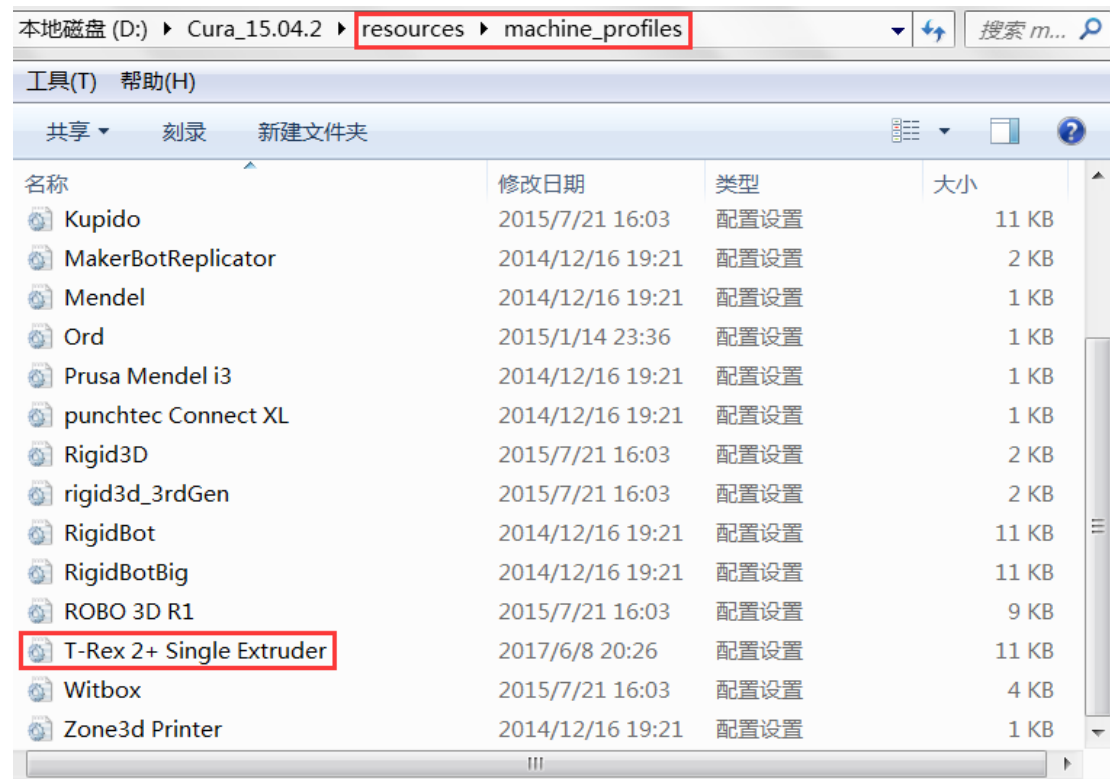


1. Load Profile

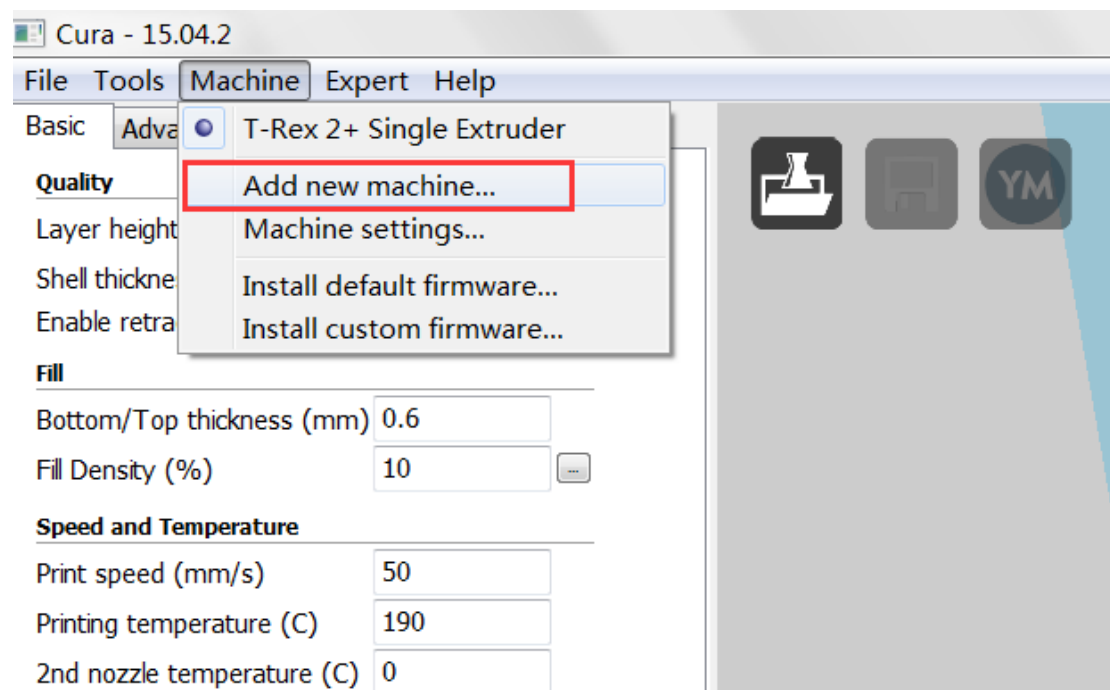
1.1 CURA

Install CURA, then open CURA root directory, choose “resources” -> “machine profiles”.

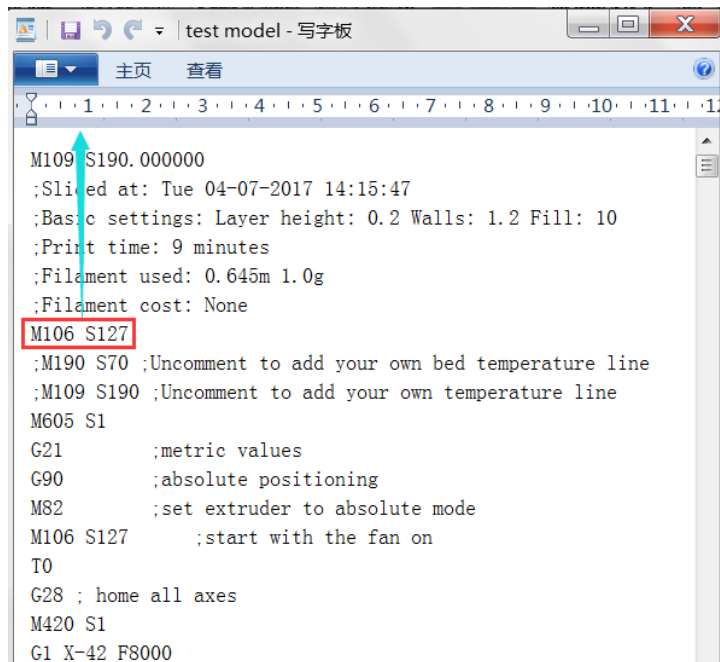
Copy profile to above “machine profiles” folder.



