

Info

Choose the printer you are using.

The 3D Workshop has:

1x **Ultimaker 2**

3x **Ultimaker 3**

1x **Ultimaker S5**

The PDF will show you how to add all 3

The Ultimaker 2 is the most basic machine. It has a single print head and can only print in PLA plastic. Use it for flat models without any unsupported areas.

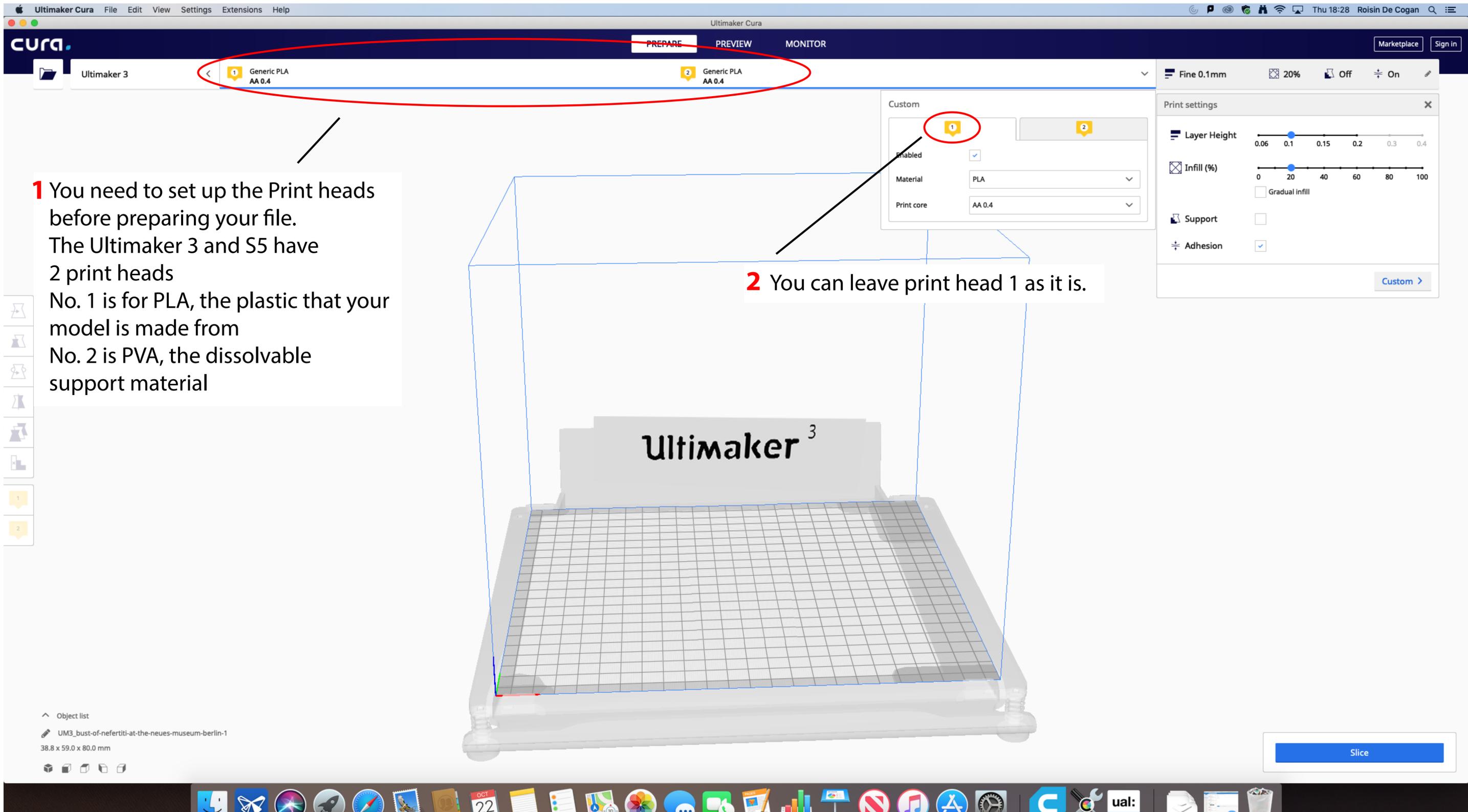
The Ultimaker 3s and S5 are more advanced machines. They have 2 print heads. One prints PLA plastic. The other prints a dissolvable support material which supports any overhanging areas while the hot plastic solidifies. This stops any drooping in the final print on areas like the chin of a person.

The Maximum print sizes are

Ultimaker 2 - 230 x 225 x 205mm.

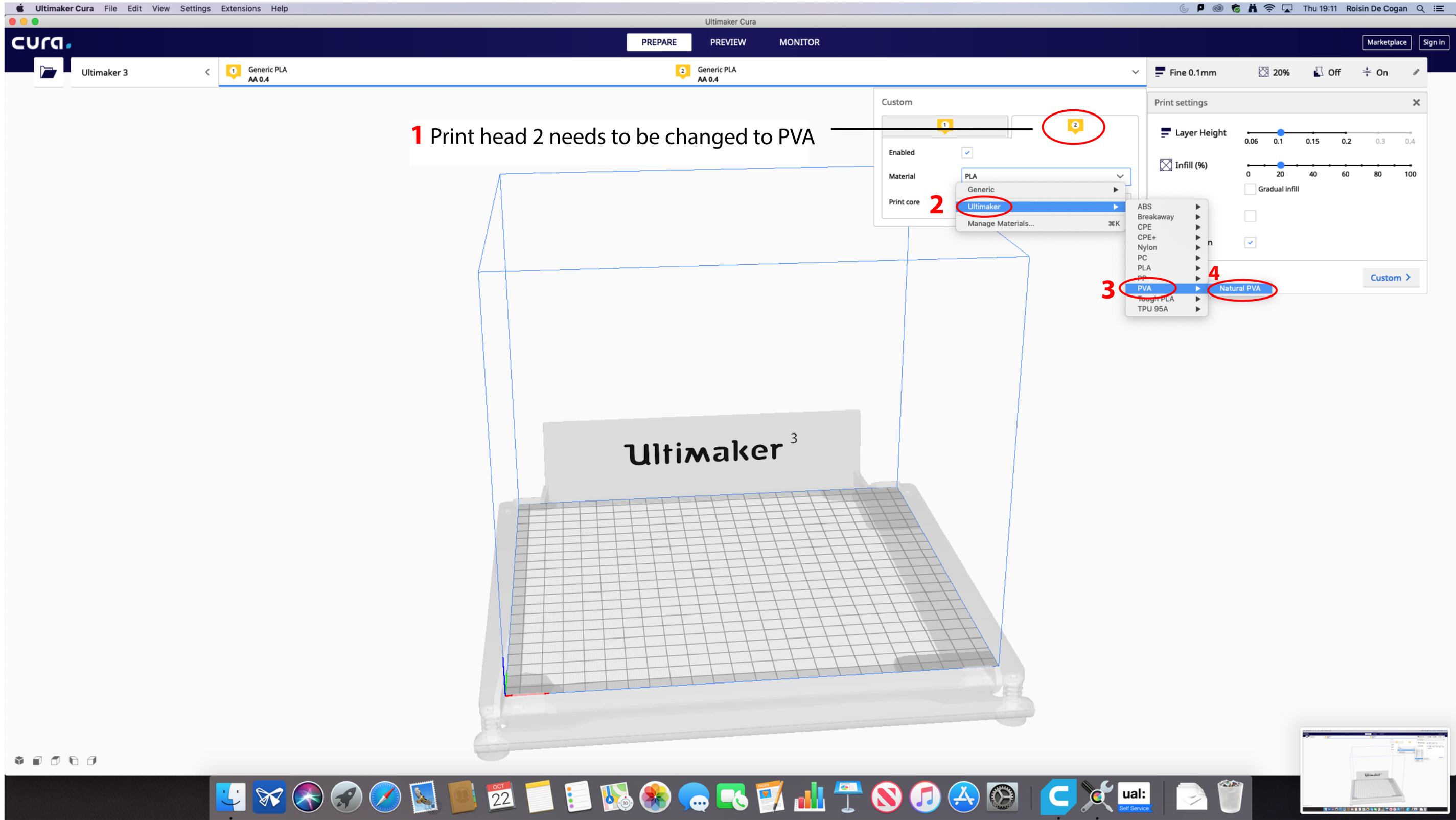
Ultimaker 3 - 169 x 170 x 198mm.

