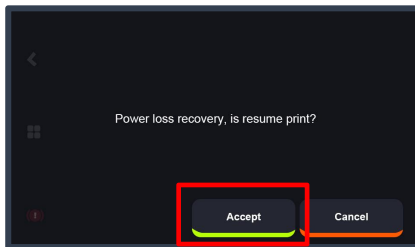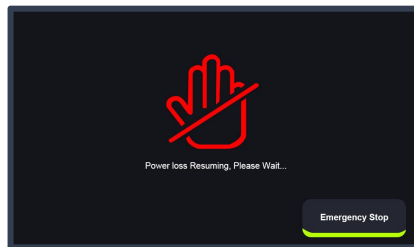# 8. Resume Printing

AD-F4 is equipped with a resume printing function to assist you in resuming the print from the point of interruption.
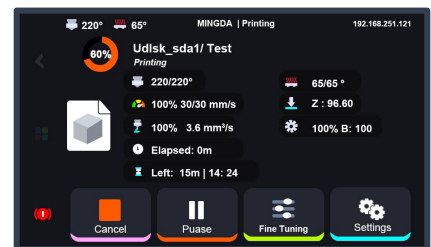
1. After power failure

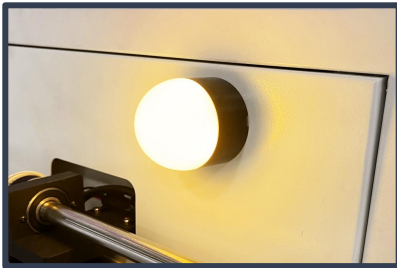After power restored, turn on the printer, click "**Accept**"

Please wait the printer resuming.

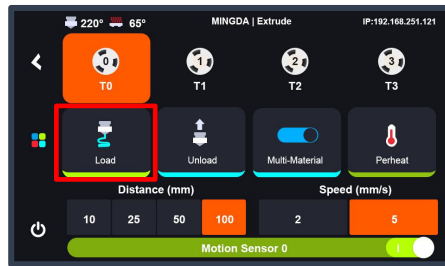
After reaching the specified temperature, the printer will automatically transition to the printing interface.
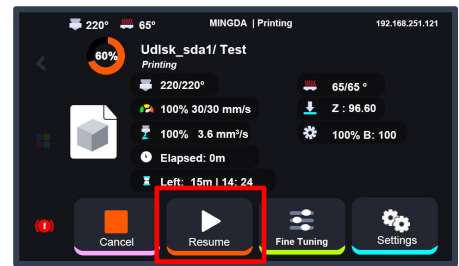
2. After filament run out

Printer will stop working, and yellow light up.

Replace new filament into the extruder, click load till the filament was feed out.
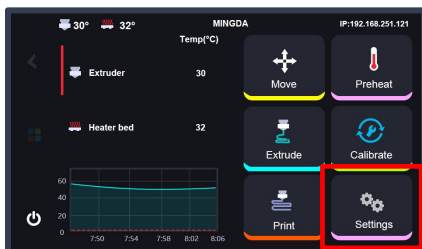

Click "**Resume**" ▶ , continue to print from the point of interruption.
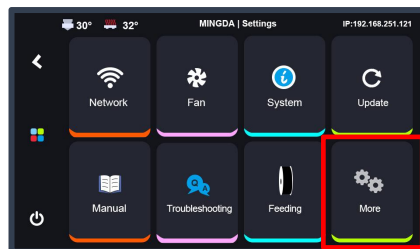
3. Filament Autofeed

This mode is only available for single-color printing and cannot be enabled for multi-color printing.
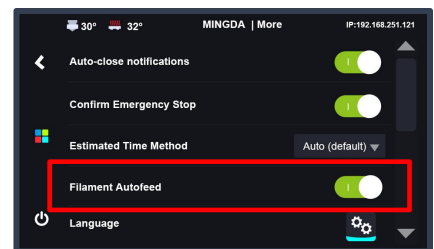
When this mode is enabled, if Filament 1 runs out, the printer will automatically switch to Filaments 2, 3, and 4 sequentially, continuing to print until all filaments are used up.

Click "**Settings**"

Click "**More**"

Open "**Filament Autofeed**"

9. Slicing Software Installation and Usage

Installation:

Search "**www.3dmingda.com/download**" in any Broswer.

Download "**MINGDA OrcaSlicer**"

Configuration:

MINGDA
OrcaSlicer
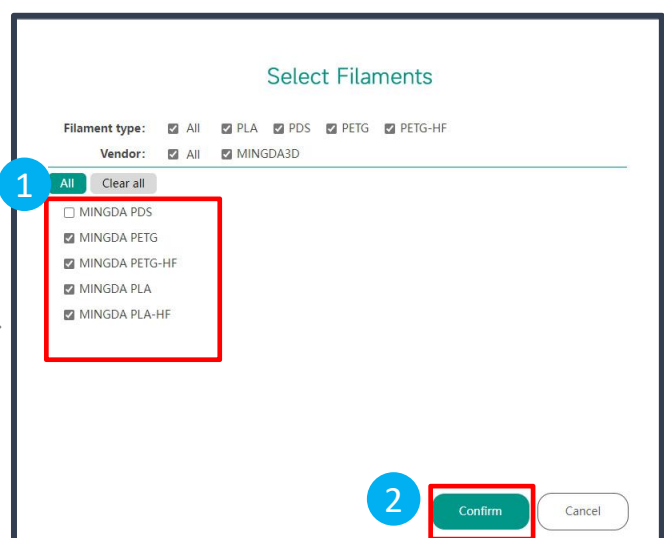
If you are the first time to use MingDa OrcaSlicer, you will enter the configuration wizard.
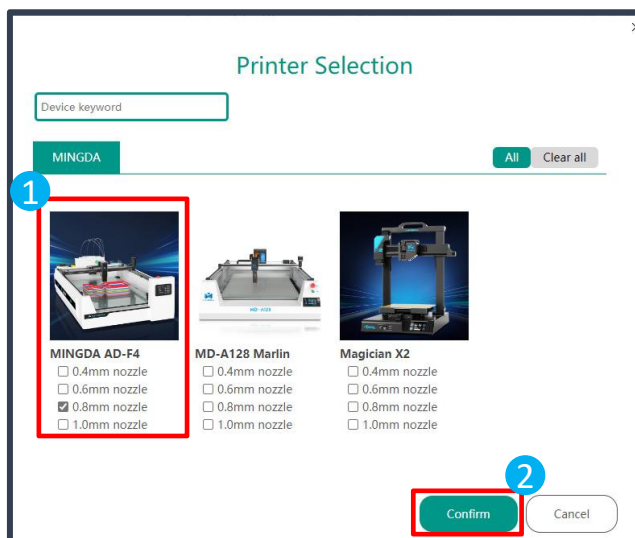
Select MingDa AD-F4 0.8mm nozzle, Click "**Confirm**".

Select the desired filament type.

Usage

Click "Prepare".
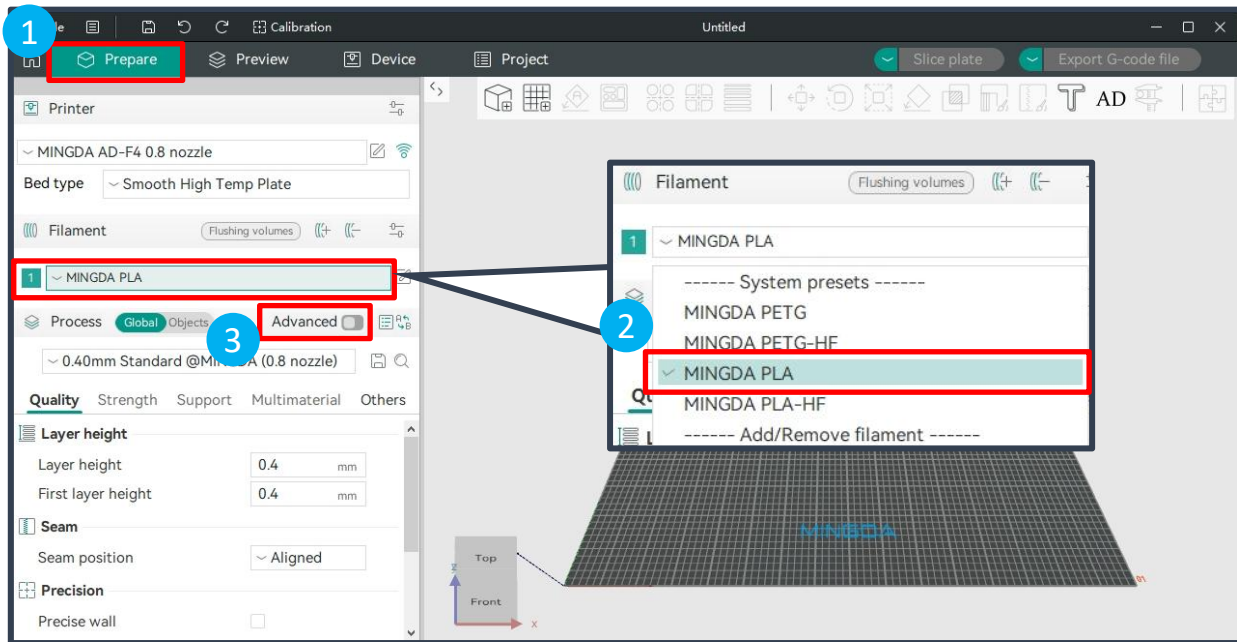
Select the filament type; you can select Advanced Mode to unlock more setting parameters.
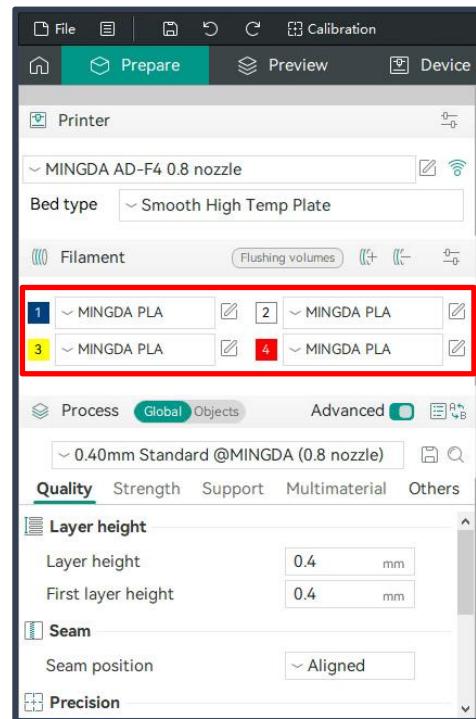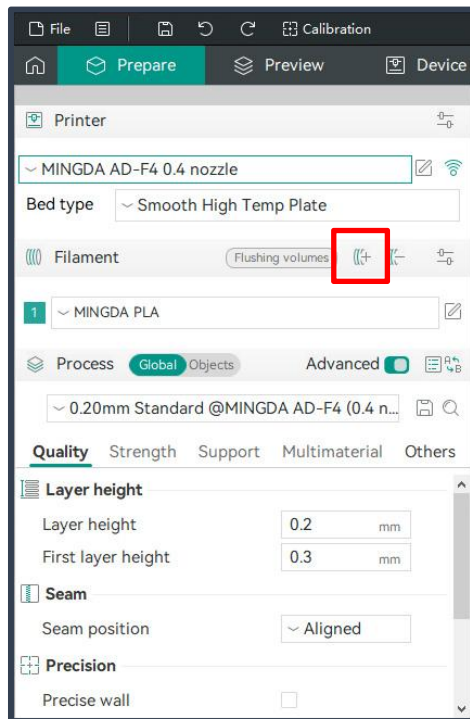
Click to add up to four filaments and set the corresponding colors.

