

3D Printing Using the LulzBot TAZ6

May 2023 – www.FredricRaab.com

Note: The TAZ6 removable media is a full size SD card requiring the use of a USB SD card reader.

Slicing the 3D Model

1. Plug the SD Card into the reader, then plug the reader into the computer's USB port.
2. Verify that the USB card can be accessed.
3. Open the Cura slicer.
4. Open .STL file (File > Open File>
5. Set printer to LulzBot TAZ6
6. Set Material to filament type (typically Generic PLA)
7. Set Print Settings to desired settings, typically
 - o Profile = Normal
 - o Layer Height = 0.15 mm
 - o Infill = 50%, Pattern = Triangles
 - o Build Plate Adhesion = Skirt
 - o NOTE: Press the down arrow in the quick settings box to reveal full settings
6. Click the Slice button
7. Click the Save to Removable Disk
8. Click Eject and remove the SD card reader, then the SD card.
9. Close Cura

Printing the 3D Model

1. Turn on the printer
2. Clean the print bed with alcohol. Also clean the 4 metal disks at each corner.
3. Scrape the print head nozzle with the wire brush.
4. Plug the SD card into the TAZ6 slot with the gold pins facing towards you. Display should read "Card inserted".
5. Press in the round knob.
6. Rotate knob clockwise to display "Print from SD". Press knob to select.
7. Rotate knob to highlight desired file and press knob to select. Display should read "Bed heating".
8. Once the bed and extruder reaches the required temperature, the machine will auto-level by touching each of the 4 metal disks.

If successful, the print will proceed. Otherwise, the message "Probe Failed" will be displayed. Again clean the 4 metal disks and wire brush the nozzle. Turn the power off, then on to try again.

Aborting the Print

1. Press the knob. Rotate clockwise to highlight "Stop print".
2. Press the knob to select. The display should read "Print aborted".

Changing the Filament

Note: The TAZ6 uses PLA and ABS filament 3.0 mm in diameter.

1. Press the knob. Rotate clockwise to "Change Filament" and press the knob to select.
2. Rotate to either "Preheat PLA" or "Preheat ABS" and press knob to select. The display should read "Heating nozzle Please wait".
3. Wait for the filament to unload from the extruder.
4. Pull the filament through the clear tube and remove spool.
5. Replace spool with new filament and push through the clear tube, leaving 6 inches of filament out of the tube. Cut the end of the new filament at 45 degree angle.
6. Insert the filament into the extruder and press the knob. Push the filament downwards until it is grabbed by the feeder.
7. Wait for the new filament color to cleanly extrude through the nozzle.
8. If necessary, click "Purge More" multiple times as needed.
9. When the filament color is pure, click "End filament change". The display should read "LulzBot Taz6 Ready."