



T-REX² **3D Printer Twin Extruder**

Art. No. 2010600



Instruction manual

Contents

Introduction.....	4
General Information.....	5
Safety Instructions	6
Chapter 1: 3D printing technology	10
1.1 procedure.....	10
Chapter 2: About the 3D Printer	12
2.1 About the 3D Printer.....	12
2.2 Unpacking and installation	17
2.3 The initial setting	24
2.4 Touchscreen Interface - Introduction	35
Chapter 3: Slicing Software	43
3.1 Installation.....	43
3.2 Get to know REXprint.....	44
3.3 How do I create a .g file?	63
3.4 Introduction to functions	65
Chapter 4: Maintenance	72
Chapter 5: Warranty and service	73

Further information, updates or software

Visit our website via the following QR code or web link. Here you will find additional information, available updates or software for this product as well as suitable accessories:

3D printer



www.bresser.de/P2010600

Accessories



www.bresser.de/P2080210000000

After Sales Support / Service

For this product we offer an individual service even after the purchase. If you have problems with this product, our customer service will be happy to help you.

For smooth **processing, please have the following information ready for possible inquiries:**

- Warranty & Service
- Part number and product description
- Date of purchase and dealer

Contact details:

e-Mail: **service.3d@bresser.de** (preferred way of communication)
Internet: **www.bresser.de/c/de/service**
Phone: **+ 49 28 72 80 74 210**

Service hours:

Monday thru Friday 9:00 a.m. to 3:00 p.m. (CET)
(except on national holidays)

*Number charged at local rates / amount you will be charged per phone call depends on the tariff of your phone provider / calls from abroad will involve higher costs

Guarantee

Please refer to the enclosed card "Warranty & Service" for further information.

Introduction

Note: Each unit is subjected to a factory test before shipment. Residues on the extruder or the smallest of scratches on the construction tape are normal and have no influence on the print quality.

Bresser GmbH would like to take this manual as an opportunity to thank both the technicians of Bresser GmbH and the users of this 3D printer for their tireless efforts and extremely important support.

This Bresser GmbH Saurus user manual is intended for the users of Saurus who are now starting their journey into the future of printing with Bresser GmbH Saurus. Even if you are familiar with the older models of Bresser GmbH equipment or 3D printing technology, we recommend that you read this manual. It contains a lot of important information for you to know regarding Saurus and to improve your 3D experience:

(1) BRESSER T-REX² Quick Start Guide

The Quick Start Guide is included with the printer. The information it contains will help you start printing in no time.

(2) BRESSER T-REX² product page on the Internet

Visit the product page on the Internet at www.bresser.de/P2010600 for additional information, available updates or software for this printer and related accessories.

General Information

Important notes:

- - Please read this manual carefully before using the machine.
- - This manual assumes that you are using the Windows 7 operating system to operate the 3D Printer.
- - The current version of the REXprint software is used.

This manual contains all necessary information for setting up and operating the device.

The operating instructions consist of the following parts: Introduction, general and safety information, operation and product service.

For service requests, please have ready:

Item nr: 2010600

Product reference BRESSER T-REX 2 3D Printer

Instruction manual:

Manual_2010600_Wifi-3D-Printer-T-REX-2_en_BRESSER_v112021a.docx

Safety Instructions

IMPORTANT NOTE!

Familiarise yourself with this manual and read all the instructions it contains before you start setting up and operating the machine. Failure to heed warnings and instructions may result in personal injury, fire, and damage to the unit or other property.

STRICTLY FOLLOW ALL SAFETY AND OTHER INSTRUCTIONS GIVEN IN THIS MANUAL AT ALL TIMES!

Safety in the working environment

- ① Keep the workplace clean!
- ② Do not operate the 3D Printer in the presence of flammable liquids, gases or dust.
- ③ Keep children and untrained persons away from the 3D printer.

Security of power supply

- ① Operate the 3D Printer only from an earthed power outlet. Do not make any changes to the power plug of the 3D Printer.
- ② Do not operate the 3D printer in a hazy or humid environment. Do not expose the 3D printer to direct sunlight.
- ③ Do not use the power cable for any purpose other than its intended use.
- ④ Do not operate the unit during thunderstorms.
- ⑤ To avoid accidents, disconnect the device from the power supply if you are not going to use it for a long period of time.

Safety of people

- ① Do not touch the nozzle or pressure plate during printing.
- ② Do not touch the nozzle after printing is completed.
- ③ Wear suitable clothing. Do not wear loose clothing or loose-fitting jewellery. Make sure that your hair, clothing and gloves do not come into the vicinity of moving parts.
- ④ Do not operate the device if you are tired or under the influence of drugs, alcohol or medication.

Safety Precautions

- ① Do not leave the device unattended for a longtime.
- ② Do not make any changes to the device.
- ③ Lower the pressure plate before inserting/removing filament. (The distance between nozzle and pressure plate should be at least 50 mm)
- ④ Operate the device in a well-ventilated environment.
- ⑤ Do not use the device for unlawful purposes.
- ⑥ Do not use the appliance to make containers for storing food.
- ⑦ Do not use the device to manufacture electrical equipment.
- ⑧ Do not put models in your mouth.
- ⑨ Do not remove the models by applying force.

Environmental conditions

TEMPERATURE: Room temperature 15 to 30 °C °C

Moisture: 20% ~ 70%

Filament specifications

Use the filament only for the intended purpose! Use only the BRESSER filament or a filament of the brands authorised by BRESSER!

Filament storage

A certain degree of decay can be observed in all polymers over time. Only unpack the filament when you need it. The filament should be stored in a clean and dry environment and protected from sunlight.

Legal notice

All information in this document can be extended or adapted without prior notice.

BRESSER GMBH MAKES NO WARRANTIES WITH RESPECT TO THIS DOCUMENT, INCLUDING, WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

Furthermore, BRESSER GmbH does not assume any liability for errors contained in this manual or for incidental consequential damages in connection with the delivery, performance or use of this material.

EC DECLARATION OF CONFORMITY



A "Declaration of conformity" in accordance with the applicable directives and corresponding standards has been prepared by Bresser GmbH. The full text of the EC declaration of conformity is available at the following Internet address:

www.bresser.de/download/2010500/CE/2010200_CE.pdf

EC DECLARATION OF CONFORMITY



A "Declaration of conformity" in accordance with the applicable directives and corresponding standards has been prepared by Bresser GmbH. The full text of the EC declaration of conformity is available at the following Internet address:

www.bresser.de/download/2010500/UKCA/2010500_UKCA.pdf

This document contains information protected by copyright.

Copyright © 2020 BRESSER GmbH. All rights reserved.

The reproduction of this documentation - even in extracts - in any form (e.g. photocopy, print, etc.) as well as the use and distribution by means of electronic systems (e.g. image file, website, etc.) without the prior written permission of the manufacturer is prohibited.

The designations and brand names of the respective companies used in this documentation are generally protected by trade, trademark and/or patent law in Germany, the European Union and/or other countries.

Chapter 1: 3D printing technology

3D printing transforms three-dimensional models into physical objects that you can touch and hold in your hand. This printing form is also called additive manufacturing, because the 3D model is created by applying as many layers as necessary until the object is completely formed.

Fused Filament Fabrication (FFF) is the most common method of 3D printing used by this 3D printer. In this printing method, a plastic, the filament, is melted at high temperature and applied to a printing surface. The filament solidifies during cooling, i.e. practically immediately after leaving the nozzle. 3D objects are formed by applying the filament in several layers on top of each other.

1.1 procedure

3D printing involves three steps:

1. Create or download a 3D model
2. Slicing and exporting the 3D model
3. Building the 3D model

1.1.1 Creating a 3D model:

There are currently three ways to create a 3D model:

- **Design from scratch** You can use free computer-aided design (CAD) software such as 3DTADA, AutoCAD, SolidWorks, Pro-E or our own software Happy 3D to design your own 3D model.
- **3D Scanner** As an alternative to creating a 3D model, you can also scan an object. A 3D scanner digitalises a physical object by capturing the object's geometric data and storing it in a file on the computer. It is also possible to use a mobile device as a 3D scanner by using an app.
- **From the Cloud** - currently the most common method for obtaining a 3D model is to download a 3D model from a website where users can upload their own 3D models.

<https://cloud.sz3dp.com/> Bresser GmbH Cloud

www.thingiverse.com Thingiverse is an active community for discovering, making and sharing 3D models.

1.1.2 Slicing and exporting a 3D model:

Slicer software is used to prepare 3D models for printing and converting them into instructions for the 3D printer. REXprint is the slicer software for this 3D printer. With REXprint, STL files can be converted to G or GX files for printing. These are then transferred to the 3D printer via USB cable, USB stick or W-LAN.

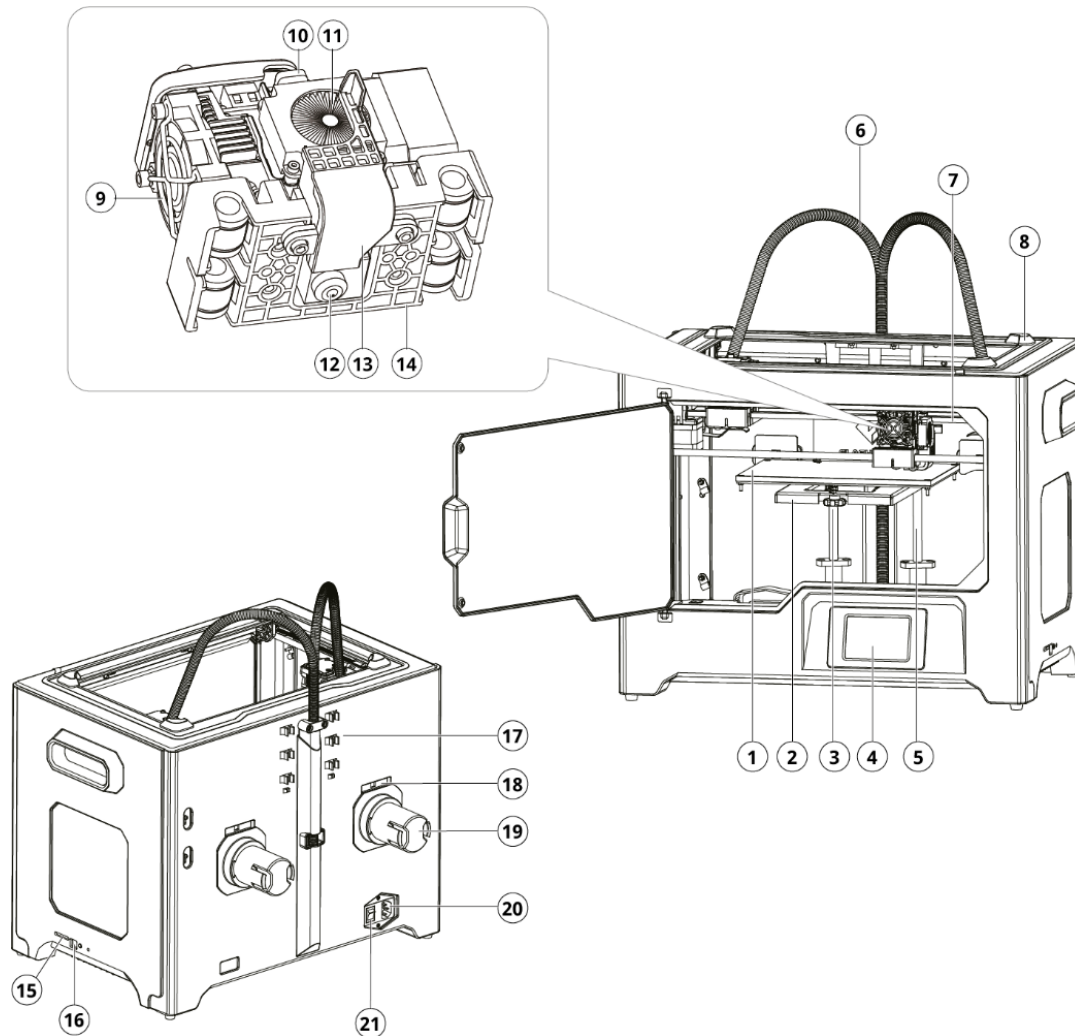
1.1.3 Structure of the 3D model

After the output file is sent to the 3D printer, the printer begins to transfer the 3D model into a physical object by applying layers of filament over each other.

Chapter 2: About the 3D Printer

2.1 About the 3D Printer

Parts overview

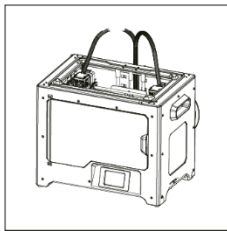


- 1. Platform
- 2. Platform support
- 3. Levelling nut
- 4. LCD display
- 5. Z-axis guide rod
- 6. Extruder cable set
- 7. X-axis guide rod

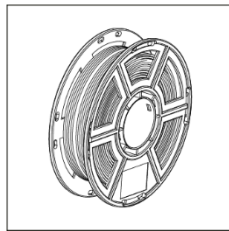
- 8. Slit
- 9. Nozzle cooling fan
- 10. Spring Retainer
- 11. Cooling fan
- 12. Nozzle
- 13. Turbo blower plate
- 14. Extruder holder

- 15. SD card slot
- 16. USB input
- 17. Filament guide tube
- 18. Bobbin holder slot
- 19. Spool holder
- 20. Power Input
- 21. Power switch

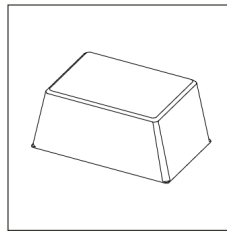
2.1.2 Accessories



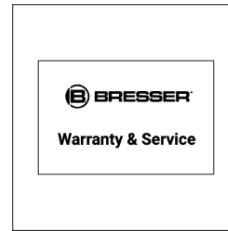
3D printer



Filament spool



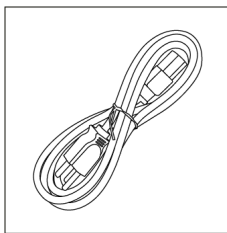
Top cover



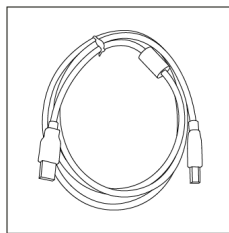
Service card



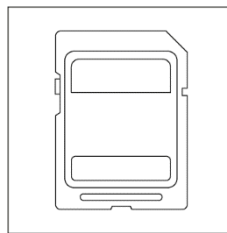
Quickstart Guide



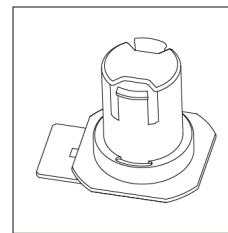
Power cable



USB cable



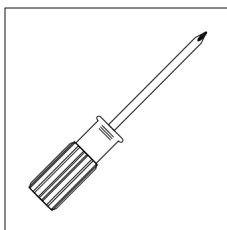
SD Card



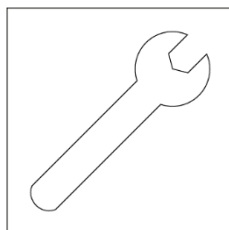
Spool holder



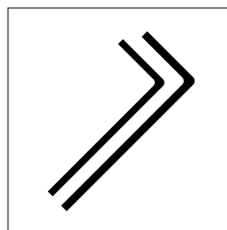
Build tape



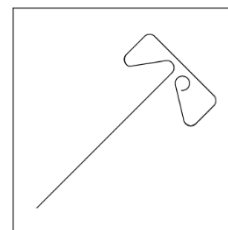
Screwdriver



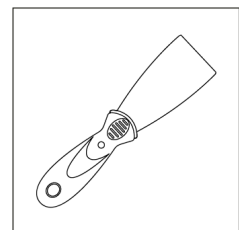
Stamping wrench



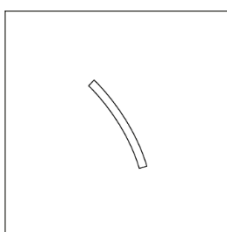
Allen key



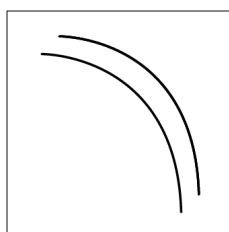
Pin tool



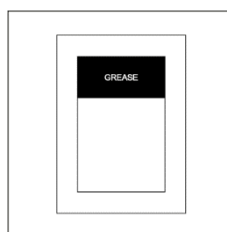
Scraper



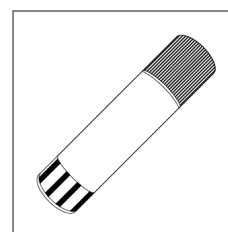
PTFE tube



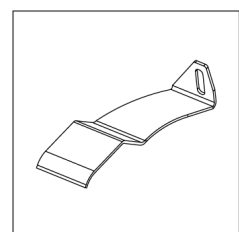
Guide tube



Grease



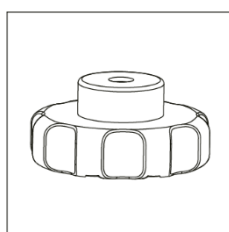
Glue stick



Anti-oozing plate



Levelling
-map



Levelling nut

2.1.3 Terms and definitions

Construction plate	The surface on which BRESSER T-REX 2 builds an object.
Construction volume	The three-dimensional surface of an object after its completion. Largest construction volume of BRESSER T-REX 2: 200x148x150 mm.
Levelling nuts	Use the nuts under the platform to adjust the distance between the nozzle and the construction platform.
Extruder	The extruder pulls the filament from the spool, melts it and pushes it through a nozzle onto the construction platform.
Nozzle	This "print head" sits at the bottom of the extruder, there where the heated filament is pressed out.
Filament guide tube	A plastic tube in which the filament is fed from the filament box to the filament holder.
Punch key	A tool for determining the size of the nozzle metal cube.
Cleaning pen tool	A tool for cleaning the clogged extruder.

2.1.4 Device data

Name	BRESSER T-REX 2 3D Printer
Number of extruders	2 (independent)
Printing Technology	Fused Filament Fabrication (FFF)
Display size	8.9 cm (3.5")s
Print volume	200 x 148 x 150 mm Mirror Mode: 80 x 148 x 150 mm Duplicate mode: 95 x 148 x 150 mm
Layer resolution	0.1 mm
Printing accuracy	±0.2 mm
Printing filament	PLA/PVA/ABS/HIPS
Filament diameter	1,75 mm
Nozzle diameter	0,4 mm
Software	REXprint
Supported file formats	Input: 3MF/STL/OBJ/FPP/BMP/PNG/JPG/JPEG GX/G
AC input voltage	Entrance: 100-240 VAC, 47-63 Hz, power: 320 W
Connections	SD card, USB cable, Bresser GmbH Cloud
Operating system	Windows XP/Vista/7/8/10、 Mac OS、 Linux
Unit dimensions	526 x 360 x 403 mm
Net weight	15 kg

2.2 Unpacking and installation

Unpacking

This chapter describes how to unpack completely the 3D Printer.

Note:

Please read the unpacking guide completely.

