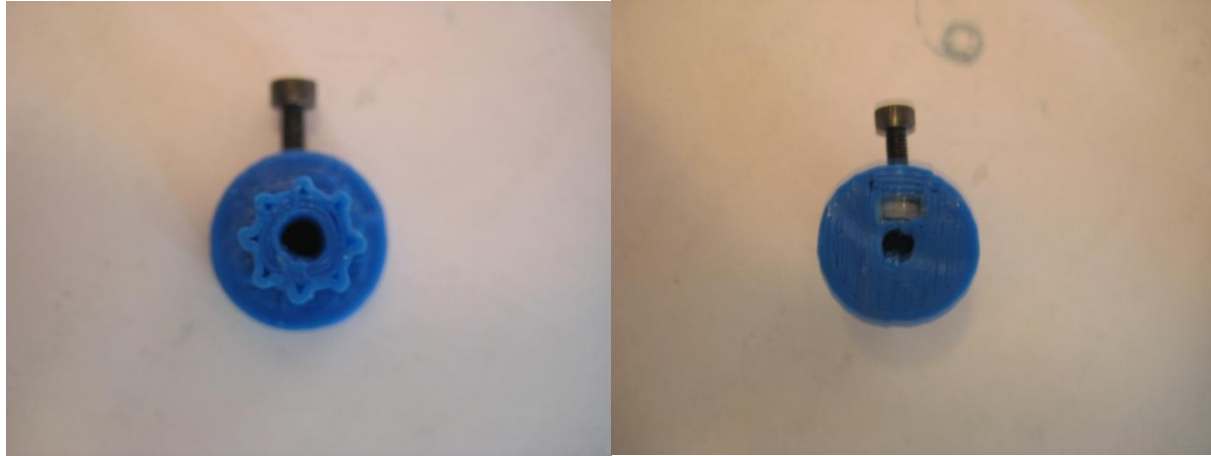
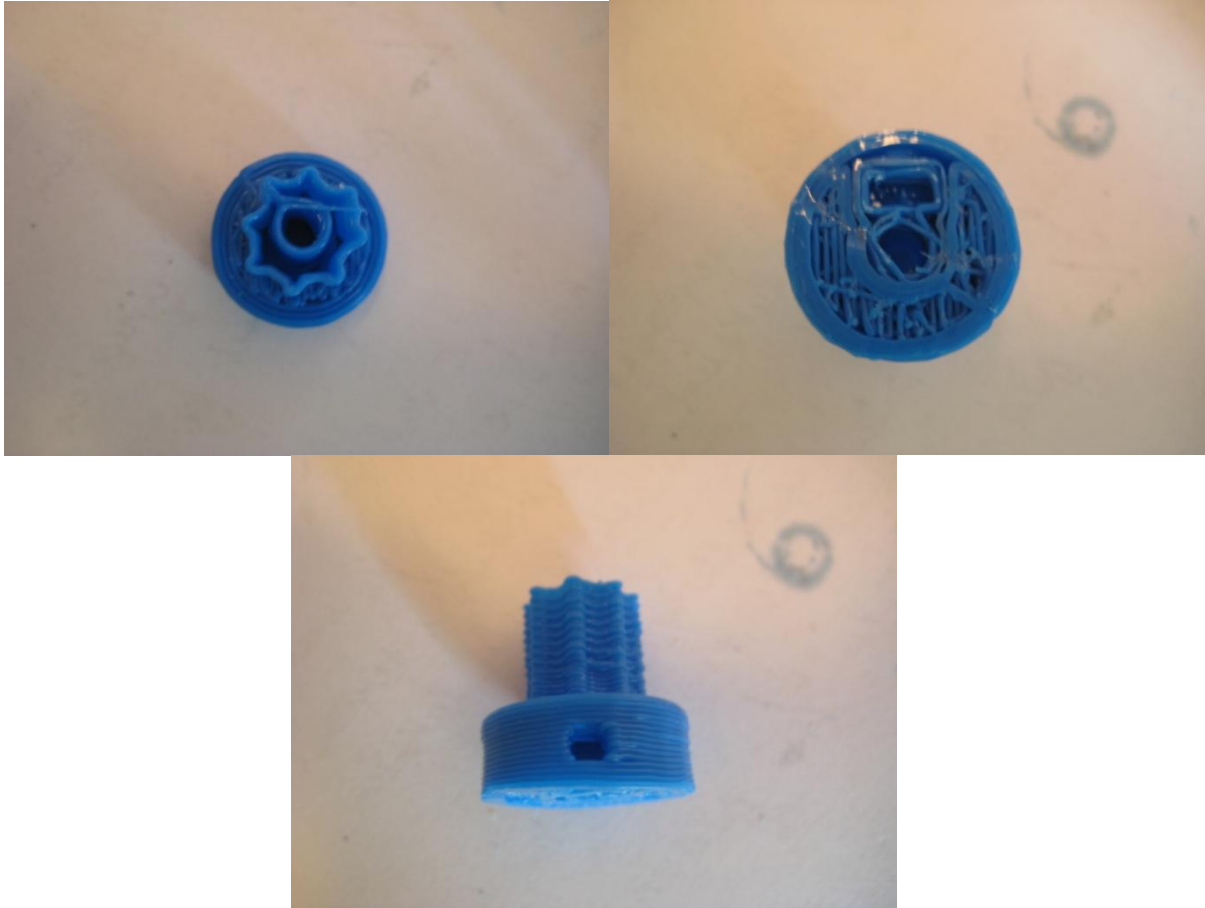


