

**WEB-BASED MODEL SLICING  
FOR 3D PRINTERS**

BY

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## **Abstract**

3D printing currently contains a large gap between software and hardware. A hobbyist machine can now be purchased for less than \$500 but having good software to drive it is difficult to find. Currently the only competent and free slicing software available is Cura and Repetier Host. Currently, Cura has varied support on all platforms, and Repetier Host is intended only for Windows. The purpose of this research is to construct an open source, web based slicing software and make it simple for users without any prior knowledge of 3D printing to take full advantage of their printer and as a result will make 3D printing much more approachable for users who are not computer savvy. Additionally, this opens up opportunities for educators in STEM programs to teach students about 3D printing in a simple and practical way.

# Acknowledgments

# Contents

<b>1</b>	<b>Introduction</b>	<b>1</b>
1.1	The RepRap Idea . . . . .	3
1.2	Sudden Growth of 3D Printing . . . . .	3
1.3	Purpose of Research . . . . .	3
1.4	Research Objectives . . . . .	4
1.4.1	Design Intuitive Web Interface . . . . .	4
1.4.2	Run Beta Testing with Actual Users . . . . .	4
1.5	Related Work . . . . .	5
1.6	Thesis Map . . . . .	5
<b>2</b>	<b>Libraries &amp; Existing Code</b>	<b>7</b>
2.1	CuraEngine . . . . .	7
2.2	Client Side Libraries . . . . .	8
2.2.1	Bootstrap . . . . .	8
2.2.2	AngularJS . . . . .	8
2.3	JavaEE . . . . .	9
2.4	OctoPrint . . . . .	9
2.5	G-Code Visualizer . . . . .	10
<b>3</b>	<b>Methodology</b>	<b>11</b>
3.1	Research Design . . . . .	11
3.2	Working Procedure . . . . .	11
3.2.1	Web Interface . . . . .	11

3.2.2	Slicing Engine . . . . .	13
3.2.3	Web Tool Path Viewer . . . . .	13
3.3	Review and Usability Testing . . . . .	13
<b>4</b>	<b>Client Side</b>	<b>14</b>
4.1	AngularJS . . . . .	14
4.1.1	Controllers & Data Binding . . . . .	14
4.1.2	Factories & Services . . . . .	15
4.1.3	Directives . . . . .	15
4.2	WebSlicer AngularJS Structure . . . . .	15
4.2.1	app.js . . . . .	15
4.2.2	index.html . . . . .	16
4.2.3	Settings . . . . .	17
4.2.4	G-code Visualizer . . . . .	18
4.3	Key Challenges . . . . .	19
4.3.1	Visualizer Integration . . . . .	19
4.3.2	Interpolating Settings . . . . .	19
4.4	Other Planned Integrations . . . . .	20
4.4.1	OctoPrint . . . . .	20
4.4.2	Thingiverse & YouImagine . . . . .	20
4.5	Issues & Known Bugs . . . . .	21
<b>5</b>	<b>Server Side</b>	<b>23</b>
5.1	JavaEE Structure . . . . .	23
5.2	ProcessBuilder . . . . .	24
5.3	REST API . . . . .	25
5.4	Key Challenges . . . . .	25
5.4.1	ProcessBuilder Deadlock . . . . .	25
5.4.2	FileTracker Revamp . . . . .	27
5.5	Future Improvements . . . . .	28
5.6	Issues & Known Bugs . . . . .	29

<b>6</b>	<b>Discussion</b>	<b>30</b>
6.1	Usability Testing . . . . .	30
6.2	Data Gathering . . . . .	30
6.3	Design Updates & Improvements . . . . .	30
6.4	Future Work . . . . .	30



# List of Figures

1-1	(a) High level view of the normal 3D printing process. (b) High level view of proposed new process using WebSlicer. . . . .	2
3-1	High level view of how WebSlicer functions and how users will interact with it . . . . .	12
4-1	Full AngularJS structure breakdown . . . . .	16
4-2	The flow of data through the application from beginning to end of client side user interaction . . . . .	22
5-1	The structure of the server side of WebSlicer . . . . .	24
5-2	Diagram of a deadlock issue that took weeks to resolve . . . . .	27

# List of Tables

5.1	Documentation of all exposed endpoints of my RESTful API . . . . .	26
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# Listings

4.1	A sample from a static settings file in JSON format. . . . .	17
4.2	An example of a ng-repeat looping construct in HTML5. . . . .	17
5.1	An example of running CuraEngine C++ executable directly from the command line. . . . .	25
5.2	WebSlicer's underlying file structure supported by FileTracker. . . . .	28

# Chapter 1

## Introduction

(Jones et al., 2011) Over the past few years, 3D printing, has become immensely popular due in part to its reduction in cost and its easy availability. An enthusiast can now purchase a do it yourself (DIY) 3D printer kit for less than \$500 however, one major pitfall that remains is the software support which leaves much to be desired. Most of the big name companies that used to hold all of the patents for 3D printers have retained the software patents but not the hardware patents. This creates a gap in knowledge between building the printer and running it. This research has served as an exploration of what software existed in the open source for 3D slicing and using that software to build a web based 3D print slicer. This will, effectively “democratize” the world of 3D printing, much in the same way that Google has democratized the way we search the web. In an article written by Harvard Business review, they theorize that this rise in the popularity of 3D printing will spur an industrial revolution as manufacturing becomes more personalized and decentralized (D’Aveni, 2015).

To print something on a 3D printer, there is a multi-step process that can be daunting to many first time users. The first step in the process is to either create or download a model. Creating a model can be achieved with any standard 3D CAD software, such as AutoCAD or SolidWorks. Downloading pre-existing models from an online repository can be done from websites such as Thingiverse or YouMagine. Once a model file is obtained, it is time to “slice” the model. Slicing is the act of

taking this model file and splitting it up into many thin layers that the 3D printer can understand. This process can only be executed by a dedicated slicing software which can often be complicated to use and difficult to install. Once the file has been sliced, the resulting file is a G-code file, which is simply a set of movement instructions that the printer head must follow. This file is then loaded to an SD card or sent via a print server similar to the way that a normal 2D printer is networked. Once the G-code file has been loaded all, that is left is to hit print either manually using the printers interface for the SD card or by hitting print on the network interface for the file that was uploaded.

