# HOW TO PRINT WITH RUBBER

Load/change the rubber filament…

1. Turn on printer using both power switches.
2. On printer panel (blue screen), push knob, choose Temperature > ABS/Ninja, then push knob again.
3. Wait for 2nd nozzle to fully heat (227 degrees)
4. After nozzle is <u>fully</u> heated, slowly turn large, black gear counter-clockwise to remove filament from green hole.
5. Insert new filament into green hole, then turn black gear clockwise until it oozes from the nozzle.

Prepare the printing software…

1. Start Cura with the icon on the desktop.
2. If prompted to "Select your machine":
   a. Choose "Modified TAZ 5"
   b. Choose "PEI" platform, "V2 Hexagon" hot end, and "FlexyDually V2" tool head.
   c. On "Expert" menu, choose "Switch to full settings"
3. Click "File > Open Profile", then browse to 3D > TAZ folder.
4. Choose a "NinjaFlex" profile:
   a. If printing rubber-only object, choose a "NinjaFlex rubber only" profile.
   b. If printing combined rubber and plastic object (dual extrude), choose a "NinjaFlex dual extrude" profile.
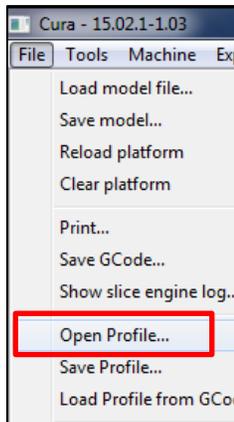
   Each of the above profiles above have "high speed", "medium quality", and "high quality" variants. Choose one, then click [Open].

To print rubber-only object…

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. Click [Control] button
4. Click [Print] button.
5. Do <u>not</u> close this window while printing!
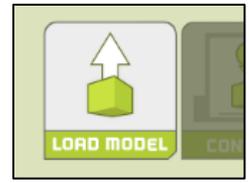
To print combined rubber and plastic object (dual extrude)…

1. Make sure plastic is loaded in the <u>black</u> hole and rubber is loaded in the <u>green</u> hole.
2. Click [Load Model], then choose the STL file for the <u>plastic</u> model that you want to print.
3. Repeat above for the <u>rubber</u> model that you want to print.
4. Right-click the <u>rubber</u> model, then choose "Dual extrusion merge" from the menu that appears.
5. Click [Control] button
6. Click [Print] button.
7. Do <u>not</u> close control window while printing!
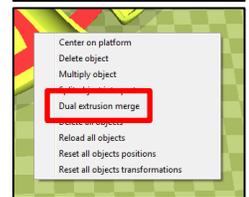
After printing…

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.

> **NOTE: Do <u>not</u> apply Kapton tape nor acetone to print bed! Acetone will ruin it.**