



# How to print from PC by Repetier-Host

Version : 1.0

# Operation Process

## 3D Printing Process



\*3D printer can only support gcode files, before placing the 3D model into 3d printer, need to convert the 3D model file (usually they are stl, obj, AMF files) to gcode files, this process is called slicing.

## Repetier-host installation and setting process



## Slicing and print process

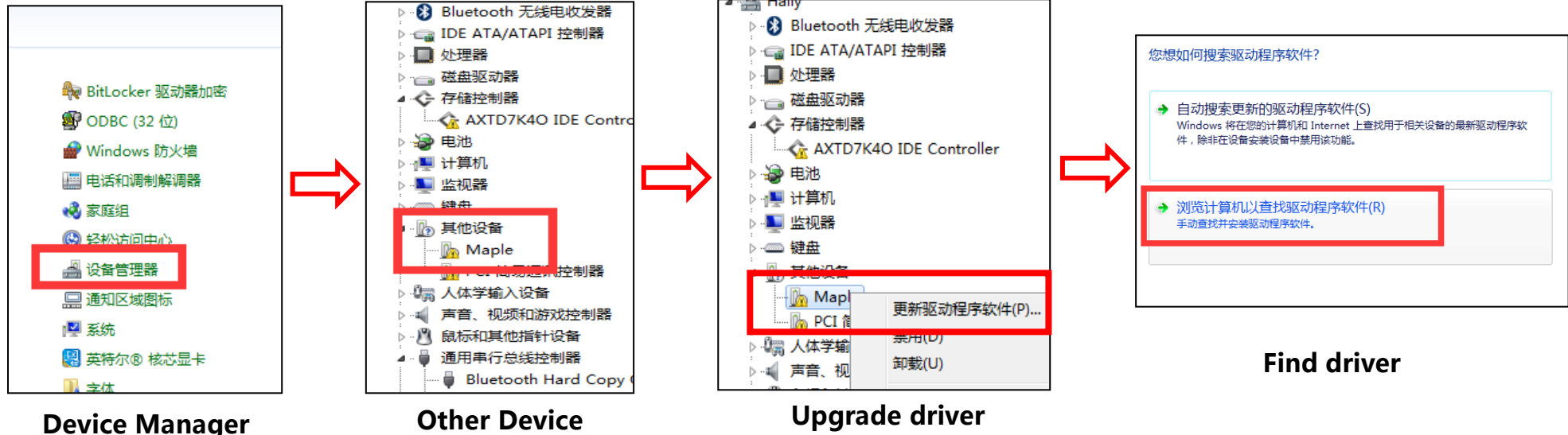


