

MakerBot. METHOD

MakerBot.

METHOD

REFERENCE GUIDE

CHAPTER 1

WELCOME

Welcome to the Reference Guide for the MakerBot® Method™ Performance 3D Printer.

LEGAL NOTICES

LIMITED WARRANTY

The MakerBot Limited Warranty (available at makerbot.com/legal) applies to the MakerBot Method 3D Printer.

OVERALL PROVISIONS

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SAFETY AND COMPLIANCE

MANUFACTURER:

MakerBot Industries, LLC
 One MetroTech Center, 21st Floor
 Brooklyn, NY 11201
 347.334.6800



PRODUCT: 3D Desktop Printer

MODEL: METHOD

METHOD, Cat Nos. PACT56

RATINGS: 100-240VAC ~ 50/60 Hz, 3.9 - 1.6 A

MakerBot declares that the radio equipment type 802.11 a/b/g/n dual band complies with Directive 2014/53/EU.

CMIIT ID: XXXXXXXXXX

Regulatorycompliance@makerbot.com

RADIO AND TELEVISION INTERFERENCE

This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his own expense.

Any changes or modifications made to this equipment voids your authority to operate this equipment under FCC Rules.

WIRELESS SPECIFICATIONS

FREQUENCY	WLAN RF FREQUENCY RANGE	PROTOCOL	ANTENNA TYPE	ANTENNA SPECIFICATIONS
2.4 GHz / 5GHz	2.412 - 2.484 GHz / 4.91 - 5.825 GHz	802.11 a/b/g/n	PulseLarsen Antennas, Part #W3006 2.5 dBi in the 2.4 FX831.07.0100C GHz Bands	2.2 dBi in the 2.4 GHz Band / 4.5 dBi in the 5 GHz Band

The module supports router channels 1-14.



Safety alert symbols precede each safety message in this manual. These symbols indicate potential safety hazards that could harm you or others or cause product or property damage.



Warning: The MakerBot Method includes moving parts that may cause injury. Never reach inside the MakerBot Method while it is in operation.



Warning: The MakerBot Method generates high temperatures. Always allow the MakerBot Method Performance Extruders to cool down before you reach inside.



Warning: There is a risk of shock. The electronics of the MakerBot Method are not user serviceable.



Caution: Do not print using materials that have not been approved by MakerBot for use with the MakerBot Method.



Caution: The socket outlet must be located near the printer and must be easily accessible.



Caution: In case of emergency, disconnect the MakerBot Method from the socket outlet.



Caution: The MakerBot Method melts plastic during printing. Plastic odors and particles may be emitted during this operation. Make sure to set up the MakerBot Method in a well-ventilated area.



Caution: Always allow the Performance Extruders to cool to 50°C before reaching inside the MakerBot Method or removing the Performance Extruders.



Caution: Children under 12 should be supervised by an adult.



Caution: Dust generation and accumulation should be minimized. Some dust and dry powders can build static electricity charges when subjected to friction and create an ignition hazard.

Note: For users in Japan, the power cord is only for use with this printer model, the MakerBot Method Performance 3D Printer.

