

ZONESTAR

Settings Guide



www.zonestar3d.com



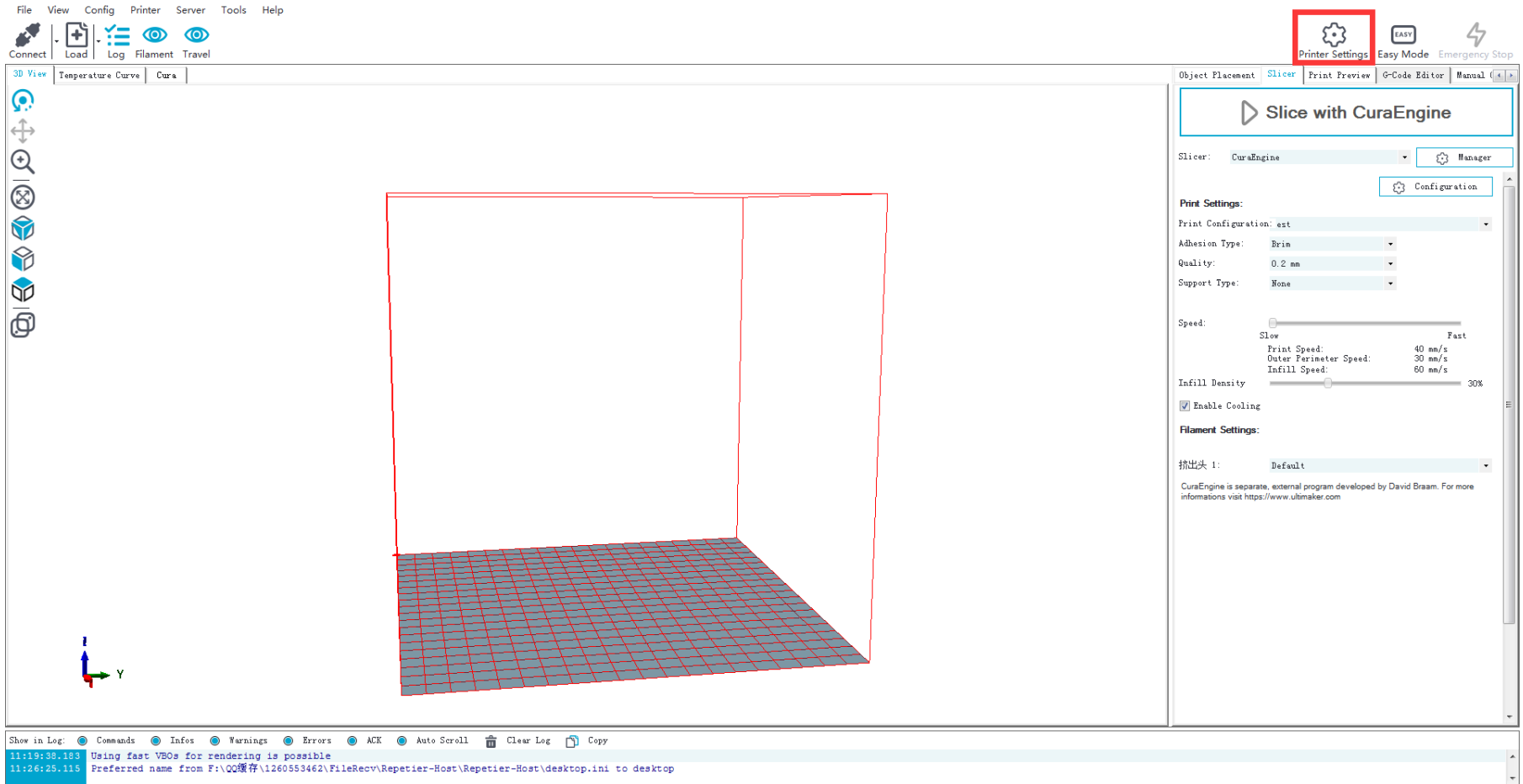
[Youtube Channle](#)



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Open Printer Settings

Click "Printer Settings" to open the page of settings



Connection Setting

Printer Settings

Printer: default ← You can rename to your printer or what you want

Connection | Printer | Extruder | Printer Shape | Scri

Connector: Serial Connection Help

Notice: You have a Repetier-Server installation. We highly recommend using the Repetier-Server connector instead. Click "Help" for more informations.

Port: Auto

Baud Rate: 115200 ← Set it to 115200

Transfer Protocol: Autodetect

Reset on Emergency Send emergency command and reconnect

Receive Cache Size: 127

Communication Timeout: [s]

☐ Use Ping-Pong Communication (Send only after ok)

The printer settings always correspond to the selected printer at the top. They are stored with every OK or apply. To create a new printer, just enter a new printer name and press apply. The new printer starts with the last settings selected.