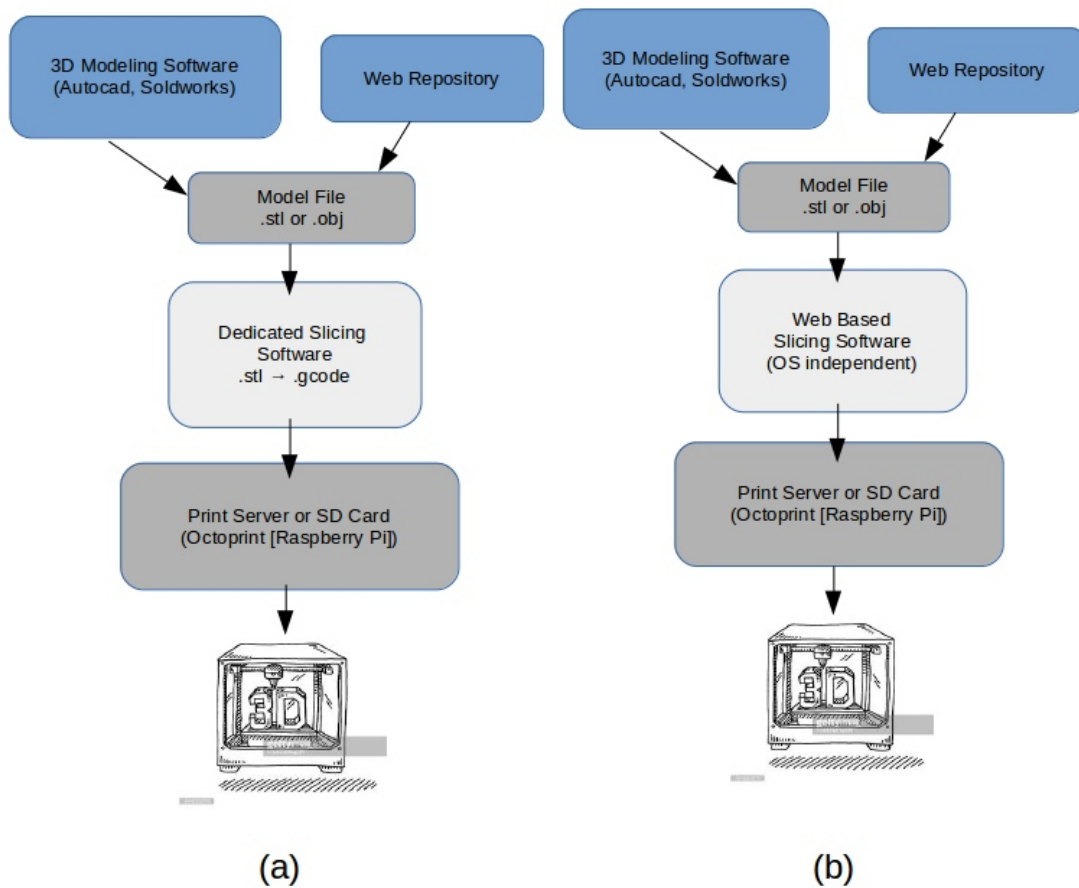


Figure 1-1: (a) High level view of the normal 3D printing process. (b) High level view of proposed new process using WebSlicer.

## 1.1 The RepRap Idea

The Replication Rapid-Prototyper Project (RepRap) is a movement with the goal of providing Open-source, diy 3D printers at low cost (Jones et al., 2011). RepRap printers are 3D printers with the additional ability to produce most of the parts necessary to assemble another identical printer. This idea also extends outside of hardware but to the software as well. Much of the software available for RepRap style printers are open source projects put together by the community. Unfortunately, community based software development is slow and leads to hardware that outpaces its software.

## 1.2 Sudden Growth of 3D Printing

In an article written by Forbes, the market trend for 3D printing was analyzed. They determined that 3D printing is becoming one of the fastest growing emerging markets, stating that “The worldwide 3D printing industry is now expected to grow from \$3.07 billion in revenue in 2013 to \$12.8 billion by 2018, and exceed \$21 billion in worldwide revenue by 2020” (Columbus, 2015). 3D printing may be reaching more people as a result of the availability of the RepRap designs. Additionally, building a 3D printer from a kit only requires basic hand tools and a moderate knowledge of electronics, which means that it has been opened up to a much broader audience.

## 1.3 Purpose of Research

The purpose of this research is to construct a web based slicer and simplify it for users who not well versed in 3D printing, so they are able to slice models and run their 3D printers. This will make 3D printing much more approachable for occasional users who are not prepared to spend thousands of dollars on a professional machine and expensive software. Additionally, this opens up opportunities for educators in STEM programs to teach students about 3D printing in a simple and practical way. Under normal circumstances, this would not be a feasible project for a year-long Masters

thesis; however, many of the technologies required to complete this project exist in varying states of completeness. Combining them into a cohesive application will be the subject of this study.

## **1.4 Research Objectives**

This research encountered several milestones which had to be met for it to be considered complete. These milestones are listed in no particular order; however, several of them must be completed before allowing other milestones to be completed as detailed below. However, several of them must be completed before allowing other milestones to be completed as detailed below.

CuraEngine is an open-source slicing engine designed to take model files in .stl file format and convert them into G-code for 3D printing. For this project, wrapping this code and making it callable from the web is the heart of this application.

### **1.4.1 Design Intuitive Web Interface**

This project requires both an intuitive and easy to way to slice a model file for 3D printing. This would be completed using Bootstrap and AngularJS because they are both scalable and flexible for almost any web design. These technologies also allow for small scale or even mobile use.

### **1.4.2 Run Beta Testing with Actual Users**

No research would be complete without testing the software in question. Running a closed beta test of this software is a milestone that must be met as one of the major aspects of this application is its usability. The goals of this test were to see if WebSlicer is both easy to use and useful to those who decide to use it with their 3D printer.

## 1.5 Related Work

AstroPrint is an all-inclusive cloud operating system for 3D printers. It attempts to encompass the entire package of 3D printing to a dedicated Raspberry Pi, or similar computer system. It is also one of the only software platforms that currently exists that attempts to do web based slicing. Unfortunately, the AstroPrint software tries to accomplish too many tasks at once and has become somewhat like a Swiss army knife, being capable of many functions but only complete a few tasks well. Additionally, their cloud-based slicing software, while being reasonably fast, lacks any support for reviewing the sliced model. This review stage is critical for anyone who is printing something that will take more than a few hours to complete.

## 1.6 Thesis Map

- Chapter 2: Background and design choices.

