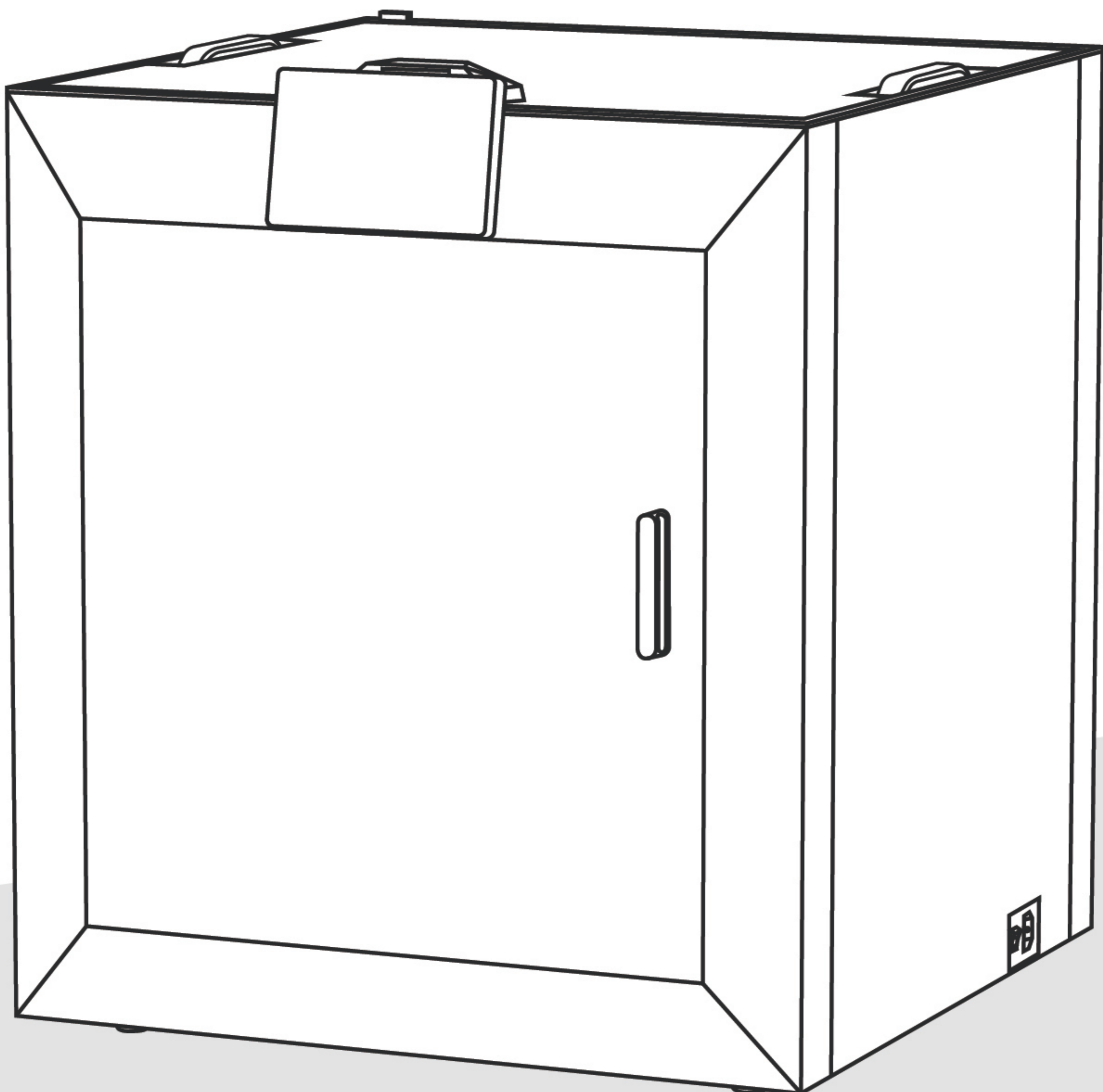


# PLUS 4

## Quick Start Guide

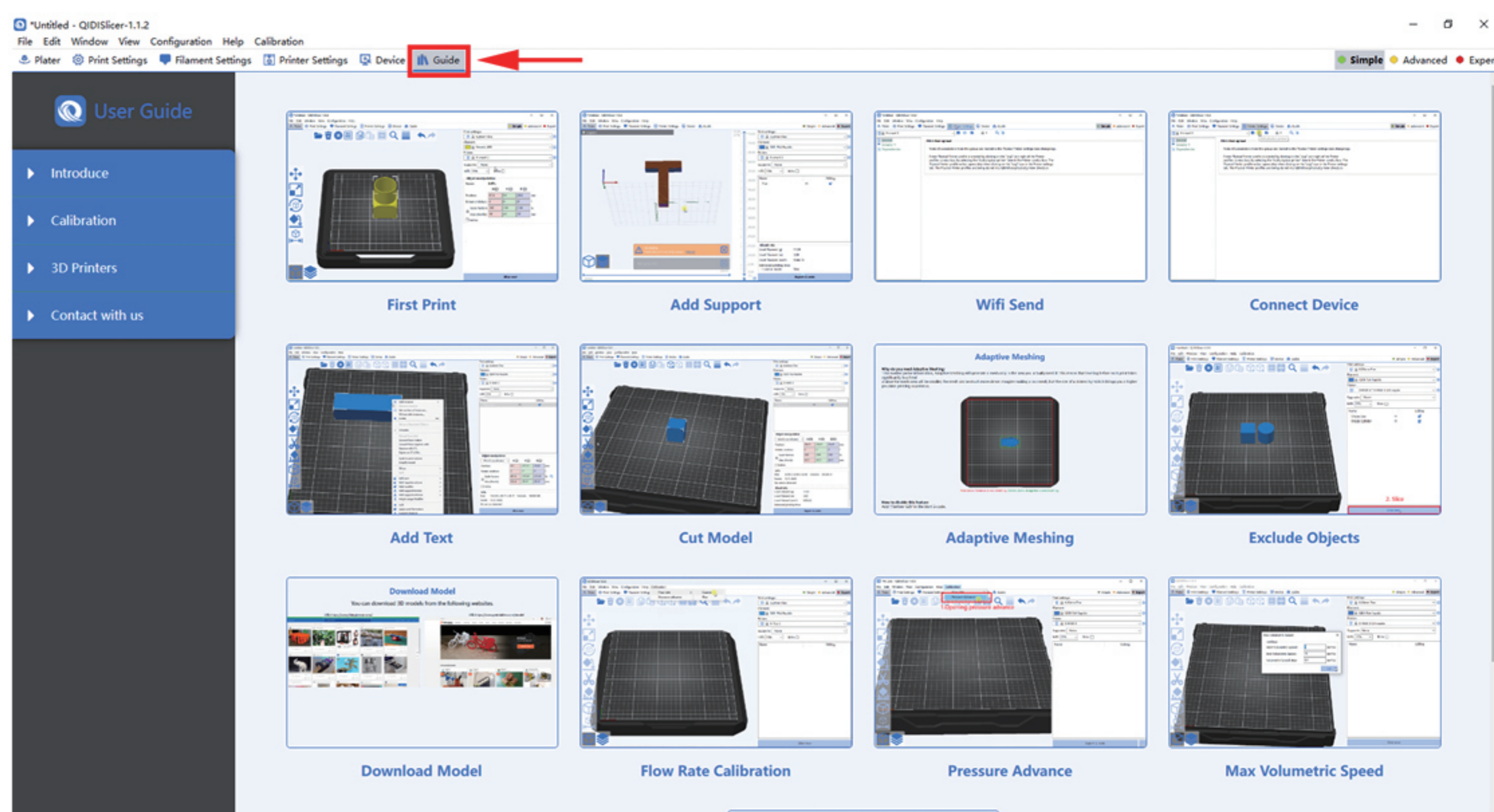


## Usage Notice

- 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 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.
- 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 warranty. 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 recover the factory system files, you need to purchase the EMMC-Adapter additionally.

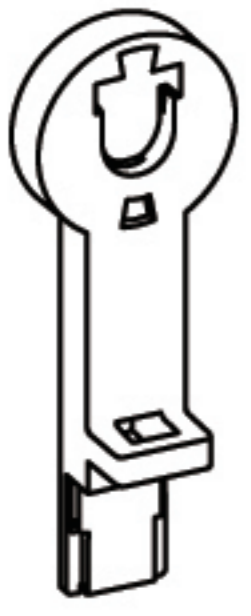
## QIDISlicer

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.

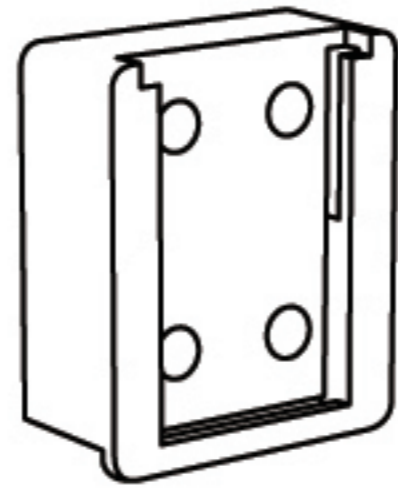


## Accessory List

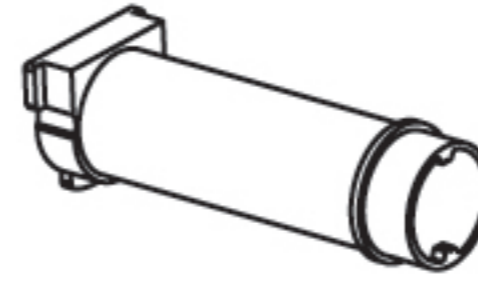
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Filament Extension  
Bracket



