolbox.

Your package should contain:

- A box with the Welcome Kit;
- 3D printer Sharebot BIG;
- Sharebot Cure;
- Ultrasonic cleaner;

Welcome Kit

The Welcome Kit contains:

- Print Plate;
- Resin Tank;
- Corner tank funnel;
- Scraper;
- Allen Key;
- Funnel;
- Paper Strainer;
- Nitrile Gloves;
- Print Sample;
- Tank Fep Film;
- Tank gasket;
- USB stick with Slicing Software and manuals;
- power and Rj45 cable;
- Oil pen for Z axis;

Test materials

A sample bottle of Sharebot D-Hard resin is provided with the 3d printer.

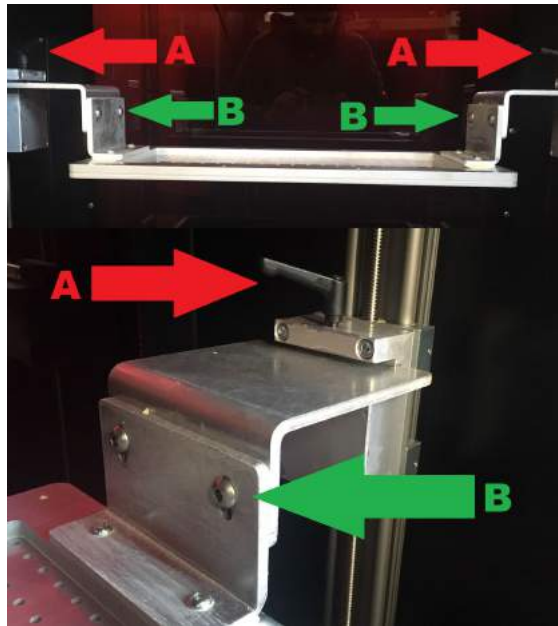
A sample of C-Cleaner;

Assembly instructions

1. Unscrew the screws on the top and front panels of the crate and place them to one side;
2. Remove the polystyrene from around the printer;
3. Remove the resin bottle from the crate;
4. Unscrew the platform, remove and put it to one side. Lift the ancillary box out of the printer (To unscrew the bolts lift them up to disengage the lock and turn the bolt to loosen it. Repeat this step until the bolts are fully loose so the platform can be removed.);
5. Place the platform back into the printer and tighten the bolts;
6. With two people lift the printer out of the crate holding the printer at the bottom and top corner on both sides;
7. Place the printer on a flat and sturdy worktop ready for set-up;
8. Level the printer;
9. **Calibrate the building plate:**

Warning

- Make sure you have the building plate and the bottom of the tray perfectly clean, any debris residues could compromise the calibration / printing or even damage the printer;
- Be sure to use protective gloves and goggles if you are calibrating the printer with resin in the tray;
- Plate calibration must always be done before each print;
 - A. Insert the construction plane and lock it with the 2 knobs A;
 - B. Unscrew the 4 Allen screws B and secure the body in the middle of the building plate;
 - C. From the printer menu, send the printer to Home;
 - D. When the plate is in position, apply a soft pressure with hands on the building plate towards the bottom and tighten the 4 Allen screws B;



Resin management:

Sharebot Big 3D printer uses a resin management system that prevents the machine use when the availability of material is less than the required to print the desired object. The consumables management system works by decreasing the amount of resin used for each print succeeded by the amount of resin available in the bottle currently in use. At the time of insertion of a new resin code the available quantity of that resin comes set to the amount available in the bottle.

The materials management guidelines are the following:

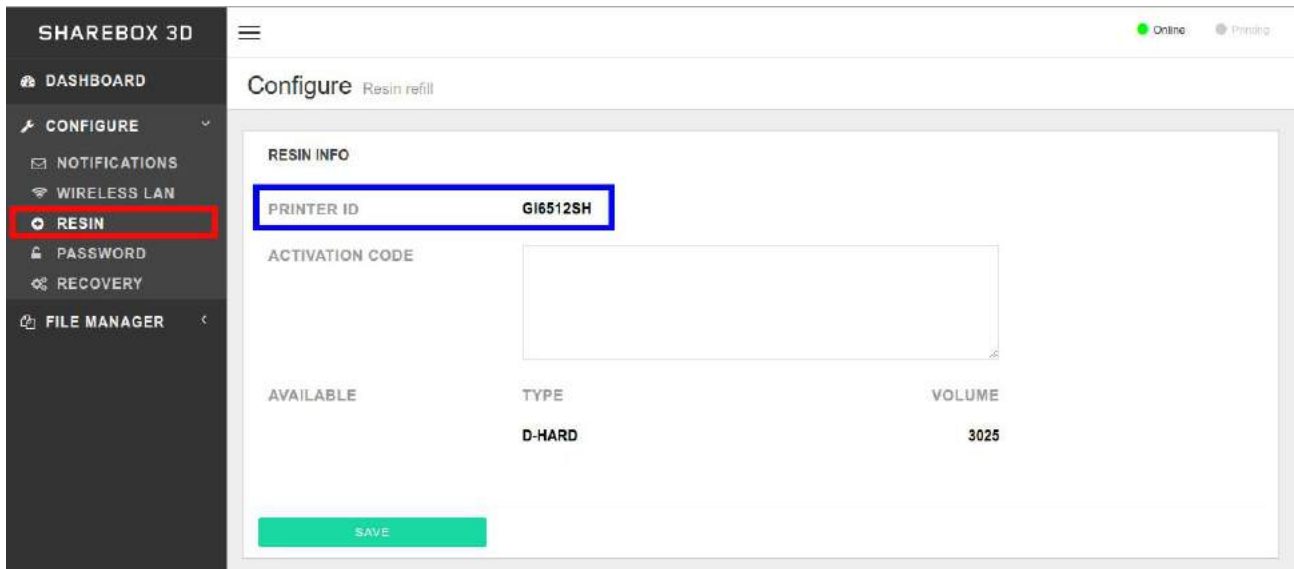
- Each resin bottle is associated with one and only one printer;
- When a new bottle is open, is necessary to generate the corresponding activation code and insert it into the 3D printer where the material will use.

The procedure to add a material consists of the following steps:

- Access to the web interface (Sharebox) of the printer;
- Generation of the activation code;
- Entry of the activation code into the machine.