Open CURA, choose “Machine” -> “Add new machine”, then choose “Next” -> “Other” to find the profile of T-Rex 2+.



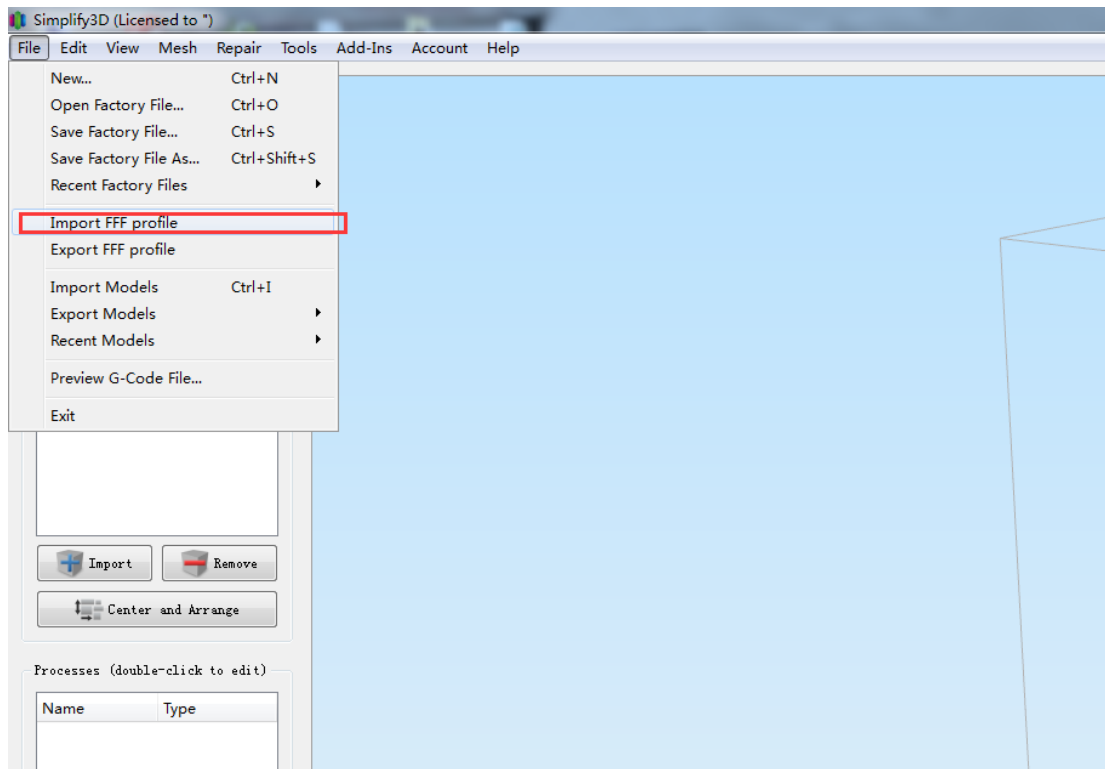
Note: If slice model by Cura, you need to revise the gcode as below:
move “M106 S127” to headmost, so the fan will be turned on before heating up.
But if you slice model by Simplify3D, it doesn’t need to revise.



