

## Dimension 3D Printer User Guide:

### File type:

- Save your file with the **.stl** extension
- Make sure that your file is either accessible from the MAC-PC Exchange or portable storage such as a thumb drive.

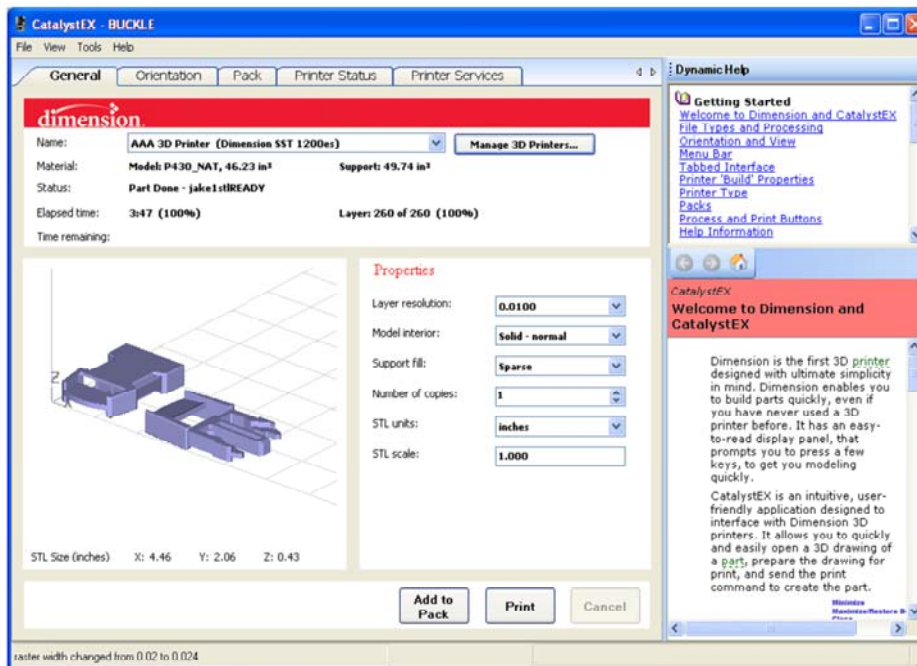
### The Printer:

- Ensure that the Dimension sst 1200es is ON and in standby mode
- Secure plastic printing base tray in machine.
- Open CatalystEX  
(CatalystEX can be opened by using the icon on the desktop or by clicking **start > All programs > Dimension > CatalystEX 3.0 > CatalystEX**)

### The software:

Click File, open STL...

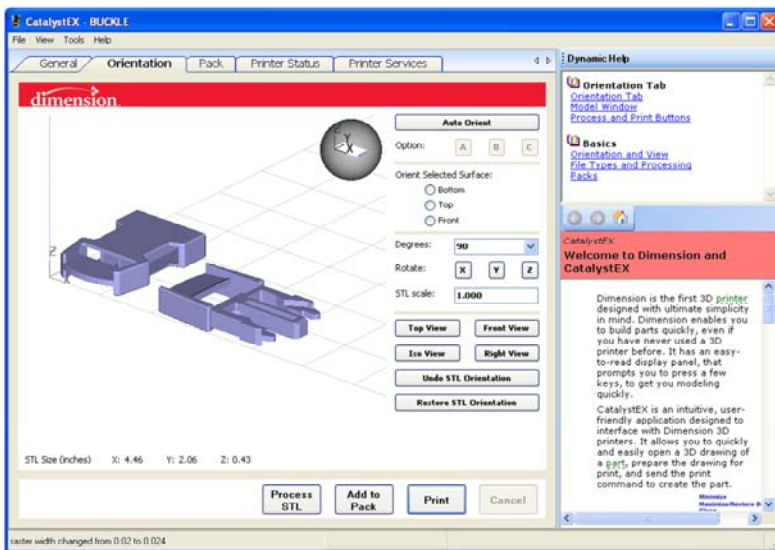
Under the **General tab**, select the Properties you wish your model to have by using the pull down menus.