Access to the printer

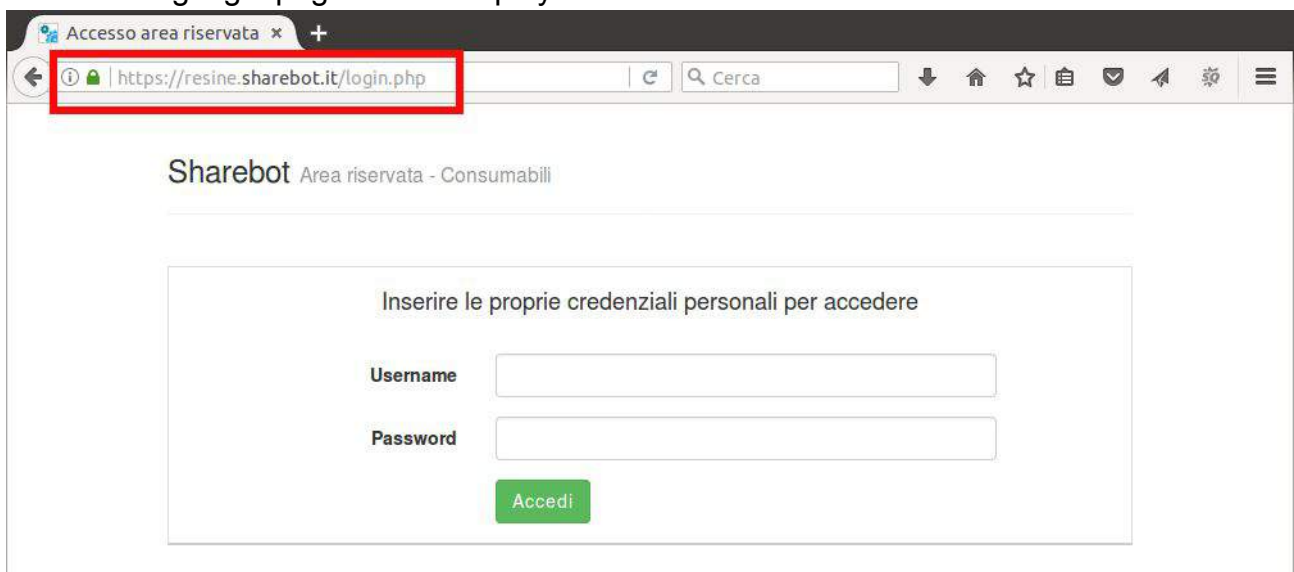
The printer to which the material should be associated must be reachable via browser, opened the address shown in the corresponding section "Configuration" and inserting the credentials you be able to open the "Configure" section, select "Resin".



Generation of the activation code

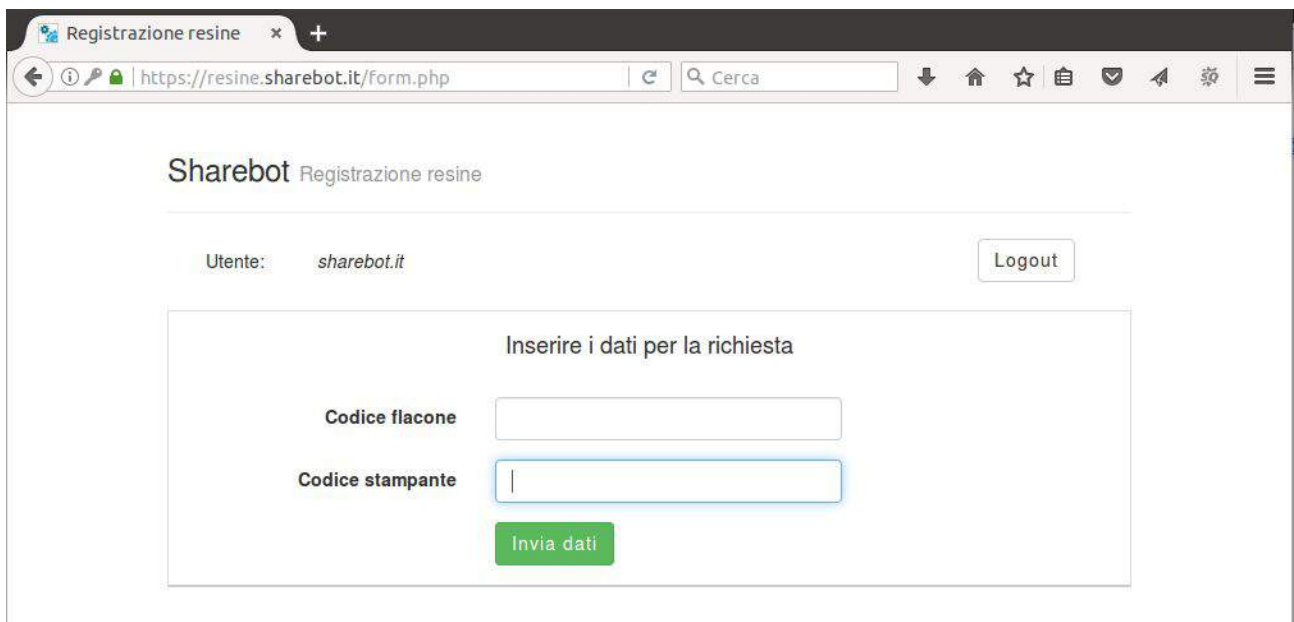
Connect to the web site <https://resine.sharebot.it/>

The following login page will be displayed:

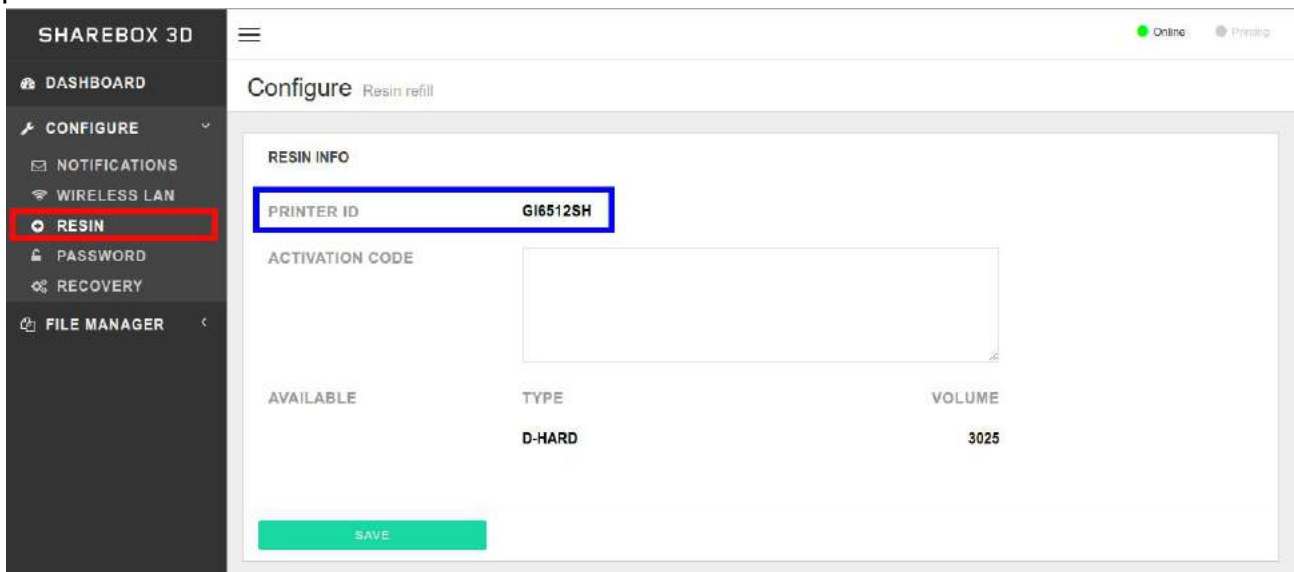


Warning: Check that the lock that indicates a secure communication is green.