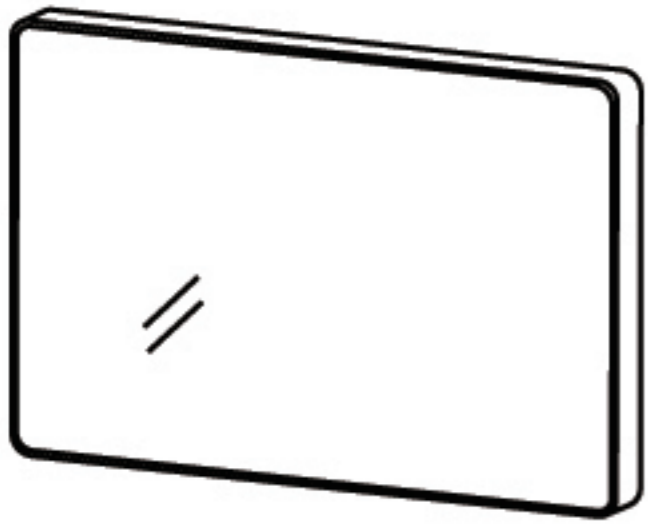
Extension Bracket  
Fixing Block



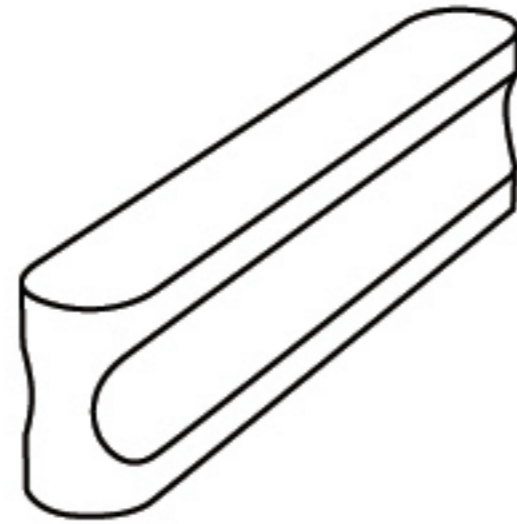
Filament  
Spool Holder



Holder Cover



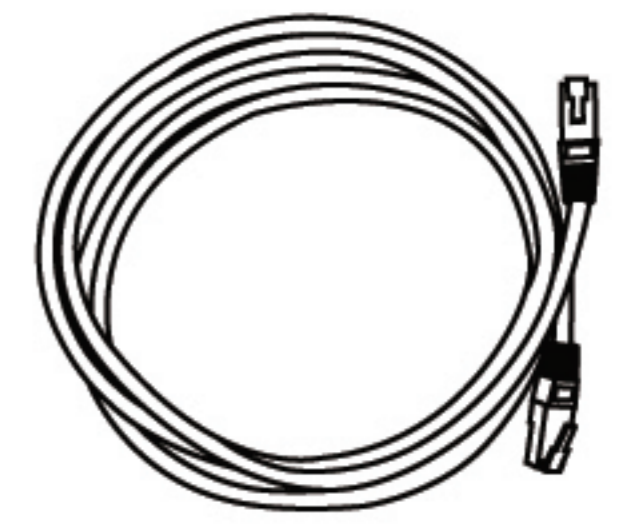
Touch Screen



Door Handle



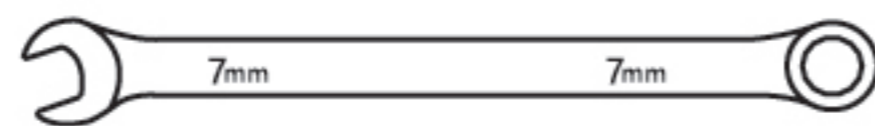
Power Cord



Ethernet Cable



Allen Key H1.3  
Allen Key H1.5  
Allen Key H2  
Allen Key H2.5  
Allen Key H3



7mm  
Spanner



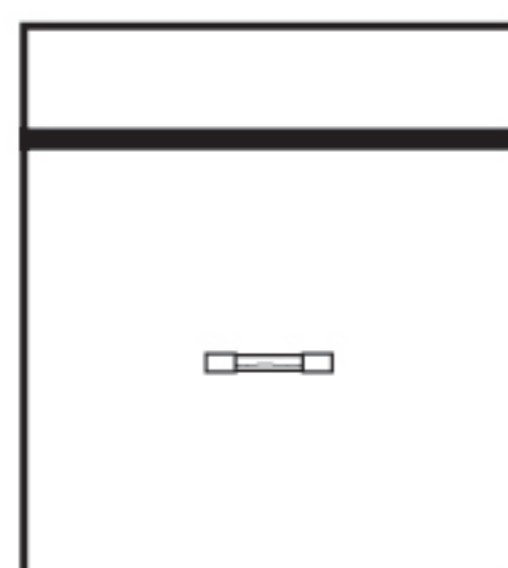
Flat Head  
Screwdriver



Scraper



Glue Stick

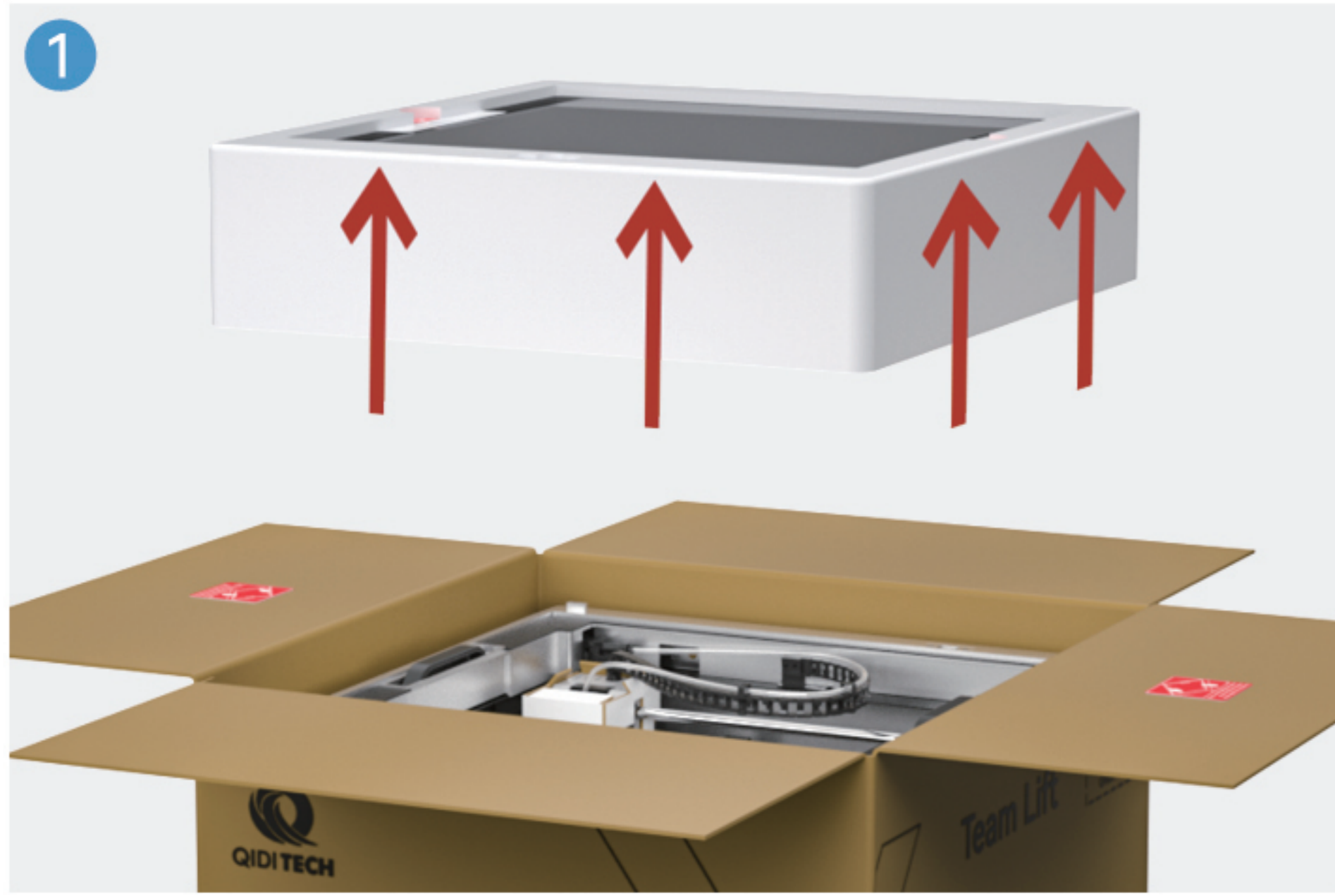


Spare Parts Kit



USB 2.0  
Flash Drive

## Starting Up

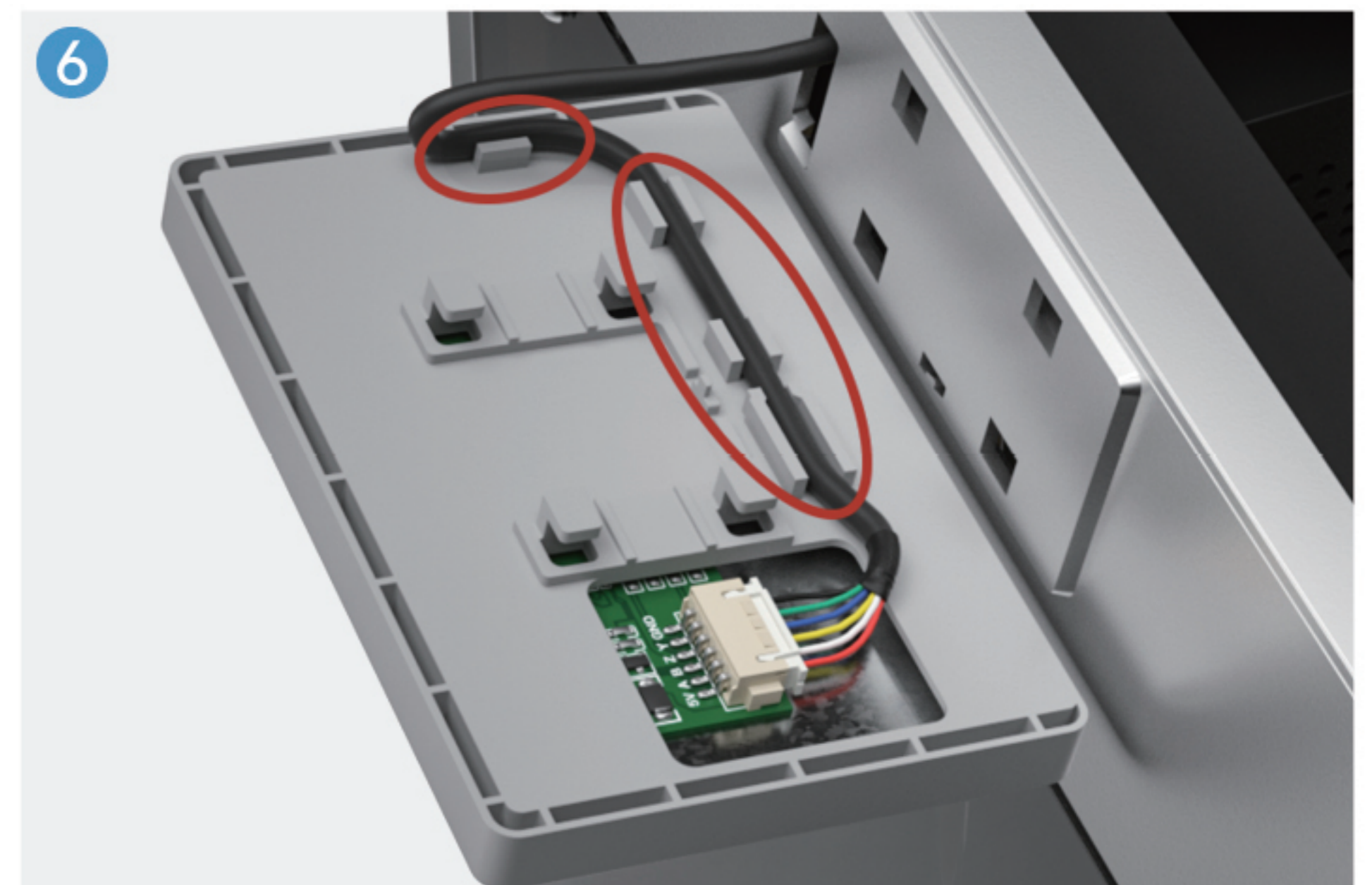
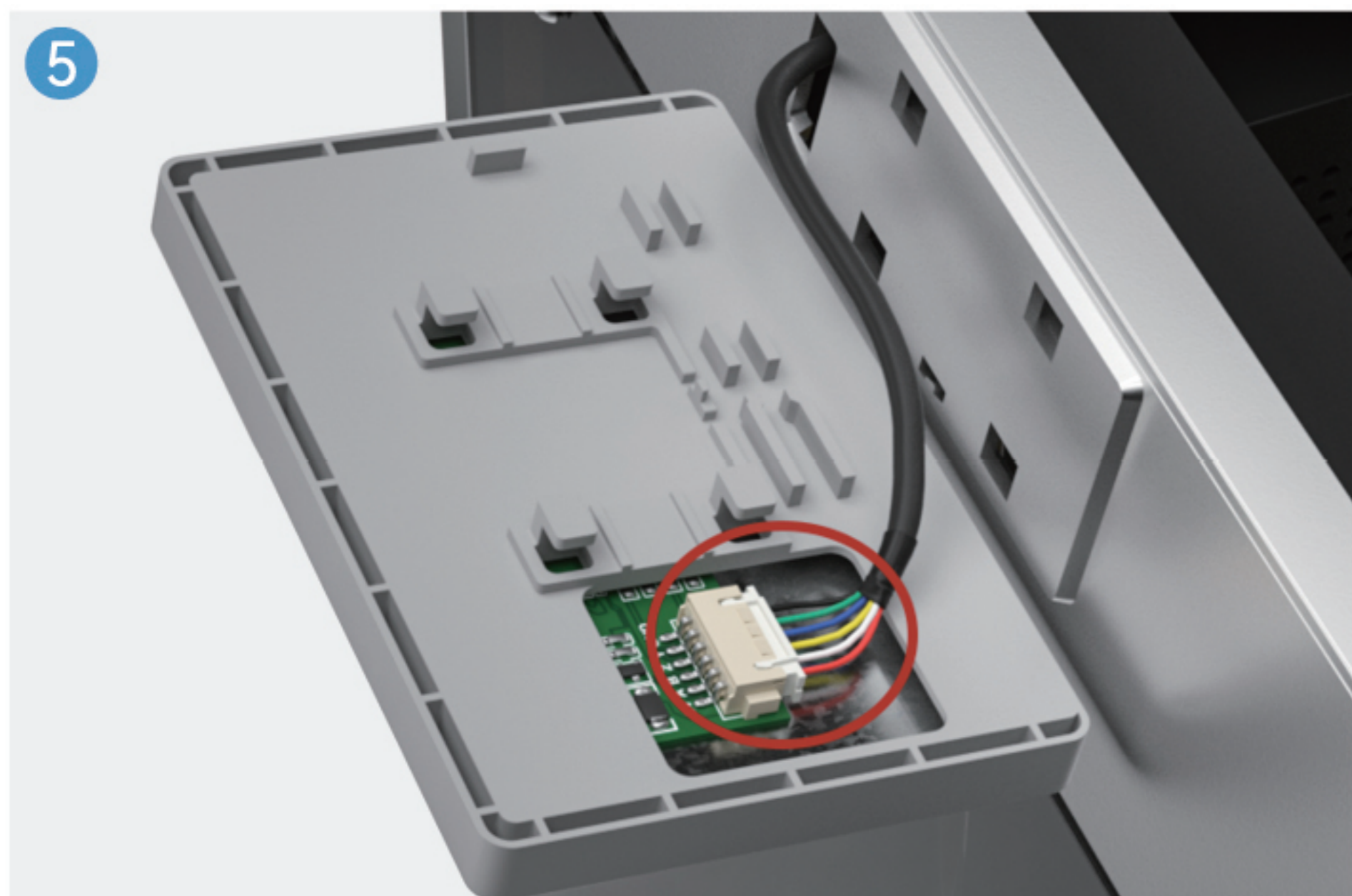


Remove the upper foam and take out the printer.

**NOTE:** The upper foam contain the glass top cover. Please handle with care. Additionally, please note that there are accessories at the bottom of the carton.

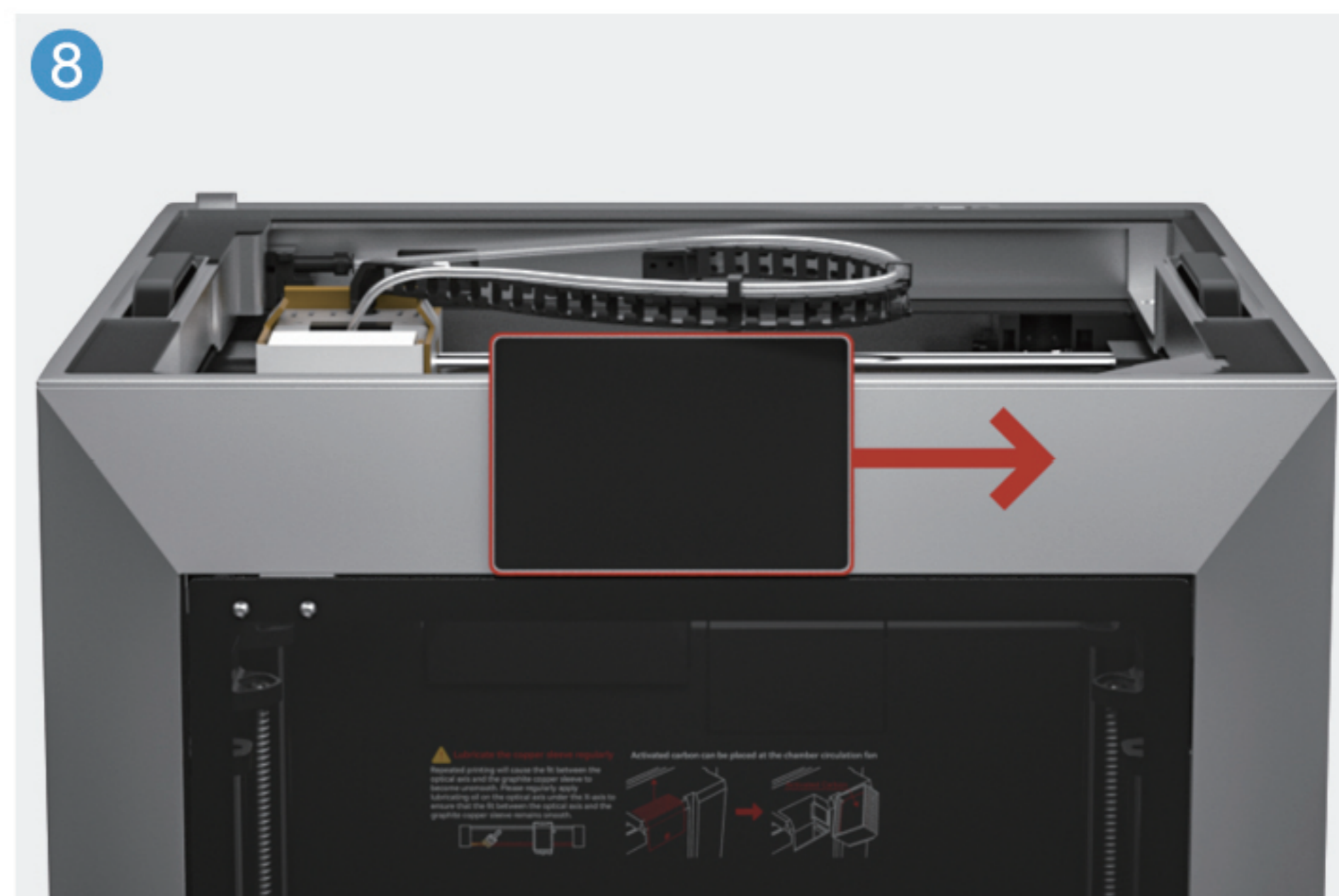


Take out the door handle from the accessory box, and remove the M3 screws and plastic plugs on the door handle. First, insert the plastic plug into the corresponding hole on the door from the inside of the machine door, then align the door handle with the hole on the door and fix it with the M3 screws.



