Thanks to support TinyBoy2 Education Project

Please follow the below guidelines to install and prepare your print

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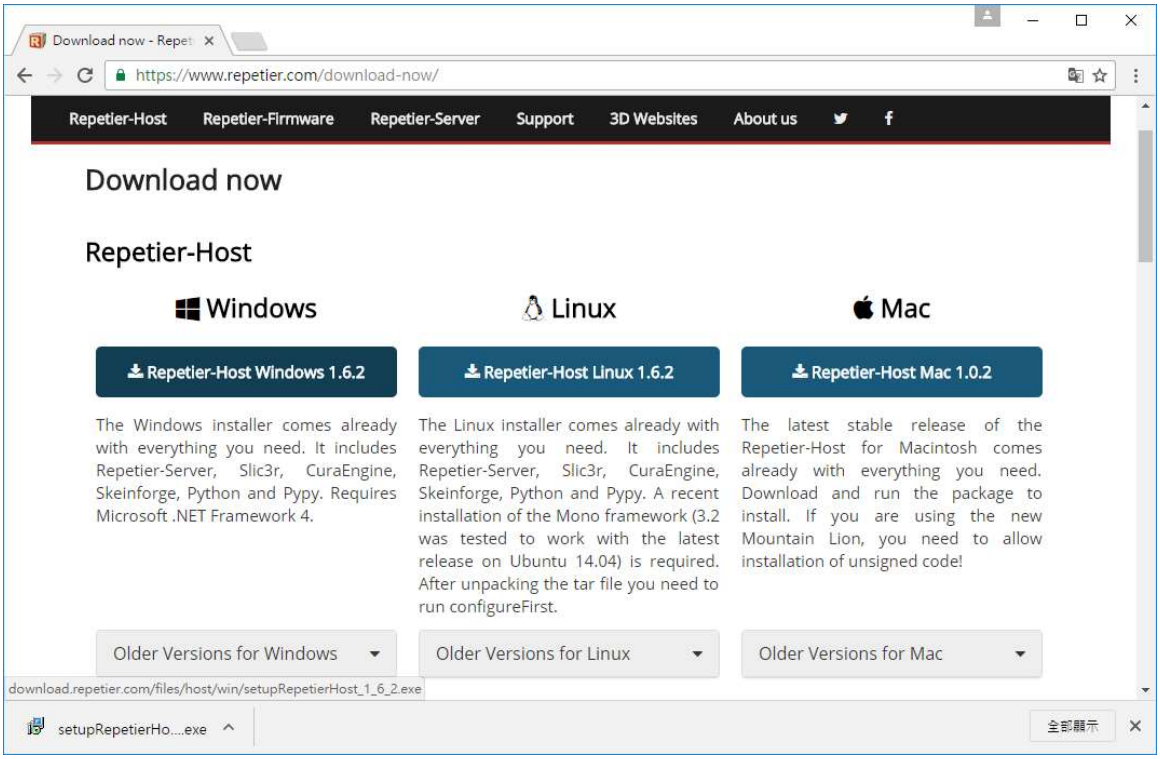
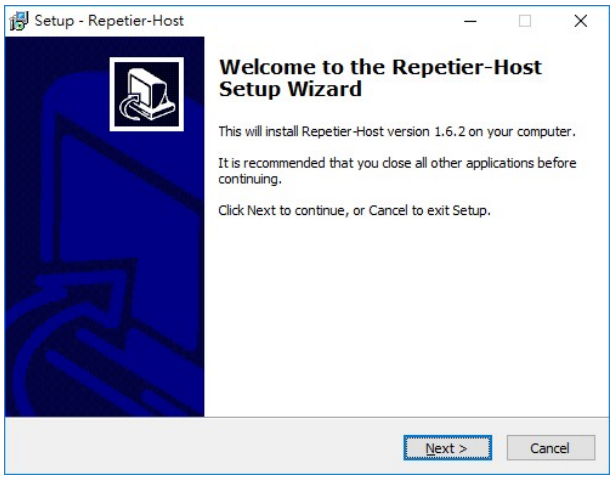
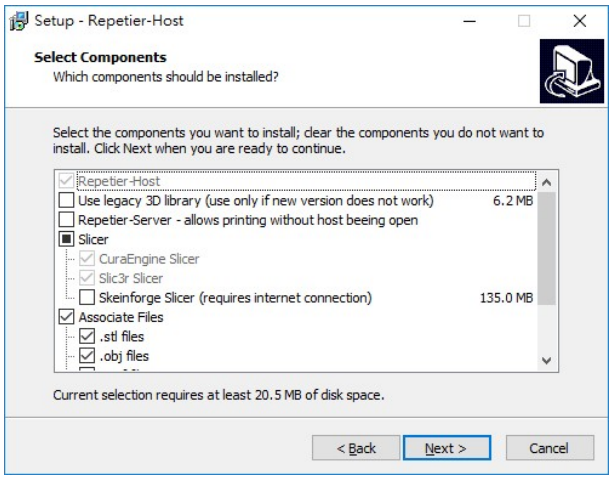
A. Download and Install Repetier-Host

