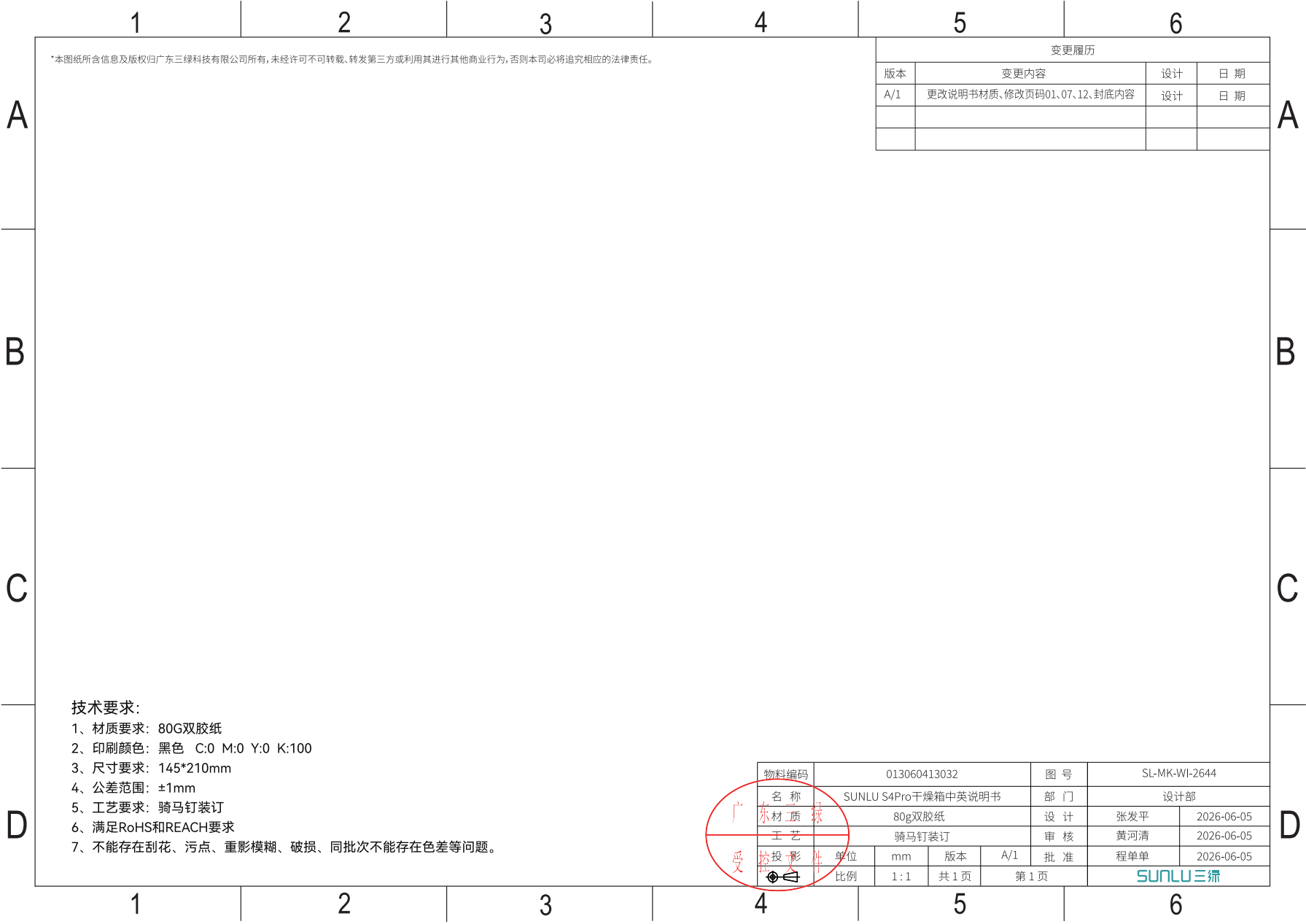




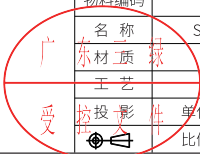
*本图纸所含信息及版权归广东三绿科技有限公司所有，未经许可不可转载、转发第三方或利用其进行其他商业行为，否则本公司必将追究相应的法律责任。

