



Instruction Manual

Table of Contents

System Requirements and Setup	2
Updating Resins	3
Importing Models and Scenes	4
Transforming Models	5
Supports	7
Auto-Generated Supports	7
Cone Supports	8
Advanced Settings	9
Array Duplication	9
Scene and Model Failure Detection	10
Saving	11
Printer Management	12
Adding Printers	12
Viewing Print History	13
User Settings and Reporting Bugs	14
Problems and Fixes	15
Saving	15
Models	15

System Requirements and Setup

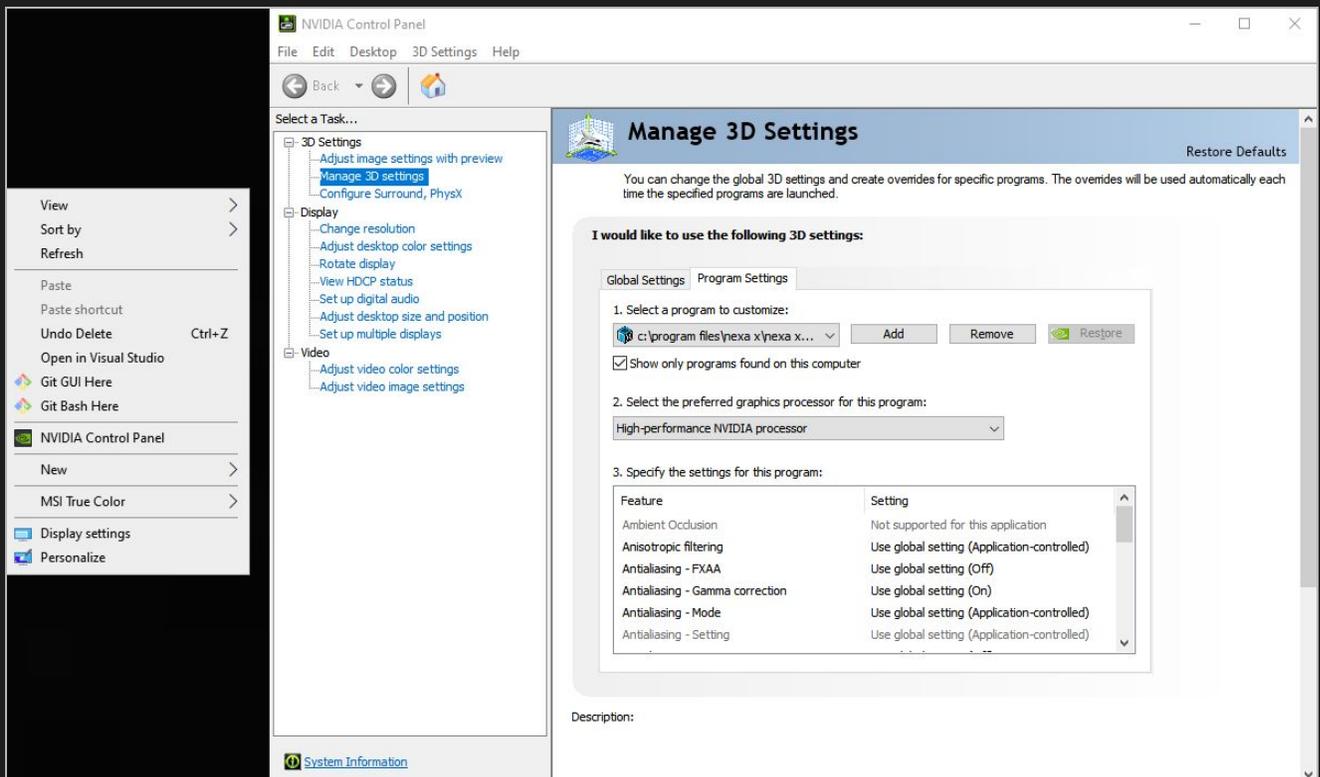
Minimum Recommended Requirements:

- RAM: 8 GB
- OS: Windows 10
- Graphics Card: NVIDIA GeForce GTX 1060 or AMD Radeon R9 Fury
- Free Disk Space: 30 GB

To get the **maximum performance and speed** of NexaX 2.0, you must add it to the list of software that uses your high-performance processor.

To do this with the NVIDIA Graphics Card, do the following in the # order they appear.

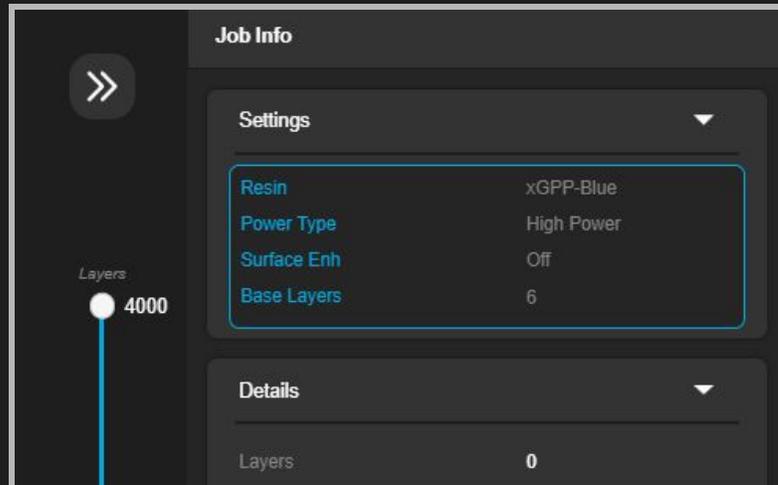
- 1) Right-click on the desktop and select NVIDIA Control Panel
- 2) Click Manage 3D settings
- 3) Program Settings
- 4) Select NexaX 2.0 from the list
- 5) Select your high-performance processor
- 6) Select your high-performance processor