Gear1



Gear2



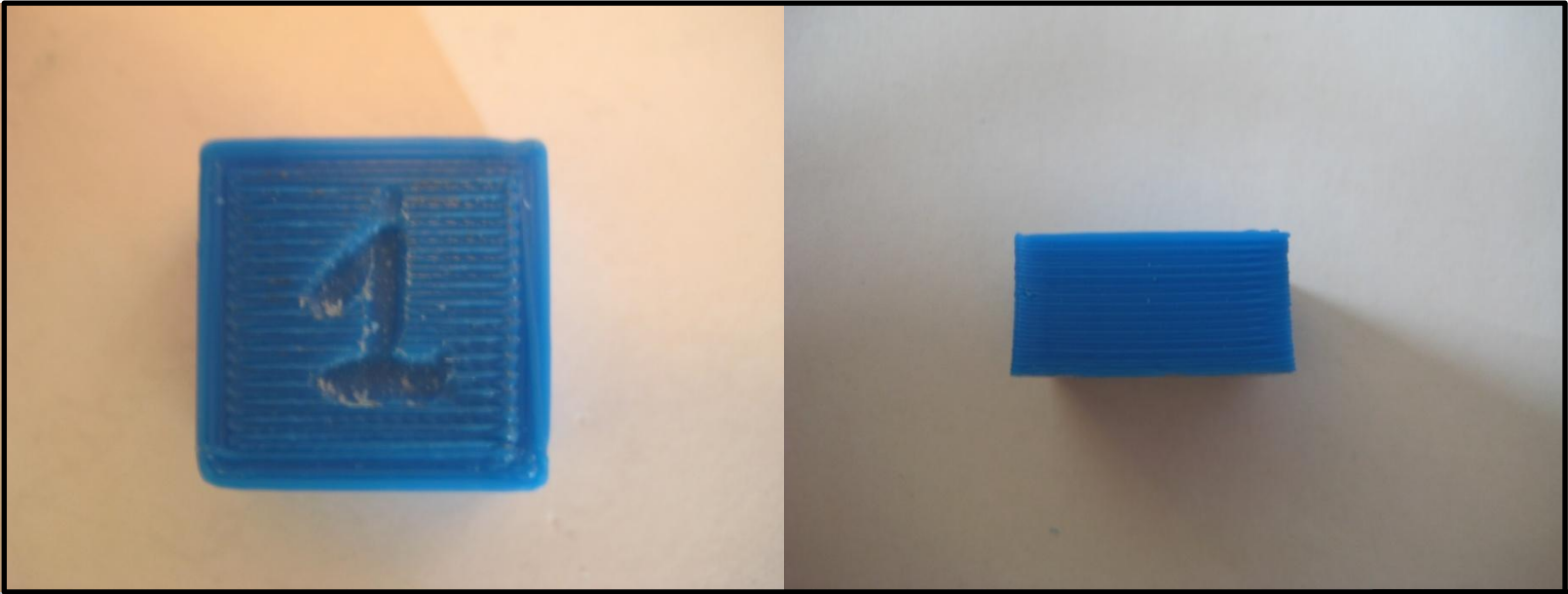
Very bad infill.

