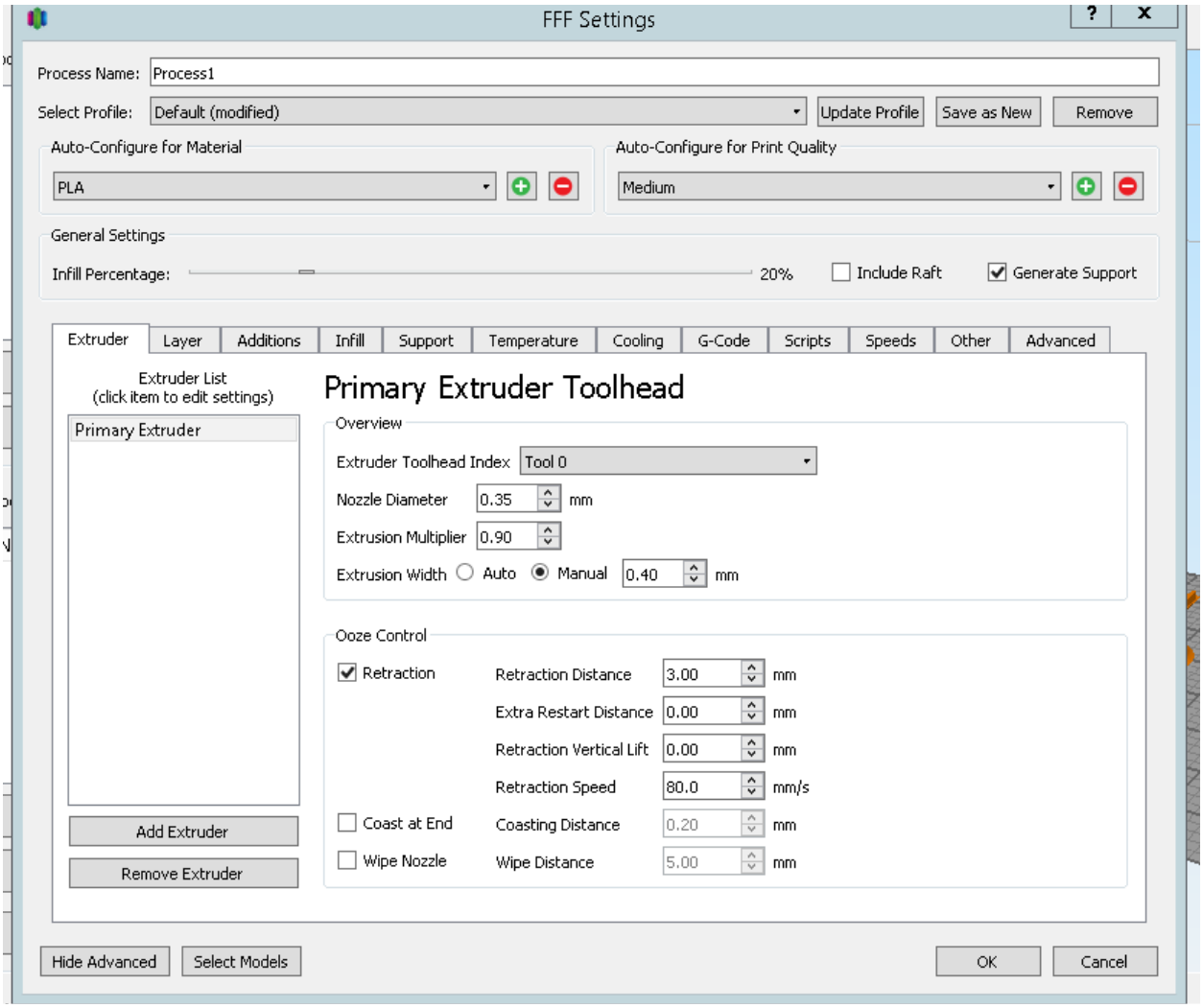
