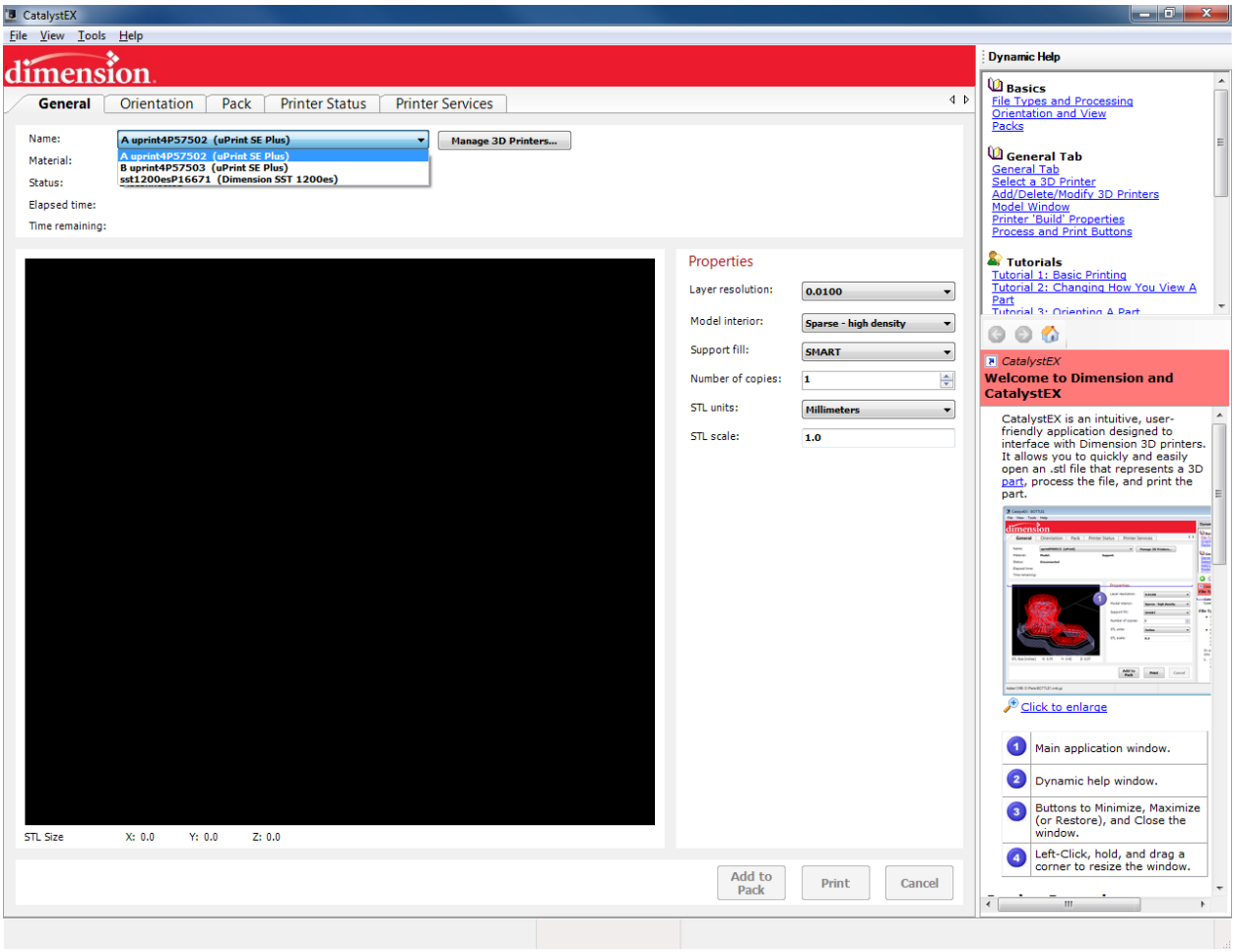
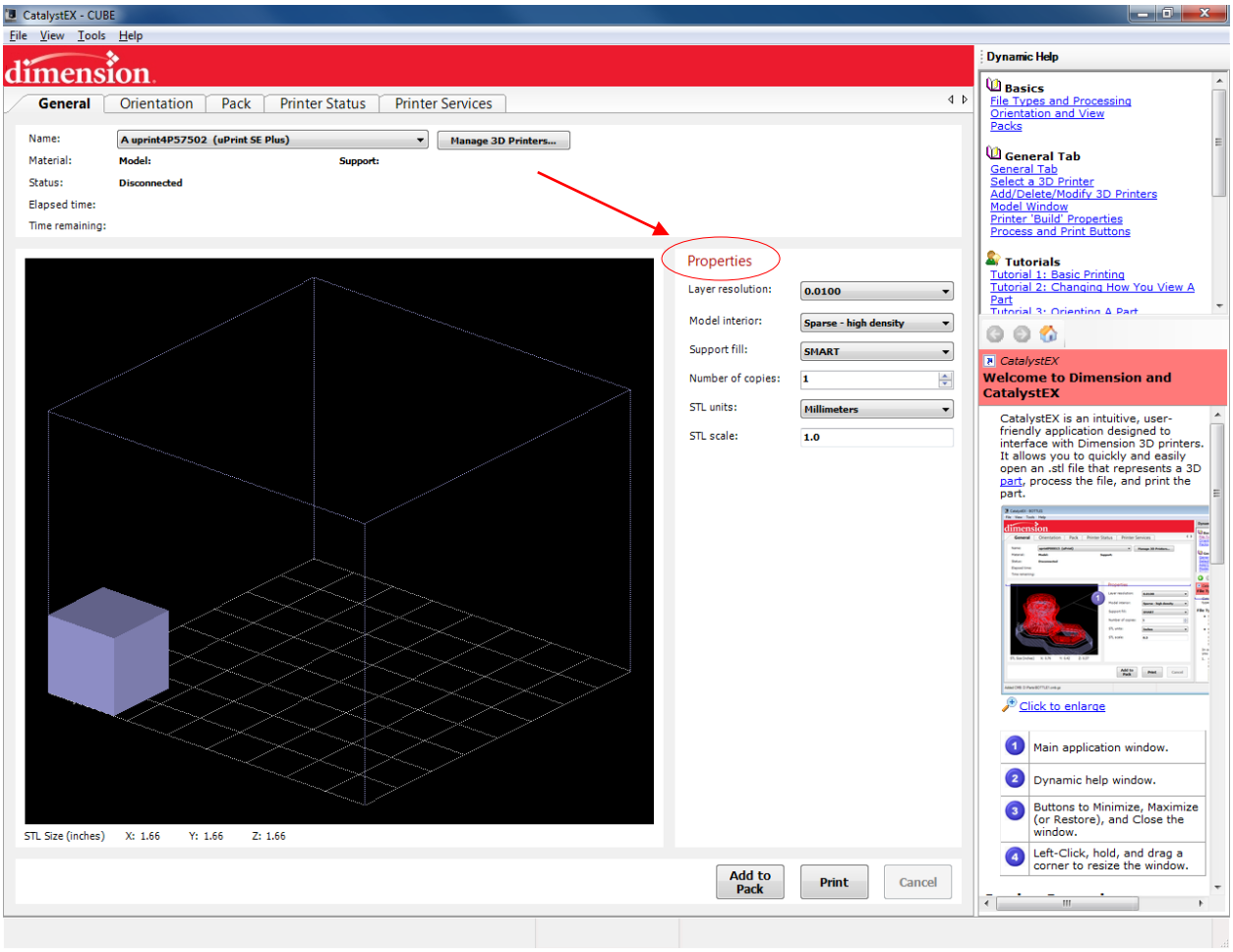
The first step is to pick the printer you want to use. Based on the size of your build, that will affect your printer choice.