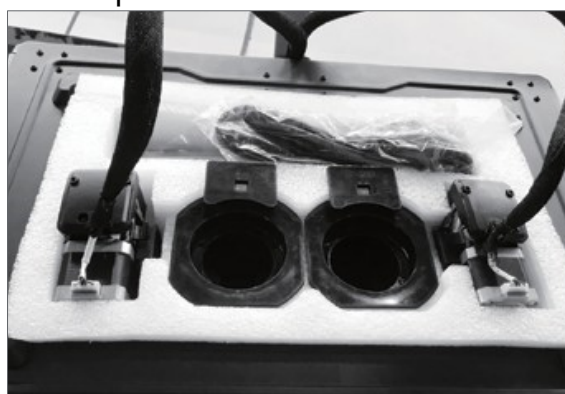
1. Remove the packaging and carefully take out the contents. Do not use force.
2. Do not remove the yellow high temperature tape around the nozzle. It exhibits thermal insulation and high temperature resistance properties.



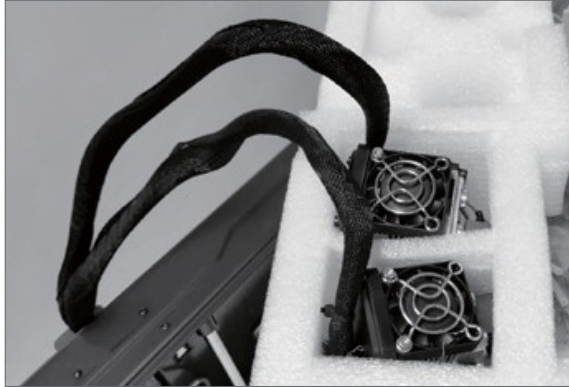
- ① Open the box and take out the foam parts.



- ② Hold both handles on the two sides of the printer. Lift it out of the box and place it on a stable surface.



- ③ Remove the packing bag and remove the tape and the protective plastic cover of the front flap.



- ④ The accessories are shown here. • Remove the package and take out accessories carefully!



- ⑤ Remove the extruder and set it up carefully. The nozzle must not touch the table so that the nozzle remains protected from scratches

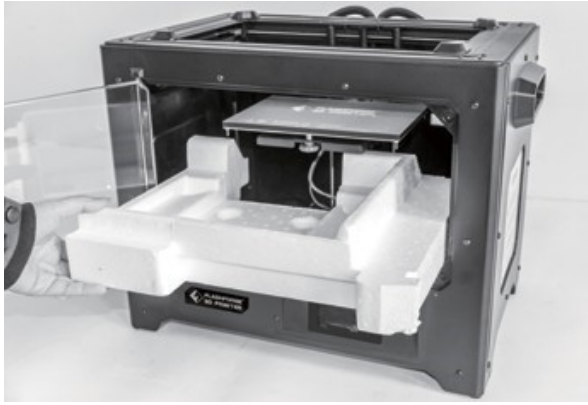
- ⑥ Take out the foam with the accessories. Cut the two cable ties on both sides of the X-axis guide rod.



- ⑦ Open the flap, remove the top cover of the printer and release the filament from the cover.



- ⑧ Hold both sides of the pressure platform and lift the platform off the floor to make it easier to remove the foam box underneath.



- ⑨ Remove the foam from the bottom of the platform and then slowly push the platform down with your hands. This simplifies the subsequent installation.

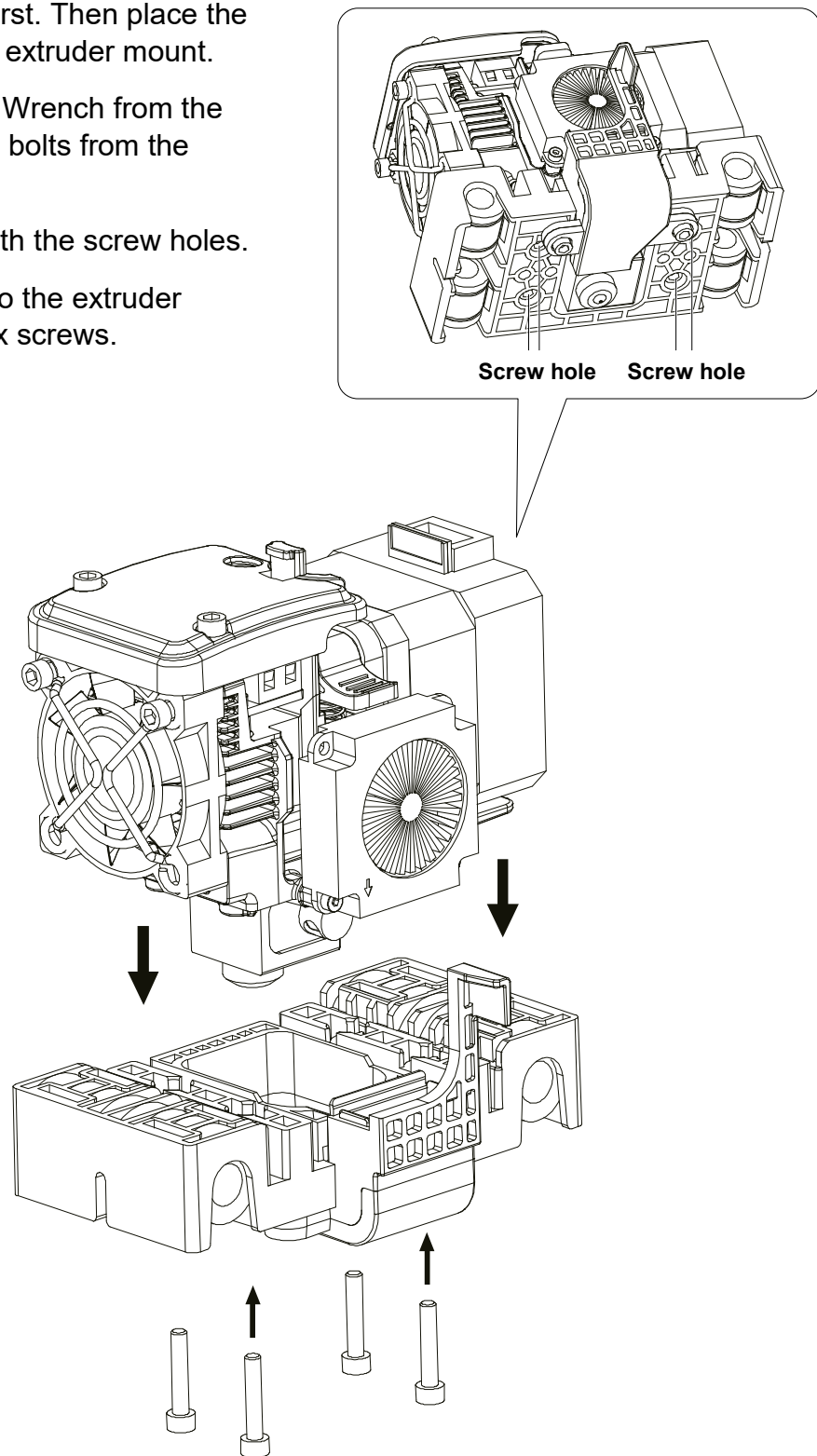


- ⑩ Now you have unpacked everything. Keep the packing material in case you need it again later.

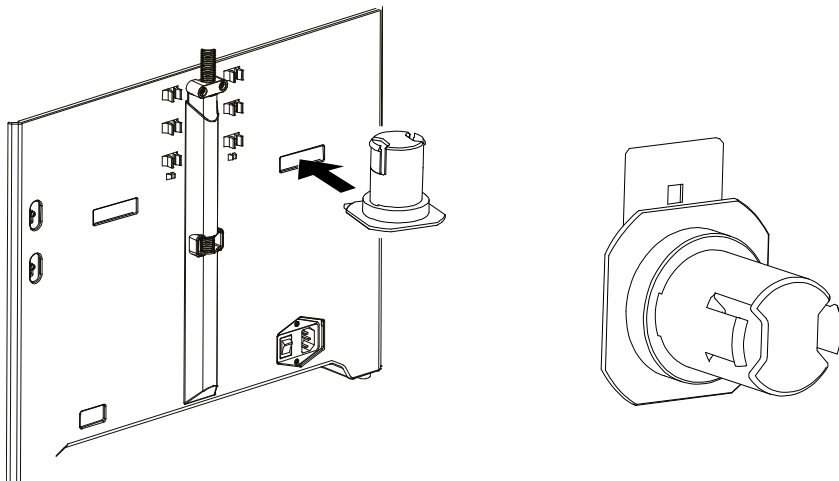
INSTALLATION

2.2.2.1 Extruder assembly

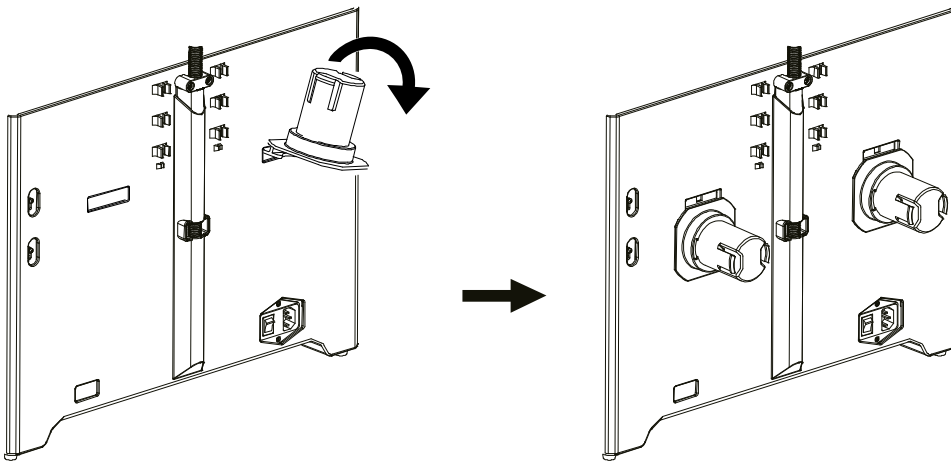
- ① Lower the platform first. Then place the dual extruder on the extruder mount.
- ② Take the M2.5 Allen Wrench from the tool bag and two M3 bolts from the accessory kit.
- ③ Align the extruder with the screw holes.
- ④ Screw the extruder to the extruder mount using the M3x screws.



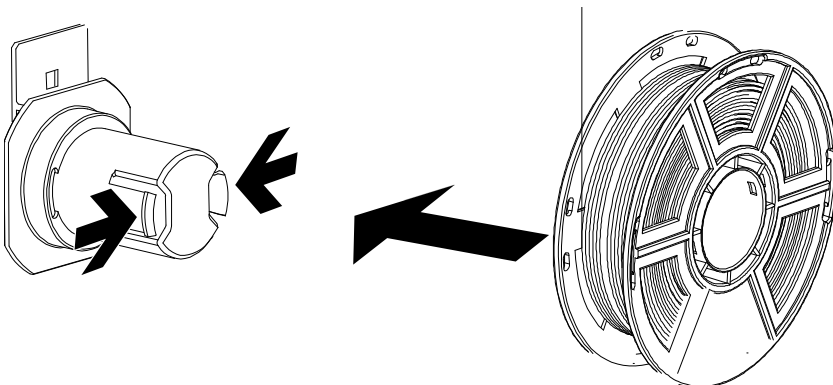
2.2.2.3 Filament guide tube and insertion of the filament



- ① For mounting a coil holder, level it. Then insert the end into the corresponding hole.



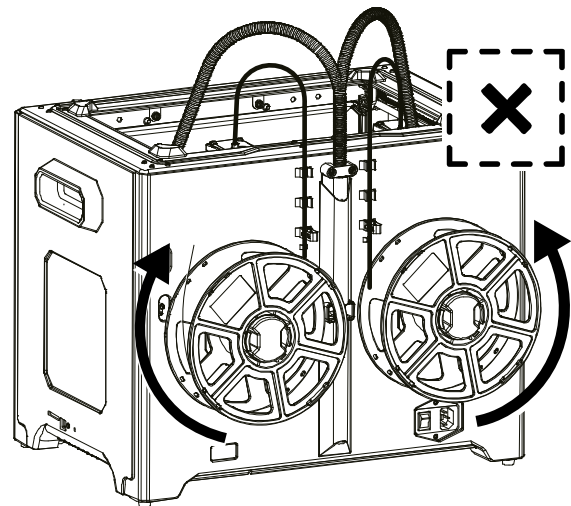
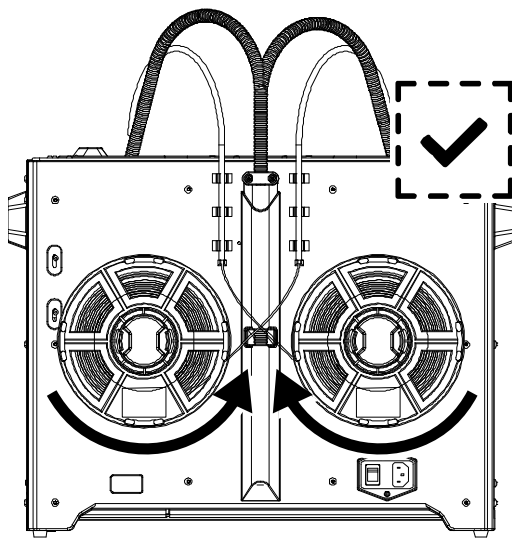
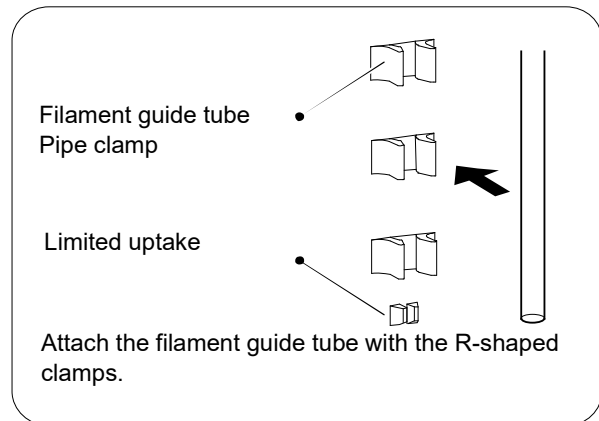
- ② Turn the spool holder down so that the bottom gap of the holder sits at the back of the printer.



- ③ Take a filament roll, squeeze the top of the spool holder and insert the filament spool into the holder.

Tips

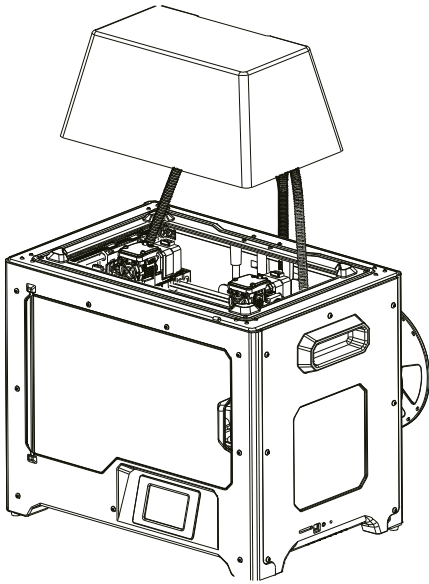
- ① The filament spool must be correctly aligned (see below).
- ② After attaching the filament guide tube, push down the left spring retainer of the extruder. Then, from the other end of the filament guide tube, insert the filament vertically into the left filament holder.



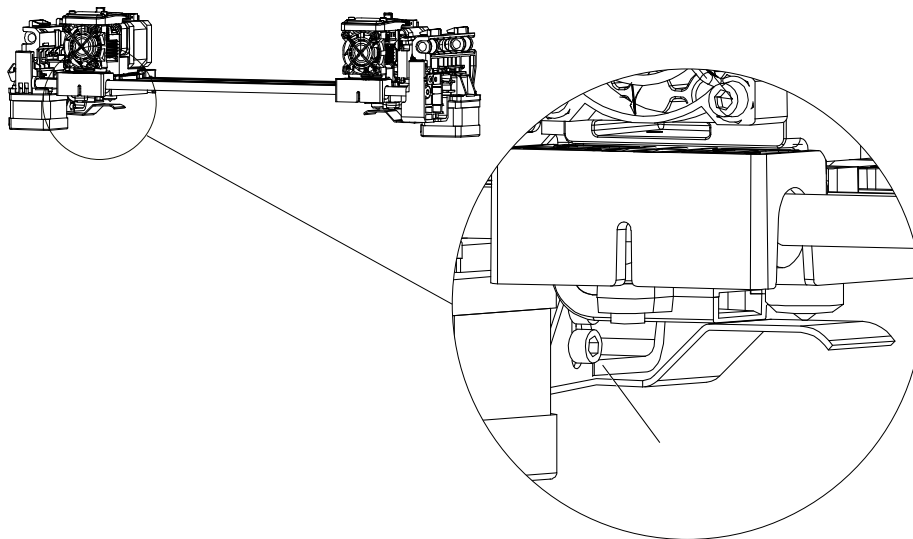
Note: Please insert the guide tube fully into the spool to prevent the filament from twisting and wrapping around the outside of the spool.

2.2.2.4 Assembling/Disassembling top cover

Install the top cover for ABS printing; remove the top cover for PLA printing.



2.2.2.5 Anti-oozing plate

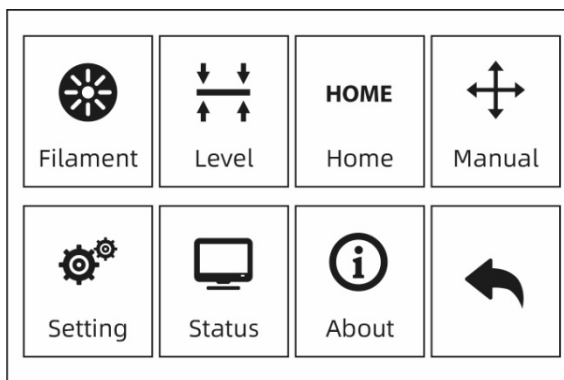
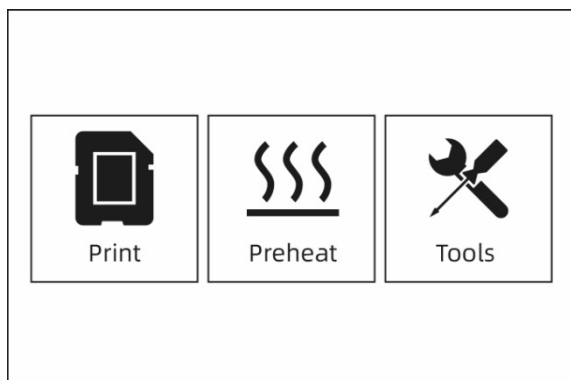


Fix the anti-oozing plate by two M3x8 screws.

