

 User Manual

**ANYCUBIC PHOTON M3 PLUS**

Dear customer,

Thank you for choosing **ANYCUBIC** products.

Maybe you are familiar with 3D printing technology or have purchased **ANYCUBIC** printers before, we still highly recommend that you read this manual carefully. The installation techniques and precautions in this manual can help you avoid any unnecessary damage or frustration.

Please visit <https://support.anycubic.com> to contact us if you have any question. You can also gain more information such as software, videos, models from the website.



**ANYCUBIC** support center

Team **ANYCUBIC**

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# Safety Instructions

*Always follow the safety instructions during assembly and usage, to avoid any unnecessary damage to the 3D printer or individual injury*



Please contact our customer service first if you have any issue after receiving the products.



Be cautious when using the scraper. Never direct the scraper towards your hands.



In case of emergency, please immediately cut off the power of **ANYCUBIC** 3D printer and contact the technical support.



**ANYCUBIC** 3D printer includes moving parts that can cause injury.



It is recommended to use protection glasses when cleaning/sanding the printed models to avoid small particles contacting eyes.



Keep the **ANYCUBIC** 3D printer and its accessories out of the reach of children.



Vapors or fumes may be irritating at operating temperature.

Always use the **ANYCUBIC** 3D printer in an open and well ventilated area.



**ANYCUBIC** 3D printer must not be exposed to water or rain.



**ANYCUBIC** 3D printer is designed to be used within ambient temperature ranging 8°C-40°C, and humidity ranging 20%-50%. Working outside those limits may result in low quality printing.



Do not disassemble **ANYCUBIC** 3D printer, please contact technical support if you have any question.

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# Technical Specification

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## Printing

Model	Anycubic Photon M3 Plus
Operation	5-inch capacitive touch screen
Software	Anycubic Photon workshop
Connectivity	USB memory stick, Anycubic Cloud

## Specifications

Technique	LCD Shadow Masking
Light source	UV-LED (wavelength 405nm)
XY Resolution	34.4 $\mu$ m 5760*3600 (6K)
Z axis Accuracy	0.01mm
Suggested Layer Thickness	0.01 ~ 0.15mm
Suggested Print Speed	MAX 100mm/h
Rated power	120W

## Physical Dimensions

Dimension	360mm (L) *290mm (W) 475*mm (H)
Build volume	197mm (L) *122mm (W) *245mm (H)
Materials	405nm UV-resin
Net weight	~12 kg

# Technical Specification

## Recommended Printing Parameters


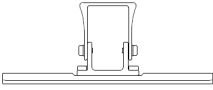
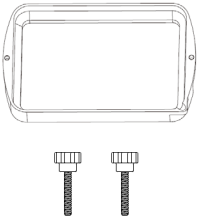

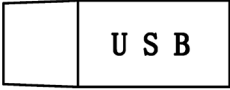
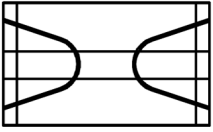

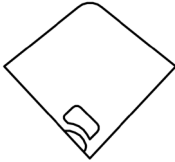
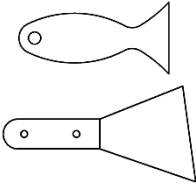


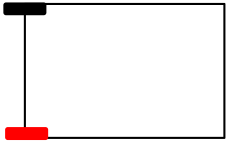


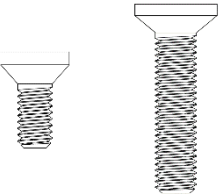

Layer Thickness	0.05 mm
Normal Exposure Time	1.5 s
Off Time	0.5 s
Bottom Exposure Time	23 s
Bottom Layers	6
Z Lift Distance	6 mm
Z Lift Speed	6 mm/s
Z Retract Speed	6 mm/s
Anti-alias	1

### Note:

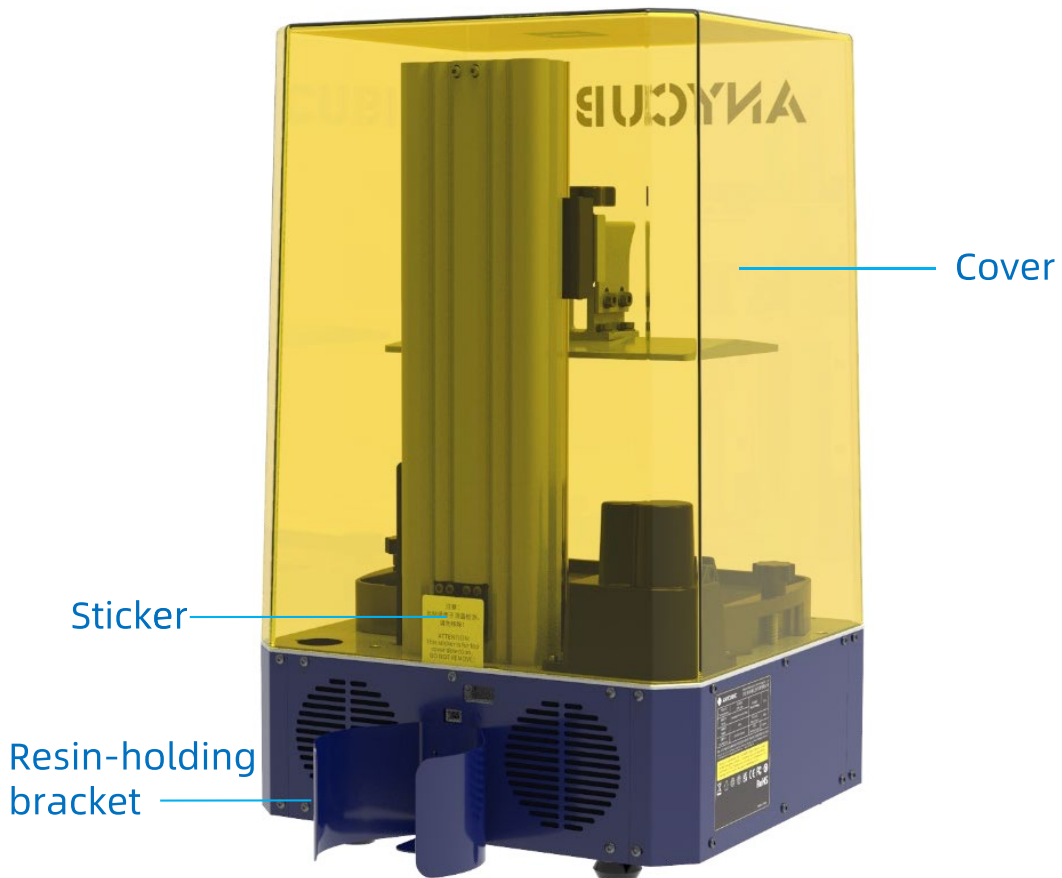
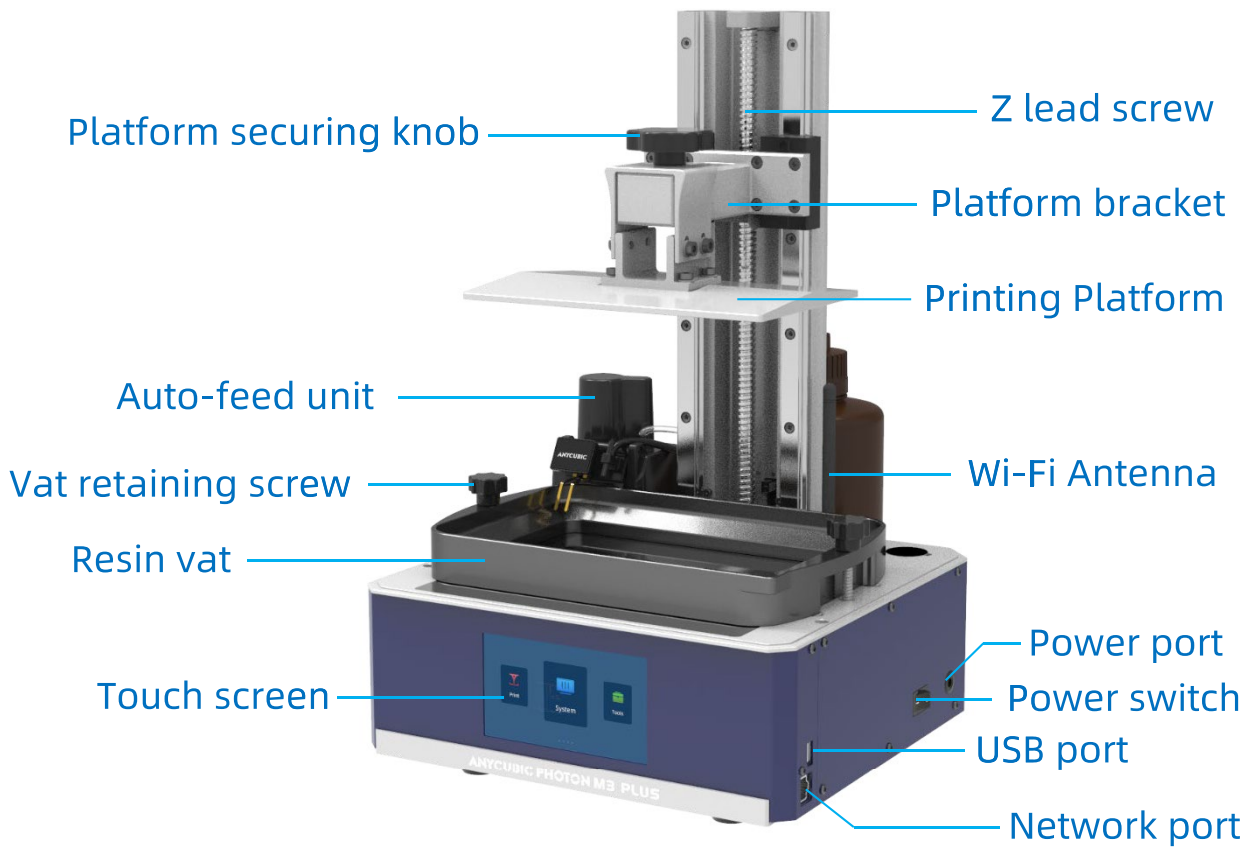
The recommended printing parameters above is for reference only, which is more suitable for Anycubic resin.



