

## Important changes between the MK4 and the XL.

1. The XL uses a corexy motion system. This means that there are more open belt systems which means more opportunities for things to get caught like long hair, necklaces, beards, etc.
2. The XL uses different steel sheets. Be sure to review the material table to know which sheet is used for which material
3. Glass cleaner is the recommended cleaner for both steel sheets instead of alcohol. Sheets should be cleaned cold (under 30°)
4. The XL has a 0.6mm nozzle compared to a more common 0.4mm.
5. The XL takes advantage of tole bed heaters to only heat the portions of the bed that are actively being used. During the preprint cycle, the steel sheet will “absorb heat” from the adjacent panels to ensure that there are no sharp temperature changes that may cause curling
6. PLA is still the only material you are allowed to use at this point. Extra materials, PETG, TPU, etc. are covered in a supplemental class
7. The XL printer has a larger range of profiles to choose from. You are still required to use profiles that have “make717 – “ in front of them. The new profiles are tuned for things like speed, layer height, temperature, etc. These profiles, just like the ones for the Prusa Mini, are specifically tuned for our printers. Using other profiles run the risk of serious damage to the machine.
8. The XL is monitored by Prusa Control. You are not allowed to remote start prints or upload files remotely.