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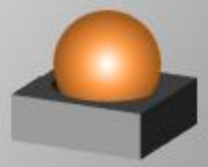
Duinotech Mini 3D Printer TL4076 3D Printer Cura Settings



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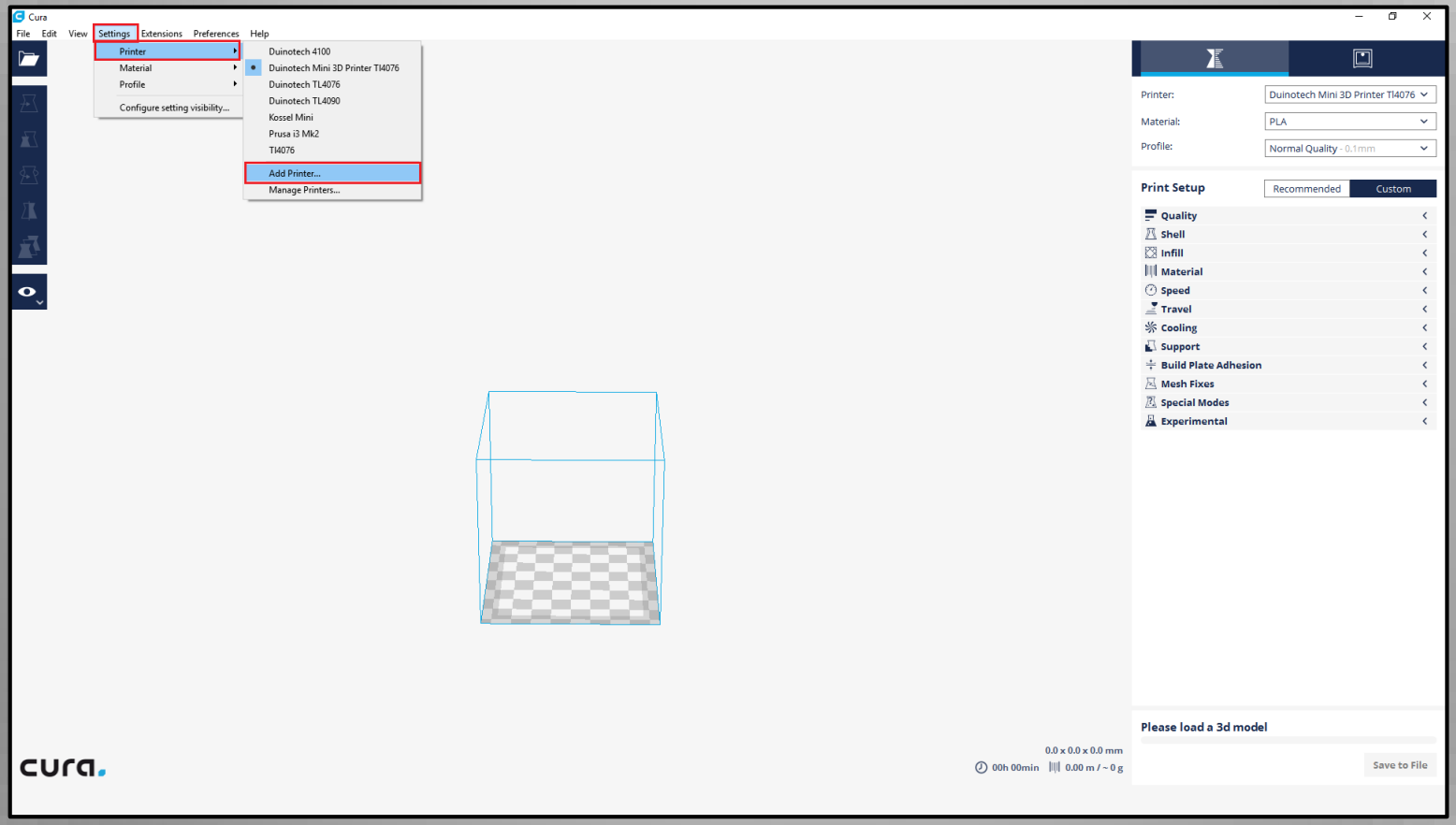
You can download Cura for free from:
https://ultimaker.com/en/products/cura-software

