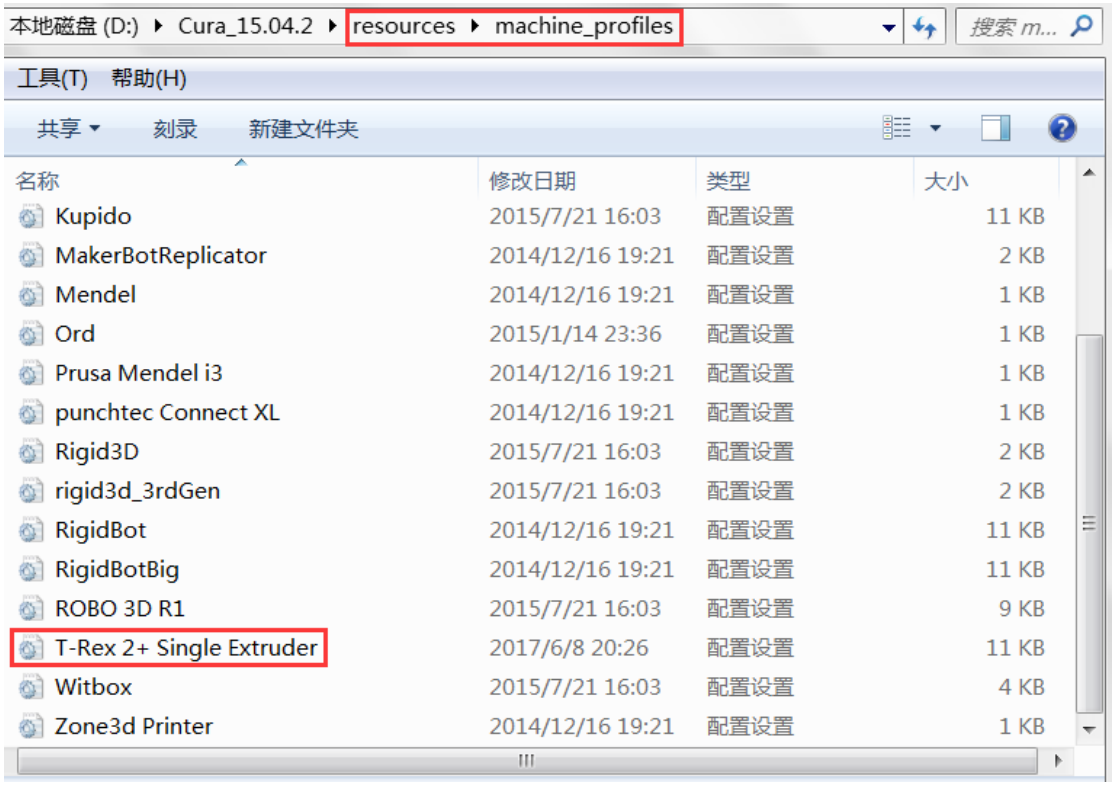
1. Load Profile

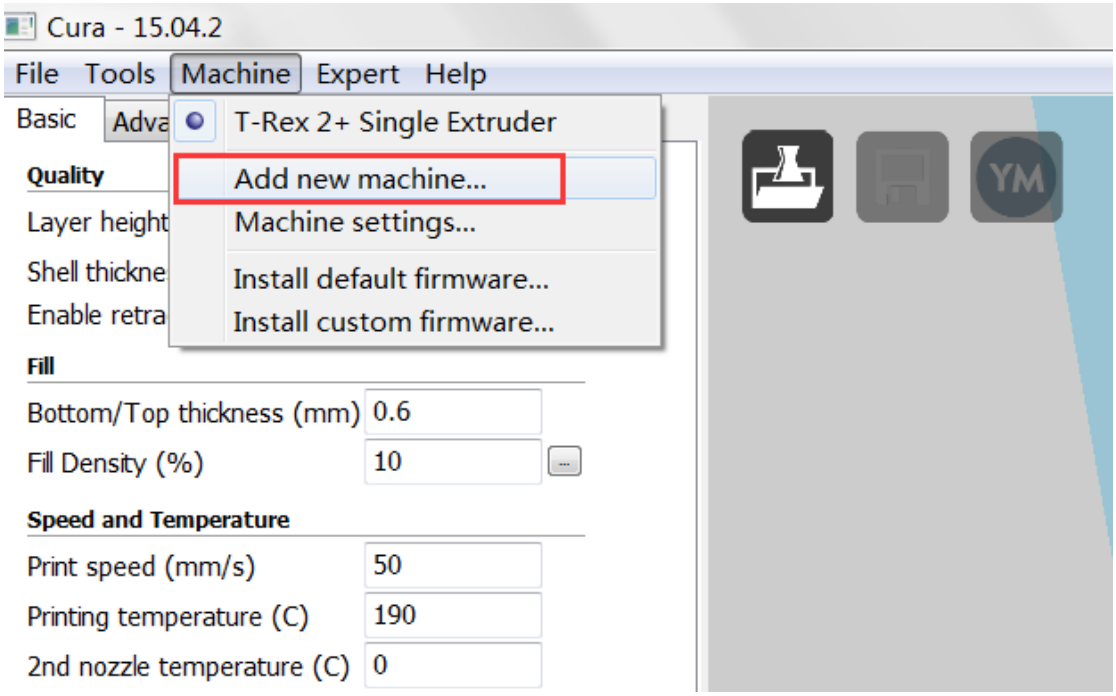
1.1 CURA

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

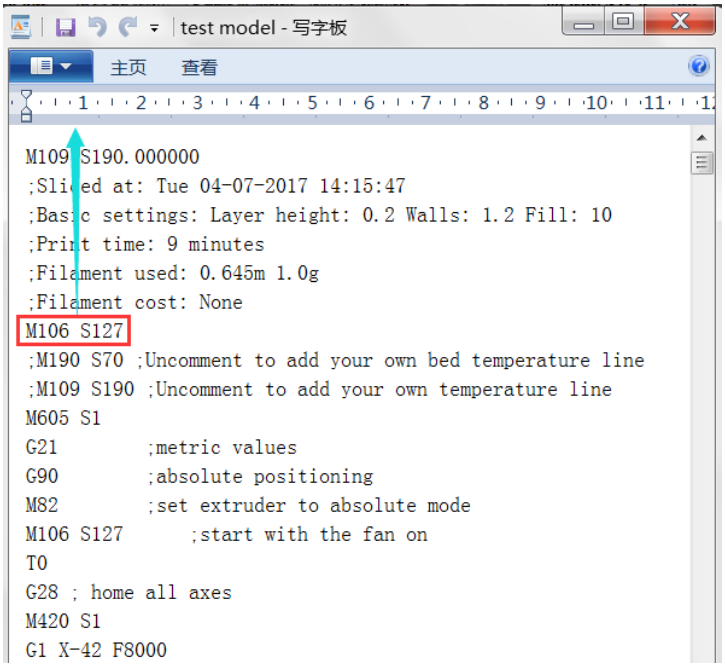
Copy profile to above “machine profiles” folder.