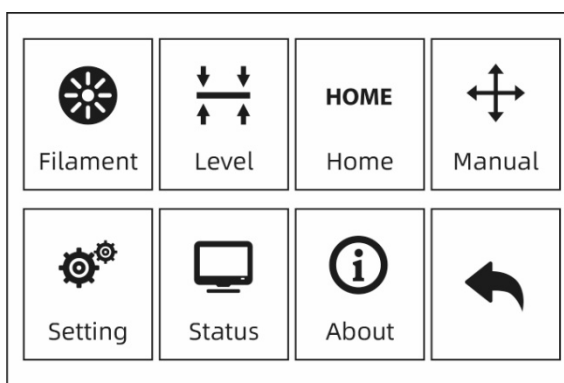
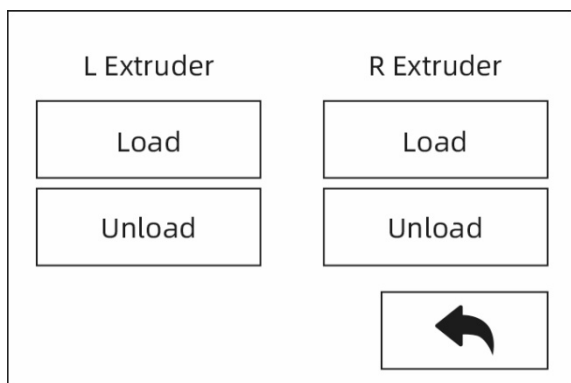
The nozzles must touch the moisture-repellent plate properly after installation. The distance between nozzle and plate can be adjusted by hand. After several printings scratches on the surface of the plate are normal.

2.3 The initial setting

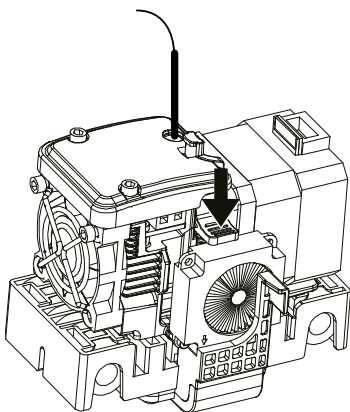
Loading/Unloading filament



- ① Tap the **[Tools]-[Filament]** button



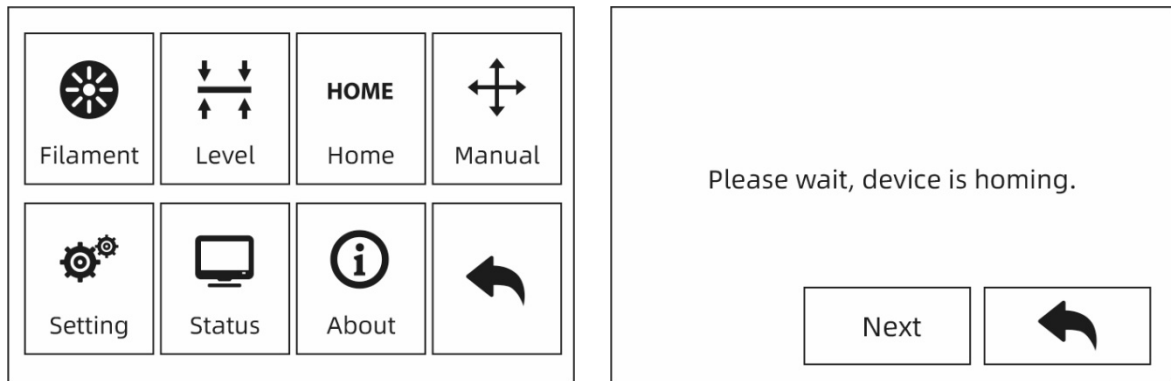
- ② Click the **[Load]** button. The extruder warm-up process begins. Once the target temperature has been reached, please feed the filament into the filament feed wheel by hand. When filament comes out of the nozzle, the loading process is complete.



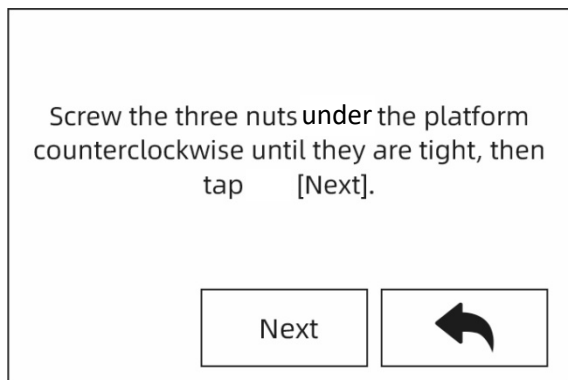
- ③ Tap the **[Unload]** button. The extruder warm-up process begins. Once the target temperature has been reached, feed some of the filament out of the nozzle by hand. Then push down the spring retainer, quickly pull out the filament and finish unloading.

Leveling

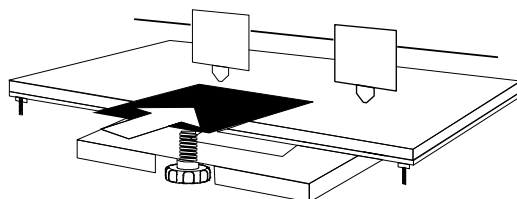
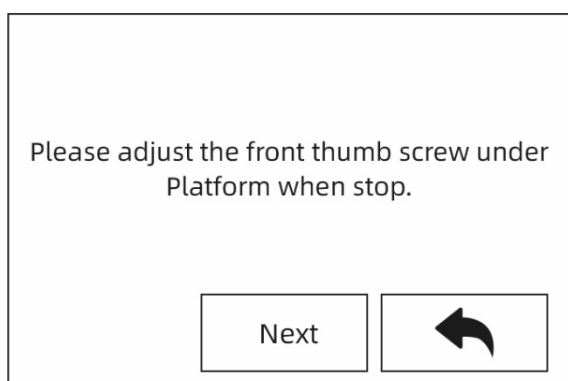
To avoid levelling errors, the residual material must first be removed from the nozzle.



- ① Tap the **[Tools]-[Level]** button to start levelling. The device first moves back to the home position.



- ② After stopping movement of extruder and platform, tighten the three nuts below the platform counterclockwise. (This procedure is important to avoid scratches on the construction plate caused by the extruder).

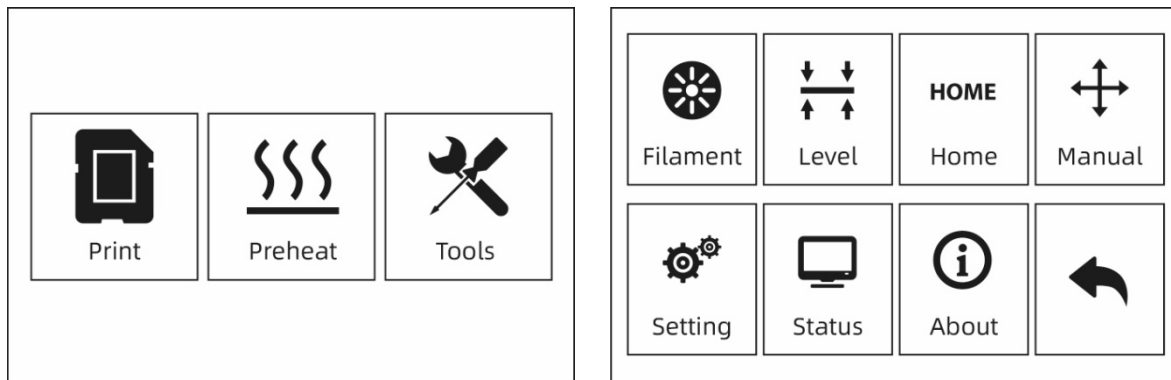


- ③ Choose one extruder and move it to the first nut by hand. Place a sheet of paper under the extruder and tighten the nut to reduce the distance between extruder and platform. Gently move the paper and feel the friction. If the paper has only slight friction, the distance between the extruder and the platform is set correctly. After the adjustment of the first plate is completed, repeat the procedure for the second and third nut.

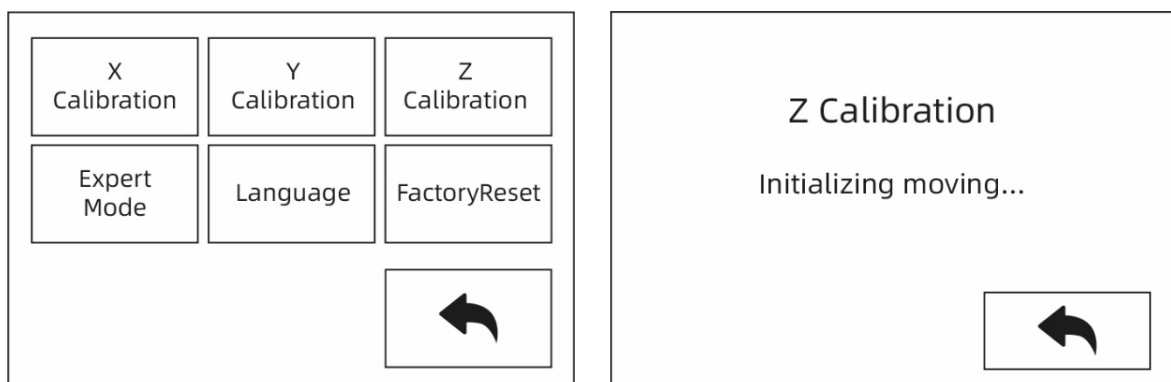
Note: The short distance between extruder and platform makes it difficult to remove printed objects. Greater distances lead to bonding errors or wrapping.

2.3.3 XYZ axis calibration

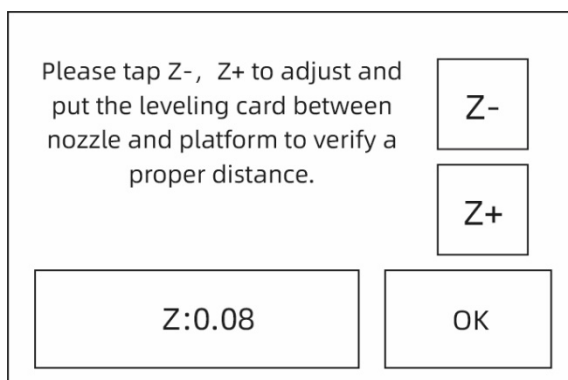
Z-axis calibration



- ① Touch **[Tools]-[Setting]-[Z Calibration]**. The printer uses a compensation layer mechanism. The mounting positions of the right and left nozzles do not have to be adjusted by hand. A programme calculates the height difference between the two nozzles.



- ② The extruder and the platform first move back to the zero position. Then select an extruder for calibration. If the temperature of the nozzle and platform is too high, the unit waits until the temperature has cooled down to 50 °C so that the nozzle does not burn the construction tape.

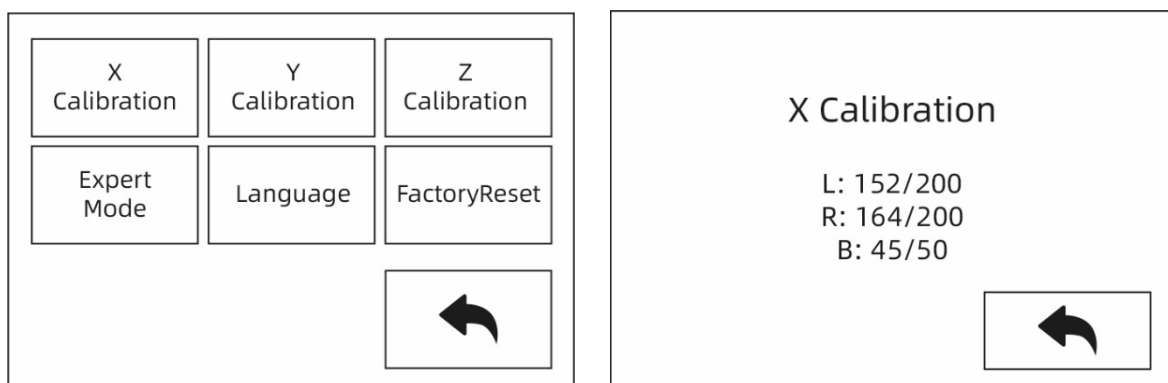


- ③ Follow the on-screen instructions and insert the levelling card between the nozzle and the platform. Adjust the distance using "Z-" and "Z+". The adjustment range refers to the levelling paper. As soon as you feel low frictional resistance, the distance between nozzle and platform is set correctly. After the first extruder has been calibrated, the switchover to calibration of the next extruder takes place.

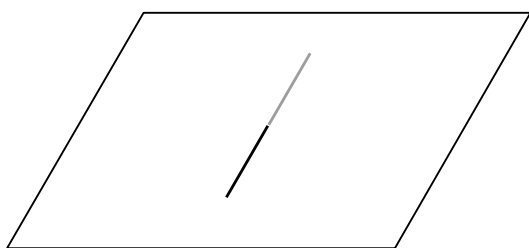
Note: Do not turn the nuts under the platform during Z-axis calibration.

X-axis calibration

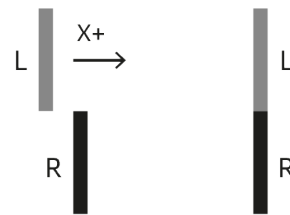
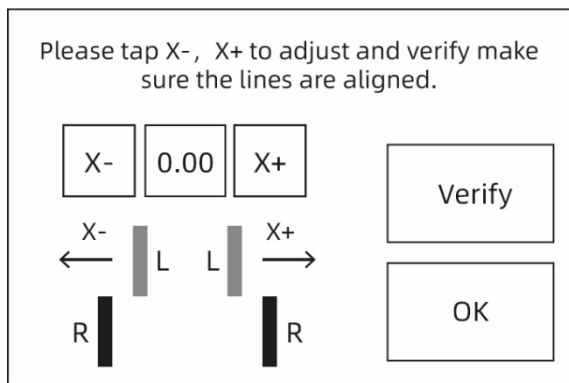
X-axis calibration: Uniform adjustment of the two extruders in the direction of the X-axis to avoid misalignment during printing.



- ① When Z-axis calibration is complete, touch **[Setting]-[X Calibration]** or proceed to X-axis calibration. After the initialization movement of the device has been carried out, the nozzle and the platform are heated. Now make sure that the filament has been inserted into the extruder.



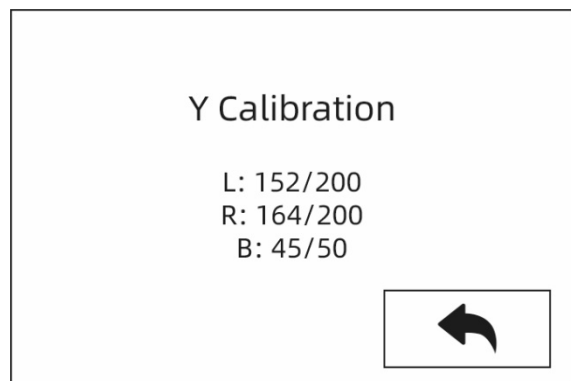
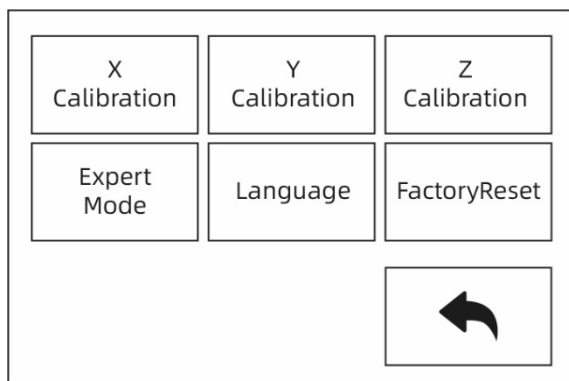
- ② Once the warm-up phase is complete, the left and right extruders print a line one after the other.



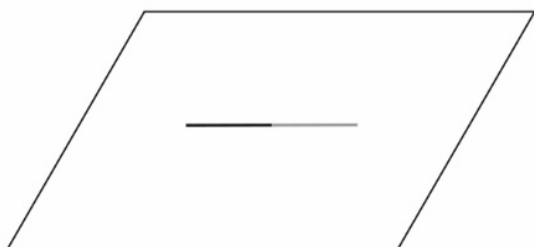
- ③ Touch "X-", "X+" according to the printed lines to adjust the extruder deviations and remove the printed lines. Then touch the **[OK]** button. The two extruders (left and right) reprint the lines to check that they match. If they match, the X-axis calibration is complete. Otherwise, the adjustment must be continued until conformity is established.

Y-axis calibration

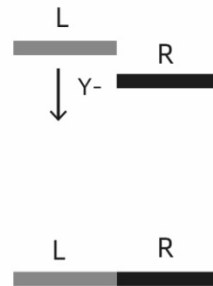
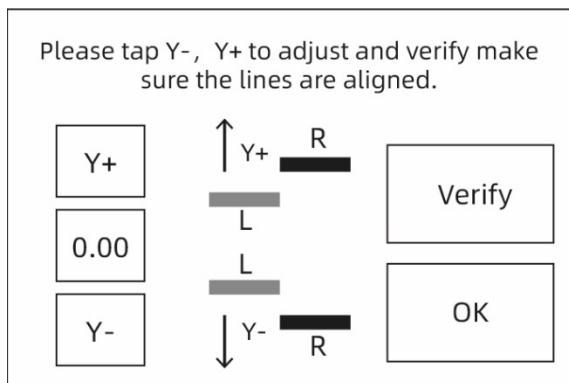
Y-axis calibration: Uniform adjustment of the two extruders in the direction of the Y-axis to avoid misalignment during printing.



- ① Finally, touch **[Setting]-[Y Calibration]** or continue to calibrate the Y axis after completing the X axis calibration. After the initialization movement of the device has been carried out, the nozzle and the platform are heated. Now make sure that the filament has been inserted into the extruder.



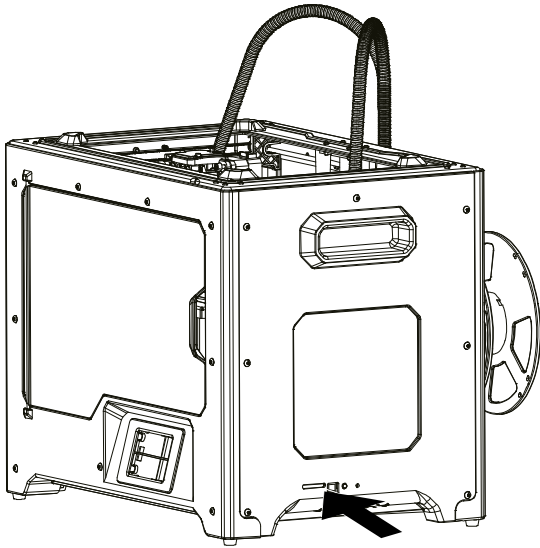
- ② Once the warm-up phase is complete, the left and right extruders print a line one after the other.