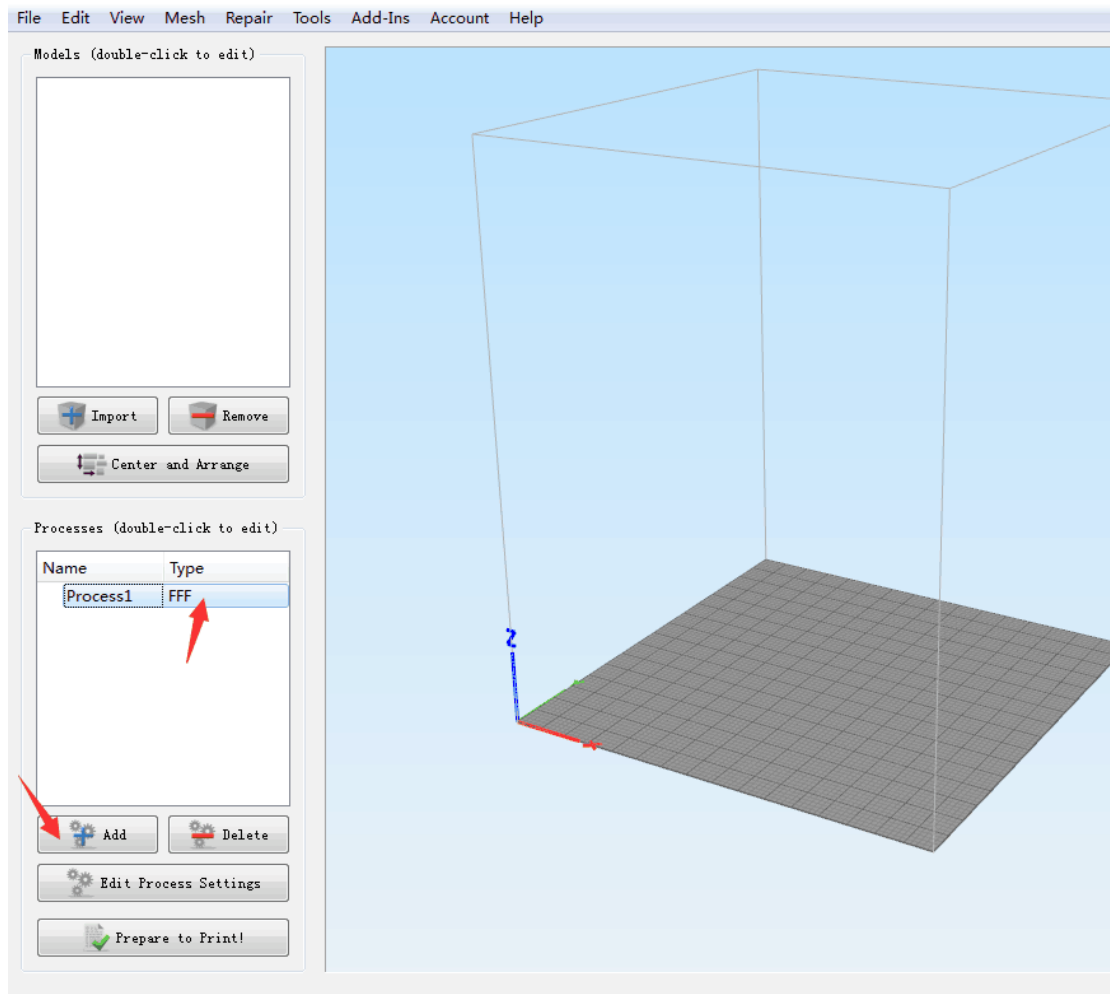
```
M109 S190.000000
;Sliced at: Tue 04-07-2017 14:15:47
;Basic settings: Layer height: 0.2 Walls: 1.2 Fill: 10
;Print time: 9 minutes
;Filament used: 0.645m 1.0g
;Filament cost: None
M106 S127
;M190 S70 ;Uncomment to add your own bed temperature line
;M109 S190 ;Uncomment to add your own temperature line
M605 S1
G21 ;metric values
G90 ;absolute positioning
M82 ;set extruder to absolute mode
M106 S127 ;start with the fan on
T0
G28 ; home all axes
M420 S1
G1 X-42 F8000
```

