

This model was tested with **PLA material**.

To avoid printing problems, we recommend the following settings:

### **Layer height**

Layer height: 0.1 mm

First layer height: 90%

### **Vertical shells**

Perimeters: 2

### **Horizontal shells**

Solid layers:

Top: 8

Bottom: 5

### **Quality**

Detect thin walls: Check

Detect bridging perimeters: Check

### **Advanced**

Seam position: Random

### **Infill**

Fill density: 20%

Fill pattern: Honeycomb

Top/bottom fill pattern: Rectilinear

### **Reducing printing time**

Combine infill every: 1 layers

### **Advanced**

Solid infill every: 0 layers

Fill angle: 25 deg

Solid infill threshold area: 0mm

### **Skirt**

Loops: 2

Distance from object: 6 mm

Skirt height: 1 layers

Minimum extrusion length: 4 mm

### **Brim**

Brim width: 10 mm

### **Support material**

Generate support material: Check

Overhang threshold: 45 deg

Enforce support for the first: 3 layers

### **Raft**

Raft layers: 0 layers

### **Options for support material and raft**

Contact Z distance: 0.1 mm

Pattern: Rectilinear  
Patter spacing: 2 mm  
Pattern angle: 0 deg  
Interface layers: 2 layers  
Interface pattern spacing: 0.2 mm

### **Speed for print moves**

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

### **Speed for non-print moves**

Travel: 60 mm/s

### **Modifiers**

First layer speed: 30 mm/s

### **Acceleration control**

Perimeters: 800 mm/s  
Infill: 1500 mm/s  
Bridge: 1000 mm/s  
First layer: 1000 mm/s  
Default: 1000 mm/s

### **Autospeed**

Max print speed: 100 mm/s  
Max volumetrix speed: 0 mm/s

### **Extrusion width**

Default extrusion width: 0.42 mm  
First layer: 0.42 mm  
Perimeters: 0.42 mm  
External perimeters: 0.42 mm  
Infill: 0.42 mm  
Solid infill: 0.42 mm  
Top solid infill: 0.42 mm  
Support material: 0.42 mm

### **Overlap**

Infill/Perimeters overlap: 20%

### **Flow**

Bridge flow ratio: 0.95

### **Other**

XY Size Compensation: 0 mm

Threds: 8

Resolution: 0 mm