F400 QUICK-START GUIDE

PLEASE READ THIS DOCUMENT BEFORE OPERATING YOUR PRINTER
7. Loading Filament

1. Slide the filament dowel through the center hole of the filament spool.

2. Orient the spool so that the filament pays off the front underneath the spool.
3. Using 1 hand on either side of the spool, slide the dowel into the track in the filament bay. The dowel will drop into the groove in the track when it’s positioned correctly.

4. Locate the end of the filament. Trim off the end of the filament at an angle.

5. Feed the end into the inlet of the extruder.
6. While gently pushing on the filament, slowly turn the orange wheel until you feel the extruder “bite” on the filament and begin to pull it.

7. Continue to turn the wheel until the end of the filament protrudes into the feed tube on the exit side of the extruder.

8. On the screen, navigate to the “control” tab. Press the “Macros” button.

9. Select the “Load filament” macro. The printer will home the z axis and begin heating the print head. Once it’s up to temperature it will feed the filament up the tube and into the print head.
10. After the load is complete the extruder will reverse slightly and the heaters will shut off. **CAUTION:** The print head will still be hot.

11. Remove the string of filament the print head extruded.

1. Use the included gluestick to apply a single even layer of glue to the center of the bed. You do not need to coat the entire bed unless you are printing a large part.

2. On the touchscreen, navigate to the “Print” tab.
3. Select the SD card icon to see a list of files on the card.

4. Select your file. You will see a pop-up with some additional information about the file. Select “Print”.

5. Your printer will begin the print by homing all the axes and pre-heating the bed.

6. Once the bed is up to temperature, it will run the bed probing sequence to detect the level of the bed. After this is complete it will heat the print head.

7. When the print head is up to temperature it will start the print!

8. During a print we recommend closing the door, but your printer will run with the door open (there are no safety interlocks). You will get better quality, especially on larger prints, with the door closed.

9. After the print is finished the bed will drop all the way down and the heaters will shut off.

10. PLA parts can be removed immediately. ABS and other high temperature materials need to wait until the bed cools below 50C before you remove them.
9. Removing Finished Parts from the Bed

Different materials behave differently. Use the part removal tool to work the part loose from the bed.

PLA will need to be manually detached. Larger parts will require more force. One helpful trick is to heat the bed to 70°C to soften the bottom layer.

ABS will self-release as the bed cools below 45°C (you will hear a “pop”).

Nylon blends will need to be pried off. Since they are flexible they can be worked off a little bit at a time.

For more details, see section 9.1 in your user manual.
10. Cleaning Up After a Print

1. Remove the outline (skirt) printed around the part.

2. Remove the priming pile at the front left corner.

3. Spray down the bed with water from your spray bottle, let it soak for at least 15 seconds.
4. Remove the glue using the part removal tool and paper towels.

**PLEASE NOTE:**

- Fresh glue must be used for every print!
- **ONLY** use normal tap water to clean the bed. Cleaners such as rubbing alcohol, windex, etc will affect print adhesion.
14. Additional Resources

Manuals & Downloads: http://www.fusion3design.com/manuals/

Questions about Filament: http://www.fusion3design.com/3d_printer_filament/

Contact Support: http://www.fusion3design.com/contact_support/ or 877-452-0010 x2

Simplify3D resources: https://www.simplify3d.com/support/