



# KINGROON KLP1-FDM 3D Printer User Manual

[Home](#) » [KINGROON](#) » KINGROON KLP1-FDM 3D Printer User Manual 

## Contents

- [1 KINGROON KLP1-FDM 3D Printer](#)
- [2 Specifications](#)
- [3 DESCRIPTION](#)
- [4 Packing accessories](#)
- [5 Configure network And Leveling](#)
- [6 Leveling](#)
- [7 Print](#)
- [8 install software](#)
- [9 frequently asked question](#)
- [10 matters need attention](#)
- [11 Safe Working Environment](#)
- [12 Daily Maintenance](#)
- [13 CONTACT US](#)
- [14 Documents / Resources](#)
  - [14.1 References](#)
- [15 Related Posts](#)

***KINGROON***

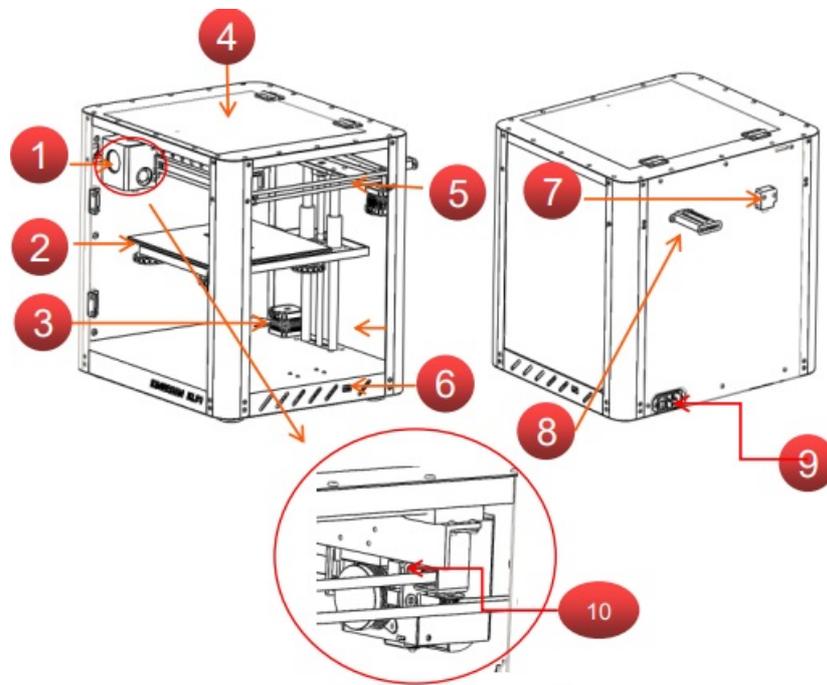
**KINGROON KLP1-FDM 3D Printer**



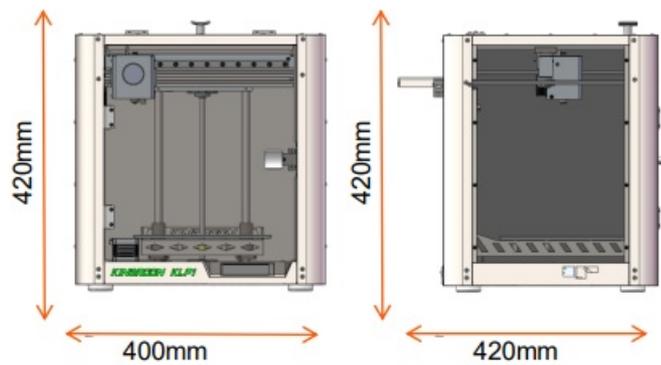
## Specifications

- **Model:** KLP1
- **Forming Technology:** FDM melt deposition
- **Nozzle Diameter:** 0.4mm
- **Material of nozzle:** Hard steel
- **Printing accuracy:** 0.05-0.3mm
- **Filament diameter:** 1.75mm
- **Support filament:** PLA/WOOD/TPU
- **Maximum nozzle temperature:** 200°C
- **Maximum temperature of hotbed:** 100°C
- **Maximum movement speed:** 500mm/s
- **Maximum printing speed:** 350mm/s
- **Recommended printing speed:** 200mm-350mm/s
- **Printing method:** Web/USB drive
- **File format:** STL/Obj/Gcode
- **System requirements:** Win7-10/Mac/Linux
- **Slicing software:** Cura/Slice/Host...
- **Firmware:** Klipper
- **Power supply voltage:** 110V-220V