Create text for printing

Click the AD icon AD to launch the AdWordCraft software.

You can import pre-designed vector files [.svg or .dxf] from the File menu or create designs directly using the

text tool Ta , as shown in the example above.

1. After creating or importing a vector file, select the model and choose the **Horizontal Mirror** option.

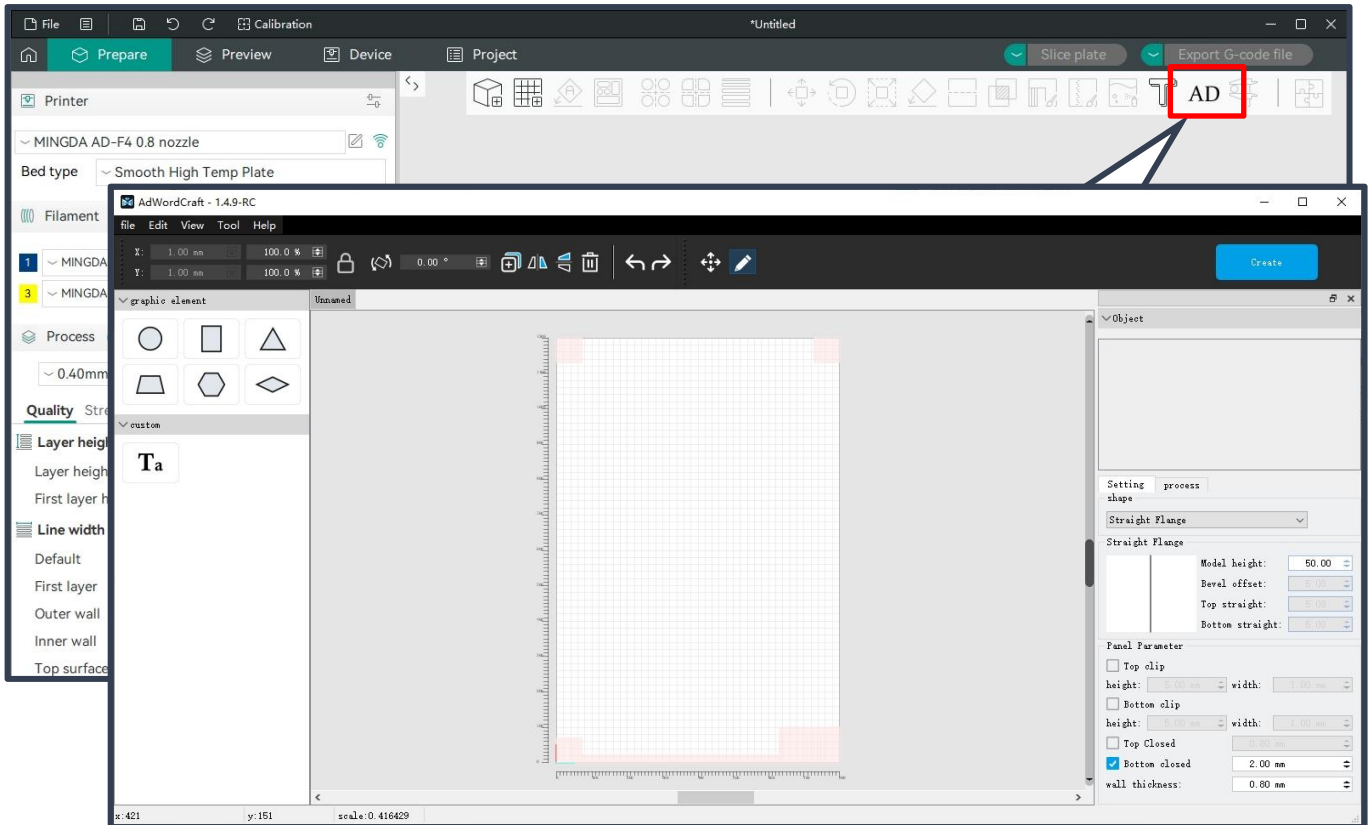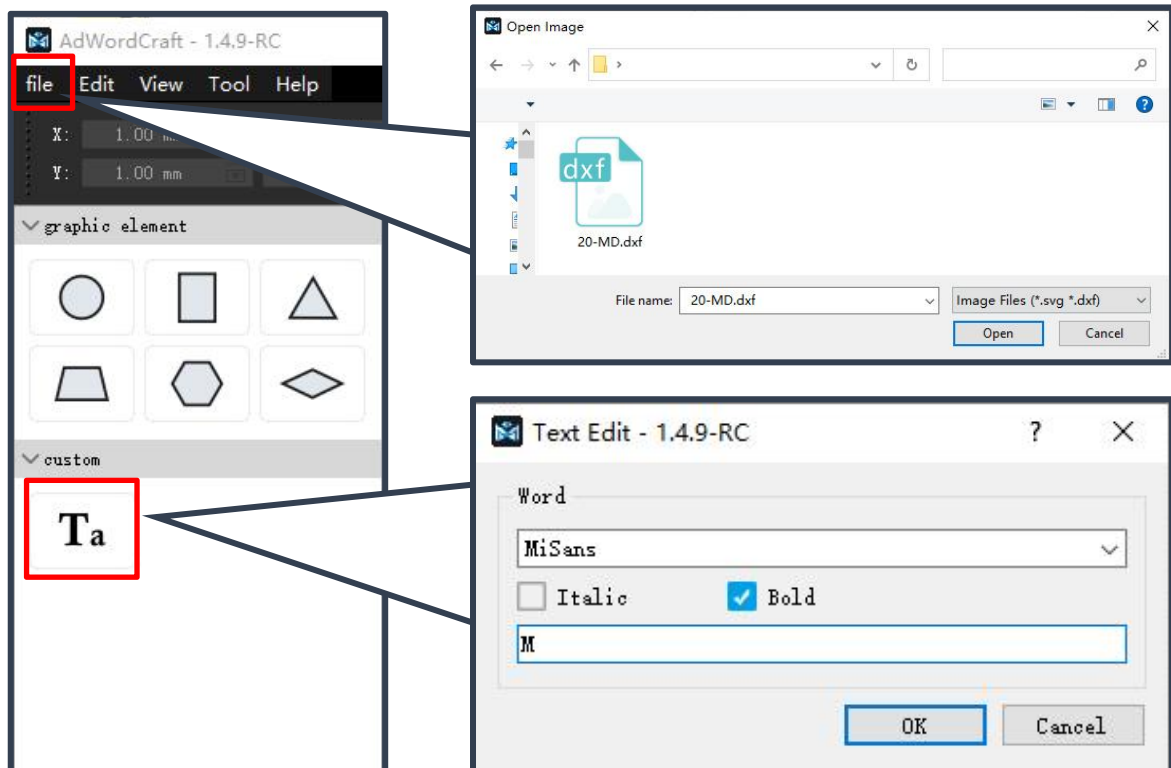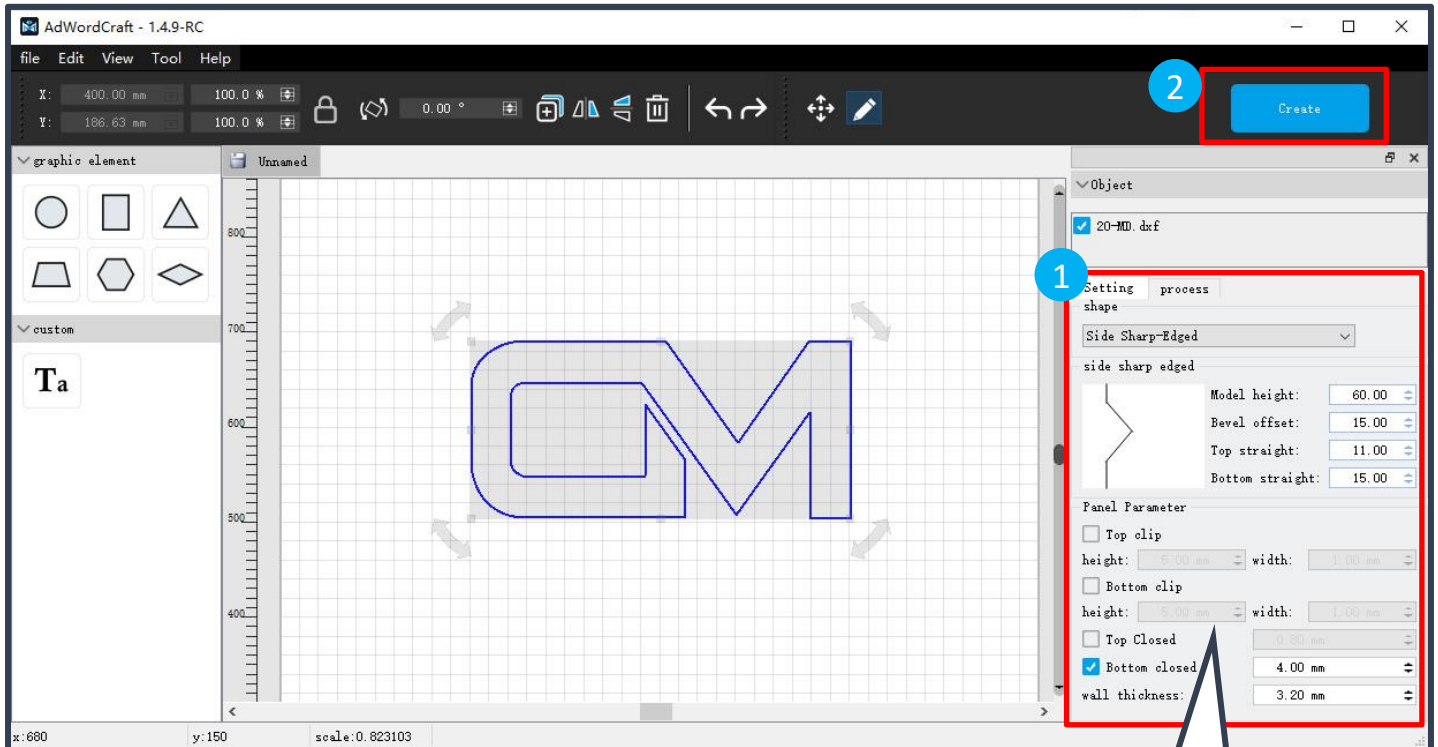2. You can adjust parameters in the right panel, including side border shape, height, bottom thickness, and wall thickness.

