

UP Box+ / UP Studio print procedure.

To use this guide follow the steps numerically not pictorially. If you are having problems or unsure find a technician.

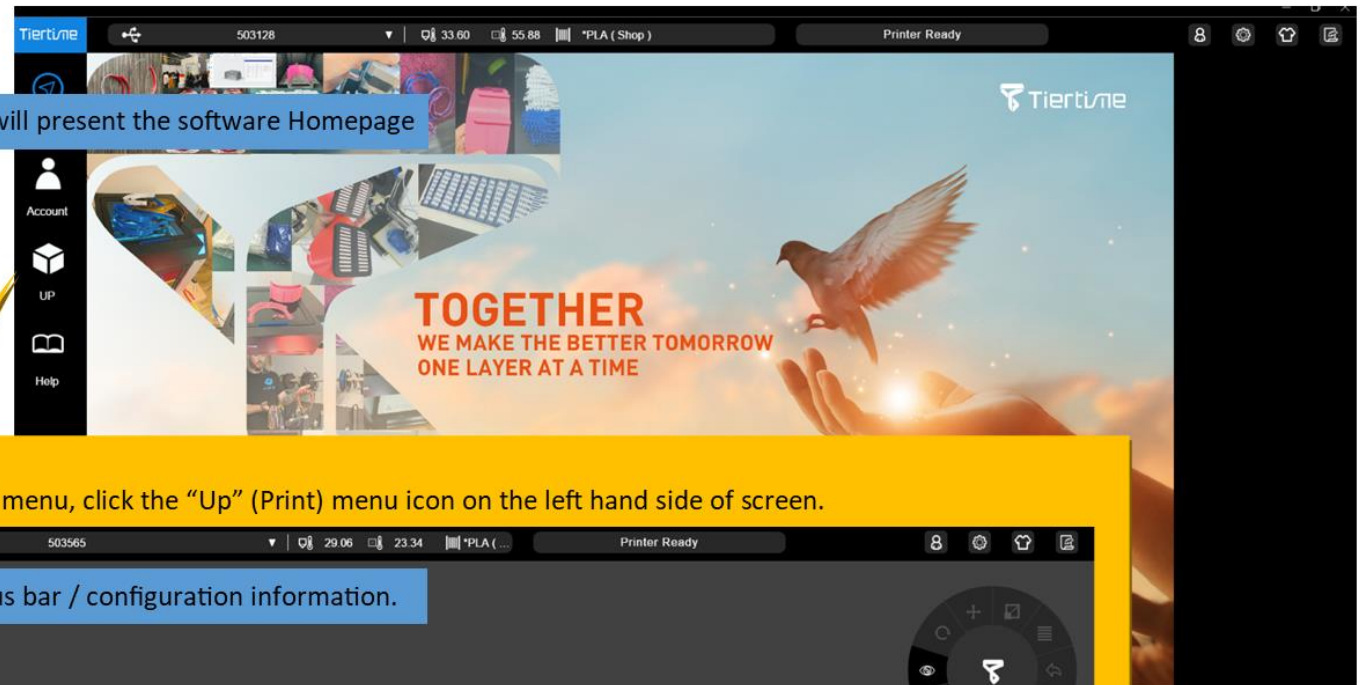
Step 1.

Switch all the switches on the switch box in front of the PC to the **off** position.





Opening "Up Studio" will present the software Homepage



Step 2.

From the "Homepage" menu, click the "Up" (Print) menu icon on the left hand side of screen.

Back to Homepage

Add / Insert model

Print

Initialise

Calibration

Maintenance

Printer status bar / configuration information.

Model adjustment wheel

Build space

Step 3a.

Find the large number on the front left of the door of the printer you want to use. Switch the switch with the matching number above it on the switch box to the on position. The red light for that number should come on. Wait 5 seconds before proceeding to the next step.



