USER MANUAL

REVO OS

System version 1.4.33 · November 2026

Revon printers: Belt 350 · 600×600×400 · 600×600×600 · 1200×600×500



REVON BELT

350 × 350 × 300 mm · pas

Revotech Sp. z o.o. · revotech3d.com · biuro@revo3d.pl · +48 512 960 411

User manual for **Revo OS 1.4.33** (there is also a quick guide) for Revon printers (Belt 350, 600×600×400, 600×600×600, 1200×600×500). It starts with the basics – what is on the screen and how to switch the machine on – and goes through daily work to calibration, maintenance and commands. The latest version is always at revotech3d.com/revo-os-manual. *[r]evo – sometimes evolution, sometimes revolution.*

Download the manual (PDF)

Part I – Basics

1. What Revo OS is
2. Safety
3. How to read the screen
4. First start

Part II – Daily work

5. Home screen
6. Filament and spool
7. Nozzle
8. Preparing files – Orca Slicer
9. Printing
10. Materials and the chamber door

Part III – Revo Panel and your team

11. Revo Panel in the browser
12. Operators and access
13. Print cost
14. Menu → More

Part IV – Maintenance and service

15. Maintenance and counters
16. Machine test and self-diagnostics
17. Remote service
18. Updates

Part V – Advanced

19. Filament calibration
20. Commands

Part VI – Help

21. Messages and troubleshooting
22. Data and privacy
23. Contact

Part I – Basics

1. What Revo OS is

Revo OS is the control system of Revon printers. Underneath runs **Klipper** (the Kalico edition) – the software that drives the motors and heaters. On top of it Revotech built everything the operator touches:

- the **machine touchscreen** with the **OrionUI** look – status, temperatures, printing, filament, nozzle, machine test,
- **Revo Panel** – the same machine in a browser on a computer, tablet or phone, with camera, history and costs,
- the **Revo agent** – watches heater safety, counts filament and part wear, runs self-diagnostics and (with your consent) sends notifications to service,
- **Revo Library** – guides, a materials table, a glossary and test models, available straight from the screen.

You prepare print files in **Orca Slicer** with Revotech profiles. The machine prints only such files – this guarantees the settings match the machine and nozzle.

2. Safety

- **E-STOP** (emergency stop) – on the motion screen, during printing, on the lock screen and in Revo Panel. Hold it for 1 second: the machine stops motors and heating immediately. Afterwards restart it with the button on the screen or by cycling the power.
- The nozzle heats up to 320°C, the bed/belt up to 100°C. Do not touch the toolhead or the bed during and right after printing.
- Keep the chamber door closed while printing. With ABS and ASA, ventilate the room. With PLA and PETG the machine tells you when to open the door (chapter 10).
- Do not leave the machine unattended during the first print with a new material. Revo OS watches heating (an alarm when the bed heats by itself or overheats) and the chamber temperature.
- Work inside the electronics is done only by Revotech service, with the power disconnected.

3. How to read the screen

Colours

Colour	Meaning
green	*READY* – the machine is ready, everything is fine.
orange	*HEATING*, calibration, warning – wait or check the message.
red	*ERROR*, alarm, E-STOP – read the message; if in doubt, call service.
blue	active or selected button, progress, heating in the hexagons.

Windows and hexagons

The screen is made of windows with a title bar (a red square ■ and a name, e.g. *SCHEMATIC VIEW* – the machine drawing, *TELEMETRY* – readings). Temperatures are shown as hexagons made of dots: the more dots light up, the closer the target temperature. The vertical bar on the left edge has the colour of the machine state – visible from across the room.

Bottom bar

Every screen has at the bottom: ⟲ (*back*), ▦ (*home screen*) and ⏻ (*power* – shut down or restart, confirmed with a second tap). Buttons that change something in the machine usually need a second tap too.

4. First start

The first start takes about fifteen minutes (plus about 20 minutes for the machine test).

