MONOPRICE

Select Mini 3D Printer V2

P/N 15365, 21711, 21872, 24166

User's Manual

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SAFETY WARNINGS AND GUIDELINES

- Be careful not to damage the yellow film on the build plate.
- Do not remove the insulating tape on the extruder nozzle.
- Take care to avoid touching hot parts, including heat blocks, extruder nozzle, extruded filament, and the heated build plate.
- Do not wear gloves when operating or repairing to avoid entanglement.
- Keep the printer and all accessories out of reach of children.
- Do not remove or disconnect the USB cable when printing from a computer.
- Do not pull or twist the black cable at any time.
- Do not force or tear anything when during unpacking and setup. This may cause damage to the printer and/or its accessories.
- Do not reach inside the printer during operation.
- Always allow the printer and extruded filament to cool before reaching inside.
- Ensure that the printer is turned off and unplugged from its power source before making repairs or performing service.
- Do not install this device on an unstable surface where it could fall and cause either personal injury or damage to the device and/or other equipment.
- Do not subject the product to extreme force, shock, or fluctuations in temperature or humidity.
- This device is intended for indoor use only.
- Do not expose this device to water or moisture of any kind. Do not place drinks or other containers with moisture on or near the device. If moisture does get in or on the device, immediately unplug it from the power outlet and allow it to fully dry before reapplying power.
- Do not touch the device, the power cord, or any other connected cables with wet hands.
- Use only in a well-ventilated area. Do not use in close, confined spaces.

- Prior to operation, check the unit and power cord for physical damage. Do not use if physical damage has occurred.
- Before plugging the unit into a power outlet, ensure that the outlet provides the same type and level of power required by the device.
- Unplug this device from the power source when not in use.
- Take care to prevent damage to the power cord. Do not allow it to become crimped, pinched, walked on, or become tangled with other cords. Ensure that the power cord does not present a tripping hazard.
- Never unplug the unit by pulling on the power cord. Always grasp the connector head or adapter body.

INTRODUCTION

Thank you for purchasing this 3D printer from Monoprice! This printer features a single extruder, which is capable of printing in PLA, ABS, and other materials. You can print from a Windows® or Mac® PC using a USB connection or can print from 3D model files stored on a microSD[™] card, without the need for a PC connection of any kind. This printer is easy to setup and easy to use following the instructions in this manual.

FEATURES

- Single extrusion print head
- Can print PLA, ABS, and other materials
- Open frame design for ease of use and maintenance
- Includes 256MB microSD[™] card with Cura, Repetier-Host, and a sample 3D model

CUSTOMER SERVICE

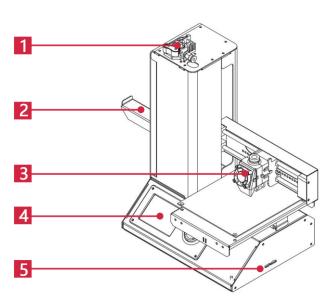
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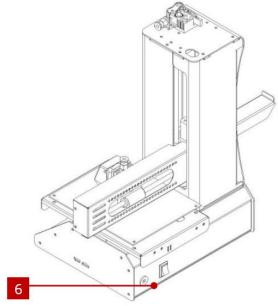
PACKAGE CONTENTS

Please take an inventory of the package contents to ensure you have all the items listed below. If anything is missing or damaged, please contact Monoprice Customer Service for a replacement.

- 1x 3D printer 1x Filament rack 1x Plastic scraper 1x USB cable 1x MicroSD[™] card 1x Hex wrench 1x Power adapter
- 1x AC power cord (NEMA 5-15 to IEC 60320 C13)

PRODUCT OVERVIEW





- 1. Feed Mechanism
- 2. Filament Rack
- 3. Extruder

- 4. LCD Display
- 5. Micro USB and MicroSD Ports
- 6. Input Power Jack and Power Switch

USING THE MENU SYSTEM

- The menu system is displayed on a lighted LCD screen.
- The menu selection highlight or pointer is moved by pressing the top and bottom buttons to the right of the display.
- Pressing the top button moves the highlight/pointer to the left and up.
- Pressing the bottom button moves the highlight/pointer to the right and down.
- Pressing the top button while editing a value decreases that value.
- Pressing the bottom button while editing a value increases that value.
- Press the center button to activate the selected menu item or to save an edited value.

SETUP

Warning! Take care not to remove or damage the yellow tape on the build platform. This tape is essential to ensure the 3D model properly adheres to the build platform during printing. If this tape becomes damaged or wears out, replace it with painter's tape, Kapton[®] tape, or ordinary masking tape.