**Note:** This document only provides a brief description of Repetier-Host. For more details, please search on the web.

# Install the driver (Windows 64-bit)

1. Power on printer first!!
2. Connect the printer to the PC by USB cable
3. Find communication port

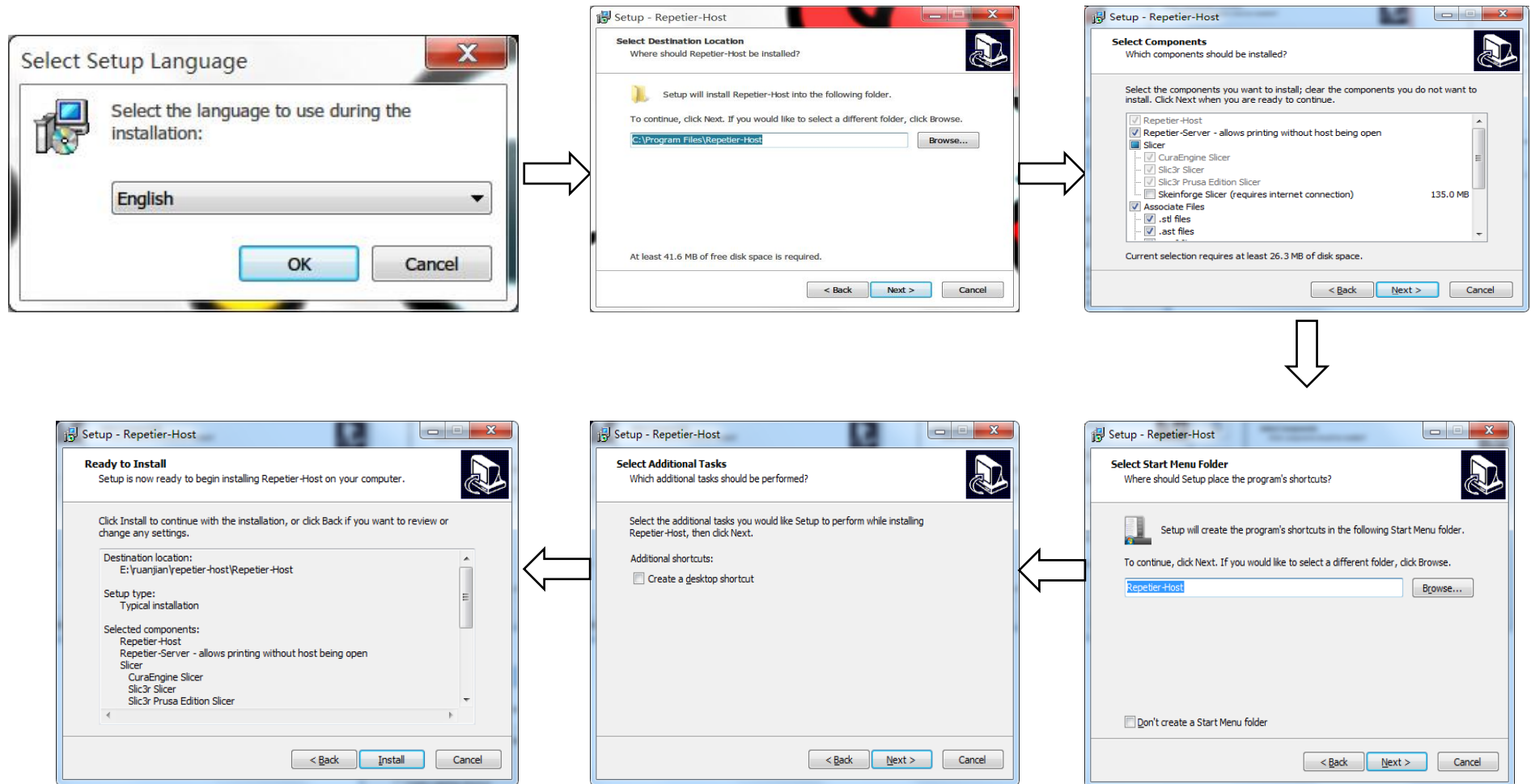
Right click on "Computer" >> "Properties" >> "Device Manager" >> "Other Device" >> "Maple"



