
In-Line 3D Filament Dryer

24V version User Manual

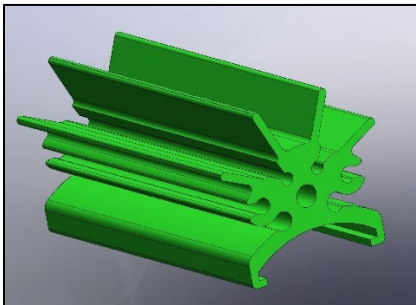
Introduction

This filament dryer is designed to work with FDM/FFF 3D printers. It is an in-line device; it will remove moisture from the filament in real time, before the consumable reaches and passes through the extruder. The device can feed moisture free 3D print filament to one or two extruders simultaneously. It is compatible with Ø1.75mm and Ø2.85mm filament.

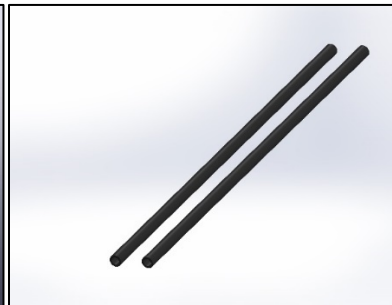
General safety information

- Before using this product read and understand the safety measures.
- Use the product for intended purpose only.
- Use the product with caution. The heating element of the product can generate high temperatures ($\geq 100^{\circ}\text{C}$). Do not dismantle the product. Allow 15 minutes for product to cool down before performing any maintenance or setup modifications.
- Follow standard electrical safety procedures.
- Install the product near (or on to) the 3D printer in a secure manner. When the device is connected to the 3D printer through filament, the extruder's gear may move or misalign the device.
- The product removes moisture from third party materials. Please follow the safety procedures of the manufacturers of such materials.

Main Components



Heating Element



Carbon fiber tubes



Temperature Controller

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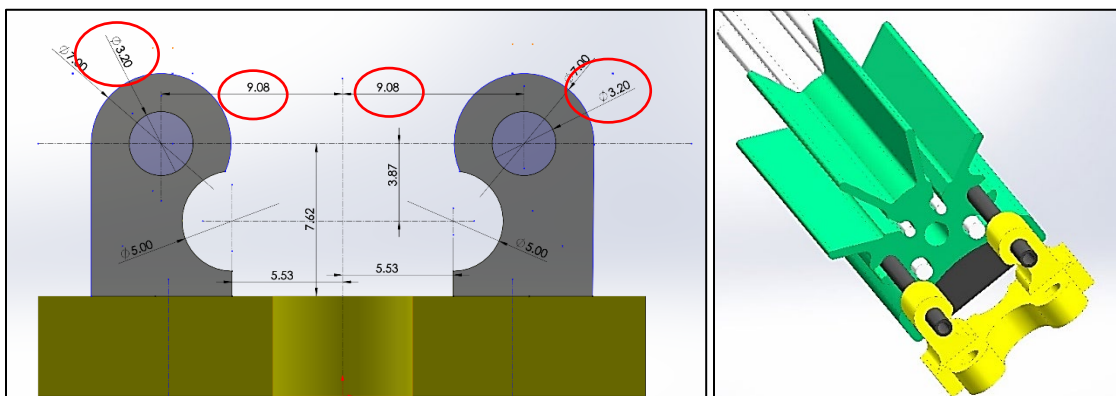
- 24V/12W heating element (color: green)
- 24V electronic temperature controller
- (2x) Ø3mm x 110mm carbon fiber tube

- (1x) generic 3D printed console
 - 2ft 20AWG wire red
 - 2ft 20AWG wire black
 - Quick start guide
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- **Specifications**
 - Power: 24V/12W
 - Current draw: 0.5A
 - Temperature controller range: -50°C to 120°C
 - Max temperature in filament channels: 111°C

This is intended for open frame 3D printers, where access to wiring, filament spool, filament feed, frame, gantry and power supply is relatively easy. The carbon fiber rods are used for attaching the heater to the printer and will prevent heat transmission from the heating element to console's mount points. Use Superglue or Silicone to secure the rods and temperature sensor. Do not use metal or plastic rods. Replacement carbon fiber rods are available.