变更履历			
版本	变更内容	设计	日期
A/1	更改说明书材质、修改页码01、07、12、封底内容	设计	日期

技术要求：

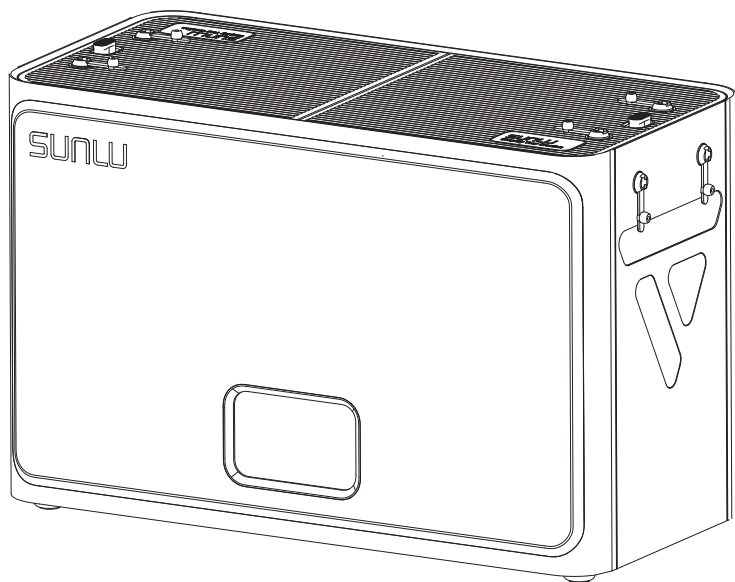
- 1、材质要求：80G双胶纸
- 2、印刷颜色：黑色 C:0 M:0 Y:0 K:100
- 3、尺寸要求：145*210mm
- 4、公差范围：±1mm
- 5、工艺要求：骑马钉装订
- 6、满足RoHS和REACH要求
- 7、不能存在刮花、污点、重影模糊、破损、同批次不能存在色差等问题。

物料编码	013060413032		图号	SL-MK-WI-2644	
名称	SUNLU S4Pro干燥箱中英说明书		部门	设计部	
材质	80g双胶纸		设计	张发平	2026-06-05
工艺	骑马钉装订		审核	黄河清	2026-06-05
投影	单位	mm	版本	A/1	批准
比例	1:1	共1页	第1页		



SUNLU三绿

SUNLU



S4Pro 干燥箱用户手册

FilaDryer S4Pro User Manual

3D Printing-Mate

RoHS FC CE 

IMPORTANT SAFEGUARDS

(MESURES DE SÉCURITÉ IMPORTANTES)

READ THESE INSTRUCTIONS

(Lire ces INSTRUCTIONS)

1. For household use and indoor use only.

1. Pour usage domestique et intérieur seulement.

2. CAUTION: To reduce continued protection against risk of electric shock, connect to properly grounded outlets only.

2. Attention: pour réduire la protection continue contre le risque de choc électrique, branchez uniquement les prises correctement mises à la terre.

3. WARNING: Do not immerse in water.

3. Attention: ne pas immerger dans l' eau.

4. A short power-supply cord is provided to reduce the risks resulting from becoming entangled in or tripping over a longer cord.

4. Un cordon d' alimentation court est fourni pour réduire les risques de s' enchevêtrement ou de trébucher sur un cordon plus long.

5. Extension cords are available and may be used if care is exercised in their use.

5. Des rallonges sont disponibles et peuvent être utilisées avec soin.

6. If an extension cord is used:

6. Si une rallonge est utilisée:

a) The marked electrical rating of the extension cord should be at least as great as the electrical rating of the appliance;

a) la puissance électrique marquée de la rallonge doit être au moins aussi grande que la puissance électrique de l' appareil;

b) The extension cord should be a grounding-type 3-wire cord; and

b) la rallonge doit être un cordon à 3 fils de terre; Et en plus

c) The longer cord should be arranged so that it will not drape over the counter top or tabletop where it can be tripped over, snagged, or pulled on unintentionally (especially by children).

c) le cordon plus long doit être disposé de sorte qu' il ne sera pas drapé sur le comptoir ou la table où il peut être trébuché, accroché, ou tiré sur involontairement (en particulier par des enfants).

