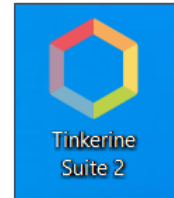# Exploratory 9 – 3D Printing
Sound Sensing LED Display Stand

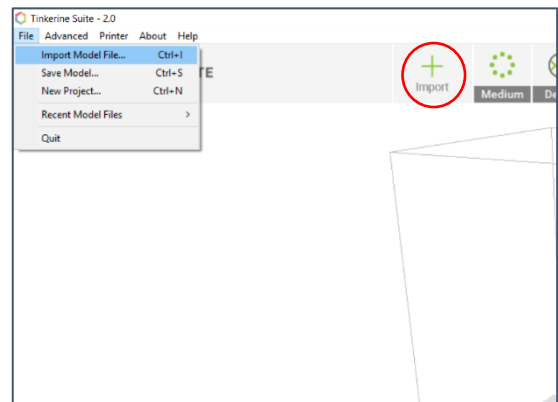**Step 1** – Download the 'zipped' file from the class website

Step 2 – Open the zipped file, the model file is inside. Copy and paste the model file into your Class Folder that you should have created inside the 'Documents' folder.

Step 3 – Open the 'Tinkerine Suite' application, there should be a shortcut on your desktop
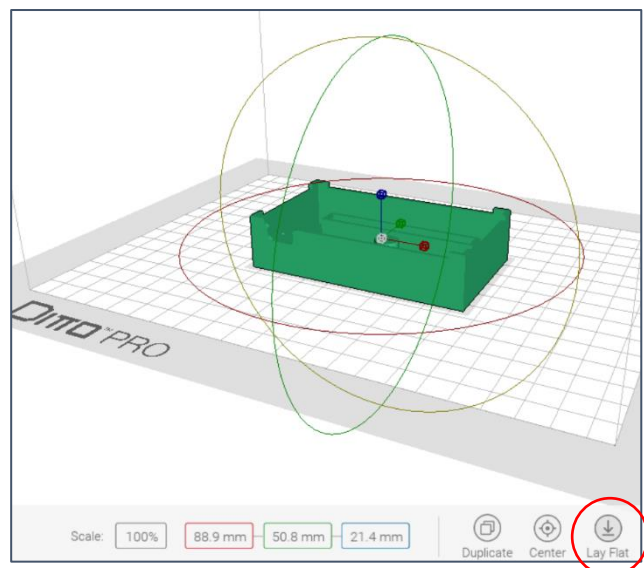
Step 4 – Under the 'File' tab select 'Import Model File…' and import the model you saved in Step 2

