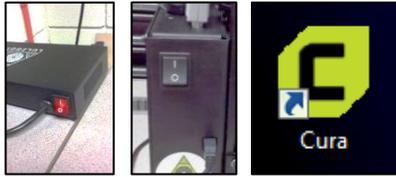# HOW TO USE THE TAZ 3D PRINTER

Starting the printer and software…

1. Turn on the printer using both power switches.
2. Start Cura with the icon on the desktop.

Choose the correct printer type…

1. From the top menu, choose Settings > Printer, then…
2. If you are printing plastic only, choose "LulzBot Taz 5 FlexyDually (plastic only)" from the menu.
3. If you are printing rubber only, choose "(rubber only)".
4. If you are printing combined plastic and rubber, choose "(dual extrude)".

Load object in program…

1. Click the folder icon on the left, then locate the STL file that you want to print.
2. To resize or rotate object, click object, then click [Scale] or [Rotate] buttons on the left.
3. If printing the object in plastic, click object, then [1] on the left.
4. If printing the object in rubber, click object, then [2] on the left.
5. If printing an item that uses both plastic and rubber, click either object, then select [1] or [2] for each object.
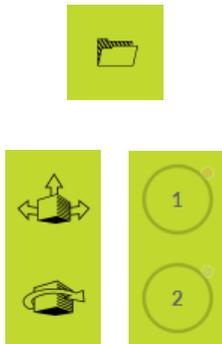
Adjust printer settings…

6. Choose [Extruder 1] at the top-right, then choose "ABS (Village Plastics)" under "Material".
7. Specify a print quality mode (Standard, High Speed, or High Detail) under "Profile" on the right. **Standard is recommended.**

Material		ABS (Village Plastics)	▼
Profile		Standard - 0.3mm	▼

8. If printing rubber, choose [Extruder 2] at top-right, then choose "NinjaFlex (NinjaTek)" under "Material".
9. Place a checkmark in "Generate Support" on the right if supports are needed.

Generate Support
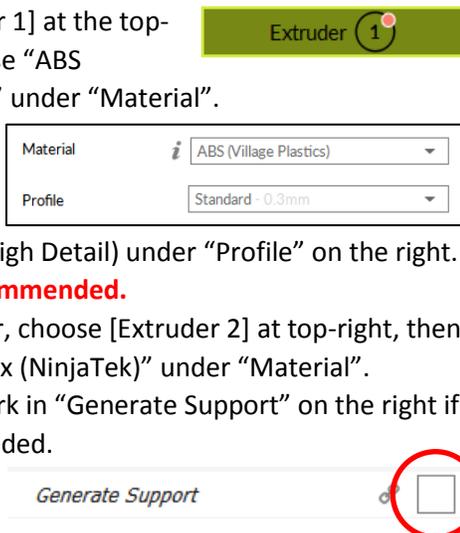
Change filament (if needed)…

1. On the printer's black control panel, push the knob to display the menu.
2. Turn the knob to highlight "Temperature", then push the knob to select.
3. If you are printing in plastic, highlight "Nozzle 1", press the knob, rotate the knob to "240", then press knob.
4. If you are printing in rubber, repeat the above steps, but choose "Nozzle 2" to heat it to 240 degrees.
5. Wait for the nozzle(s) to reach 240 degrees.
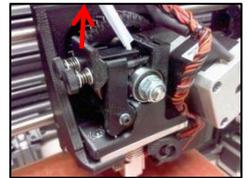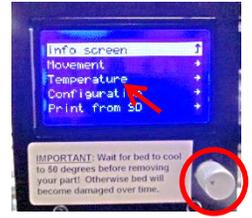
Load filament

6. Lift two spring-loaded screws, then rotate idler downward.
7. Pull-out filament slowly.
8. Insert new filament and push into extruder until new color comes out the nozzle below **(plastic filament goes in black hole and rubber goes in green hole).**
9. Rotate idler upward, then flip down spring-loaded screws to secure it.
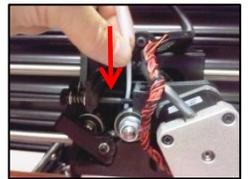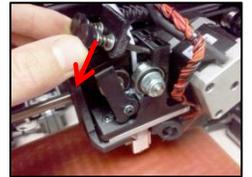
Start printing…

1. Click the down-arrow next to "Save to File" at the bottom-right.

   Save to File ▼

2. In the menu that appears, choose "Print via USB".
3. When "Print via USB" appears on the button, click it to start printing.
4. The printer begins heating the build plate and nozzle. When they are fully heated, printing will begin.

After printing…

1. Wait until bed cools to 50 degrees. **This is important to avoid warping and to allow easier part removal!**
2. Remove object with fingers or gently use putty or palette blade. **Be careful not to hurt yourself as the blade can slip easily.**