Slicing software instructions

1. Basic settings

Preferences ✕
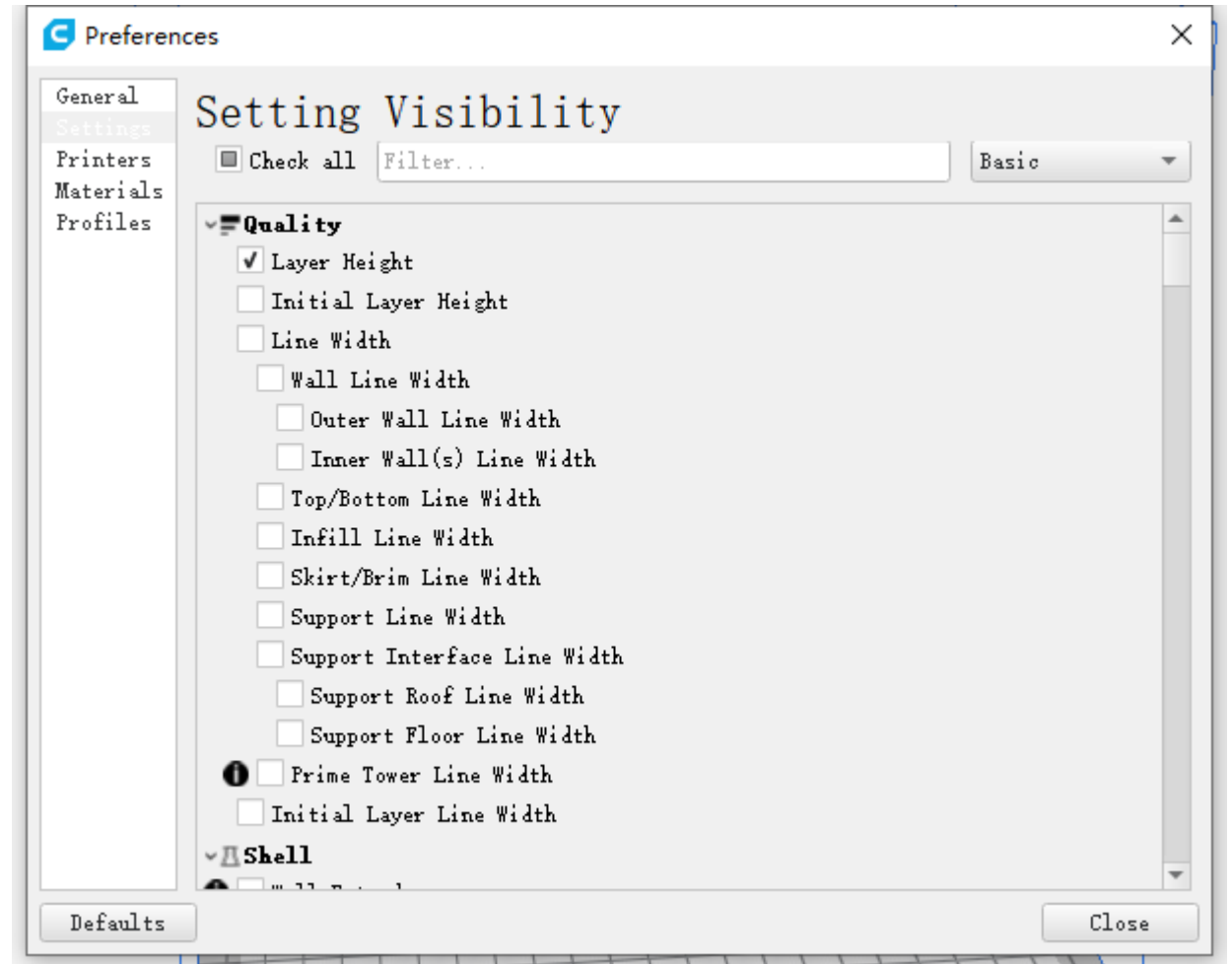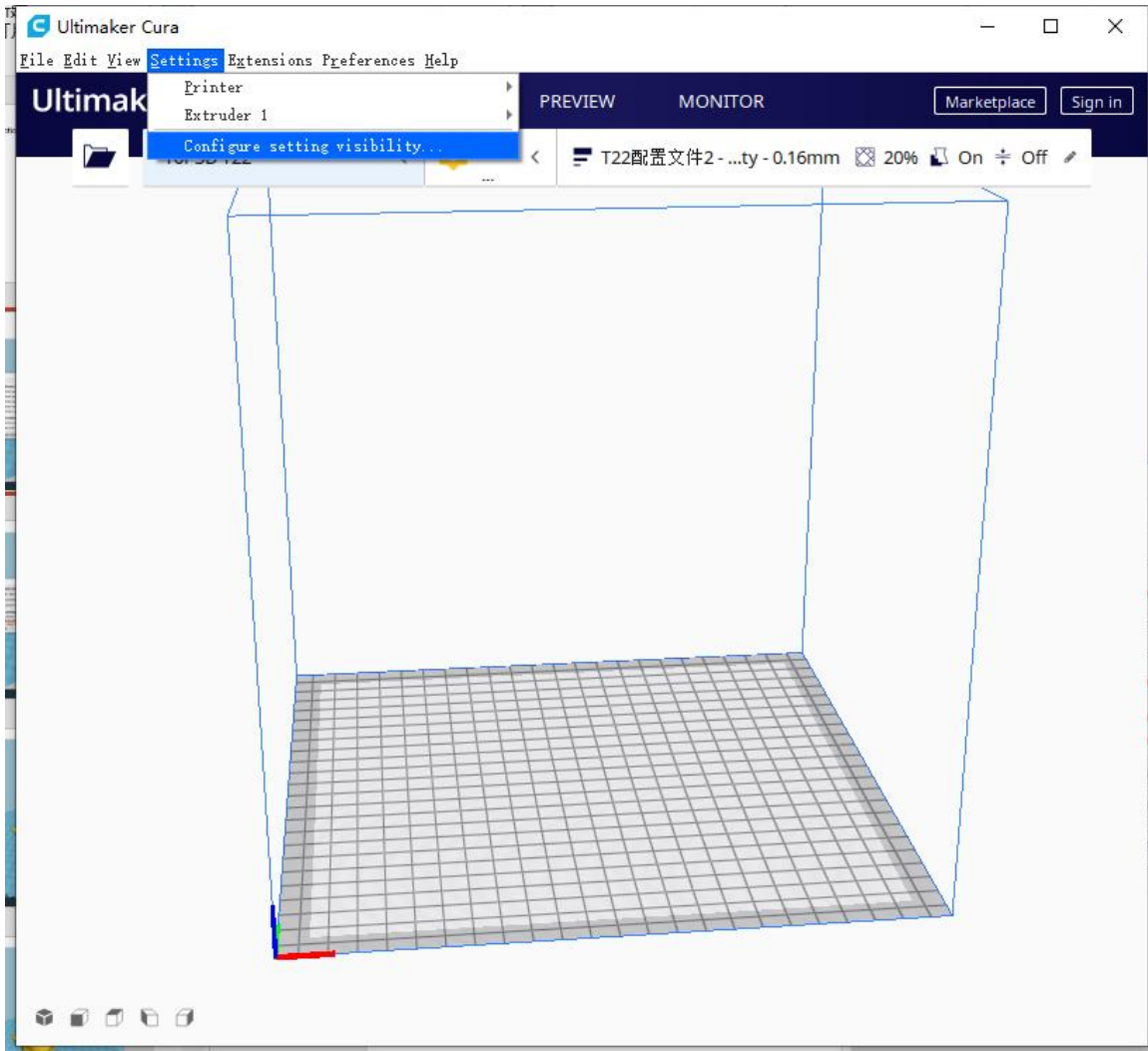
General

Settings
Printers
Materials
Profiles

General

Interface

choose a language

Language: English ▼   Currency: €

Theme: Ultimaker ▼

choose model

You will need to restart the application for these changes to have effect.