Printer Envelopes:

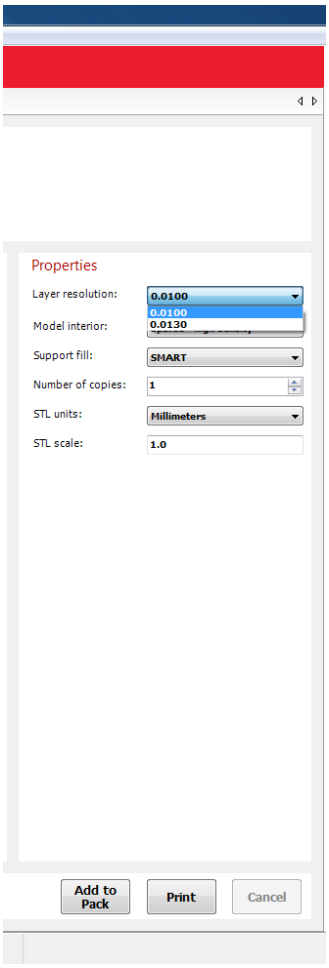
- Dimensions sst 1200es – 254 x 254 x 305 mm (10 x 10 x 12 in.)
- uPrint SE Plus - 203 x 203 x 152 mm (8 x 8 x 6 in.)

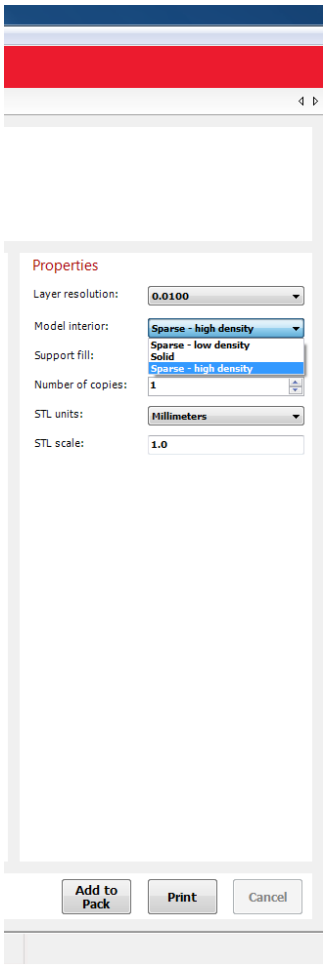


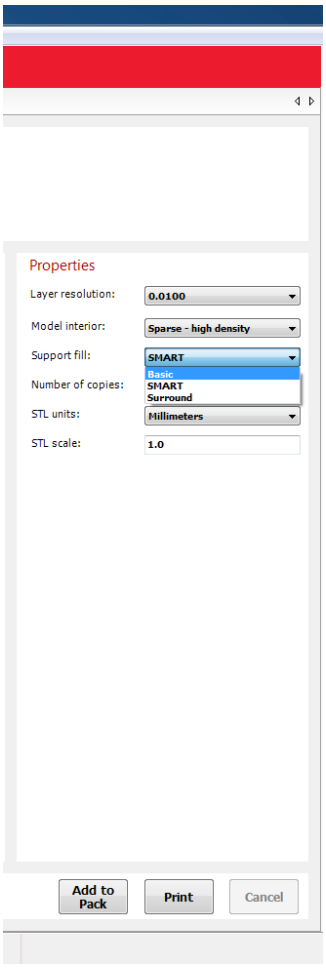
Then click “File” / “Open .stl” and browse for the file you wish to build.



