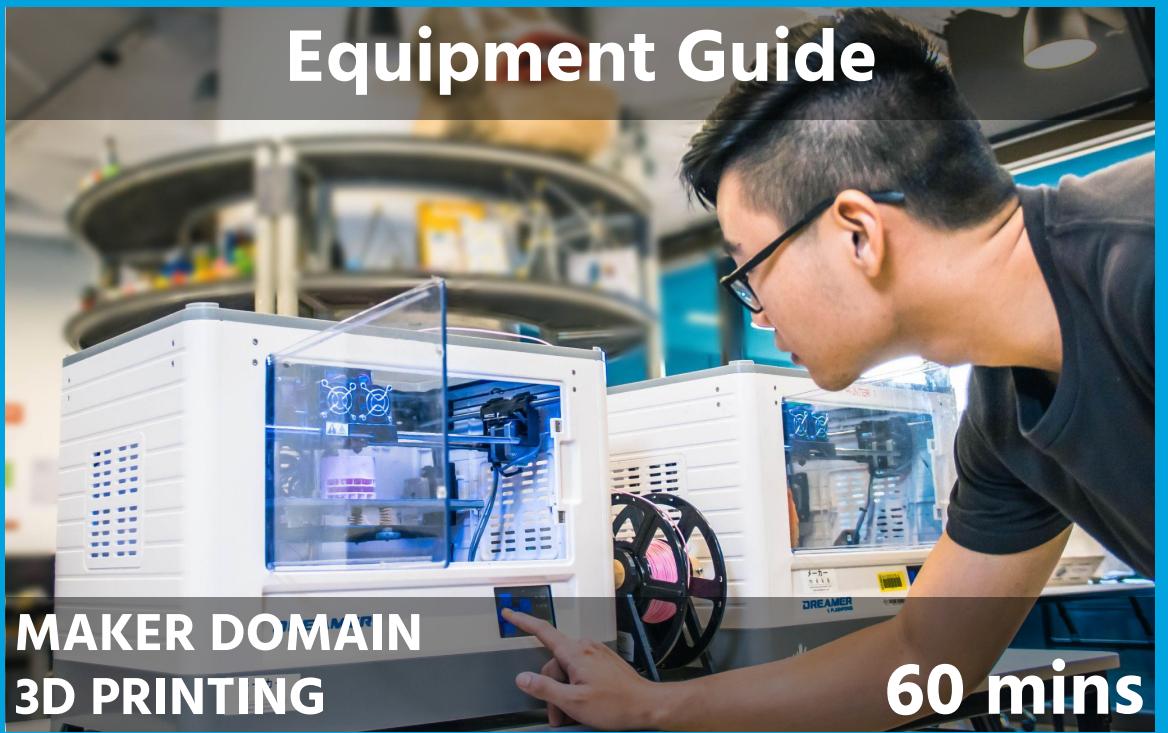


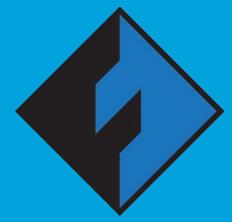
Equipment Guide



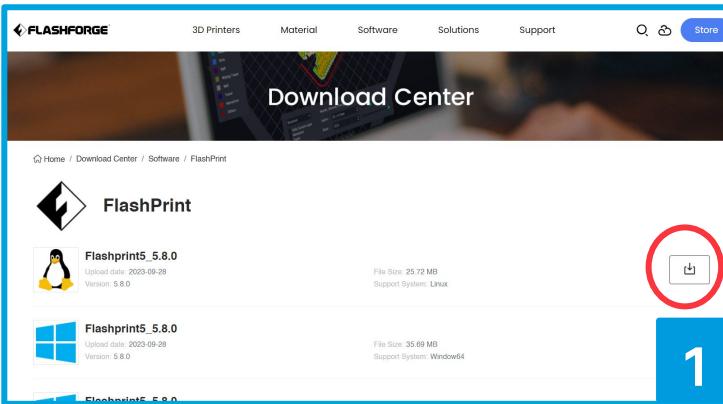
Flashforge Dreamer

- Safely Operate 3D Printer
- Slice 3D Files with Flashprint 5
- Adjust 3D Printer settings

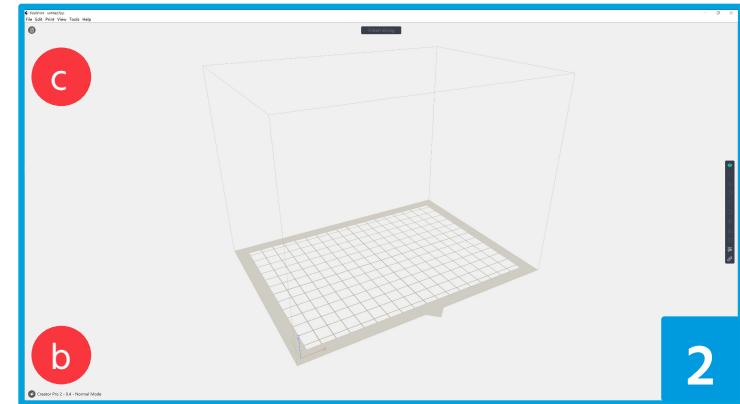
EQUIPMENT



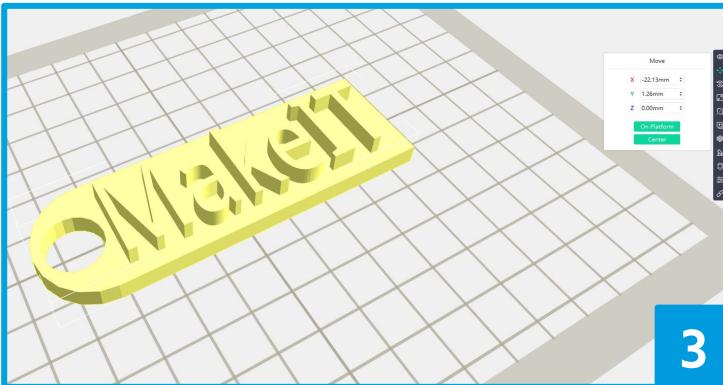
A Slicing Models with FlashPrint 5



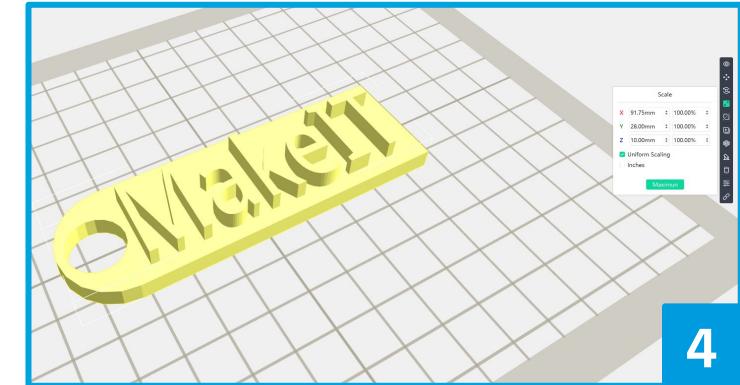
You will first need to install the FlashPrint slicer. Visit <https://www.flashforge.com/download-center/63>. Download the latest version of FlashPrint 5 compatible with your support system and install the software to your laptop.



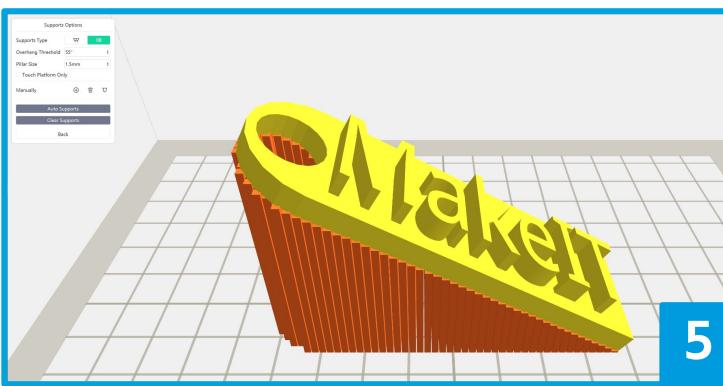
- Open up the FlashPrint 5 slicer on your laptop.
- Click the nozzle, navigate to "Machine Type", and select "Dreamer".
- To load your STL or OBJ file, you can either click on "Load" and select the 3D object that you will like to print.



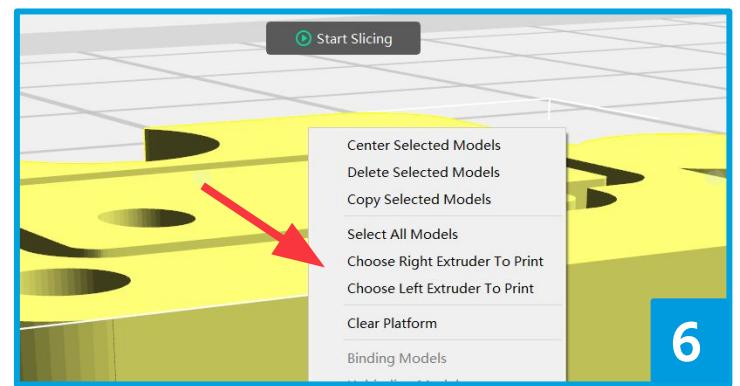
Click on the model and select "Move" followed by "On Platform" and "Centre". To maximise its chance at success, try having your largest, flattest surface on the print bed.



Should you find your object to be too big could select "Scale" and change the size of your object accordingly. Click on "Supports" to enter the support edit mode.



Click on "Auto Supports". Supports are required on if your model has overhanging (nothing below a part of your 3D print) parts.



Right-click on the model and select the correct extruder - default to 'Right'.

A list of FlashPrint 5's tools can be found below.

In addition to the changes mentioned earlier, you may also rotate your objects, cut objects into parts, duplicate objects, or automatically lay out multiple objects on the print bed.



View - Look at your 3D Objects from different angles

Move - Relocate your 3D Objects to utilize print bed

Rotate - Reorient your 3D Objects to print on flat surfaces

Scale - Resize your 3D Objects

Cut - Break up 3D Objects to 3D print smaller pieces

Duplicate - Make many copies of an object

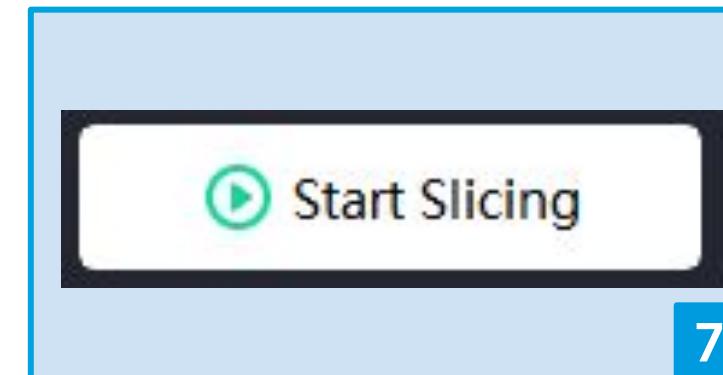
Auto Layout All - Optimizes where your 3D Objects sit

Supports - Adds materials to help with overhangs

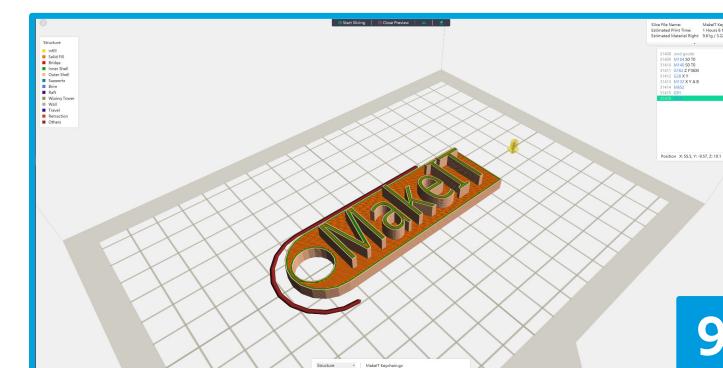
Wiping Tower - Adds tower for multicolour prints

Multi-Machine Control - Not used at MakeIT

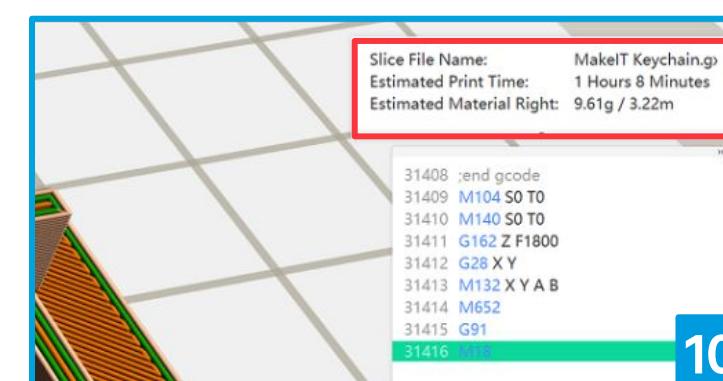
Connect Machine - Not used at MakeIT



Click on "Start Slicing" to proceed to the print settings.



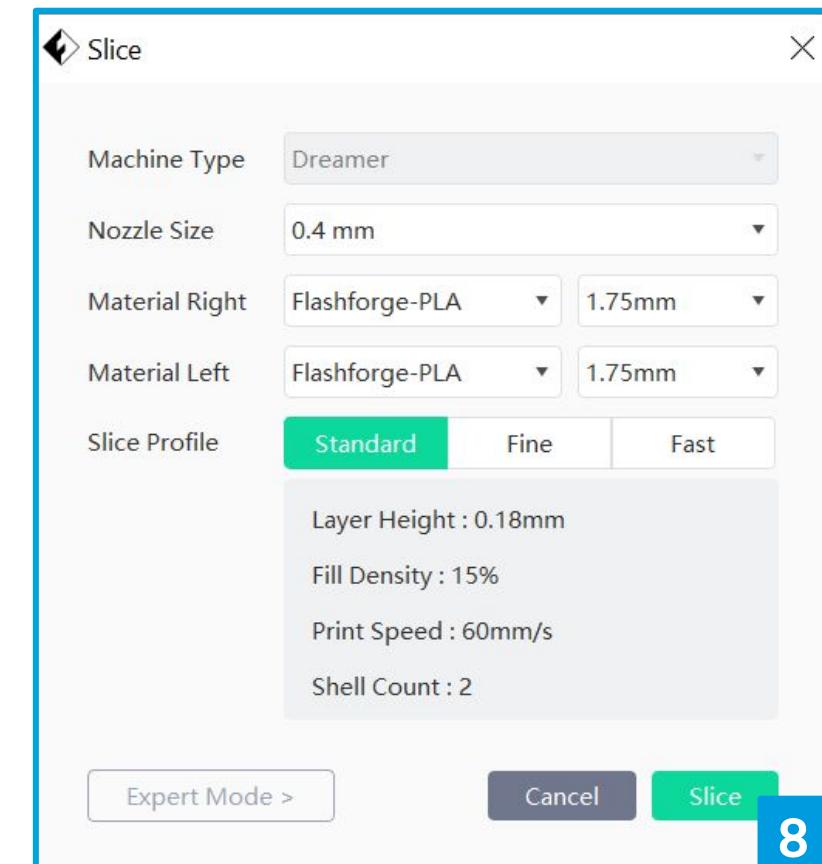
Click 'Slice'. FlashPrint 5 lets you preview your print and estimated time needed for your 3D print to be completed.



Make sure that the Estimated Print Time of your 3D print is well within your booked duration.

To shorten your print time, try the following:

- If you aren't concerned about size, reduce the scale of your 3D print
- If you aren't concerned about print quality, Change the Slice Profile from 'Standard' to 'Fast'
- If the print must be of the same size and quality, cut your 3D print and print in separate pieces. Assemble together after printing.



Ensure that print settings are set as shown above. Press 'Expert Mode' to bring up additional options.



Save the file in the .gx format into a SD Card.

B Setting up the Flashforge Dreamer

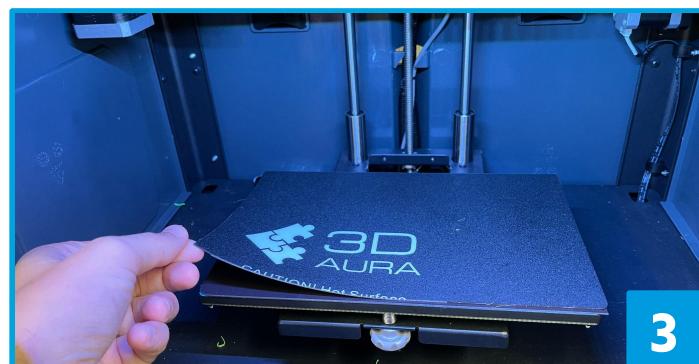


1

Perform a visual inspection of the Flashforge Dreamer before printing. The interior should be clean and clear of debris. Filament should be inserted through the printer into the right extruder. There should be a magnetic sheet placed on the print bed as the print surface. Once checked, you may turn on the printer and begin printing.



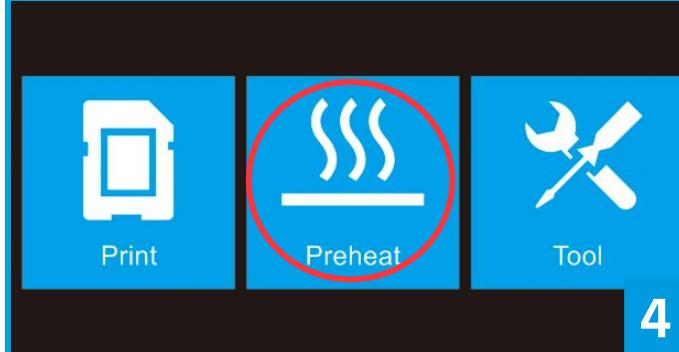
2



3

Turn on the Flashforge Dreamer 3D Printer. The switch can be found on the right side of the printer.

Verify that the magnetic sheet is on the print bed and in good condition.



4

Before printing, the printer needs to be preheated. To preheat the printer, go to the LCD and tap on "Preheat".



6

Transfer your sliced .gx file to the printer by using an SD card, inserted at the right side of the printer.