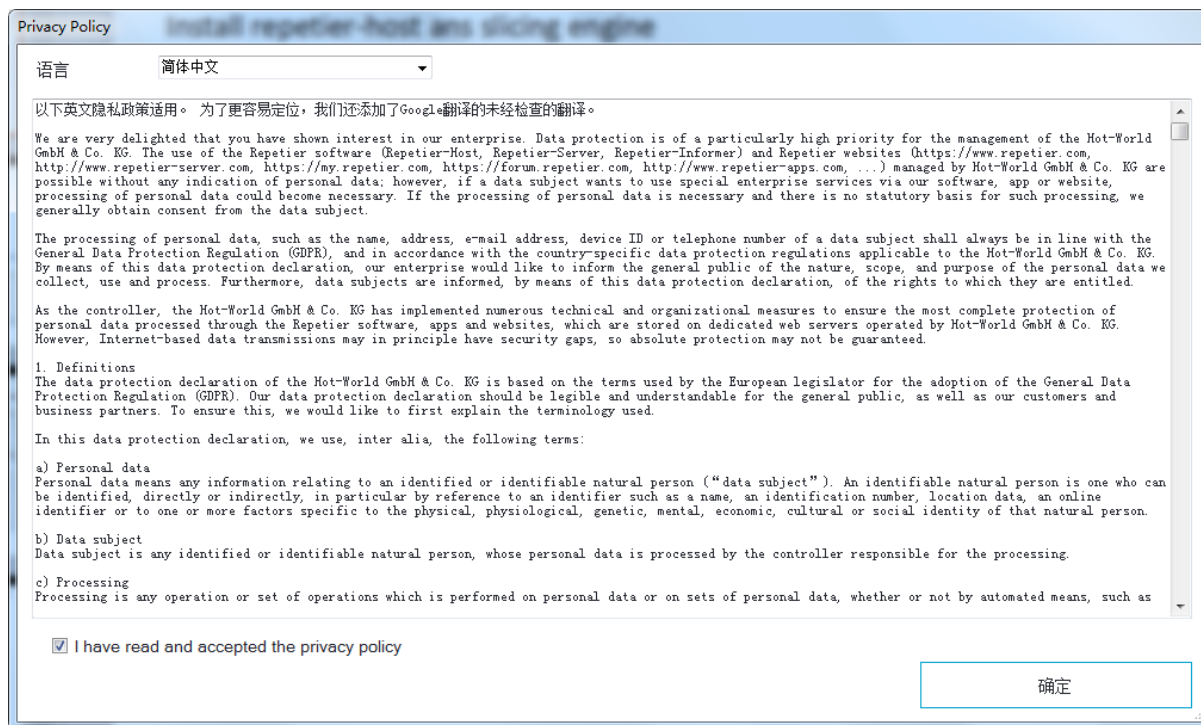
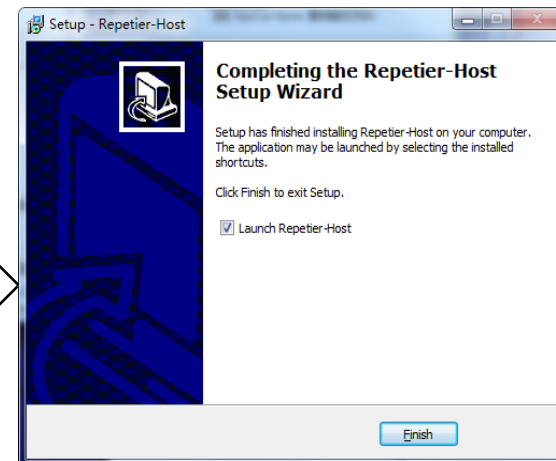
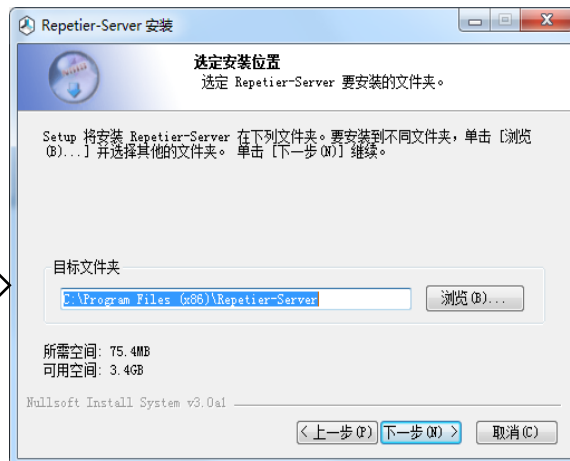
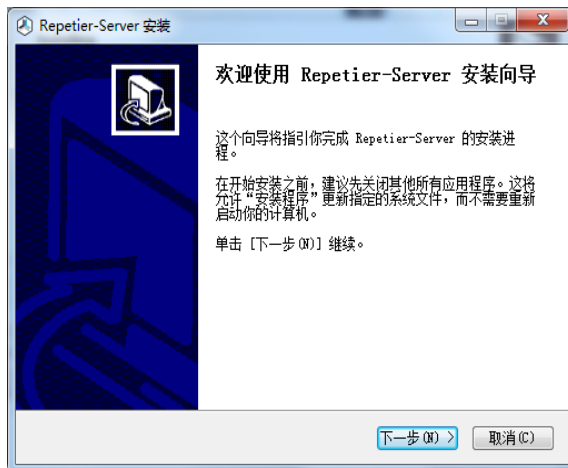
Please note the port number

