

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

Prepare the printer...

1. If power light is off, flip-up power switch in back, then press front switch for one second.



2. 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.



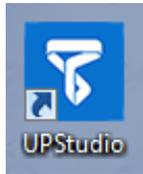
3. Reattach build plate. **Ensure all spring clips secure build plate**, otherwise plate may shift during printing.

4. Apply thin layer of glue stick. This ensures that your part sticks to build plate. This is especially important when printing large parts.



Load part in UP! program

1. Open "UPStudio" program by clicking icon on desktop.



2. After it loads, choose "Up" icon from left-side bar.



3. Choose "+" icon from left-side bar, then the "Add 3D Model" icon, then locate the STL file that you will print.

4. Use buttons on circular toolbar on right to rotate, move, scale, or flip your part.



Load filament (if necessary)

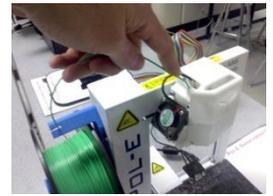
If there is no filament on the spool holder, do the following:

1. Choose "Maintenance" button on left-side toolbar.



2. Click [Withdraw] button from window that pops up. After second beep, **slowly remove filament** by pulling from top of extruder.

3. Remove spool, then place another spool on holder (**only use filament marked for "Up Plus"**).



4. Click [Extrude] button, then insert filament after second beep. Apply slight pressure while filament loads to force-through possible hardened plastic inside nozzle.

Print part

1. Click [Print] icon in left-side toolbar.



2. In "Print Settings" windows, choose "**0.2mm**" in "Layer Thickness" field for standard quality, 0.15mm for detailed prints (slower), or 0.25-0.40mm for faster prints.



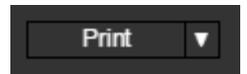
3. In "Infill" field, choose the first icon in the second row for the standard 20% infill.



Choose a denser icon for a stronger part.

4. If your part does not requires supports, place a checkmark in "No Support" field.

5. To begin printing, click [Print] button at the bottom of this window.



6. The printer will beep, take several minutes to warm up, beep again, then begin printing.

After printing...

1. **To avoid printer damage, please remove plate before removing your part.**



2. Unfasten spring clips around build plate edges, then **remove plate**.

3. Use putty knife to **carefully** remove part. The knife slips easily; do not cut yourself!



4. If your part has supports, wait for the part to cool completely to allow easy support removal.