FLASHFORGE

EN/CN-A02

Adventurer 5M Pro / 冒险家5M Pro

User Guide

用户使用手册

中文P34

WARNING 注意事项

1. Please refer to this Guide for initial printer setup.
2. Hot! Avoid touching the heating nozzle in operation.
3. Moving parts in the printer may cause injuries. Do not wear gloves or other sources of entanglement in operation.

1. 请参照本指南完成打印机的初始准备。
2. 高温危险！打印机喷嘴在工作时会被加热，操作时请避免接触！
3. 可动部件可能会造成卷入挤压和切割伤害。操作机器时请不要佩戴手套或缠绕物。

Safety Notice 安全提示

Do not power on the printer until installation is completed.
请勿在打印机安装完成之前通电。

For more information, you can visit the Flashforge official website.
www.flashforge.com - [Support]

CONTENTS

NOTICE

SAFETY NOTICE: PLEASE CAREFULLY READ AND STRICTLY FOLLOW ALL THE SAFETY WARNINGS AND NOTICES BELOW ALL THE TIME.

Note: Each 3D printer undergoes printing tests before leaving the factory. Filament residue on the nozzle or slight scratches on the build plate are normal and do not affect usage.

WORK ENVIRONMENT SAFETY

- Please keep the workspace clean and tidy.
- Please ensure the equipment operates away from combustible gases, liquids, and dust. High temperatures generated during operation may react with combustible gases, liquids, or airborne dust, potentially causing fires.
- Children and untrained individuals should not operate the equipment alone.

ELECTRICAL SAFETY

- Please properly ground the equipment. Do not modify the plug. Ungrounded equipment/improperly grounded equipment/modified plug will inevitably increase the risk of electric leakage.
- Avoid exposing the equipment to damp or direct sunlight environments. Humidity will increase the risk of electric leakage. Exposure to sunlight will accelerate the aging of plastic parts.
- Make sure to only use the power cord provided by Flashforge.
- Do not use the equipment during thunderstorms.
- Please turn off the equipment and unplug it if it is not in use for a long time.

PERSONAL SAFETY

- Do not touch the extruder, build plate, etc., during printing.
- Do not touch the extruder and build plate after finishing printing to avoid high temperature burns or mechanical damage.
- Do not wear scarves, masks, gloves, jewelry, or other objects that can easily get tangled into the equipment while operating it.
- Do not operate the equipment while you are tired or under the influence of drugs, alcohol or medication.

CAUTIONS

- Keep the inside of the equipment clean. Do not drop metal objects into the grooves at the bottom of the build plate.
- Please clean up filament debris in time. It is recommended to operate this outside the equipment.
- Any modification of the equipment by yourself will void the warranty.
- Please keep the distance between the extruder and build plate for at least 50mm during filament loading. Too-close distance may cause nozzle clogs.
- Please operate the equipment in a well-ventilated environment.
- Do not use the equipment for illegal activities.
- Do not use the equipment to make food storage containers.
- Do not place printed models into your mouth.

EQUIPMENT ENVIRONMENT REQUIREMENTS

- Room temperature: 15-30℃; Humidity: 20-70RH%

EQUIPMENT PLACEMENT REQUIREMENTS

- The equipment must be placed in a dry and well-ventilated environment. A distance of at least 35cm must be reserved around the front, back, left and right sides of the equipment. Recommended storage temperature: 0-40°C

COMPATIBLE FILAMENT REQUIREMENTS

- When using this equipment, it's recommended to use Flashforge's filaments. If non-Flashforge filaments are used, there will be certain differences in material properties, and print parameters may need adjustments.

FILAMENT STORAGE REQUIREMENTS

- Please store filaments in a dry and dust-free environment after unpacking. It is recommended to use the matching filament dry box for storage.

