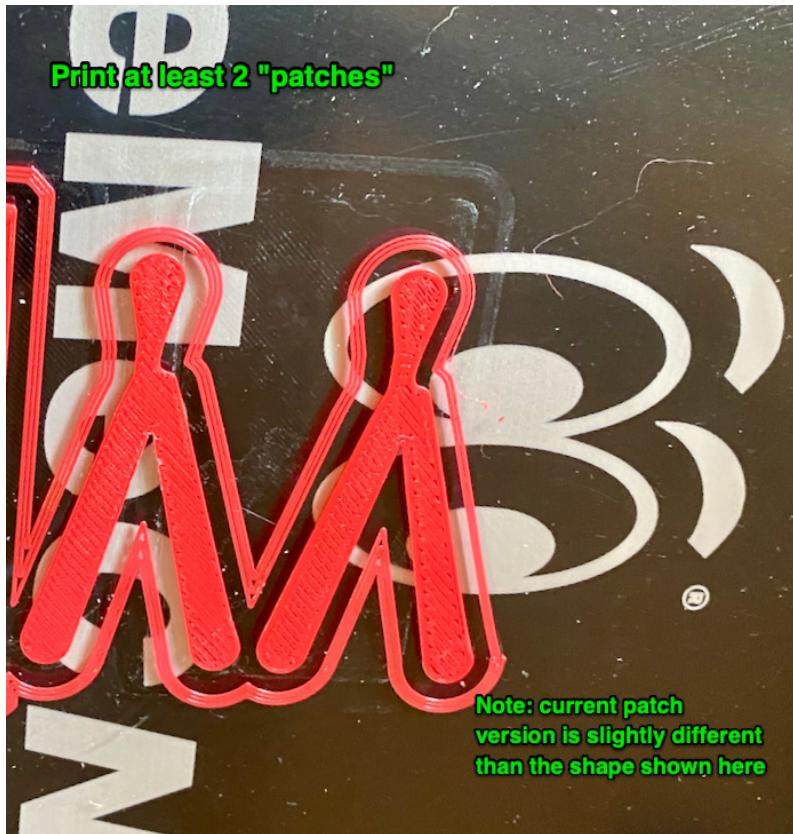


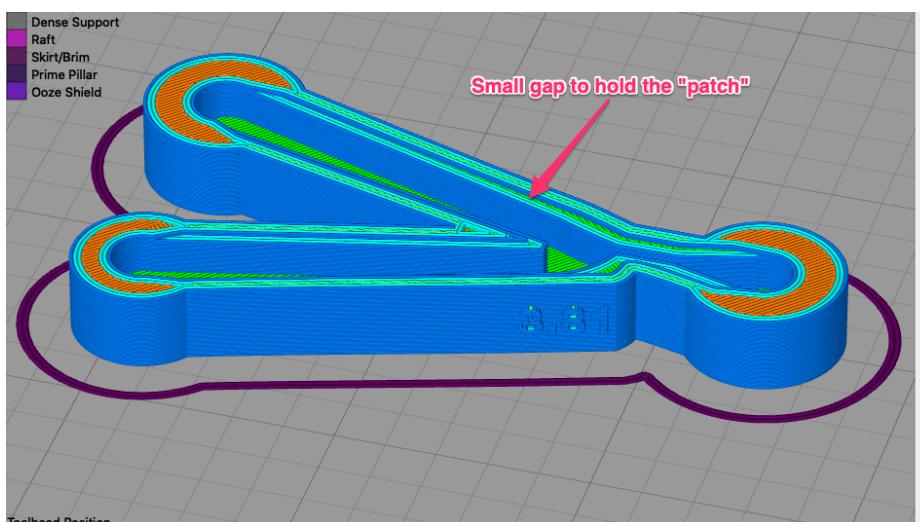
How to patch a bridge.

By AMG

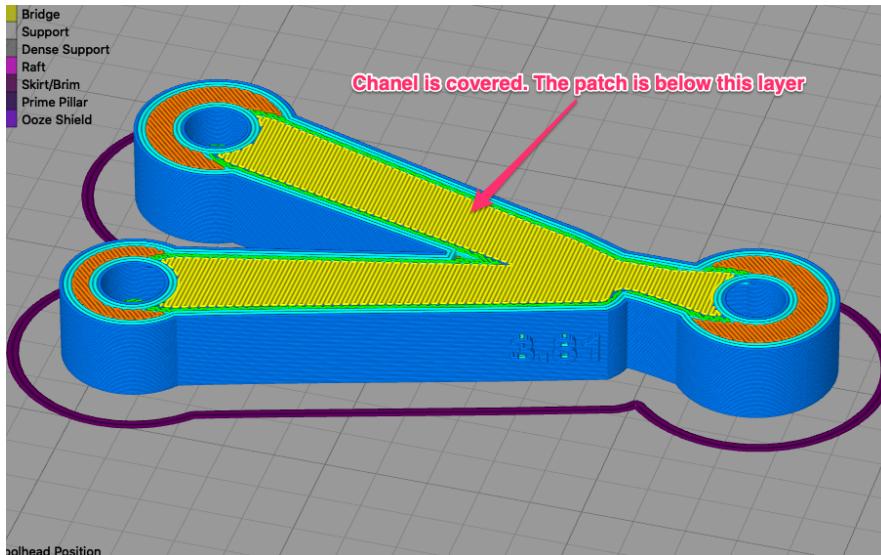
Step 1: print the “patch” (Alpha I Rev1 - Patch for FDM Unibody).