3. After configuring the parameters, save the file to your computer.

Model height; Setting of side shape and parameters; [Select Straight Flange, Model height set to 60mm]

Set the top card slot: used to secure the backing plate of advertising text.
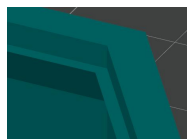
The model's bottom thickness can be set between 4 to 5mm.
If you don't need to print the bottom surface, you should disable the **Bottom Closed** option.

The wall thickness of the model is set as a multiple of the nozzle size.
For example, with a 0.8mm nozzle, the wall thickness can be set to 3.2mm.
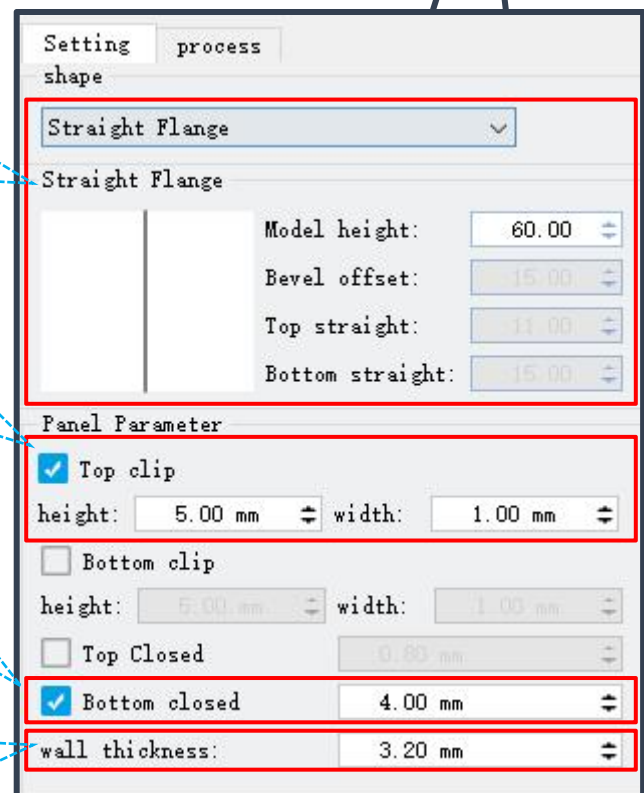
Import print file

Click ⬚⊕ , upload your file in your slicer.
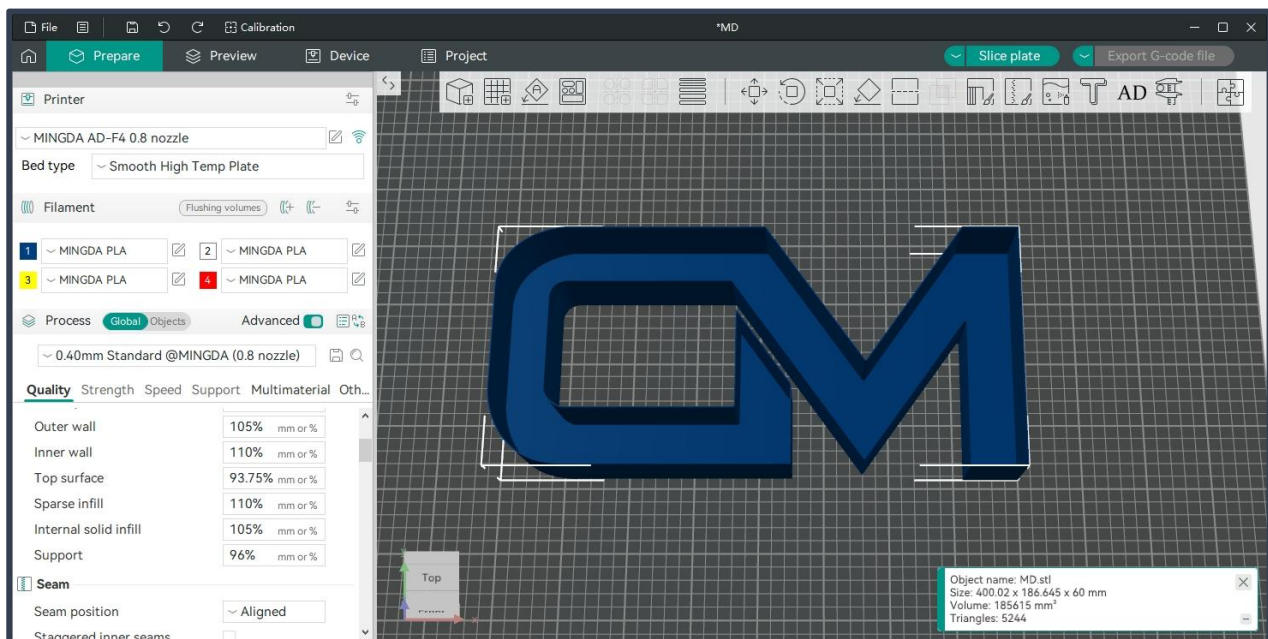
Adjust your model parameter.

Bottom Pattern Settings
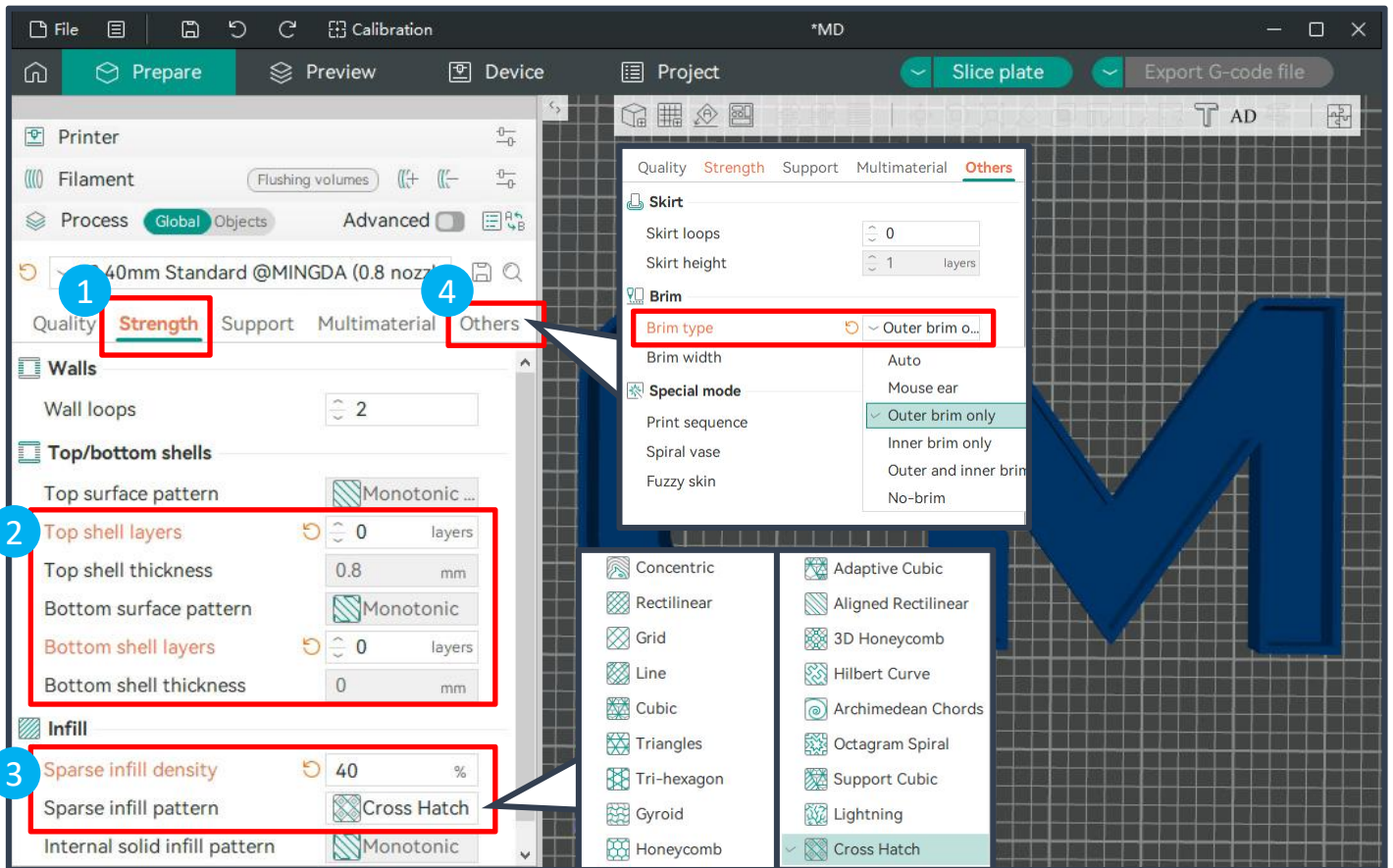
1. Click **"Strength";**

2. Set **Top Shell Layers** and **Bottom Shell Layers** to **0** to prevent the top and bottom shells from affecting the bottom pattern.

