

# 3D Printing Tips

## All Users

- 1) A level bed and build platform is crucial to good prints.
- 2) First layer height is especially critical to success and the nozzle should just barely touch the build platform when at the z-home position.
- 3) The filament spool should feed filament freely. Watch for tangles and other problems with the filament spool while printing.

## PLA Users

- 1) Shut-off extruder temp as soon as finished printing using pronterface by clicking the off button. Leave printer plugged in to keep extruder fan rotating.
- 2) Use blue painters tape for best adhesion on the build plate
- 3) To lubricate the nozzle and prevent blockages, every filament change or start of a new roll put a few drops of canola oil into your hot-end.

## ABS Users

- 1) Spraying the build plate with hair spray (Aqua Net – Extra Super Hold) liberally before printing helps parts stick and helps prevent part warpage.
- 2) Another option to help parts stick is to use Kapton tape on your build plate.