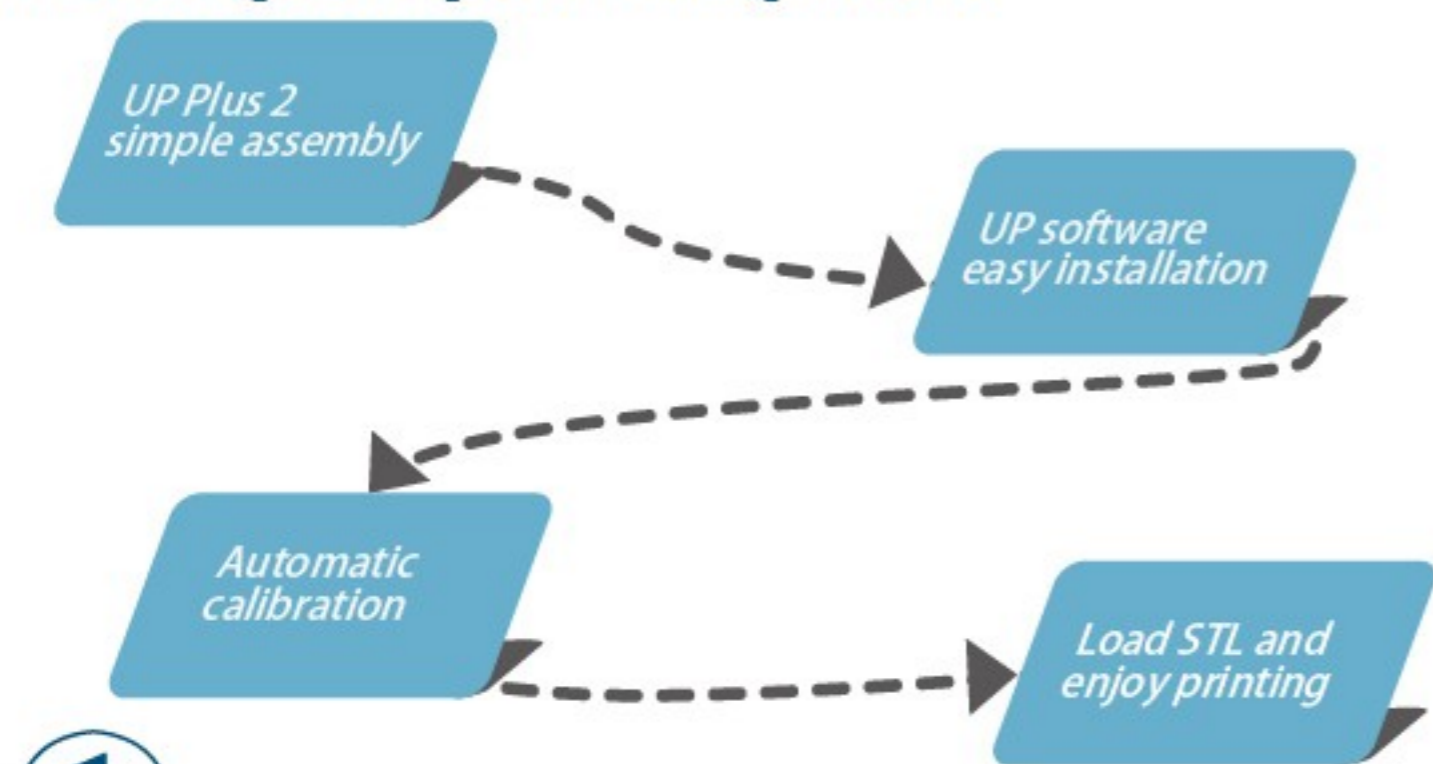


UP Plus 2 Quick Start Guide

Highlights

UP Plus 2 introduced automatic table leveling calibration, and nozzle height calibration, and brought much easier 3D printing experience to 3D printing community.

UP Plus 2 operation procedure for quick start:



1 Open the box

Open your UP Plus 2 3D printer box, and you should find one machine, and a box of accessories.



