



PRUSA SL1

- **LCD Shadow Masking DLP**
- **Build Volume: 120 x 68 x 150**
- **Layer Thickness: 0.025 mm – 0.1 mm**
- **Material: 405nm Resin**



SAFETY

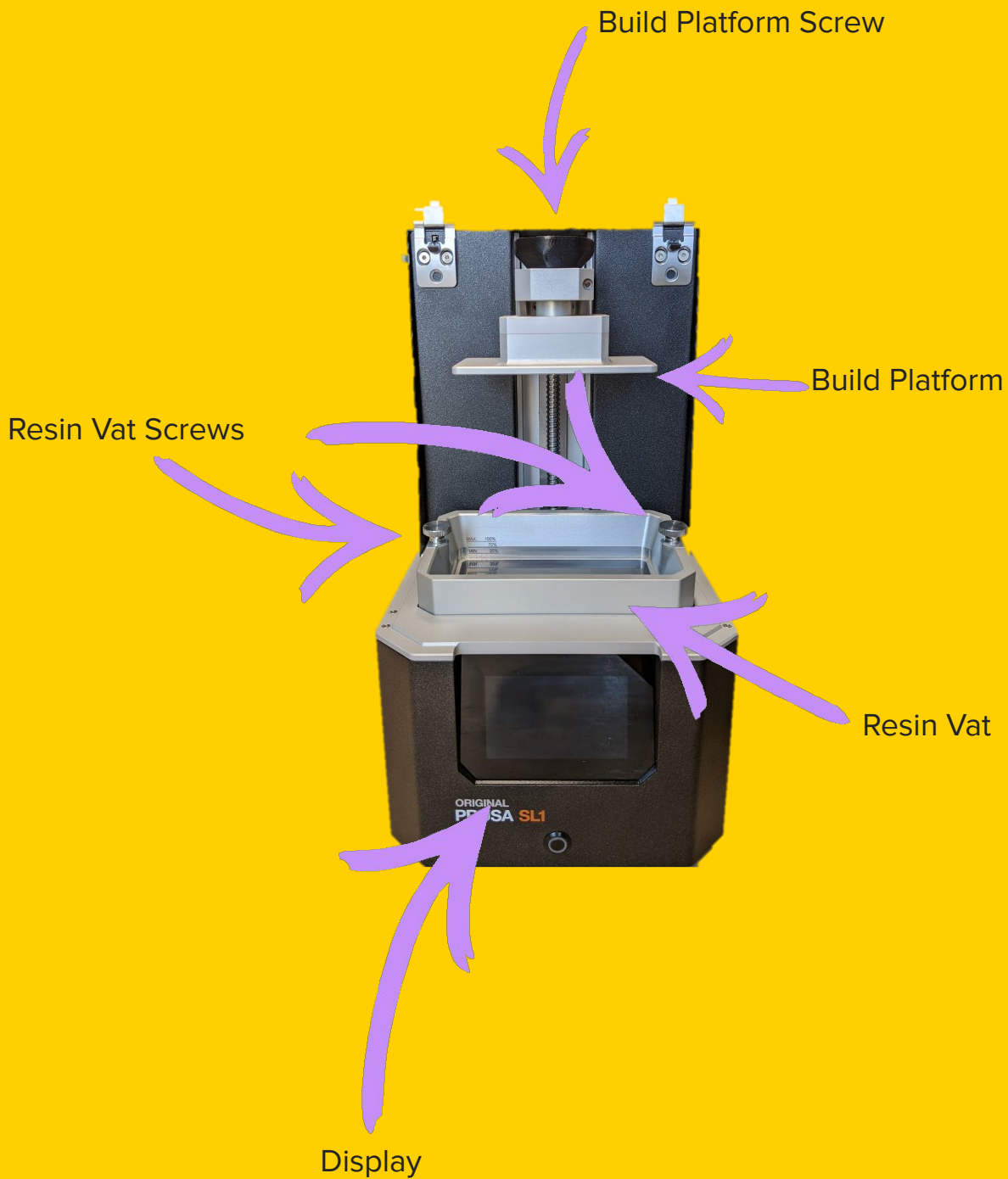
- Wear **MASK**, **GLOVES** and **SAFETY GOGGLES** when handling the resin.
- **PREPARE** your workstation **BEFORE** getting the part out of the printer.
- Do **NOT** get your skin in contact with the resin
- When in **DOUBT** ask a makerspace manager



STEPS

- Slice your 3D-Model
- Prepare the Printer
- Print
- Post cure your print
- Clean the printer