Take out the screen from the accessory box, insert the connecting cable plug on the machine into the screen interface, and install the connecting cable into the corresponding card slot of the screen.

**Note:** Wind the connecting cable around the outside of the buckle on the far left side of the touch screen to avoid interfering with the installation.

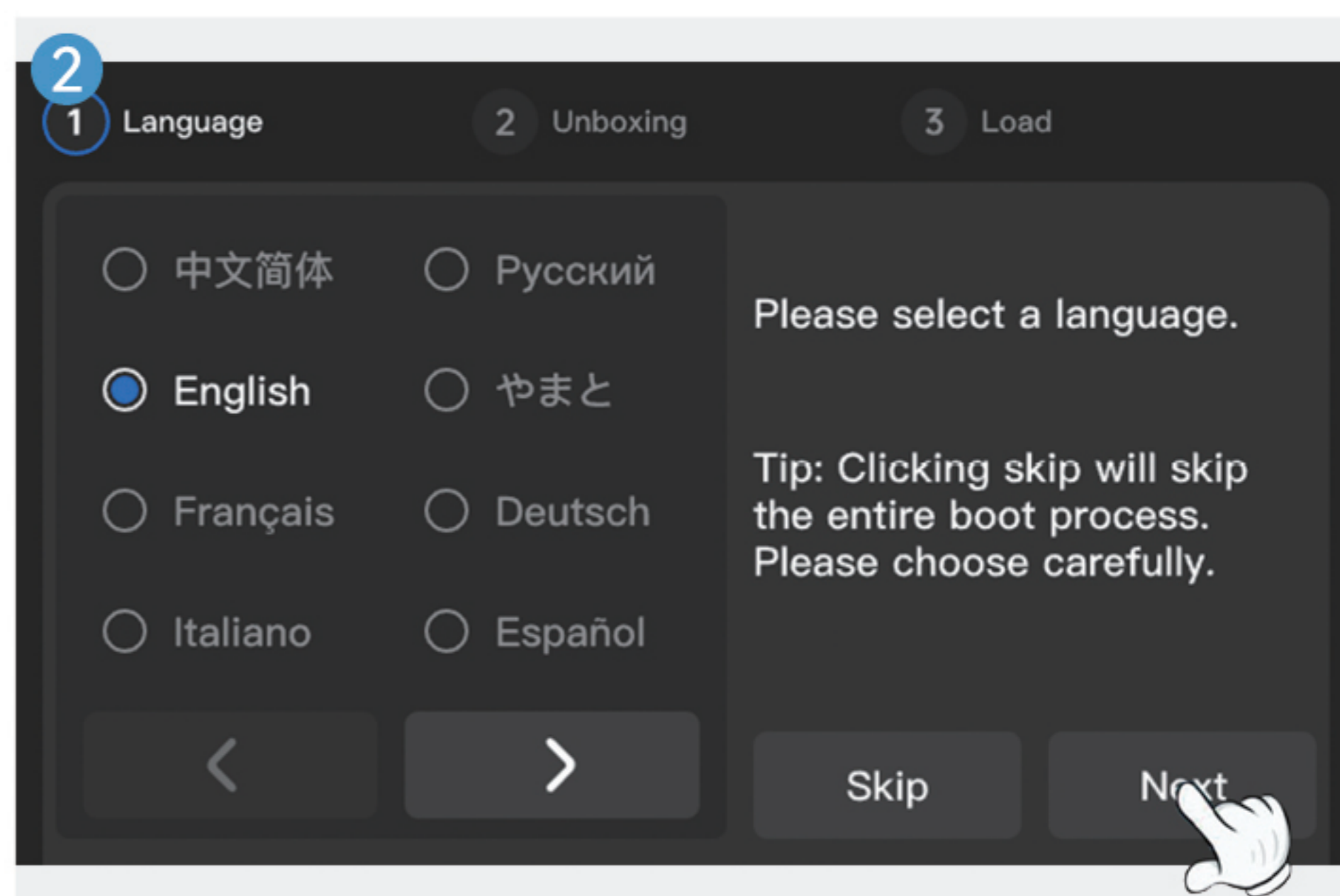


Insert the touch screen into the corresponding groove of the printer and push it to the right to lock it in place.



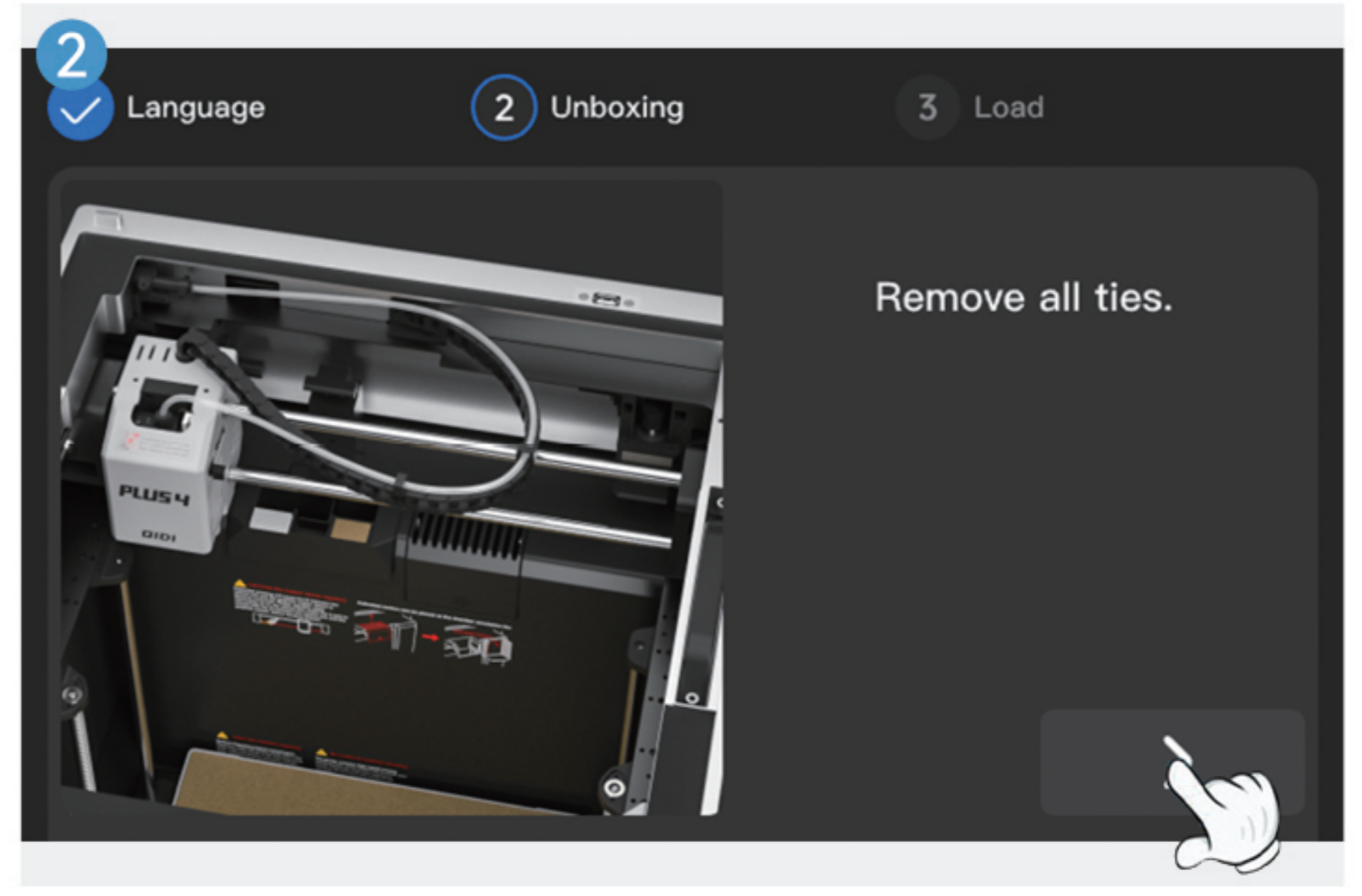
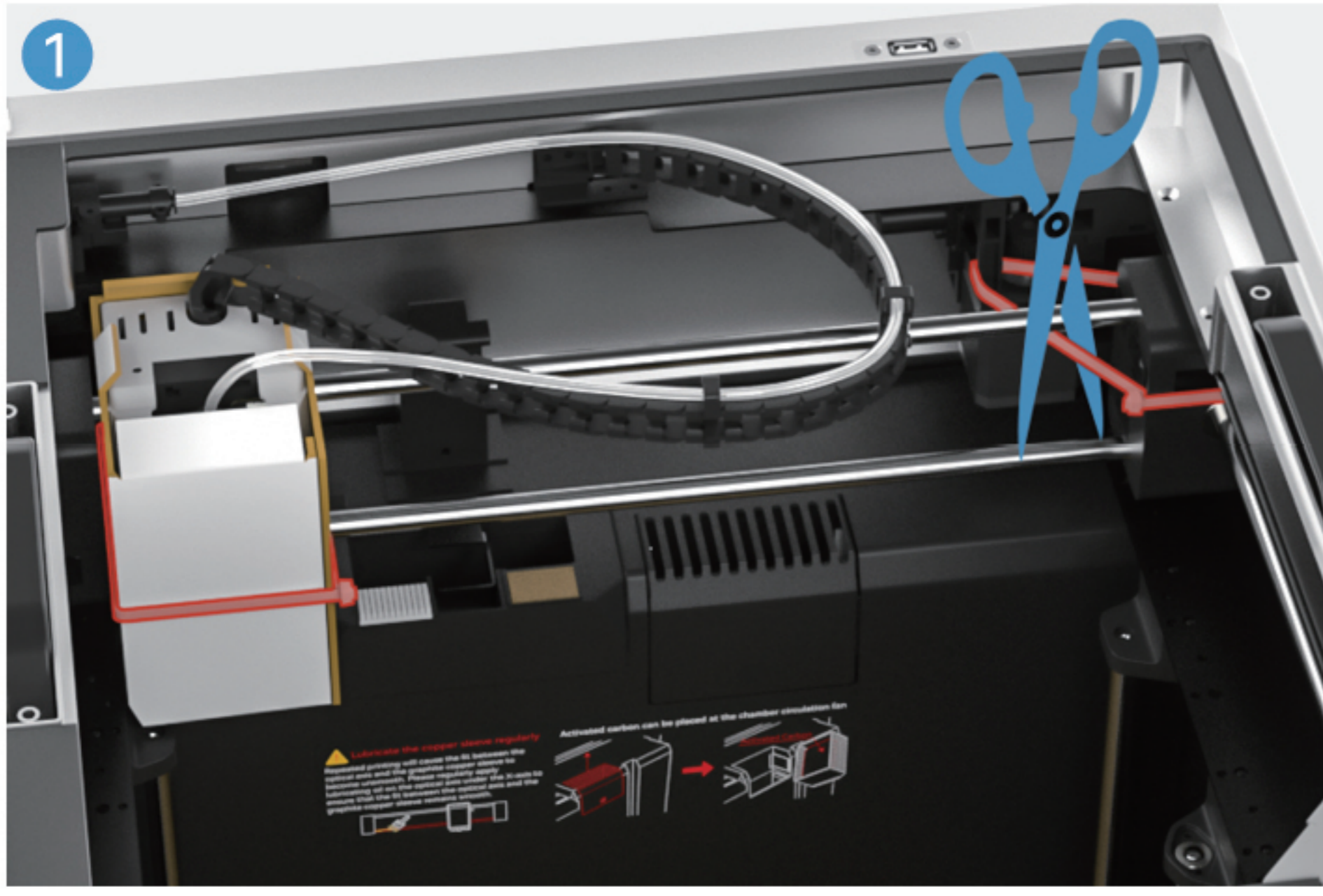
Remove the power cord from the bottom of the carton and plug it into the printer. Turn on the printer and follow the on-screen instructions to complete the unpacking and load the filament.

## Language

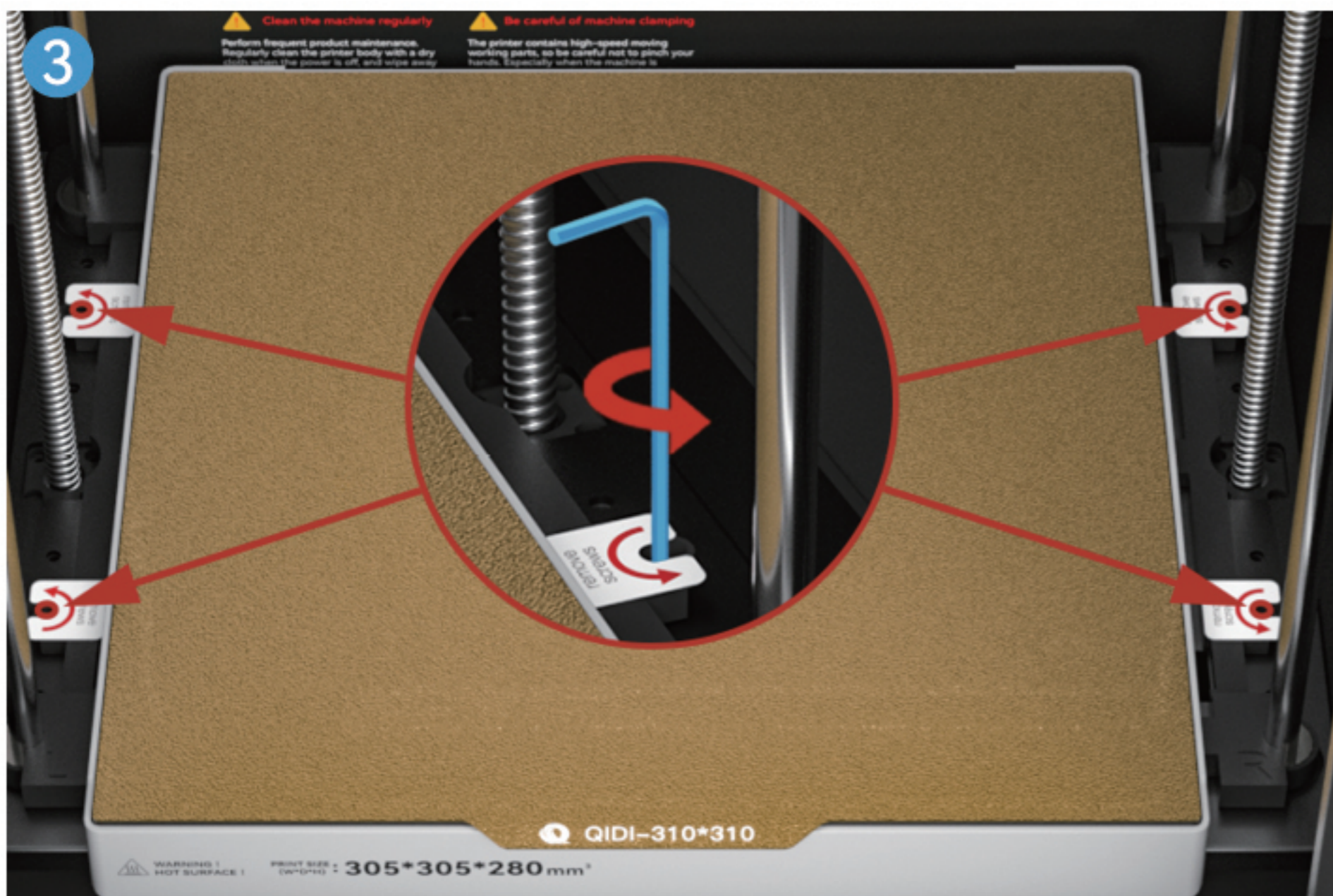


Please select your preferred language and click 'Next' to continue.