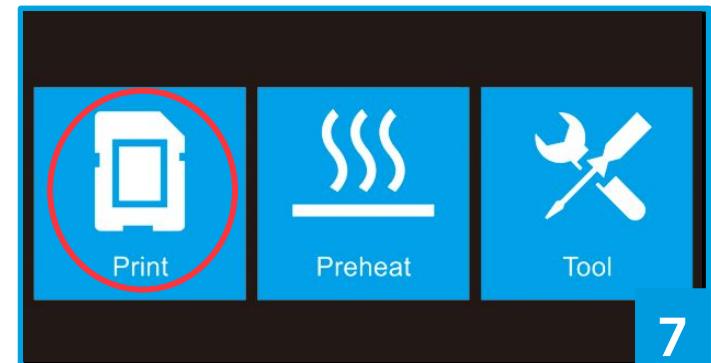
8

Click on the SD card icon to bring up your file.



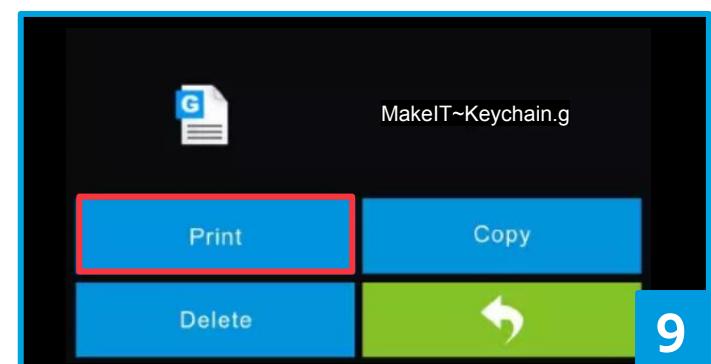
5

Tap on the "Start" button to start preheating the printer nozzle and print bed. The default temperature of the nozzle is 230°C. Printing will start once temperature is reached.



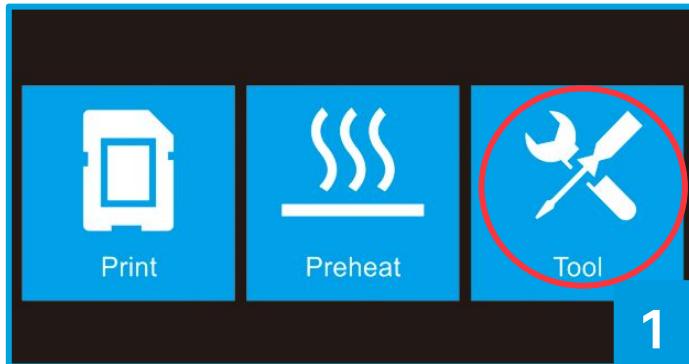
7

Navigate to the main menu, then press "Print".

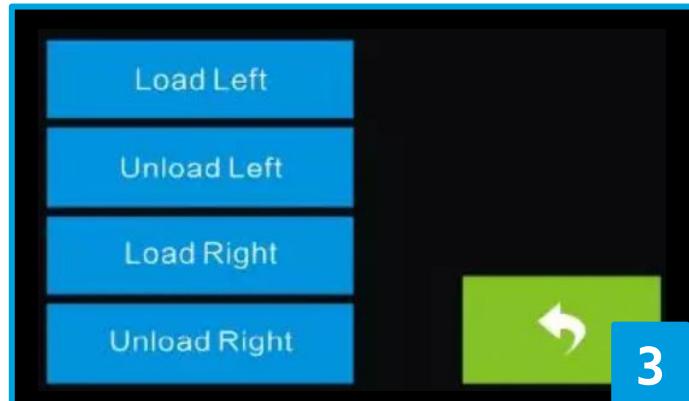


9

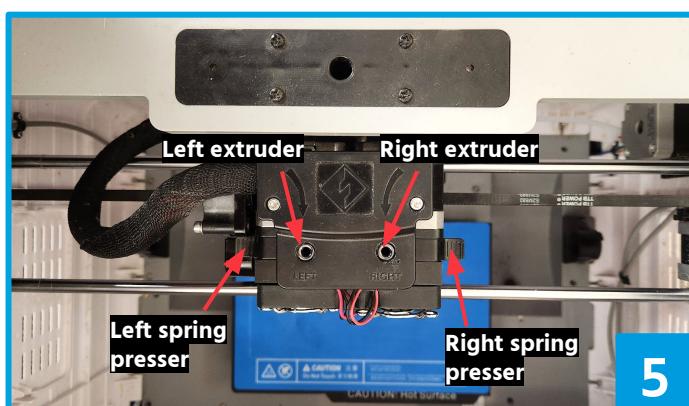
Find your file from the list, then press it. It will bring you to the following menu. Press "Print" to begin your print job!

C**Loading and unloading of filament**10
min

On the LCD, go to the main menu and tap on "Tools".

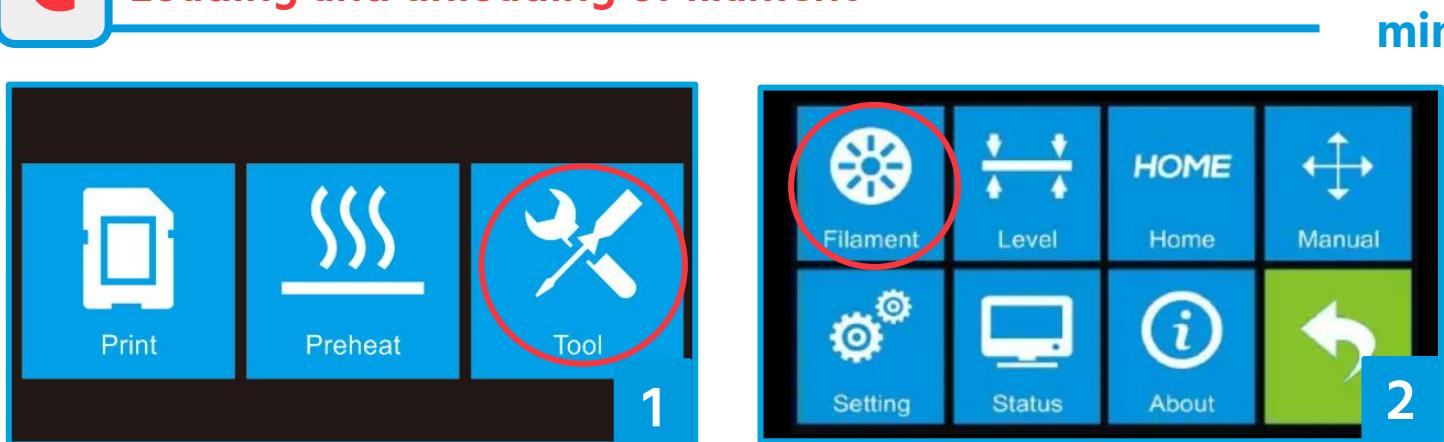


Tap on the relevant button to load/unload left/right extruder.

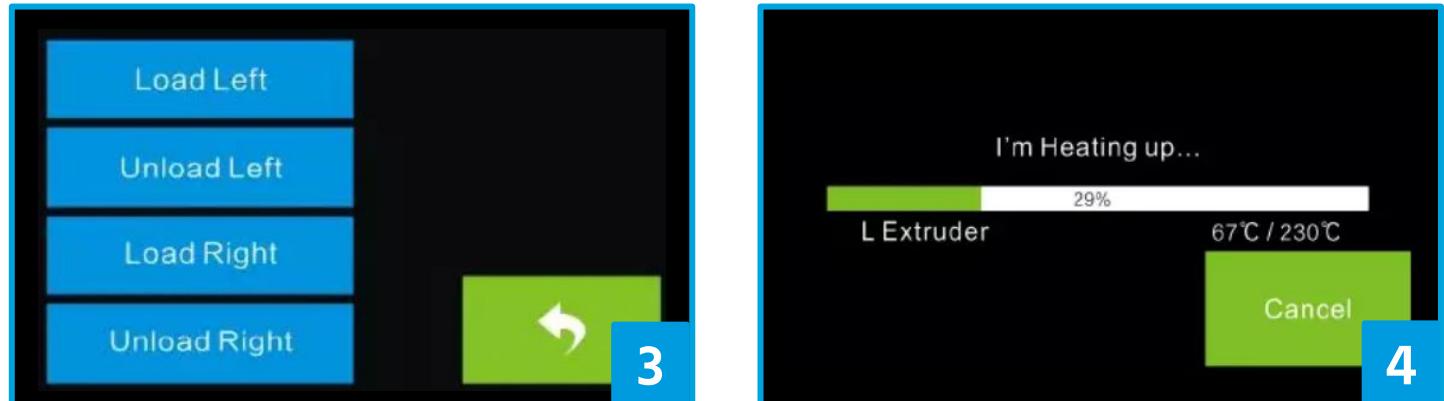


Once optimal temperature is reached,

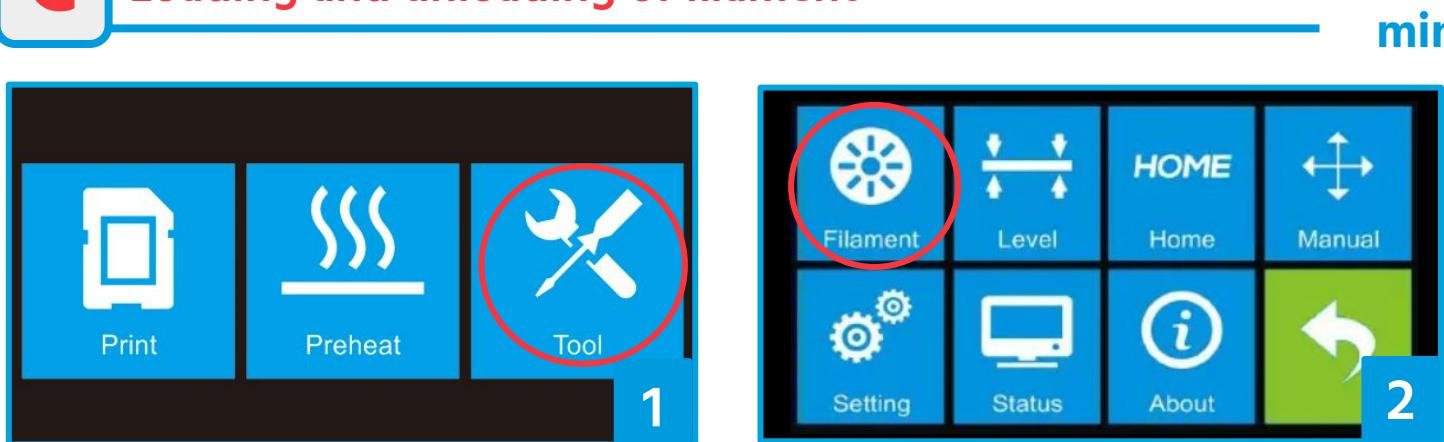
- (a) For loading filament: gently feed the filament into the extruder at an upright angle.
- (b) For unloading filament: press the spring presser, press down the filament for 3 seconds before gently pulling the filament out. Tap "Done" on the LCD to finish unloading.



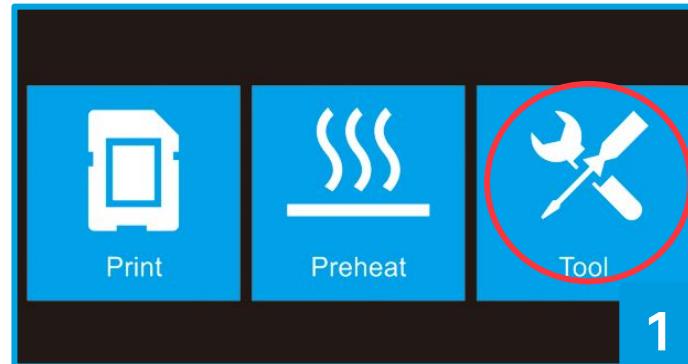
Tap on "Filament".



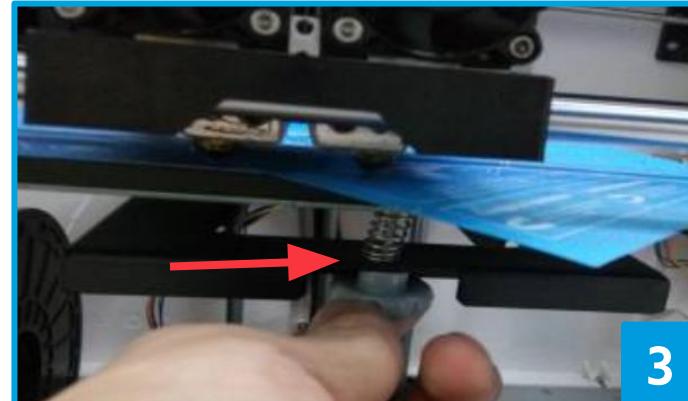
The printer will begin to heat up the extruder. It will take a few minutes for the temperature of the extruder to rise to optimal temperature.



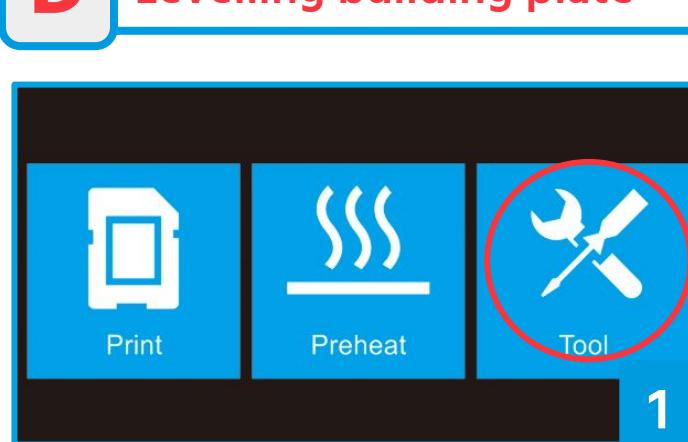
On the LCD, go to the main menu and tap on "Tools".

D**Levelling building plate**10
min

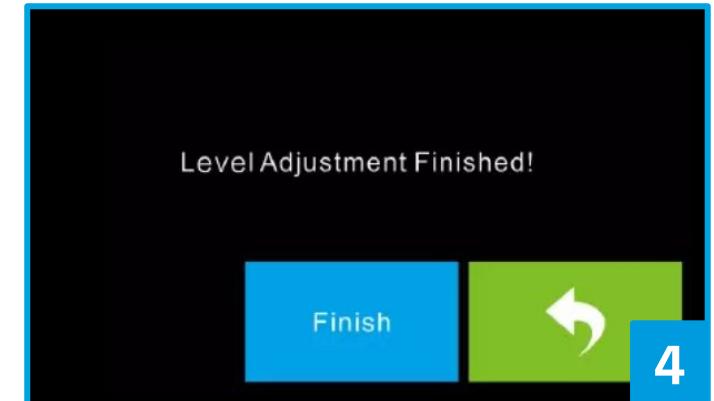
On the LCD, go to the main menu and tap on "Tools".



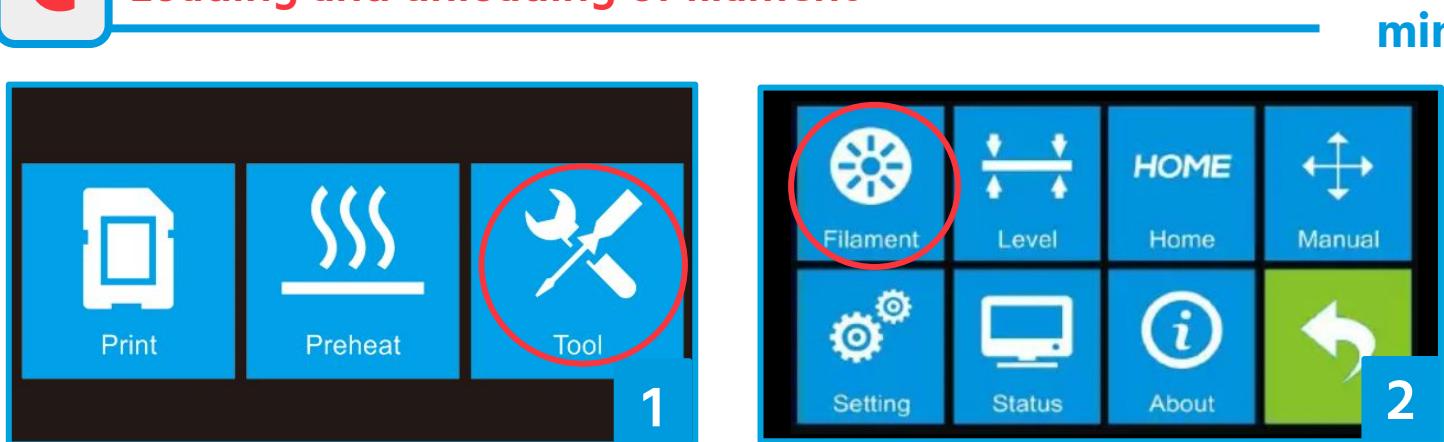
Take the levelling card and slide it back and forth between the nozzle and the build plate. Slowly adjust the knob until the paper causes a slight friction. Tap "Next" when done.



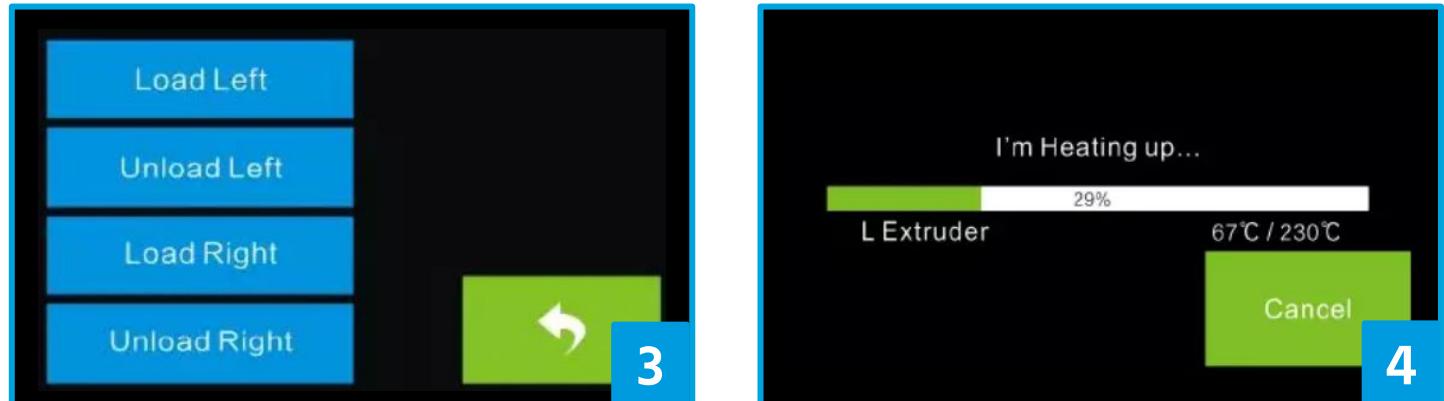
Tap on "Level". The extruder and build plate will move to starting position.