Once the correct credentials have been entered and the "Login" button is pressed, the activation code generation page is displayed:

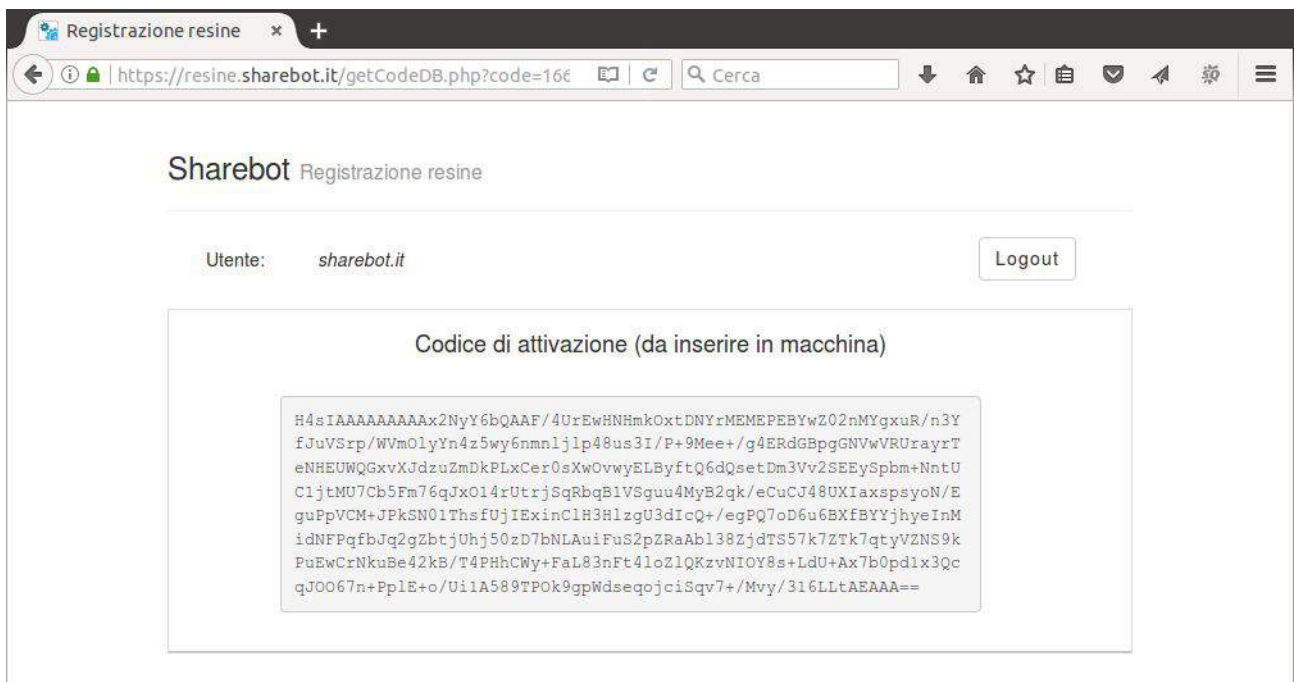


Enter in the "Bottle code", the code shown on the resin bottle label
Enter in the "Printer Code", the code indicated in the "Configure" - "Resin" section of the printer in which to activate the resin.

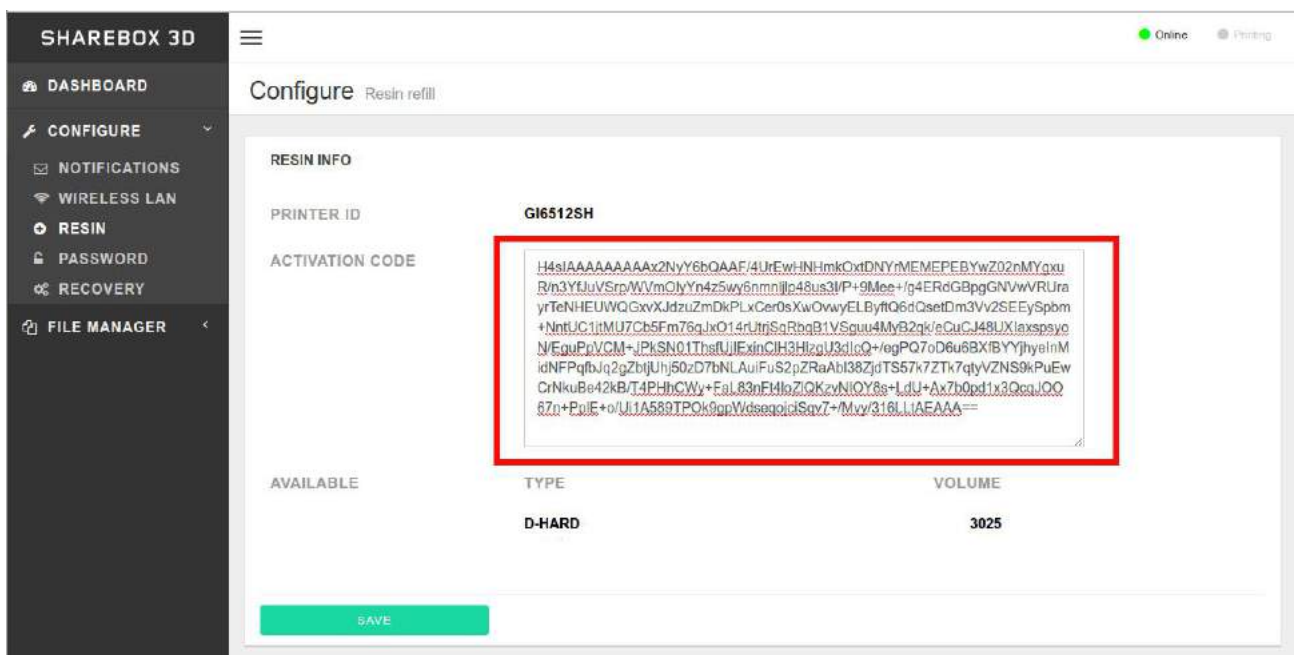


Warning: If you own a single machine, the "Printer Code" field will be automatically compiled.

Pressing the "Send data" button will generate the activation code.
The generated code is valid only for the printer identified by the entered code.



Select the text of the gray area, copy it and paste it in the "Activation code" section of the "Configure" - "Resin" section of the printer:



Once the "Save" button is pressed, the resin volume will be set to the contents of the new bottle.

Fill in resin

Warning

- Make sure you have the building plate and the bottom of the tray perfectly clean, any debris residues could compromise the calibration / printing or even damage the

- printer;
- Be sure to use protective gloves and goggles;
 - A. From the printer menu launch "Homing" ;
 - B. From the printer menu launch "plate up", the building plate will get up by 5cm;
 - C. **Mix the resin** into the bottle for 2/3 minutes, then pour the resin into the printing tank, to cover all the bottom of the tank;
 - D. Finally, launch "Homing", well now you are ready to print.

Support

You can find useful documents on the Sharebot Support Page, along with a form to get in touch with Sharebot Support.

Parts Replacement

All moving parts of the machine are excluded from warranty as they are subject to normal wear and tear.

Printing plate and Resin tank are considered wear parts and excluded of warranty. Covered by warranty and to be change all the parts with obvious manufacturing or assembly defects.

The spare parts, as per regulations, are available for 5 years starting from the date on which the machine is put on the market.

For any spare parts requirement, contact the Sharebot Authorized Centers network or use the dedicated form on the sharebot.it website.