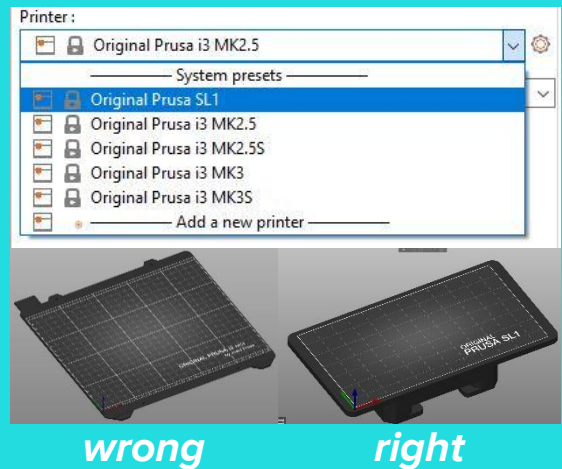
MACHINE OVERVIEW



SLICE YOUR 3D-MODEL

Steps

- Open PrusaSlicer
- Select the “Original Prusa SL1” in the machine dropdown on the right.
- Drag and drop your .stl file onto the build plate.



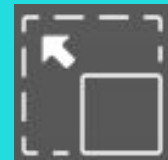
Move

- Use this to move your part around on the build plate.



Scale

- This tool can be used to make a part bigger/smaller.



Rotate

- With this tool you can rotate your part around the x, y and z axis.



Place on face

- Select a face and the software will place it on the build pate.



Cut

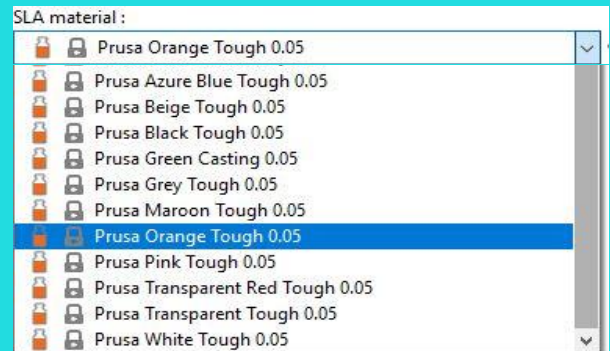
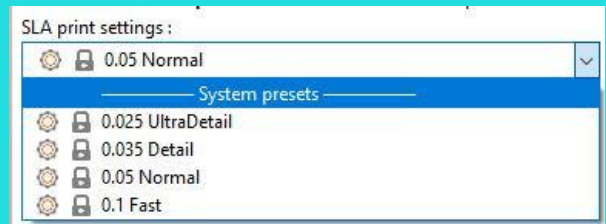
- This tool lets you cut your part into two



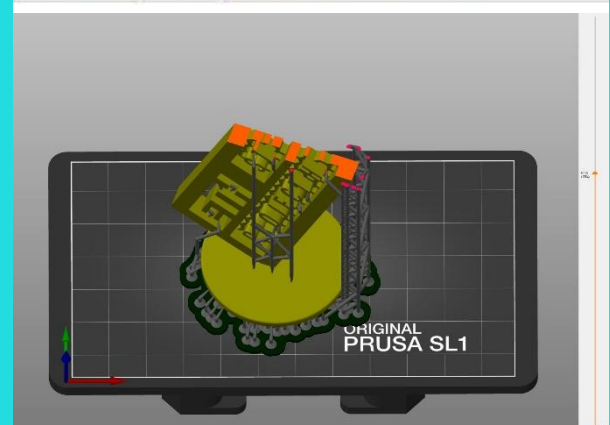
SLICE YOUR 3D-MODEL

Steps

- When you are happy with the orientation of your part it is time to select the Layer Height.
- Then select the material according to the name on the bottle.
- Afterwards it is time to select the support setting. Support everywhere is recommended.
- The Use pad will add a pad underneath your print that will help with adhesion. It is recommended to use this.
- After pressing **Slice now** the software will show you a preview. Please check the preview using the bar on the right to see that at no point a part of the model appears out of nowhere without support. If all is good use **Export**.



Sliced Info	
Used Material (ml) :	17.40
- object(s)	13.54
- supports and pad	3.86
Estimated printing time :	7h 39m 55s