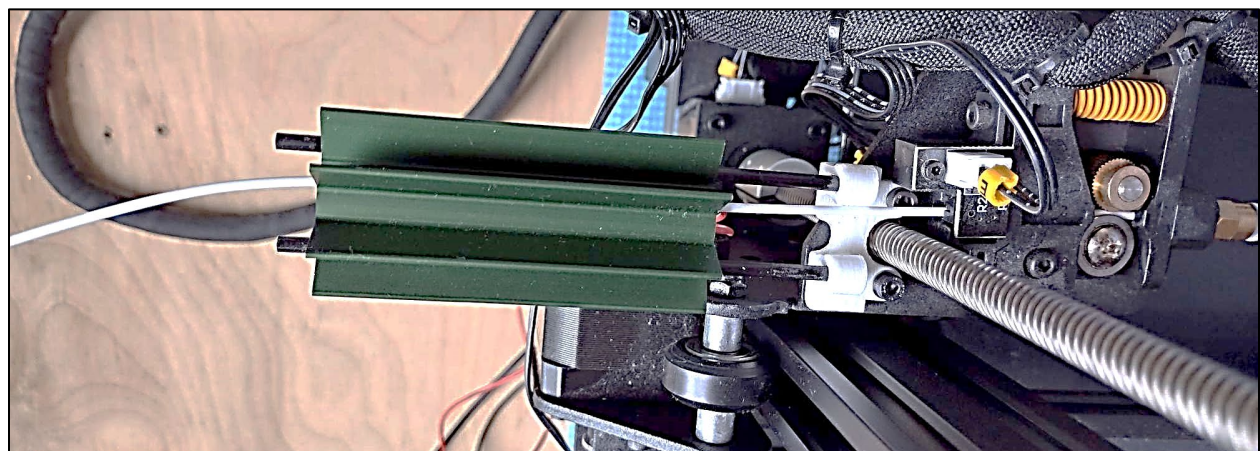
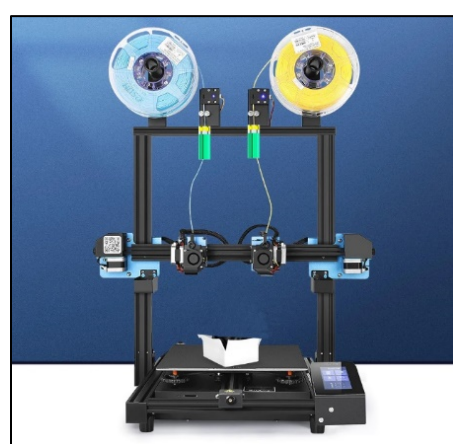
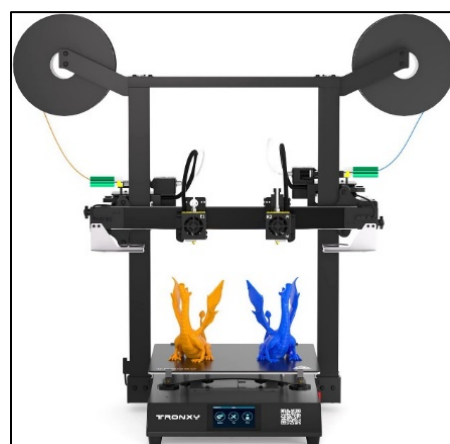
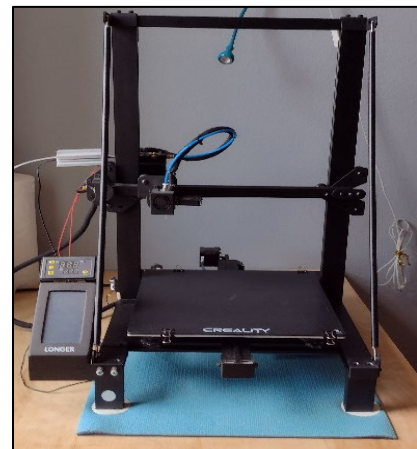
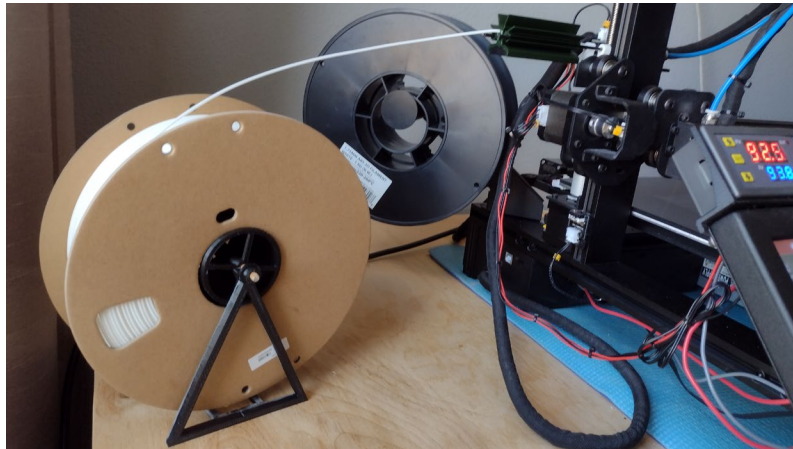
Most 3D printers have a 24V power supply with a good power reserve. The device will draw 0.5A intermittently. Our testing showed no impact upon the printer's performance, if everything else is in order.

