

Prusa S1S & CW1

Important, read before using!

- Be careful when handling resin!
- Use safety gloves when instructed!
- Always have a clean paper wipe ready!
- IF you spill resin, clean it immediately with IPA!

Slicing

In order to print your model, you must follow these steps:

- Slice the model using PrusaSlicer in FabLab
 - Import your 3D model in .stl form.
 - Pick the resin profile according to your chosen resin.
 - Remember to choose the right printer profile!
 - Export the G-code onto an USB flash drive.
- Tips for slicing:
 - **Layer height** has the largest effect on details and printing time.
 - 0,05 mm is usually recommended.
 - Rotate your models so that there are no surfaces parallel to the build plate.
 - You can also use PrusaSlicer's auto rotate function.
 - When printing delicate models, you can reduce the tips of the **supports**.
 - When printing bigger and less detailed models, you can use a longer **exposure time**.
 - Reduce spent resin by **hollowing** your models in PrusaSlicer.
 - **Add a breathing hole on the build plate side and a draining hole on the other side!**

Printing

- Turn on the power by pressing the button in front of the printer.
- Insert your USB stick.
- **Make sure that the build plate and the vat are clean!**
- Open the lid and insert the build plate.
 - Tighten the build plate by turning the black screw
- Place the Vat on the screen.
 - screw in the long silver screws on the ends of the vat.
- Choose your file to be printed and follow the instructions on the screen.
- When it's time to pour the resin:
 - Shake the resin bottle gently.
 - Place the protective tray on the vat.
 - Look at the measuring lines on the wall of the vat when pouring the resin. Don't overfill the vat!
- Remove the tray and close the lid.
- Start printing.

Post processing

- Open the lid and place the protective tray on the vat.
- **Put a glove on your left hand.**
- Loosen the black screw.
- Grip the build plate with your left hand.
- Take the lid of the washing bucket with your right hand.
- Press the button on the lid and slide the build plate under the lid.
- Place the lid back on the bucket.
- **Throw away the glove.**
- Lift the bucket on the curing & washing machine.
- Start the wash. The machine beeps when the wash is completed.
- Lift the lid onto the empty bucket.

- Lift the washing bucket back between the curing & washing machine and the printer.
- Take the empty bucket to the sink and rinse the prints and the build plate with hot water.
- Return all the things to the printing station.
- Detach the build plate from the lid and clean the build plate with isopropyl alcohol.
- Place the print on the turntable of the curing & washing machine and close the lid.
- Choose curing mode. Press and hold the knob to change the mode:
 - If your print is still wet, use drying mode.
 - If your print is dry, use the curing mode.
- **If no one is using the same resin right after you:**
 - Empty the vat into the right resin bottle.
 - **Use the funnel with the filter!**
 - Clean the vat with dish soap and hot water.
 - **Be careful not to damage the surface of the film on the bottom of the vat!**