PREPARE THE PRINTER

Steps

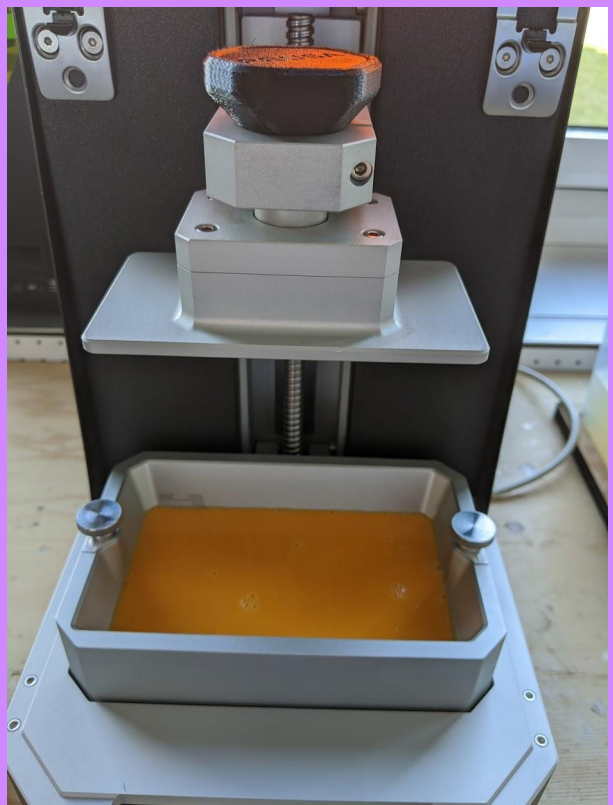
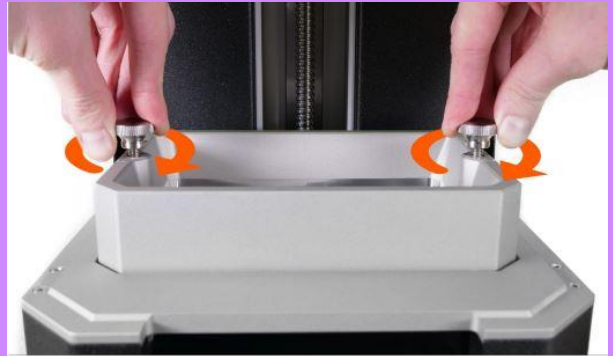
- Log into the machine and use the button on the front to turn it on.
- Select the print option and navigate to your part on the USB stick.
- The machine will tell you some further information about your print.
- If you choose to print the part, the machine will tell you how much resin to add.



PRINTING

Steps

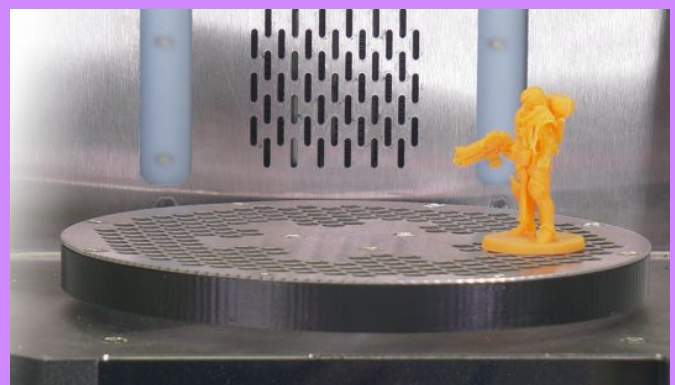
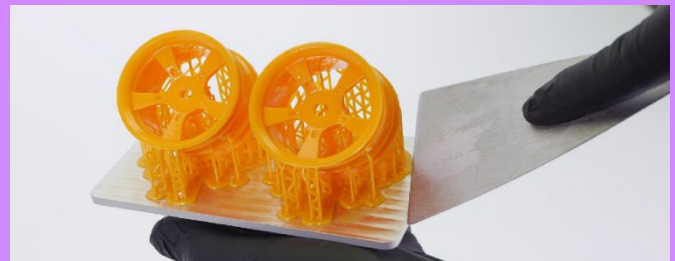
- Place the resin vat in the machine. It should slip right into place. Tighten the two screws to fixate the tank.
- Fill the resin in the vat. There are indications in the tank telling you how much you added.
- After the vat is filled you can press the print button.
- While printing the machine will tell you information about the status of your print.



POSTCURING

Steps

- Prepare your workstation.
- You need:
 - Paper towels (a lot)
 - Plastic scraper
 - Isopropanol
 - Funnel and filter
- Loosen the build platform screw and remove the build platform from the printer.
- Remove your part from the build platform with the scraper.
- Place with the basket in the “first rinse” container
- Place the container in the washing station and select wash
- Repeat the last two steps with the “second rinse” container
- Remove your print from the container and place it without a container into the washing station and select cure



CLEAN THE PRINTER



Steps

- NOTE: No cleaning is necessary if another print with the same color is started directly after your print.
- Clean the build platform using alcohol and paper towels.
- Put the funnel with a filter on top of the resin bottle.
- Fill the resin from the vat into the bottle through the filter. Use the plastic scraper to fill back as much resin as possible.
- Clean the tank using ONLY paper towels. **IMPORTANT: NEVER** use isopropanol on the build tank!
- Put the build platform and the resin vat back into the printer.
- Finally, clean the scrapers you used with isopropanol

BILLING

- Weight your print before you log out of the machine. (with the supports)
- Enter the weight of the part
(The amount will be subtracted from your Makerspace balance).
- Price: 2 CHF per single print + 0.15 CHF/g

IMPORTANT

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