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

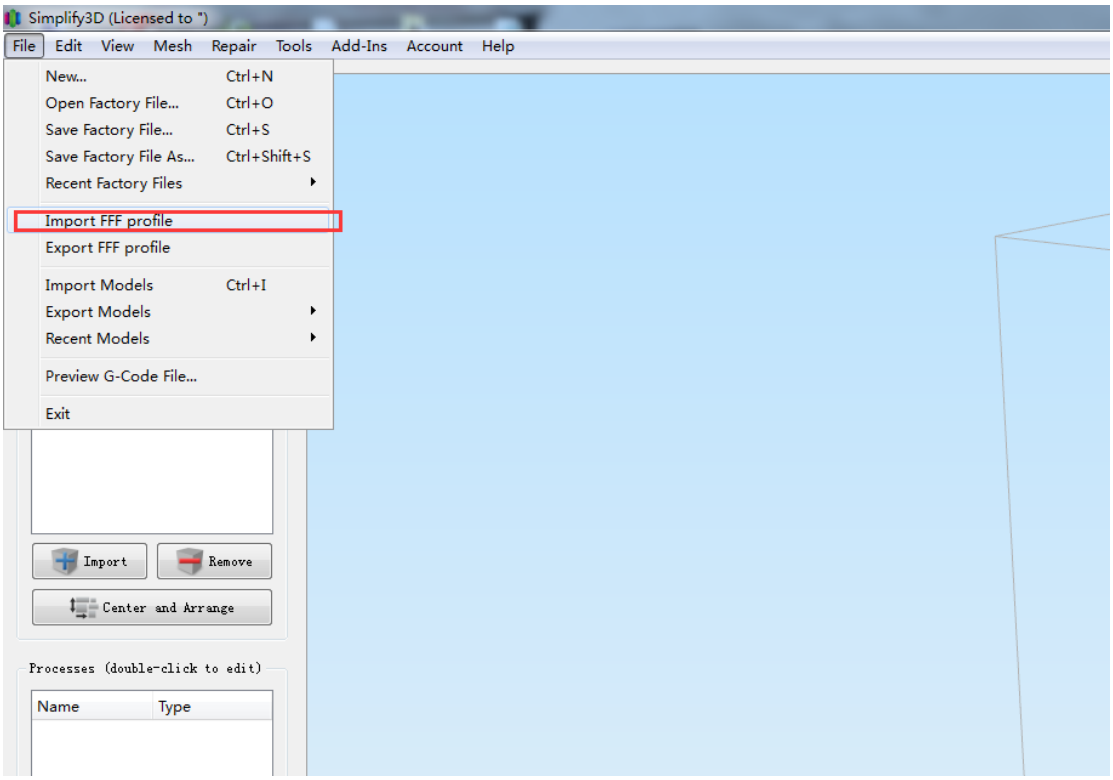


Note: If slice model by Cura, you need to revise the gcode as below:
move “M106 S127” to headmost, so the fan will be turned on before heating up.
But if you slice model by Simplify3D, it doesn’t need to revise.