1. 從 https://www.repetier.com/download-now/ 網站，下載 Repetier-Host。



2. Install Repetier-Host

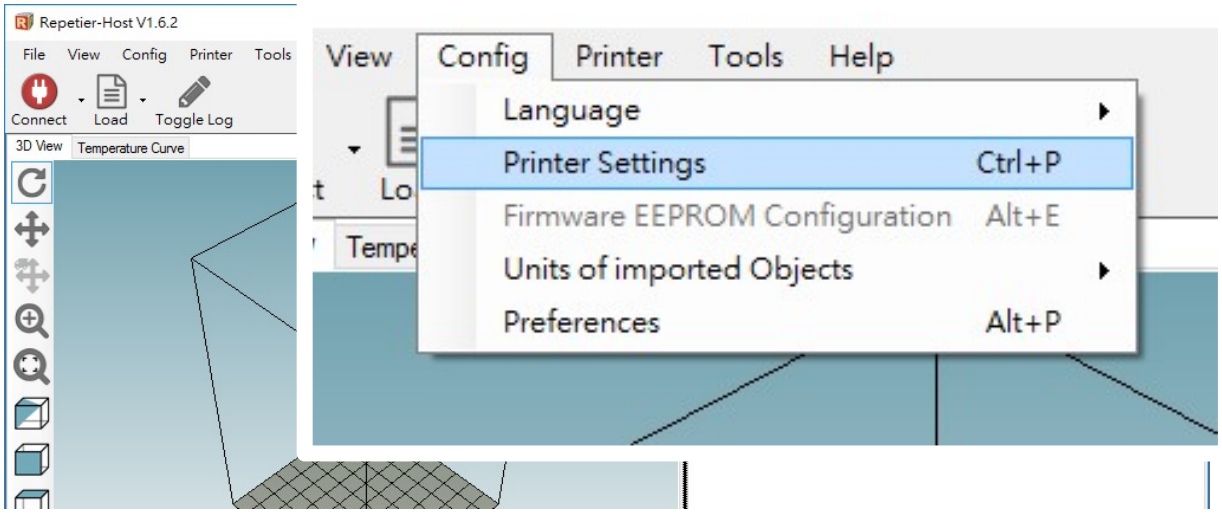




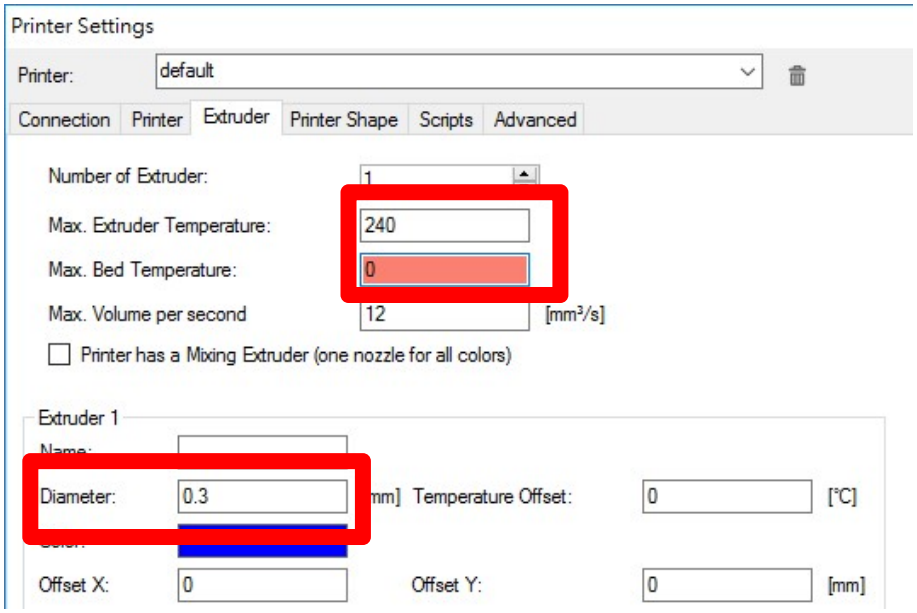
3. Click to open Repetier-Host

B. Repetier-Host Parameter Setting

1. Config → Printer Setting



2. Please key in the following **TinyBoy2** parameters.

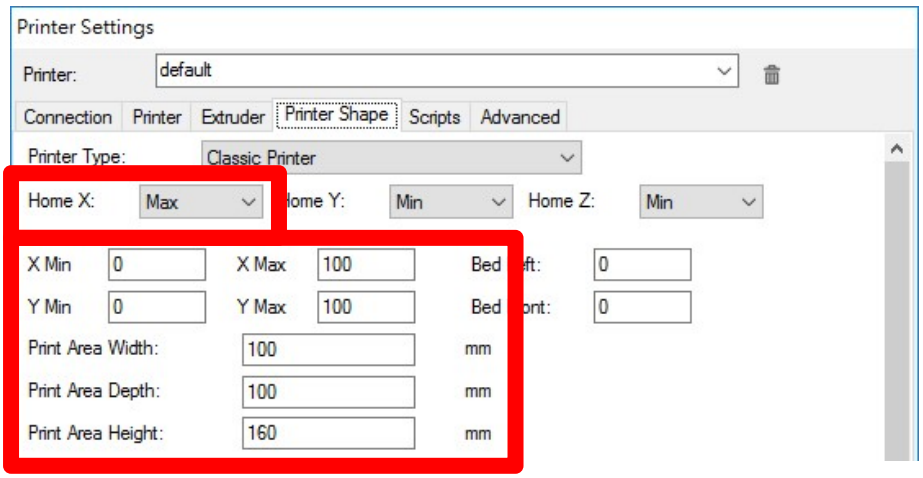


Extuder

Max. Extruder Temperature
240

Max. Bed Temperature
0

Diameter
0.3
(* Nozzle size)



