

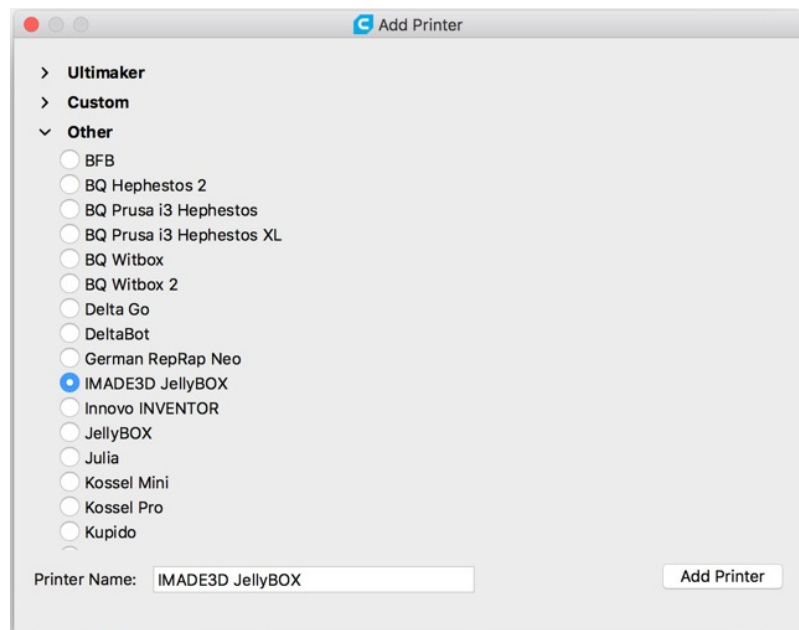
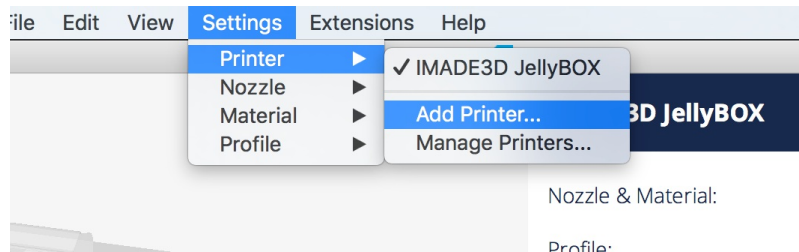
# Using 'Cura'/'Ultimaker Cura' with IMADE3D JellyBOX

*Note: Cura on your computer may look a bit different depending on your system and Cura version. Yet, the procedure will be the same.*

*Naming Note: that since version 3.04, "Cura" has been renamed to "Ultimaker Cura" to signify Ultimaker's huge contribution in leading and organizing the development of this open source gem. They are doing a great job.*

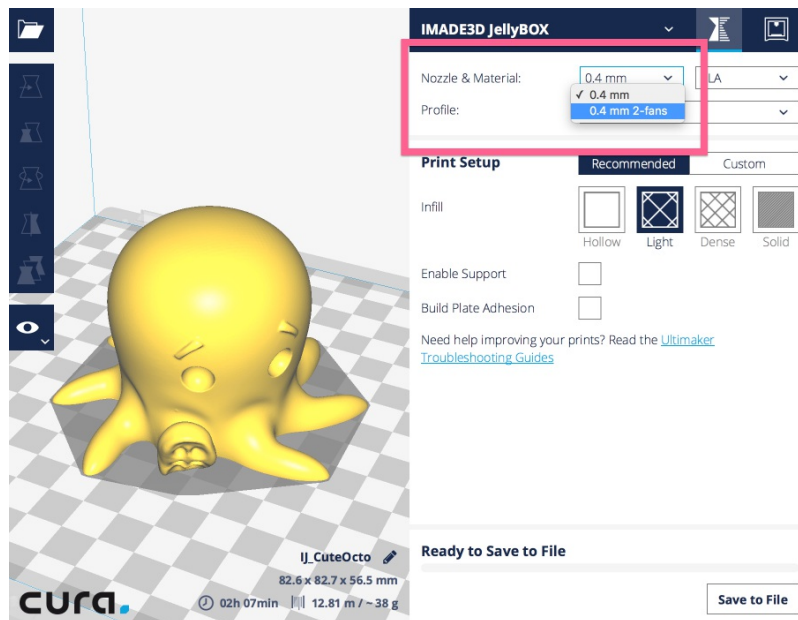
## 1. Add IMADE3D JellyBOX machine

- Settings > Printer > Other > IMADE3D JellyBOX
- (When you start Cura for the first time, you will be presented with the 'add Printer' dialog automatically.)