- a. ABS
- b. USB cable
- c. Power adapter (19 V)
- d. Pen Knives
- e. Clip
- f. Platform Level Calibration
- g. Screws
- h. Filament tube
- i. Roller Shaft
- j. Cellboard 3.5mm
- k. Nozzle wrench
- l. Hexwrench
- m. Cable
- n. Pliers
- o. Shovel
- p. Tweezers
- q. Gloves

Accessories:



2 Prepare to print

A. Remove clips

Two yellow "Remove me" stickers on the machine mark the positions of two clips that are needed to be removed.

- a. Clip at print head:
The clip at print head is to avoid possible damage to the print head during shipping.

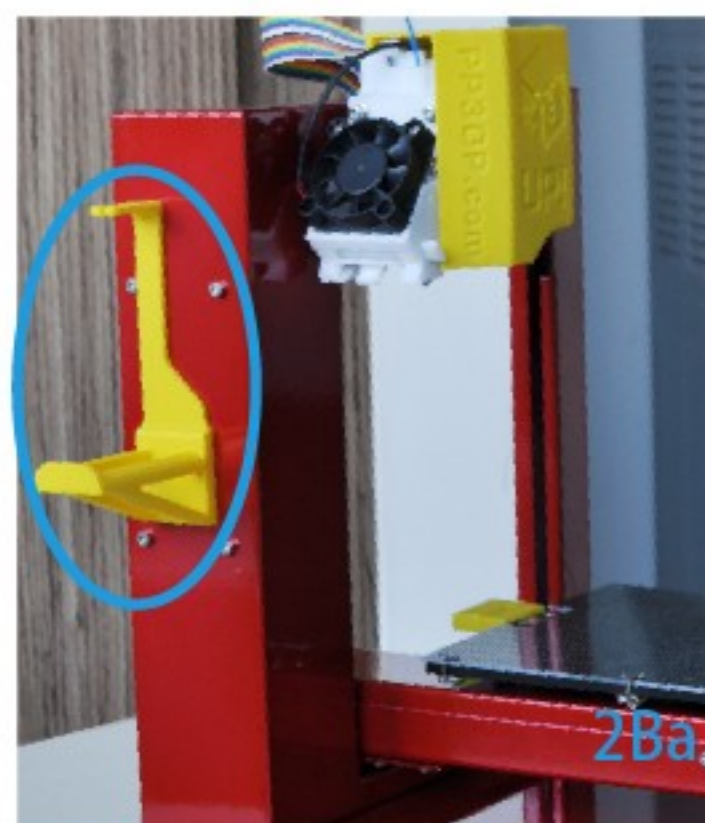


- b. Clip at print table:
The clip at print table is to protect table from unnecessary shift during shipping.



B. Install the machine

- a. Install spool shaft:
Spool shaft is one of the machine's accessories. You will find a square hole on the left side of the machine, and you can insert the spool shaft into the hold.



- b. Secure cellboard or perfboard:
You can find the latches on the print table. Twist the latches to position beneath the table, place the perfboard at the center of table, and then twist the latches upward to secure the perfboard.



- c. Connect the printer with power, and USB wire with a computer.

3 Installation of UP software and driver

Please find the UP software at our website, <http://www.pp3dp.com/> main page-> download -> software section.

Mac: Double click the UP Mac Setup.pkg icon. Follow the prompts through the installation. The drivers will be added and the UP software will be installed into the Application folder.