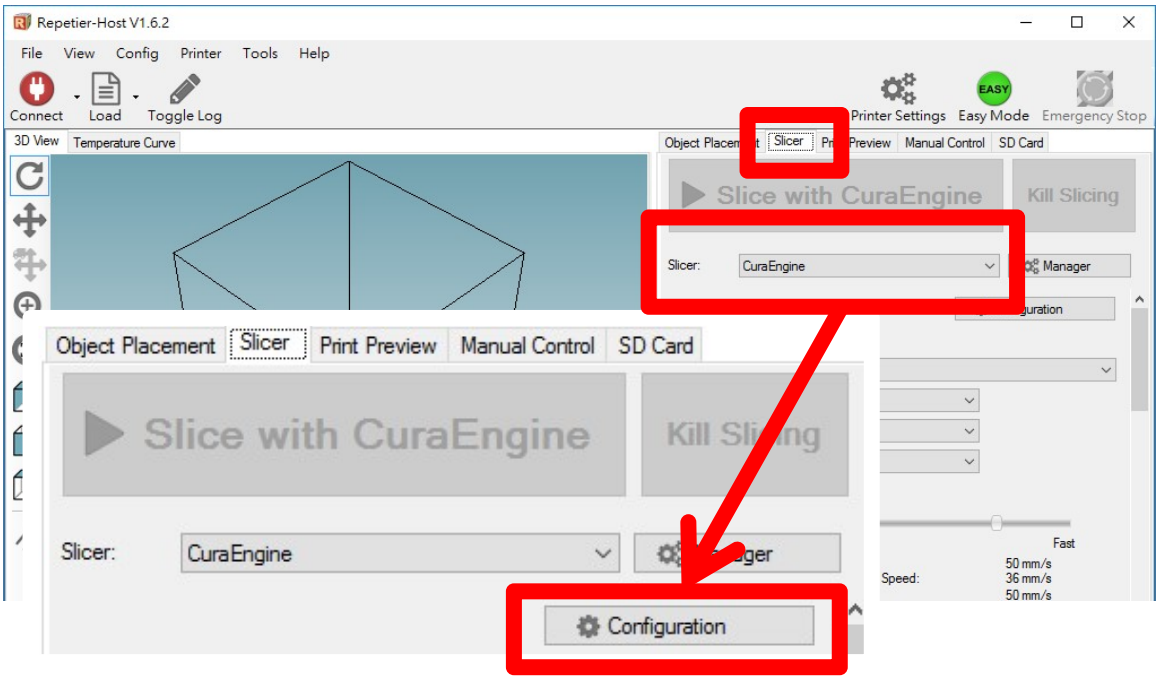
Printer Shape

Home X → Max

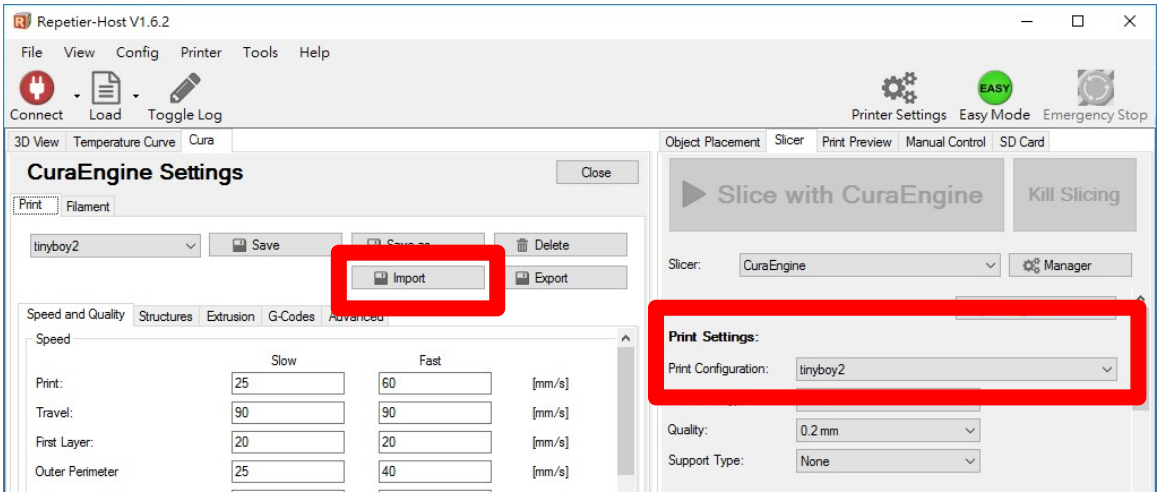
X Max = 100
Y Max = 100

Print Area Width = 100
Print Area Depth = 100
Print Area Height
(L10) = 100
(L16) = 160

