3D Metal Printing User's Manual

This document will guide you through the use of the 3D Metal Printer, and some possibilities of what to check if something has gone wrong during a print.

1. **Power on everything**
2. **Run LinuxCNC on the CNC control computer**
3. **Home the CNC machine**
4. **Open the file you plan to print on LinuxCNC.**
5. **Run 3DP\_Controller.exe on the control computer**
6. **Follow the steps displayed by the 3DP\_Controller program for calibration**

* Make sure welder is turned on and not grounded
* Make sure nothing can get in the way of the wire as it feeds as this will affect the speed it feeds at, cut the wire off at the nozzle when feed is complete
* Alternatively; Leave the system grounded and find a portion of your base plate that will not affect the rest of your print. Position the welder above this and run the calibration procedure. Note: this will leave a small bead which can be chipped off later.

1. **Check if the welder's nozzle needs to be cleared of slag, act accordingly.**
2. **Enter the CNC speed of your print into the 3DP\_Controller program when prompted.**
3. **Run your CNC program on LinuxCNC**
4. **Monitor the system for errors during print.**