2025/10/16 05:46 1/4 printing3d

HowTo use the new 3D Printer "Formlabs Form 2"

3D Printer Status: **WORKING (see Issues)** if you have troubles please write a request (following the report guideline) to simon.haller@uibk.ac.at.

Handling

HANDLE THE PRINTER WITH CARE !!!

Material

Following Resins are available.

• (in use) Clear Resin 1L (GPCL02) ... lasts for

Clear Resin polishes to near optical transparency, making it ideal for working with light or showcasing internal features. Supports print resolutions: 100, 50, and 25 microns.

- (in stock) Black Resin 1L (GPBK02)
- Black Resin is formulated for models with very small features and intricate details. Supports print resolutions: 100, 50 and 25 microns.

Formlabs currently sells several resins that are compatible with the Form 2. Their general-purpose hard plastic resin is available in different colors: clear, white, grey, black. In addition, the company sells a resin specialized for casting, a flexible resin, a tough resin, and a resin for intraoral surgical guides.

Known Issues

| Date | Description | Solution |
|------------|--|---|
| 02.04.2016 | Use external Power Supply to speed fans. | |
| 10.08.2015 | again broken fans - ordered replacement | |
| 16.02.2015 | Makerware crashes (segfault) | http://www.ichdruck3d.de/makerware-stuerzt-unter-linux-ab-solved/ |
| 08.12.2014 | Use the left extruder (the right one is unplugged) | |

Solved Issues

| Date | Description | Solution |
|------------|--------------------|----------------------|
| 31.08.2015 | Broken Capton Band | Changed Capton Band |
| 10.08.2015 | Broken Temp Sensor | Replaced temp sensor |

| Last | update: | 2017 | /01 | /19 | 10.38 |
|------|---------|------|-----|-----|-------|
| | | | | | |

| Date | Description | Solution | | | |
|------------|---|---|--|--|--|
| 29.07.2015 | Broken Capton Band | Changed Capton Band | | | |
| 03.05.2015 | Broken Capton Band | Changed Capton Band | | | |
| 01.12.2014 | Broken Gear | Fixed with a new gear holder | | | |
| 21.10.2014 | Broken Capton Band | Changed Capton Band | | | |
| 17.09.2014 | Broken Capton Band | Changed Capton Band | | | |
| 08.08.2014 | Rigth extruder not working ("Heating Failure"). | Reattached thermocable at extruder. Seems to be very fragile | | | |
| 08.08.2014 | Kapton Band had holes | Replaced it | | | |
| 23.07.2014 | Still jumpy X Axis | Got Cables from Support (hafners-buero.com), Replaced them. | | | |
| 16.07.2014 | Still jumpy X Axis | Requested new Cables from Support | | | |
| 15.07.2014 | Joggy Movement of motors | Strengthend X Axis belt. Resolderd X Axis Connectors | | | |
| 15.07.2014 | SD Card Slot does not hold Card | Fixed Slot (push sd card softly in - do not use any tape around an SD Card) | | | |
| 14.07.2014 | Broken Fan | Replaced Fan | | | |
| 14.07.2014 | Jumpy Stepper Motors | Used WD40 as lubrication | | | |
| 05.06.2014 | Greasy Kapton Band | Replaced Band | | | |

Updates

| Date | Description |
|------------|------------------------|
| 08.08.2015 | Firmware update to 7.6 |
| 14.07.2014 | Firmware update to 7.5 |

Creating a 3D Object

Choose a CAD or 3D Software which can handle stl files (examples: MeshLab, Blender, Bricscad, QCad, FreeCAD, VariCad, Open CASCADE, Cycas CityEngine, BRL-Cad, Draftsight, LibreCAD, ...)

Create your 3D model and save it as STL file.

You can also have a look at the makerbot thingiverse library - where you can find free (gpl licensed) 3D models ready for printing: http://www.thingiverse.com/

If you want to share your CAD models with the group (or if it is more often used) add your STL file(s) to following repository:

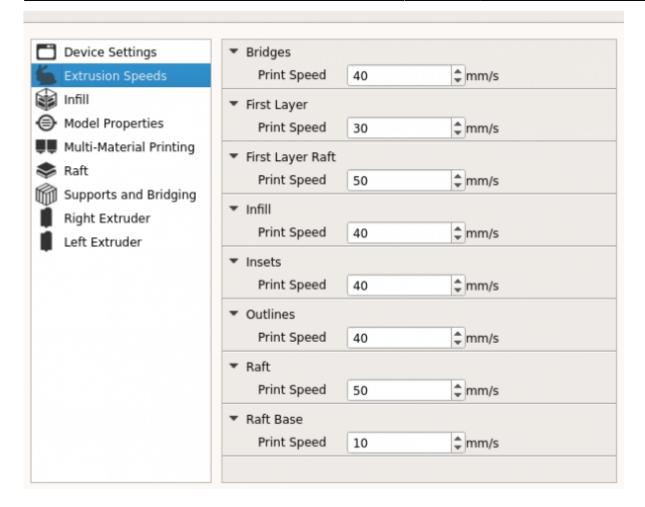
ssh://iis.uibk.ac.at/projects/git/CAD-models

Makerware and 3D Print Files

Use the following speed settings:

https://ifi-wiki.uibk.ac.at/ Printed on 2025/10/16 05:46

2025/10/16 05:46 3/4 printing3d



To create 3D print files you have to use the original Replicator 2x software: makerware (Download: Makerware)

- 1. start Makerware
- 2. SELECT CORRECT 3D Printer
- 3. MakerBots \rightarrow Type of Makerbot \rightarrow The Replicator 2x

Import your STL file in Makerware and use the following settings as default for print-file export (object without quotes refers to the imported stl file; "Object" refers to the menu point):

- 1. move object to platform (select object → selct "Move" → "On Platform")
- 2. place object a bit to the front
- select object → "Object" → select Extruder "right"
- 4. select "Make"
- 5. Export for "The Replicator 2X"
- Select Right: "Makerbot ABS"
- 7. Resolution: Standard
- 8. Raft: "Right Extruder"*
- 9. Supports (only if you have overhanging parts in you object): "Right Extruder" or "Color matched"*
- 10. Quality
 - 1. Infill: betweeen 10% 40% depending on how stable your object should be
 - 2. Number of Shells: 2
 - 3. Layer Height: 0.15mm
- 11. Temperatur:
 - 1. Extruders: 233

Last update: 2017/01/19 10:38

2. select "Heat Build Plate"

3. Build Plate: 114

12. Speed:

Speed while extruding: 40mm/s
Speed while traveling: 70mm/s

Save the x3g file on a FAT formated SD-Card. The SD card used with your MakerBot Replicator x2 must be formatted FAT16 with a maximum capacity of 2GB. Put the SD-Card into the printer and select your file to print.

If (and only if) you want do dig REALLY DEEP and have full control, consider defining you own slicer options as documented here: http://www.makerbot.com/support/makerware/documentation/slicer/ BE AWARE that already the default options differ a lot from what you are used to. So take your time and adjust every single setting to your needs.

* When printing large objects, Makerware may decide to use the two extruders altough only one was chosen, this to let the material/extruder cool down. You can check this by looking at the preview, in the right top corner the material use will be displayed, if both extruders are used "right material use" AND "left material use" will appear and the object will be shown in two different colors. If you do not want Makerware to do so, choose "color matched" instead of "left extruder".

Instruction for old MakerBot

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Last update: 2017/01/19 10:38

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