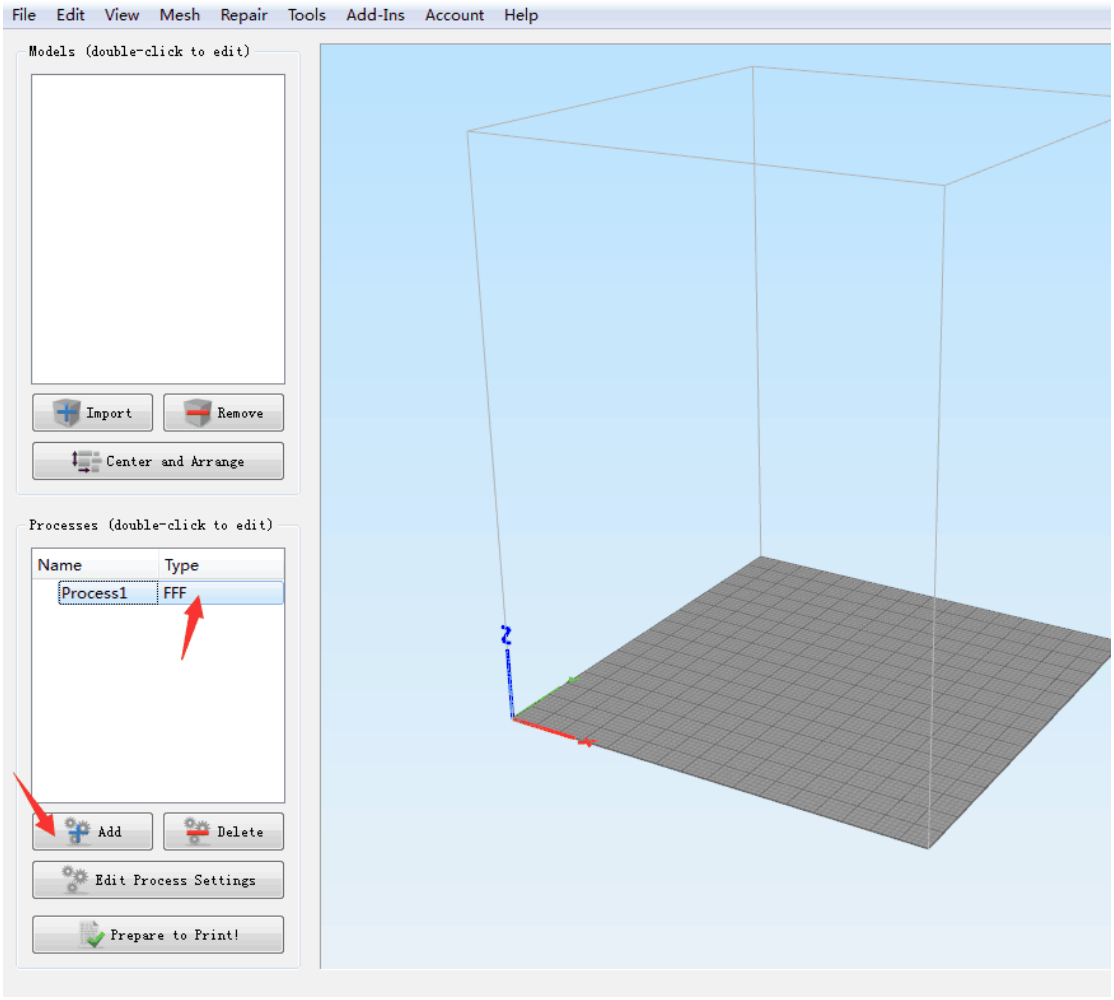


1.2 Simplify3D

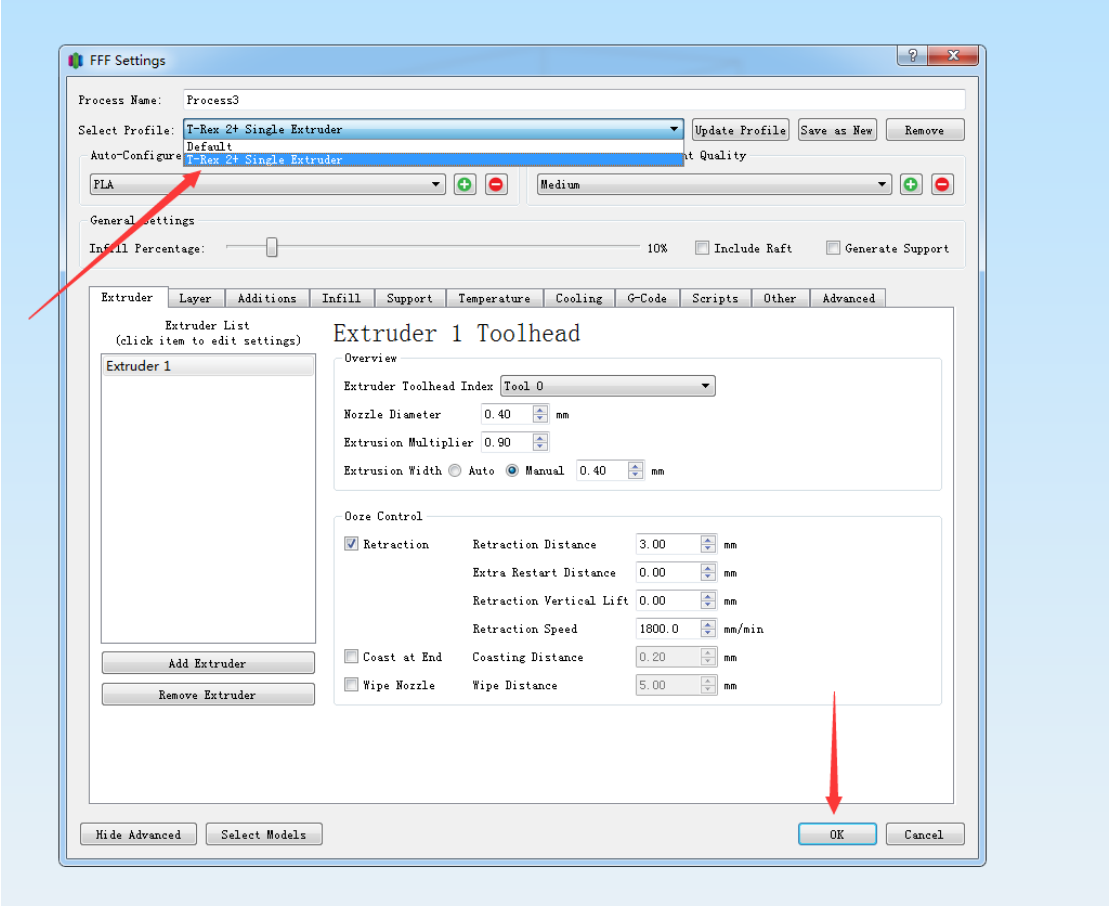
Install and open Simplify3D, choose “File” -> “Import FFF profile”.



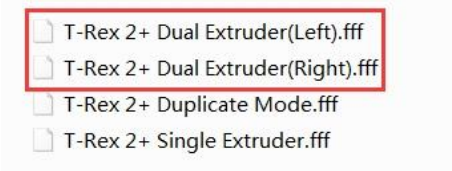
Then click below “Add” button and open “FFF”.