3. In the **Infill** section, set the **Sparse Infill Density** to **40%** (the density can be adjusted as needed). Choose the desired pattern style for **Sparse Infill Pattern**.

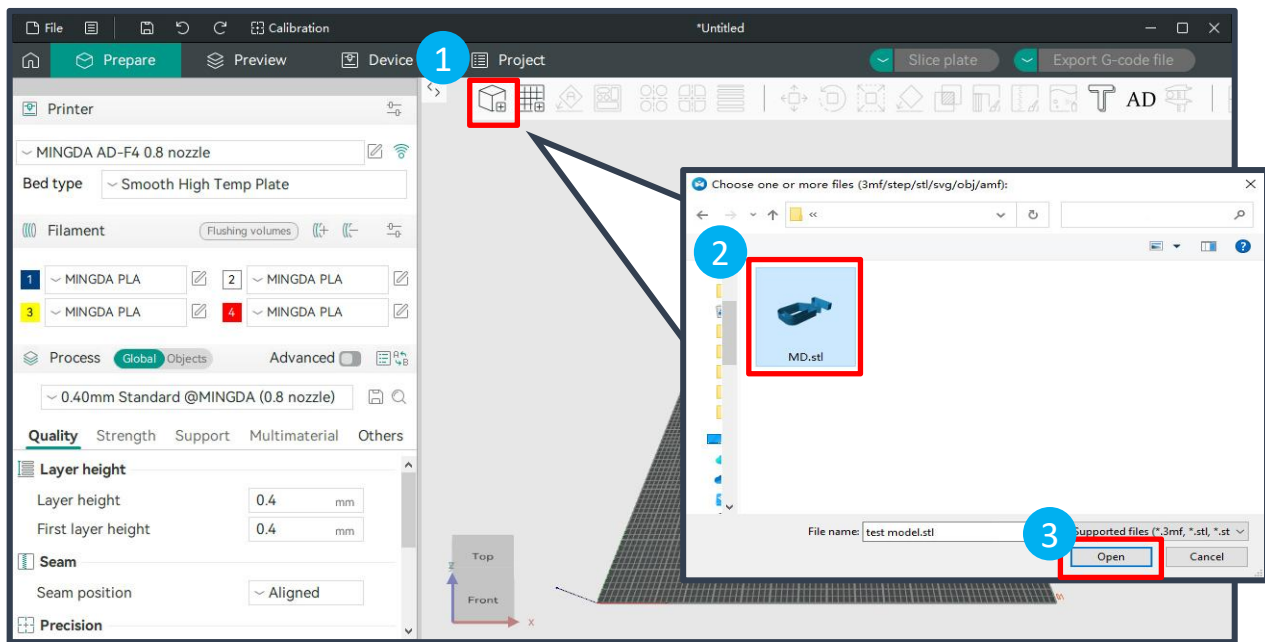4. Click "**Others**" and set the **Brim Type** option to **Outer Brim Only**. This generates only the outer edge of the model to enhance its adhesion to the platform.

5. After completing the model parameter settings, click "**Slice Plate**" [Slice plate] to preview the slicing.

6. "**Export G-code file**"
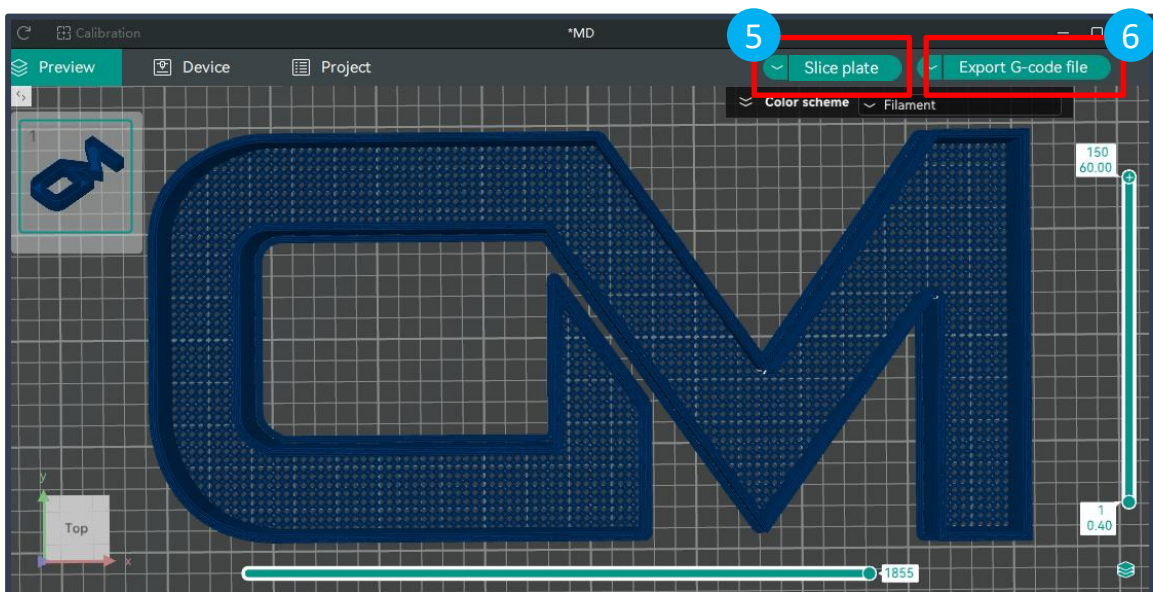
Side Multi-Color Settings
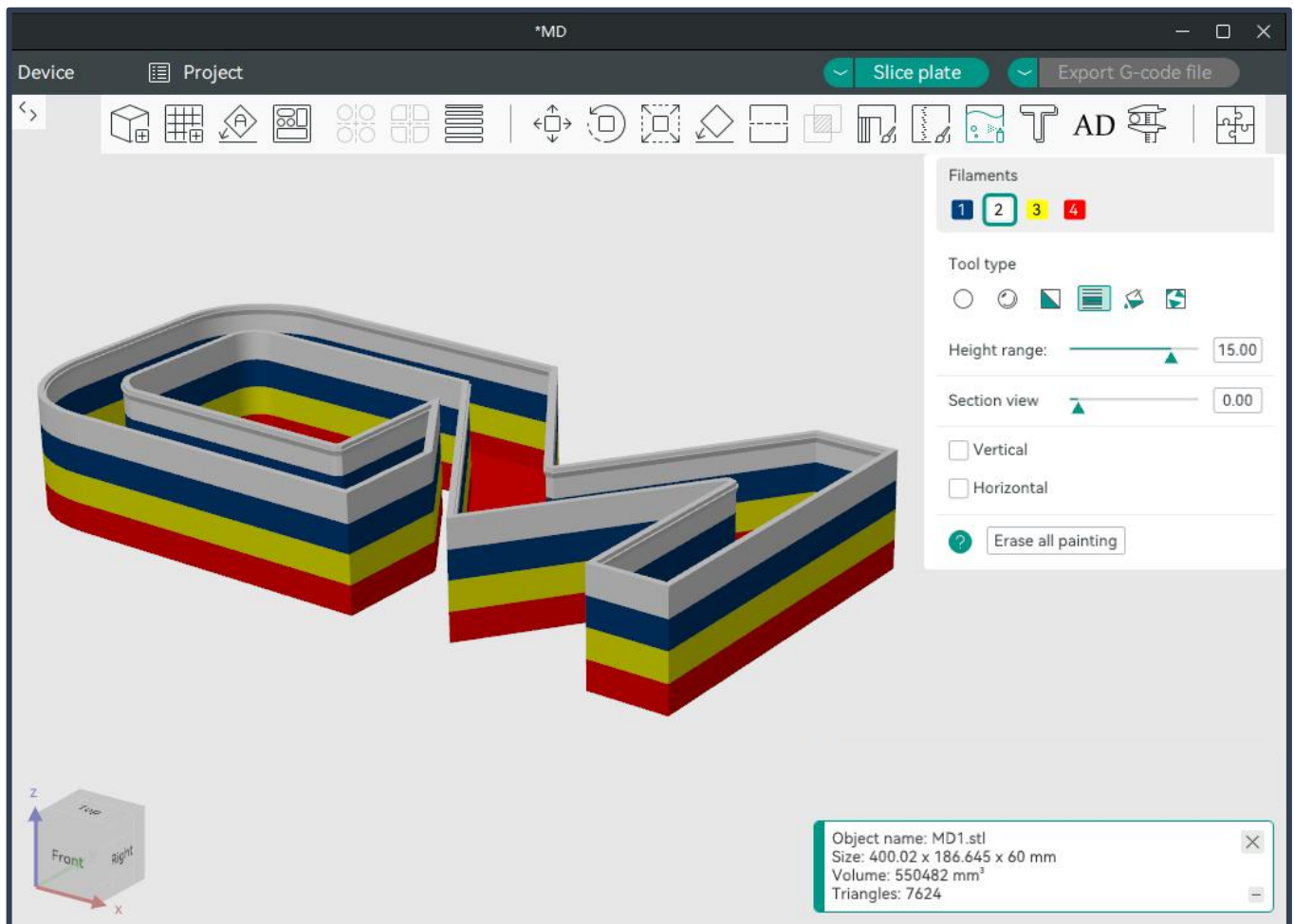
1. Click **Color painting [N]**

2. Select the desired **Filaments color**
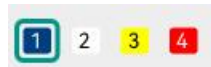
3. Select **Height Range**

4. Set the **Height Range** you need

5. After completing the settings, you can proceed to paint directly on the model.

Start the Prime tower

During the printing process of multi-color models, filament switching may leave residual filament from the previous color in the nozzle, causing color mixing issues on the model.