Once installed we go to Setting, Printer, Add Printer



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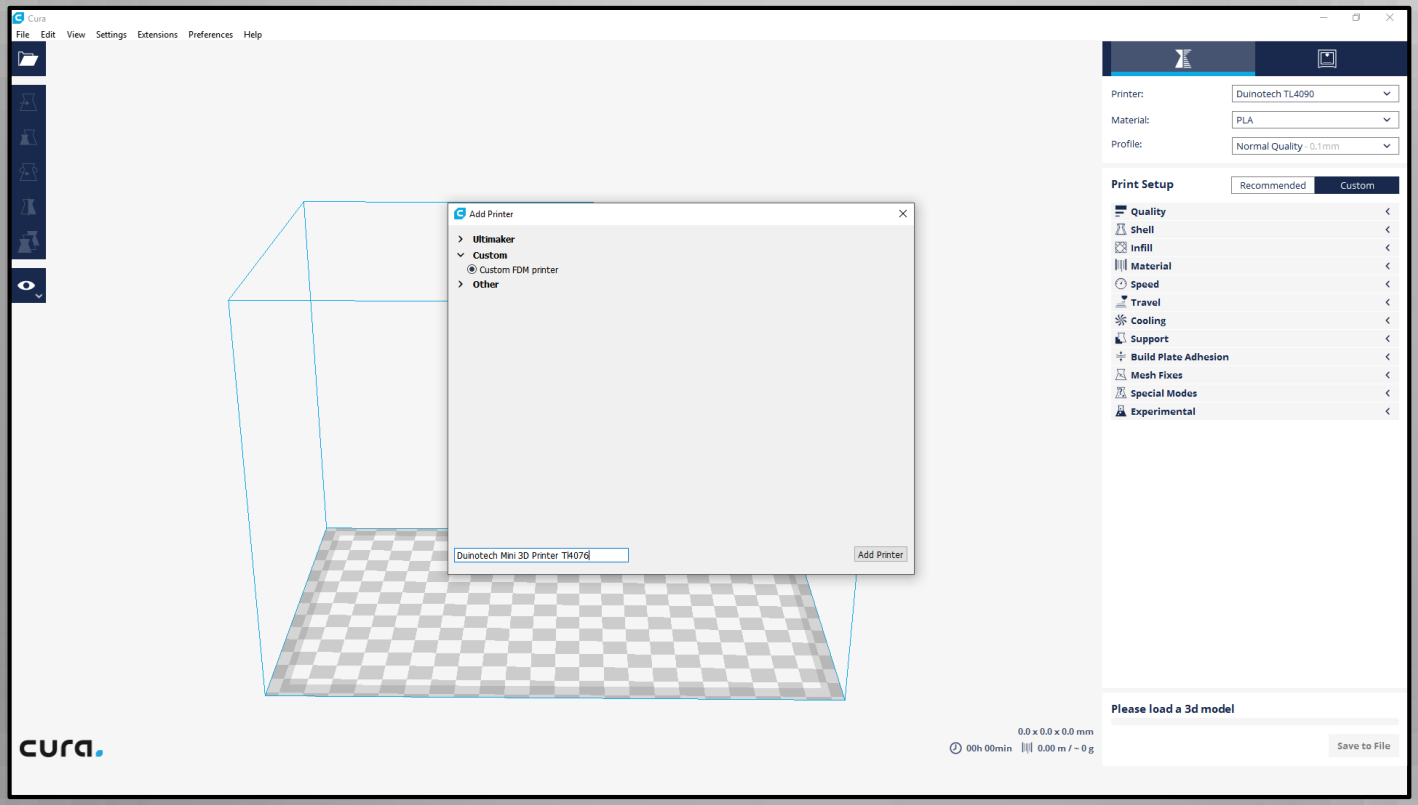
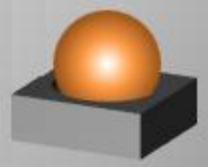
In Add Printer chose Custom FM printer and name it what you like. I named mine Duinotech Mini 3D Printer TL4076 to keep it easy