7.Keep out of reach of children.

7.Tenir hors de la portée des enfants.

8.Ensure electrical safety during operation. Do not use near water sources such as bathrooms, bathtubs, or sinks.

8.Assurez la sécurité électrique pendant le fonctionnement. Ne pas utiliser à proximité de sources d'eau comme les salles de bains, les baignoires ou les éviers.

9.Use original power cable or safety-certified alternatives.

9.Utilisez un câble d'alimentation d'origine ou des alternatives certifiées de sécurité.

10.Turn off power when not in use.

10.Tenir hors tension lorsqu'il n'est pas utilisé.

11.Do not place the product on temperature-sensitive items during operation.

11.Ne placez pas le produit sur des articles sensibles à la température pendant le fonctionnement.

12.Avoid touching the heater or fan during operation to prevent burns. Keep drying box lid closed when drying filament to retain heat.

12.Évitez de toucher l'appareil de chauffage ou le ventilateur pendant le fonctionnement pour éviter les brûlures. Garder le couvercle de la boîte de séchage fermé lors du séchage du filament pour retenir la chaleur.

13.Do not block internal air inlets or outlets to prevent heat accumulation.

13.Ne bloquez pas les entrées ou les sorties d'air internes pour empêcher l'accumulation de chaleur.

14.If malfunction occurs, turn off power, unplug device, and contact support team.

14.En cas de dysfonctionnement, éteignez l'alimentation, débranchez l'appareil et contactez l'équipe d'assistance.

SAVE THESE INSTRUCTIONS

Sauvegarder ces INSTRUCTIONS

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1

装箱清单 Package Contents

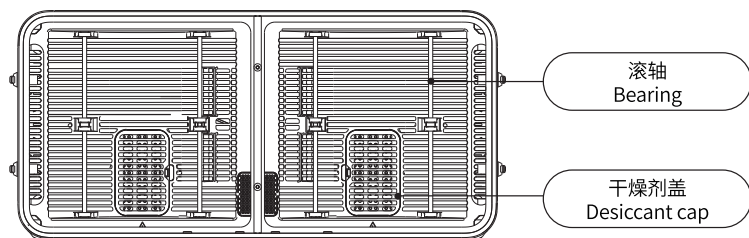
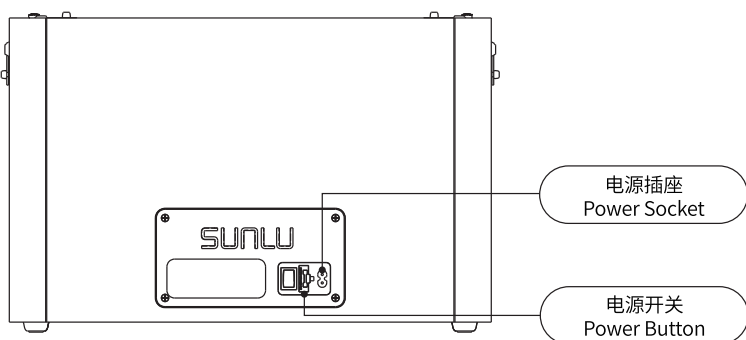
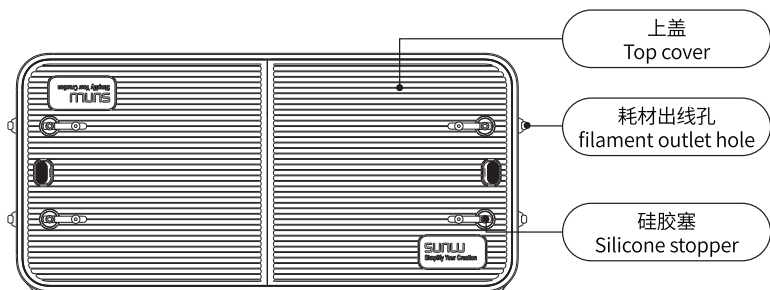
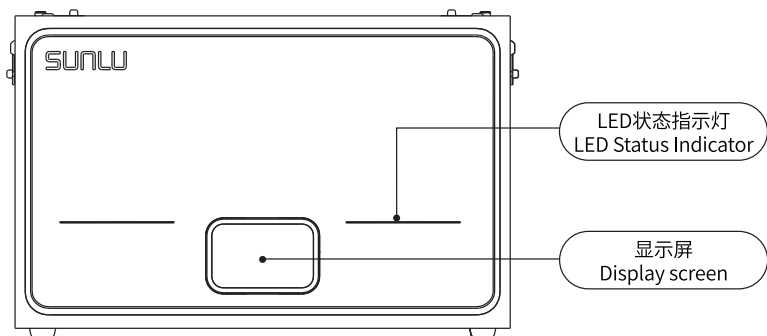
❶ S4Pro干燥箱×1	FilaDryer S4Pro × 1	❸ 特氟龙管 1m×2	PTFE Tube 1m× 2
❷ 电源线×1	Power Cable × 1	❹ 说明书×1	User Manual × 1