# Packing List

			
		Print platform 1PC	Resin vat 1PC
			
Anycubic Photon M3 Plus		WIFI Antenna 1PC	USB memory 1PC
			
Mask 1PC	Gloves 3Pairs	Funnel 5PCS	Scrapers 2PCS
			
Tool kit	Leveling paper 1PC	Screen protector kit	Assembly Instruction 1PC
			
Power adaptor	M3*5 spare screws M4*12 spare screws	Auto-feed unit (with Screws:M3*6 2PCS,M3*8 2PCS)	

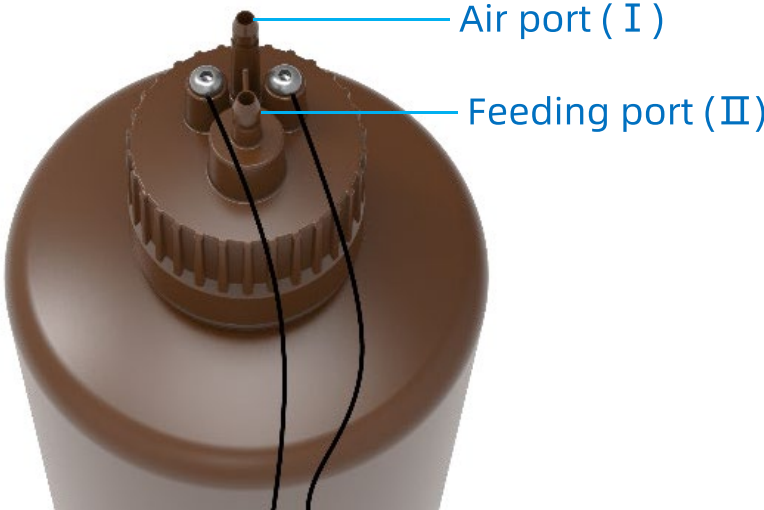
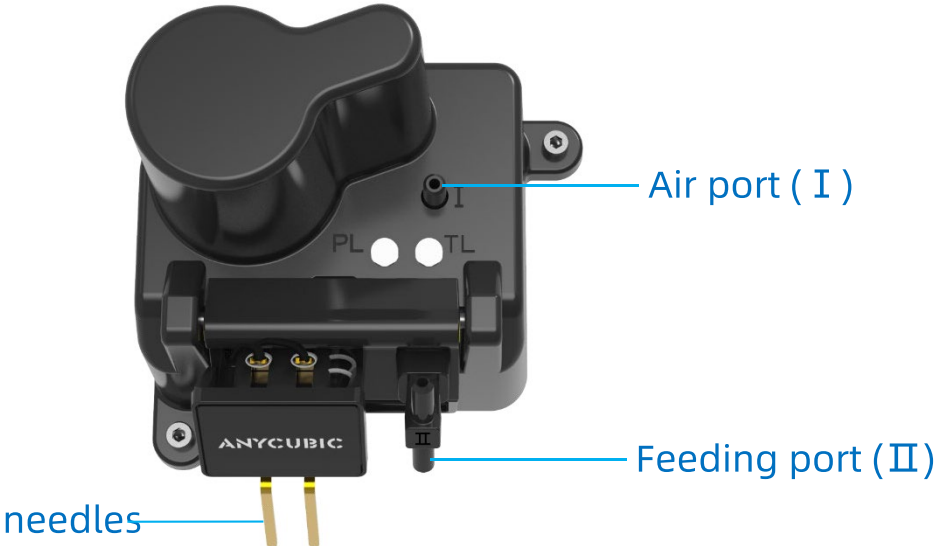
# Product Overview