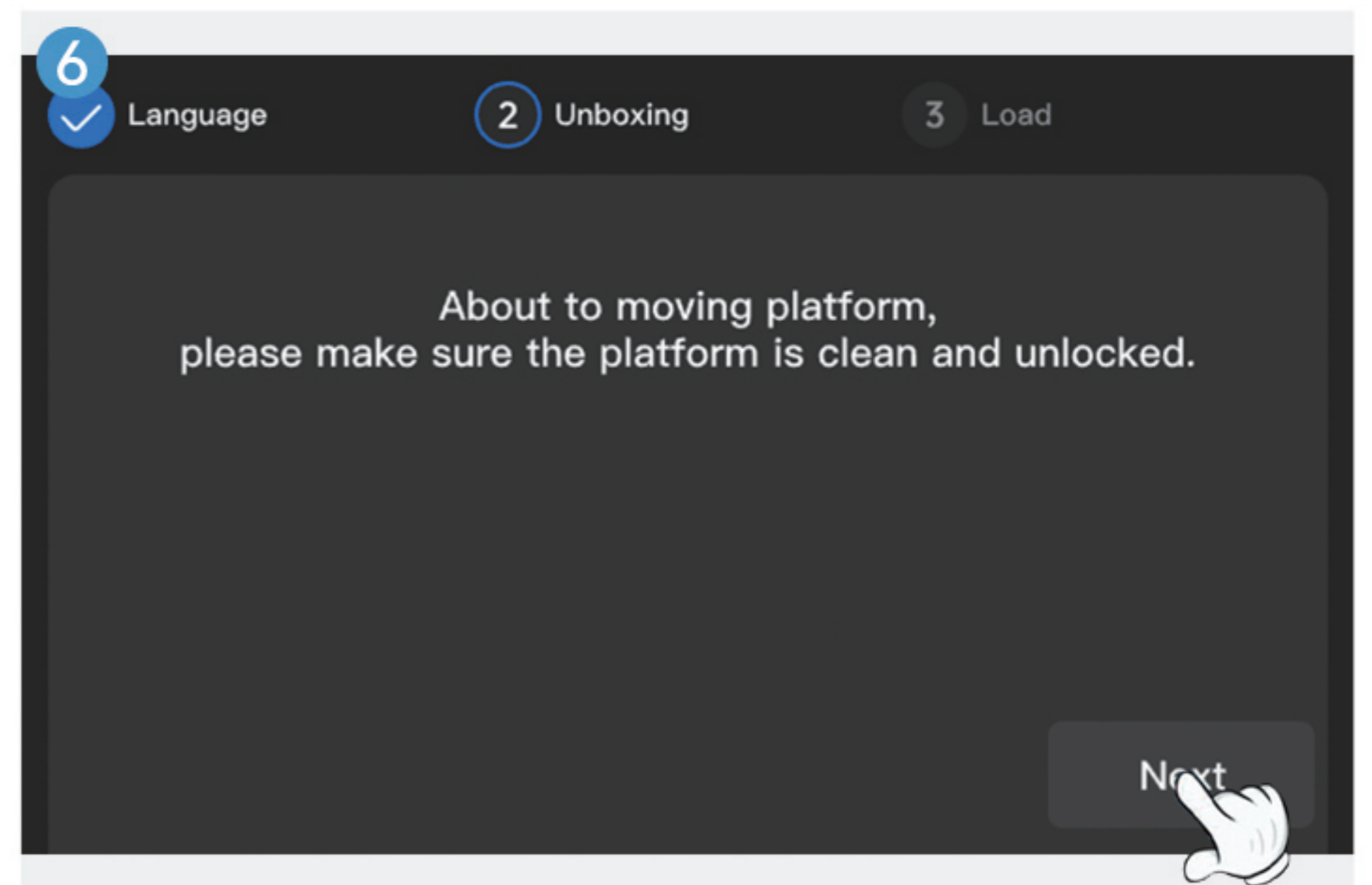
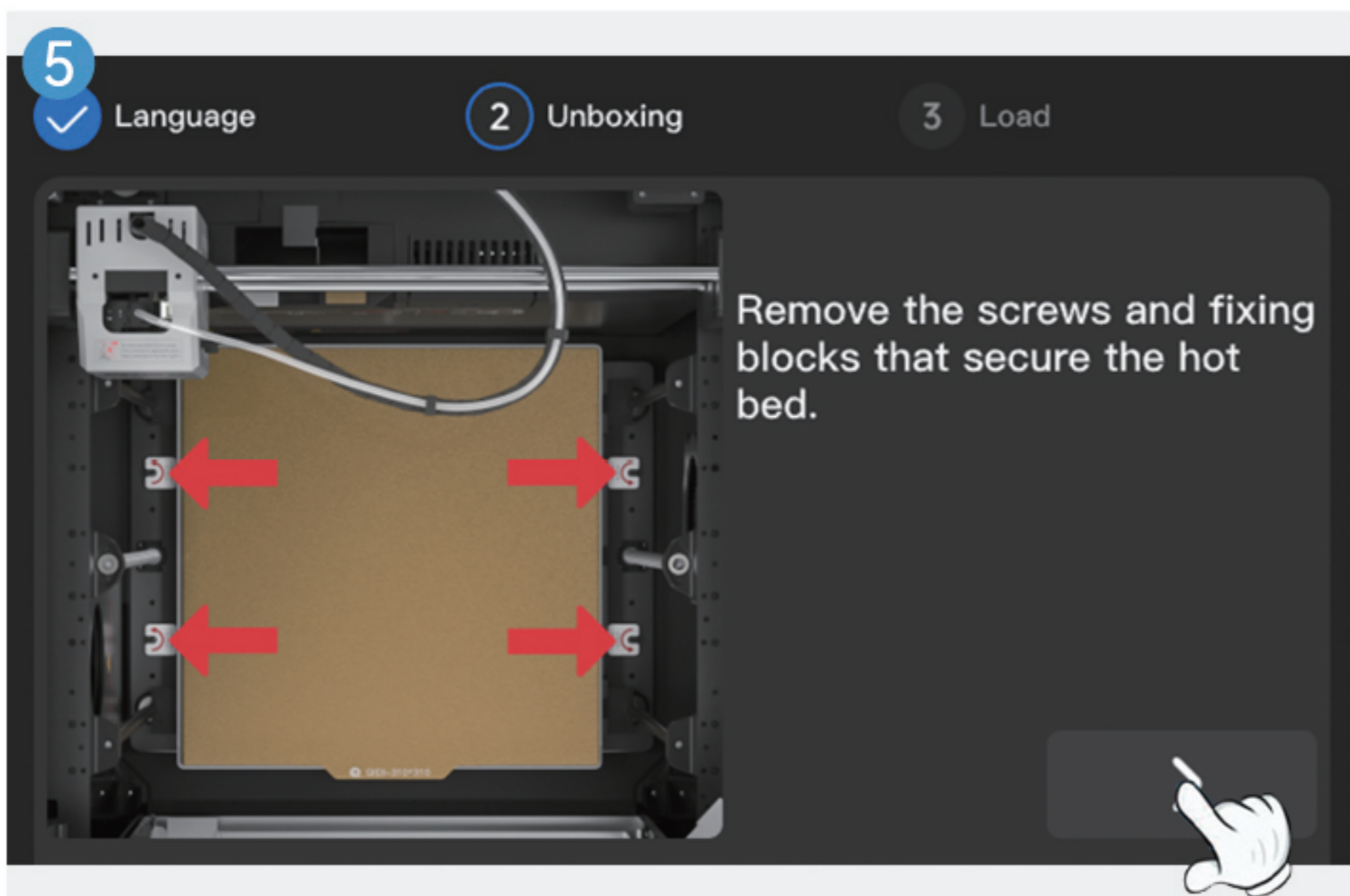
# Unboxing



According to the on-screen instructions, remove the cable ties that secure the print head and X-axis, remove the cardboard and tape on the print head, and then click Next.

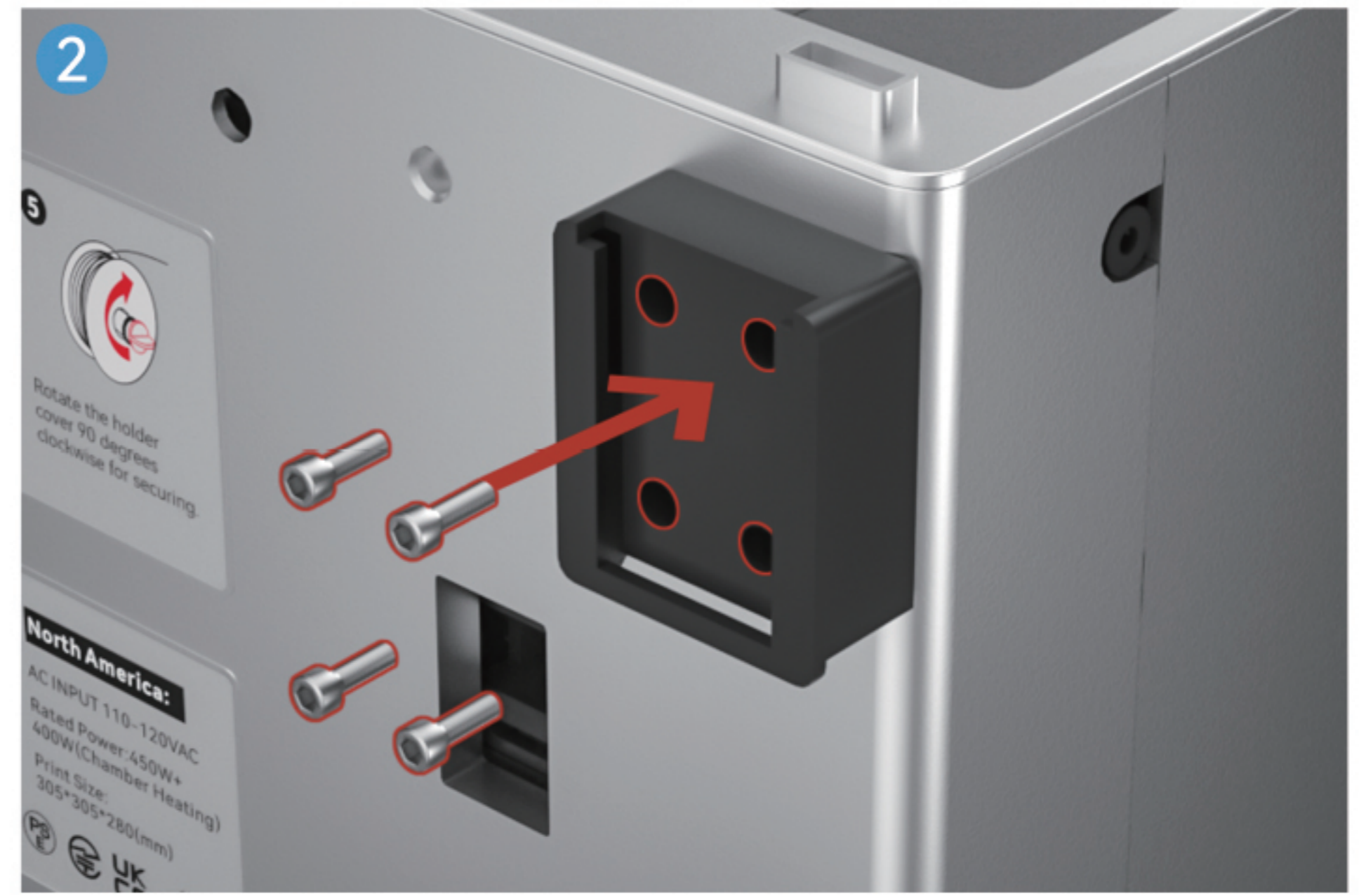


Follow the on-screen instructions to remove the screws and retaining blocks that secure the printing platform.



Click 'Next'. Ensure the print bed is unlocked and free of any debris before proceeding.

## Load Filament



Retrieve the illustrated accessories from the bottom of the carton and install them according to the on-screen instructions.

Remove the retaining block from the filament extension bracket and secure it to the back of the machine with the screws.