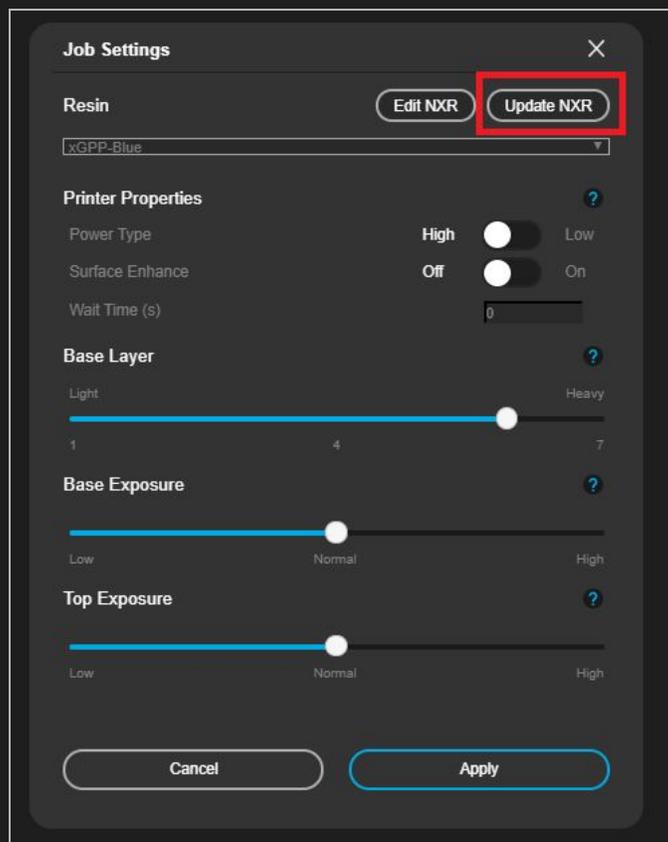
Updating Resins

When new resins are out, their parameters will be in a .nxr file. To update these settings:

- 1) Click resin settings from the right panel

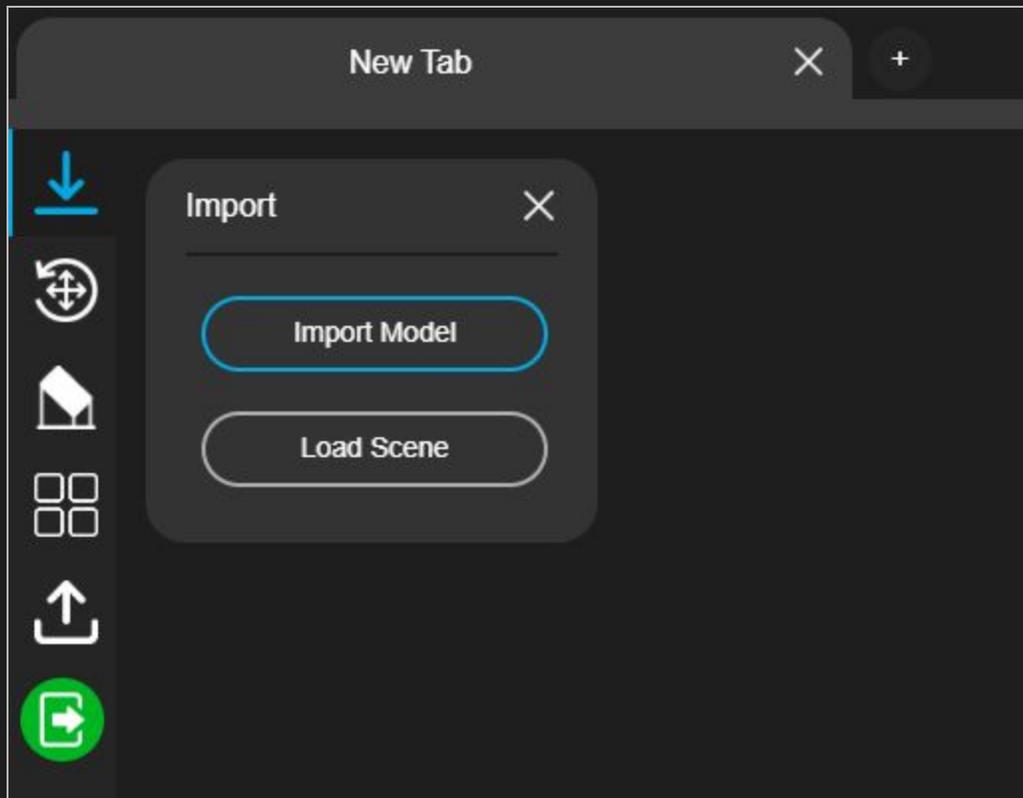


- 2) Click **W** and select your file



Importing Models and Scenes

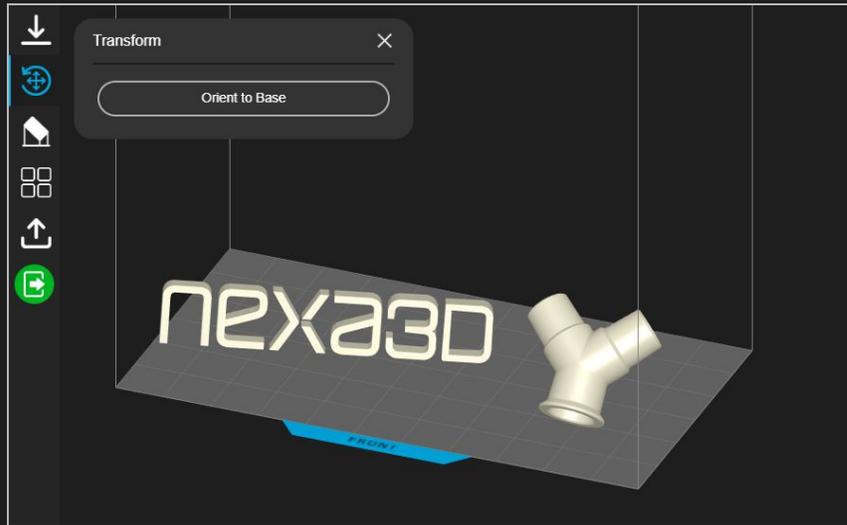
To import 3D models (.stl format) or scenes (.nxs), click “import” and select the option you want. Drag and dropping into the scene directly also works.