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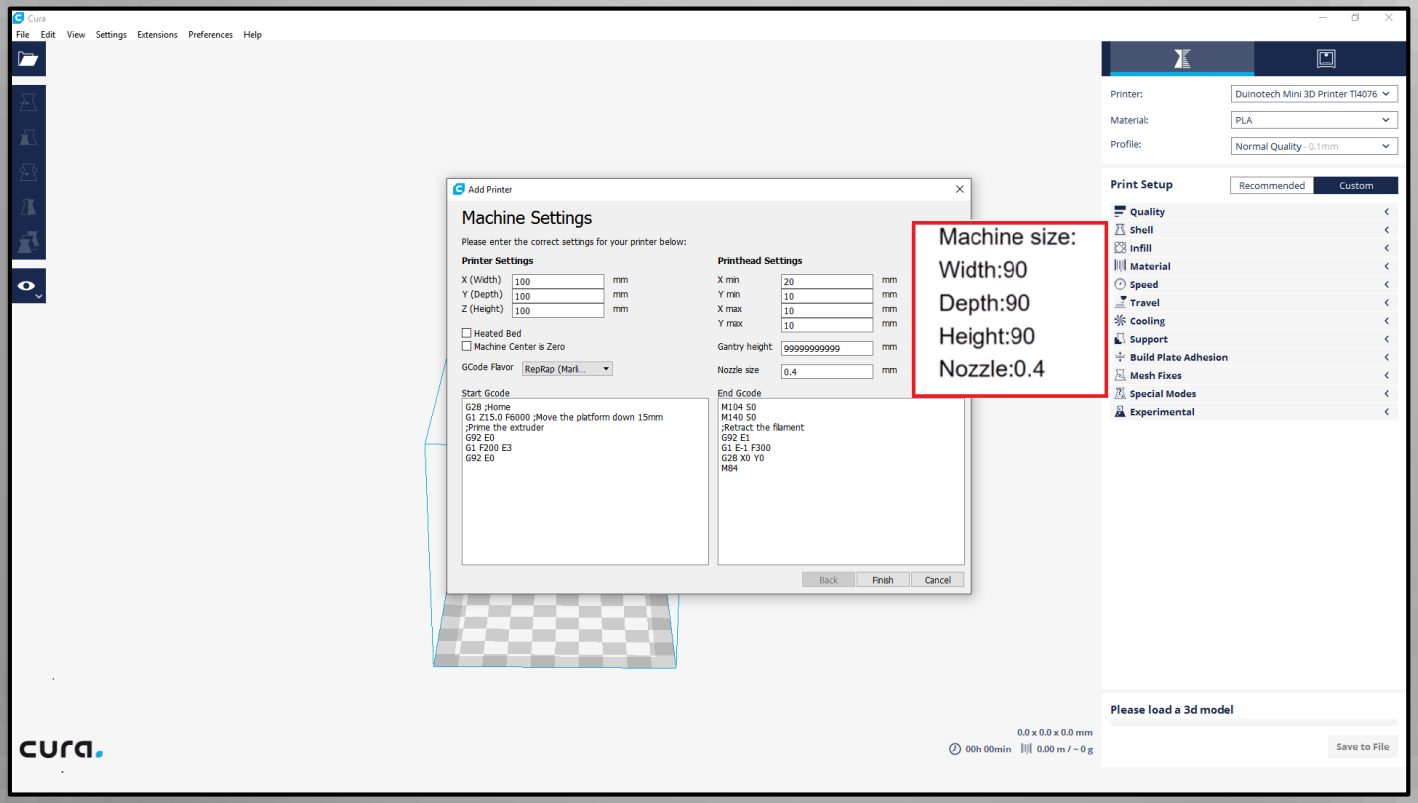
Now we want to input the dimensions of the printer and change the Start code and End code



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We are now going to edit the Start Gcode and End Gcode to the following.

