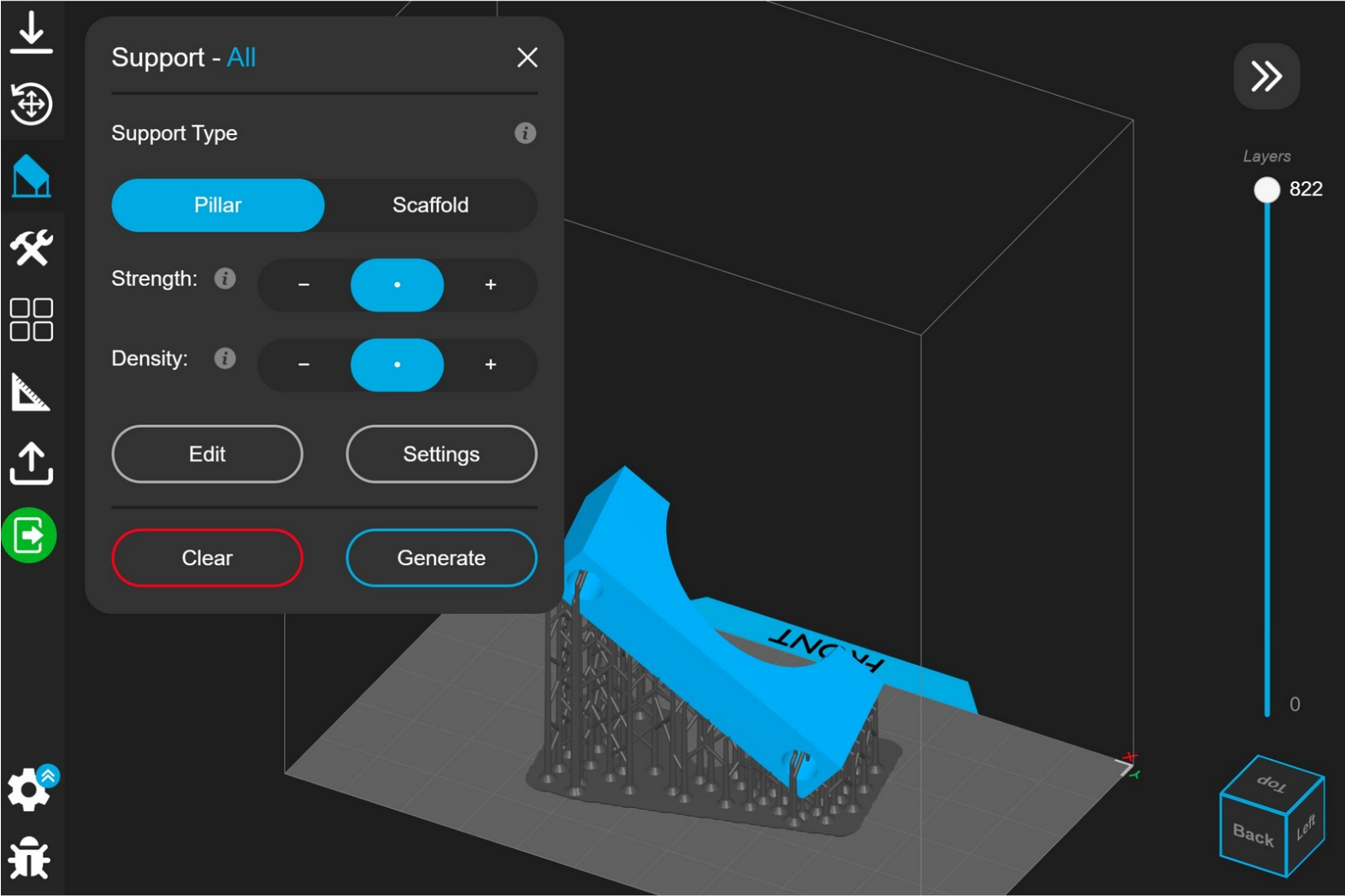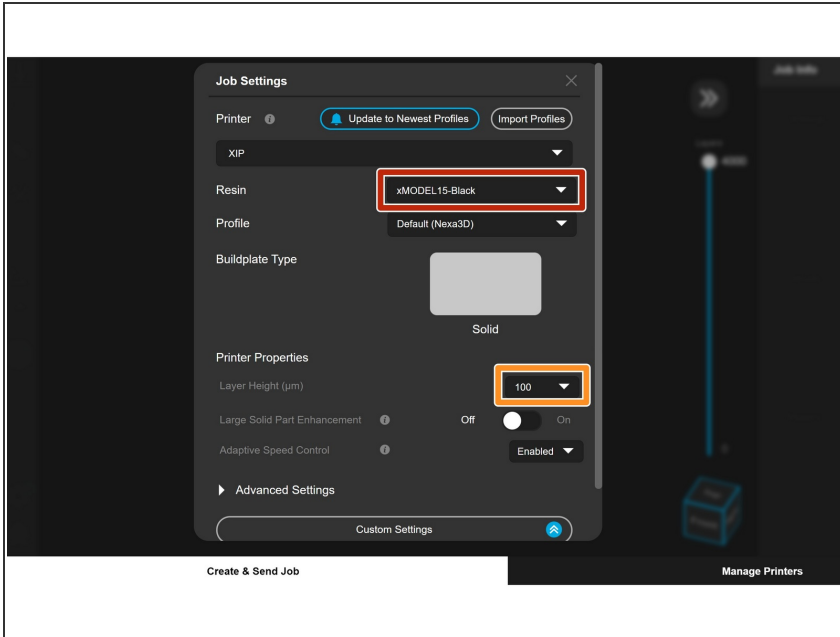# NexaX: Slicing