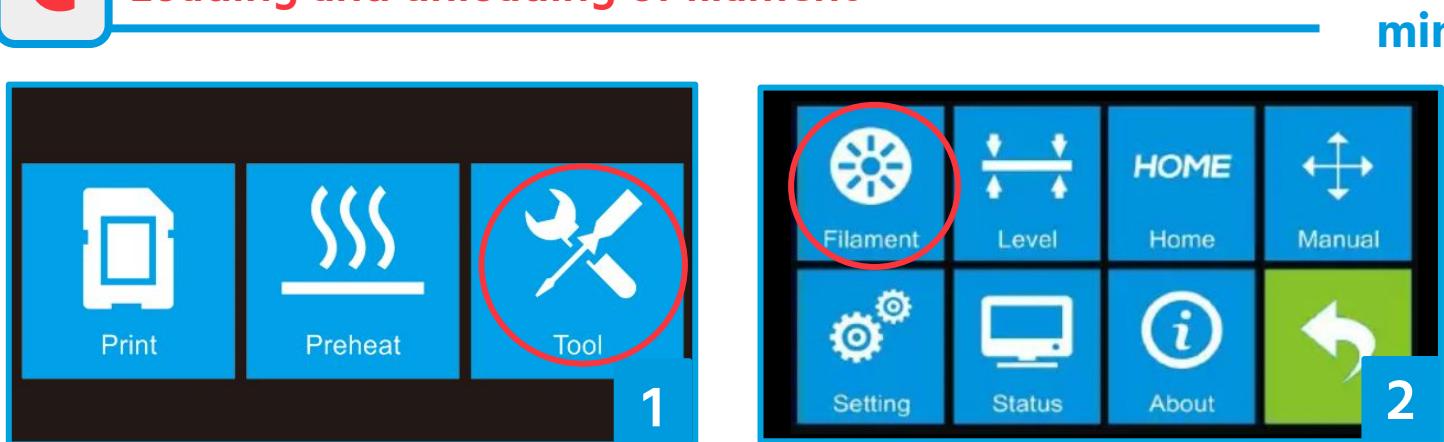
Follow the onscreen wizard to move to its next position. Repeat step 3 and follow the directions on the LCD until the whole levelling process is completed. Tap "Finish" once done.

E**Recommendations and Requirements for 3D Printing**10
min

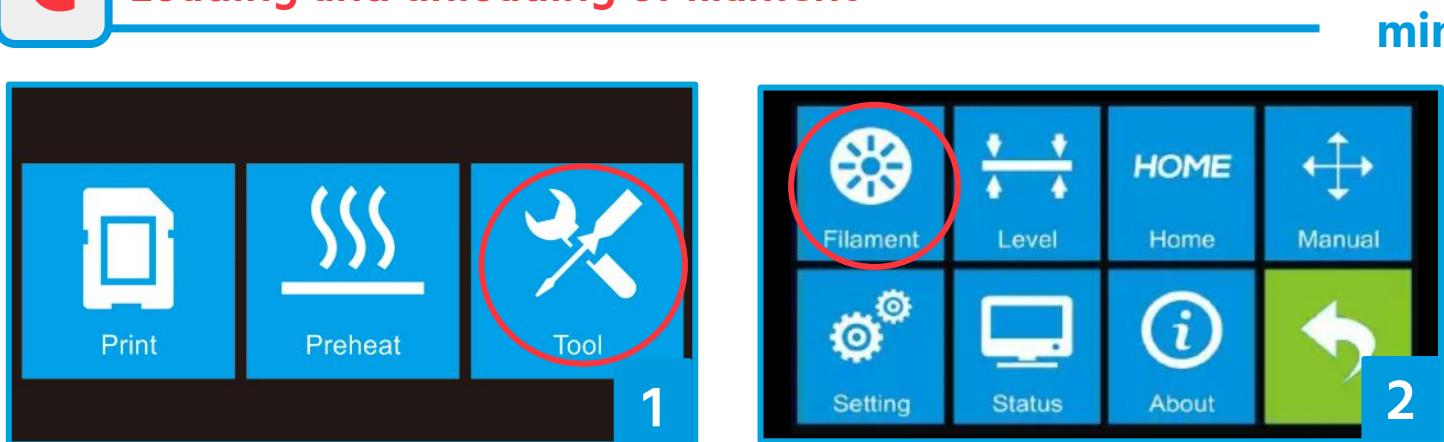
Tap on "Setting".



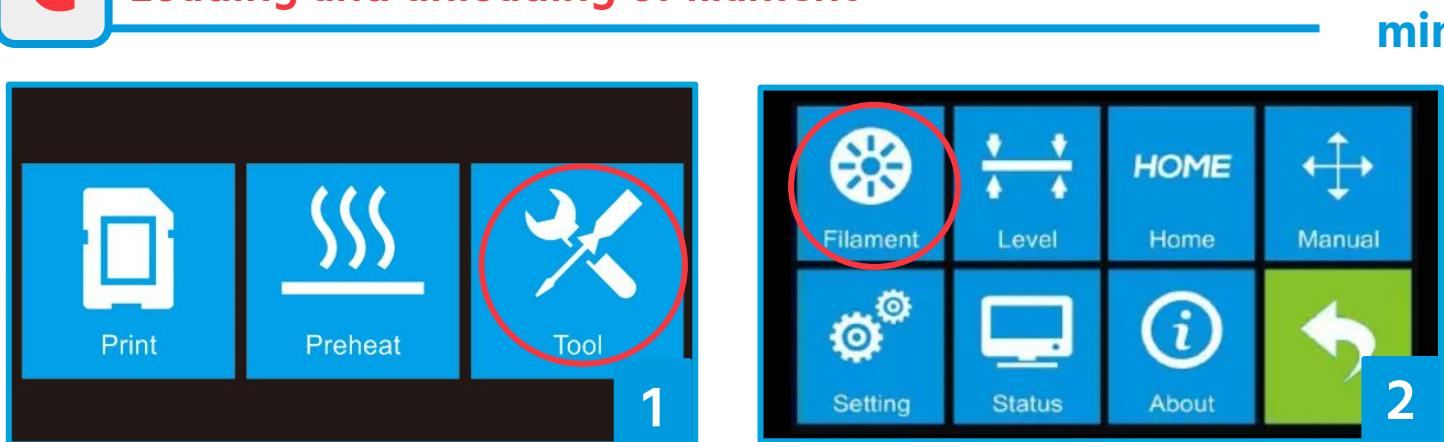
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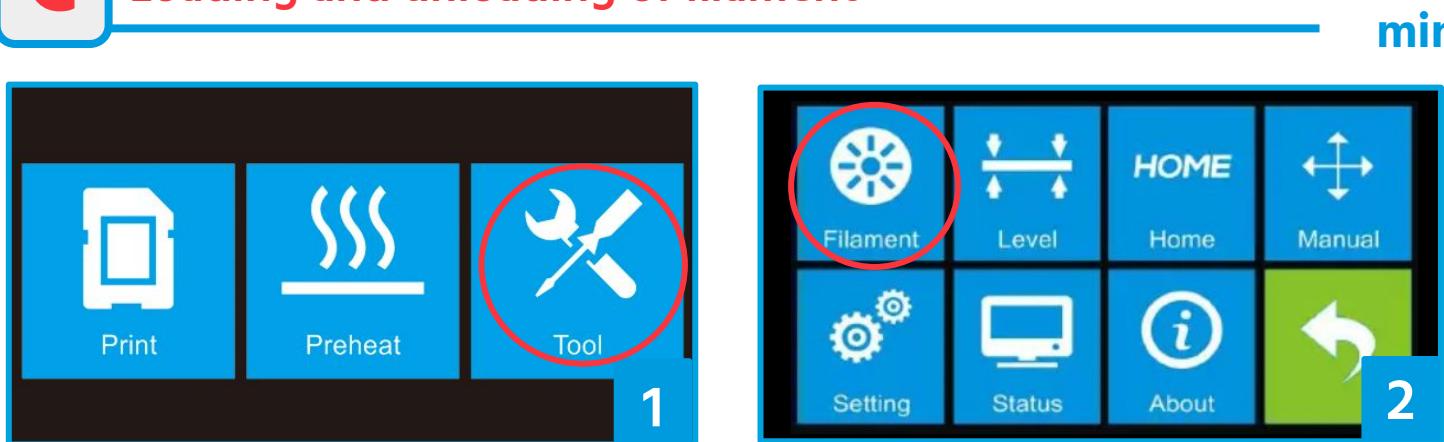
On the LCD, go to the main menu and tap on "Tools".



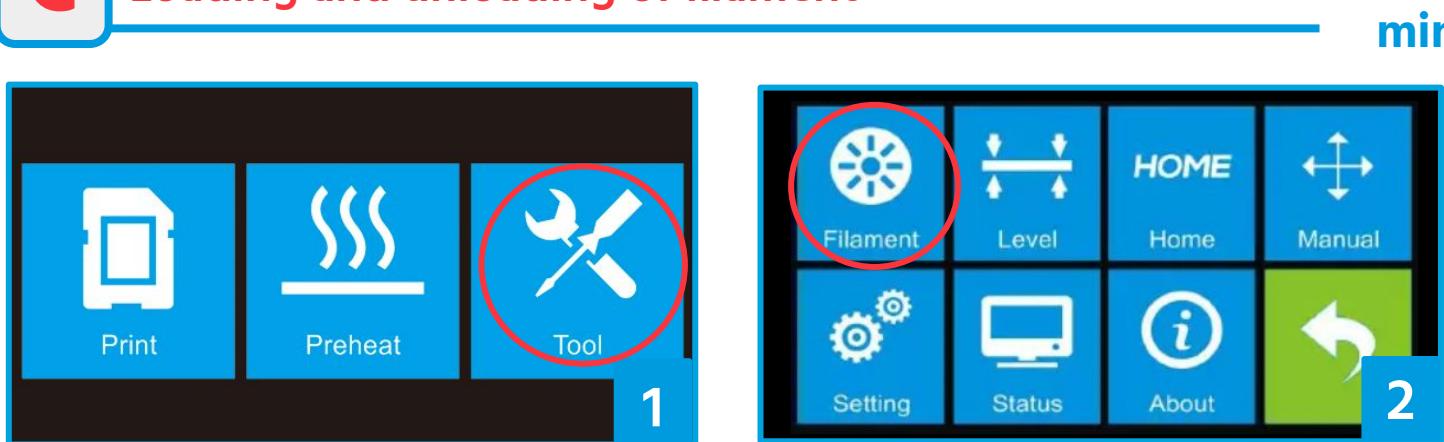
Tap on "Manual".