Start Gcode

```
M104 S[first_layer_temperature] ; start extruder heat

G28 ; home all axes

G90 ; use absolute coordinates

G21 ; set units to millimeters

G92 E0

M82 ; use absolute distances for extrusion

G1 F5000 Z3 ; move to side of bed for priming

M109 S[first_layer_temperature] ; wait for extruder heat

G1 E20 F200 ; prime the nozzle

G1 E15 F500 ; retract

G1 F5000 Z10 ; move away from dump area

G1 F5000 Y45 ; move away from dump area

G92 E0
```

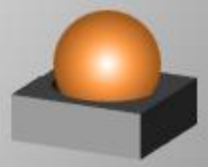
End Gcode

```
M104 S0 ; turn off extruder

M140 S0 ; turn off bed

G28 X0  ; home X axis

M84     ; disable motors
```



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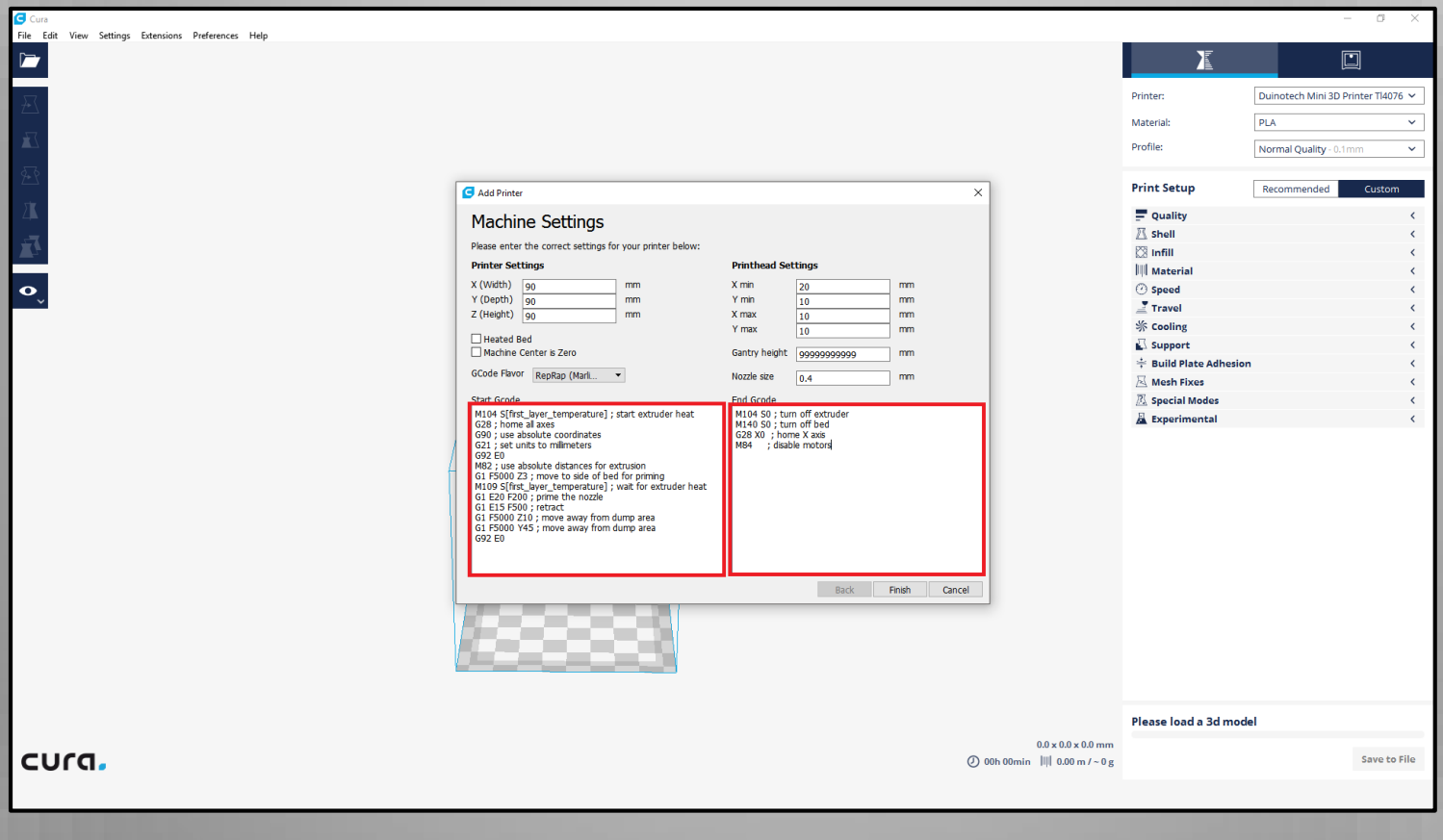
Once entered it will look like this