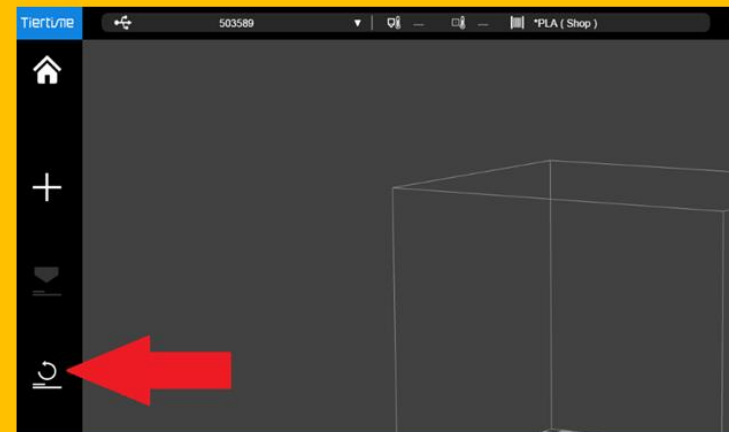
Step 3b.

Check that the serial number displayed on at the top of UP studio matches the serial number on the yellow labels on the printers front and sides. If it doesn't try another printer or find a technician.



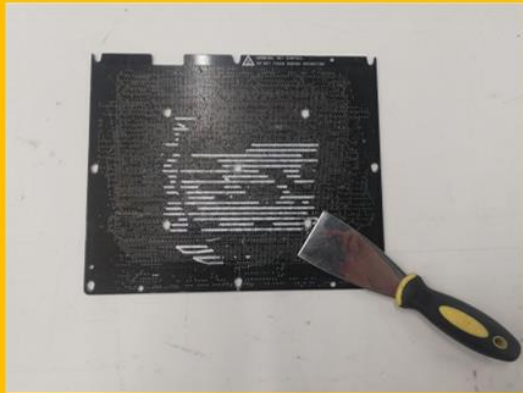
Step 4.

Click the initialize button to Initialize the printer.



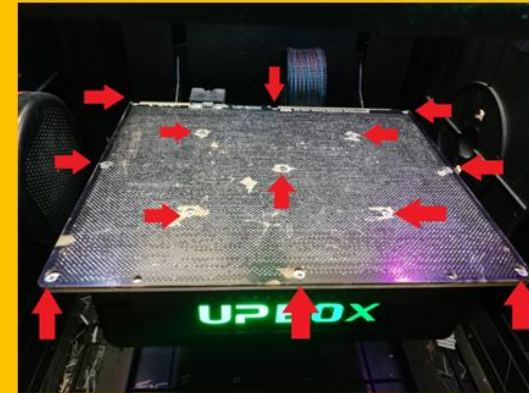
Step 5.

Remove the build plate and check that it is clean and free from any protruding plastic on the front and back of the plate. If no build plate is present on the printer spare plates are located at the cleaning station as well as the scraper used for cleaning the plates.



Step 6.

Fit the build plate to heater bed in the printer. This will require a firm push to get it to seat and lock correctly. Check that all locking screws sit flush with the build plate. If any screws are not flush with the plate this will cause calibration issues and print failures.



Step 7.

