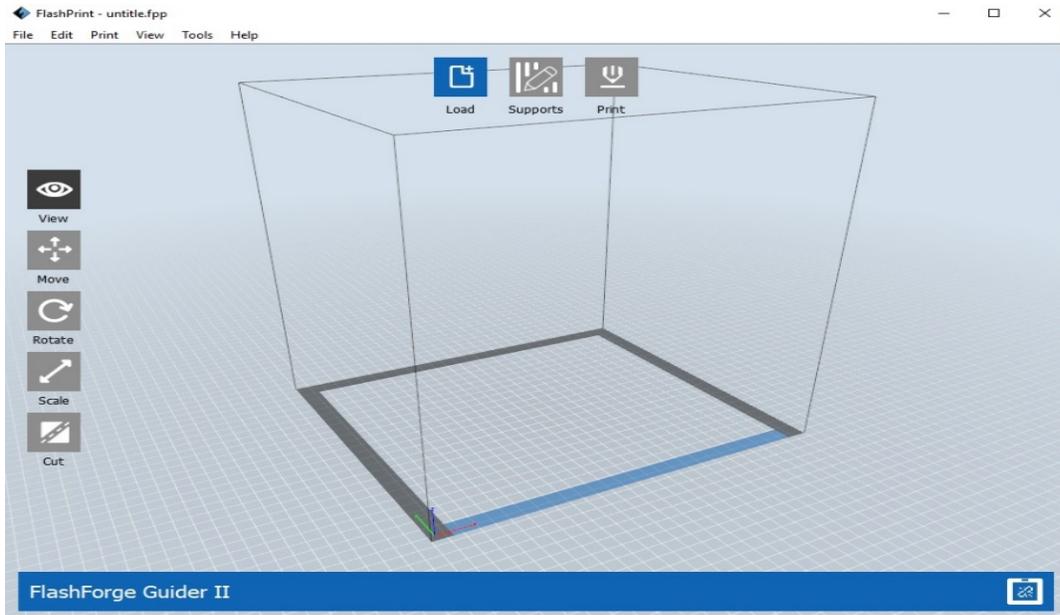
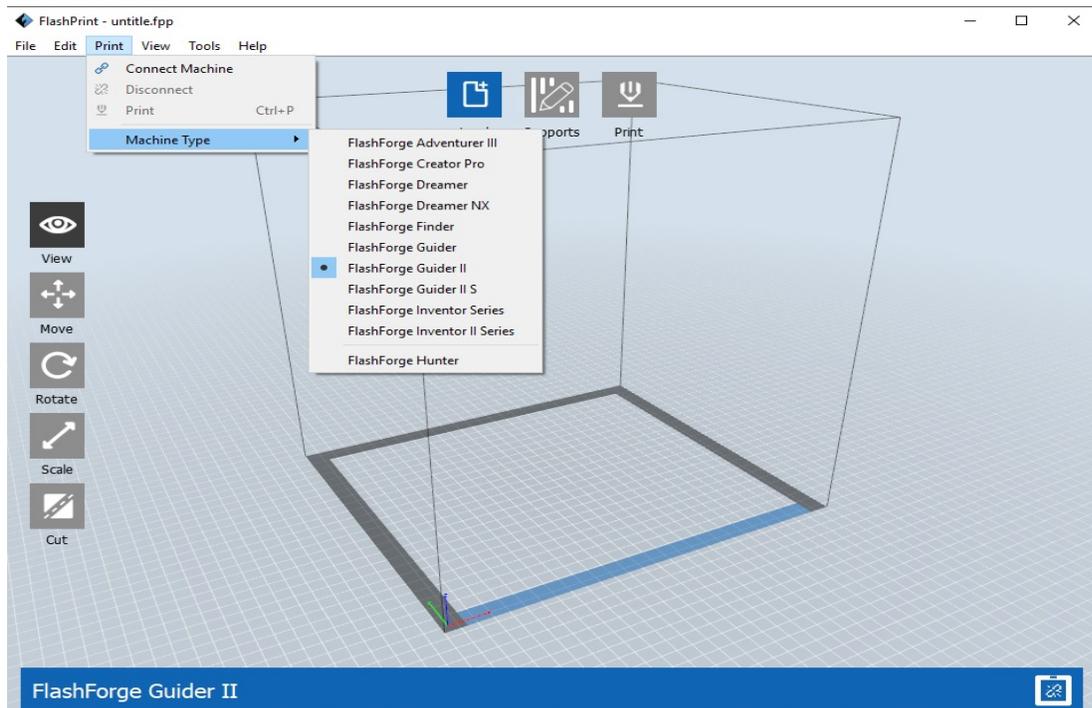