OK Apply Cancel

Extruder Setting

Printer Settings

Printer: default

Connection | Printer | **Extruder** | Printers | Advanced

Click it first

Set it how much extruder your printer have

Number of Extruder: 16

Number of Fans: 1

Max. Extruder Temperature: 260

Max. Bed Temperature: 115

Max. Volume per second: 12 [mm³/s]

☒ Printer has a Mixing Extruder (one nozzle for all colors)

If your printer has mixing extruder, check it

Extruder 1

Name: E0

Diameter: 0.4 [mm]

Color: [Blue]

Offset X: 0 Offset Y: 0 [mm]

Rename it of number or what you want (Set other extruder like it)

Set It 0.4 (Set other extruder like it)

Extruder 2

Name: E1

Diameter: 0.4 [mm] Temperature Offset: 0 [°C]

Color: [Red]

Offset X: 0 Offset Y: 0 [mm]

Extruder 3

OK Apply Cancel

Printer Setting

Printer Settings

Printer: default

Connection | Printer | Extruder | **Printer Shape** |

Printer Type: Classic Printer

Home X: 0 Home Y: 0 Home Z: 0

X Min: 0 X Max: 200 Bed Left: 0

Y Min: 0 Y Max: 200 Bed Front: 0

Print Area Width: 200 mm

Print Area Depth: 200 mm

Print Area Height: 200 mm

Set it According your Printer

The min and max values define the possible range of extruder coordinates. These coordinates can be negative and outside the print bed. Bed left/front define the coordinates where the printbed itself starts. By changing the min/max values you can even move the origin in the center of the print bed, if supported by firmware.

Y Max

D

E

OK Apply Cancel

To Configure Filament

The screenshot displays the CuraEngine software interface. On the left, the 'CuraEngine Settings' window is open, showing the 'Print' tab. The 'Import' button is highlighted with a red box. A text box with the text 'Input the "Print.rcp"' has an arrow pointing to this button. On the right, the main Cura interface is visible, showing the 'Slice with CuraEngine' button. A text box with the text 'Click it first' has an arrow pointing to the 'Configuration' button, which is also highlighted with a red box. The bottom of the interface shows a log window with the following text:

```
Show in Log: Commands Infos Warnings Errors ACK Auto Scroll Clear Log Copy
16:50:22.480 OpenGL renderer:GeForce GT 730/PCIe/SSE2
16:50:22.480 Using fast VBOs for rendering is possible
Disconnected: default Idle
```

To Configure Printer

The screenshot shows the CuraEngine Settings window. The 'Print' tab is selected, and the 'Filament' sub-tab is highlighted with a red box and an arrow pointing to it with the text 'Click it first'. The 'Import' button is also highlighted with a red box and an arrow pointing to it with the text 'Input the “PLA.rcf” and “ABS.rcf”'. The settings are organized into sections: Filament, Temperature, and Cooling. The Filament section includes fields for Filament Diameter and Flow. The Temperature section includes fields for Print Temperature and Bed Temperature. The Cooling section includes fields for Min. Fan Speed, Max. Fan Speed, and Minimum Layer Time. The bottom of the window shows a log window with the following text: 'Show in Log: Commands Infos Warnings Errors ACK Auto Scroll Clear Log Copy', '16:50:22.480 OpenGL renderer:GeForce GT 730/PCIe/SSE2', '16:50:22.480 Using fast VBOs for rendering is possible', and 'Disconnected: default'.

File View Config Printer Server Tools Help

Connect Load Log Filament Travel

3D View Temperature Curve Cura

CuraEngine Settings

Print Filament

Default

Save Save as ... Delete Import Export

Click it first

Input the “PLA.rcf” and “ABS.rcf”

Filament

Filament Diameter: 1

Flow: 1

Temperature

Print Temperature: 210 [° C]

Bed Temperature: 50 [° C]

Cooling

Min. Fan Speed: 50 [%]

Max. Fan Speed: 100 [%]

Minimum Layer Time: 5 [s]

CuraEngine only supports one extruder diameter and flow value, because it assumes identical extruders. If you have a multi-extruder setup with different values, the values from the first extruder are used for all. Print temperatures are set in the start g-code, so using different temperatures for different materials is no problem. For cooling the highest values of all extruders are used.

Object Placement Slicer Print Preview Manual Control SD Card

Slice with CuraEngine

Slicer: CuraEngine Manager

Configuration

Print Settings:

Print Configuration: est

Adhesion Type: Brim

Quality: 0.2 mm

Support Type: None

Speed:

Slow Fast

Print Speed: 40 mm/s

Outer Perimeter Speed: 30 mm/s

Infill Speed: 60 mm/s

Infill Density 30%

☒ Enable Cooling

Filament Settings:

Extruder 1: Default

CuraEngine is separate, external program developed by David Braam. For more informations visit <https://www.ultimaker.com>

Show in Log: Commands Infos Warnings Errors ACK Auto Scroll Clear Log Copy

16:50:22.480 OpenGL renderer:GeForce GT 730/PCIe/SSE2

16:50:22.480 Using fast VBOs for rendering is possible

Disconnected: default

Idle