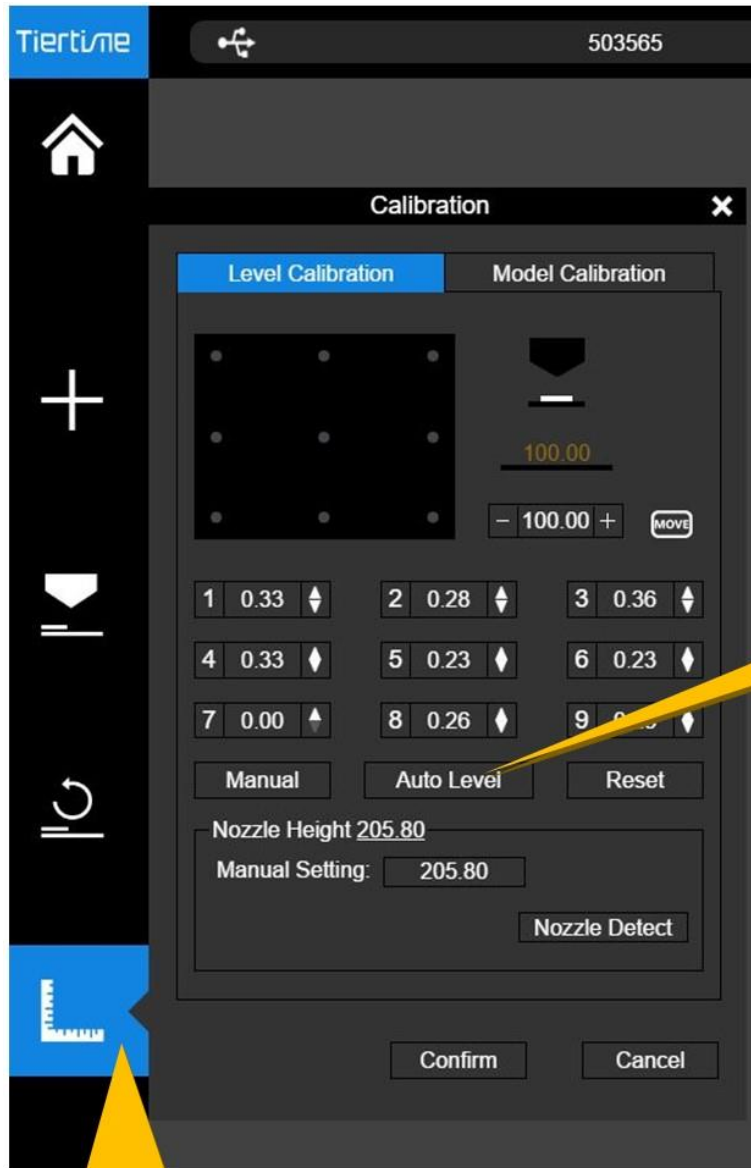
Fit two clips to the front of the plate and heater bed to prevent plate from coming free. Spare clips are located in the boxes beside the printer PC's.



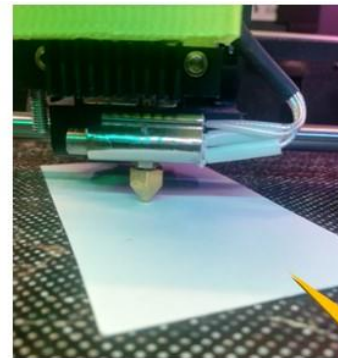
Step 8.

Check there is no filament protruding from the nozzle. If present this must be cleaned away using side cutters as it will give a false nozzle height reading and cause print failures.





Step 9.
Select the Calibrate sub-menu

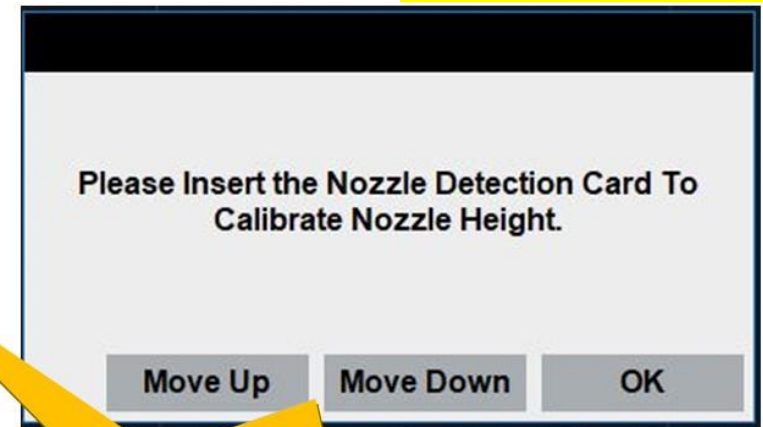


Step 10.
Run the "Auto Level" routine. The "Nozzle Height Detect" routine automatically follows.

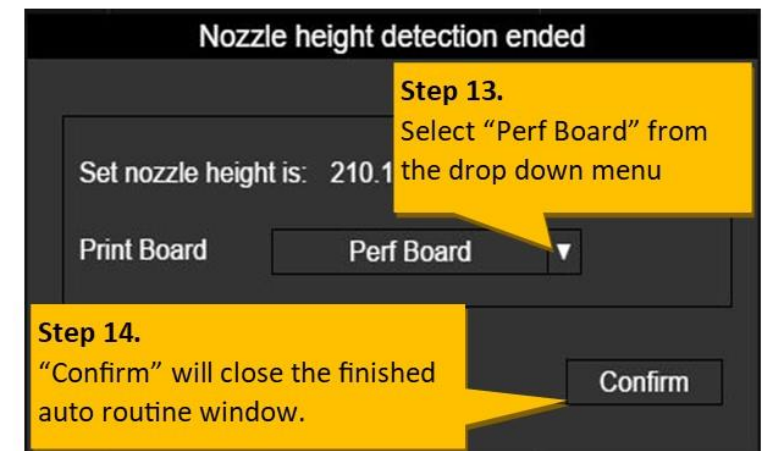


Step 11.
Wait while the Auto Level and Nozzle Height Detect routines complete.