# Install Repetier-Host

Install repetier-host and slicing engine

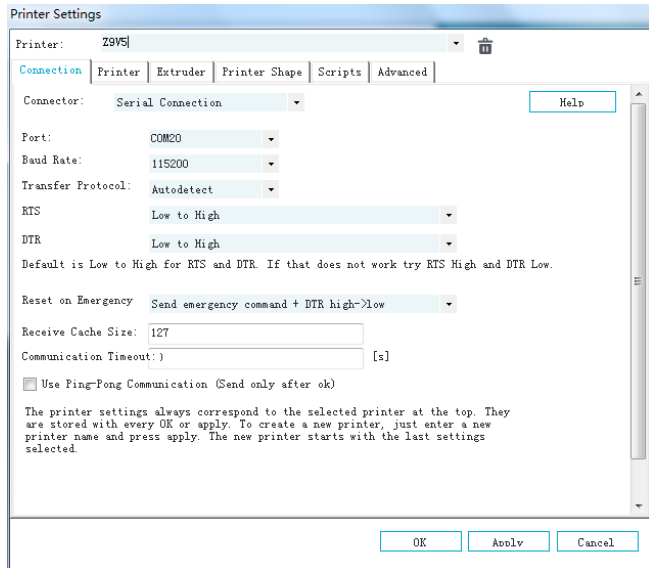


# Install Repetier-Host



# Set Parameters

Open Repetier-Host and click on “Printer Settings” in the upper right corner to set the printer parameter.



Printer Settings

Printer: Z9V5

Connection | Printer | Extruder | Printer Shape | Scripts | Advanced

Connector: Serial Connection [Help]

Port: COM20

Baud Rate: 115200

Transfer Protocol: Autodetect

RTS: Low to High

DTR: Low to High

Default is Low to High for RTS and DTR. If that does not work try RTS High and DTR Low.

Reset on Emergency: Send emergency command + DTR high->low

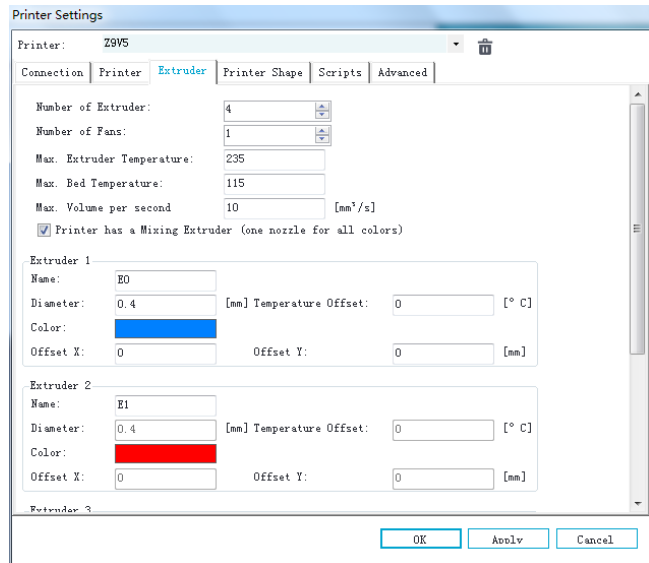
Receive Cache Size: 127

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



Printer Settings

Printer: Z9V5

Connection | Printer | Extruder | Printer Shape | Scripts | Advanced

Number of Extruder: 4

Number of Fans: 1

Max. Extruder Temperature: 235

Max. Bed Temperature: 115

Max. Volume per second: 10 [mm³/s]