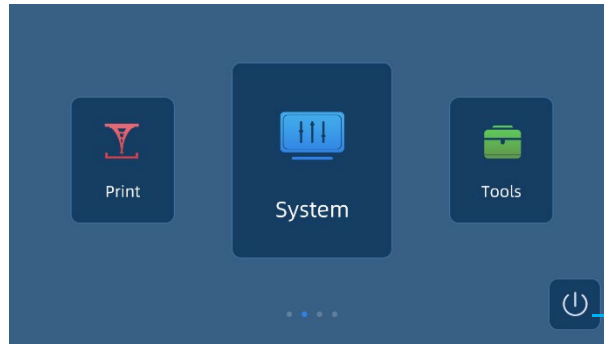
# Product Overview

## Auto-feed unit



# Menu Directory

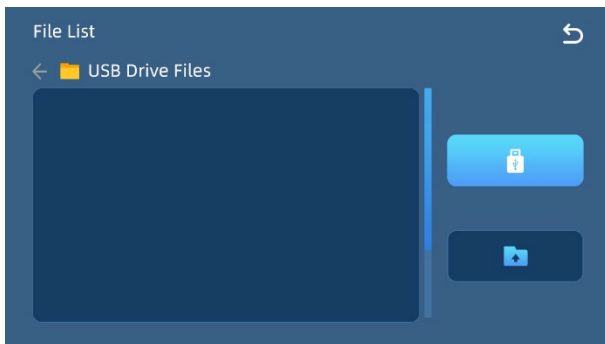
## Home menu



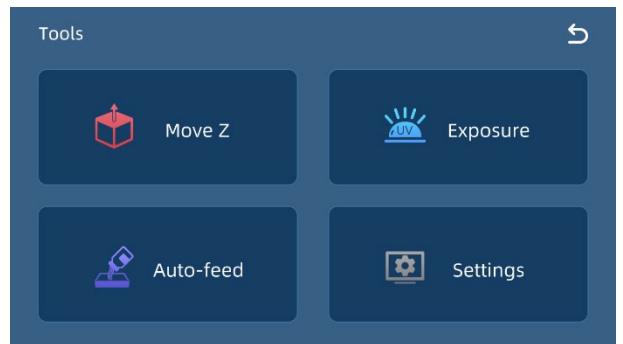
Click to shut down

Click to choose

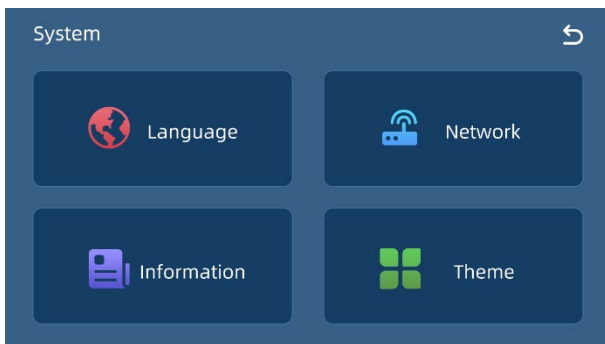
## Print



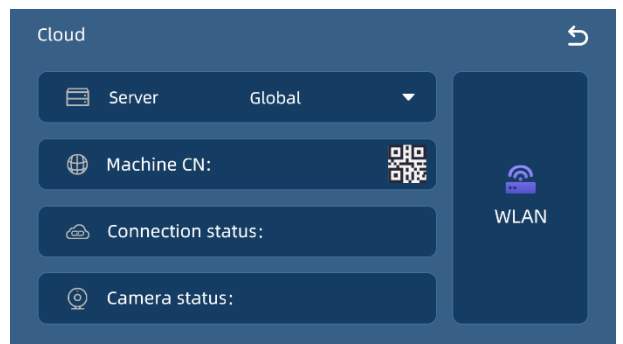
## Tools



## System



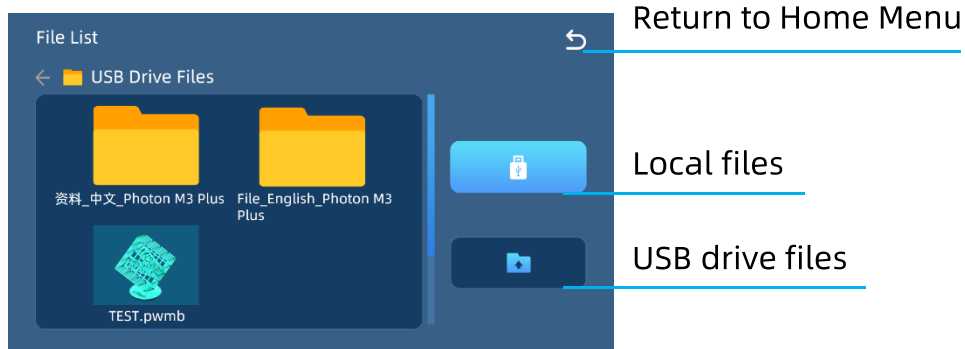
## Cloud



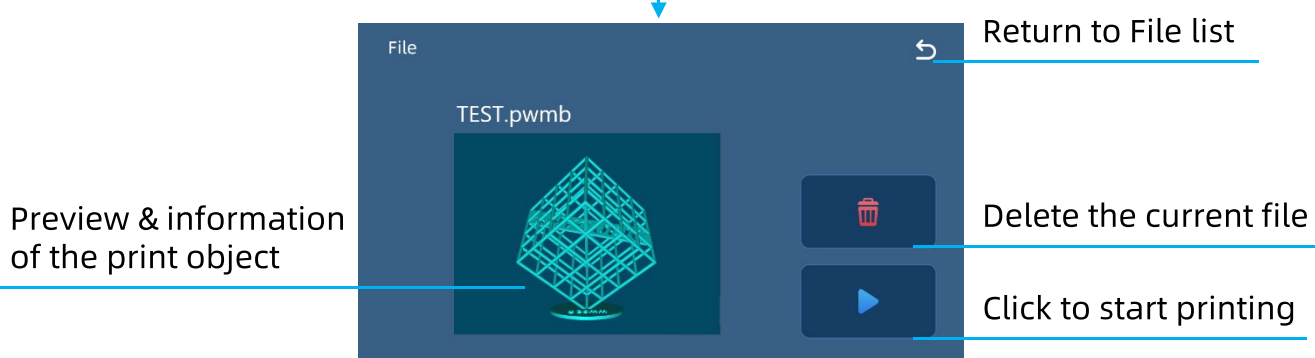
# Menu Directory

## Print

### File List:

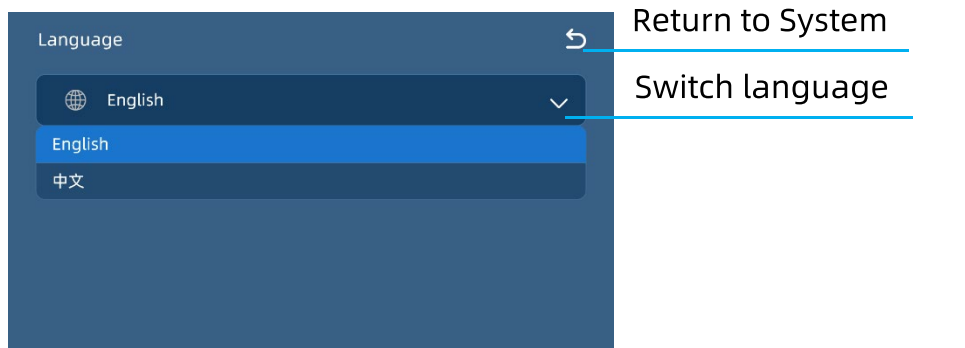


### Click Files

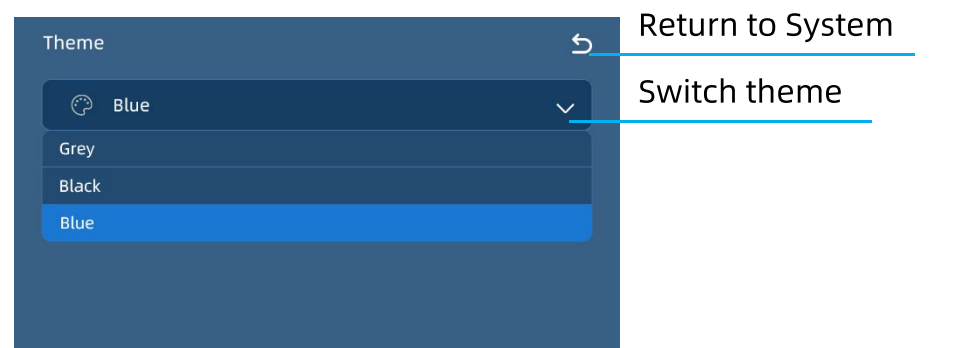


## System

### Language:



### Theme:



# Menu Directory

## Information:

The screenshot shows the 'Information' menu with a back arrow in the top right. On the left, four items are listed with blue underlines: 'Machine type', 'System version', 'Serial number', and 'Official website'. On the right, two callouts with blue underlines point to the 'Return to System' back arrow and a 'Version check' button with a circular refresh icon.

## Software update:

The screenshot shows the 'Version Detection' menu with a back arrow in the top right. On the left, two items are listed with blue underlines: 'The current version' and 'TIPS for update'. On the right, three callouts with blue underlines point to the 'Return to Information' back arrow, a blue 'upgrade' button next to 'Local upgrade:', and a grey 'upgrade' button next to 'OTA upgrade:'.


## Network:

The screenshot shows the 'Network' menu with a back arrow in the top right. On the left, one item is listed with a blue underline: 'Wired/wireless connection'. On the right, four callouts with blue underlines point to the 'Return to System' back arrow and the 'IP:', 'MAC:', 'Connection mode:', and 'SSID:' labels.

# Menu Directory

## Tools

### Move Z:



Move Z

0.1mm 1mm 10mm

Move Z by 0.1mm/1mm/10mm

Stop moving Z axis

Return to Tools

Move Z axis upwards


Move Z axis downwards

Return to Zero

Reset the zero point

Detailed description: This screenshot shows the 'Move Z' menu. At the top left, the text 'Move Z' is displayed. Below it are three buttons labeled '0.1mm', '1mm', and '10mm'. To the right of these are three vertical buttons: an upward arrow, a downward arrow, and a home icon. At the bottom left is a button with a red prohibition sign, and at the bottom center is a button labeled 'Z=0'. A 'Return to Tools' button with a circular arrow icon is at the top right. Blue lines connect text labels to the corresponding UI elements.

### Auto-feed:



Auto-feed

Feed in

Feeding speed

Resin in bottle

Show whether the resin in bottle is enough


Return to Tools

Turn on/off feed-in

Set feeding speed

Detailed description: This screenshot shows the 'Auto-feed' menu. It features three horizontal control panels. The top panel is 'Feed in' with a toggle switch that is currently turned on. The middle panel is 'Feeding speed' with a slider. The bottom panel is 'Resin in bottle' with a bar graph. A 'Return to Tools' button is at the top right. Blue lines connect text labels to the corresponding UI elements.