This chapter discusses many of the external resources used and why they are relevant to this research.

- Chapter 3: Software architecture review.

Compiled here is a complete overview of the architecture of WebSlicer. It follows the user through the entire process of slicing while explaining briefly some of the details of what is really happening.

- Chapter 4: Client side in detail.

Here is where all of the possible client interactions and application specific details are explained.

- Chapter 5: Server side in detail.



Details of exactly how a C++ executable is tied into a Java process are explained here as well as the exposed web API created for this research.

- Chapter 6: Discussion about usability testing and further improvements.

Included in this chapter are the formal results from closed beta testing and a discussion of the printer which inspired this research.

# Chapter 2

## Libraries & Existing Code

This chapter discusses many of the external resources used and why they are relevant to this research. All of the resources discussed in this chapter are open source projects and libraries.

### 2.1 CuraEngine

CuraEngine is the server side of a larger application called Cura. Cura is an open source 3D print slicer designed by Ultimaker that is part of the software suite for their Ultimaker line of 3D printers (Kuipers, 2016). As it is the main portion of the server side of WebSlicer, Cura will be discussed extensively in latter portions of this paper.

The reason for choosing to use CuraEngine as the slicing engine is that it has the most clear separation between application and interface. Another option was to use Slicer, which is much older and has better documentation, but is unfortunately written on Windows and would require a large amount of extra effort to get working properly for my needs. CuraEngine is also platform agnostic, as it is written in C++ and uses one library called protobuf, which is its main interface library for the Cura application.

## 2.2 Client Side Libraries

When structuring a website for optimal layout and scalability, there are few better options than using the combination of Bootstrap and AngularJS. Bootstrap is a client side CSS library which includes most commonly used CSS options such as buttons and input fields and styles them all accordingly. AngularJS creates a client side environment to support higher level language constructs and features that are normally reserved for complex server side applications.

### 2.2.1 Bootstrap

Bootstrap is one of the most popular CSS and JS frameworks for developing responsive and mobile projects on the web (Mark Otto, 2016). Being responsive means that Bootstrap is capable of being dynamically displayed on screens of varying sizes. When the screen size changes, Bootstrap is capable of moving and resizing elements on the page without losing any content or overlapping items (Mango, 2013). In addition, it speeds up the process of developing web based applications, as it removes the need to write heavy amounts of CSS to make an application look and preform nicely. Bootstrap also includes many standard features which most web developers use every day, further simplifying the process of building a website.

### 2.2.2 AngularJS

AngularJS is a framework that allows for easy development of dynamic web pages (Brat Tech LLC, 2016). It contains many ways to logically separate code similar to popular object oriented programming languages like Java or C++. Freeman (2014) states, “the goal of AngularJS is to bring the tools and capabilities that have been available only for server-side development to the web client and, in doing so, make it easier to develop, test, and maintain rich and complex web applications” (p. 48). Therefore, the use of Bootstrap for the unified look, responsiveness, and mobile support combined with the power of AngularJS as a framework, make it the easy choice for a web based application such as WebSlicer.

## 2.3 JavaEE

JavaEE is a layer built on top of JavaSE the standard Java development environment (Gosling, 2016). This additional layer provides many important architectural interfaces, such as the ability to encapsulate code in EJB containers or web containers for deployment of large applications which may have many of such containers (Pilgrim, 2013). JavaEE also provides frameworks for working with RESTful web services which streamlines the creation of a useful application API.

There are many server side frameworks which have support for RESTful web services, but most lack real scalability like that provided in JavaEE. Furthermore, JavaEE provides the ability to easily distribute computing as more resources are needed. As this research may eventually scale to supporting many users, it was logical to choose a framework which allowed for this kind of growth. The use of JavaEE as a framework also provides the full platform cross compatibility which is standard in Java. Allowing for cross platform compatability would facilitate the process of linking many computers that are running on different operating systems together, further simplifying the prospect of scaling.

To run a JavaEE based application, it must run in a web capable application container. This container must be placed on an application server which exposes it to the web under some context. For WebSlicer, the application server WildFly was chosen for this task as it is well known for its reliability (Fleury, 2016).

## 2.4 OctoPrint

OctoPrint is a small server that connects a Raspberry Pi to a 3D printer and serves printer info and files to the printer remotely (Häußge, 2016). The Raspberry Pi serves a small webpage which allows the user to easily keep track of the temperature of the printer and the current print progress. This interface allows for a web based connection between your remote g-code files and the local printer (Horvath, 2014).

OctoPrint also contains its own API which makes for easy integration into other web applications.

The fact that OctoPrint is so easily integrated into other web based applications made it a logical choice for integration with WebSlicer. Integrating with OctoPrint would allow for one touch printing by allowing me to send g-code files directly to a connected OctoPrint server. The only interaction that is required of the user is to connect their OctoPrint server which is done by simply indicating the address at which the server can be reached at. Additionally, users are required to include an API key to allow for other applications to directly access the servers API.

## 2.5 G-Code Visualizer

When building the G-code visualizer, it seemed logical to find one which already existed and worked well. gCodeViewer is an open source project originally written by Nils Hitze (Hitze, 2015). This project was written in pure JavaScript and would be seemingly easy to integrate with WebSlicer.

Unfortunately, many of the libraries that were needed to make this code needed to be updated. Additionally, integrated into the existing AngularJS framework which was more challenging than anticipated. Thus, what ultimately remained from the existing open source project was very small.

# Chapter 3

## Methodology

This chapter discusses the architecture of WebSlicer. It also serves to justify the design choices that were made.

### 3.1 Research Design

This thesis is a mixture of both research and design implementation. The research portion of this project focused on linking an existing C++ application (CuraEngine) into a larger JavaEE based project. This research also included running a closed beta test of the software and logging the results.

### 3.2 Working Procedure

As shown in Figure 3-1, the application will have 3 major components that all need to work together in a cycle until the user decides that the output is what they desire.

#### 3.2.1 Web Interface

The web interface includes a set of forms for collecting the user's settings for their printer and the settings as they relate to printing the model itself. This interface also includes a method so the user may retain the files they have uploaded for future use.