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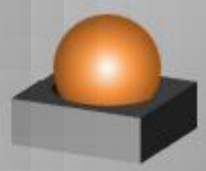
Now let's print. I will choose the Ghost that comes with the SD card. You can download this from http://www.thingiverse.com/thing:523193



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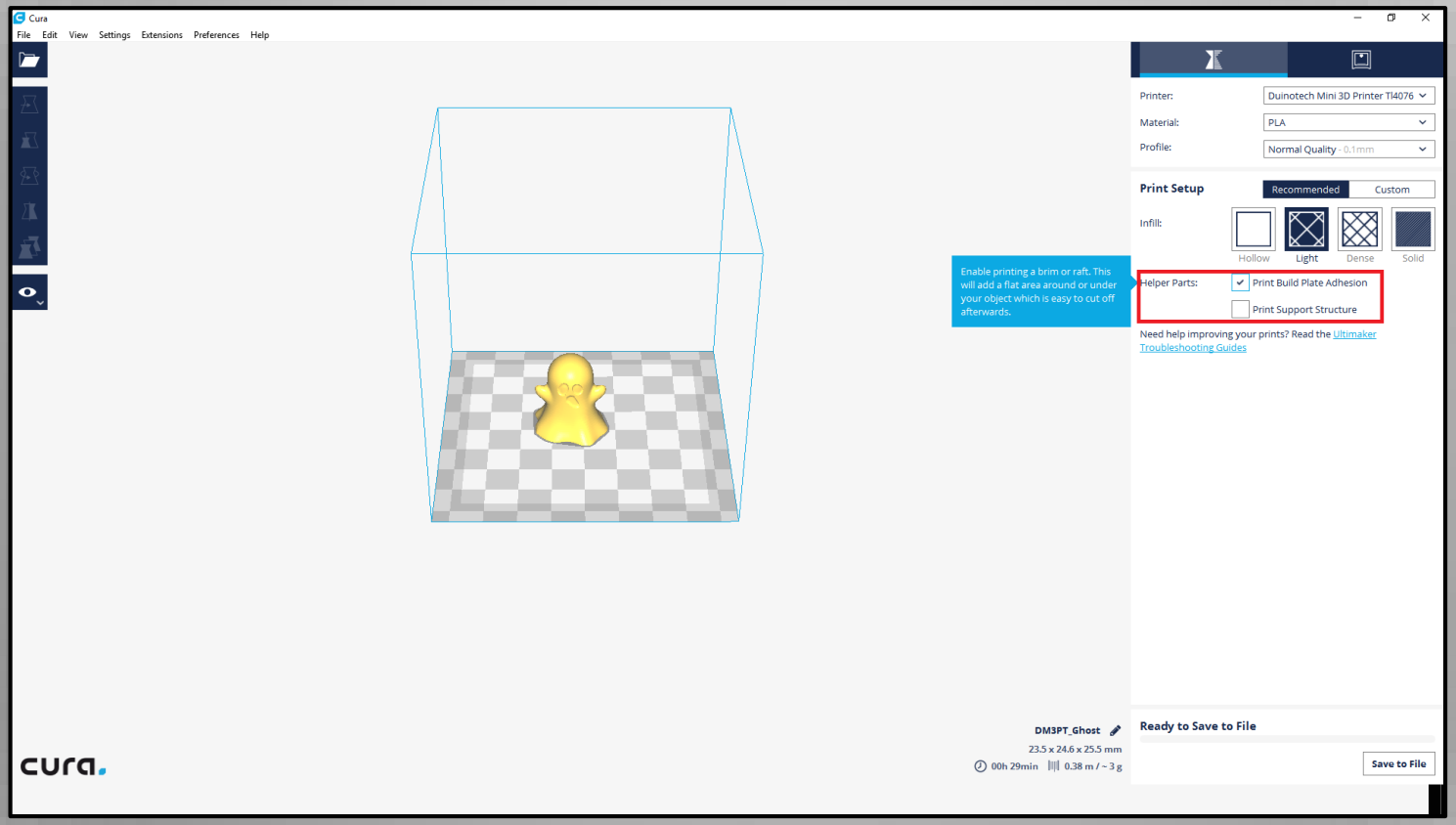
Once loaded you will see some options to help you



