

3D Drucker Tutorial

Vor dem Druck – Filament Wechsel

- Extruder auf 200°C hochheizen
- Filament Entfernen
 - Mono Mendel:
Motoren deaktivieren, Kurbel drehen um altes Filament zu entfernen
 - Anet A8:
Hebel herunterdrücken, Filament entfernen
- Filament einfügen
 - Mono Mendel:
500mm extrudieren, Filament reindrücken bis es greift
 - Anet A8:
100mm extrudieren, Hebel herunterdrücken, Filament reindrücken bis es greift
- Extruder abkühlen lassen

Vor dem Druck - Druckbett

!! Vor jedem Druck mit Isopropanol abwischen !!

Die PEI Oberfläche verliert Haftung wenn Fett von Anfassen drauf bleibt.

Drucken

- Mono Mendel:
 - Drucker anschalten, USB Verbinden, Richtiges Profil auswählen, mit Simplify3D tethered drucken
- Anet A8
 - Drucker anschalten, Speicherkarte entnehmen, Gcode auf Speicherkarte packen, Sicher entfernen, in Drucker einfügen
 - Im Drucker Menu: ENTER → Print from SD → Refresh → Datei auswählen

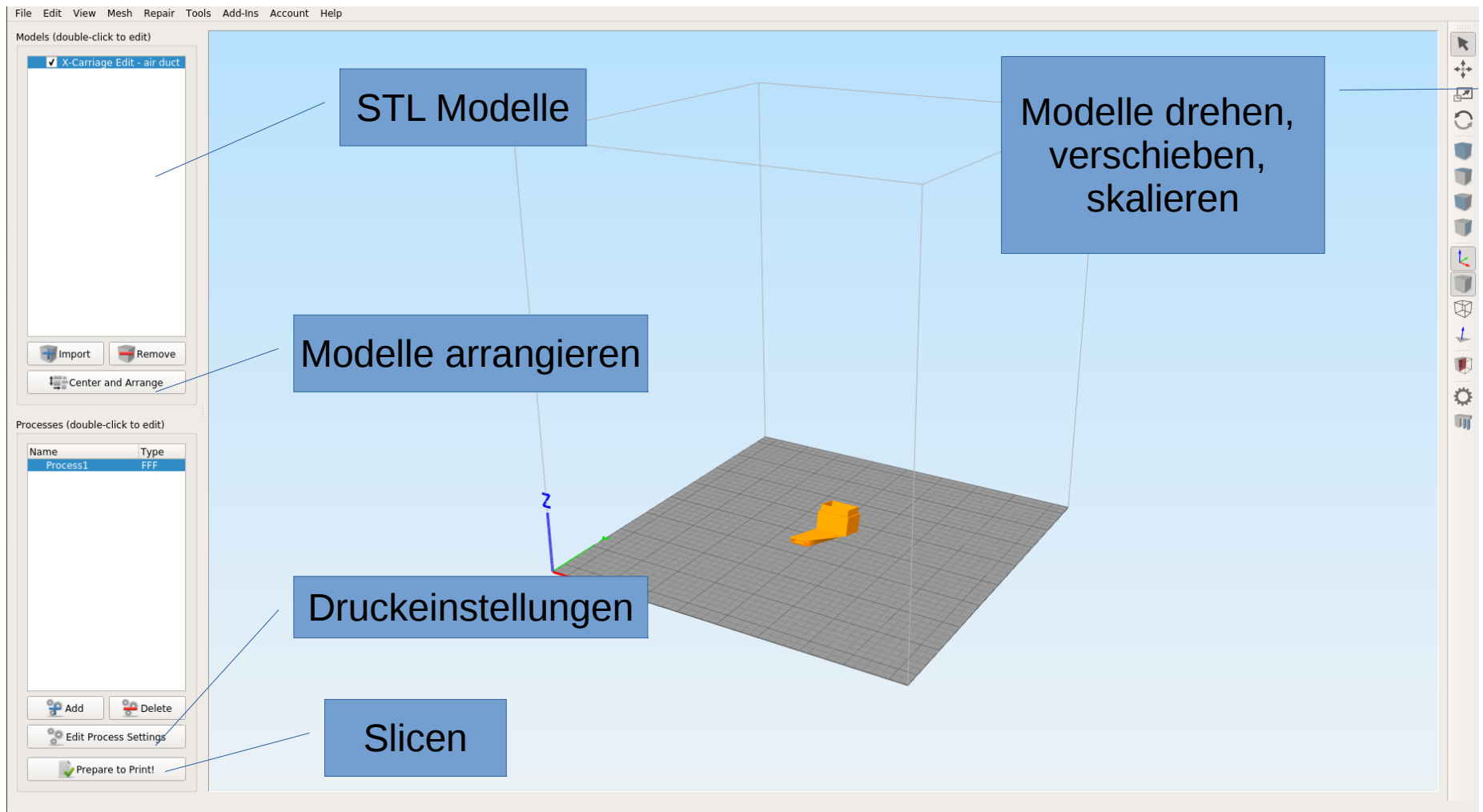
Nach dem Druck

- 5 Minuten warten damit Oberfläche Haftung verliert
- Mit Spachtel Objekt abhebeln
!! Alle Plastikreste von Oberfläche entfernen!!

Simplify3D



Printer Host + Slicer
Advanced Features



NETZ39
HACKERSPACE
MAGDEBURG

FFF Settings

Process Name:

Select Profile:

Auto-Configure for Material

Auto-Configure for Print Quality

PLA

Medium

General Settings

Infill Percentage: 20%

☐ Include Raft

☐ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Extruder List
(click item to edit settings)

Primary Extruder

Primary Extruder Toolhead

Overview

Extruder Toolhead Index

Nozzle Diameter mm

Extrusion Multiplier

Extrusion Width ☐ Auto ☒ Manual mm

Ooze Control

☒ Retraction

Retraction Distance mm

Extra Restart Distance mm

Retraction Vertical Lift mm

Retraction Speed mm/s

☐ Coast at End

Coasting Distance mm

☐ Wipe Nozzle

Wipe Distance mm

Add Extruder

Remove Extruder

Hide Advanced

Select Models

OK

Cancel

Drucker

Support

Material

FFF Settings

Process Name:

Select Profile: Update Profile Save as New Remove

Auto-Configure for Material

+ -

Auto-Configure for Print Quality

+ -

General Settings

Infill Percentage: 15% ☐ Include Raft ☐ Generate Support

Extruder **Layer** Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

Layer Settings

Primary Extruder

Primary Layer Height mm

Top Solid Layers

Bottom Solid Layers

Outline/Perimeter Shells

Outline Direction: ☒ Inside-Out ☐ Outside-In

☐ Print islands sequentially without optimization

☐ Single outline corkscrew printing mode (vase mode)