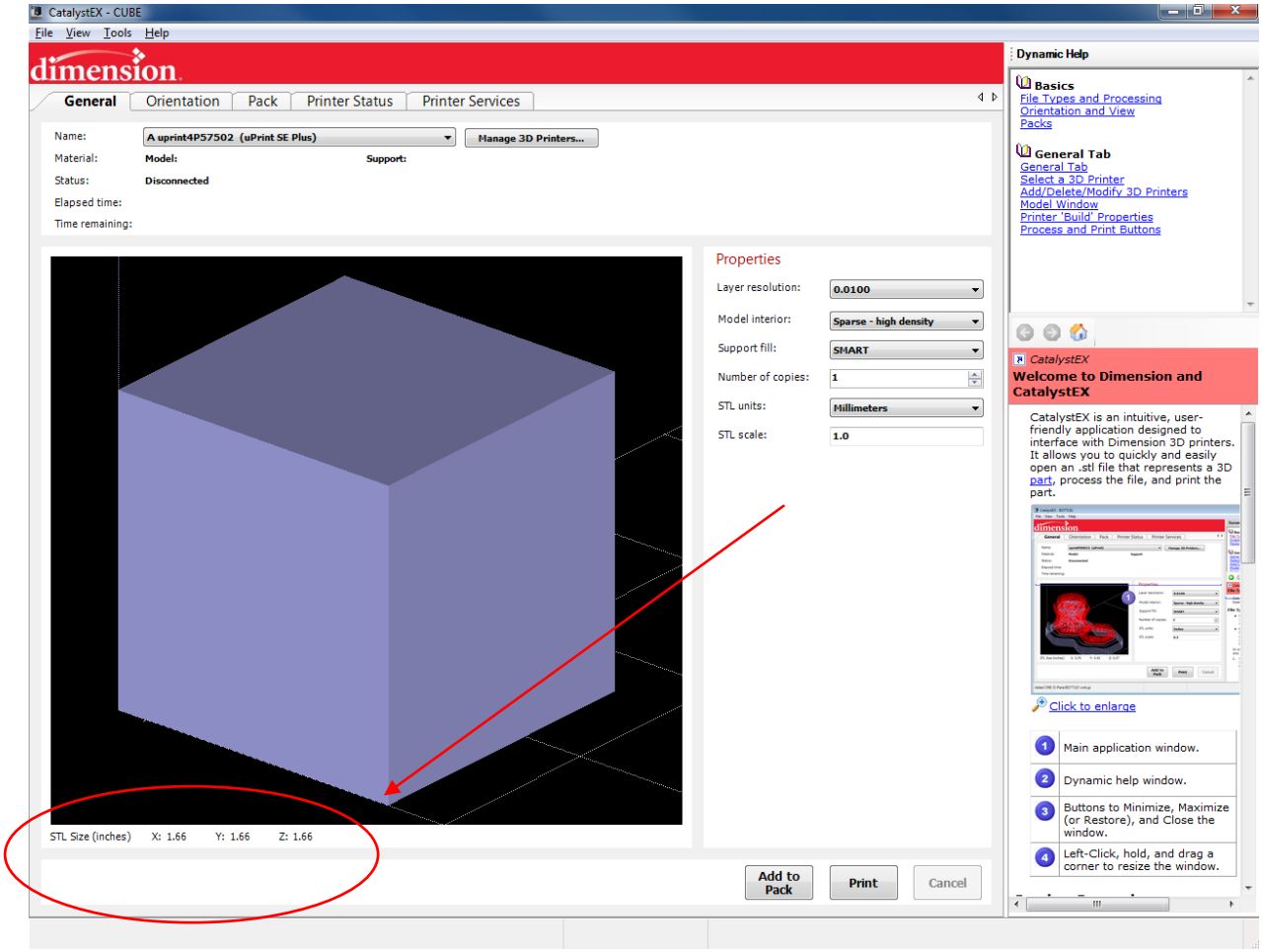
It will then show a preview of your .stl within the printer bound, as seen with this test part. The next step is to adjust the properties specifically for this build.