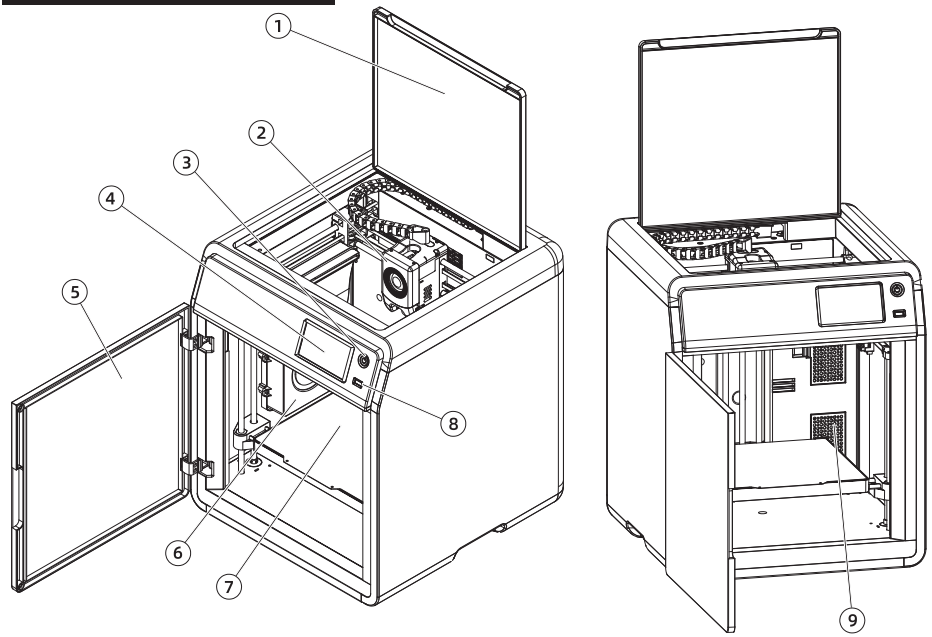
LEGAL STATEMENT

- Users are not authorized to make any modifications to this User Guide.
- Flashforge shall not be held responsible for any safety incidents resulting from the disassembly or modification of the equipment by the customer. No one is allowed to modify or translate this Guide without Flashforge's permission. This Guide is protected by copyright, and Flashforge reserves the right of the final interpretation of this Guide.

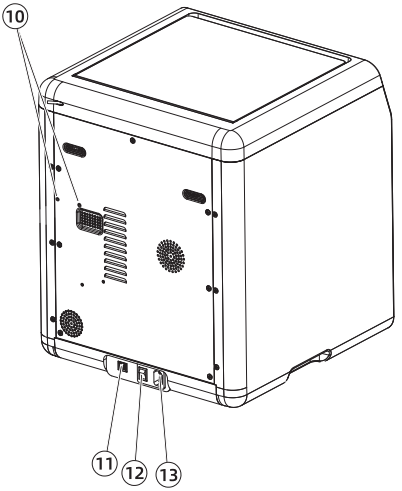
- First Edition (September 2023)

1.Equipment Introduction

1.1 Printer Components



1. Top Cover
2. Extruder
3. Switch Button
4. Touch Screen
5. Front Door
6. Auxiliary Cooling Fan
7. Build Plate
8. USB Port
9. Air Filter
10. Screw Holes for Spool Holder
11. Ethernet Input
12. Power Switch
13. Power Socket



1.2 Printer Parameters

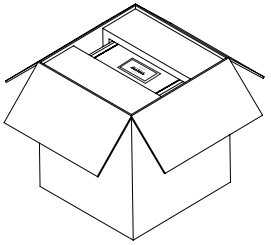
Machine Name	Adventurer 5M Pro
Extruder Quantity	1
Printing Precision	±0.2mm [testing based on 100mm cubes]
Positioning Accuracy	X/Y-axis: 0.0125mm; Z-axis: 0.0025mm
Layer Thickness	0.1-0.4mm
Build Volume	220 x 220 x 220mm
Nozzle Diameter	0.4mm [default]; 0.6/0.8/0.25mm [optional]
Printing Speed	10-300mm/s
Max. Acceleration	20000mm/s²
Max. Travel Speed	600mm/s
Max. Extruder Temperature	280°C
Supported Filament	*PLA/*PETG [0.4mm nozzle] ASA/ABS *TPU/PLA-CF/PETG-CF [0.6/0.8mm nozzle] Note: Materials marked with * are recommended for printing.
Power Supply	Input: AC 100~240V, 50/60Hz, 350W
Device Size	380 x 400 x 453mm [excluding the spool holder]
Net Weight	14.6kg
Connectivity	USB/Wi-Fi/Ethernet
Operating Temperature	15-30°C
Compatible Operating System	Windows 7/8/10/11; Linux: Support version Ubuntu 20.04 or later; Mac OS: Support version 10.9 or later.
Compatible Slicing Software	FlashPrint 5 / Orca / Prusa / Cura
Max. Platform Temperature	110°C
Leveling Method	One-click auto leveling
Filament Run-out Reminder	√
Power Loss Recovery	√
Smart Touch Screen	4.3-inch
Remote Video Monitoring	√
Time-lapse Video	√
Air Filtration	Internal circulation + external circulation [HEPA + activated carbon]
Build Plate	PEI flexible steel plate
Automatic Shutdown	√

2. Initial Setup

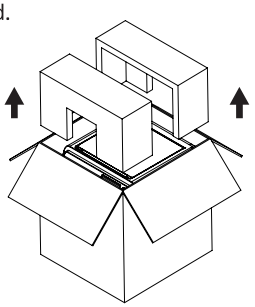
2.1 Unboxing

Safety Notice: Do not power on the printer until installation is completed.

