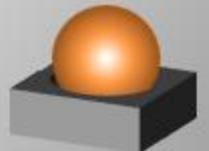


# duinotec

**Duinotech Mini 3D  
Printer TL4076 3D  
Printer Cura Settings**

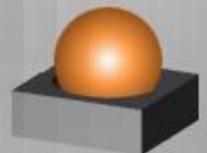
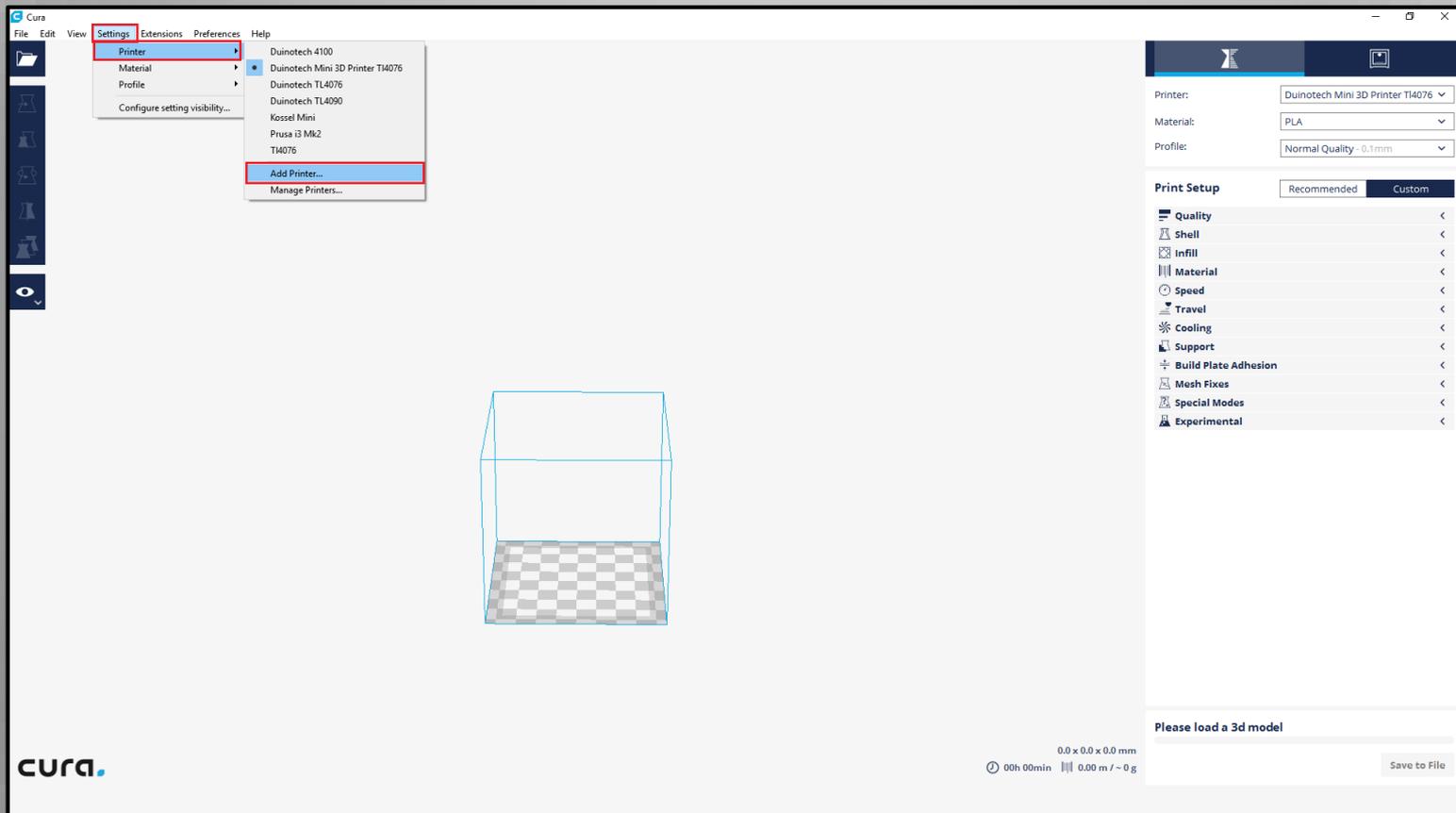