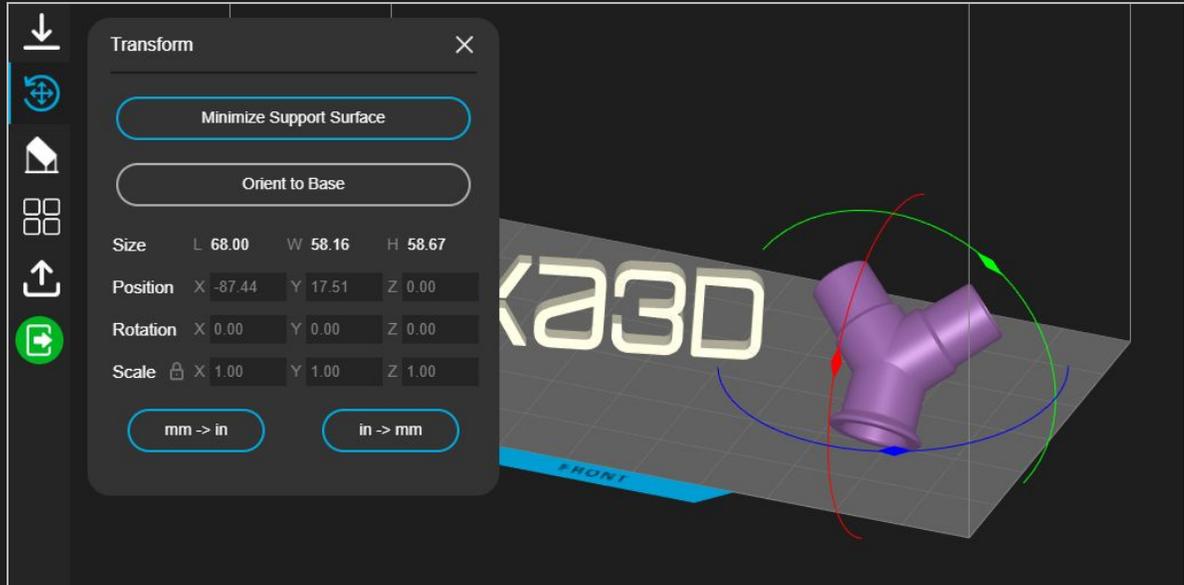
Transforming Models

The **Transform** panel enables you to orient, translate, and scale models. It is also where you will find orientation tools and unit conversion tools.

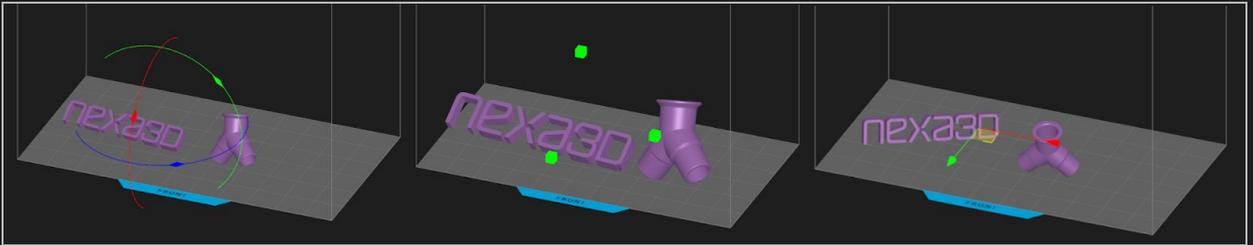
- 1) When no model is selected, only auto-orientation features and the **Unit Conversion Tool** will be visible



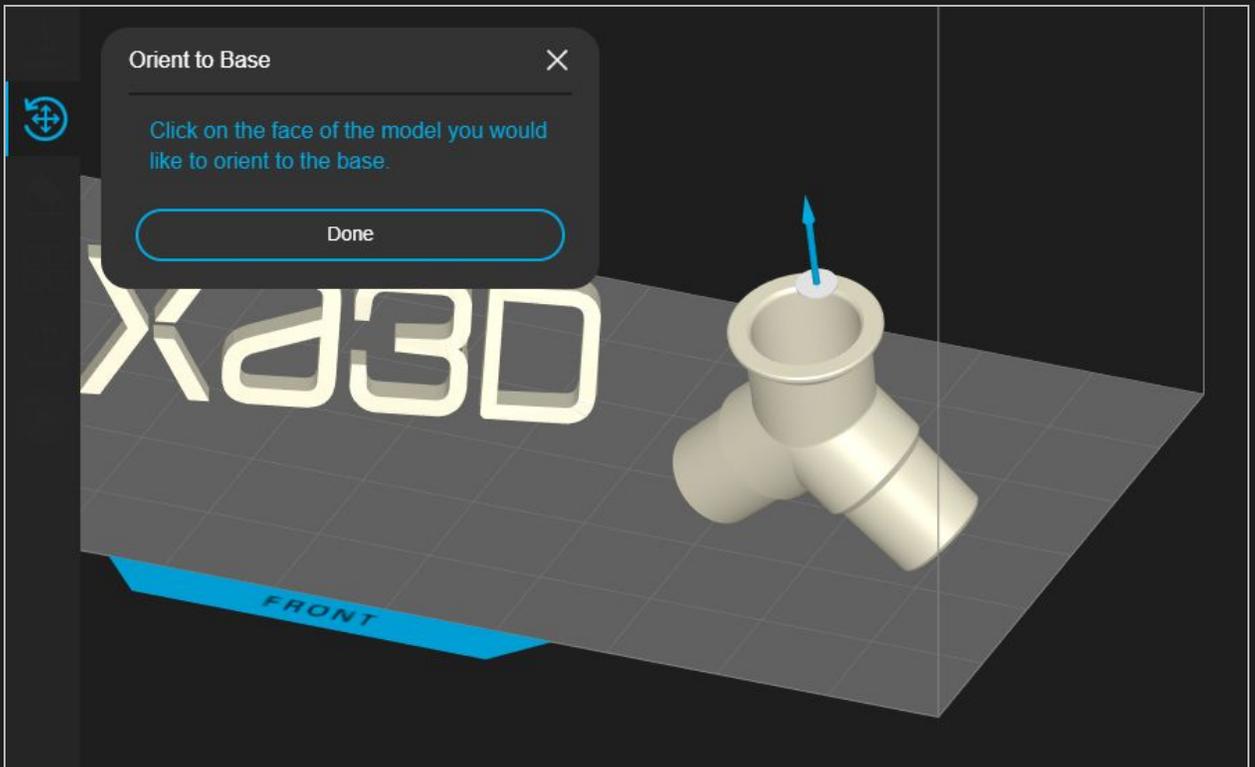
- 2) When a model is selected, the options will expand to allow you to transform it.