Using a Prime Tower can resolve this problem. Before switching filaments during printing, the nozzle prints a Prime Tower, where the residual filament is deposited. This effectively prevents color mixing during filament transitions.
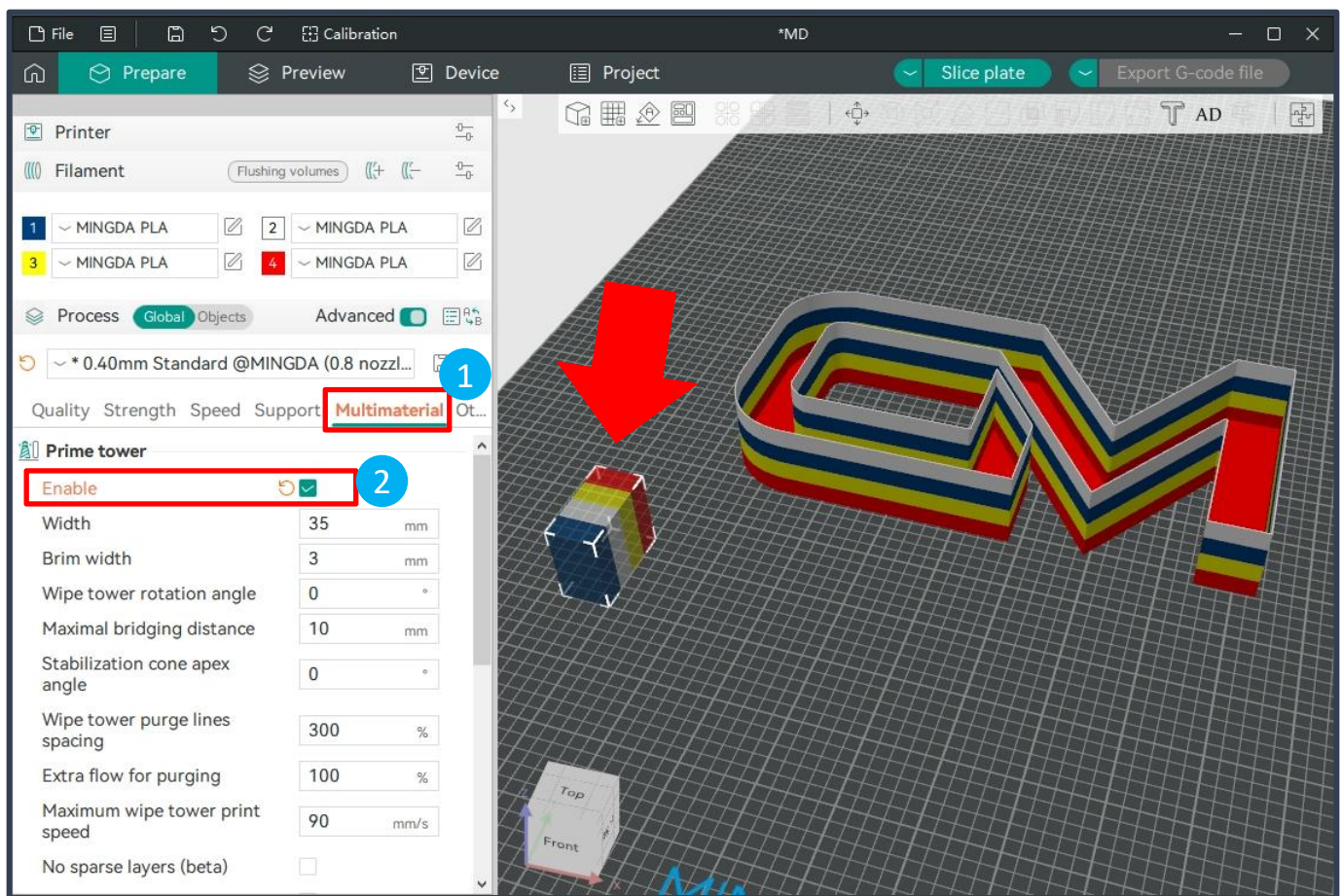
1. Select the "**Multimaterial**" section.
2. Check the "**Enable**" option in the "**Prime tower**" settings.

Note: The printing position of the Prime tower cannot coincide with the model

Bottom Multi-Color Settings

Using the example on the right (colors: red, yellow, white, blue):

When exporting the vector file, you can subdivide it into separate files.

For instance:
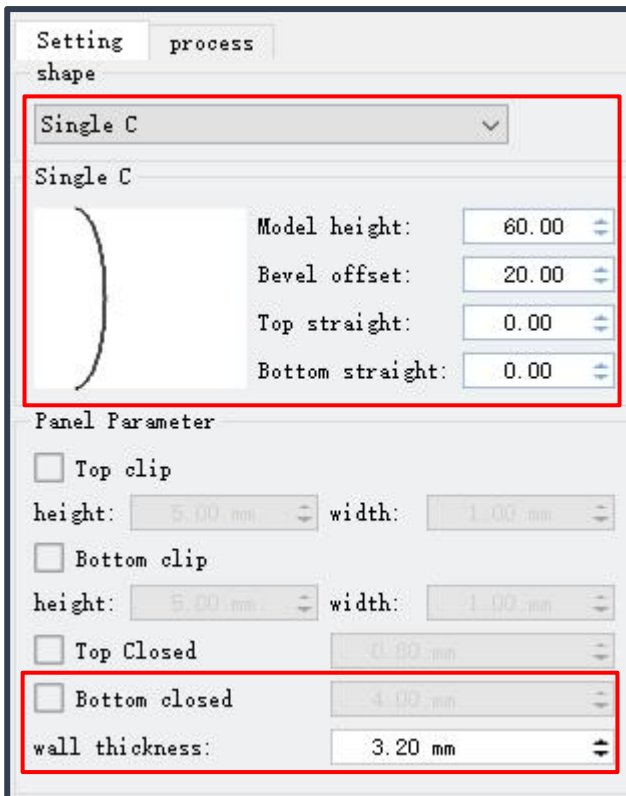
1. Export the model border as an individual **dxf** or **svg** file.
2. Export each of the four colors (red, yellow, white, blue) as separate **dxf** or **svg** files.

This approach ensures better management and precise application of each design element during further processing or printing.
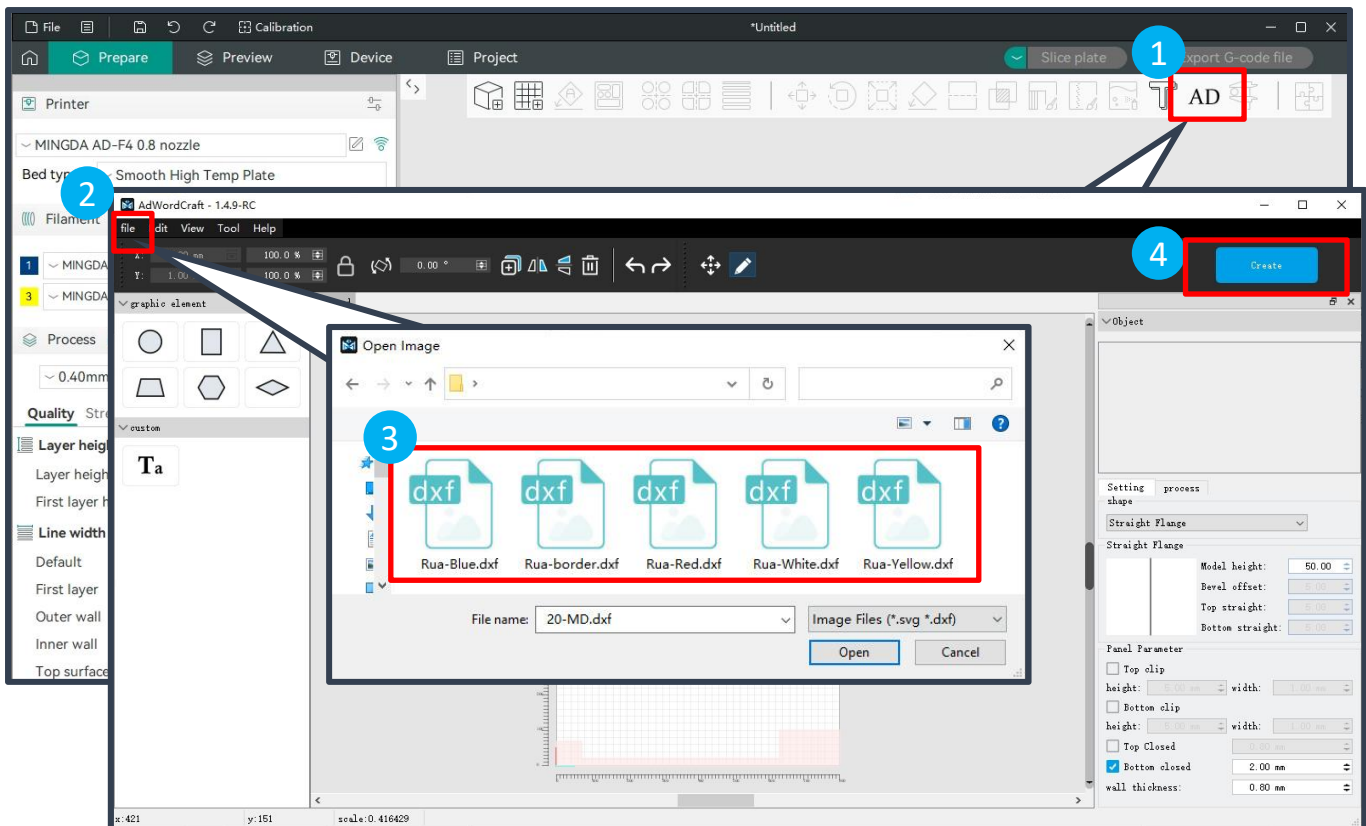
Click the AD icon   AD   , then import the created dxf or svg files individually into the AdWordCraft software. Set the parameters as needed and save your settings.