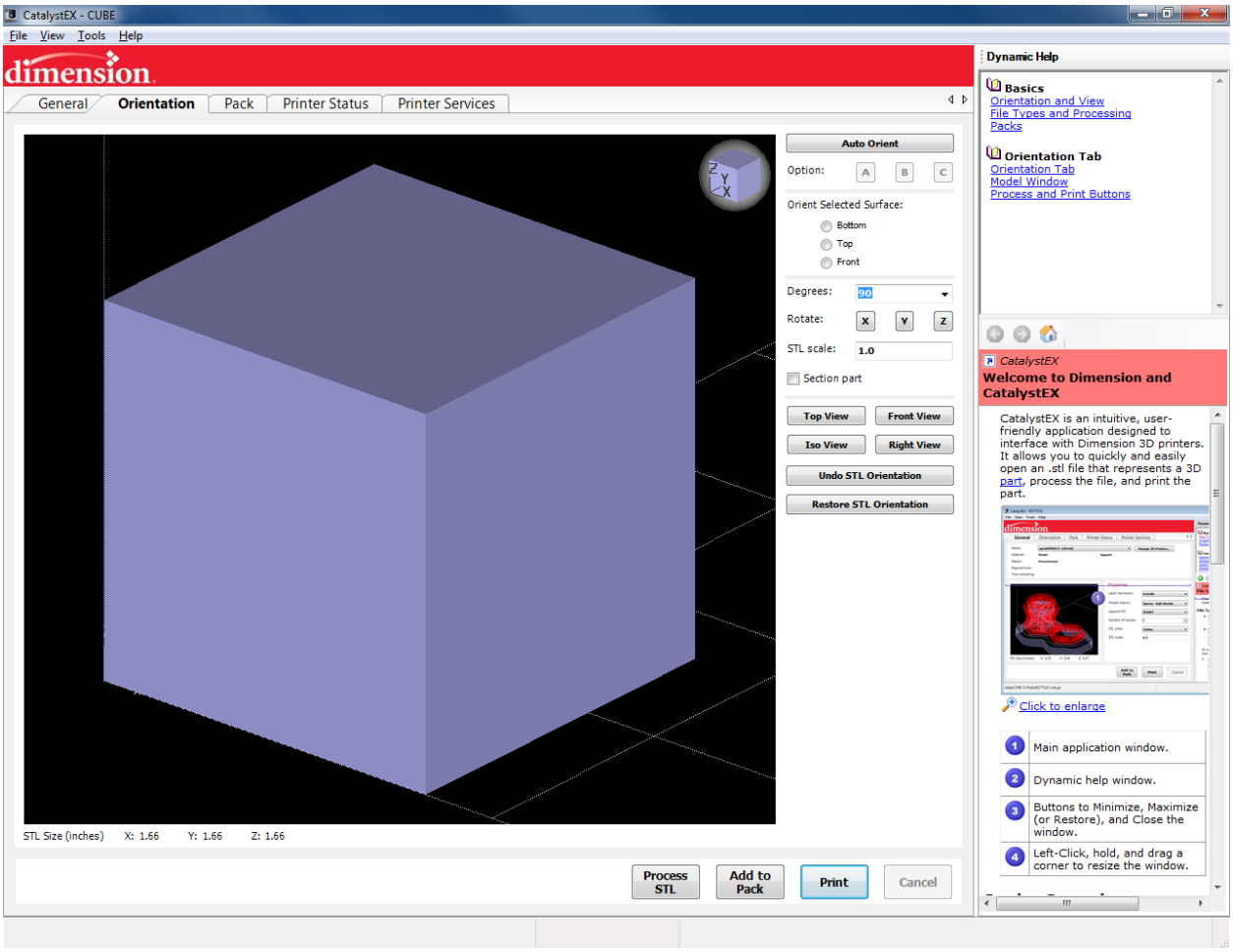


You must provide information for all the properties listed. If you desire to print as your file was dimensioned in your 3D modeling software – leave the scale option at 1. The .stl units – leave in millimeters; the Catalyst software will read the x,y,z dimensions of you part in inches in the bottom left corner in inches.