## Web Based Slicer Detailed View

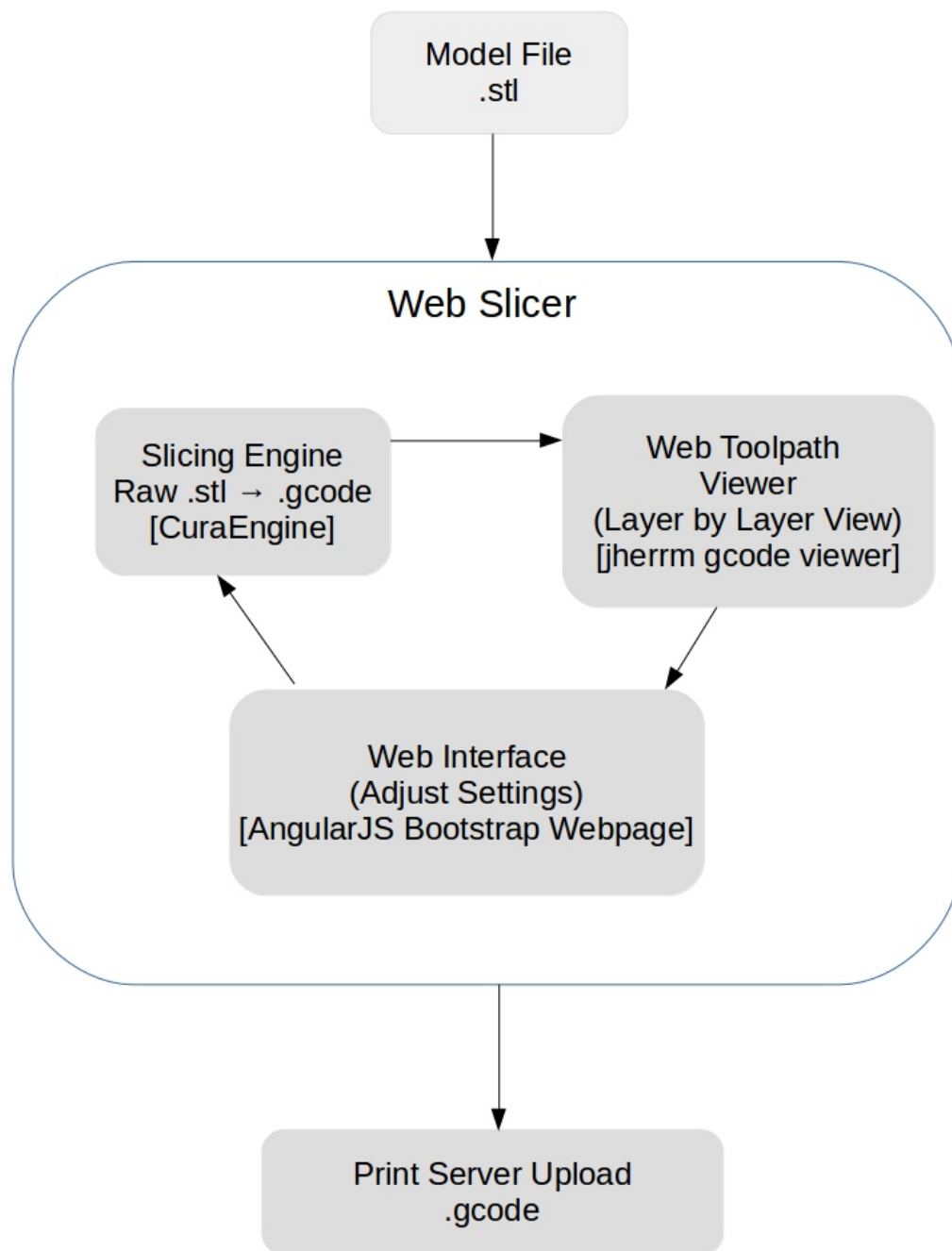


Figure 3-1: High level view of how WebSlicer functions and how users will interact with it

This does not include the actual slicing engine, which must be driven and accessed independently.

### **3.2.2 Slicing Engine**

The slicing engine rests at the core of this project as most of the computation time is spent performing geometry calculations within the engine. Its purpose is taking uploaded .stl model files from the user and converting them into raw G-code through a process known as slicing. An application which is encapsulated and performs slicing is known as a slicing engine. The engine which carries out the raw geometry calculations for WebSlicer is CuraEngine which is written in C++. Thus, this portion of the project required deploying the CuraEngine application on a remote server and creating a RESTful API to interface with it.

### **3.2.3 Web Tool Path Viewer**

After configuring and generating the G-code representation for a 3D model, there must be a way to visually review how the slicing engine will divide the model. This is executed by loading the resulting G-code from the slicing engine into a web based visualizer. The user is then able to view each of the layers and the steps involved in creating each one in detail. As displayed in Figure 3-1, this process of changing settings, slicing, and reviewing can occur an arbitrary number of times before the user decides they are satisfied with the result.

## **3.3 Review and Usability Testing**

After performing all steps of the working procedure, it was then necessary to test WebSlicer by running a small beta test. This beta test consisted of a small group of users with varying familiarity with 3D printing to test how simple WebSlicer is to use through a series of simple tasks. These simple tasks ranged from uploading a file to finding and adjusting the correct setting for a printer.



# Chapter 4

## Client Side

This chapter discusses the client side of WebSlicer in detail. It also includes some necessary background about AngularJS as it will be crucial to understanding latter sections of this chapter.

### 4.1 AngularJS

In order to understand the structure of WebSlicer a few things must be known about how AngularJS applications are structured and how AngularJS itself works.

#### 4.1.1 Controllers & Data Binding

The controller structure in AngularJS that sits between the view and the JavaScript world acts like the glue between the two. From a controller the user is allowed access to “scope” variables, which are similar to normal JavaScript variables, but they have a special two-way data binding property. Two-way data binding is one of the most interesting features of AngularJS, as it gives the user real time updates as the user interacts with a view. In traditional JavaScript, a developer must identify key events that occur in the browser as the trigger for a sequence of events. AngularJS also has a sequence of events but no trigger is required as the sequence of events is triggered automatically. This action is known as a digest cycle. AngularJS has a watch function

for each variable attached to its scope. When any changes to this variable occur, they propagate that change to the functions that are associated with that variable (Freeman, 2014).

### **4.1.2 Factories & Services**

JavaScript has many pitfalls, including the lack of any kind of larger design pattern support, such as Object Oriented Programming (OOP). The current trend with web based applications is to create single page applications with the same functionality as prior designs that have many pages. AngularJS is the answer to this with Factories and Services which mimic the design of a POJO (Plain Old Java Object) and Singleton objects in Java.

