07. Full Build Complilation

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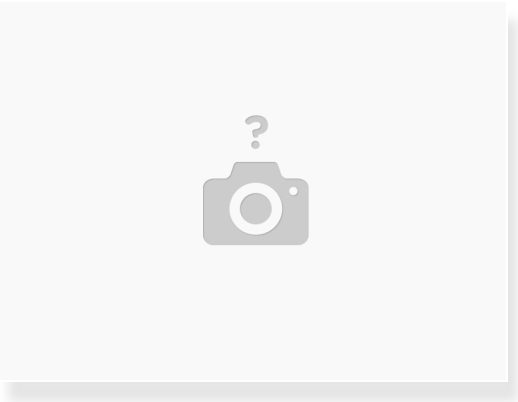
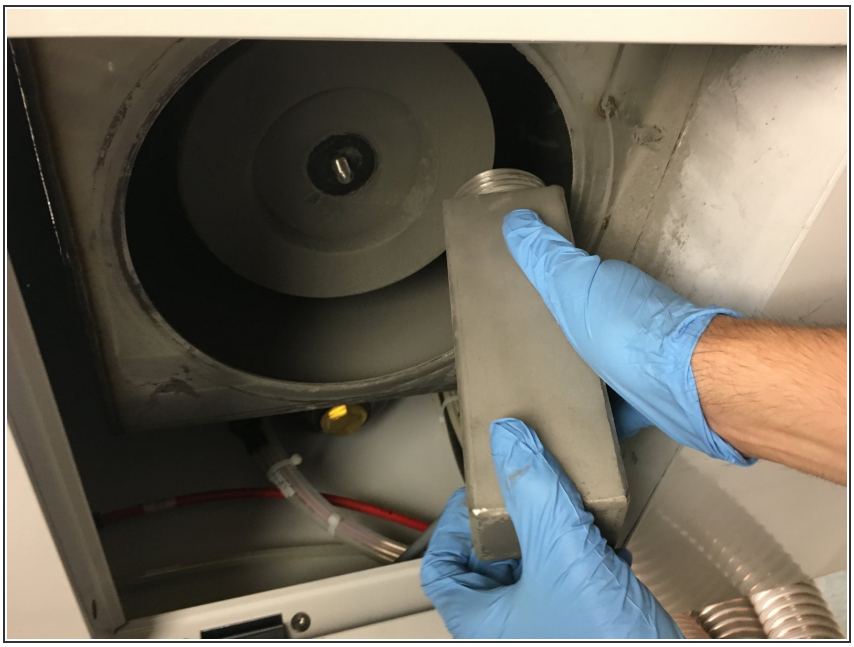
Step 1 — Clean the Build Chamber



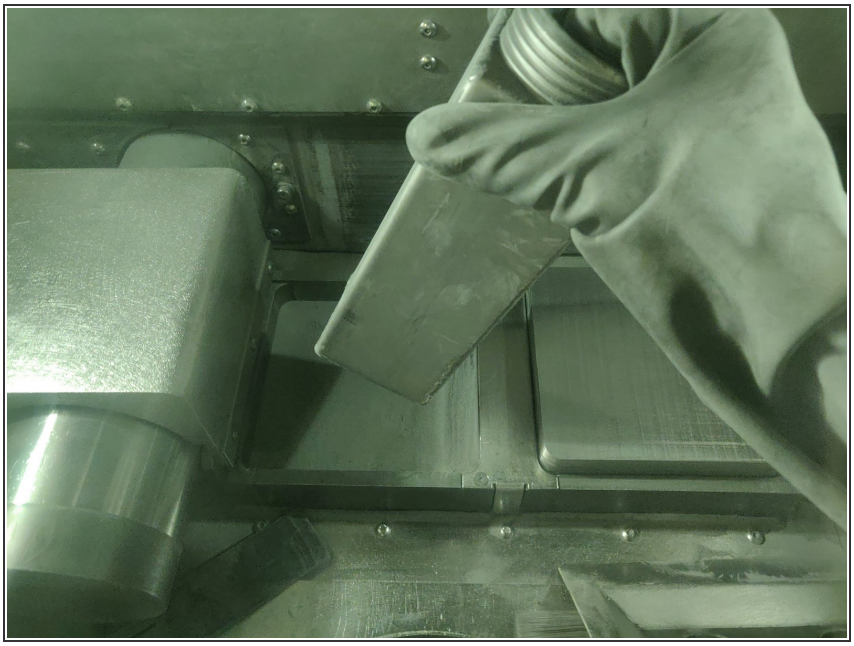
- Use paint brushes, scrapers, and/or scoops to push all powder into the (2) canisters on the right