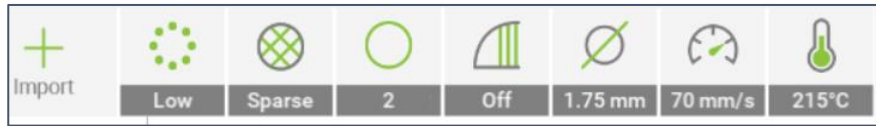Or…simply select the import button

Step 5 – Click the model and use the appropriate rotational 'hoop' to position the print with the feet up the stand up.
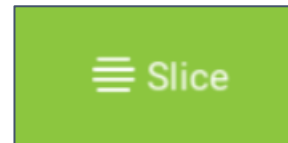
If the rotation is off by even a single degree the print won't work. Use the 'Lay Flat' button at the bottom of the screen to ensure that the model is positioned flat on the build plate
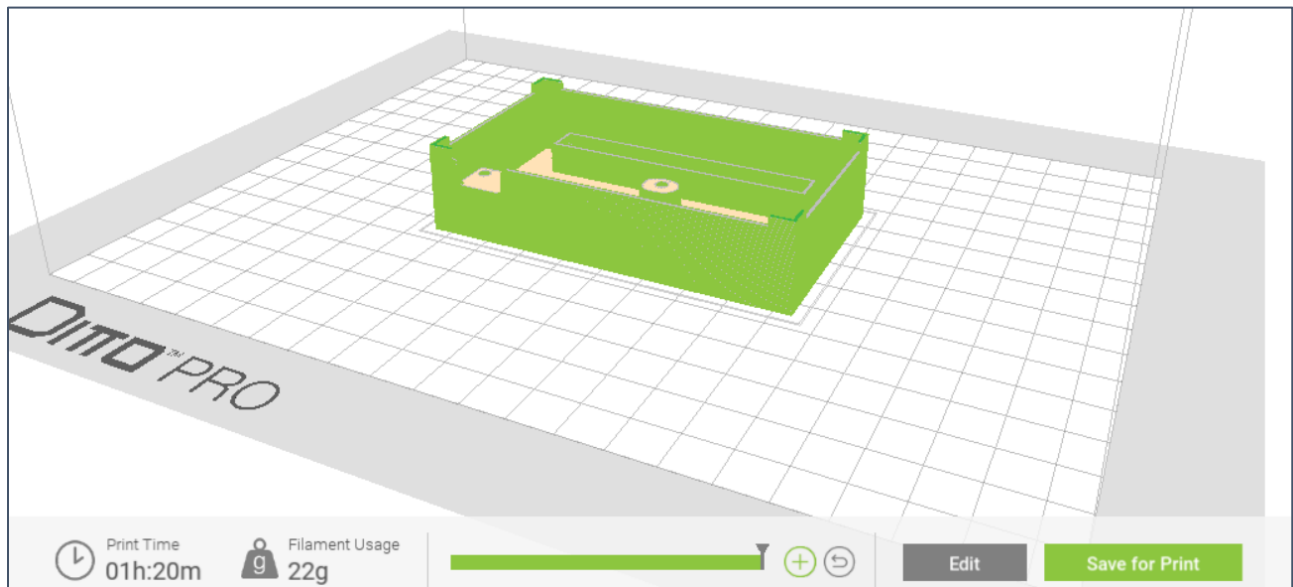
Step 6 – Adjust the settings at the top of the screen as per below:

| Import | Low | Sparse | 2 | Off | 1.75 mm | 70 mm/s | 215°C |

Step 7 - 'Slice' the model into layers by selecting the button at the upper right
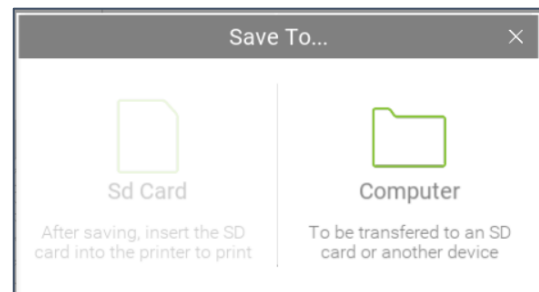
≡ Slice

Step 8 – Note the slicing results. You can use the slide bar to view each layer from the build plate upward. If all looks good, select 'Save for Print'. If not, use the 'Edit' button to return to the model and make adjustments.

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| Print Time | Filament Usage | | | | Edit | Save for Print |
| 01h:20m | 22g | | | | | |

Step 9 - Get one of the Sd cards from the front of a printer that is not being used. Insert it into your computer's Sd card port (gold contacts face down) then select 'Save To…. Sd Card'

Click 'Eject' then remove the card. Take note of the file name.

Save To…   ✕

Sd Card   Computer

After saving, insert the SD   To be transferred to an SD
card into the printer to print   card or another device

Step 10 – Insert the Sd card into the printer (gold contacts down). Ensure that the build plate is properly attached and is clean. Consider the adhesive, is it good to make another print? If not, adhesive will need to be re-applied.

Step 11 – Rotate the selection dial and press it when it is highlighting 'Print'

Step 12 – Rotate the selection knob to locate your file, then press to select.

Step 13 – Observe the first layer to ensure that is goes down well, after this check in on the print periodically in case any troubles arise.