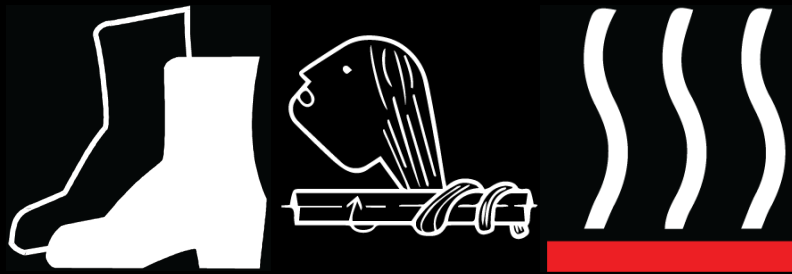


GREEN:  
USE AS  
INSTRUCTED



## Ultimaker 2 Extended 3D Printer

ANU MakerSpace Safe Operating Procedure:

**Low Risk Equipment - low incidence of minor burns, pinched fingers.**  
**PPE: Closed toe shoes, loose clothing and hair must be restrained.**

### Pre-operational Checks

1. Make sure you have been shown how to use the CURA software for slicing your 3D models. Issues begin with a poorly designed model or poor choice of printing parameters.
2. In Cura, ensure that "Ultimaker 2 Extended" is the selected machine from the machine menu.
3. Only use 2.85mm PLA filament in the Ultimaker 2 Extended. If you are interested in using other plastics, speak with staff/mentor.
4. Make sure you are familiar with how to change filament before doing so. Ensure there are no knots in the filament spool.

### Operational Checks

5. Watch your print until the first layer is complete - this is when most prints fail and need to be restarted.
6. Do not manually move the printhead or print bed using your hands.
7. Do not reach inside the printer while parts are moving. The motors are strong enough to cause injury if you trap a finger.
8. Do not touch the nozzle or plastics while printing. The nozzle is heated to temperatures of greater than 200°C.
9. Do not touch the bed when printing. The print bed can be heated to above 80°C
10. If there are issues with the nozzle/bed/filament check <https://ultimaker.com/en/resources/> for troubleshooting

### Post-operational Checks

11. Wait until the bed has cooled before attempting to remove your model. Waiting 5 mins after the build is complete ensures the part will easily separate from the bed.
12. Beware of sharp edged tools (pliers, chisels and knives) when removing support material.
13. Discard any failed prints/support in the bins provided. Leave the print enclosure clean.

