

MonoPrice Mini Delta

Saturday, September 30, 2017 10:33 PM

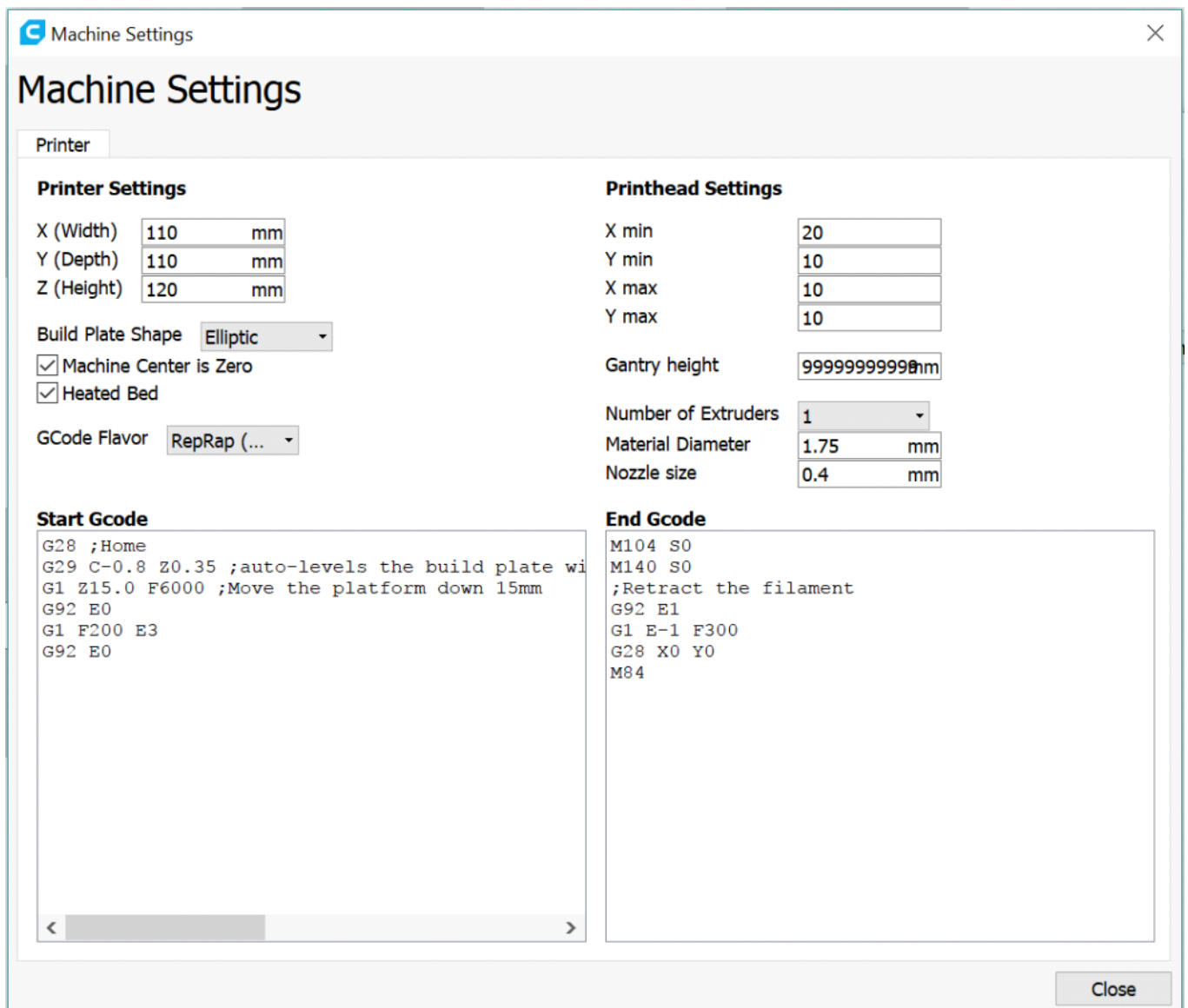
I changed the Z offset after autolevel to 0.45mm instead of 0.3 to account for the thickness of the painters tape on top of the build platform sticker.