Ultimaker S5 - 308 x 218 x 298mm



1 You need to set up the Print heads before preparing your file. The Ultimaker 3 and S5 have 2 print heads
No. 1 is for PLA, the plastic that your model is made from
No. 2 is PVA, the dissolvable support material

2 You can leave print head 1 as it is.



1 Print head 2 needs to be changed to PVA

Custom

Enabled

Material PLA

Print core **2** **Ultimaker**

- Generic
- 3** PVA
- Manage Materials...
- ABS
- Breakaway
- CPE
- CPE+
- Nylon
- PC
- PLA
- PP
- Tough PLA
- TPU 95A

4 Natural PVA

Print settings

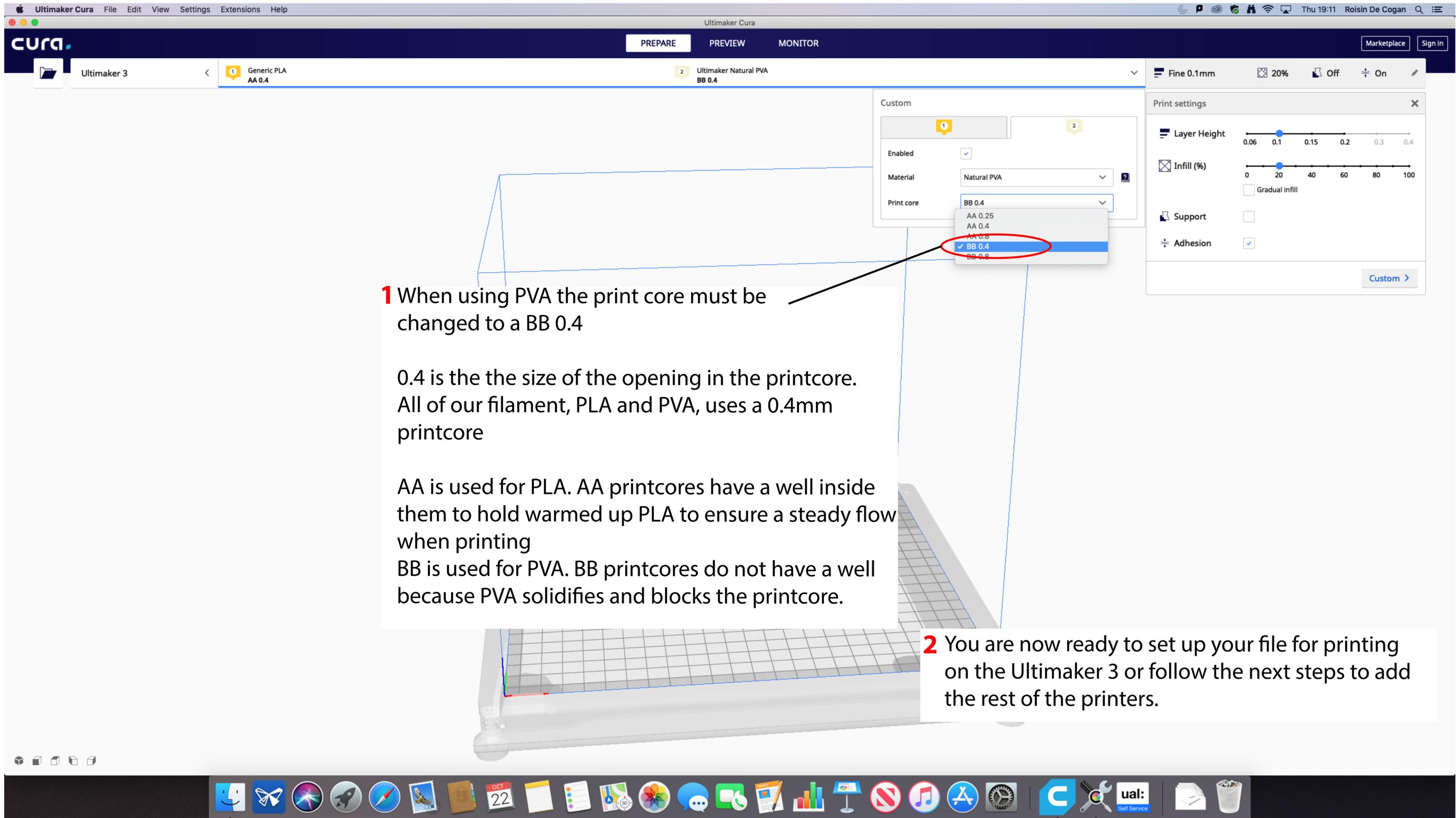
Fine 0.1mm 20% Off On

Layer Height 0.06 0.1 0.15 0.2 0.3 0.4

Infill (%) 0 20 40 60 80 100

Gradual infill

Custom >



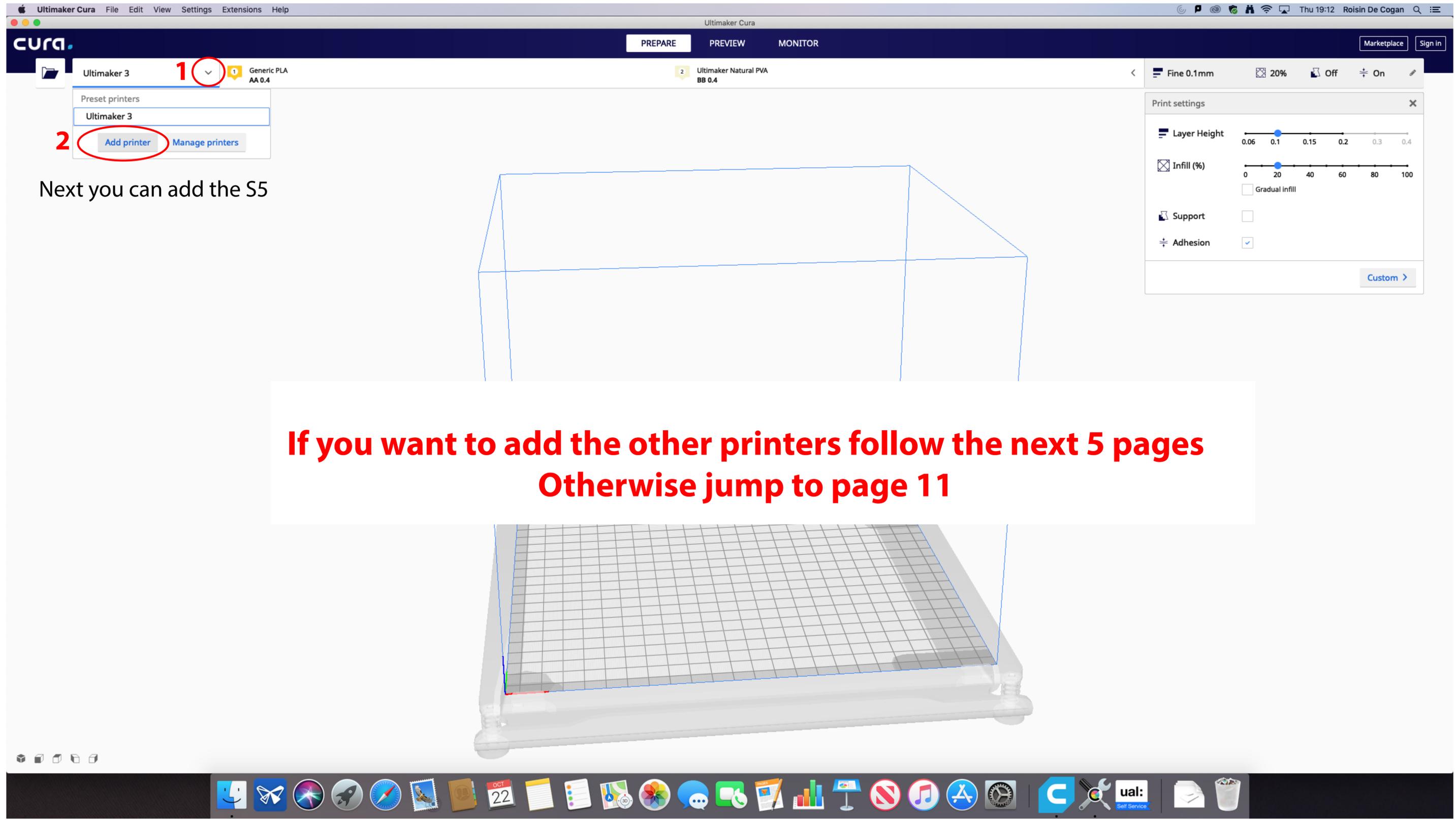
1 When using PVA the print core must be changed to a BB 0.4

0.4 is the the size of the opening in the printcore. All of our filament, PLA and PVA, uses a 0.4mm printcore

AA is used for PLA. AA printcores have a well inside them to hold warmed up PLA to ensure a steady flow when printing

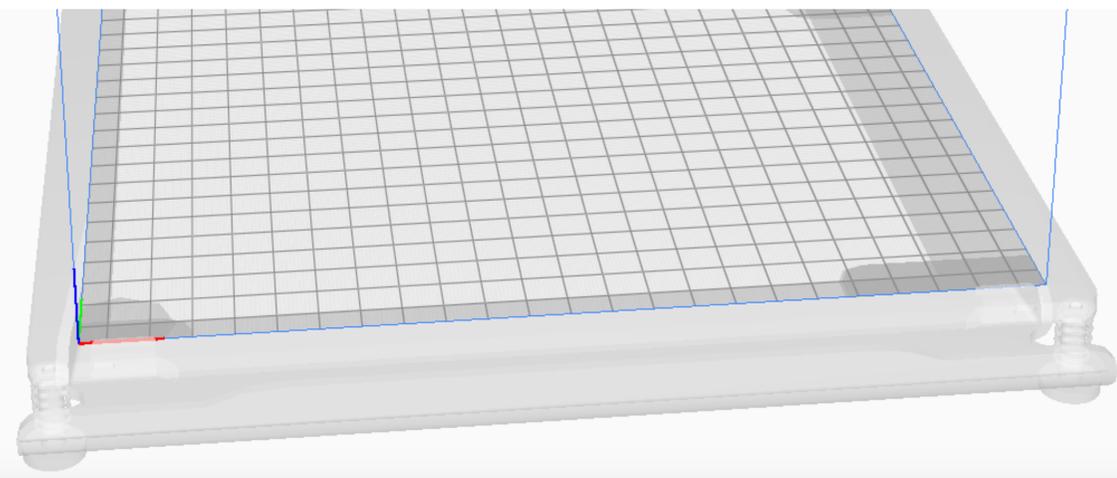
BB is used for PVA. BB printcores do not have a well because PVA solidifies and blocks the printcore.

2 You are now ready to set up your file for printing on the Ultimaker 3 or follow the next steps to add the rest of the printers.