Step 2 — Load PX Box Hopper



- Load the PX Box with the dirty powder canisters
- Run the powder recycling process

Step 3 — Load & Level New Powder



- Load new powder into the supply
- Level the powder supply using the bottom of the powder canister
- Place the (2) now empty canisters in the right compartment

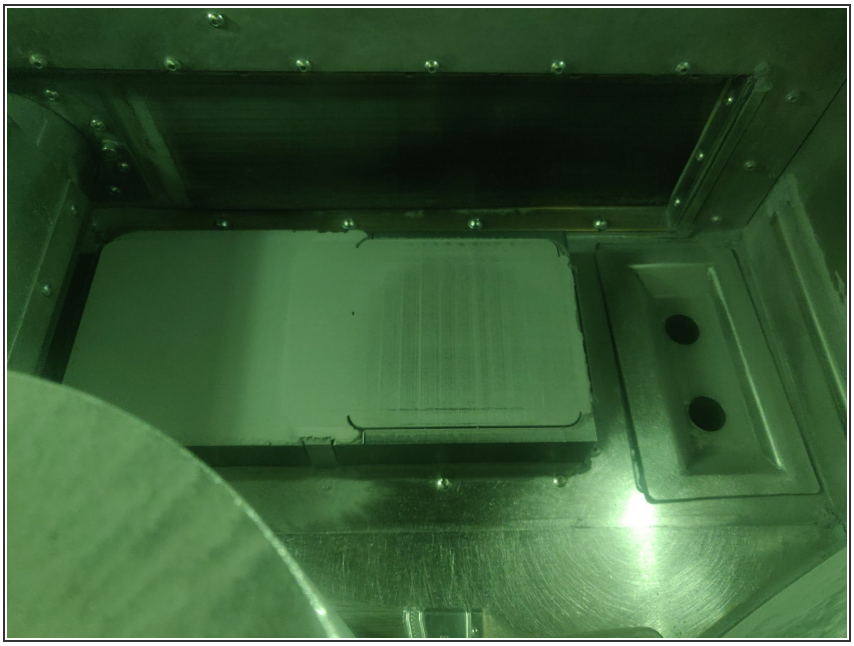
Step 4 — Clean Build Chamber...Again

- Clean any residual powder by pushing into the (2) empty canisters on the right

Step 5 — Prepare & Load Build Plate

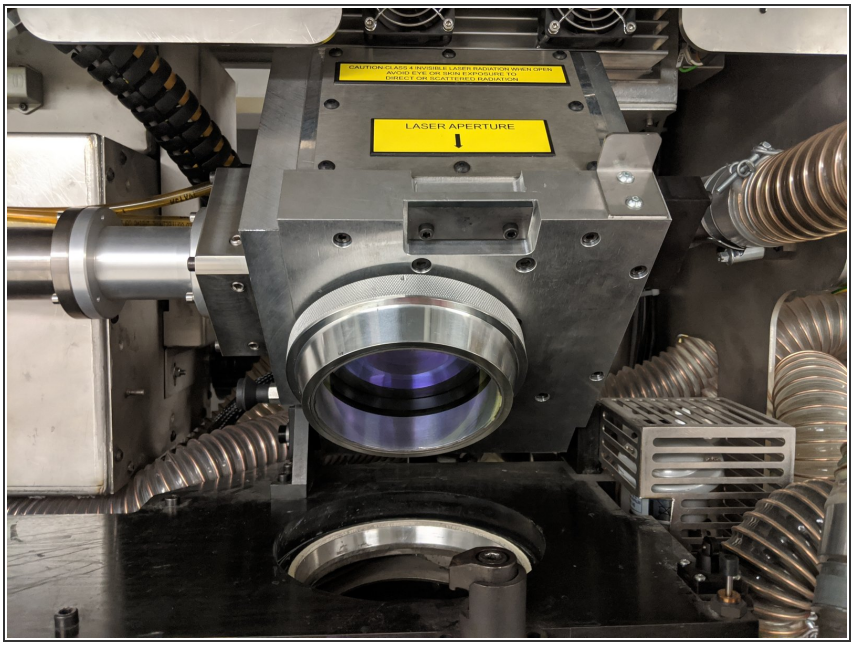
- Clean and attach build plate to base
- Load build plate with the grain direction moving towards the engraved **FRONT**