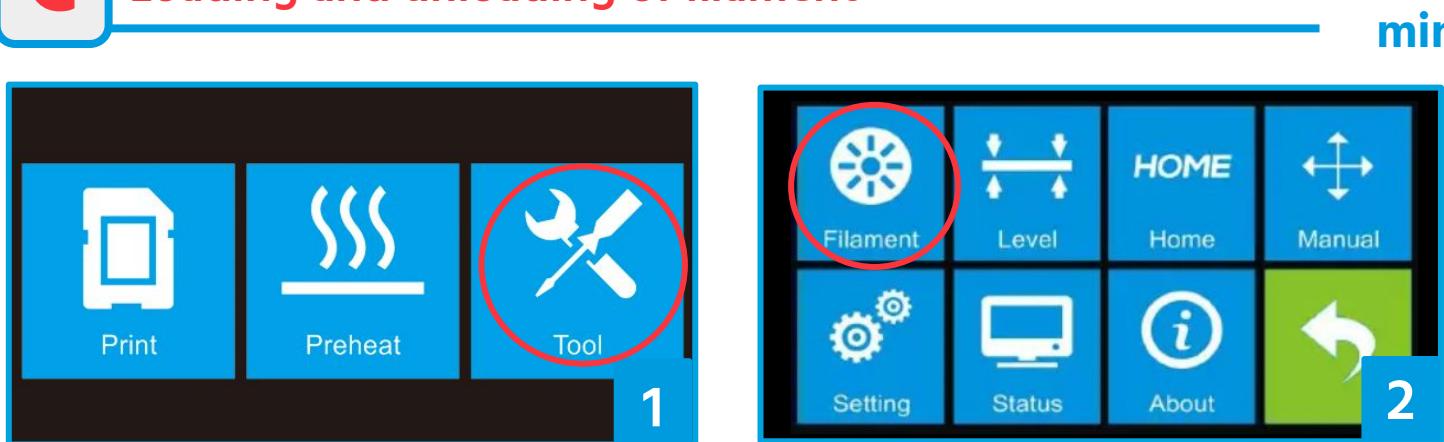
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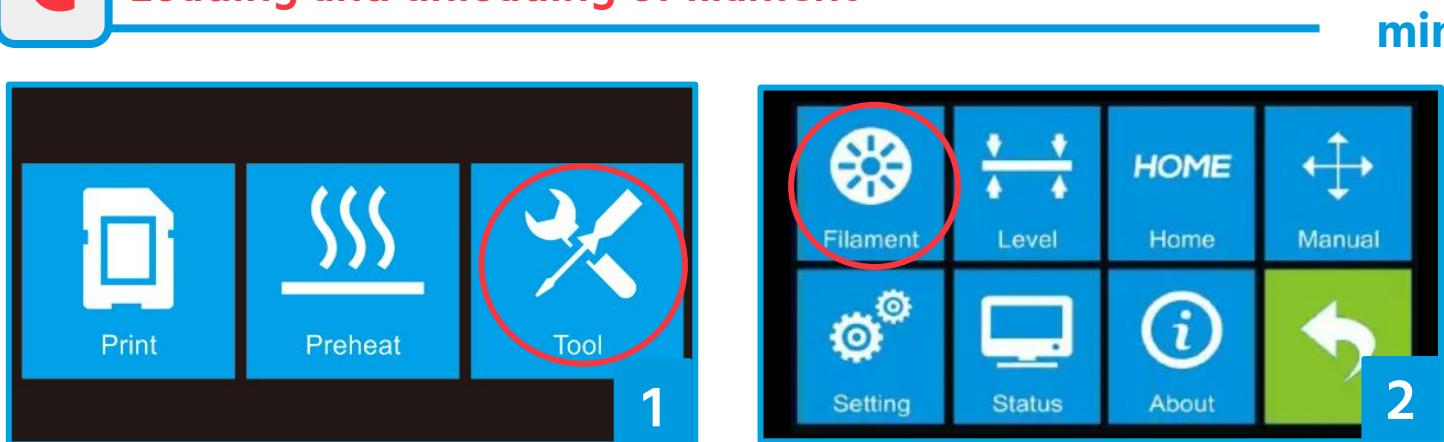
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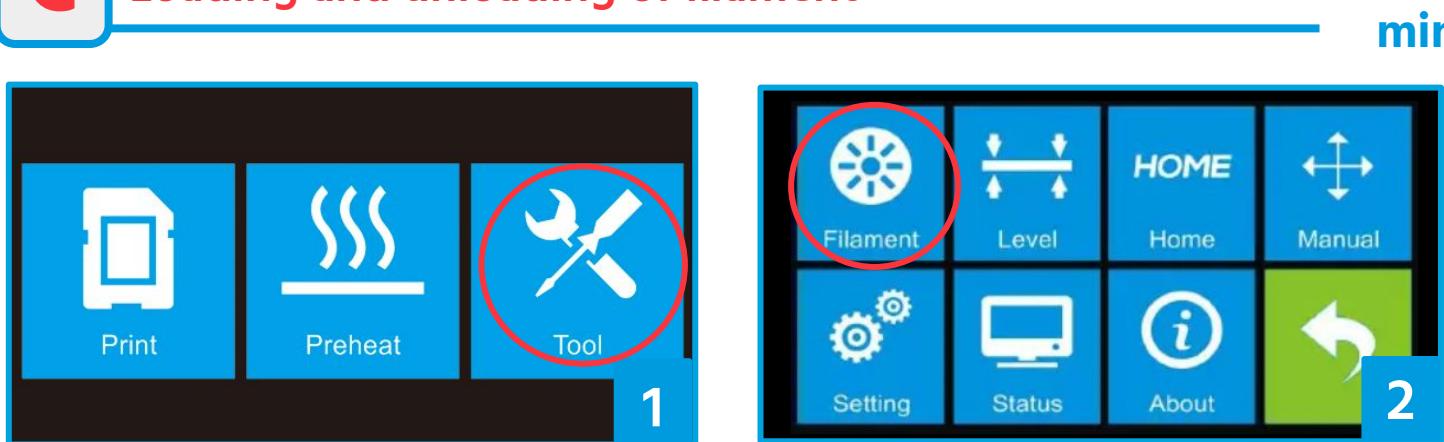
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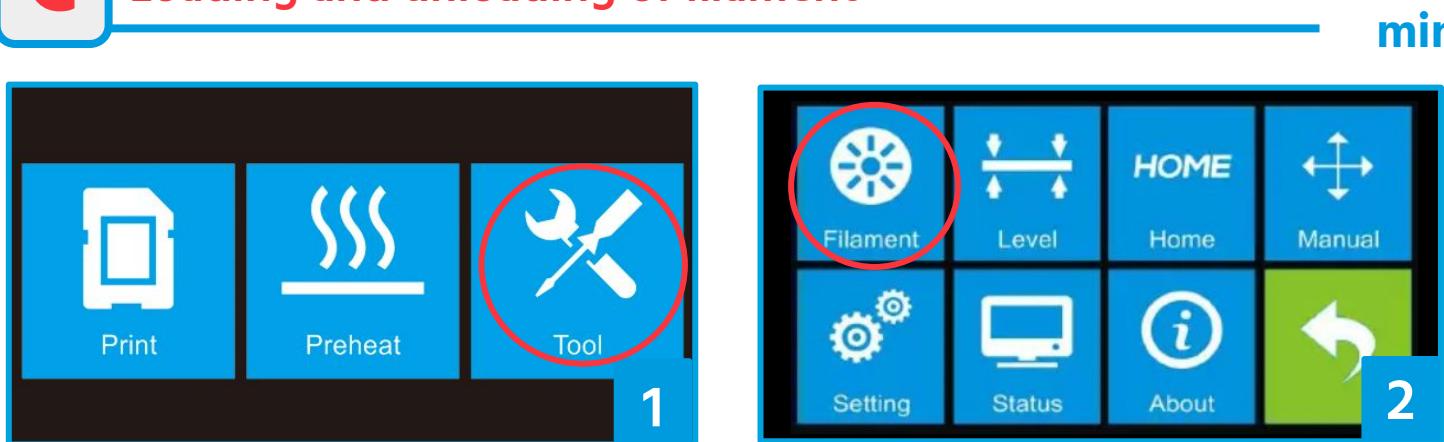
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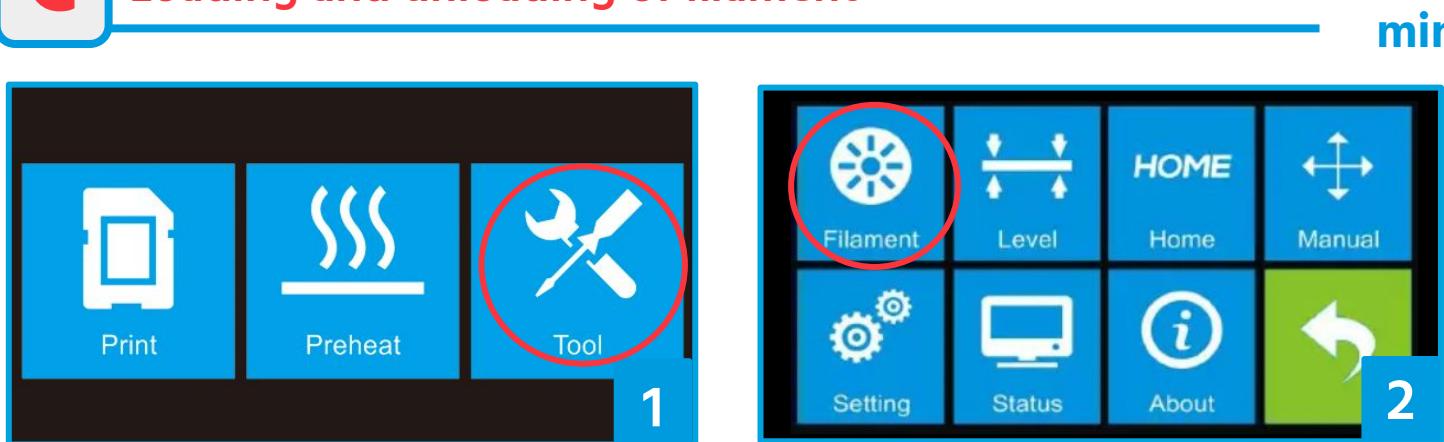
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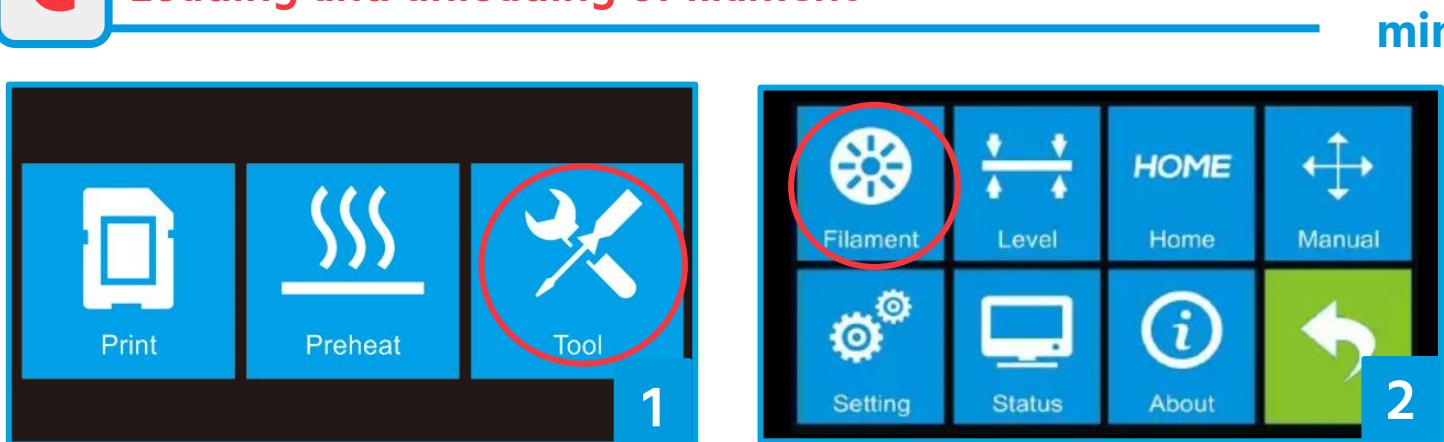
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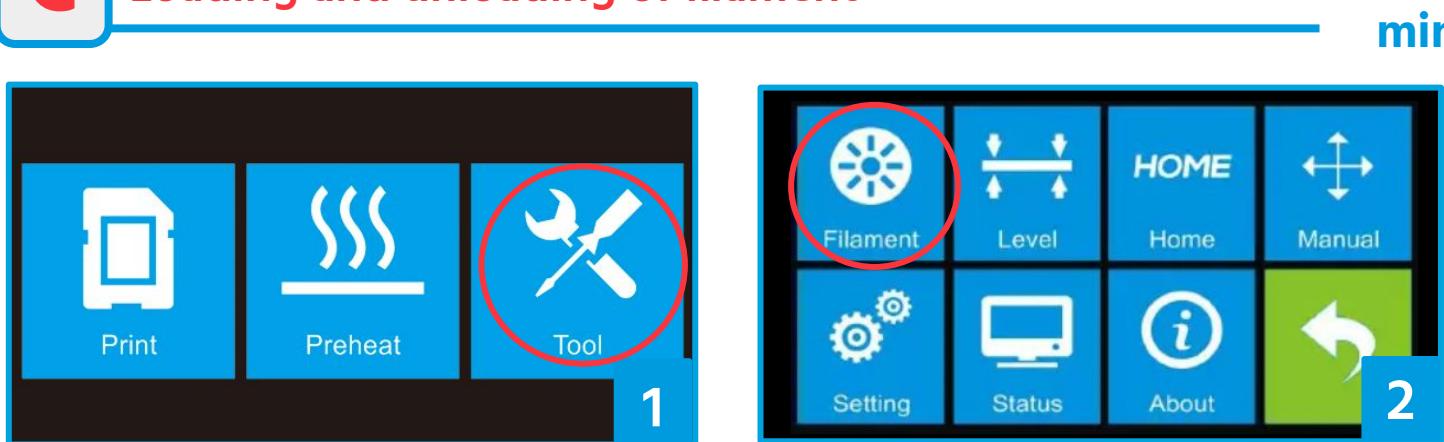
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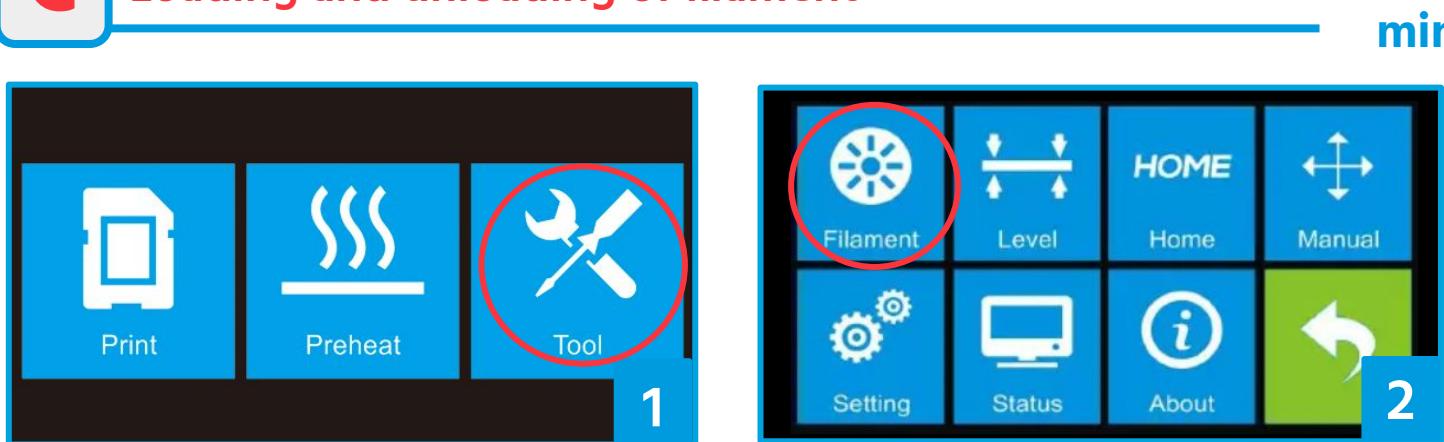
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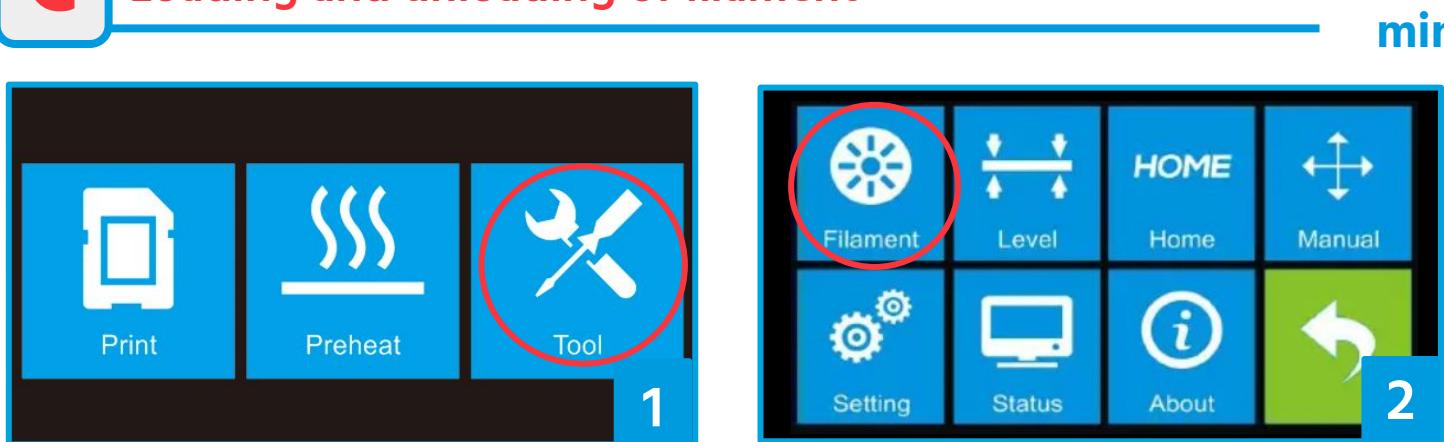
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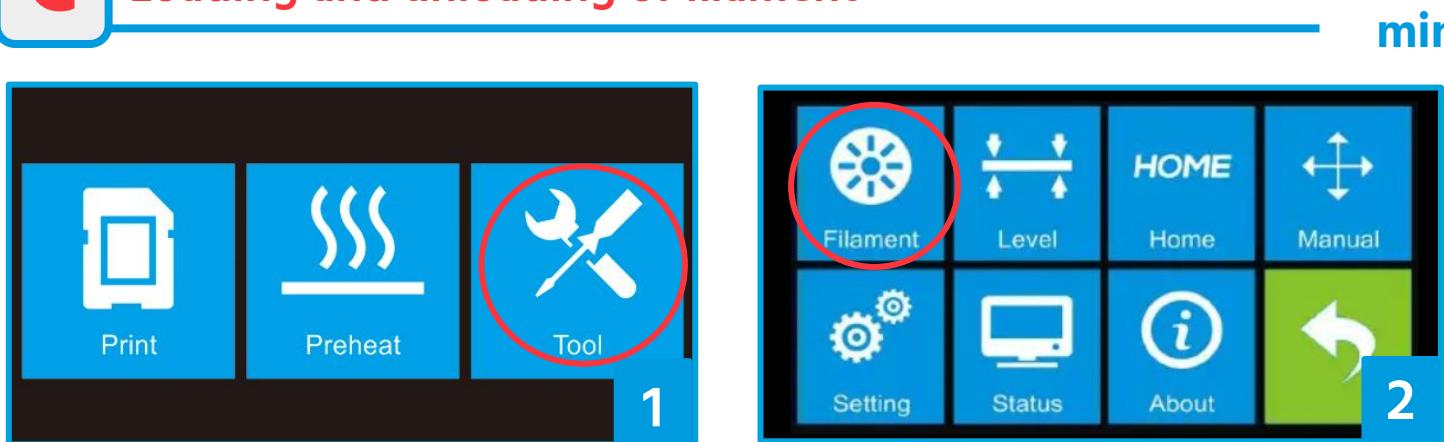
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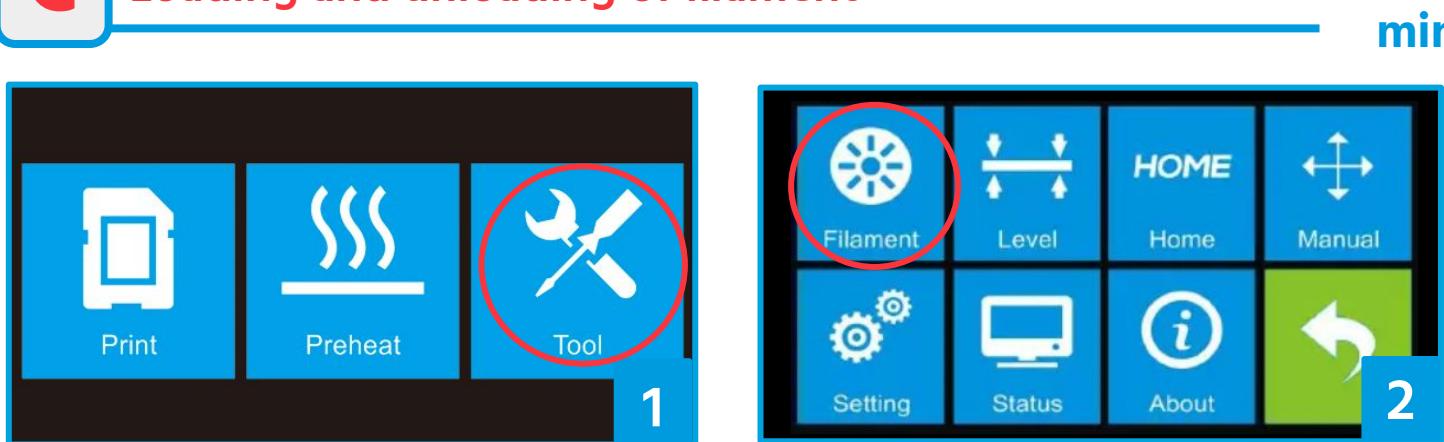
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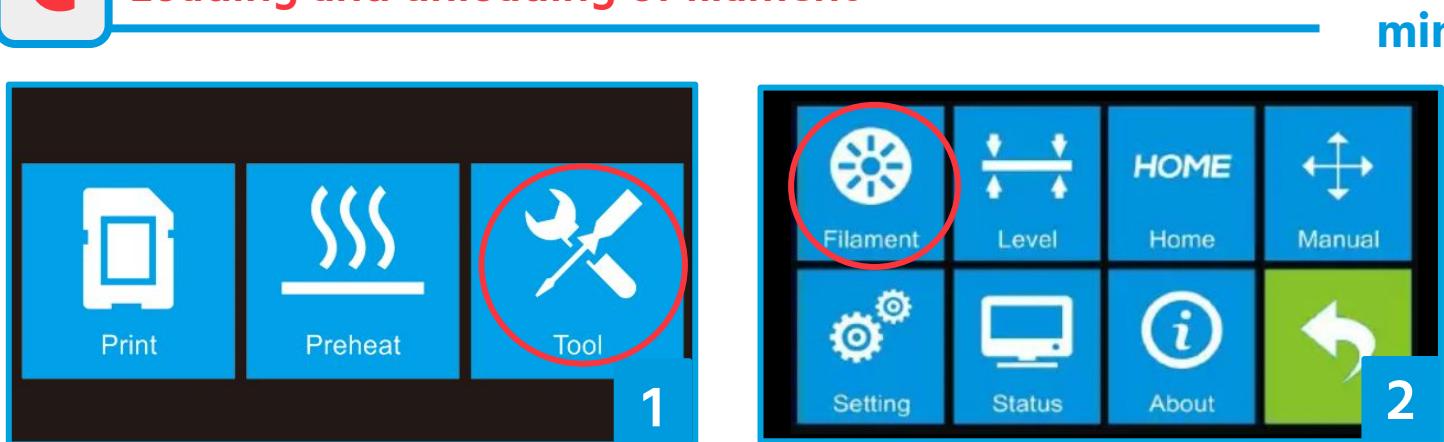
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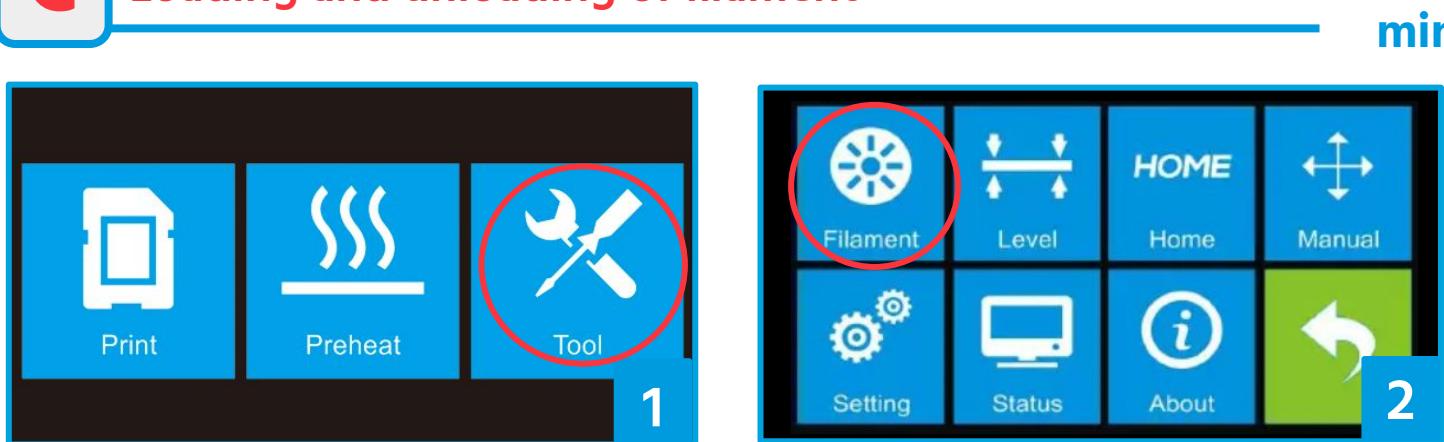
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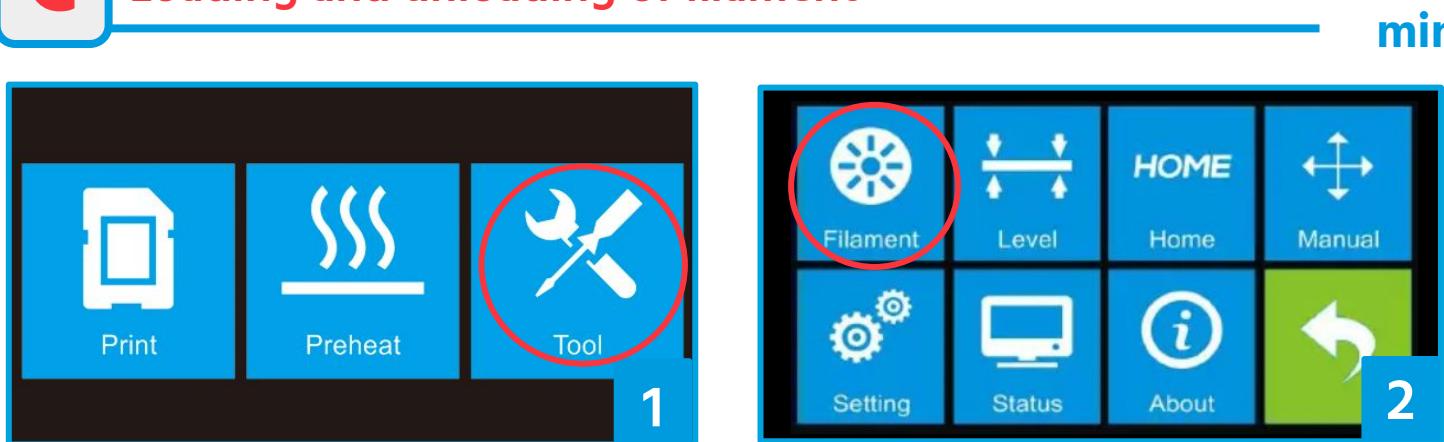