- **Power:** 300W, 24V12.5A300W
- **Filament Exhaustion sensor**
- **Automatic leveling**
- **Touch screen**
- **Drive free USB camera**
- **Product weight:** ~14kg
- **Product size:** Print Size – 400\*420\*420mm, 210\*210\*210mm

## DESCRIPTION



1 Extruder	6 110V/220V Switching switch
2 Hot bed	7 Filament exhaustion sensor
3 Z-axis motor	8 Filament holder
4 PMMA	9 Power switch/socket
5 belt	10 BELT TENSIONER



Model	KLP1	system requirements	Win7-10/Mac/Linux
Forming Technology	FDM melt deposition	Slicing software	Cura/Slice/Host...
Nozzle Diameter	0.4mm	Building board	Flexible steel plate
Material of nozzle	Hard steel	firmware	Klipper
Printing accuracy	0.05-0.3mm	power	300W
Filament diameter	1.75mm	supply voltage	110V-220V
Support filament	PLAWOOD/TPU	POWER	24V12.5A300W
Maximum nozzle temperature	≤200 C	Filament exhaustion sensor	support
Maximum temperature of hot bed	≤100 C	Automatic leveling	support
Maximum movement speed	≤500mm/s	Touch screen	support (TF35/Mini12864)
Maximum printing speed	≤350mm/s	Drive free USB camera	support (optional)
Recommended printing speed	200mm-350mm/s	Product weight	~14kg
Printing method	Web/USB drive	Product size	400*420*420mm
file format	STL/Obj/Gcode	Print Size	210*210*210mm

## Packing accessories

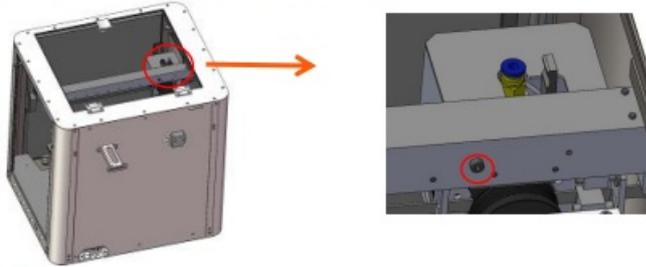


- Assembly Tutorial

•



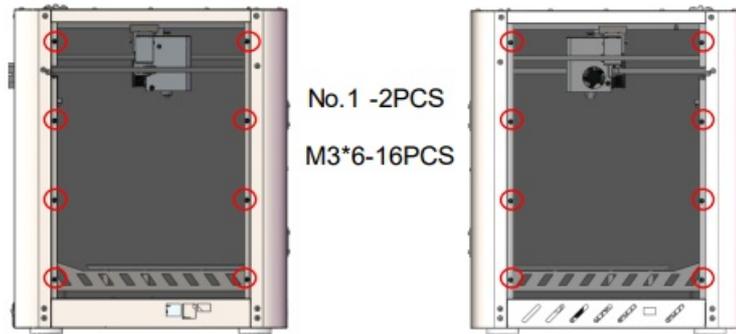
Step 1  
Remove the fixing screws on the Y-axis.