1.2 Simplify3D

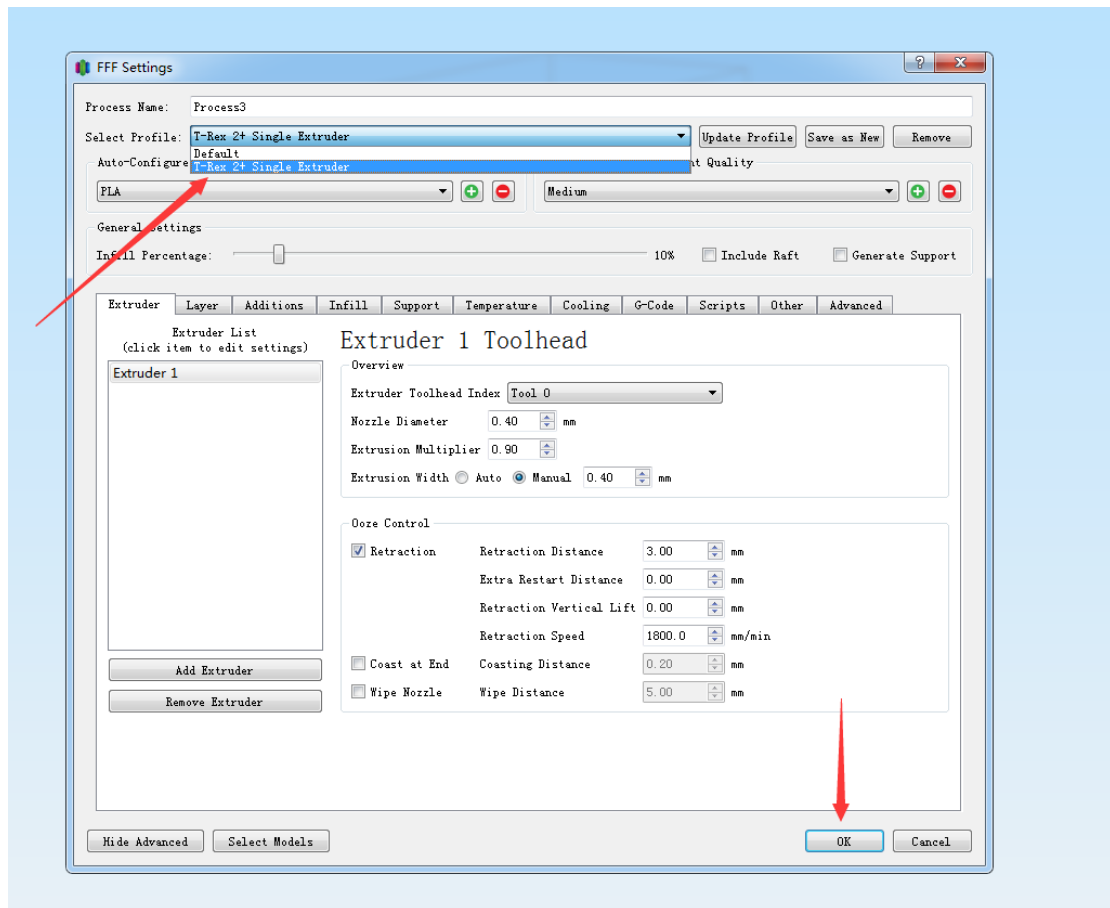
Install and open Simplify3D, choose “File” -> “Import FFF profile”.



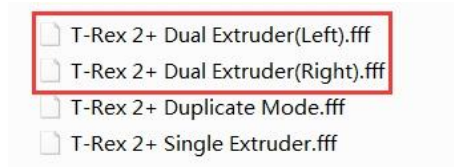
Then click below “Add” button and open “FFF”.