### **4.1.3 Directives**

A directive is one of the most powerful structures in AngularJS. It allows the programmer the power to write their own HTML5 tag with its own parameters and rules. Directives also contain support for templates which are HTML snippets that replace the main tag when the code is loaded. Combining this with the use of the aforementioned design patterns creates a very powerful tool to create and organize dynamic content.

## **4.2 WebSlicer AngularJS Structure**

This section discusses the entire client side structure of WebSlicer when it is broken down into its respective Controllers, Factories, and Directives.

### **4.2.1 app.js**

The full graphical AngularJS structure of WebSlicer is shown in Figure 4-1. Flow through this diagram starts with the app.js node which represents the main controller of the application. This can be thought of as a main function in C++. The main

## WebSlicer Angular Structure

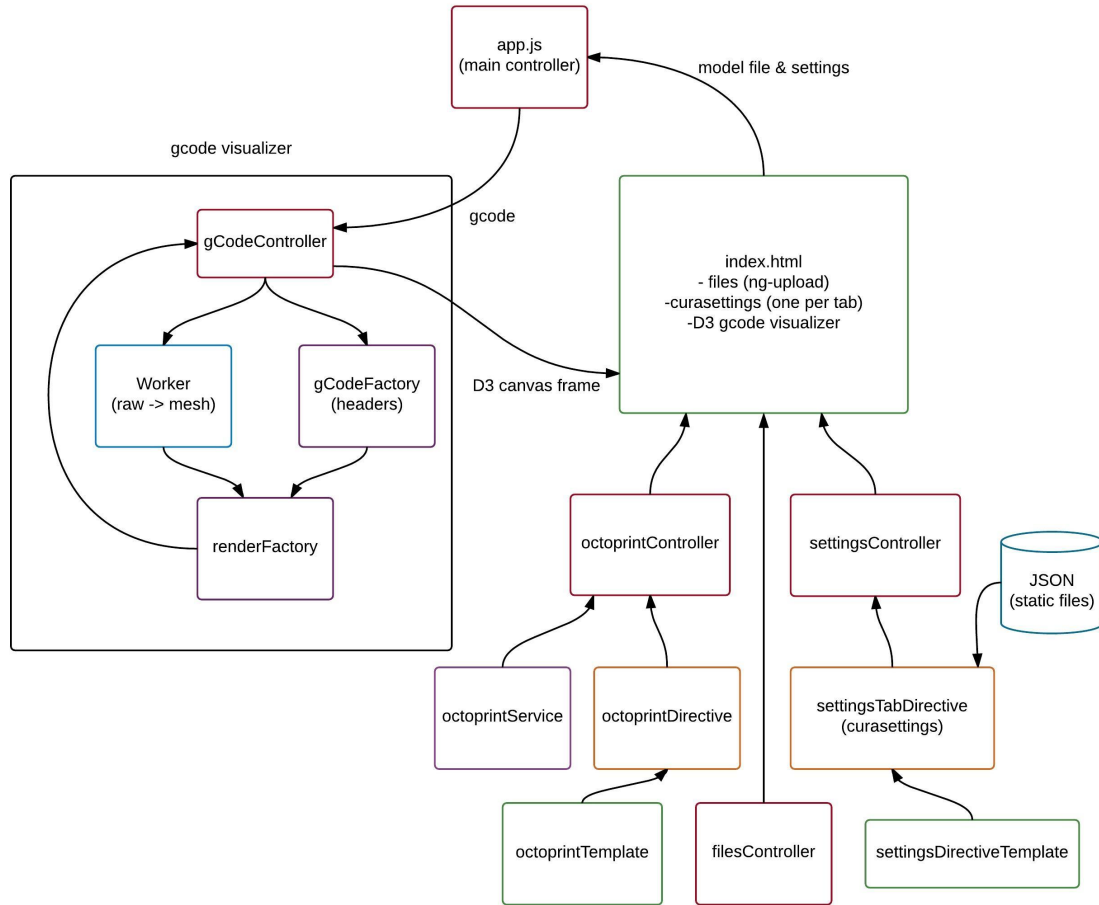


Figure 4-1: Full AngularJS structure breakdown

control variables are also inside of `app.js` which are similar to global variables. Variables in this controller are used to store the current settings, file pointer, and output G-code.

### 4.2.2 index.html

Figure 4-1 also shows that `index.html` is large hub and, as WebSlicer is a single page web application, this is the only static HTML file. `Index.html` has several other functions, such as bringing in all libraries and custom directives.

### 4.2.3 Settings

As shown in Figure 4-2, settings have a long path that they must travel before they are submitted to be used while slicing. This data flow starts with loading a static JavaScript Object Notation (JSON) file, which describes the settings in a pattern as shown in Listing 4.1.

Listing 4.1: A sample from a static settings file in JSON format.

```

1 {
2   "setting": "layer_height",
3   "default": 0.1,
4   "type": "float",
5   "category": "Quality",
6   "label": "Layer Height (mm)",
7   "description": "Layer height in millimeters. This
   is the most important setting to determine the
   quality of your print. Normal quality prints are
   0.1mm, high quality is 0.06mm. You can go up to
   0.25mm."
8 }
```

Listing 4.2: An example of a ng-repeat looping construct in HTML5.

```

1 <table class="table">
2   <tr><td>Action</td><td>Done</td></tr>
3   <tr ng-repeat="item in todos">
4     <td>{{item.action}}</td>
5     <td>{{item.done}}</td>
6   </tr>
7 </table>
```

A directive called `curasettings` takes this static JSON file and divides it so an input field exists in the template for each setting object. AngularJS provides this functionality through the use of an `ng-repeat`, which is written in a similar fashion to that of a for-loop in Python which is shown in Listing 4.2. Using a template for a directive in this case also means that the user can have control over many different fields, such as drop-downs and number-specific inputs. The `curasettings` directive also gave the logical separation of one static JSON file per tab of settings in the UI, which made it simple to find and modify the settings as needed.

Settings in WebSlicer have a complex method of being tracked after loading to the client. In most applications such as this, there would be an individual watch on each field or a submit button which would trigger grabbing all the fields. WebSlicer, however, uses a single object to track all of the settings for the application and uses a dynamic method of AngularJS to map from the input field to a field of a single object. Thus, when the settings are submitted, there is no more interpolation needed, as the settings object already has the current state as shown in the Figure 4-2 as “Pull Current Settings.”