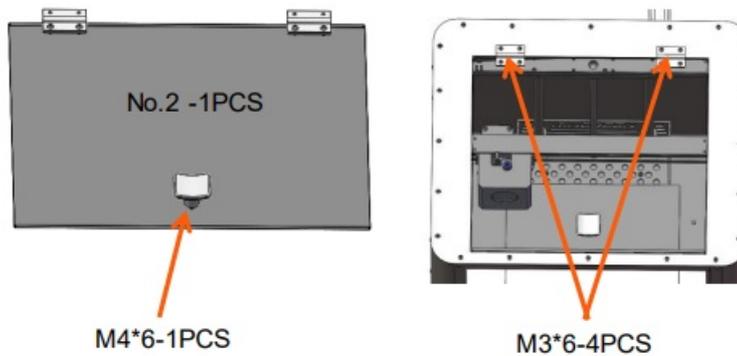
Step 2  
Remove the fixing screws on the X-axis.



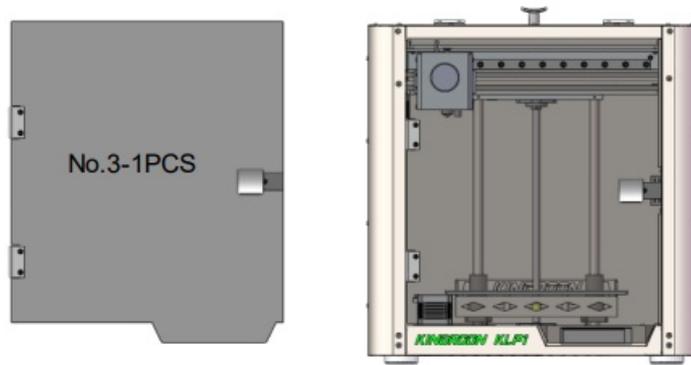
Step 3  
Remove the fixing screw on the Z-axis.



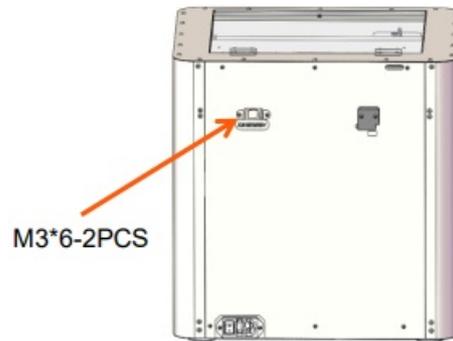
Tear off the protective film on board 1 and use 16 M3 \* 6 screws to secure the two boards on the left and right sides of the machine.



- Tear off the protective film on board 2 and use one M4 \* 6 screw to secure the handle to board 2. Use 4 M3 \* 6 screws to secure the No.2 board to the top of the machine.

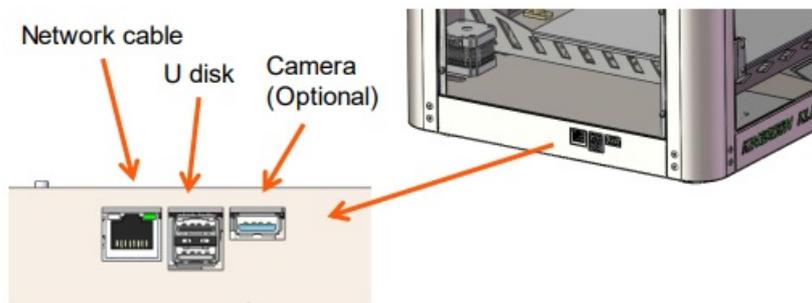


- Tear off the protective film on board 3 and use one M4 \* 6 screw to secure the handle to board 3. Use 4 M3 \* 6 screws to secure the 3rd board to the front of the machine.



## Configure network And Leveling

- **configure network**

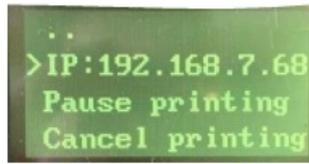


- **Network cable connection:** Insert the network cable and power cord to power on and turn on. (Please note: Before starting the machine, please confirm the local voltage requirements and switch between 110V/220V)
- **WIFI connection:** Use a USB flash drive to configure WIFI, open the (wpa\_supplicant wlan0. conf) file in the USB flash drive, modify the 2.4GZ WIFI account password, insert the USB flash drive into the machine before starting up, and then power on the USB flash drive. (Note that the distance between the machine and the router cannot exceed 5 meters)It is strongly recommended to use a network cable to connect your printer and router.

```
country=GB
ctrl_interface=DIR=/var/run/wpa_supplicant GROUP=netdev
update_config=1
```

```
network={
    ssid="Your WIFI name"
    psk="Your WIFI password"
    key_mgmt=WPA-PSK
}
```