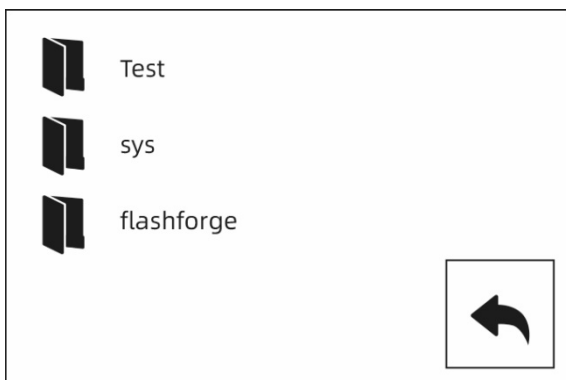
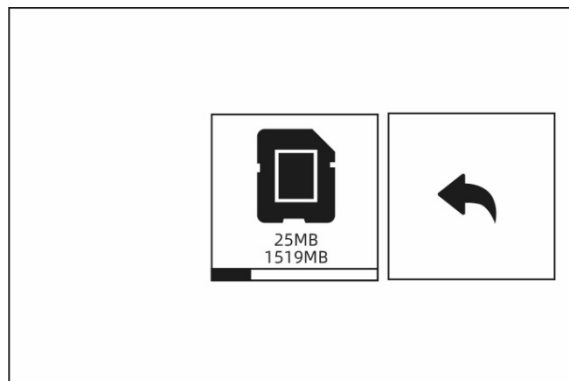
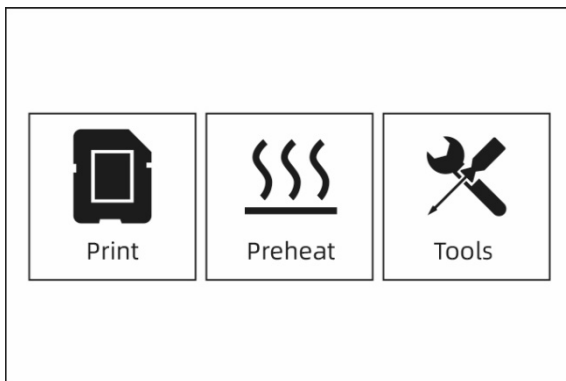
- ③ Touch "Y-", "Y+" according to the printed lines to adjust the extruder deviations and remove the printed lines. Then touch the **[Verify]** button. The two extruders (left and right) reprint the lines to check that they match. If they match, the Y-axis calibration is complete. Otherwise, the adjustment must be continued until conformity is established.

First print

After mounting, loading the filament and calibrating, start your first print.



- ① Insert the SD card into the side of the device.



- ② Touch **[Print]-[SD card]** and select the test file for printing.

2.3.5 Remove model

Hot! Lower the platform first before removing the model. Pay attention to the removal direction to avoid scratches caused by the scraper blade.

The construction plate must not be damaged during the removal of the model. Scratches on the construction plate can cause printing errors.

- **Cooling of the model**

The model is printed without glue on the construction plate. After the printed objects and the construction plate have cooled down, the models can be easily removed.

- **Use of the scraper blade**

After cooling, the printed object continues to adhere to the platform. It can be detached from this with the help of the spatula. Hold the blade parallel to the printing platform and carefully insert it at the bottom of the model. Then remove the model using little force.

2.3.6 Removing supports

The PVA supports are removed after processing. Place the PVA supports in water to loosen them from the model.

- ① **Place the printed objects in water.**

Place the printed objects with the PVA supports in water to loosen the PVA supports. There are a few ways to speed up the dissolving process.

- The use of warm water speeds up the dissolving process. If the main structure of the printed objects is PLA, the water temperature must not exceed 35° C. Otherwise the printed model will be deformed.
- Stir the water. Stirring can accelerate the dissolution of the PVA.
- Soak the printed objects in water for about 10 minutes. Then remove the supports with pliers. Place the printed objects in water to dissolve PVA residues.

- ② **Rinse with water**

After the PVA support is completely dissolved, wash the object with water to remove the remaining PVA.

- ③ **Dry model**

Allow the model to dry completely and continue working on the object if necessary.

- ④ **Waste water disposal**

PVA is biodegradable and therefore the waste water can be disposed of without any problems. After the wastewater has been disposed of, wash the object with hot water for 30 minutes to remove residual PVA from the drain pipe so that

blockages are avoided. The water can be used several times to soak several objects in it. However, the resolution time may be extended. Therefore, it is recommended to use fresh water, because then the best effect can be achieved.

2.3.7 Material compatibility

The printer has two independent extruders and supports PLA, ABS, HIPS and PVA. Combo mode:

PVA+PLA HIPS+ABS PLA+PLA ABS+ABS

BRESSER materials give the best results, but BRESSER T-REX 2 also supports the use of other brands of materials. All BRESSER materials have been tested. The best test results were achieved with REXprint.

PVA filament is water soluble and has strong water absorbing properties. The filament may become soft after absorbing water, which may cause misprints. Place the PVA filament in a dry box during printing. PVA must be kept closed tightly and dry.

To achieve the best results, the appropriate settings must be made for each material.

When REXprint is used to slice the model, these settings are made automatically when the correct extruder and suitable material are selected.

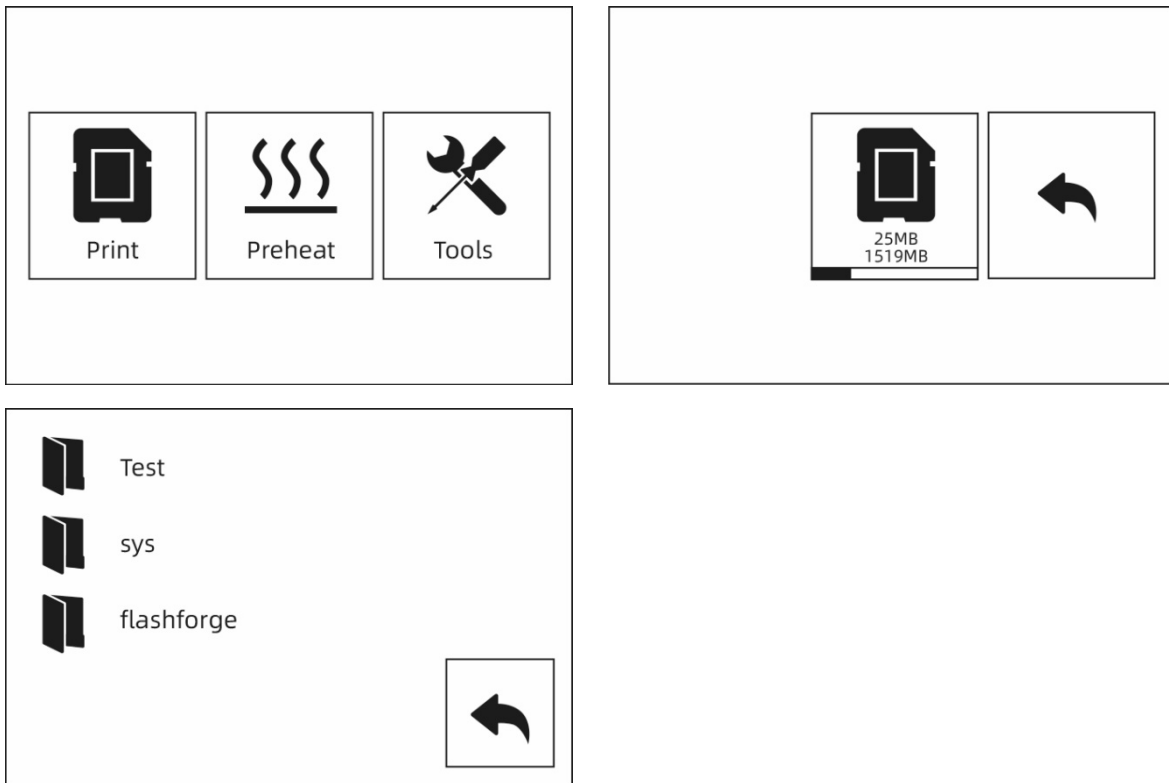
Adjustment of material parameters

Different brands of filament have different material properties. Therefore, it is recommended to use the expert mode to fine-tune the parameters so that a good print quality is guaranteed.

- Determining the thickness of the first layer adhesion to the platform improves when the first filament layer is applied.
- Set the platform temperature for printing small PLA models at 30°C or whenever the ambient temperature exceeds 25°C.
- Set the platform temperature for printing large PLA models at 50° C, or whenever the ambient temperature falls below 10° C.
- The open pressure chamber is suitable for PLA prints. Remove the top cover.
- The closed pressure chamber is suitable for ABS prints. Close the top cover to prevent the filament from breaking.
- It is recommended to reduce the normal printing speed by 40%. Place the PVA filament in a dry box so that no water is absorbed from the air, which can cause misprints.

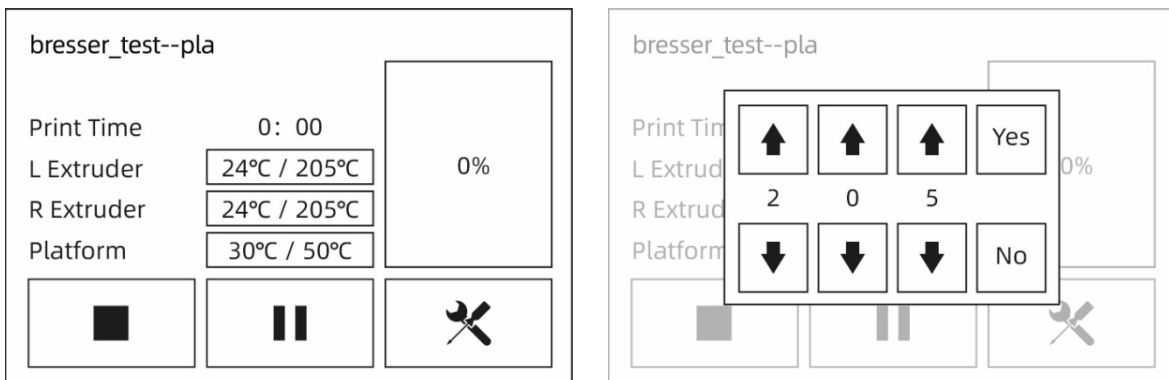
2.4 Touchscreen Interface - Introduction

Print surface

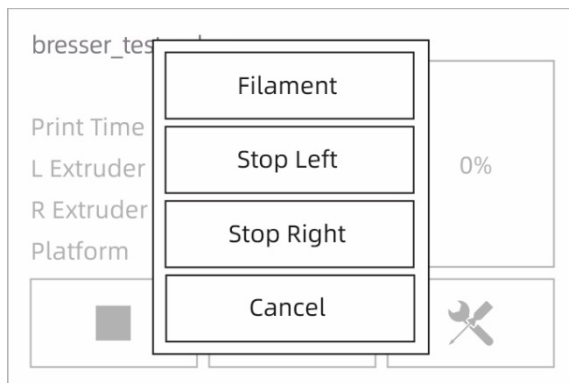


- ① Insert the SD card to the side of machine. During printing, the SD card must be inserted into the printer, regardless of whether you are printing from the SD card or connecting REXprint via a USB cable.

Touch **[Print]-[SD Card]** and select the files to print.

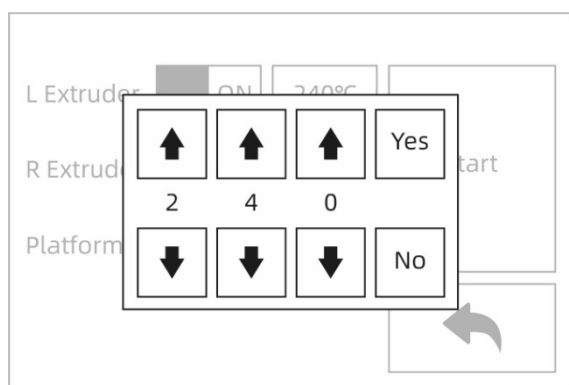
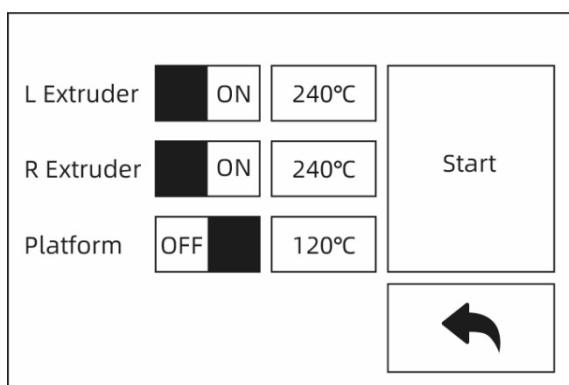


- ② To change the temperature, touch the extruder or platform temperature display on the touchscreen.

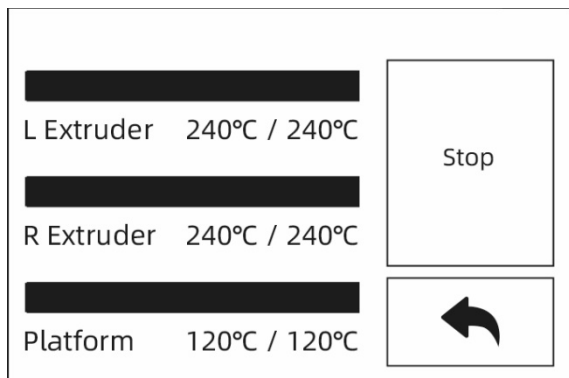


- ③ Touch **[More]** to pause printing or to replace the filament during printing.

Preheat surface

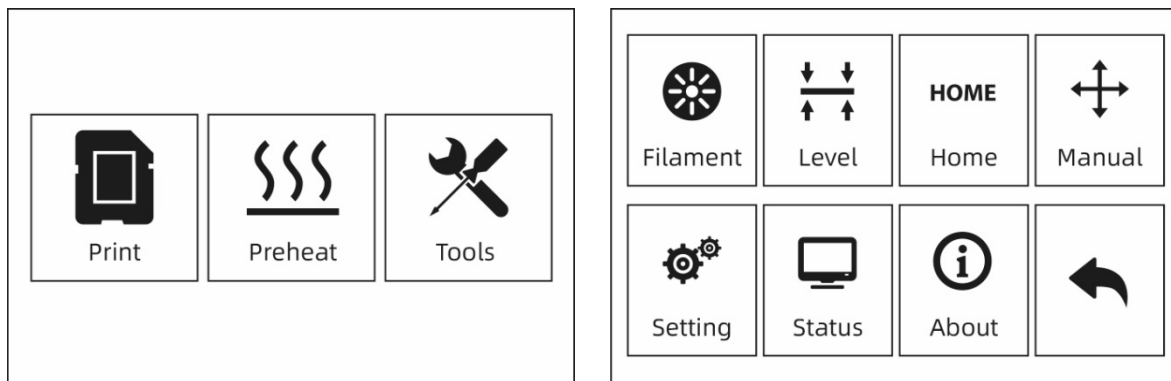


- ① Touch **[Preheat]** to preheat the extruder or platform. Set the target temperature by touching it on the touchscreen.

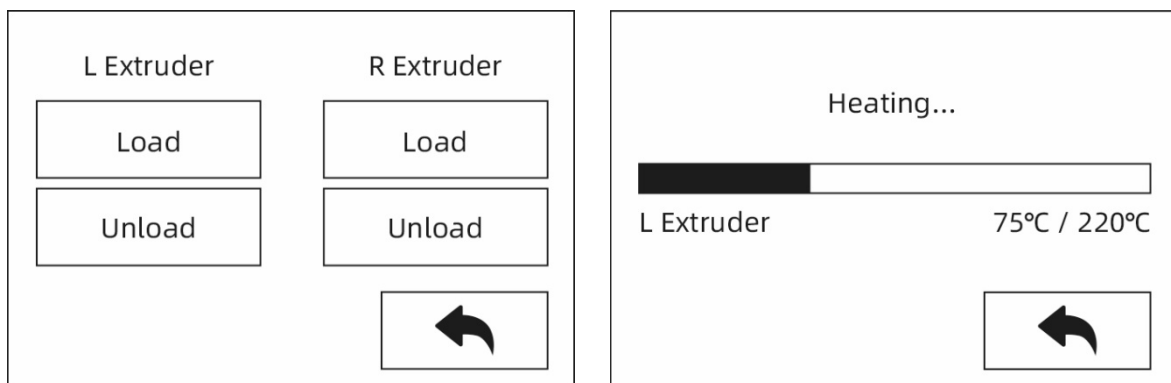


- ② Touch **[Stop]** to stop the warm-up. Touch the black arrow to return to the main window. As soon as the desired preheating temperature is reached and if no further entries are made, the preheating process stops.

Tool surface

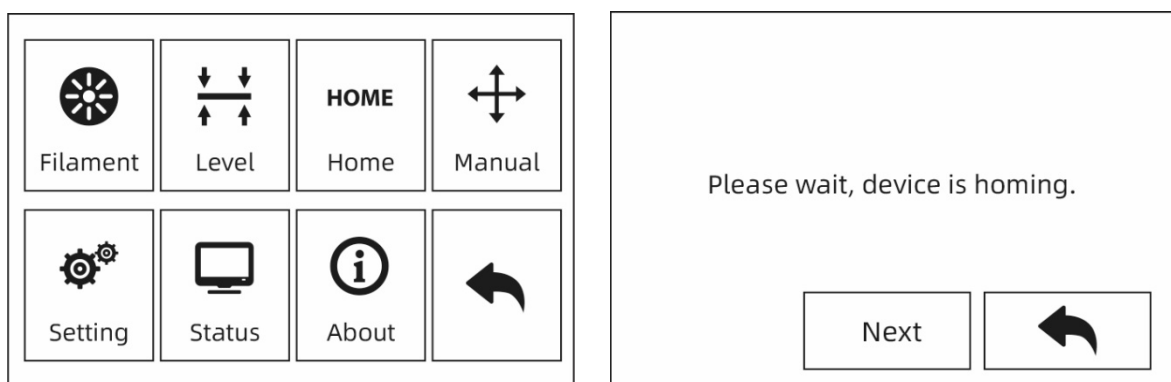


The tool interface contains the **Filament**, **Level**, **Home**, **Manual**, **Setting**, **Status**, and **About** tabs.



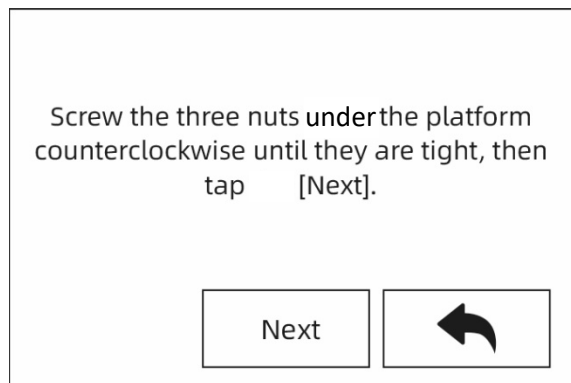
[Filament]

Filament load and unload settings.