2

性能参数 Technical Specifications

产品名称 Product Name	3D打印伴侣/3D printing-mate
产品型号 Model	FilaDryer S4Pro
产品尺寸 Product Dimensions	458mm × 218mm × 310mm(LWH)
内部尺寸 Internal Dimensions	220mm × 210mm × 211mm(LWH)x2
产品净重 Net Weight	4.7KG
工作环境温度/湿度 Operating Environment	环境温度10°C-35°C , 相对湿度≤95% Temperature: 10°C-35°C, Relative Humidity: ≤95%
温度设置范围 Working Temperature Range	45°C-85°C
湿度显示范围 Humidity Display Range	10%-90%
时间设定范围 Timer Range	1-99H
电源输入规格 (请核对您购买的产品电压规格与当地电压一致再使用) Power Input (Please verify local voltage compatibility)	AC 110V 60Hz or AC 220V 50Hz
最大工作电流 Maximum Operating Current	2.2A@230V 4.2A@120V
额定功率 Rated Power	380W
待机功率 Standby Power	<1W
灯丝出线兼容孔径 Compatible Filament Diameters	φ1.75mm/φ2.85mm

3 部件说明 Component Description



耗材干燥温度/时间推荐表

Filament Drying Temperature/Time Recommendations

材质 Material	PLA/PLA+	WOOD	PETG	TPU	PVA	PVB	ASA	PA/PC
干燥温度 Drying temperature	50-55℃				65-70℃			80-85℃
烘干时间 Drying time	4-6h				4-6h			8-24h

- 1、为保证干燥效果，烘干过程中请勿随意打开干燥箱上盖。
To ensure optimal drying results, do not open the drying chamber cover during the drying process.
- 2、当环境温度 $\leq 10^{\circ}\text{C}$ 时，出现升温慢或者腔内实际温度略低于显示温度，属于正常现象。
When the ambient temperature is below 10°C , slow heating or the actual temperature inside the chamber being slightly lower than the displayed temperature is normal.
- 3、设置工作温度为 70°C 时，应确认耗材种类与线盘的耐温应 $\geq 70^{\circ}\text{C}$ ，避免线盘变形或耗材热熔。
When setting the working temperature to 70°C , ensure that the material type and spool have a temperature resistance of $\geq 70^{\circ}\text{C}$ to prevent spool deformation or filament melting
- 4、设置工作温度为 85°C 时，应确认耗材种类与线盘的耐温应 $\geq 85^{\circ}\text{C}$ ，避免线盘变形或耗材热熔。
When setting the working temperature to 85°C , ensure that the material type and spool have a temperature resistance of $\geq 85^{\circ}\text{C}$ to prevent spool deformation or filament melting.
- 5、耗材干燥过程中建议打开耗材出线孔的硅胶塞，让内部水分排出，干燥结束后建议塞紧硅胶塞，避免外部水分进入。
During the drying process, it is recommended to open the silicone plug on the filament output port to allow internal moisture to escape. After drying, securely plug the silicone plug to prevent external moisture from entering.

模型退火温度/时间推荐表 (注意耗材禁止退火)

Recommended Annealing Temperature/Time for Models (Note: Do NOT anneal consumables)

材质 Material	PC	PA	PA
退火温度 Annealing temperature	85°C	80°C	85°C
退火时间 Annealing Time	4-5h	6-7h	4-5h

1、在使用退火功能(MO2)时,本说明书虽提供了部分耗材的退火温度与时间参考,但因不同厂家耗材特性不同,建议使用耗材厂家推荐的温度与时间进行退火,并根据模型的大小进一步调整退火时间。

When using the annealing function (MO2), although this manual provides reference temperatures and times for some materials, due to variations between manufacturers, it is recommended to use the temperature and time recommended by the filament manufacturer for annealing. Adjust the annealing time further based on the size of the model.