ABOUT THE MAKERBOT METHOD

HOW THE MAKERBOT METHOD WORKS

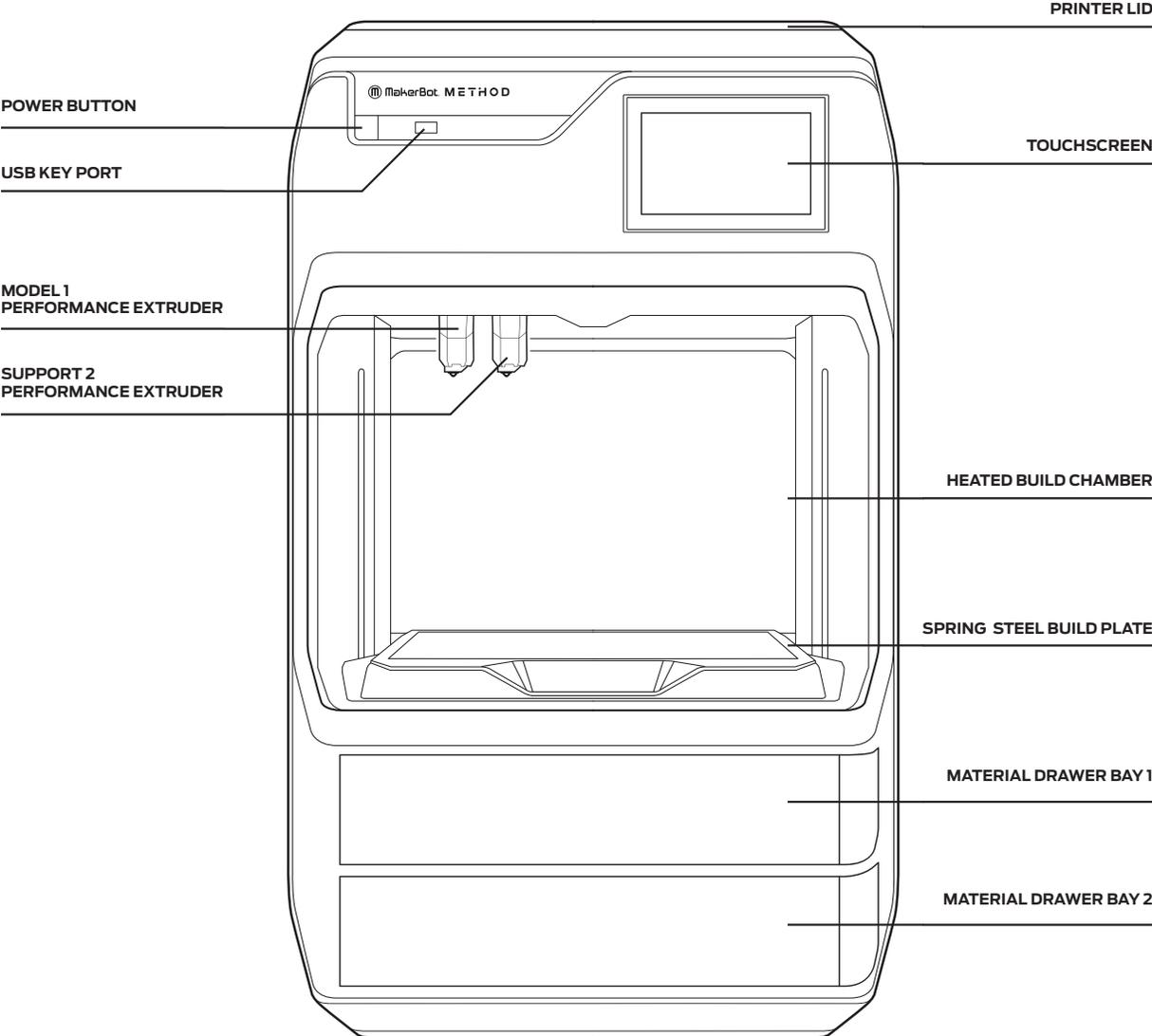
The MakerBot Method makes three-dimensional objects out of different types of melted materials. First, download a model from the internet or design a part, then use MakerBot Print to translate 3D design files into a .makerbot file, which creates instructions for the MakerBot printer. Then, transfer the .makerbot file to the MakerBot printer via your local network, USB drive, or USB cable.

The MakerBot Method will melt materials and extrude it out onto the build plate in thin lines to build your object layer by layer. The heated build chamber allows the extruded material to cool slowly, minimizing warping and curling. This 3D printing technology is called fused deposition modeling (FDM).

SPECIFICATIONS

PRINTING	
Print Technology	Fused deposition modeling (FDM)
Build Volume	19 L x 19 W x 19.6 H cm / 7.5 x 7.5 x 7.75 in single extrusion 15.2 L x 19 W x 19.6 H cm / 6.0 x 7.5 x 7.75 in dual extrusion
Maximum Layer Resolution	20 – 400 microns
Nozzle Diameter	0.4 mm
Print File Type	.makerbot
SOFTWARE	
Software Bundle	MakerBot Print, MakerBot Mobile
Supported File Types	MakerBot (.makerbot), STL (.stl), SolidWorks (.sldprt, .sldasm), InventorOBJ (.ipt, .iam), IGES (.iges, .igs), STEP AP203/214 (.step, .stp), CATIA (.CATPart, .CATProduct), Wavefront Object (.obj), Unigraphics/NX (.prt), Solid Edge (.par, .asm), ProE/Creo (.prt, .asm), VRML (.wrl), Parasolid (.x_t, .x_b)
PHYSICAL DIMENSIONS	
Printer	64.9 H x 41.3 W x 43.7 D centimeters [25.6 H x 16.3 W x 17.2 D inches]
Shipping Box	76.5 H x 50.0 W x 55.5 D centimeters [30.1 H x 19.7 W x 21.9 D inches]
Printer Weight PACT56	65 lbs
Shipping Weight PACT56	81.7 lbs
TEMPERATURE	
Ambient Operating Temperature PACT56	15 - 26° C / 59 - 78° F, 10 - 90% RH non-condensing
Storage Temperature	0 - 38° C / 32 - 100° F
ELECTRICAL	
Power Requirements : PACT56	100 - 240 VAC, 50/ 60 Hz, 400 W max 3.9A -1.6A
Connectivity	USB 2.0, Unshielded Ethernet: 10/100Base -T, WiFi 802.11 a/b/g/n 2.5Ghz, 5Ghz
CAMERA	
Camera Resolution	640 by 480 pixels