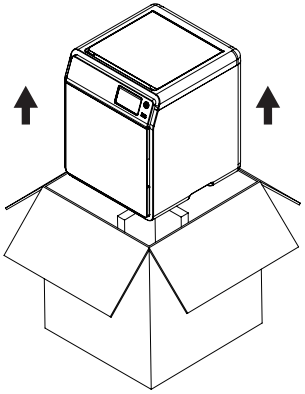
1. Open the box.



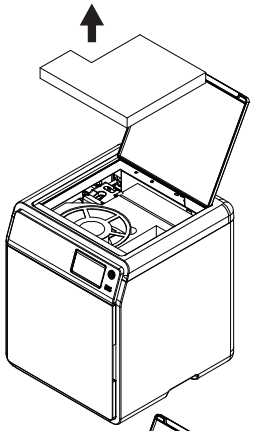
2. Remove the upper foam packaging, Quick Start Guide and After-sales Service Card.



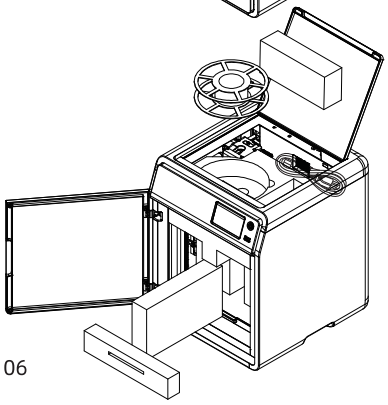
3. Take out the machine, place it on a level workspace and remove the packaging bags and tapes.



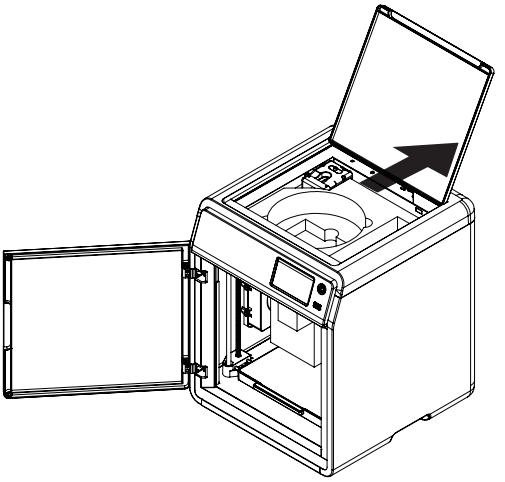
4. Open the top cover and remove the upper protective foam.



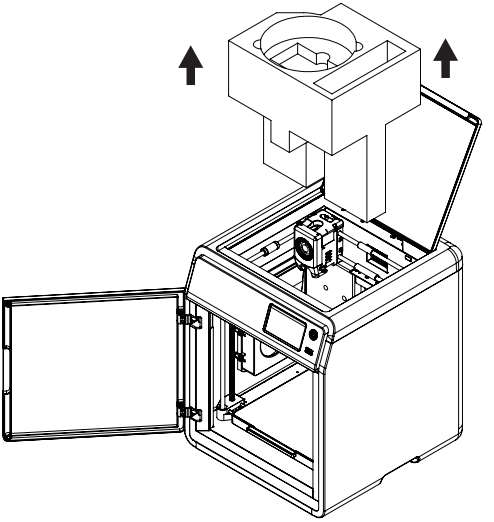
5. Remove the filament and power cable from the chamber protective foam. Remove the inner protective foam of the extruder. Open the front door, and remove the front protective foam and accessory box.



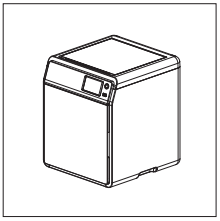
6.Move the chamber foam according to the arrow direction.



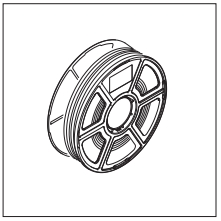
7. Remove the foam.