1. **Wizard** – on first start the screen guides you step by step (*STEP 1 / 5*): *WELCOME*, network, consents, installed nozzle and machine test. *LET'S START* begins, *NEXT* moves on.
2. **Network** – a LAN cable is the most reliable. Set up Wi-Fi in *Menu* → *More* → *Network*: pick the network from the list and enter the password. The machine IP address is shown on the top bar of the screen.
3. **License** – you get the license number (`REVO-XXXX-…`) from Revotech with the machine. Enter it once in *Menu* → *More* → *License* and tap *ACTIVATE*. It works without internet too.
4. **Consents** – the machine asks whether to send error notifications to Revotech (recommended – help comes faster) and work statistics. Machine state and working hours are always sent. Change consents in Revo Panel → *Service*.
5. **Nozzle** – select the installed nozzle: *DIAMETER* and material (*Brass*, *Hardened steel*, *Tungsten*).
6. **Manager account in Revo Panel** – on the screen open *Menu* → *More* → *Operator*: a 6-digit code valid for 10 minutes appears. In the browser enter the machine address (e.g. `http://192.168.0.38`), choose *CODE FROM SCREEN*, enter the code and create the manager account (name, login, 4–8 digit PIN).
7. **Machine test** – finally run the full test (chapter 16). We do it at handover and after every transport.

Panel on phone – *Menu* → *More* → *Panel on phone* shows a QR code. Scan it with a phone on the same network and Revo Panel opens.

Part II – Daily work

5. Home screen



Revo OS home screen (OrionUI).

- **Top bar**: state (*READY*, *PRINTING*, *PAUSED*…), connection (LAN / Wi-Fi with signal strength and IP address), clock. Below it "System OK", working hours (h) and the Revo OS version.
- **SCHEMATIC VIEW** – a drawing of the machine with three hexagons below: *NOZZLE*, *BELT/BED* and *CHAMBER*. *SET 215°* is the target temperature, *OFF* – heating off, *PASSIVE* – chamber without a heater. Tap the nozzle or belt/bed to set the temperature.
- **TELEMETRY** – diameter of the installed nozzle (e.g. Ø0.4) and *LIGHTS On/Off* (tap to toggle).
- **FILAMENT** – material and how much is left on the spool (grams, %). Tap to set a new spool.
- **OPERATOR** – who is working on the machine.
- **START PRINT** – the file list.
- **PLA / PETG / ABS/ASA** – heat the nozzle and belt/bed with one tap; **Heaters off**.
- **Bottom menu**: *Filament*, *Nozzle*, *Files*, *Menu*.
- **Message bars**: *SERVICE DUE*, a running test, the red remote service bar.
- **Screensaver** – after 5 minutes of inactivity: a large clock, machine state, a dimmed schematic and temperatures. *TOUCH TO WAKE* – tap anywhere to return.
- **Messages** appear as a bubble at the top of the screen and disappear by themselves.

6. Filament and spool

Step-by-step filament change

The easiest way: *Filament* → *FILAMENT CHANGE – STEP BY STEP*. The machine guides you through choosing the material, heating, unloading the old filament, loading the new one and setting the spool.

Load manually

1. Heat the nozzle – a material preset or the temperature in the *NOZZLE TEMPERATURE* tile. The nozzle must be at least 180°C.
2. Cut the filament end at an angle. A blunt, squashed end often does not enter the extruder.
3. Push the filament into the toolhead until you feel the gears, then tap *LOAD FILAMENT*. The machine feeds 100 mm and purges the nozzle.
4. An even strand in the new colour should come out of the nozzle. Remove the excess with pliers – do not touch the nozzle.

Unload

UNLOAD FILAMENT: the machine heats the nozzle, pushes out a little material and retracts the filament. Pull it out gently and secure the spool end.

Extrusion

EXTRUDE feeds filament at the selected flow (*FLOW*, in mm^3/s) for the selected time (*TIME*). Values above the nozzle capacity (*nozzle limit*) are blocked. *RETRACT 5 mm* pulls the filament back.

