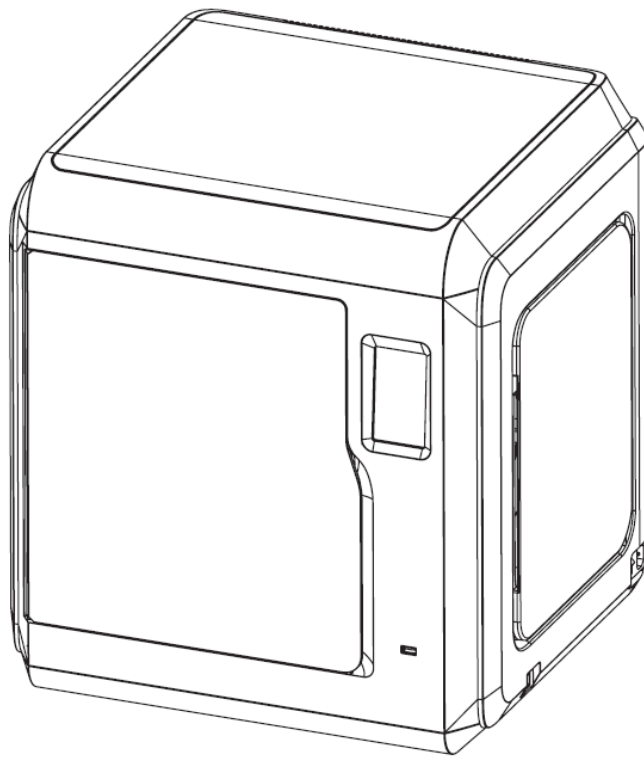




MP Voxel™ Pro Fully Enclosed 3D Printer



P/N 44091

User's Manual

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SAFETY WARNINGS AND GUIDELINES

Please read this entire manual before using this device, paying extra attention to these safety warnings and guidelines. Please keep this manual in a safe place for future reference.

- This device is intended for indoor use only.
- Do not expose this device to water or moisture of any kind. Do not place drinks or other containers with moisture on or near the device. If moisture does get in or on the device, immediately remove it from its power source and allow it to fully dry before reapplying power.
- Do not touch the device, the power cord, or any other connected cables with wet hands.
- Do not install this device on an unstable surface where it could fall and cause either personal injury or damage to the device and/or other equipment.
- Do not expose this device to excessive vibration or extreme force, shock, or fluctuations in temperature or humidity.
- Do not expose this device to excessively high temperatures. Do not place it in, on, or near a heat source, such as a fireplace, stove, radiator, etc. Do not leave it in direct sunlight.
- Do not place or install this device in an area where it can be exposed to excessive amounts of dust, humidity, oil, smoke, or combustible vapors.
- Use only in a well-ventilated area. Do not use in close, confined spaces.
- Prior to operation, check the unit and power cord for physical damage. Do not use if physical damage has occurred.
- Before plugging the unit into a power outlet, ensure that the outlet provides the same type and level of power required by the device.
- This device uses a grounded power cord and requires a ground connection for safe operation. Ensure that the power source has a proper ground connection. Do not modify the plug or use a "cheater" plug to bypass the ground connection.
- Unplug this device from the power source when not in use.

- Take care to prevent damage to the power cord. Do not allow it to become crimped, pinched, walked on, or become tangled with other cords. Ensure that the power cord does not present a tripping hazard.
- Never unplug the unit by pulling on the power cord. Always grasp the connector head or adapter body.
- Ensure that the printer is turned off and unplugged from its power source before making repairs or performing service.
- Ensure that the printer is turned off and unplugged from its power source before replacing the fuse in the rocker switch power socket.
- Clean using a soft, dry cloth only. Do not use chemical cleaners, solvents, or detergents. For stubborn deposits, moisten the cloth with warm water.
- This device is intended for use by persons 14 years of age or older. Adult supervision is required.
- Take care to avoid touching hot parts, including heat blocks, extruder nozzle, extruded filament, and the heated build plate.
- Do not wear gloves when operating or repairing to avoid entanglement.
- Do not reach inside the printer during operation.
- Always allow the printer and extruded filament to cool before reaching inside.
- Do not remove the wrapping around the nozzle.



**Keep body parts away
from moving parts**



**Warning
crushing of hands**



**Hot surface
Do not touch**



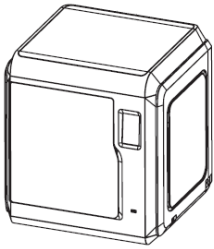
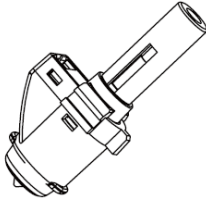
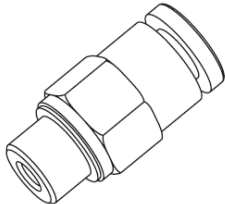
**Keep this
area clear**

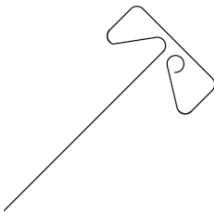
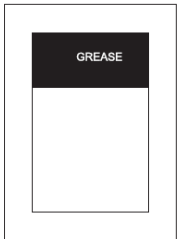
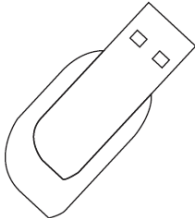
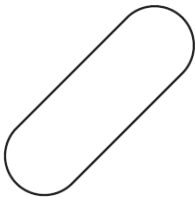
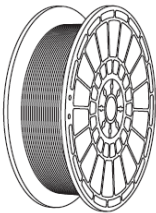
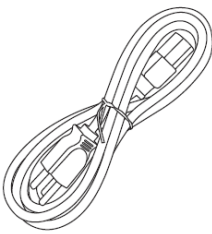
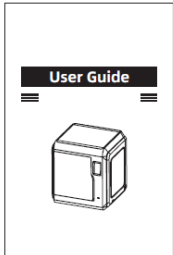
CUSTOMER SERVICE

The Monoprice™ Customer Service department is dedicated to ensuring that your ordering, purchasing, and delivery experience is second to none. If you have any problem with your order, please give us an opportunity to make it right. You can contact a Monoprice Customer Service representative through the Live Chat link on our website www.monoprice.com or via email at support@monoprice.com. Check the website for support times and links.

PACKAGE CONTENTS

Please take an inventory of the package contents to ensure you have all the items listed below. If anything is missing or damaged, please contact Monoprice™ Customer Service for a replacement.

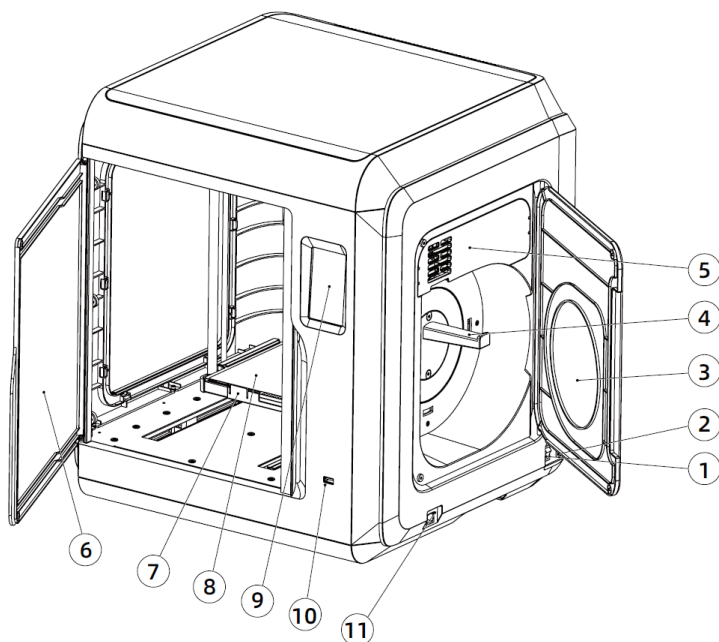
		
1x Voxel™ Pro 3D Printer	1x 0.4-240 Nozzle (installed) and 1x 0.4-265 Nozzle	2x Filament Guide Tube Joint

