

A. General instructions for 3D printing:

1. Import One or more than one **.stl** file(s) in **fracktory Slicer**.
2. Make sure to check 3D printer model selection as '**Julia Advance**'
3. Place the 3d model and adjust space between more than one object, if any
4. Make the following settings and then press prepare/slice to make **gcode**.
 - a) Profile- Normal / 0.2mm
 - b) Infill density - 20%
 - c) Infill pattern - Triangles
 - d) Printing temperature - 210°C
 - e) Build plate/ bed temperature - 60°C
 - f) Support structure- Normal
 - g) Support placement - Everywhere/touching to build plate (as per requirement)
 - h) Support density - 5/6%

Note: Place or do the orientation of the 3D model to have no support or minimum support

Build plate adhesion - skirt/brim

B. General instructions for laser cutting/engraving:

1. Convert your sketch from fusion360 to **.dxf** file format and name it.
2. Make sure to cut/engrave any object, there should be a single sketch for that object
3. Ensure to **remove construction lines** from sketch if any before exporting it to **.dxf** file format (it will appear in lasercad if not removed, and laser will start cutting that line, too)
4. Import the **.dxf** format file into **lasercad** software
5. Select the lines or shapes for cut operation and set parameters for it as speed - 17 and power - 60 (ensure min. & max. Power as same)
6. Select the lines or shapes for engrave operation (if any), and add layer. Set parameters as speed - 300 and power - 12 (ensure min. & max. Power as the same)
7. Download the file and name it.