Digital Lab 3D Printing

STEP ONE: SET UP

1. Make sure the extruders and bed are clean before calibration. Have whoever is working in The Hub, and knows how to 3D print, clean the extruders for you. **DO NOT TOUCH THE RED WIRES OR THE PRINTER WILL SHUT DOWN.**

2. To **Calibrate** the printer go to **UTILITIES**>**CALIBRATE**>**YES**. All the numbers must be near each other in order to work. The **X axis** is located in the **upper left**, the **Y axis** is the **upper right**, and the **Z axis** is located in the **back**. To calibrate correctly, turn the gears to the **RIGHT** to go **UP**, and the **LEFT** to go **DOWN**. Have whoever is working in The Hub assist with this step if you are unsure.

STEP TWO: PRINTING

1. Download an image from www.thingiverse.com **OR** upload one, if you already have it picked out, and **save it to the desktop**. The image **must be an STL file** in order to print.

2. Open **the XYZ software** and **IMPORT** the **STL file**. You can resize and move the image around.

3. To glue the bed down where your object will be printed, go to **UTILITIES**>**JOG MODE**>**Z AXIS** and **click** the **down arrow** until the bed is low enough to glue. Also glue down where the test strip will go depending on what color you chose to use. **Left side – for the left extruder; Right side – for the right extruder.**

4. Click the **Print** icon. Make sure the following settings are in place: daVinci 2.0 – ABS Good – auto repair. The extruders and bed will take a minute to heat up.

5. Let the printer cool down before removing your object.

STEP THREE: CLEAN UP

1. Once the printer has cooled down and the object has been removed, placed a damp paper towel on the bed for about 5-10 minutes, and wipe the glue off. Wipe once more with a dry paper towel.

2. Clean the extruders for the next person by going to **UTILITIES**>**CLEAN NOZZEL**. Use the wire toothbrush to clean the extruders, like in the beginning. Be sure **NOT TO TOUCH THE RED WIRES** connecting the extruders, the printer will shut down.

3. Log out of the computer and turn off printer when you are finished.