		
1x Screwdriver	1x Clog Removal Tool	1x Allen Wrench
		
1x Packet of Grease	1x USB Flash Drive	1x Leveling Card
		
1x Spool Filament	3x AC Power Cords (US/UK/EU)	1x User's Manual

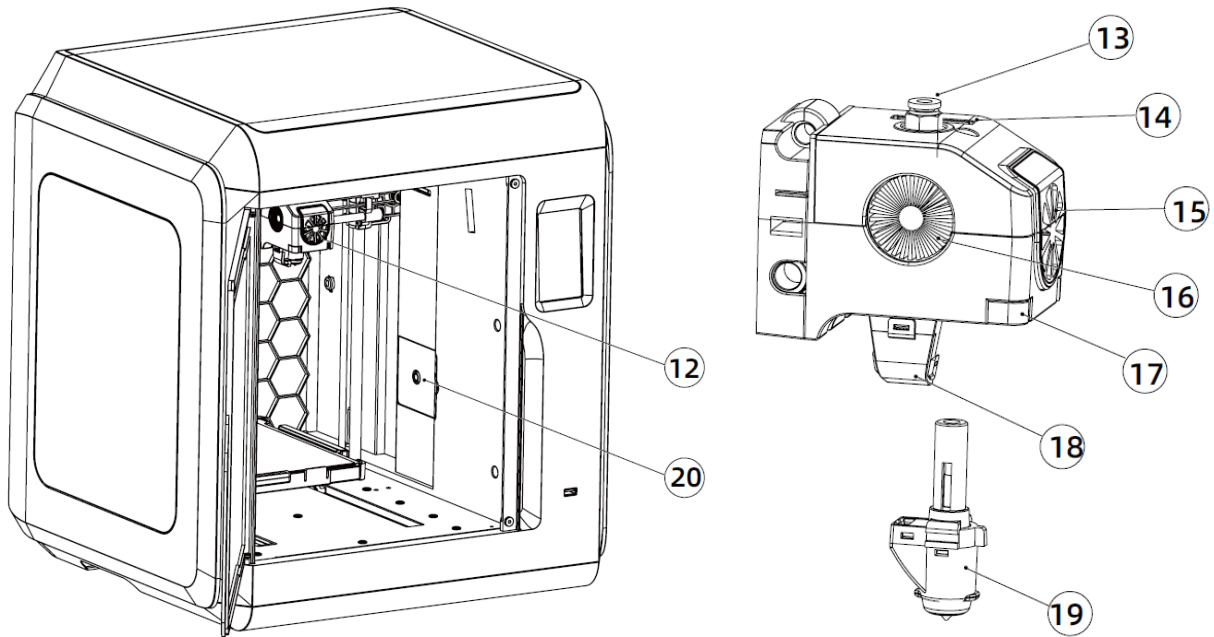
PRODUCT OVERVIEW

Front and Right Side View

1. Power Switch
2. Power Connector
3. Filament Door
4. Filament Spool Holder
5. Filament Intake Cover
6. Front Door
7. Build Platform Base
8. Build Plate
9. Touchscreen Interface
10. USB Port
11. Ethernet Jack



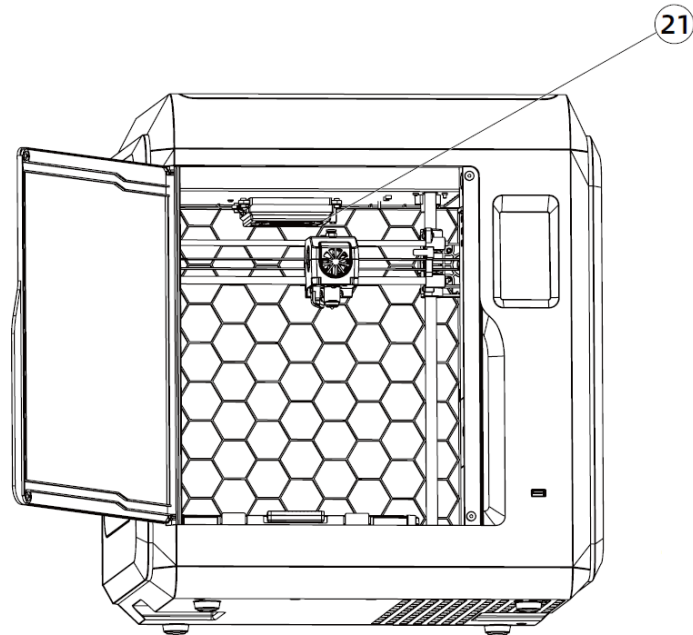
Internal and Extruder Views



- 12. Extruder
- 13. Filament Guide Tube Joint
- 14. Cable Slot
- 15. Extruder Cooling Fan
- 16. Model Cooling Fan
- 17. Buckle
- 18. Air Duct
- 19. Nozzle
- 20. Camera

Internal View

21. Chamber Cooling Fan



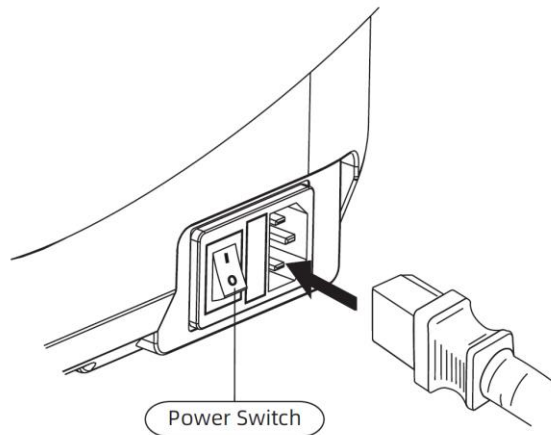
SOFTWARE INSTALLATION

The **FlashPrint** installation package can be found on the **USB Flash Drive** included with the printer. You can also download it from the product page on the website. To locate the download file, navigate to <https://www.monoprice.com>, then type **44091** into the search bar, and hit **ENTER**. Scroll to the bottom of the page to find the **Support Files** section, which has the full manual, the FlashPrint software package, and any other related files.

The website will always have the most recent version of FlashPrint, as well as the latest version of the manual and any firmware updates that may be available, so it is a good idea to check the website periodically.