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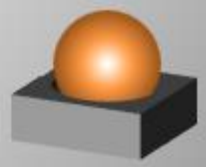
For example, Build plate Adhesion. Since TL4076 doesn't have a heated build plate this will help your prints stick with the help of our [Blue 3D Printer Bed Tape that we sell in 50m Roll CAT.NO: NM2818]



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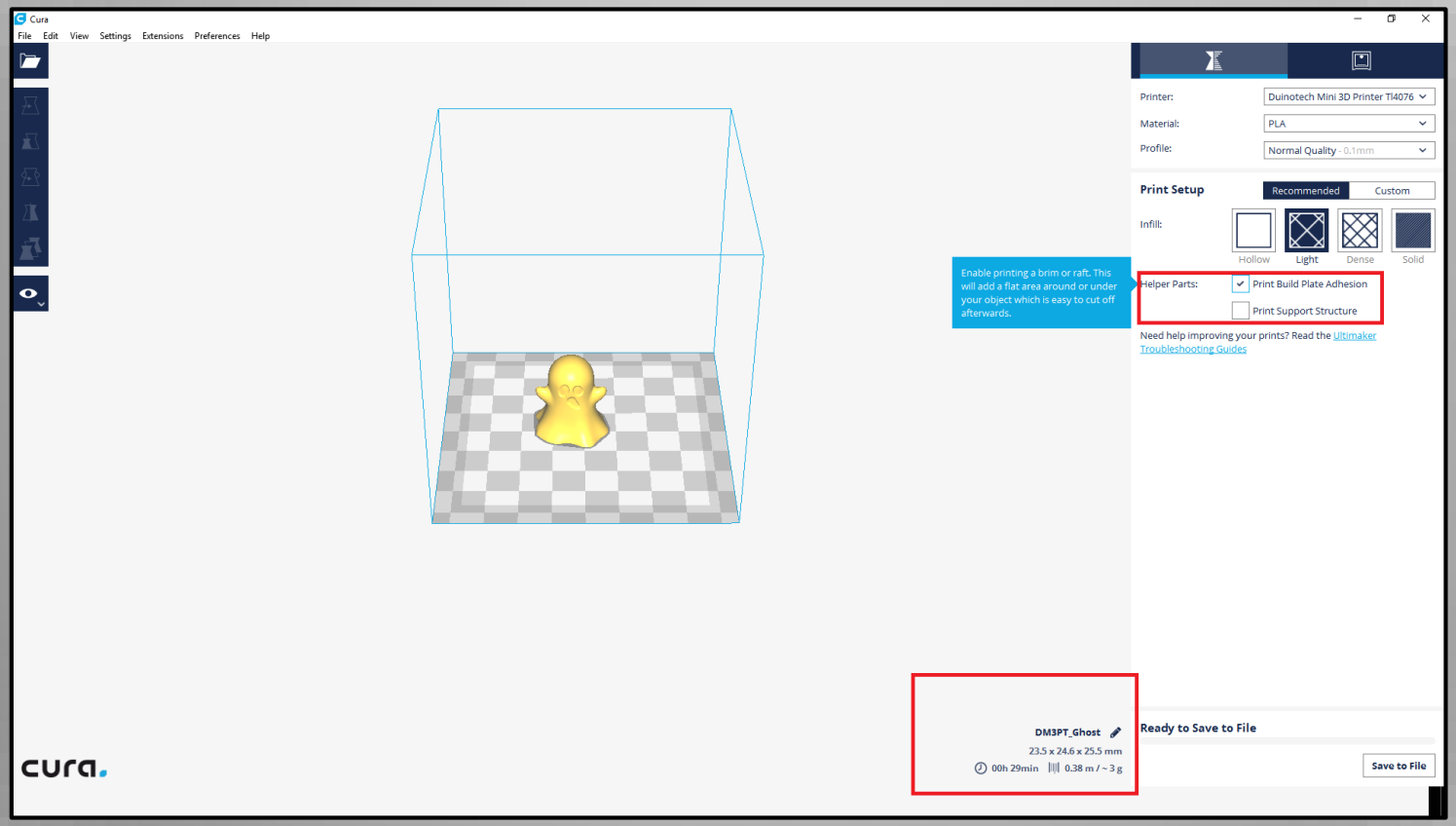
Cura will also give you more information like. Size, Print time, how much filament you will use and weight