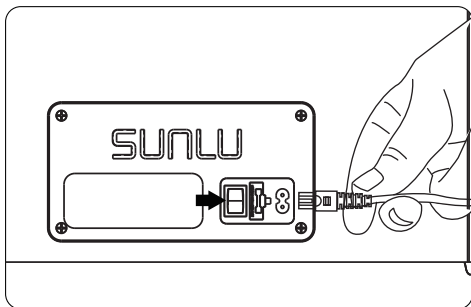
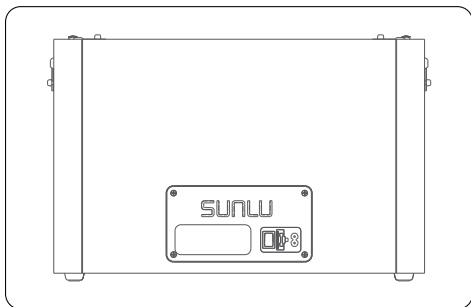
2、退火步骤:先让干燥箱按设定温度值升温30mins,再将需退火的模型放入干燥箱内,设置好退火时间,倒计时结束后不要立即取出模型,等待干燥箱内温度自然下降,约30mins后取出模型,完成退火。

Annealing Procedure: First, let the dryer heat up to the set temperature for 30 minutes. Then place the model to be annealed inside the dryer. Set the annealing time. Once the countdown ends, do not remove the model immediately. Allow the temperature inside the dryer to decrease naturally. Remove the model after approximately 30 minutes to complete the annealing process.

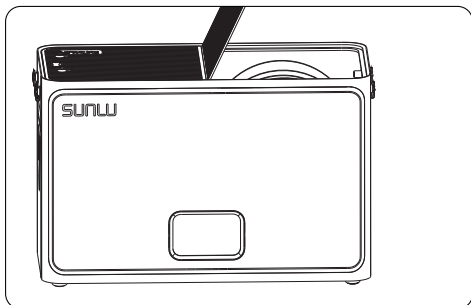
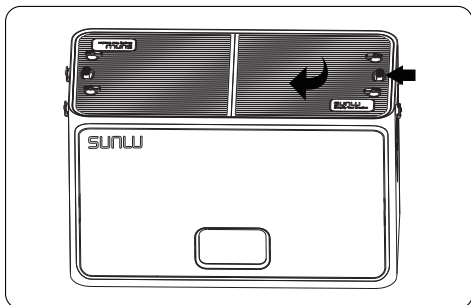
5 操作步骤 Operating Instructions

5.1 安装步骤说明: Installation Steps

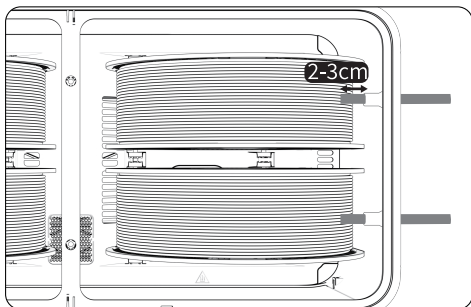
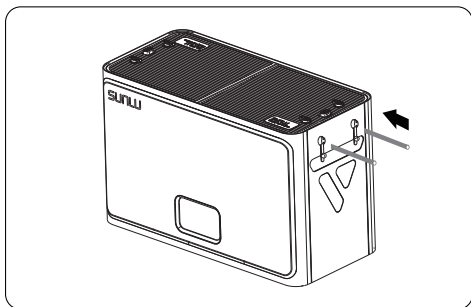
01/ 接入电源, 拨动开关 Connect the power supply and press the switch



02/ 向后拨动开关, 然后提拉上盖, 将耗材放入干燥箱
Open the top cover and put the filament into drying box.