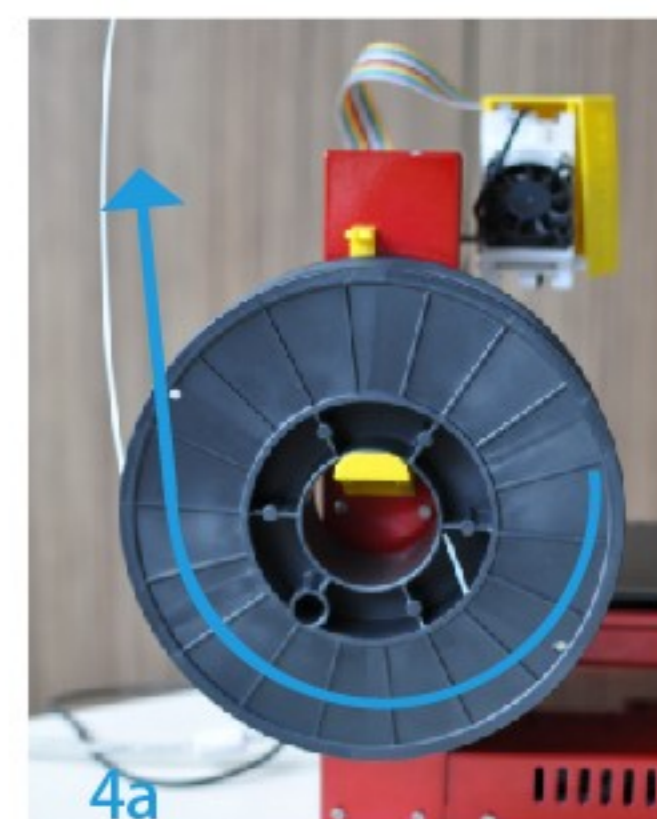
Windows: Double click the UP 3D Printer Setup.exe file and install it to the specified directory, *Program Files\UP*.

Follow the instruction in the installer to be sure the drivers and software are all in place before connecting the UP 3D Printer to the PC when prompted to do so. For installation on Windows XP, you will need to manually specify the driver location, *Program Files\UP\Driver*.

For more details of this process, please see the User's manual.

4 Load ABS material

- a. Put material spool on the spool shaft.
Please pay attention to the direction of the spool wire.



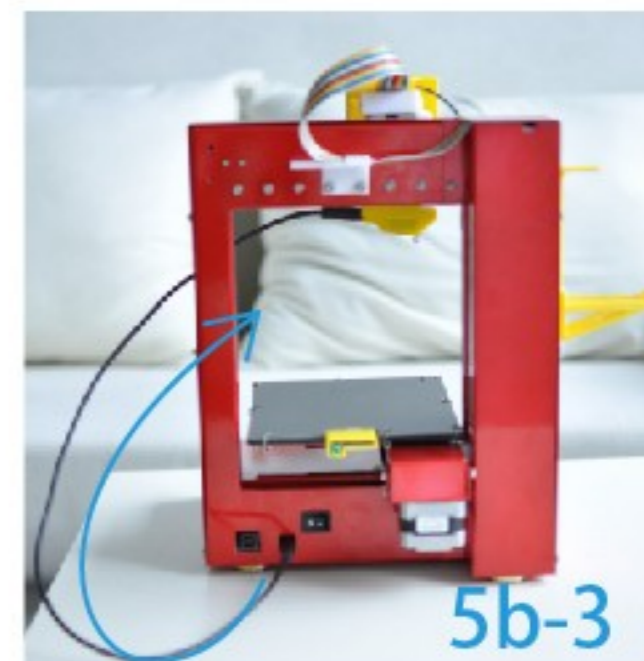
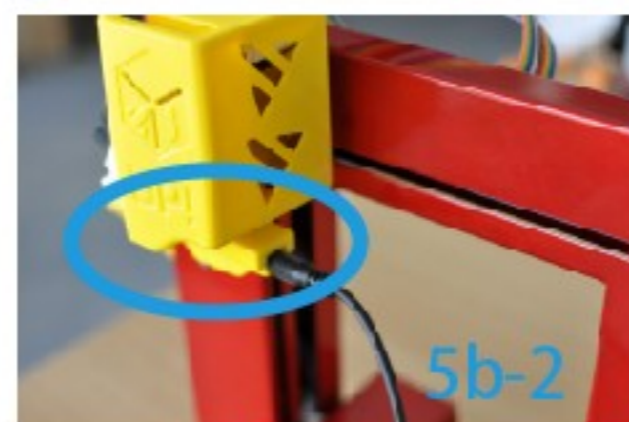
- b. Lead one end of the ABS wire through the spool shaft opening on the top, through the wire tube (accessories), and then insert it into the filament orifice on top of the print head.