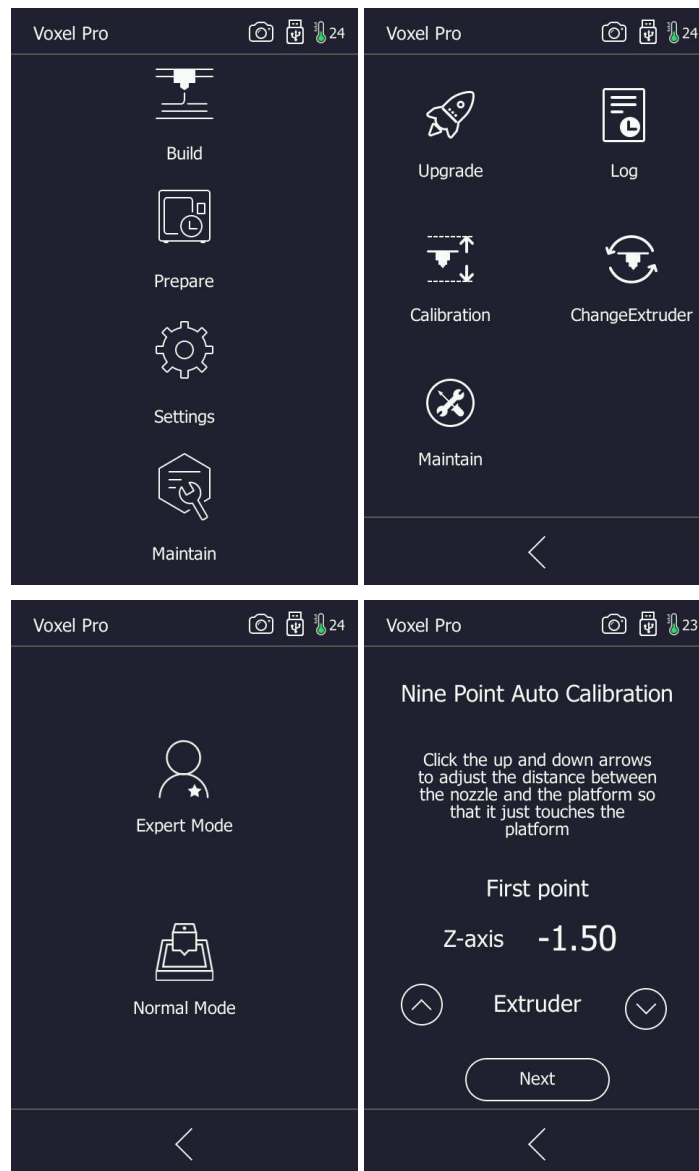
GETTING STARTED

1. If you have not already installed the FlashPrint software package, install it now by following the instructions in the *SOFTWARE INSTALLATION* section above.
2. Ensure that the **Power Switch** on the printer is in the OFF (O) position.
3. Plug one end of the included **AC Power Cord** into the **Power Connector** on the printer, then plug the other end into a nearby AC power outlet.

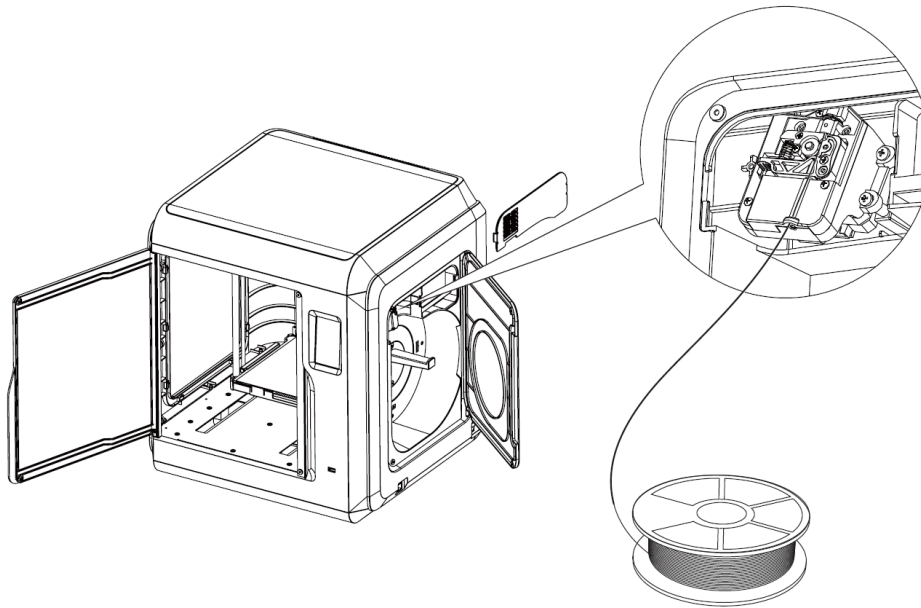


4. Flip the **Power Switch** on the printer to the ON (I) position.

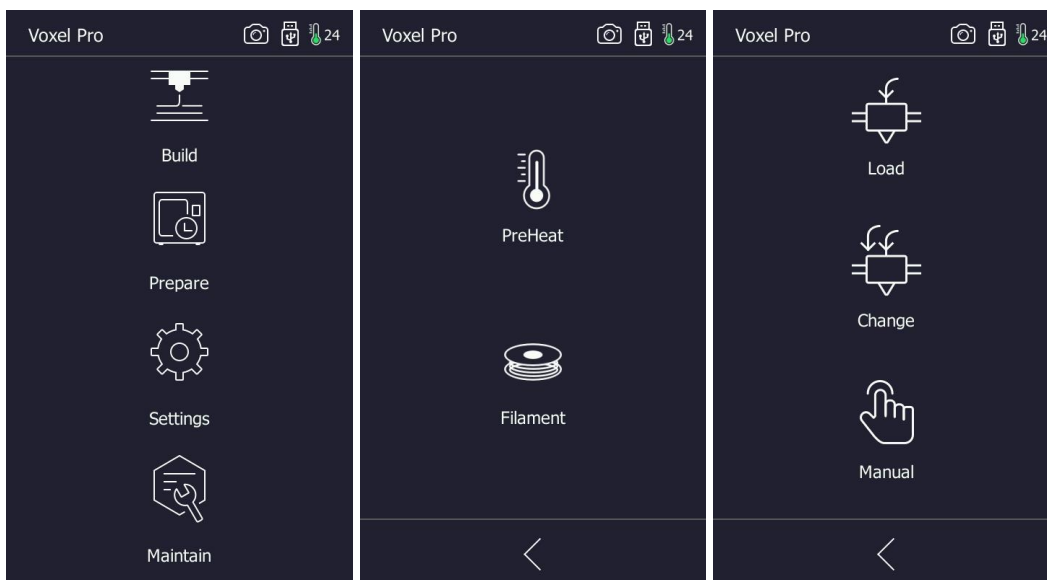
5. Although the printer was fully calibrated at the factory, it may have gone out of calibration during the shipping process, so it is a good idea to do at least a single-point calibration. On the **Touchscreen Interface**, touch **Maintain > Calibration > Normal Mode**. Follow the on-screen instructions for the first point. You can then either exit or finish the full **Nine Point Auto Calibration**. For more information, refer to the *USER INTERFACE > Calibration* section.