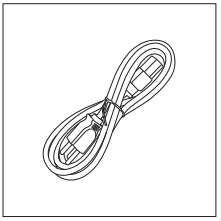
2.2 Packing List



3D Printer

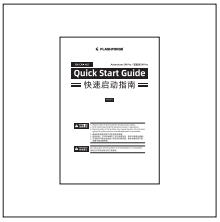


Filament

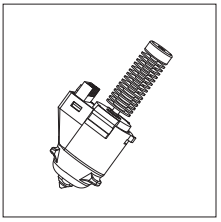


Power Cable

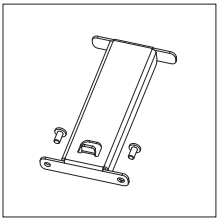
After-sales Service Card



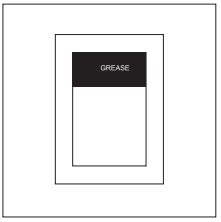
Quick Start Guide



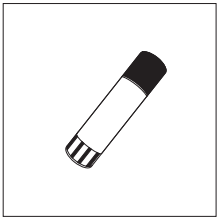
0.6mm Nozzle



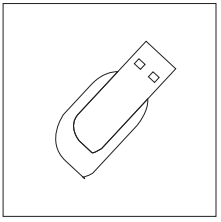
Spool Holder (with 2 screws)