### Exposure:



Exposure

Return to Tools

Select one image to expose

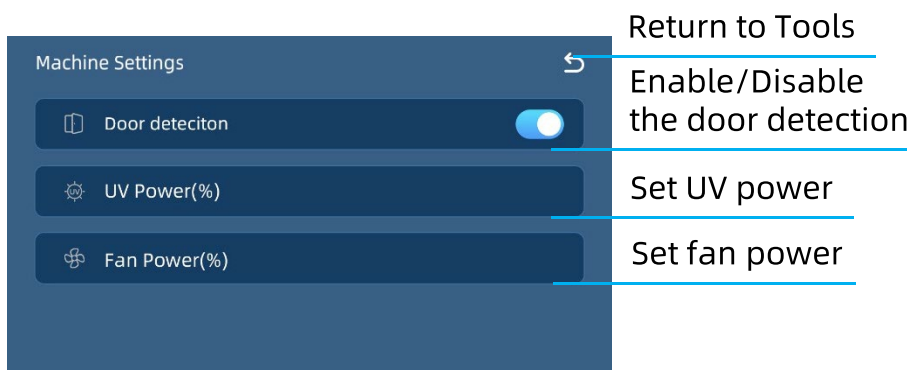
Set exposure time

Click to expose

Detailed description: This screenshot shows the 'Exposure' menu. It has a 2x2 grid of image thumbnails. To the right of the grid is a vertical slider for 'Set exposure time' with a blue bar and the number '5'. Below the slider is a large button with a right-pointing arrow and the word 'Next'. A 'Return to Tools' button is at the top right. Blue lines connect text labels to the corresponding UI elements.

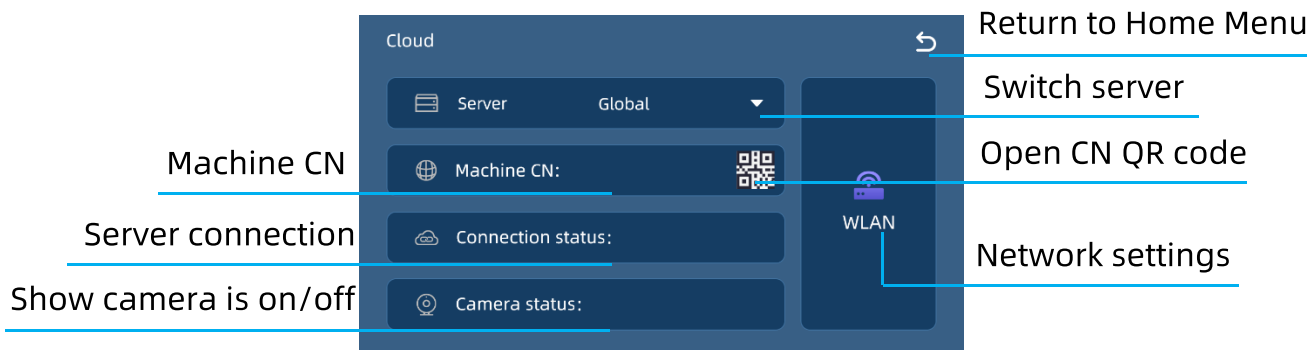
# Menu Directory

## Machine settings:



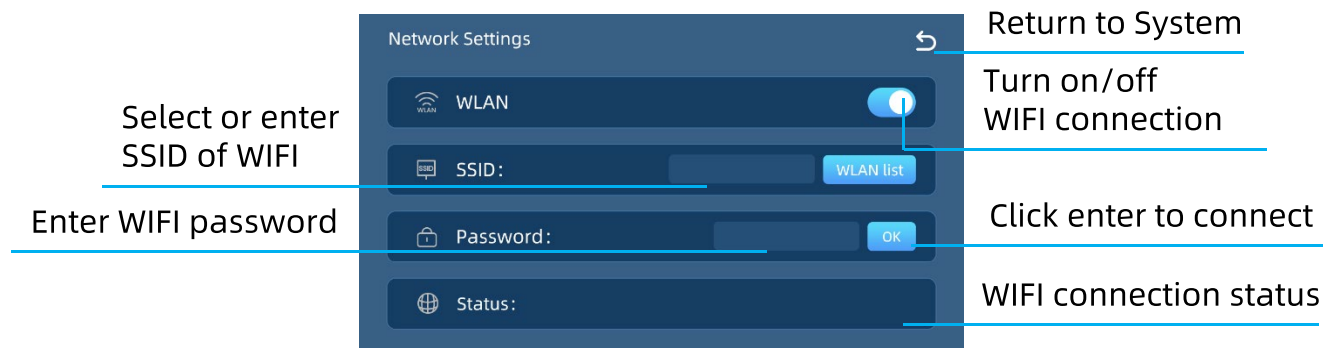
## Cloud

### Cloud:



Click to set up network

### Network settings:

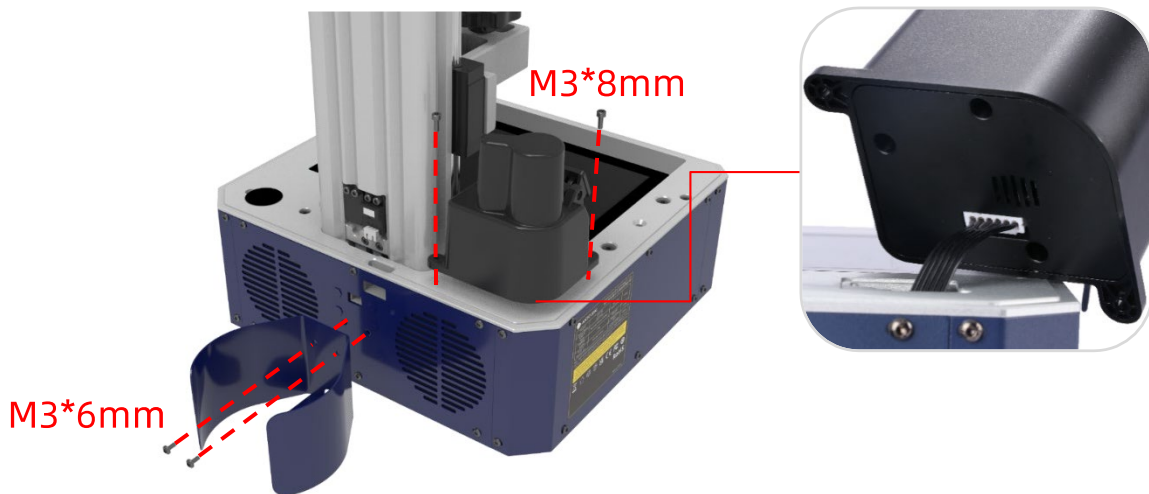


# Assembly and Leveling Instructions

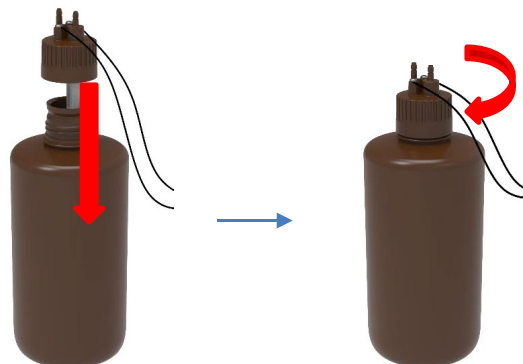
1. Unpack the machine and take out the accessories. Skip to Step 7 if you do not want to install auto-feed unit first.
2. Turn the machine back. Remove the black square cover upon the base and take out the wire below.