Model Border Parameter Settings
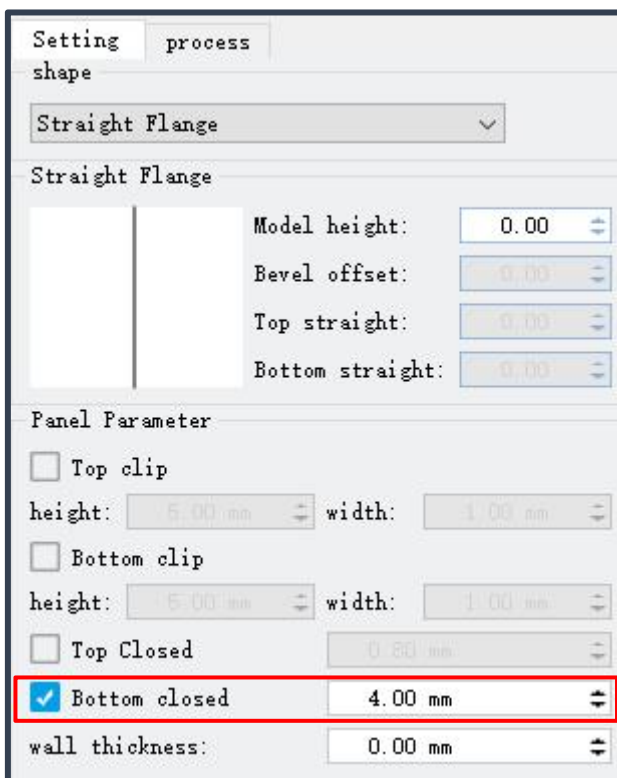
1. Select the desired side shape and adjust the corresponding parameters.

2. Click to disable "**Bottom Closed**".

3. Set the appropriate "**Wall Thickness**".

4. Select the model and apply a "**Horizontal Mirror**".

5. Click "**Create**" to save the file.
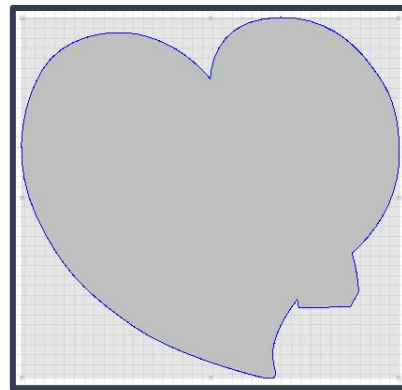
Border

Model Bottom Parameter Settings

1. Set the **bottom thickness** to **4-5mm**, and cancel or set all other parameters to zero.

2. Select the model and apply a "**Horizontal Mirror**".

3. Click "**Create**" to save the model.

| Entire bottom | Red heart | Blue side |

| White font | Yellow font |
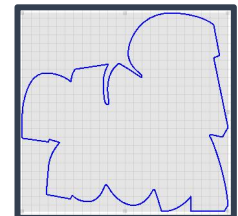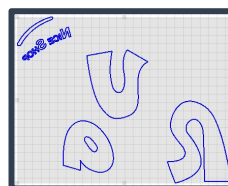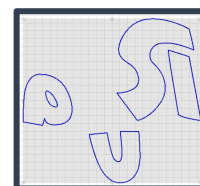
Model File Adjustment

Import the created model files into Mingda OrcaSlicer.
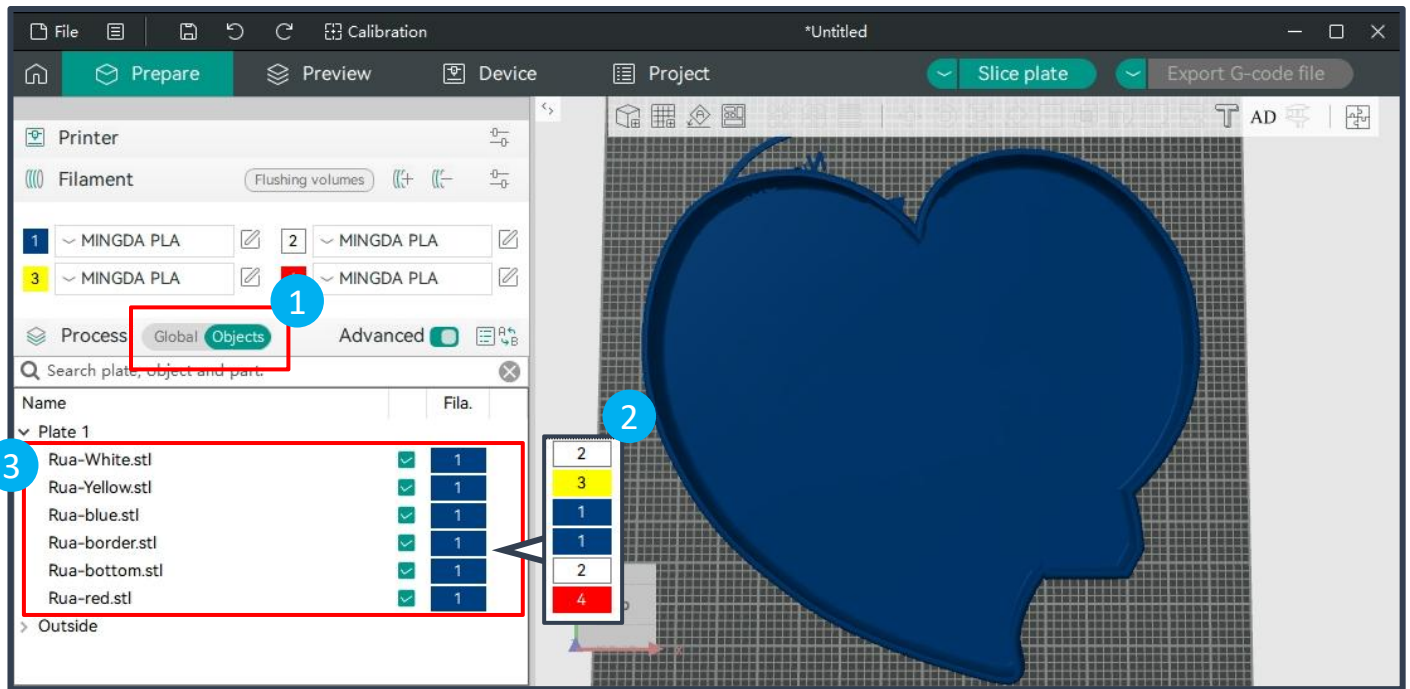
1. Click the button **Global Objects** to switch to the "**Objects**" interface.

2. Double-click the color block to change the model to the desired color.

3. Adjust the positions of the models as needed, moving each to its correct location.

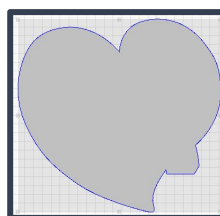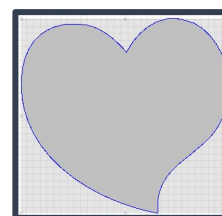Since the models are stacked together, making it difficult to differentiate and adjust them, we can modify the height of some models first to make it easier to adjust their positions.

Select the model from the left side; modify its Z-axis height by clicking **Scale [S]** . Uncheck **Uniform Scale** , then increase the Z height. After making the adjustments, you can now easily adjust the positions of each model.
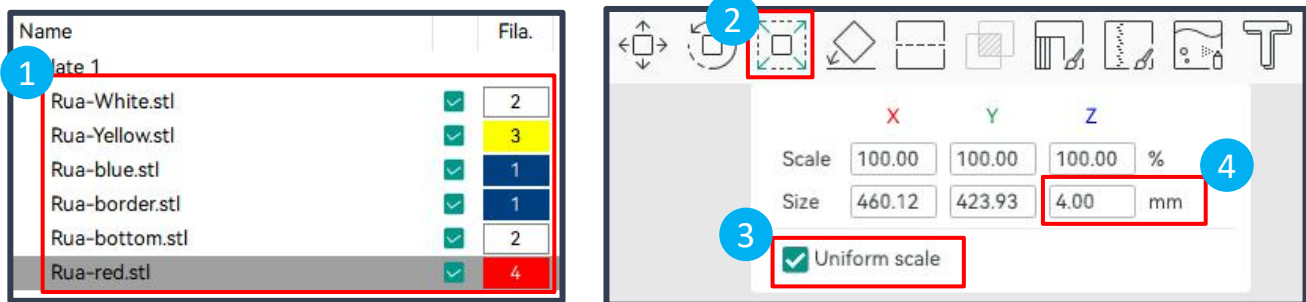
After the adjustments are complete, you can modify the models back to their original height.

4.We need to organize these models to ensure each color is printed correctly.

You can directly drag and drop the corresponding STL files in the left panel to arrange the models in the desired order.

For models that overlap, the smaller model has higher priority.
In the "**Objects**" interface, the higher-priority models should be placed at the bottom, and the lower-priority models at the top.