- **Layer Resolution:** sets the thickness of each printed layer. Default is 0.0100
- **Model Interior:** determines how much material is used to create the internal structure of the model
  - **Solid – normal:** fills the interior with a dense pack of honey comb structure (default setting)
  - **Sparse:** Fills the interior with a loose weave of honey comb structure
- **Support fill:** determines how much material will be used to give support to the model.
  - **Basic:** creates a honey comb pattern of support material around the model. Basic uses only what is needed to support the model.
  - **Sparse:** Similar to Basic but creates a wider honey comb to use less support material. (default setting)

- **Surround:** Creates a honey comb of support material that contains the whole model. Surround uses the most support material
- **Number of copies:** Allow the user to set the number of models to be printed (default 1)
- **STL units:** sets the units of measurement used to create the model. Depending on the model one can either chose Inches or Millimeters. (Remember to maintain continuity with your 3D model; one must select the proper unit of measure that the model was drawn with.) (Default setting of Inches)
- **STL scale:** allows for the model to be scaled to any size. (default setting: 1.000)

Under the **Orientation tab**, select the physical orientation of your model for printing. Different orientations can help conserve support material, depending on your model.



For example the buckle shown here is using the least amount of support material because of the flat orientation.

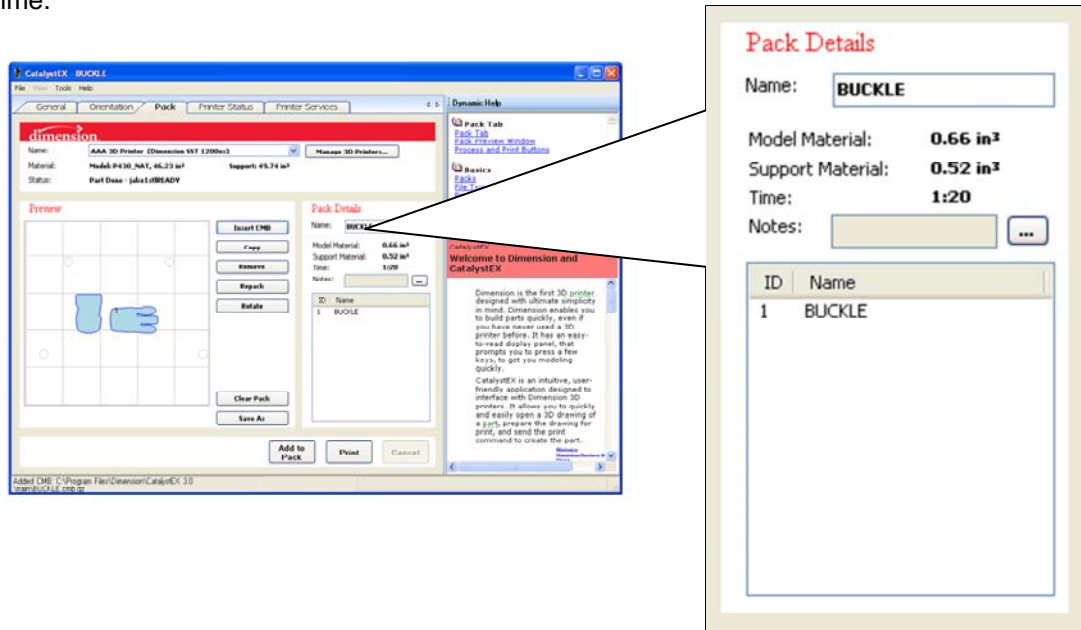
If it were printed with the two parts turned 90 degrees vertically direction it would require more material to keep it stable.

Once the model is in the proper orientation with the desired properties select the **Add to Pack** button at the bottom of the screen.

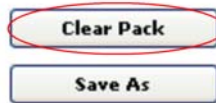


If you wish to add more models to a pack, repeat the process by opening another STL file, assigning it **properties**, designate the **Orientation**, and then **Add to Pack**.

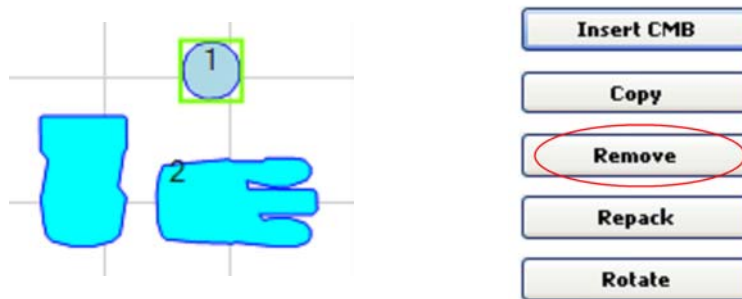
Under the **Pack tab**, the Model Material and Support Material will be displayed in cubic inches, along with estimated time.



If the result of the pack is undesirable and/or there has been or needs to be a change in settings, simply select **clear pack**.



If there are multiple models in one pack (each model is numbered within the blue outline), select the model you wish to remove and it will become highlighted with a green box around it. Then click **Remove**.



Click the  button in CatalystEX.

On the Dimension sst 1200es control panel push the start button to begin the printing process