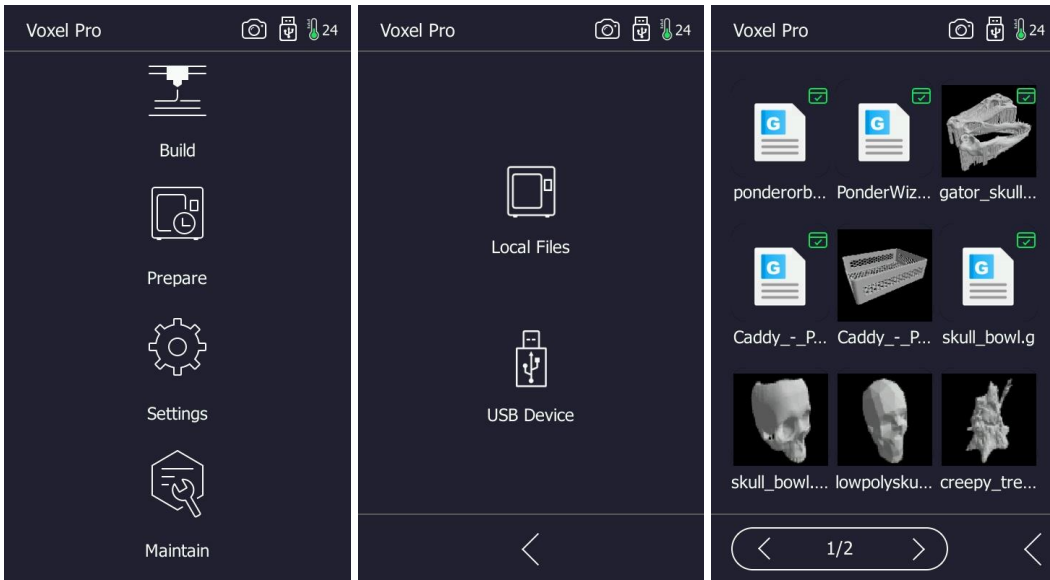


6. Open the **Filament Door** on the printer, then place a spool of filament on the **Filament Spool Holder**.

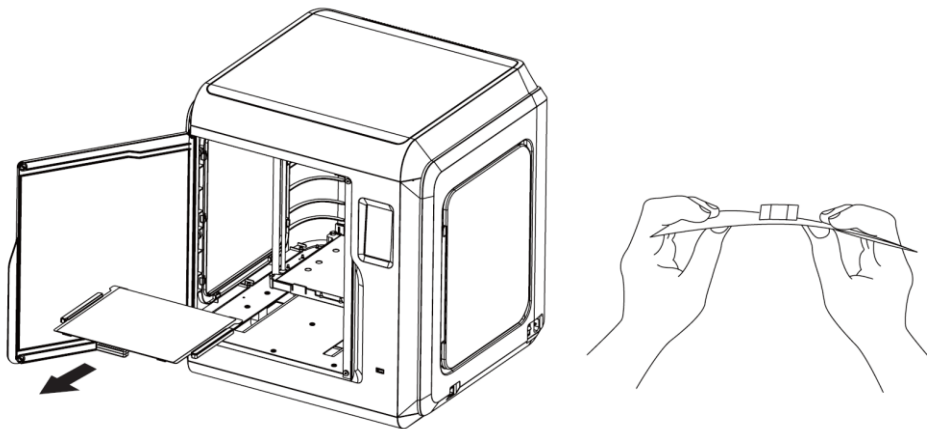


7. Remove the **Filament Intake Cover**, then insert the end of the filament into the filament intake. Push the filament into the feeding wheel until some resistance is felt.
8. On the **Touchscreen Interface**, touch **Prepare > Filament > Load**, then follow the on-screen instructions to load the filament.





9. The **USB Flash Drive** included with the printer has sample models preloaded. Insert the **USB Flash Drive** into the **USB Port** on the printer. On the **Touchscreen Interface**, touch **Build** >  **USB Device**. The system will display the files on the flash drive. Touch a model image to display the file details, then touch the **Build** button to start printing the file.
10. When the print is finished, wait for the printer and model to fully cool down to room temperature. Once they are fully cooled, remove the **Removable Build Plate**, then slightly bend the plate to detach the model.

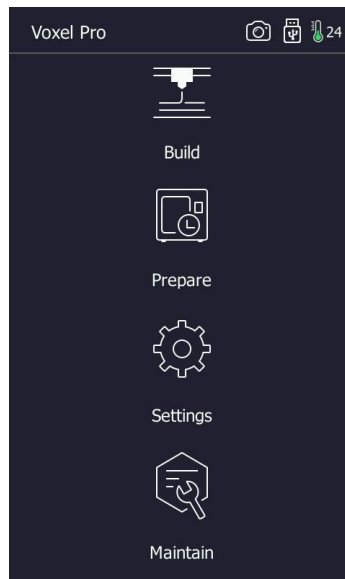


USER INTERFACE

This printer features a touchscreen menu system, which allows you to easily adjust the printer settings, select and print models, and perform basic maintenance. This section details key elements of the user interface, with instructions on how to perform basic functions. Note that the interface is subject to change with subsequent updates, so this should be considered a general guide to the interface.

Main Menu

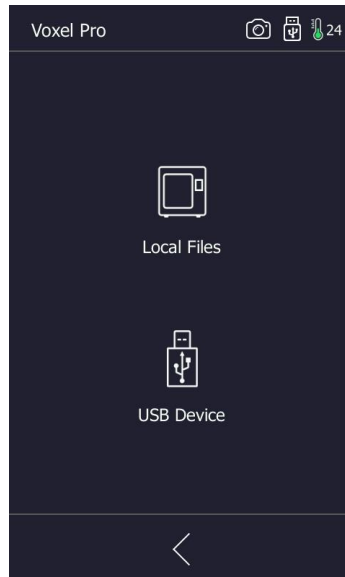
When the system finishes powering up, the **Main Menu** will be displayed on the **Touchscreen Interface**.



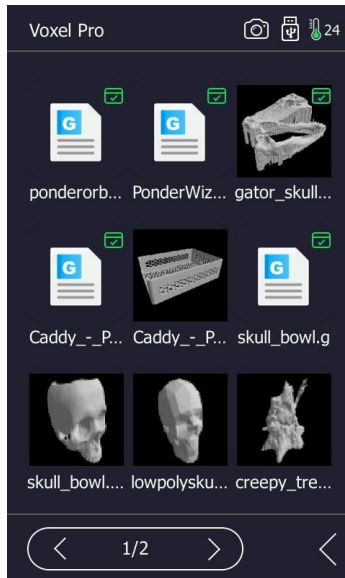
Build

Perform the following steps to print one or more models.

1. Touch the **Build** icon on the **Main Menu**. The system will display the **File Location Selection** screen.



2. Touch the  **Local Files** icon to select files stored in the printer's internal memory. Otherwise, touch the  **USB Device** icon to select files stored on a USB flash drive inserted into the printer's USB port. The system will display a list of files in the selected location.



3. The system displays the files as a series of thumbnail images of the finished print. Momentarily touch an image to display the **File Details** screen. Press and hold an image to enable multi-selection mode, which allows you to select multiple files for printing. The icon for each selected file will be highlighted and the finished prints will be indicated with a checkmark.
4. The **File Details** screen displays the following information about the model:



Extruder temperature and target temperature.



Time required to print the model.



Amount and type of filament required.



Print speed.



Layer thickness.



Build plate temperature and target temperature.



Copy the file to local memory.

5. The **Print Progress** screen displays a progress bar with the remaining print time required. It also displays the extruder and build plate temperatures and target temperatures. While printing is in progress, the following actions are possible:



Pause the print job.



Resumes a paused print job.



Displays the **More Settings** pop-up dialog.

6. The **More Settings** pop-up dialog contains three icons for additional actions:



Begins the process for changing the filament.



Turns the internal LED light on or off.



Displays the **Print Parameters** screen.

7. The **Print Parameters** screen allows you to adjust several settings on the fly. Touch the **OK** button to save any changes.



Adjust the extruder target temperature.



Adjust the build plate target temperature.



Adjust the print speed.



Adjust the **Z Offset**, which is the distance between the first printed layer and the extruder.

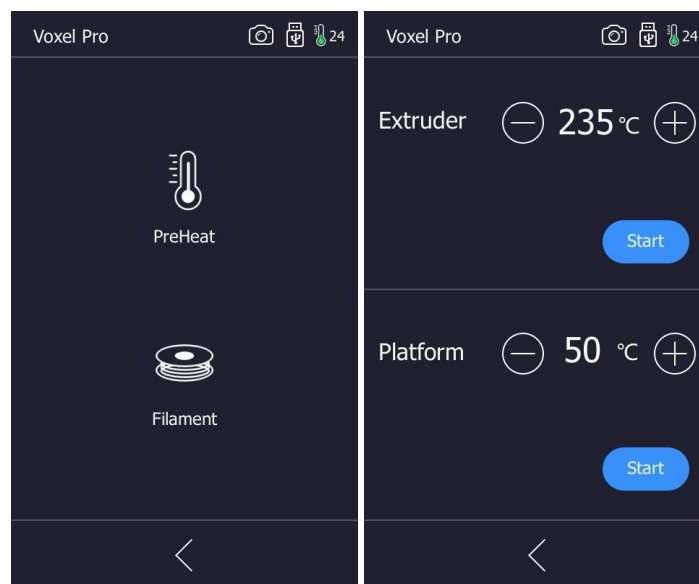
Fan Adjust the fan speed for the **Model Cooling Fan**.

Preheat

Perform the following steps to adjust the target temperature and preheat the Extruder and/or Platform (build plate).

1. Touch the **Prepare** icon on the **Main Menu**. The system will display the **Prepare Menu**.

2. Touch the  **Preheat** icon to adjust the extruder and/or build plate target temperatures.



3. Momentarily press the  and  buttons to increase or decrease the target temperature for the **Extruder** and/or **Platform** (build plate). Press and hold the buttons to rapidly change the target temperature.

