



# Getting started with 3D printer

Haenau - Big Box



# Stage 1: Slicing:

Open your 3D model in slic3r,

Then On the SD there is a profile for slic3r, Import this profile.

**DO NOT CHANGE THE FILE ON THE SD CARD.**

Slice your model, and check everything looks good, such as infill, support material, and wall count/thickness.

**If in doubt ASK !!**

Save your new .GCODE file to the SD Card, noting the filename.

# Step 2: Getting ready:

Switch on the power supply,

Insert SD Card.

Scroll through the menu system and select:

Prepare | Preheat PLA | Profile 1

Which will start heating the print surface to 60°C and the nozzle to 180°C. CAUTION from now on the printer is not child safe.

Allow about 5 to 10 minutes for the print bead to reach target temperature.

# Step 3: Start print :

When the temperature is stable, then you can start !

In the menu, select print from SD, select your file.

The hot end will now need to heat up about 25°C,

And then the X, Y, and Z will home, and start your print.

# Step 4: First layer:

The first layer is THE MOST IMPORTANT OF ALL !!

During the beginning of the print, the printer will lay down a loop of plastic, just outside the model,

This is the best time to tweak layer height.

Too far away - bobbly unattached mess.

Nearly close enough - round layer not sticking to bed.

Just right - squashed oval.

Just too close - squashed oval, with a groove inside.

Too close - no or intermittent feeding.

**WAY TOO CLOSE - gouging print surface, resulting in you buying me a new print bed.**

# Stage 5: Bottom layer:

First layer of model.

This SHOULD be flat and reasonably smooth,

With little or no ridges (slightly too close)

And nearly no gaps between outside walls and infill.

In general, if your first 2-3 layers are good then the print will be too.

# All done:

It is very important to allow the heated bed to cool down to less than 28°C,

At this point, the model should just pop off the build plate.

Maybe with a little encouragement, depending on the amount of surface contact.