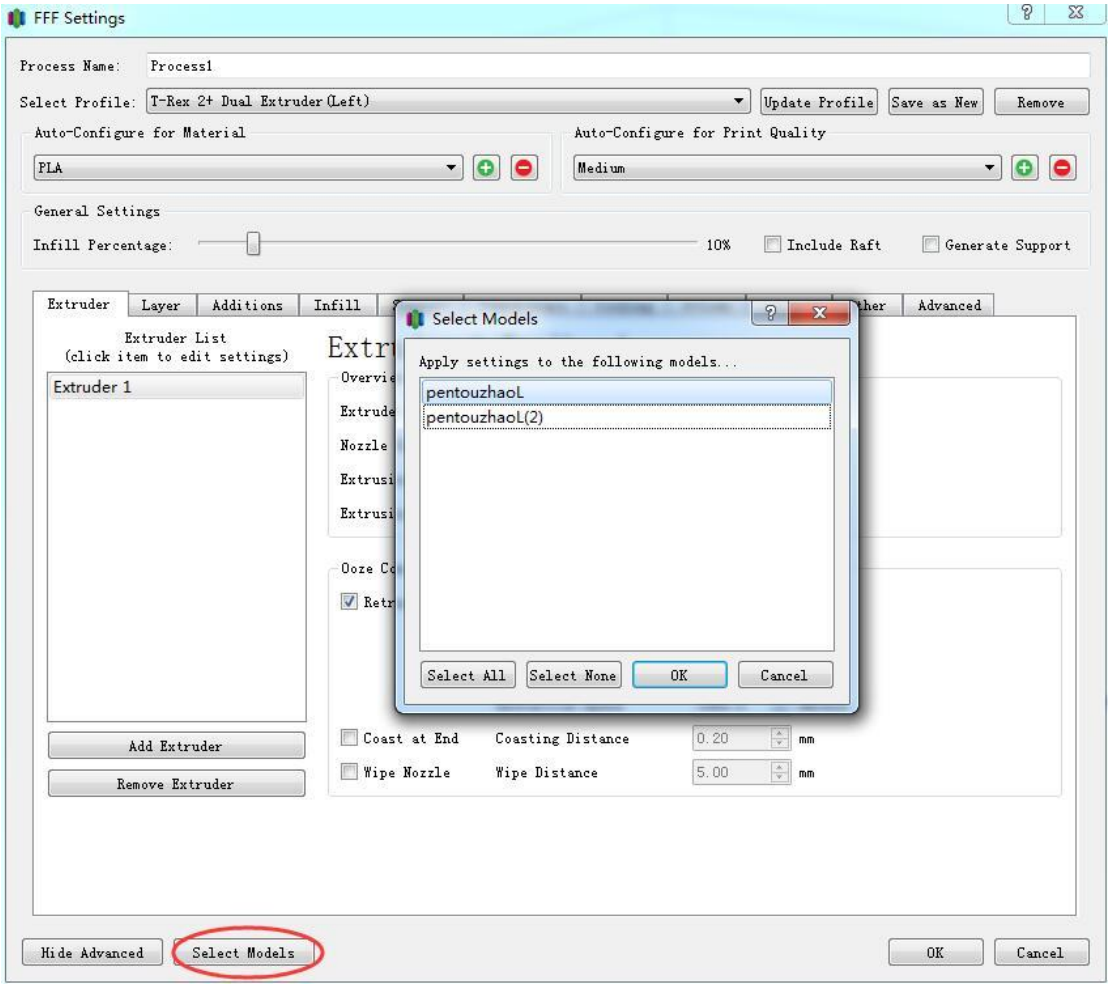
Then choose the profile from “Select Profile”.