#### 4.2.4 G-code Visualizer

The G-code visualizer for WebSlicer is written using a combination of D3 and a JavaScript web worker. From Figure 4-1, it can be seen that the controller for the visualizer is sent in a G-code file, which it splits up to two separate services. The controller completes an initial parse of the file, which places each one of the lines into its own entry in an array before exchanging it with `gCodeFactory` and `Worker`. Both of these files parse through this entire array, but do so at roughly the same time to expedite the process of visualizing. The worker takes the array of lines and ignores the header to just focus on converting the raw movement commands into D3 lines so that they may be rendered. The `gCodeFactory` takes the headers from the array and uses them to do analytics of the G-code file, such as total print time.

The final steps in the process of visualizing the G-code require splitting the G-code file into layers for rendering. This task which is made simple by following the given tags in the G-code which signal a layer change. Once all of the cumbersome tasks of parsing and splitting up the G-code file are finished, it is simply a matter of returning layer requests with canvas frames. Each time a layer is requested, a progress for that layer is also sent. The controller then indexes to the layer height in the array and renders a frame with the number of lines that are described by the current progress. As array indexing is nearly instantaneous, the visualizer once parsed and loaded runs very quickly to display layers.

## 4.3 Key Challenges

Discussed in this section were the most notable challenges that had to be overcome when developing the client side of WebSlicer.

### 4.3.1 Visualizer Integration

The visualizer starter code for this was originally written by Nils Hitze as an open source project which had many other features (Hitze, 2015). This code, however, required a lot of work to integrate properly with the rest of the application. AngularJS, despite its many features does not mix well with other projects. Ultimately, the only code that remained from the original was the JavaScript web worker and some of the parser code.

### 4.3.2 Interpolating Settings

A method was required to be designed for the application to handle a lot of input fields. A simpler method would have been to create a series of fields, each with their own variable, and submit methods and triggers; however, if settings ever change format it would require refactoring many files. Thus, spending the extra time to design an intelligent method of handling large amounts of input data seemed logical.

This, however, took much more time and effort than anticipated. At one point, this even required contacting the original developers of CuraEngine discuss the meaning of some of their settings. Documentation for many of the settings was dissatisfactory and in many instances was non existent which further slowed down development.

## **4.4 Other Planned Integrations**

During the development process often many items do not make it into the final product for various reasons. Included in this section are some items which were cut from WebSlicer before beta testing.

### **4.4.1 OctoPrint**

A feature that was removed at a late state in the process of building this application was an integration with OctoPrint. OctoPrint has a exceptional API that allows for external applications to integrate easily, making it an ideal choice for this application. This integration was to allow a user who was running an OctoPrint server to be able to send files directly to their server. This would eliminate the need to download the G-code from WebSlicer only to be uploaded to the print server seconds later. It was decided at the last moment that this feature need not be in the minimum viable product and that time was best allocated to finishing more crucial features of the application.

### **4.4.2 Thingiverse & YouMagine**

Another planned integration was the ability to import from a web based repository such as Thingiverse or YouMagine. These repositories are public sites where users can upload their 3D designs so others can 3D print them. Thingiverse in particular has a effective API for accessing models from their site, which would make it an easy integration for a web based slicing software; however, this feature was terminated early on, as it would have required too much unnecessary development time to finish.

## 4.5 Issues & Known Bugs

As mentioned in prior sections, WebSlicer was designed with a minimum viable product in mind. Developing a working 3D print slicer for the web was the primary task and all other features needed to support this or extend this functionality. For this reason, there is no login or user database, which would normally be the first item to be developed for an application such as this. There is also no way to view any of the models in 3D which, for most users, makes the software significantly harder to use.



