

Printing

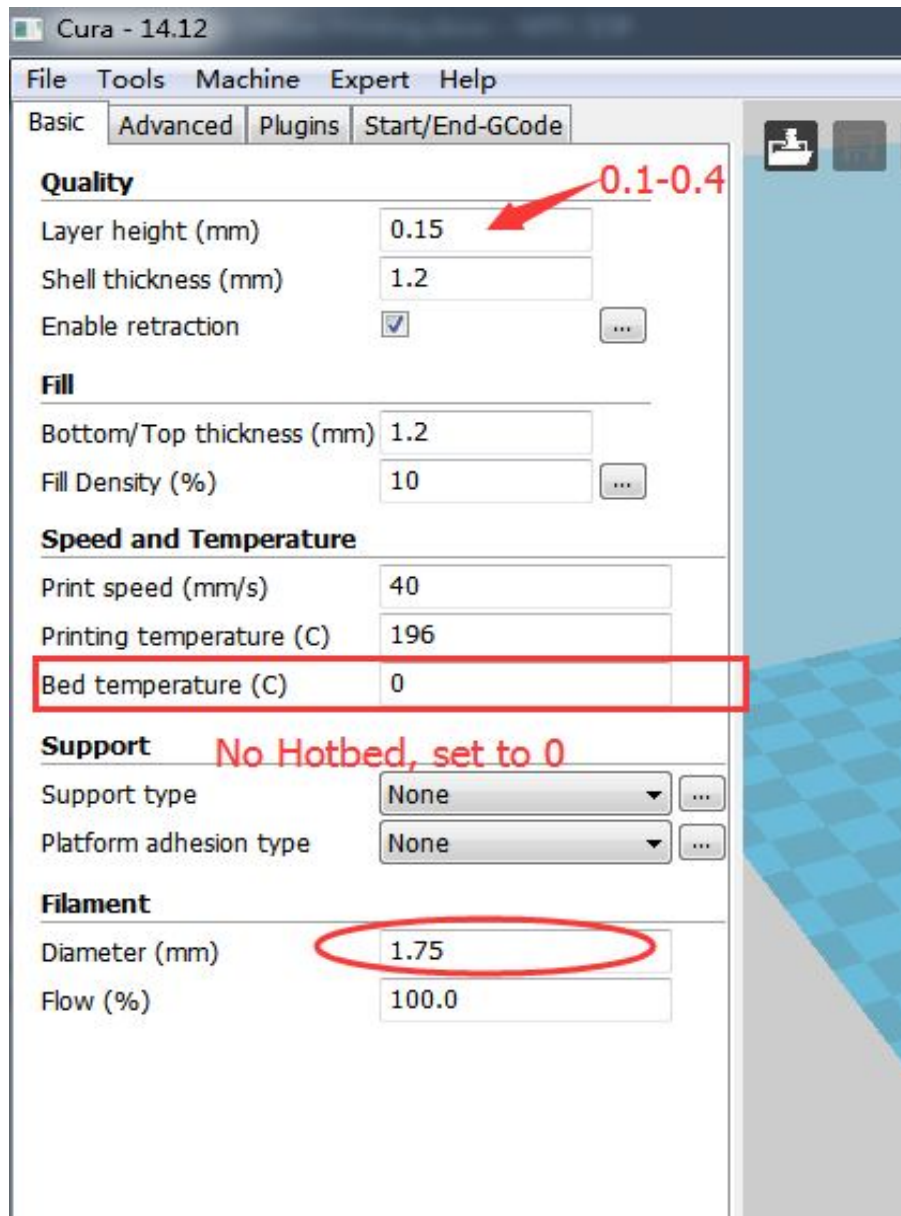
After completion of commissioning, you can try the official print. In general, the commissioning phase has solved the problems of the machine.

Before printing, you need to slice the .STL file to generate .Gcode that machine code can identify.

Slice software we offer is CURA, the software itself is simple and approachable.

To know more about the software CURA, you can view in "Step 3 install USB drivers and software" step. Below we will provide you with a reference configuration parameter file:

Reference configuration parameters



Cura - 14.12

File Tools Machine Expert Help

Basic **Advanced** Plugins Start/End-GCode

Quality

Layer height (mm) 0.15 *0.1-0.4*

Shell thickness (mm) 1.2

Enable retraction

Fill

Bottom/Top thickness (mm) 1.2

Fill Density (%) 10

Speed and Temperature

Print speed (mm/s) 40

Printing temperature (C) 196

Bed temperature (C) 0

Support *No Hotbed, set to 0*

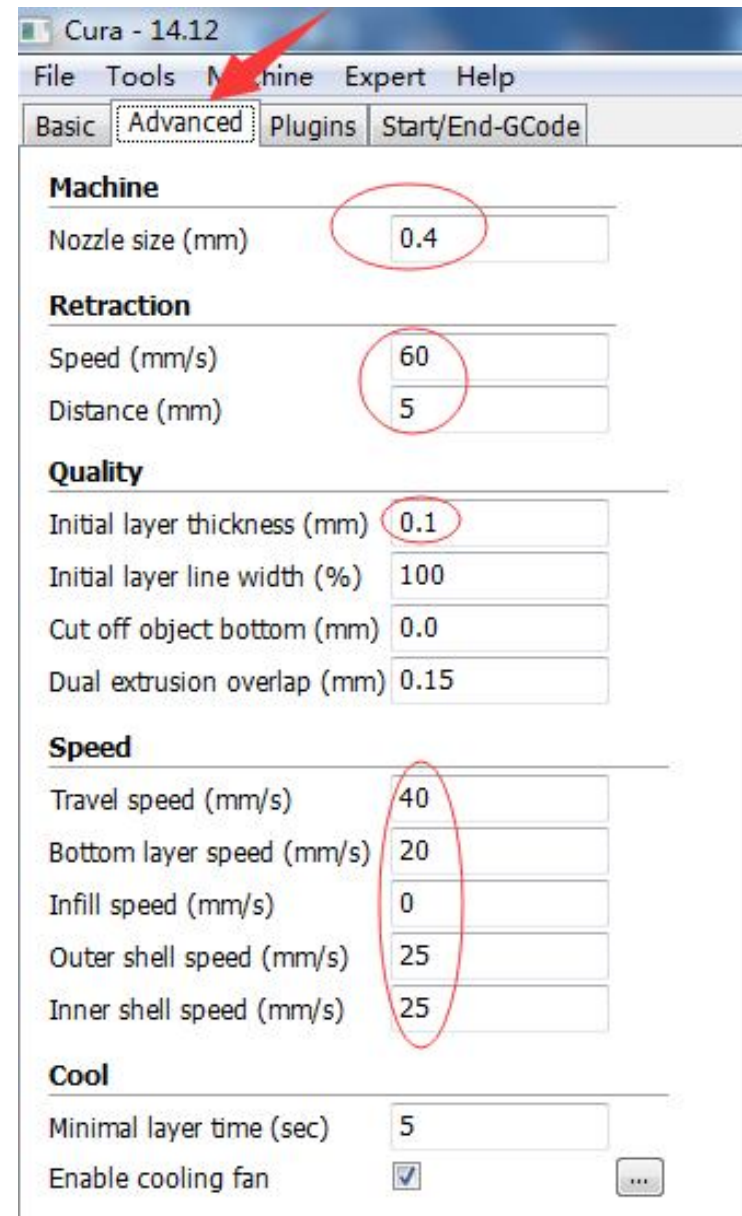
Support type None

Platform adhesion type None

Filament

Diameter (mm) 1.75

Flow (%) 100.0



Cura - 14.12

File Tools **Machine** Expert Help

Basic **Advanced** Plugins Start/End-GCode

Machine

Nozzle size (mm) 0.4

Retraction

Speed (mm/s) 60

Distance (mm) 5

Quality

Initial layer thickness (mm) 0.1

Initial layer line width (%) 100

Cut off object bottom (mm) 0.0

Dual extrusion overlap (mm) 0.15

Speed

Travel speed (mm/s) 40

Bottom layer speed (mm/s) 20