Perform the following steps to prepare the printer for use.

- Remove the printer from its packaging and place it on a flat, stable surface with plenty of ventilation and a nearby AC power outlet.
- Open the Accessories box and remove the Filament Rack. Slide the tab at the flat end into the slot on the left side of the printer frame.
- 3. Ensure that the power switch on the rear panel is in the OFF position (**O** side depressed). Plug the C13 end of the included AC Power Cable into the C14 panel connector on the AC Power Adapter, then plug the other end into a nearby AC power outlet. Depress the I side of the power switch to power the printer ON.
- Rotate the control wheel clockwise to move the highlight to the Move entry, then press the center of the control wheel to open the Move menu.
- 5. Rotate the control wheel clockwise to move the highlight to the **Home Axis** entry, then

press the center of the control wheel to activate the Home Axis function. The printer will move the extruder head to the "home" position.

- 6. Turn the printer off by depressing the **O** side of the power switch.
- 7. Slide a sheet of A4 paper between the build platform and the extruder nozzle. The extruder height above the build platform should be 0.05mm, which is the thickness of a sheet of A4 paper. The extruder is at the correct height when the sheet of

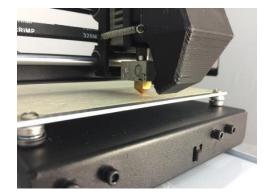


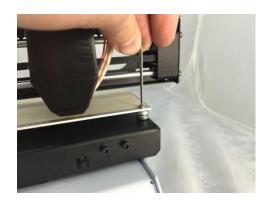


paper can be slid between the nozzle and the platform without binding. When the extruder head is moved or when the paper is moved under it, there should be a slight amount of resistance, but the paper should not be dragged with the extruder when it is moved.

If the height is incorrect, use the included hex wrench to make slight adjustments to the platform height by turning the screws at each corner of the platform. Turn the screws clockwise to lower the platform and counterclockwise to raise the platform. Turn the wrench no more than 1/4 turn each time, then recheck the height. Continue checking and adjusting until the height is correct at all points on the platform.

- Insert the included microSD[™] card into the slot on the right side of the printer.
- 9. Turn the printer on by depressing the I side of the power switch on the rear panel.
- 10. Rotate the control wheel clockwise to highlight the **Temperature** entry, then press the control wheel to open the Temperature menu.
- 11. Use the control wheel to highlight the **Extruder** entry, then press the control wheel to edit the value. Rotate the control wheel to set the temperature to the target temperature for the type of filament you plan on using.



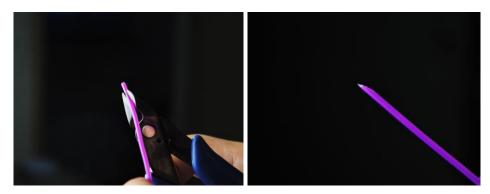






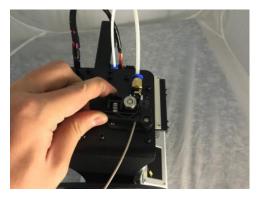
12. Using the same procedure, set the **Platform** temperature to the target temperature for your filament type.

- 13. If the button under the Extruder and Platform reads Start Preheat, use the control wheel to highlight the **Start Preheat** entry, then press it to start preheating the extruder and build platform. The button will change to read Stop Preheat and the Extruder and Platform buttons will read the actual temperatures.
- 14. While the printer is heating, open your filament. Using a pair of scissors or side cutters, diagonally snip the end of the filament to make a point, as shown in the images below.



- 15. Using the control wheel, navigate to the Move menu, then select the Z Axis option and press the wheel. Turn the control wheel counterclockwise to raise the extruder off the build platform.
- 16. Place the filament reel on the filament rack on the left side of the printer.
- 17. While squeezing the lever on the Feed Mechanism, insert the filament and push it into opening. Keep pushing until you feel resistance as it hits the extruder. Release the lever on the Feed Mechanism.
- 18. Using the control wheel, highlight the Extruder entry on the Move menu. Press the control wheel, then turn it counterclockwise to feed filament into the extruder. Continue until filament starts to extrude out of the nozzle. Wait until filament is no longer coming out of the nozzle.