Spool

The machine subtracts usage after every print and warns before the start if filament may run out. After mounting a new spool choose its weight (*NEW FULL SPOOL* – 1 kg, 0.75 kg…) or *ENTER REMAINING (g)*.

When something goes wrong

- **Filament does not go in** – check that the end is cut at an angle and has no bulge.
- **Nothing comes out of the nozzle** – wait until the nozzle reaches temperature. If still nothing, run the machine test and report the result.
- **The extruder clicks** – temperature too low or a clogged nozzle. Do not force it.

7. Nozzle

Which nozzle for what

Nozzle	Use
Brass	PLA, PETG, ABS, ASA, TPU without additives. Best heat conduction, wears fastest.
Hardened steel	Fibre-filled materials: CF (carbon), GF (glass), glow-in-the-dark, metal-filled.
Tungsten	Abrasive materials at high volumes; durable and conducts heat well.

Diameter: **0.4** for most parts, **0.6–0.8** for large, strong parts and fast printing, **0.25** for fine detail. Print fibre-filled materials with at least 0.4, preferably 0.6.

Set the installed nozzle

Bottom menu *Nozzle* → *INSTALLED NOZZLE*: diameter and material → *Save*. Before every print the machine compares it with the nozzle stored in the file and asks if they differ.

Nozzle change

Replace nozzle (in the nozzle window) or *Menu* → *More* → *Nozzle change* starts a guided change in 6 steps: choose the new nozzle, unload filament, heat to 250°C, unscrew the old one, screw in the new one and save. The nozzle is changed hot, with gloves, using a 7 mm wrench. The nozzle wear counter resets after Revotech approves it. If you are not experienced with this, call service.

8. Preparing files – Orca Slicer

Revo OS works closely with **Orca Slicer**. Tested Orca versions are available in the Software section.

1. **Revotech profiles (Revo Sync)** – close Orca and install once on the computer:
   Windows (PowerShell): `irm https://revo3d.pl/orca/revo-sync.ps1 | iex`
   macOS (Terminal): `curl -fsSL https://revo3d.pl/orca/revo-sync.sh | bash`
   You get Revon printers (with bed model and logo), the *Revo 0.20mm Standard* print profile and Revotech filaments. They update themselves at login and every 6 hours and never change your own profiles. Save a modified profile under your own name (Save as).
2. **Connecting to the machine** – a manager in Revo Panel → *Service* → *SHOW CONNECT COMMANDS* copies the ready command (with address and API key) and runs it on the computer. The printer "My Revon … @ address" appears in Orca.
3. **Sending** – the *Send* button in Orca uploads the file to the machine (and can start printing straight away). The *Device* tab shows Revo Panel.
4. The profiles' start G-code contains the nozzle check and PRINT_START – do not remove these lines.

The machine rejects files from other slicers right after upload – the screen shows *File from another slicer removed*.

9. Printing

Start

1. Send the file from Orca or upload it in Revo Panel (drag the file onto the *Files* tab).
2. On the screen: *START PRINT* → choose the file (thumbnail, time, material, filament needed) → *Print*. You can enable *timelapse* and – on the Belt – the number of copies (series).
3. Before printing the machine checks the **nozzle** (installed versus file – if they differ it asks: *Print* prints anyway, *Cancel* cancels) and the **filament on the spool**.
4. PRINT_START: bed heating, gantry leveling, bed mesh, nozzle heating – then printing.

During printing

- Progress, time left (*REMAINING*) and finish time, time since start (*ELAPSED*), *LAYER*, temperatures.
- Camera view on the screen and in Revo Panel.
- *Pause / Resume*, *Cancel* (with confirmation), *Fine Tuning* (speed, flow, Z).
- After the first layer the camera takes a photo (visible in Revo Panel). On a sudden image change (e.g. a detached print) the machine warns: *Camera: sudden image change*.

After printing

- **Belt**: hold *EJECT (hold)* and the belt pushes the print out the front. In a series the belt ejects each copy by itself.
- **Rigid bed**: remove the print; with a print queue confirm *BED CLEAR – PRINT NEXT*.
- History, time, filament and cost – Revo Panel → *History*.