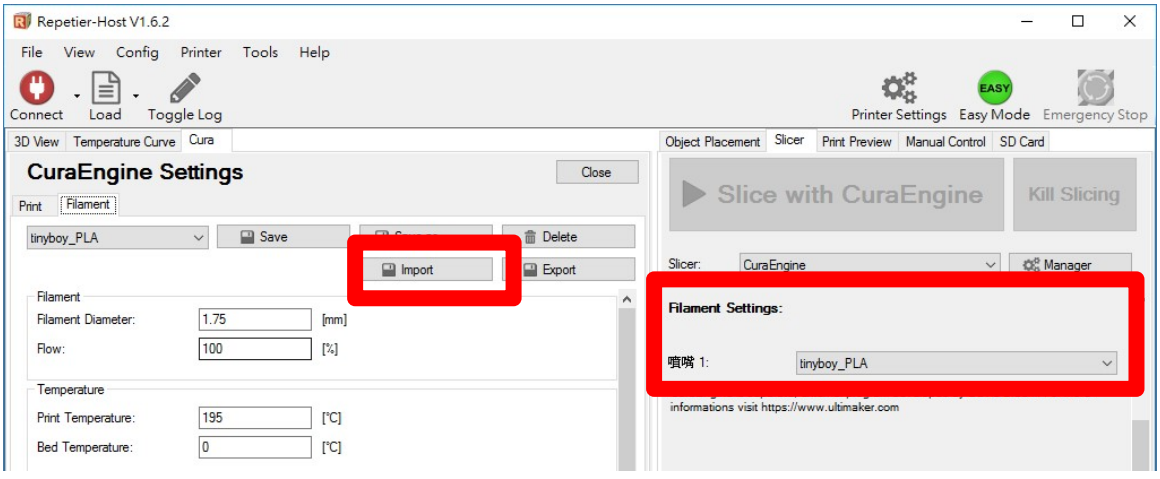
3. In **'Slicer'** Tab, select '**CuraEngine**' as slicer. Then click 'Configuration'.