3. Connect the wire to resin sensor, then install the sensor and resin-holding bracket.

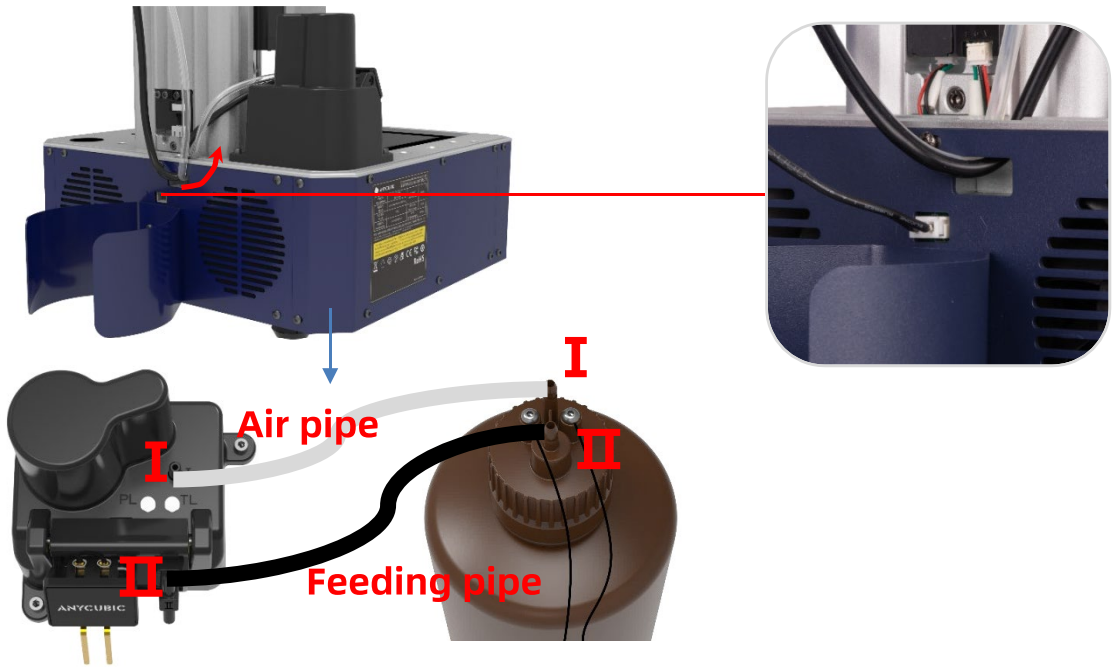


4. Insert the cap part into **Anycubic 1kg resin bottle** and tighten it.

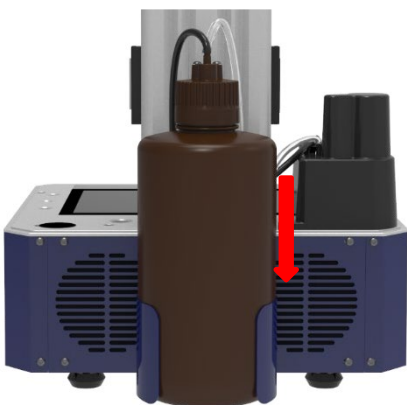


# Assembly and Leveling Instructions

5. Pass two pipes through the limit hole on the back of the machine from the bottom up. **Connect ports II with feeding pipe (black) and connect ports I with air pipe (transparent)** . Please completely follow this way of connection to avoid the damage of auto-feed unit. Then, connect the cap part wire to machine.



6. Place resin bottle on the bracket.

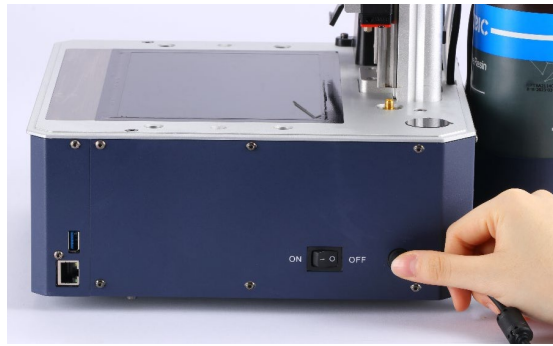


TIPS: When you change resin, it is recommended to tighten the cap through rotating bottle to avoid blockage caused by twisting pipes.

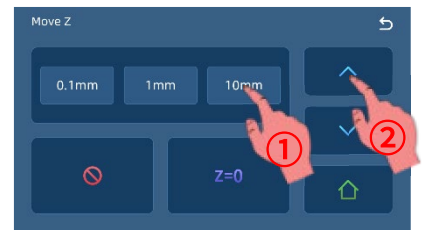
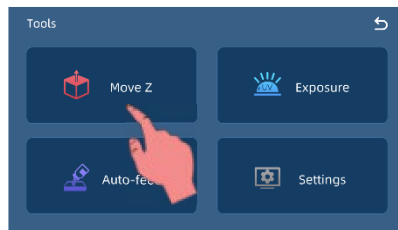
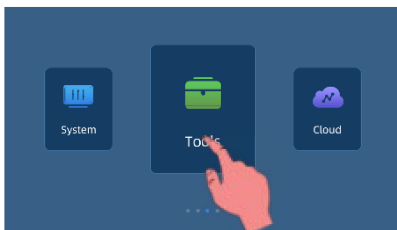
7. Turn the machine back to the front. Then plug in the power cord and turn on the printer.



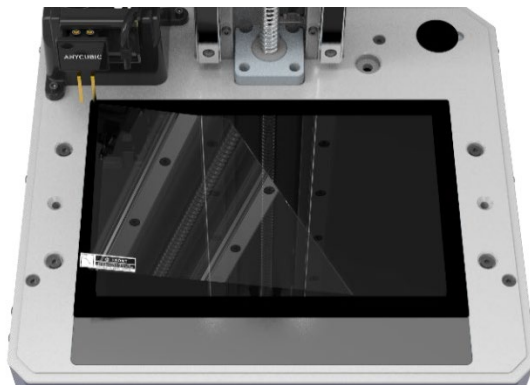
# Assembly and Leveling Instructions



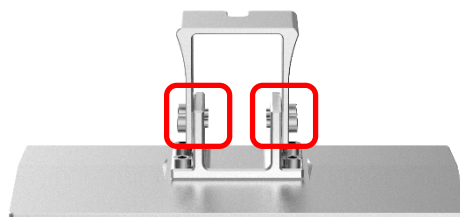
8. Rise the Z axis to a certain height to ensure that the curing screen will not be scratched when the printing platform is installed.



9. Tear off the protective film before leveling and printing.

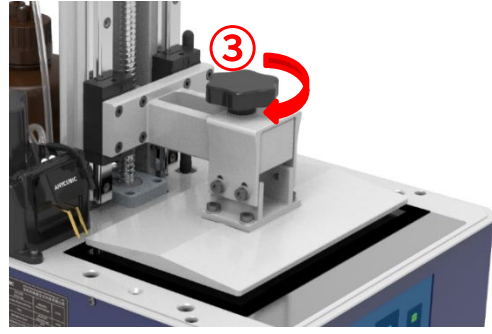
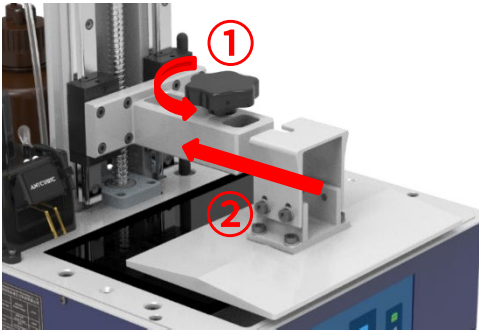



10. Loosen the four screws on the printing platform.

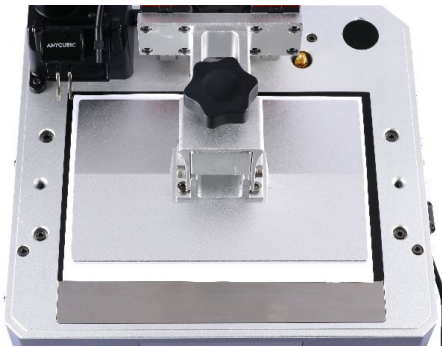


# Assembly and Leveling Instructions

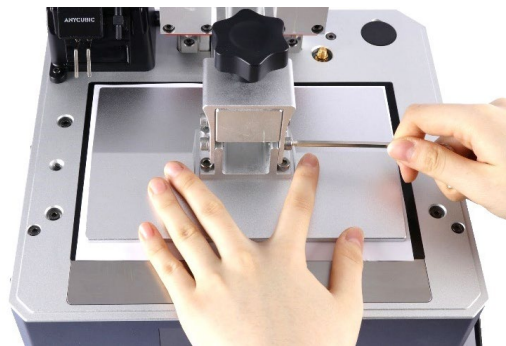
11. Install and secure the printing platform.