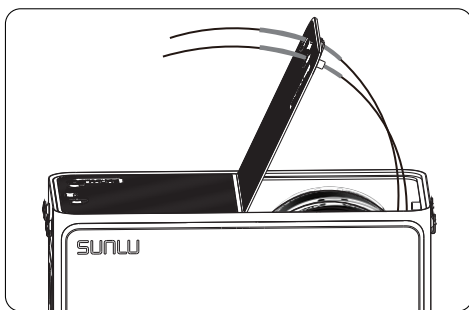
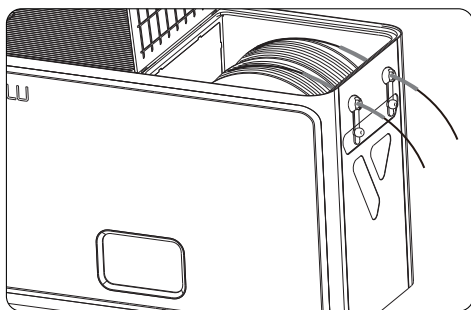
03/ 安装特氟龙管。按图示, 将特氟龙管插入出线孔。
Insert the Teflon tube into the filament outlet according to the picture.



5 操作步骤 Operating Instructions

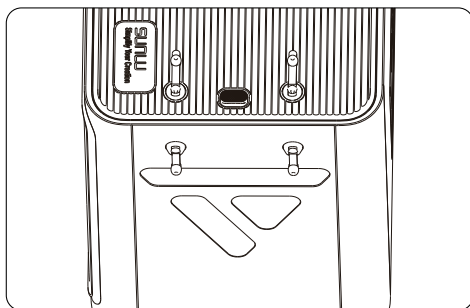
04/ 根据出线位置, 选择适合的出线方式

Based on the position of the exit, select the appropriate exit method.



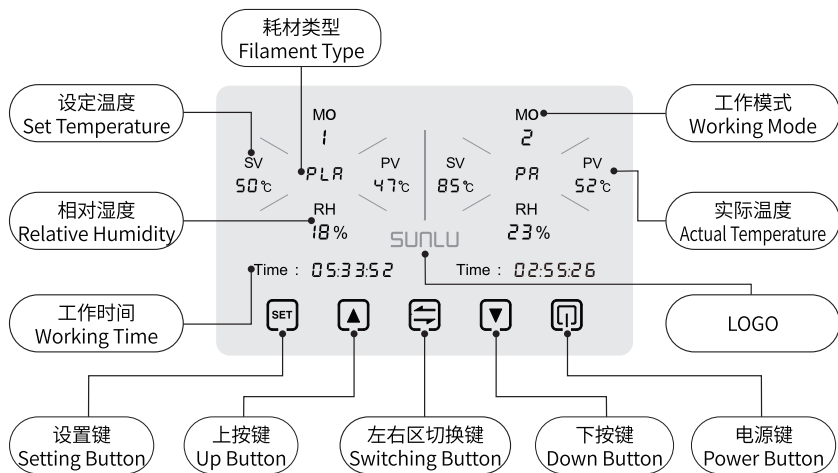
为达到最佳烘干效果, 建议在烘干过程中打开出线孔处的硅胶塞

To achieve the best drying effect, it is recommended to remove the silica gel plug at the outlet hole during the drying process.



5 操作步骤 Operating Instructions

5.2 显示屏内容说明: Display Screen Description



5.3 操作步骤说明: Operating Steps

【开机】Turn On

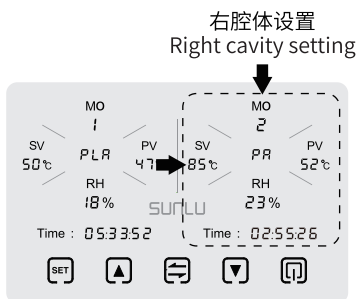
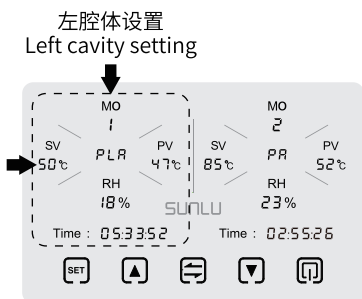
单击电源键  开机, 背光屏幕亮起, 左右双腔均开始按默认参数进行加热;

Click the power button  to turn on the device. The backlight screen lights up. Both the left and right chambers start heating up according to the default parameters.

