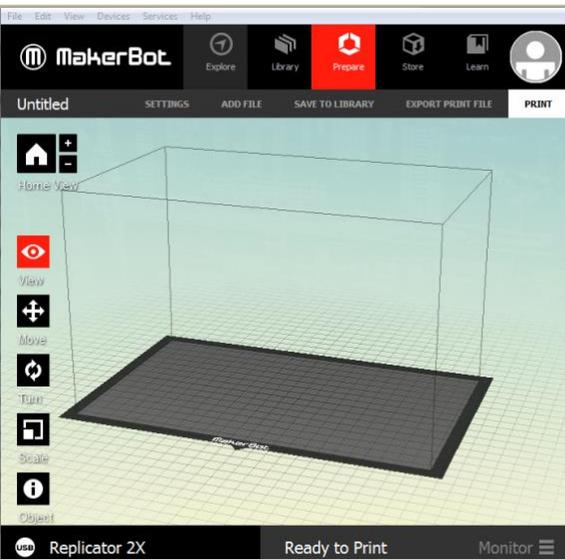


MAKERBOT REPLICATOR 2X



SETUP

You've decided that you want to 3D print something. Whether you made it in Solidworks or imported it from thingiverse, we suggest to have the file ready in a ".stl" format (".thing" also works). If a bot is available check to see if there is adequate filament loaded for your print, especially for larger prints. If there isn't an appropriate amount filament, you can load another spool (at this time, you can also specify a color). To unload and reload filament, on the Makerbot menu go to "Utilities"-> "Change Filament" and then specify whether you want to unload or load the right or left extruder. Follow the instructions on the screen. Furthermore, if the plate isn't level you can level it by selecting "Utilities" -> "Level Build Plate" and following the instructions. Preferably, use a piece of paper to ensure that the head is just above the plate for each of the checkpoints. Ensure the Kapton tape is not shredded; replace if it is. Once ready, you can start to print. Load up Makerbot Desktop.



MAKERBOT DESKTOP

Open or add your ".stl" file. Use the "Move," "Turn," and "Scale" options to orient the part (you may need some guidance by a worker). Carefully consider large build angles, tricky geometry, and circles. Under "Object," select the appropriate extruder that corresponds with your chosen color. Go to "Settings" and decide on a raft, supports, and plastic. The Advanced Options provide for resolution, infill, and temperature settings. You can then insert an SD card and hit "Export Print File" and save as an ".x3g"

THE WAITING GAME

Once the file is on the SD card, you can insert it into a Makerbot and then select "Build from SD." Now commence waiting. Some prints can take hours based on the size. After exporting the file, Makerbot Desktop should have given you an estimate of the mass and the print time. Be prepared for failure due to warping, extrusion blockage, or miscellaneous factors unbeknownst even to the Makerbot Gods.

Tech Specs

Build Volume:
9.7"W x 6.4"L x 6.1"H

Print Tech:
Fused Filament
Fabrication

Layer Height Settings:
High: 100 microns
Med: 200 microns
Low: 300 microns

Positioning Precision:
X and Y axes: 11 microns
Z axis: 2.5 microns

Filament Diameter:
1.75 mm

Nozzle Diameter:
0.4 mm

Dimensions:
w/o Spools-
49x32x38 cm³
w Spools-
49x42x38 cm³

Weight:
27.8 lbs [12.6kg]

More info here:



[Makerbot Manual](#)

http://download.makerbot.com/replicator2x/MakerBot_Replicat or2X_UserManual_Eng.pdf