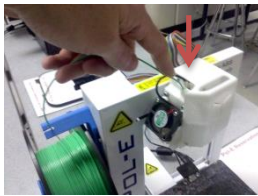


HOW TO USE THE UP! PLUS 2 PRINTER (POL-E)

Change filament if necessary...

1. If there is no filament on the spool holder or you want a different color, do the following:
2. If power light is off, flip-up power switch in back, then press front switch for one second.
3. Open "UP!" program by clicking icon on desktop, then choose "3D Print > Maintenance" from menu.
4. Click [Withdraw] button. After second beep, **slowly** remove filament by pulling from top of extruder.
5. Remove spool, then place another spool on holder (**ABS plastic only**). Click [Extrude] button, then insert filament after second beep. Apply slight pressure while filament loads to force-through possible hardened plastic inside nozzle.



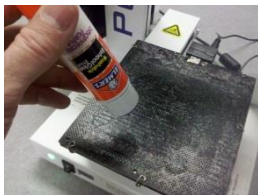
Check build plate

1. If build plate feels bumpy or has plastic stuck on it, unfasten spring clips around edges, **remove plate**, then use putty knife to scrape smooth both sides.
2. Reattach build plate. Ensure **all** spring clips secure build plate, otherwise plate may shift during printing.



Apply glue stick

1. Apply thin layer of glue stick before every print. This ensures that your part sticks to the build plate. This is especially important when printing large parts.

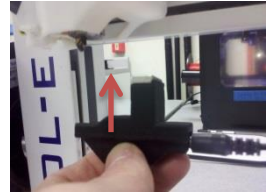


Level build plate if necessary...

1. Do this when parts are not sticking to build plate, filament jams during printing, or the plate seems higher on one side than the other:
2. Plug black cable into back of build plate.



3. Choose "3D Print > Nozzle Height Detect" from program menu. Wait for extruder to finish moving around.
4. Move plug from back of build plate to black leveling sensor, then snap sensor to bottom of extruder nozzle (it's magnetic).
5. Choose "3D Print > Auto Level" from program menu. Wait for extruder to finish moving around.
6. Remove leveling sensor from extruder nozzle.



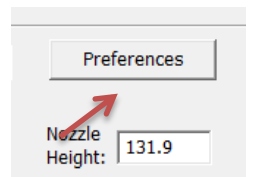
Load part in UP! program

1. Open UP! program by clicking icon on desktop.
2. Click [Open] button to locate your STL file.
3. Use buttons on toolbar to move, rotate, and/or scale your part.



Print part

1. If power light is off, flip-up power switch in back, then hold-down front switch for one second.
2. Click [Print] button in toolbar. If no raft is needed, place checkmark in "No raft" area.
3. Click [Preferences] button. If no supports are needed, click "Support > Area > Only Base" drop-down. To increase desired shells, choose "Part > Surface" drop-down. Choose desired infill in "Fill" area.
4. Click [OK] button to close "Preferences/Setup" window, then click [OK] button in "Print" window to begin printing.



After printing...

1. Unfasten spring clips around build plate edges, **remove plate**.
2. Use putty knife to **carefully** remove part.