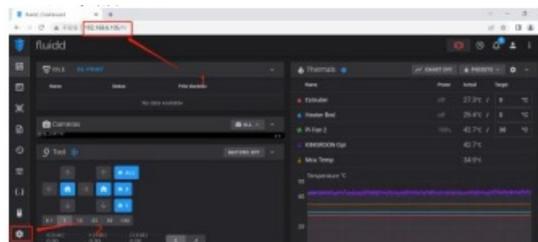
- 12864 display screen: Press the OK button on the knob, move the arrow cursor to IP, and once the network is successfully connected, the complete IP address can be displayed.



3.5 Touch screen: Click on Settings, WIFI, and successfully connect to the network to display the complete IP address.

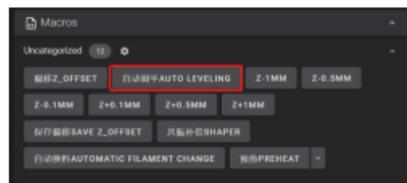


- Open a computer browser on the same router and input the IP address to enter the Fluidd operation interface. The Fluidd operation interface can be modified in the language settings interface. Currently, the webpage supports English



## Leveling

**Web page:** Macros option, click on offset z\_ The offset button will move the printer to the center position of the hot bed, place a piece of A4 paper above the hot bed, adjust it up and down using the Manual Probe, adjust the distance between the nozzle and 0.1mm (there is some resistance when pulling the A4 paper), and click ACCESS to save after the adjustment is completed. Click on automatic leveling for 36 point leveling.



3.5 Touch screen: Click on Configuration, Z calibrate, Start, wait for the extrusion head to move to the middle of the hot bed, select the distance to move, and then click on Lower Nozzle to move the nozzle distance. Adjust the distance between the nozzle and 0.1mm (there is some resistance when pulling A4 paper). After the adjustment is completed, click on ACCESS to save.

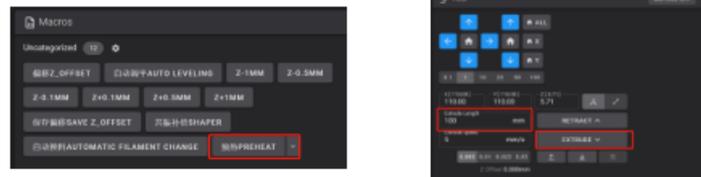


Click on Bed Mesh, Callrate to perform a 36-point leveling, wait for the leveling to complete, and then click Save.

12864 display screen: Click on Level, Z\_ Offset, Probe, and wait for the extrusion head to move to the middle of the hotbed. Use the Probe to adjust up and down, adjust the distance between the nozzle and 0.1mm, and click Save to save after the adjustment is completed. Then click on Auto\_ Perform 36-point automatic leveling at the level.



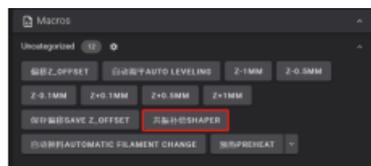
Preheat the extruder and load the filament. On the webpage side: Macros option, click on the preheating function, and wait for the printer to automatically return to zero before loading the high-speed printing filament. Please pass the high-speed printing filament through the filament exhaust sensor and then feed it into the extruder. Tool option, change the Extrude Length to 100mm, and then click EXTRUDE, Wait for the nozzle to have filament extrusion.



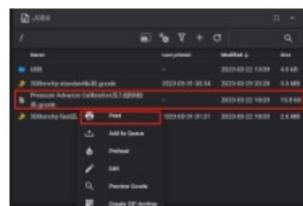
**3.5 Touch screen:** Click on Actions, Extract, Temperature, PLA, wait for the temperature to reach the target temperature, and extrude a 100mm filament.