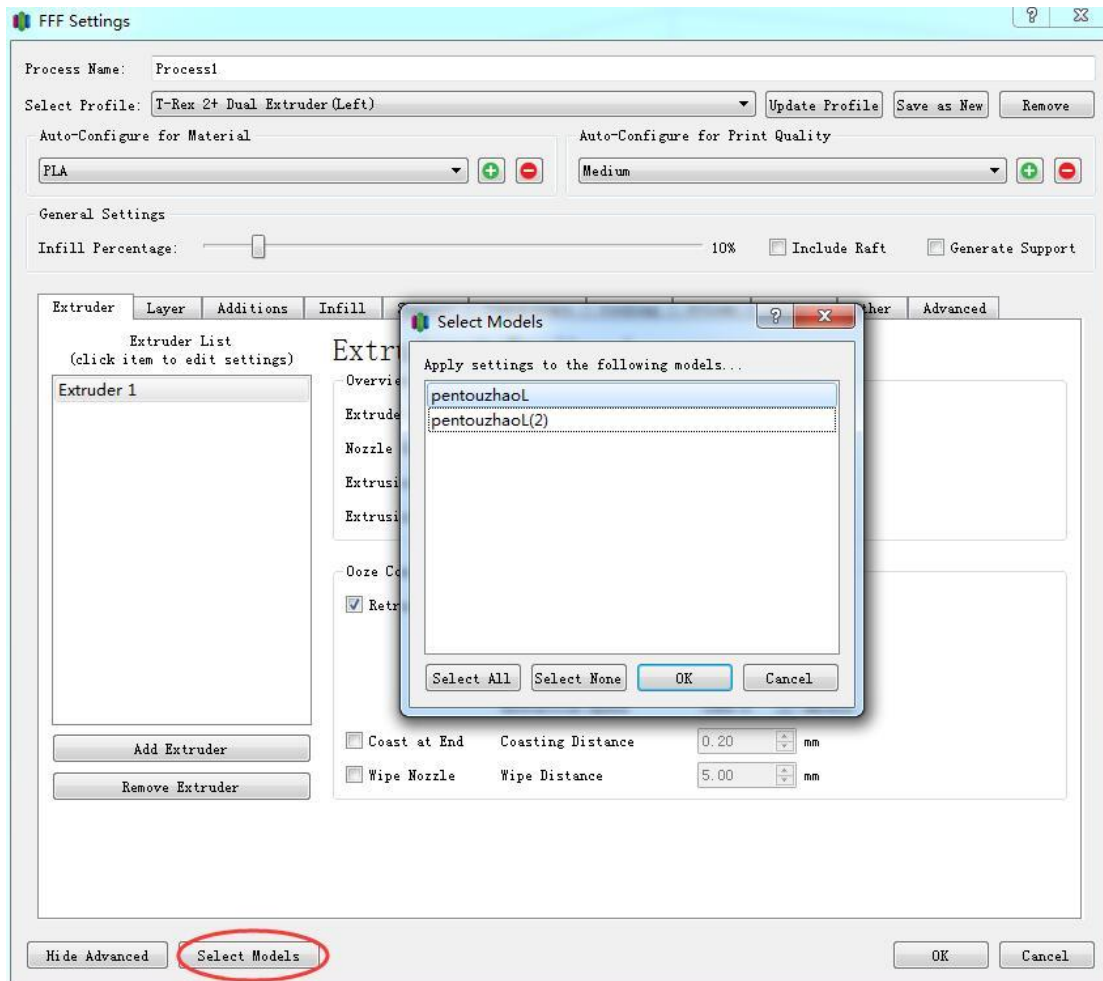
Then choose the profile from "Select Profile".