Step 6 — Run Zero-Sinter & Preparation Layer



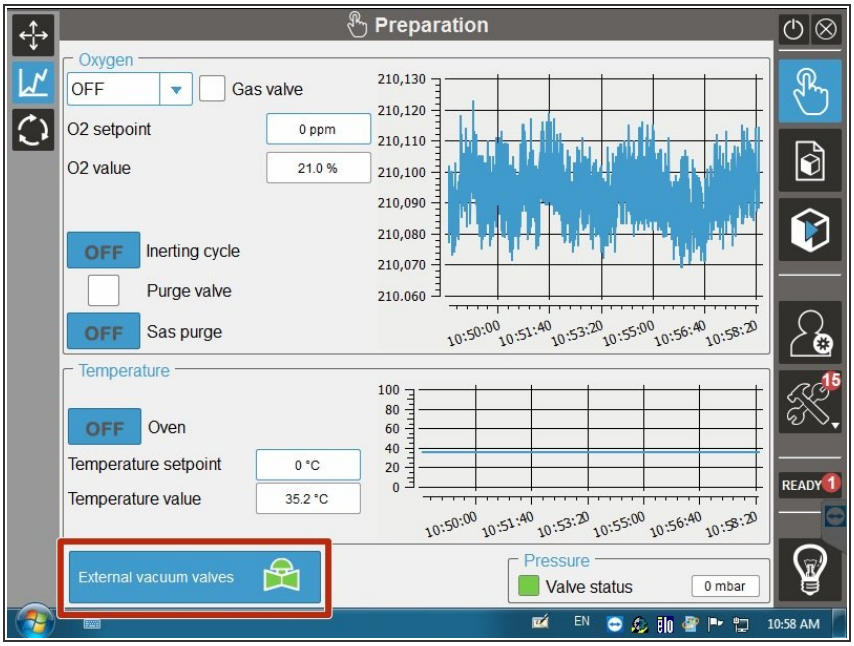
- Run both zero-sintering search and preparation layer
  - Make sure the first layer has uniform coverage without any noticeable patterns or clumps

Step 7 — Clean Lens & Check Water



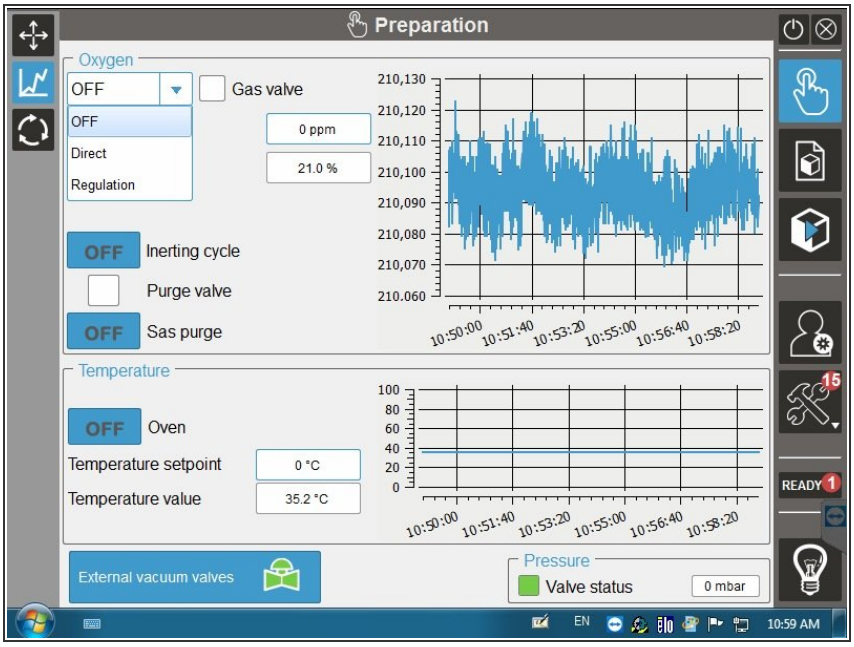
- Check the water level
- Clean the lens