Based on the current model, the priority order is as follows:
White font > Yellow font > Blue side > Red heart > Entire bottom > Border.
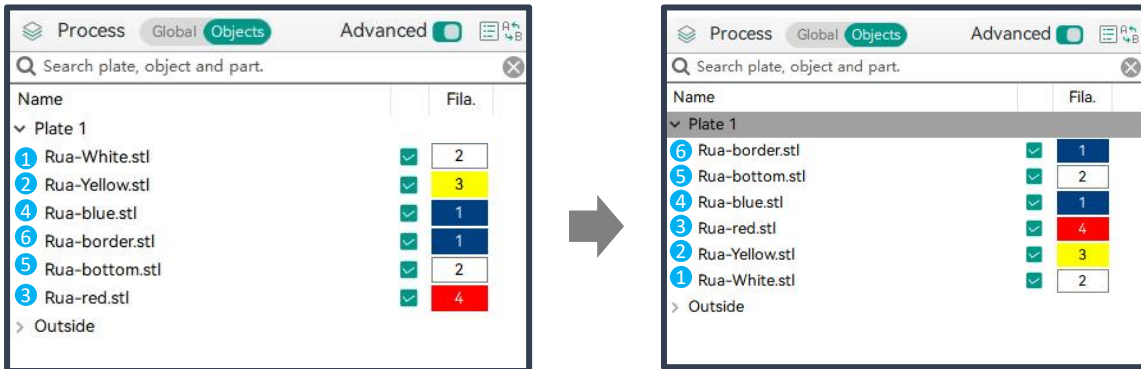
5. After adjusting the order, press **[Ctrl + A]** to select all the model files. Right-click and choose "**Assemble**" to group all the model files into a single Assembly.

6. Click "**Slice Plate**" to preview the model. If everything is correct, proceed by clicking "**Export G-code File**".
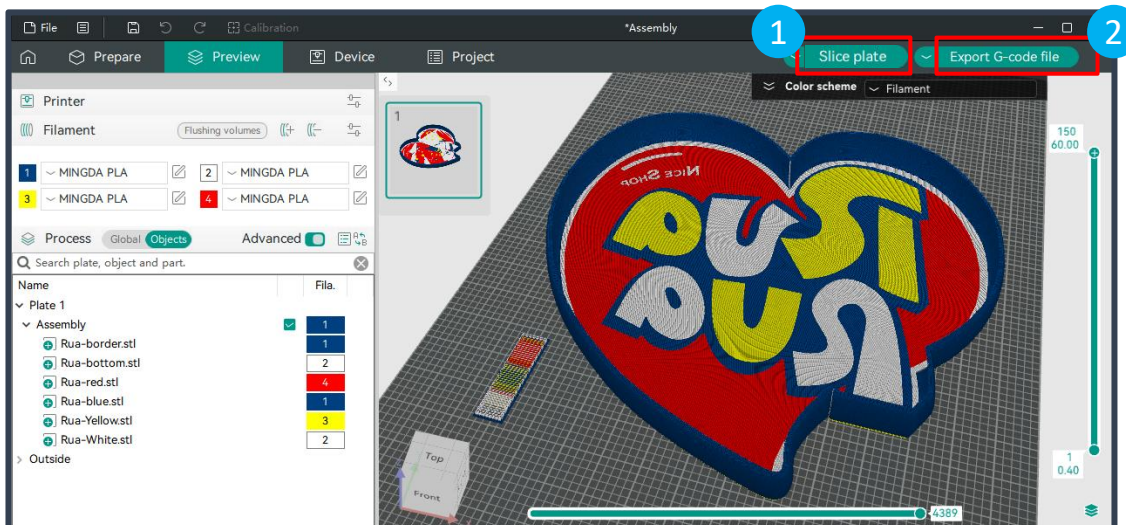
Printing

Local Printing
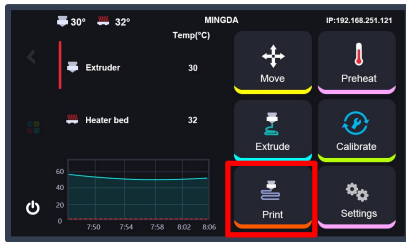
Insert the U-disk, then click the "**Print**"

Find the folder and Click the arrow on the right
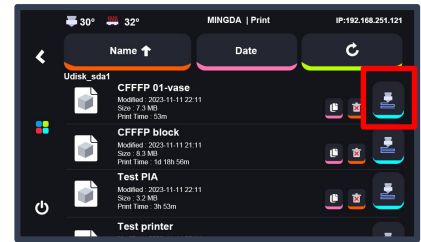
Select the test gcode which was preset in the U-disk.

LAN Printing

Ensure that the printer and the computer host are on the same local network.
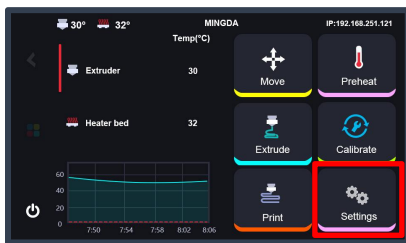
Click "**Settings**" to enter the settings page.
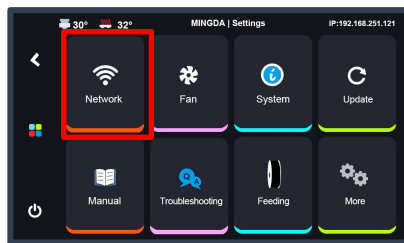
Click "**Network**" to enter the network page.

Check the printer's IP address.
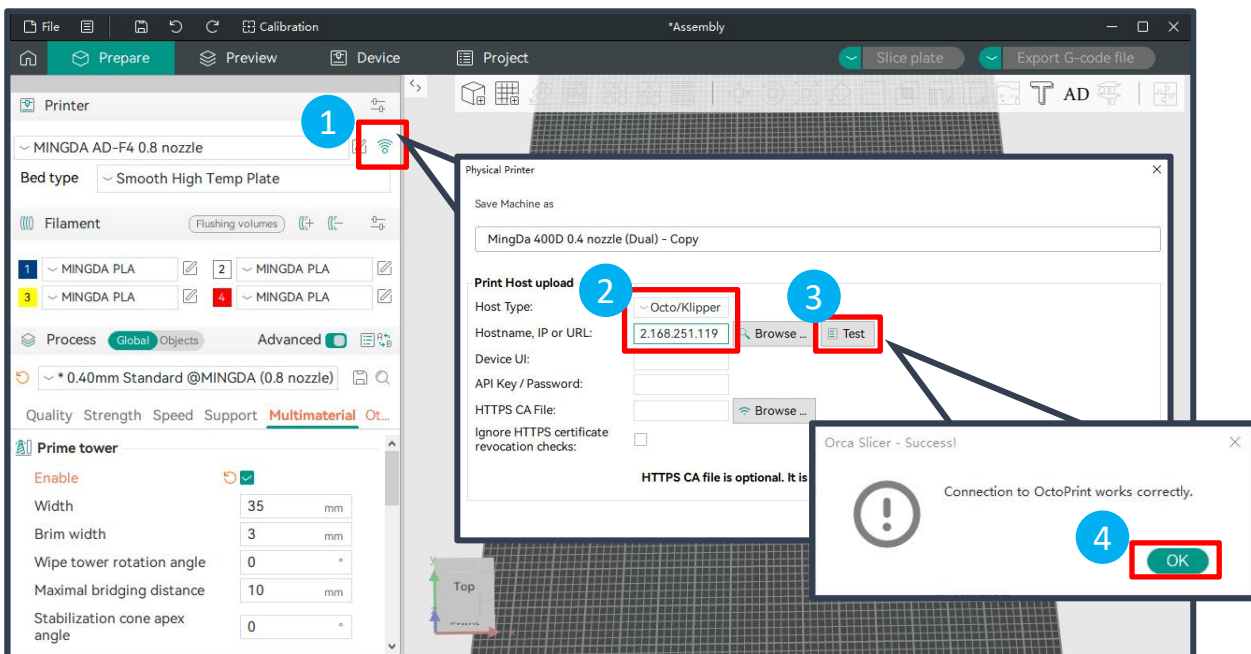
Click WIFI , select Host type as Octo/Klipper, enter the printer's IP address, and click "**Test**" and "**OK**"