☐ Slice automatically

Viewport behavior
☑ Display overhang
☑ Display model errors
☐ Center camera when item is selected
☐ Invert the direction of camera zoom.
☐ Zoom toward mouse direction
☐ Ensure models are kept apart
☑ Automatically drop models to the build plate
☑ Caution message in g-code reader
☐ Force layer view compatibility mode (restart required)
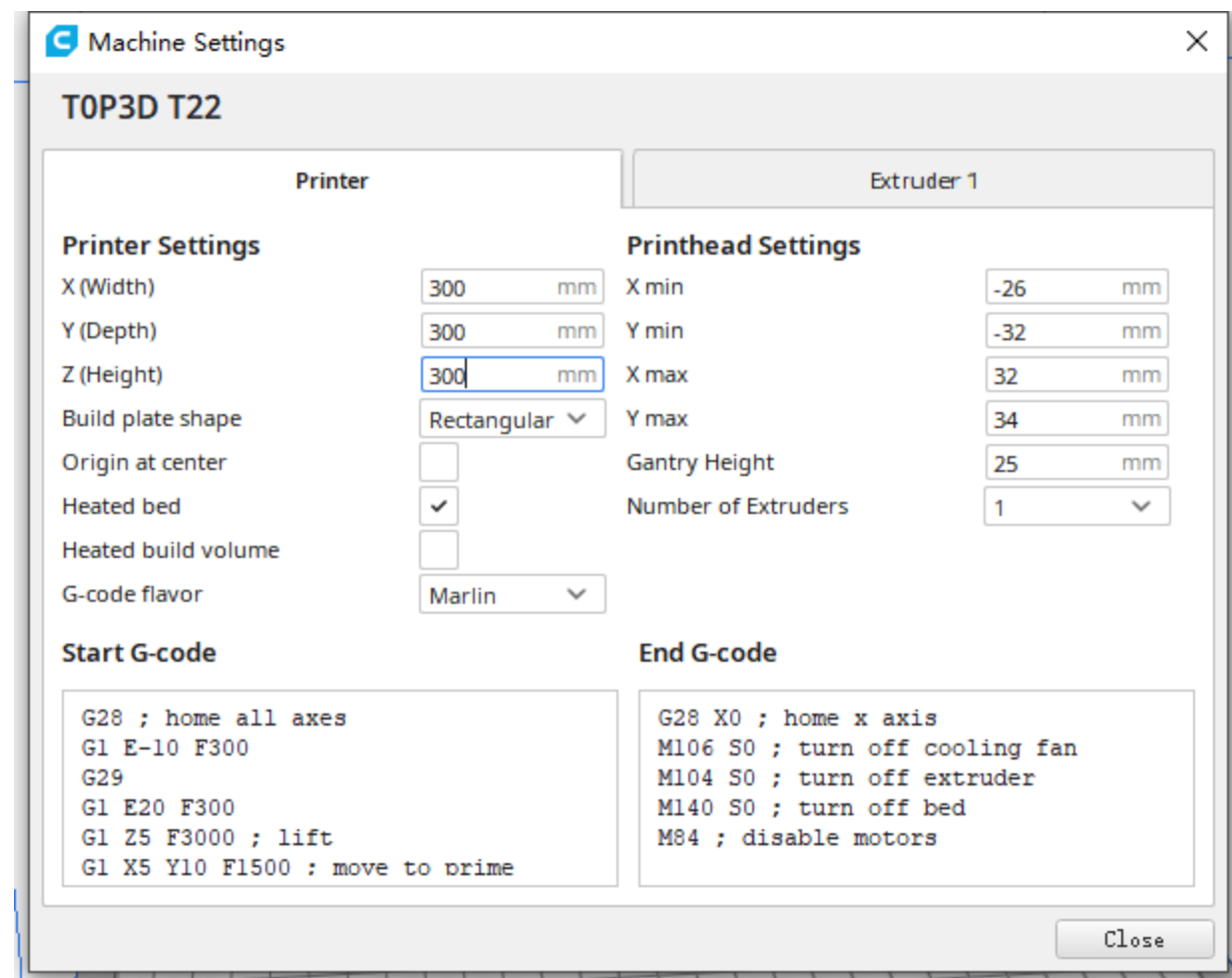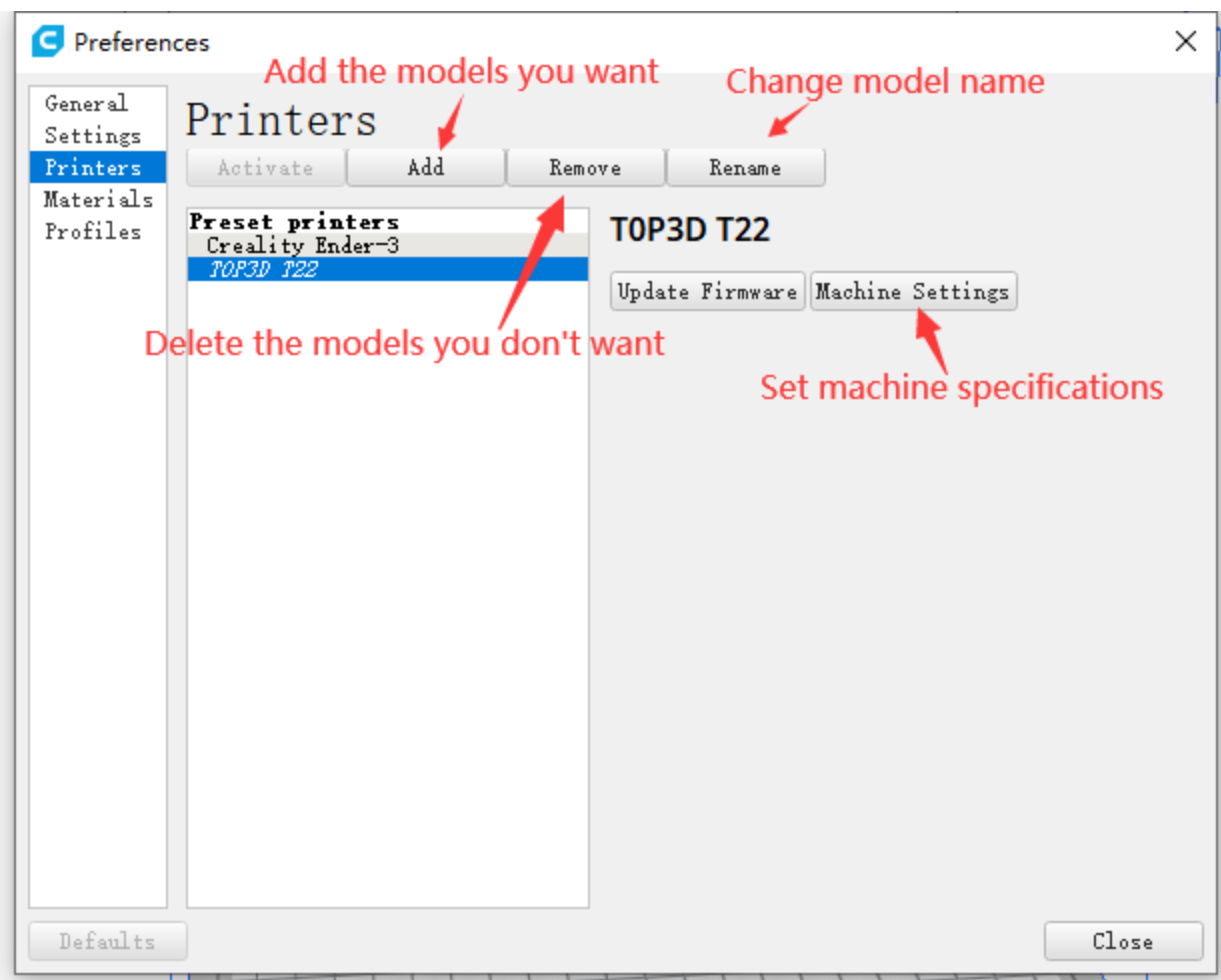☑ Restore window position on start
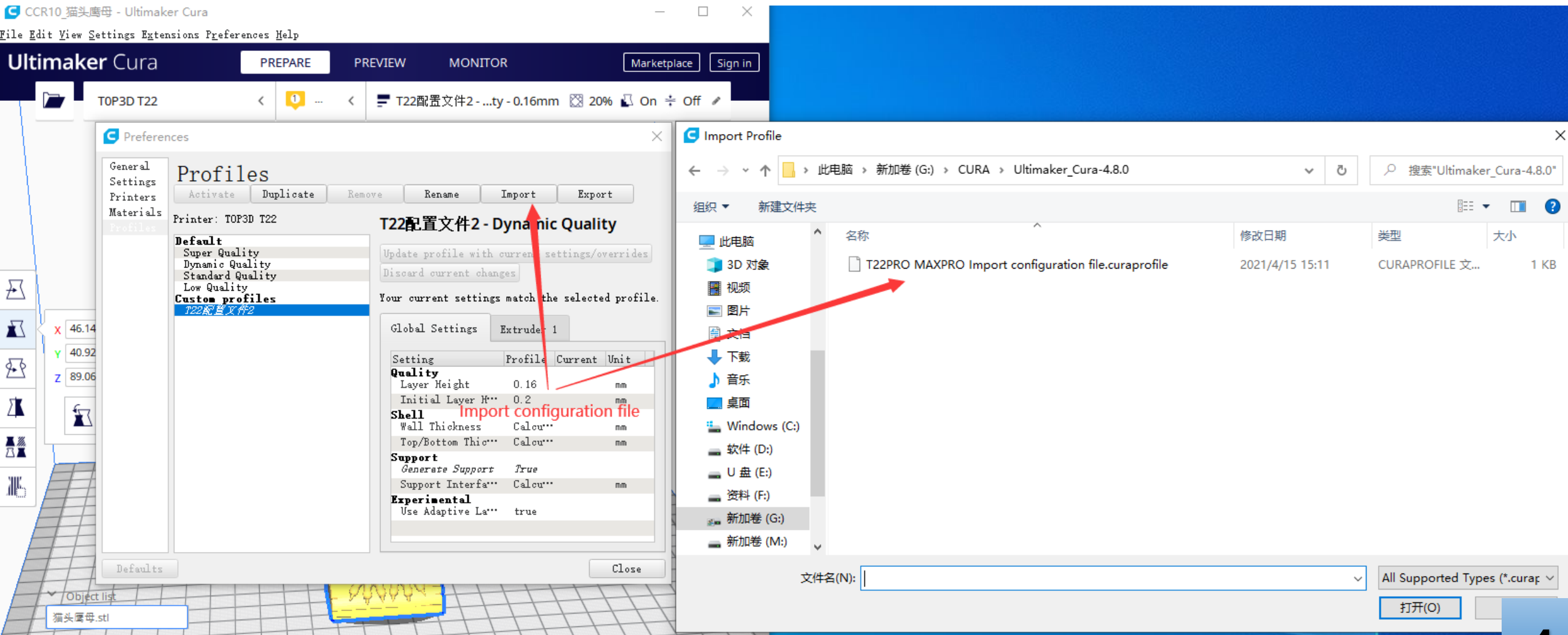Camera rendering:
Perspective ▼