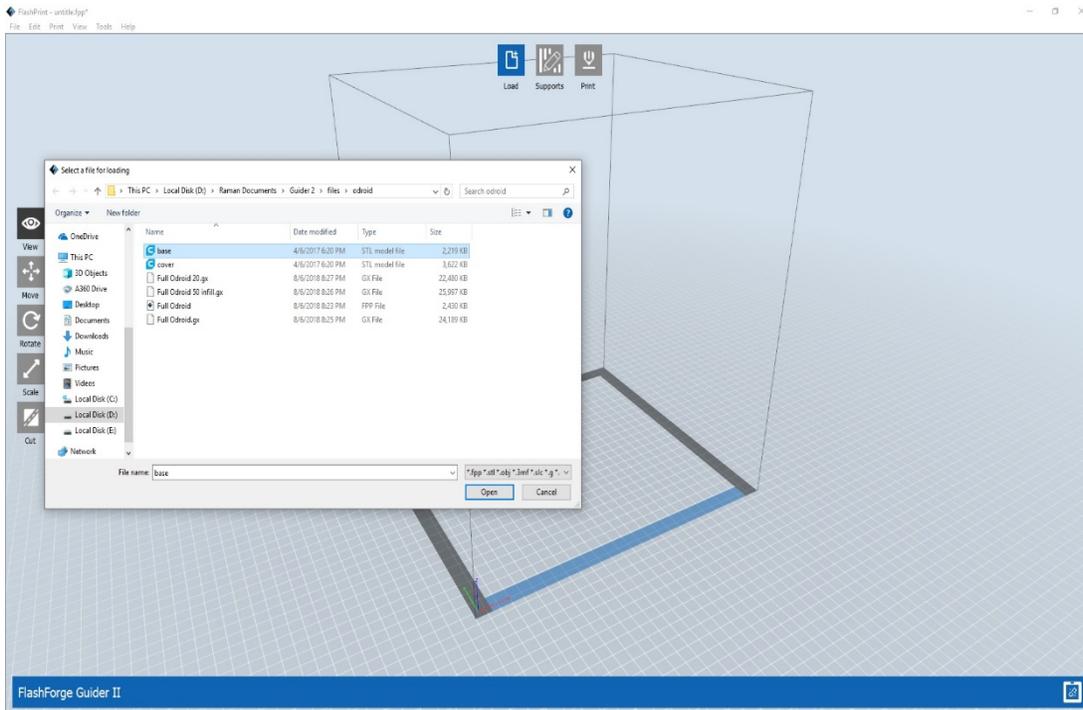
1. Open FlashPrint Software
Blue Line is the front of the machine