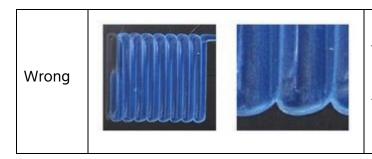
- 19. Using the included plastic scraper, clean the extruded filament from the nozzle and build platform.
- 20. Using the control wheel, select the **Print** option from the main menu. The printer will read the contents of the microSD[™] card and display them on screen. Highlight the **cat.gcode** file, then press the control wheel to start printing the model.
- 21. After the first layer has been laid down, use the control wheel to **Pause** or **Cancel** the printing operation. Examine the layer and compare the printed material with the images in the table below. If the result is wrong, turn off the printer and re-adjust the platform





height as indicated. Clean off the printed material using the included plastic scraper, then print the model print again. Keep repeating this process until the result is correct.

Wrong	The nozzle is too far from the platform. This can result in the extruded material not sticking to the build platform.
Correct	The nozzle is at the correct height above the platform.



The nozzle is too close to the platform. This can result in damage to the nozzle and build platform.

Congratulations, your 3D printer is setup and ready for use!

WI-FI SETUP

You can connect the printer wirelessly to a 2.4Ghz Wi-Fi[®] network to print models from your Android[™] or iOS[®] phone or tablet. Perform the following steps to setup the Wi-Fi connection for your device.

- 1. Download the free **MP 3D Printer WiFi Connect** app from the Google Play Store or from iTunes, depending on which type of mobile device you have.
- 2. Disconnect the USB cable from the printer. You cannot use USB and Wi-Fi connections at the same time.
- 3. Power on the printer.
- 4. Start the MP 3D Printer WiFi Connect app.
- The SSID of your Wi-Fi network should be displayed on screen. If a different SSID is displayed, open your device's Wi-Fi settings and select the appropriate Wi-Fi network.
- 6. Enter your wireless password.
- 7. Use the printer's buttons to navigate to the **Move** menu.
- Press and hold the center button for 3 seconds. Release the button when Smart config started is displayed on screen.
- Press the Connect to WiFi button on your mobile device. The connection will be completed within 10 ~ 60 seconds and the message MP Select Mini is now

connected to Wi-Fi will be displayed on your device's screen and the IP address will be displayed at the top of the printer's LCD screen.

Note that you may have difficulty connecting to the Wi-Fi network if you have a 2.4GHz and 5GHz network with the same SSID. Try changing the SSID of the 5GHz network if this occurs. For best results, move the printer to a location closer to the Wi-Fi router or access point.

SOFTWARE INSTALLATION AND SETUP

As you've seen, you can print a model directly from a gcode file on a microSD[™] card and this is the preferred method, as it does not require a continuous connection to your computer. You can download gcode files to the microSD card and print them without having to build any model files.

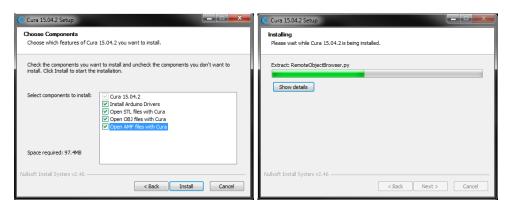
However, you can create your own gcode files using an open source program, such as Cura or Repetier-Host, which are pre-installed on the microSD card that comes with the printer. These programs use M200 models (typically .STL or .OBJ files) and, using machine specific information, generate a gcode file with detailed instructions for the printer to create the selected model. We recommend you start with Cura, since it includes a Slicing Engine.

Installing Cura for Windows

- Use a card reader to read the contents on the included microSD[™] card. Locate and doubleclick the Cura_15.04.2.exe file to start the setup program.
- You may choose a new location for the program files or accept the default (recommended). Click Next to continue.

-	15.04.2 Setup			
Choo	se the folder in which to ins	tall Cura 15.04.2.		
Setuj Brow	will install Cura 15.04.2 in se and select another folde	the following folder. r. Click Next to conti	To install in a diffe nue.	rent folder, dick
De	tination Folder			
	:\Program Files (x86)\Cura	_15.04.2		Browse
	e required: 97.4MB			
Spac	e available: 39.4GB			
Nullsoft	Install System v2.46			
			Next	> Cancel

3. Ensure that all boxes are checked, then click **Install** to continue.



4. Once the files have been extracted and the Cura installation is complete, the driver installation wizard will launch. Click **Next** to continue.



5. Click Finish to complete the driver installation.

Device Driver Installation Wizar	d					
	Completing the Device Driver Installation Wizard					
	The drivers were successfully installed on this computer.					
	You can now connect your device to this computer. If your device came with instructions, please read them first.					
	Driver Name	Status				
	V Arduino LLC (www.ardui	Ready to use				
	< Back	Finish Cancel				

6. Click **Next** to continue.

Rady Navt	> Cancel
	<back next<="" td=""></back>

7. Ensure that the box next to the **Start Cura 15.04.2** option is checked, then click **Finish** to complete the installation and launch the program.

