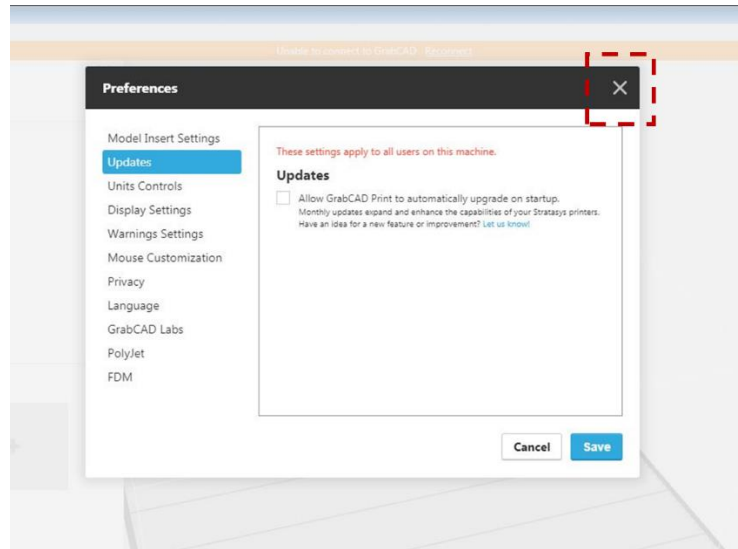
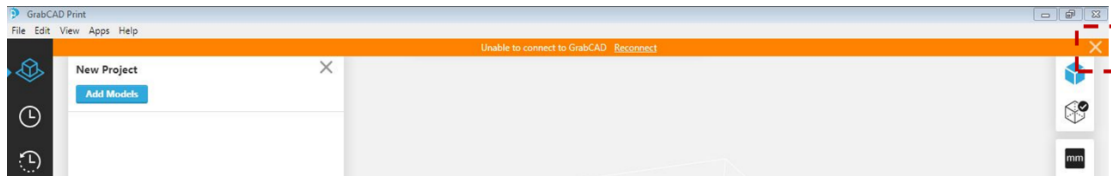