Next you can add the S5

**If you want to add the other printers follow the next 5 pages
Otherwise jump to page 11**



Print settings

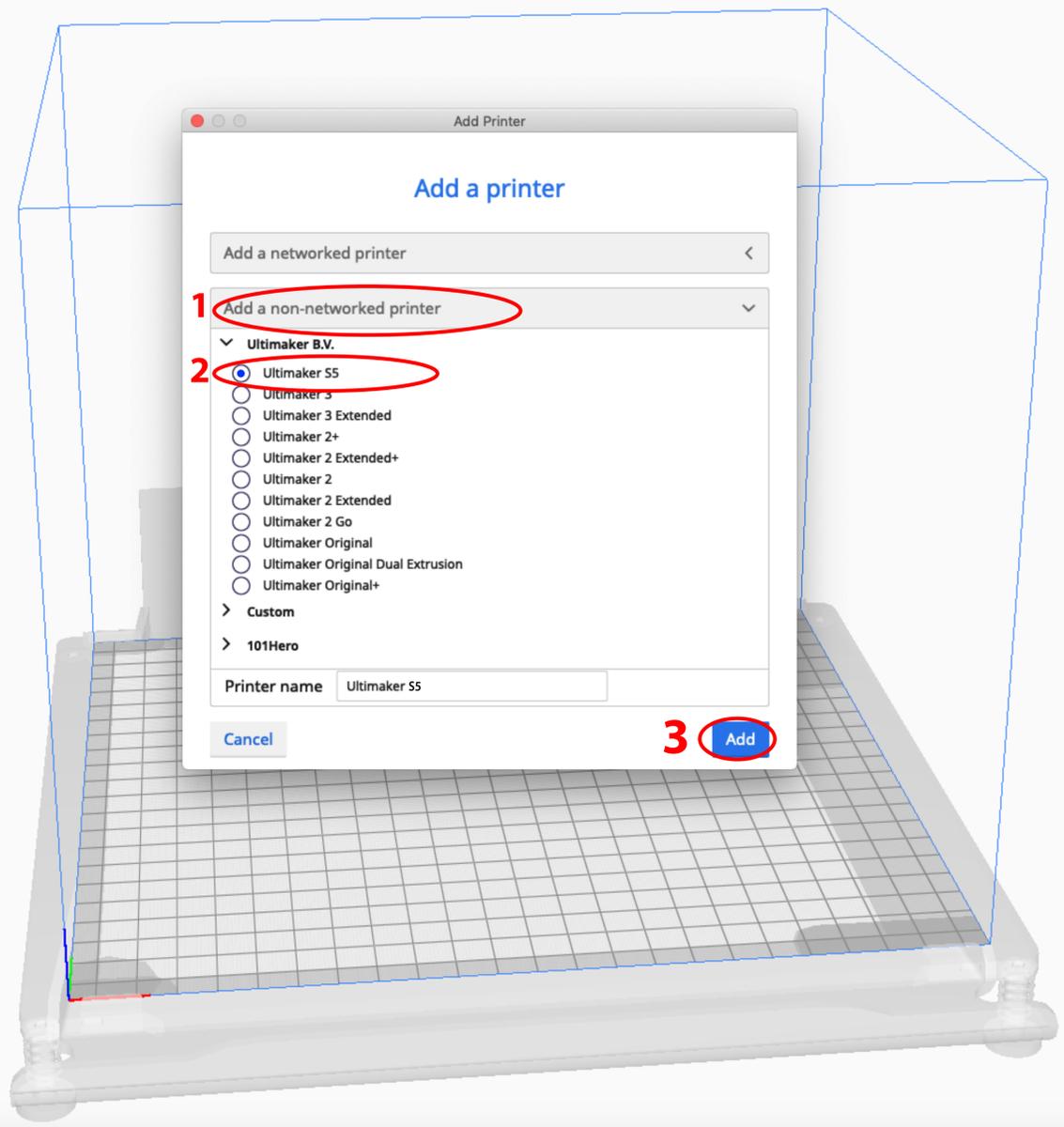
Layer Height 0.06 0.1 0.15 0.2 0.3 0.4

Infill (%) 0 20 40 60 80 100
 Gradual infill

Support

Adhesion

Custom >



Add a printer

Add a networked printer <

1 Add a non-networked printer >

2 Ultimaker B.V.

- Ultimaker S5
- Ultimaker 5
- Ultimaker 3 Extended
- Ultimaker 2+
- Ultimaker 2 Extended+
- Ultimaker 2
- Ultimaker 2 Extended
- Ultimaker 2 Go
- Ultimaker Original
- Ultimaker Original Dual Extrusion
- Ultimaker Original+

