

# Operating Procedures

1. Launch Cura version 4 (blue icon)
2. From connected printers, select IW-Ultimaker3
3. Select File → Open Files → Open desired project (.STL file type)
4. Using task bar on the left hand side, position model as desired
5. From print settings, select slice height, infill percentage, and support
6. Support can be generated using either nozzle, typically nozzle one holds build material with nozzle two printing with dissolvable support material.
7. Setting can be fine tuned using the “Custom” option from print settings
8. Within custom settings, nozzle and build plate temps can be adjusted (build plate temps should be based off of build material)
9. Save the file from Cura on a thumb drive
10. Connect thumb drive to printer → select desired file → select print

Note: Adjusting settings may lead to more (OR LESS) successful prints. Contact Workshop Wizard responsible for Ultimaker if print fails or knowledge of advanced settings is desired.

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