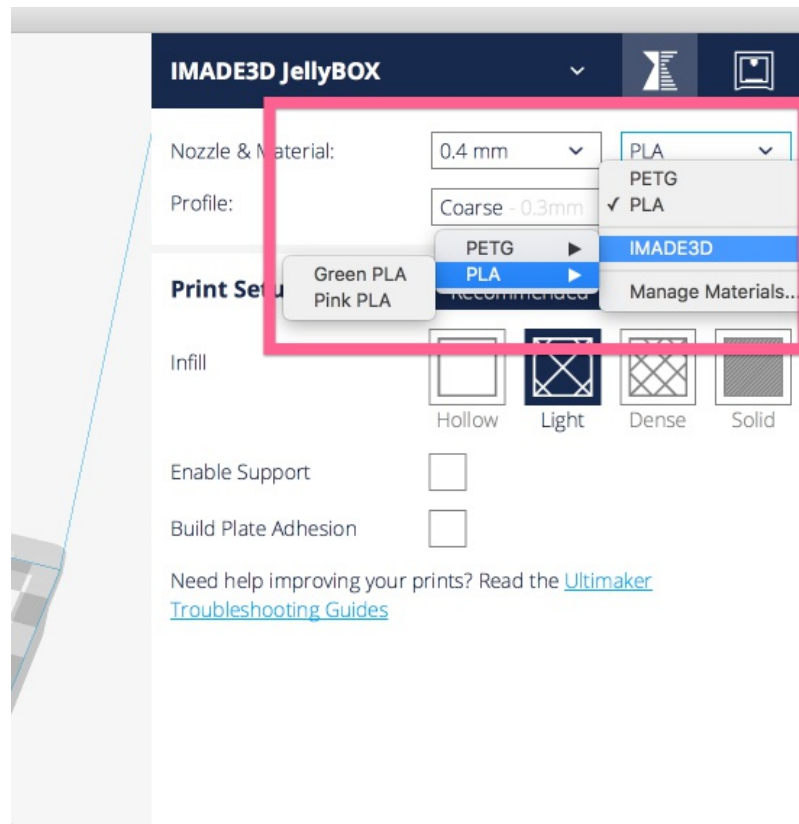
## 2. Select Nozzle (= JellyBOX Variants)

- Choose the variant depending on your configuration of nozzle size/ number of filament fans.
- Use **0.4 mm** if you have JellyBOX with 0.4mm nozzle (default) and only one single filament fan on the left side.
- Use **0.4 mm 2-fans** if you have JellyBOX with 0.4mm nozzle (default) and the dual fan upgrade. In this case, you have a filament fan on both left and right side.



### 3. Select a Material Profile

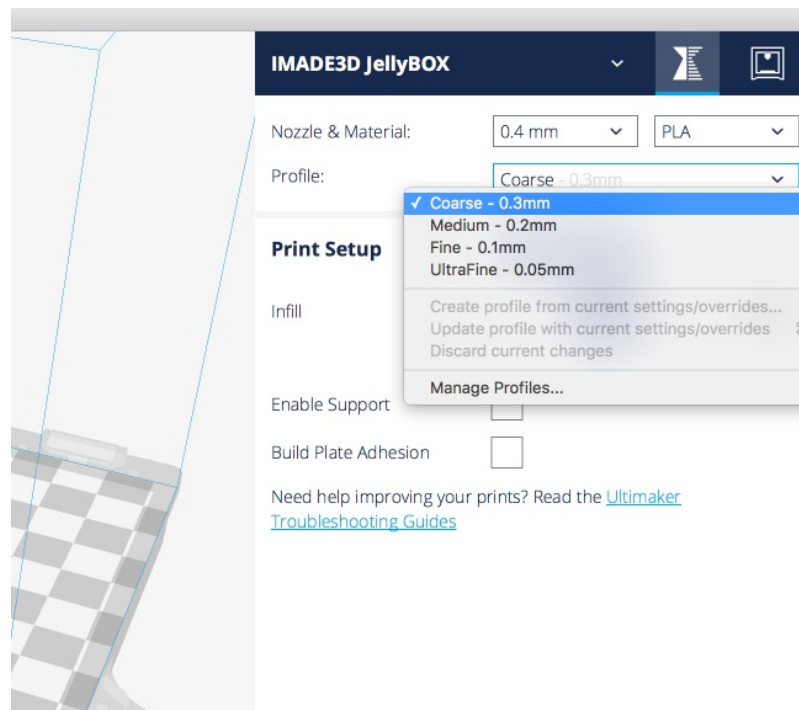
- PLA
  - a generic PLA profile for both cold and heated platforms.
- PETG
  - a generic PETG profile for both cold and heated platforms.
- IMADE3D Green/ Pink PLA
  - These are only visual tweaks. The settings are identical to the generic PLA, but the model will be pleasingly green/pink.
- IMADE3D Green/ Pink PETG
  - These are only visual tweaks. The settings are identical to the generic PETG, but the model will be pleasingly green/pink.