You will need to adapt and 3D print the console/bracket to suit your machine. On our website www.jms.com you find the STEP and STL files necessary to get you started. You can get creative and design your custom bracket(s); the only dimensions to observe are the ones circled in red, as they need to match the diameters and spacing between the carbon fiber rods channels in the extruded part. Example: the console shown below (available for download) will fit a LONGER LK5 PRO machine (dimensions in mm).

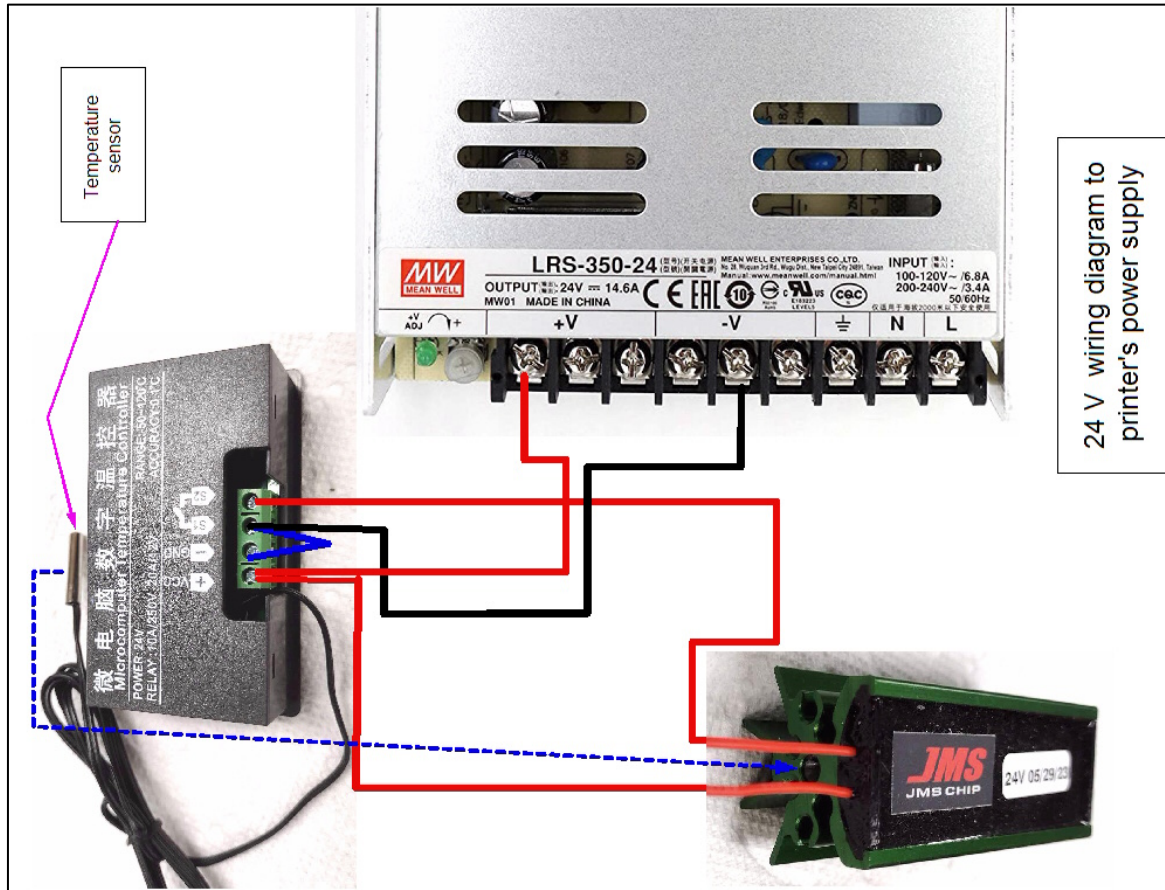


You may also need to change the filament's spool location to accommodate for the new device attached.