C Cura 15.04.2 Setup	_ □ ×					
	Completing the Cura 15.04.2 Setup Wizard					
	Cura 15.04.2 has been installed on your computer.					
	Click Finish to close this wizard.					
A	☑ Start Cura 15.04.2					
	< Back Finish Cancel					

 Wait for Cura to finish launching. If this is the first time you have run Cura on this machine, Cura will automatically launch the First time run wizard. Otherwise, you will need to select Machine > Add new machine.

Configuration Wizard	<u>l</u>	
First time run wizard		
Welcome, and thanks for trying Cura!	I	
This wizard will help you in setting up Cura for your machine.		
Select your language: English -		
		File Tools Machine
		Prusa Mendel I3
	۲	Reprap
		Add new machine
		Machine settings
		Install default firmware
< Back Next > Cancel		Install custom firmware

9. Click the button next to the **Other** option, then click the **Next** button to continue.

Configuration Wizard
Select your machine
What kind of machine do you have: Utimake 2 Utimake 2 Utimake 200 Utimake Original Utimake Original
Printbot Lubbot TAZ Lubbot TAZ Uubbot Miri Other (Ex: RepRap, MakerSot, Witbox)
The collection of anormous usage information helps with the continued improvement of Cura. This dees NIC3 advects on or gathers are privacy related information. Submit anonymous usage information: [2] For full details see: http://wks.utamaker.com/Cura:stata
<back next=""> Cancel</back>

10. Select the **Custom...** option, then click **Next** to continue.



11. Click the button to the left of the **Other** entry, then click **Next** to continue.



12. Change the settings to match those shown in the images below, then click **Finish** to continue.

RepRap machines can be v Be sure to review the defa If you like a default profile then make an issue on gith	An RepRap information astly different, so here you can set your own settings. dit profile before running it on your machine. for your machine added, .do. stall Markin or Sportter Finnware. Monoprice 13055		
Machine width X (mm) Machine depth Y (mm) Machine height Z (mm)	120 120 120	Machine name	Monoprice 15365
Nozzle size (mm) Heated bed Bed center is 0,0,0 (RoStor	0.4	Machine width X (mm)	120
		Machine depth Y (mm)	120
		Machine height Z (mm)	120
		Nozzle size (mm)	0.4
	< Back Finish Cano	Heated bed Bed center is 0,0,0 (RoStoc	▼ k) □

13. The program will finish launching and leave you on the main screen. Select the **Basic** tab, then change the settings to match those in the accompanying image for PLA filament.

Note that the Fill density, Support type, and Platform adhesion type options should be set according to the needs of the model you are printing.

The **Fill density** will determine the overall strength of the finished object. If printing a decorative object, a low fill density is appropriate. However, if printing an object that will be used as a tool or part (e.g., a gear), a high fill density will impart maximum structural strength to the finished object.

If printing something with no overhang, such as a cube, you can set the **Support type** to **None**. If the model has areas that overhang the

Basic	Advanced	Plugins	Start/End-GCode	
Quali	ty			
Layer	height (mm)		0.1]
Shell t	hickness (mm)	0.8]
Enable	retraction		\checkmark	
Fill				
Botton	n/Top thickne	ess (mm)	0.6]
Fill Der	nsity (%)		20	
Spee	d and Ten	iperatu	ire	
Print s	peed (mm/s)		50	
Printin	g temperatu	re (C)	210	
Bed te	mperature (C)	0	
Supp	ort			
Suppo	rt type		Touching buildplate	•
Platfor	rm adhesion	type	Brim	•
Filam	ent			
Diame	ter (mm)		1.75	
Flow (%)		100.0	

build plate, but which are not overhanging a lower section, you can use the **Touching buildplate** option. The **Everywhere** option is usually only necessary for very complex models with parts that overhang other parts.

In most cases, the **Brim** option for the **Platform adhesion type** is sufficient and is easier to remove and clean up. The **Raft** option builds a flat layer on which the model is then built and will need to be removed once the print is complete.

Feel free to experiment with these options to achieve the best possible print.