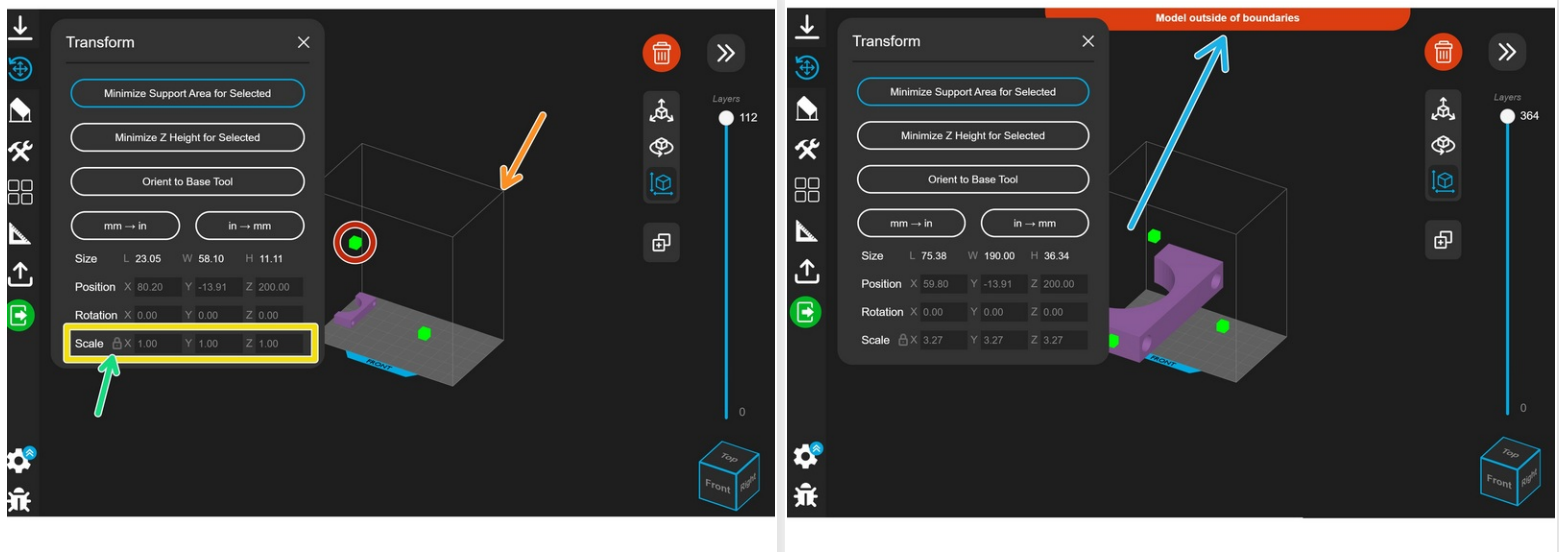**Written By: Benjamin Gerald Hroblak**

Step 1 — Job Set-Up

- Select the Material you would like to print in here. Make sure machine is set to "XiP."
  - ⓘ If you are connected to the printer the material info will automatically update to what is loaded in the printer
- Use the dropdown to match the Layer Thickness to the request

Step 2 — Scaling

- You can change the size of the part by scaling it from it's original size. Drag the green boxes to the desired size.
  - Nexa X displays a bounding box with the maximum exterior dimensions of the part.