Before requesting technical assistance, please check the two sections: FAQ and HOW-TO from the Sharebot.it website as well as the provided documentation.



Learn more:

www.sharebot.it/en/support

Working with Sharebot BIG

Configuration

The Sharebot BIG has an internal operating system using which you can manage the printer.

There are two ways of accessing the printer interface, loading files and managing print operations:

By Sharebox 3D or from the LCD interface.

You can choose this during the set-up.

Connect the power cables and the RJ45 cables into the printer, then turn on the power using the power switch at the back. Turn on the screen using the switch on the front of the printer.

Installation and use of slicing software

PC with Windows operating system for installing the slicing software with the following requirements:

- I5 processor;
- at least 8GB RAM;
- Windows 10;
- 2GB graphics card (ideally NVIDIA);
- LAN network or a Windows PC with Ethernet port to send files and manage the 3D printer;

Other information on the slicing software can be found in the Slicing Software Handbook (Pyramis).

Using the printer interface

After you have chosen the desired access mode, you can access the printer's management interface (Sharebox 3D).

There are two main pages:

Via the »Dashboard« you can display the status of the printer and suspend the operation. In the »Filemanager/CWS file« view you can manage print files, i.e. you can load the files to ready the machine to process successive print operations.

Dashboard

If you are connected to the printer via the network, the dashboard is the first page that is displayed once you have started up the printer. The status of the printer is shown on this page. By clicking the Dashboard symbol you can return from the sub-menu to the Dashboard at anytime.

In the »Overview« section the status of the print operation is shown. Here you can suspend the print operation at any time by clicking »Stop«.

Overview of the fields displayed

- Object: Name of the print job;
- Current layer: Number of layers that have already been printed;
- Total layers: Total numbers of layers;
- Time elapsed: How long the printer has already been running;
- Total time: Expected time for the entire print;
- Progress: Percentage-based progress of the print operation;

There are two other displays at the top right:

The first display »ONLINE«, in green, indicates the printer is ready for operation. The second display »PRINT« indicates that a print operation is currently underway as soon as it lights up red.

Attention: If the »Online« display does not light up green, please contact the Support service.

Managing files

If you select »file manager« menu and the symbol »CWS file«, you can access the file manager. Here you can upload prepared print jobs, repeat or delete saved jobs. It is also possible to transmit print jobs via USB stick.

Click on »Upload CWS« to load a file into the printer.

If you click on this button, the upload window is opened.

Click »Select file« to upload the desired object.

Via »Local«, »USB« and »All« you can display files in the internal printer memory, the USB stick or by both media.

Each file can be printed via the »Print« button or deleted using »Delete«.

You can access additional functions via the »Service program« folder.

Z Homing: the building plate moves upwards into its end position

LCD interface

Sharebot BIG has a 7" LCD interface located at the top front of the 3D printer.

This means independent use of the 3D printer is possible without a network connection.

You can set the NET parameters of the printer over the LCD, copy files to the memory, and launch service programs or an order file.

The functions of the LCD interface may vary from one firmware version to another.

LCD interface structure:

»Homepage« symbol (Sharebot logo)

- Dashboard page

»3D printer« symbol

- File from memory

- File from USB stick

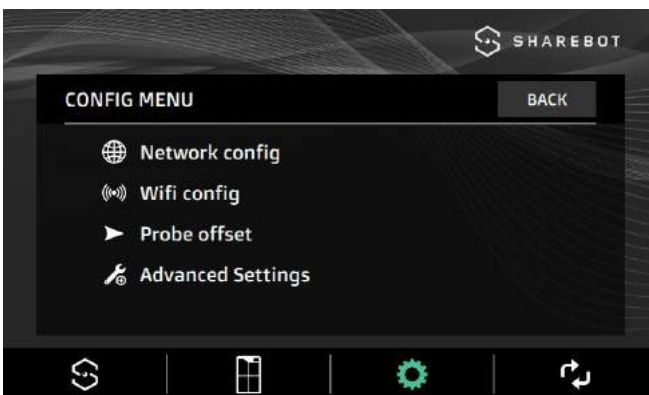
»Setup« symbol

- Preparation
 - Auto Home
 - »Plate UP«
 - Cleaning Cycle
- File operations
 - Copy file Copy file from memory (... in memory / on USB stick)
 - Copy file from USB memory (... in memory / on USB stick)
- Delete file
 - File from memory
 - File from USB stick
- Configurations
 - Network configuration
 - Advanced settings:
 - Security PIN
 - Touch screen Calibration

»Software« symbol

- Software info
- Error logs
- Licenses
- Statistics
- Load SW update

Network configuration



The Sharebot BIG can be configured as a network client with the assignment of a static or dynamic IP address (via DHCP). A Sharebot machine connected to the network works as a network client accessible from an IP address via a browser (see Sharebox 3D), in order to manage some functions. For network configuration, the intervention of the network administrator of your company is recommended.

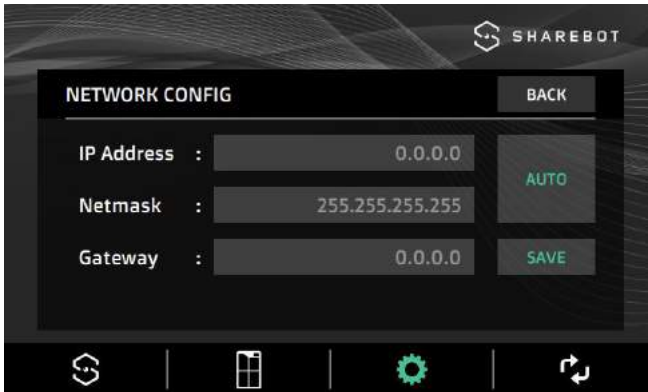
The gray color of the font indicates the automatic configuration of the network client (DHCP).

By selecting AUTO the fonts and the IP for network configuration become black and editable. The AUTO command becomes MAN, indicating Manual configuration.

Section	Select:
Configurations	Network Config AUTO / MAN

Procedure for network configuration

By connecting the Ethernet cable, DHCP automatically assigns an IP address to the machine.



The addresses displayed become editable, the message on the button changes to MAN and the address triplets must be entered:

- of the chosen static IP,
- of the LAN Netmask,
- of the router's Gateway (optional)

To save the settings, select the confirmation button.

Wifi configuration

To use the printer via the WIFI connection, it is first necessary to connect via a network cable, as described in the previous paragraph.

To configure the WIFI connection it will now be necessary to access *Sharebox 3D* and in the specific menu choose and execute the configuration (see *SHAREBOX 3D*)

First print

Attention: If you are working with liquid resin for the first time, please observe all precautionary measures.

You can then fill the material tray with the corresponding resin.

Ensure that no resin is spilled out of the tray.

Take special care to ensure no resin drips into the machine.

If liquid resin does drip into the machine, disconnect the power cable from the printer and refer to technical support.

After filling the tray properly, close the door of the printer.

