Here is a summary and tips :)

\*Workflow\*

1. Design part in CAD software

2. Save/export it as a .STL file

3. Open Repetier-Host and add the . STL file

4. Select the appropriate slicer settings (specifically print settings and material)

5. Slice the object

6. Turn on and connect to the printer

7. Press "print"

\*Installing Repetier-Host\*

1. Download the installer

2. Run the installer, deselect "repetier-server"

3. Open Repetier-Host

4. Configure the Printer Settings (top right)

5. Configure the slicer: click Slicer tab, select "Slic3r Prusa Edition" from the dropdown, click Configuration, click "Next" in wizard after selecting correct printer, then close Slicer

6. Done

\*Moving Printer\*

1. Carry printer by center of top cross bar

2. Install on level, stable surface

3. Upon first power-up, use the Prusa LCD menu to navigate to "Calibration -> Z calibration"

4. Run the z-calibration

\*Troubleshooting\*

1. Part is brittle/weak

Change infill to 100%/rectilinear in the "Override" section of the slicer tab.

2. Part detached from print bed

This usually means the nozzle was too far from the bed for the first layer. Restart the print, and use the Prusa LCD menu to select "Live adjust Z axis". Then adjust the offset for nice smushing.

Another cause is oil or dirt. Clean the bed with isopropyl before starting a print.

If the part has very small surface area, see instruction below for warping.

3. Part is warping

Warping is due to thermal contraction of plastic. It is prevalent on very long prints (2+ hrs), and also prints with very small surface area. It can be improved through various methods:

A) use a raft (edit the slicer Printer Settings). A raft is a thin, detachable layer of plastic under the part that increases surface area to minimize thermal difference.

B) reorient the part for more surface contact

C) if the first layer does not look sufficiently smushing, perform "Live adjust Z axis" on first layer of new print (see 2 above).

D) construct a box around the printer to contain the heat and minimize cool breezes.