# duinotec

You can download Cura for free from:

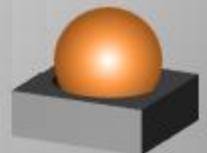
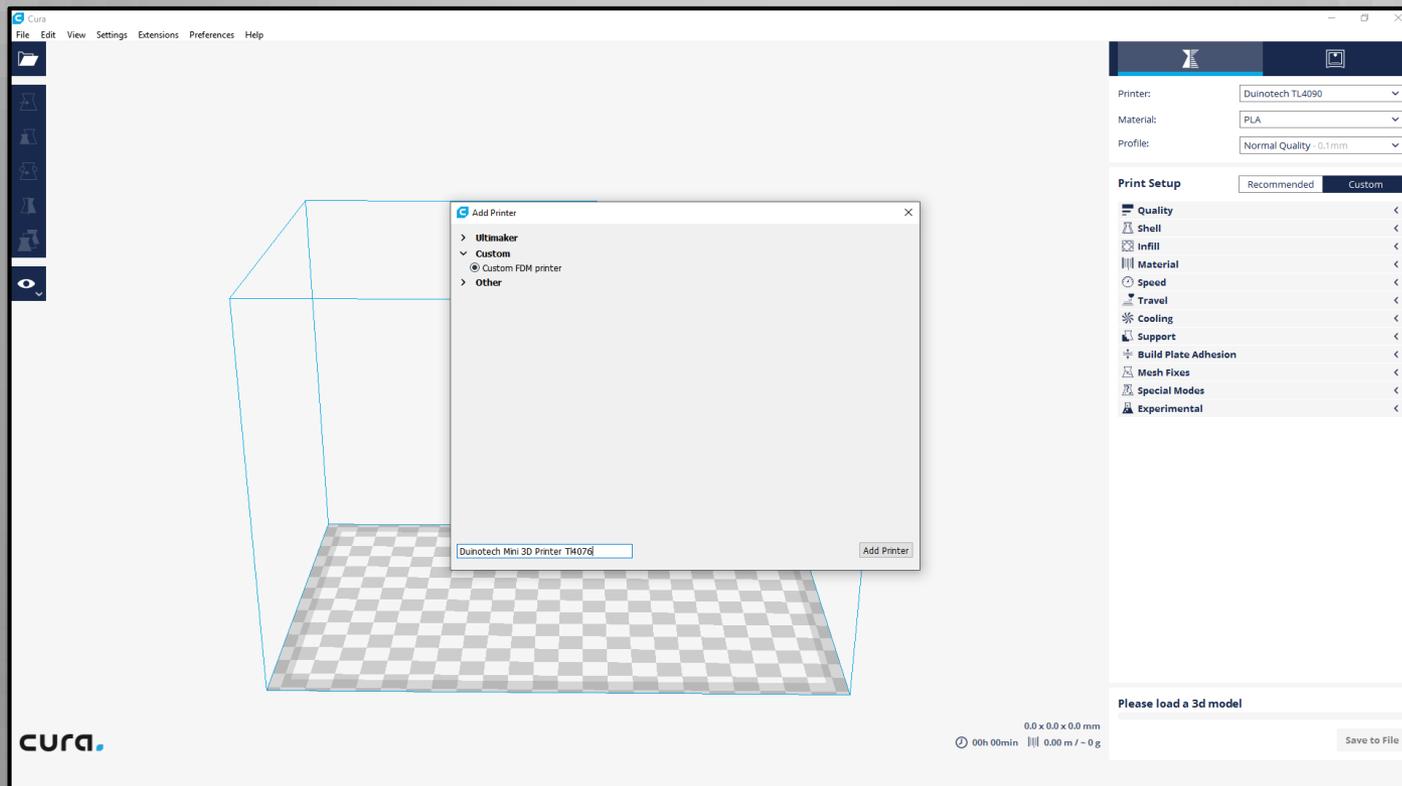
<https://ultimaker.com/en/products/cura-software>