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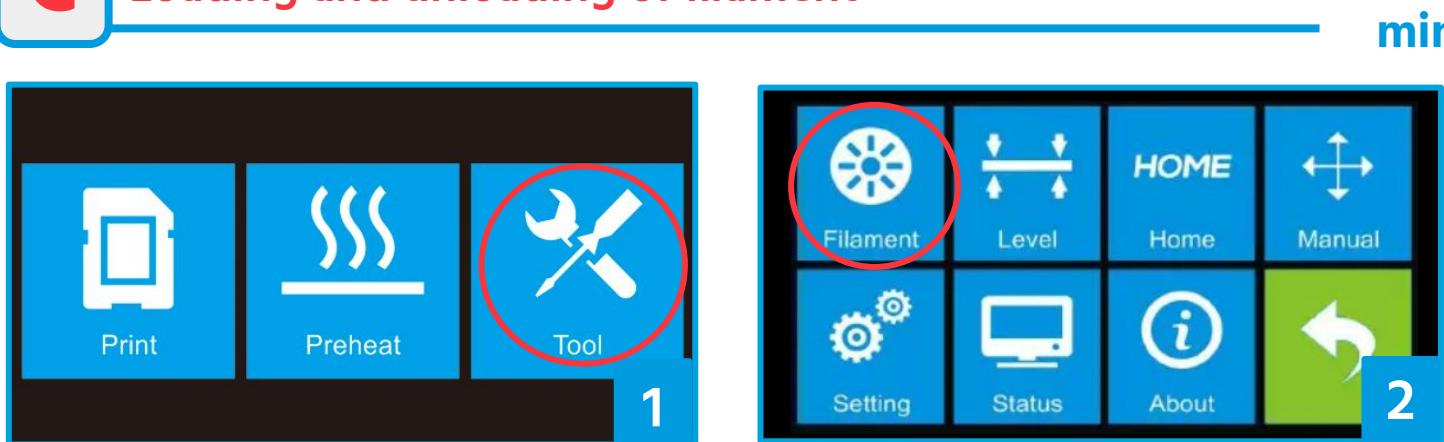
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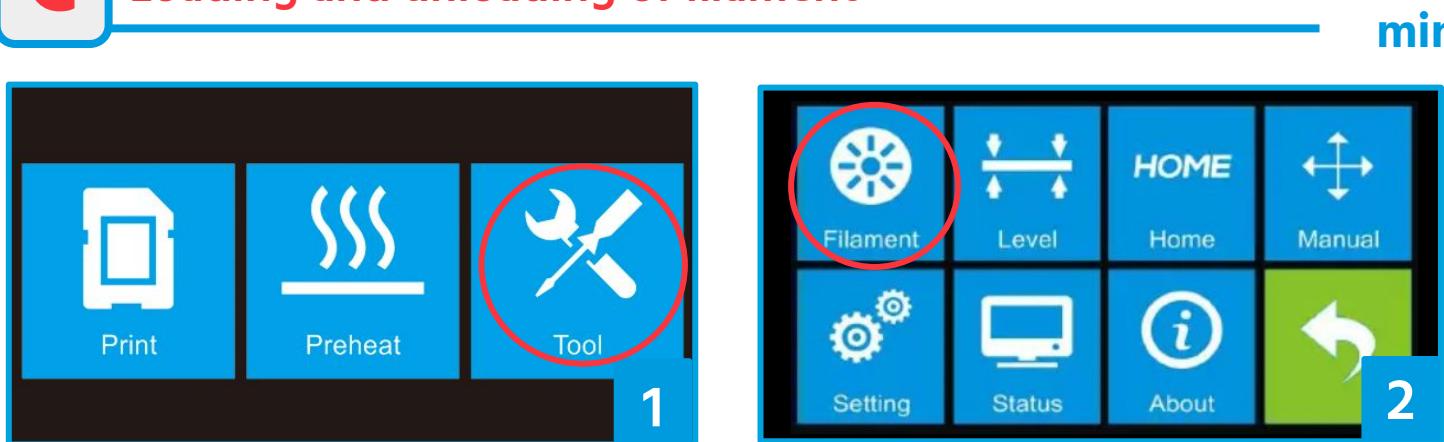
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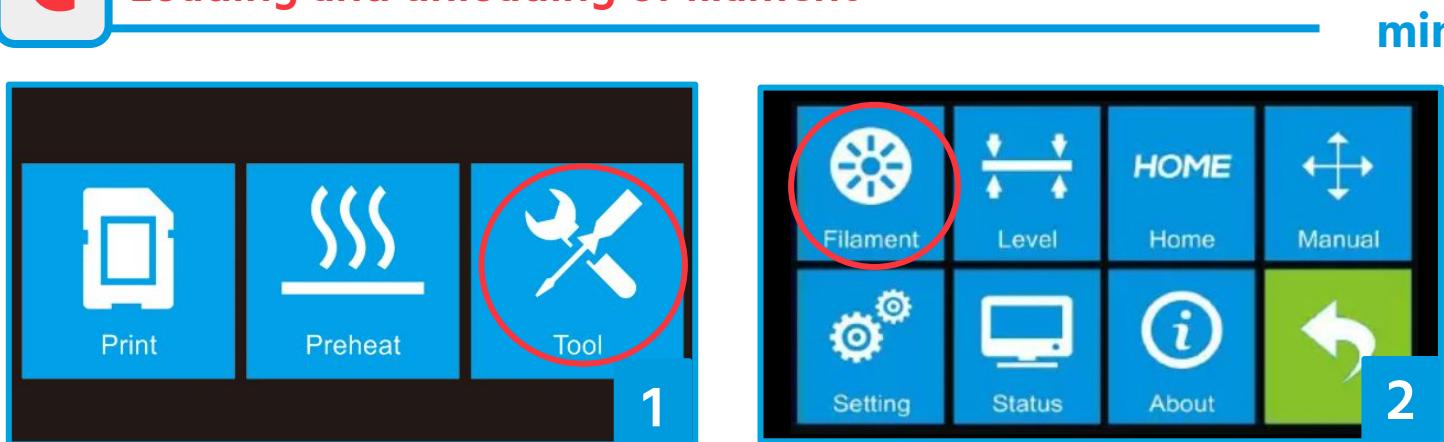
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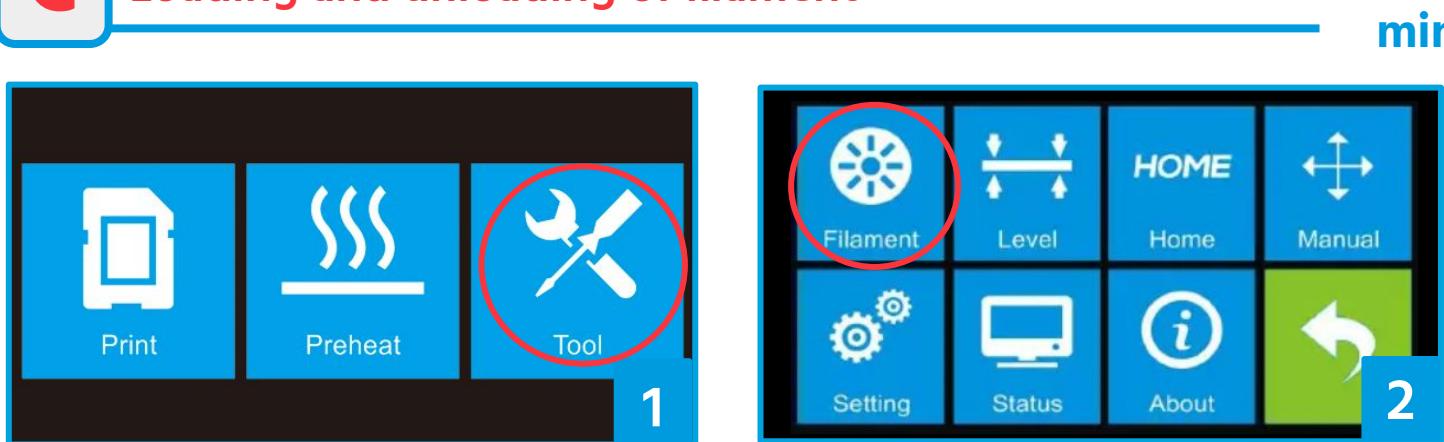
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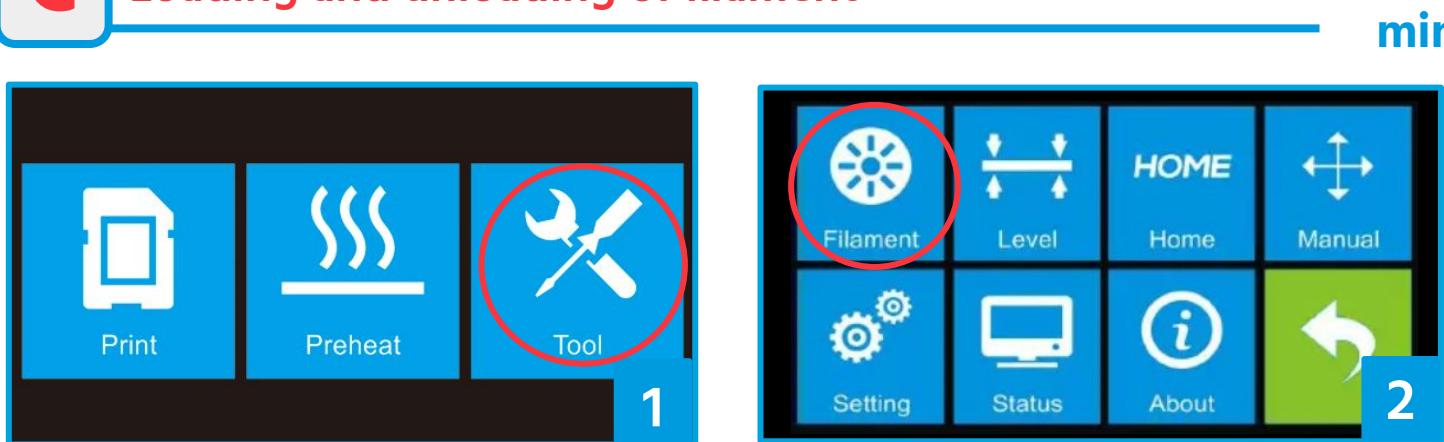
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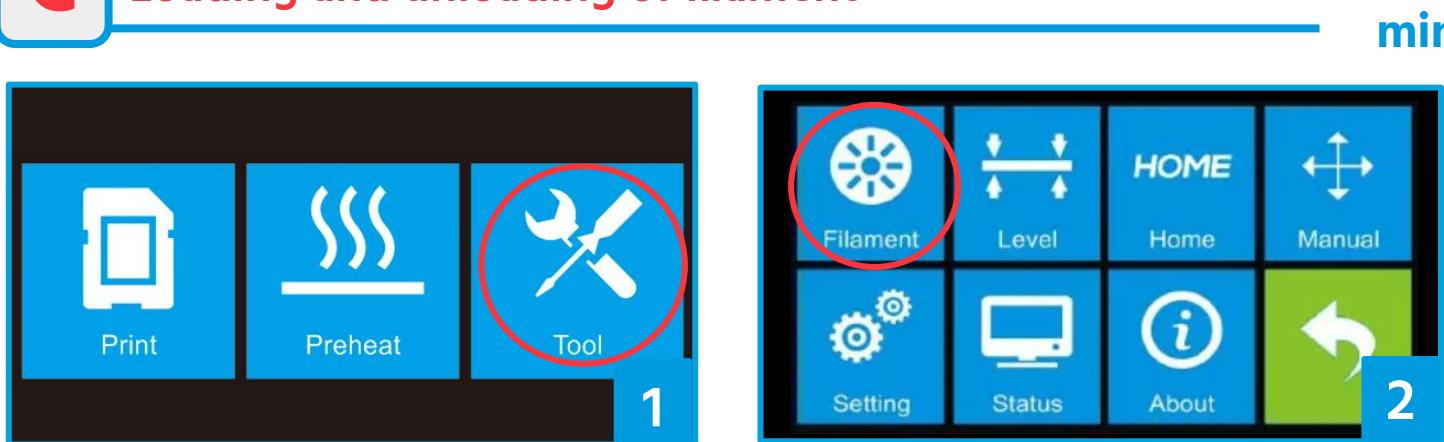
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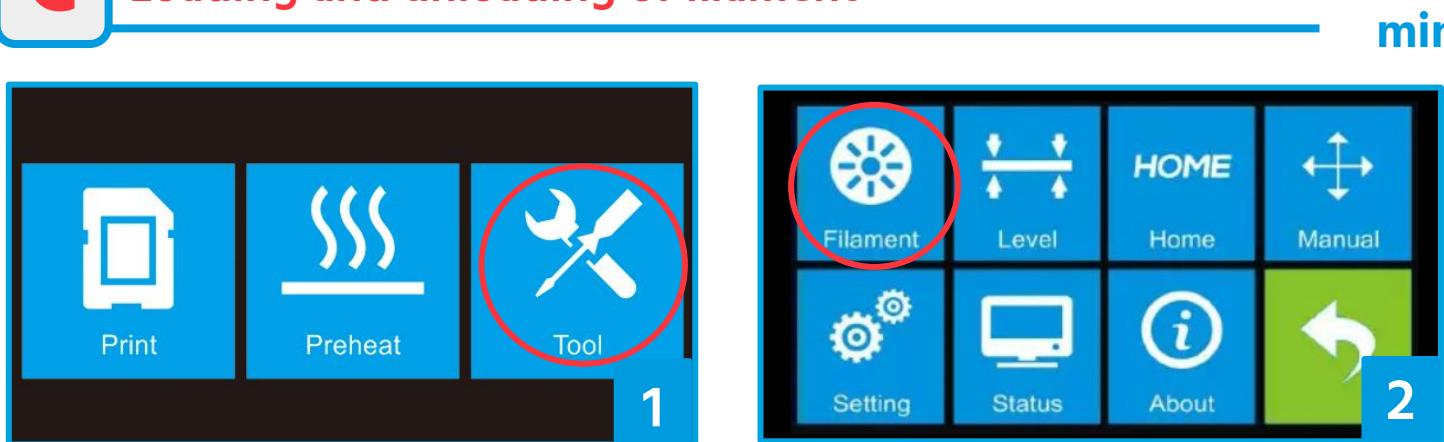
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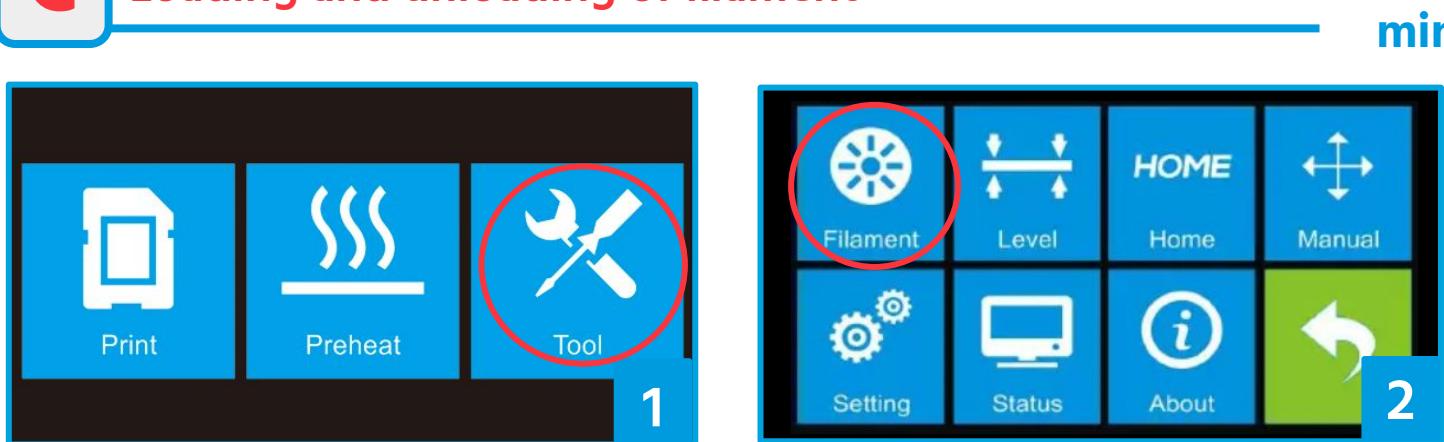
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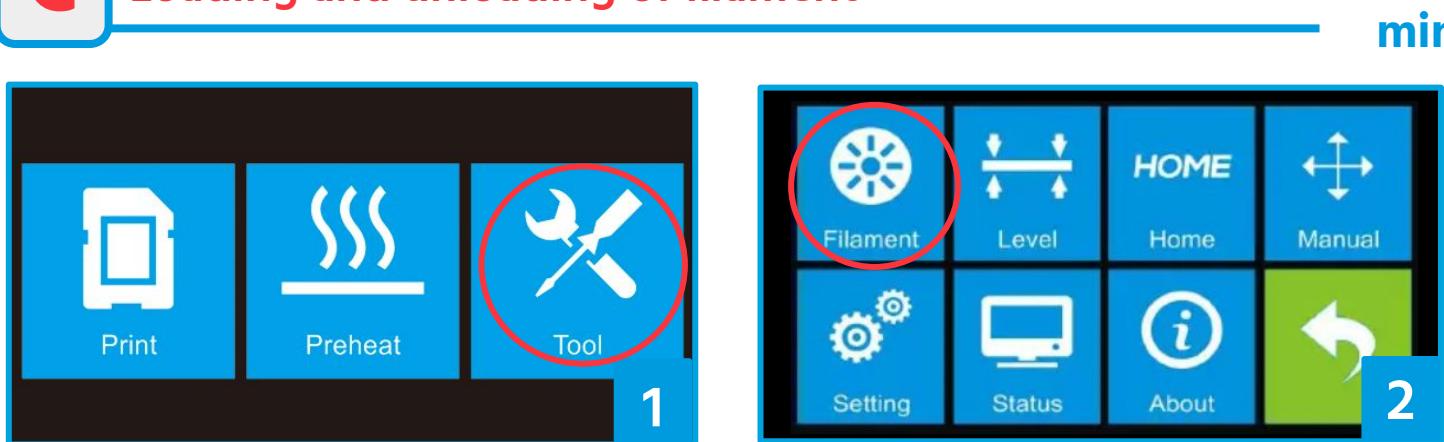
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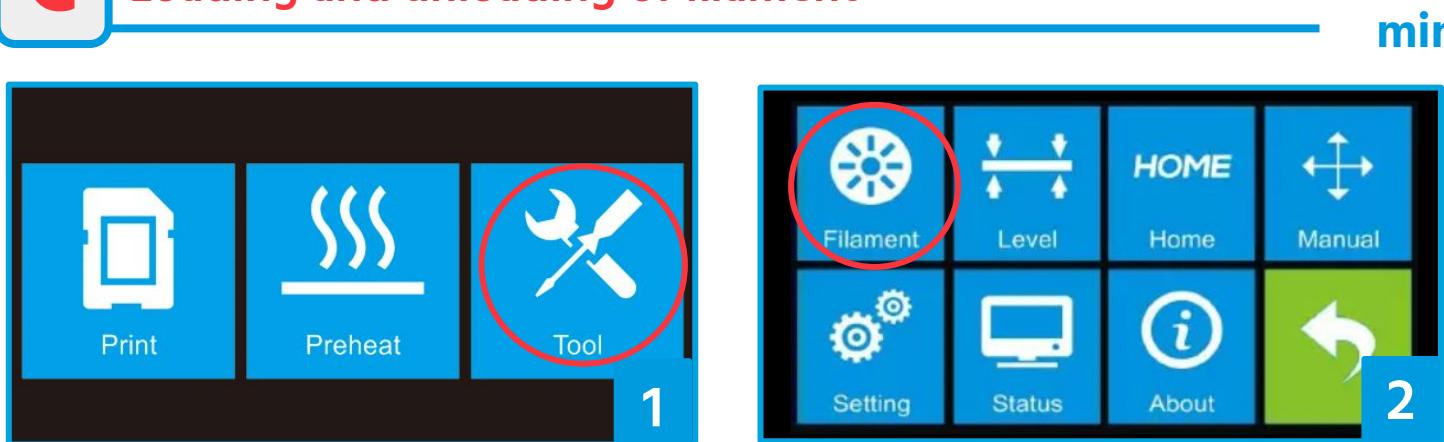
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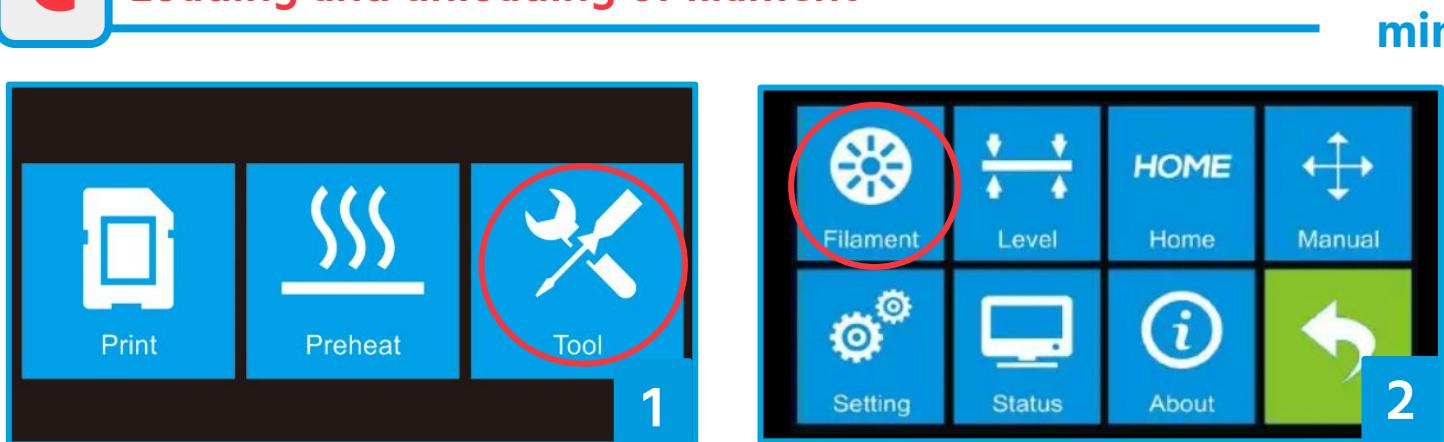
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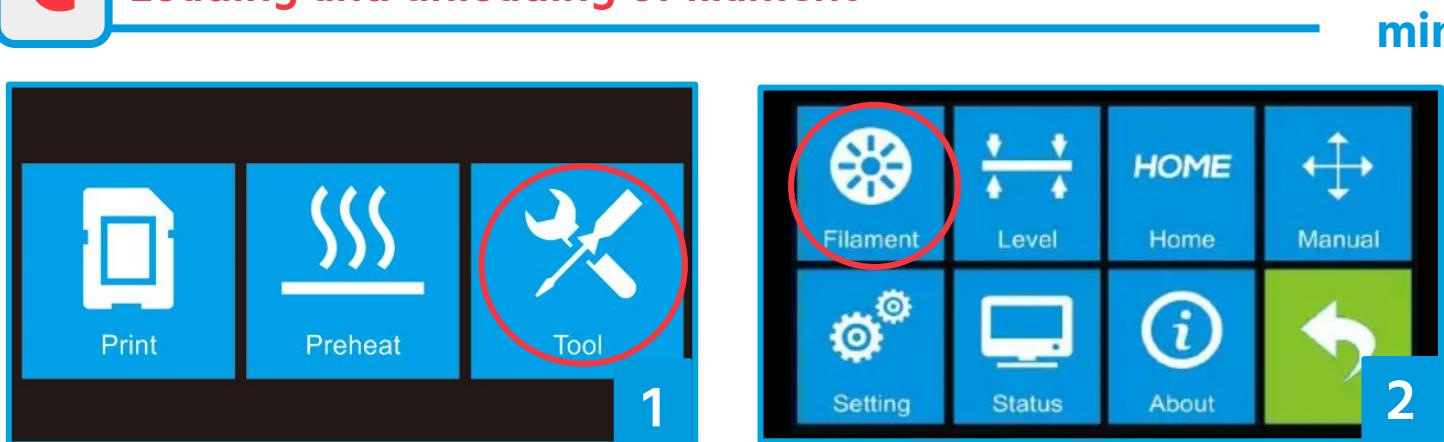
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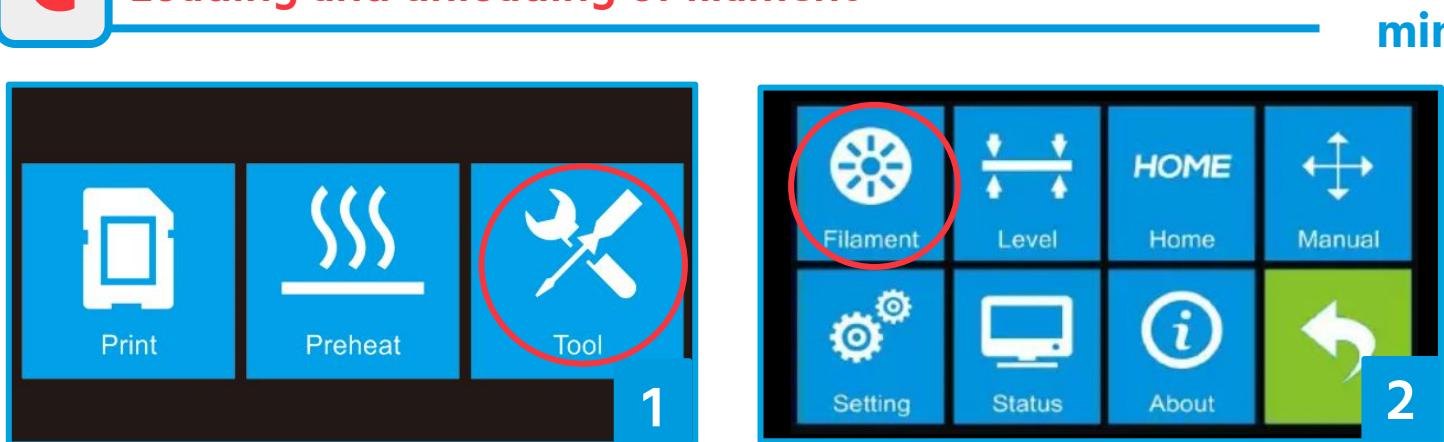