File Transfer:
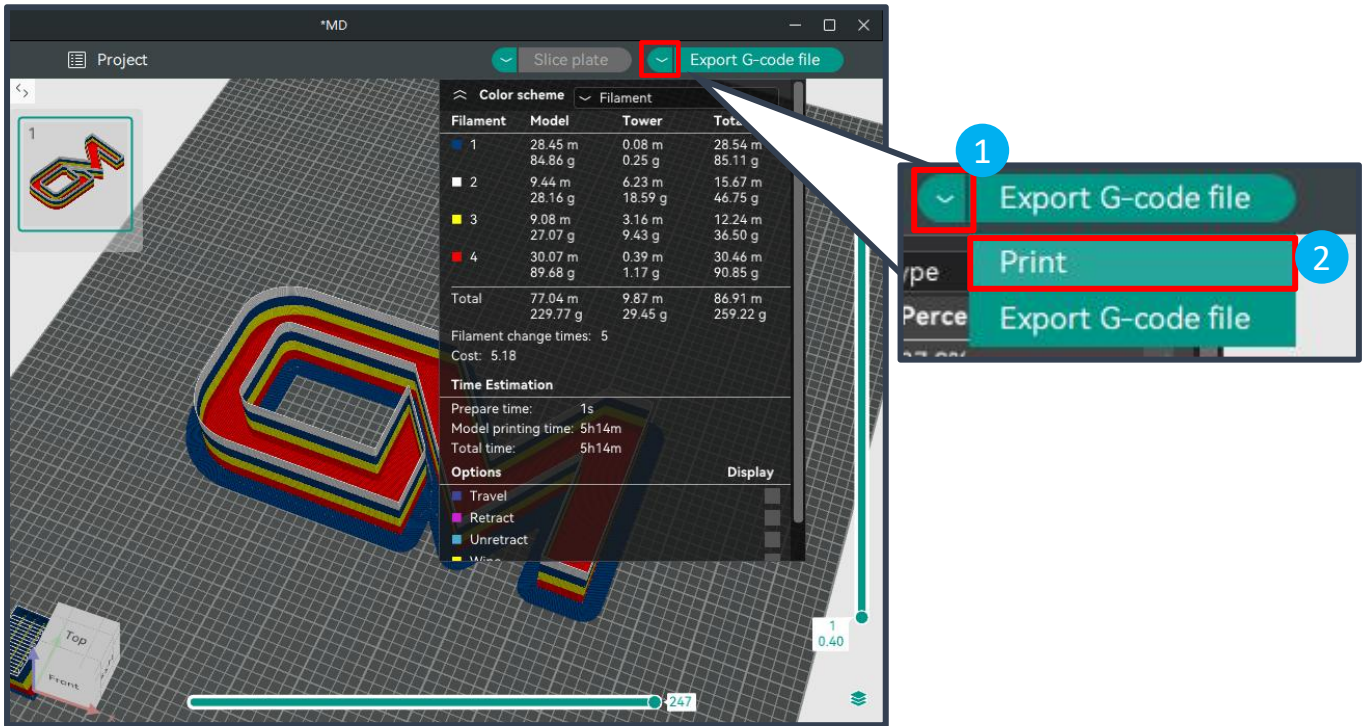
Click the dropdown icon in the top right corner , select "**Print**."
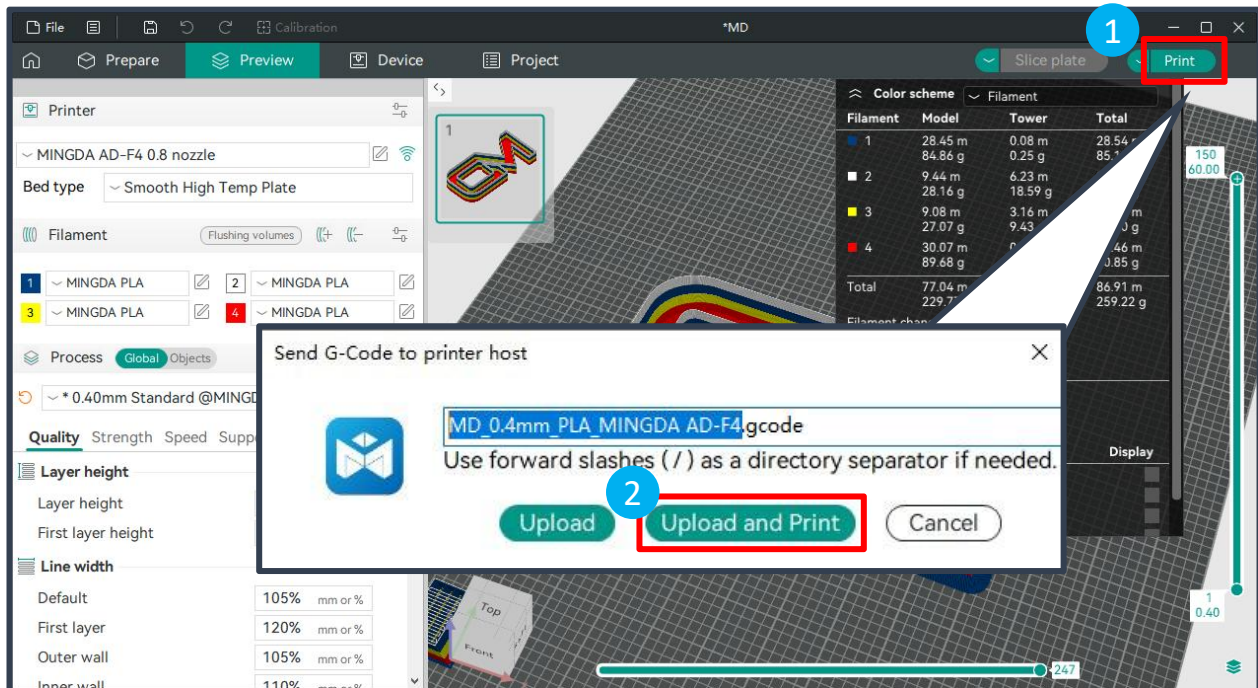
Click "**Print**" and choose "**Upload and Print**."

Device Connection

After successful connection, click on "Device"
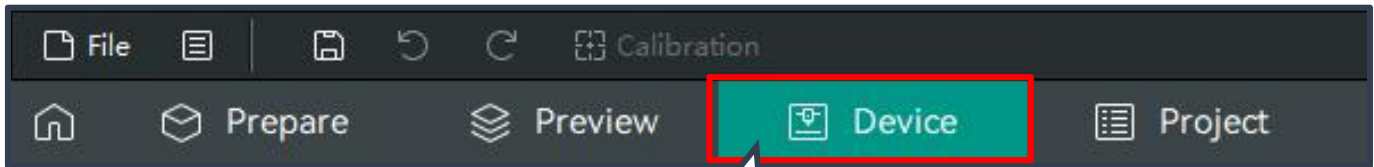
Enter the control interface below the diagram
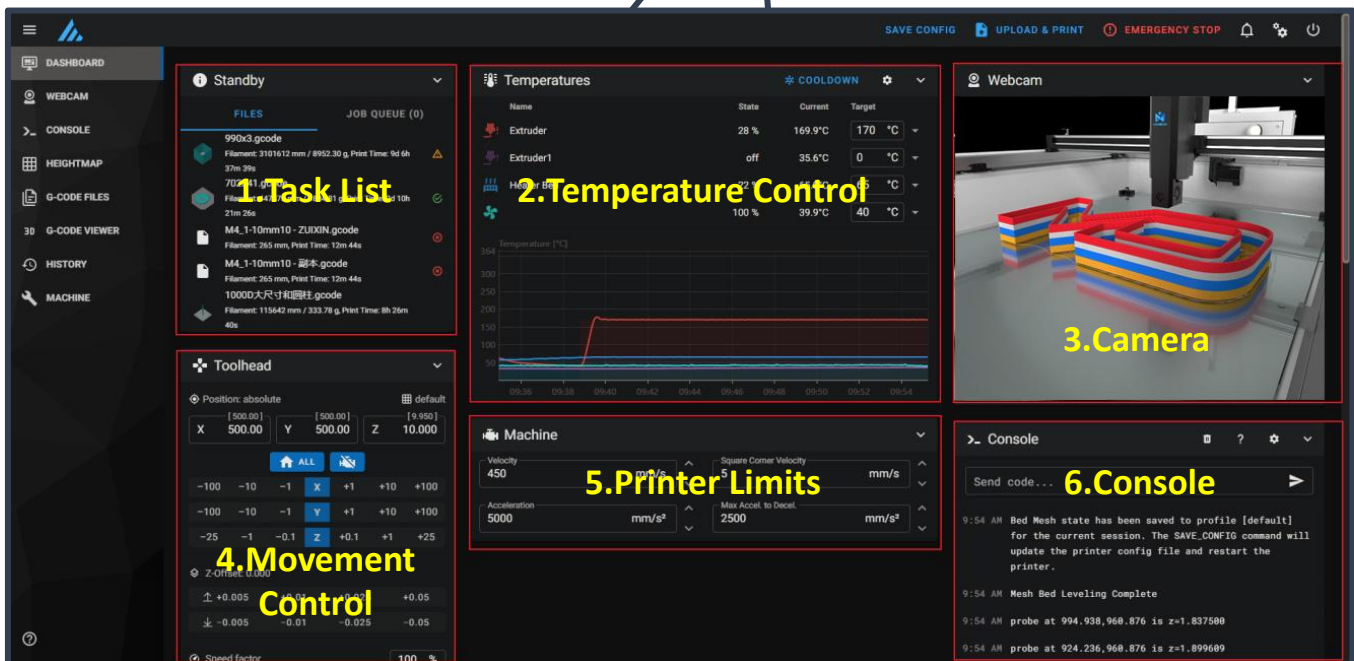
1. **Task List:** Drag G-code files to this task list for printing.

2. **Temperature Control:** Displays machine temperature changes and allows pre-setting nozzle and bed temperatures.

3. **Camera:** Monitors the printing status.

4. **Movement Control:** Controls the movement of each axis and allows compensation settings after leveling.

5. **Printer Limits:** Controls the maximum acceleration of the printer, usually doesn't need to be changed.

6. **Console:** Sends G-code commands to run the machine and displays error output.

10. Maintenance and Care

Cleaning the Nozzle: After printing is complete, promptly clean the residue on the nozzle using a tool and taking advantage of the nozzle's residual heat. Avoid touching the nozzle directly with your hands to prevent burns.

Replacing Filaments: Timely replace filaments based on the type and actual usage. It is recommended to use filaments recommended by the manufacturer. Seal filament not in use for an extended period, as excessive exposure to moisture in the air can make the filament brittle.

Checking the Platform: Regularly check if the print platform is flat. If there is deformation or damage, contact the manufacturer or dealer for repairs.

Regular Lubrication: Periodically apply lubricating oil to the guide rails. During the operation of the printer, friction between various parts occurs. Without proper lubrication, it can lead to wear and damage.

Software Updates: Regularly update the printing software to improve print quality and efficiency.

This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

Any Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

Note: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:
-Reorient or relocate the receiving antenna.
-Increase the separation between the equipment and receiver.
-Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
-Consult the dealer or an experienced radio/TV technician for help.
-This equipment complies with FCC radiation exposure limits set forth for an uncontrolled environment. This equipment should be installed and operated with minimum distance 20cm between the radiator & your body.

MINGDA

Shenzhen MINGDA Technology Co., Ltd

Tel: 0086-13530306290

Email: support@3dmingda.com

www.3dmingda.com

Address: No. 19, Dahe Industrial Zone, Longhua District,

Shenzhen, 518110, Guangdong Province, China.