MAKERBOT METHOD DIAGRAM

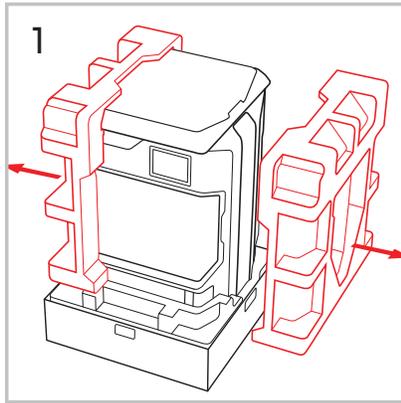


CHAPTER 2

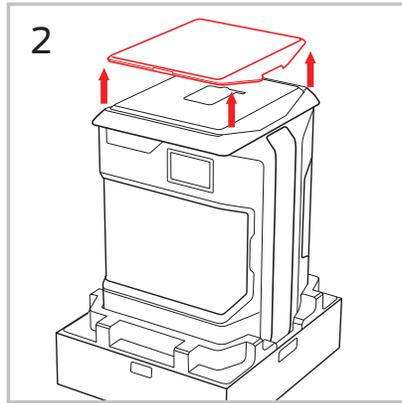
GETTING STARTED

When you set up your MakerBot® Method™ Performance 3D Printer, remember that it was built and packaged very carefully. We hope you will take your time and be just as careful unpacking it and getting it set up.

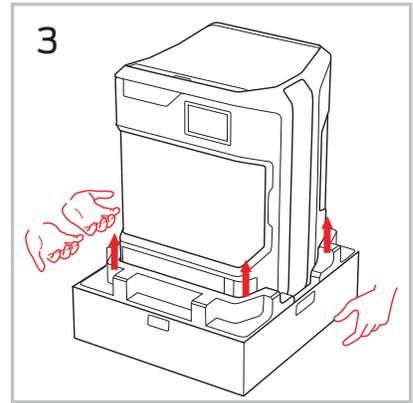
UNPACKING THE METHOD



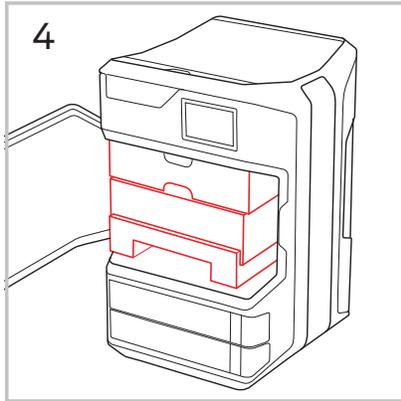
Carefully remove the foam from the sides of the printer.



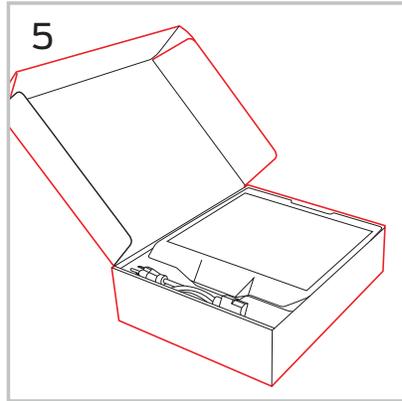
Lift the lid off and store nearby.



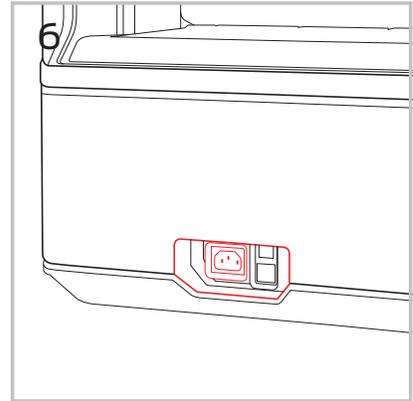
With two people lift from the side handles of the printer and put it on a stable flat surface.



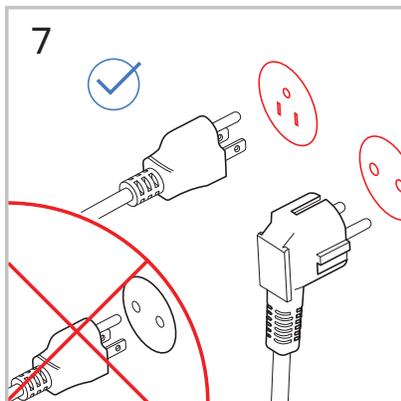
Remove the bag, remaining packaging tape, and open the door to remove the starter kit.