10. Materials and the chamber door

Values are indicative. The Orca profiles for your machine are binding.

Material	Nozzle °C	Bed °C	Chamber / door	Nozzle	Drying
PLA	200–220	55–65	door open	brass	45–50°C, 4–6 h, when damp
PETG	230–250	70–85	ajar for long prints	brass	60–65°C, 4–6 h
ABS / ASA	240–265	95–110	closed, warm	brass	70–80°C, 4 h
TPU	220–240	40–60	door open	brass, slow	50–55°C, 6 h
PA (nylon)	260–290	80–100	closed, warm	steel / tungsten	70–80°C, 8–12 h, always
PA-CF / PA-GF	270–300	80–100	closed, warm	hardened steel / tungsten	80°C, 8–12 h, always
PC	270–300	90–100	closed, warm	steel / tungsten	80°C, 8 h

Why the door matters

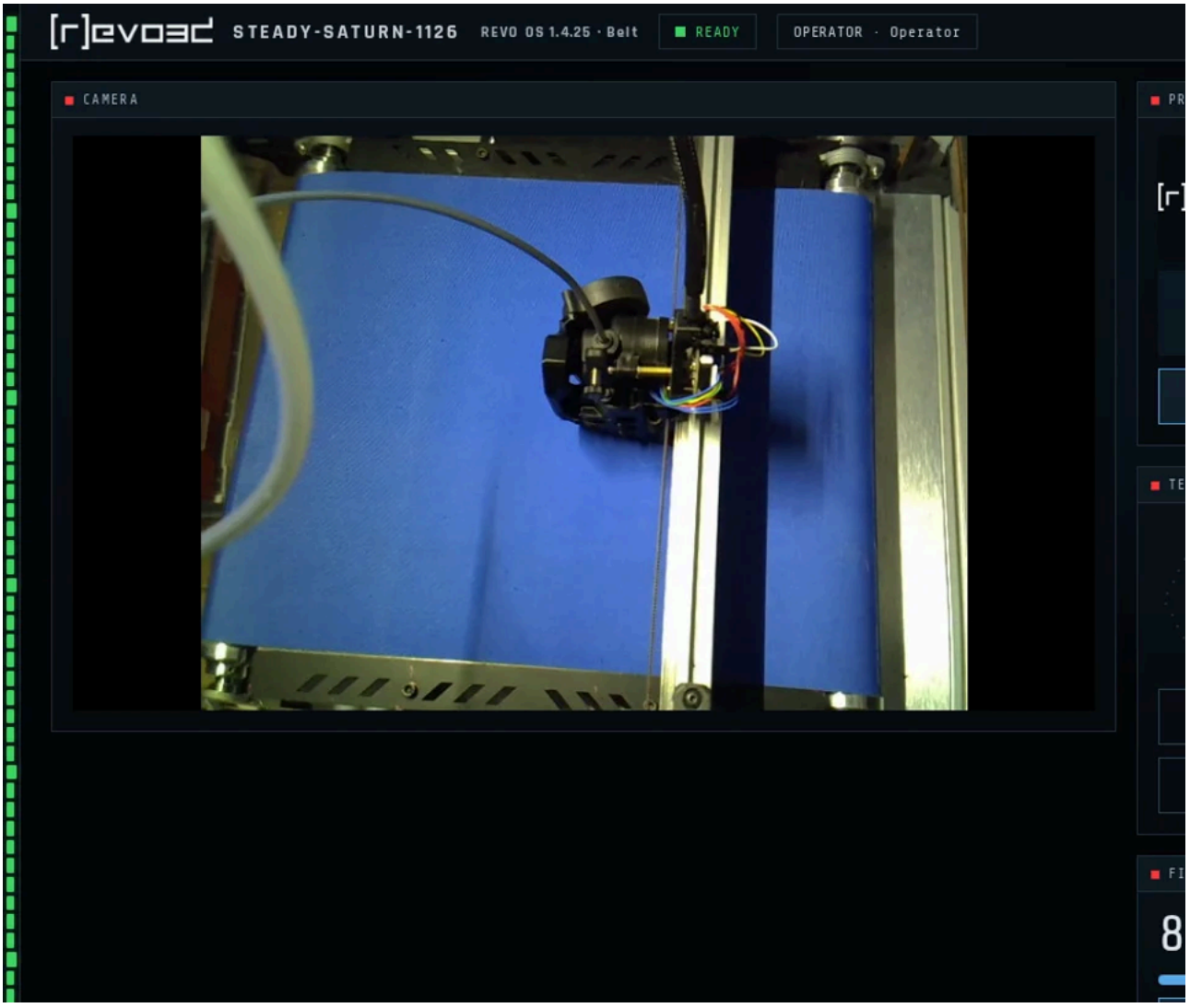
- **PLA, TPU** – above about 40°C in the chamber PLA softens in the cold zone of the toolhead and clogs the nozzle. The machine reminds you at the start: "Printing PLA – we recommend an open door".
- **PETG** – tolerates more heat, but above about 50°C the risk of clogging grows.
- **ABS, ASA, PA, PC** – a warm, closed chamber limits shrinkage and layer cracking.
- *Chamber too hot* – above 70°C with any material. Printing continues and the event goes into the service report. The machine does not stop a print because of the chamber – the decision is yours.