Touch the **Start** button to begin preheating. While preheating, the system displays a progress bar and the current temperature. Touch the **Cancel** button to cancel preheating.

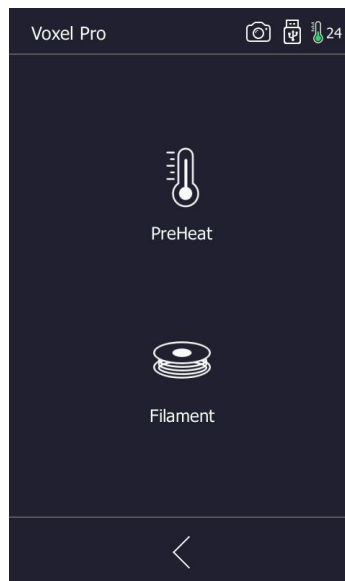
The maximum Extruder temperature is 265°C, which is set by the selected nozzle setting. This depends on the installed nozzle. The nozzle installed on this printer at the factory is a 0.4-240 version, which has a maximum nozzle temperature of 240°.

The maximum Platform (build plate) temperature is 110°C.

Filament

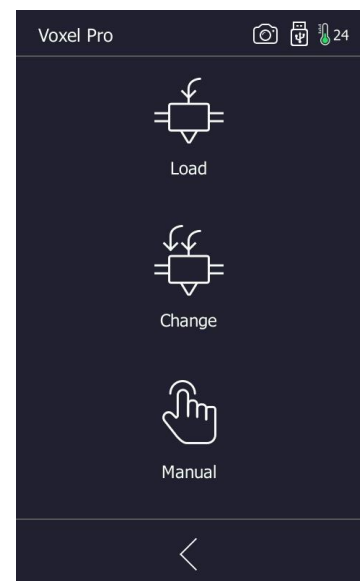
Perform the following steps to Load, Change, or Manually Change the filament used for printing.

1. Touch the **Prepare** icon on the **Main Menu**. The system will display the **Prepare Menu**.



2. Touch the  **Filament** icon to display the **Filament** screen.

3. Touch the  **Load** icon to start the filament load process. The system will begin heating the Extruder to the target temperature. Insert the filament into the filament intake until some resistance is felt, but do not push it into the tube. Follow the on-screen instructions. The system will automatically use Fast or Slow loading. You may hear a noise during Fast loading. When filament comes out of the Extruder, loading is complete. Remove the extruded filament.



4. Touch the  **Change** icon to start the process to change the current filament for a different filament. The system will begin heating

the Extruder to the target temperature. Follow the on-screen instructions to remove the old filament, then insert the new filament into the filament intake until some resistance is felt, but do not push it into the tube. When filament comes out of the Extruder, loading is complete. Remove the extruded filament.

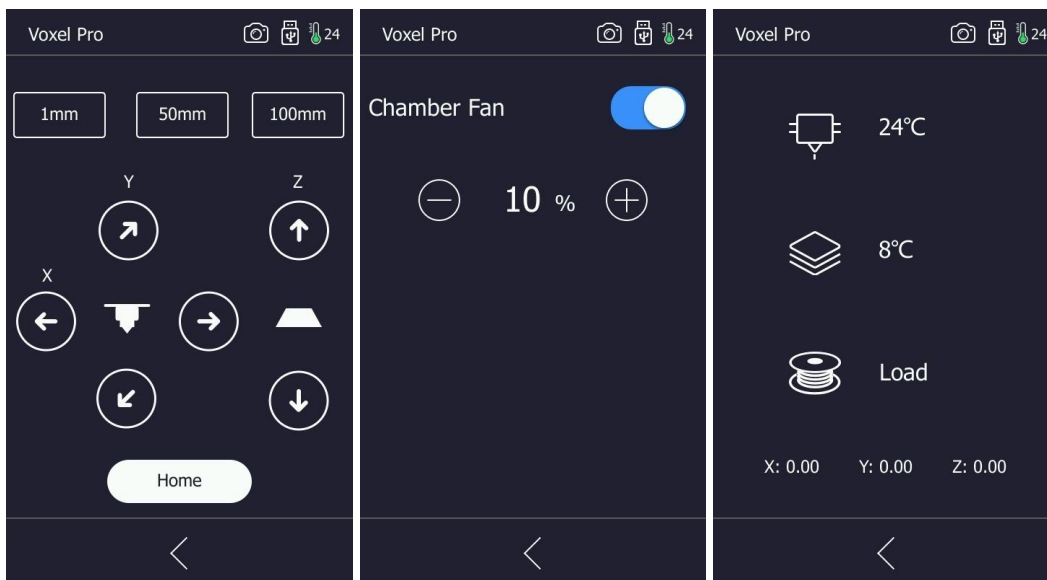
5. Touch the  **Manual** icon to manually load or unload filament. The system will heat the Extruder to the target temperature. Select the amount of filament to extrude (**100**, **200**, or **300** mm) when loading. Touch the **Load** or **Unload** buttons to manually load or unload filament.

Note that Manual loading is preferred when there is remaining filament in the tube.

Settings

Perform the following steps to adjust the printer's settings.

1. Touch the **Settings** icon on the **Main Menu**. The system will display the **Settings** screens.
2. You can perform the following actions on the **Settings** screens:



Move: Moves the extruder left or right or moves the build plate forward or back, up or down. It is normal for noise to occur when the extruder is moved

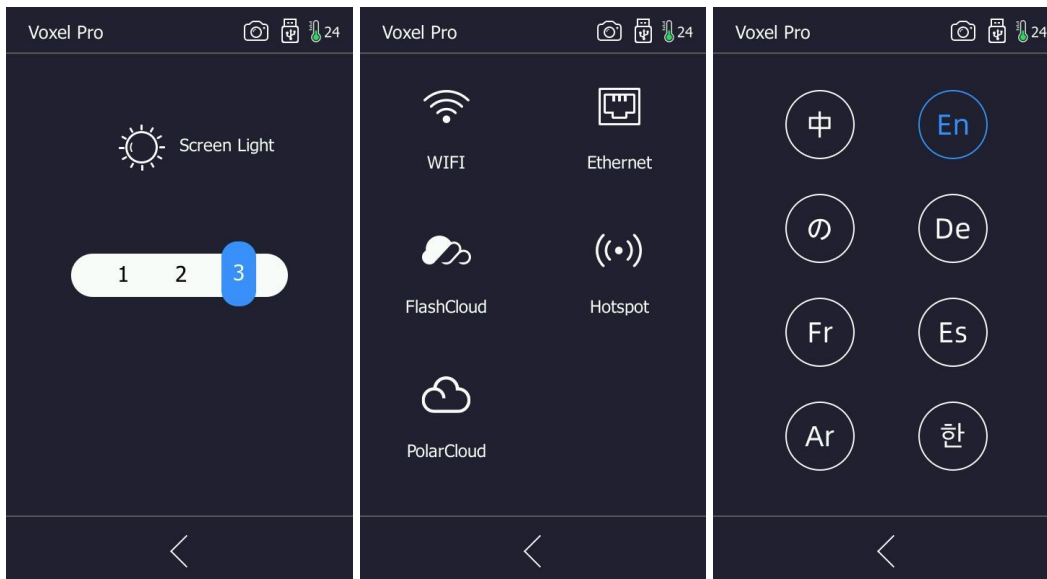
to the farthest point of the left side or when the build plate is moved to the farthest point of the front side.



Fan: Turns the Chamber Cooling Fan at the top of the printer on or off.



Status: Displays the printer status, including the temperature, X/Y/Z position, etc.