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

Extruder 1

Name: E0

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

Color: [Blue]

Offset X: 0 Offset Y: 0 [mm]

Extruder 2

Name: E1

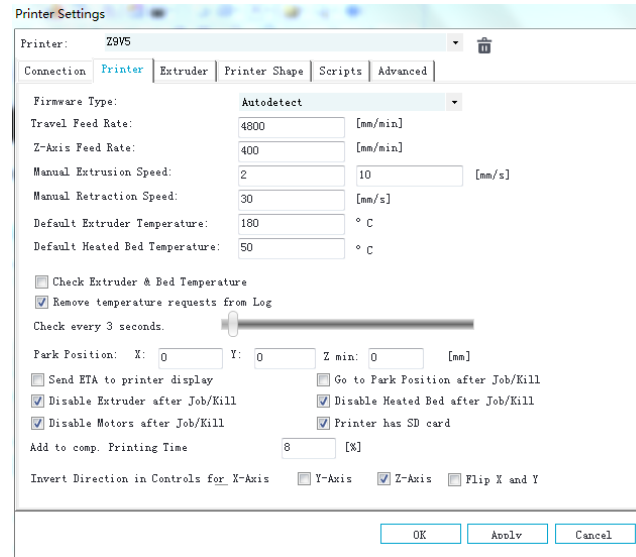
Diameter: 0.4 [mm] Temperature Offset: 0 [°C]

Color: [Red]

Offset X: 0 Offset Y: 0 [mm]

Extruder 3

OK Apply Cancel



Printer Settings

Printer: Z9V5

Connection | Printer | Extruder | Printer Shape | Scripts | Advanced

Firmware Type: Autodetect

Travel Feed Rate: 4800 [mm/min]

Z-Axis Feed Rate: 400 [mm/min]

Manual Extrusion Speed: 2 10 [mm/s]

Manual Retraction Speed: 30 [mm/s]

Default Extruder Temperature: 180 °C

Default Heated Bed Temperature: 50 °C

☐ Check Extruder & Bed Temperature

☒ Remove temperature requests from Log

Check every 3 seconds.

Park Position: X: 0 Y: 0 Z min: 0 [mm]

☐ Send ETA to printer display

☐ Go to Park Position after Job/Kill

☒ Disable Extruder after Job/Kill

☒ Disable Heated Bed after Job/Kill

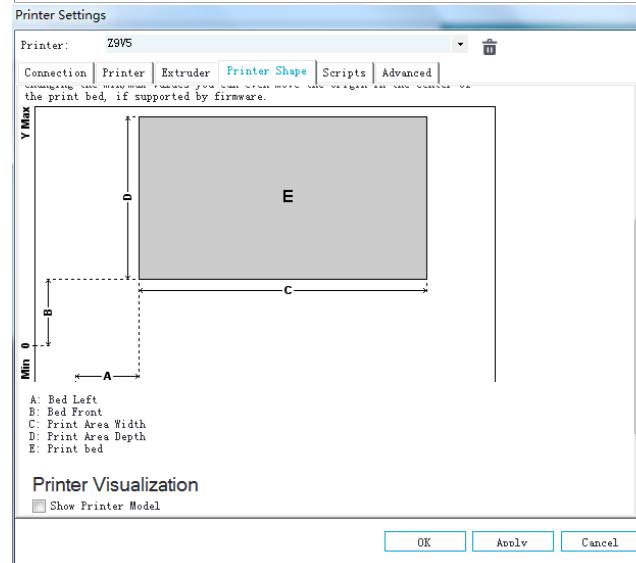
☒ Disable Motors after Job/Kill

☒ Printer has SD card

Add to comp. Printing Time: 8 [%]