Fibre-filled composites wear the nozzle and extruder several times faster – the machine counts their wear separately. Nylon and PC absorb moisture within hours – print from a dryer.

Part III – Revo Panel and your team

11. Revo Panel in the browser

Enter the machine address in a browser (e.g. `http://192.168.0.38/` – the address is shown on the screen next to the clock) or scan the QR code. It works on a computer, tablet and phone on the same network. Sign-in is required (*SIGN IN*): operator + PIN, the shared *Operator* account without a PIN, "Revotech service" or the code from the screen (first sign-in).



Revo Panel – Dashboard tab.

Tab	Contents
Dashboard	Camera, state, progress, temperature hexagons, presets, spool, working hours, recent messages.
Files	Files with thumbnails, upload (drag onto the page), start, delete, print queue.
History	12-month statistics, print cost, history with *PRINT AGAIN*, timelapses, camera photos.
Motion	Homing, axes, belt (Belt), E-STOP.
Filament	Loading, extrusion in mm^3/s, nozzle.
Bed mesh	Colour flatness map, new measurement, profiles.
Console	Machine commands as buttons and Klipper replies (advanced).
Library	Revo Library, including the glossary.
Service	Contact and *REPORT ISSUE*, consents, maintenance, machine test, Orca connect commands, operators, license, SYSTEM (versions, self-diagnostics).

The administrator panel (Mainsail) runs on port 8088 and is intended for Revotech service.

12. Operators and access

- The **manager** (*MANAGER*) adds and removes operators, resets PINs and sees the Orca API key. An **operator** runs the machine and prints.

- **Two ways of working**: named operators (the manager adds them in Revo Panel → *Service*: name, login, PIN) – the history shows the actual person; or the shared **Operator** account without a PIN – for companies that do not want to create accounts.
- Signing in on the screen: *Menu* → *More* → *Operator* → choose yourself → PIN. In the browser: login + PIN. A browser session lasts up to 12 h. After 5 wrong attempts – a 15-minute lockout.
- **Forgotten PIN**: the manager clicks *RESET PIN* next to the operator. The manager's PIN is reset remotely by Revotech service. After a reset the PIN is **0000**, and a new one must be set at the first sign-in.
- Without signing in nobody on the network can control the machine, download files or see the camera. Orca sends files only with the API key.
- **Screen lock** – optional: *Menu* → *More* → *Screen lock* → *TURN ON AND SET PIN*. The screen locks after inactivity, printing continues and E-STOP always works.