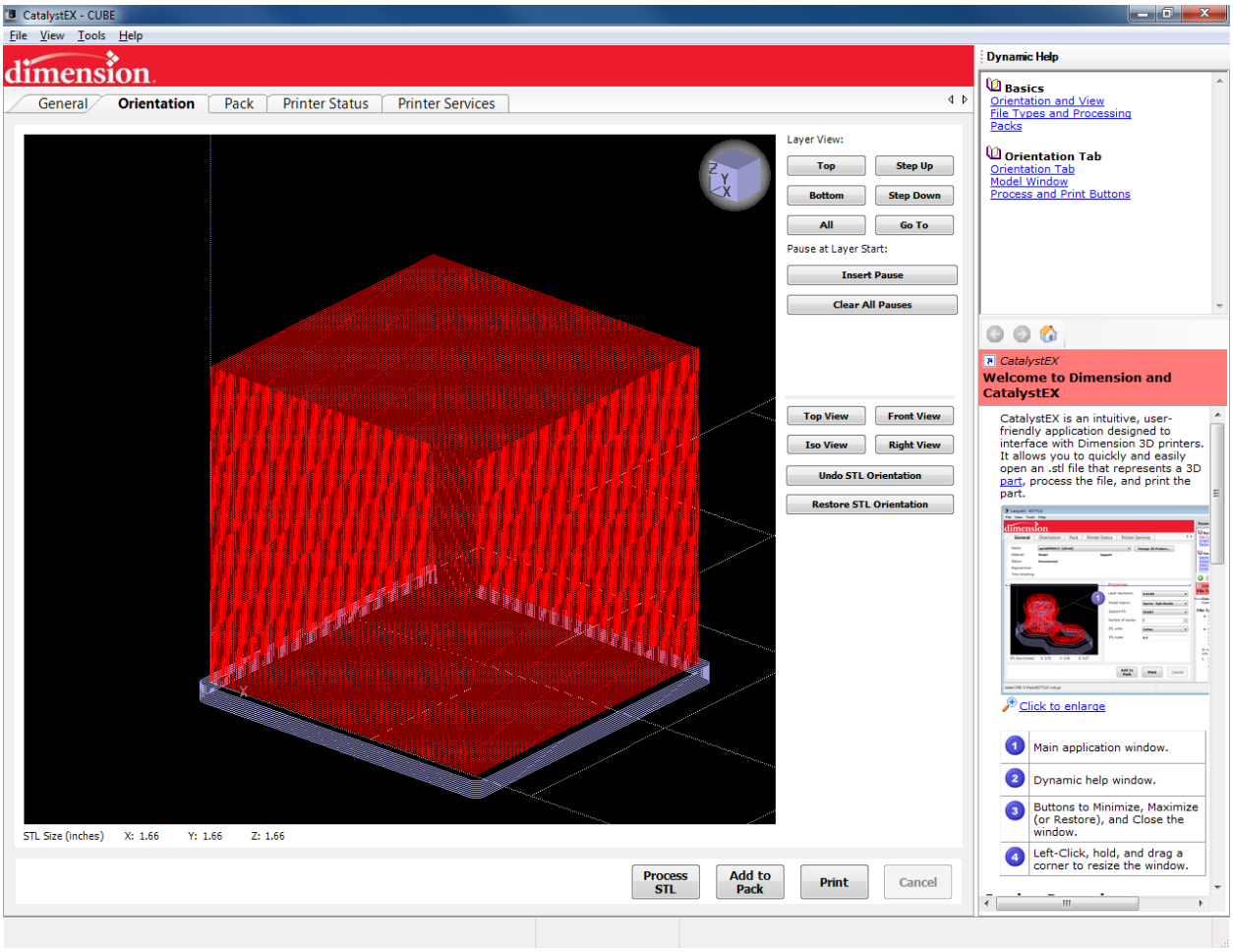
If no change in the orientation is needed, click the “Add to Pack” button on the bottom of the page. It will process the .stl file and add it to the pack.

The next step is to go to the “Orientation” tab at the top of the page. Note that the plane in which the .stl is being built upon is the XY plane, known as the modeling base or the print bed, and it is built up in the Z direction. To change the orientation follow the directions below.