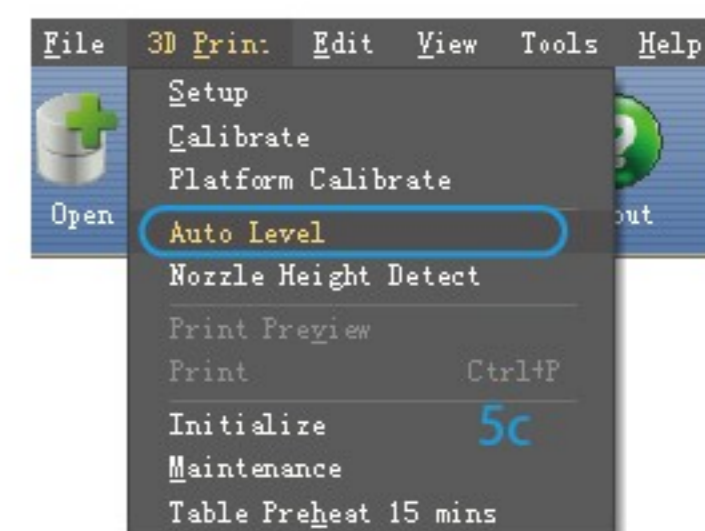
- c. Run the UP software
In UP software, find the command in the menu "3D Print" -> "Maintenance", and "Extrude" in the Maintenance Dialog. After the temperature reach 260 degrees Celsius, the machine will give off a beep. You can then press the filament wire until the print head starts extruding ABS out of the nozzle tip.



- b. Install the calibrating wire. Insert one end of the wire into the platform level calibrator, and the other end in the back of the machine. Please pay attention to the calibrating wire location.



- c. Click UP software by the menu "3D Print" -> "Auto Level"



- d. Print head will touch the perf board at 9 different locations, and the software will automatically compute the leveling of the print plate. You can then calibrate the nozzle height.

5 Calibrate

Note:

1. Before calibration, you should secure a new perfboard on the print table.
2. First calibrate print table leveling, then nozzle height.

A. Print plate leveling calibration

- a. Stick the table level calibrator on the print head. Table level calibrator is part of accessory.

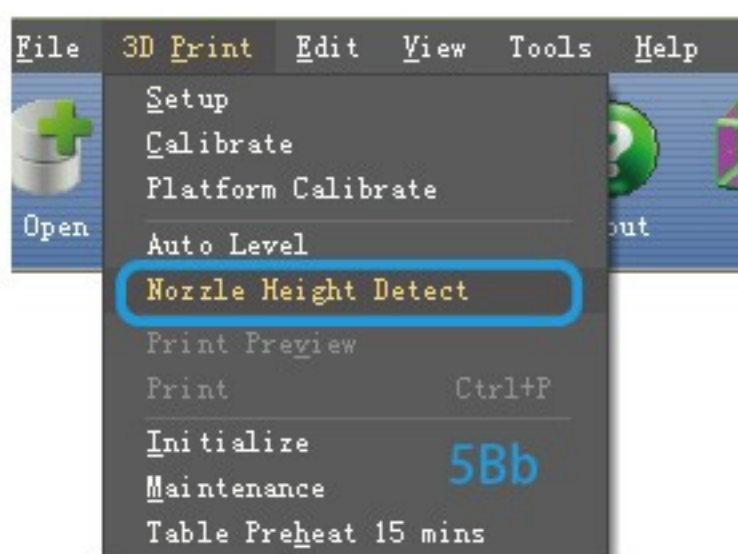


B. Nozzle height calibration

- a. Install the calibrating wire with one end in the nozzle height calibrator, and the other end in the back of the machine.



- b. Click UP software by the menu "3D Print" -> "Nozzle Height Detect"



- c. Print table will rise slowly, and nozzle touch the nozzle height calibrator. The software will automatically calculate the nozzle height, and display the height in a popup dialog.



6

After you finish all the easy steps mentioned above, the UP printer is ready to work. You can load any STL files, and start printing. Enjoy!

For more information, please see the UP Plus 2 3D printer User's Manual!