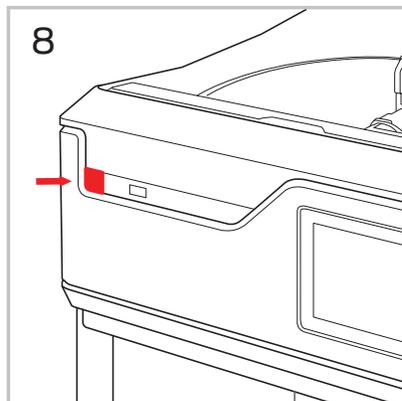
Open the starter kit on a flat surface.



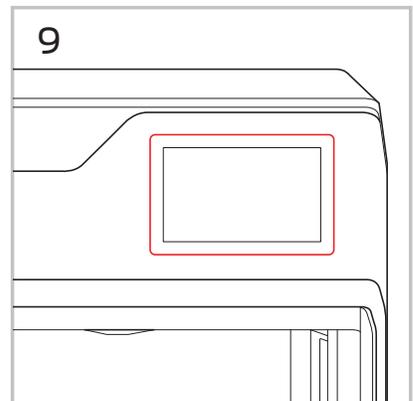
Locate the power input on the lower back of the printer.



Use the correct power cord to connect the printer to an accessible outlet.



Press the power button on the front of the printer.



After the printer powers on, follow the on screen instructions to finish setting up your printer.

STARTER KIT

Inside the box of your MakerBot Method, you will find all the necessary tools to get started, including both a Model Performance Extruder and Support Performance Extruder, a spring steel build plate, a leveling hex key, a nozzle cleaning brush, and two power cords (North America and EU). To order material, visit store.makerbot.com.

					
SPRING STEEL BUILD PLATE	MODEL PERFORMANCE EXTRUDER	SUPPORT PERFORMANCE EXTRUDER	CLEANING BRUSH	LEVELING HEX KEY	NORTH AMERICA AND EU POWER CORD

SETTING UP THE METHOD

In case of conflicting information between this Manual and the on-screen instructions, FOLLOW THE ON-SCREEN information, since it is updated more frequently.

INSTALL THE PERFORMANCE EXTRUDERS

1. Remove the lid from the top of the printer.
2. Open both latches on the carriage labeled “1” and “2”.
3. Insert the Performance Extruder labeled “Model-1” into the slot labeled “1”.
4. Insert the Performance Extruder labeled “Support-2” into the slot labeled “2”.
5. Close both latches on the Performance Extruders, locking them in place.
6. Insert the swivel clip labeled “1” into the “Model-1” Performance Extruder.
7. Insert the swivel clip labeled “2” into the “Support-2” Performance Extruder.
8. Replace the lid on top of the printer.



Caution: Never remove a Performance Extruder from your MakerBot Method 3D printer during or immediately after printing. Always allow a Performance Extruder to cool below 50°C.

INSTALL THE SPOOLS OF MAKERBOT MATERIAL

On the touchscreen tap [Material], then tap [LOAD ON MATERIAL BAY 1] and follow the on-screen instructions. Once complete, follow the same steps for [LOAD ON MATERIAL BAY 2].

CHAPTER 3

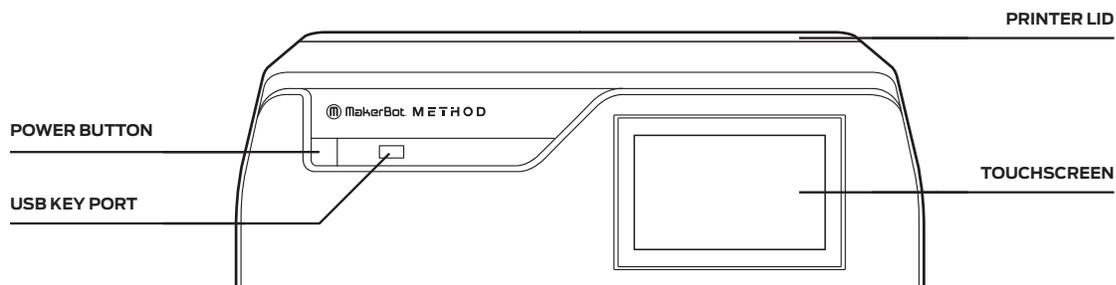
GUIDED SETUP

The first time you turn on your MakerBot® Method™ Performance 3D Printer, you will be guided through the setup process via the onboard touchscreen. From there, you will learn everything you need to know to start your first 3D print.

THE MAKERBOT METHOD TOUCHSCREEN

The touchscreen located at the upper right of the machine operates the MakerBot Method.

>>> See [Chapter 4 The User Interface](#) for more related information.



THE GUIDED SETUP

The first time you turn on your MakerBot Method, you will be guided through the initial setup process using the MakerBot Method user interface. This Guided Setup will walk you through connecting the printer to an internet connection, authorizing your printer, attaching Performance extruders, running calibration, loading material, and running your test print.

RE-RUN THE GUIDED SETUP

To re-run the Guided Setup, select **SETTINGS > RESET TO FACTORY**.