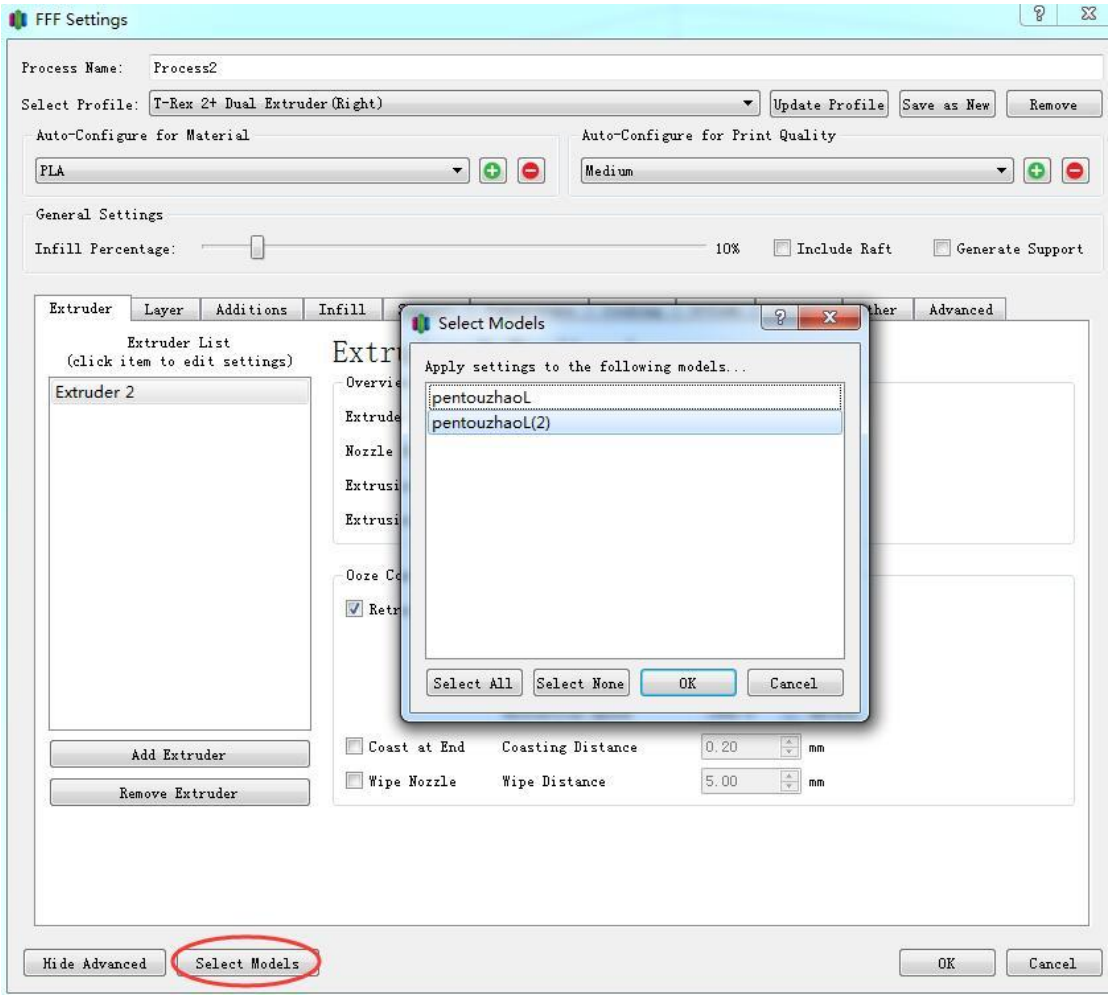


As to dual extruder printing, we have Simplify3D profiles for left and right extruder separately. Please load below profiles into Simplify3D first.



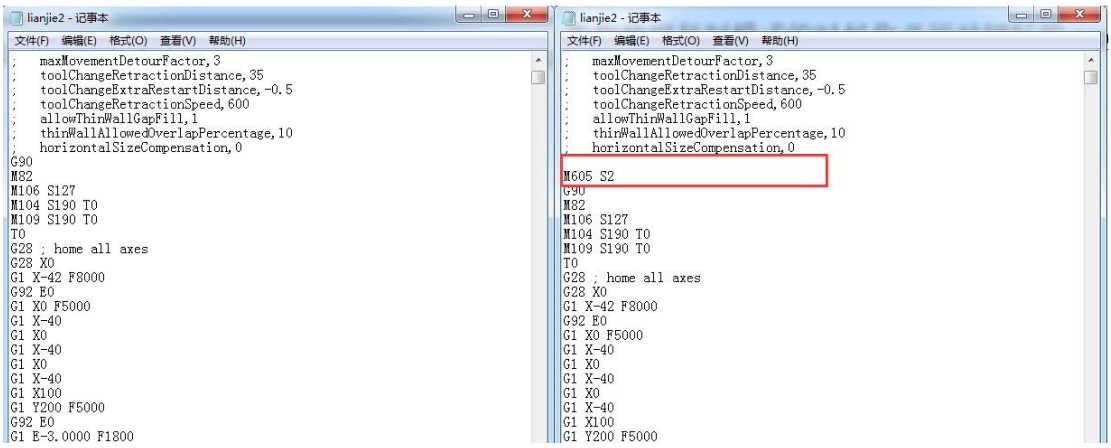
Then select model for left and right extruders separately.


FFF Settings
Process Name:
Process1
Select Profile:
T-Rex 2+ Dual Extruder (Left)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
10%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Advanced
Extruder List
(click item to edit settings)
Extruder 1
Add Extruder
Remove Extruder
Coast at End
Coasting Distance
0.20
mm
Wipe Nozzle
Wipe Distance
5.00
mm
Hide Advanced
Select Models
OK
Cancel
Select Models
Apply settings to the following models...
pentouzhaoL
pentouzhaoL(2)
Select All
Select None
OK
Cancel



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.

