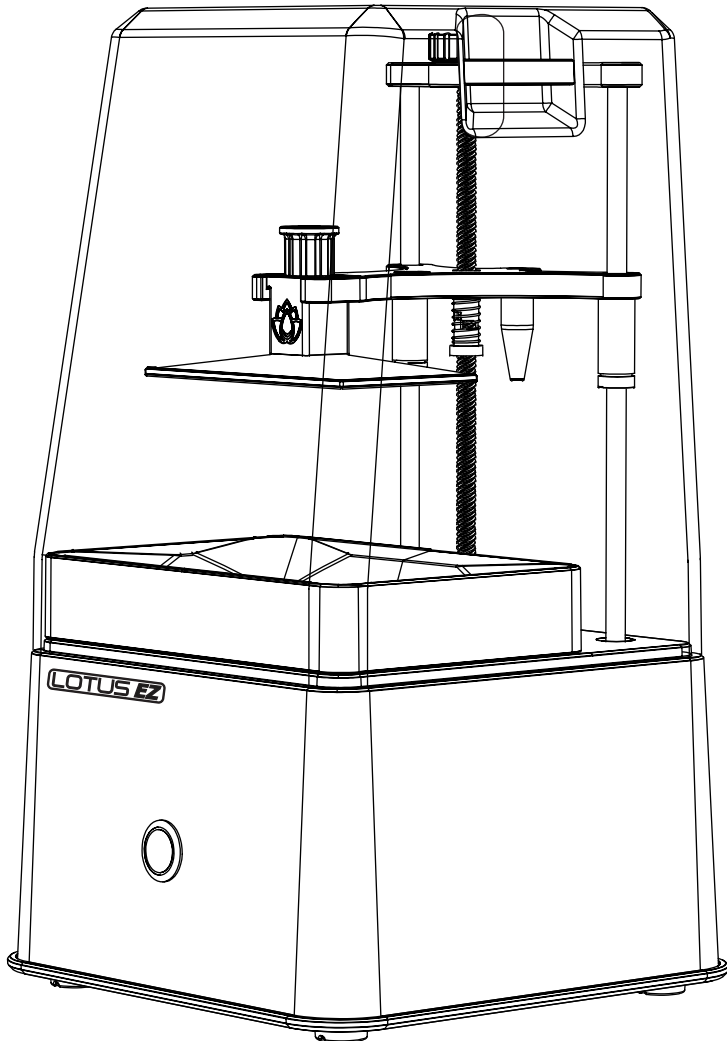


# Quick start guide

Version 1.0

## LOTUS EZ

Your personal Wi-Fi hotspot name and password can be found inside this guide.



[www.lotus3dprinters.com](http://www.lotus3dprinters.com)

# Setting up the Lotus EZ

## 1) Power

- Plug the provided power adapter into the wall socket.
- Connect the power adapter to the back of the Lotus EZ.
- Turn on the Lotus EZ by pressing the front power button.

## 2) Connecting the Lotus EZ

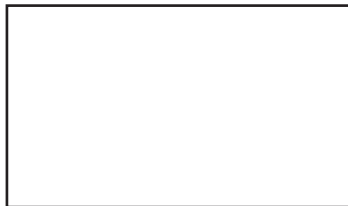
### ***Wi-Fi connection:***

- After powering on the Lotus EZ, wait approximately 30 seconds and then connect to the Wi-Fi hotspot with the password as shown on the sticker below.
- Once connected, simply go to the address as shown on the sticker below (or to 192.168.4.1) in your internet browser. **Note:** Microsoft Edge will require you to enter the IP address.
- Follow the guide on how to connect the Lotus EZ to your home Wi-Fi network on our support page at [www.lotus3dprinters.com/support](http://www.lotus3dprinters.com/support).

or,

### ***Ethernet connection to a router:***

- Plug in the provided ethernet cable into your router and the Lotus EZ. After approximately 60 seconds browse to the address as shown on the sticker below.

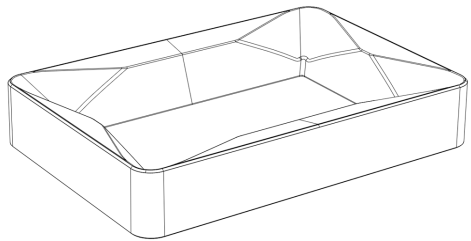
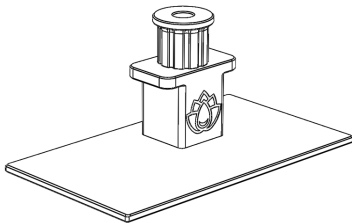


*For more detailed instructions and videos on any step in this Quick Start Guide please see [www.lotus3dprinters.com/support](http://www.lotus3dprinters.com/support)*

# Printing with the Lotus EZ

## Preparing the Lotus EZ

- Install the build platform and the vat onto the printer. These can be found in the 'Parts & Accessories Box'.
- The printer comes precalibrated and prelevelled. Find out more on [www.lotus3dprinters.com/support](http://www.lotus3dprinters.com/support).
- Shake the EZResin very well for at least 30 seconds. Pour the EZResin into the vat (resin of max 100ml is recommended, this is roughly a height of 5mm).