Restoring factory settings will allow you to rerun the Guided Setup.

CHAPTER 4

TOUCHSCREEN USER INTERFACE

The touchscreen interface gives you options for managing your printer and the printing process. You can use these options to print objects from a USB flash drive on your MakerBot® Method™ Performance 3D Printer or start prints initiated via MakerBot Print™ software. You can also change printer settings and monitor a print's progress.

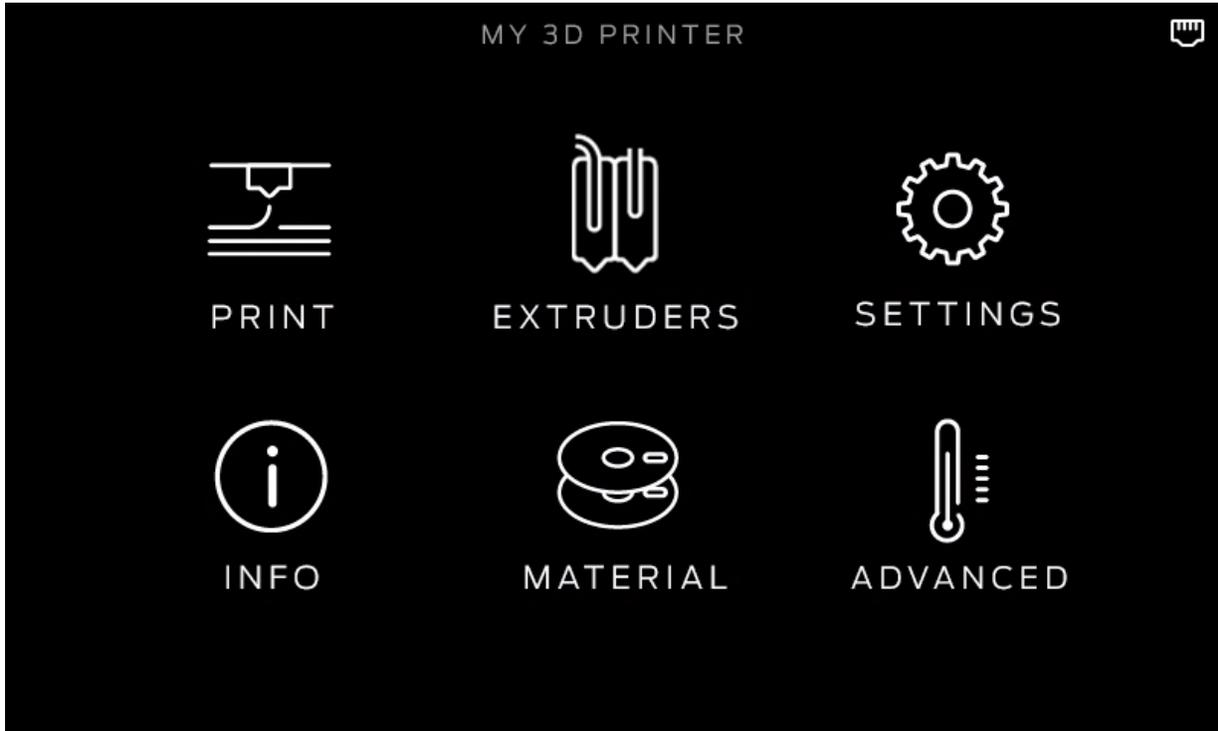
HOME SCREEN

The touchscreen gives you six options for managing your printer and the printing process:

› PRINT
› INFO

› EXTRUDERS
› MATERIAL

› SETTINGS
› ADVANCED



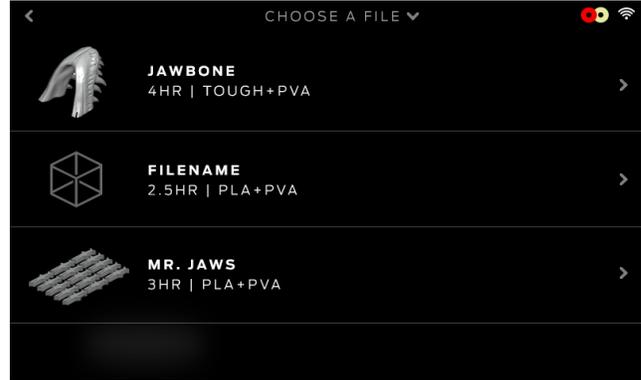
START A PRINT

1 SELECT A FILE



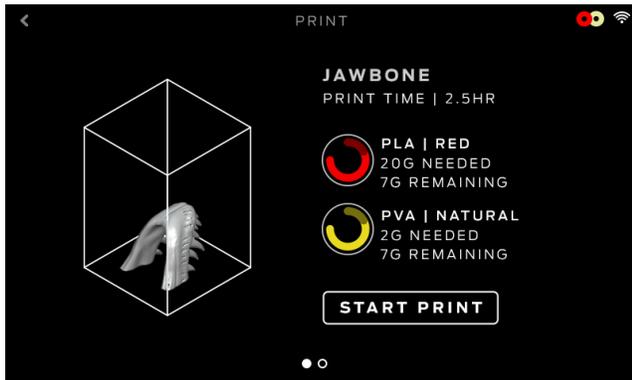
Select **[PRINT]** on the touchscreen to initiate a print stored on a USB flash drive.