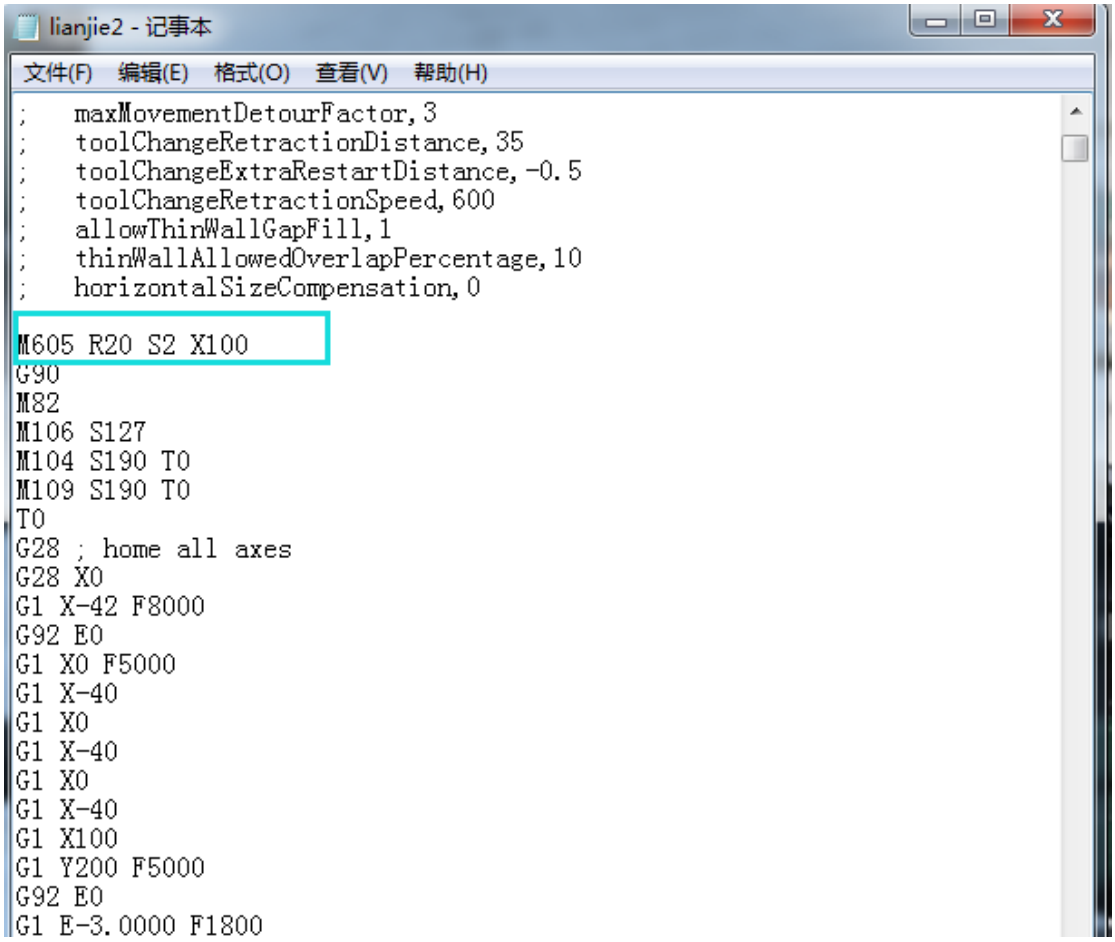


Save above file for printing, then both extruders will reach target temperature at the same time.

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:



Annotation:

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

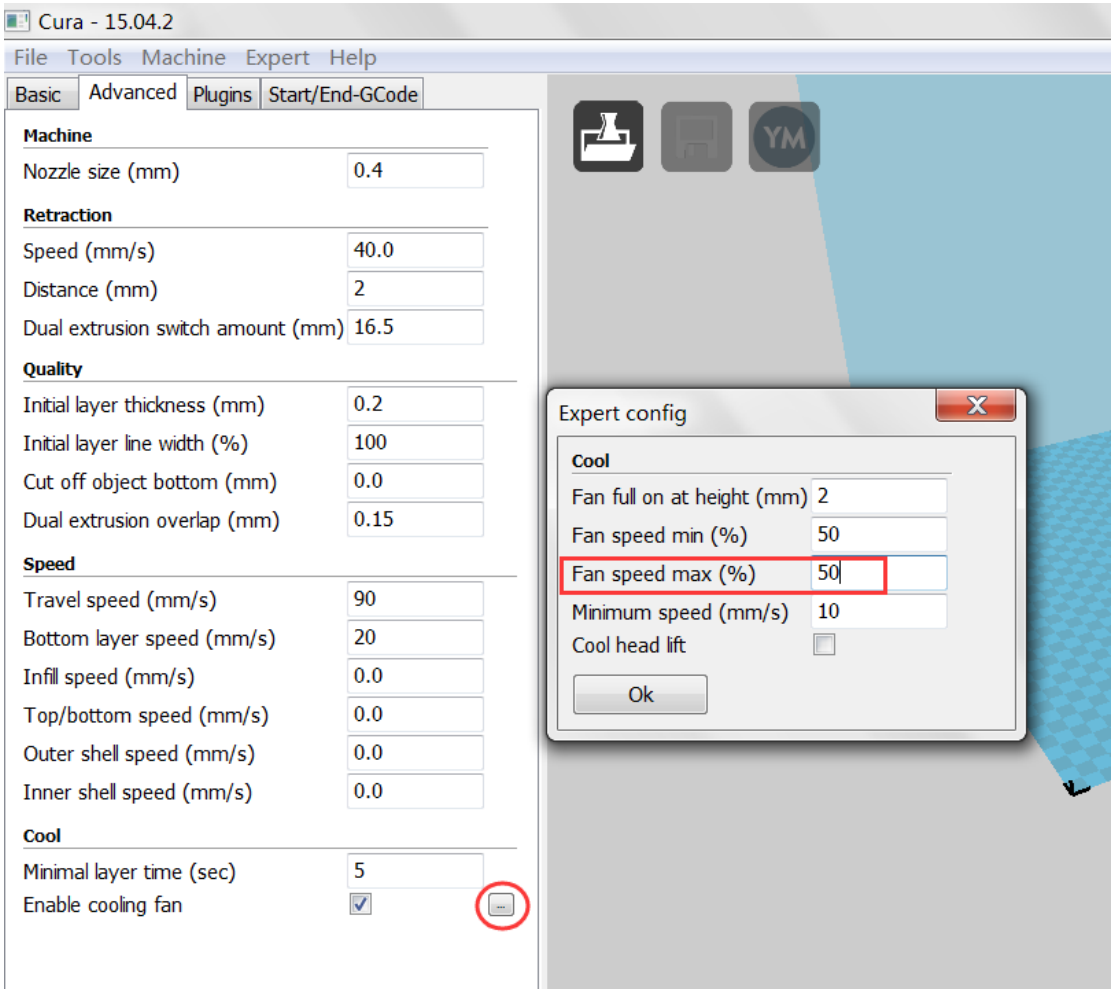
S2: for switch to duplicate printing mode.