Start a printint operation

Start a printing operation from management interface:

- Connect to the printer's management interface;

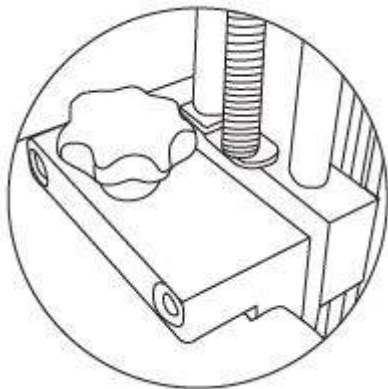
- Select the »Filemanager« menu;
- Select the item »CWS file« or upload CWS file;
- Click the »Print« button;
- Confirm printing process;

Start a printing operation from the LCD interface:

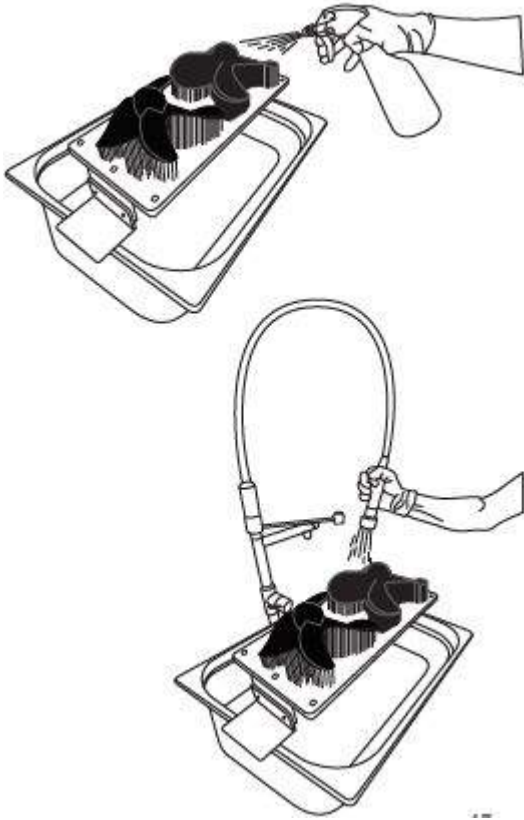
- Click the »3D printer« symbol;
- Select File from memory or File from USB stick;
- Select the »CWS file«;
- Click the »Print« button;
- Confirm printing process;

Removing the printed object, finishing and postcuring process

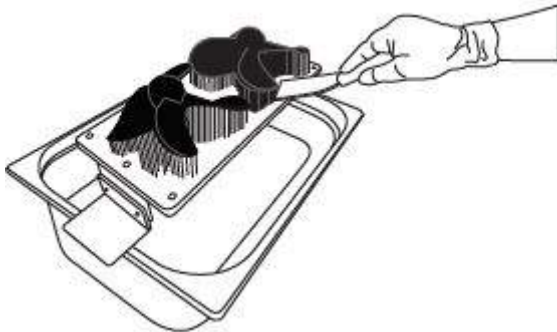
1. Move the print plate up from the LCD interface. Allow the print to drain for a few minutes to reduce the chance of drips;
2. Make preparations for cleaning the print. You will ideally need a large sink with a good supply of hot water. The ambient light level should be low. Have a spray bottle with in the C-CLEANER. Wear protective gloves at all times you come into contact with liquids;
3. Loosen the bolts that secure the print plate to the drive carriages. Grip the print plate L brackets firmly and take the weight of the print. Carefully slide the print plate towards you and out of the machine. Close the printer door take care not to drip resin;



4. When your print is finished remove the platform from the printer and lay it with the object facing upwards in a large plastic tray. Spay the part throughouly to remove all the unreacted surface polymer. When you have covered the entire surface, finish by spraying with S-CLEANER. You can use a sponge or soft brush to clean detailed parts. Alternatively use a large utrasonic cleaner;



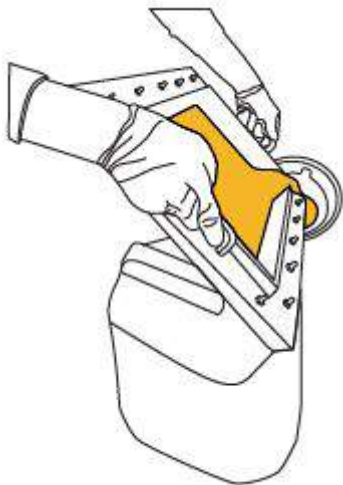
5. Using a scraper detach the supports at the base to remove the part from the platform. Handle it gently as it won't achieve full strength until after full post exposure. Note that for large models, we recommend post curing the model on the build plate in order to minimize any possible warping. If your part is strongly adhered to the build platform you can aide removal by heating the metal to expand it by applying **hot air gun** to it;



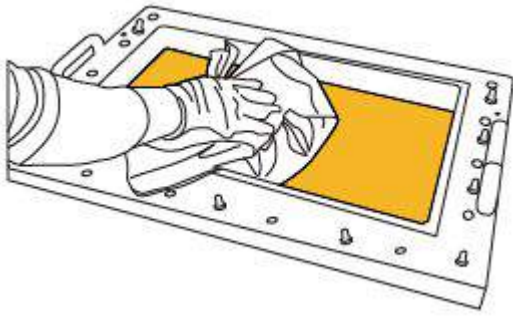
6. Put the printed part(s) in the Sharebot Cure. Follow the Sharebot Cure instruction;
7. Clean the print plate thoroughly. Make sure all cured resin is removed from the underside of the plate as this may cause damage to the vat or screen. Hot soapy water and/or methylated spirits can be used to clean off uncured resin. Make sure the print plate is completely dry before returning it to the printer;
8. Once the printed part(s) have been fully post-cured they should be removed from the Sharebot Cure and dried thoroughly. Any support material can be removed using clippers. The part can be sanded and postworked if necessary;

Remove the resin from the resin tank and cleaning

1. Before starting a print on the Sharebot BIG, the resin tank should be emptied and cleaned. Wear protective gloves. Ensure that the ambient light level is not too high, don't work in direct sunlight and use low lighting where practical;
2. Prepare an area for cleaning the vat. You should have a smooth, flat, clean surface with plenty of space. Lay down two layers of paper towel to protect the vat film from scratches and soak up any spilled resin. Do not work on a surface that could be stained or damaged by contact with resin;
3. Position a 5 litre resin bottle near the printer on a flat, stable surface and at a convenient height. Be sure that there is enough space in the bottle for all of the resin from the tank. Remove the lid of the bottle and insert the funnel (supplied in the accessory box) into the top. Place a clean filter (supplied in the accessory box) inside the funnel.
4. Remove the two tank bolts and set them aside. Grip the tank firmly by the handles and lift it carefully out of the printer. The resin tank will be heavy, especially if there is a large volume of resin remaining. Pour the resin gently into the funnel from one corner of the resin tank. Pour at a steady rate and be careful not to over-fill the funnel. Resin will flow over the flange of the tank; this is not a problem. Use a plastic card to push resin down the vat film towards the funnel;



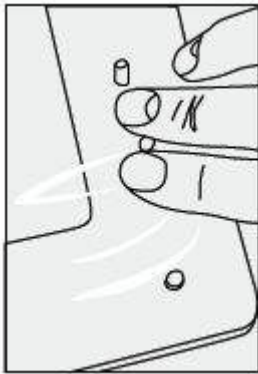
5. When most of the resin has drained from the vat, place it on the paper towels ready for cleaning. When the funnel has drained, remove it from the resin bottle and replace the lid;
6. Use paper towels to clean up the resin on the flange of the tank. Be particularly careful to clean the resin out of the holes. If resin is allowed to cure in the holes it can obstruct the nuts and make it difficult to re-skin the tank film. Methylated spirits can be used to help clean the tank body;