【设置不同腔体】Set different cavities

单击切换键 , 左侧SV下的数字闪烁时, 表示进入到左腔体设置状态; 再次单击切换  键, 进入右腔体设置状态。

Click the switch button . When the numbers under the SV on the left side flash, it indicates that you have entered the left cavity setting state; click the switch button  again to enter the right cavity setting state.



5 操作步骤 Operating Instructions

【设定加热温度】Set Heating Temperature

当SV下方数字闪烁时,单击上下键  ,可设定加热温度。(45°C-85°C)

When the number below the SV flashes, click the up or down keys   to set the heating temperature.

【设定工作模式】Set Working Mode

点击设置键 , MO下方数字闪烁时,单击上下键   可切换工作模式。

Click the settings button . When the number below MO flashes, click the up or down keys   to switch the working mode.

MO1:常规烘干模式,当时间倒计时归零时,对应的腔体会停止加热,风扇会在3min后停止,TIME显示OFF

MO1: Normal drying mode. When the countdown timer reaches zero, the corresponding chamber will stop heating, and the fan will stop in 3 minutes. The "TIME" indicator will show "OFF".

MO2:退火模式,耗材种类仅显示部分工程耗材,当时间倒计时归零时,对应的腔体停止加热TIME显示OFF

MO2: Annealing mode. Only some engineering consumables are displayed. When the countdown timer reaches zero, the corresponding chamber stops heating. The "TIME" indicator shows "OFF".

MO3:湿度控制模式,当时间倒计时归零时,TIME显示CLOSED,并将实时监测腔内湿度,通过连续点击设置键  至rH闪烁时,即可设定湿度上限值(30%-50%),当腔内湿度值到达设定值时,机器自启,当湿度下降至25%,设备再次停止加热

MO3: Humidity control mode. When the countdown timer reaches zero, the "TIME" display shows "CLOSED", and it will continuously monitor the humidity inside the chamber. By continuously clicking the setting key  until the "rH" indicator flashes, you can set the upper limit of humidity (30%-50%). When the humidity value inside the chamber reaches the set value, the machine will start automatically. When the humidity drops to 25%, the equipment will stop heating again.

5 操作步骤 Operating Instructions

【设定耗材种类】Set Consumables Types

点击设置键 ，直到PLA闪烁时，单击上下键   可选择对应耗材：PLA、PETG、TPU、ABS、PC、PA、PA6、PA12。干燥箱将按照推荐的烘干温度与干燥时间开始工作

Continuously press the settings button . When PLA is flashing, click the up or down keys   to select the corresponding consumable: PLA, PETG, TPU, ABS, PC, PA, PA6, PA12. The drying oven will start operating at the recommended drying temperature and duration.

【设定工作时间】Set working hours:

点击设置键 ，直到TIME闪烁时，每单击一次上下键  ，时间按照1h变化，时间可设置范围1-99h。

Click the settings button  until the "TIME" indicator flashes. Each time you click the up or down key   , the time changes by 1 hour. The time can be set within the range of 1 to 99 hours.

【设定灯光效果】Set Lighting Effects

点击设置键 ，直到SUNLU闪烁时，单击上下键  ，调整不同的灯光效果状态：

(1) 流水灯 

(2) 常亮 

(3) 关闭 

Click the settings button  continuously. When SUNLU flashes, click the up or down keys   to adjust different lighting effect states:

(1) Water Flow Light 

(2) Always On 

(3) Off 

【设定温度单位】Set Temperature Unit

点击设置键 ，直到℃闪烁时，单击上下键  ，温度单位在℃/°F之间切换。

Continuously click the setting button . When the "°C" symbol flashes, click the up or down keys   to switch the temperature unit between "°C" and "°F".

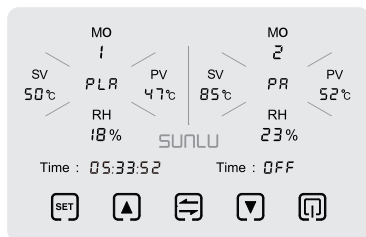
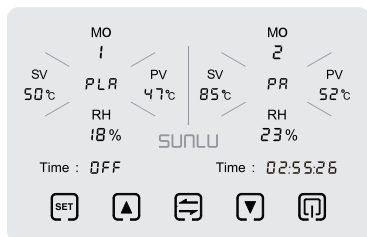
【关机】Power Off

当左侧界面图标闪烁时，双击电源键 ，左腔体关机，对应左边的TIME处显示为 OFF。

When the icon on the left interface flashes, double-click the power button . The left speaker will power off. The corresponding "TIME" section will display as "OFF".