12. Place the leveling paper on the curing screen. Then click  on the touch screen. Wait for descent of Z axis.



13. Press on top of the platform gently, and then tighten the four screws to secure the platform.

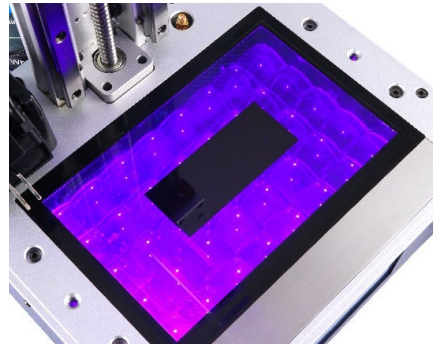
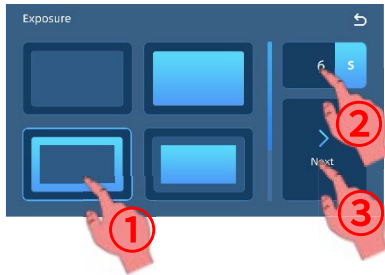


14. Lastly, click "Z=0" and confirm to save the zero position. Click "Enter" and Z axis will automatically lift up. Then, take out the paper.

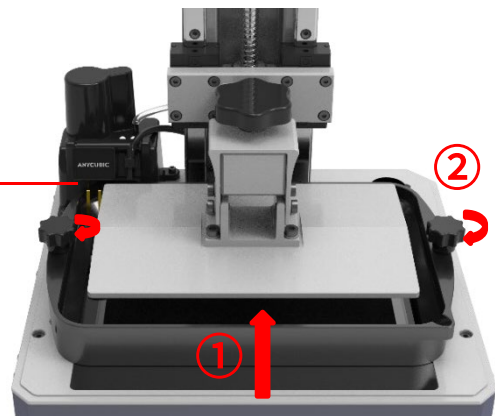


# Assembly and Leveling Instructions

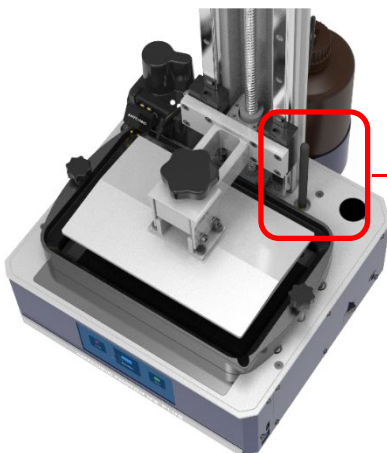
15. Raise printing platform until the curing screen can be observed completely. Return to Tools menu and click "Exposure". Select an image, set the test time and then click "Next". The corresponding image should be displayed completely on curing screen.



16. Install resin vat with both needles being set in it.



17. Install WIFI antenna.

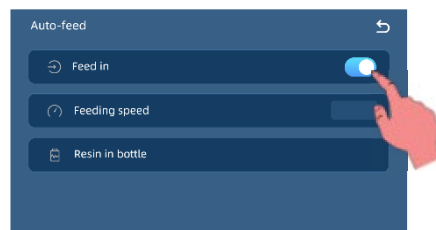
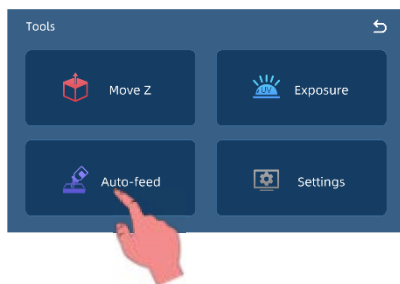


# Auto-feed

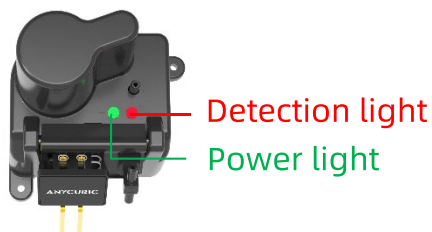
## 1. Instructions

Ensure the auto-feed unit has been installed and the resin in bottle is enough to print. **The function is for supplement only, please pour resin into resin vat before printing.**

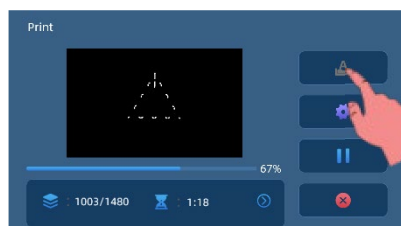
Click "Tools" → "Auto-feed" → "Feed in". It will feed in automatically if resin in the vat is sufficient during printing. Click "feeding speed" to set the speed.



- Auto-feed only works when machine is printing.
- The unit feeds every five minutes normally.
- Green light indicates that the unit has been powered.
- Red light indicates that resin is not detected by needles. When needles detects resin, the light goes off.



If the insufficiency of the resin in bottle is detected when it is printing, the machine will beep to warn and disable auto-feed function. Please add or change resin first and click auto-feed button to enable it if necessary.



Click auto-feed button to enable the function after add or change resin

# Auto-feed

## Notice:

1. If you use non-Anycubic resin, it is suggested to check whether red light goes out normally when resin reaches both needles before printing. If not, the resin cannot be automatically fed.
2. To save resin, pour the remaining resin that is out of the reach of pipes to resin vat.
3. **DO NOT vigorously shake or turn over the resin bottle when cap part is installed. If the inside of cap is stained by resin, please immediately clean it to avoid malfunction or damage of auto-feed unit.**

## 2. Troubleshooting

Issues	Troubleshooting		Solution
Do not feed in during printing	Red light is off	The resin in vat reaches both needles	Wait until the resin is insufficient.
		The resin in vat does not reach both needles	The power light(green) is off, reconnect the wire under detection unit.
			Two needles touch each other. Please contact the tech support.
		Resin abnormally gets into the air pipe to cause malfunction of the unit. A replacement is needed.	

# Auto-feed

Issues	Troubleshooting		Solution
Do not feed in during printing	Red light is on	Waiting status	It feeds every five minutes normally. Wait for the next feeding.
		Feeding status	The wrong connection of air pipe and feeding pipe cause malfunction of auto-feed unit. A replacement is needed.
The machine shows resin in bottle is insufficient and disable auto-feed function	Resin in bottle is insufficient		Add resin to bottle
	Resin in bottle is sufficient but machine shows its status as No Resin	The two screws on the cap is loosened	Tighten the screws
		The wire connecting cap and machine is disconnected	Connect the wire to machine
Nothing wrong with screws and wire	The resin cannot be used for auto-feed		

# Auto-feed

Issues	Troubleshooting	Solution
Consistent feeding cause overflow of resin	Red light does not go off when resin reaches both needles	The resin cannot be used for auto-feed unit
	The lowest points of needles is rose	Check whether you completely follow the assembly instructions
		Two needles are distorted. Please contact the tech support.

**\*Please contact the tech support if the troubleshooting above cannot solve your problem.**

# First Print Instructions

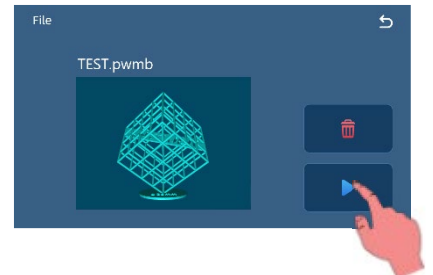
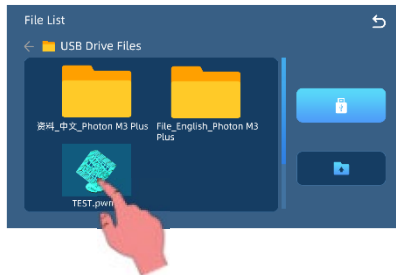
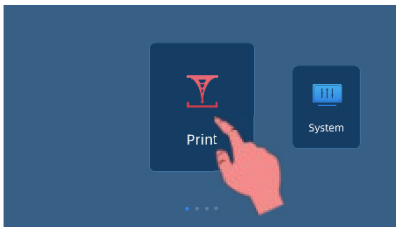
## 1. Print

\*Please check FEP film carefully before and after every printing. If the FEP film is broken, replace it immediately to avoid further damage to machine.

**Wear masks and gloves (to avoid direct skin contact with resin),** and slowly pour the resin into the vat. The resin cannot exceed the vat's maximum scale. Then, put on the cover and the side with sticker needs to face backward. Insert the USB memory into the USB port, print the test file in it. Or connect the machine to Anycubic Cloud and remotely control the printing. The printing time on the screen is for reference only, we make no guarantee that it is the actual printing time.