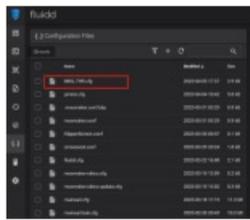
• Macros option, click on the vibration compensation shaper and wait for the vibration frequency data. Note: During the vibration compensation process, the printer will generate vibration noise in the vibration compensation shaper.



Step 7 Jobs option, print Pressure Advance Calibration, wait for pressure advance calibration After printing, observe the most complete line, and the value on the right is the pressure advance number.



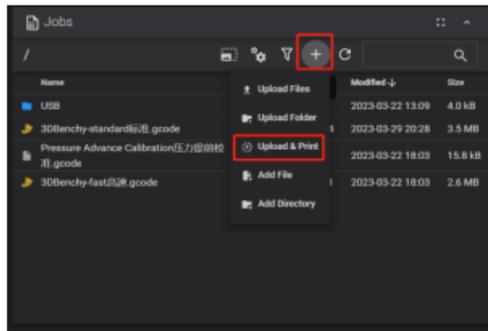
Step 8 Open MKS in the configuration file\_ THR.cfg, modify the pressure in line 45\_ Advantage Advance the pressure data, then save and restart it in the upper right corner. It is recommended to perform the following steps every time the consumables are replaced a pressure pre-calibration once.



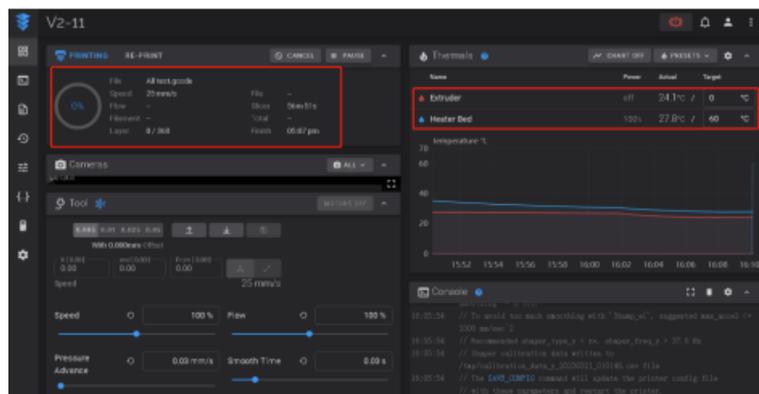
## Print

- Jobs option, click+to upload and print the file.

•



Wait for the hot bed and nozzle to heat up to the specified temperature before printing begins.



## install software

- Find the cura slicing software on the USB drive and install it according to the instructions as follows

