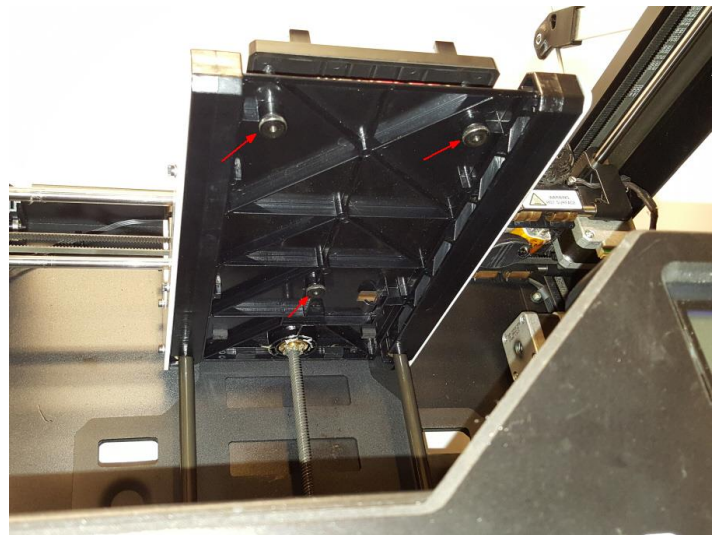
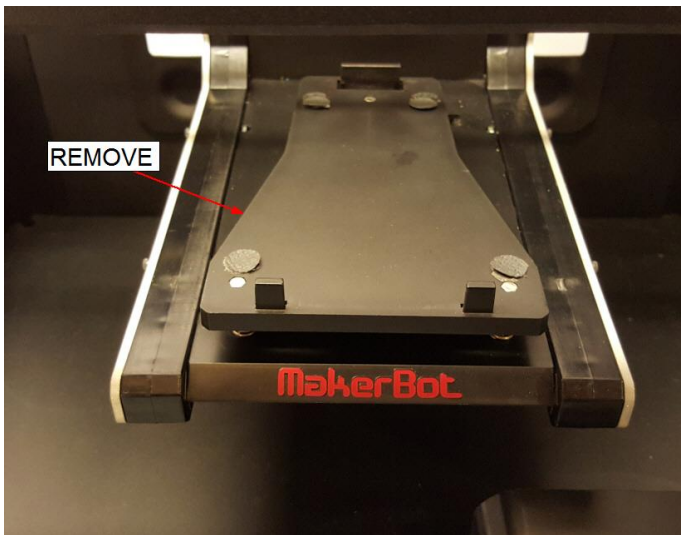


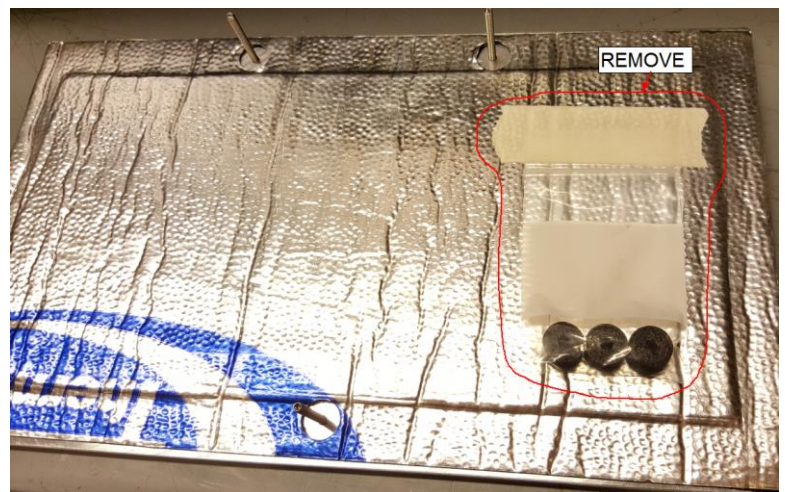
Thank you for your purchase of our heated build plate system for the Makerbot Replicator 2. If you have any questions, please contact us at sales@p3-d.com and we will get right back to you.

Installation:

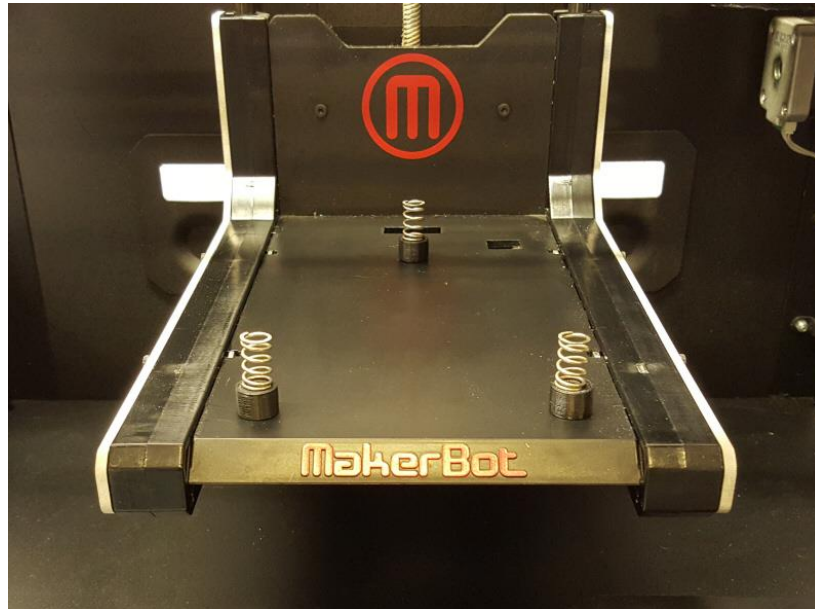
Remove the existing build plate (acrylic, glass, etc...) by unsnapping it from the clips. Then remove the plastic frame by removing the 3 thumb nuts underneath the Z-stage:



KEEP the **3 thumb nuts** and **springs**, you will re-use these! Remove the bag and masking tape from the underside of the new heated build plate. Also notice the 3 cutouts around the threaded posts, this is where the springs will sit.



