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### **Ultimaker 3 Extended**

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# **Safety Concerns**

- Both print heads and bed are heated during operation. Do not attempt to clean, remove, or adjust without allowing for adequate cool down time.
- Keep hands clear of printer during operation. Pause print before clearing or adjusting print.

### **Safe Operating Procedures Review**

- 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 ether nozzle, typically nozzle one holds build material with nozzle two printing with dissolvable support material.
- 7. Setting can be fined 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.

## **Post Processing**

- If support was constructed from ABS carefully break away with pliers
- If support was constructed from PVA soak part in warm water for several hours to dissolve support structure

#### **Maintenance**

- Bed should be cleaned with IPA between prints
- Print heads and silicone head protector should be cleaned as needed
- Filament should be dried before use if printer has been idle for several weeks
- Bed leveling should be completed every time print cores are swapped
- Print cores should be swapped after clog or to change print line width. Used print heads should be kept for spare parts

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Last update: 2020/08/18 18:20