- You can also set an exact dimension for one of the dimensions of the bounding box.

- Toggling the small lock will allow the axis to be scaled independently.

- If a part exceeds the bounding box, an error will appear.

Step 3 — Automatic Orientation
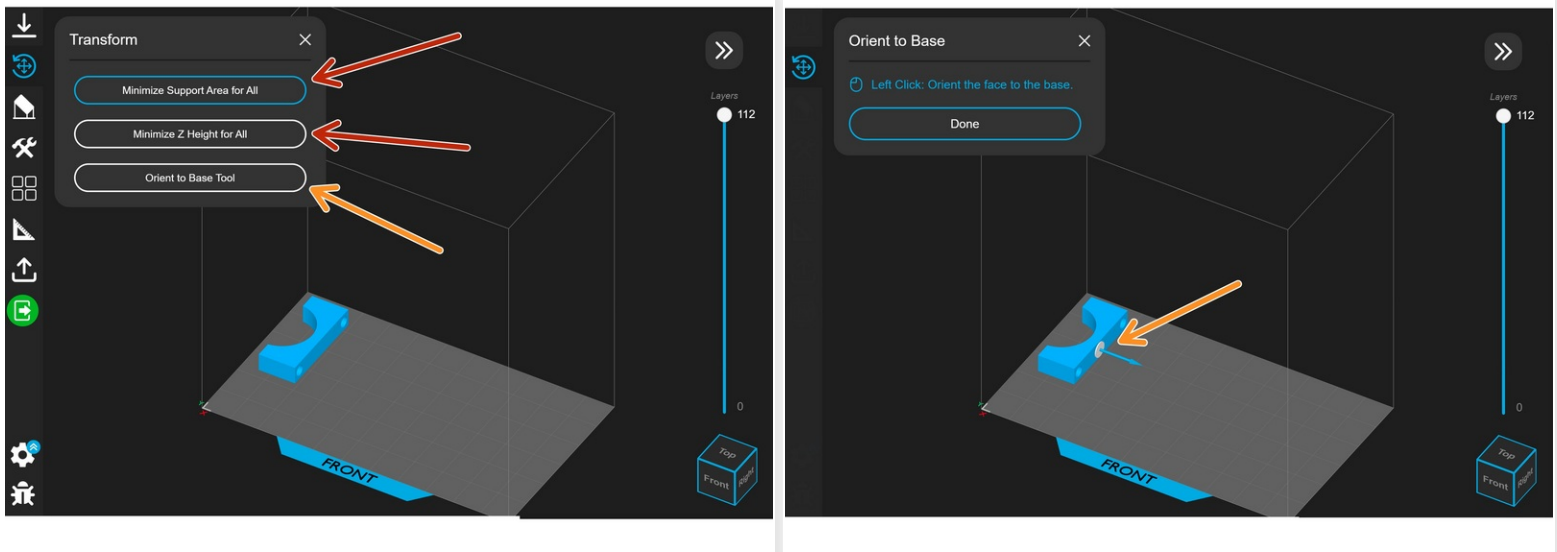
- ⓘ Some Nexa prints require support, and Nexa X optimizes the orientation for printing support.

- 🔴 To Auto-Orient, select "Minimize Support Area" or "Minimize Z Height." It is best to try both to see which orientation is better.

- 🟠 There is also the option, "Orient to Base Tool." This allows you to select a flat surface to place on the build plate.