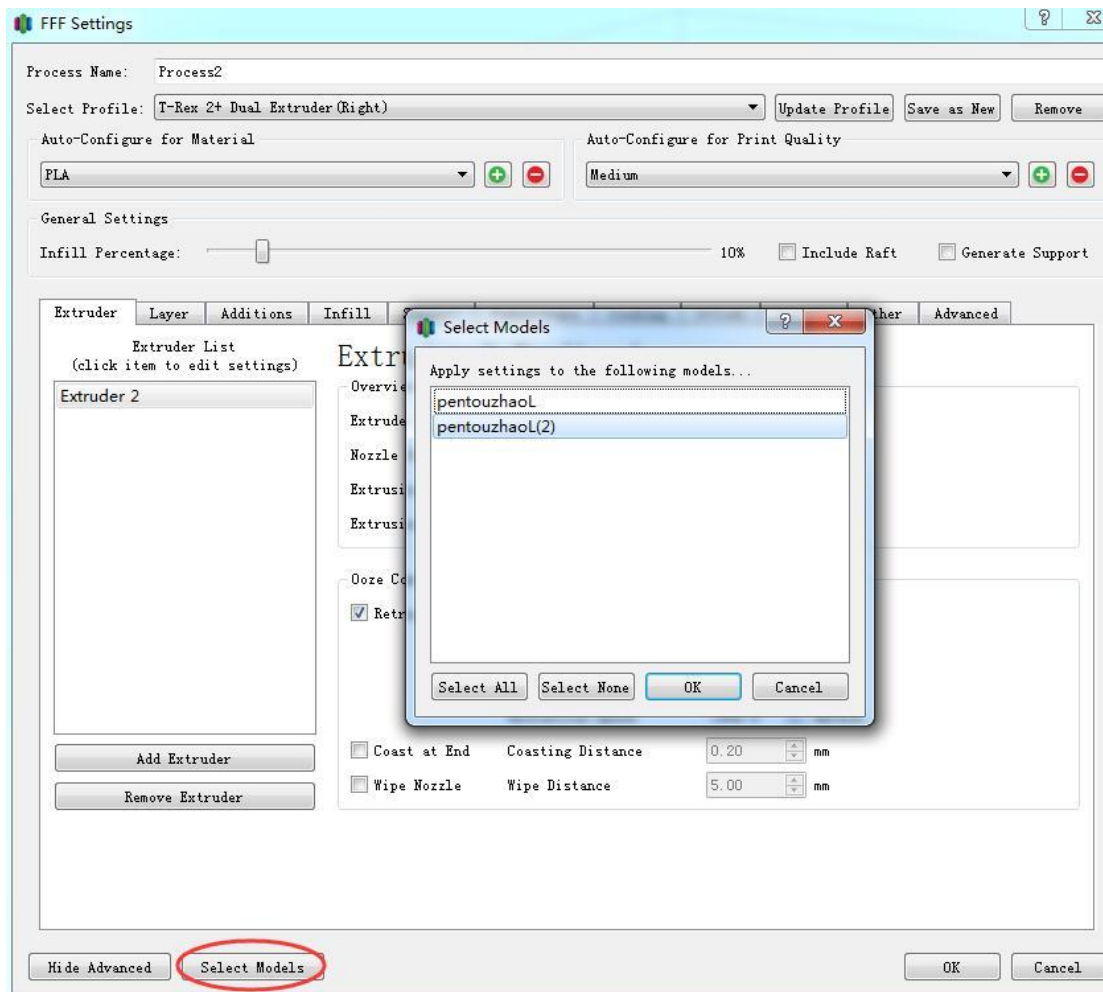


As to dual extruder printing, we have Simplify3D profiles for left and right extruder separately. Please load below profiles into Simplify3D first.



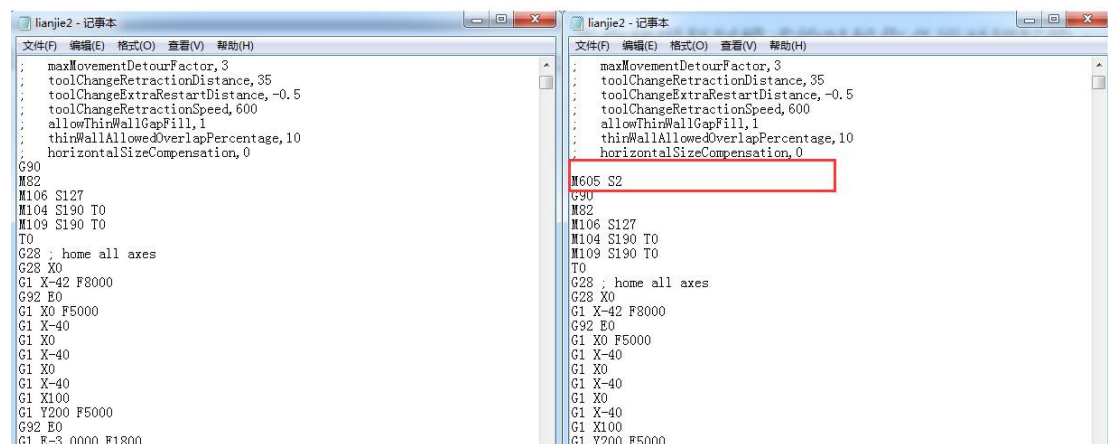
Then select model for left and right extruders separately.





2. Duplicate Printing

When duplicate printing, you need to edit the gcode before printing. Please open gcode file, then input “M605 S2” at the beginning.