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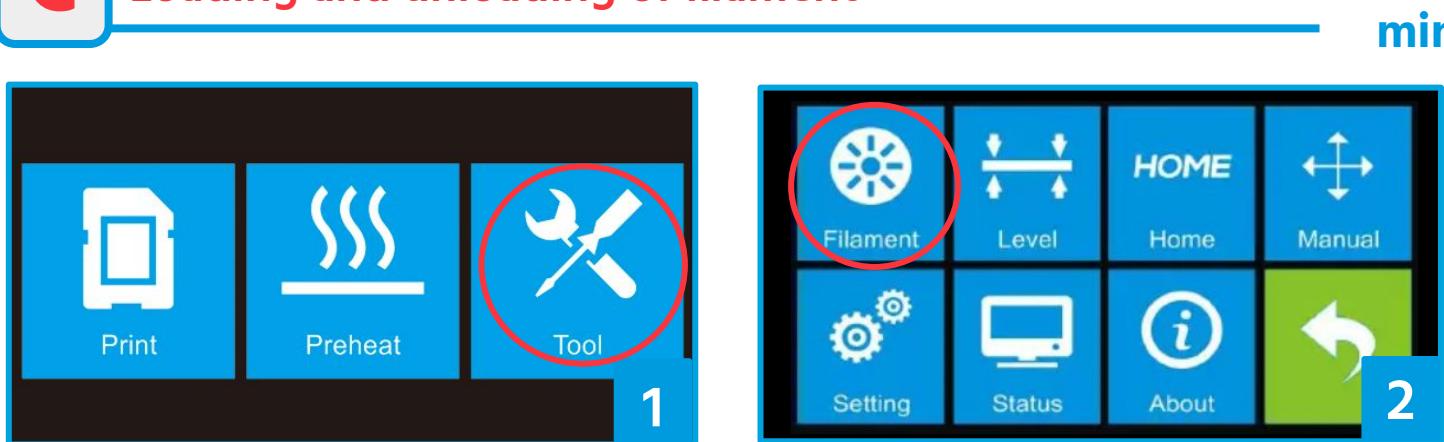
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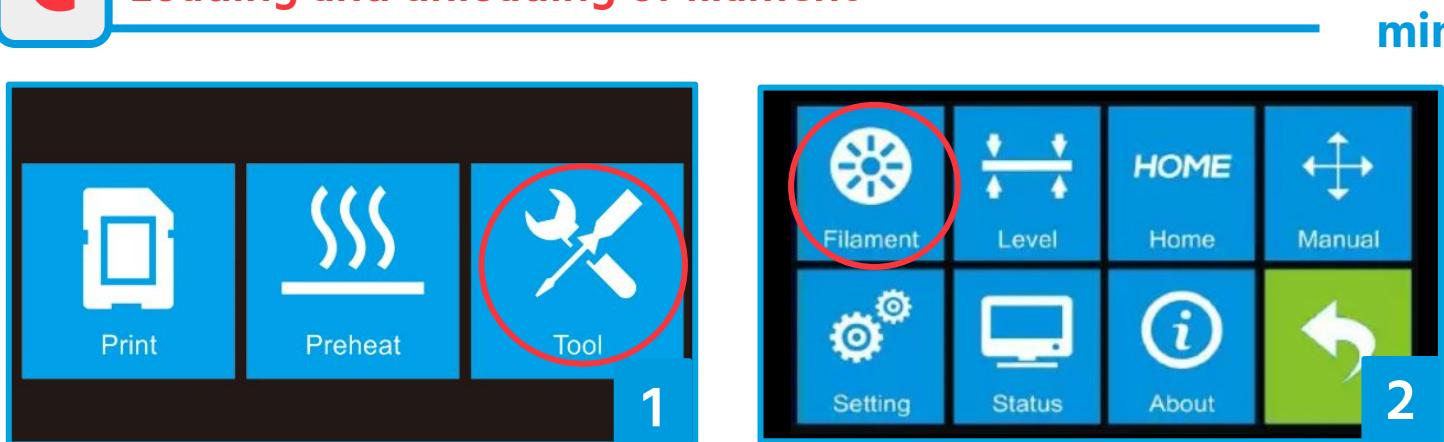
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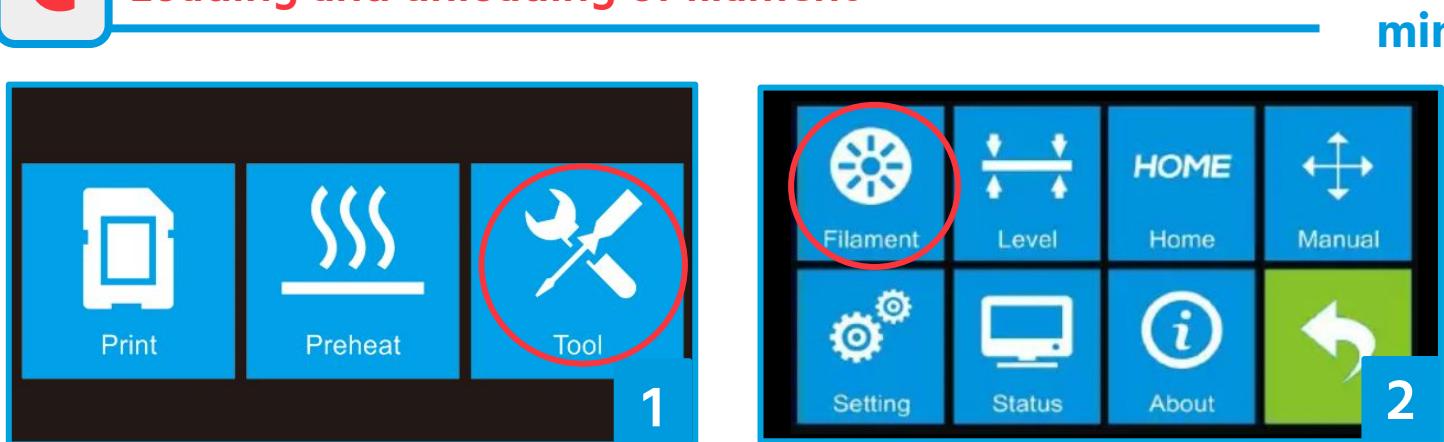
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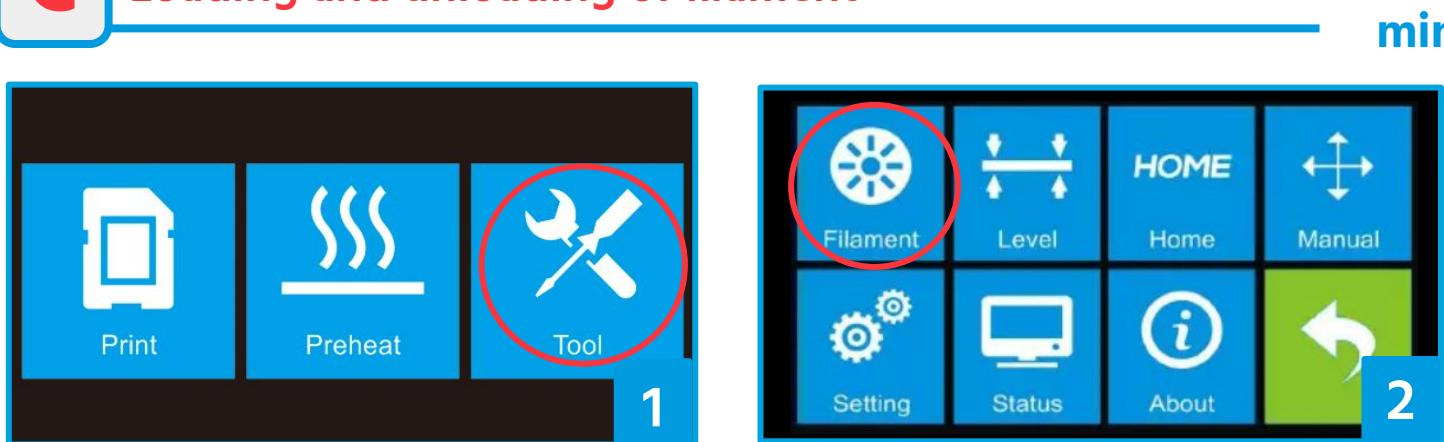
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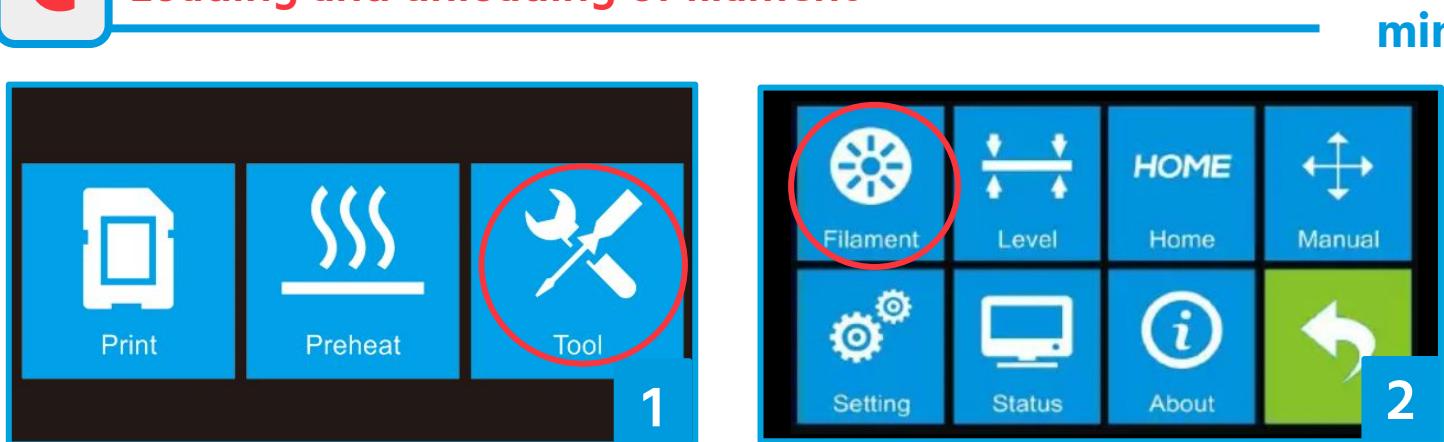
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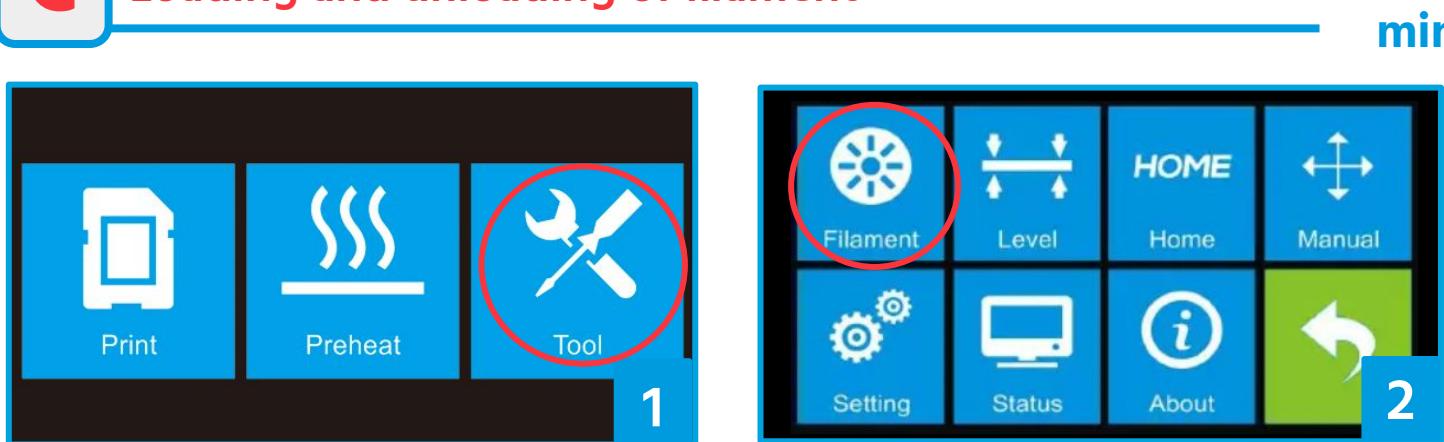
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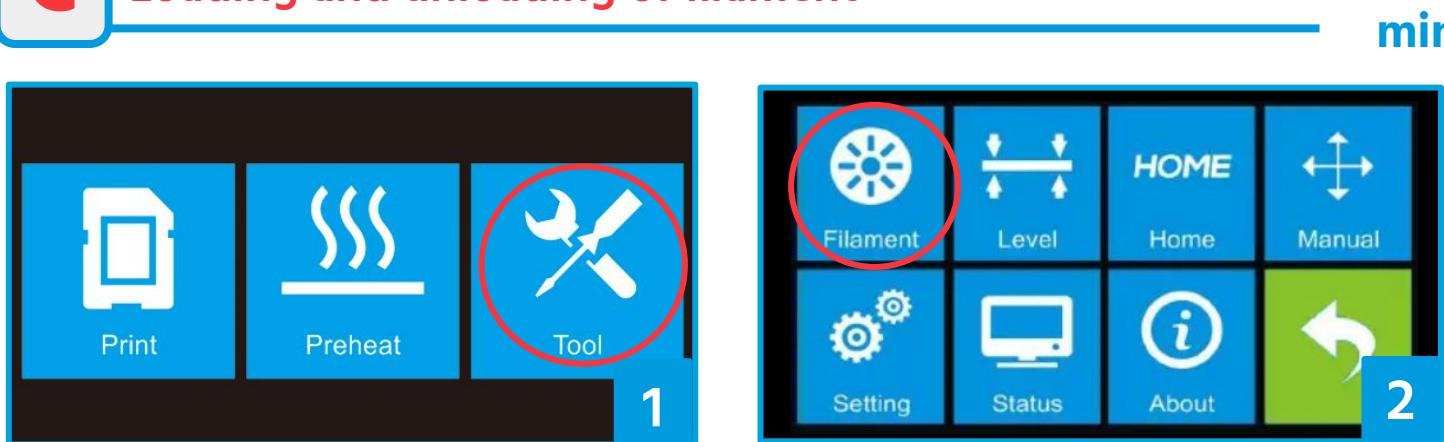
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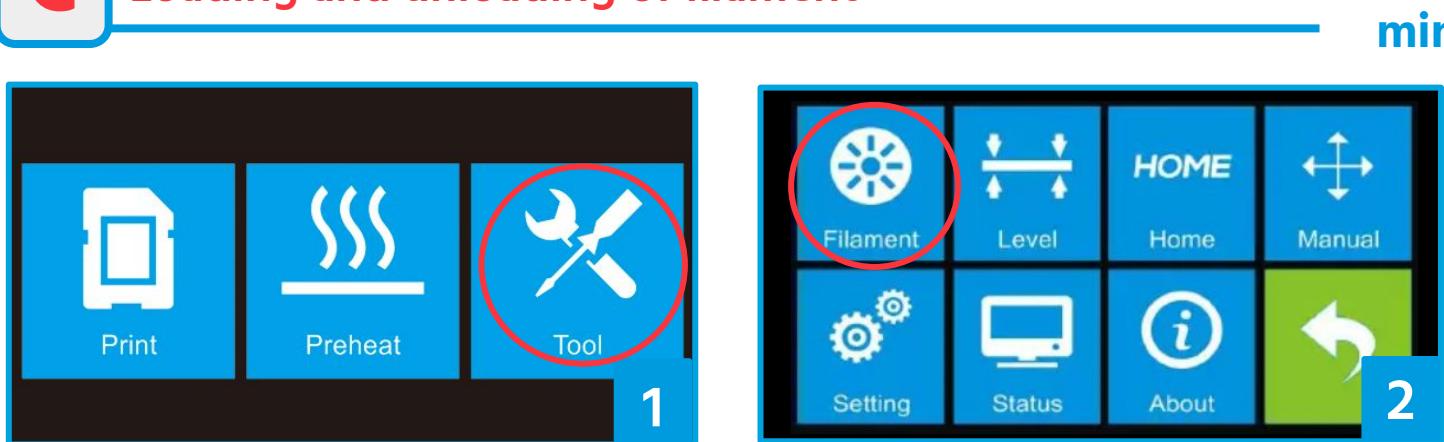
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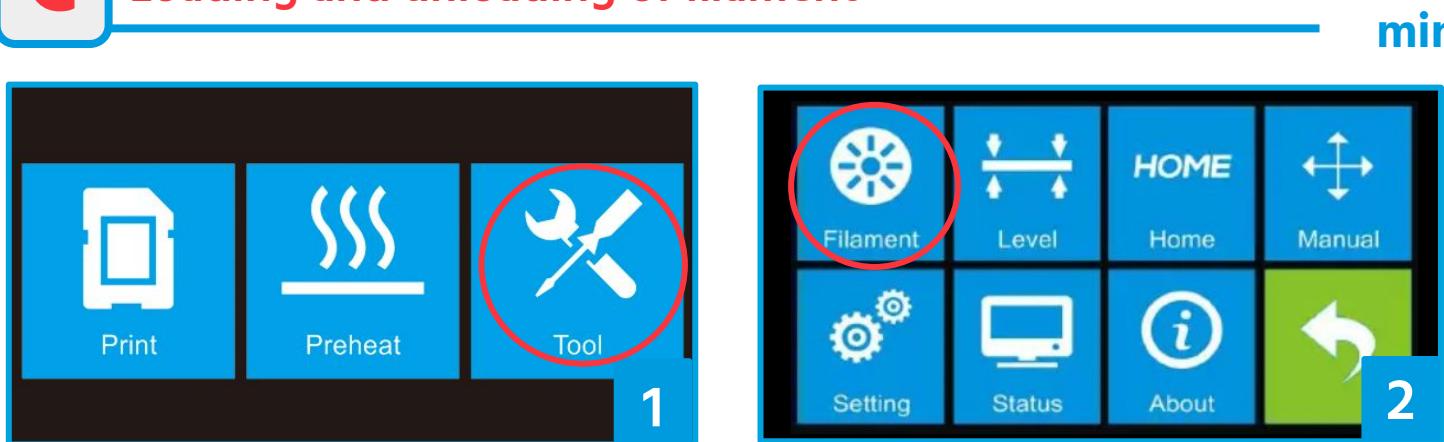
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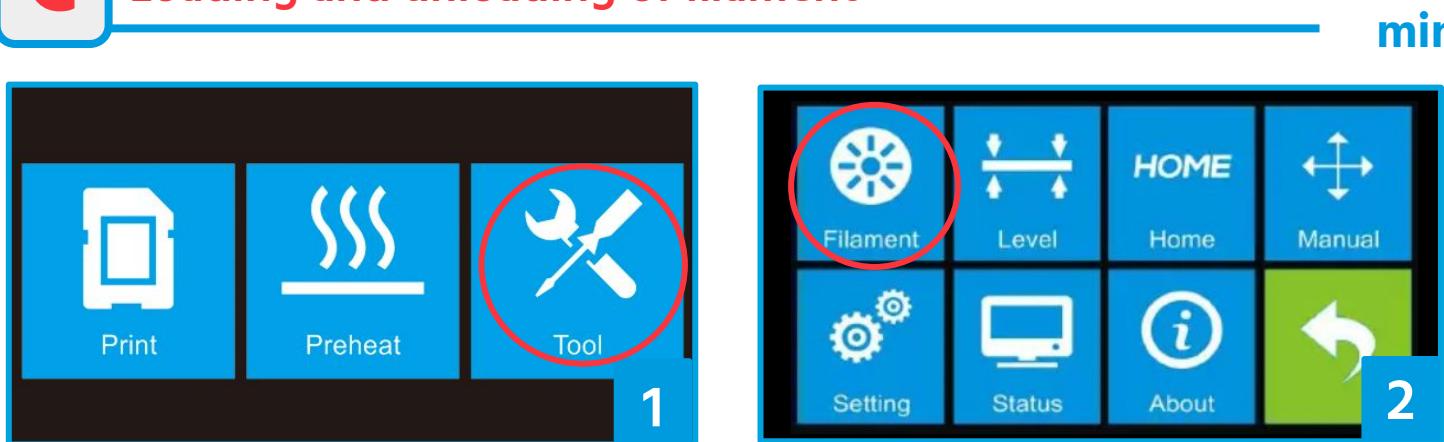
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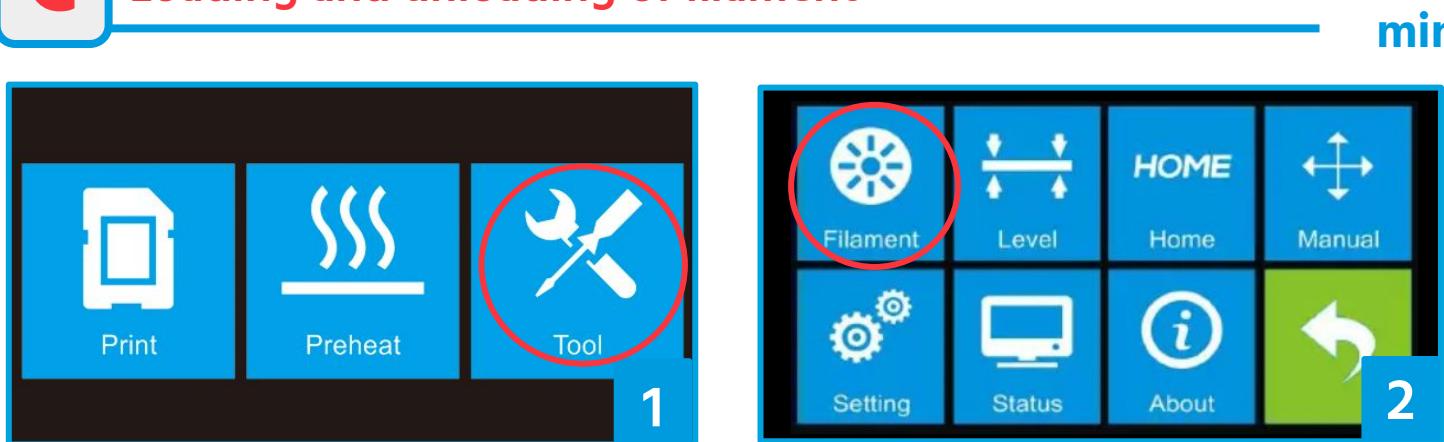
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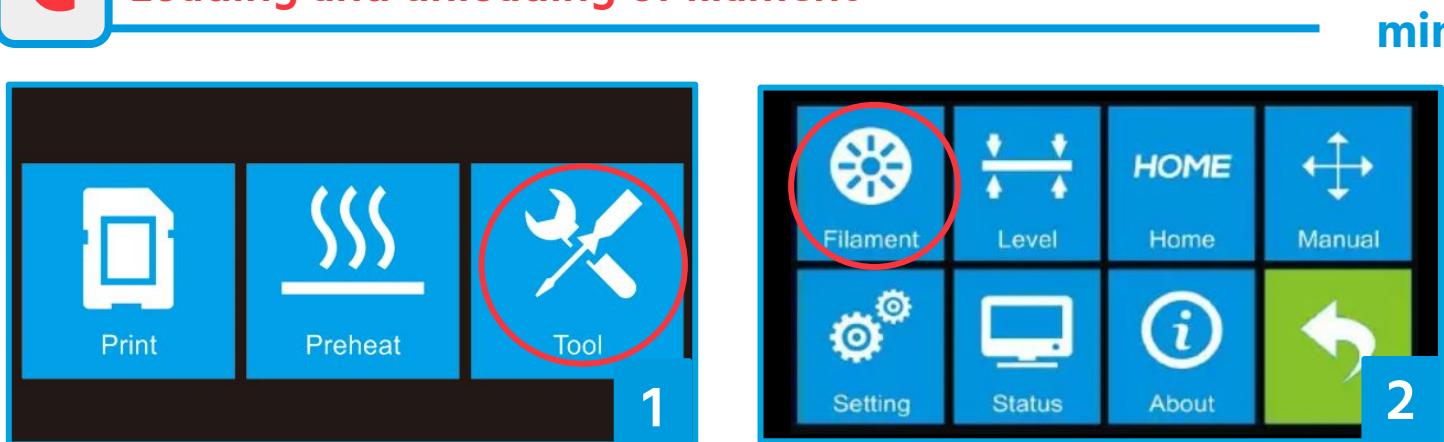
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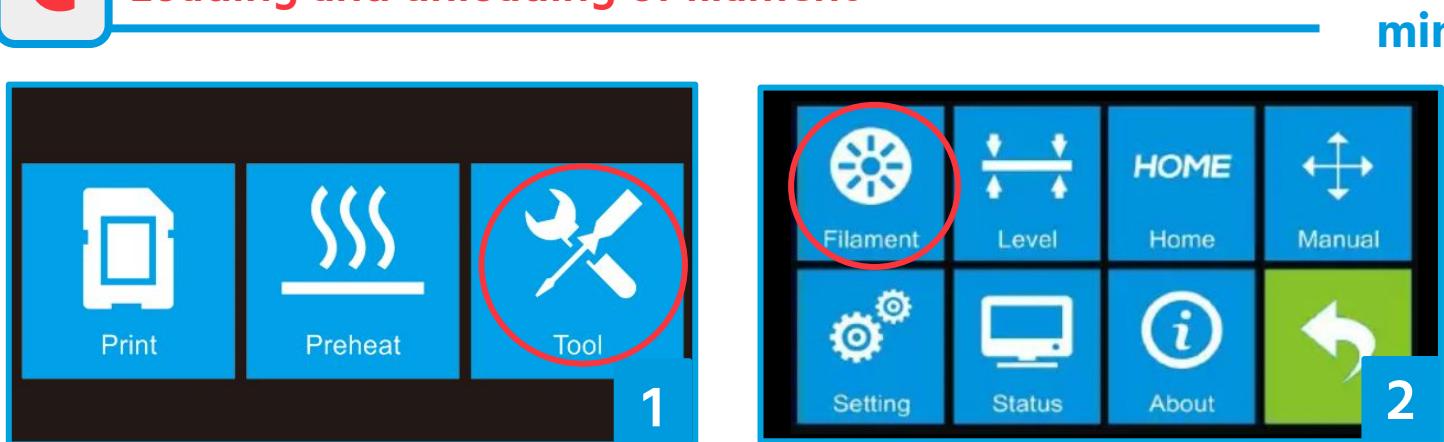
Tap on "Manual".