Push the icon to select the location of the file you want to print. Select **[USB STORAGE]** to print a file stored on a USB drive inserted into the USB port.



Use the touchscreen to scroll through the list of available files and press it again to select the file you would like to print.

2 START PRINT



Choose a .MakerBot file that has been exported from MakerBot Print to begin printing. Note that the file needs to be formatted from within MakerBot Print for MakerBot Method before being exported.

Select **[START PRINT]** to begin printing the file.

3 PRINTING



During the printing process you will be able to view print progress information and other printer details.

1. Percentage of the print completed.
2. Time elapsed and estimated time remaining in the print. While the Heated Chamber and Performance Extruders are heating, the screen will display the current and target temperatures.
3. While actively printing, swipe the touch screen between the following screens:
 - Print progress
 - Rendering of your model or layout
 - File information
 - Print options information
 - Extruder temperatures
4. The Print menu contains the following options:
 - **PAUSE** - Press the pause button on the screen to temporarily pause your print.
 - **CHANGE MATERIAL** - Select this option to load or unload material.
 - **CANCEL** - Select this option to cancel your print.

4 PRINT COMPLETE

After the print is complete, the screen will indicate its completion. Push the screen to continue to the next menu. You will then be asked if you would like to print the object again, or return to the storage menu screen. Select your choice by touching the screen accordingly.

If you wish to print the object again, make sure to clear the build plate.

MATERIAL

Select the **[Material]** icon to load or unload material.

TO LOAD MATERIAL

1. Cut the end of your material to create a clean edge
2. Use the touch screen to select **[LOAD FOR MATERIAL BAY 1]** or **[LOAD FOR MATERIAL BAY 2]**
3. Follow the instructions on the screen

TO UNLOAD MATERIAL

1. Use the touch screen to select **[UNLOAD MATERIAL]** for either Material Bay 1 or 2
2. Follow the instructions on the screen
3. When the Performance Extruder has stopped pushing the material out and the screen states that the material is ready to be removed, gently pull the material and rewind it onto the spool

If you are changing material spools, make sure to keep the spool tightly wound as you pull the material free of the guide tube. If you do not, the material could unravel or tangle on the spool.

NOTE: When you are not using a material spool, make sure the free end of the material is inserted into one of the storage slots of the spool. This allows you to find the insertion end of the material much faster and will prevent the spool from tangling. Spools not in use should be stored in the original bag they came in. This prevents moisture uptake, which is important for maintaining print quality.

SETTINGS

Select the **[SETTINGS]** icon to personalize your MakerBot Method, edit network or sharing settings, update firmware, access automated XYZ calibration, and other tools.

FIRMWARE UPDATE

Select **[FIRMWARE UPDATE]** to see if you have the most up-to-date firmware. If the MakerBot Method is already connected to a network, then it will automatically check for an update. If there is an update, push the screen to begin the download. If the MakerBot Method already has the most current firmware, a message will display on the touchscreen stating that your firmware is already up-to-date. If the printer can not be connected to the internet, firmware can be updated via MakerBot Print.

CONFIGURE WIFI

Select **[CONNECT TO WIFI]** to begin the setup process of connecting your MakerBot Method to a WiFi connection. When you select **[CONNECT TO WIFI]**, the MakerBot Method will show the available WiFi networks. Select the WiFi network that you would like to connect to and enter a password if required.

CALIBRATION

Select **[CALIBRATE TOOLHEADS]** to run an automated XYZ calibration after inserting the performance extruders to the extruder assembly. For more information on calibrating toolheads, [see Chapter 6 Maintenance](#).

DIAGNOSTICS AND LOGS

Select **[DIAGNOSTICS AND LOGS]** to run a system diagnostic scan of the MakerBot Method and save the resulting logs. These logs can be sent to MakerBot should you ever need support.

Copy System Logs to USB

Allows you to copy system logs of the MakerBot Method to a USB drive.

RESET TO FACTORY SETTINGS

Select **[RESET TO FACTORY SETTINGS]** to restore the MakerBot Method to its original factory settings and wipe any information stored on the internal storage drive.

POWER OFF

Select **[POWER OFF]** on the touchscreen to turn off the MakerBot Method.

EXTRUDER

Select the **[EXTRUDER]** icon for assistance in attaching a Performance Extruder. If the Performance Extruder is attached, the screen will show the Performance Extruder information such as temperature and print statistics.

