Cura 4.6 Tutorial

General Process

- 1. Before printing, save the 3D model as a STL file.
- 2. Import the file into Cura to slice.
- 3. Export the sliced 3D model as a GCODE file.
- 4. Copy the GCODE file into a TF card and insert the card into the 3D printerpay attention to the inserting direction.
- 5. Select the sliced file and start printing.

How to use Cura?

- 1. We suggest beginners to use Cura to slice the 3D model.
- Slicing parameters are set according to the characteristics of different models.
- 3. Each time before you start printing, make sure that the printer is in good condition, leveling has been done and the distance between the heated bed and the nozzle is about 0.1 mm (thickness of a printing paper).
- 4. Most of the parameters are default. If you need to make changes, the changes should be set depend on the 3D model that you are going to print. At the same time, you need to be proficient in the slicing software.



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Cura supports Windows, MacOS and Linux. This tutorial takes Windows for example, MacOS and Linux are similar.

1. Install Cura

1.1. Open the installation file G Ultimaker_Cura-4.6.1-win64 in the TF card at "\\Cura 4.6\1.Cura Installation\Cura 4.6.1 Windows 64 bit\" (take Windows for example).





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1.3. Click "I Agree".

C Ultimaker Cura 4.6 Setup	0		_		×
	License Agreen	nent			
	Please review th 4.6.	e license terms befo	re installing Ul	timaker O	ura
Press Page Down to see th	e rest of the agree	ment.			
GNU LESSER GENERAL I Version 3, 2	PUBLIC LICENSE 19 June 2007				^
Copyright (C) 2007 Free s Everyone is permitted to of this license document,	Software Foundatio copy and distribute but changing it is no	n, Inc. < <u>http://fsf.c</u> verbatim copies ot allowed.	org/>		
This version of the GNU L the terms and conditions of License, supplemented by	esser General Publi of version 3 of the G the additional perm	c License incorporat SNU General Public issions listed below.	es		¥
If you accept the terms of agreement to install Ultima	the agreement, clic ker Cura 4.6.	k I Agree to continu	e. You must a	ccept the	
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1.4. Choose the folder in which to install Cura, then click "Next".

G Ultimaker Cura 4.6 Setup	_		×
Choose Install Location Choose the folder in which to install Ultim	aker Cur	a 4.6.	
Setup will install Ultimaker Cura 4.6 in the following folder. To install in Browse and select another folder. Click Next to continue.	a differe	nt folder, o	dick
Destination Folder C:\Program Files\Ultimaker Cura 4.6	B <u>r</u> o	wse]
Space required: 577.9MB Space available: 32.2GB Nullsoft Install System v2.51			
< <u>B</u> ack <u>N</u> ex	d >	Can	cel



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1.5. Click "Next".

C Ultimaker Cura 4.6 Setup		_		×
Choose Start Menu Fold	er			
Choose a Start Menu folder	for the Ultimak	ker Cura	4.6 short	cuts.
Select the Start Menu folder in which you would like to cre can also enter a name to create a new folder.	eate the progra	am's shor	tcuts. You	J
Ultimaker Cura				
				^
Do not create shortquits				*
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1.6. Choose the supported file format you need, STL is the default and recommended to

choose. Click "Install" and start the installation.

C Ultimaker Cura 4.6 Setup		_		×
a	noose Components Choose which features of Ultimaker Cura 4.	6 you v	vant to in	stall.
Check the components you wa install. Click Install to start the	nt to install and uncheck the components y installation.	ou don	't want to)
Select components to install: Space required: 577.9MB	 ✓ Ultimaker Cura ✓ Arduino Drivers ✓ Install Visual Studio 2015 Redistributa Open 3MF files with Cura Open AMF files with Cura Open CTM files with Cura Open DAE files with Cura Open GLB files with Cura 	able		^
Nullsoft Install System v2.51 —	Open gITF files with Cura			*
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C Ultimaker Cura 4.6 Setup		_		×
ci	noose Components Choose which features of Ultimaker Cura	4.6 you i	want to in	stall.
Check the components you wa install. Click Install to start the	nt to install and uncheck the component installation.	s you dor	't want to)
Select components to install:	 Open DAE files with Cura Open GLB files with Cura Open gITF files with Cura Open OBJ files with Cura Open PLY files with Cura Open STL files with Cura Open X3D files with Cura 			^
Space required: 577.9MB	Open GCODE files with Cura			~
Nullsoft Install System v2,51	< <u>B</u> ack <u>I</u> ns	tall	Cano	cel