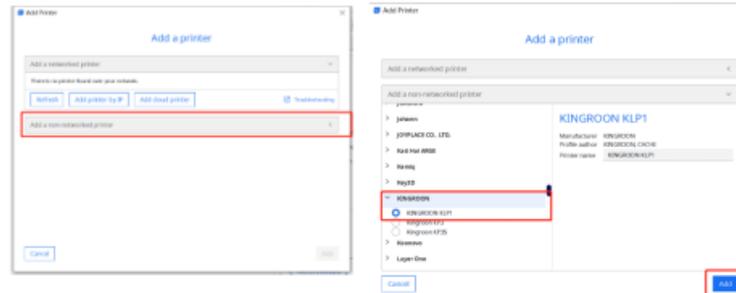


Import the slicing configuration file from the USB drive into Cura

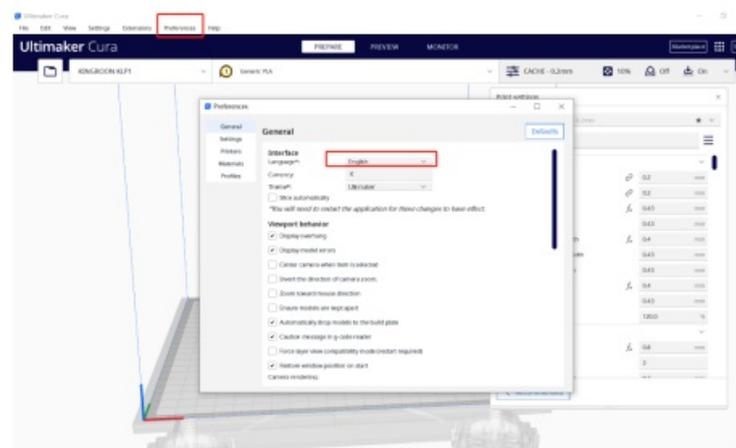
1. Place the "KIINGROON\_KLP1" folder in the "share\cura\resources\quality" directory under the cura5.1 installation path.
2. Place the "KIINGROON\_KLP1.def.json" file in the "share\cura\resources\definitions" directory in the

installation path.

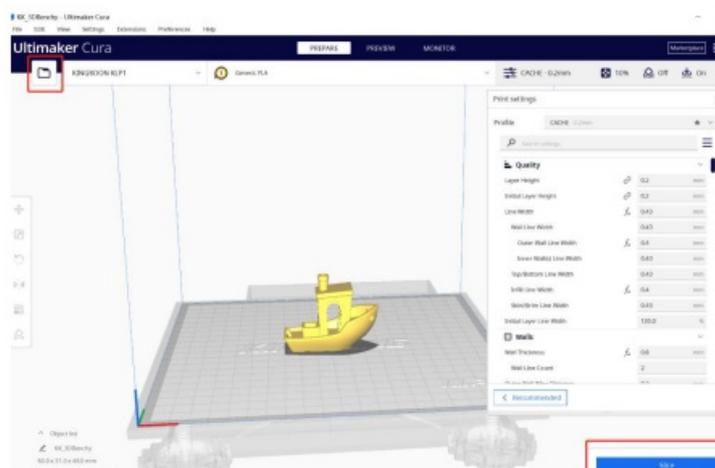
3. Place the “KIINGROON\_KLP1\_extruder\_0. def. json” file in the “share\cura\resources\extruders” directory in the installation path.
4. Place the “KIINGROON\_KLP1. stl” file in the “share\cura\resources\meshes” directory of the installation path.
5. Close all open CURA software and add KLP1 after reopening.
6. Open cura, select a printer that is not connected to the network, and select KLP1 from KINGROON.If the model is not available, please check if the previous step is correct.



Select the language you need and restart Cura



Load the model and start slicing.



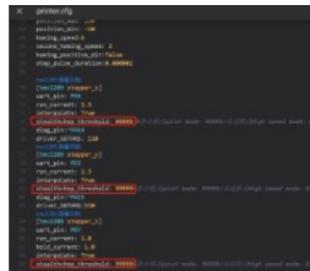
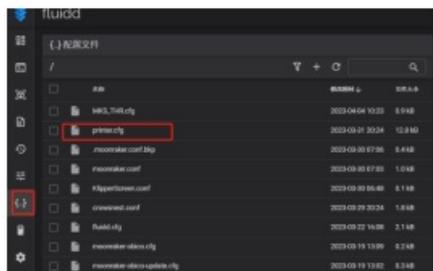
Kingroon has configured all parameters, You can directly save the Gcode to a USB drive for printing, Alternatively, you can directly upload Gcode for printing on the webpage. If you have any questions, please contact KINGROON customer service. We will solve the problem for you as soon as possible, You can also join Facebook discussion groups.

## frequently asked question

1. Do not operate the motherboard and adapter board while powered on.
2. Nonprofessional players are not allowed to change the configuration file at will.
3. After the machine is powered off, it cannot be turned on for 2 minutes.

Because Klipper runs on a Linux system, the KLP1 motherboard is designed with a capacitor that stores power. The capacitor provides temporary power support during a power outage, achieving a soft shutdown of the Linux system and saving data, effectively extending the system's lifespan. Therefore, it cannot be powered on immediately after a power outage. It is necessary to wait for the capacitor's power consumption to complete before powering on. This process takes approximately 1-2 minutes.