- 3) Multiple models can be transformed at the same time



- 4) To orient a model to the base, click that button and then clicking the plane of the model that you want oriented parallel and touching the base

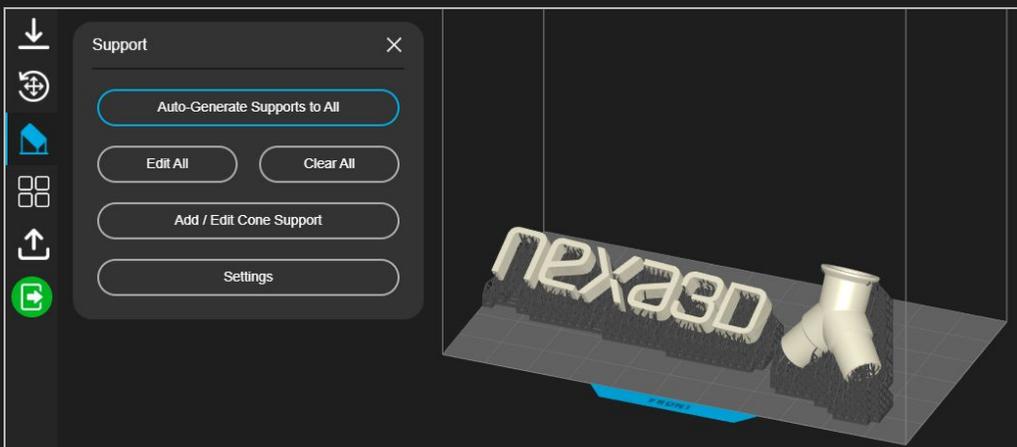


Supports

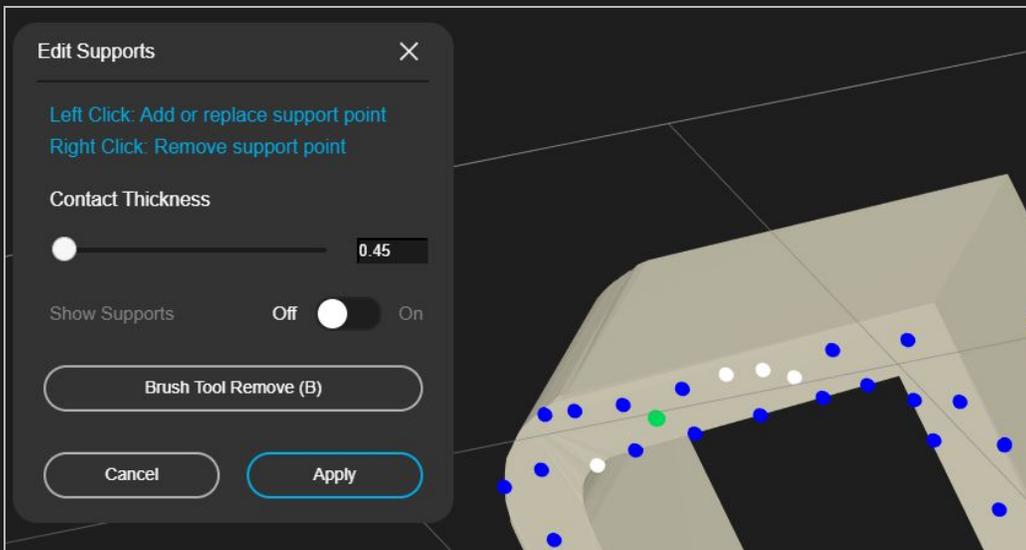
Supports are usually needed for a successful print. In NEXAx 2.0, you can automatically generate scaffolding supports, edit it, and add cones as well. Parts automatically move up in order to account for them- no manual translation is needed. You can have parts with supports and parts without supports on the same platform

Auto-Generated Supports

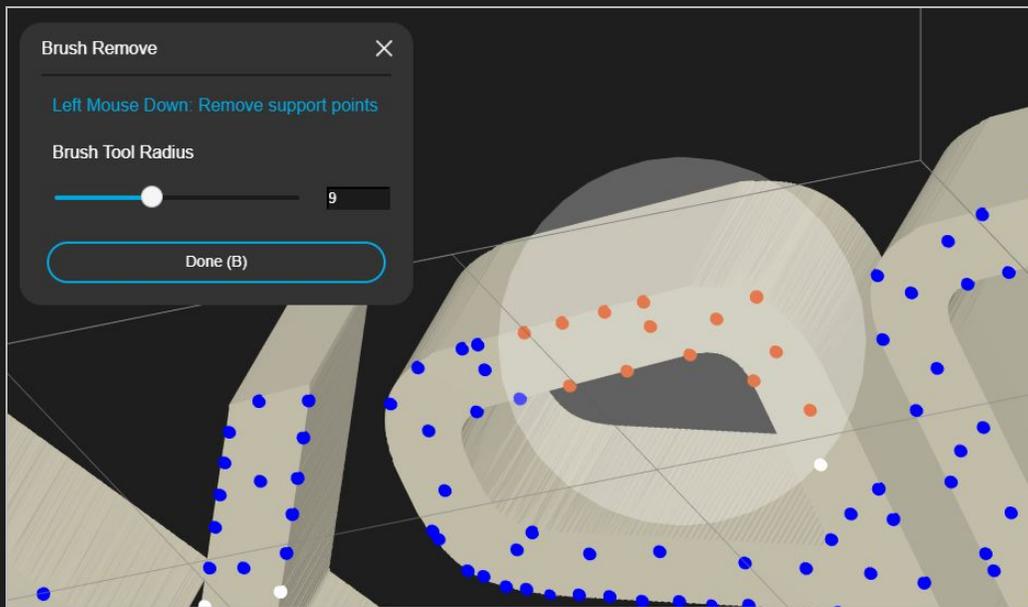
- 1) To auto-generate supports, you can click the auto-generate button. This can be performed for all the parts on the build or individual parts.



- 2) To edit supports, you can go to the edit tool, and either remove or add support points individually. Contact thickness can be changed as well. This can either be performed per model, or for all of them.