4. Import **tinyboy2.rcp**, then change ***Printer Configuration*** from Default to **TinyBoy2**.

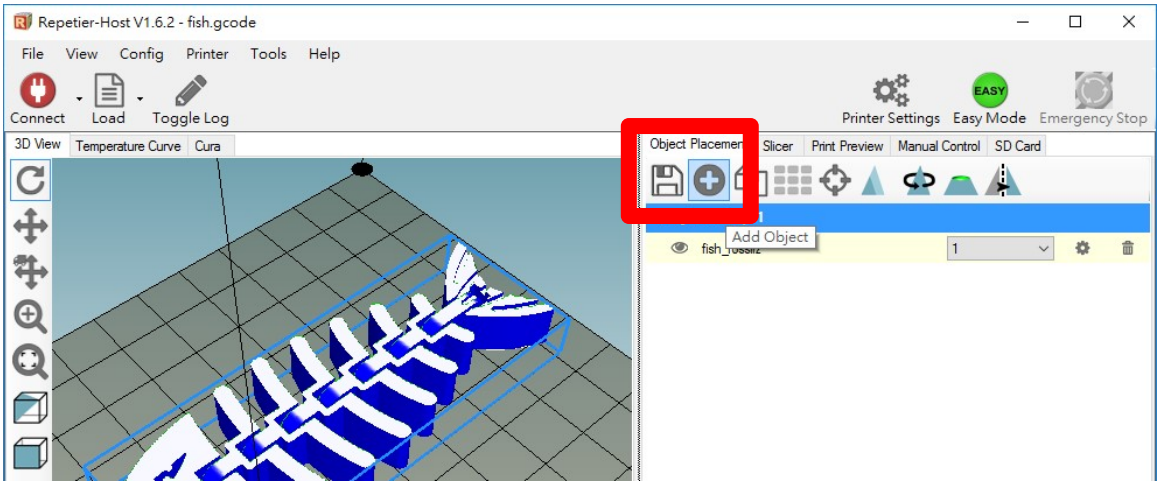


5. Import **tinyboy2-PLA.rcf**, then change ***Filament Setting*** from