Gear3

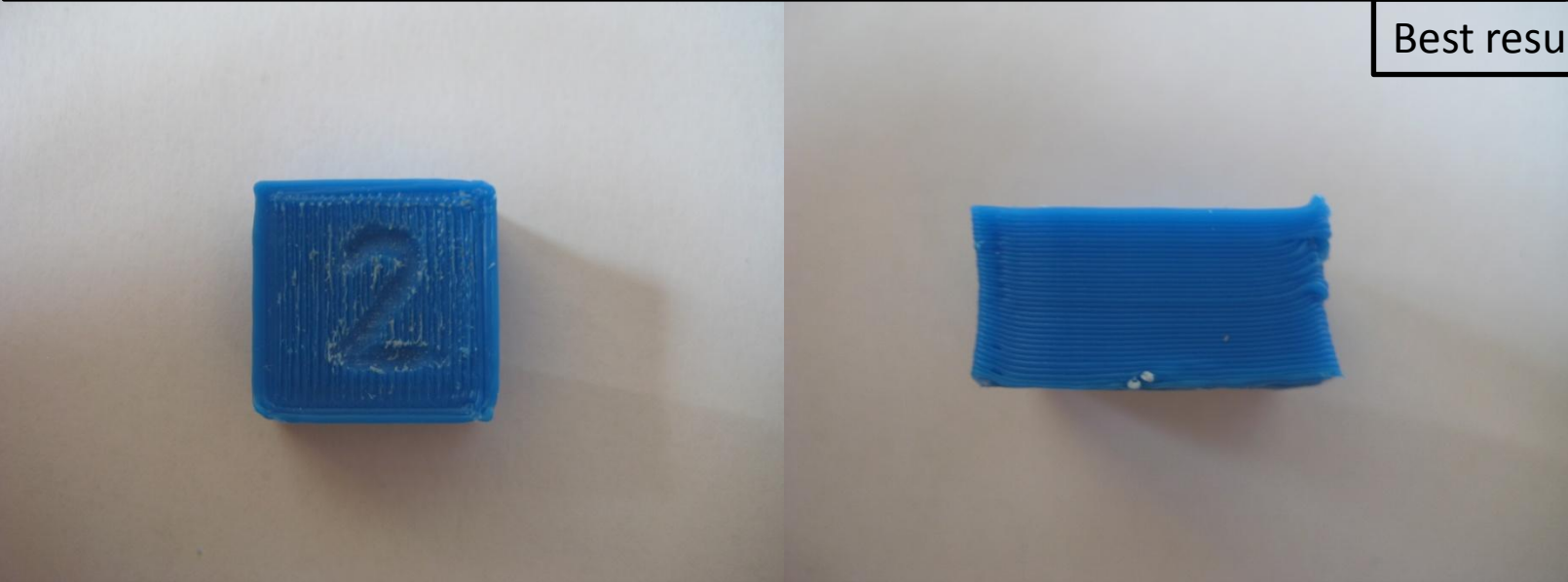


After the 3rd bad print of a gear, I start reading the manual of dave durant for achieving reliable, good and strong prints. I made 4 tests with the calibration box. Watch slides below.