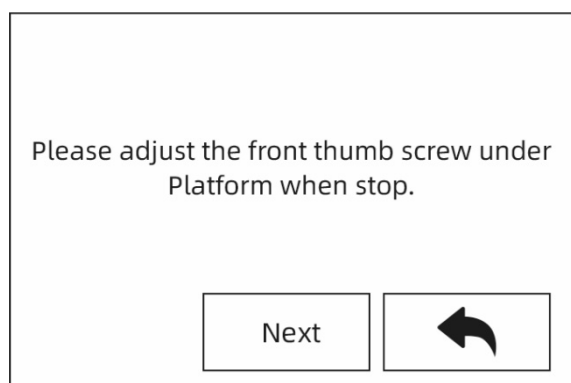


[Level]

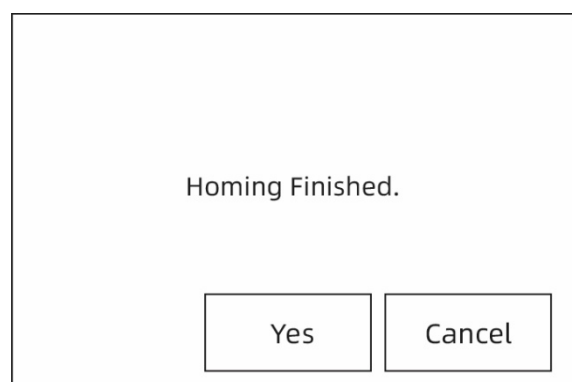
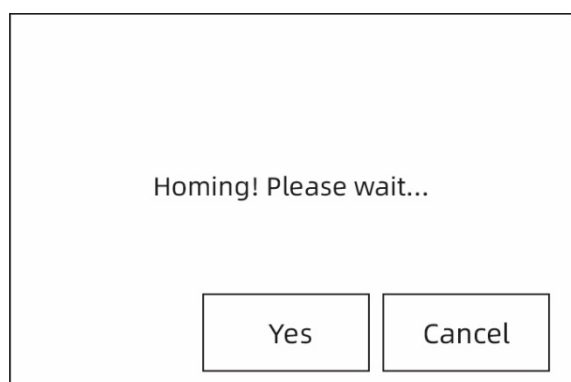
The flatness of the platform is adjusted manually.

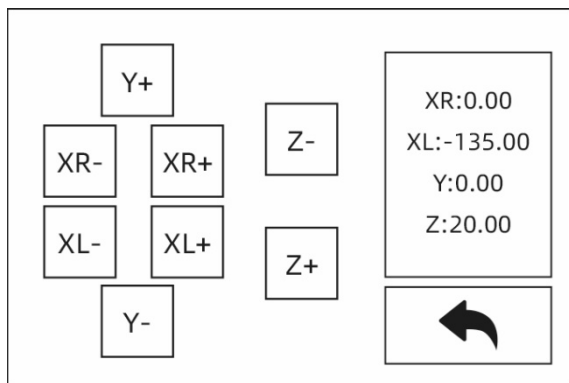


After stopping movement of extruder and platform, tighten the three nuts below the platform counterclockwise. (This procedure is important to avoid scratches on the construction plate caused by the extruder)



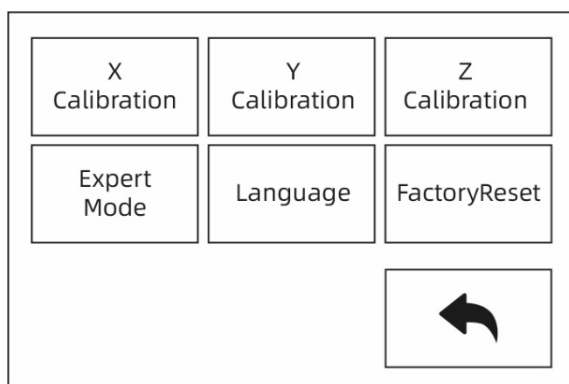
Choose one extruder and move it to the first nut by hand. Place **a sheet of** paper under the extruder and tighten the nut to reduce the distance between extruder and platform. Gently move the paper and feel the **friction**. If the paper has only slight friction, the distance between the extruder and the platform is set correctly. After the adjustment of the first plate is completed, repeat the procedure for the second and third nut.





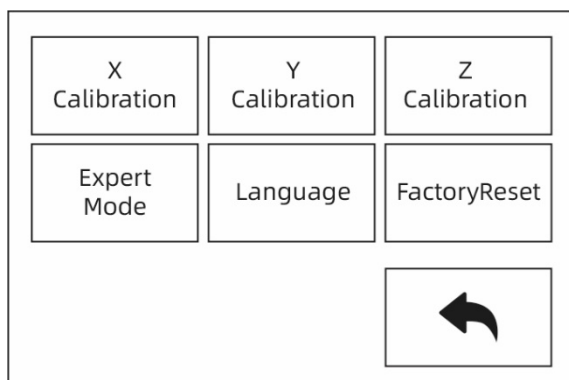
[Manual]

Touch the touch screen for XYZ axis movement control.



Setting

The **"Setting"** interface includes **"X Calibration"**, **"Y Calibration"**, **"Z Calibration"**, **"Expert Mode"**, **"Language"** and **"FactoryReset"**.



[X Calibration, [Y Calibration], [Z Calibration]

For further information, please refer to chapter 2.3.3.

Manual fine calibration

This assistant is for advanced users only.
After a printer calibration. Fine-tune the calibration offsets of X or Y axis if needed.

Next

[Expert mode]

Simplified calibration for experienced users in expert mode. The placement of the extruder on the X or Y axis can be adjusted according to the deviation value of the model printed by two extruders on the same axis.

Manual fine calibration

X-

0.00

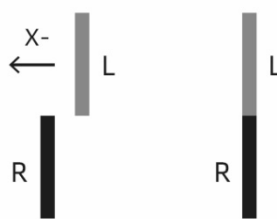
X+

Y-

0.00

Y+

OK



If the left extruder prints to the right on the X axis, touch [X-]. If the left extruder prints to the left on the X axis, touch [X+].

When the right extruder is printing to the left on the Y axis, touch [Y-]. When the right extruder prints to the right on the X axis, touch [Y+].

简体中文

English

繁體中文

日本語

Deutsch

한국어

↓

↶

↑

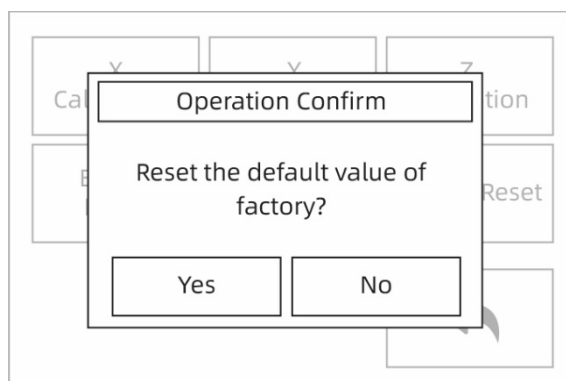
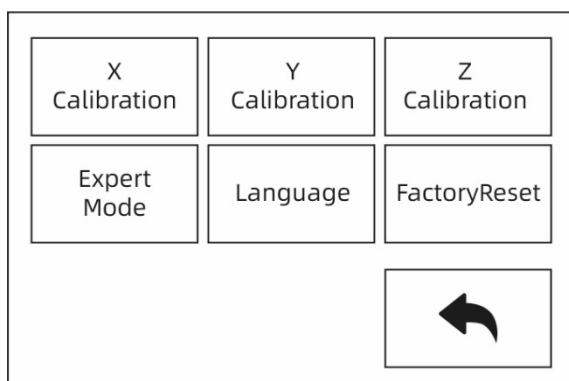
Français

Spanish

↶

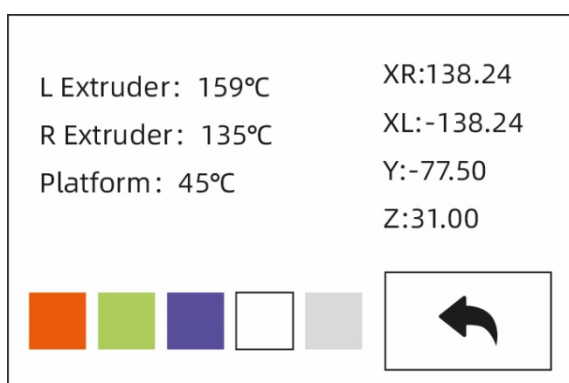
[Language:]

Support: Chinese, English, Japanese, German, French and Spanish.



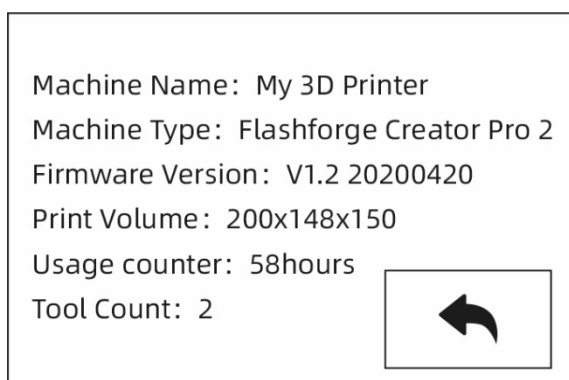
[Factory settings]

After touching, all values are reset to the factory settings.



[Status]

Under "Status" the extruder and platform temperature as well as the coordinates of the XYZ axis are displayed. Touch the light status bar. The ambient light in the chamber of the device changes according to the settings.



[Info]

The basic device information is displayed. The information displayed varies depending on the current device.

The firmware version of the device, the print volume, the total print time, etc. are displayed here.

Note: Always quote the serial number when contacting customer service.

[Firmware Upgrade]

Method 1:

Insert the SD card into the computer and create a folder named "sys". Copy the firmware files to the "sys" folder. Then insert the S-card into the device. Switch on the device and update the firmware. After updating the firmware, delete the "sys" folder.

Method 2:

Update the firmware via USB cable with REXprint.

Chapter 3: Slicing Software

Using the slicing software REXprint, .stl and .obj files are converted into .g files that can be printed with BRESSER T-REX 2.

3.1 Installation

3.1.1 How do I get REXprint?

There are two ways to get the REXprint software:

Method 1: Download the installation package from the SD card in the accessory kit.

Method 2: Download the latest version from the Download Center on the Bresser product website www.bresser.de/P2010600.

Getting Started

Extract the zip file or run the installer. Install the software according to the instructions.

Start the software with Start menu keyboard shortcut by touching the software icon.

3.2 Get to know REXprint

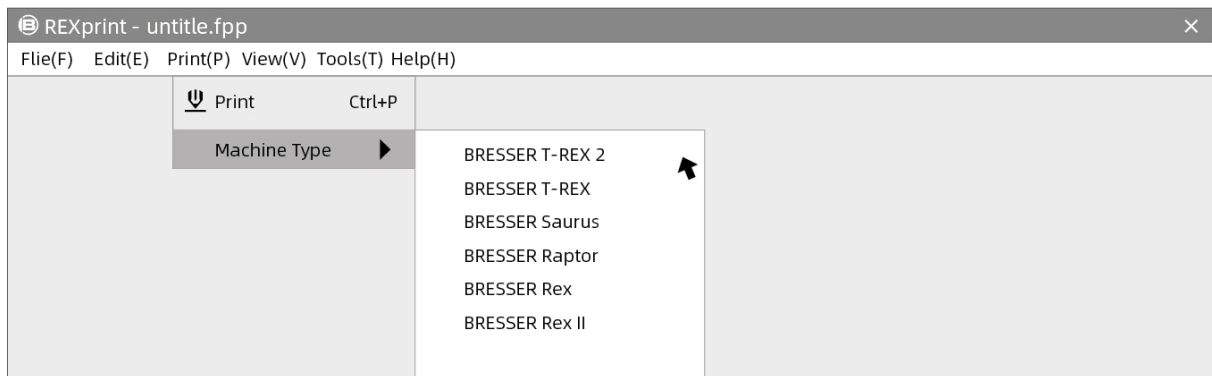
Note:

BRESSER T-REX 2 supports printing from REXPrint via USB cable.

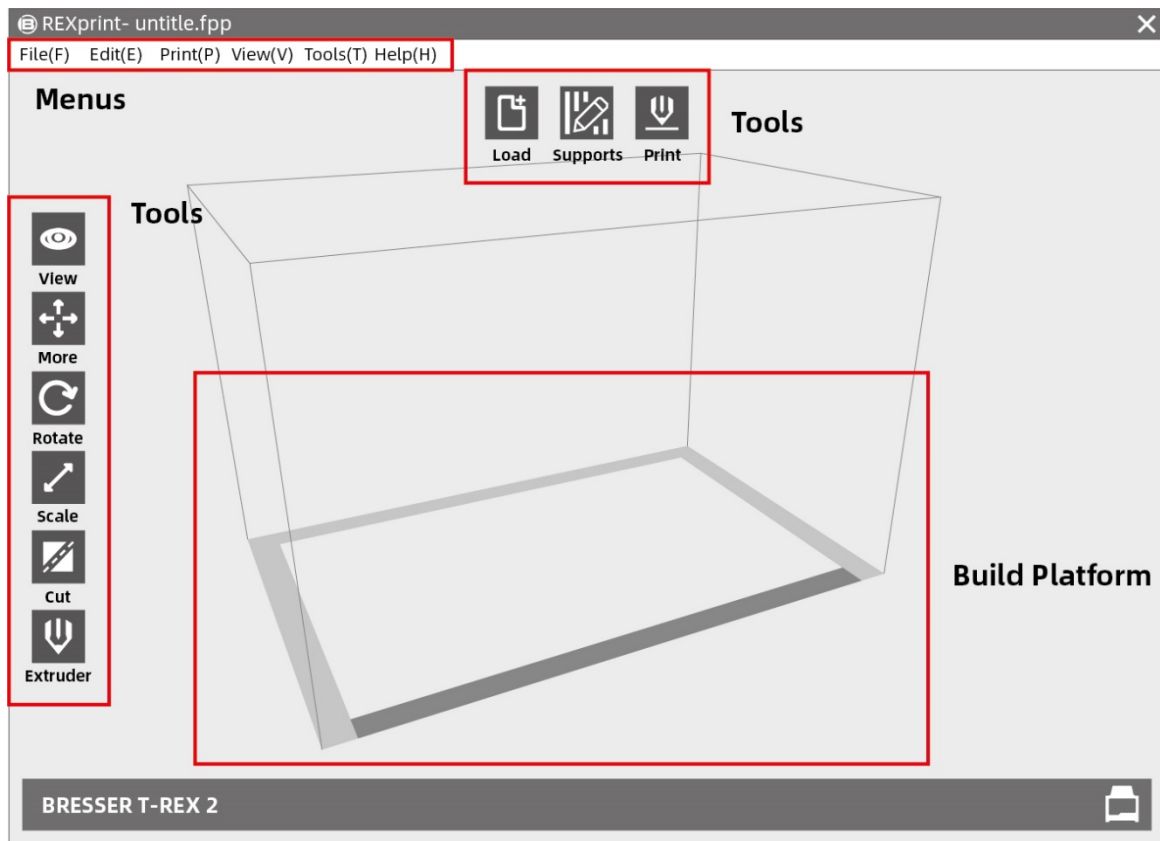
3.2.1 Selection of the device type

Attention! After starting REXPrint, you must first select the device type.

A dialogue box opens when you start REXprint. Select BRESSER T-REX 2 from the list of displayed device types and tap **[OK]**. You can also change the machine type by touching **[Print]-[Machine Type]**. See the figure below:



3.2.2 Presentation of REXPrint



Load

Load only one file at a time



Supports (Support)

Open prop editing mode.



Printing (Print)

Print directly with the BRESSLER T-REX 2 or export to a USB stick



View (View)

View FlashPoint home screen, from one of six angles



Move

Move the model on the XY axis. For the movement on the Z-axis "Shift+click".



Rotate

Rotate and turn your model.



Scaling

Size scaling of your object



Cutting (Cut)

Cut the model into several parts



Extruder

Select the left or right extruder before setting the parametre

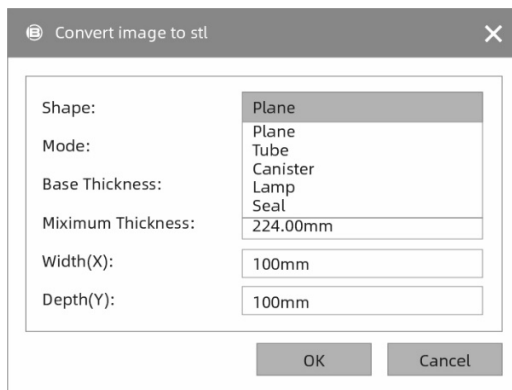
3.2.3 Loading

You can use the following six methods to load a model or Gcode file into REXprint:

- Method 1: Touch the **[Load]** icon on the main interface.
- Method 2: Then select the object file. Select the file you want to load and drag it to the main interface of the software.
- Method 3: Touch **[File]--[Load File]**. Then select the object file to be loaded.
- Method 4: Touch **[File]--[Examples]** to load the example files.
- Method 5: Touch **[File]--[Recent Files]** to open the previously loaded files.
- Method 6: Select the destination file, touch it and drag it to the REXprint icon.

Note: 3D models can be saved as .STL, .OBJ or .FPP files and processed with REXPrint.

Enhanced: Designing reliefs



Shape: includes the shapes "Plane", "Tube", "Canister" and "Lamp".

Fashion: Includes "darker is higher" and "lighter is higher".

Maximum Thicknes: Z-value of the model

Base Thickness: The minimum raft thickness: Default value 0.5 mm.

Width: X-value of the model

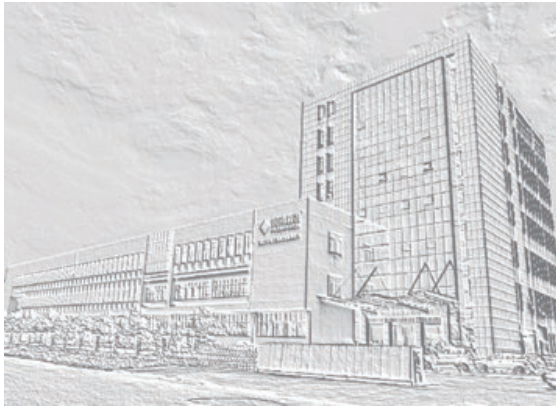
Depth: Y-value of the model

Bottom Thickness: Determination of the base thickness for the "Tube", "Canister", "Seal" and "Lamp" moulds.

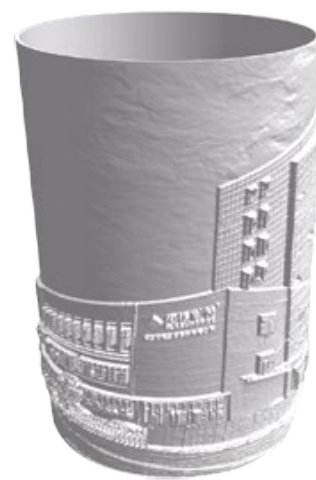
Top Diametre: Determination of the upper diametre for the shapes "Tube", "Canister" and "Lamp".

Bottom Diametre. Determination of the bottom diametre for the shapes "Tube", "Canister" and "Lamp".