Opening and saving files
☐ Use a single instance of Cura

Defaults   Close

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Preferences

General Settings
Printers
Materials
Profiles

Printers

Add the models you want ↗

Change model name ↗

Activate | Add | Remove | Rename

Delete the models you don't want ↗

Preset printers
Creality Ender-3
TOP3D T22

TOP3D T22

Update Firmware | Machine Settings

Set machine specifications ↗

Defaults | Close

Machine Settings

TOP3D T22

Printer | Extruder 1

Printer Settings

X (Width)	300	mm
Y (Depth)	300	mm
Z (Height)	300	mm
Build plate shape	Rectangular ⌄	
Origin at center	☐	
Heated bed	✔	
Heated build volume	☐	
G-code flavor	Marlin ⌄	

Printhead Settings

X min	-26	mm
Y min	-32	mm
X max	32	mm
Y max	34	mm
Gantry Height	25	mm
Number of Extruders	1 ⌄	

Start G-code

```
G28 ; home all axes
G1 E-10 F300
G29
G1 E20 F300
G1 Z5 F3000 ; lift
G1 X5 Y10 F1500 ; move to prime
```

End G-code

```
G28 X0 ; home x axis
M106 S0 ; turn off cooling fan
M104 S0 ; turn off extruder
M140 S0 ; turn off bed
M84 ; disable motors
```
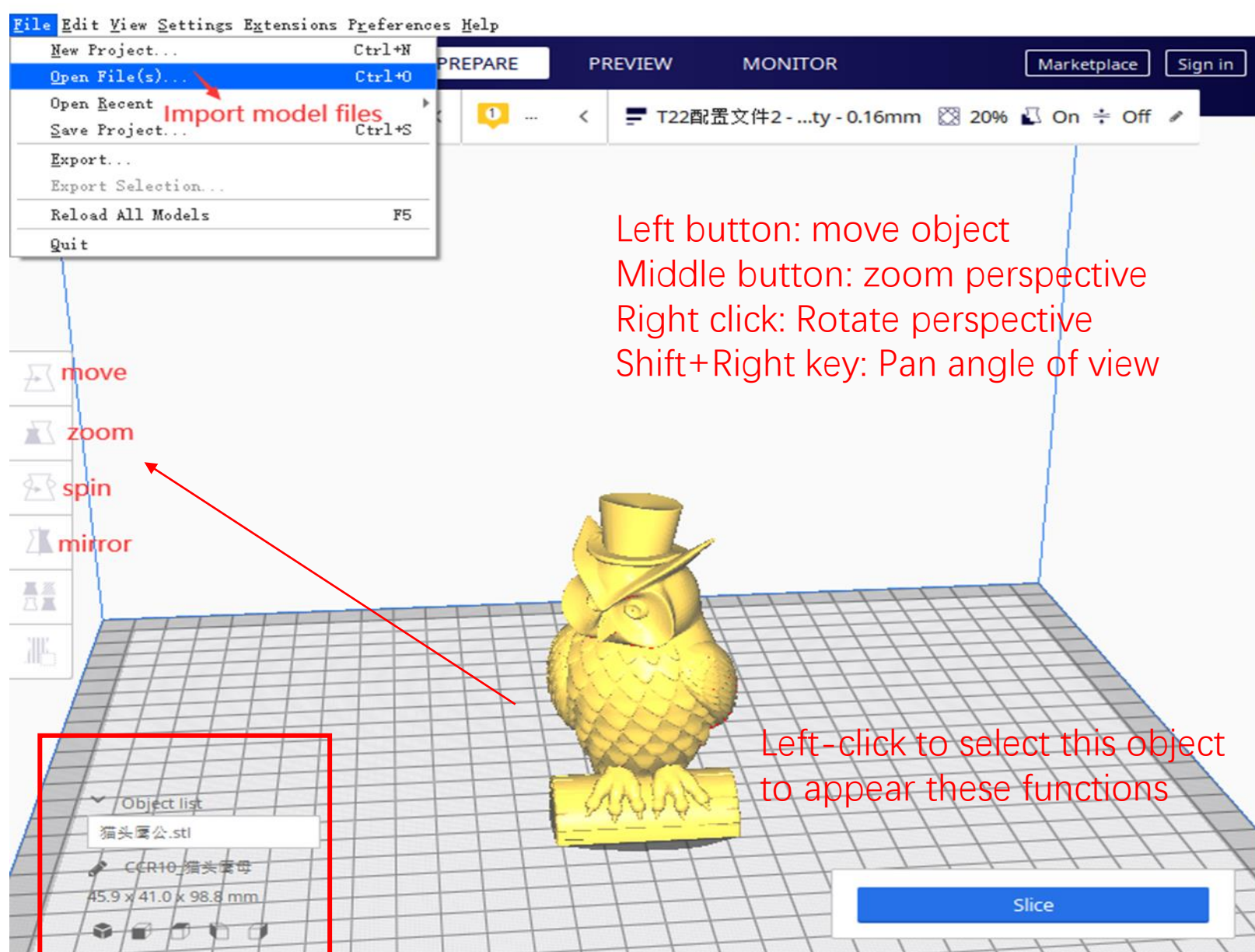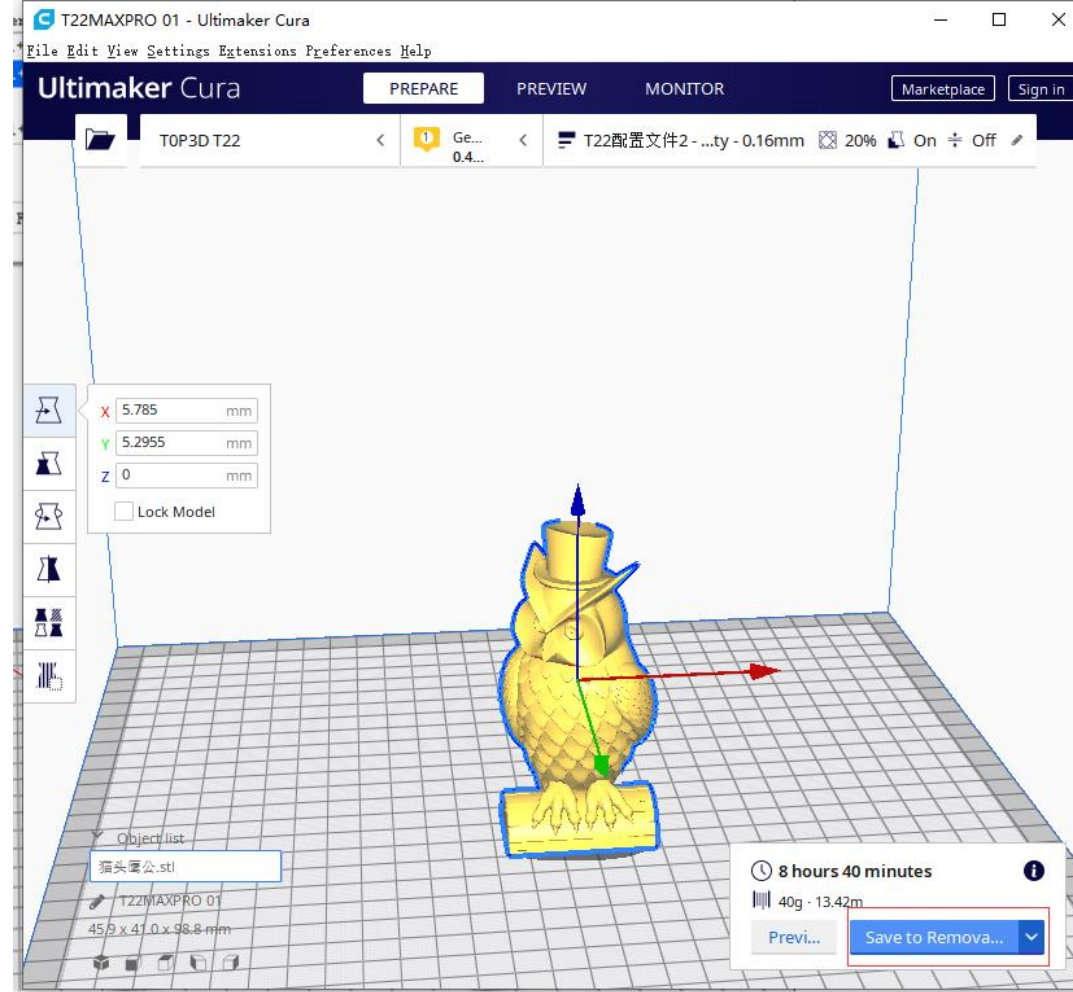
Close