13. Print cost

Revo OS estimates the cost of every print: *filament* (usage × price per kg) + *electricity* (measured heater work + electronics × price per kWh). Set prices in Revo Panel → *History* → *CHANGE POWER AND FILAMENT PRICES*. You see the last print, the 30-day total and a list of prints with the operator.

14. Menu → More

On the screen	Purpose
Move	Homing (*HOME*), moving axes with the chosen step, belt (Belt), E-STOP.
Temperature	Temperatures and material presets.
Report a problem	A service request (type, description, phone) – with the last error, log and camera photo.
Revo Library	Glossary, guides, materials, profiles, test models.
Service mode	For Revotech service (service PIN). Every entry is reported.
About system	Component versions, machine ID, network address, self-diagnostics result.
Panel on phone	QR code with the Revo Panel address.
Nozzle change	Guided nozzle change.
Operator	Sign in and *SIGN OUT*, code for the first browser sign-in.
Screen lock	PIN lock after inactivity.
Maintenance	Maintenance due dates, confirming completion (*DONE*).
Machine test	Full test with step pictures.
Network	LAN / Wi-Fi with IP address, network list, password, *FORGET NETWORK*.
License	License number – entered once, works without internet.
Screen mode	Emergency switch to standard KlipperScreen and back – in case of screen problems.
⏻ (power)	*SHUT DOWN MACHINE* or *RESTART* – confirmed with a second tap, unavailable while printing. Wait 30 s before cutting the power.

Part IV – Maintenance and service

15. Maintenance and counters

Maintenance	Every	What to do
Nozzle	200 h	Wear, leaks, hot tightening. Replace if the orifice is worn out.
Belt, belts and axes	500 h	Belt tension, rails, axis play; clean and lubricate the rails. On the Belt also the conveyor belt and its guidance.
Full service	1000 h	Electronics, cables, fans, heating, calibration – preferably with Revotech service.

The machine counts hours and reminds you about maintenance on the screen (*SERVICE DUE*), in Revo Panel and (with consent) by e-mail. When done, tap *DONE* in *Menu* → *More* → *Maintenance*. Parts have their own counters too: nozzle, extruder, belts, bearings, CAN board – after a replacement the counter resets once Revotech approves it.

16. Machine test and self-diagnostics

Full machine test

Menu → More → Machine test → START TEST. It takes 15–25 minutes. Run it after installation, after transport, after replacing parts and when prints suddenly go bad. Remove prints and load filament.

1. **Electronics link** – the mainboard and toolhead respond.
2. **Thermistors** – temperature readings are plausible.
3. **Motors** – each motor twitches 10 times; you confirm only that one moved.
4. **Belt drive** (Belt) – the belt moves and returns.
5. **Endstops / homing** – endstops and axis homing.
6. **Axis move** – each axis moves in the right direction by the right distance.
7. **Gantry leveling, probe repeatability**.
8. **Nozzle / bed heating** – nozzle to 200°C and belt/bed to 60°C.
9. **Fans, extrude, filament sensor, lights, touchscreen**.

You answer questions with *WORKS* or *PROBLEM*. For endstops, hold the endstop with a finger and tap *CHECK*. Heating can be skipped – *SKIP*: the step gets a yellow flag but does not fail the test. "Problem" is not a failure, just information for service. You can stop the test at any time (*ABORT*) – the machine turns heating off. The result goes to Revotech.

Daily self-diagnostics

Once a day, when the machine is not printing, Revo OS runs a short check without moving the axes: motor drivers, communication with the boards, temperature sensor noise, heating rate (compared with previous days), fans and the control computer. Result: *OK*, *ATTENTION* (plan a service) or *NEEDS SERVICE* (report a problem). It is shown in *About system* and in Revo Panel → *Service* → *SYSTEM*.

17. Remote service

Revotech service works remotely. When we need access, the screen shows the request *Revotech requests remote service* (camera and screen view plus service commands for 30 min). You answer *ALLOW* or *DECLINE* – without your consent we have no access. During the session a red bar is shown on the screen; tapping it ends the session immediately. Every command is digitally signed and written to the machine log.