Once installed we go to Setting, Printer, Add Printer



# duinotec

In Add Printer chose **Custom FM printer** and name it what you like. I named mine **Duinotech Mini 3D Printer TL4076** to keep it easy



# duinotec

Now we want to input the dimensions of the printer and change the Start code and End code

The screenshot shows the Cura software interface. The main window displays the 'Add Printer' dialog box, which is used to configure printer settings. The dialog box is divided into several sections:

- Machine Settings:** This section contains fields for X (Width), Y (Depth), and Z (Height), all set to 100 mm. There are also checkboxes for 'Heated Bed' and 'Machine Center is Zero', and a dropdown for 'GCode Flavor' set to 'RepRap (Marlin...)'.
- Pinthead Settings:** This section contains fields for X min (20 mm), Y min (10 mm), X max (10 mm), Y max (10 mm), Gantry height (9999999999 mm), and Nozzle size (0.4 mm).
- Start Gcode:** This section contains a text area with the following code:

```
G28 ;Home
G1 Z15.0 F6000 ;Move the platform down 15mm
;Prime the extruder
G92 E0
G1 F200 E3
G92 E0
```
- End Gcode:** This section contains a text area with the following code:

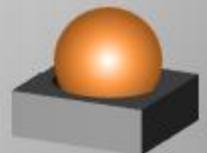
```
M104 S0
M140 S0
;Retract the filament
G92 E1
G1 E-1 F300
G28 X0 Y0
M84
```

A red box highlights the 'Machine size' section, which includes the following values:

- Width:90
- Depth:90
- Height:90
- Nozzle:0.4

The 'Print Setup' sidebar on the right side of the window shows the printer configuration for 'Duinotech Mini 3D Printer T14076'. The material is set to 'PLA' and the profile is 'Normal Quality - 0.1mm'. The sidebar also lists various print settings such as Quality, Shell, Infill, Material, Speed, Travel, Cooling, Support, Build Plate Adhesion, Mesh Fixes, Special Modes, and Experimental.

At the bottom of the window, there is a 'Please load a 3d model' section with a 'Save to File' button. The Cura logo is visible in the bottom left corner.



# duinotec

**We are now going to edit the Start Gcode and End Gcode to the following.**

## **Start Gcode**

**M104 S[first\_layer\_temperature] ; start extruder heat**

**G28 ; home all axes**

**G90 ; use absolute coordinates**

**G21 ; set units to millimeters**

**G92 E0**

**M82 ; use absolute distances for extrusion**

**G1 F5000 Z3 ; move to side of bed for priming**

**M109 S[first\_layer\_temperature] ; wait for extruder heat**

**G1 E20 F200 ; prime the nozzle**

**G1 E15 F500 ; retract**

**G1 F5000 Z10 ; move away from dump area**

**G1 F5000 Y45 ; move away from dump area**

**G92 E0**

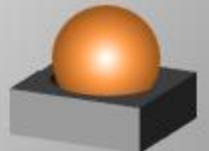
## **End Gcode**

**M104 S0 ; turn off extruder**

**M140 S0 ; turn off bed**

**G28 X0 ; home X axis**

**M84 ; disable motors**



# duinotec

Once entered it will look like this

The screenshot displays the Cura software interface. The main window shows a 3D model of a printer bed with a checkerboard pattern. The 'Add Printer' dialog box is open, showing the 'Machine Settings' section. The 'Print Setup' panel on the right is also visible, showing the printer name 'Duinotech Mini 3D Printer T14076', material 'PLA', and profile 'Normal Quality 0.1mm'. The 'Machine Settings' dialog box has two columns of settings: 'Printer Settings' and 'Printhead Settings'. The 'Start\_Gcode' and 'End\_Gcode' sections are highlighted with a red box.

**Machine Settings**

Please enter the correct settings for your printer below:

**Printer Settings**

X (Width)	90	mm
Y (Depth)	90	mm
Z (Height)	90	mm

Heated Bed  
 Machine Center is Zero

GCode Flavor: RepRap (Marlin...)

