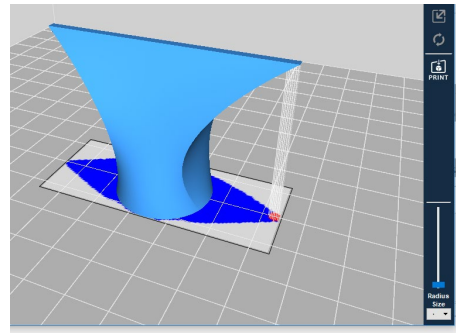
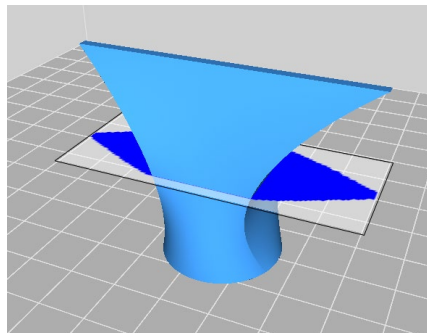
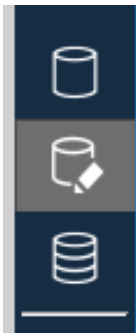


## How to print a part with the 3DWOX1?

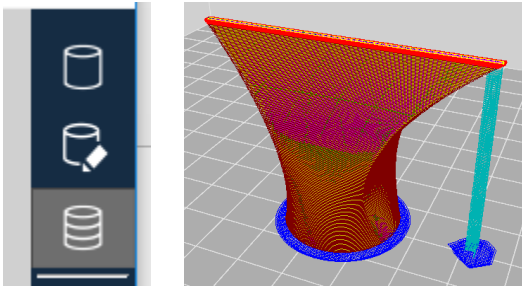
- 1) Make a part in SolidWorks
- 2) Export the part as an STL (using "save-as" and selecting the stl filetype)
- 3) Download 3DWOX Desktop from [Downloads | Sindoh 3D Printer | Unmistakable Sindoh](#) or use a campus computer
- 4) Import (or drag and drop) the STL file into the 3DWOX Desktop slicer app window
- 5) Under “**Settings**” --> “**Printer Setting**”, set the selected printer to “**3DWOX1**”
- 6) Under “**Mode**”, check if you’re in the “**Advanced**” or “**Easy**” mode.
  - a) If in **EASY** mode:
    - i) Under Settings, set Material in Cartridge 1 to PLA
    - ii) Choose placement of support (None, Touching Buildplate, or Everywhere)
    - iii) Choose the Support Pattern or leave it in the default “Zigzag”
    - iv) Select from one of the four Quick Print Profile options and hit OK
  - b) if in **ADVANCED** mode:
    - i) set Profile in Settings to “**Sindoh PLA**”
    - ii) Chose the desired support type and bed adhesion
    - iii) Adjust other settings (as needed) and hit OK
- 7) (Optional) Edit support material with the “**Support Edit Viewer**” (cylinder with pen icon): select the radius size and click in the darker blue part shadow to place support material. (Only add support if needed)



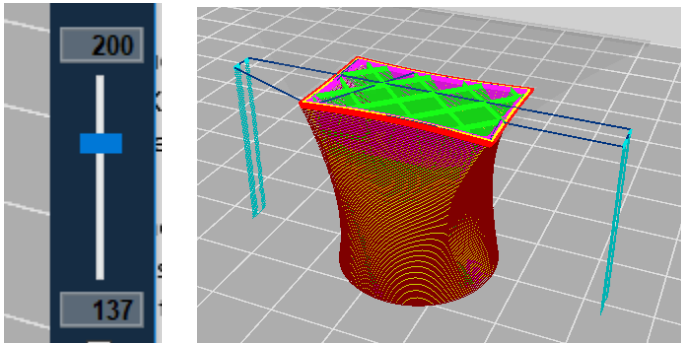
3DWOX Desktop icon



- 8) Build layers with the “**Layer Viewer**” (multi-layered cylinder icon) – this compiles the G-code



- 9) Use the slider to view individual layers and travel paths



- 10) Click “**File**”-->“**Save G-Code**”.
- 11) Put the G-Code on a thumb drive.
- 12) Use the touchscreen to load filament (if needed) under the “**FILAMENT**” option, following on-screen instructions.
- 13) Put thumb drive into the printer’s usb port (front side , upper-right of printer)
- 14) Using the touch screen, select “**Print**”, select your file, and follow on-screen instructions to start the print.
- 15) Watch the first 2 layers to make sure the PLA adheres properly to the bed.
- 16) Come back after the part has finished, remove the flexible print bed from the printer. Allow the part time to cool.
- 17) While the part is cooling, use the touchscreen to unload filament under the “**FILAMENT**” option, following on-screen instructions, and removing the cartridge so the printer is ready for the next user.
- 18) Flex the bed to pop the part free from the surface. Avoid prying or peeling the part off the bed, especially with a hot bed to limit adhesive separation between bed and bed sheet.

**Note:** If you arrive to the printer with a finished print that isn’t yours, there is an extra print bed that can be swapped with the one that has a part on it. Set aside to allow recently printed part time to cool.