Control of the software will be lost during these routines (it has not crashed), it will return once complete.



Step 12.
Use a business card from the box beside the printer PC and insert it between the nozzle and the build plate (as shown in picture). Click Move Up (closer) to raise the build plate or Move Down (further away) to lower the build plate until the business card can move between the nozzle and build plate with a light tight resistance. No resistance or having to force the card under the nozzle is not correct. Click OK when done.

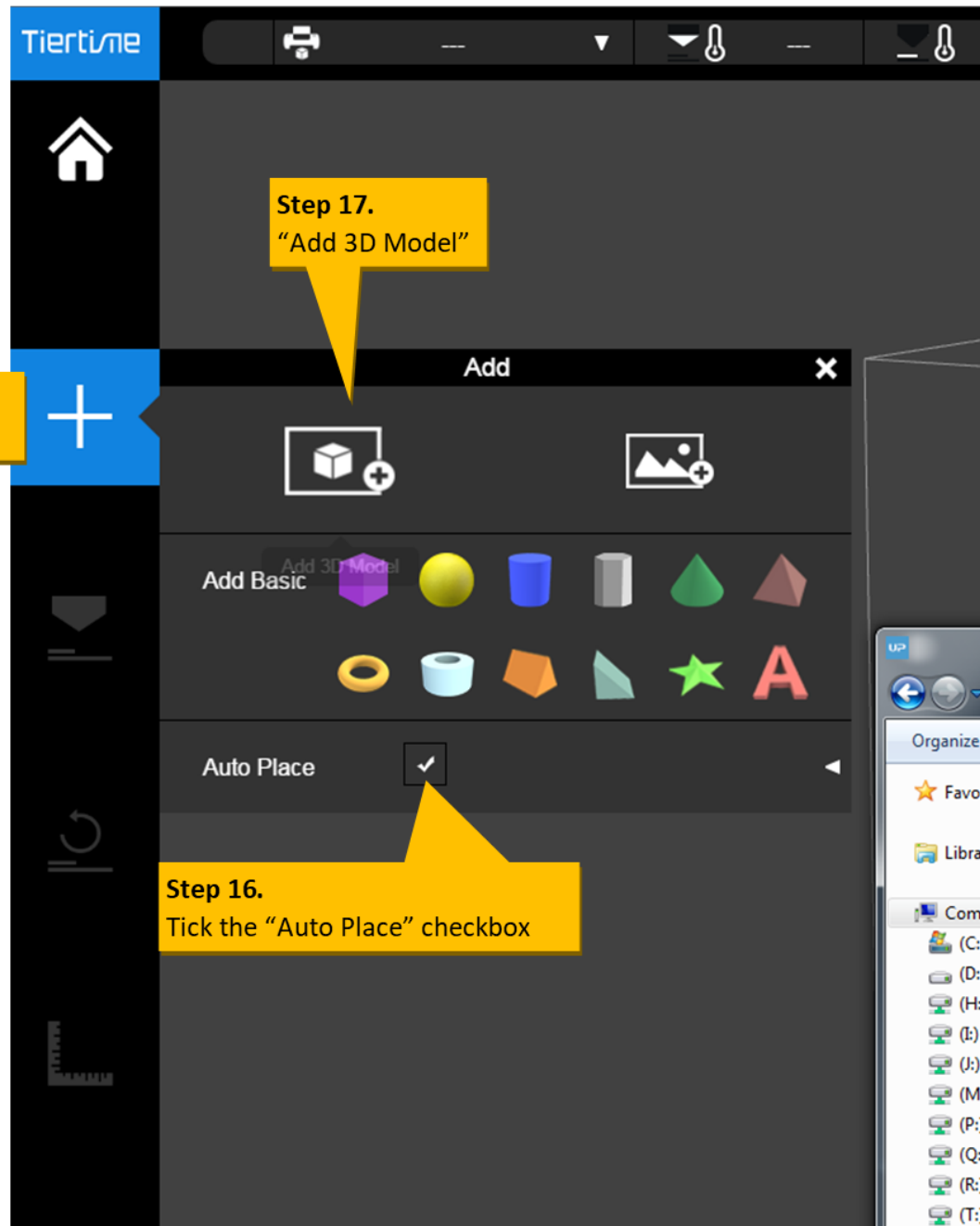


Step 13.
Select "Perf Board" from the drop down menu

Step 14.
"Confirm" will close the finished auto routine window.