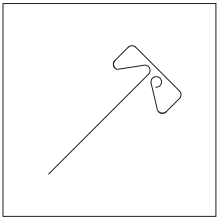
Grease



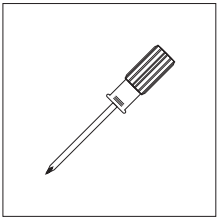
Glue



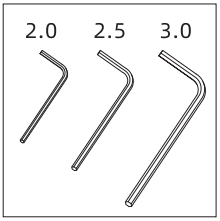
USB Disk



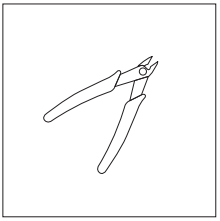
Unclogging Pin Tool



Screwdriver



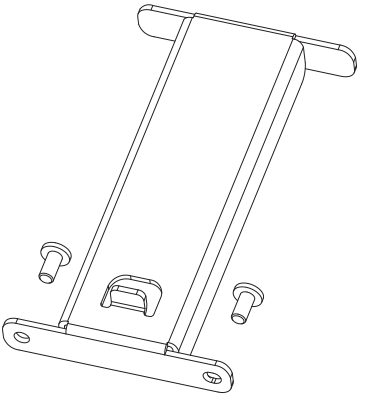
Allen Wrench



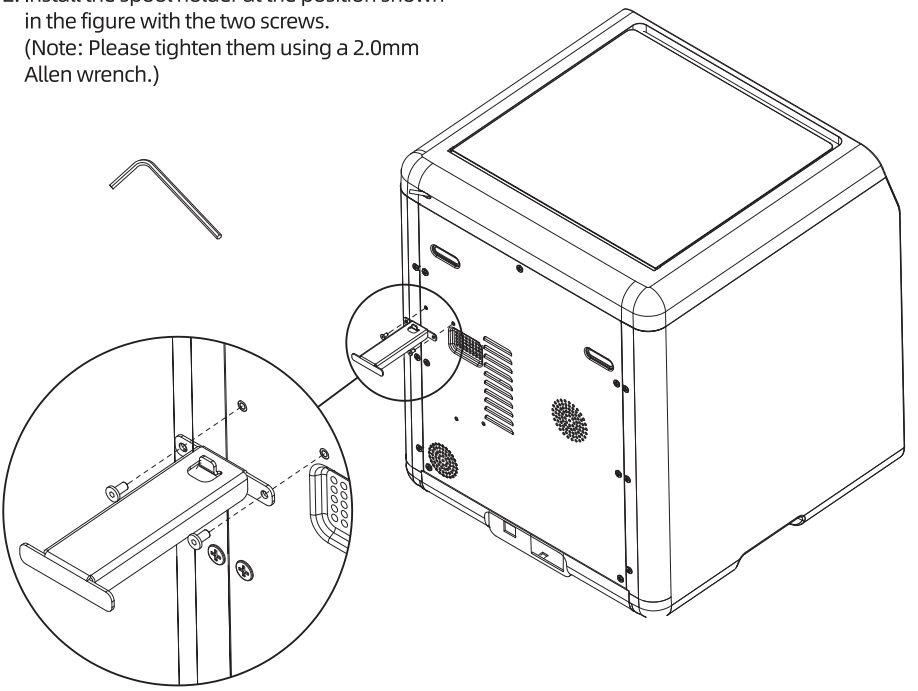
Diagonal Pliers

2.3 Installing the Spool Holder

1. Take out the two screws and spool holder from the accessory box.



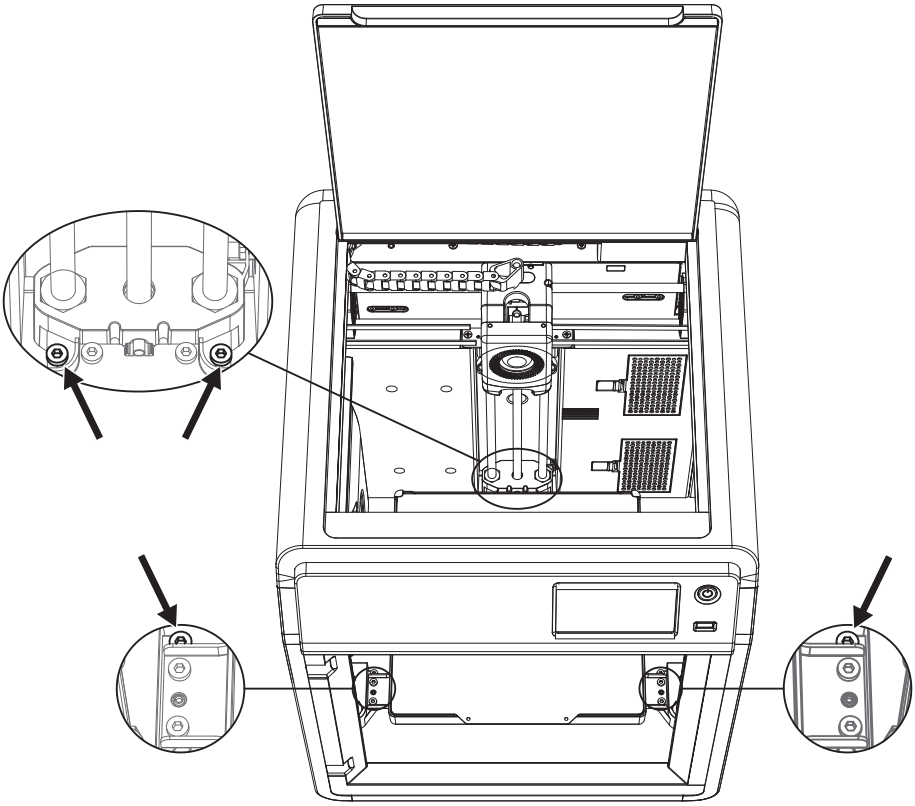
2. Install the spool holder at the position shown in the figure with the two screws.
(Note: Please tighten them using a 2.0mm Allen wrench.)



2.4 Unlocking the Build Plate

Note **Please ensure the platform has been cleared up!**

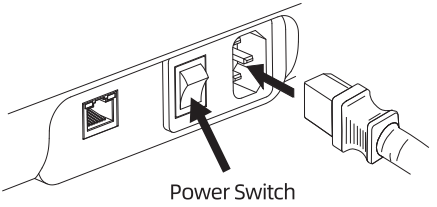
Please use a 2.0mm Allen wrench to remove four screws which lock the build plate (as indicated by the arrow).

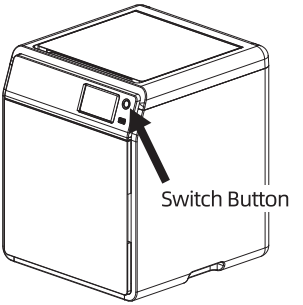


2.5 First Print

* The interface layout may change whenever there is an upgrade of firmware.

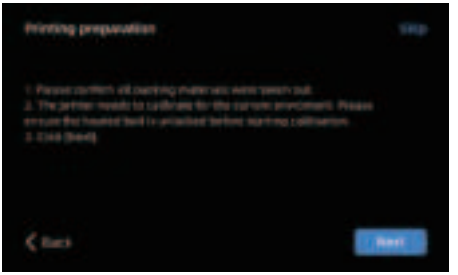
1. Connect the power, turn on the power switch, and press the switch button to turn on the screen.

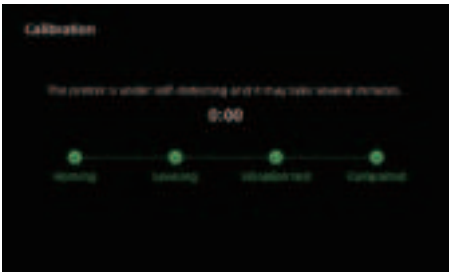




2. Following the guide on the screen, select the language.

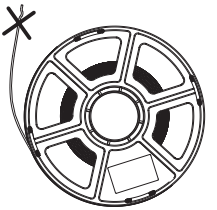
3. Click [Next] according to screen prompts and the machine will perform the first calibration. Vibrations and noise during calibration are normal. (Note: Please keep the machine on a stable surface and do not move it during calibration.)