- ⓘ Unlike the Form 3+, parts can be oriented with flat faces directly on the build plate. This is recommended because it will keep the part secure while it is printing

Step 4 — Manual Orientation
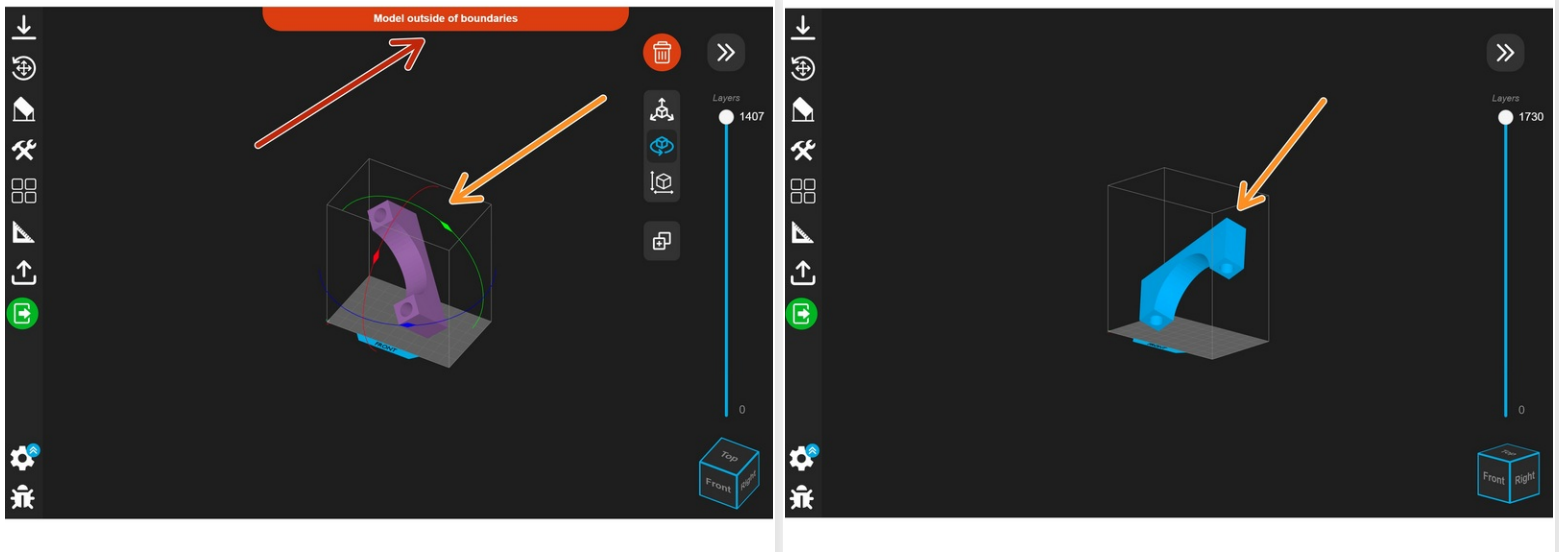
- For some larger parts, the optimized orientation results in the bounding box extending outside the workspace.