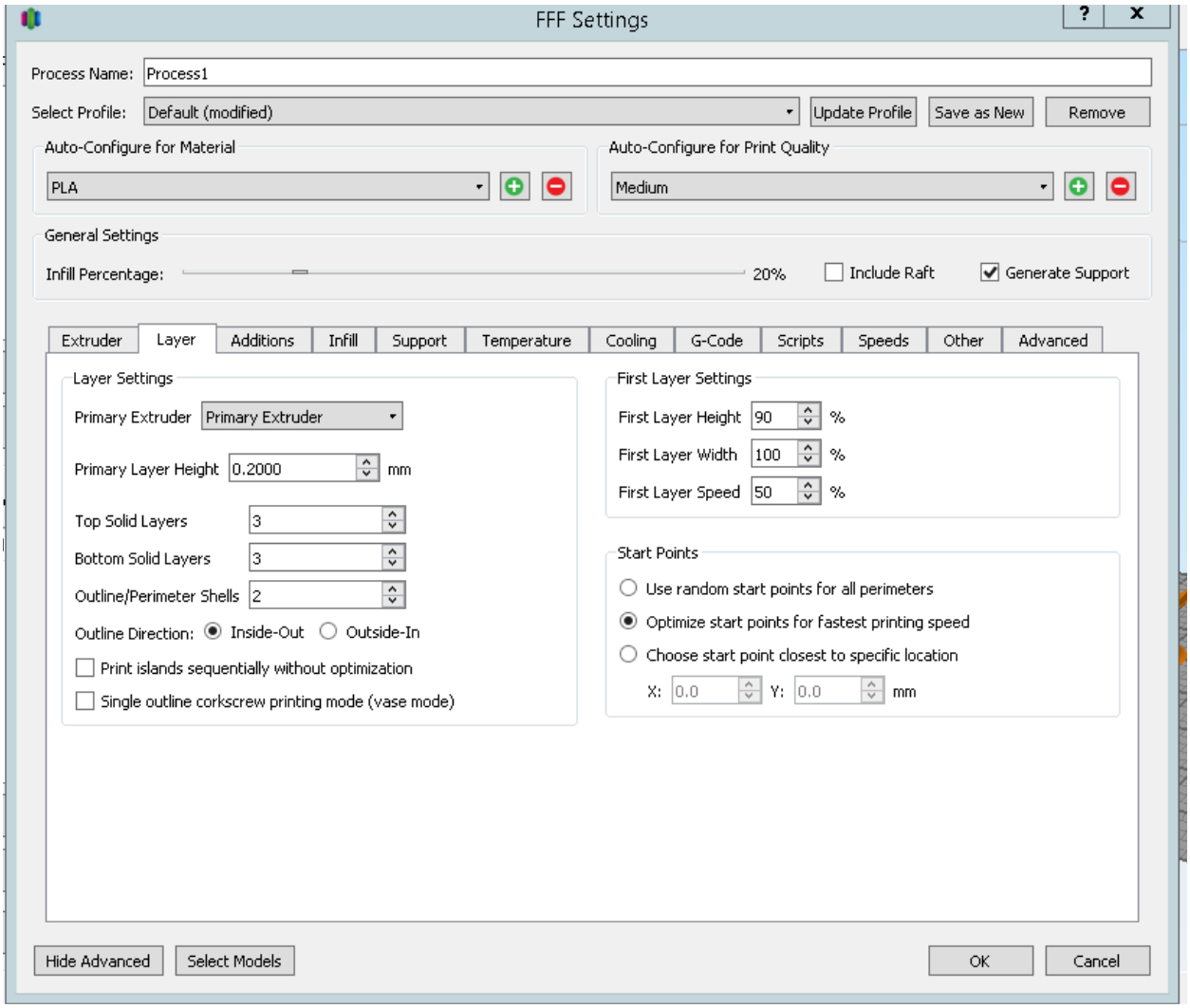