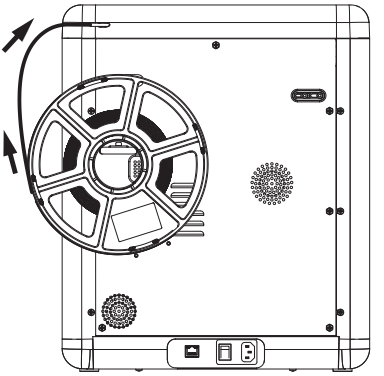


4. Load filament following the on-screen startup boot:

a. Cut off the bent part of the filament end.



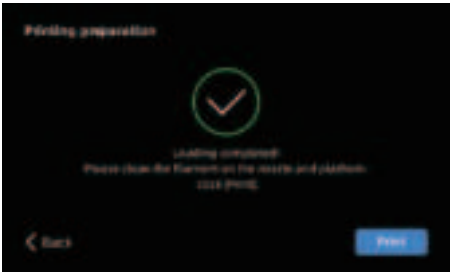
b. Hang the filament on the spool holder. Pass it through the filament sensor until it's seen from the other end of the filament guide tube. Push it forward to the feed roller, until it can not go further. (*Please use PLA filament for the first print on initial setup).

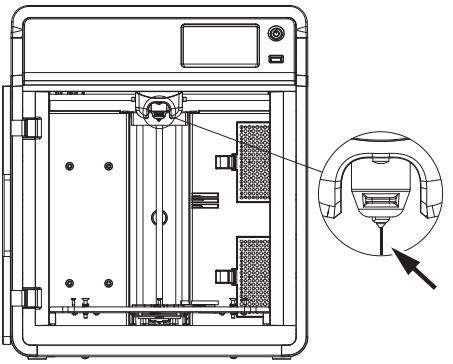


C1. Click [Load] and select [PLA] for the first print.

C2. Wait for the extruder to heat up.

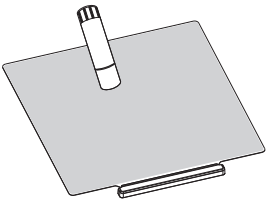
C3. Feeding will begin after heating. Successful filament extrusion from the nozzle indicates successful loading. Lastly, confirm the filament guide tube is properly inserted.





Note If no filament is extruded, manually insert the filament into the inlet and click **[Back]** to retry. Feel for filament movement until it is extruded.

5. Please clear the filament residues on the nozzle and platform. Users must apply glue to the platform so as to improve adhesion for the first print.



6. Click [Print] and the machine starts printing the built-in file (configured for PLA material).

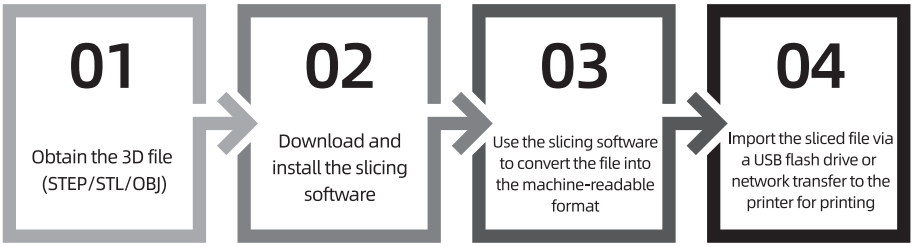
3. Software Introduction & Installation

Slicing Software Instructions for Adventurer 5M Series

Note **Before reading the brief instructions, please ensure you have reviewed the Quick Start Guide and completed the first print.**

Before printing 3D model files, you need to configure slicing presets for the corresponding printer. Recommended slicing software: **OrcaSlicer / FlashPrint 5**

Pre-printing Steps:



Open-source Slicing Software

OrcaSlicer

This slicing software, created by the open-source community, offers more open configuration options. Experienced users are recommended to use this slicing software.

Download and Installation Instructions

1. Download the latest slicing software from the official website: https://github.com/SoftFever/OrcaSlicer/releases.
2. Find the OrcaSlicer software package on the USB flash drive and install the version that matches your system.

Note

Files can be imported by project, requiring a click on the project file each time you open it. Alternatively, configs can be imported, eliminating the need to do so each time, but this may not be compatible with higher software versions.