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We provide a reference configuration file, just import the configuration file directly.

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Then you can import the model through "File"> "Read Model File" or open the file icon or directly drag the model file into the software. The operation of the model is as follows:


Left button: move object
Middle button: zoom perspective
Right click: Rotate perspective
Shift+Right key: Pan angle of view

Left-click to select this object
to appear these functions

Import model files

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Go to "File">Save gcode to SD card. The file name "XX.gcode" must be English or numbers, and cannot be special characters such as Chinese. Save the sliced file to the SD card

then insert SD card into the card slot, and open Power supply, Select "start print" in the main menu, and then select the "XX.gcode" file you just saved, confirm to print.
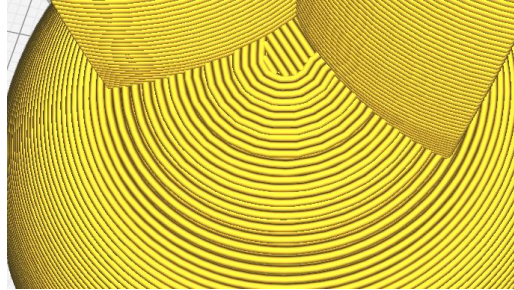
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二. Detailed parameter settings
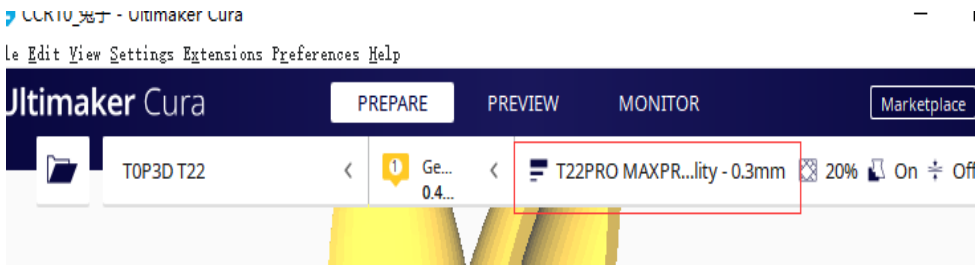
Layer thickness: 0.1 printing accuracy is relatively high, generally 0.2, if you want to save printing time, you can also use 0.3, the greater the layer thickness, the shorter the printing time.
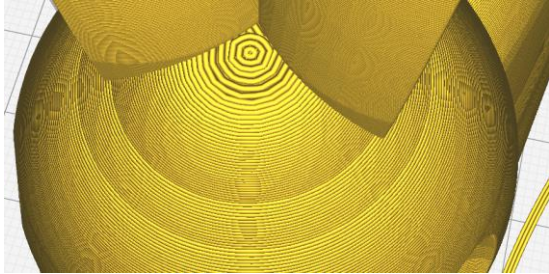
Left: 0.1mm layer thickness   Right: 0.3mm layer thickness

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