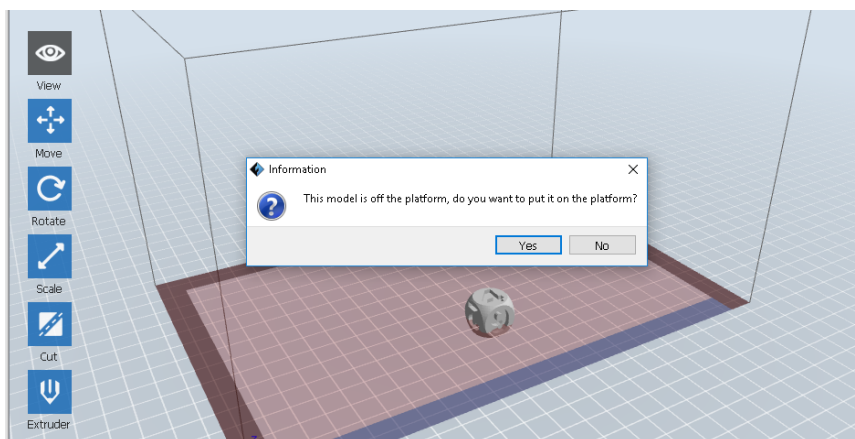


These guidelines are for CoderDojo Ninja use

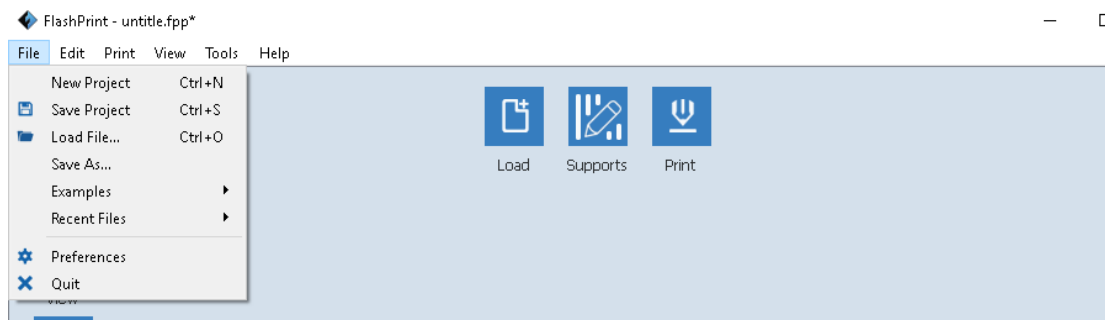
- If you are a member of the public, **please make an appointment** to sit with a library officer to convert the file for printing
- If you are a Ninja at the CoderDojo, please follow these instructions below.

FlashPrint Guidelines

- Double click on your saved .stl file to open with Flash Print and click **Yes** to place model on the build platform, **or**



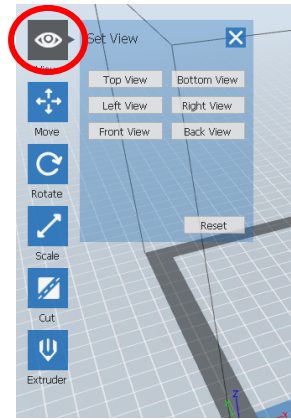
- Open Flash Print software then click **New Project** under the File tab



- Browse and select the .stl file you wish to open with Flash Print

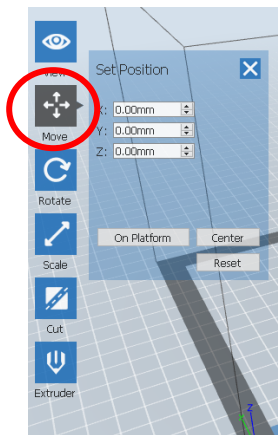
The FlashPrint software allows you to:

View your model from different angles and perspectives.

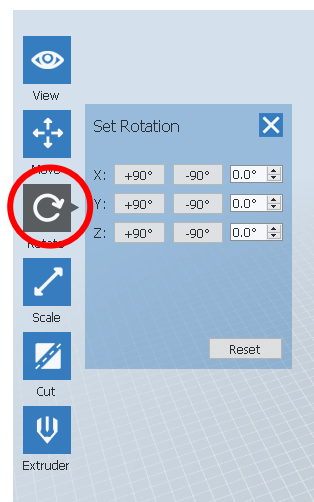


Move your model:

- Set the position of your model on the X, Y and Z axis.
- Centre the model on the build plate
- Place your model on the platform

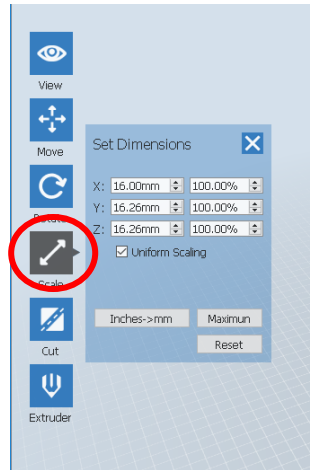


Rotate your model on the X, Y and Z axis.



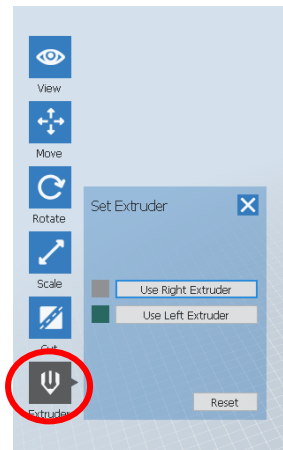
Scale your model:

Check or Set dimensions of the model



Select the Extruder:

Set your model to print from right or left extruder



Add **supports** if needed:

- Add supports if there are any overhangs in the print job.
- Click supports and then auto supports.

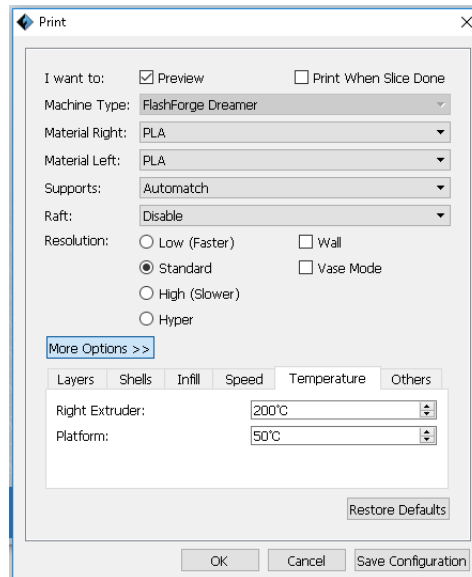


The final steps in FlashPrint:

To prepare the finished model for print

- Click **Print** icon
- Enter Print specifications:

- Material Right: PLA
- Material Left: PLA
- Temperature: 200 degrees for extruder and 50 degrees for platform.
- Resolution: Standard (resolution can be set on low to speed up the print job but lower the quality or set on high if it is a detailed print job)
- Infill (15% is normally fine but can be increased to make the print stronger)
- Add a raft if needed (for small unstable prints)



- **Save** project as a .g file to a USB SD card reader.
Give SD card to staff (who will insert it into the 3D printer)