- You are able to rotate parts about the X, Y, and Z axes of the bounding box using the circles surrounding them, allowing some larger parts to fit.
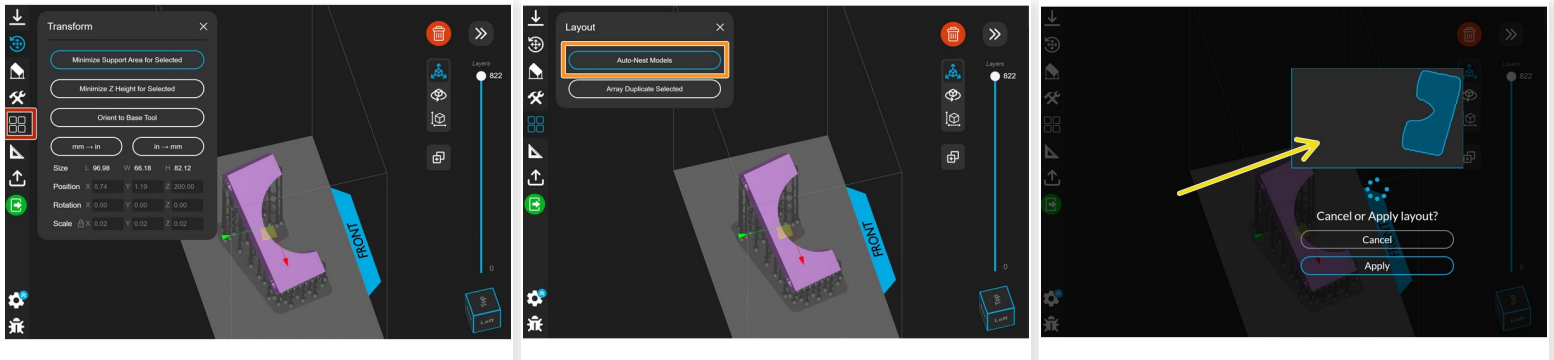
Step 5 — Exact Orientation
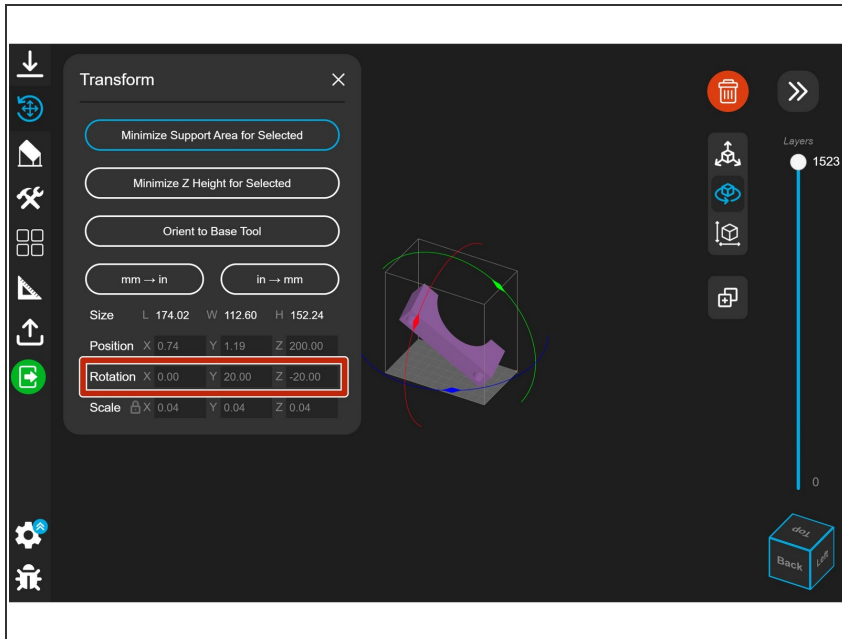
- You can rotate the model an exact amount about the X, Y, and Z axes by typing a value where it says "Rotation."

Step 6 — Support
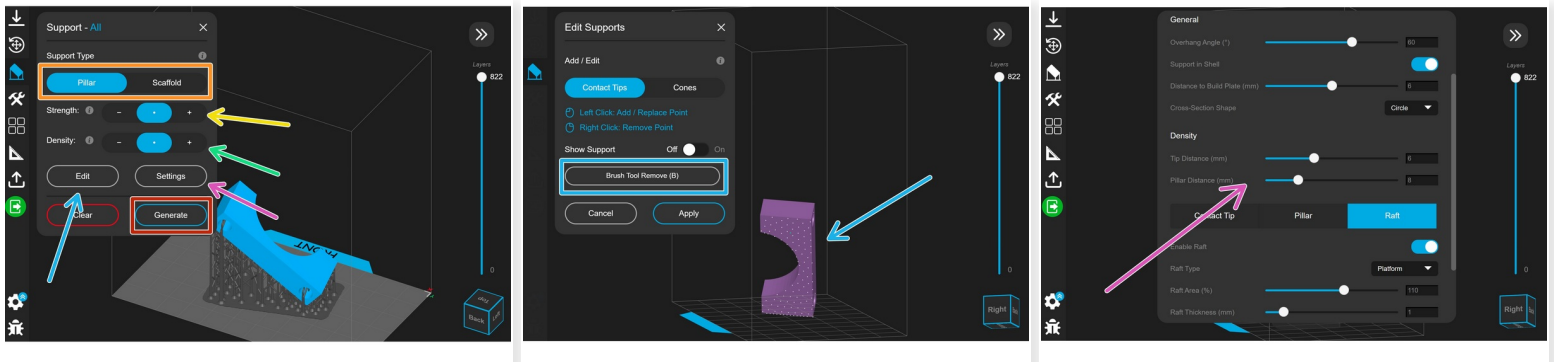
- Click "Generate" to generate supports.

- You can select between pillar and scaffold supports depending on the model you are printing.

- The strength setting will increase the contact area of the supports with the model. This makes the support stronger, but may decrease surface quality.

- Density increases the number of support structures. Also helpful for strength, but makes post-processing harder sometimes.