Invert Direction in Controls for: ☐ X-Axis ☐ Y-Axis ☒ Z-Axis ☐ Flip X and Y

OK Apply Cancel



Printer Settings

Printer: Z9V5

Connection | Printer | Extruder | Printer Shape | Scripts | Advanced

Printer Shape

Min 0 Y Max

A: Bed Left

B: Bed Front

C: Print Area Width

D: Print Area Depth

E: Print bed

Printer Visualization

☐ Show Printer Model

OK Apply Cancel

# Manual Control Menu


Object Placement

Slicer

Print Preview

Manual Control


SD Card


 Heating Bed


G-Code:


Send

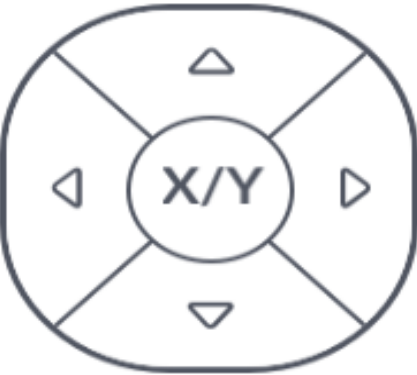
X: 0.00 Y: 0.00 Z: 15.00


 X


 Y



 Z











 P 1 2 3 4 5 ?