Infill speed (mm/s) 0

Outer shell speed (mm/s) 25

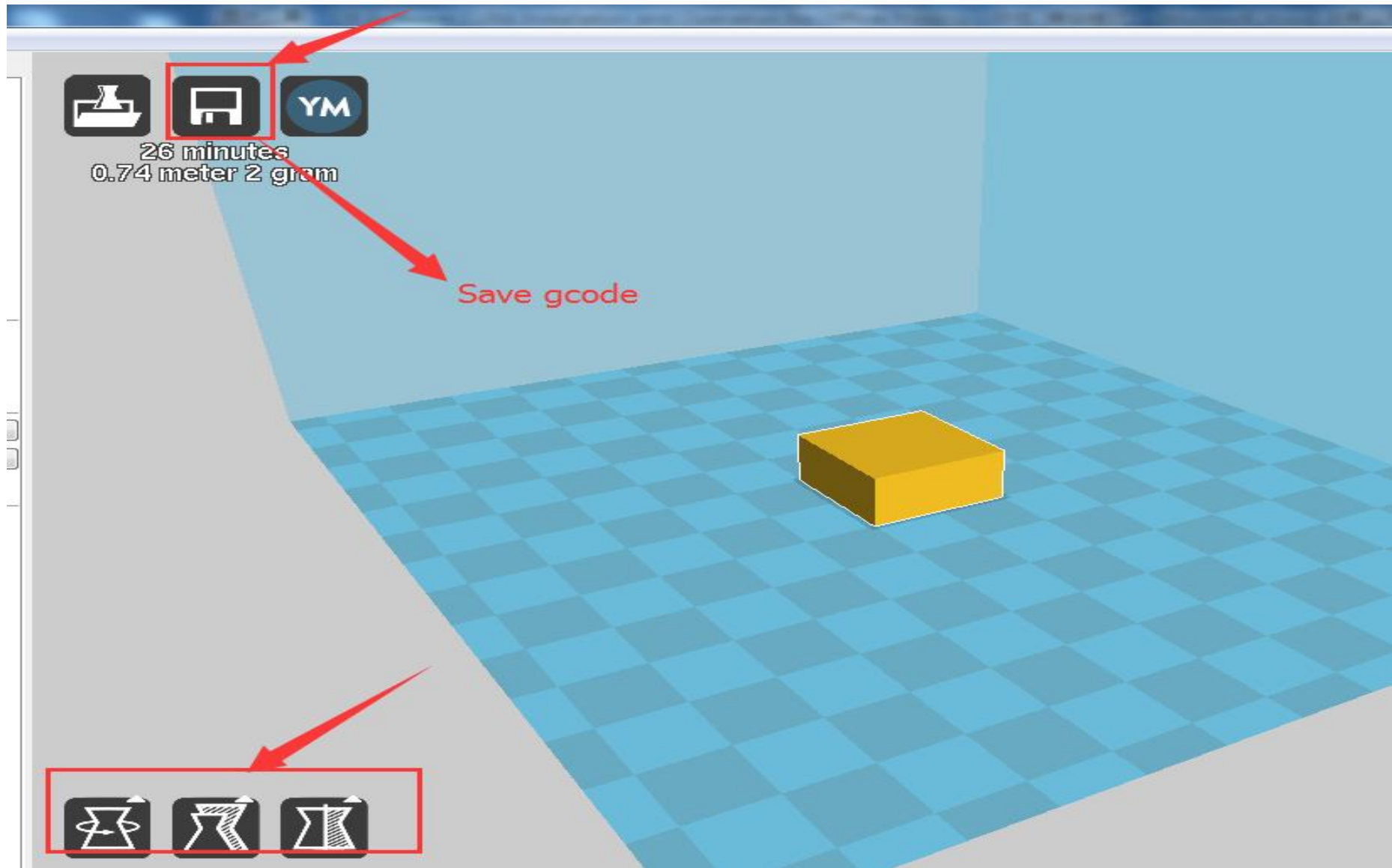
Inner shell speed (mm/s) 25

Cool

Minimal layer time (sec) 5

Enable cooling fan

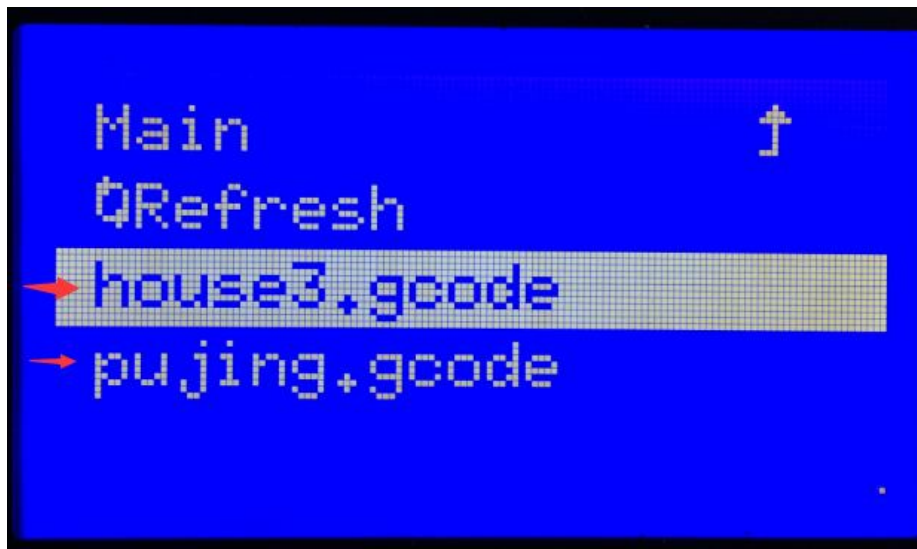
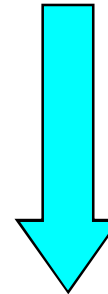
Save to SD card



LCD Screen Print



1. Select Print from SD card.



2. Select you just saved to TF / SD card file name, you can print.

When the official printing, the printer's warm-up order as "extrusion head preheat - machine back zero - start printing." Do not preheat nozzle too long, otherwise it will lead to two problems:

a. nozzle prolonged heating, easy to make long-term heating supplies charred head, causing nozzle clogging;

b. extruding head early heating, it is possible to cause the firmware have been waiting for "extrusion head heating is completed" instruction, which can not enter the "start printing" step.