Step 8 — Close Valves, Lock Doors & Vacuum Up



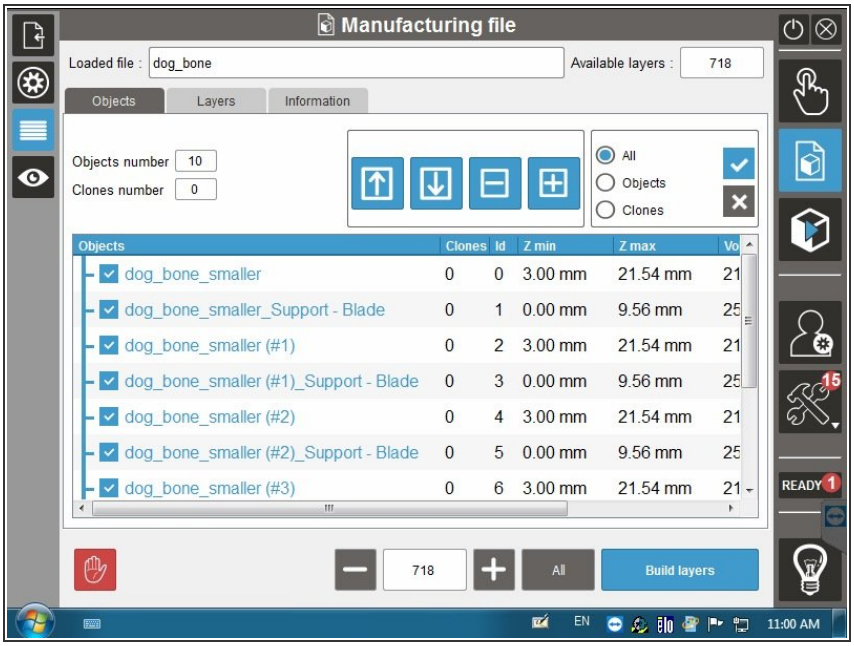
- Make sure to close the valves and lock the glove ports prior to argon purge
- Make sure the vacuum is locked in place inside the machine

Step 9 — Inert Build Environment



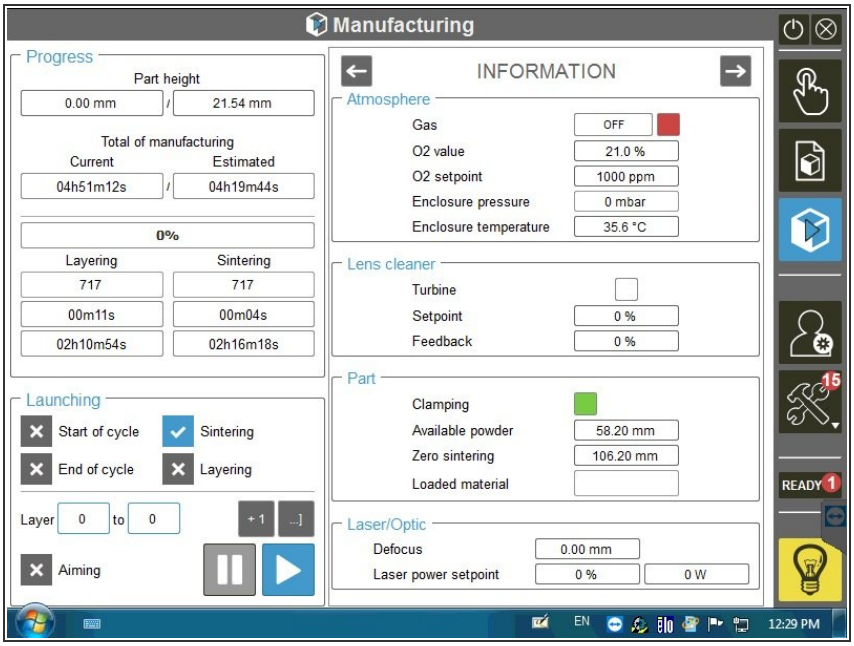
- Turn on the argon and run the purge cycle
- Make sure to burp the trap at ~2000 ppm

Step 10 — Load File



- Load the sliced file and **BUILD LAYERS**

Step 11 — Manual Layering & Start



- Layer and sinter 0-4 manually to make sure everything looks good

Step 12 — Save Build Report & Argon Off

- Make sure to open internal valves

Step 13 — Harvest & Clean Part

- Slowly excavate part making sure to not overfill powder canisters
- Remove **ALL** powder from part and build plate

Step 14 — Remove Part Support

- Use bandsaw