# 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.



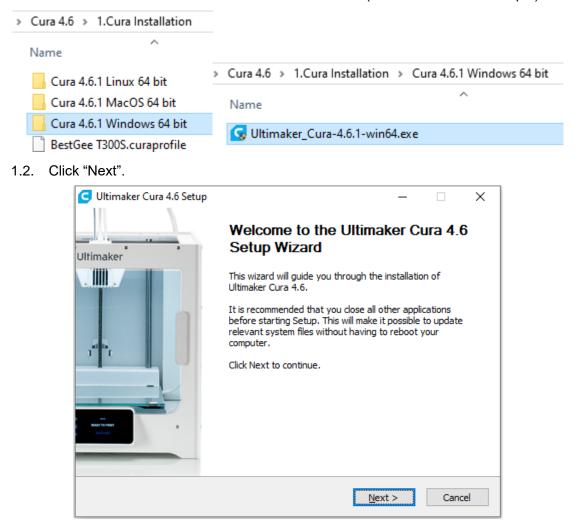
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Cura supports Windows, MacOS and Linux. This tutorial takes Windows for example, MacOS and Linux are similar.

### 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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support@tronhoo3d.com +86-0755-27908975-846 3121834042 sales@tronhoo3d.com +86-18938884079 878162114

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1.3. Click "I Agree".

C Ultimaker Cura 4.6 Setu	р		_		×
	License Agreen	ient			
	Please review the 4.6.	e license terms be	fore installing U	timaker O	ura
Press Page Down to see th	ne rest of the agreer	nent.			
GNU LESSER GENERAL Version 3, 2	PUBLIC LICENSE 29 June 2007				^
Copyright (C) 2007 Free Everyone is permitted to of this license document,	copy and distribute	verbatim copies	.org/>		
This version of the GNU I the terms and conditions of License, supplemented by	of version 3 of the G	NU General Public			~
, If you accept the terms of the agreement, click I Agree to continue. You must accept the agreement to install Ultimaker Cura 4.6.					
Nullsoft Install System v2,51					
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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 Cu	ra 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	Bro	owse	]
Space required: 577.9MB Space available: 32.2GB Nullsoft Install System v2.51			
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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 shortcuts				*
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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.

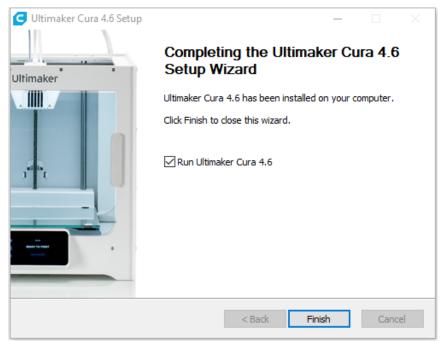
C Ultimaker Cura 4.6 Setup		_		×
	noose Components Choose which features of Ultimaker Cura 4.	6 you v	vant to in	stall.
Check the components you wa install. Click Install to start the	nt to install and uncheck the components y installation.	ou don	't want to	)
Select components to install: Space required: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

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ile <u>E</u> dit <u>V</u> iew <mark>S</mark>	<mark>ettings</mark> E <u>x</u> tensions P <u>r</u> eferences <u>H</u> elp		
Ultimak	Printer	Þ	Network enabled printers
Olumak	Extruder 1	Þ	Local printers
	Configure setting visibility		• Custom FFF printer
			<u>A</u> dd 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 T300S.

Add Printer		×
	Add a printer	
Add a network	d printer	<
Add a non-net	vorked printer	~
<ul> <li>Custom FFI</li> <li>Custom FFI</li> <li>3Dator GmbH</li> <li>3DMaker</li> <li>3DTech</li> <li>ABAX 3d Tech</li> <li>Alfawise</li> <li>Anet</li> <li>Anycubic</li> </ul>		
Printer name Cancel	BestGee T300S	Add



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2.3. Set printer and extruder as shown below.

	Machir	ne Settings	
BestGee T300S			
Pri	nter	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	300 SUU mm 300 SUU mm 400 HUU mm Rectangular V Marlin V	Y min 0 v m X max 300 v m Y max 300 v m Gantry Height 400 400 m Number of Extruders 1 x Shared Heater 5 End G-code 410 410 410 410 410 410 410 410 410 410	M104 S0 M140 S0 ;Retract the fila G92 E1 G1 E-1 F300 G28 XY M84
			Next
Add Printer BestGee T300S	Machir	ne Settings	×
BestGee T300S	Machir		

2.4. Click "Next" and done.



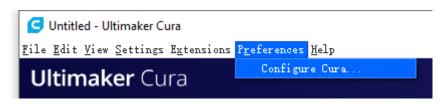
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## 3. Import Profile

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



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

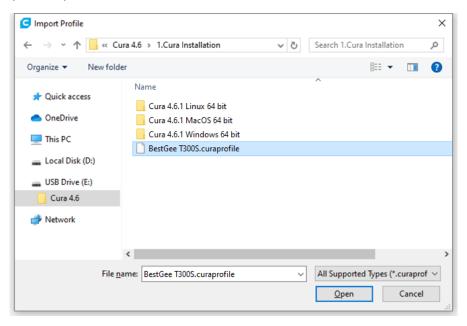
Preference	es	×
Printers	Profiles Activate Duplicate Remove Rename Import Export Printer: BestGee T300S	
	Default Extra Fine Pine Normal Draft Extra Fast Coarse Extra Coarse	
Defaults	Close	



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



#### 3.4. Click "OK".

C Preferen	ces						$\times$
General Settings Printers Materials	Profil Activate	Duplicate	Remove	Rename	Import	Export	
	<b>Default</b> Extra Fine <i>Pine</i> Normal	Gee 13005					
	Draft Extra Fast Coarse Extra Coars Custon prot BestGee T30	Cura	ccessfully imp	orted profile B	? ×	;	
				(	OK		
Defaults						Close	



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

C Preferences				Х
General Profiles Settings Activate Duplicate Remo	ve Rename	<b>T</b> .		
We tank al	ve Kename	Import	Export	
Profiles Printer: BestGee T300S	BestGee T300S	- Fine		
Default Extra Fine				
Pine Normal Draft	Global Settings	Extruder	1	
Extra Fast	Setting	Profile	Unit	
Coarse Extra Coarse <b>Custom profiles</b>	Quality Leyer Height Taterial	0.2	шш	
BestGee T300S	Build Plate Tem-	60	° C	
	Dual Extrusion Prime Tower Size	20	шш	
Defaults			Close	

3.6. Click "Close" and done.

C Preference	ces						×
General Settings	Profil	<b>O</b> S Duplicate	Remove	Renam		Import	Export
Printers Materials Profiles	Printer: Best			estGee T		-	Export
	<b>Default</b> Extra Fine Fine Normal			pdate profil iscard curre			ettings/overrides
	Draft Extra Fast Coarse					-	e selected profile.
	Extra Coars Custom prof BestGee 130	iles		Global Sett Setting	ings	Extruder	1 Current Unit
				Quality Leyer Seig	ght	0.2	ממ
				Build Pla: Dual Extru		60	° C
				Prime Town		20	ши
Defaults							Close



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