Do not exceed the maximum scale on the vat



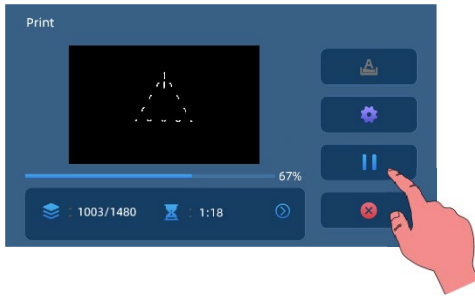
### Notes:

- ① It is recommended that use the USB drive we provided. Otherwise, please use the USB drive whose memory size **not exceed 8G** and ensure that it is formatted to **FAT/FAT 32**.
- ② The print files should be placed at the root directory of USB drive to avoid read error.

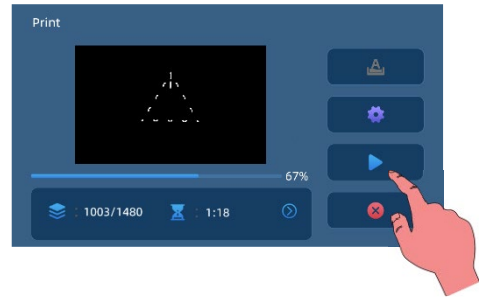
If it is necessary, click "Pause" to pause the printing and wait for platform rising automatically. Then click "Start" to resume printing.



# First Print Instructions



click to pause

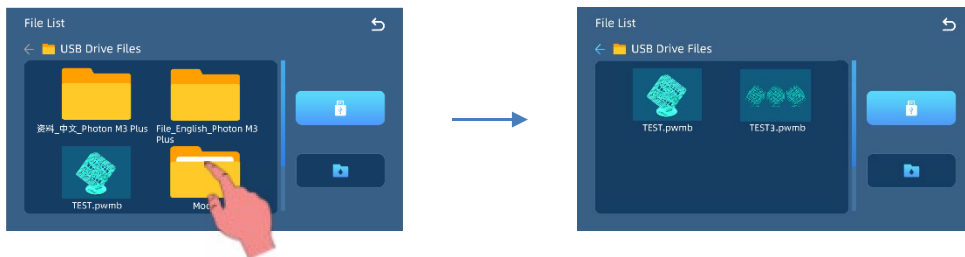


click to start

## 2. File list

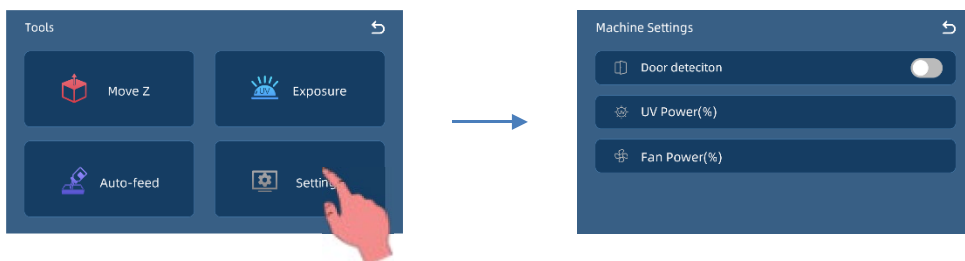
File list is consist of USB driver file list and local file list. The print files sent remotely from Anycubic Cloud will be saved to local file list.

The first two level directory can be checked. For example, insert USB drive and then select USB drive file to open its first level directory. And click the file icon to open the second level directory.



## 3. Machine settings

Click Settings in Tools interface to adjust the machine setting according to the personal requirement.



**Door detection:** The function is disabled by default. If this function is enabled, the printer can detect whether the cover is on or not. Printing will pause when the cover is removed, and will continue when the cover is put back.

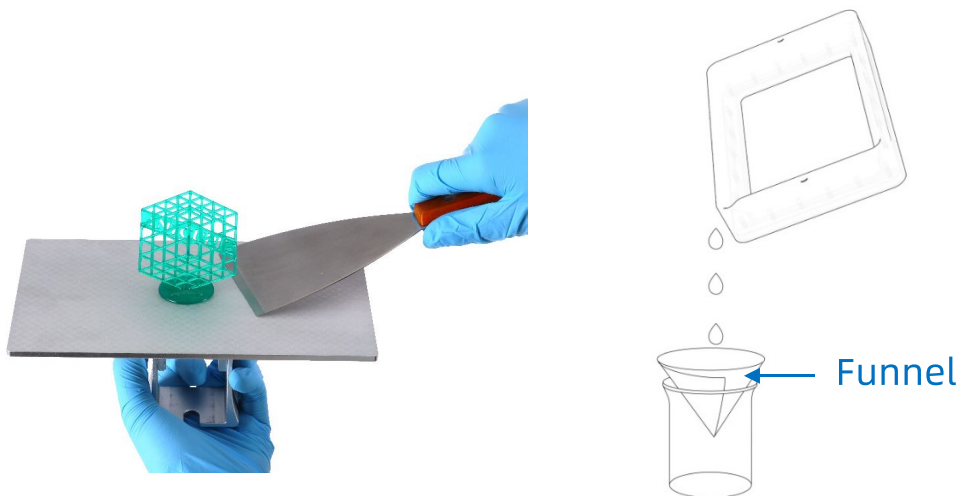
# First Print Instructions

**UV power:** Set UV power to adjust the exposure intensity. The default value is 80%. Its range is 30%-100%.

**Fan power:** Set fan power to adjust the wind force of fan. The default value is 80%. Its range is 30%-100%.

## 4. Handling models and residues

After printing, wait until the resin stop dropping from the platform and then unscrew and remove the platform. The model can be removed by scraper carefully. The removed model should be washed with ethanol 95vol% concentration. The printed model may need post curing to achieve better hardness by direct **sunlight** or UV-curing box.



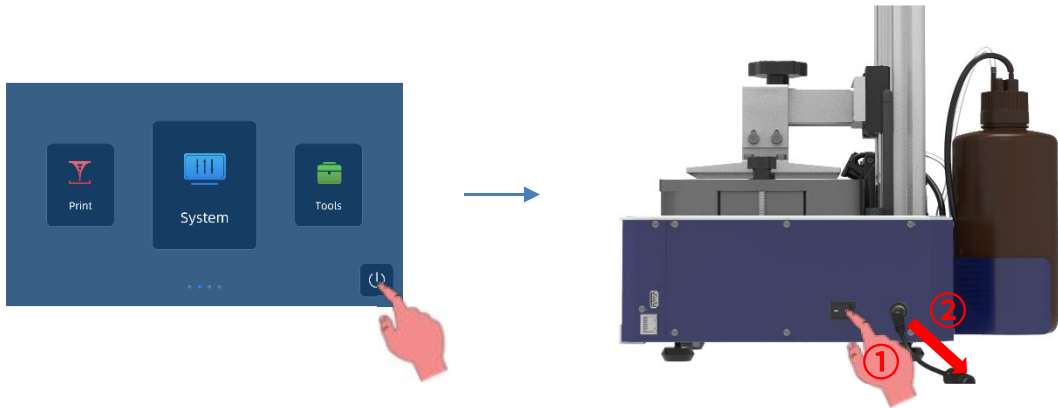
**【IMPORTANT】** Inevitably, in case of incomplete curing or failed prints, there might be some cured resin left in the vat. It is suggested to filter the resin by a funnel and then store the liquid in a sealed container. The residues left on the platform or in the vat can be wiped off with paper towel.

Before each prints, please ensure there is no solid residues in the vat or on the platform, otherwise the FEP film may be crushed and broken during printing.

# First Print Instructions

## 5. Power off

If you want to power off the 3D printer completely after printing, please click the icon in home menu to shut down, then turn off the power switch and disconnect the power cord. Otherwise, it may cause data loss and malfunction.



# Slicing Software Overview

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3D printer reads sliced file and prints models. It is necessary to convert 3D files (stl./obj.) into sliced files for machine to recognize. Software that realize the process is called slicing software, for example, Anycubic Photon Workshop.