6. On the next window that appears please close the window by selecting the “X” in the upper right corner.

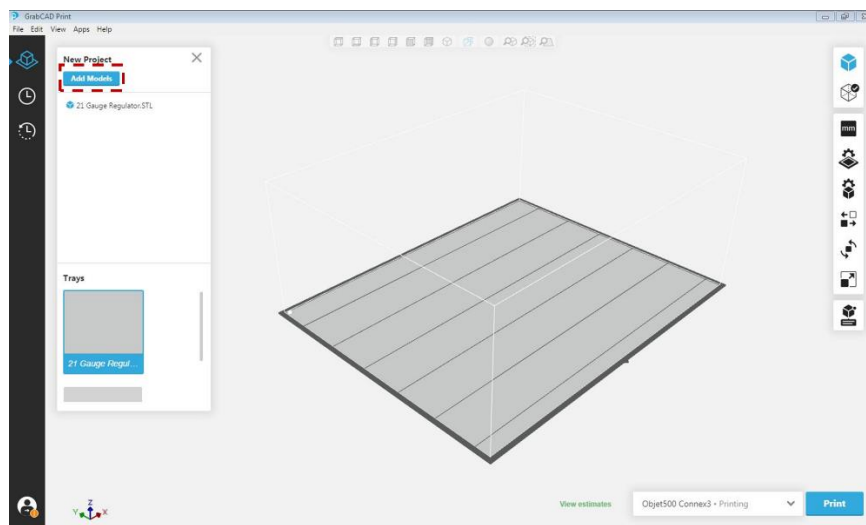


7. Finally, close the Orange Bar at the top of the window by selecting the “X” on the right side of the Orange Bar.

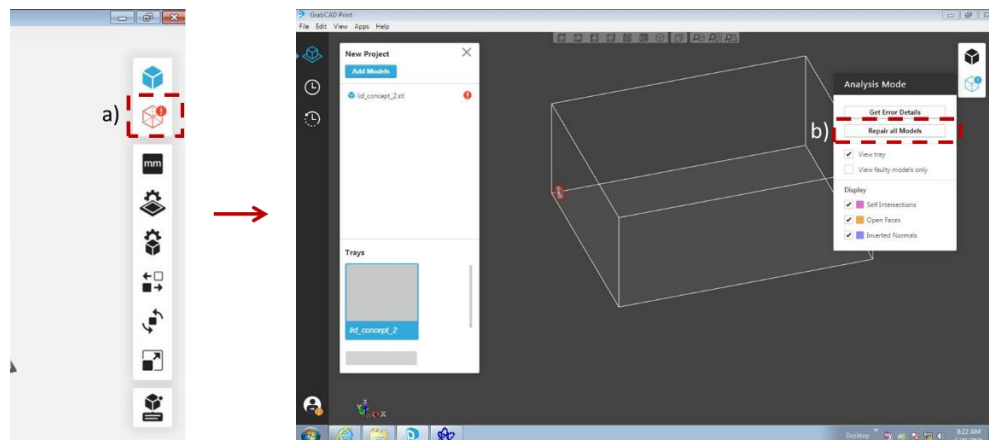


Using GrabCAD

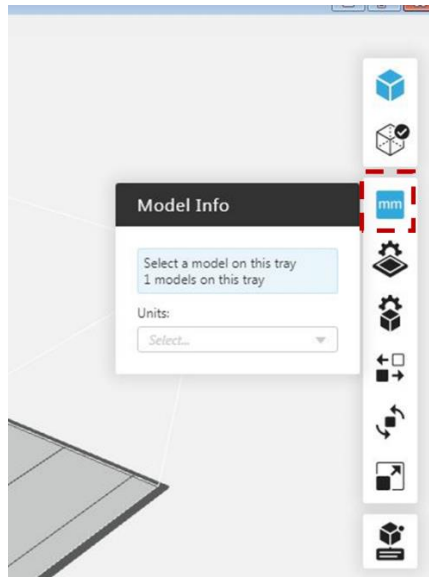
1. GrabCAD is a software that is easy to use. Simply Load your STL files and select the tools on the right-side, starting top to bottom. The following instructions will go through the basic tools in more detail.
2. Add your STL files by selecting the “Add Models” Blue tab found near the upper left of the screen. Repeat this step for as many samples as you want to add.



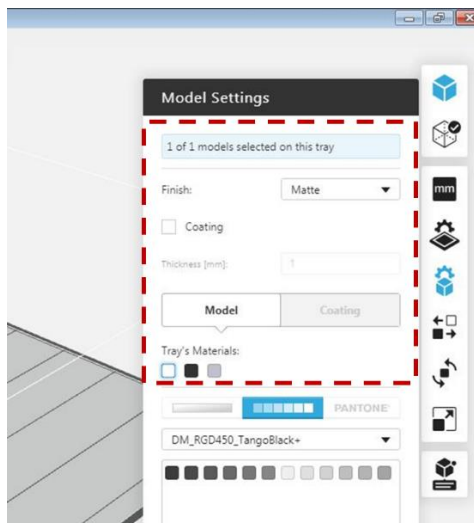
3. If the second box (a) is highlighted in red after loading the stl, please click that box. Then click “Repair all Models” (b) to fix any flaws in your stl file. If this does not fix your model, you will need to go back to your CAD file.



4. You can change the units used for each model by selecting the part on the build plate and selecting the “mm” box on the right side of the screen.