How to Use OrcaSlicer (Import Project Files)

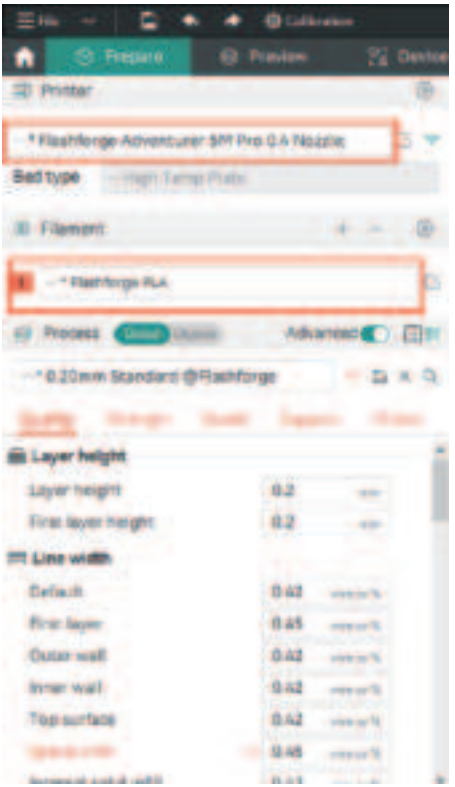
* The steps are illustrated for one machine type.

1. Open the installed OrcaSlicer.

2. Click [Open Project].

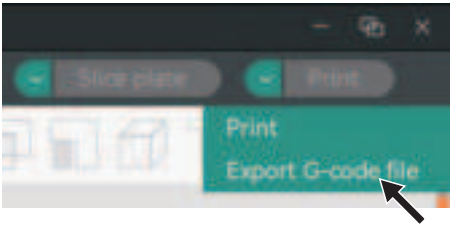
3. The profile should be in .3mf format. You can find the corresponding file on the USB flash drive. Drag it directly into OrcaSlicer, or open it directly (if the machine is not configured with a USB flash drive, please download the corresponding profile from Flashforge's official website).

4. After importing the profile, the software interface will display the corresponding printer, and you can select the desired printing material.



5. Select the model file to be printed. You can drag it directly into the software, or click [File] - [Import] to import the model file (STL/STEP/OBJ/3MF, etc.).

6. Click [Slice all]. Once slicing is completed, click [Export G-code file], save the file to a USB flash drive, and then insert it into the printer for printing.



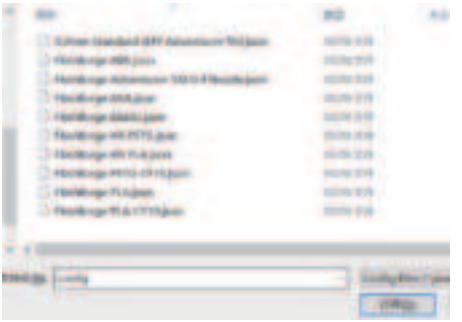
How to Use OrcaSlicer (Import Configs)

* The steps are illustrated for one machine type.

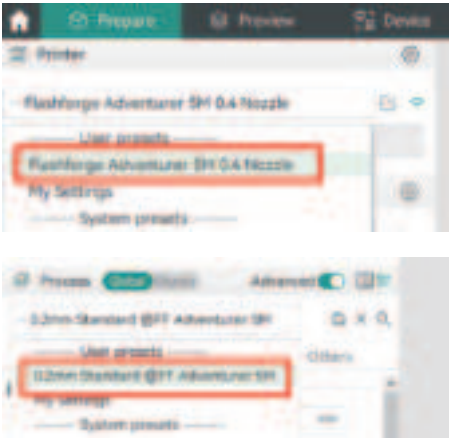
1. Open the installed OrcaSlicer.

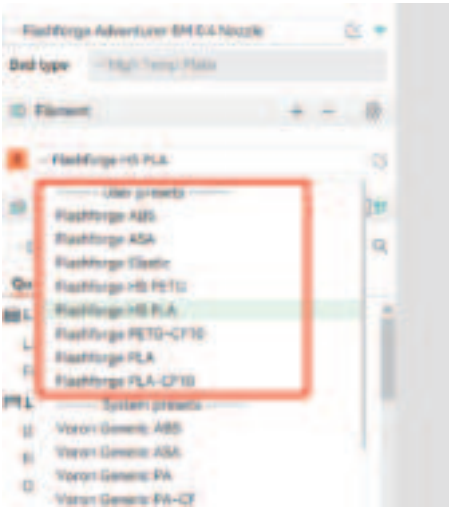
2. Click **[File] - [Import] - [Import Configs...]**.