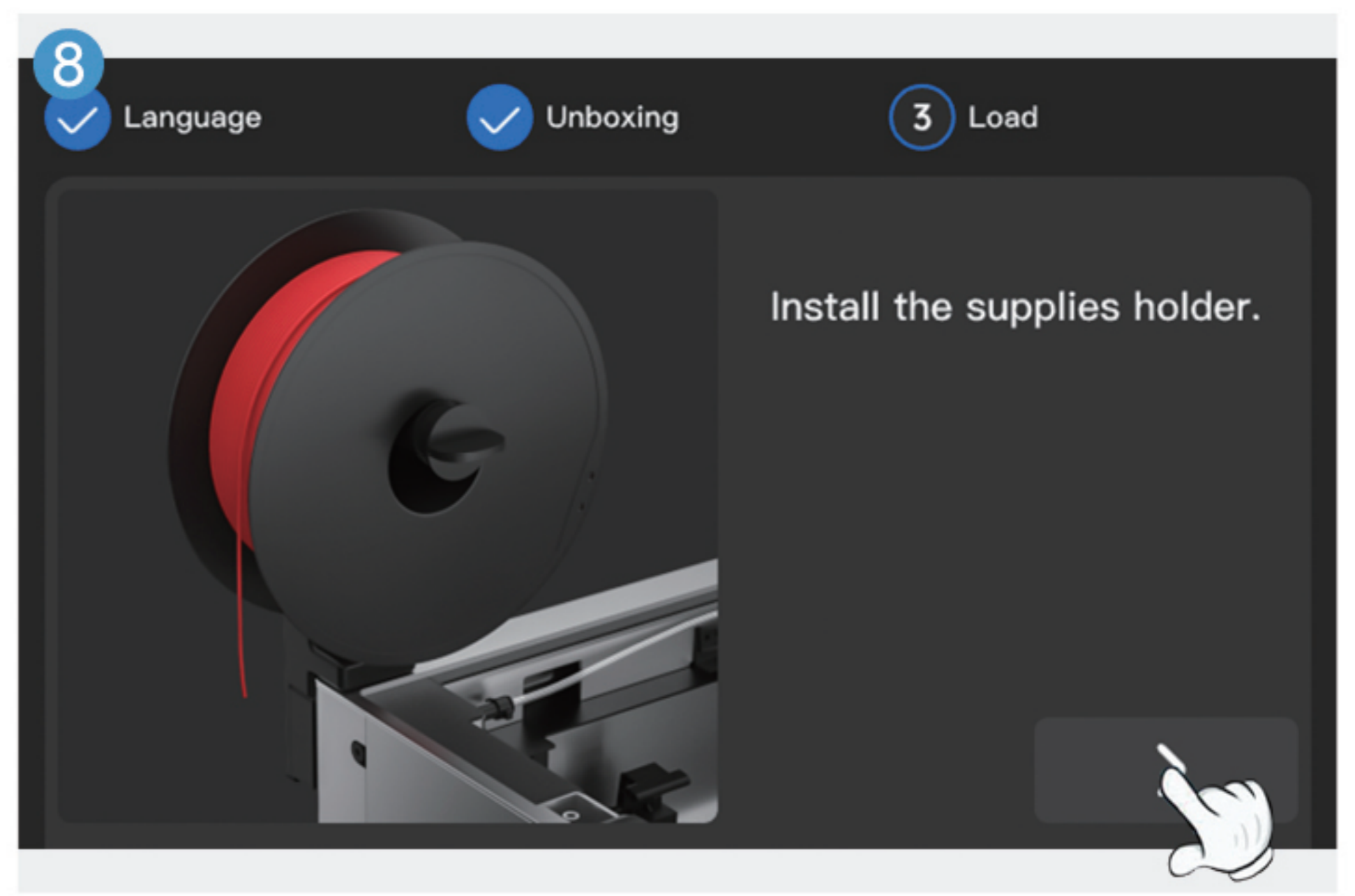
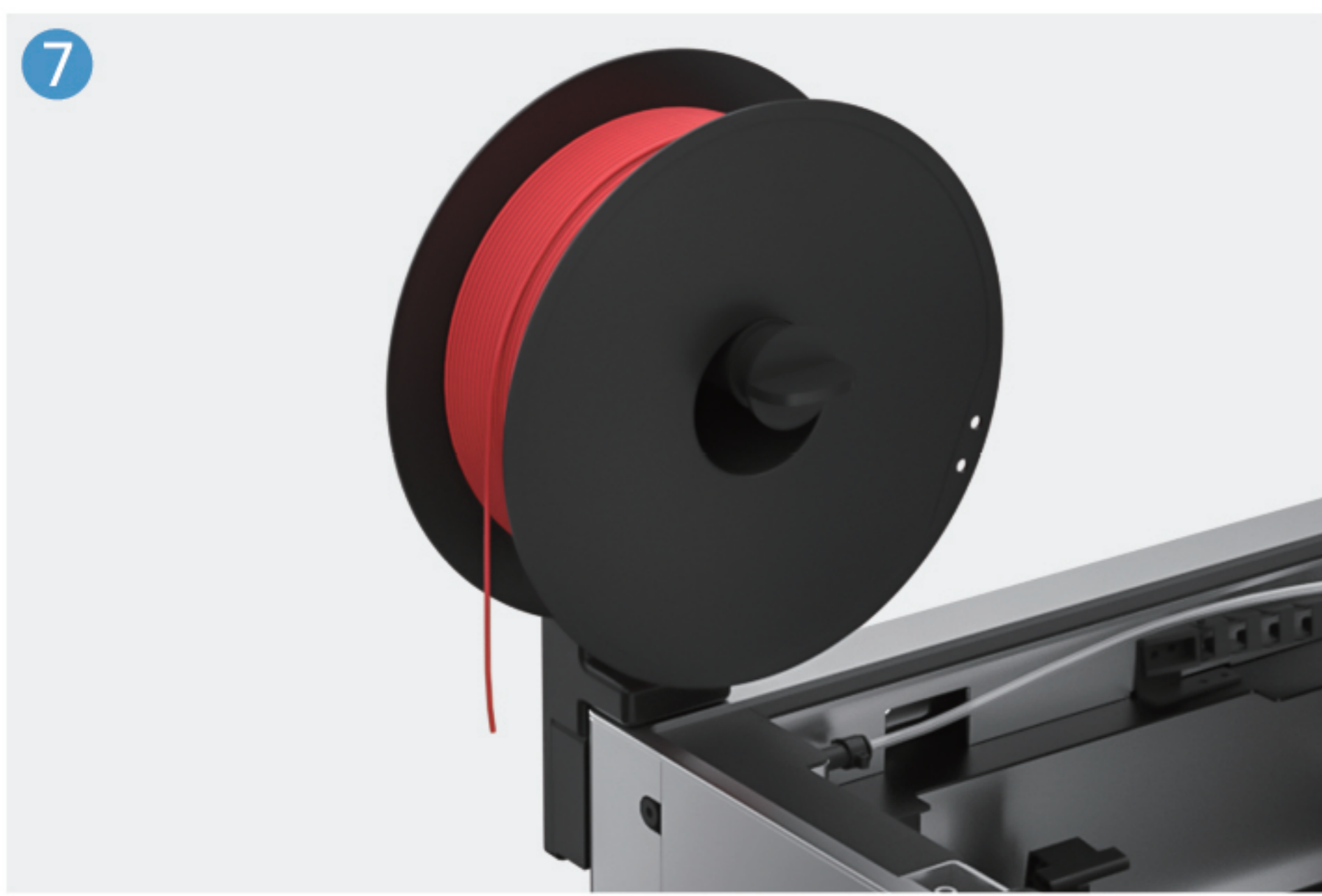
Tips: The screws for fixing are on the back of the machine.



Attach the filament extension bracket to the extension bracket fixing block.

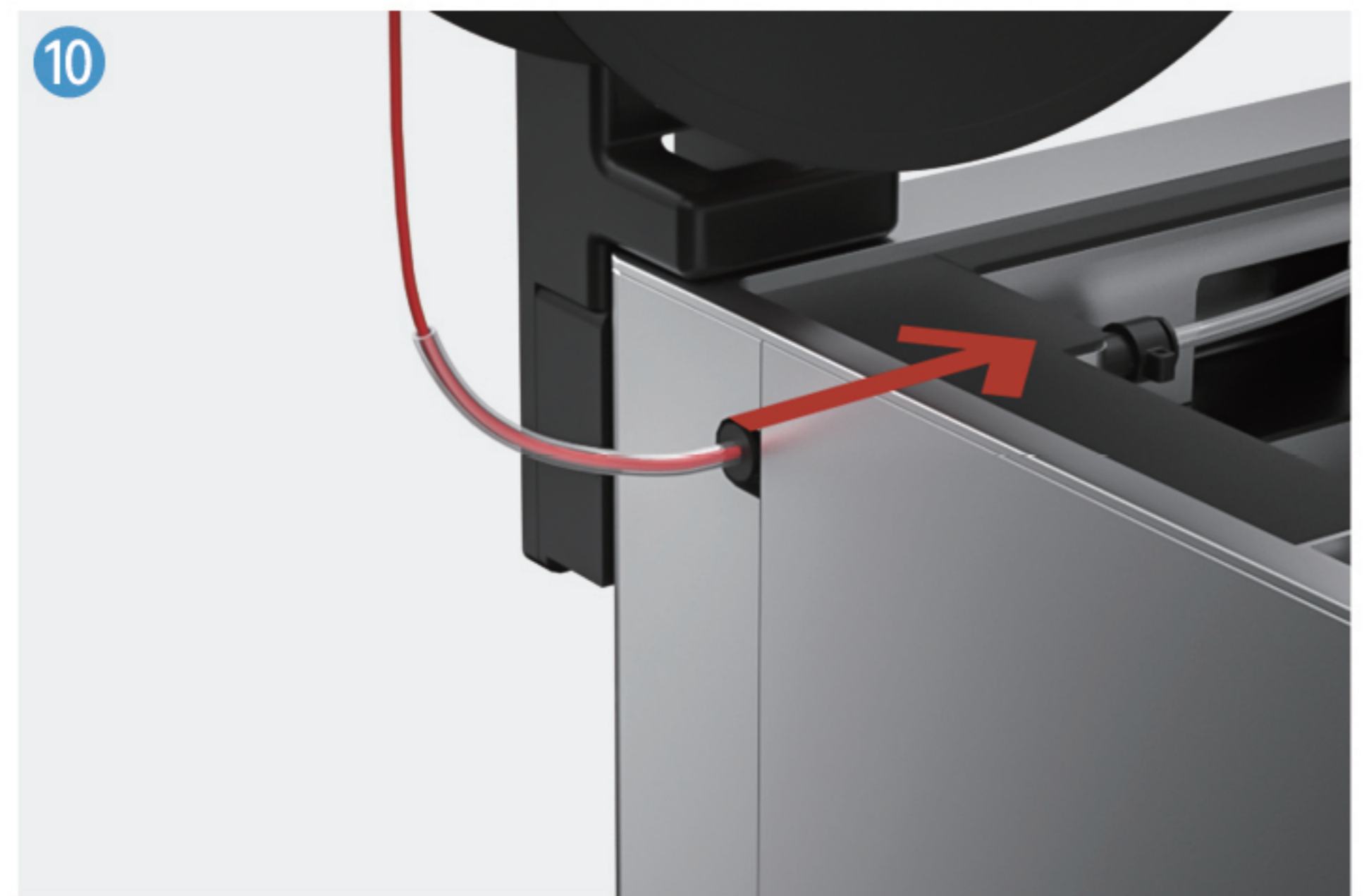


You can refer to the sticker tips on the back of the machine for installing the filament holder onto the filament extension bracket.

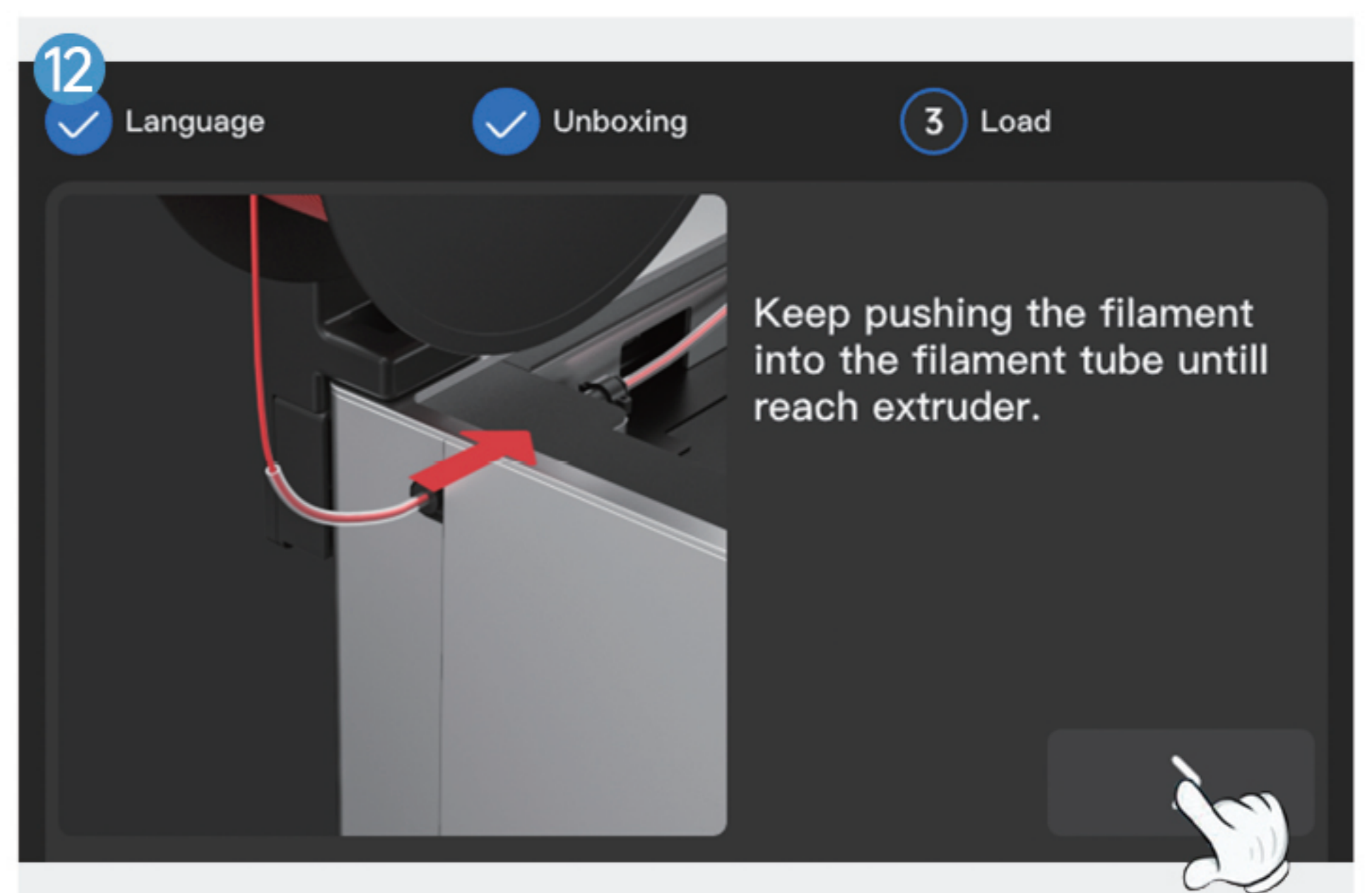


Place the filament on the filament holder and click 'Next'.