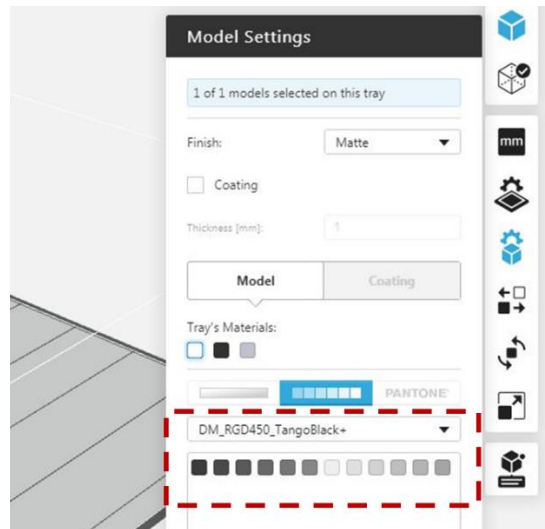


5. Then, change the material for each model by selecting the model and then selecting the 3rd box on the right-side toolbar. Just like in “Objet Studio” you can select Matte or Gloss Finish. Then you can select either “RGD”, “TangoBlack”, or “Vero Clear” by selecting one of the 3 boxes under “Tray Materials”. Do NOT worry about anything below the “Tray Material” option (outside dashed box) if you only want one material.

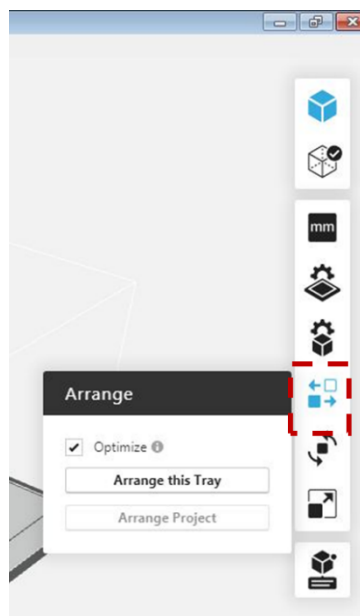


6. Finally, you can mix materials by selecting a mixture in the “DM_RGD450_TangoBlack+” box found below. Once you select what mixture you want, select one of the boxes under it to determine your ratio of materials.

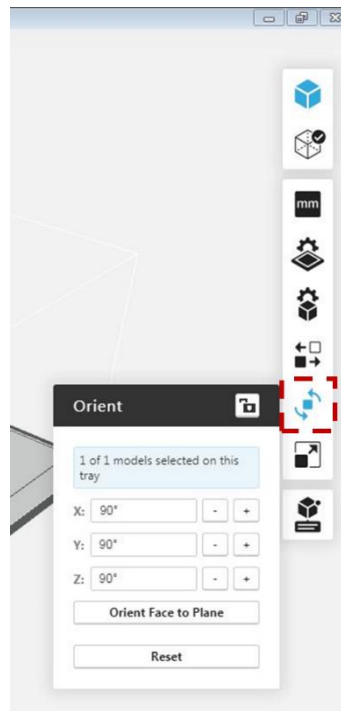
For basics don't worry about Grid Style or Hollow settings.



7. The next step is to arrange your build tray by selecting the tool underneath the Model Setting tab. Select “Optimize” then “Arrange this Tray”.



8. If an orientation is not to your liking this can also be modified in the “Orient” tab found underneath the “Arrange” Tab.