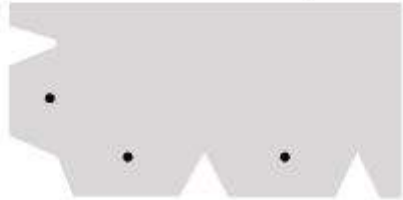
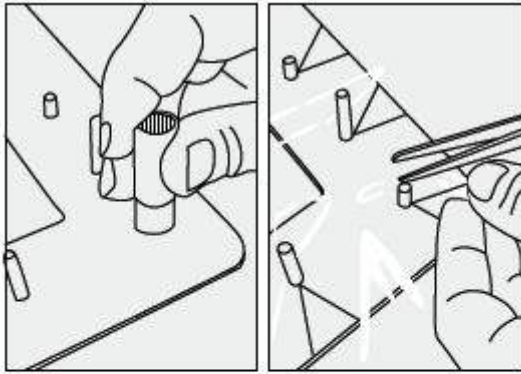
7. Use paper towels to clean up any further resin inside the tank. At this point it is important to remove any pieces of cured resin that remain in the resin tank. Anything left inside the tank could cause damage to the tank or screen when the printer is homed. It could also could prevent successful printing;
8. Once the tank is clean, inspect the film for any signs of damage or excessive wear. If there is a puncture, or obvious damage, replace the tank film. You can cover tiny holes in the tank film with clear tape. If the tank is in good condition, return it to the printer. Replace the 2 tank bolts (do not tighten).

Replacing the tank film

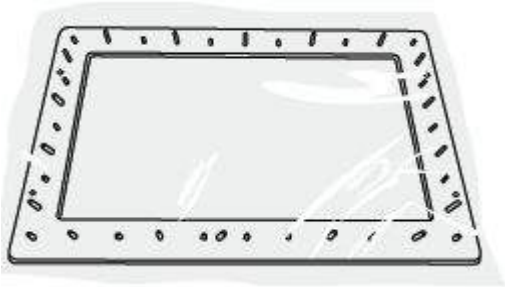
1. Disassemble the tank, dispose of the film and gaskets, and clean all other parts thoroughly. Check that any cured resin is removed. The resin tank parts will not be damaged by cleaning solvents;
2. Place the tank bottom film frame;
3. Lay the new piece of film over the vat bottom film frame. Position it centrally. Grip the film tightly on either side of one of the long bolts. Press the film down firmly to puncture it;



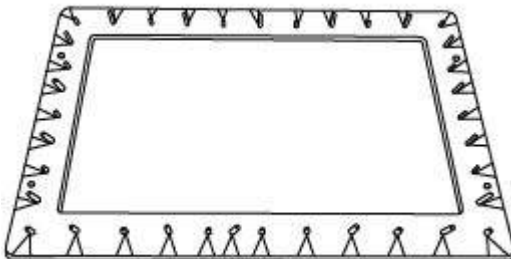
4. Move to an adjacent long bolt and press the film down to puncture it again. Make sure that the film is under tension as you create the new hole so that there are no crease;



5. Carry out the same procedure for the short bolts, using the socket to puncture the film;



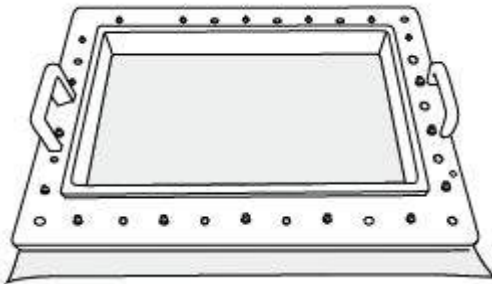
6. Use scissors to cut away a triangular piece of film outside each of the bolts. Carefully make two cuts from the edge of the film to the punched hole;



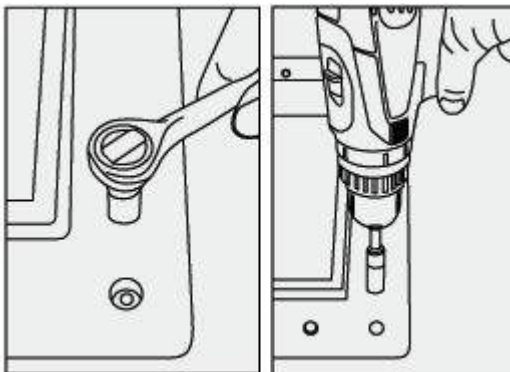
7. Widen each of the remaining holes by gripping the edge of the film near each long bolt and stretching outwards slightly;



8. Lay the vat bottom gasket (with small holes) down over all the bolts;
9. Lay the vat top gasket (with small and large holes) down over all the bolts;
10. Do not tighten the short bolts. Place the tank body onto the bolts. The handles should be on the top;
11. Take 18 tank nuts and thread them about one turn onto the long bolts. You may find that you need to lift the tank bottom film frame slightly to allow the thread to engage;
12. Once all 18 tank nuts are in place, you can start to tighten them using a ratchet socket wrench or a socket driver. Work around the tank giving each nut two or three turns. It should take three or four passes to fully tighten all the nuts;
13. The film should be pulled taught as the nuts are tightened. If any creases remain once the film is taught, the tank body will have to be removed and the holes in the film stretched to correct the creases;



14. Lift the completed tank and carefully turn it on to one edge. Rest it on the table and check that the tank body and the tank bottom film frame are parallel. The gaskets should be under uniform compression. If there are any gaps, the nuts have not been fully tightened evenly or something is obstructing the thread. If the tank body has been significantly distorted by the compression around each nut, they are too tight;



15. Also inspect the tank film where it is stretched over the wall of the tank. There

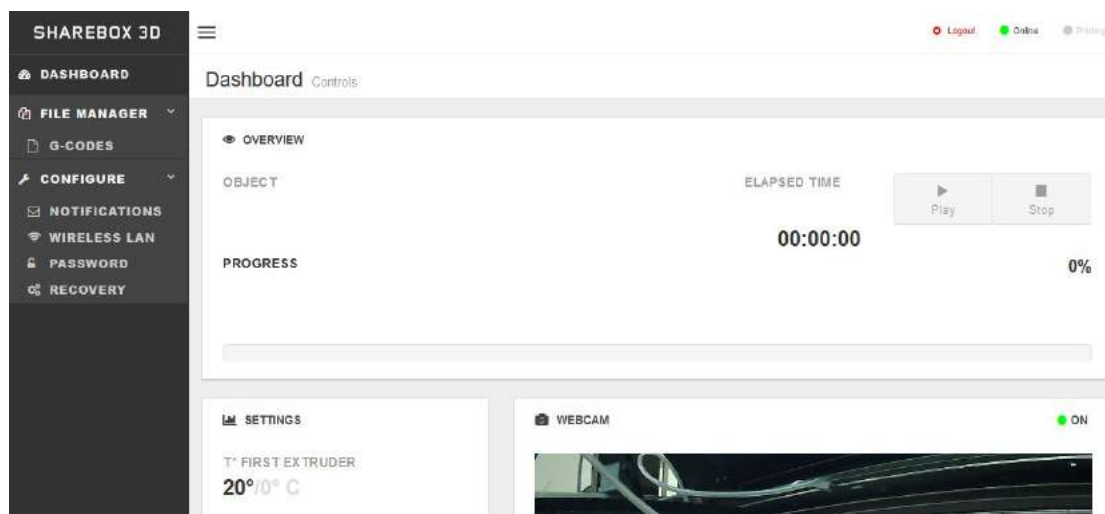
should be no holes, creases or other visible damage. If any pieces of cured resin or other contamination is trapped between the tank wall and the film, this could cause a leak during use. In the corners, there may be some creasing in the film. This is acceptable as long as the creases do not extend onto the base of the tank;



16. Turn the tank around and inspect each side as described above. You can check for leakage by filling with water and leaving for 1 hour;
17. The tank is complete and ready to use in your Sharebot BIG. Following this procedure applies less tension to the vat film than in the standard configuration. This can assist with release of the print from the tank and improve reliability.