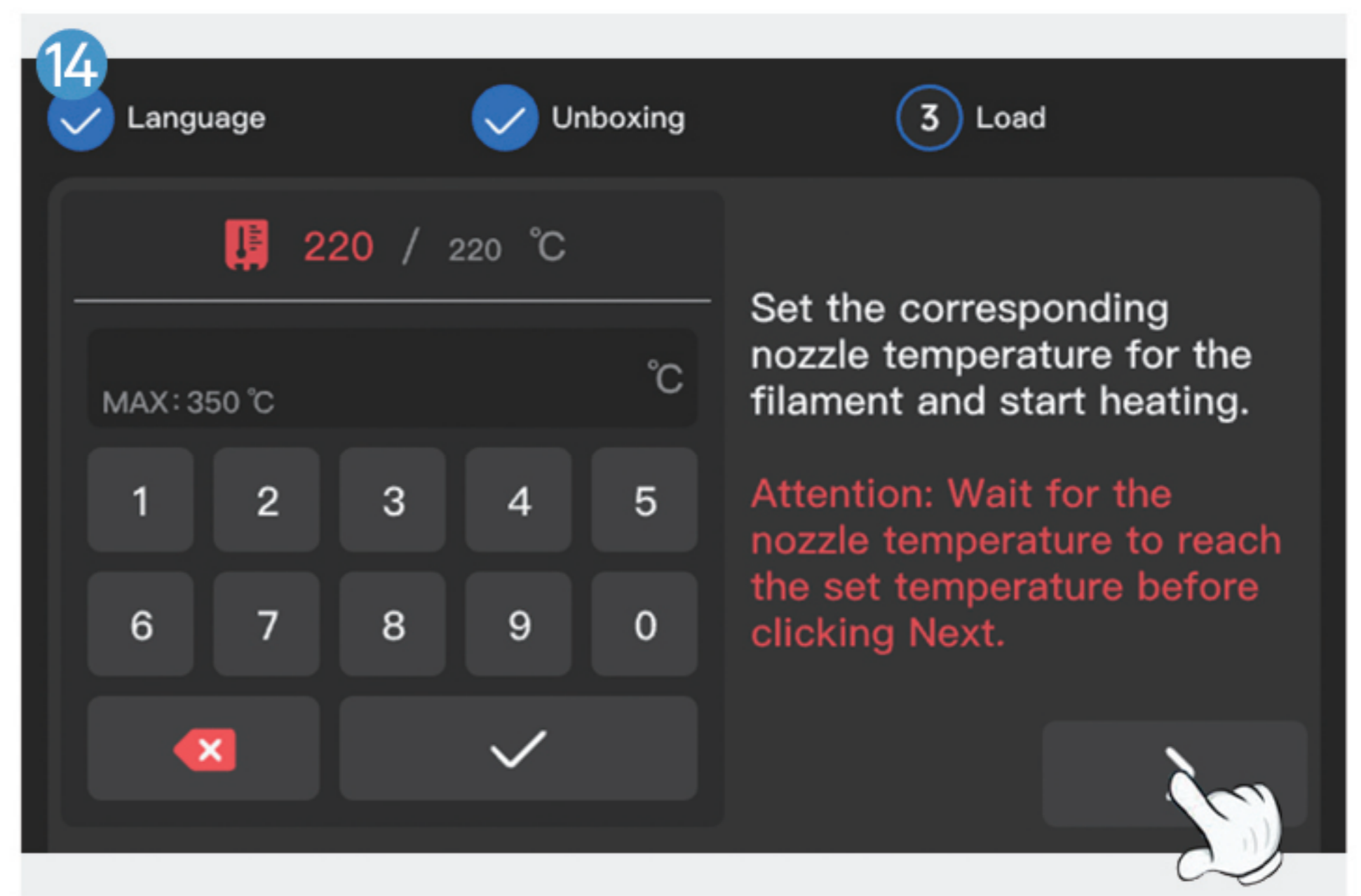
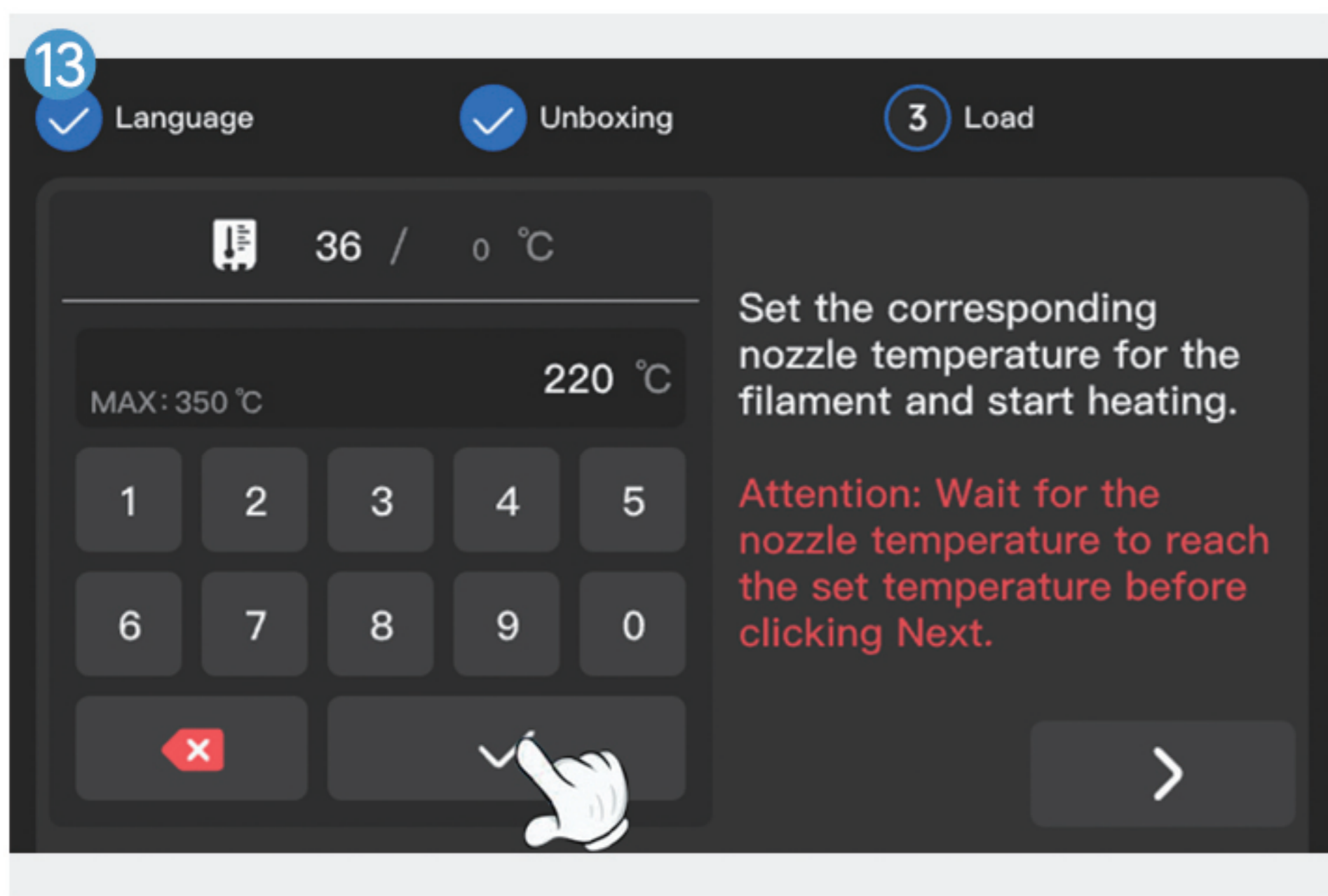
**Note:** We recommend installing the filament holder cover to prevent filament from falling off.



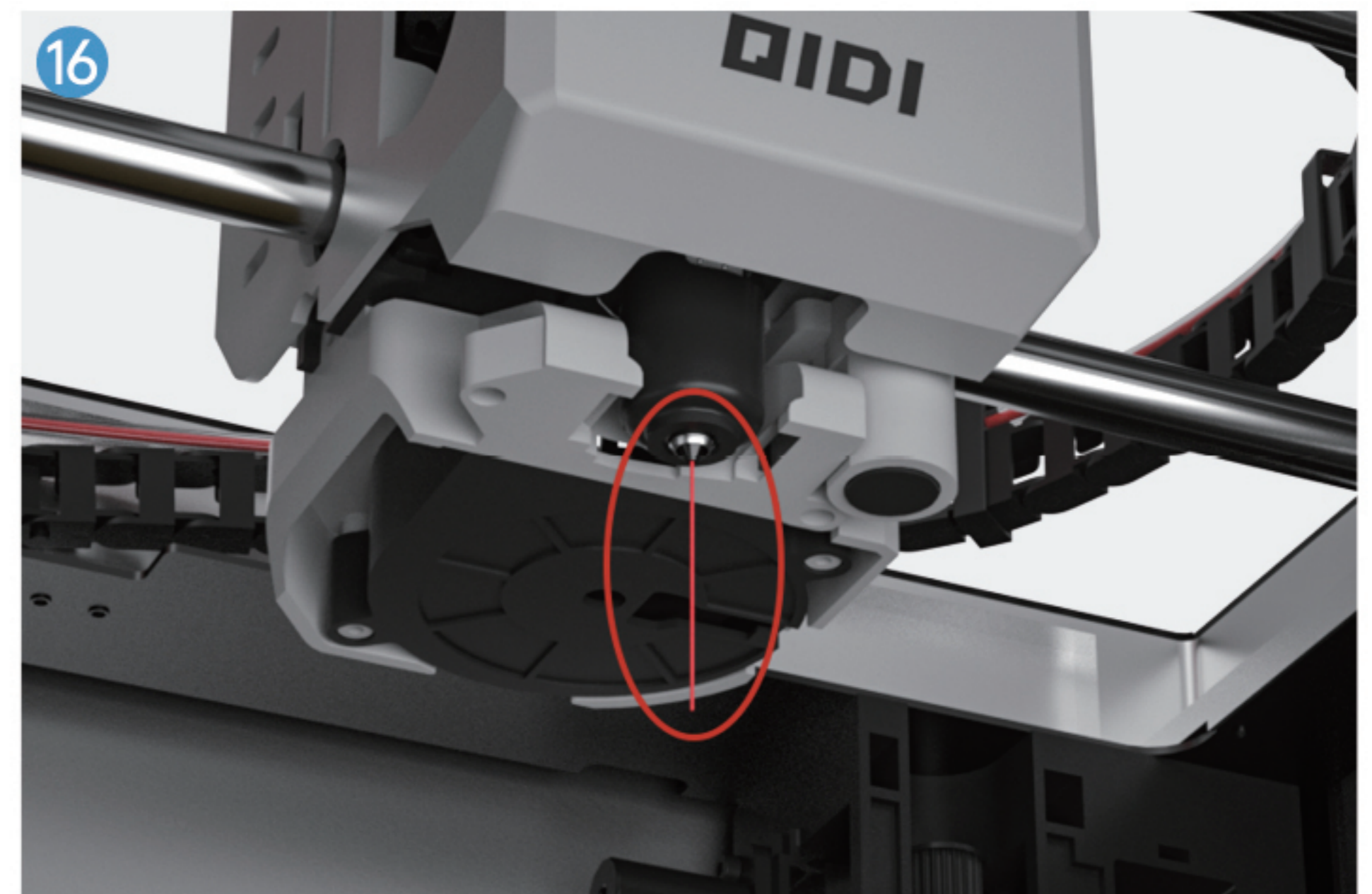
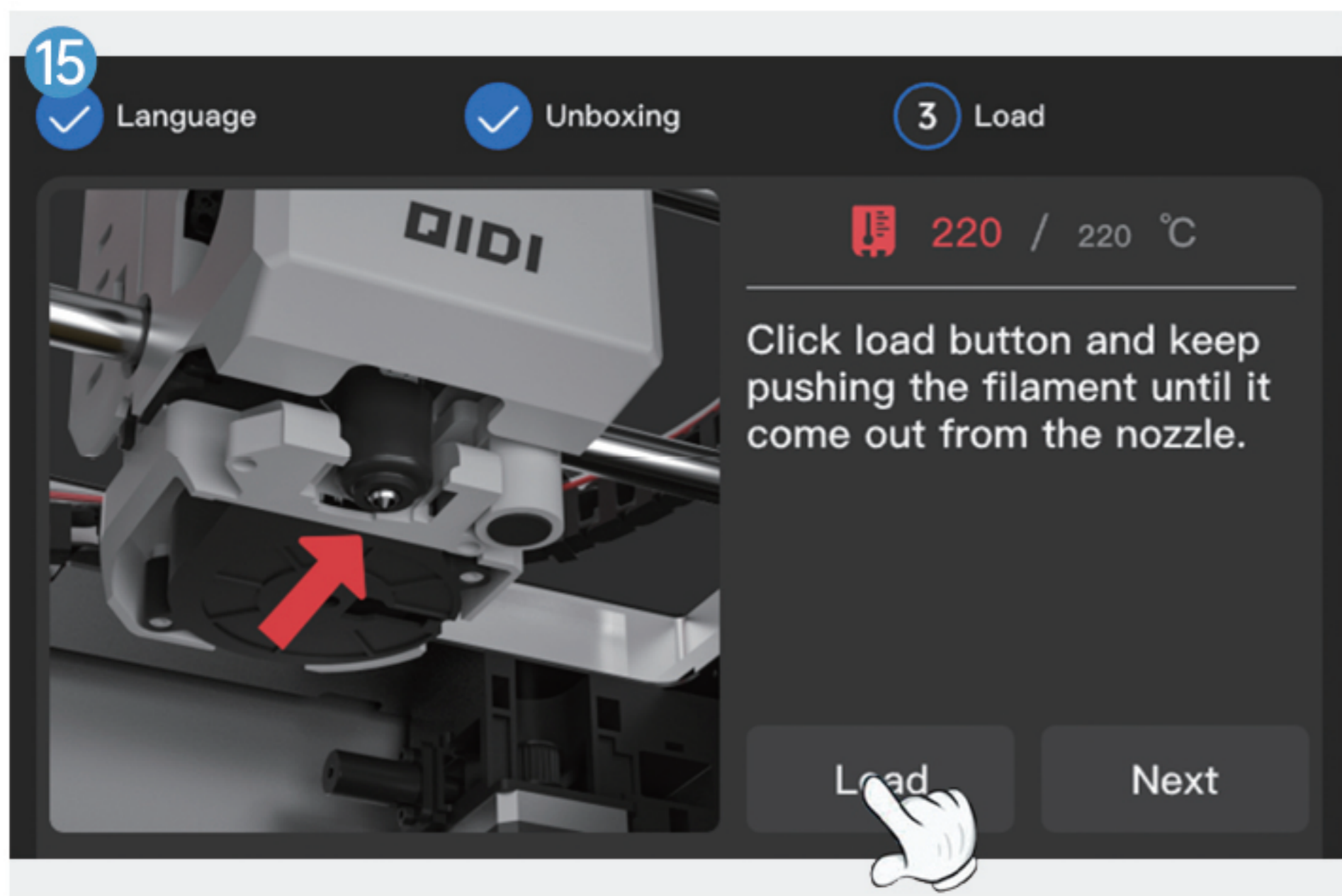
Follow the on-screen prompts to take out the PTFE tube in the accessory box, install it in the tangle inspection inlet, and then thread the filament through the PTFE tube.