Follow steps numerically not pictorially.

Step 15.
Select the Add / Insert sub-menu



Step 16.
Tick the "Auto Place" checkbox

Step 18.
Browse for & select your .stl, .3mf, .obj, .up3, .tsk or .okk model

NB: Perf Board set in Step 13

Step 21

Check the Nozzle Diam: setting matches the size listed on the info label on the front of the printer.

Step 24.

Preheat the platform by setting a time and then click the "HEAT" icon (15 minutes min). You do not need to wait the full time you can carry on with further steps and it will preheat in the background. By the time you are ready to press print the platform will be at temperature.

Step 19.

Select the Maintenance sub-menu

Step 25. Press close to confirm your choices.

Step 23.

Click "Extrude" to load your filament into the head.

NB: The nozzle will take a few minutes to heat up.

Ensure no filament protrudes from the nozzle after the extrusion has finished (Ref Step 10).

Step 22

"Withdraw" any old filament present in the head. Skip this step if no filament is left in the head.

DSDN104 can skip this step as the filament is preloaded for your projects.

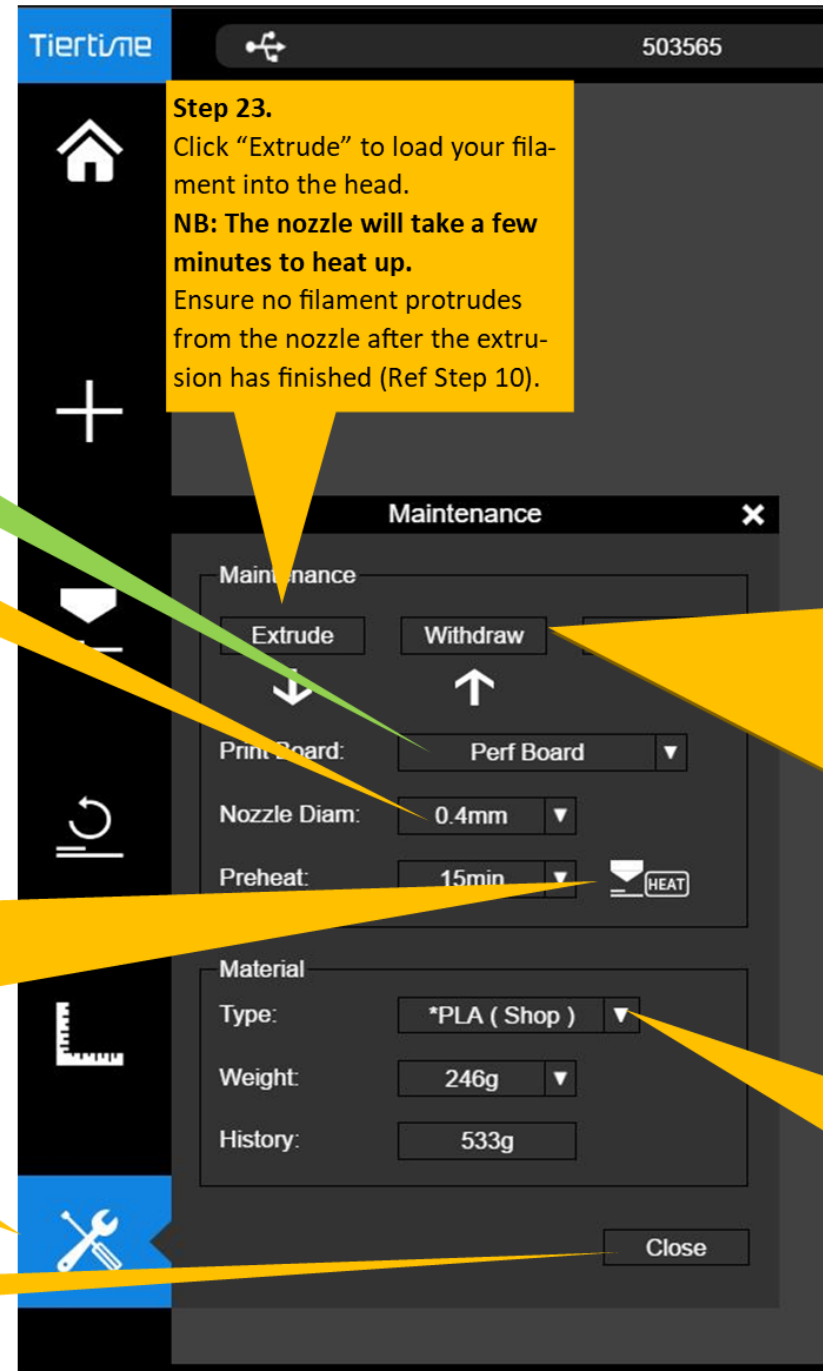
NB: The nozzle will take a few minutes to heat up.