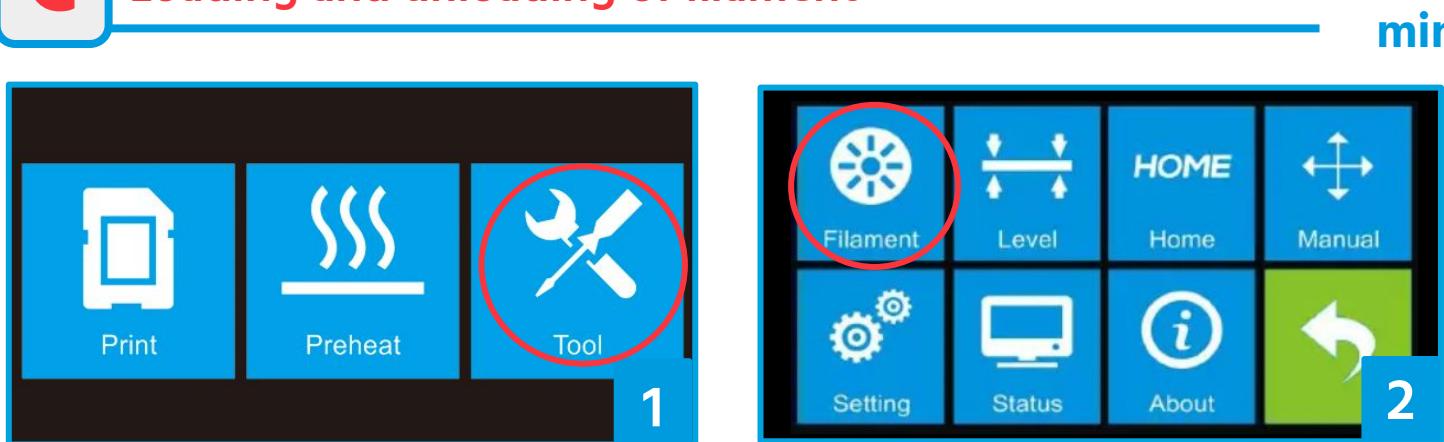
On the LCD, go to the main menu and tap on "Tools".