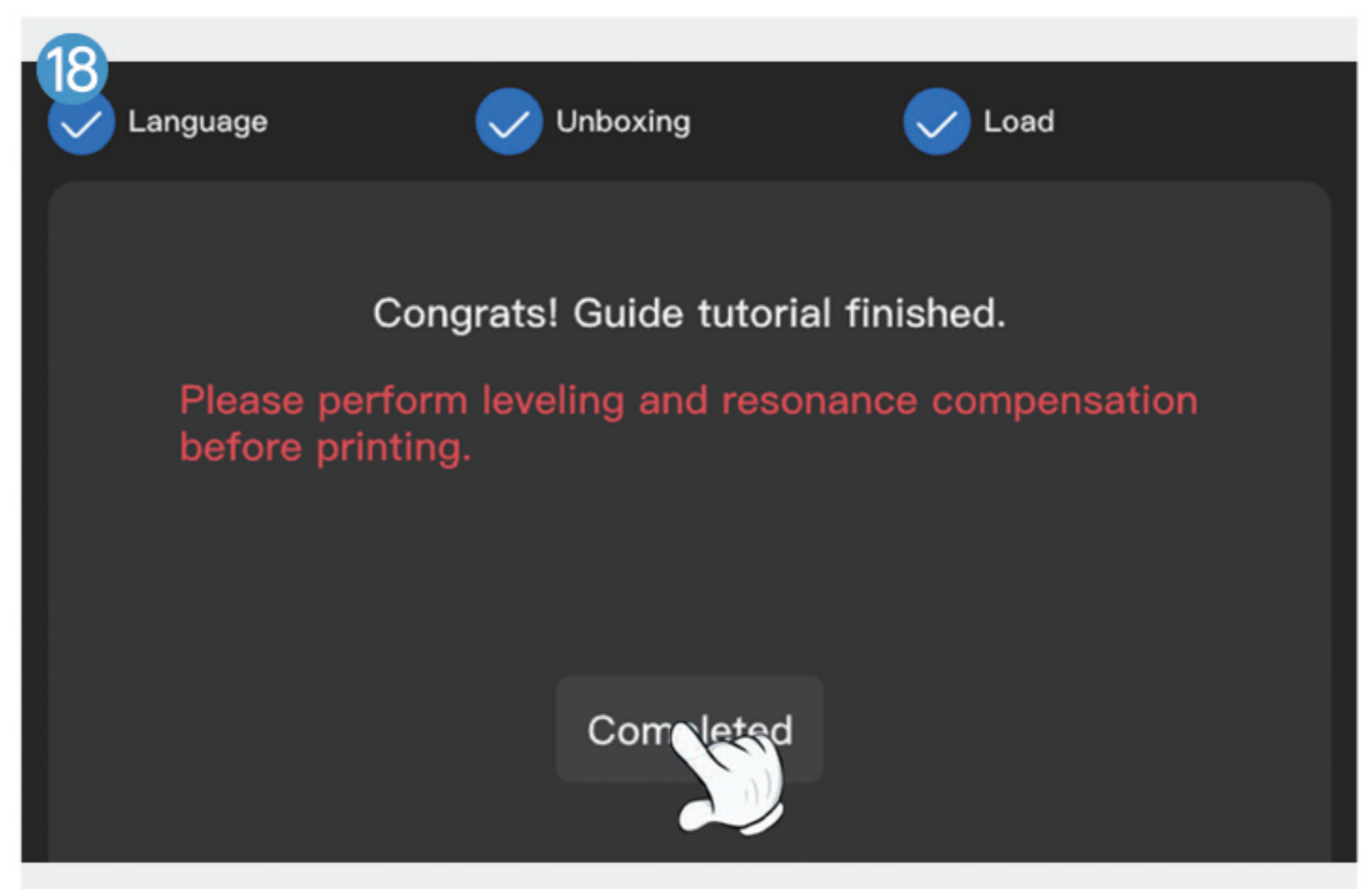
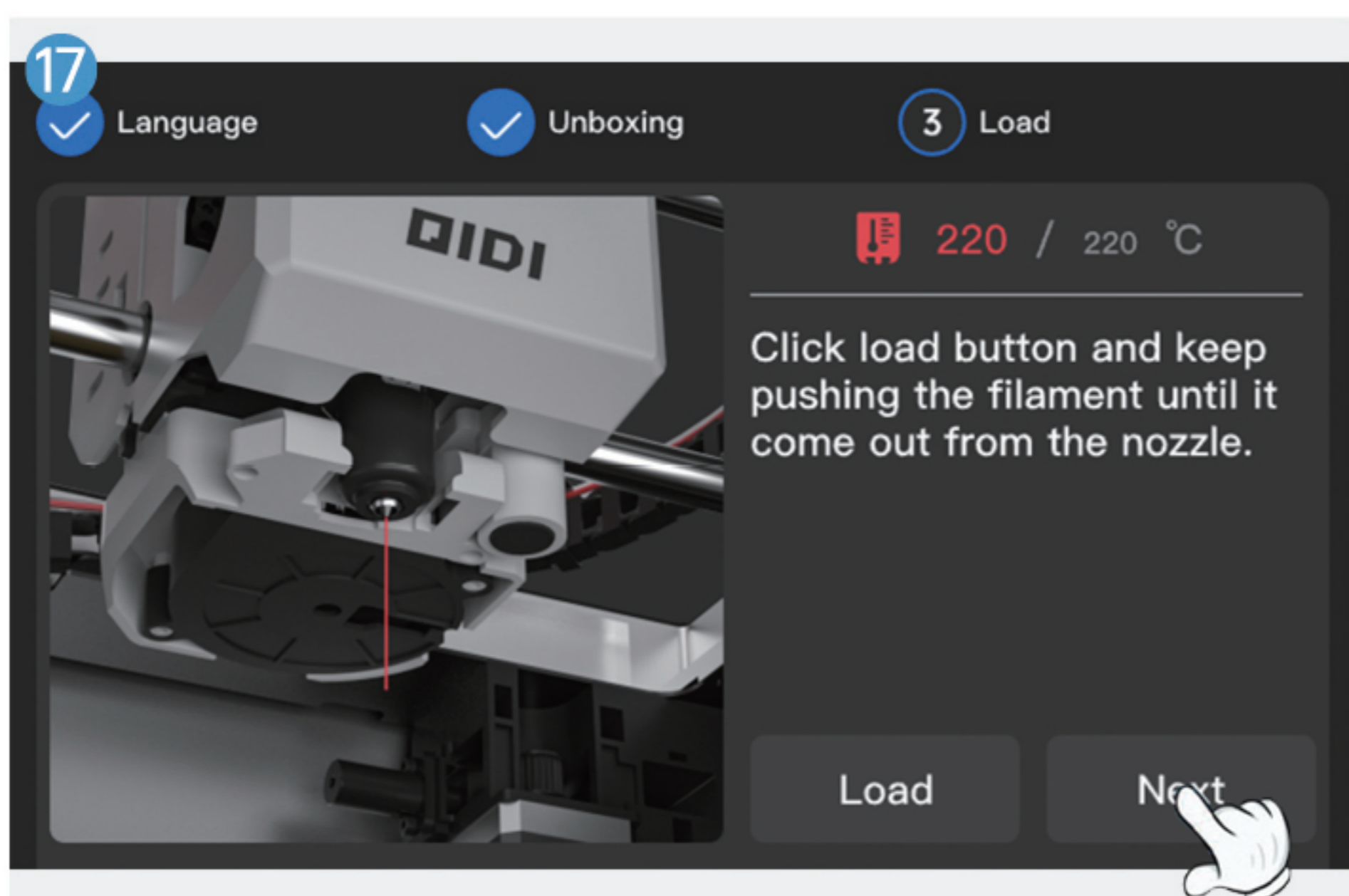
Ensure that the filament is inside the nozzle, and then click Next.



Set the desired temperature of the filament and click ' ✓ ' to begin heating. Wait until the temperature reaches the setting value before proceeding to the next step.



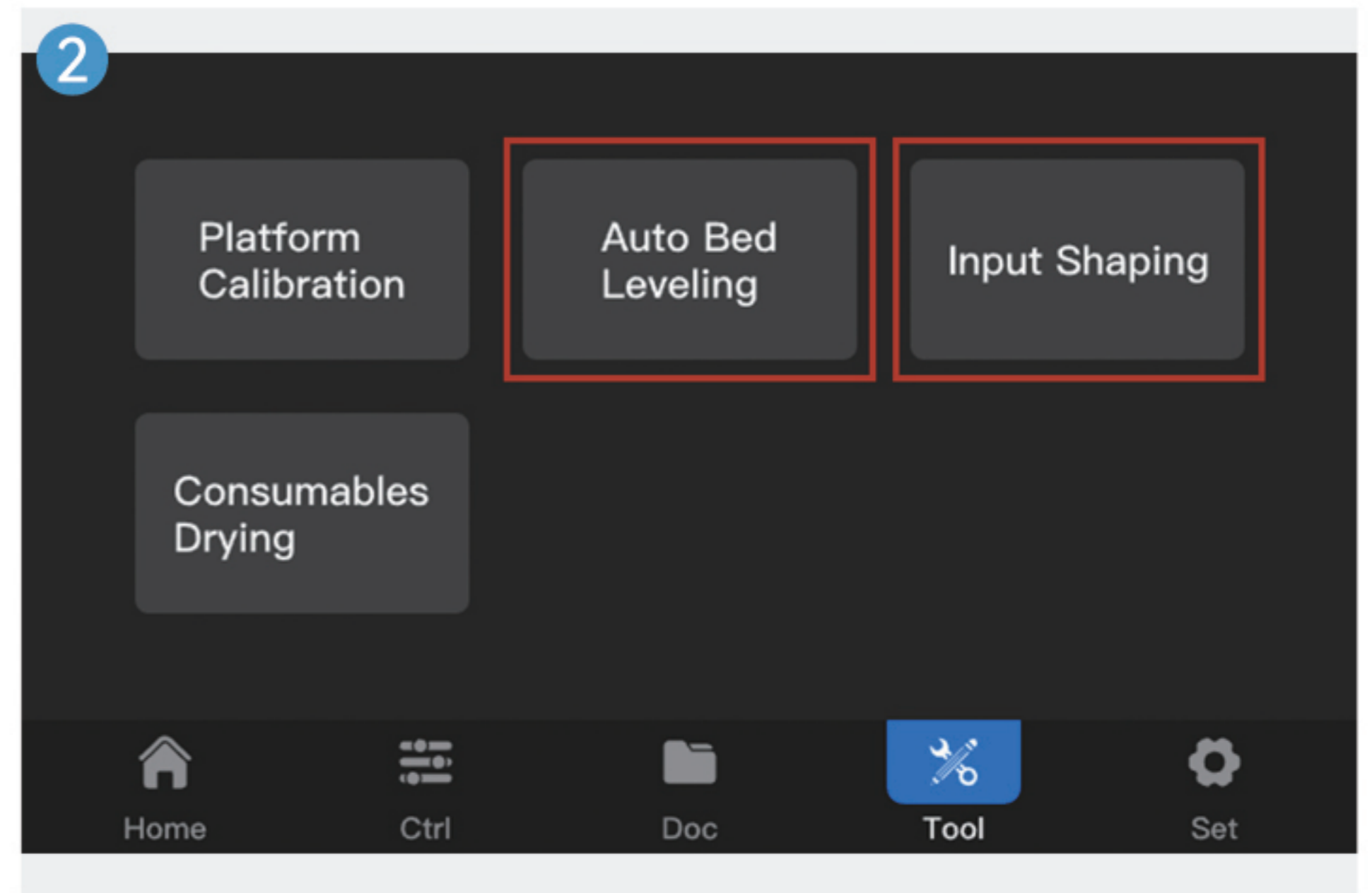
Click the 'Load' button until filament is extruded from the nozzle.



Click 'Next' to complete the startup guide.

Note: Before your first print, please ensure you have performed Auto Bed Leveling and Input Shaping.