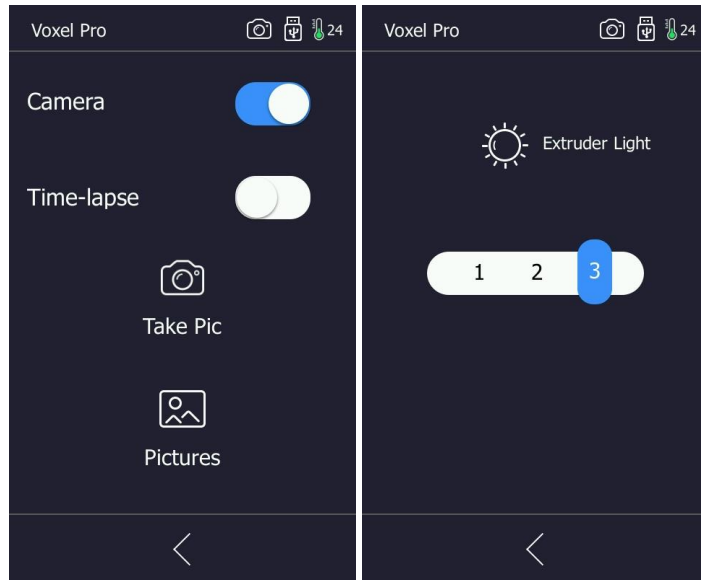
Brightness: Adjusts the screen brightness.



Network: Allows you to connect to a hotspot, WLAN, Flash Cloud, Polar Cloud™, etc.



Language: Allows you to select the language used in the User Interface.



Camera: Displays the **Camera Control** screen, which allows you to turn the camera on or off and display saved Photos and/or Videos.



Light: Turns the light on the extruder on or off.



FilamentDetect: Turns the filament check sensor on or off.



PrinterName: Allows you to change the name of the printer.



Buzzer: Turns the printer sounds on or off. The sounds include system startup, screen selection click, etc.



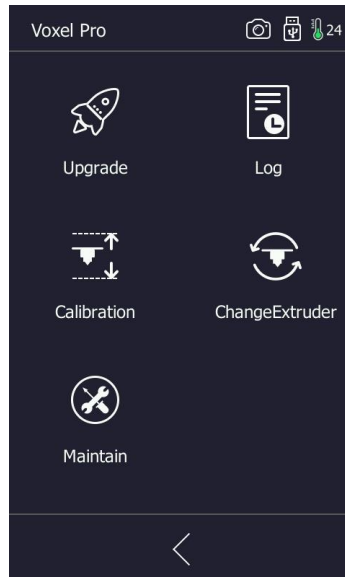
FactoryReset: Resets all printer settings to their factory default values.



About: Displays information about the printer.

Maintain

1. Touch the **Maintain** icon on the **Main Menu**. The system will display the **Maintain** screen.



2. You can perform the following actions on the **Maintain** screen:



Upgrade: If you are connected to the internet, you will be prompted to upgrade the firmware, if a firmware update is detected.



Calibration: Displays a series of screens that guide you through the calibration process.



Maintain: Displays the **Maintenance advice** screen with helpful tips for maintaining your printer.



Log: If there is an abnormal condition or operation, you can send the Log file to Technical Support for troubleshooting assistance.

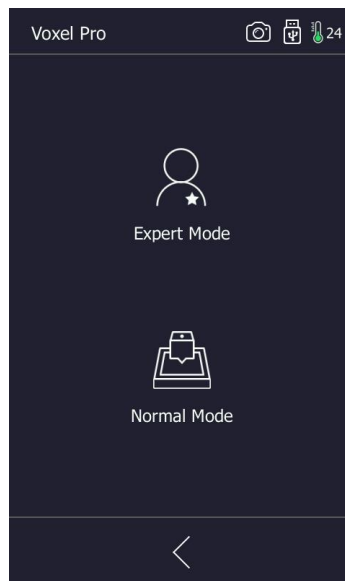


ChangeExtruder: Displays a series of screens that guide you through the process of replacing the extruder.

Calibration

Although the printer was calibrated at the factory, it is a good idea to perform a calibration before you use the printer for the first time. You should also perform a calibration after changing the nozzle.

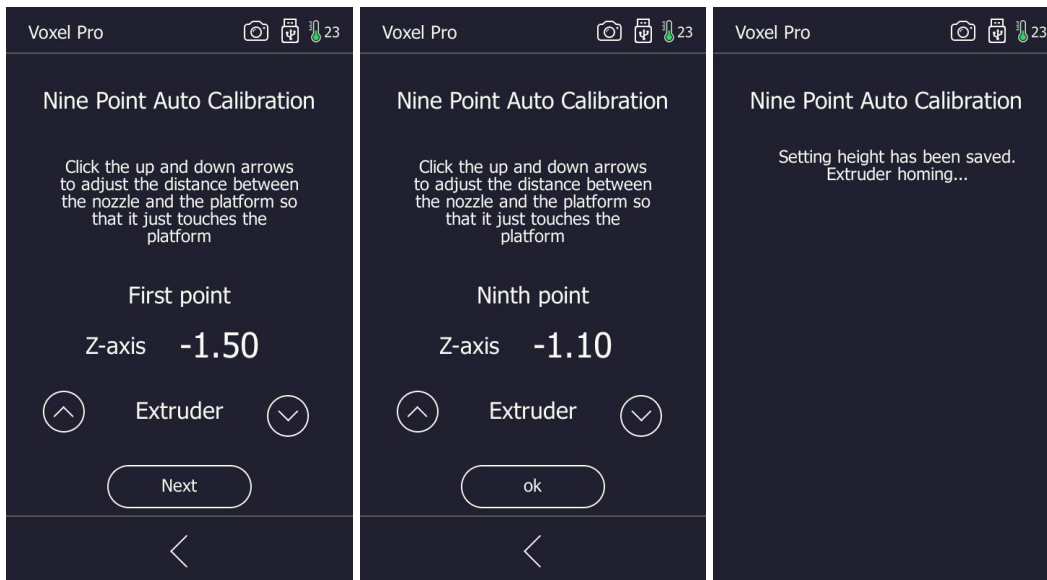
There are two methods of performing calibration: **Expert Mode** and **Normal Mode**.



In **Expert Mode**, you can manually adjust the distance between the nozzle and the build plate. Insert the included **Leveling Card** between the nozzle and the build plate to gauge

the distance setting. Use the  button to move the extruder up away from the build

plate and use the  button to move the extruder down toward the build plate. The proper distance is when there is a slight amount of resistance when moving the **Leveling Card** between the nozzle and the build plate. Touch the **OK** button to save the changes.



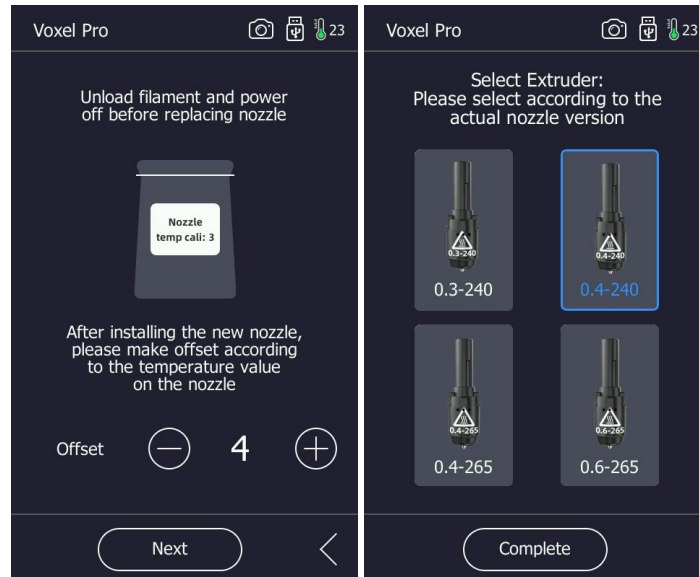
In **Normal Mode**, the printer first performs an extruder calibration, then performs a full **Nine Point Auto Calibration**. The first point calculates the initial distance between the extruder

and the built plate. You can use the  and  buttons to adjust the Z-axis deviation value. Use the included **Leveling Card** between the nozzle and build plate to judge the proper distance. The proper distance is when there is a slight amount of resistance when moving the **Leveling Card** between the nozzle and the build plate.