If the Performance Extruder is not attached, the Extruder icon will not be highlighted or display the MakerBot logo.

When attaching the Performance Extruder, position the extruder so that the connectors lock into place with the Extruder Assembly and close the latch onto the extruder. If the Performance Extruder is successfully attached, you will see the extruder icon highlighted.

NOTE: Only the Performance Extruder is supported for the MakerBot Method. Both extruders are required to start a print.

INFO

Select the **[INFO]** icon to view firmware information, network information, and print statistics from your MakerBot Method.

CHAPTER 5

MAKERBOT PRINT™

The MakerBot® Method™ Performance 3D Printer streamlines 3D print preparation and file management using MakerBot Print™ software. MakerBot Print is a free desktop application that allows you to discover, prepare, manage, and share 3D prints.

DOWNLOADING AND INSTALLING MAKERBOT PRINT™ (WEBSITE)

1. Go to **MAKERBOT.COM/PRINT**. Click the Download button.
2. Select your operating system from the drop-down menu on the download pack and click Download.
3. Double-click the MakerBot Print installer to run the installation wizard. Follow the installation instructions.

HOW IT WORKS

MakerBot Print streamlines 3D print preparation and file management. PC users can also import and manipulate Native CAD files. MakerBot Print allows you to Arrange, Orient, Scale, and View your 3D models and prepare them for print. You can also access print settings to modify your print.

USING MAKERBOT PRINT

Please visit our [MakerBot Print Learning Page](#) to get our most up-to-date instructions and guides on how to use the MakerBot Print application.

STARTING A PRINT WITH THE MAKERBOT METHOD

There are two ways to begin printing an object. You can use the touchscreen on the MakerBot Method or MakerBot Print.

When you are ready to print your model, click **PRINT** in MakerBot Print to slice the model using the current settings and send a .makerbot print file to your MakerBot Method. You will be reminded to clear the build plate and asked to initiate the print on the touchscreen. You can also select **[BEGIN PRINTING]** on the touch screen after starting the file transfer.

If MakerBot Print is connected to your MakerBot Method, the print file will be sent directly to your 3D printer. If MakerBot Print is not connected to your MakerBot Method, this button will open a dialog allowing you to export and save a .makerbot print file. You can transfer the print file to your MakerBot Method using a USB drive.

HOW TO PAUSE OR CANCEL A PRINT

To pause a print, push the pause icon on the print progress screen. You can also select the printer in MakerBot Print and select **PAUSE**.

To cancel a print, tap the top of the screen that says printing or paused. A drop down will appear with the option to cancel the print.

TO ADD AN OFFLINE PRINTER

1. Open the printer panel and click **[ADD A PRINTER]**
2. Select **[ADD AN UNCONNECTED PRINTER]**
3. Select a printer, and the build plate will update to the appropriate size

AFTER YOU PRINT

REMOVING THE PRINT FROM THE BUILD PLATE

When your print finishes, remove the flexible build plate from the MakerBot Method. Remove the print from the build plate by simply bending the flexible build plate. The print will peel off the smooth grip surface. After the model has been removed, soaking it in warm water will cause the PVA to dissolve. Warm water with agitation will increase the speed at which the support material dissolves. Do not heat the water higher than 40° Celsius as this may cause the part(s) to deform.

NOTE: When you bend the flexible build plate, some pieces of the raft may remain on the plate. Simply bend the flex build plate again or use a flat, non-sharp tool such as a putty knife to remove the raft pieces. Never use a knife to remove pieces of the raft—doing so can damage the build plate.

CHAPTER 6

PRINTER MAINTENANCE

As soon as you take your MakerBot® Method™ Performance 3D Printer out of the box, it is ready to print high-quality models. However, like any precision machine, routine maintenance is needed. Here are some ways you can keep your MakerBot Method printing smoothly.

AUTOMATED XYZ CALIBRATION

Each time you attach a Performance Extruder or a new build plate, you will need to run the Automated XYZ Calibration routine. This process will make sure that the Performance Extruders are positioned properly with respect to the build plate when you begin a print.

Before inserting a Performance Extruder into the printer, use the nozzle cleaning brush to clean the extruder nozzle tip of any debris or material. This is critical for attempting to run Automated XYZ Calibration. **IMPORTANT NOTE:** Please make sure the extruder nozzles are 100% clean and there is absolutely no filament residue left. Your calibration will otherwise be inaccurate and your print performance will suffer from it.

Follow the instructions on the screen and remove the build plate. The MakerBot Method will then check and record the X and Y locations of the extruders. When the screen prompts you, insert the build plate to continue. The MakerBot Method will now check and record the Z locations of the extruders.

Once this process has completed, you will be ready to start a print.