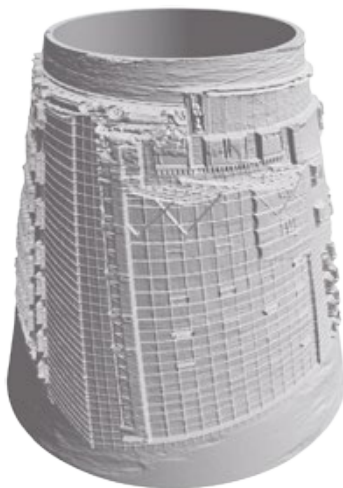
Plane



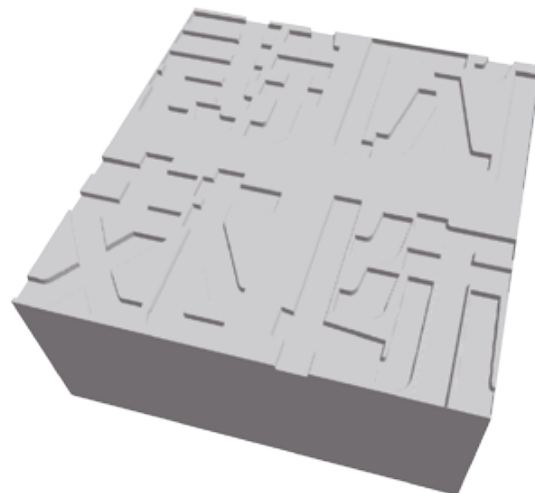
Tube/Canister



Lamp (6-8)



Seal (6-9)




3.2.4 Views

① Changing views

Change the model views by moving, rotating and scaling.

• Pulling


Click on the **[View]**  icon. The object can then be moved using one of the following three methods:

Method 1: Drag the mouse while holding down the left mouse button.

Method 2: Drag the mouse while holding down the middle mouse button.

Method 3: Drag while holding down the **Shift key** and right mouse button.

• Rotate

Click on the **[View]**  icon. The object can then be rotated using one of the following two methods:

Method 1: Hold down the right mouse button and drag.

Method 2: Hold down the **Shift key** and left mouse button and drag.


• Scaling

Turn the mouse wheel to enlarge or reduce the printing plate.

② Set the view

The user can view the object on the printing plate. There are six views available in the View menu, i.e. the home view, the view from below, from above, from behind, from the front, from the left and from the right.


Method 1: Click the **[View]** button. The drop-down list then lists six views.

Method 2: Click on the  **[View]** button and then click again to open a submenu with the six views available for selection.


③ Reset the view

There are the following two ways to reset views:


Method 1: Click the **[View]** menu and select **[Home View]**.

Method 2: Click the  **[View]** button on the left, and click it again to display the display options. You may then click on **[Reset]**.

④ Display the model outline


Click  **[View] > [Show Model Outline]**. The yellow outline of the object is then highlighted.


⑤ Display of a steep overhang

Click  **[View] > [Show Steep Overhang]**. If the angle of intersection between the model surface and the horizontal line is within the range of the overhang threshold, the surface has a steep overhang and is displayed in red in the software. The threshold value for the overhang can be adjusted as required. By default the value is set to 45°.

3.2.5 Moving

Select the desired object and move it using one of the following two methods:


Method 1: Left click on the  **[Move]** icon, hold down the left mouse button and drag to move the position of the model in the XY direction. Hold down the Shift key and left mouse button and drag to move the position of the model in the Z direction. The distance and direction of movement are displayed.


Method 2: Click the  **[Move]** button on the left, and then enter a value for the distance. Click **[Reset]** to reset the distance values.

Note: After adjusting the position, you should click **[Centre]** and **[On Platform]** to ensure that the models are in the print area and on the print platform. If a specific position is required, click only **[On Platform]**.

3.2.6 Turning


Select the desired object and rotate it using one of the following two methods:


Method 1: Click the  **[Rotate]** icon on the left. Three rings at right angles to each other are then displayed around the object. Click on a ring and make a rotation around the current axis. You can then see the angle of rotation and the direction in the middle of the ring. This allows you to rotate the model around the X/Y/Z axes.

Method 2: Click the  **[Rotate]** icon on the left, and then enter the rotation angle values for positioning for the X/Y/Z axes. Click **[Reset]** to reset the rotation angle values.

3.2.7 Scaling


Select the desired object and scale it using one of the following two methods:

Method 1: Click on the symbol  **[Scale]** on the left, keep the left mouse button pressed and scale the model. The corresponding values are displayed next to the object.

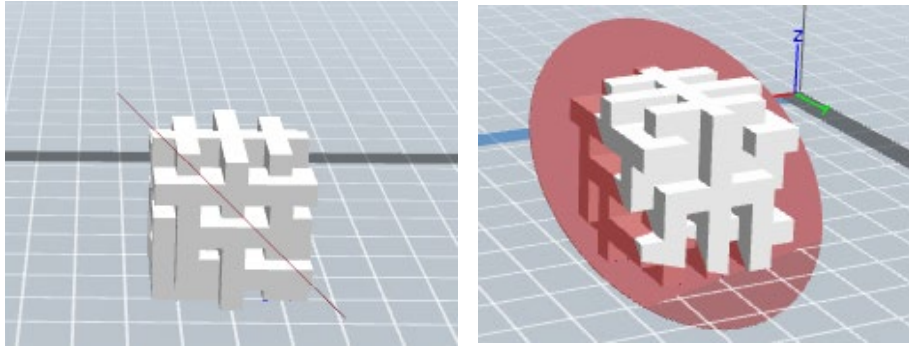
Method 2: Click the  **[Scale]** icon on the left, and then enter the positioning scale values for the X/Y/Z axes. Click the **[Maximum]** button to achieve the maximum possible size for printing. Click **[Reset]** to reset the size of the model.

Note: If you clicked the **[Uniform Scaling]** radio button, the model will be scaled to scale when you change any value of the model's positioning. Otherwise, only the corresponding item **value** is changed.

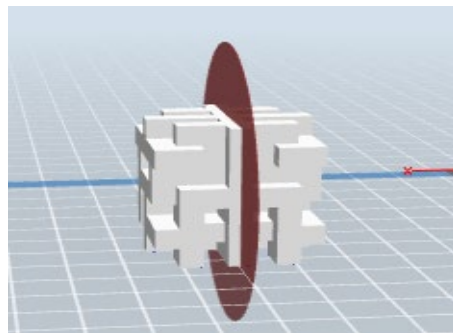
3.2.8 Cutting

Left-click the model to select it, then double-click the **"Cut"** icon  to set the cut plane. You can set the direction and the position.

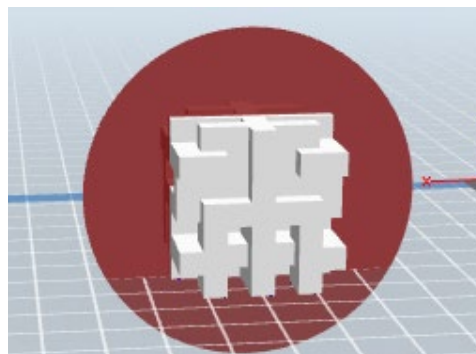
① Draw with mouse



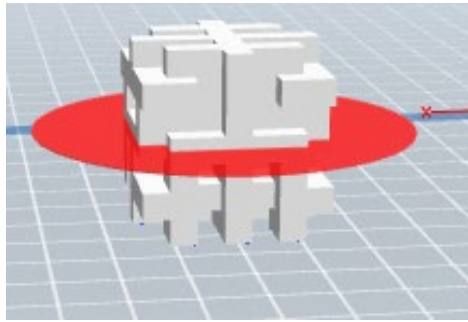
② X plane



③ Y-plane



④ Z-level




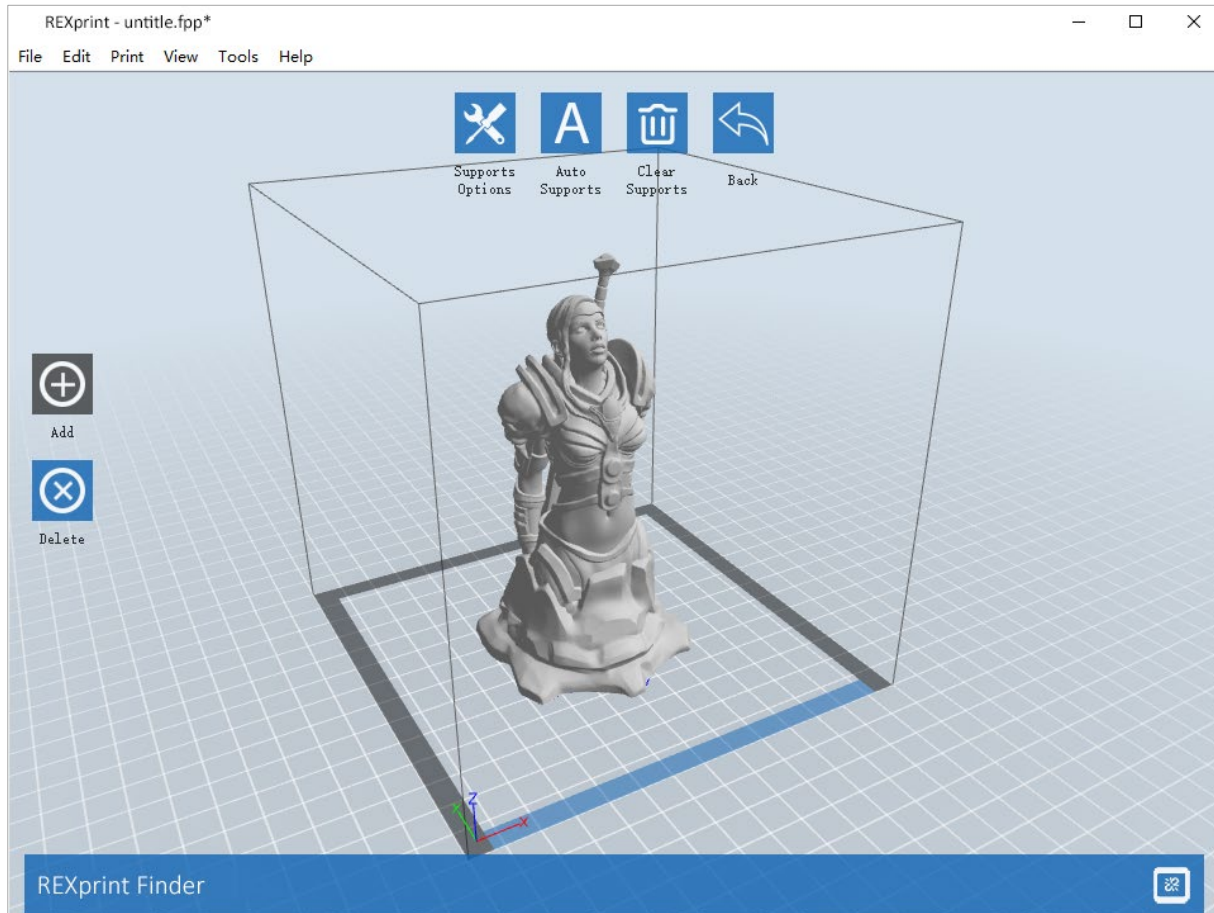
Extruder

There are right and left extruders. First select the model. Click on the extruder icon. The extruder settings menu is displayed. Before starting the printing process, the left or the right extruder must be selected.

3.2.10 Supports

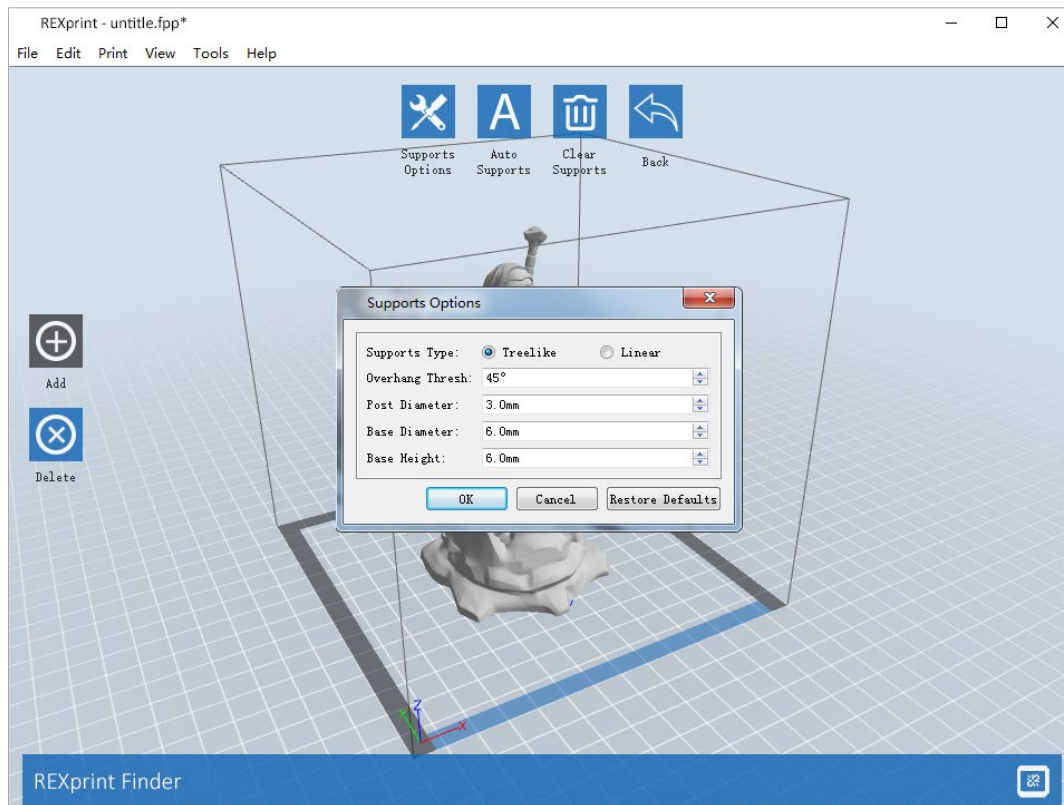
After you have loaded the model, click on **[Edit] > [Supports]** or directly on the

Supports icon . You then switch to the editing mode for supports (as shown in the figure below). Click **[Back]** to exit this mode when you have finished editing.



① Support options

When you click on "Support Options", a radio button is displayed listing the support options "Treelike" and "Linear". If you select the "Treelike" option and click **[OK]**, a tree structure is created. However, if you select "Linear" and then click **[OK]**, a linear structure is created. If the model already has supports and you select one of the support options, the software will assess whether the existing supports need to be deleted. This decision is made on the basis of the type of support selected. You can confirm this decision in a pop-up window.



② Automatic supports

Click the **[Auto Supports]** button. The software evaluates the positions where supports are required and creates corresponding supports in tree format or linear format. For a model with supports, the existing supports are removed and new ones are created.

③ Adding supports

Supports are added when you click the **[Add]** button. Position the mouse pointer at the point where a support is required, click the left mouse button to select the starting point for the support, hold down the left mouse button and drag the mouse. The column preview opens (if no column is required for the area or if the angle of the column is too large, this is highlighted in the column view). Release the left mouse button. If the support column is not suitable for a model, the support is created at the starting and end points (the highlighted support in the preview does not create a support structure).

④ Removing supports

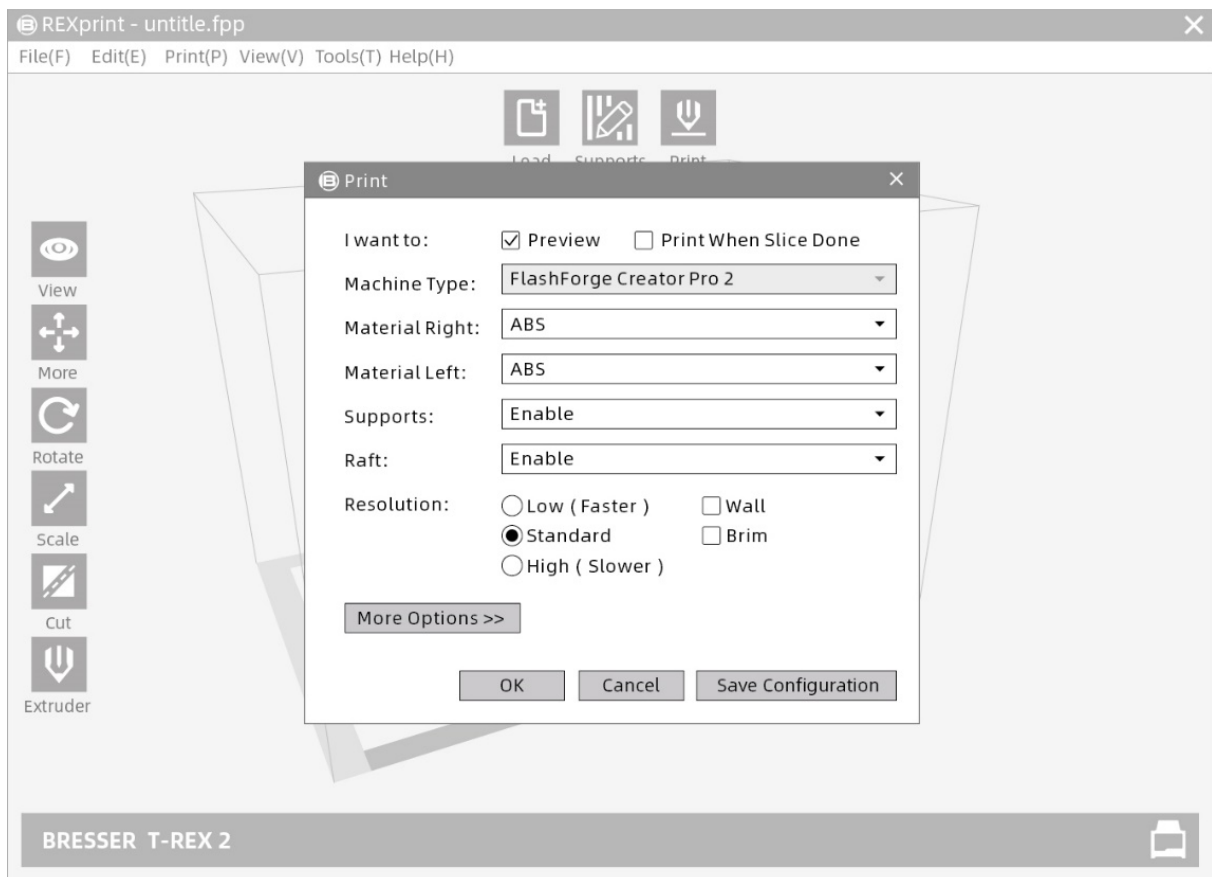
Click on **[Clear Supports]**. All supports are then deleted. You can cancel this deletion process by clicking on **[Undo]** or by pressing the key combination **Ctrl+Z**.

⑤ Deleting supports

Supports are deleted when you click the **[Delete]** button. Position the mouse pointer on the column to be deleted. The current column and its subnodes are highlighted. Press the left mouse button to delete the highlighted support.

3.2.11 Printing

Click the print icon. Now the print screen is displayed. After all parameters have been set, click **[OK]**. Then select the correct file format and click **[Save]**.