0.45mm was too far away, moving to 0.35mm.

0.35 seems to work fine, but it seems like the center of the plate is lower than the outside edges of the plate.

Cura Setup

I used V2.6.2. When you first start Cura it will ask you to set up your printer, the MP mini delta is not listed, so you will have to do a custom printer.



The screenshot shows the 'Machine Settings' window in Cura. The 'Printer' tab is selected. The 'Printer Settings' section includes: X (Width) 110 mm, Y (Depth) 110 mm, Z (Height) 120 mm, Build Plate Shape set to 'Elliptic', 'Machine Center is Zero' checked, 'Heated Bed' checked, and GCode Flavor set to 'RepRap (...)'. The 'Printhead Settings' section includes: X min 20, Y min 10, X max 10, Y max 10, Gantry height 999999999mm, Number of Extruders 1, Material Diameter 1.75 mm, and Nozzle size 0.4 mm. The 'Start Gcode' section contains: G28 ;Home, G29 C-0.8 Z0.35 ;auto-levels the build plate wi, G1 Z15.0 F6000 ;Move the platform down 15mm, G92 E0, G1 F200 E3, G92 E0. The 'End Gcode' section contains: M104 S0, M140 S0, ;Retract the filament, G92 E1, G1 E-1 F300, G28 X0 Y0, M84. A 'Close' button is at the bottom right.

Printer Settings	
X (Width)	110 mm
Y (Depth)	110 mm
Z (Height)	120 mm
Build Plate Shape	Elliptic
<input checked="" type="checkbox"/> Machine Center is Zero	
<input checked="" type="checkbox"/> Heated Bed	
GCode Flavor	RepRap (...)

Printhead Settings	
X min	20
Y min	10
X max	10
Y max	10
Gantry height	999999999mm
Number of Extruders	1
Material Diameter	1.75 mm
Nozzle size	0.4 mm

Start Gcode

```
G28 ;Home
G29 C-0.8 Z0.35 ;auto-levels the build plate wi
G1 Z15.0 F6000 ;Move the platform down 15mm
G92 E0
G1 F200 E3
G92 E0
```

End Gcode

```
M104 S0
M140 S0
;Retract the filament
G92 E1
G1 E-1 F300
G28 X0 Y0
M84
```

Close

Note if you don't see the Start Gcode and End Gcode windows you can grab the lower right corner and drag it down to expand the window.

Fill in the setting as seen above, note this is **very important**, you must add the G29 line after the G28 line in the Start Gcode, if you don't, then the printer head will crash into the build plate.

The full line is
G29 C-0.8 Z0.35 ;auto-levels the build plate with a overall vertical offset of 0.3mm with a center offset of -0.8mm

The ; is a comment, so all of the comment should be on the same line.

Now you should be good to go.

Just load a .stl file arrange it on the print bed, pick your filament and layer height save the gcode to your micro sd card and print. The preloaded material properties work very well.

MP Mini Delta

Material: PLA

Profile: Draft Quality - 0.2mm

Print Setup Recommended Custom

Infill

0% 20% 50% 100% Gradual

Generate Support

Build Plate Adhesion

Need help improving your prints?
Read the [Ultimaker Troubleshooting Guides](#)


You can adjust settings further by selecting custom instead of recommended. I usually turn off build plate adhesion since I don't want a brim.

I added a TPE material.

eLASTIC

Information

Print settings

Display Name	eLASTIC
Brand	INLAND
Material Type	TPE
Color	 BLUE

Properties

Density	1.20 g/cm ³
Diameter	1.75 mm
Filament Cost	\$ 19.00
Filament weight	500 g
Filament length	~ 173 m
Cost per Meter	~ 0.11 \$/m

Description