First Layer Settings

First Layer Height %

First Layer Width %

First Layer Speed %

☐ Start points for all perimeters

☐ Start points for fastest printing speed

☐ Choose start point closest to specific location

X: Y: mm

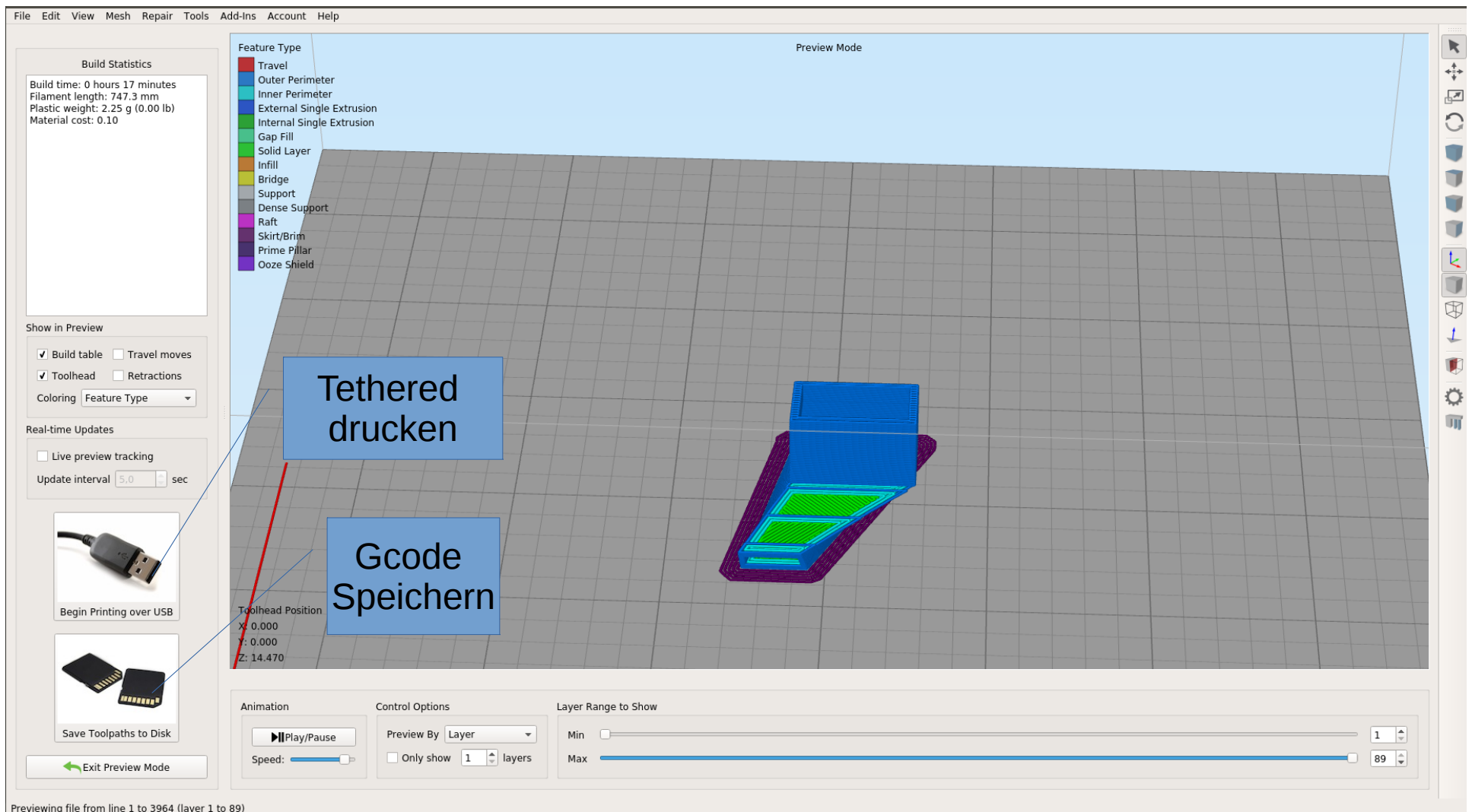
Für mehr Stärke
erhöhen

Hide Advanced

Select Models

OK

Cancel



Machine Control Panel

Initialization

Disconnect

Print

Pause

Port /dev/ttyUSB0

Refresh

Baud Rate 115200

bits/sec

Verbose

G-Code Library

Communication

Temperature Plot

Jog Controls

+Y

100

10

1

0.1

-0.1

-1

-10

-100

-Y

+Z

100

10

1

0.1

-0.1

-1

-10

-100

-Z

Retract

-100

-10

-1

-0.1

0.1

1

10

100

Extrude

-X

+X

Jog Speeds

X/Y-Axis

Z-Axis

Extruder

Speed (mm/s)

30,0

20,0

4,0

Home X

Home Y

Home Z

Home All

Position Readout

X

0.00

Zero X

Y

0.00

Zero Y

Z

0.00

Zero Z

EMERGENCY STOP

Force Next

Accessory Control

Active Toolhead

Tool 0

Extruder

200

15 °C

On

Off

Heated Bed

60

17 °C

On

Off

Set Fan Speed

Custom Commands

Disable Motors

Enable Motors

Print from SD Card

Pause SD Print

Upload to SD Card

SD Card Status

Macro 1

Macro 2

Macro 3

Override Settings

Movement:

100%

100

1%

200%

Extrusion:


100%

100

50%

150%

Strg + P



NETZ39

HACKERSPACE

MAGDEBURG