当右侧界面图标闪烁时，双击电源键 ，右腔体关机，对应右边的TIME处显示为 OFF。

When the icon on the right interface flashes, double-click the power button . The right speaker will power off. The corresponding "TIME" section will display as "OFF".



5 操作步骤 Operating Instructions

- (1) 当单侧腔体已显示关机时, 单击切换键  使其图标闪烁, 在单击电源键 , 对应腔体即可重新启动;
- (1) When the single-sided cavity has indicated that it has shut down, click the switch key to  make its icon flash. Then click the power key , and the corresponding cavity can be restarted.
- (2) 当单侧腔体已显示关机时, 双击电源键 , 整机关机, 屏幕黑屏, 此时仅电源键亮, 风扇会在3min后停止。
- (2) At this point, double-click the power button  to turn off the device. The screen goes black. At this point, only the power button is illuminated. The fan will stop after 3 minutes.
- (3) 当界面无闪烁时, 双击电源键 , 整机关机, 屏幕黑屏, 此时仅电源键亮风扇会在3min后停止。
- (3) When there is no flickering on the interface, double-click the power button to  turn off the device. The screen goes black. At this point, only the power button is illuminated. The fan will stop after 3 minutes.
- (4) 当°C闪烁、或者SUNLU闪烁时, 双击电源键 , 不做关机动作。
- (4) When the °C indicator flashes or the SUNLU indicator flashes, double-click the power button  without performing the shutdown operation.

6 常见故障排除 Common Troubleshooting

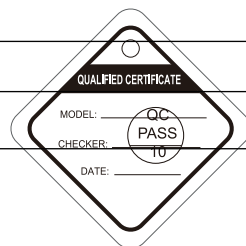
如产品在使用过程中遇到如下问题，请尝试按下表中的方法排除故障，如故障依旧，请联系我们

If you encounter the following issues during use, please try the solutions below. If the issue persists, please contact us.

现象 Issue	问题原因 Possible Causes	故障排除方法 Troubleshooting Methods
无法开机 Won't Power On	电源开关未打开或电源连接异常 Power switch off or poor connection	检查电源线是否与插座连接良好，检查保险丝是否烧坏 Check if the power cord is connected properly to the socket. Check if the fuse is blown.
显示开机但左右腔体无温度 No temperature in chambers despite power-on status.	检查是否因左右腔体显示OFF关机，导致没有正常工作 Check if the unit is not working properly because the left and right chambers display "OFF" and are shut down.	可点击切换键进入对应腔体设置界面，单击电源键开机即可 Press the Switching Button to access the settings interface for the desired chamber, and then press the Power Button to start up
显示屏乱码/显示不全 Display Garbled / Incomplete	接触不良或显示屏坏 Loose connection or faulty display	关机重启，如故障依旧需要更换显示屏，请联系我们 Power cycle the unit. If the problem persists, the display may need replacement. Contact us.
ER1	温度检测异常 Temperature sensor abnormal	检查温度传感器连接是否良好或联系我们 Check the temperature sensor connection. If secure, contact us.
ER2	PTC加热风扇异常 PTC heater / fan abnormal	检查风扇是否不转或者被异物卡住或联系我们 Check if the fan is not spinning or is obstructed. If clear, contact us.

7 合格证 Certificate of Conformity

Product Name:	Manufacture Date:
Inspector:	Inspection Date:



8 售后服务 After-Sales Service

1.如在本手册所示产品在正常操作下发生故障,保修一年。

1. The product comes with a one-year warranty under normal operating conditions as shown in this manual.

2.在保修期内,因使用不同规格的电源线或未按说明书正确操作导致机器损坏的,恕不提供保修服务。

2. The warranty does not cover damages caused by using power cables of different specifications or incorrect operation as per the instructions in the manual during the warranty period.

9 联系我们 Contact us

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