

Unloading Filament

Click the printer's knob and open the main menu. Go to **Unload Filament**, then select the filament type loaded into the printer.(PLA, ABS, or TPU, typically)

Wait for the extruder to heat; the Prusa i3 will heat to the correct temperature for your material. It will beep when the extruder has reached the temperature.

Follow the instructions on screen and pull out the filament.



Loading Filament

Grab a new spool of filament from the storage bag. Unwind a length of the filament and straighten it as much as possible. Cut the filament tip with flush cutters to have a clean end.

Open the printer's **LCD Menu** and go to **Preheat**. Select the filament type you want to load and wait for the extruder to heat up. (PLA, ABS, or TPU, typically)

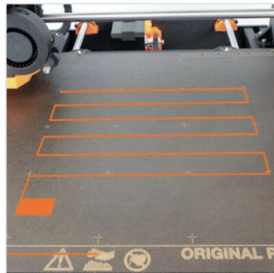
When the extruder is hot, go to **Load filament** from the main menu. Push the cut end of your filament roll into the hole at the top of the extruder. The IR sensor should detect the filament and the motor will push it through the hot-end.

Follow the onscreen prompts. If the filament has not extruded correctly, or you want to extrude more, ask it to continue.

First Layer Calibration

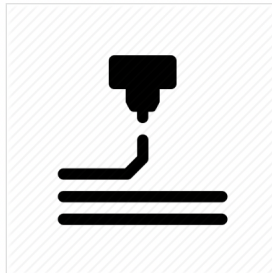
Prusa published a number of great calibration articles:

Articles



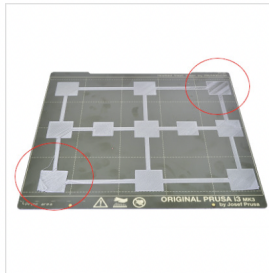
First Layer Calibration (i3)

Calibration > Basic calibration



Extrusion multiplier calibration

Calibration > Advanced calibration



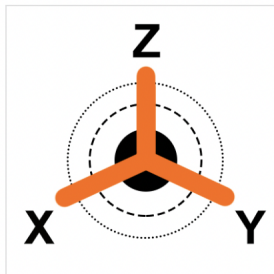
Bed Level Correction

Calibration > Advanced calibration



Linear Advance

Calibration > Advanced calibration



XYZ Calibration (MK3/MK3S/MK3S+)

Calibration > Basic calibration



Live adjust Z

Calibration > Basic calibration



Mesh bed leveling

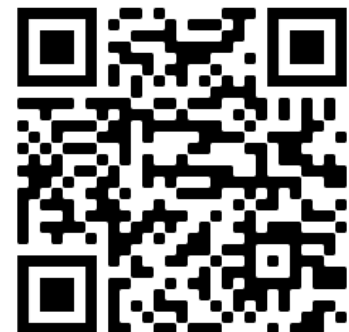
Calibration > Basic calibration



Extruder linearity correction calibration

Calibration > Advanced calibration

Try the **First Layer Calibration** if your print is not sticking well to the plate, or if the first layer is too thin.



Prusa Calibration Guides:

https://help.prusa3d.com/tag/mk3s-2/calibration_199

How to Print a File

Use the **Prusa Slicer** software and **export your G-CODE** for the i3 MK3S+. Add supports, if you need them. Make sure your print material in Slicer matches the material in the machine. Save your GCODE file to the SD card.

Remove any remnants of previous prints, and clean the build plate (alcohol wipe) if it looks greasy.

Load your material onto the machine. (**Unload Filament** and **Load Filament**)

Run the **First Layer Calibration** if you want to make sure the z height is set correctly.

Print your file: Select **Print from file** in the main menu on the printer.

Stay with your print for the first 15-30 minutes, or until the first few layers have completed, to be sure it is printing correctly. If the build height seems off, quit the print and re-rerun the first layer calibration.

Check on your print a number of times over the first 1-2 hours, if it is a longer print. At that point it is ok to let it run unattended.