Preview:	Open or do not open the preview interface. Selecting this option automatically displays the preview after slicing is complete. Slide the model layer slider on the left side of the interface up and down to display the model layer. The estimated print time for the model and filament are displayed in the upper right corner. Click [Print] to connect the machine. Click [Back] to display the main interface again.
Materials:	ABS/PLA
Supports:	A support is required for printing off/on models. Clicking [Support] creates a support part for the print.
Raft:	With the help of this function, the model adheres well to the platform.
Wall	During dual color printing, this feature protects against contact with filament exiting another extruder.
Brim:	Expansion of the bottom layers of the model so that the edges of the model are anchored to the platform in such a way that it does not warp or the pressure fails.
Resolution:	There are three resolutions (including the default): high resolution corresponds to a slow print speed, low resolution to a fast print speed. The "Hyper" function is available for PLA printing.
More Options:	Under [More Options] , settings can be made for "Position", "Layer", "Infill", "Speed" and "Temperature". The different resolutions according to the different default settings. To restore the default settings, click [Restore Defaults] .

More Options >>

Layer Height	Shells	Infill	Speed	Temperature	Others
Layer Height:	<input type="text" value="0.18mm"/>				
First Layer Height:	<input type="text" value="0.27mm"/>				

Restore Defaults

Layer height

Layer Height: Layer thickness of the print model. The smaller the value, the smoother the surface of the model.

	<p>b. First Layer Height: This first layer of the model influences the adhesion performance between model and platform. The maximum value is 0.4 mm. Normally the default value is sufficient.</p>
Shells	<p>This includes the outer shell value, the cover layer value (under a vase pattern; the upper robust layer setting is invalid).</p> <p>Perimetre Shells: Maximum is 10</p> <p>Top solid layer: Maximum is 30, minimum is 1</p> <p>Bottom solid layer: Maximum is 30, minimum is 1.</p>
Infill	<p>Fill Density: Fill rate.</p> <p>Fill Pattern: The pattern of the filling mold. This has an influence on the printing time.</p> <p>Combine infill: The layers for the combination can be selected according to the layer thickness. The combined thickness should not exceed 0.4 mm. "All n layers" refers to all layers. "All n inner layers" only affects inner infills, i.e. the printing time is shortened.</p>
Speed	<p>Print Speed: The extruder movement speed. Generally speaking: The lower the print speed, the better the print result. 80" is recommended for PLA printing.</p> <p>Travel Speed: Control of the movement speed of the extruder without printing. 100" is recommended for PLA printing.</p> <p>Note: The parameter settings can be adjusted accordingly for different models.</p>
Temperature	<p>Extruder temperature: Recommended extruder temperature: 220°C Note: The different temperatures influence the printing process. The temperature must be adapted to the prevailing conditions in order to achieve a good printing result.</p>

Platform Temperature: Determination of the platform temperature.

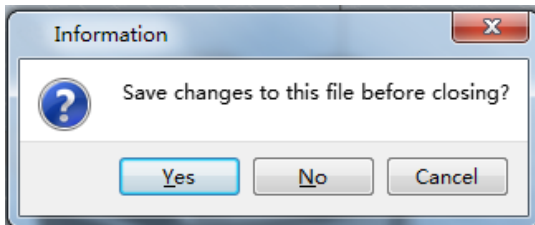
Others

Cooling Fan Control: Setting up the time period until the cooling fan is switched on. You can set the value in advance, then the cooling fan will be activated when this point is reached.

3.2.12 File menus

① New Project

Click at **[File] > [NewProject]** to create an empty project. If a change has not yet been confirmed for a previous project, you will be asked whether or not to save the change. Click **[Yes]** to save the change or **[No]** to discard it. If you click **[Cancel]** or close the tooltip, the new project is not created.



② Save

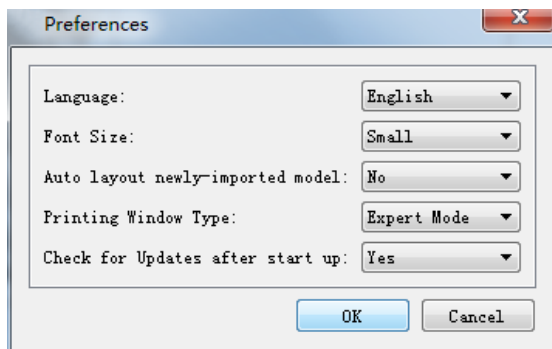
After the model has been edited and adjusted, there are two ways to save all the models displayed.

Method 1: Click on **[File]--[Save Project]** to save the file as project file with the file name extension FPP. All models shown (including supports) remain independent of each other. When the file is re-loaded, the configuration information for the extruder and model positioning will be the same as the configuration when the file is saved.

Method 2: Click **[File] > [Save as...]** to save the model as a project file in FPP, STL or OBJ format. With the STL and OBJ file formats, the models are integrated into a single model (including the supports). When re-loading these file formats, only the position of the model is saved, but not the print parameters.

③ Preferences

Click on **[File] > [Preferences]** . Here you can select the language and define the search for existing updates at device startup.



- **Language:** The software supports the following six languages: Chinese (simplified and traditional), English, French, Korean, Japanese and Russian.
- **Printing Window Type:** Includes basic mode and expert mode
- **Check for Update After Start Up:** This setting allows you to specify whether automatic online updating should be activated. If you select "Yes", the software can check online each time it is started to see if a new software version is available and, if so, prompt the user to download and install the new software version.

3.2.13 Editing menu

① Undo

The following two options are available to cancel the last changes made:

Method 1: Click at **[Edit] > [Undo]**.

Method 2: Press the key combination **Ctrl+Z**.

② Redo

The following two options are available to restore the last undone change to the model file.

Method 1: Click to **[Edit] > [Redo]**.

Method 2: Press the key combination **Ctrl+Y**.

③ Empty Undo Stack

You can use this function to delete the stored processing steps to free up memory space.

④ Select All

The following two methods can be used to select all models in the editing environment. (If models are so small that you cannot see them, or are outside the viewport, click the [Center] and [Scale] buttons to adjust the model)

Method 1: Click at **[Edit] > [Select All]**.

Method 2: Press the key combination **Ctrl+A**.

⑤ Duplicate

Duplicate the object using one of the following two methods:

Method 1: Click on **[Edit] > [Duplicate]**.

Method 2: Press the key combination **Ctrl+D**.

⑥ Delete

Delete object using one of the following two methods:

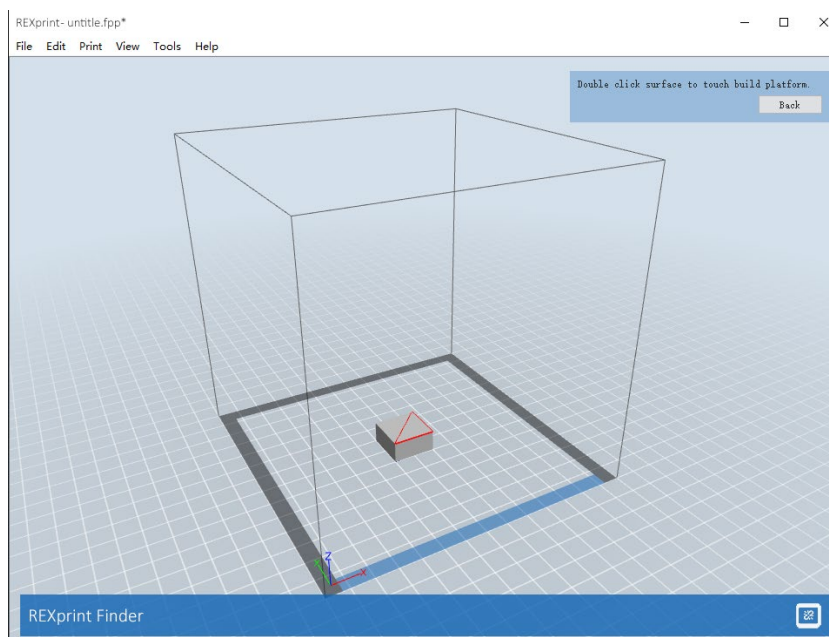
Method 1: Click on **[Edit] > [Delete]**.

Method 2: Press the **Del** key.

⑦ Surface to Platform

After you have selected the model, you can use the following procedure to place the model surface on the platform.

Click **[Edit] > [Surface to Platform]** to switch to Surface to Platform mode (as shown in the following figure).



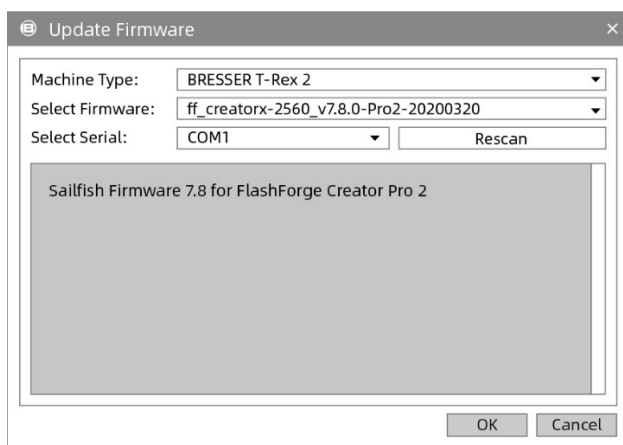
⑧ Auto Layout All

Click **[Edit] > [Auto Layout All]** after you have loaded one or more models. All models are then positioned using the automatic placement rule.

3.2.14 Tool menus

FIRMWARE UPDATE

Open REXPrint (your computer and the printer must be connected via a USB cable). Click **[Tools]** and **[Update Firmware]**, and then click **[OK]**. A dialogue box is displayed. Click **[Yes]** to start the firmware update.



3.2.15 Help menu

① Initial execution assistant

Here the basic functions are briefly introduced.

② Help contents

Clicking **[Help]-[Help Contents]** displays the help contents.

③ Check for updates

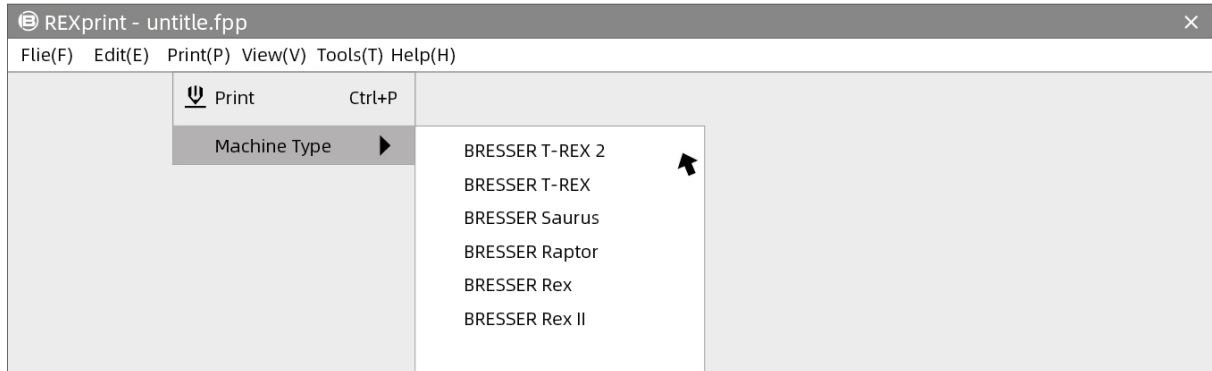
Clicking **[Help]-[Check for Updates]** will check for available online updates.

③ About REXprint

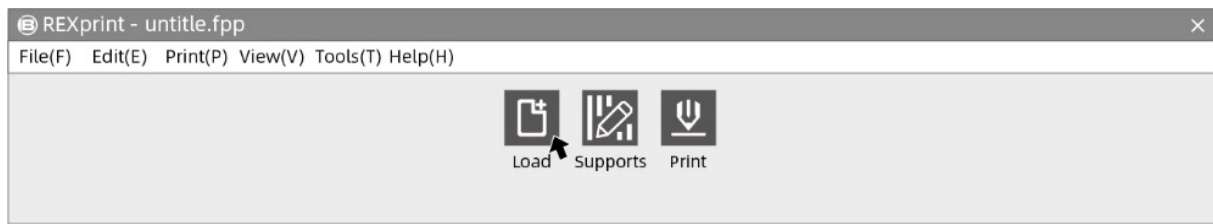
Clicking **[Help]-[About REXprint]** displays the software info window. The current software version and copyright notices are displayed here.

3.3 How do I create a .g file?

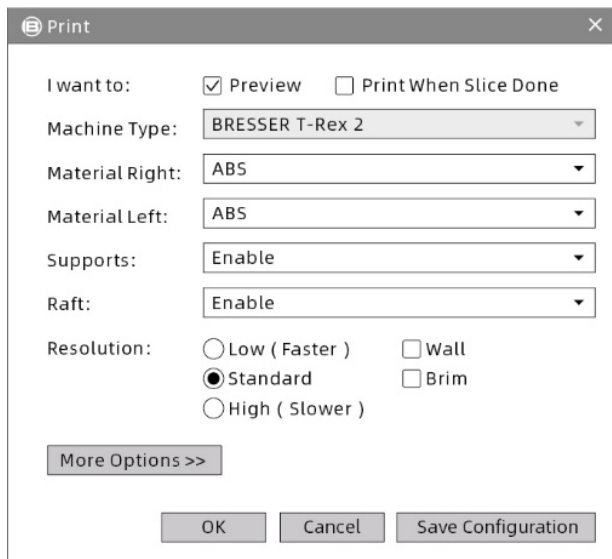
By default, the left extruder is used as the material extruder; the right extruder is the printing extruder. When printing a monochrome model, the right extruder is automatically set as the print extruder unless this setting is changed by the user.



- ① Click **[Print]**-**[Machine Type]** for the printer model selection.



- ② Click the **[Load]** icon to load an STL model file. The object is displayed in the construction area.



Preview: Check the function recommend.

Machine type: BRESSER T-REX 2.

Materials: Select the desired materials.

Supports: Recommended setting [Enable].

Raft: Recommended setting [Enable].

Resolution: Recommended setting [Default].

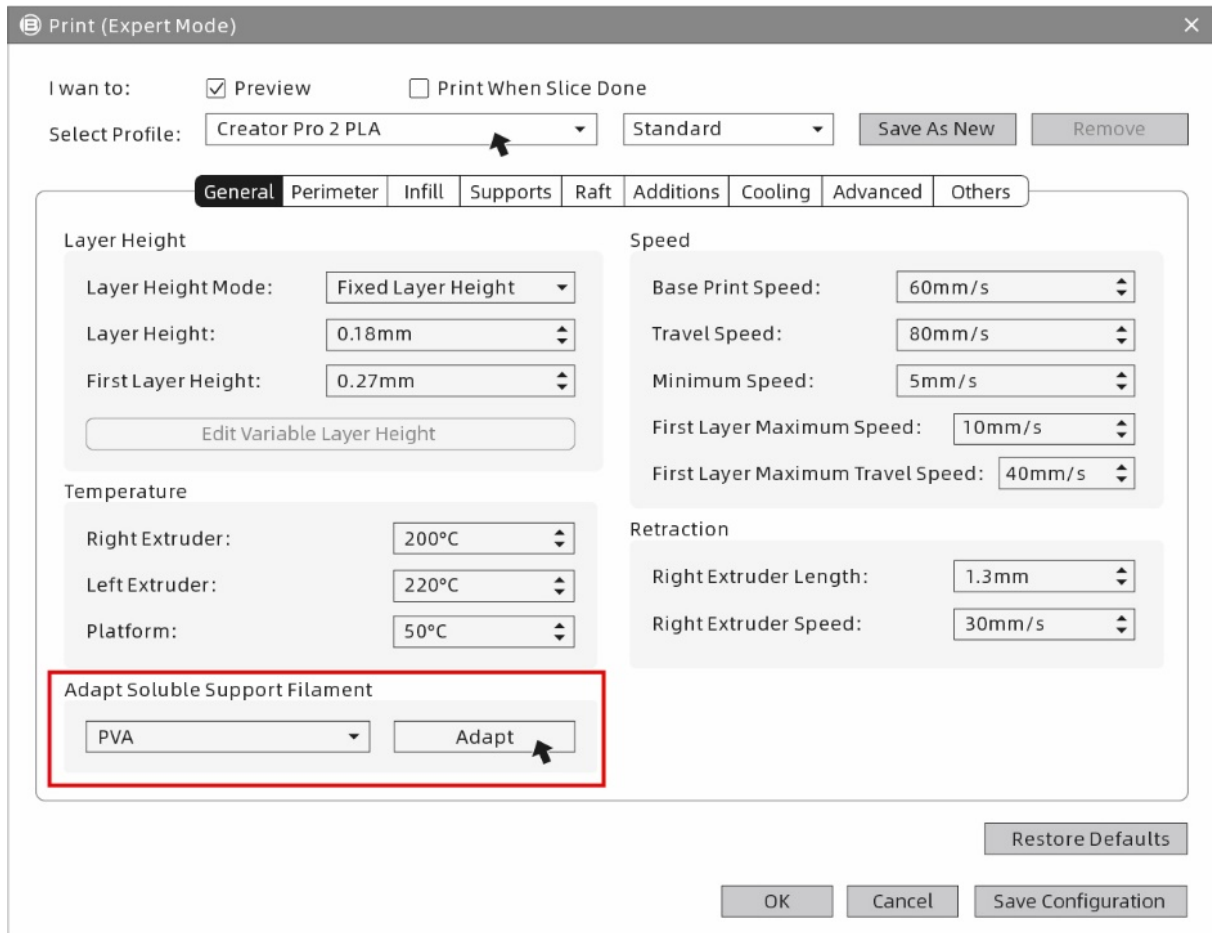
More Options: It is suggested that you keep the default settings.

Note: The default settings are good for first time users.

3.4 Introduction to functions

Expert mode

① Click **[File]** on the menu and select **[Preferences]**. Select "Expert Mode" in the pop-up window and click **[OK]**.



② Click the **[Print]** icon on the REXprint interface. The parametre settings window is displayed. Select the materials, including Creator Pro 2 PLA. For printing with water-soluble supports, click **[General]-[Adapt Soluble Support Filament]-[PVA]-[Adapt]**, and then click **[Save Configuration]**.

The expert mode supports the selection of soluble materials. Click on it and set the feed for the left extruder. It depends on the material properties whether the feed has to be adjusted. The feed setting can reduce drawings.