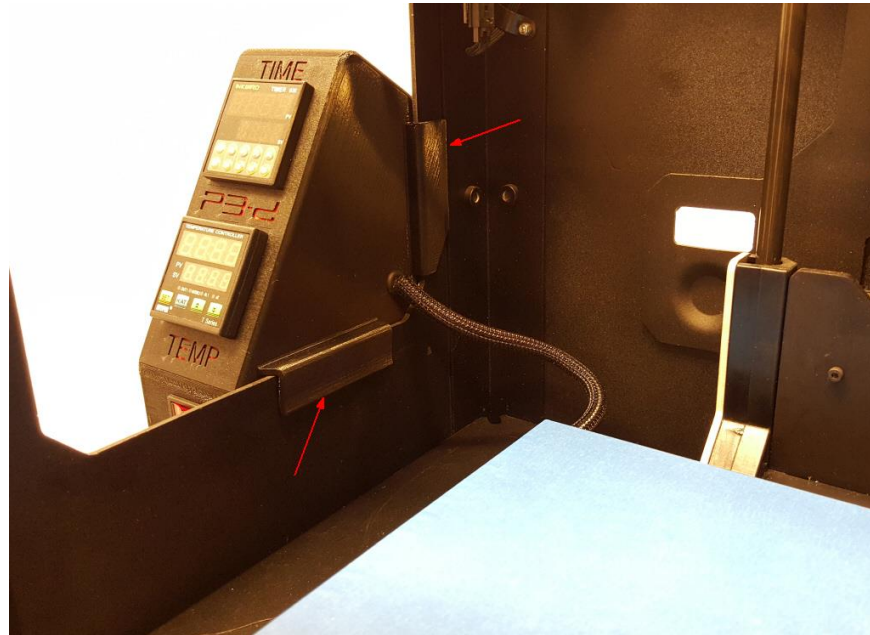
Setup the 3 height spacers and the springs as shown below. Ensure the spacers are ON BOTTOM (away from the heated build plate):



Lower the build plate rods thru the springs, spacers, and Z-stage. Re-attach the thumb nuts from underneath (you may have to compress the springs slightly to start the thumb nuts). Tighten the thumb nuts all the way (this will help ensure the nozzle doesn't crash into the plate when you level it).



Clip the controller box onto the left side of the Makerbot Replicator 2 side panels as shown. Take care the cord from the controller to the build plate is not kinked or tangled and is free to move up and down unobstructed:



After build plate is installed, and the control box is hung from left side of Replicator 2, plug in the power cord.

Be sure to PRE-HEAT both the extruder AND the build plate (see operating instructions on next page), and then RE-LEVEL the nozzle! We recommend running the leveling procedure twice when you first install the build plate.

Temperature Operation:

1. Switch bottom button to ON.
2. The unit will power up for a few seconds (it will display the temperature unit, the max and min set points, and finally the current temperature and current set point).
3. Adjust the temperature setting by pressing the blue ALT key until the digit you wish to change is highlighted. Use the up/down arrow keys to set the new value. Finish by pressing the orange SET button once.
4. Due to different ambient temperature conditions, different print bed materials, and different filament types, it is up to the user to determine the optimum temperatures for each individual situation. A good place to start is 55°C for PLA and 110°C for ABS. The heated build plate input is limited to 130°C.
5. Make sure to **pre-heat the nozzle** and let the **build plate temperature stabilize for approx. 5 minutes** and then **re-level the build platform!** Tighten the springs almost fully the first time to avoid crashing into the nozzle! It is **HIGHLY** recommended to use our aluminum arm stiffeners with this product.

Timer operation:

1. Simply use the up/down arrow keys to set the hour and minutes for the timer. Press the MD key once when finished. The timer will count UP to the set value and then shut off the heater.
2. At any time during a print you wish to restart the timer, you can press the RST key. You can also adjust the timer at any point by keying in a new value and pressing the MD key.
3. The recommended operation is to set the timer for a bit longer than you know the print will take.
4. The timer is always active. The maximum time allowed is 99.99 hours.

****The timer function is not an excuse to leave your printer unattended.** 3D printers and heated print beds must be used by adults and under the direct supervision of experts. Your use of this product is entirely at your own risk. Your purchase and use this product shall serve as your explicit acknowledgement that you understand and consent to the fact that we hereby disclaim any responsibility or liability for any harm, loss (economic or otherwise), injury or death resulting from the assembly or operation of our products, either as instructed or otherwise, and affirm that under no circumstances shall you be entitled to any damages of any sort whatsoever related to your use or misuse of our products. Due to the nature of high performance 3d printing parts and the variation of available printers, our products depend on highly skilled customers to correctly install and operate our products. If any damage should occur from using a P3-d product or from improper installation of a P3-d product, liability of P3-d will not extend past the P3-d product in question and/or the original purchase price. This includes, but is not limited to, damage to other parts of a 3d printer, the 3d printer itself, the vicinity the printer resides in, personal injury, failed prints or materials.

If any part of your purchase should fail to meet your expectations, please message us directly at sales@p3-d.com and we will do our best to resolve any issues immediately. Please check out our other 3D printer upgrades and accessories on our website.

-The Performance 3-d Team