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

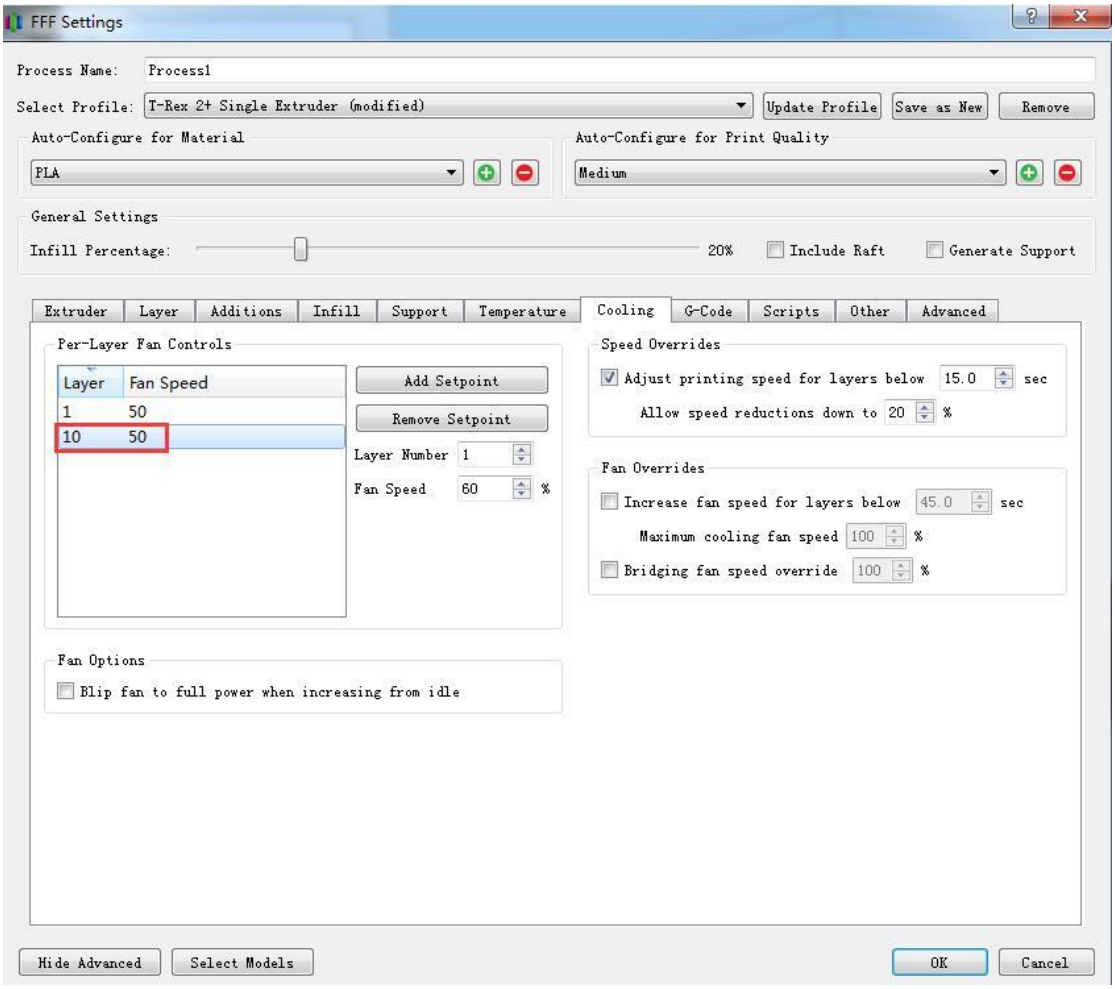
3. ABS Printing

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:



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