**Printhead Settings**

X min	20	mm
Y min	10	mm
X max	10	mm
Y max	10	mm

Gantry height: 9999999999 mm  
Nozzle size: 0.4 mm

**Start\_Gcode**

```
M104 S[first_layer_temperature] ; start extruder heat
G28 ; home all axes
G90 ; use absolute coordinates
G21 ; set units to millimeters
G92 E0
M82 ; use absolute distances for extrusion
G1 F5000 Z3 ; move to side of bed for priming
M109 S[first_layer_temperature] ; wait for extruder heat
G1 E20 F200 ; prime the nozzle
G1 E15 F500 ; retract
G1 F5000 Z10 ; move away from dump area
G1 F5000 Y45 ; move away from dump area
G92 E0
```

**End\_Gcode**

```
M104 S0 ; turn off extruder
M140 S0 ; turn off bed
G28 X0 ; home X axis
M84 ; disable motors
```

**Print Setup**

Printer: Duinotech Mini 3D Printer T14076  
Material: PLA  
Profile: Normal Quality 0.1mm

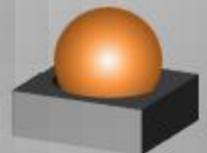
Print Setup: Recommended Custom

- Quality
- Shell
- Infill
- Material
- Speed
- Travel
- Cooling
- Support
- Build Plate Adhesion
- Mesh Fixes
- Special Modes
- Experimental

Please load a 3d model

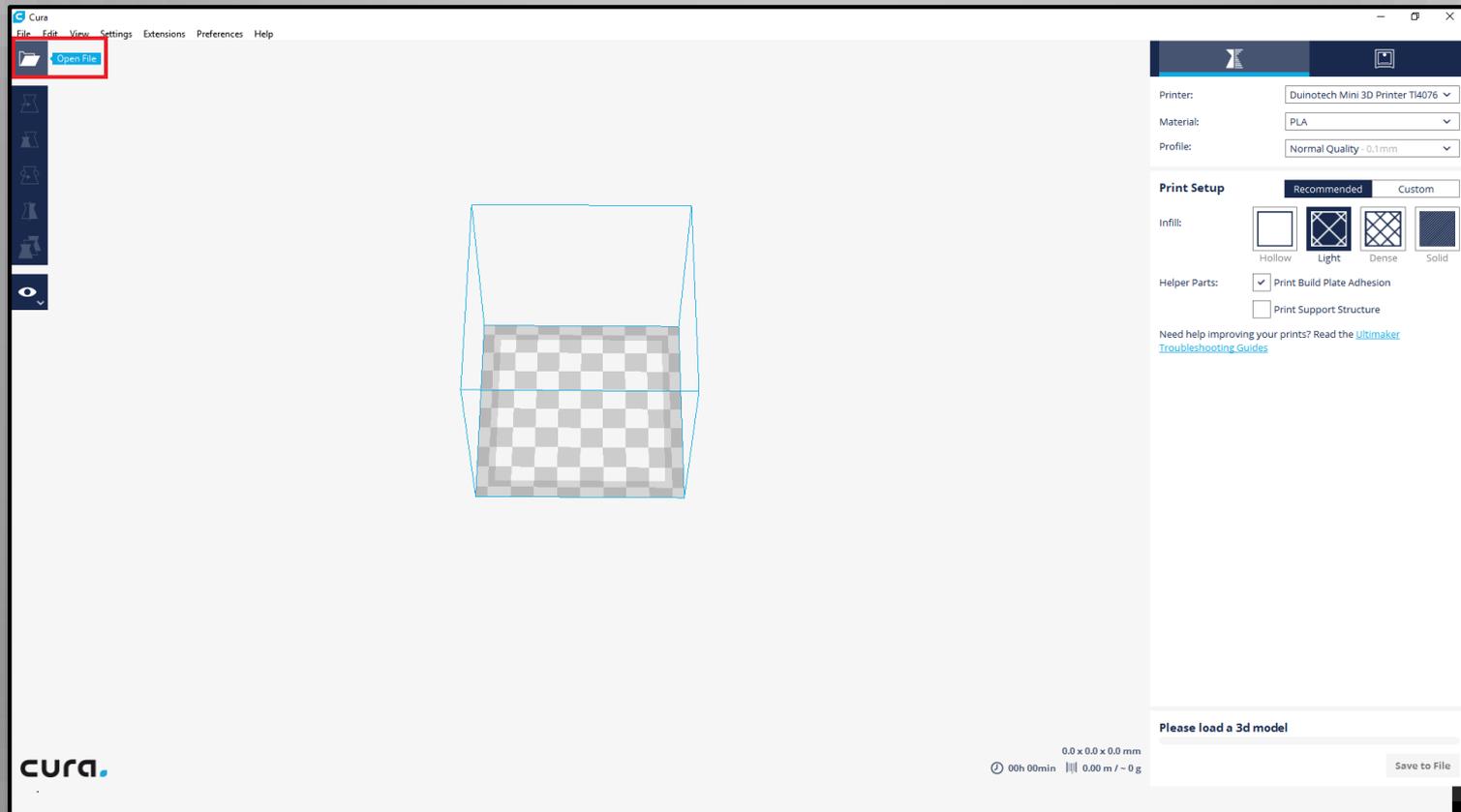
0.0 x 0.0 x 0.0 mm  
00h 00min 0.00 m / -0g