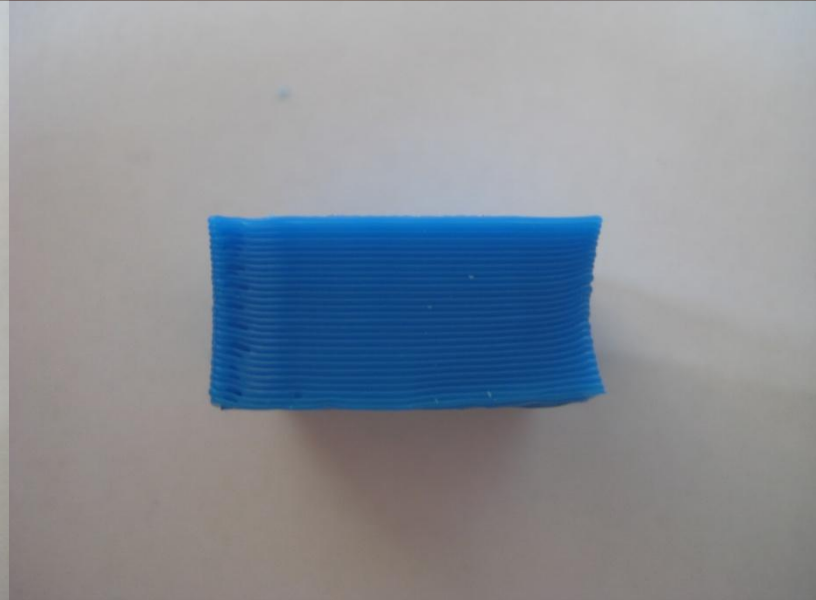
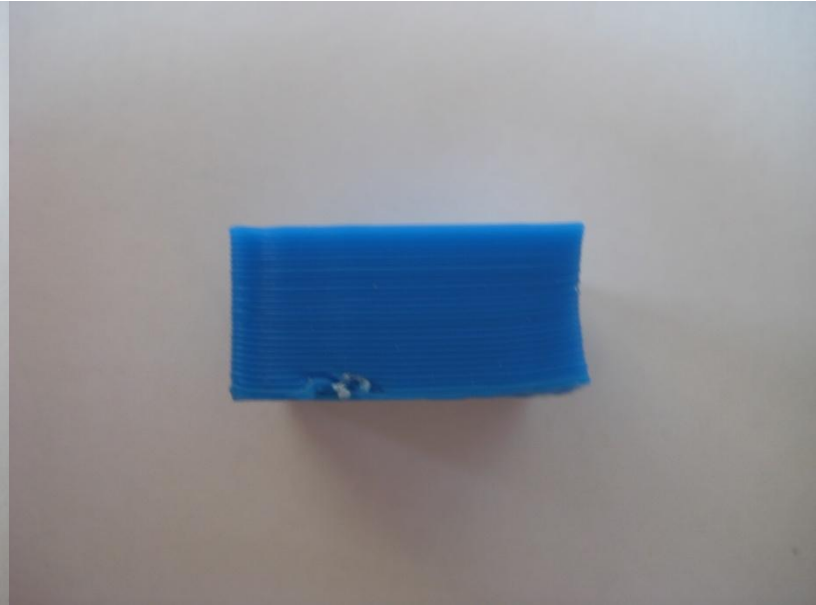
Tweaks with calibration box