## Settings Data Flow

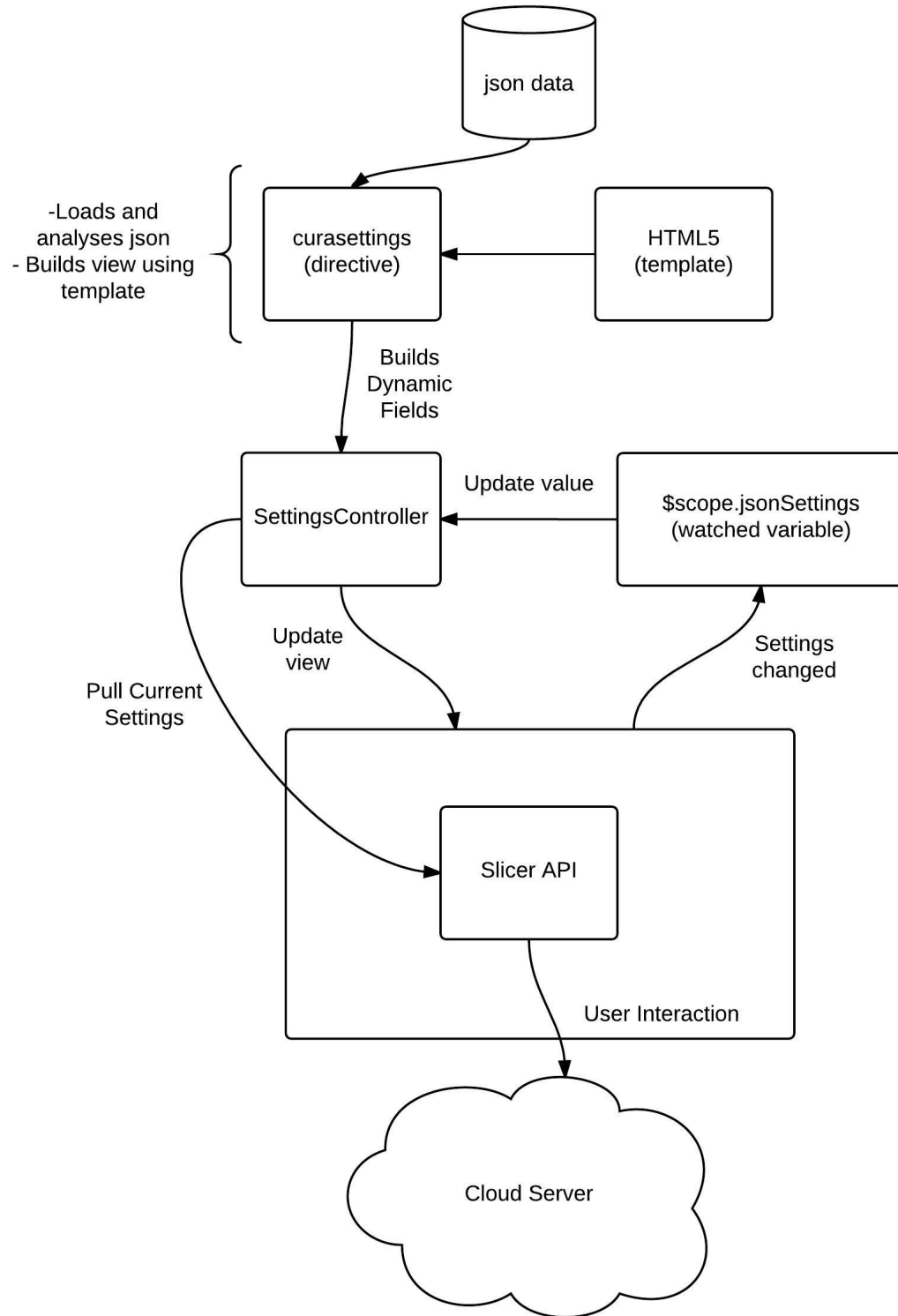


Figure 4-2: The flow of data through the application from beginning to end of client side user interaction

# Chapter 5

## Server Side

This chapter discusses the server side of WebSlicer in detail. Included with this is some nessasary background about JavaEE and some of its functions.

### 5.1 JavaEE Structure

The server side of WebSlicer was written in JavaEE, the structure for which is shown in Figure 5-1. JavaEE was the optimal choice for this application, as it allowed for the easiest deployment and was also the easiest to scale (Pilgrim, 2013). Additionally, JavaEE has a excellent code packaging mechanism for web and non web based applications alike. The web container which is in use for this application exposes a RESTful API on a privately hosted server.

To further simplify the development process, Maven was also used. Maven is a build tool for Java and has support for deploying complex applications such as those in JavaEE (Vincent Massol, 2005). Thus, when a build was completed, it was automatically deployed and ready for testing.

## WebSlicer JavaEE Structure

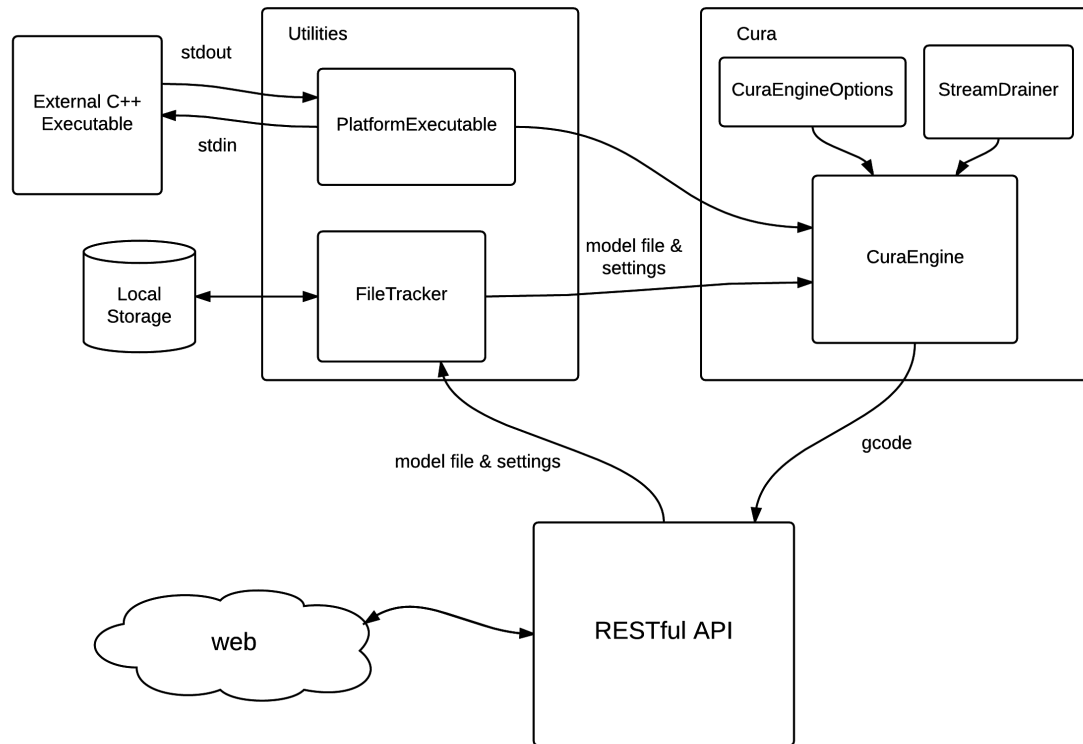


Figure 5-1: The structure of the server side of WebSlicer

## 5.2 ProcessBuilder

At the core of the server side application is an executable called **CuraEngine**. It is the main executable which is compiled from the open source slicing platform **Cura** which is written in C++. This presented a problem, as all of the server side code in this application is written in Java. **ProcessBuilder** was the solution to this problem as it is capable of redirecting the input and output streams of a local executable process into the Java server application. **CuraEngine** from Figure 5-1 uses a **ProcessBuilder** and the **PlatformExecutable** to create a runnable Java method that is capable of executing like a C++ executable. **CuraOptions** feeds the **CuraEngine** class with all of the parameters that it needs from the API. It gathers the path to the appropriate settings file and includes all of the parameters needed to run the **CuraEngine** executable.

Listing 5.1: An example of running CuraEngine C++ executable directly from the command line.

```
1 CuraEngine slice -v -j {settings.json} -g -e -o {
    output.gcode} -l {model-file.stl}
```

An example of running the CuraEngine C++ executable from the command line is shown in Listing 5.1. When the ProcessBuilder class of WebSlicer receives a slice command from the API it gathers the arguments listed in brackets and sends them to PlatformExecutable. PlatformExecutable then spawns a native process and pipes its input and output streams into the respective Java streams. In the meantime, StreamDrainer spawns a new thread and waits for the output stream that was created by PlatformExecutable. StreamDrainer’s task is to take the unneeded output from stdout and pipe it into a log file for debugging.

After CuraEngine has finished slicing the current file and PlatformExecutable has returned the REST API, which has been waiting, it unblocks and starts reading the output gcode file. This file is then packaged and sent back to the client as the response of the ”/slice/{clientId}/{modelId}” command as shown in Table 5.1.