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Explanation for key settings :

Quality

Layer height (mm) 0.1

1.Layer height: it's decide the accurate of printed object. The figure is bigger, then the print time is short,however the accurate will be lower, like you set 0.2mm or 0.3mm. If you set 0.1mm, then the accurate will be higher and print time will be longer.

Shell thickness (mm) 1

2.Shell thickness: it's the thickness of object shell, normally, seller will send 1-1.5mm. More thickness, than need more print time.

Fill

Bottom/Top thickness (mm) 1.2

Fill Density (%) 10

3. Bottom/Top fill thickness (mm): it's will decide your printed object bottom and top thickness.

4.Fill Density (%): If need your object more stronger, then you can put higher number, maximun is 100. For normal use is 30-50. More high fill %, then the print time will be more, and your model will be more stronger and heavy.

Speed & Temperature

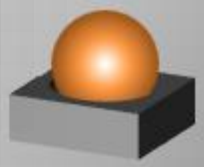
Print speed (mm/s) 45

5. Print speed (mm/s): it's decide your model accurate and time. Seller has been tested, if you want have good accurate then use 30-40 speed, if you want save time, can raise up to 50-70, but the accurate will be low, but save time. Therefore, this setting will be depend on the model you want.

Support

Support type None

6. Support type: if you want print the suspended object, then you need select the support. Select "everywhere", when you finish printing, it's will need time to clear the support.



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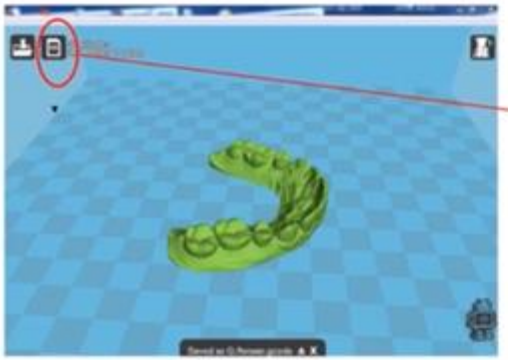
All that's left now is to print

SD card method for printer:

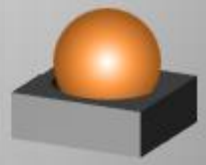
Saved to the SD



Copy Gcode to sd card

1. Slice the STL to be gcode in the CURA, and load it into SD card

2. Save the gcode to SD card from CURA. Insert the SD card to into the 3D printer, Connect printer by repeitor-host select the file you want to print.



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