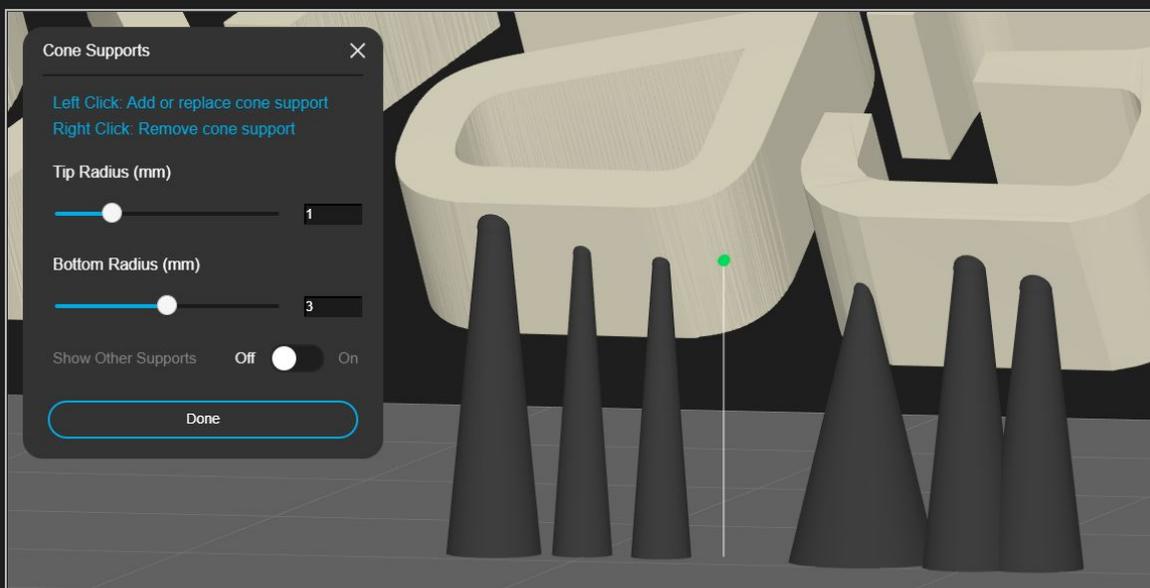


- 3) The brush tool can be used to mass-delete supports. The radius of the brush can be changed, and this can either be performed per model, or for all of the models on the scene.



Cone Supports

The Cone supports are used occasionally to strengthen your model as it prints. They reduce warpage if used properly, and add extra strength. They can be used with or without supports. They can also be used for models that have some areas that need supports, but otherwise can be printed straight on the build platform. Cones can also attach to the part itself.



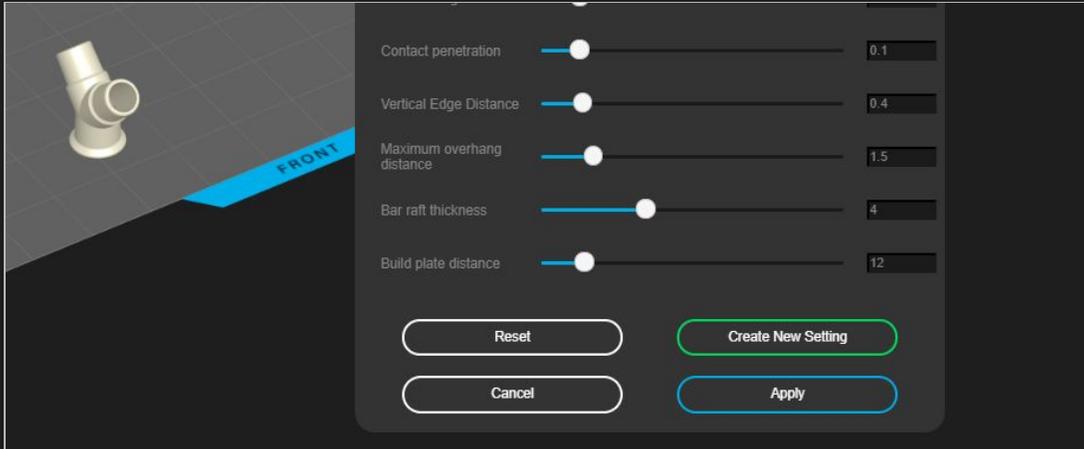
Á

Á

íÁ

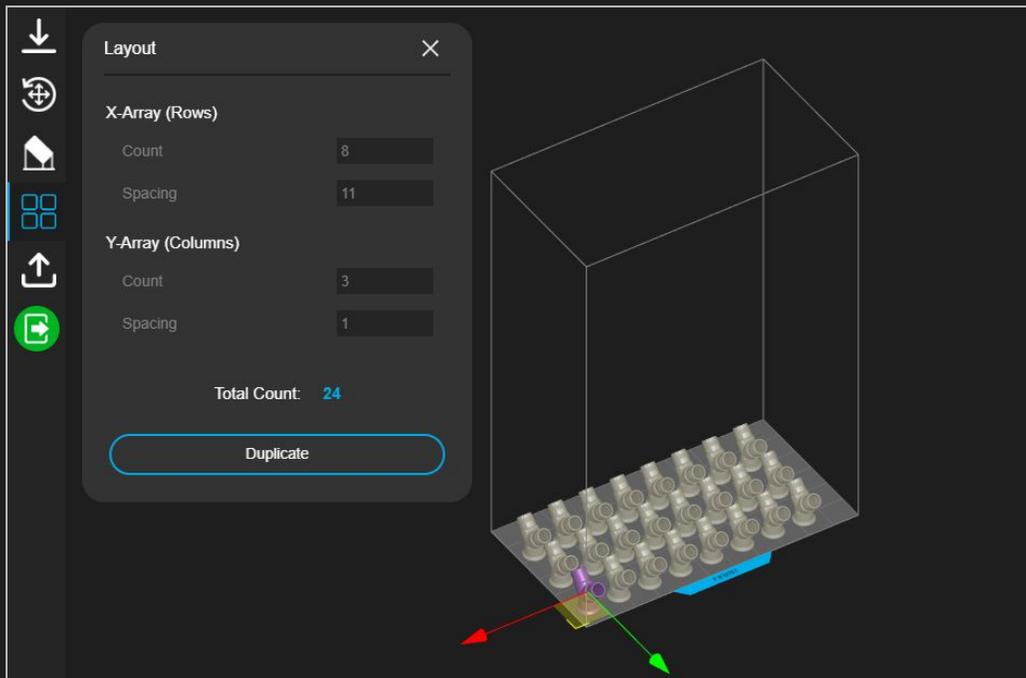
Advanced Settings

Support settings are found for each resin at Nexa3D HQ. However, you can easily adjust scaffolding support settings if you are an advanced user. You can save these custom support settings as well.



Array Duplication

You can easily array duplicate by defining your x and y count, and the spacing (mm) between each part's bounding box. The duplicator will not allow for more parts than can fit on the platform.