1.7. Wait until the installation is finished, then click "Finish".





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2. Add Printer

2.1. Select "Setting - Printer - Add Printer...".

G Untitled - Ultimaker Cura							
<u>F</u> ile <u>E</u> dit <u>V</u> iew	<u>Settings</u> Extensions Preferences <u>H</u> elp						
Illtimak	Printer	•	Network enabled printers				
Olumak	Extruder 1	Þ	Local printers				
	Configure setting visibility		• Custom FFF printer				
			Add Printer				
			Manage Pr <u>i</u> nters				

2.2. Choose "Add a non-networked printer – Custom – Custom FFF printer" and input a printer name, for example BestGee T220S.

Add Printer	×
Add a printer	
Add a networked printer	<
Add a non-networked printer	~
 > Ultimaker B.V. > Custom > Custom FFF printer > 101Hero > 3Dator GmbH > 3DMaker > 3DTech > ABAX 3d Technologies > Alfawise > Anet 	
Printer name BestGee T220S Cancel	Add



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2.3. Set printer and extruder as shown below.

		Machine	e Settings			
BestGee T220S			-			
F	Printer		E	Extruder 1		
Printer Settings X (Width) Y (Depth) Z (Height) Build plate shape Origin at center Heated bed Heated build volume G-code flavor Start G-code G28 ;Home	230 230 250	250 mm 250 mm 250 mm Rectangular ♥ Marlin ♥	Printhead Settings X min Y min X max Y max Gantry Height Number of Extruders Shared Heater End G-code M104 S0	0 v 0 v 230 230 230 230 250 230 1	mm mm mm mm	G1 F2000 X0 Y0 M104 S0 M140 S0 ;Retract the filam G92 E1 G1 E-1 F300 G28 XY M84
					Next	
Add Printer BestGee T220S		Machine	e Settings		Next	
Add Printer BestGee T220S	Printer	Machine	e Settings	Extruder 1	Next	

2.4. Click "Next" and done.



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3. Import Profile

3.1. Select "Preferences – Configure Cura..."



3.2. Select "Profiles" and Click "Import".

C Preferences	×
General Settings Printers Materials Profiles Printer: BestGee T220S	me Import Export
Default Extra Fine Pine Normal Draft Extra Fast Coarse Extra Coarse	
Defaults	Close



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3.3. Open the profile file at "\\Cura 4.6\1.Cura Installation\".



3.4. Click "OK".

C Preferences	\times
General Settings Activate Duplicate Remove Rename Import Export	
Materials Printer: BestGee T2205	
Default Extra Fine Pine Normal	
Draft Extra Fast Coarse Extra Coars	
Custom proj BestGee T22 OK	



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3.5. Select the imported profile and click "Activate" to set the profile.

C Preferences	×
General Profiles	
Printers Activate Duplicate Remo	ove Rename Import Export
Materials Profiles Profiles	BestGee T220S - Fine
Default	
Pine Normal	Global Settings Extruder 1
Extra Fast	Setting Profile Unit
Coarse Extra Coarse Custom profiles	Quality Leyer Height 0.2 mm
BestGee T220S	Build Plate Tem. 60 ° C
	Dual Extrusion Frime Tower Size 20 mm
Defaults	Close

3.6. Click "Close" and done.

C Preferen	ces					×
General Settings	Profile	es Duplicata	Romovo	Roporto	Import	Funcet
Materials Profiles	Printer: Best	Gee T220S	Be	stGee T220S	- Fine	Export
	Default Extra Fine Fine Normal		Up d Dis	ate profile with card current ch	h current sett anges	ings/overrides
	Draft Extra Fast Coarse		Your	- current settin	igs match the s	elected profile.
	Extra Coarse Custom prof BestGee T220	iles 25	G	obal Settings	Extruder 1	rrant Unit
			Q	nality Leyer Height	0.2	mm
				Build Plate Tem	60	° C
			ru,	nal Extrusion Prime Tower Siz	e 20	шш
Defaults						Close



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