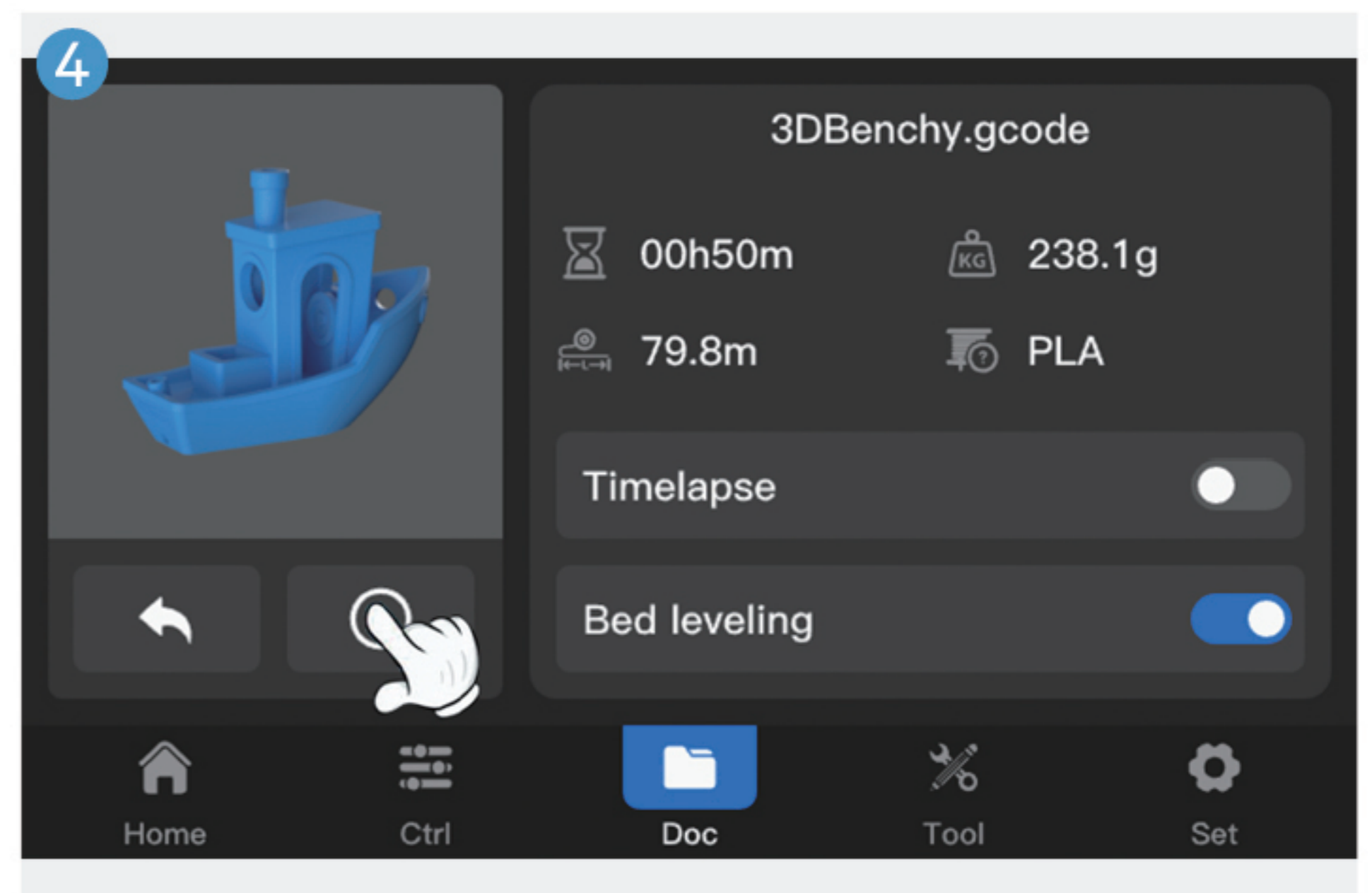
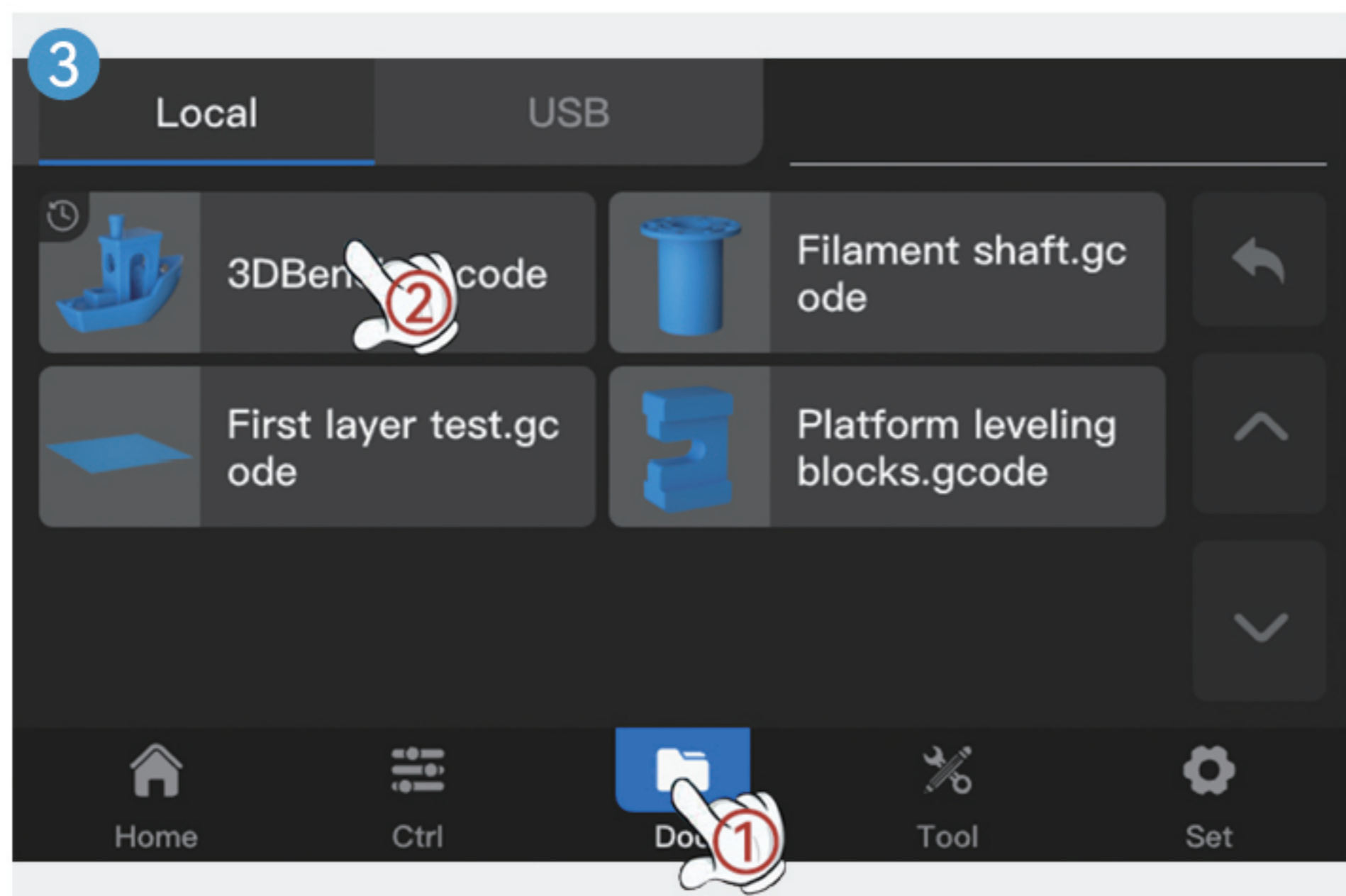
## First Printing



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

**Note:** Before initiating auto bed leveling, ensure to input the heating bed temperature corresponding to the printing filament for increased accuracy.

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.

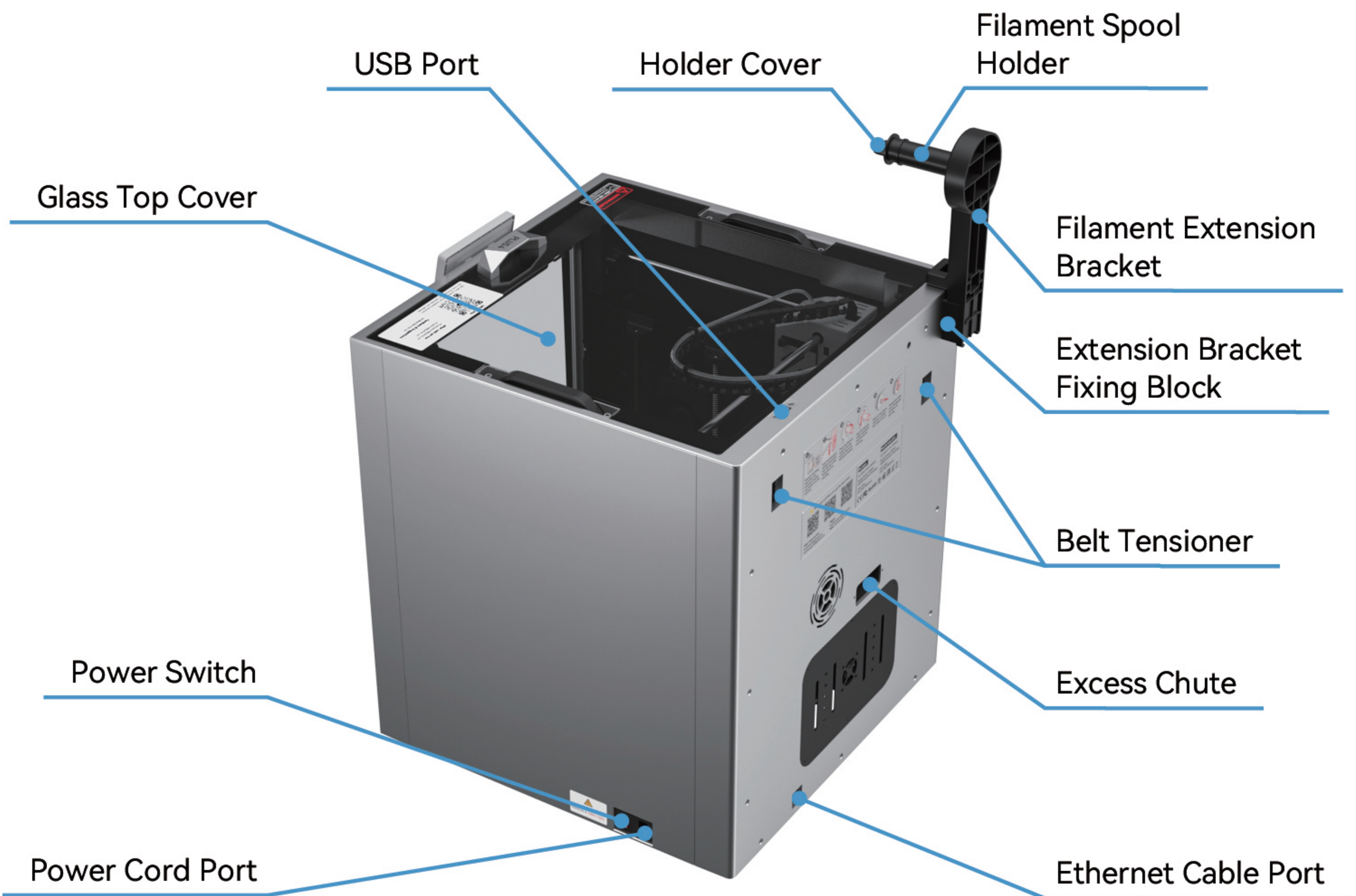
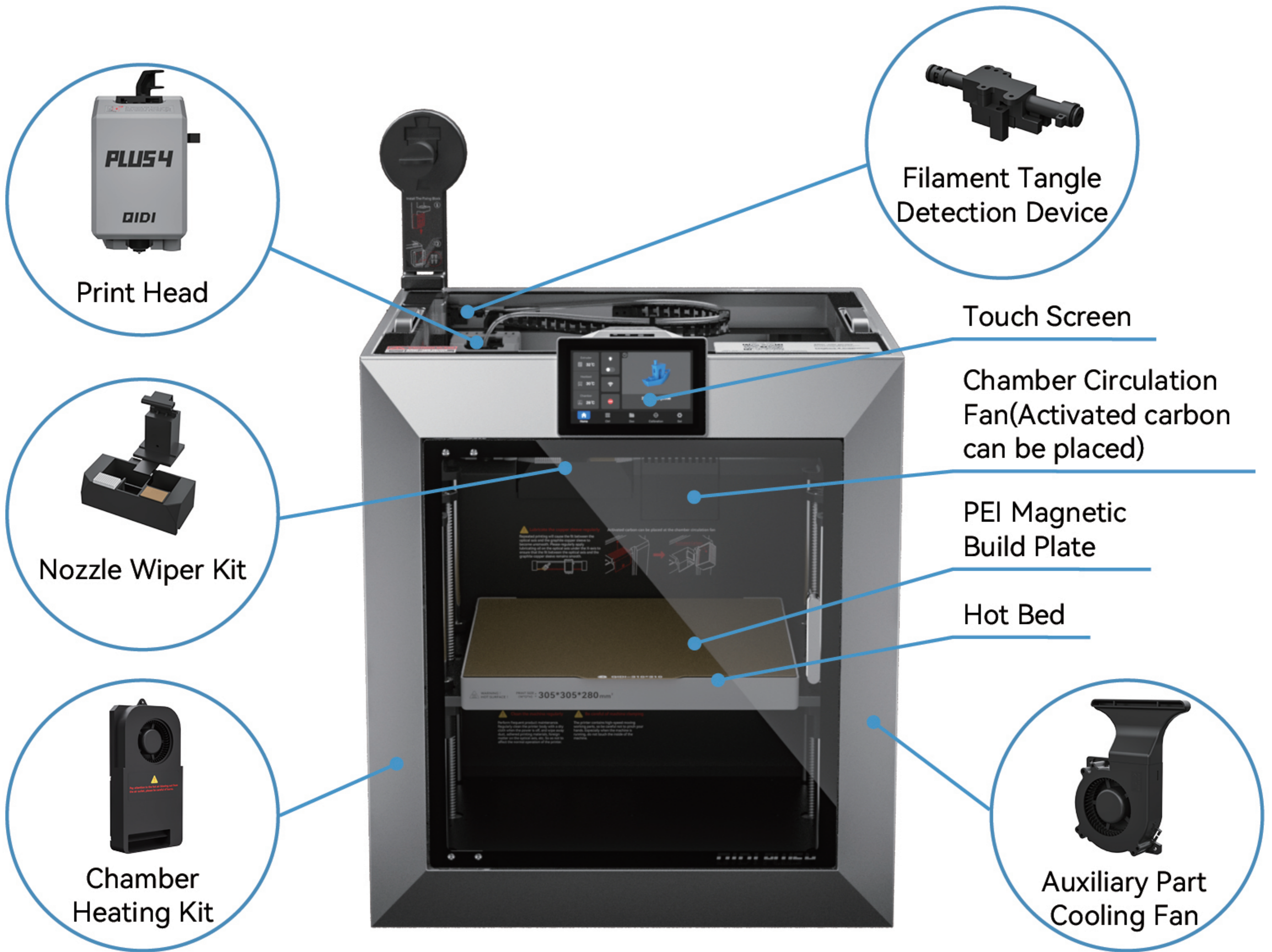
**Note:** Pre-saved models files use PLA Rapido filament by default.

## How To Remove The Print Head Front Cover



The print head front cover features a buckle structure on the top. Do not remove it directly. First, unlock it by lifting it upward, then remove the print head front cover outward and laterally.

# Printer Introduction



## 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 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 by Z-offset 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		Plus 4
Body	Print Size (W*D*H)	305*305*280 mm
	Dimensions	505*487*550 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 Temperature High Speed Motor
Print Head	Print Head Temperature	≤ 370°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	Integral Aluminum Plate
	Printing Plate	PEI Magnetic Build Plate
	Hot Bed Temperature	≤ 120°C
Speed	Max Speed Of Tool Head	250-600mm/s
	Maximum Printing Acceleration	20000mm/s <sup>2</sup>
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	65° C Independent Chamber Heating
Filament	Recommended Filament	PLA
	Compatible Filament	PLA, ABS, ASA, PETG, TPU, PET-CF, PA12-CF, PC, UltraPA, Nylon, etc.
	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	450W+400W(Chamber Heating)
Electronics	Display Screen	5.0 Inch 800*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](http://www.qidi3d.com)

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

E-mail address: [Plus4Ams@qidi3d.com](mailto:Plus4Ams@qidi3d.com)  
[Plus4support@qidi3d.com](mailto:Plus4support@qidi3d.com)

Skype ID: [Plus4support@qidi3d.com](https://www.skype.com/people/Plus4support@qidi3d.com)



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

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