Feedrate

100




Fan

100



Bed Temperature - 42.27°C

50



Extruder 1 - 24.59°C

210

Send gcode to printer

Current position of axis


Move axis

Print Speed

Fan Speed

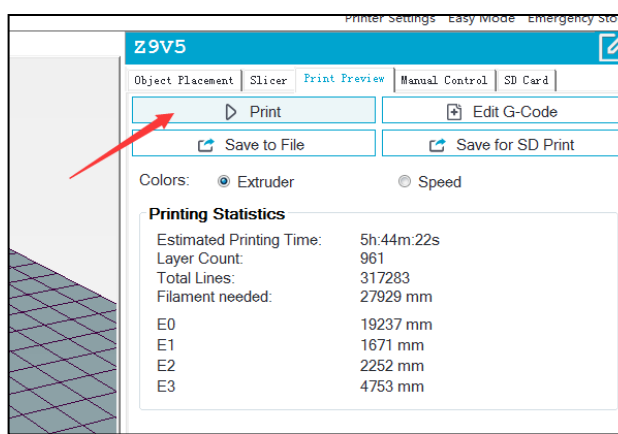
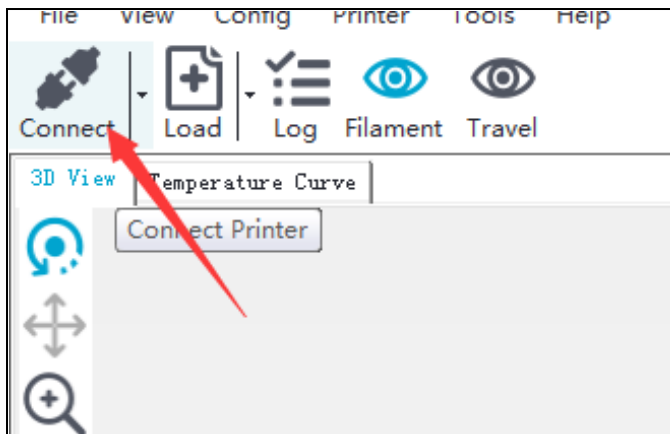
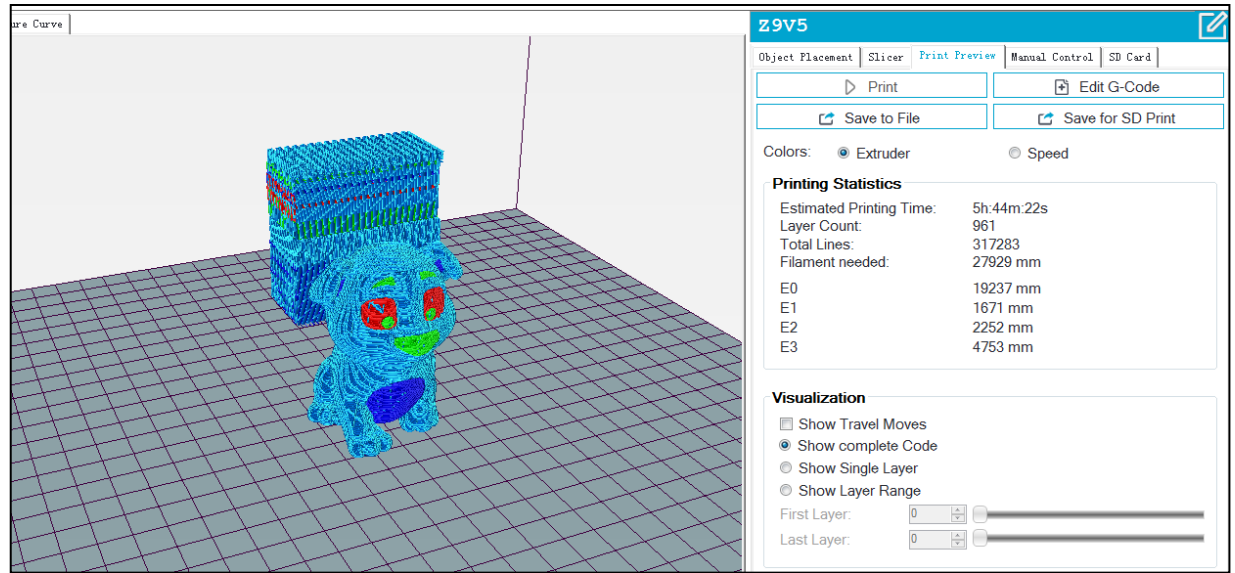
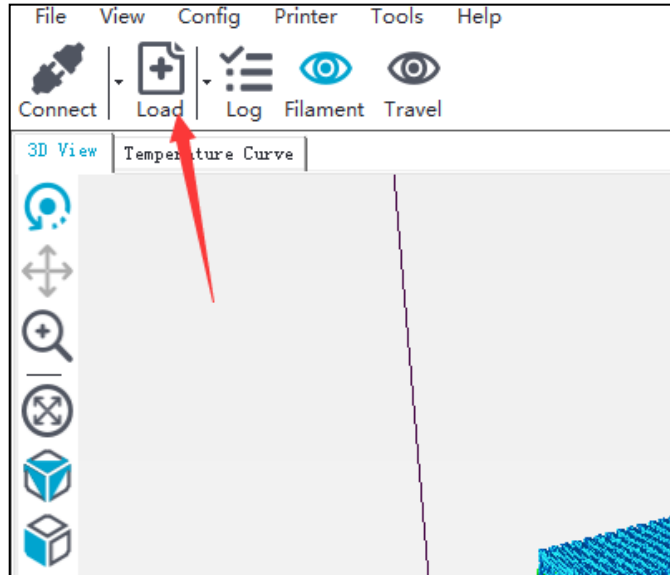
Hotbed Temperature

Nozzle

 Zonestar

# Load and Preview gcode file

1. Use Cura software to slice 3D model to gcode file, please refer to Slicing guide for Mixing Color Printer V1\_1.pdf
2. Load gcode file, preview and then start to print from PC





# User guide for Repetier-host

Please refer to the following links for more detailed instructions on how to use them

<https://www.repetier.com/documentation/repetier-host/>

## □ Repetier-Host Documentation

The software is very easy and intuitive to use. To help you get started, please see our documentation. For specific questions and problems our community will help you in [our forum](#).

□ Windows & Linux Documentation

□ Mac Documentation