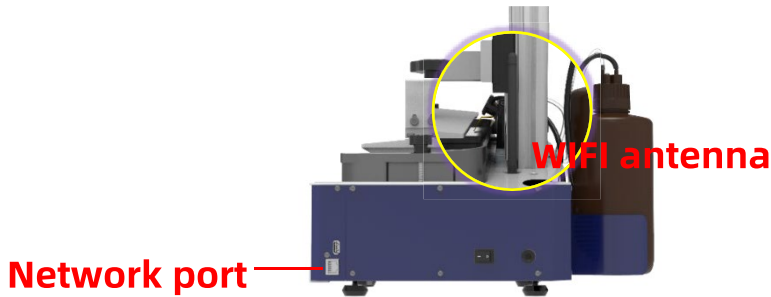
Anycubic Photon Workshop can be used to export sliced file. You should select **Anycubic Photon M3 Plus** as machine type first, then manipulate the model and set the parameters. Lastly, export the sliced file (.pwmb).

**The instruction of Anycubic Photon Workshop has been saved in the USB memory, it is recommended that read it carefully if it is the first time for you to use Anycubic Photon Workshop.**

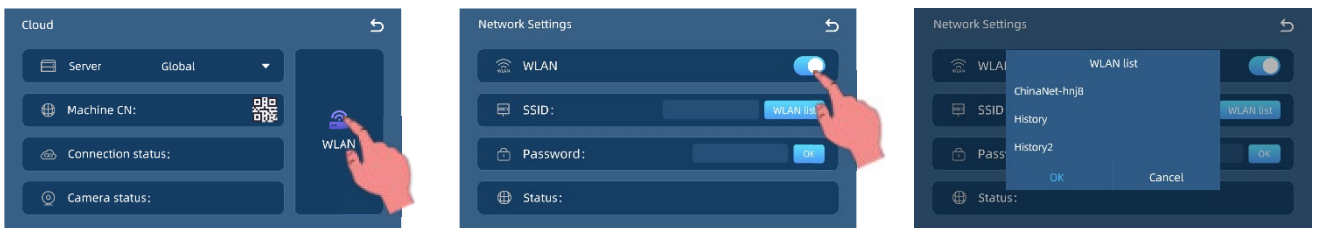
# Anycubic Cloud

1. Connect Anycubic Photon M3 Plus to Anycubic Cloud to upload and manage printing over WIFI and Ethernet.

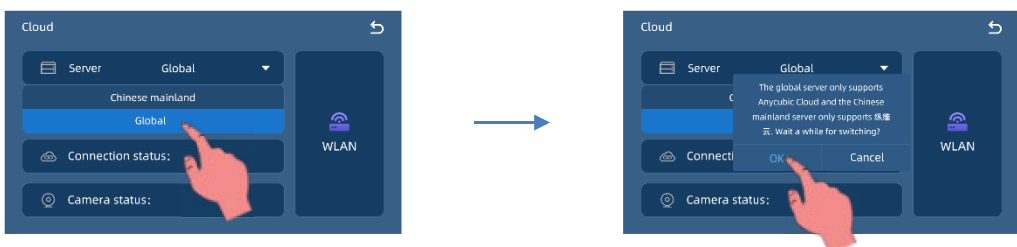
- Connect with Ethernet: Plug one end of the network cable into the network port.



- Connect with WIFI: Install the antenna first. Click “Cloud”→“WLAN”, turn on to search for available network and select one. Then, enter the password and click OK to connect.




2. To download the application, search “Anycubic Cloud” in App Store or Google Play. Sign up and log in Anycubic Cloud. Then, select “Global” server in Cloud interface on the printer.

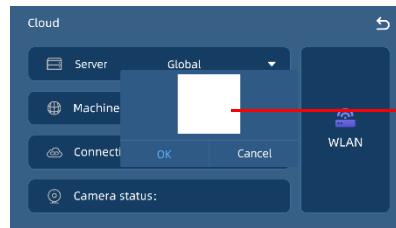


Select the corresponding server

Click OK to switch server

# Anycubic Cloud

3. Open Anycubic Cloud - workbench - 3D printers, click "Add Printers". Open Cloud interface on the printer, check Machine CN and enter it to "Add Printers" interface in Anycubic Cloud; or click "  " icon and then scan QR code with your smart phone. Lastly, confirm to add printers.



QR code is displayed here

4. When printer is added successfully, you can control printing remotely. If necessary, you can install an extra camera unit to monitor printing in real time.

# FAQ and Machine Maintenance

## 1. FAQ

### (1) Model do not stick to platform

- Bottom exposure time is insufficient, increase the exposure time.
- Contact area between the model and platform is small, please add raft.
- Bad leveling.

### (2) Layer separation or splitting

- The machine is not stable during printing.
- FEP film in the vat is not tight enough or it need a change for new one.
- The printing platform or resin vat is not tightened.
- The lift speed is too fast.
- The printing object is hollowed without punching.

### (3) Layer shift

- Add supports.
- Reduce the lift speed.

### (4) Floccules left in resin vat

- The exposure time is too long. Reduce the normal exposure time and bottom exposure time.

## 2. Machine maintenance

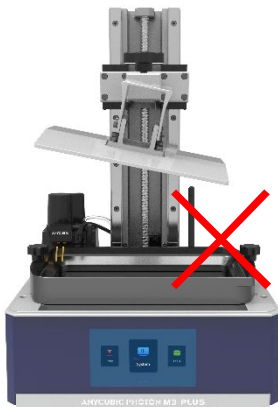


- (1) If Z axis make noisy sound, please apply lubricant to Z lead screw.

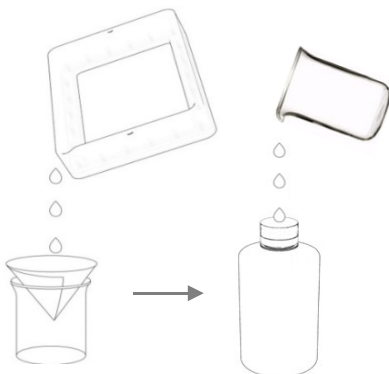
# FAQ and Machine Maintenance



(2) Clean off the residues cured on FEP film when the printing fail: Set full-screen exposure for 20s and then remove the cured resin sheet to protect the film. Do not use sharp objects to scrape off the residues on the FEP film.



(3) Be careful when remove the platform, do not let it fall onto the curing screen.

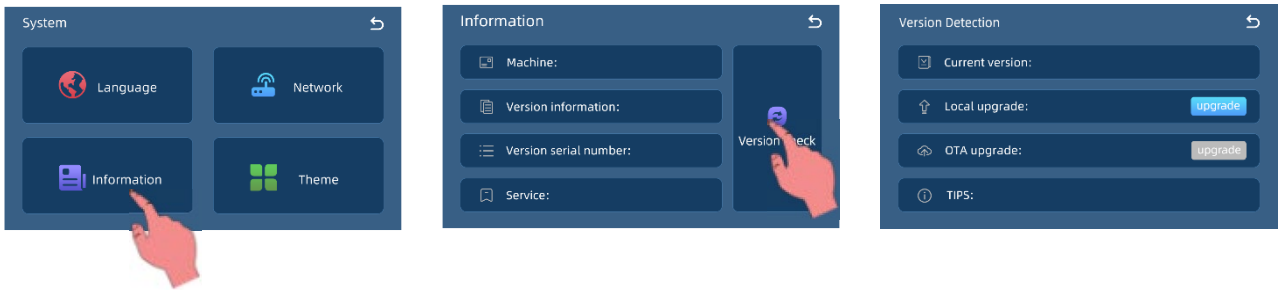


(4) Do not left the resin in the vat for over two days if not using it. Please filter and store the resin properly.



# FAQ and Machine Maintenance

(5) Firmware update: Click “System”→“Information” →“Version check” to check whether the current firmware can be updated. To update firmware, you can copy latest firmware file to USB driver and then click Local upgrade button. When the latest version is detected by OTA and the upgrade button of OTA upgrade highlights, you can click the button to upgrade directly.



(6) After printing, please clean up the platform (**wipe with paper towels or wash with alcohol**), and ensure no residue left before next print (**filter the residue with funnel**).

(7) If the outside of printer is stained with resin, use alcohol to clean.

(8) To switch the resin colors, please clean the original resin vat first.

Thank you for purchasing **ANYCUBIC** products! Under normal usage and service, the products have a warranty period up to one year. Please visit **ANYCUBIC** support center([support.anycubic.com](https://support.anycubic.com)) to report any issue with **ANYCUBIC** products. Our professional after-sale service team would respond within 24 hours and solve the issues.