## 5.3 REST API

## 5.4 Key Challenges

### 5.4.1 ProcessBuilder Deadlock

One considerable bug encountered while developing this project was a thread deadlock issue. The server side code uses Java’s ProcessBuilder, which builds a system native call to an executable and then pipes the input and output into the

Type	Address	Description
GET	/ping	A simple ping endpoint used for testing.
POST	/setupClient	Sets aside all needed files for a new client and return its unique ID.
POST	/importStl/{clientId}	Takes a MIME type file stream and imports the file to the clientId specified in the URL. It also returns a unique identifier for the file.
POST	/importSettings/{clientId}	Similar to importStl this endpoint takes a settings JSON file and imports it to the specified clientId
POST	/slice/{clientId}/{modelId}	This is the main slice function of the API. It combines all of the parameters specified by the calls before and returns a gcode file to the user.
POST	/testSlice	A test endpoint that requires no parameters and simply returns some arbitrary gcode to the user.
GET	/getFiles/{clientId}	Returns all the model file names and their tracking ID's that are associated with a clientId.

Table 5.1: Documentation of all exposed endpoints of my RESTful API

corresponding pipes of Java's stdio as shown in Figure 5-2. This is suitable for small platform executables with limited I/O, but can become problematic when complex native calls such as CuraEngine are used.

ProcessBuilder executes its normal writes to stdout and the drainer pipes them into a file; however, the drainer must wait for a file pointer using the `fp.available()` function. This is a non-blocking function that only estimates the buffer size that it has for the file. The check for file pointer availability was determining whether this function returned something greater than 0 as an estimate before notifying the ProcessBuilder that it was ready; however, the buffer size would often start as zero before allocation and, as this check was not part of a loop, it would stay stuck forever as the notify was missed.

This problem was solved by using the correct blocking file pointer available check. Occasionally, the buffer size was larger than 0 and the application ran suitably but,

## WebSlicer Deadlock

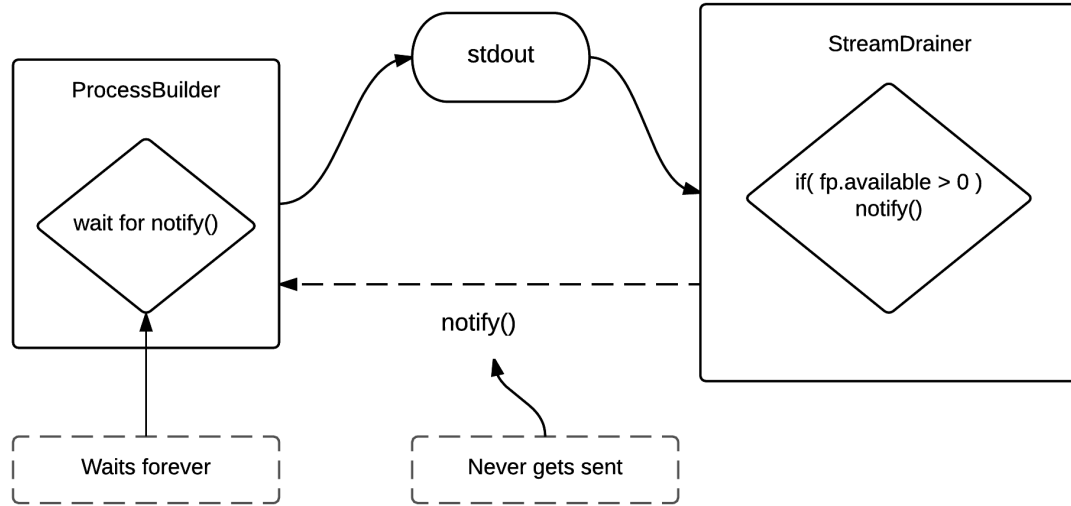


Figure 5-2: Diagram of a deadlock issue that took weeks to resolve

with some models, it would consistently fail, as the buffer had not been allocated yet. This solution is seemingly obvious yet it took many days to find and correct because the application did not fail consistently.

### 5.4.2 FileTracker Revamp

The first iteration of FileTracker was crude and not well planned out. It tracked two hashmaps: one for model files and the other for settings files with no mind for the client who required access to those files. This worked for testing, but experienced many pitfalls including the inability to reuse files that already existed. As soon as the client closed their session, those files were lost, which is a major inefficiency.

The `fdmprinter.json` file within the unique client folder is symbolically linked to the `fdmprinter.json` file within the common folder. The CuraEngine executable requires that all of the settings files rest within the same directory when performing a slice as shown in Listing 5.2. Unfortunately, this leaves the potential result of having this file

copied for many clients. Thus, symbolically linking the file to the rescue.

The `output.gcode` and `settings.json` files are dynamically overwritten for every iteration so their existence here is only for the sake of running CuraEngine through file arguments. The user has no access to these files and is only able to obtain their content through the web interface, which parses in and out of files.

Listing 5.2: WebSlicer’s underlying file structure supported by FileTracker.

```

1 webslicer/
2 - b1a2a69e-5893-4d7c-aa1f-d639fa3b4ed1/
3   - fdmprinter.json -> /tmp/webslicer/common/
      fdmprinter.json
4   - models/
5       - balanced_die_version_2.stl
6       - raldrich_planetary.stl
7   - output.gcode
8   - settings.json
9 - common/
10  - fdmprinter.json
11  - presets/
12    - prusa_i3.json
13    - ultimaker2.json

```

## 5.5 Future Improvements

Currently, FileTracker does not take advantage of the presets within the `common/presets/` folder as described by Listing 5.2. These files contain the default settings for the corresponding printer, which are the `ultimaker2` and a basic configuration of a `prusa i3` variant. Optimally, the user would select from one of these starting presets and then modify and save their own. This would allow users an optimal starting

point while lowering the amount of starting knowledge and increasing the usability of WebSlicer.

This new file structure also allowed for an easy client index. In the future, the unique folder ID will become the client's identification number, which will be attached to their login. Additionally, simplifying the login process with Google's OAuth 2.0 system was also planned.

## 5.6 Issues & Known Bugs

Currently there is no way for the server to import existing user files into its structure. Thus, when the server is restarted for any reason, the supporting file structure with all user files is lost. Resolving this is just a matter of writing an initial import function that indexes all of the existing files. It was removed from the initial version due to time constraints.



# Chapter 6

## Discussion

6.1 Usability Testing

6.2 Data Gathering

6.3 Design Updates & Improvements

6.4 Future Work

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