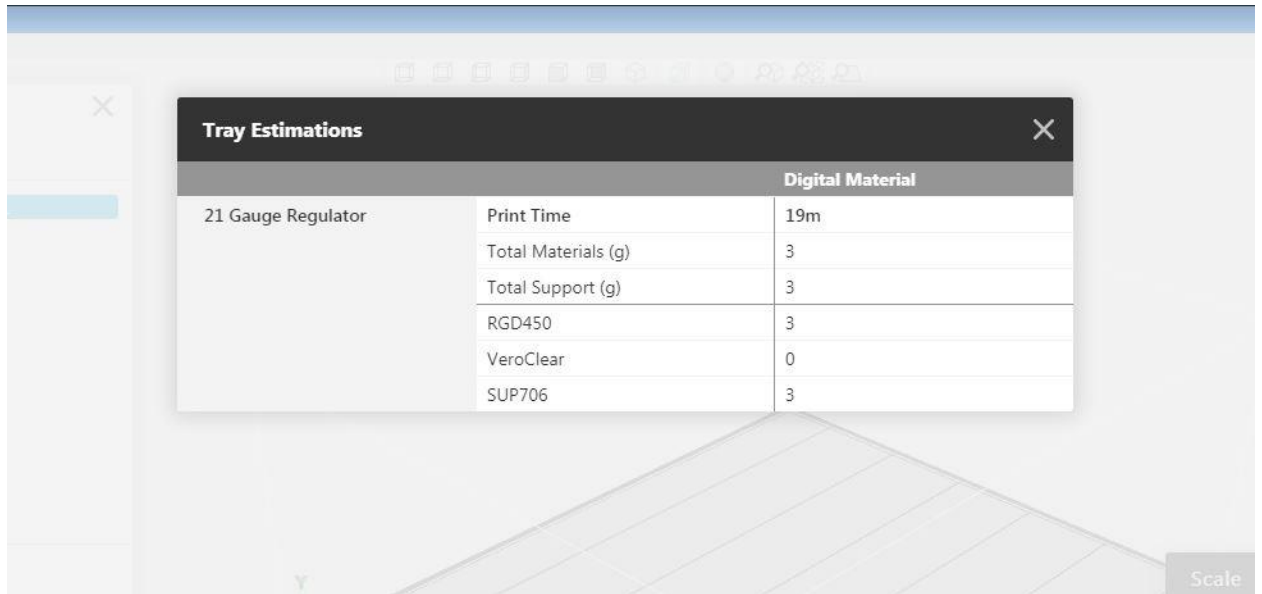


9. If part needs to be scaled larger or smaller please select the last “Scale” tab and scale the size of your part.



10. Next, select the “Estimate” Tab found in the bottom center of the screen and take a picture of the following window and send it to your Manager for price confirmation.

For material logging, use “Digital Material” column.



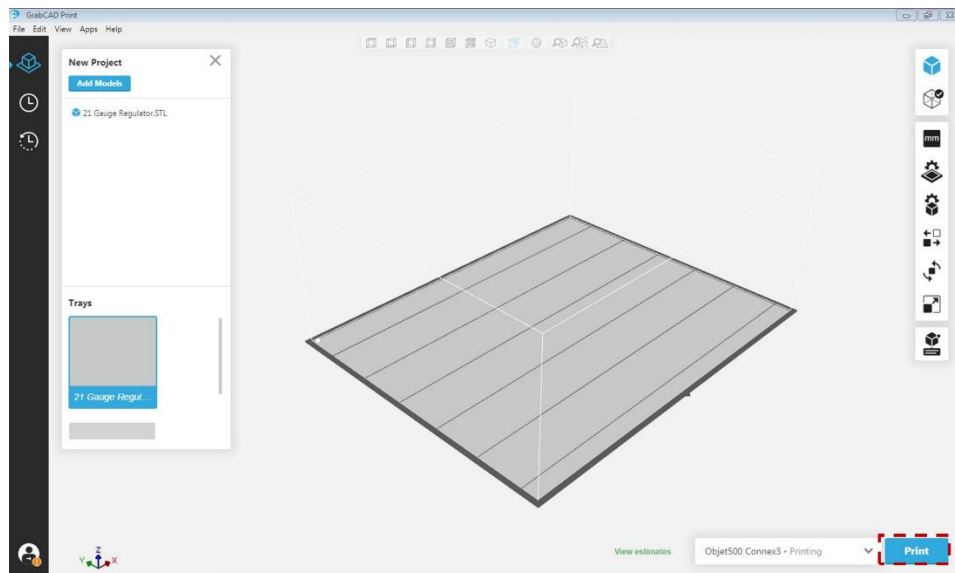
The screenshot shows a window titled "Tray Estimations" with a close button (X) in the top right corner. The window contains a table with the following data:

	Digital Material	
21 Gauge Regulator	Print Time	19m
	Total Materials (g)	3
	Total Support (g)	3
	RGD450	3
	VeroClear	0
	SUP706	3

11. After this step you should be able to save your tray by selecting “File” and “Save”.

Save the tray in your folder.

12. Then you can select the blue “Print” button at the bottom right of the screen.



13. You will then have to switch screens to the “Printer Computer” by selecting the physical button on the switch found near the computer.
14. Then select the Red button found on this window to turn the printer into “Online Mode”.



15. To monitor your print, select the second tab on the left side of the screen to go into schedule mode. Then select the print that is currently happening on the schedule. Information on your print can be found on the right side of the screen.