- Supports can be manually added by clicking "Edit." Click the model to add support points and use the brush to remove points.

- Additional settings can be found by clicking "Settings." This tab is generally not needed.

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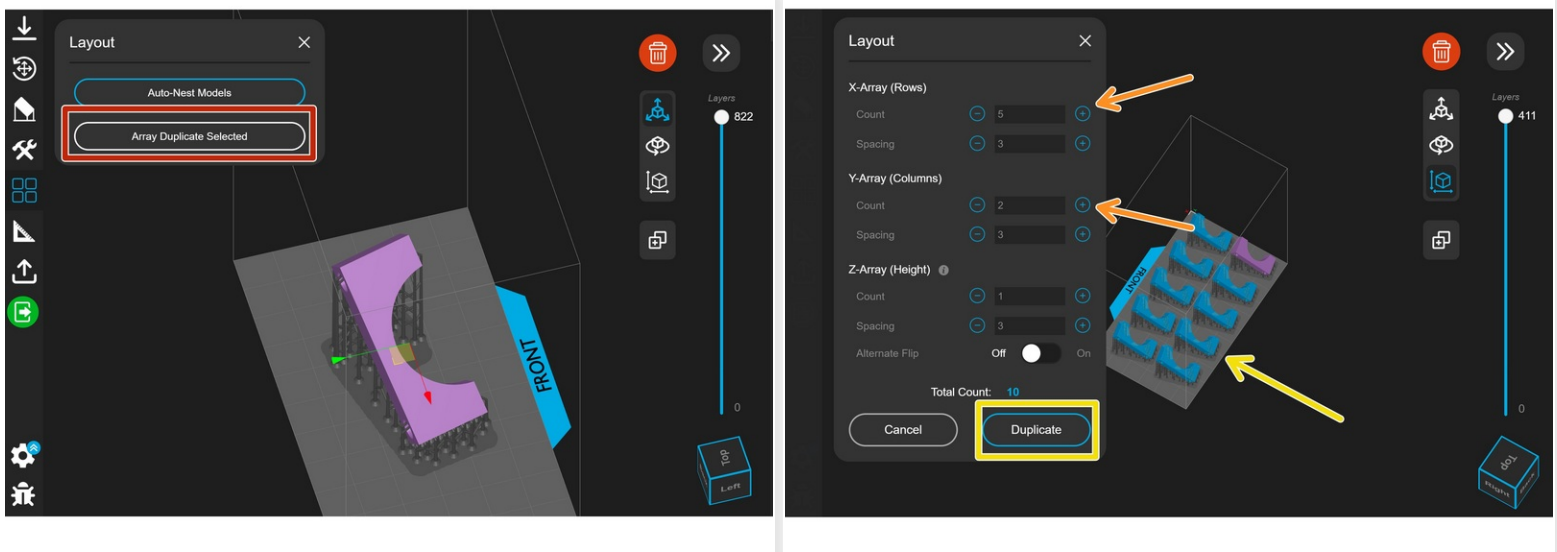
Step 7 — Layout Settings

- Selecting layout from the sidebar brings up options for nesting and arrays.

- "Auto-Nest Models" orients all of the models on the build plate.

- A preview of the model footprints will appear that you can choose to apply.
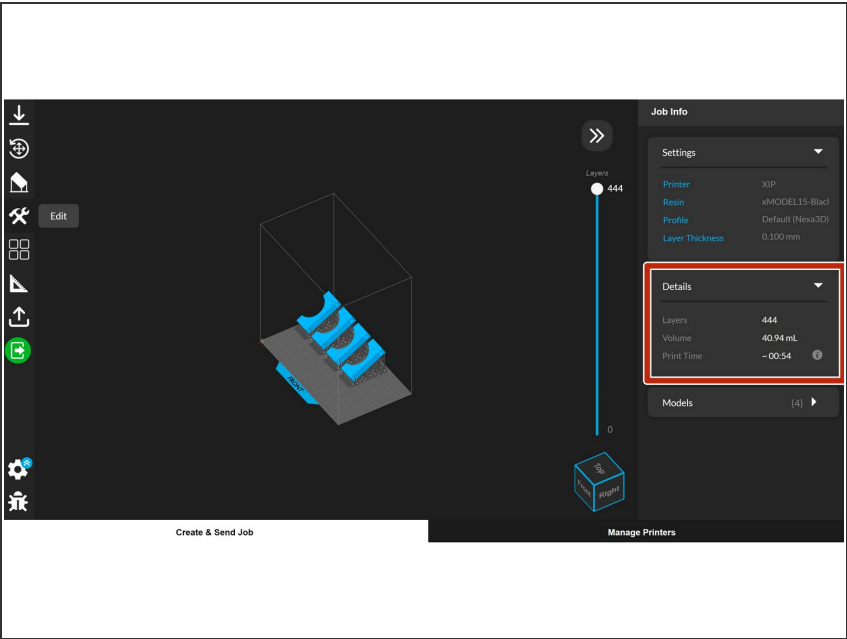
Step 8 — Other Features