> Custom

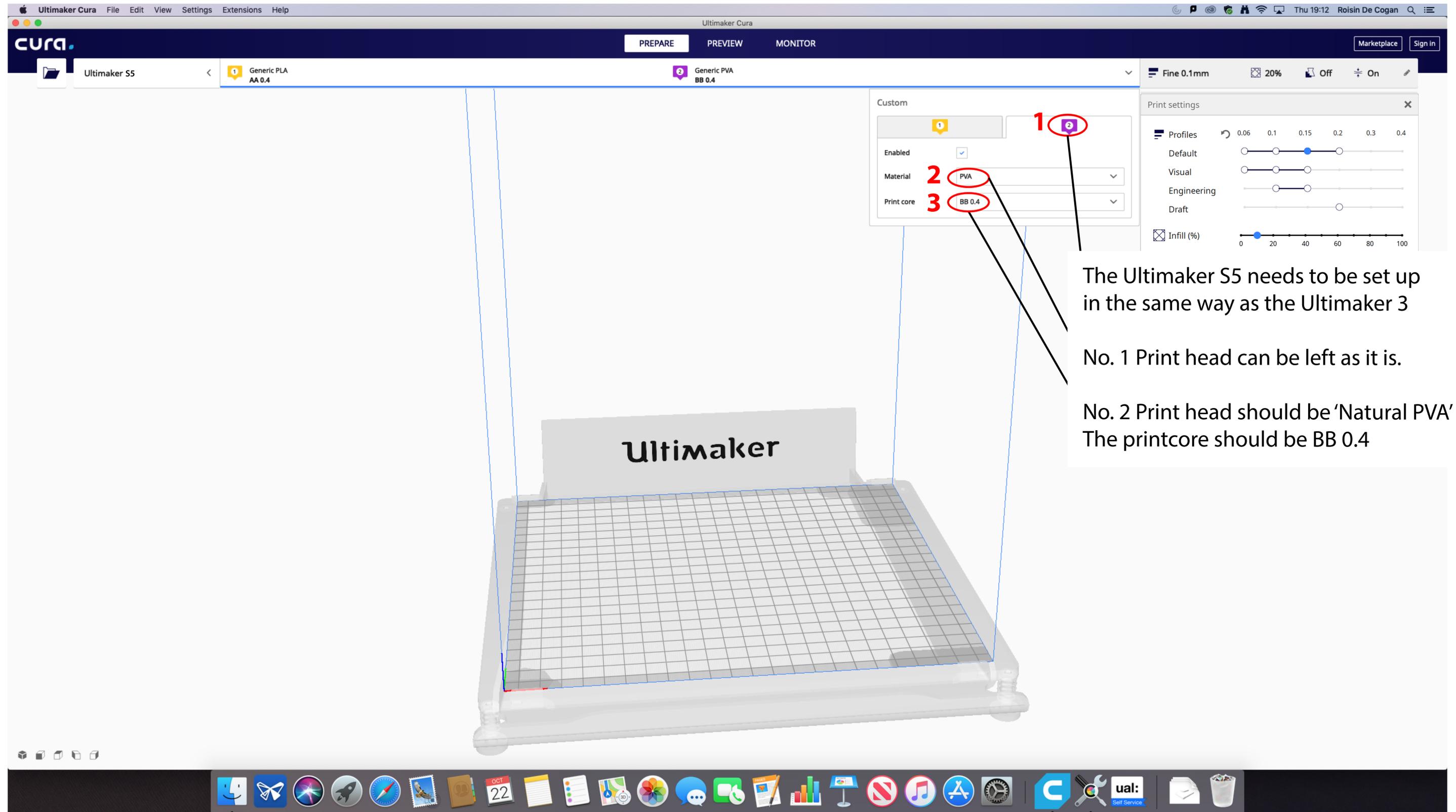
> 101Hero

Printer name Ultimaker S5

3 Add

Cancel

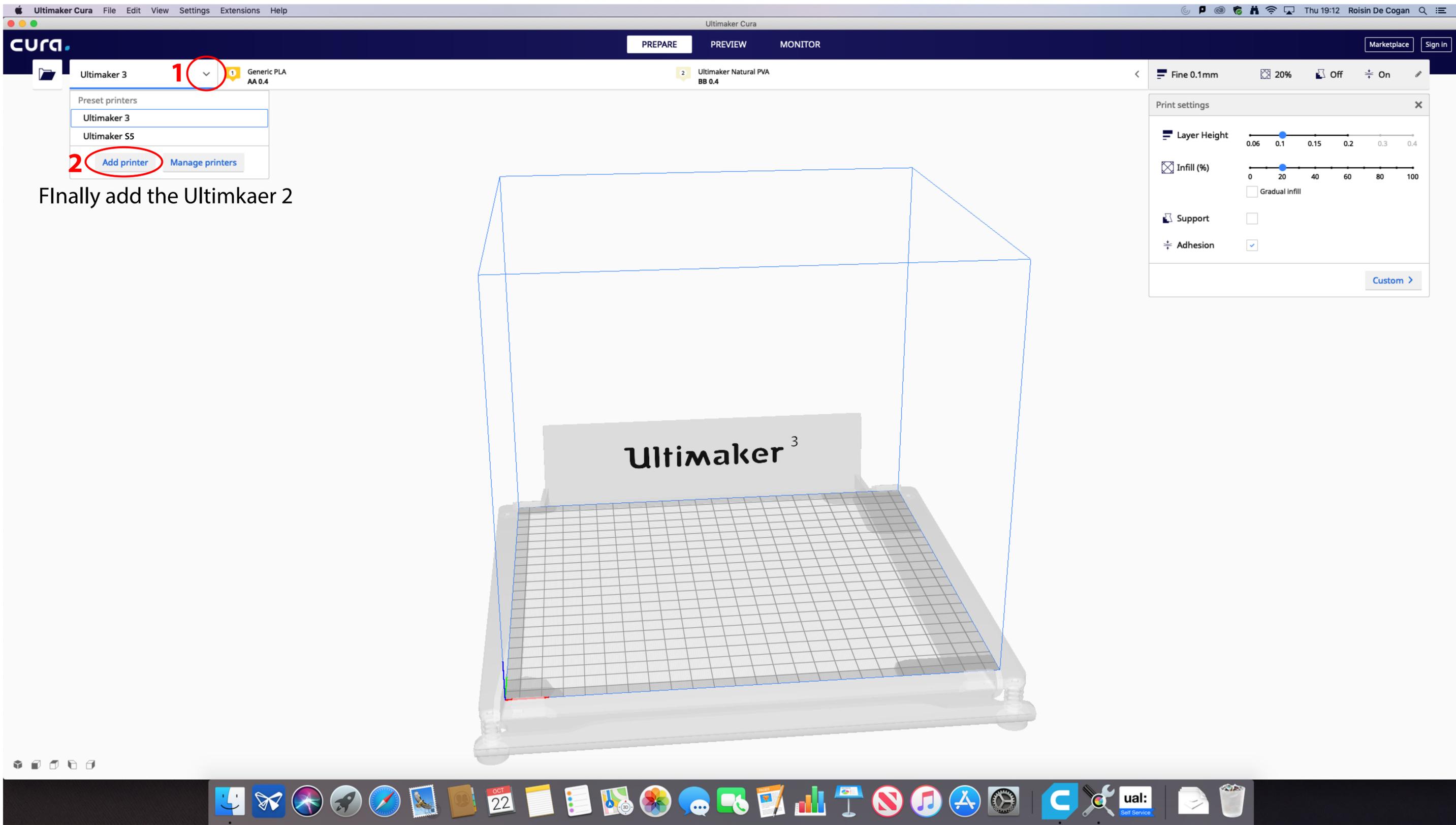




The Ultimaker S5 needs to be set up in the same way as the Ultimaker 3

No. 1 Print head can be left as it is.

No. 2 Print head should be 'Natural PVA'
The printcore should be BB 0.4