Default to **TinyBoy2 – PLA**.

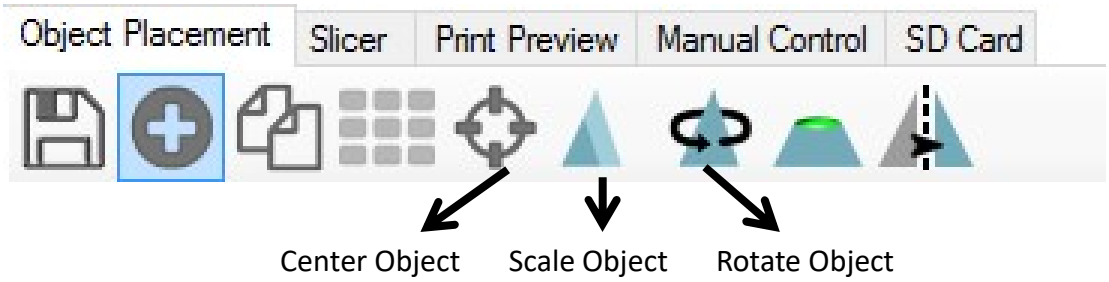


C. Prepare G-code in Repetier-Host

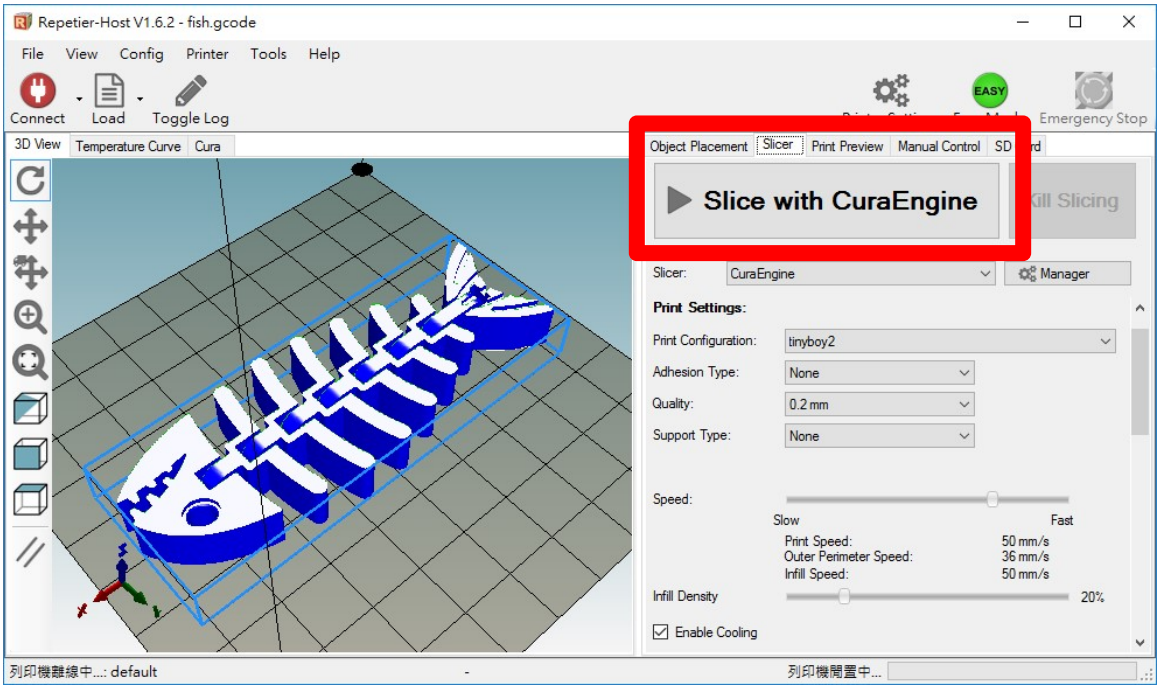
1. **'Object Placement'** Tab → **'Add Object'**

