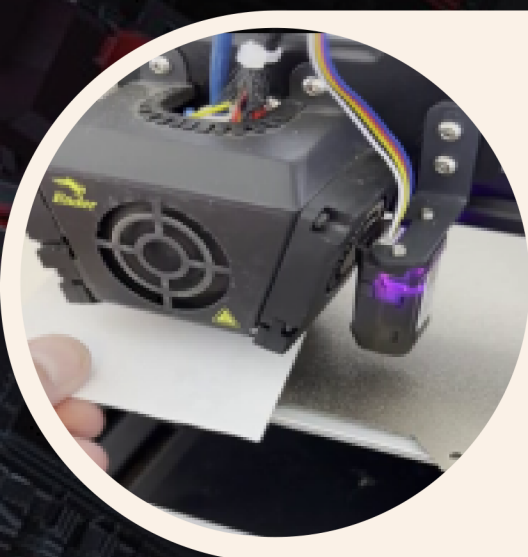


BEGINNER'S

guide to

3D PRINTING



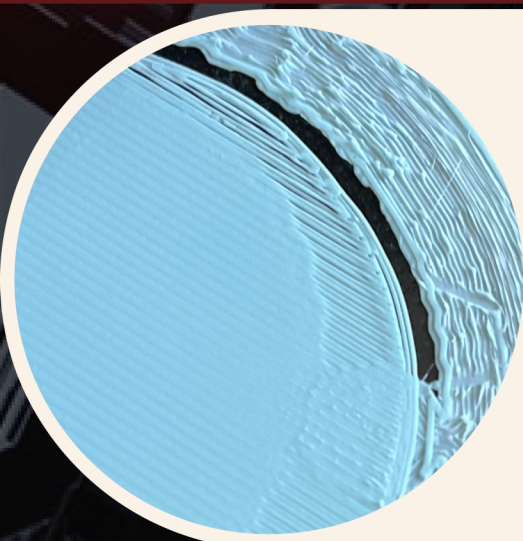
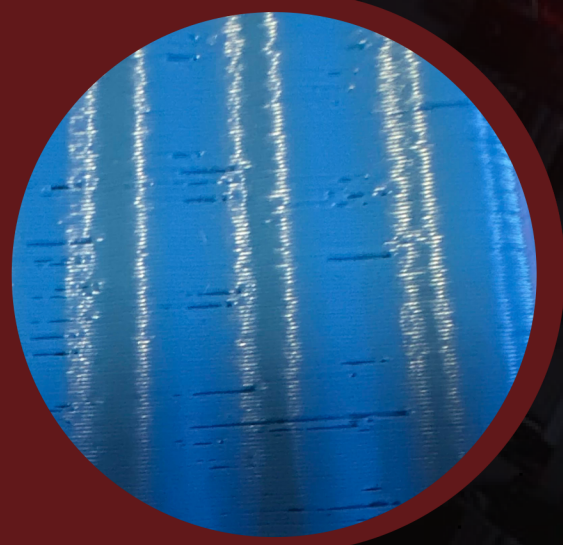
1. Keep a level bed

Your bed should be clean and level.

1. Auto-home
2. Tighten screws
3. Disable Steppers
4. Level the bed
5. Re-home & Repeat

2. Calibrate e-steps

1. Preheat extruder
2. Measure 100mm & mark
3. Extrude 100 mm
4. Measure to mark
5. Calculate
6. Adjust e-steps
7. Repeat



3. Probe Z-axis

As your printer is printing the first layer, use the Probe Z-axis tool to get the perfect adjustment for the nozzle. Remember, clumpy layer means the nozzle is too close and gaps means the nozzle is too far away.

4. Choose the Right Filament

PLA

- Strong
- Variety
- Biodegradable

PETG

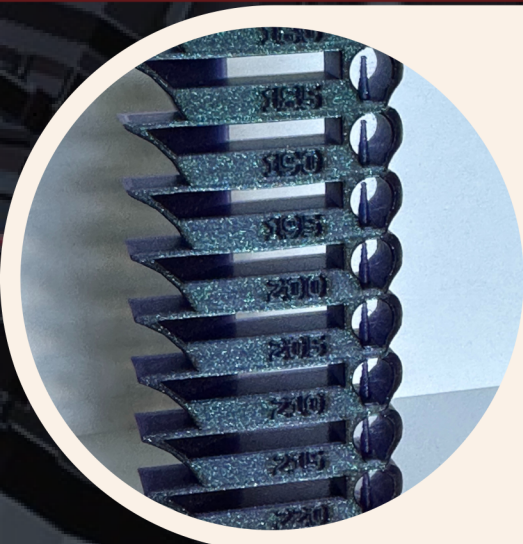
- Food Safe
- Durable
- Withstands high temp

ABS

- Chemical resistant
- Rigid
- Finish with acetone

TPU

- Durable
- Flexible
- Impact Resistant



5. Adjust Your Settings

Bed Temp: helps the filament adhere.

Nozzle Temp: print a temp tower

Bed Adhesion: None, Brim, Skirt, Raft

Supports: necessary for 45° overhangs

Layer Height: Smaller for better detail

Speed: Slower for better finish

Infill: More infill, stronger structure



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