EasyThreed self-developed slicing software is a simple and easy to use slicing software, suitable for beginners and children. If you want better printing effect, you should learn how to use Cura slice.



CURA 15.04 user's instruction

Please read the setting instruction carefully before application,

The picture is for reference only, and the product is subject to the real object

1: install CURA software

After clicking the Cura installation program, the page will pop up, and you can always click the next step to complete the installation.(set the required path in the preinstallation window: it is better to install it in English directory)



Configuration Wizard	Configuration Wizard
Other machine information The following pre-defined machine profiles are available Note that these profiles are not puaranteed to give good results, If you find issues with the predefined profiles,	Custom RepRap information
or want an extra profile. Please report it at the github issue tracker. BFB DeftaBot Hephestos Hephestos_XL	Be sure to review the default profile before running it on your machine. If you like a default profile for your machine added, then make an issue on github. You will have to manually install Marlin or Sprinter firmware.
 Kupido Make#BotReplicator Mendel Ord Prusa Mendel 3 	Machine name X1 Name your 3d printer
RIGID3D HOBBY ROB0 3D R1 Rigid3D Rigid3d_Zero Rigid3d_Zero	Machine depth Y (mm) 100 Your printer's build volume X,Y,Z Machine height Z (mm) 100 Nozzle size (mm) 0.4
Vitbouchig Vitbouchig Julia punchter Connect XL rigid3d_3rdGen © Custom	Heated bed Bed center is 90.0 (RoStock)
< Back Next > Cancel	if your machine has a hotbed
E Cura - 15.04.6	
Elle roots Modrille Explicit neip Bas: Advanced Plugns Start/End-Gode Quality Quality Lave heipht (mm) 0.2 Shel thickness (mm) 0.8 Enable refraction af Fill Bottom/Too thickness (mm) Bottom/Too thickness (mm) 0.8	
Speed and Temperature Prints peed (nm/s) 60 Printing temperature (C) 190 Support	
Augency Lyne Imms V Imms V </td <td></td>	
Hachne Hozie sze (mm) 0.4	

2: slice setting for printer

Filament diameter

Open Cura's interface to modify all the control parameters of the printing process .

🔳 Cura - 15.04.6			
File Tools Machine Exp	ert Help		
Basic Advanced Plugin	Switch to quickprint.		
Quality	Switch to full setting	s	Full print settings
	Cura - 15.04.6 Eile Tools Machine Expe	ert Help	
	Basic Advanced Plugins Sta	art/End-GCode	Layer thickness:
	Quality	←	0.1mm printing quality higher,
左 0.1mm 层厚 右 0.3mm 层厚	Layer height (mm)	0.2	normally use 0,2mm,
外壳的厚度	Enable retraction		· · · ·
0.4mm	Fill Bottom/Top thickness (mm) Fill Density (%) 2	2.6	Shell thickness: 0.4mm too thin,1.2mm take more
	Speed and Temperature		times to print, normally 0.8mm, use
	Print speed (mm/s) 4	10	integer times of the diameter of the
0.8mm	Printing temperature (C)	.90	
	Support type	lone v I	
	Platform adhesion type B	Irim v	
	Filament		Enable retraction:
1.2mm	Diameter (mm) 1	.75	The purpose is not to let the silk leak
	Flow (%) 1	00.0	out when moving rapidly, otherwise it
	I		will affect the appearance



Eile	Tools Maa	chine E	xpert Help		
Basic	Advanced	Plugins	Start/End-GCode		
Quali	ty				
Layer height (mm)		0.2			
Shell	thickness (m	ım)	0.8		
Enabl	e retraction				
Fill					\checkmark
Botto	m/Top thick	tness (mm	n) 0.6		
Fill De	nsity (%)		20)	Ҡ
Spee	d and Tem	perature			
Print	speed (mm/	s)	40		
Printir	ng temperat	ure (C)	190		
Supp	ort				
Supp	ort type		None	~	
Platfo	rm adhesion	type	Brim	~	

Bottom/top thickness:

If the filling density is less than 20%, the thickness of 0.6 mm is very easy to cause holes on the top, and the value of 1 mm is generally better

Fill density:

If high strength is not required, 10% is enough. For high strength, increase the filling ratio, but the printing time will increase

Print speed:

This is the default speed. If the shell and filling speed are not set separately, the printing time is not directly proportional to the speed. If the speed is too fast, printing will easily cause quality problems. Generally speaking, 40mm / S is a better speed, According to the speed specifications of your printer

<u>E</u> ile	Tools Ma	chine E	Expert	Help		
Basic	Advanced	Plugins	Start/E	nd-GCode		
Qual	ity					
Layer height (mm)			0.2			
Shell thickness (mm)			0.8			
Enabl	e retraction					
Fill						
Botto	om/Top thick	mess (mr	n) 0.6			
Fill Density (%)		20				
Spee	d and Tem	perature	\checkmark			
Print	speed (mm/	s)	40			
Printi	ng temperat	ure (C)	190			
Supp	oort					
Supp	ort type		None		~	•
Platfo	orm adhesion	type	Brim		~	

Print temperature:

PLA starts to melt at 180 °C, but the viscosity is relatively large, so it is difficult to squeeze. It is recommended to set the temperature at 190 °C -- 210 °C, printing speed faster or layer thickness thicker, and set the printing temperature a little higher