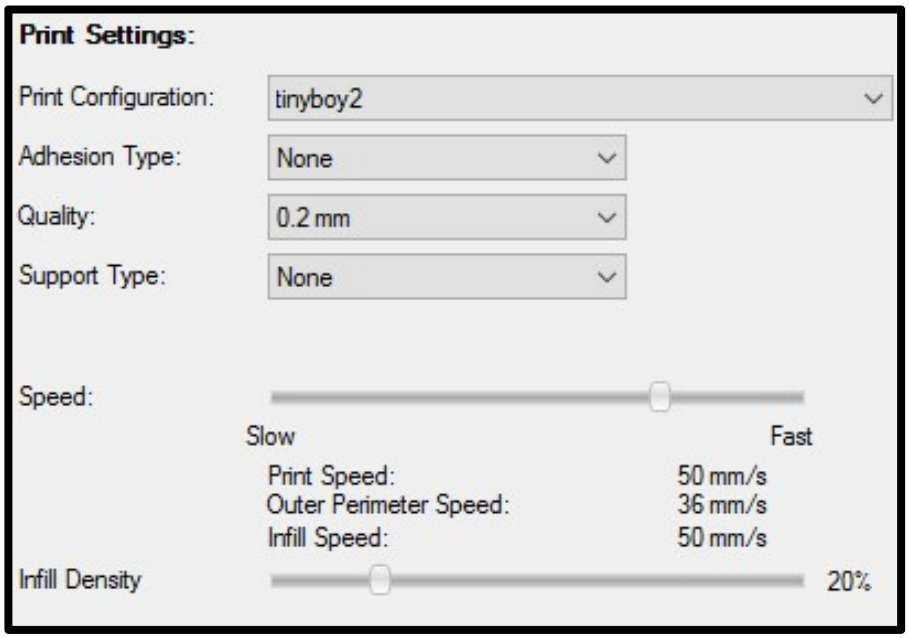


2. Modify the printout size and ratio if need.



3. In **'Slicer'** Tab, click ' ▸ **Slice with CuraEngine'** to generate G-code.





Infill Density

Suggest 15 – 20%

0% = Empty

100% = Full Fill (not suggested)

Adhesion Type

Default: None

Choose ‘Brim’ or ‘Raft’ to increase the contact area between printout and bed, when printout is too small.

Quality

Normal Quality 0.2mm

Fine Quality 0.1mm

0.05mm is possible by print time is very long.

Support Type

Default: None

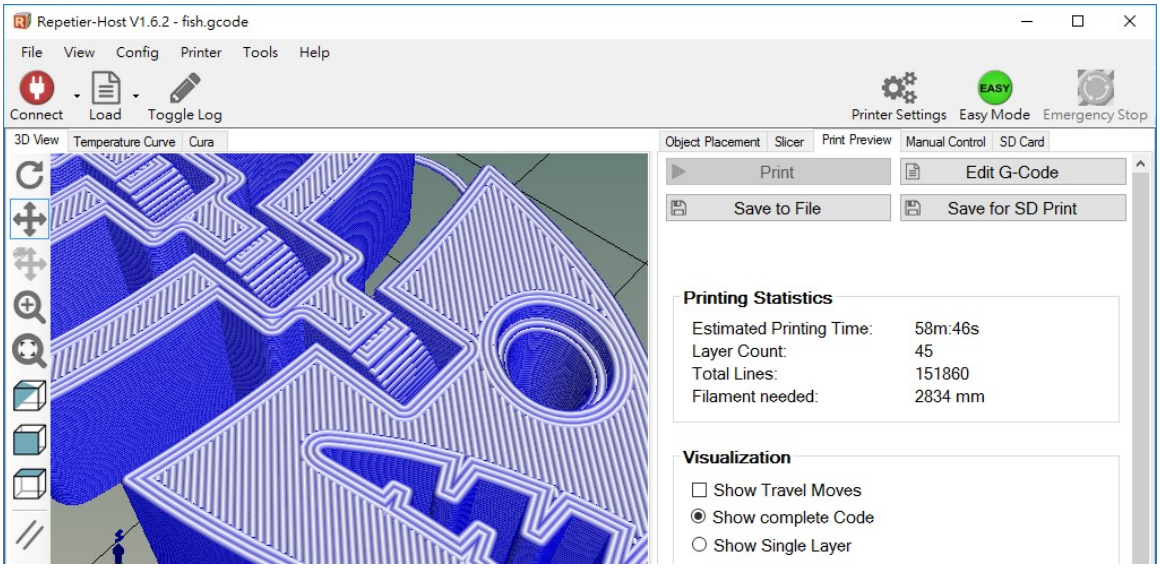
Choose ‘Everywhere’ if printout have overhang.