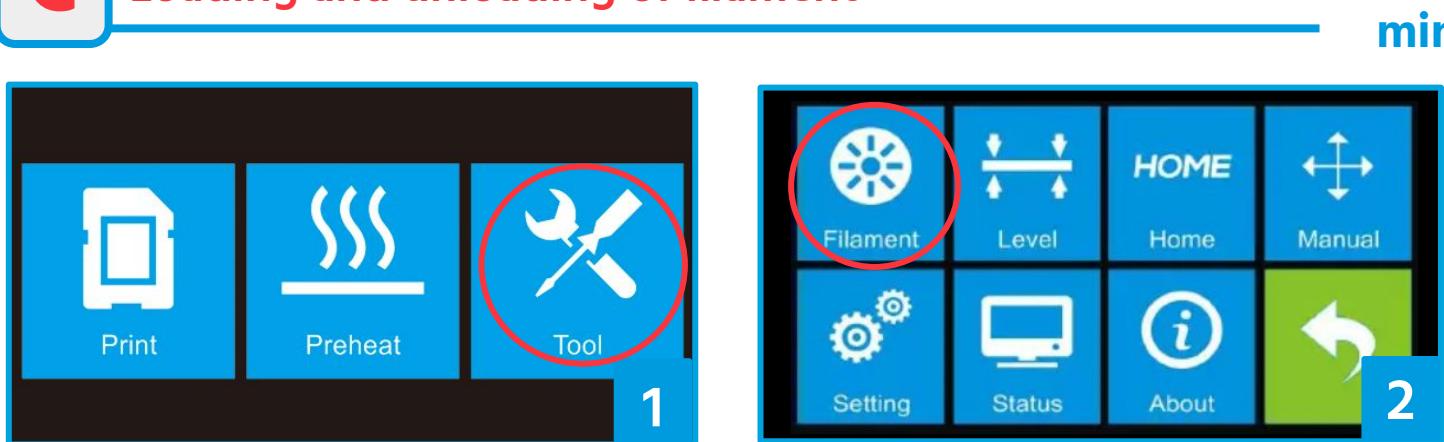
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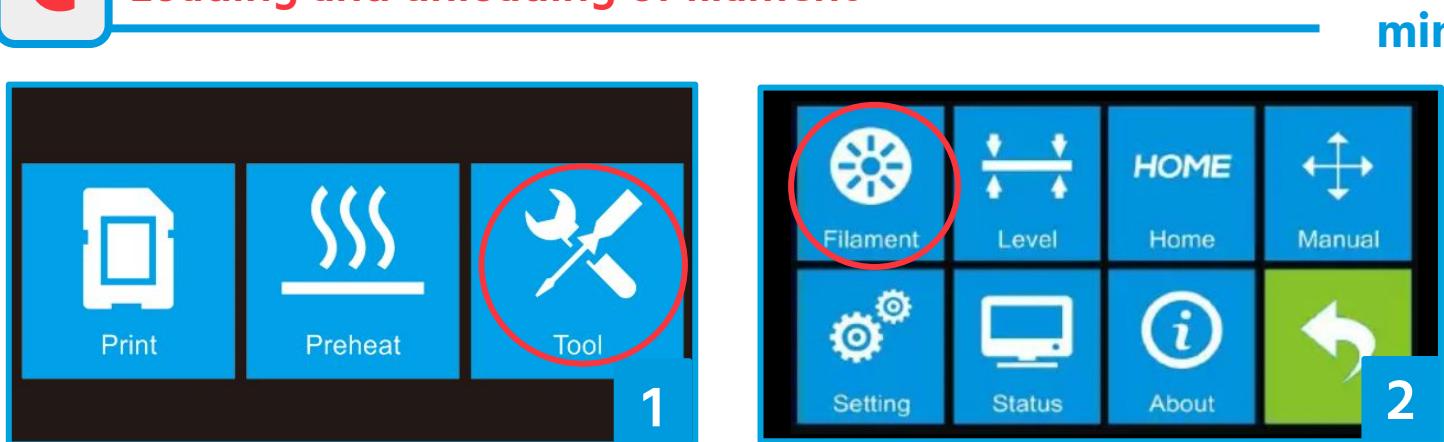
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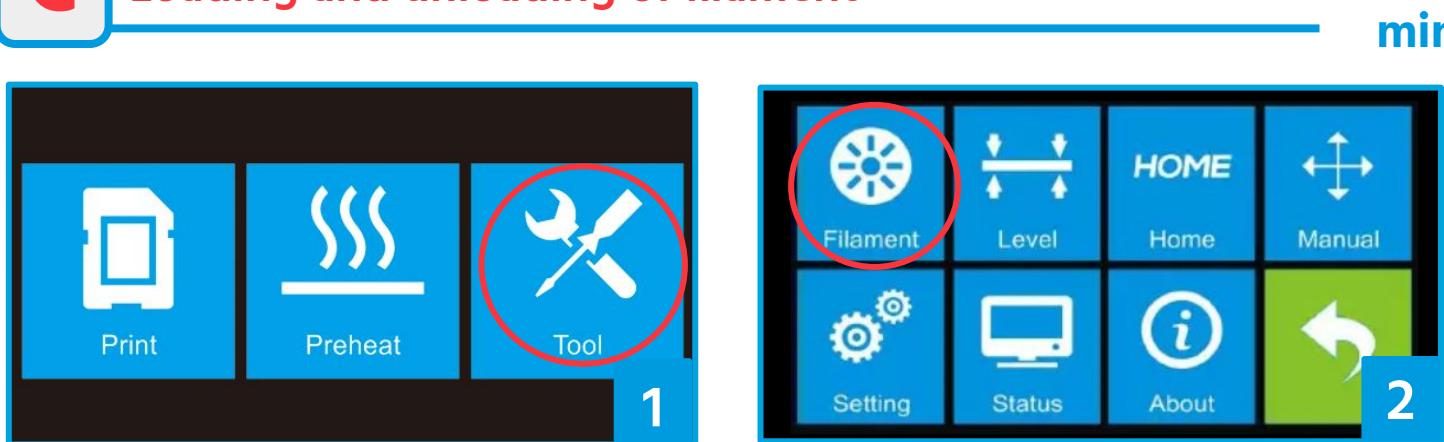
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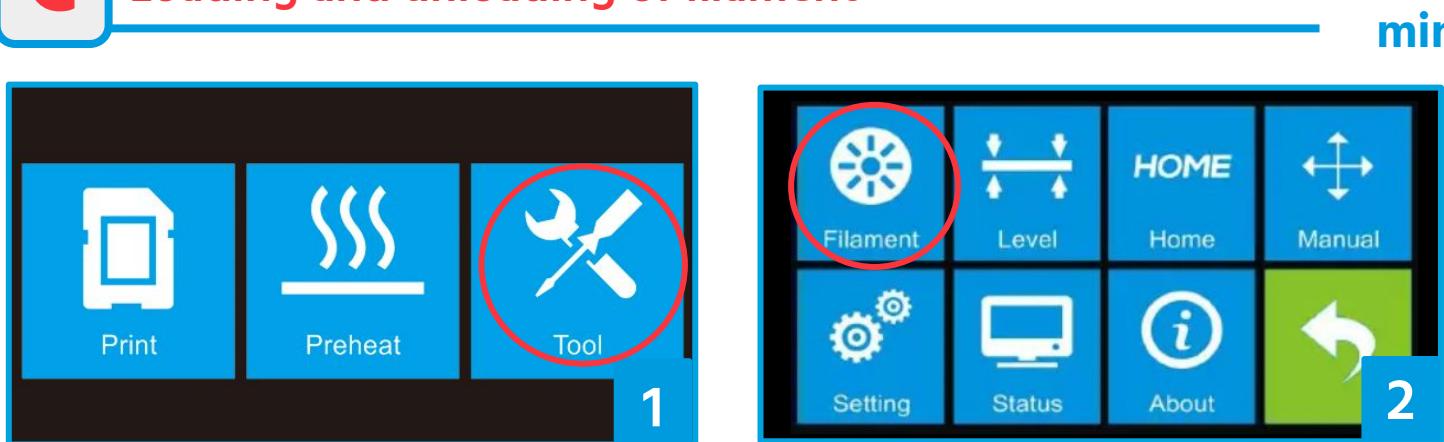
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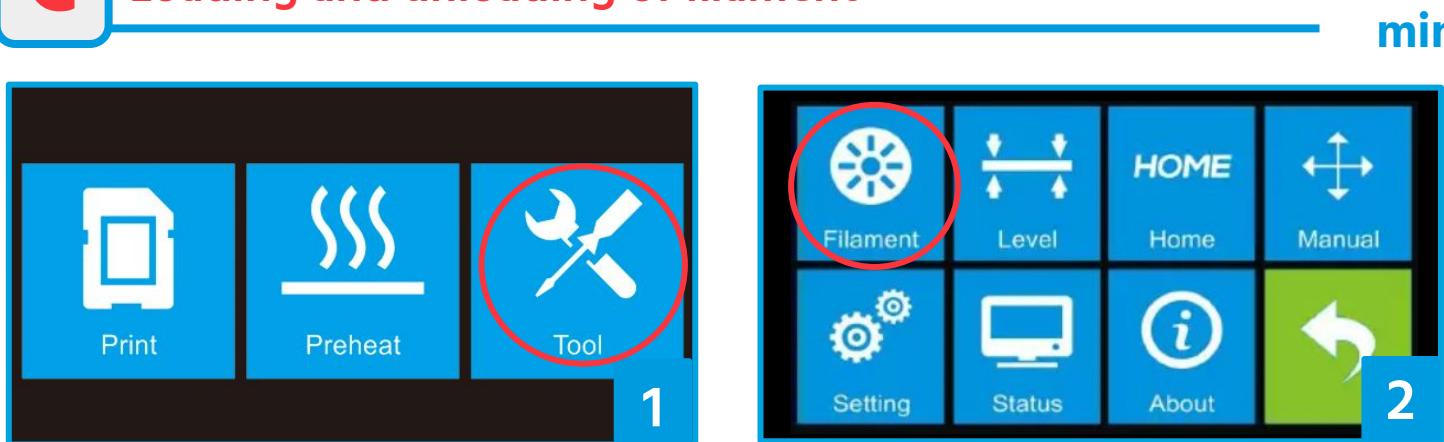
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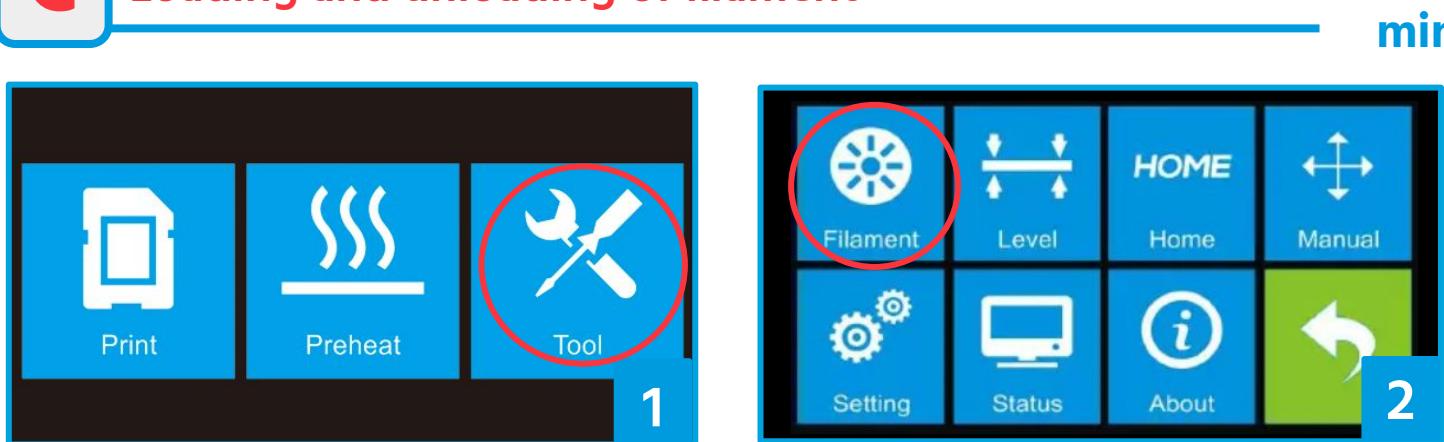
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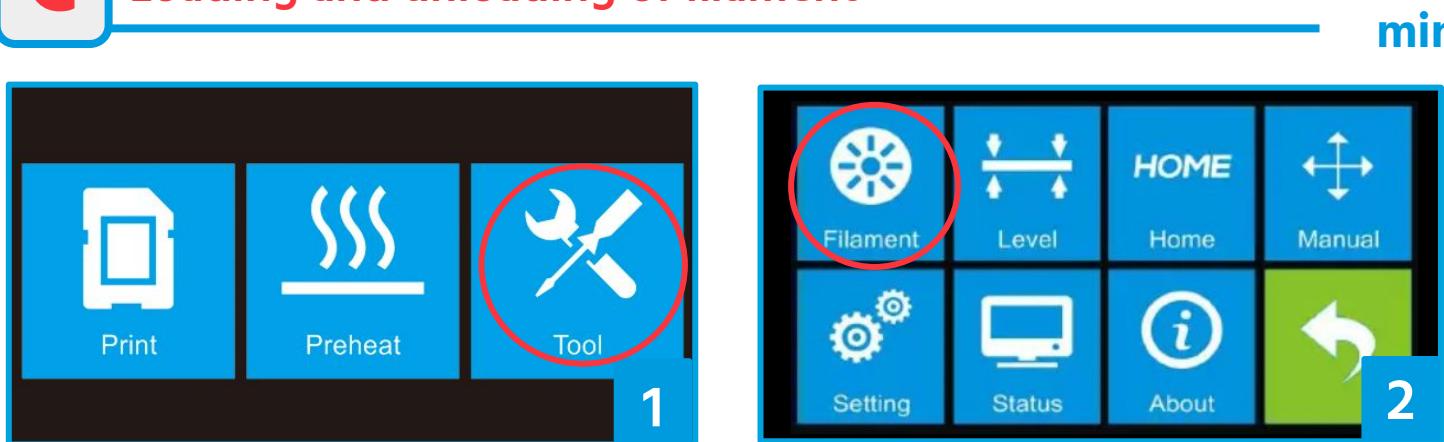
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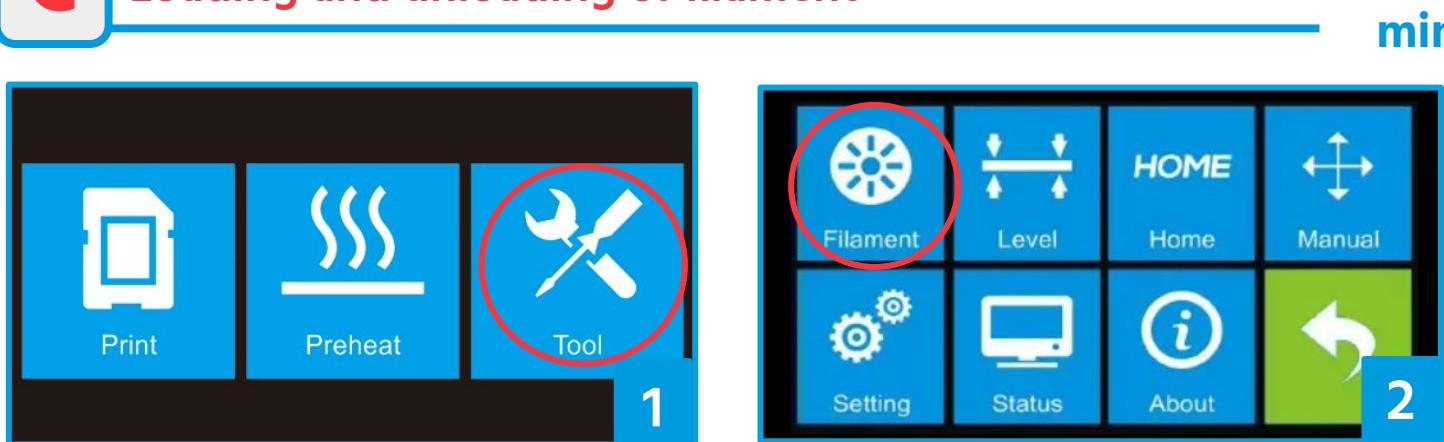
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