Finally add the Ultimaker 2

Print settings

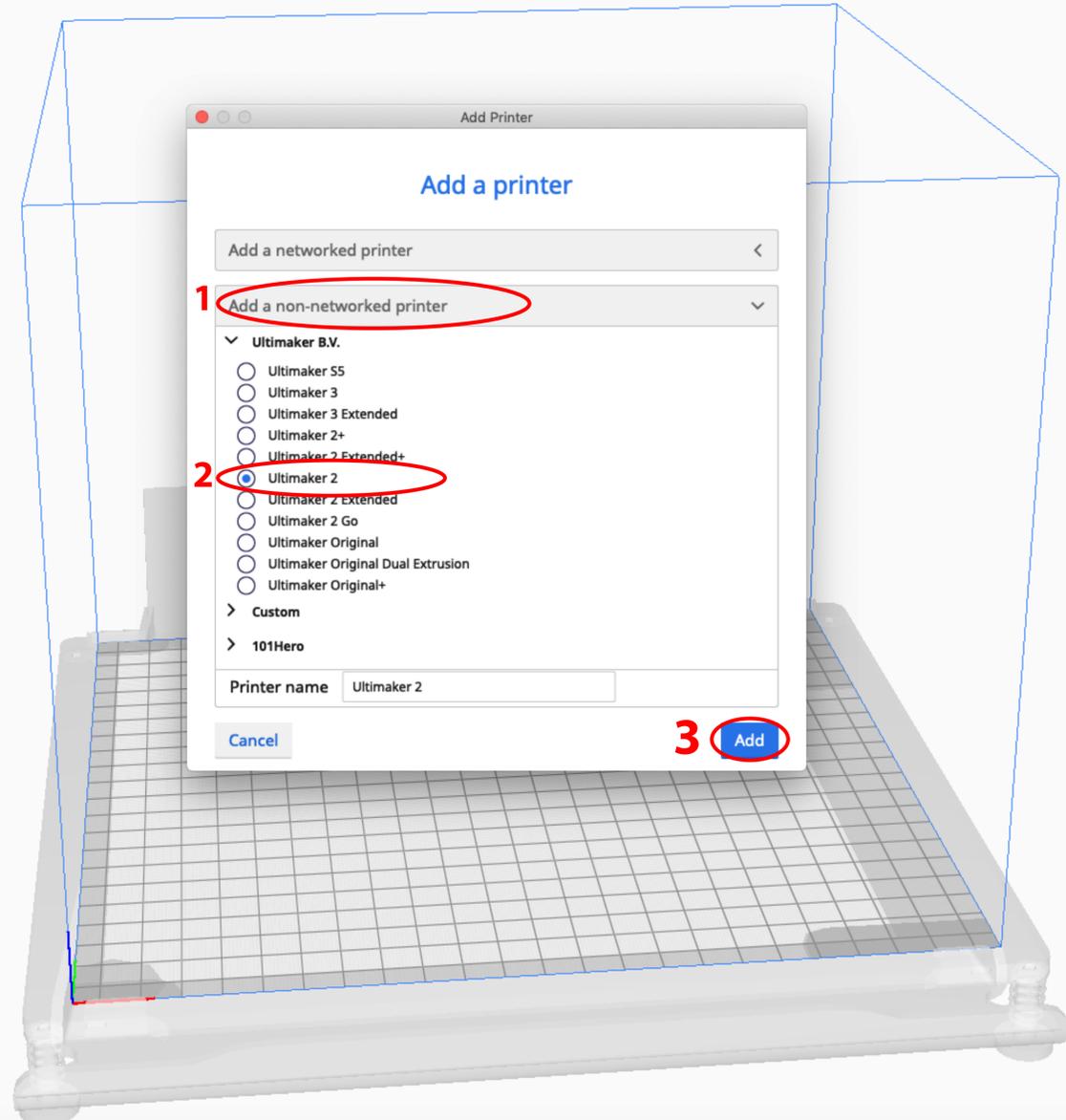
Layer Height 0.06 0.1 0.15 0.2 0.3 0.4

Infill (%) 0 20 40 60 80 100
 Gradual infill

Support

Adhesion

Custom >



Add Printer

Add a printer

Add a networked printer <

1 Add a non-networked printer >

Ultimaker B.V.