SHAREBOX 3D

Sharebox 3D is the Sharebot Web Interface to remotely monitor and manage print jobs and file uploads. The web interface is designed with responsive features and can be viewed on the display of each mobile device.



The Sharebox 3d Dashboard Menu

You access Sharebox 3D through the IP address of the machine connected to the network, properly configured.

Access credentials:

Enter the following user and password to gain access to the Sharebox 3D Web User Interface. The user and Password are case-sensitive.

User admin

Note: After the first access they can be modified by accessing the "configure" > "password" menu.

The Sharebox 3D User Interface consists of:

Dashboard, for monitoring the parameters and the printing process via webcam, File Manager, for loading Gcode files and launching the print job, Configure for settings related to notifications, passwords and WiFi

Dashboard

Section	Select:
Dashboard	Dashboard

The Dashboard displays:

- Printer status: Online / Offline - Printing / waiting for user
- The printer status file name with the extension .Gcode
- Control commands of the printing process
- Elapsed time
- Percentage advancement
- The video streaming printing process, the webcam image is highlighted in the
- Foreground when it is selected
- Temperature values set and detected

File Manager

Section	Select:
File Manager	G-Codes

Files uploaded by File Manager are sent to the internal memory of the machine. After the file is loaded via the web interface, a print job can be started from both the Sharebox 3D and the front display of the client machine.

Managing Gcodes From the G-Codes File Manager

Upload a file remotely

From File Manager it is possible to upload files with a *.Gcode extension to the

internal memory of the machine.

To load a file:

- GCODE upload (a pop-up window opens),
OR Select files (opens the Explorer window of the local computer),
- Choose the file with the Gcode extension.

The file is loaded into the machine's internal memory and appears in the file list in alphabetical order.

Start a remote print job

From File Manager, you can start a print job by using a file in the machine's internal memory.

- Print (opens a pop-up window),
- choose No / Yes to abandon or confirm the start of the print job.

Delete a file remotely

From File Manager, you can delete a file from the machine's internal memory.

- Select Delete (a pop-up window opens),
- choose No / Yes to abandon or confirm the deletion procedure.

The file is deleted from the internal memory of the machine and disappears in the file list.

From this menu you can access various settings:

Notifications

Section	Select:
Configure	Notifications

The printer is able to send email notifications about the main events via Sharebox:

- Press start
- End of print
- Change filament
- Hardware problem

It is possible to set one or more email addresses (separated by a space) to which to send notifications, which can be selected as desired among the four default proposals.

TEST: only after saving the configuration, it is possible to verify the correct insertion of the data by sending a test email.

SMTP SERVER:

In this section you can make the classic configuration to send and receive emails.

WIRELESS LAN

Section	Select:
Configure	Wireless LAN

To configure the wireless connection, first connect the printer to the network using the ethernet cable, access Sharebox3D via the IP supplied by the printer ("gear" menu → "configuration" → "network config.").

Now from the wireless lan menu you can activate or deactivate the WiFi connection, choose the network to which the printer (SSID) to connect by scanning the available networks, choose the type of security (WPA - open).

Once the connection has been configured click "SAVE" and the next confirmation.

Now from the printer display select "WiFi Config.": Using the IP address provided by the printer you can connect to it in WiFi mode.

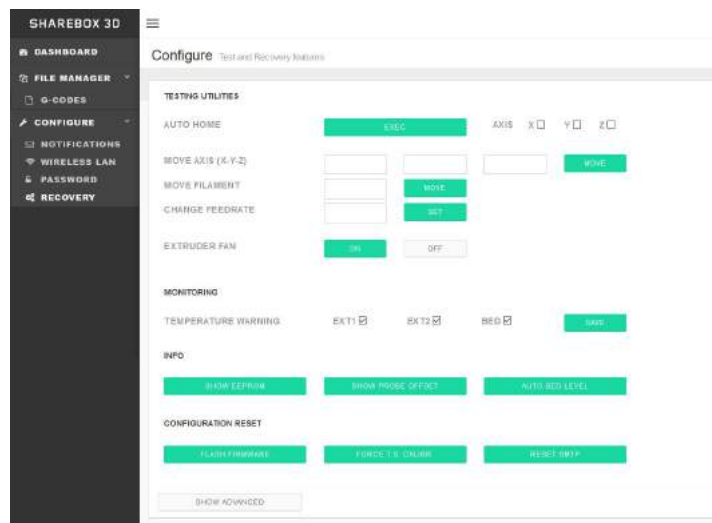
PASSWORD

Section	Select:
Configure	PASSWORD

Here you can change the password for the login credentials to Sharebox 3D

Pre-set password: "Sharebot" (with capital S).

SHAREBOX 3D Recovery Menu



Section	Select:
Configure	Recovery

From the main menu you can access the Recovery Menu by going to *Configure>Recovery*.

The recovery menu can be used to test and diagnose issues. Use this menu with caution. This page contains the following subsections:

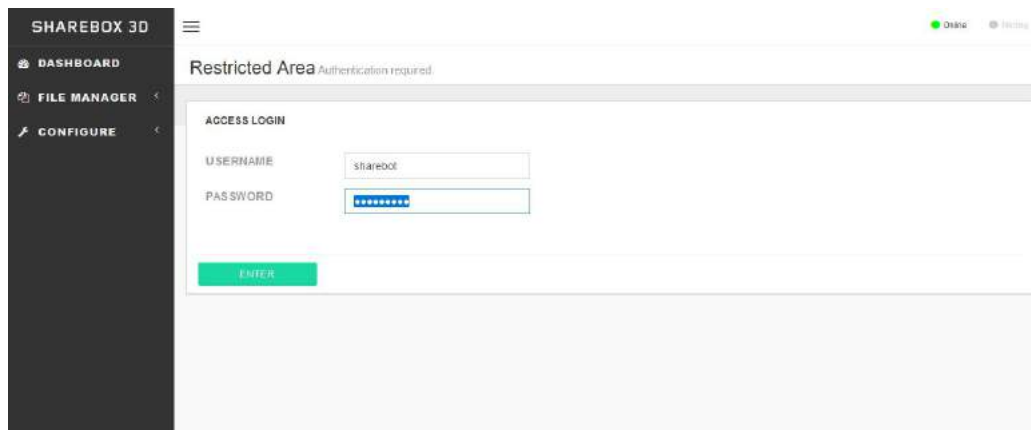
- *Testing Utilities*
 - **Auto Home Axis:** will home the checked axis. If no axis is selected it will home all of them.
 - **Move Axis :** Move the desired axis by filling the amount to move in each field (x,y,z)
 - **Move Filament :** Extrude or retracts (use positive and negative numbers)
 - **Change Feedrate :** change feedrate for the movement (If empty uses default)
 - **Extruder fan:** Enable/Disable Extruder Fan.