Print (Expert Mode) [X]

I want to: ☒ Preview ☐ Print When Slice Done

Select Profile: Creator Pro 2 PLA Standard Save As New Remove

General Perimeter Infill **Supports** Raft Additions Cooling Advanced Others

General

Enable Support: Yes

Select Extruder: Automatch

Treelike

Speed: 60%

Space to Model(X/Y): 0.20mm

Shell Count: 3

Lower build plate while traveling: Yes

Linear

Speed: 70%

Space to Model(X/Y): 0.35mm

Space to Model(Z): 0.20mm

Space to Raft(Z): 0.15mm

Path Shape: Polyline

Path Space: 2.0mm

Path Angle: 45°

Support Thickness: 70%

Top Solid Layers: 0

Print Outline: No

Restore Defaults

OK Cancel Save Configuration

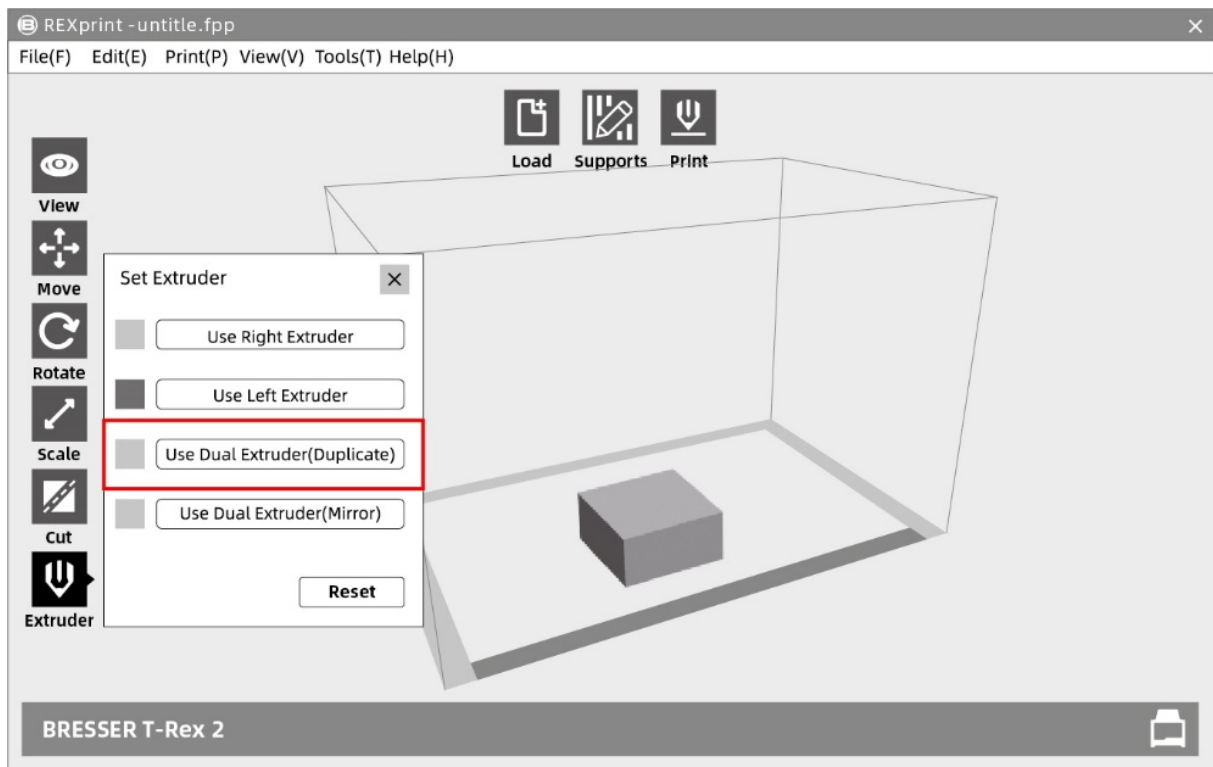
The distance between supports and model and the support density can be adjusted in the **[Supports]** setting tabs.

Mirror/duplicate functions

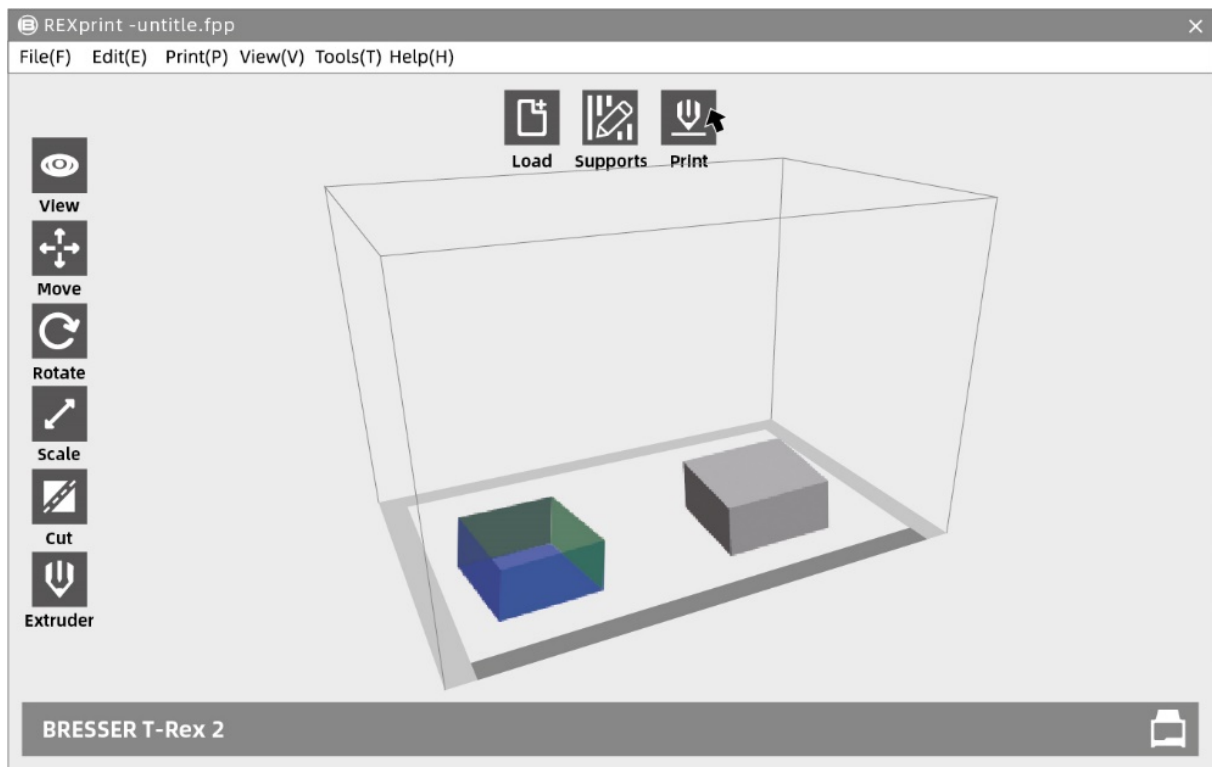
Print two identical models, select duplicate mode; print two mirror-like models, select mirror mode.

In "mirroring" or "duplicating" mode, two extruders print the models simultaneously.

Note: The size of the X-axis of the model should be less than 80 mm in mirror or duplicate mode.



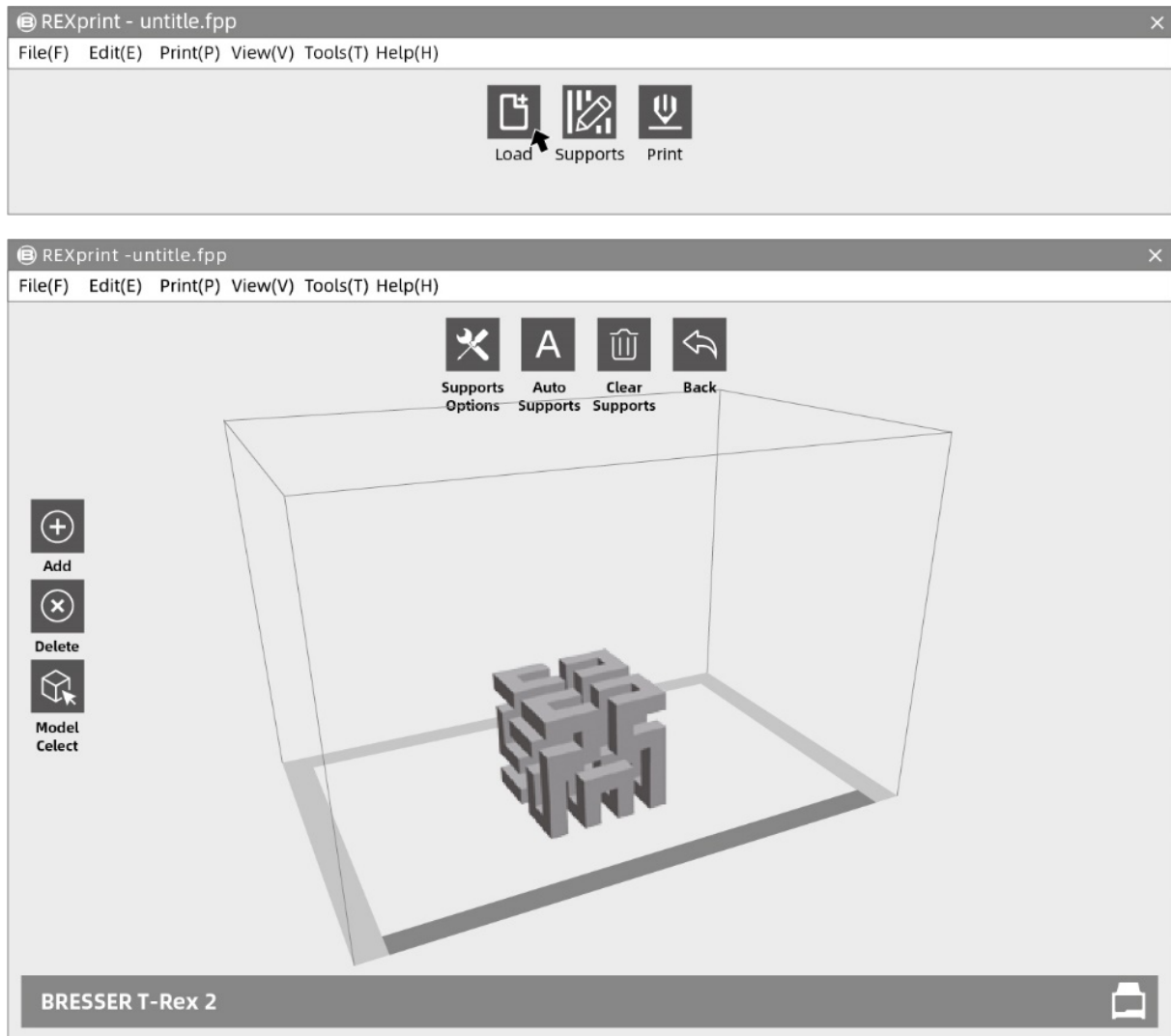
- ① Select Model and click **[Extruder]** to start setting the extruder.



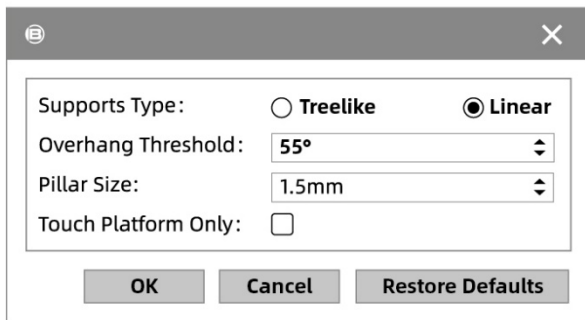
- ② After the executed mirroring or duplicating, the models are displayed in the build area. Tap **[Print]**. Due to the difference in height of the two extruders in mirroring mode, a compensation layer may be printed. Therefore, it is recommended to add "Raft" in the mirror mode.

Add supports

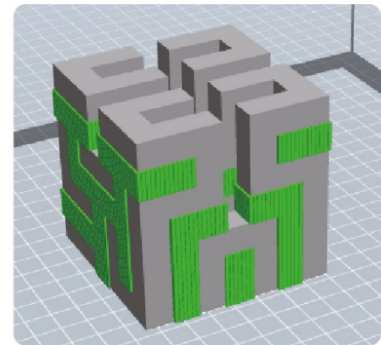
Adding supports for off/on structures for a good print result.



① Click the **[Supports]** icon to make the settings for the supports. The prop settings can be made automatically. Click **[Delete]** on the left side to delete the supports manually.



- ② Under **[Support Options]**, select tree shape or linear supports. Overhang threshold refers to the angle of the up/down suspended model. If the angle is exceeded, the support is generated.



- ③ Click **[Auto Supports]** to create supports automatically.

Dimensional adjustments

Print (Expert Mode)

I want to: ☒ Preview ☐ Print When Slice Done

Select Profile: Creator Pro 2 PLA Standard Save As New Remove

General Perimeter Infill Supports Raft Additions Cooling Advanced **Others**

Dimensional Adjustments

Enable Adjustments: No

External Compensation: 0.00mm

Internal Compensation: 0.10mm

Z Compensation: 0.00%

Sequential Printing

Enable Sequential Printing: No

Right Nozzle Margin X: 50.15mm

Right Nozzle Margin Y: 59.00mm

Left Nozzle Margin X: 50.15mm

Left Nozzle Margin Y: 59.00mm

Gantry Height: 31.70mm

Pause At Heights

Pause Heights: Edit

Restore Defaults

OK Cancel Save Configuration

For dimensional deviations, click **[Others]** to open the dimensional adjustment functions. Positive adjustments of values produce enlargements, negative adjustments produce reductions. The Z-axis height is adjusted according to the percentage value.

Chapter 4: Maintenance

Problem	Cause	Remedy
Extruder head off-centre	The device no longer recognizes the exact extruder position and cannot build.	Return the extruder to the home position to recalibrate the BRESSER T-REX 2. Abort your object, empty the construction platform, send the extruder to the home position and restart your object.
No PLA extrusion or adhesion to the construction tape.	This may be due to the platform and extruder head not being properly aligned (levelled).	By levelling the platform, the extruder head is aligned, which improves the quality of the object. Abort your object, empty the design platform, level the extruder in the home position, and restart your object.
BRESSER T-REX 2 frozen before object start.	BRESSER T-REX 2 may receive contradictory commands.	Turn off the power switch, wait 30 seconds, and turn on the power switch.
Entanglements at the end of the construction.	A layer of your object is not adhering properly, the model was secured to the construction platform with minimal contact, or the object was built floating and without supports above the construction platform. Wrong Z-axis offset, extruder tip is not aligned with the correct distance to the design platform.	Use the preview function of your slicing software to display the height and position of the first layer. Build with supports if necessary. For information on calibrating the Z-axis offset, contact Customer Service.
No filament leaks.	Extruder clogged. Filament not loaded properly.	Try changing the filament to make sure the extruder gears have gripped the filament properly. Contact customer service.
Extruder not in home position.	Limit switch wiring	Contact customer service.
Straggly or frayed plastic layers on steep overhangs.	Object overhangs are too far apart or too steep (angle less than 45 degrees).	Building with supports.

Chapter 5: Warranty and service

Warranty

The regular guarantee period is 5 years and begins on the day of purchase.

Please keep the proof of purchase (receipt/invoice) carefully as proof of purchase.

During the warranty period, defective devices will be accepted by the local dealer or, if necessary, sent in directly by you. In any case, the postage costs must be at your expense. In case of a warranty claim, the postage costs will be refunded. You will then receive a new or repaired device back free of charge. The decision whether to repair or replace the device is up to us.

Excluded from this warranty are accessories/components such as mounting plates and foils, acrylic glass/plastic elements, USB/removable storage media, filaments and coils, adhesives, resins/greases, vessels and containers, tools etc.

The guarantee expires if defects in the object of purchase are due to the following circumstances:

- improper usage
- negligent or intentional damage through own fault and/or unauthorized third parties
- Repairs or alterations carried out by third parties without our order
- Changes or damage due to force majeure (storm, hail, fire, power failure, lightning, flooding, snow damage, frost and other effects caused by animals, etc.)

The warranty is also void if a damaged and/or illegible or incomplete proof of purchase is presented.

The rights from the guarantee exist independently of the legal warranty claims.

The guarantor is BRESSER GmbH, Gutenbergstr. 2, 46414 Rhede, Germany.

After the warranty period has expired, you also have the possibility to send a defective device for repair. Repairs after the warranty period are subject to a charge. You will receive a cost estimate from us before the repair is carried out.

In case of a return, please note the following:

Make sure that the article is sent carefully packed. If possible, use the original packaging. Fill out the Service Form and enclose it with the proof of purchase.

Service

You can contact the BRESSER service team if you have problems with the 3D printer. If questions or problems are not covered in this manual, you can search for solutions on our official website or contact us by phone.

Our Knowledge Base provides solutions and instructions for frequently occurring problems. It is advisable to look for a solution there first, as the most frequent questions are answered there.

<http://www.bresser.de>

Email: service.3d-printer@bresser.de

You can reach the BRESSER service team by phone or e-mail from Monday to Saturday, 8:30-15:30 (CET). If you contact us outside these business hours, we will answer your request on the following working day.

Note: Due to different filaments the extruder can be blocked. This problem is not a quality problem and is outside the range of 400 hours of operation. If this problem occurs, please contact customer service and carry out cleaning according to the instructions provided there.

Service

DE AT CH BE

Bei Fragen zum Produkt und eventuellen Reklamationen nehmen Sie bitte zunächst mit dem Service-Center Kontakt auf, vorzugsweise per E-Mail.

E-Mail: service@bresser.de
Telefon*: +49 28 72 80 74 210

BRESSER GmbH

Kundenservice
Gutenbergstr. 2
46414 Rhede
Deutschland

*Lokale Rufnummer in Deutschland (Die Höhe der Gebühren je Telefonat ist abhängig vom Tarif Ihres Telefonanbieters); Anrufe aus dem Ausland sind mit höheren Kosten verbunden.

GB IE

Please contact the service centre first for any questions regarding the product or claims, preferably by e-mail.

E-Mail: service@bresseruk.com
Telephone*: +44 1342 837 098

BRESSER UK Ltd.

Suite 3G, Eden House
Enterprise Way
Edenbridge, Kent TN8 6HF
United Kingdom

*Number charged at local rates in the UK (the amount you will be charged per phone call will depend on the tariff of your phone provider); calls from abroad will involve higher costs.

FR BE

Si vous avez des questions concernant ce produit ou en cas de réclamations, veuillez prendre contact avec notre centre de services (de préférence via e-mail).

E-Mail: sav@bresser.fr
Téléphone*: 00 800 6343 7000

BRESSER France SARL

Pôle d'Activités de Nicopolis
314 Avenue des Chênes Verts
83170 Brignoles
France

*Prix d'un appel local depuis la France ou Belgique

NL BE

Als u met betrekking tot het product vragen of eventuele klachten heeft kunt u contact opnemen met het service centrum (bij voorkeur per e-mail).

E-Mail: info@bresserbenelux.nl
Telefoon*: +31 528 23 24 76

BRESSER Benelux

Smirnoffstraat 8
7903 AX Hoogeveen
The Netherlands

*Het telefoonnummer wordt in het Nederland tegen lokaal tarief in rekening gebracht. Het bedrag dat u per gesprek in rekening gebracht zal worden, is afhankelijk van het tarief van uw telefoon provider; gesprekken vanuit het buitenland zullen hogere kosten met zich meebrengen.

ES IT PT

Si desea formular alguna pregunta sobre el producto o alguna eventual reclamación, le rogamos que se ponga en contacto con el centro de servicio técnico (de preferencia por e-mail).

E-Mail: servicio.iberia@bresser-iberia.es
Teléfono*: +34 91 67972 69

BRESSER Iberia SLU

c/Valdemorillo, 1 Nave B
P.I. Ventorro del Cano
28925 Alcorcón Madrid
España

*Número local de España (el importe de cada llamada telefónica dependen de las tarifas de los distribuidores); Las llamadas des del extranjero están ligadas a costes suplementarios..

Contacte con

Bresser Iberia

Servicio al Cliente

c/Valdemorillo,1 Nave B

P.I. Ventorro del cano

28925 Alcorcón Madrid

España

www.bresser-iberia.es

    @BresserEurope