MAINTAINING THE BUILD PLATE

The surface of the MakerBot Method build plate, known as the Grip Surface, allows for better print adhesion and print quality compared to other types of build surfaces. However, over time the grip surface can become cracked and damaged. If these cracks or tears begin to affect print quality, it is time to replace the grip surface. Visit [HTTPS://SUPPORT.MAKERBOT.COM](https://support.makerbot.com) to learn how to replace the grip surface.

Go to [HTTPS://STORE.MAKERBOT.COM/](https://store.makerbot.com/) to order more Grip Surfaces and build plates.

OTHER ISSUES

For help with issues not covered in this chapter, please go to [HTTPS://SUPPORT.MAKERBOT.COM](https://support.makerbot.com).

CHAPTER 7

REFERENCE

GLOSSARY

BUILD PLATFORM: The support for the build plate. The build platform's underside contains adjustable hex bolts for use during assisted-leveling.

ETHERNET CABLE: The cable used to connect your MakerBot Method to a local area network.

EXTRUDER ASSEMBLY: The swappable Performance Extruders which contain the sensors, drive gears, hot end, and nozzle.

EXTRUDER CARRIAGE: Holds the extruders firmly in place on the rail of the x-y gantry while allowing for quick and easy extruder swapping.

EXTRUDER NOZZLE: The opening on the end of the Performance Extruder from which heated MakerBot material emerges to be spread onto the build plate.

FIRMWARE: The software that runs on your MakerBot Method.

GANTRY: The apparatus that allows the carriage and extruder assemblies to move along the x and y axis.

GRIP SURFACE: The surface on which the extruder prints on. Prints adhere better to the Grip Surface resulting in reduced warping and curling.

GUIDED SETUP: The set of tasks that runs when you turn on the MakerBot Method for the first time. The setup assistant helps you level the build plate, load material and start a test print.

INTERNAL STORAGE: The part of the MakerBot Method onboard storage that you can use to store print files.

LAYOUT: An arrangement of 3D models on the build plate. Multiple layouts can be saved as part of any .Thing in your Library.

LEVELING SCREWS: The two screws underneath the build platform that allow you to pivot the build plate around its center point during the leveling process.

.MAKERBOT: The format of print files for your MakerBot Method. Print files contain instructions for your MakerBot Method.

MAKERBOT ACCOUNT: The username and password you will use to sign in to MakerBot Print, and log on to Thingiverse and other MakerBot sites.

MAKERBOT PRINT SOFTWARE: Free software for use with your MakerBot Method. MakerBot Print will help you discover, manage, share and print 3D models.

MATERIAL DRAWER BAYS: The two drawers located at the base of the MakerBot Method, where both the model and support material spools are stored during the printing process.

MATERIAL GUIDE TUBE: The plastic tube that guides the MakerBot material from the material spool to the Performance Extruders.

.OBJ: A file format used for 3D models.

PERFORMANCE EXTRUDER: The Performance Extruder draws the material from the spool, melts it, and pushes it through a nozzle onto the Spring Steel Build Plate.

PROFILE: The settings used to slice your 3D model and create a print file. MakerBot Print Software comes with preset profiles for Balanced and High-resolution prints.

RAFT: A plastic base printed on the build plate and used as a printing surface for your printed object.

SLICING: The process of turning a 3D model into a print file containing instructions for your MakerBot Method. The MakerBot Method uses print files with the extension .makerbot.

SPRING STEEL BUILD PLATE: The flat plate on which the MakerBot Method 3D Printer builds an object. This plate is removable and bending the plate allows you to remove objects.

.STL: A widely used file format for 3D models.

SUPPORTS: Automatically generated support structures used to prop up any sections of a print that will not stand alone.

.THING: A file format used by MakerBot Print that stores additional information about your 3D model files.

THING: A file or group of files saved to Thingiverse or to your MakerBot Cloud Library.

THINGIVERSE: An online community for sharing 3D design files.

TOUCHSCREEN: The touchscreen at the upper right corner of the MakerBot Method. The touchscreen allows you to start prints, change settings and view status information.

USB CABLE: A cable that allows your computer to communicate with the MakerBot Method.

USB DRIVE: A USB flash drive. You can use a USB drive to transfer print files to and from the MakerBot Method. Make sure that the USB drive is formatted to FAT32. USB drives that are formatted to NTFS will not be visible.

CONTACT

SUPPORT

support.makerbot.com

Our website has extensive documentation and troubleshooting information about your MakerBot Method. It's a great resource when you want to try to solve issues quickly on your own.

my.makerbot.com/support

At MakerBot, we take pride in offering expert, responsive, friendly customer support to our customers around the world. If you need help resolving an issue with your MakerBot Method, open a case with the MakerBot Support Team at the web address above.

SALES

sales@makerbot.com

To learn about other MakerBot products, including MakerBot material, please email the address above, or call our Sales Team at **+1 347.334.6800**