Step 2: Prepare the Gcode so it can stop at the *last layer* that has the channel open. It should be layer 54 if printed at 0.15mm, or z=7.950mm. However it can change depending on your own setups/printer. The way to verify what layer is the right one is by looking at your GCODE, find the *last layer* that cover the channel. The last layer should look like this:



The next layer would be something like this:



You need to stop the printer right after the last layer had finished or right after the next one (e.g. my last layer is 53, so I stop my printer at layer 54, before it starts covering the channels)

(**NOTE: again, the layer number CAN be different than 54 in your own printer depending on your specific setup, please verify!**)

Best way to stop the printer at the required layer is using your slicer. I use Simplify 3D. So, what I do is to add postprocessing commands to the “starting script” as shown.

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

Starting Script Layer Change Script Retraction Script Tool Change Script Ending Script

```
G28 ; home all axes  
G1 X5 Y10 Z0.2 F3000 ; get ready to prime  
G92 E0 ; reset extrusion distance  
G1 X160 E15 F600 ; prime nozzle  
G1 X180 F5000 ; quick wipe
```

Post processing command in Simplify 3D to stop the printer starting layer 54

Post Processing

Export file format Standard G-Code (.gcode)

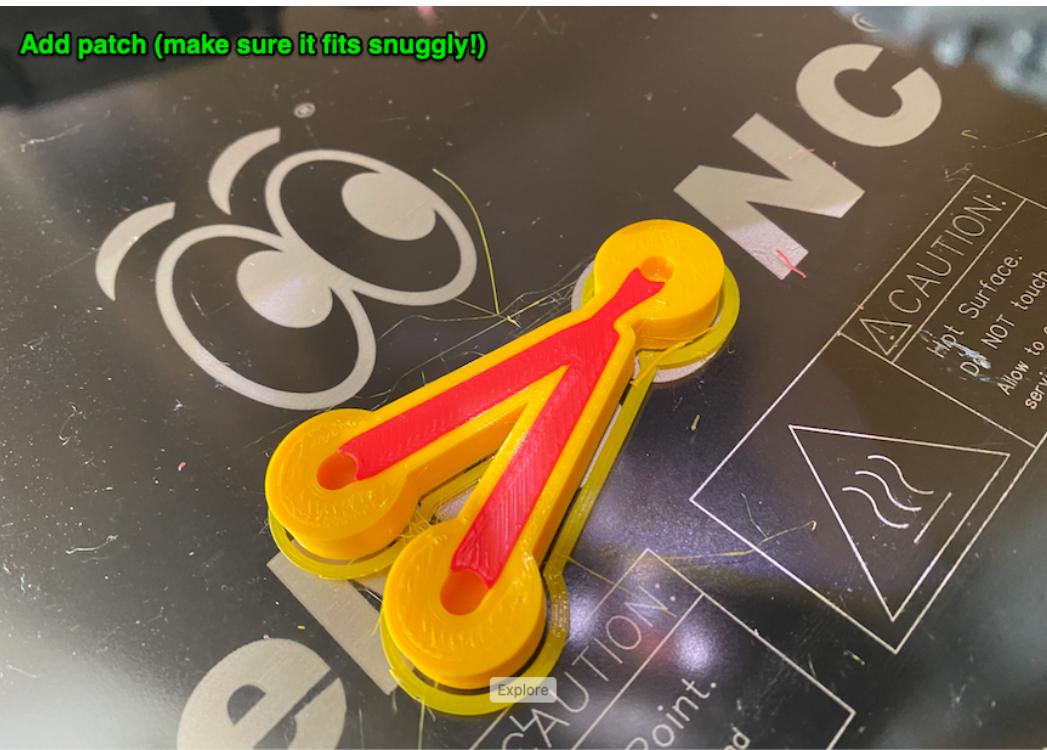
Add celebration at end of build (for .3g files only) Funky Town

Additional terminal commands for post processing

```
{REPLACE "\n; layer 54, Z = \" "; layer 54\nG28 Y0 X0\nM300\nM25\nG92 E0\nG28 Y0 X0\nlayer 54 }
```

NOTE: the layer number CAN BE DIFFERENT in your setup. You need to review the GCODE to determine what's the right layer number!

Step 3: once the print stops, it is time to patch it



Step 4: Continue printing

Note: if the patch moves during this step, it means that it is too loose. You can change the X-Y dimensions of the print FOR THE PATCH to find the right size, compensating for any printing differences. Also, you can hold the patch in place using a screwdriver or any other suitable tool. You need to be careful not to be in the path of the printer nozzle to avoid any crash.

