

Using the Fortus 3D Printer

- Turn the printer on if it is not already, remove any previous prints, and then make sure an empty build plate is installed. Close the door.
- Open Insight on the left-hand computer.
- Open your STL by going to File > Open...
- Confirm the unit dimensions if asked.
- Click the Orient button (second icon in the upper left corner of the window). Select an orientation you want and click a corresponding surface on the part.
- In the Modeler Setup panel, choose the options for interior fill, support style, etc. that you want. Clicking the icon of the printer brings up further options.
- Click the green flag to do all processing steps on your part.
- Open Control Center.
- Click [Insert CMB] and find the folder named `ssys_YourPartName` and select the `.cmb` within.
- Add any additional `.cmb` files as needed. Layer heights must be the same for all models in a single pack.
- Place the model on the build plate as desired. If reusing an old build plate, choose a fresh surface if possible. Start from the edges if using a fresh plate. The edge of the plate with the handle corresponds to the bottom of the build window.
- Name the pack using the **format TeamName_PartName**, then fill out the 3D printer log (link located on the desktop).
- Back in Control Center, click [Build Job].
- On the Fortus printer's front panel, press "Start Model".
- After the print is done, remove the build platform.
- Remove the part from the build plate. Flexing the plate can be helpful. Be careful, as the support material can be sharp.
- If necessary, place the part in the large caustic bath to remove any support material that does not come off by hand. Wear gloves when handling parts, as it is a lye solution! You have been wearing goggles the whole time you're in the wet lab, so we don't need to remind you again here, *right?*

- After the support material has been dissolved, remove the part and rinse it with water in the sink.