When heated, gently pull the filament out of the head. You should see the wispy end of the filament that has been down inside the heater. This must come all the way out to avoid blockages.



Step 20.

Check filament type is the same as the type you are using, if not change it to the correct type. If unsure refer to Filament Temperature Tables and How to Load Filament Settings guide on the back page (page 9).



Step 26.
Select the Print sub-menu.

Step 27.
Set Z "Layer Thickness" (0.25mm is mid range for 0.4mm nozzles
0.35mm is mid range for 0.6mm nozzles)

Step 28.
Choose an infill density appropriate to your model. These are 8 separate buttons.

Step 29.
Normal "Quality" recommended

Step 30.
Open "Preferences" Menu by pressing double arrow button

Step 31.
"Sleep" powers down printer on completion. (It will idle for 2 minutes then drop to amber).

Step 32.
"Easy to peel" will make removing raft and support material easier.

Step 33.
"Print"

Step 34.
Once you are happy the print is underway correctly you can log off from the PC.

Other annotations:
 - "Ignore 'Nozzle offset' options" (pointing to Nozzle offset dropdown)
 - "'Unsolid Model' selected by default." (pointing to the checked box for Unsolid Model)

ABS				
Filament type	Nozzle temp	Platform temp	Supplier	Note
ABS			Tiertime	Pre-set by supplier—Not Recommended.
ABS+			Tiertime	Pre-set by Supplier— <u>Do not use on ABS machine.</u>
PLA			Tiertime	Pre-set by Supplier— <u>Do not use on any machine.</u>
TPU			Tiertime	Pre-set by Supplier— <u>Do not use on ABS machine.</u>
*ABS (Shop)	260	100	Resource Centre ABS	Recommended.

PLA & TPU				
Filament type	Nozzle temp	Platform temp	Supplier	Note
ABS			Tiertime	Pre-set by Supplier— <u>Do not use on PLA machine</u>
ABS+			Tiertime	Pre-set by Supplier— <u>Do not use on any machine</u>
PLA			Tiertime	Pre-set by Supplier—Not recommended.
TPU			Tiertime	Pre-set by Supplier—Not recommended.
*PLA (Shop)	220	60	Resource Centre PLA	Recommended.
*WOOD (Shop)	230	60	Resource Centre PLA Wood	Recommended.
*TPU (Shop)	220	50	Resource Centre TPU (Flexible)	Recommended.

Filament Temperature Tables and How to Load Filament Settings.

If you are not seeing the **(Shop)** filaments listed or a red **Unknown** is showing in the material type setting you will need to import the filament settings into the software follow the steps below to do so.

1. Open “Maintenance” menu.
2. Click arrow beside filament type selection box.
3. Click ‘Customised’ option, to open Customized Material box.
4. Click “Import” button.
5. Find the folder “UpPrinter Filament file” on the **P:** drive in the following location **P:\Workshop** and double click to open. (normal windows file navigation)
6. Highlight the “UPBOX Filament settings 2024.fmd” file and Click “Open” button.
7. Click “Exit” button. The correct filament settings should now be available to you.

