

Printer Settings:

Plater	Print Settings	Filament Settings	Printer Settings
TEST			
<ul style="list-style-type: none">Layers and perimetersInfillSkirt and brimSupport materialSpeedMultiple ExtrudersAdvancedOutput optionsNotes		<div>Layer height</div> <div>Layer height: 0.1 mm</div> <div>First layer height: 150% mm or %</div> <div>Vertical shells</div> <div>Perimeters: 3 (minimum)</div> <div>Spiral vase: <input type="checkbox"/></div> <div>Horizontal shells</div> <div>Solid layers: Top: 3 Bottom: 3</div> <div>Quality (slower slicing)</div> <div>Extra perimeters if needed: <input checked="" type="checkbox"/></div> <div>Avoid crossing perimeters: <input type="checkbox"/></div> <div>Detect thin walls: <input checked="" type="checkbox"/></div> <div>Detect bridging perimeters: <input checked="" type="checkbox"/></div> <div>Advanced</div> <div>Seam position: Aligned</div> <div>External perimeters first: <input type="checkbox"/></div>	

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<ul style="list-style-type: none">Layers and perimetersInfillSkirt and brimSupport materialSpeedMultiple ExtrudersAdvancedOutput optionsNotes		<div>Infill</div> <div>Fill density: 25 %</div> <div>Fill pattern: Honeycomb</div> <div>Top/bottom fill pattern: Octagram Spiral</div> <div>Reducing printing time</div> <div>Combine infill every: 1 layers</div> <div>Only infill where needed: <input type="checkbox"/></div> <div>Advanced</div> <div>Solid infill every: 0 layers</div> <div>Fill angle: 45 °</div> <div>Solid infill threshold area: 70 mm²</div> <div>Only retract when crossing perimeters: <input checked="" type="checkbox"/></div> <div>Infill before perimeters: <input type="checkbox"/></div>	

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Skirt

Loops (minimum): 1

Distance from object: 6 mm

Skirt height: 1 layers

Minimum extrusion length: 0 mm

Brim

Brim width: 0.1 mm

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Support material

Generate support material: ☒

Overhang threshold: 0 °

Enforce support for the first: 0 layers

Raft

Raft layers: 0 layers

Options for support material and raft

Contact Z distance: 0.2 (detachable) mm

Pattern: pillars

Pattern spacing: 2.5 mm

Pattern angle: 0 °

Interface layers: 3 layers

Interface pattern spacing: 0 mm

Don't support bridges: ☒

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Speed for print moves

Perimeters:	50	mm/s
Small perimeters:	30	mm/s or %
External perimeters:	60%	mm/s or %
Infill:	60	mm/s
Solid infill:	20	mm/s or %
Top solid infill:	15	mm/s or %
Support material:	60	mm/s
Support material interface:	100%	mm/s or %
Bridges:	60	mm/s
Gap fill:	20	mm/s

Speed for non-print moves

Travel:	150	mm/s
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Modifiers

First layer speed:	50	mm/s or %
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Acceleration control (advanced)

Perimeters:	0	mm/s ²
Infill:	0	mm/s ²
Bridge:	0	mm/s ²
First layer:	0	mm/s ²
Default:	0	mm/s ²

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PLA

Filament
Cooling

Filament

Diameter:	2.85	mm
Extrusion multiplier:	1	

Temperature (°C)

Extruder:	First layer: 230	Other layers: 210
Bed:	First layer: 65	Other layers: 60