

Form 3B Printer at CLS Fab Lab_

Setting Up Job in Resin Printer

1. Open FormLabs PreForm 3.28.1 on a computer in Charlotte Latin School Fab Lab.
2. Open model file (either .STL or .OBJ).
3. Select type of resin (on right-hand side) that will be used (Durable) on the Form 3B printer.
4. Go to File→ Open. Bring file in. It will place the file in the virtual workplane.
5. Choose Printer Type (Form 3B for CLS).
6. Choose a durable resin v2.
7. Choose layer thickness (default is 0.100 mm; or 0.050 mm).
8. Choose print settings. Use defaults.
9. Type in a job name.
10. Hit “Apply”.
11. On right side of screen, verify “Printability”. This should be green in color.
12. On left side of screen, click on orange “Start A Print” button.
13. Select a printer; this should be selected based on material type.
14. Choose “select”.
15. Then “Upload Job”.
16. Go to printer to confirm that the build plate is clean and locked.
17. Follow on-screen prompts to get the print started.

After Job Is Complete

1. Pull the entire build plate out.
2. Open the washer and slide the entire build plate onto the ledge.
3. Start washer for a twenty-minute cycle (for the Durable resin).
4. When the wash cycle is finished, put on disposable gloves.
5. Carefully pry the print job from the build plate.
6. Place print job (alone) in curing machine for sixty minutes.

7. Remove print job from curing machine.

Setting Up Job in Resin Printer

1. Go to printer and clean build plate then lock it in
2. Then hit “Prime”
3. Follow the steps provided ie, locking build plate and opening vent
4. Open FormLabs PreForm 3.28.1 on a computer in Charlotte Latin School Fab Lab.
5. Under “Job Setup” select “LearnedFish” Printer preset
 - a. Settings are Form 3B, Durable V2, and layer thickness of 0.100 mm or 0.050 mm
6. Open model file (either .STL or .OBJ).
 - a. Go to File→ Open. Bring a file in. It will place the file in the virtual workplane.
7. Orient the model for the best printability
8. On the right side of the screen, verify “Printability”. This should be green in color.
9. On the left side of the screen, click on the orange “Start A Print” button.
10. Select a printer; this should say “LearnedFish” since it’s already been configured
11. Then “Upload Job”.
12. Go to printer to confirm that the print is running
13. Wait until step 5 of the checking process

After Job Is Complete

1. Pull the entire build plate out
2. Press “Open” for the washer and slide the entire build plate on the ledge
 - a. If not using the basket, please remove basket and place it on some paper towels
3. Start washer for twenty-minute cycle
4. Once wash cycle is finished, put on disposable gloves

- a. If the build plate is still sticky, the wash didn't cover the entire print. Fill more alcohol into the wash and re-wash the print
5. Carefully pry the print job from the build
6. Place print job (alone) in curing machine for sixty minutes
7. Wash the build plate with alcohol and put it back into printer