18. Updates

Revo OS updates come only from Revotech servers – first to our test machines, then to customers. The machine installs them when it is not printing: the screen shows *Revo OS update ...: The machine will be unavailable for about 2–5 min. Do not switch off the power*. Update commands are signed and verified. Version history: revo3d.pl/revo-os.

Part V – Advanced

19. Filament calibration

Revotech filaments come with ready, tested settings. Calibrate your own filament in Orca Slicer (the *Calibration* menu). Start with dry filament and a suitable temperature, run the tests in this order and save each result in the filament profile.

1. **Temperature** – *Calibration → Temperature*: a temperature tower. Pick the segment with the best bridges, overhangs and surface, without strings.
2. **Flow rate** – *Pass 1*, optionally *Pass 2*. Pick the smoothest block. New flow = current × (100 + correction) / 100.
3. **Pressure advance** – line method (fast) or tower (more accurate). Pick the line with the most even width. Typical for direct drive: PLA 0.02–0.06, PETG 0.04–0.10, TPU 0.08–0.30. Each material has its own value.
4. **Retraction** – the smallest value at which strings disappear. If strings stay despite large retraction, dry the filament and lower the temperature by 5°C.
5. **Max flowrate** – read where the surface starts to break down and enter 10–20% less. A High Flow hotend passes about 50 mm^3/s of PLA, Standard about 25.

Input shaper (frame vibration) is set by Revotech service at handover – no need to repeat it. Want a ready profile for your material? We will set it up for you.

20. Commands (G-code / macros)

Command	Action
`PRINT_START BED= EXTRUDER= CHAMBER= MATERIAL=`	Print preparation (heating, gantry leveling, bed mesh). Called from the Orca profile.
`PRINT_END`	End of print: retraction, heaters off, toolhead parked.
`REVO_CHECK_NOZZLE NOZZLE=0.4`	Nozzle check before printing (in the start G-code).
`REVO_SET_NOZZLE`	Stores the installed nozzle (the screen does this for you).
`LOAD_FILAMENT` / `UNLOAD_FILAMENT`	Load / unload filament (nozzle at least 180°C).
`REVO_SELFTEST`	Full machine test.
`REVO_SERIA_PRZERWA`	Between queued prints: the Belt ejects the print, a rigid bed waits for confirmation.
`CLEAR_BELT` / `CLEAR_BELT_200`	Belt: moves the belt by 100 / 500 mm.

Command	Action
`REVO_POZYCJA_SERWISOWA`	Toolhead to the nozzle change position.
`PAUSE` / `RESUME` / `CANCEL_PRINT`	Pause, resume, cancel the print.
`M600`	Filament change during a print (pause).
`G28`, `QUAD_GANTRY_LEVEL`, `BED_MESH_CALIBRATE`	Homing, gantry leveling, bed mesh.
`MPC_CALIBRATE HEATER=extruder`	Heater model calibration (service).
`SHAPER_CALIBRATE`, `PROBE_ACCURACY`	Input shaper, probe repeatability (service).

Part VI – Help

21. Messages and troubleshooting

Message	What to do
File prepared for nozzle ...	Install the nozzle from the file or slice the file for the installed nozzle. *Print* prints anyway, *Cancel* cancels.
File from another slicer removed	Slice the file in Orca Slicer with Revotech profiles.
Filament may run out	Prepare a new spool or set the correct spool level.
Axes are not homed	Tap *HOME ALL*.
Heat the nozzle to at least 180°C...	Loading and unloading need a hot nozzle – choose a material preset.
Chamber door is open	Close the door and start the print again.
Chamber too hot	Open the chamber door; keep it open for PLA and PETG.
Bed heats by itself / Bed too hot	Switch the machine off with the main switch and call service.
Bed not reaching temperature	Close the door; if it happens again – *Report a problem*.
Heating error / Heater ... not heating at expected rate	Check the heater and thermistor cables; *Report a problem*. Restart: ⏻ on the bottom bar.
Camera: sudden image change	Check whether the print has detached or shifted.
Self-diagnostics: worth checking	The result went to Revotech – we will contact you. You can send *Report a problem*.
The PIN was reset	Sign in with PIN 0000 and set a new one.
License locked / Trial – days left	Enter the license number in *Menu* → *More* → *License* or contact Revotech.
The screen does not respond or looks wrong	*Menu* → *More* → *Screen mode* → *SWITCH TO KLIPPERSCREEN* (emergency screen), then call service.