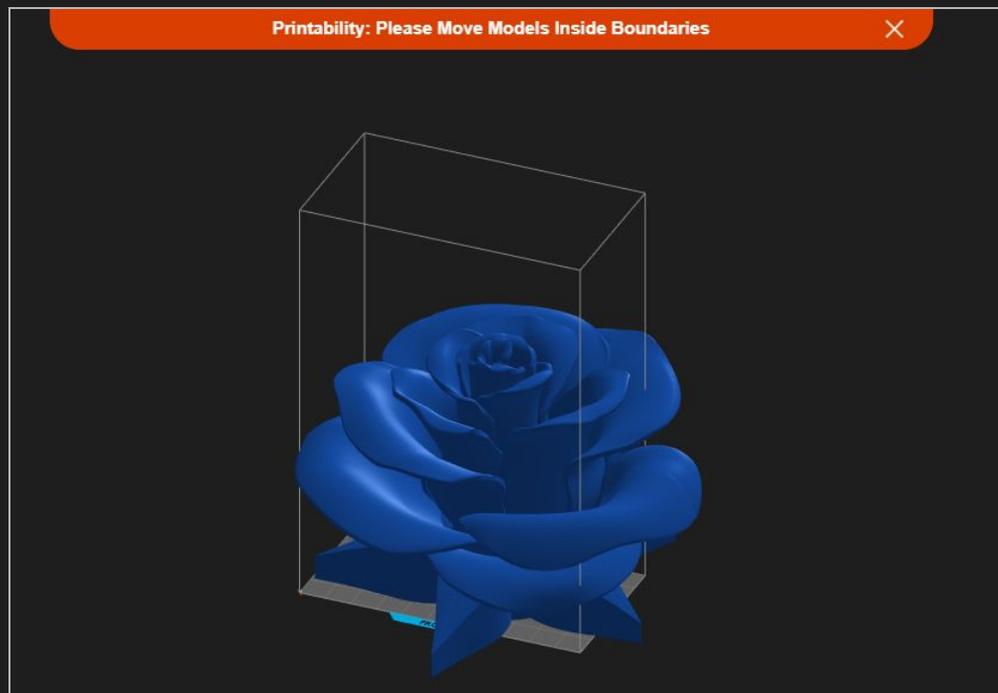
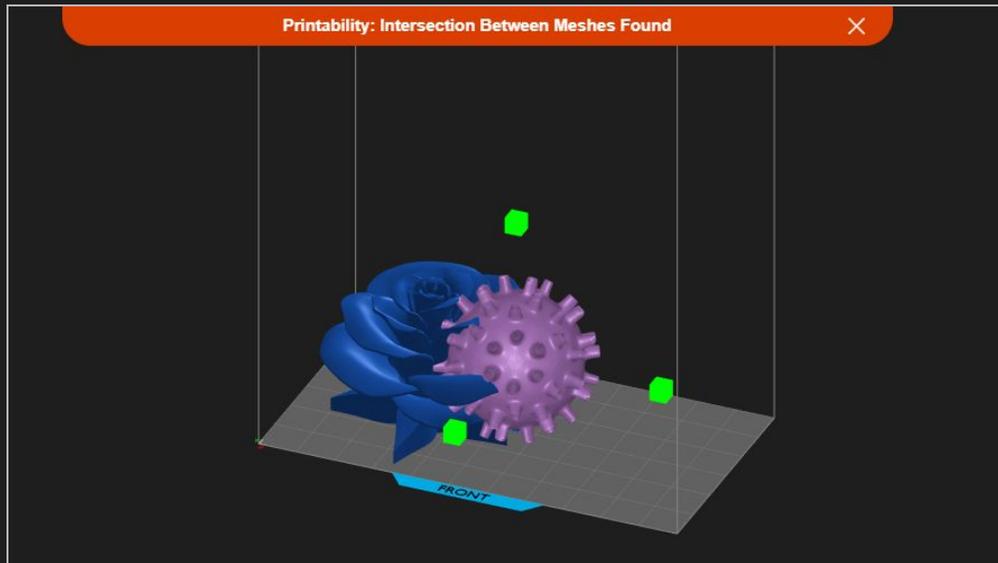
Á

Á

JÁ

Scene and Model Failure Detection

NexaX has features that enable pre-print part success. This includes model intersection detection, parts larger than the build platform, and broken meshes. Clicking the banners expands them all.



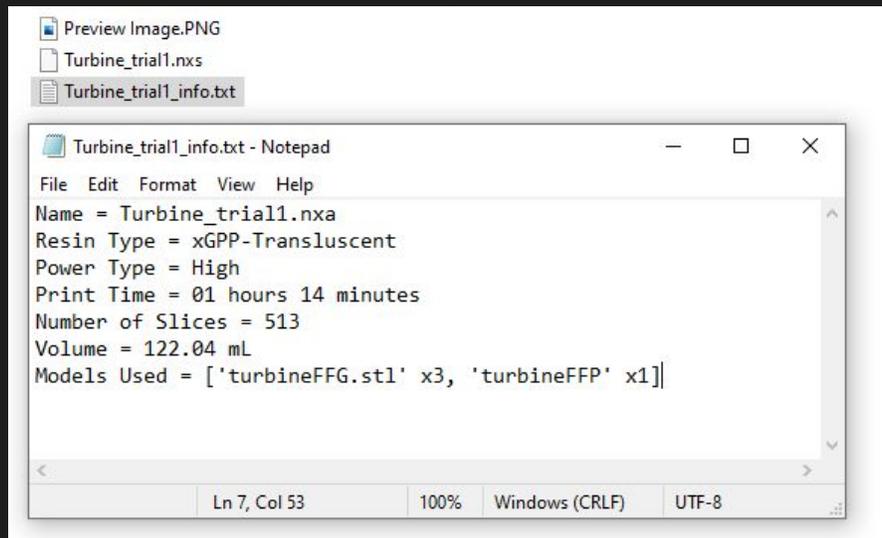
Saving

NexaX can output both a .nxs file (a •&^} ^) or a .nxa file (printer-ready format). You can save a scene by itself at any time. Saving an .nxa will save the scene automatically, as well as the .nxa, and a text file of information (time, volume, # of models) that can quickly be accessed.