- Ultimaker S5
- Ultimaker 3
- Ultimaker 3 Extended
- Ultimaker 2+
- Ultimaker 2 Extended+
- 2 Ultimaker 2
- Ultimaker 2 Extended
- Ultimaker 2 Go
- Ultimaker Original
- Ultimaker Original Dual Extrusion
- Ultimaker Original+

> Custom

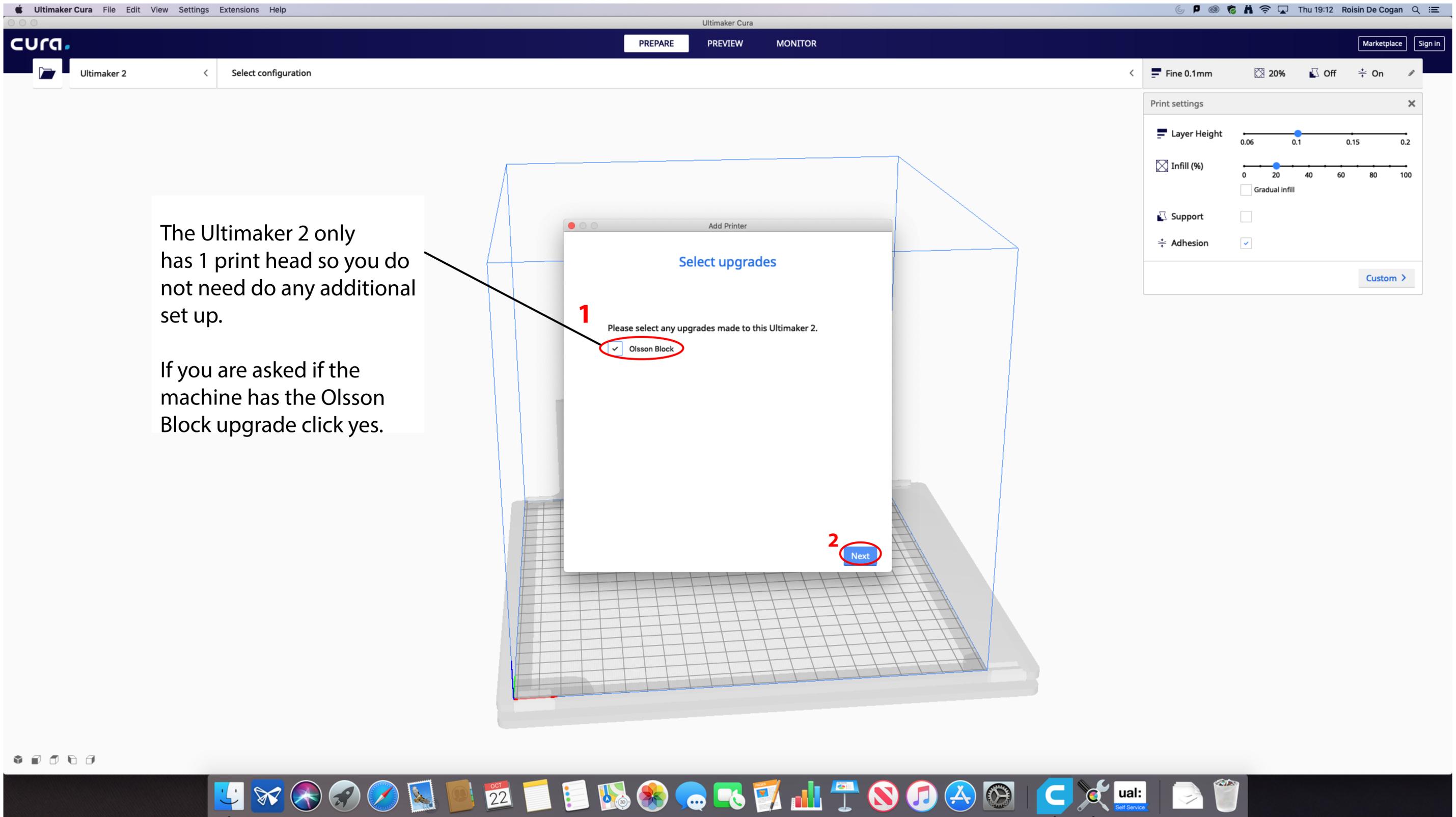
> 101Hero

Printer name Ultimaker 2

3 Add

Cancel



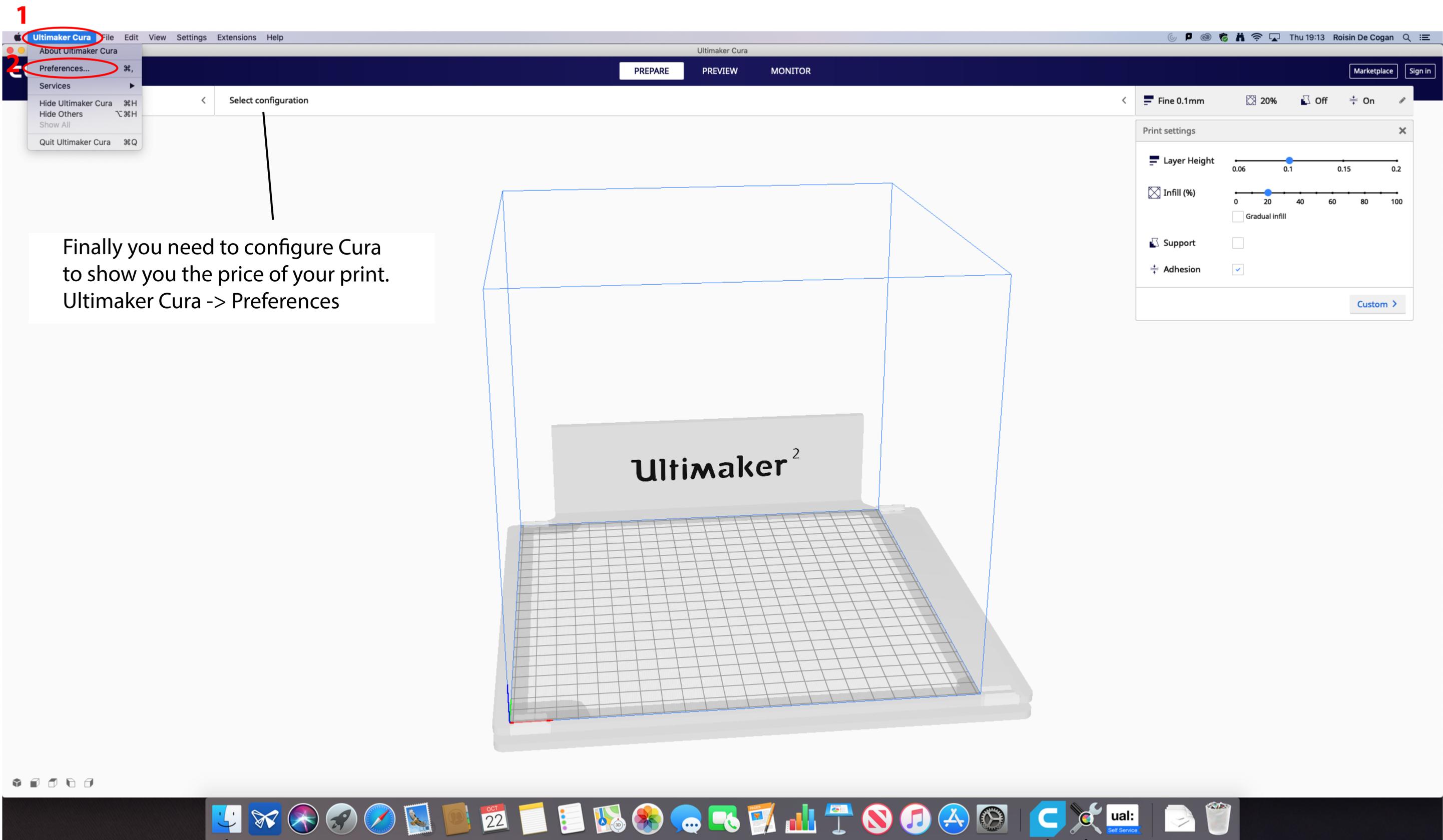


The Ultimaker 2 only has 1 print head so you do not need do any additional set up.

If you are asked if the machine has the Olsson Block upgrade click yes.

1

2



1

- File
- Edit
- View
- Settings
- Extensions
- Help
- About Ultimaker Cura
- Preferences... ⌘,
- Services
- Hide Ultimaker Cura ⌘H
- Hide Others ⌘⇧H
- Show All
- Quit Ultimaker Cura ⌘Q