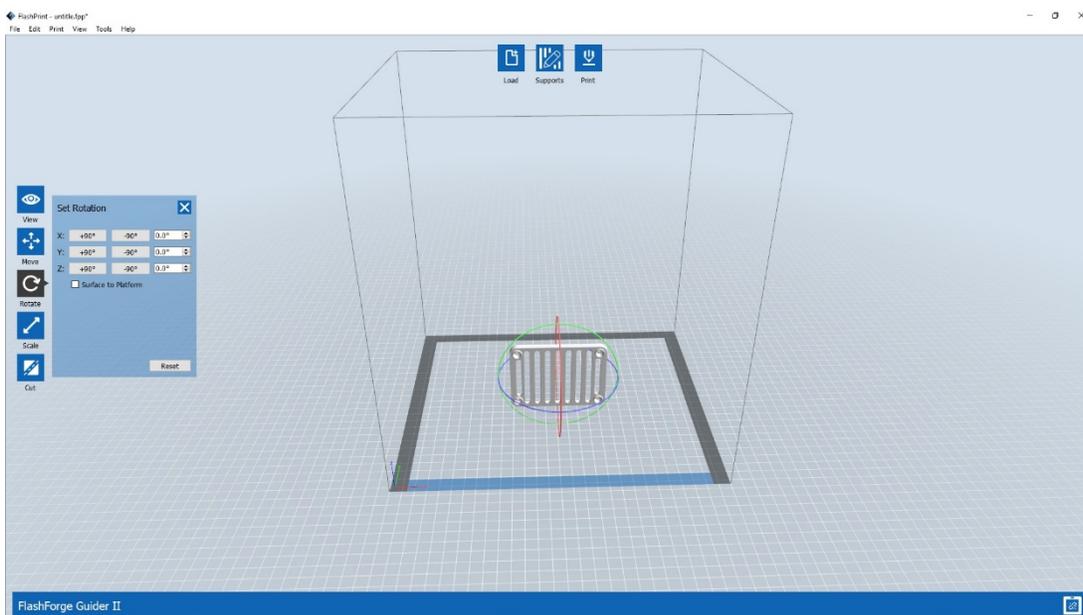
2. Select Printer as FlashForge Guider 2



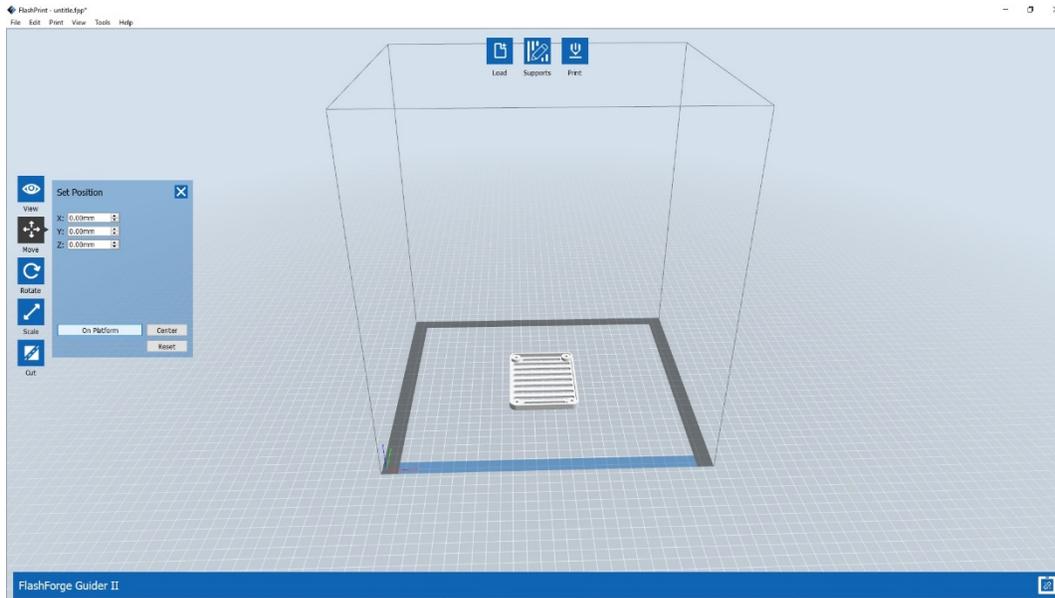
3. Load the 3D design File Preferable format “.stl “