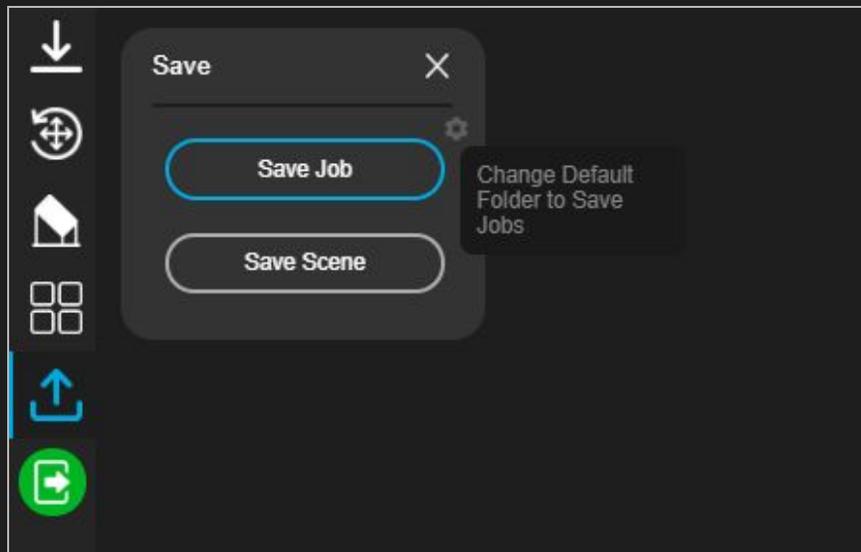
The output files will be like so:

Scene	11/20/2020 3:13 PM	File folder	
Turbines_trial1.nxa	11/19/2020 1:02 PM	NXA File	14,180 KB

With the Ú&^} ^ folder containing a preview image, your scene, and the info text file:



To change your default directory, you can click the gear icon:

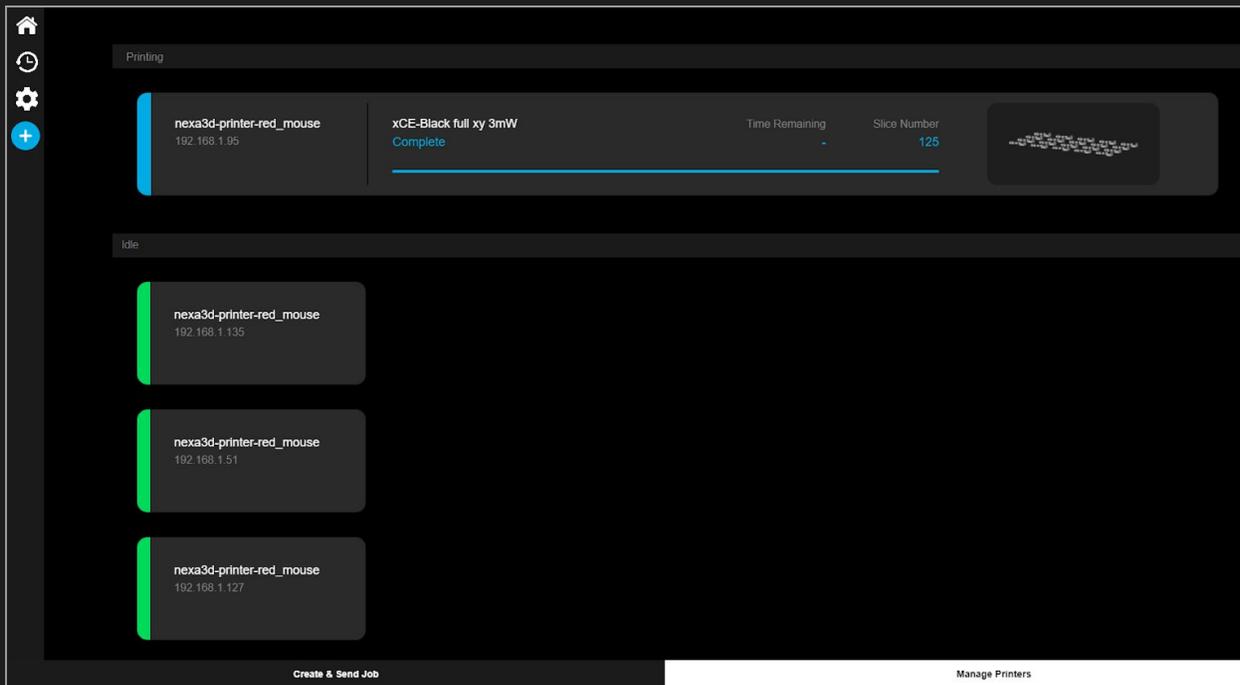


Only a .nxa file can be sent to a printer (remotely or on a USB).

Á

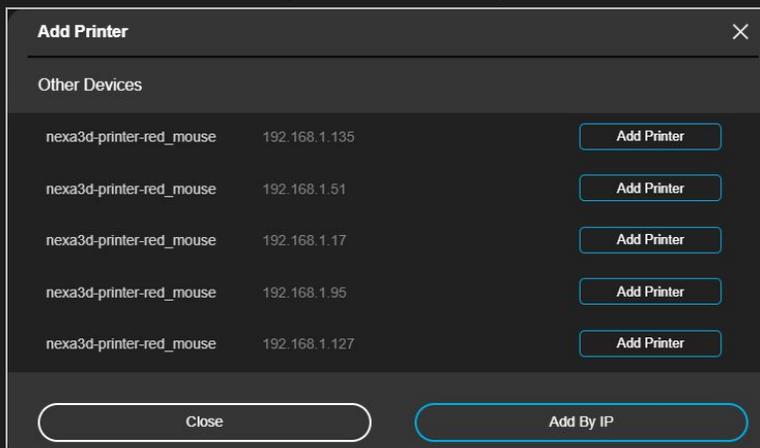
Printer Management

NexaX 2.0 includes printer and fleet management and monitoring. You can remotely send jobs, monitor a live view of your prints, organize your print queue, and examine your print history. To access it, click “Manage Printers” from the bottom right of your screen.