4. When the filament exhaust sensor detects that the filament is used up, it will automatically trigger the automatic exit filament function. Do not power off or operate the machine when the automatic exit filament function is running. This process takes 10 minutes. When the target temperature of the extruder is 0, the remaining filament can be pulled out. If there is resistance, please apply a little force to quickly pull out. The automatic exit filament function using the Macros option also
5. For better printing results, please use Kingroon high-speed printing filaments or third-party high-speed printing filaments. Using third-party ordinary printing filaments may cause other problems require the above process.
6. The default factory setting for the drive is non-high-speed mode. If the printing speed is above 300mm/s, please turn on high-speed mode. Stealthchop\_ Threshold: 99999 changed to Stealthchop\_ Threshold: 0 to enable high-speed mode.



## matters need attention

**Note:** Each 3D printer has been tested before leaving the factory. If there is a little filament remaining in the nozzle or a slight scratch on the printing platform, it is normal and it will not affect the performance.

## Safe Working Environment

The KINGROON 3D Printer should be equipped with an original transformer or power supply. Otherwise, the machine could be damaged or even cause a fire. Always place the printer on a stable base where it cannot fall over. Please ensure the printer is far away from flammable gas, liquid, and dust while it is being operated. (The high temperature generated by the operation of the printer may react with the dust, liquid or flammable gases in the air, which may cause a fire.) The ambient temperature recommended for using the printer is 10°C-30°C, and the humidity is 20%-70%. Using the print outside these ranges may cause poor printing results. Please never expose the printer to moisture or heat. Never use the printer during an electrical storm. The printer is for indoor use only. If you are not using the printer for a long time, please turn off the printer and unplug the power cord.

## Safety Manual

1. When the printer is working, DO NOT TOUCH the heat-generating parts, NOT even with gloves, as the extreme

heat can melt the gloves causing severe burns. WARNING: THE NOZZLE TIP CAN HEAT TO 260C AND THE PRINT BED CAN HEAT TO 100°C.

2. DO NOT TOUCH any working parts while the printer is printing. The nozzle tip and other mechanical parts will run at high speed. Contact with any running parts may cause damage and injury.
3. When printing with PLA or Wood materials ensure the printer is in a well-ventilated environment, due to the fumes released by the plastic materials.
4. NEVER allow children or untrained people to operate the printer.

## Daily Maintenance

Please do dust removal maintenance and lubricate the printer every month. If you are not using the printer for a long time, please remove the filament and keep the storage environment dry, dust-free. The printer should place in a temperature-stable environment. The sudden drop in temperature can affect the printing quality. When the print nozzle is squeezing, please make sure there is enough space between the nozzle and the platform; otherwise the nozzle will be blocked.

1. Clean/Maintain the print platform, replace the tape if used.
2. Preheat the nozzle and extrude a small amount of filament.
3. While the nozzle is still hot, use a steel brush on it to clean any excess filament.
4. Preheat the print bed and level it.

## CONTACT US

### QR SCAN



Facebook QR Code

- **Address:** Shenzhen Qi Pang Technology Co., Ltd
- **Email:** Aliexpress:[susie@kingroon.com](mailto:susie@kingroon.com)
- **Alibaba:** [joan@kingroon.com](mailto:joan@kingroon.com)
- **Amazon:** [jerry@kingroon.com](mailto:jerry@kingroon.com)
- A402, 4th Floor, Building A.B, Donghaiwang Industrial Zone,
- No.369 Bulong Road, Ma'antang Community,
- Bantian Street, Longgang District, Shenzhen
- Facebook/YouTube
- KingRoon 3D Printer

Shenzhen KINGROON Technology Co., Ltd.

---

## Documents / Resources



[KINGROON KLP1-FDM 3D Printer](#) [pdf] User Manual  
KLP1-FDM, KLP1-FDM 3D Printer, 3D Printer, Printer

## References

- [User Manual](#)

[Manuals+](#), [Privacy Policy](#)