3. The config file should be in .json format. You can find the corresponding files on the USB flash drive, select all, and open it (if the machine is not configured with a USB flash drive, please download the corresponding config files from Flashforge's official website).



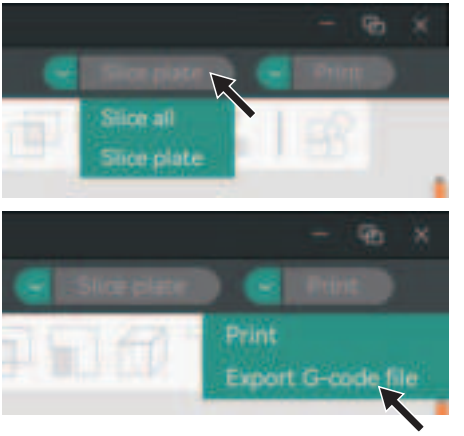
4. After importing, the corresponding printer, available filaments, and recommended parameters will be displayed.





5. Select the model file to be printed. You can drag it directly into the software, or click **[File]** - **[Import]** to import the model file (STL/STEP/OBJ/3MF, etc.).

6. Click **[Slice all]**. Once slicing is completed, click **[Export G-code file]**, save the file to a USB flash drive, and then insert it into the printer for printing.



Flashforge's Official Slicing Software - FlashPrint 5

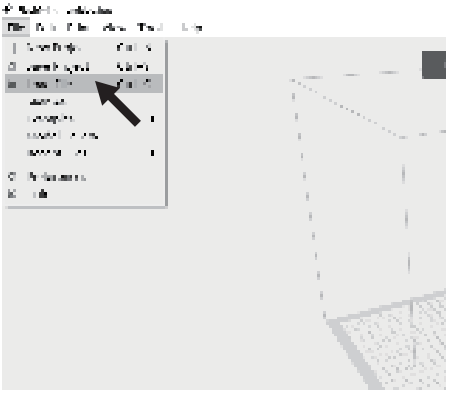
* The steps are illustrated for one machine type.

FlashPrint 5 is not open-source. It is user-friendly and suitable for users with no 3D printing experience or those who don't require parameter adjustments.

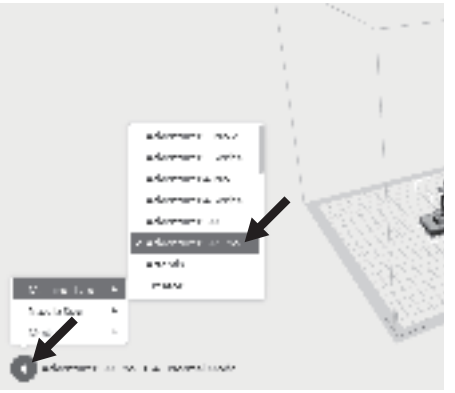
Download Instructions

1. Download the latest slicing software from the official website: https://www.flashforge.com/download-center.
2. Find the FlashPrint 5 software package on the USB flash drive and install the version that matches your system.

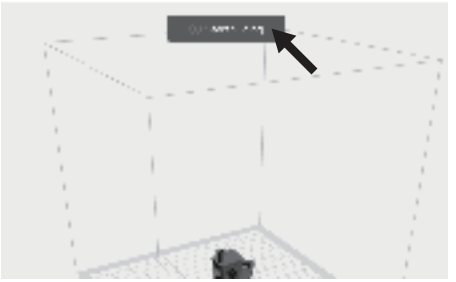
1. After installing the slicing software, import the model file.



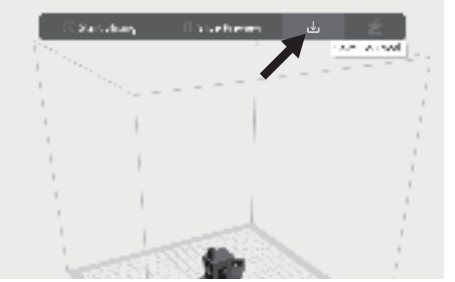
2. Select the corresponding printer type.



3. Click **[Start Slicing]**.



4. After slicing is completed, save the file to a USB flash drive for printing.



⚠ Note **The slicing profiles available in FlashPrint 5 are configured based on extensive testing with various types of filaments. We recommend using the recommended temperature settings provided in the profiles. If you believe a specific filament requires a different temperature, you can make minor adjustments and print smaller objects at the set temperature for testing to ensure smooth operation.**