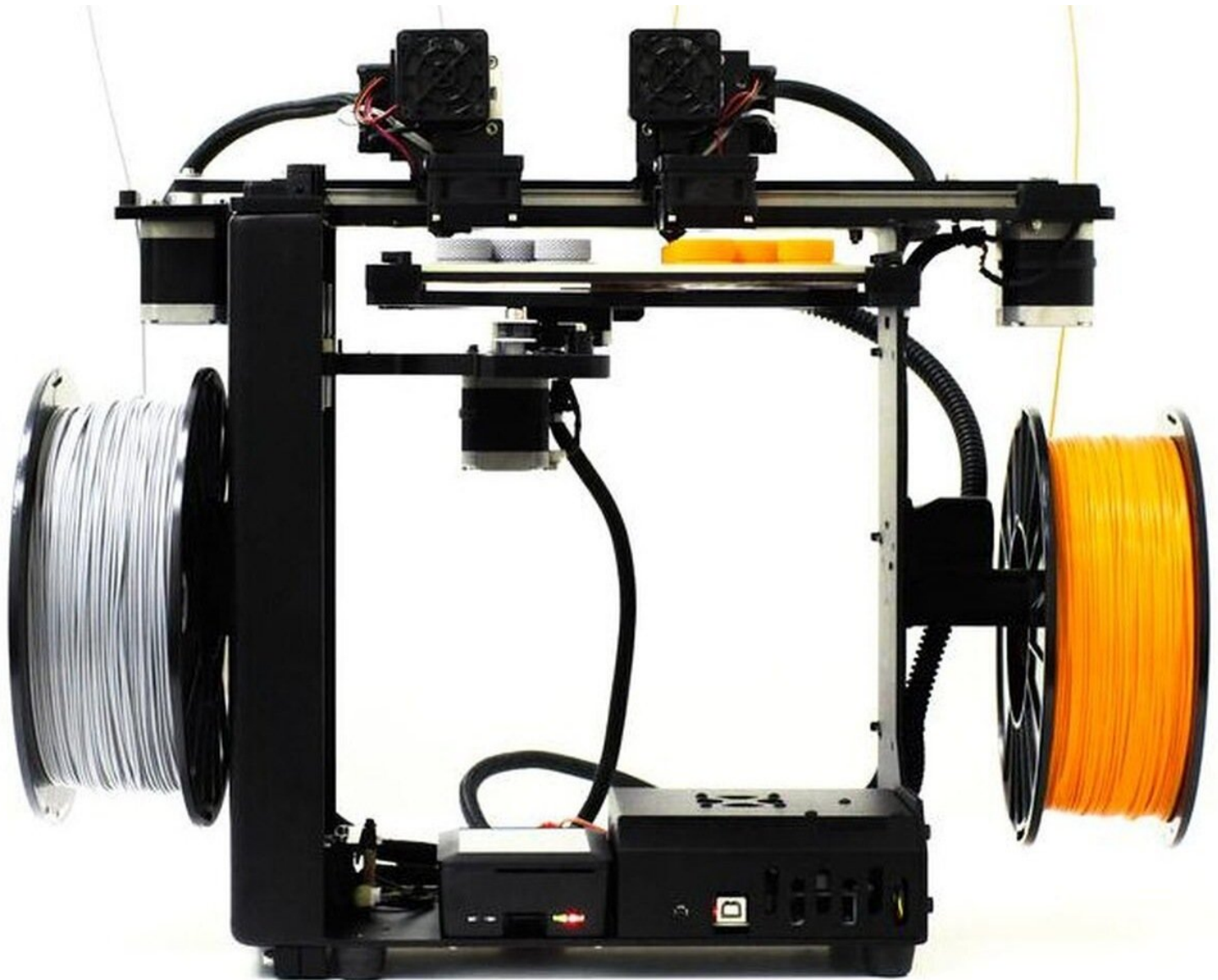




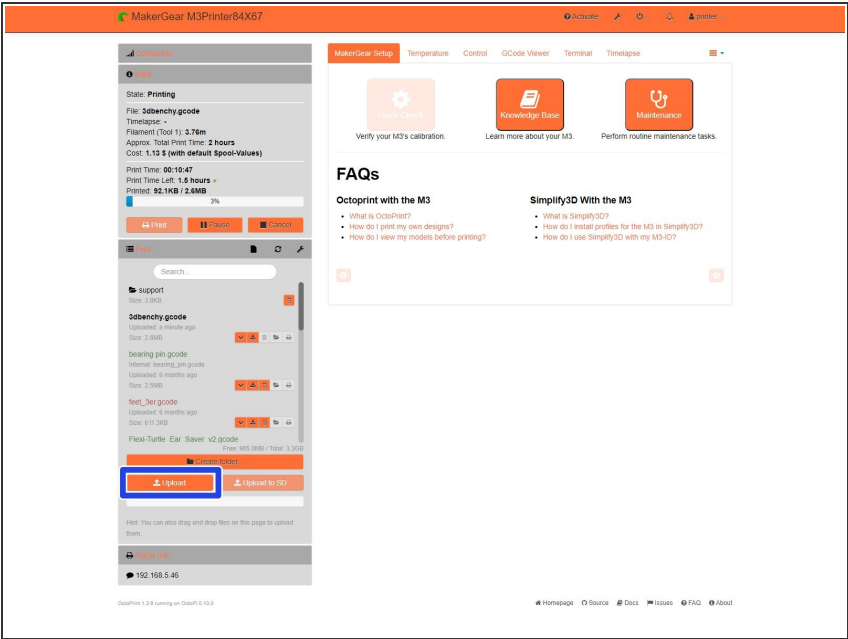
# MakerGear M3-ID: Starting a Print

Learn how to start a print on the MakerGear M3-ID.

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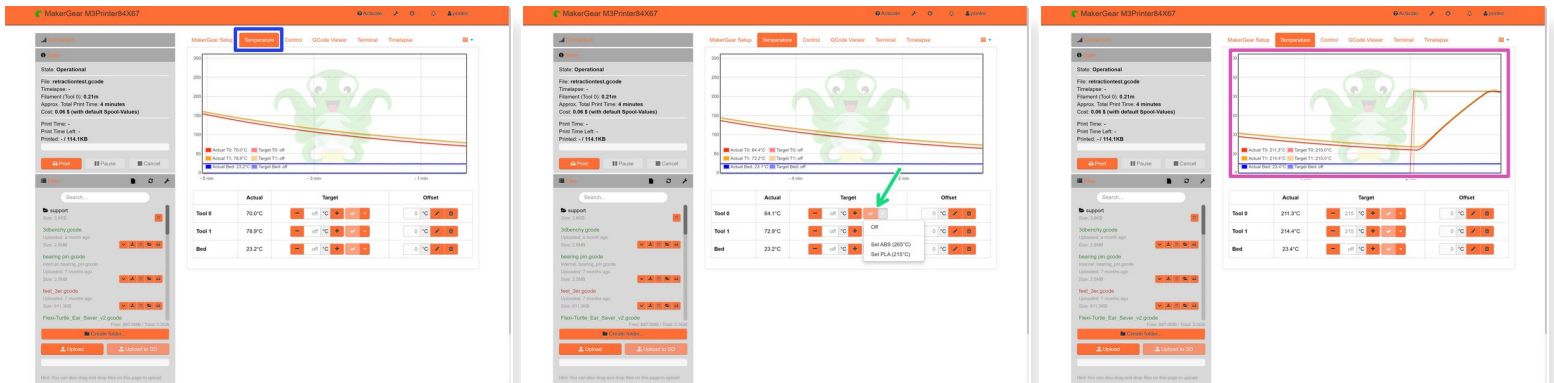


## Step 1 — Loading .gcode file



- If using Octoprint over the web, drag the sliced file into the printer files after accessing the printer web address
- If using Octoprint locally, drag the sliced file into the printer files after plugging into the Octoprint server
- In Octoprint, different file management options are available after clicking on the file title

## Step 2 — Preheating the Machine



- The M3-ID can be preheated by navigating to the "temperature" tab of the Octoprint interface
- Preheating can speed up the print start time, as you can heat both nozzles simultaneously
- ⚠ Do not leave the nozzles preheated for excessive amount of time, as this can cause filament jams
- ⓘ If there is no time pressure, preheating the printer is not necessary
- ⓘ You can see the temperature rise for both extruders

## Step 3 — Starting the Print

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- Select the desired file
- Verify that there is enough filament for the estimated print mass
  - ⚠ The stock M3-ID does not have a filament sensor
- Click the "Print" button
- Make sure the printer has the correct temperature profile by looking at the target temperature in the "temperature" tab

## Step 4 — Assuring Print Success

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- When the print starts, make sure the first layer adheres properly
  - ⚠ The first layer should not have significant gaps between adjacent lines
  - ⚠ The nozzle should not be dragging against the print surface
- ⓘ If the printer has been upgraded with a blTouch, it will perform a levelling process before each print to help with first layer adhesion
- If the print does not adhere properly, stop the print immediately
  - 📌 This can be done through the Octoprint interface
  - ⓘ Sometimes the Octoprint interface is slow, in case of potential catastrophic failure unplug the machine
  - ⚠ If the machine is unplugged with filament in the nozzle, plug it in almost immediately, heat it up and manually retract filament by ~10 mm