14. Click the Advanced tab, then change the settings to match those in the accompanying image. Note that if you have a very high fill density (from the previous step), you will want to increase the Cool down time (Minimal layer time) to 10 seconds.

asic Advanced	Plugins	Start/End-GCode	
Machine	, again		
		0.4	
Nozzle size (mm)		0.4	
Retraction			
Speed (mm/s)		40.0	
Distance (mm)		4.5	
Quality			
Initial layer thickne	ss (mm)	0.3	
Initial layer line wid	th (%)	100	
Cut off object bott	om (mm)	0.0	
Dual extrusion ove	rlap (mm)	0.15	
Speed			
Travel speed (mm/	s)	150.0	
Bottom layer speed	d (mm/s)	20	
Infill speed (mm/s)		0.0	
Top/bottom speed	(mm/s)	0.0	
Outer shell speed ((mm/s)	0.0	
Inner shell speed (i	mm/s)	0.0	
Cool			
Minimal layer time ((sec)	5	
Enable cooling fan		✓)

15. Finally, using the included Micro USB cable, plug one end into the USB port on the printer, then plug the other end into an available USB port on your computer. Watch the right hand corner of the screen. A bubble will appear in the lower right corner of your desktop, which is telling you that Windows is installing the necessary printer drivers. Click the bubble and verify that the drivers have been properly installed.

Congratulations, you have installed Cura and connected your PC to your new 3D printer. Refer to Cura's documentation for operating details and information on the various options.

Repetier-Host

You can also install Repetier-Host from the file on the included microSD[™] card or from a download from the internet. The screenshots below show the proper settings to use for this printer in Repetier-Host.

Printer Setti	ngs							
Printer:	defaul	default 🗸						â
Connection	Printer	Extruder	Prin	ter Shape	Scripts	Advanced		
Travel Fee	ed Rate:			4800		[mm/min]		
Z-Axis Fe	ed Rate:			100		[mm/min]		
Manual Ex	trusion S	peed:		2		20		[mm/s]
Manual Re	traction	Speed:		30		[mm/s]		
Default E	xtruder T	emperature	:	200		°C		
Default H	eated Bed	Temperatu	re:	55		°C		
Default Heated Bed Temperature: 55 ° C Check Extruder & Bed Temperature Remove temperature requests from Log Check every 3 seconds. Park Fosition: X: 0 Y: 0 Z min: 0 [mm] Send ETA to printer display Go to Park Fosition after Job/Kill Disable Extruder after Job/Kill Disable Heated Bed after Job/Kill Disable Motors after Job/Kill Printer has SD card Add to comp. Frinting Time 8 [%] Invert Direction in Controls for X-Axis Y-Axis Z-Axis								
-					0	K	Apply	Cancel

Printer Settings										
Printer:	default	default 🗸 💼								
Connection	Printer E	xtruder	Printer Shape	Scripts Adv	anced					
	f Extruder:		÷							
Max. Extr										
Max. Bed	Temperature	2:		60						
	une per seco			12 [mm ³ /s]						
🗌 Print	er has a Miz	king Extr	ruder (one nozz	le for all co	lors)					
-Extruder 1										
Name:										
Diameter:	0.4		[mm] Tempers	ture Offset:	0	[° c]				
Color:										
Offset X:	0		Offset	¥:	0	[mm]				
				OK	Apply	Cancel				
				OK	Apply	Cancel				

Printer Settings											
Printer:	nter: default 🗸 💼										
Connection	nnection Printer Extruder Printer Shape Scripts Advanced										
Printer Type: Classic Printer 🗸											
Home X:	Min	↓ Home ¥:	Mi	in 🗸 Home Z: Min 🗸							
X Min 0		X Max 110		Bed Left: 0							
Y Min 0		Y Max 110		Bed Front: 0							
Print Area	Width:	110		mm							
Print Area	Depth:	110		mm							
Print Area	Height:	110		mm							
The min and max values define the possible range of extruder coordinates. These coordinates can be negative and outside the print bed. Bed left/front define the coordinates where the printbed itself starts. By changing the min/max values you can even move the origin in the center of the print bed, if supported by firmware.											
E E											
				OK Apply Cancel							

TECHNICAL SUPPORT

Monoprice is pleased to provide free, live, online technical support to assist you with any questions you may have about installation, setup, troubleshooting, or product recommendations. If you ever need assistance with your new product, please come online to talk to one of our friendly and knowledgeable Tech Support Associates. Technical support is available through the online chat button on our website **www.monoprice.com** during regular business hours, 7 days a week. You can also get assistance through email by sending a message to **tech@monoprice.com**

REGULATORY COMPLIANCE

Notice for FCC

F©

This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

Notice for Industry Canada

This Class B digital apparatus complies with Canadian ICES-003.

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