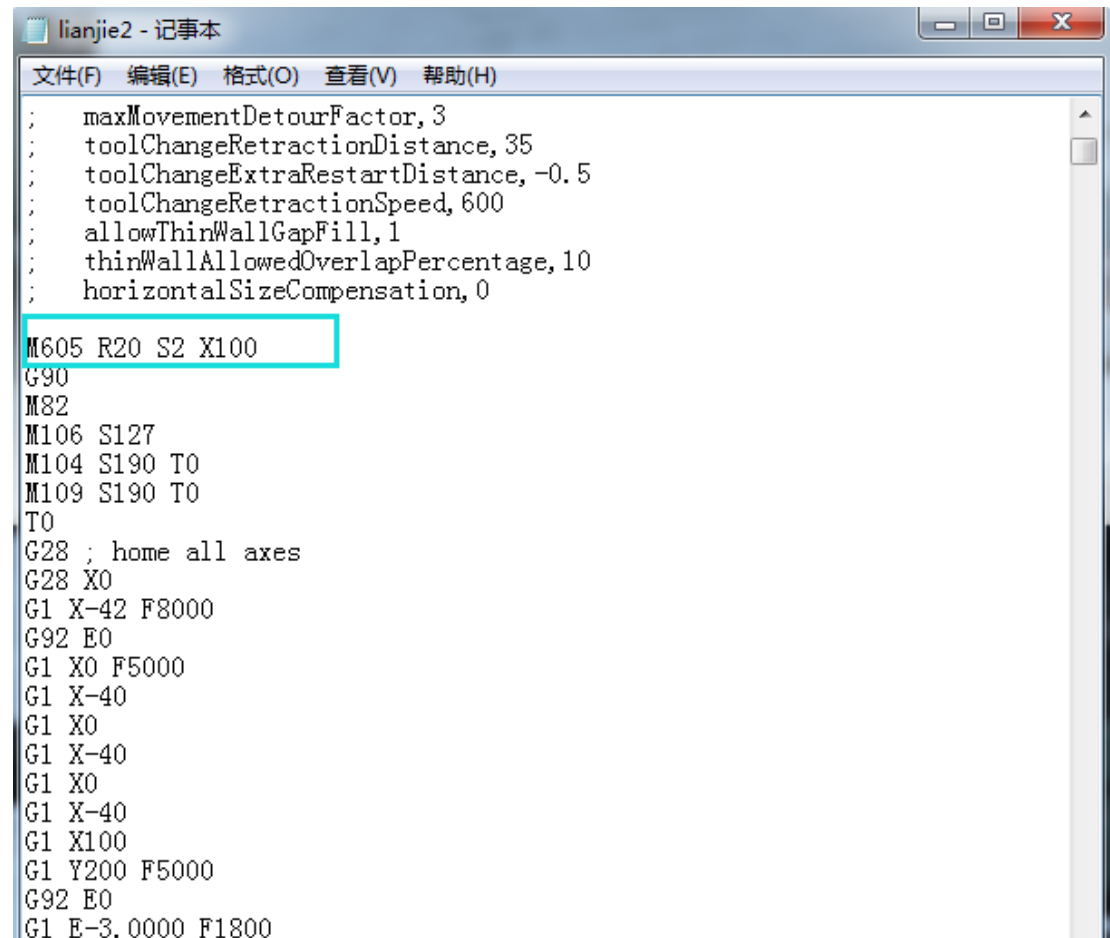


Save above file for printing, then both extruders will reach target temperature at the same time.

You can also set different temperature for different extruders when duplicate printing, so as to

print different kinds of filament simultaneously.

Meanwhile, you can also set different distance between two extruders as below:



```
; maxMovementDetourFactor, 3
; toolChangeRetractionDistance, 35
; toolChangeExtraRestartDistance, -0.5
; toolChangeRetractionSpeed, 600
; allowThinWallGapFill, 1
; thinWallAllowedOverlapPercentage, 10
; horizontalSizeCompensation, 0
M605 R20 S2 X100
G90
M82
M106 S127
M104 S190 T0
M109 S190 T0
T0
G28 ; home all axes
G28 X0
G1 X-42 F8000
G92 E0
G1 X0 F5000
G1 X-40
G1 X0
G1 X-40
G1 X0
G1 X-40
G1 X100
G1 Y200 F5000
G92 E0
G1 E-3.0000 F1800
```

Annotation:

R20: for set the temperature of right extruder. If left extruder is 190C, right extruder will be $190+20=210$ C.

