



3D PRINTER

nGen Flex Quick Guide

Set Up:

1. Install Cura for Lulzbot on your computer:
<https://www.lulzbot.com/cura#download>
2. Download the nGen Flex material profile from BeAM site:
<https://www.thingiverse.com/thing:4775517>
3. In Cura for Lulzbot complete steps to add appropriate printer.
 - a. Settings->Printer->Add Printer
 - b. Select Lulzbot Mini, Aerostruder v1, and Yes
 - c. Click add printer
4. Import the nGen Flex material profile:
 - a. Settings->Material->Manage Materials
 - b. Click Import and open downloaded material profile.
 - c. Click Close.
5. Load your .stl model into Cura for Lulzbot.
6. Under Material select colorfabb->custom->nGen Flex.
7. In the section Print Setup click the Custom button.
8. Expand the section labeled Quality and change Layer Height to .25mm.
9. Plug SD card from printer into computer and click Save to Removable Drive "Lulzbot."
10. Eject SD card from printer.

Use:

1. Begin filling out an online form for your 3D print job:
<https://go.unc.edu/a6PQi> (don't submit until you press 'Print')
2. Locate the nGen Flex equipped Lulzbot Mini.
3. Apply a thin layer of glue from glue stick to build plate.
4. Insert SD Card and use click wheel on LCD screen to select Print from SD and then select your file from list.
5. Submit your online print form. **REMEMBER: if you do not submit your form, the BeAM staff will cancel your print.**

Clean Up:

1. You must stay in the makerspace until after **the first layer of your print is complete or for 20 minutes** (whichever is longer.)
2. Once your print finishes and the bed has returned to room temperature, it should lift easily from the bed. **DO NOT PRY IT OFF** - if you have to use force, the bed is still too warm.

Want more details of the process? Email Drew.

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