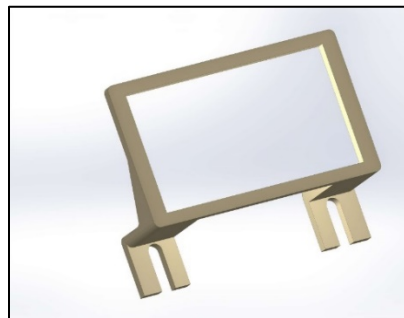
Some examples and suggestions below on the device's installation:



Wiring and connecting the device



You will need to customize and print the temperature controller frame (CAD file available for download on JMS website, example below is for LK5-PRO machine):



Note 1: Should the temperature controller fail, for safety reasons, the device is designed to reach no more than 110 - 115°C in ambient temperature up to 30°C. Therefore, the worst-case scenario

can be a failed print. **Using a power supply with higher voltage may cause the heating element to burn through potting.**

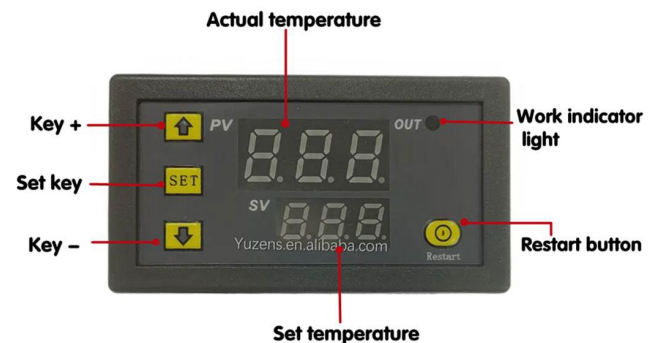
Note 2: Observe the correct polarity for the temperature controller – it has no protection to reversed polarity.

Setting the device's working temperature

The temperature controller comes set for heating at 30°C. Below is a quick start guide. For full controller features, refer to the document “**W3230 manual.pdf**” on JMS website. We recommend reading the controller instructions in full before attempting to customize settings

Parameter settings codes

- P0** Cooling/Heating
- P1** Hysteresis setting 0.1-30°C
- P2** Maximum temperature setting - upper limit 120°C
- P3** Lowest temperature limit -55°C
- P4** temperature correction
- P5** Delay start time (Unit: minutes) 0-10min
- P6** Alarm temperature setting -55°C~120°C
- P7** Data locking function ON/OFF
- P8** Restore factory settings



Press and hold **SET** for 5 seconds to enter the main menu settings. Press +/- to switch between P0 ... P6. Press and hold SET for 10 seconds or the controller will automatically confirm and return without any button action.

P0: Cooling and heating modes:

Press and hold SET for 5 seconds to display P0. Press and hold SET once to set the working mode. Press +/- to switch between [H for heating mode] and [C for cooling mode]. Press and hold SET once to return. Press and hold SET for 10 seconds or the controller will automatically confirm and save the choice.

P1: Hysteresis setting: Press and hold SET for 5 seconds to display P0, press +/- to switch to P1, press SET once to set the return difference, press +/- to set the return difference to 0.1-15, and then press SET once to return. Press and hold SET for 10 seconds or the controller will automatically save the action.

P2: Set safe temperature limit: Used to set a temperature limit; for example, you are printing ABS and you know that the glass transition temperature of your material is about 90 – 95C. Although the controller's upper temperature limit is 120°C, you can limit the maximum working temperature to, in this case, to 90C. This way, the risk of accidentally setting a higher temp is eliminated.

P7 Save settings: To save the settings, set P7 to ON when the temperature is set and the power is on. The last settings will be saved when unit is powered off.

P8: Restore factory settings

This function is used to restore the factory settings. Press and hold the + and - buttons in the shutdown state, and then turn on the controller. All the above parameters are restored to the factory settings. The Restart key acts also as On/Off switch.

How to set the desired temperature: With the controller powered up, press and hold the SET button until the SV (set value) screen starts flashing, then release; using up and down keys, set the desired temperature. The controller will save the set value.

Suggested temperature guide for various 3D print consumables

Filament	Temperature °C	Filament	Temperature °C
ABS	75-90	PLA	40-50
ASA	75-90	PC	130-140
CF-NYLON	90-100	PC-ASA	100-120
NYLON	80-95	PVA	50-60
PETG	60-75	TPU/TPE	40-50

Before starting the first print job, insert a piece of filament into the device, then gradually raise the temperature. Use tables above as starting point. When the material becomes soft or loses its original shape, lower the temperature of the drying device. Remember, the temperature inside the filament channels is typically 3 - 4°C lower than the controller's reading.