Leaflet Bambu studio

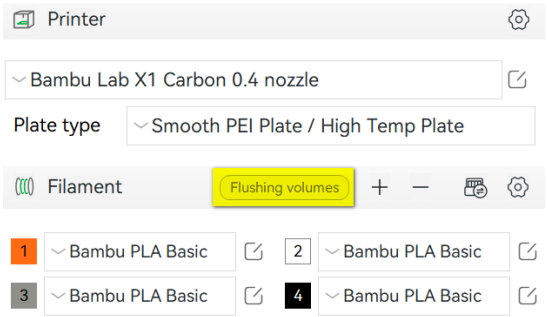
Download Software: https://bambulab.com/download/studio

Recommended filetypes:

- 3mf (exchange format for 3d objects, could be project files or models)
- Step (CAD format)
- Stl (polygonal models)

Print settings

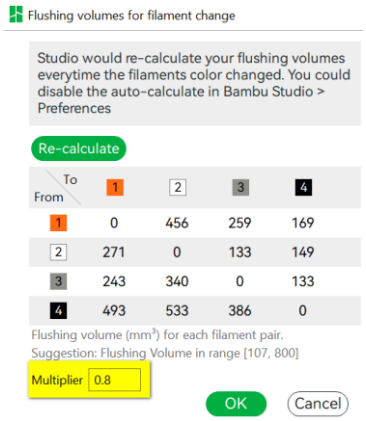
Download the file *UBTinySettingsProject.3mf* from our website and load it into BambuStudio. This automatically adjusts all settings (printer and filament). Save the object so that the settings remain.



Adjust flushing volumes

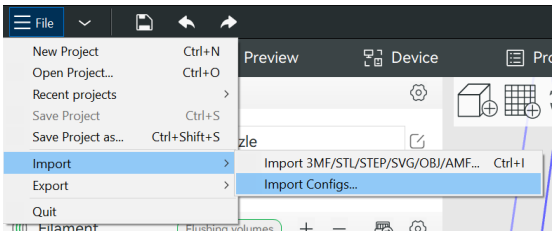
The flushing volumes should be adjusted to save filament.

1. Click on *flushing volumes*
2. Change the multiplier to **0.8**
3. Save with *ok*



Printing profiles

1. Download the file *BambuLabConfigUBTiny.bbscfg* from our website.
2. Import via *File – Import – Import configs* (4 profiles)



You find the printing profiles under *process* on the left side.

UB-Tiny 0.08mm	For very detailed prints, takes longer
UB-Tiny 0.20mm	Recommended: Standard setting sufficient for 90% of cases
UB-Tiny 0.20mm	For extra stable walls, useful for mechanical parts
UB-Tiny 0.30mm	Fast printing, with less detail, suitable for prototypes

Support structures

In the tab *Support* you can add supporting structures.

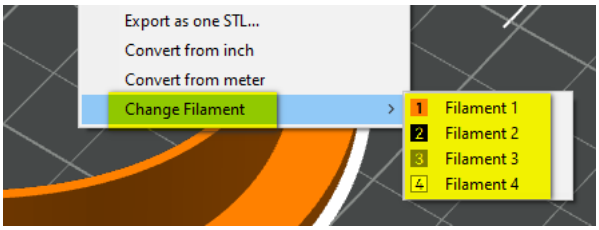
Recommendation:

Enable support:	yes
Typ:	tree (auto)
On build plate only	yes

Note: Support structures that are on the object itself (instead of on the build plate) are often difficult to remove but are sometimes necessary. In such a case, "On build plate only: Deactivated".

Colour change

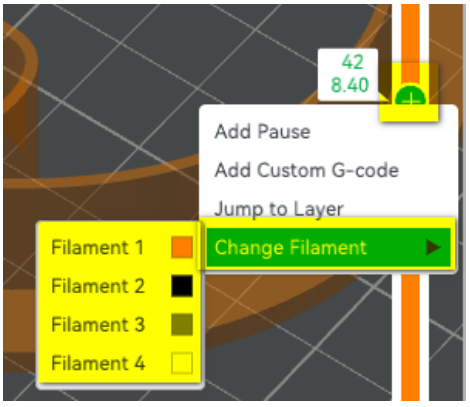
Right-click on your object to change the colour via *Change Filament*. This will change the colour of the entire object.