- *Monitoring*
 - **Temperature Warning:** Enable Disable Temperature Warning for the selected sensors (see the Temperature Warning chapter)
 - Info
 - **Show EEPROM :** Shows the current Firmware config
 - **Show Probe Offset :** shows the distance between the probe and the nozzle(s) as saved in the EEPROM
 - **Auto Bed Leveling:** Performs the Auto Bed Leveling Procedure.
 - **Configuration Reset**
 - **Flash Firmware:** Will flash the firmware when the unit is restarted.
 - **Force T.S Calibration :** Starts the Touch screen calibration when the unit is restarted

- **Reset SMTP:** restarts the SMTP server.
- *Show Advanced* (see: Advanced Maintenance Menu)
- *Recently Sent:* Shows the recently sent commands and the resulting output.

SHAREBOX 3D Advanced Maintenance Menu

The sharebox Advanced maintenance menu is accessible only to Sharebot-qualified technicians and official resellers.



The screenshot displays the SHAREBOX 3D interface. On the left is a dark sidebar with the following menu items: SHAREBOX 3D, DASHBOARD, FILE MANAGER, and CONFIGURE. The main content area is titled "Restricted Area" with a sub-header "Authentication required". Below this is a form titled "ACCESS LOGIN" containing two input fields: "USERNAME" with the value "sharebot" and "PASSWORD" with masked characters. A green "ENTER" button is positioned below the password field. In the top right corner of the interface, there are status indicators for "Online" (green dot) and "Testing" (grey dot).

Sharebot Cure



Sharebot Cure is the post curing box especially designed to treat the Sharebot BIG resins.

Cure installation:

1. Fill the transparent plastic box with enough water to submerge the printed parts;
2. Place the Cure box on the plastic box;
3. Plug the Cure box to 220V power socket;

Using Sharebot Cure:

1. Open from the top the Cure box and add your printed object into the Cure box, under the water surface;
2. Close the top door and touch from the front panel:



- a. The “power” symbol to turn on/off the light without time limitation;
- b. The “timer” symbol to select the desired curing time, each click correspond to one hour, after selected the desired time click the “power” symbol to start the cycle;

Suggested curing time under water for Sharebot Big resins are 6H.

Tips & Tricks

Printing plate calibration

Is important to calibrate the printing plate every time before launch a printing job.

Check the Fep status

1. Check before launch a new printing job the status of the FEP on the bottom of the tank;
2. To achive always good results, change your FEP foil every 5Kg of resins;

Z axis misalignment

If for any reason the two Z axis alluminium block are not alligned:

1. Add a drop of the oil contained within the accessories kit to the top of the Z-axis screw and the Z-guide;



2. Move the Z axis blocks, without the printing plate, to the top with “Plate Up”. Move the blocks untill all the two blocks will loose steps on the top of the axis;
3. Launch “Homing”;

Crack in models



If your model has cracked, it should be made hollow. Use a wall thickness of 2-3mm. We recommend that large models are always hollowed.

If the model has very fine detail, we recommend the following :

Placing the model at a 45 degree angle on both the x and y directions.

Hollowing your model will also help you save resin and reduce your print cost!

Delaminations



Delamination is a sticking issue and has a number of possible causes:

1. Cured or liquid resin on your LCD screen. If there is any resin on your screen, your vat has probably leaked and caused your model to delaminate. Mop liquid resin up with an absorbent paper towel and chip away any cured resin carefully with a plastic card.
2. Always remember to clean your vat thoroughly between every print. Any solid resin in the vat or on the vat film can adversely affect your next print.
3. Mix very well the resin and check that the resin temperature is not under 18°C at the start of a print.

Holes in model



When the platform moves down, resin pressure inside a flat, hollow model can force a break in the wall of the model, creating holes.

Hollow models cannot be printed flat on the platform, they must be placed at an angle.

1. Lift model up 5-10mm away from the platform.
2. Position model at a 10-15 degree angle.

Lines on printed models



Reasons for lines on your printed model can be:

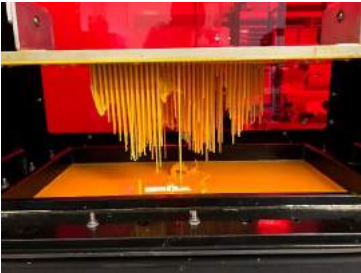
1. Overused tank film. If the same tank film has been used for many prints, the tank film will start to stick more to your print, creating unwanted lines. Cloudy or dirty tank film can also cause indented lines in your model.

Fitting problem



If your printed model parts do not fit together as designed, check the fitting tolerance in your cad files and check the resin design guide.

Only support printed



If your printed platform only has supports attached, check the support position, quantity and dimension choose in the slicing software.

Sticky model



If your model is sticky after post-curing, the cleaning procedure was not followed correctly.

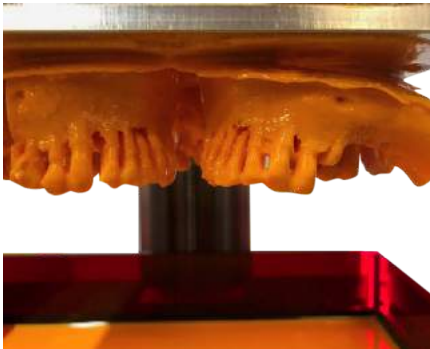
To reduce stickiness you will need to thoroughly wash the model again using the resin cleaner or IPA. Repeat the water curing cycle.

Vat leak

If your tank film has leaked, you will need to re-skin the tank before printing again. A tank leak on your LCD screen and a damaged tank will adversely affect your print.

1. Remove the vat from the printer and place on absorbent paper. If your vat has been removed and there is no resin on your screen, proceed to Step 4. If there is resin on your screen, proceed to Step 2.
2. Mop up any liquid resin from your LCD display screen with absorbent tissue and then clean the screen with a damp cloth and detergent.
3. If you have cured resin on your LCD display screen, remove this by chipping it off with a credit card or plastic scraper. Metal scrapers should only be used with extreme care to avoid scratching the screen.
4. To reskin your tank, please refer to the manual procedure.

Warping



Warping is caused when large models are printed flat on the build plate. To avoid warping when printing models with a large surface area, follow the instructions below.

1. Rotate your model to a 45-degree angle.
2. When printing models at an angle, supports are essential. Manually add supports according to the size of your print and the printer you are using.

Rotating your model and adding supports will not only discourage warping, but will also help to reduce shrinkage.

Support part missing



If some of your supports are missing please check the following:

1. Has your tank leaked? If your vat has leaked you will need to clean your display screen and reskin your tank according to printer User Manual.
2. Are you using enough supports? Check the number, size and position of the support, a missing support on the object can generate a domino effect that end in a big missing part of the object.
3. Are your supports the right size? Check the design guide for the used resin.