Normally, this is all the calibration that is needed. However, if you find you cannot print large models, you should finish the full **Nine Point Auto Calibration**. After the full calibration, the system will calculate the mean value for compensation. At each stage of

the calibration process, you can use the  and  buttons to adjust the Z-axis deviation.

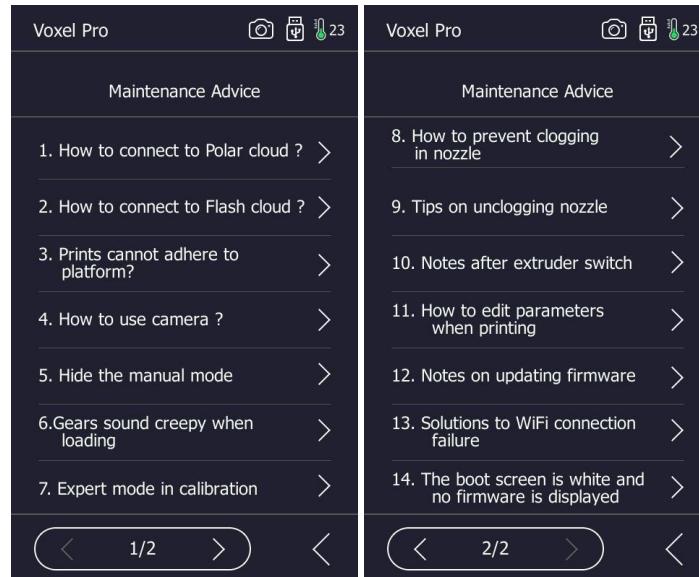
Change Extruder



1. After installing a new nozzle, set the compensation value for the temperature of the new nozzle, in the range 0 ~ 30 from the base value of 240. Note that the proper offset value for each extruder is printed on the bag. The default nozzle type installed on this printer is **0.4-240**.
2. After setting the compensation value, touch the **Next** button to display the **Select Extruder** screen. Touch the extruder that you just installed, then touch **Complete** to finish the process. The system will change the maximum extruder preheat value based on the selected extruder, so it is important to select the exact model extruder installed.

Maintenance Advice

The Maintenance advice screen displays a system FAQ, which informs you how to perform certain actions or helps with troubleshooting a problem.

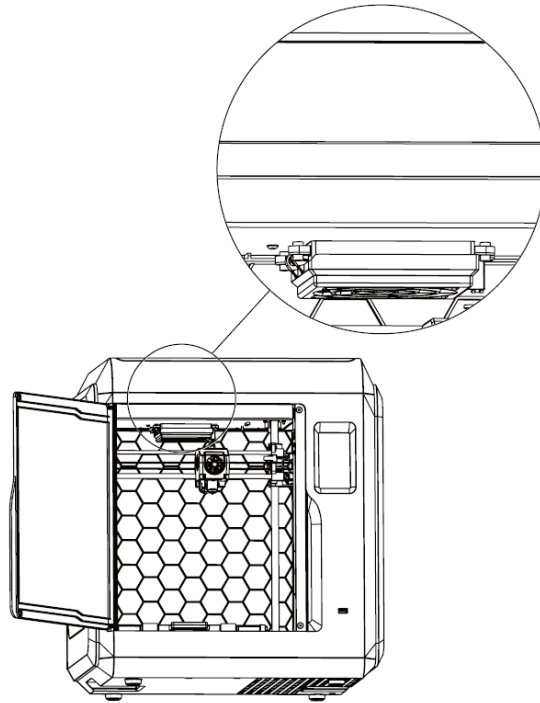


MAINTENANCE

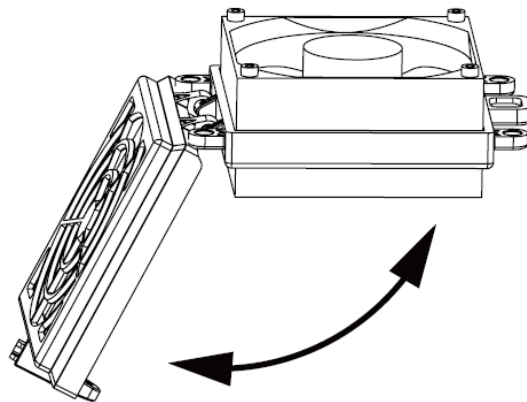
HEPA Filter

Replace the HEPA filter cotton every 2 weeks. Perform the following steps to replace the filter.

1. Open the **Front Door** and locate the **Chamber Fan** at the top of the printer.



2. Open the **Chamber Cooling Fan** cover, remove the old filter cotton and replace it with a new filter cotton. Close the **Chamber Cooling Fan** cover.



Extruder Guide Rails

Apply some grease to the **Extruder Guide Rails** every other month to ensure smooth movement of the Extruder.

Unclogging the Nozzle

From time to time, the nozzle can become clogged. Perform the following steps to unclog the nozzle.

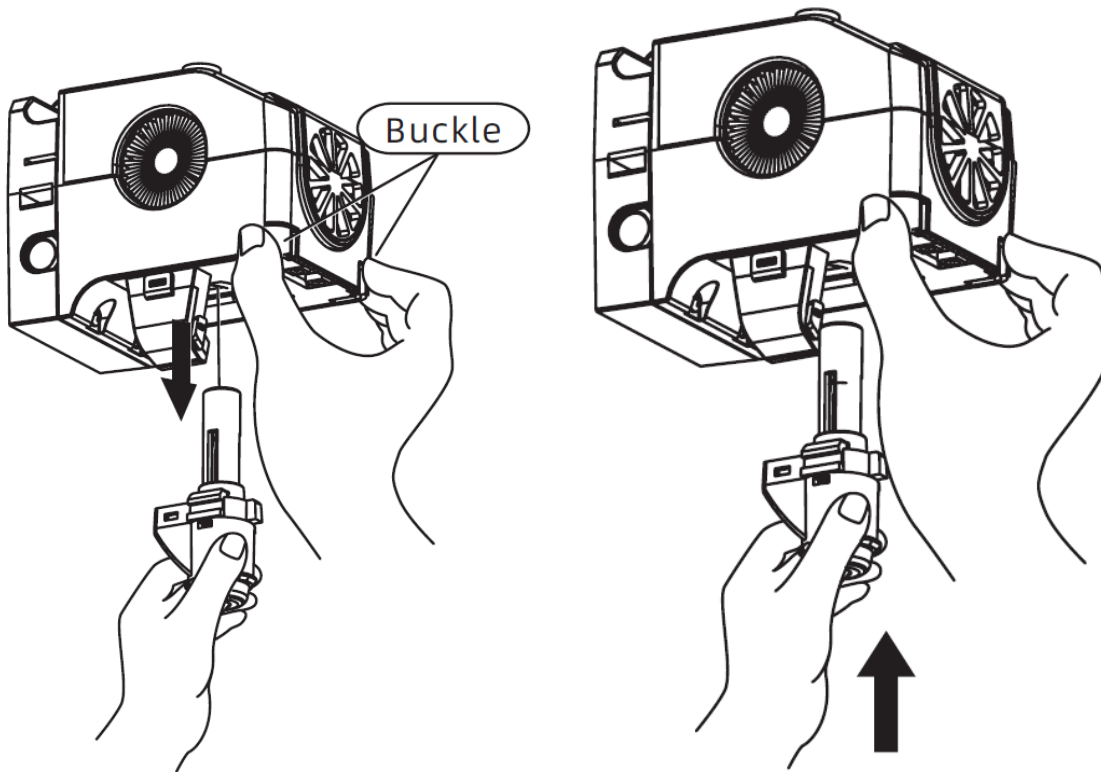
1. Preheat the nozzle to the temperature required for the type of filament that is clogging the nozzle. Refer to the *USER INTERFACE > Preheat* section above for details on how to preheat the nozzle.
2. Open the **Front Door**. Carefully reach into the printer and press the **Filament Guide Tube Joint**. Remove the **Filament Guide Tube** and the filament.
3. Inspect the end of the filament to see if is smooth. If not, use a pair of scissors or side cutters to make a smooth cut. Reinsert the **Filament Guide Tube** into the **Filament Guide Tube Joint**, then load the filament. Refer to the *USER INTERFACE > Filament* section above for details on how to load filament.
4. If filament extrudes, the clog is cleared. If not, carefully reach into the printer and insert the included **Clog Removal Tool** into the nozzle to clear the clog.
5. If filament still will not properly extrude, replace the nozzle.