*build platform and vat*

## EZ Dashboard

- Browse to the address as shown on the sticker on the left (or to 192.168.4.1) in your internet browser.
- Follow the 2 steps shown below to print a preloaded testprint.

1. [navigate to the models section](#)

| Name          | Resin   | Details              | Actions  |
|---------------|---|----------------------|--|
| Hollow Draudi | Lotus EZResin 40µm<br>40.0µm<br>12.00 seconds | 3.75ml<br>799 layers | <b>2. Print</b> <input type="text" value="Layer"/> |

[press 'Print'](#)

*EZ Dashboard*

# Preparing models for printing

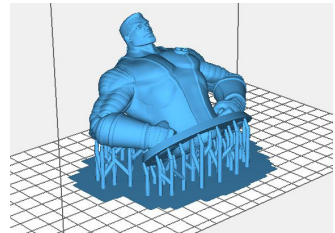
Printing with resin sometimes needs a little preparation work with the model you intend to print. We have preloaded some examples of models onto the Lotus EZ. These models show the different ways you can best prepare prints for a successful experience.

Before you begin, we recommend the following two free programs to help you on your journey:

- *ChiTu slicer*: <http://www.cbd-3d.com/en/soft/dlpslicer.shtml>
- *Autodesk Meshmixer*: [www.meshmixer.com](http://www.meshmixer.com)

## Supports

ChiTu slicer allows you to generate supports both automatically and manually. Generally it is often a good idea to raise your model and add supports. Keep in mind that overhanging features always need supports.

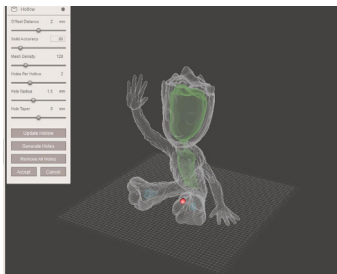


Colossus Bust by Geoffro (Thing: 1729528). On supports, hollowed and angled.

## Angle your model

1) The goal is always to make sure that the cross surface area between two proceeding layers doesn't increase drastically. To make sure this doesn't happen you can angle your model.

2) Angling your model also reduces the overall height of the model (in printing with resin, height equals time!).



Baby Groot by byambaa (Thing: 2014307). Hollowed.

## Hollowing

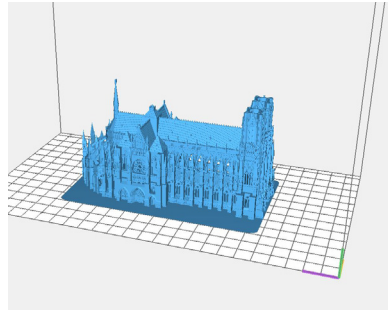
1) In order to decrease suction forces it is imperative that you hollow your models.

2) Printing solid models with resin can be very costly. Hollowing models can help you reduce the amount of resin used drastically. Often you can print models with just a few millilitres of resin!

You can hollow models with the Hollow function in Meshmixer. For an in-depth guide on hollowing, please visit: <https://all3dp.com/meshmixer-tutorial/>

## **Rafts**

Rafts help models and supports stick to the build platform during printing, while the model experiences suction forces each time it lifts after exposure.



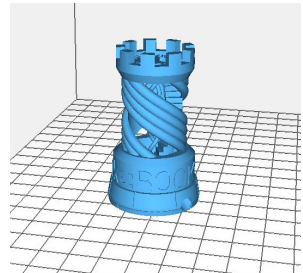
Reims Cathedral (Thing: 35798).  
On a raft.

## **Counter-suction & drain holes**

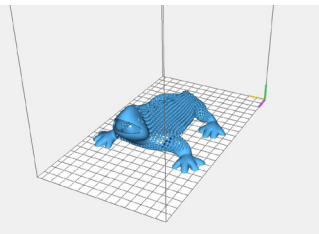
To prevent the 'suction-cup effect' it is always recommended to add counter-suction holes in any hollow model. These counter-suction holes should always be positioned as close to the build platform as possible. Preferably multiple holes. And the holes should be as big as possible.

Drain holes will allow resin to ooze out. Drain holes can be added anywhere in the model.

Counter-suction holes together with drain holes will also allow a proper flow of a post-cleaning agent to rinse excess resin out from the inside.



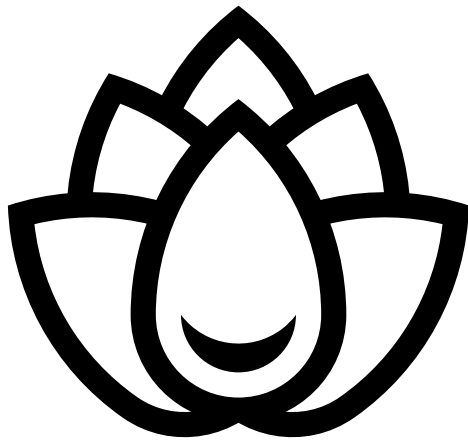
Make Rook (Thing: 533652).  
Suction hole at the bottom.



Hollow Draudi by BCN3D (Thing:  
948656).

## **No Preparation**

Of course, some models may not require any of these treatments and can be printed as they are. An example of this is the Hollow Draudi by BCN3D (Thing: 948656). This model is hollow and covered with little holes. It doesn't require supports, as all overhangs are angled sufficiently. And there is a strong enough base for the model to not need rafts.



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