Most common machine setup problems

Problem	Cause	What to do
First layer too thin, transparent, the nozzle scratches the bed	nozzle too low (Z offset)	During the first layer use *Fine Tuning* → raise Z by 0.02–0.05 mm; save the value.
First layer round "spaghetti", does not stick	nozzle too high or a dirty bed	Lower Z by 0.02–0.05 mm in *Fine Tuning*; clean the bed (no fingerprints).
Good layer only on part of the bed	old bed mesh or a skewed gantry	Revo Panel → *Bed mesh* → *NEW MEASUREMENT*; *Move* → *GANTRY LEVELING*.
Print corners lift (warping)	bed too cold or open chamber with ABS/ASA	Raise the bed temperature by 5–10°C, close the door for ABS/ASA/PA, use glue or a release agent.
PETG tears pieces out of the plate	adhesion too strong	Glue stick as a separator, bed 70–75°C.
Strings and "hairs" between features	damp filament, too hot	Dry the filament, lower the temperature by 5°C, check retraction.
PLA clogs the nozzle mid-print	chamber too warm	Print PLA with the chamber door open.
The machine asks about the nozzle before every print	file sliced for a different nozzle than set	Set the installed nozzle in *Nozzle* or slice the file for the right nozzle.
The file disappears right after upload	file from another slicer	Slice in Orca Slicer with Revotech profiles (Revo Sync).
Orca does not see the printer / does not send	no connection or a different network	Computer on the same network as the machine; run the command from Revo Panel → *Service* → *SHOW CONNECT COMMANDS* again.

Problem	Cause	What to do
No Revon printers in Orca	Orca was open during the Revo Sync install	Close Orca completely and start it again.
Wi-Fi does not connect	wrong password or a corporate network (802.1X)	*FORGET NETWORK* and connect again; on a corporate network use a LAN cable.
Revo Panel does not open in the browser	wrong address or a different network	The address is on the screen next to the clock; phone/computer on the same network; QR code: *Panel on phone*.
Filament does not go into the toolhead	cold nozzle, squashed end	Nozzle at least 180°C, cut the end at an angle, push until the gears grip.
Belt: the print does not slide off the belt	adhesion too strong, belt still warm	Wait until the belt cools, then hold *EJECT*.
The extruder clicks, weak layers	temperature too low or flow too high	Raise the temperature by 5–10°C or slow the print down; check the nozzle flow limit.

Nothing helps? Run the *Machine test* and send *Report a problem*.

Print problems

- **The print does not stick** – clean bed without fingerprints; check the bed temperature and the first layer; use a release agent for PETG.
- **Strings** – dry the filament, lower the temperature by 5°C, check retraction (chapter 19).
- **Weak, delaminating prints** – temperature too low or flow too high; close the chamber for ABS/ASA.
- **Nothing helps** – run the machine test and send *Report a problem*.

22. Data and privacy

- Always: machine state, working hours, system version, self-diagnostics result, maintenance.
- With consent: error notifications, work statistics, part counters, e-mail reminders. Statistics history is kept on the machine and, if you consent later, is sent to Revotech in full.
- Only at your request: *Report a problem* requests (with log and photo), remote service.

23. Contact

Revotech service: **+48 512 960 411**, biuro@revo3d.pl, Mon–Fri 9:00–17:00 (CET). We reply in English. Fastest: screen → *Menu* → *Report a problem* – the request automatically includes machine data, the last error and a camera photo.