PREPARE PREVIEW MONITOR

Select configuration

Fine 0.1mm 20% Off On

Print settings

Layer Height 0.06 0.1 0.15 0.2

Infill (%) 0 20 40 60 80 100

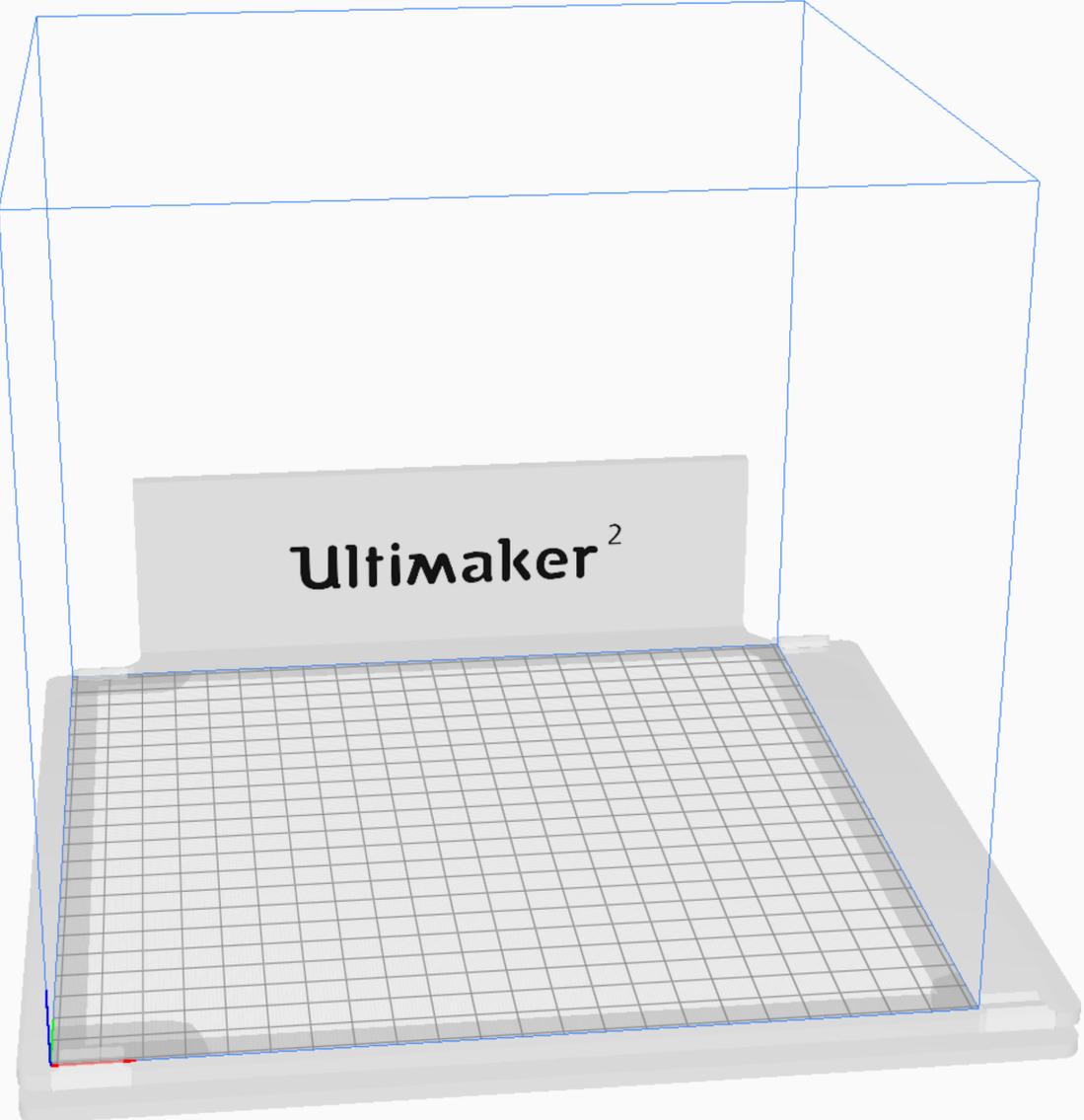
Gradual infill

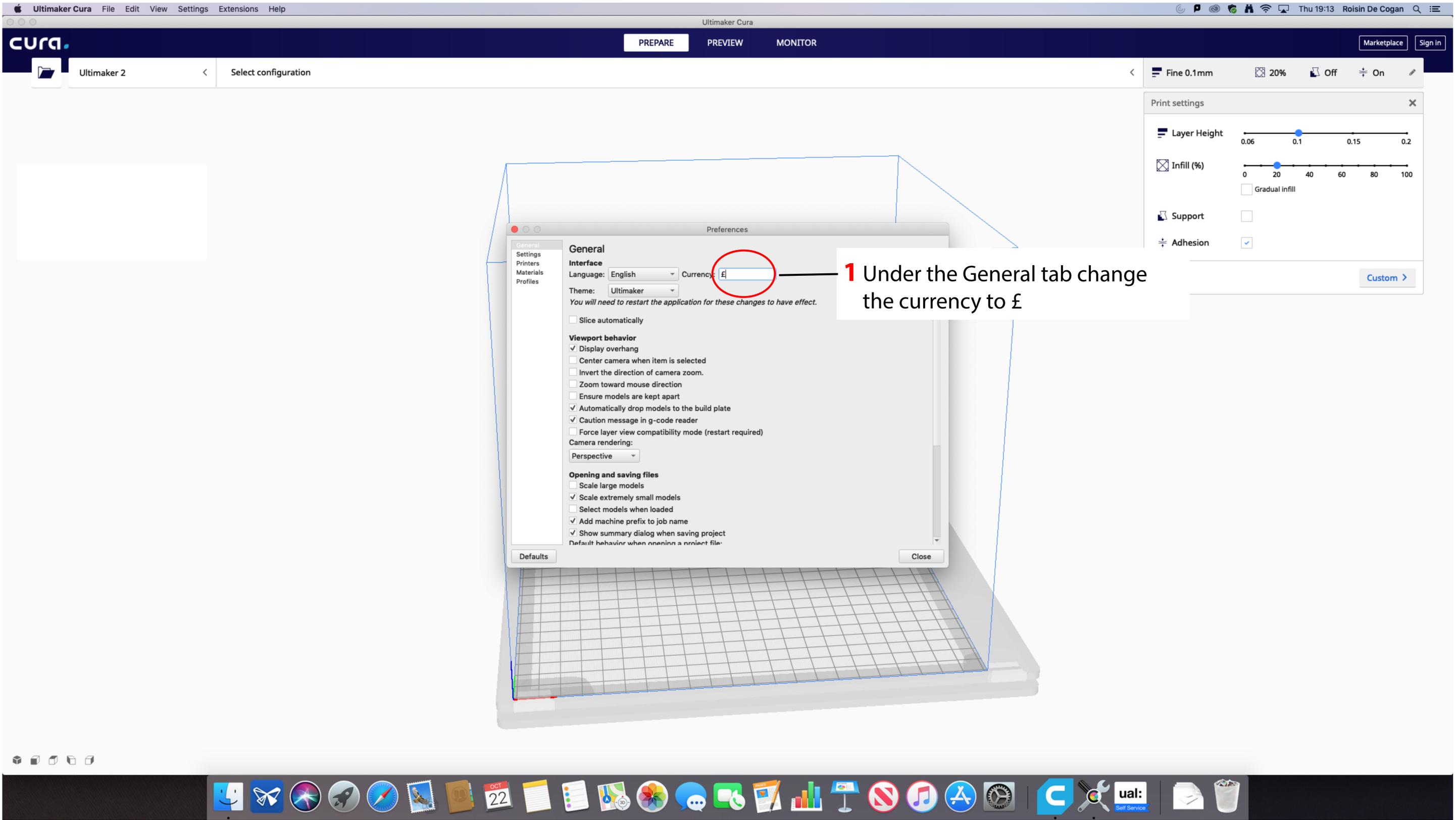
Support

Adhesion

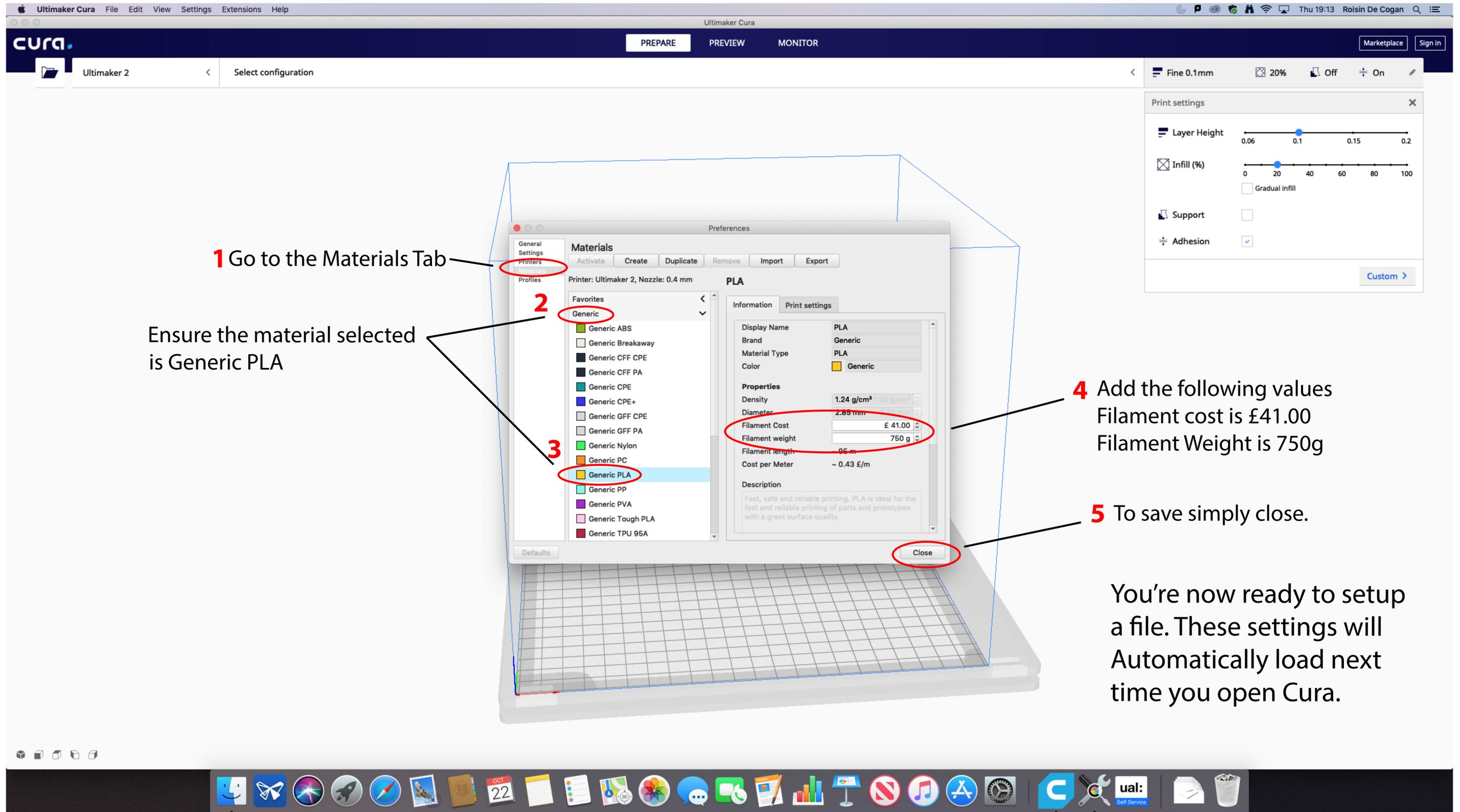
Custom >

Finally you need to configure Cura to show you the price of your print. Ultimaker Cura -> Preferences





1 Under the General tab change the currency to £



1 Go to the Materials Tab

Ensure the material selected is Generic PLA

2

3

4 Add the following values
Filament cost is £41.00
Filament Weight is 750g

5 To save simply close.

You're now ready to setup a file. These settings will Automatically load next time you open Cura.