Speed

Suggest 40 – 60mm/s

(PLA, Temperature 195)

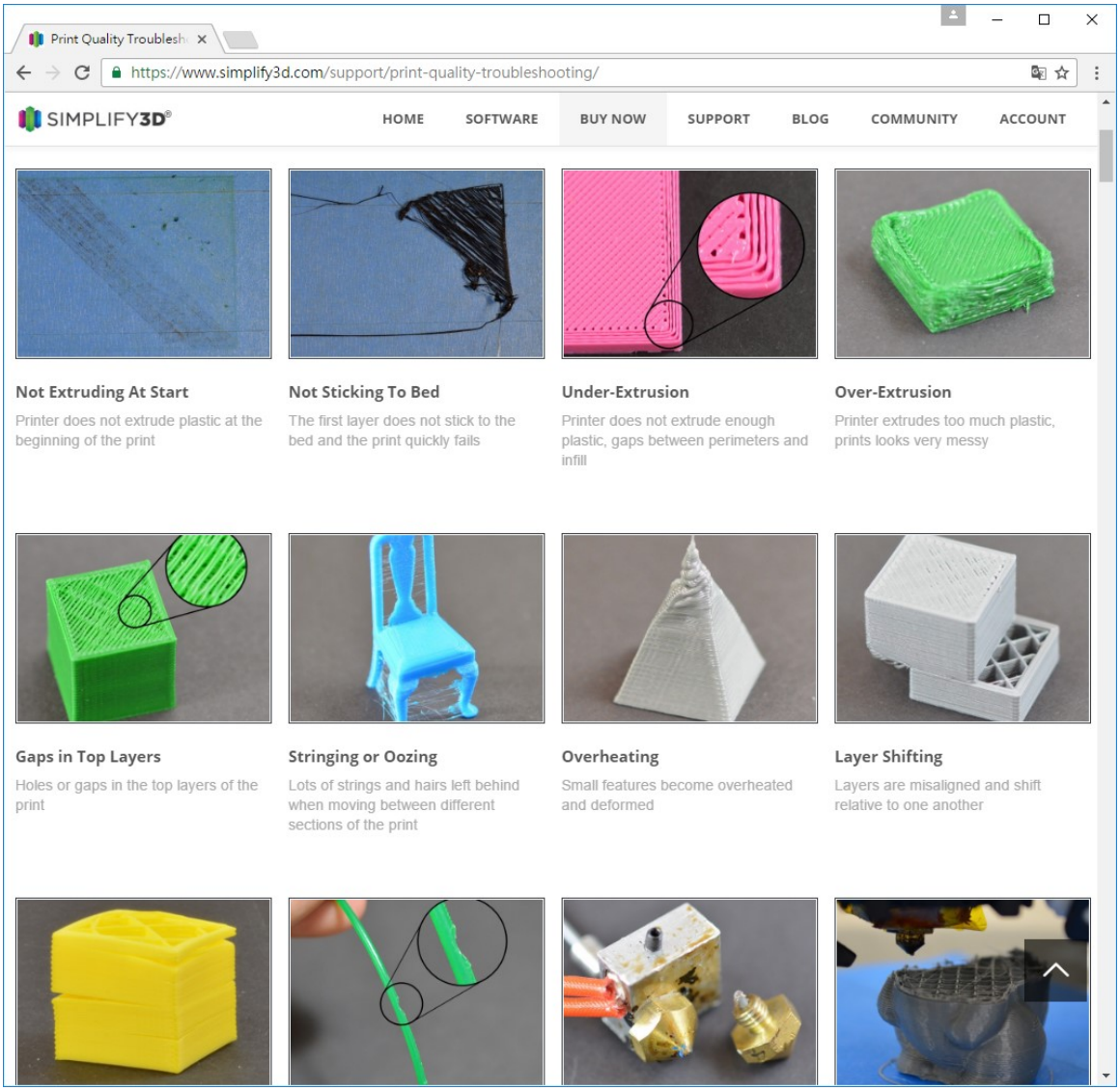
4. After finish slicing，the screen will show the printing paths。Click ‘ **Save to File**’ to save the G-code into SD card



5. Insert SD card to TinyBoy2, press menu button and choose ‘Print from SD card’. Then choose G-code from file list and start print.

D. Reference

The below website list out many 3D printing handling technique and tips for you to refer:
https://www.simplify3d.com/support/print-quality-troubleshooting/



* Repetier-Host and Simplify3D are other 3rd party companies, this notes aims for educational use only