Best result of 4



Tweaks with calibration box



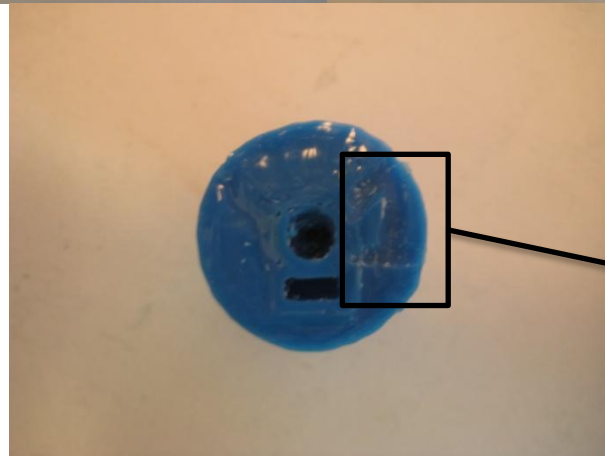
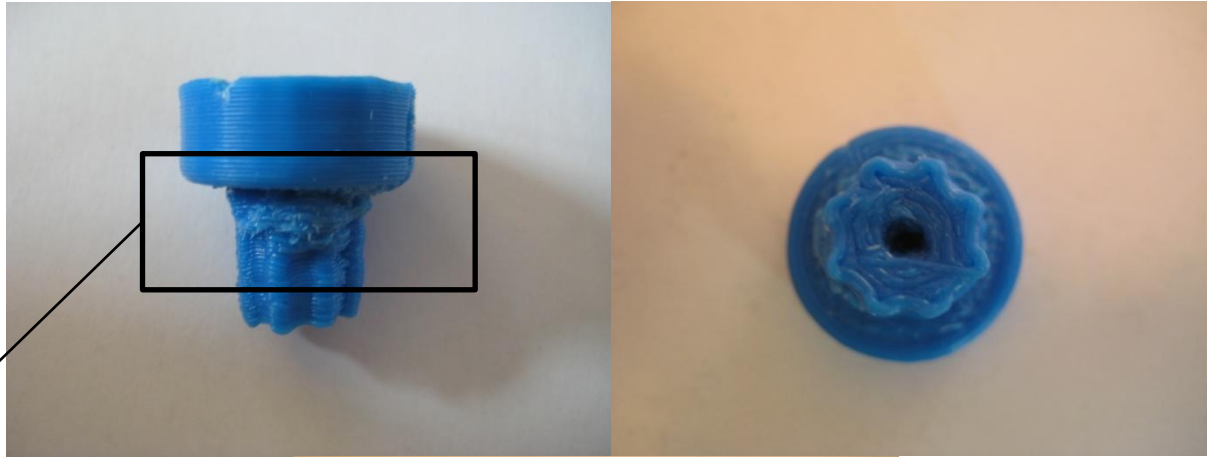
Tweak settings

SK39						
	layer height	width/ thickness	feed rate	flow rate	stuck	infill
tweak 1	0.32	1.6	36	255	20mmbox	1
tweak 2	0.28	1.4	54	255	20mmbox	1
tweak 3	0.35	1.4	34	255	20mmbox	1
tweak 4	0.35	1.0	46	255	20mmbox	1
tweak 5	0.32	1.6	36	255	pulley -Z-Axis	0.8

Conclusion

Tweak 1 gave the best result. Tried to print a gear with those settings. I used always SF 39. Result see next slide

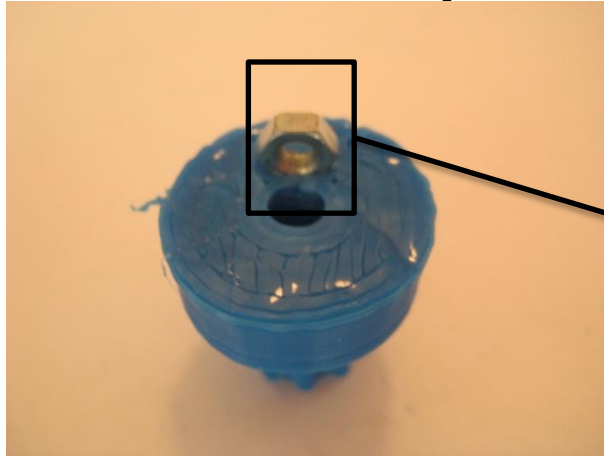
Gear4 with tweak 5 settings



Very bad quality, seems during print that feedrate was too low? Temperature too high? Infill was set to 0.8, can also be reason?

1

Gear 5 with SK35 standard settings form ReplicatorG 0024



Unable to fit in nut. Even when the piece is just coming off the heat platform. Quality is overall not so bad. I read that with stretch you can make your holes bigger, is this feature stable in SK?

2nd conclusion

Can anybody help me with some good settings for printing gears?

Thx!!