Adding Printers

- 1) Click on the blue addition symbol on the left panel
- 2) Click on the available printers or add by IP address



- 3) Once you add a printer, it will always auto-connect to it unless you remove it

Á

Á

Viewing Print History

- 1) Click on the white clock symbol on the left panel
- 2) You can organize your print history based on the resin type, the date, or the printer

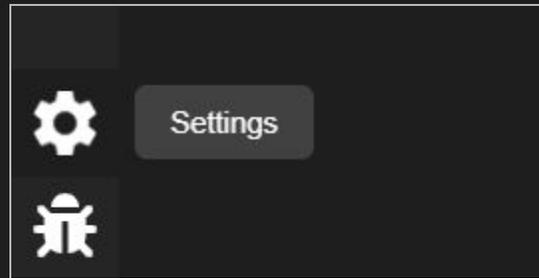
Job History

Printer: All Printers | Resin: All Resins | Order: Newest to Oldest

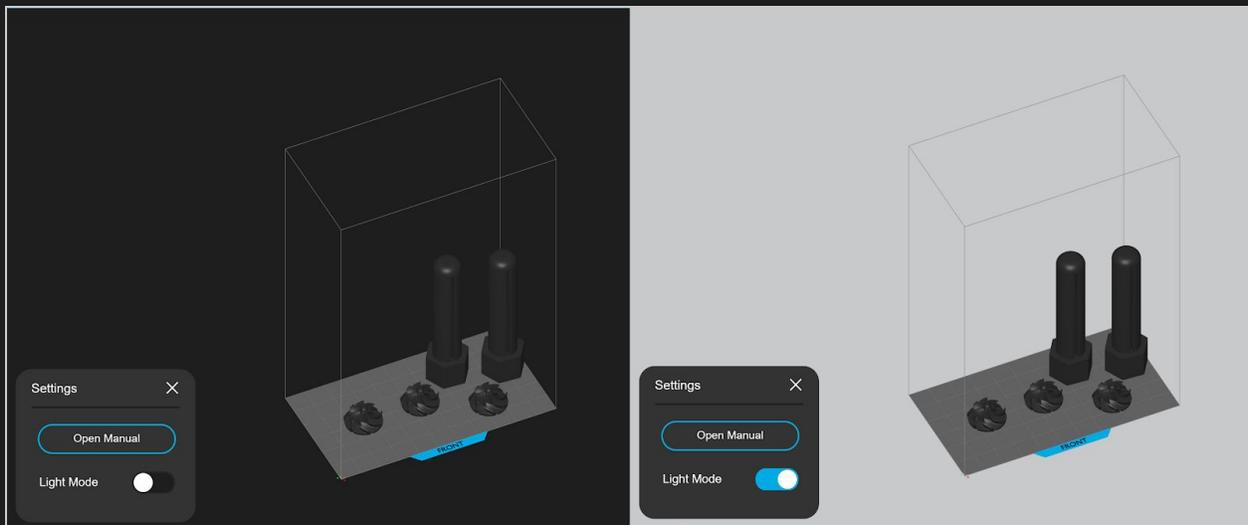
Printer	Resin	Order	
Nov 23, 2020 - 1:42 pm Red Potato - 192.168.1.125	Multi_Test.nxa xGPP-Blue	1hr 24m 0.75mL	
Nov 22, 2020 - 11:42 am Black Bull - 192.168.1.108	SomeBarThing.nxa xGPP-Orange	37m 0.13mL	
Nov 19, 2020 - 3:24 pm Blue Basket - 192.168.1.84	Panterrrr.nxa xGPP-Grey	24m 0.25mL	
Nov 12, 2020 - 10:42 am Brown Bag - 192.168.1.125	Blue_Ting.nxa xGPP-Blue	1hr 24m 0.75mL	

User Settings and Reporting Bugs

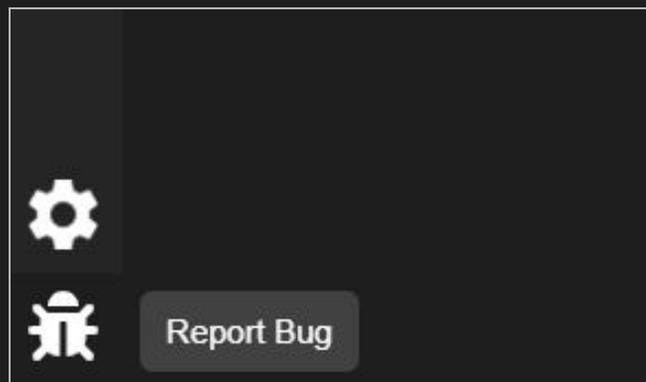
You can change some settings and open the manual by clicking the white gear on the bottom right of the screen.



Light/Dark mode is an available user preference:



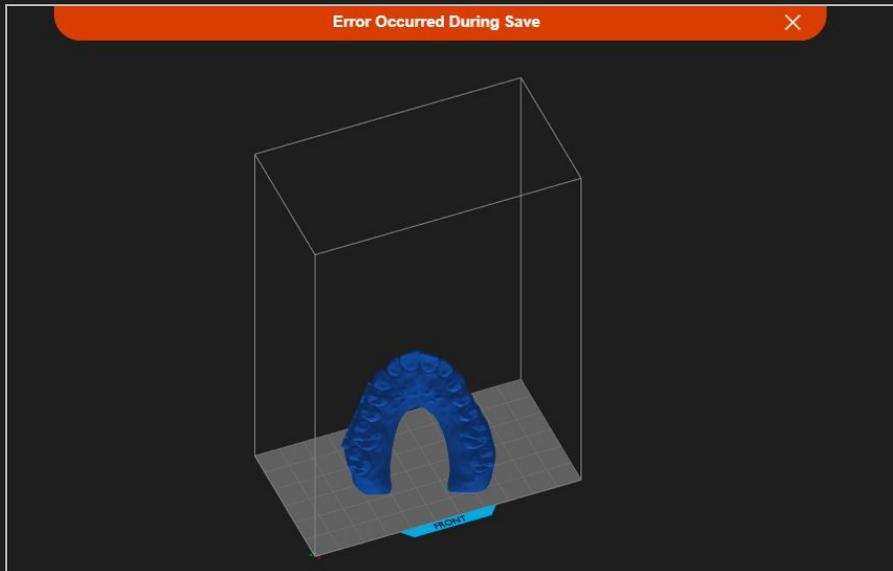
To report a bug, click the bug symbol:



Problems and Fixes

Saving

Saving can be disrupted for a variety of reasons. It can be attributed to a full hard drive, running out of memory, or a failed back-end process like the slicer. NexaX 2.0 has a catch-all banner for failed saves. Make sure that you are using your GPU when running this software.



Models

Sometimes models can appear to have pure black / no texture. This happens if the normals are inverted. You should fix your model by flipping normals and then reimport it. **All models imported into NexaX should be completely fixed** (water-tight, no non-manifold edges, flipped normals, etc.) **for the proper generation of slices.** We recommend Meshmixer for this!