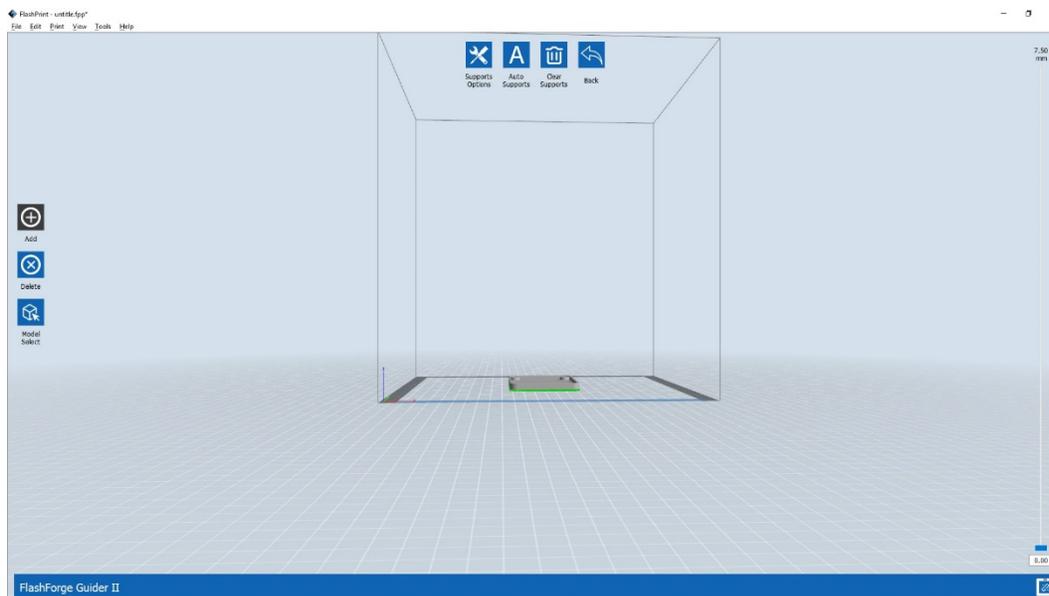
- 4. Rotate the structure to lay flat on the bed .
- Select the structure before rotating
- Hold Right Click to change the whole bed orientation
- Hold Left Click to move the bed



5. Move the design with the controls on the software
Make sure the designed is centered
Make sure the design is laid Flat on the bed
Once flat, blue color is highlighted on the surface touching the bed



6. Move to Supports Tab
Click Auto Support
Change the support type according to design



7.- Click Print Tab

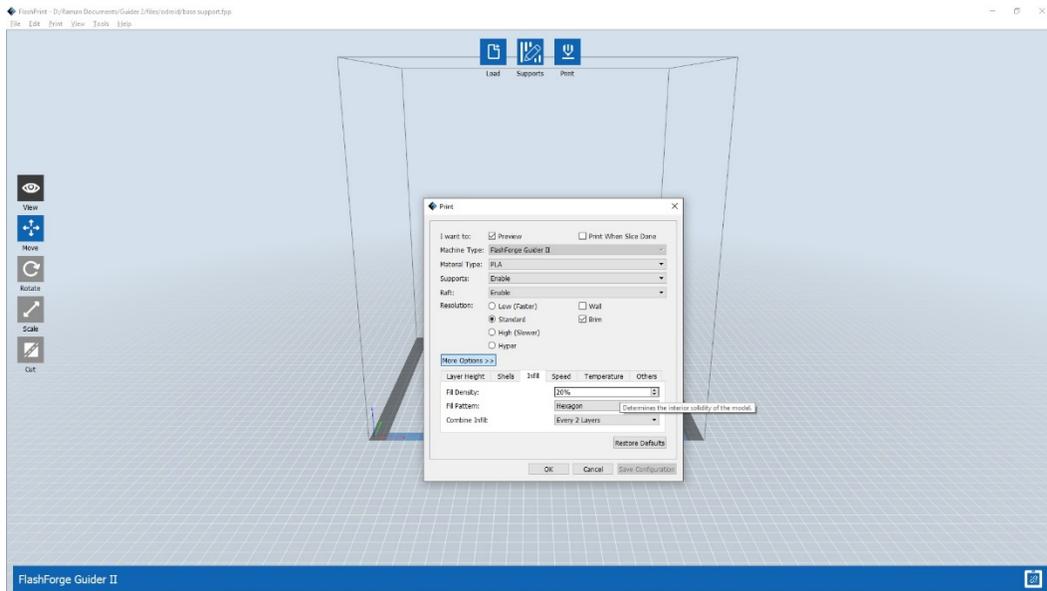
Choose material as PLA unless different Material is being used

Vary Speed according to Quality needed , faster Speed gives less surface finish and vice Versa

Change the infill accordingly to make structure light and strong

Temperature for PLA is 220 Degree C, Different materials have different temperature settings

Save Configuration



8-Press OK to generate gcode file