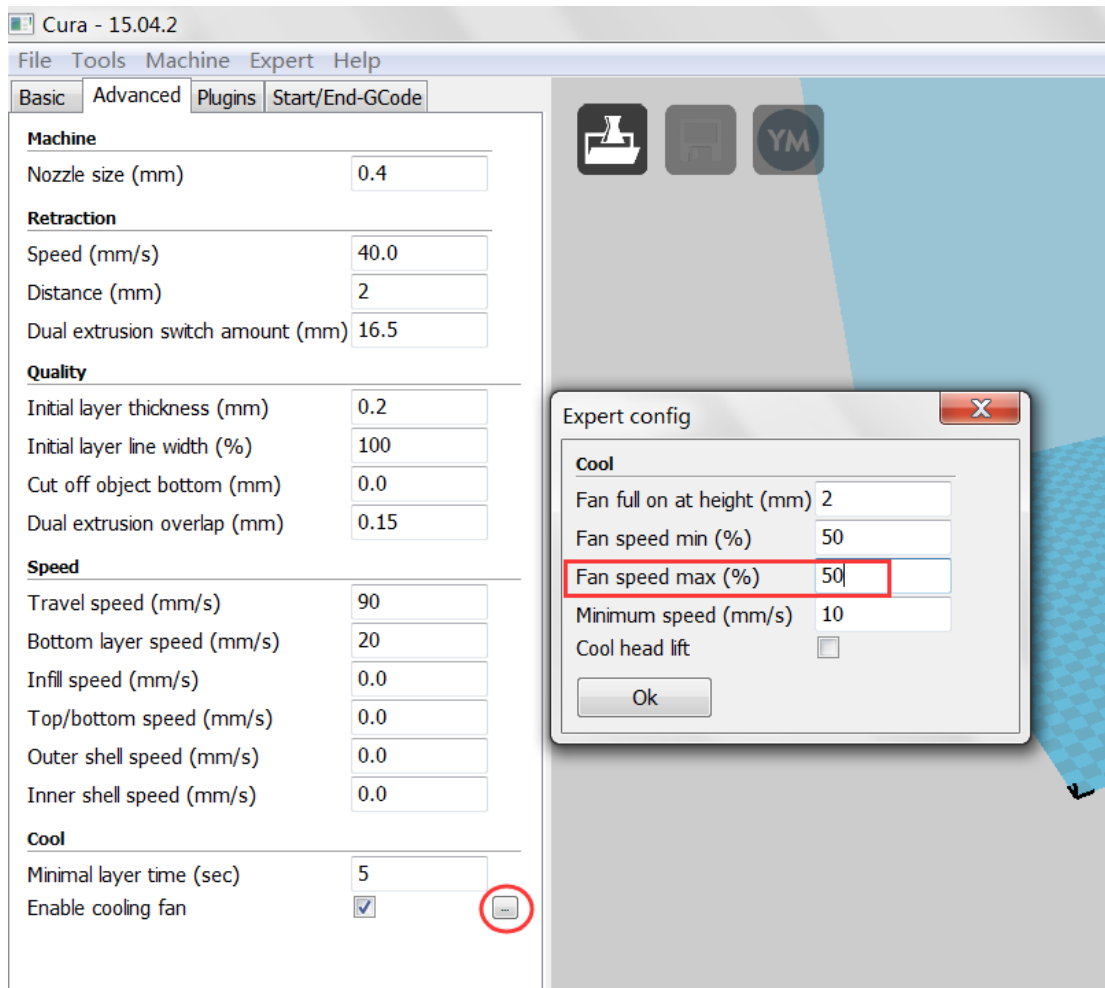
S2: for switch to duplicate printing mode.

X100: for set the distance between two extruders. (200 as the default)

3. ABS Printing

T-Rex 2+ adopts PWM tunable fan, you can adjust its power by slice software. When printing ABS filament, please adjust the fan power to 50% as below:

Setting in CURA:



Setting in Simplify3D:

FFF Settings

Process Name:

Select Profile:

Auto-Configure for Material:

Auto-Configure for Print Quality:

General Settings

Infill Percentage: ☐ Include Raft ☐ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Other Advanced

Per-Layer Fan Controls

Layer	Fan Speed
1	50
10	50

Layer Number:

Fan Speed: %

Speed Overrides

☒ Adjust printing speed for layers below sec

Allow speed reductions down to %

Fan Overrides

☐ Increase fan speed for layers below sec

Maximum cooling fan speed %

☐ Bridging fan speed override %

Fan Options

☐ Blip fan to full power when increasing from idle

Recommend Temperature: PLA 190-200C, Bed 50-60C; ABS 220-230C, Bed 100-110C