0





everywhere

touching buildplate

Bottom/Top thickness (mm)	0.6
Fill Density (%)	20
Speed and Temperature	
Print speed (mm/s)	40
Printing temperature (C)	190
Support	K
Support type	None v
Platform adhesion type	Brim ~
Filament	
Diameter (mm)	1.75
Flow (%)	100.0
Machine	
Nozzle size (mm)	0.4

Support type: (None, touching, everywhere). For the model with complex structure, it is usually necessary to add support. Usually choose Everywhere

	Quality		
	Layer height (mm)	0.2	
	Shell thickness (mm)	0.8	
	Enable retraction	✓ …	
none	Fill		
	Bottom/Top thickness (mn	n) 0.6	
	Fill Density (%)	20	
	Speed and Temperature		
	Print speed (mm/s)	40	
a start	Printing temperature (C)	190	
Brim	Support		Platform adhesion type: (Brim.Raft.
	Support type	None v	······································
	Platform adhesion type	Brim ~	Normally choose Brim bein the model
A TON	Filament	7	stick platform well
	Diameter (mm)	1.75	
Section 1	Flow (%)	100.0	You can also choose None if the platform
			leveling very well.
	File Tools Machine Exr	pert Help	
Default is OK	Eile Tools Machine Exp Basic Advanced Plugins St Retraction	pert Help tart/End-GCode	
Default is OK	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s)	oert Help tart/End-GCode 40.0	Configuration according to the
Default is OK	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm)	ert Help tart/End-GCode 40.0 4.5	Configuration according to the
Default is OK	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality	eert Help tart/End-GCode 40.0 4.5	Configuration according to the 3d printer
Default is OK	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm)	ert Help tart/End-GCode 40.0 4.5	Configuration according to the 3d printer
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer line width (%)	0.3 100	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer line width (%) Cut off object bottom (mm)	0.3 100 0.0	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Cut off object bottom (mm) Dual extrusion overlap (mm)	0.3 100 0.15	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Cut off object bottom (mm) Dual extrusion overlap (mm)	bert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer line width (%) Cut off object bottom (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s)	bert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Cut off object bottom (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s) Bottom layer speed (mm/s)	bert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Cut off object bottom (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s) Bottom layer speed (mm/s)	Dert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15 40 20 20	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off	Eile Tools Machine Exp. Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Initial layer line width (%) Cut off object bottom (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s) Bottom layer speed (mm/s) Infill speed (mm/s) Infill speed (mm/s) Top/bottom speed (mm/s)	Dert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15 40 20 20 0	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off The minimum printing time of each layer, When the real printing time of the layer less	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Initial layer thickness (mm) Cut off object bottom (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s) Bottom layer speed (mm/s) Infill speed (mm/s) Duter shell speed (mm/s)	Dert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15 40 20 20 0	Configuration according to the 3d printer Default 100%
Default is OK 0.3mm It's to make the model easier to peel off The minimum printing time of each layer, When the real printing time of the layer less Than 3 sec, the speed will be lower than the	Eile Tools Machine Exp Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Quality Initial layer thickness (mm) Initial layer thickness (mm) Initial layer line width (%) Cut off object bottom (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s) Bottom layer speed (mm/s) Infill speed (mm/s) Duter shell speed (mm/s)	Dert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15 40 20 20 0 0	Configuration according to the 3d printer Default 100%
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Default is OK 0.3mm It's to make the model easier to peel off The minimum printing time of each layer, When the real printing time of the layer less Than 3 sec, the speed will be lower than the set speed.	Eile Tools Machine Exp. Basic Advanced Plugins St Retraction Speed (mm/s) Distance (mm) Distance (mm) Distance (mm) Quality Initial layer thickness (mm) Initial layer line width (%) Cut off object bottom (mm) Dual extrusion overlap (mm) Speed Travel speed (mm/s) Bottom layer speed (mm/s) Infill speed (mm/s) Outer shell speed (mm/s) Inner shell speed (mm/s) Inner shell speed (mm/s) Minimal layer time (sec)	bert Help tart/End-GCode 40.0 4.5 0.3 100 0.0 0.15 40 20 0 0 0 3	Configuration according to the 3d printer Default 100% O Indicates that the global default speed is used, If the global speed is > 60mm / s, the shell speed should be less than 60mm / s to ensure the printing quality

3: slice and save

After all the parameters are set, load a 3D model file, s ave the sliced gcode file to the SD card, and then start printing.





	Save the gcode file to computer when SD card not available
1 hour 24 minutes 8.87 meter 26 gram 1.32	1hour24minutes: means the Estimated printing time 8.87meter 26ggram: means filament need 8m, weight 26g
2 hours 1 minutes 10.40 meter 31 gram	Save the gcode file to SD card.
2 hours 1 minutes 10.40 meter 31 gram	Online print mark

Thanks for choosing EasyThreed, we will try our best to serve you ShenZhen Easythreed technology CO.,LTD Address : No.A2 , 2nd Floor , Avant Low Carbon Innovation Park , No1034 of Longgang Road , Pingdi Street , Longgang District , ShenZhen , China Website : www.easythreed.com Email: info@easythreed.com