Save to File



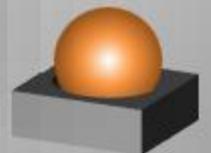
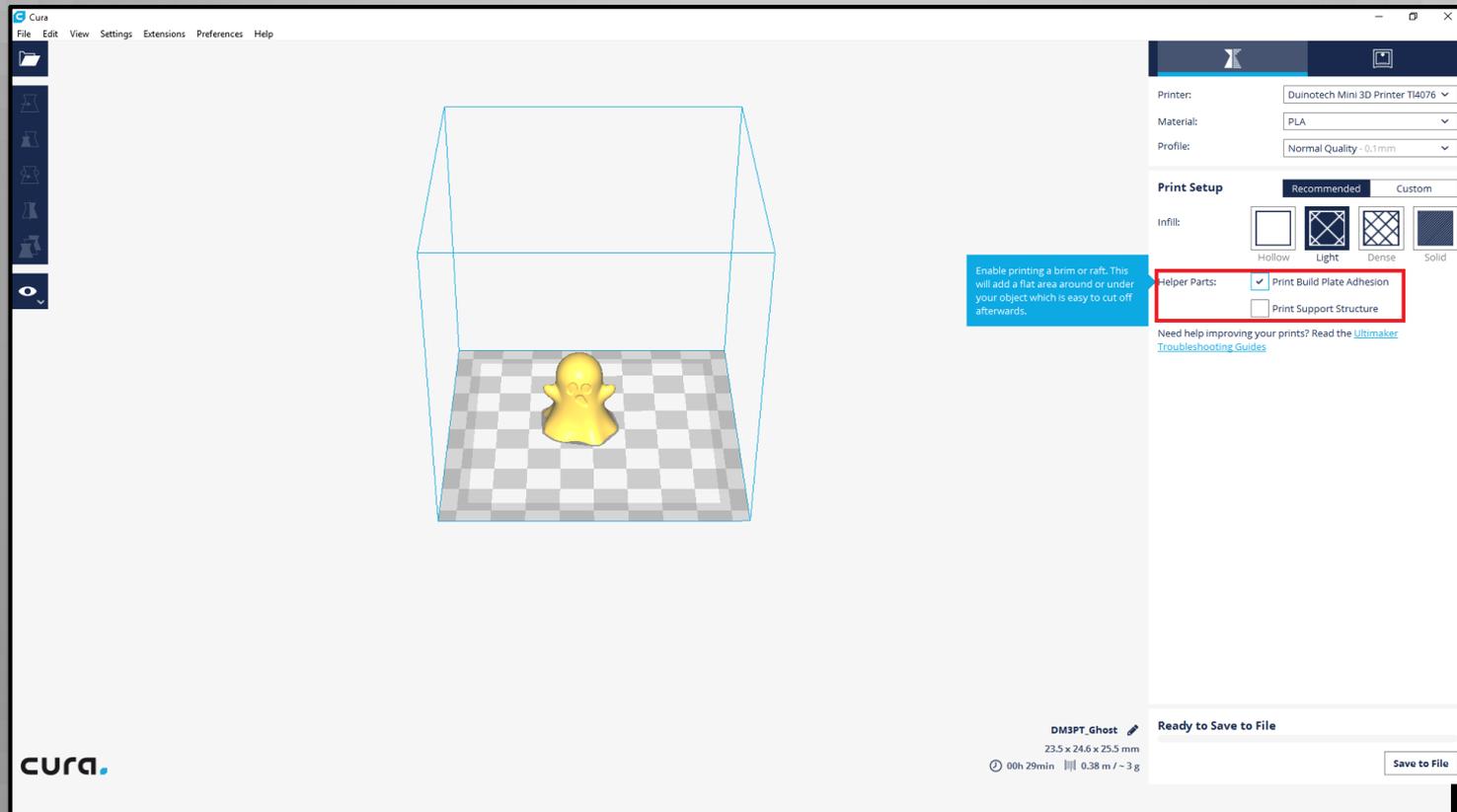
# duinotec