## 4. Select a Quality Profile

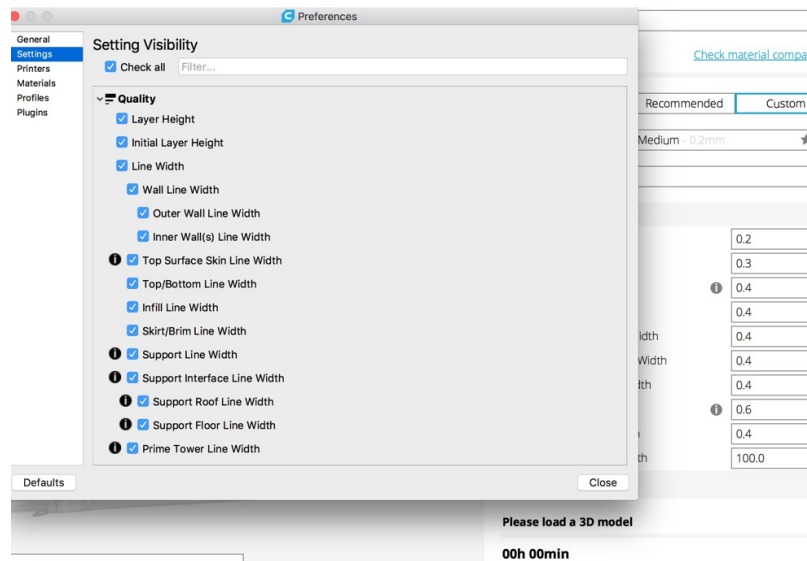
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- Coarse
  - Recommended profile for general use. Prints the strongest parts in the least amount of time. Your printed part will have clearly visible 0.3 mm thick layers.
- Medium
  - Prints slower and slightly(!) more brittle parts than Coarse. Better for printing steep overhangs and small features.
- Fine
  - Prints slower and slightly more brittle parts than Medium. Great for printing steep overhangs and small features. Smooth-looking. Some people think it looks 'better' than coarser profiles.
- UltraFine
  - Takes a very long time to print (even days). Produces curiously smooth prints and amazing overhangs.



## 5. Recommended/Custom

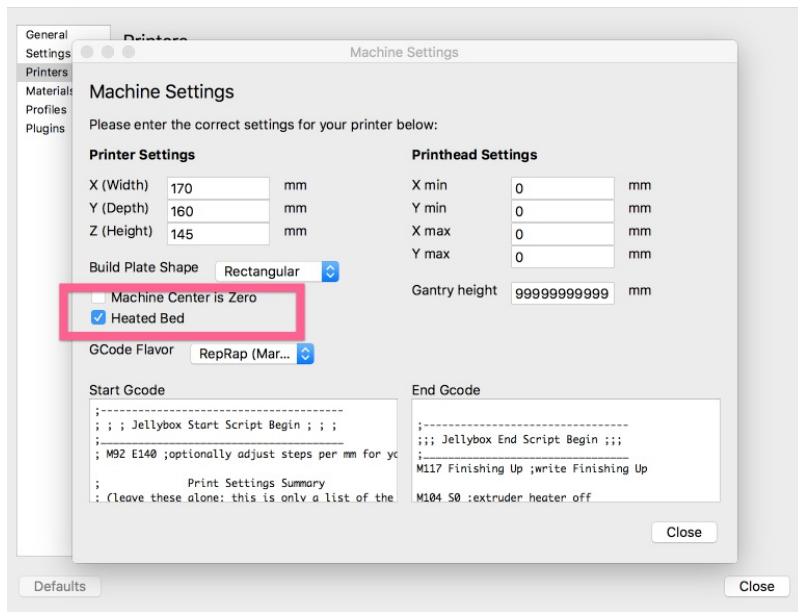
- The **Recommended** tab in Cura is great for beginners. It's a simple mode, which only lets you use our predefined presets and tweak a few parameters.
- The **Custom** tab let's you see and change all the slicing settings. This can be overwhelming when you're getting started, and there is no shame in using the Recommended mode.
- In The **Custom** tab, you can control which setting you actually want to see by going to Preferences > Settings ( **Settings Visibility** ).
  - Note that there are many settings that are actually hidden by default even if they are an important part of a preset
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## 6. Heated Bed ?

- We highly recommend the heated bed upgrade to print a wide variety of plastics.
- In general, you *do not* need a heated bed for most prints with *PLA*. PLA stick well to blue painter's tape, and you don't have to wait for the bed to heat up. Even if you have a heated bed, you may elect to set the bed temperature to only 25C-30C to combat unusually cold environments #printinginwinter.
- The heated bed is **enabled by default** in Cura.

**! Cold bed JellyBOXes ignore** heated bed instructions. So, you **can** run gcodes with heated bed settings on a cold bed JellyBOX. No problem.



- You have to make the heated be setting visible if you want to change the temperature. It's 'Build Plate Temperature' in the under 'Material'



### ! Alert: Legacy Hotends with 10 mm Heat Block - If your hotend looks like this, with the heat block only 10mm long (current default is 20mm), then you have some old old JellyBOX, congrats! - In general, you need to **\*\*set your material print temperature 10C higher\*\*** than the current JellyBOX profiles! - Alternatively, print up to 50% slower. - Else you're may have under extrusion problems.