Multicolour printing option 1 (layers)

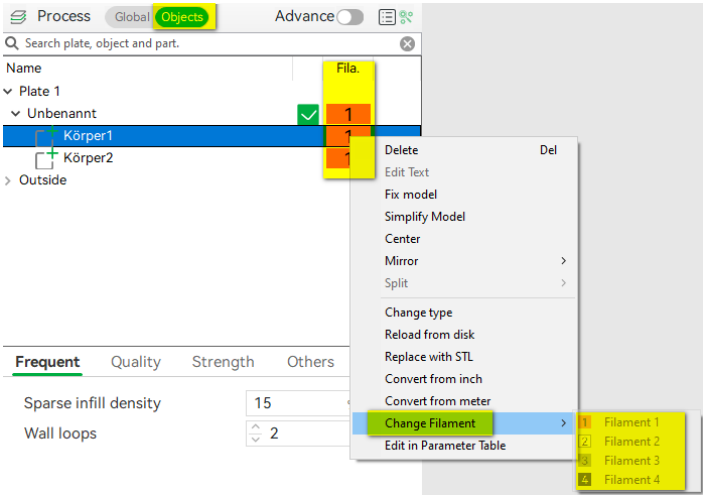
After slicing your object (see "Preview" step), you can determine the layer from which a colour change should take place.

1. Use the slider on the right-hand side to select the appropriate layer
2. Right-click and *Change Filament*
3. Select the new colour



This can be repeated as often as required. However, the printing time will increase with each colour change.

Multicolour printing option 2 (objects)

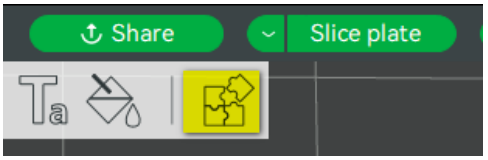


Prerequisite: an object that consists of various individual parts.

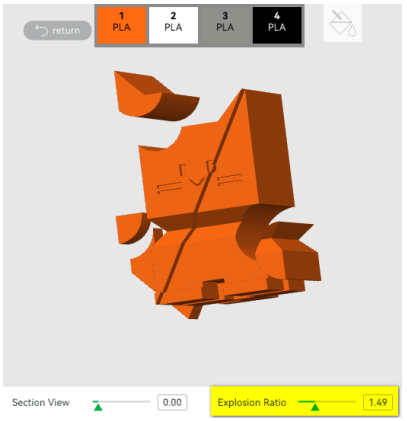
Note: This option considerably increases the printing time, as the filament must be changed several times for each multi-coloured layer.

1. Move the slider in the menu on the lefthand side (under *Process*) from *Global* to *Objects*
2. Right-click on *Filament* and select *Change Filament* for the desired body
3. Choose the desired colour

Alternative view (especially for projects with many small parts):



1. Open the *Assembly View* (top right) – this helps you to see the different parts of your object
2. With the *Explosion Rate* you can pull the parts apart for even better visualization
3. The individual parts can be coloured differently by right-clicking and then selecting *Change Filament*

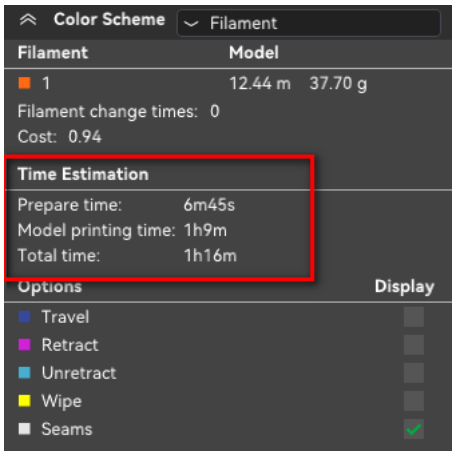


Preview

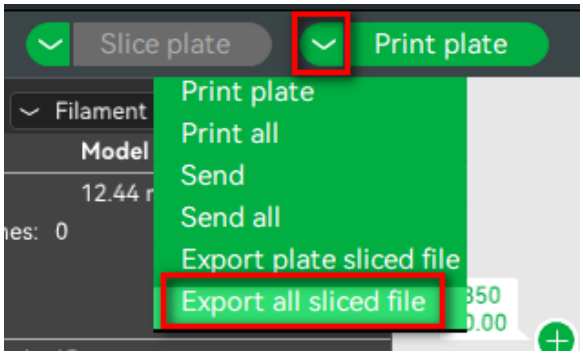
To see details of the print, you can click on the *Slice plate* button at the top right. This will take you to the preview menu where you can see the structure of the print

Time and material quantity

In the window at the top right, you can see all print information such as print time, filament quantity, and filament changes.



Export



1. Click on the arrow to the left of the *Print plate* button in the top right
2. Select *Export all sliced file*
3. Then click on the button again
4. Save the file in gcode.3mf format to the SD card and continue at the printer