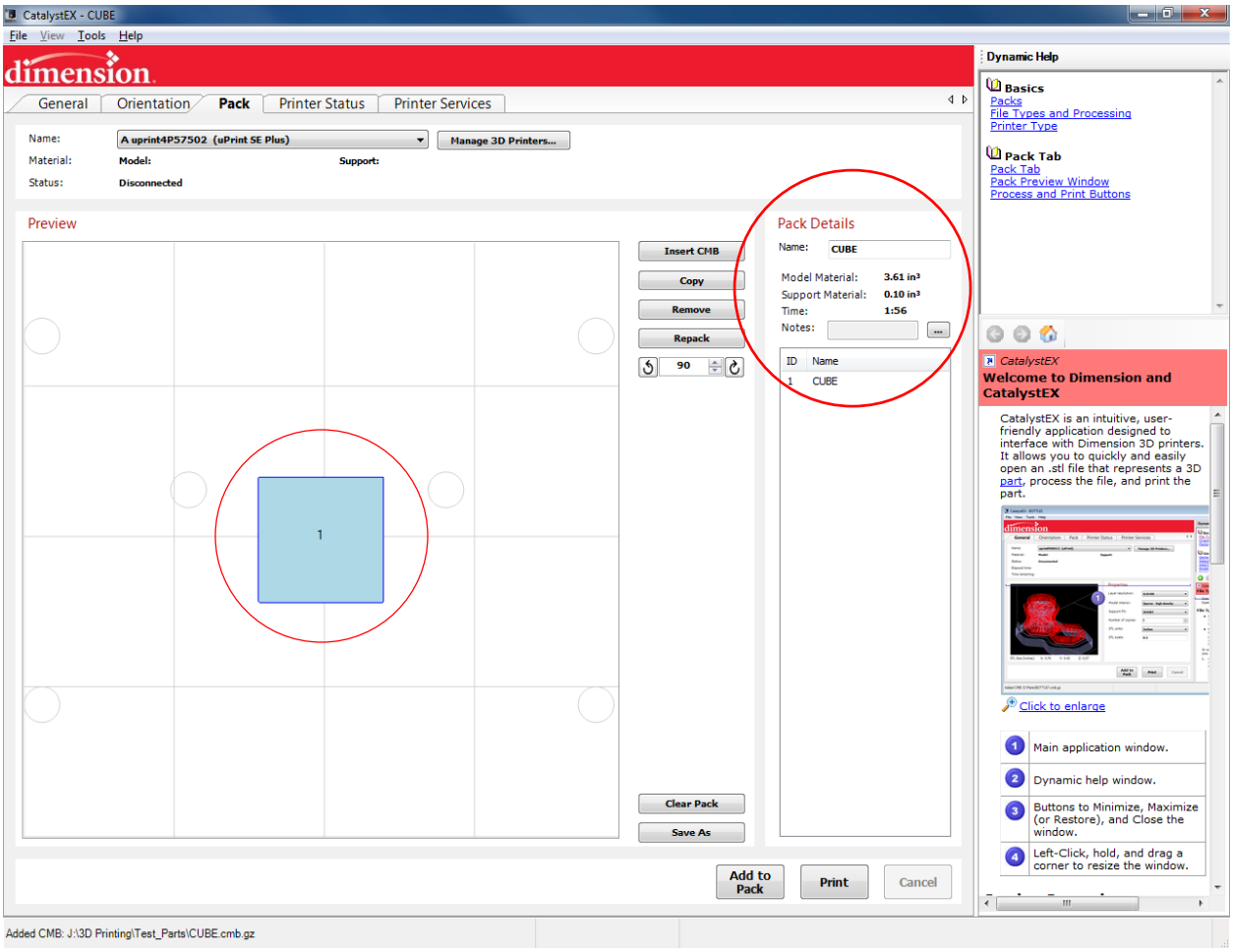


It will direct you to a page that looks like the above. Toggle through the “Degrees” option, then hit whichever axis you wish to rotate about. You can always click the “Restore STL Orientation” button to reset to the original configuration.

Once reoriented, click the “Process STL” button on the bottom of the page. This slices the part, creating a path for the print head to print the build layer by layer. It will then show a preview of the part seen below.



Now click the “Add to Pack” button, and go to the “Pack” tab on the top bar. The page will look as indicated below.



The colored and numbered icon represents the footprint of your build on the modeling base. Move it to the location on the base where you wish it to print.

The most important information will be under the “Pack Details”. It lists the amount of model material, the amount of support material and the estimated build time of the part. These values are to be reported for approval before printing is allowed.