Replacing the Nozzle

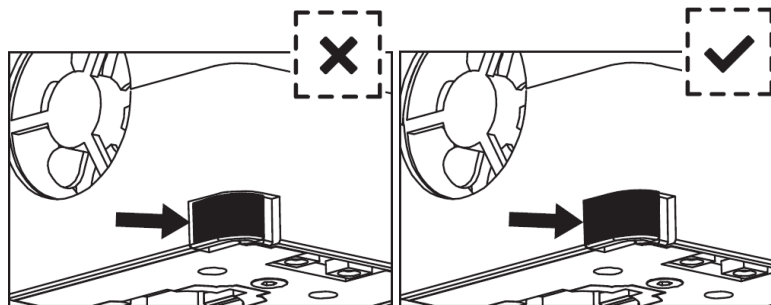
Perform the following steps to replace the installed nozzle.

1. If filament is already loaded, Unload it. Refer to the *USER INTERFACE > Filament* section above for details on how to unload the filament.
2. Turn the printer off and unplug it from its power source.

3. Squeeze the two **Buckles** on the Extruder, then remove the nozzle.



4. While still squeezing the two **Buckles**, fully insert the new nozzle, then release the **Buckles**.
5. Inspect the **Buckles** and compare their condition to the images below. The image on the right is what they look like when the nozzle is fully inserted into the Extruder. If it looks like the image on the left, repeat the steps above to remove the nozzle, then reinsert it fully.



6. Turn the printer on.

7. Perform a full **Nine Point Auto Calibration** with the new nozzle. Refer to the *USER INTERFACE > Calibration* section above for details on how to perform a calibration.
8. Change the **Temperature Offset** to match the requirements of the new nozzle, as shown on the bag that the new nozzle was shipped. Refer to the *USER INTERFACE > Change Extruder* section above for details about setting the **Temperature Offset**.
9. Load some filament. Refer to the *USER INTERFACE > Filament* section above for details on how to load filament.

TECHNICAL SUPPORT

Monoprice™ is pleased to provide free, live, online technical support to assist you with any questions you may have about installation, setup, troubleshooting, or product recommendations. If you ever need assistance with your new product, please come online to talk to one of our friendly and knowledgeable Tech Support Associates. Technical support is available through the online chat button on our website www.monoprice.com or through email by sending a message to tech@monoprice.com. Check the website for support times and links.

To download the latest drivers, firmware, manuals, etc., go to www.monoprice.com and type the **P/N** into the search bar. If available, support files are linked at the bottom of the product page.

SPECIFICATIONS

P/N	44091
Number of Extruders	1
Positioning Accuracy	X/Y Axis: 0.011mm, Z Axis: 0.0025mm
Layer Resolution	100 ~ 400 microns
Build Volume	220 x 200 x 250 mm
Nozzle Diameter	0.4mm (default), 0.6/0.3 mm (optional)
Build Speed	10 ~ 150 mm/sec
Maximum Extruder Temperature	240°C (default) or 265°C (optional), depending on extruder
Supported Filament Types	ABS, PLA, PC, PETG, PLA-CF, ASA, PETG-CF
Supported Software	MP FlashPrint
FlashPrint Input File Types	3MF, STL, OBJ, FPP, BMP, PNG, JPG, JPEG
FlashPrint Output File Types	GX, G
Connectivity	USB Flash Drive, Wi-Fi®, Ethernet
RF Operating Frequency	2400 ~ 2497 MHz
Maximum RF Power	7 ±1 dBm
USB Flash Drive File System	FAT32
Input Power	100 ~ 240 VAC, 50/60 Hz, 13.3A
Maximum Power Consumption	320 watts
Fuse Type	T10AL250V (5 x 20 mm)
Operating Temperature	+59 ~ +86°F (+15 ~ +30°C)
Operating Humidity	20 ~ 70% RH, noncondensing
Dimensions (LxWxH)	19.7" x 18.5" x 21.3" (500 x 470 x 540 mm)
Weight	60.0 lbs. (27.2 kg)

REGULATORY COMPLIANCE

Notice for FCC



This device complies with Part 15 of the FCC rules. Operation is subject to the following two conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

Modifying the equipment without Monoprice's authorization may result in the equipment no longer complying with FCC requirements for Class B digital devices. In that event, your right to use the equipment may be limited by FCC regulations, and you may be required to correct any interference to radio or television communications at your own expense.

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

RF Exposure Statement for FCC

Caution

This FCC Part 15 radio device operates on a non-interference basis with other devices operating at this frequency. Any changes or modification to said product not expressly approved by Monoprice, including the use of non-approved antennas, could void the user's authority to operate this device.

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

ISED Statement

This device contains licence-exempt transmitter(s)/receiver(s) that comply with Innovation, Science and Economic Development Canada's licence-exempt RSS(s). Operation is subject to the following two conditions:

- (1) This device may not cause interference.
- (2) This device must accept any interference, including interference that may cause undesired operation of the device.

The digital apparatus complies with Canadian CAN ICES-3 (B)/NMB-3(B).

Cet appareil contient des émetteurs/récepteurs exempts de licence qui sont conformes aux RSS exemptés de licence d'Innovation, Sciences et Développement économique Canada.

L'exploitation est soumise aux deux conditions suivantes :

- (1) Cet appareil ne doit pas provoquer d'interférences.
- (2) Cet appareil doit accepter toute interférence, y compris les interférences susceptibles de provoquer un fonctionnement indésirable de l'appareil.

l'appareil numérique du ciem conforme canadien peut - 3 (b) / nmb - 3 (b).

This device meets the exemption from the routine evaluation limits in section 2.5 of RSS 102 and compliance with RSS 102 RF exposure, users can obtain Canadian information on RF exposure and compliance.

Cet appareil est conforme à l'exemption des limites d'évaluation courante dans la section 2.5 du cnr - 102 et conformité avec rss 102 de l'exposition aux rf, les utilisateurs peuvent obtenir des données canadiennes sur l'exposition aux champs rf et la conformité.

This equipment complies with Canada radiation exposure limits set forth for an uncontrolled environment.

Cet équipement est conforme aux limites d'exposition aux rayonnements du Canada établies pour un environnement non contrôlé.

This equipment should be installed and operated with minimum distance 20cm between the radiator and your body.

Cet équipement doit être installé et utilisé à une distance minimale de 20 cm entre le radiateur et votre corps.

EU Conformity with applicable directives



This equipment complies with the essential requirements listed below:

- Radio Equipment Directive (RED) 2014/53/EU
- RoHS 2 Directive 2011/65/EU with Directive (EU) 2015/863

UK Conformity with the relevant Union harmonization legislation



This equipment complies with the essential requirements listed below:

- Radio Equipment Regulations 2017
- Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012

Disposal and Recycling Information



The symbol indicates that this product should be disposed of separately from regular household waste streams. It is your responsibility to dispose of this and other electrical and electronics products via designated collection facilities appointed by the government or local authorities. Correct disposal and recycling will help prevent potential negative consequences to the environment and human health. For more detailed information about the disposal of your unwanted product, please contact your local authorities, waste disposal service, or the shop where you purchased the product.

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