**Now let's print. I will choose the Ghost that comes with the SD card.  
You can download this from <http://www.thingiverse.com/thing:523193>**



# duinotec

Once loaded you will see some options to help you



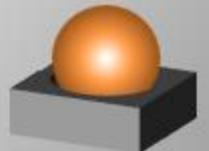
# duinotec

**For example, Build plate Adhesion. Since TL4076 doesn't have a heated build plate this will help your prints stick with the help of our [Blue 3D Printer Bed Tape that we sell in 50m Roll CAT.NO: NM2818](#)**

Enable printing a brim or raft. This will add a flat area around or under your object which is easy to cut off afterwards.

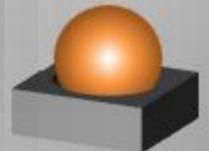
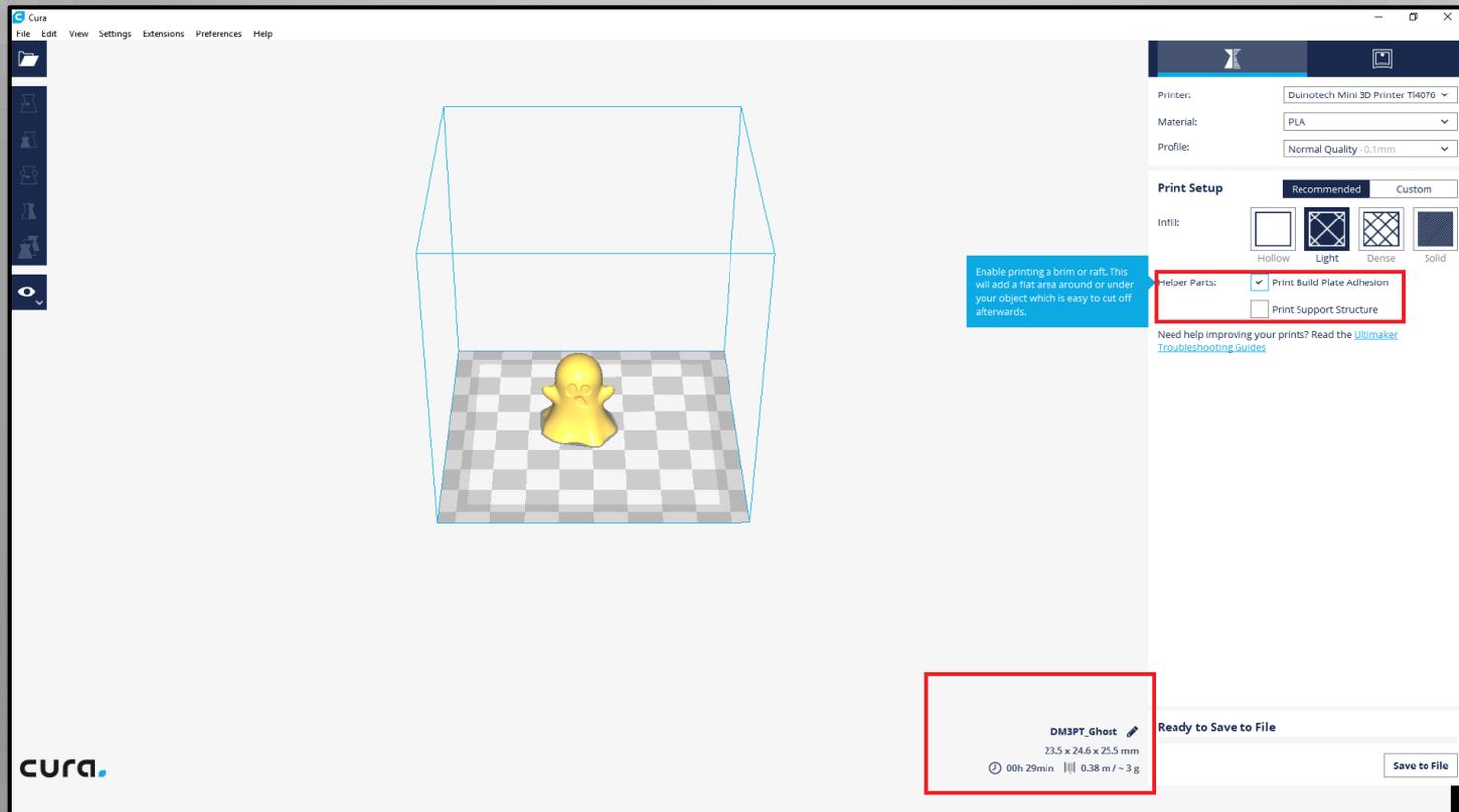
Helper Parts:

- Print Build Plate Adhesion
- Print Support Structure



# duinotec

**Cura will also give you more information like. Size, Print time, how much filament you will use and weight**



# duinotec

## Explanation for key settings :

### Quality

Layer height (mm)

1.Layer height: it's decide the accurate of printed object. The figure is bigger, then the print time is short,however the accurate will be lower, like you set 0.2mm or 0.3mm. If you set 0.1mm, then the accurate will be higher and print time will be longer.

Shell thickness (mm)

2.Shell thickness: it's the thickness of object shell, normally, seller will send 1-1.5mm. More thickness, than need more print time.

### Fill

Bottom/Top thickness (mm)

Fill Density (%)

3. Bottom/Top fill thickness (mm): it's will decide your printed object bottom and top thickness.

4.Fill Density (%): If need your object more stronger, then you can put higher number, maximun is 100. For normal use is 30-50. More high fill %, then the print time will be more, and your model will be more stronger and heavy.

### Speed & Temperature

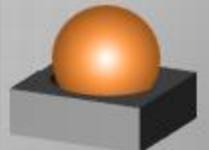
Print speed (mm/s)

5. Print speed (mm/s): it's decide your model accurate and time. Seller has been tested, if you want have good accurate then use 30-40 speed, if you want save time, can raise up to 50-70, but the accurate will be low, but save time. Therefore, this setting will be depend on the model you want.

### Support

Support type

6. Support type: if you want print the suspended object, then you need select the support. Select "everywhere", when you finish printing, it's will need time to clear the support.

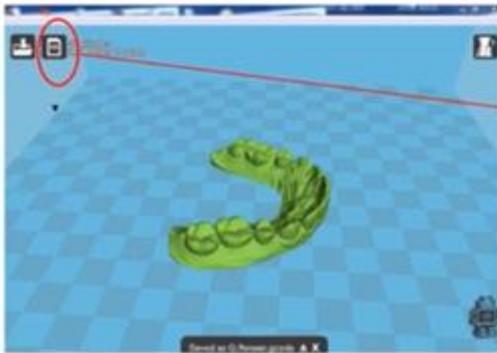


# duinotec

**All that's left now is to print**

SD card method for printer:

Saved to the SD



Copy  
Gcode to sd  
card

1. Slice the STL to be gcode in the CURA, and load it into SD card

2. Save the gcode to SD card from CURA. Insert the SD card into the 3D printer, Connect printer by repeitor-host select the file you want to print.

