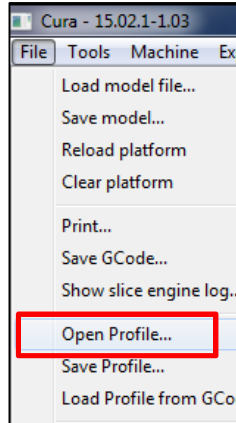


HOW TO USE THE TAZ 3D PRINTER

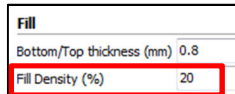
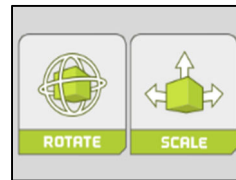
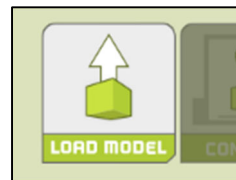
Prepare the printing software...

1. Start Cura with the icon on the desktop.
2. If prompted to "Select your machine":
 - a. Choose "Lulzbot TAZ 5"
 - b. Choose "0.5mm" nozzle size
 - c. On "Expert" menu, choose "Switch to full settings"
3. Click "File > Open Profile", then browse to W:\TAZ folder.
4. Choose a HIPS profile (fast, medium, or fine), then click [Open].



Load object in program...

1. Click [Load Model], then choose the STL file that you want to print.
2. To rotate or resize object, click object, then click [Rotate] or [Scale] buttons below.
3. Specify Fill Density (typically 10-20%).



5. Choose Support type of "Everywhere"



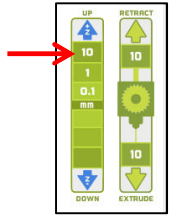
6. Turn on printer using both power switches.

Change filament (if needed)...

1. Click [Control] button.
2. Click [Connect] button, wait for top of window to show "Operational".
3. Click red [X] button, then green [Y] button.



4. Click green "10" button 4-5 times in the "Up" column.

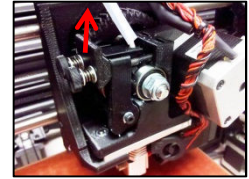


5. Enter 240 for "Temperature" field, then click [Set].



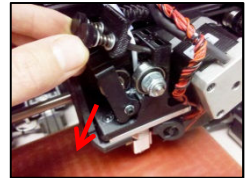
6. Wait for top of window to show "Temperature: 240".

7. Lift two spring-loaded screws, then rotate idler downward.

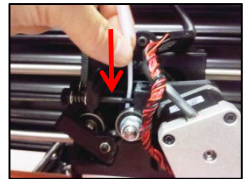


8. Pull-out filament slowly.

9. Insert new filament and push into extruder until new color comes out the nozzle below.



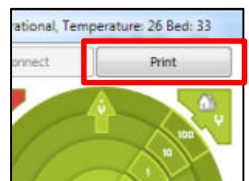
10. Rotate idler upward, then flip down spring-loaded screws to secure it.



11. Close control window.

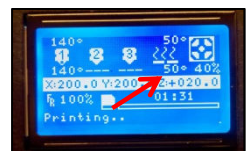
Start printing...

1. Click [Control] button.
2. Click [Connect] button, wait for top of window title to show "Operational".
3. Click [Print] button.
4. Do **not** close control window while printing!



After printing...

1. Wait until bed cools to 50 degrees. **This is important!**
2. Remove object with fingers or gently use putty knife to remove object.
3. Close Cura program.
4. Turn off printer.



NOTE: Do not apply Kapton tape, gluestick, nor acetone to print bed! Acetone will ruin it.