- Selecting "Array Duplicate Model" allows you to print multiple copies of the same part.

- Changing the count for the X and Y directions will add more copies to the build plate.

- The copies are previewed in blue. Select duplicate to apply the changes.

- (i) It is recommended to complete this step after auto nesting the parts.

Step 9 — Job Info

- The job information required for quoting in Papercut can be found in the Details tab on the right side of the slicer.

Step 10 — Export Job to Printer
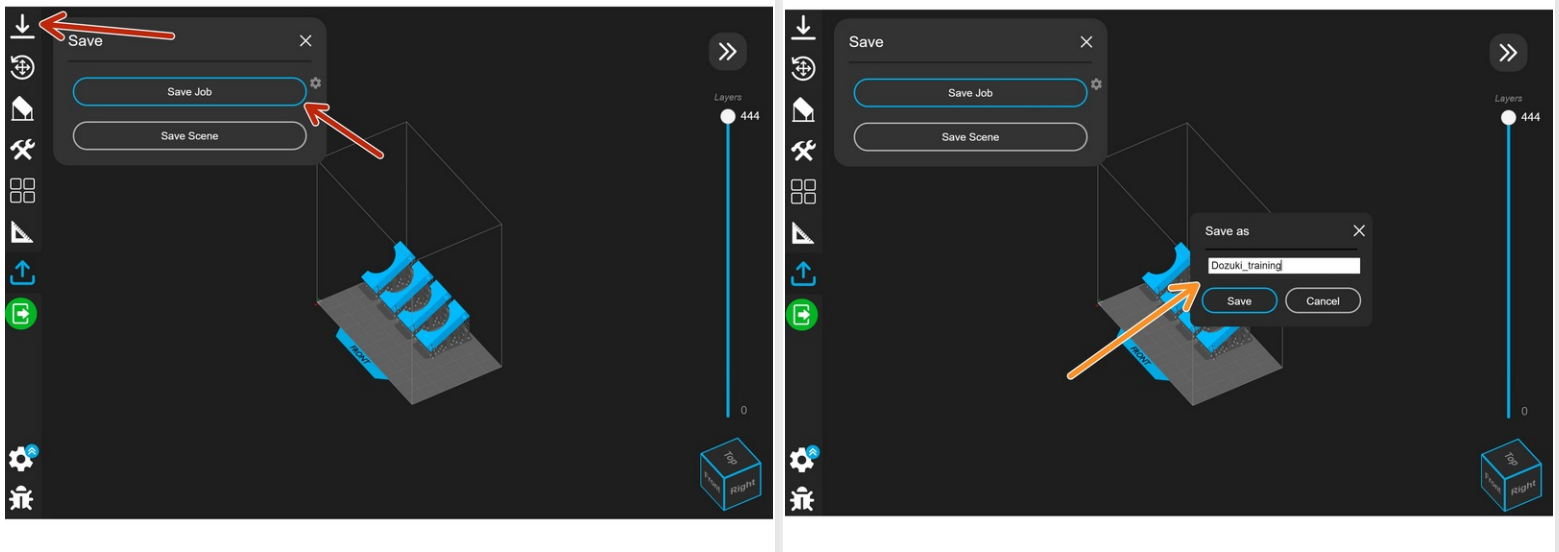
- Click the Save tab on the left side of the slicer, and then select "Save Job."

- Be sure to add the Papercut number to the title of the .NXA file. Save the file locally and upload it to the Papercut order.

- To print the file, copy the .NXA file onto a USB drive and insert the drive into the printer. Follow this guide for more info.