

The following parameters refer to the printer software 'G3DMaker'.

Model name:

Model size:

Print time:

Fill density: optional (%)

Note:

Nozzle: 0,2 /0,3 /0,5

Perimeters: 1 -5

Printing parameters:

Layer: optional (0,25 – 0,125 – 0,08)

Retract:		Cooling:		Extrusion:			
Speed (mm/s)	150	Enable cooling	YES	Extrusion width (mm)	0,5	0,3	0,19
Lenght (mm)	2,5	Keep fan always on	NO	First layer width (mm)	0,5	0,3	0,19
Lift Z (mm)	0,3	Min. Fan speed (%)	70	Perimeter extrusion width (mm)	0,5	0,3	0,19
Extra lenght on restart	0	Max. Fan speed (%)	100	Infill extrusion width (mm)	0,5	0,3	0,19
Min. Travel after retract (mm)	2	Bridge fan speed (%)	100	Support material extrusion width (mm)	0,5	0,3	0,19
Print settings:		Enable fan if layer print time is below (sec)	15	Bridge flow ratio	1	1	1
Solid layers	5	Slow down if layer print time is below (sec)	11	Nozzle diameter: 0,5 0,3 0,2			
Fill angle (°)	45	Min. Print speed (mm/s)	10				
Fill pattern	Honeycomb / linear	Disable fans for the first N layers	3				
Solid fill pattern	linear						
Randomize starting point	YES						
Skirt:		Speed:		Support material:			
Loops	1	Perimeters (mm/s or %)	40	Overhang treshold (°)	0		
Distance from object	6	Small perimetres (mm/s or %)	30	Pattern spacing (mm)	2 – 4		
Skirt height (lenght)	1	Infill (mm/s)	45	Pattern angle (°)	0		
Brim (mm)	6	Solid infill (mm/s or %)	40				
		Top solid infill (mm/s or %)	40				
		Bridges (mm/s)	50				
		External perimeter speed (mm/s or %)	35				
		Travel (mm/s)	180				
		First layer speed (mm/s or %)	60,00%				

Material editor:

Material:	PLA	ABS	(Turn OFF cooling for ABS material or set fan speed to 0)
Multiplier:	1.0	1.0	
Diameter:	1,75	1,75	
First layer bed (°C):	45	82	
Bed (°C):	45	90	
First layer extrusion (°C):	195	245	
Extrusion temperature(°C):	190	235	