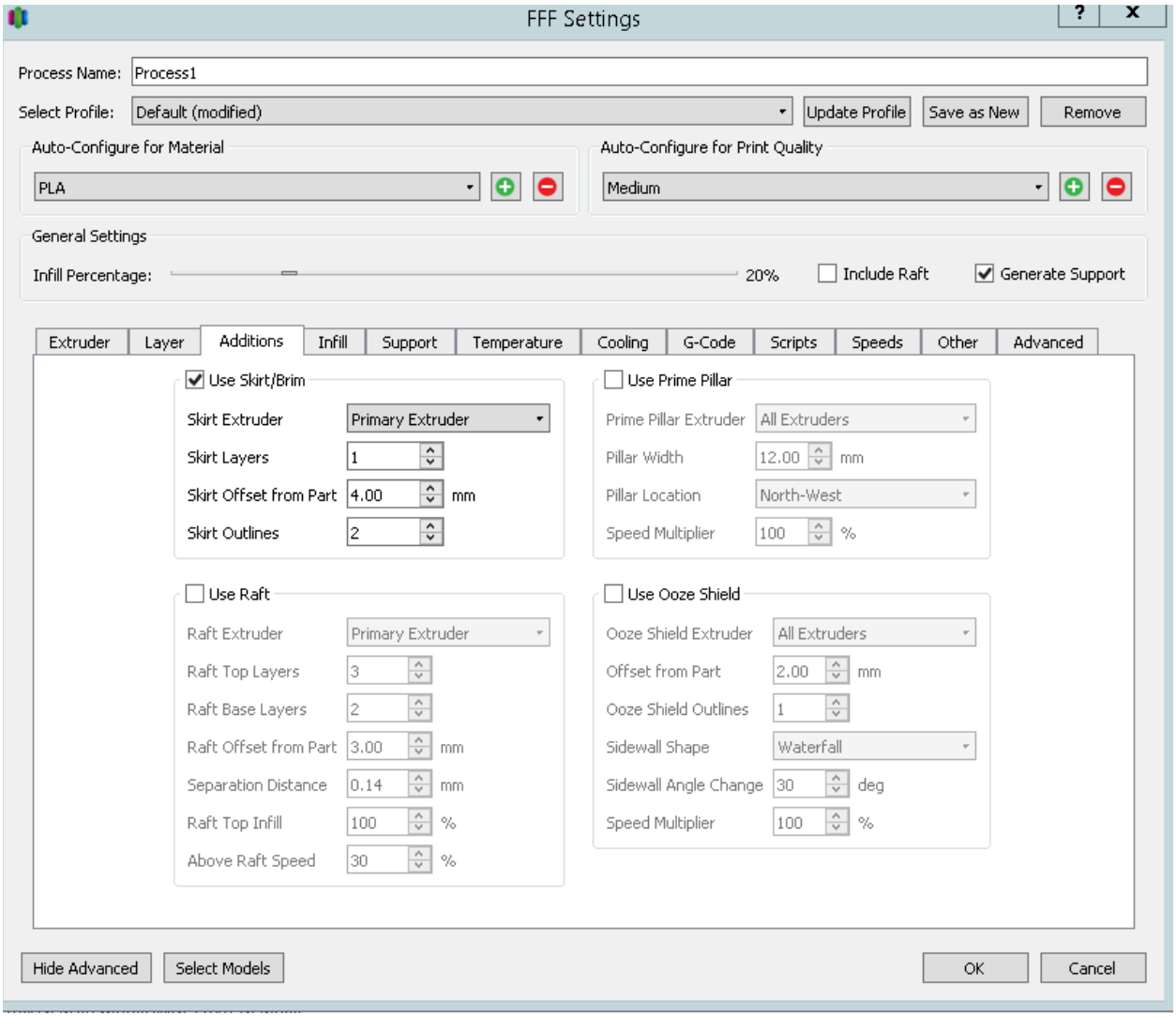
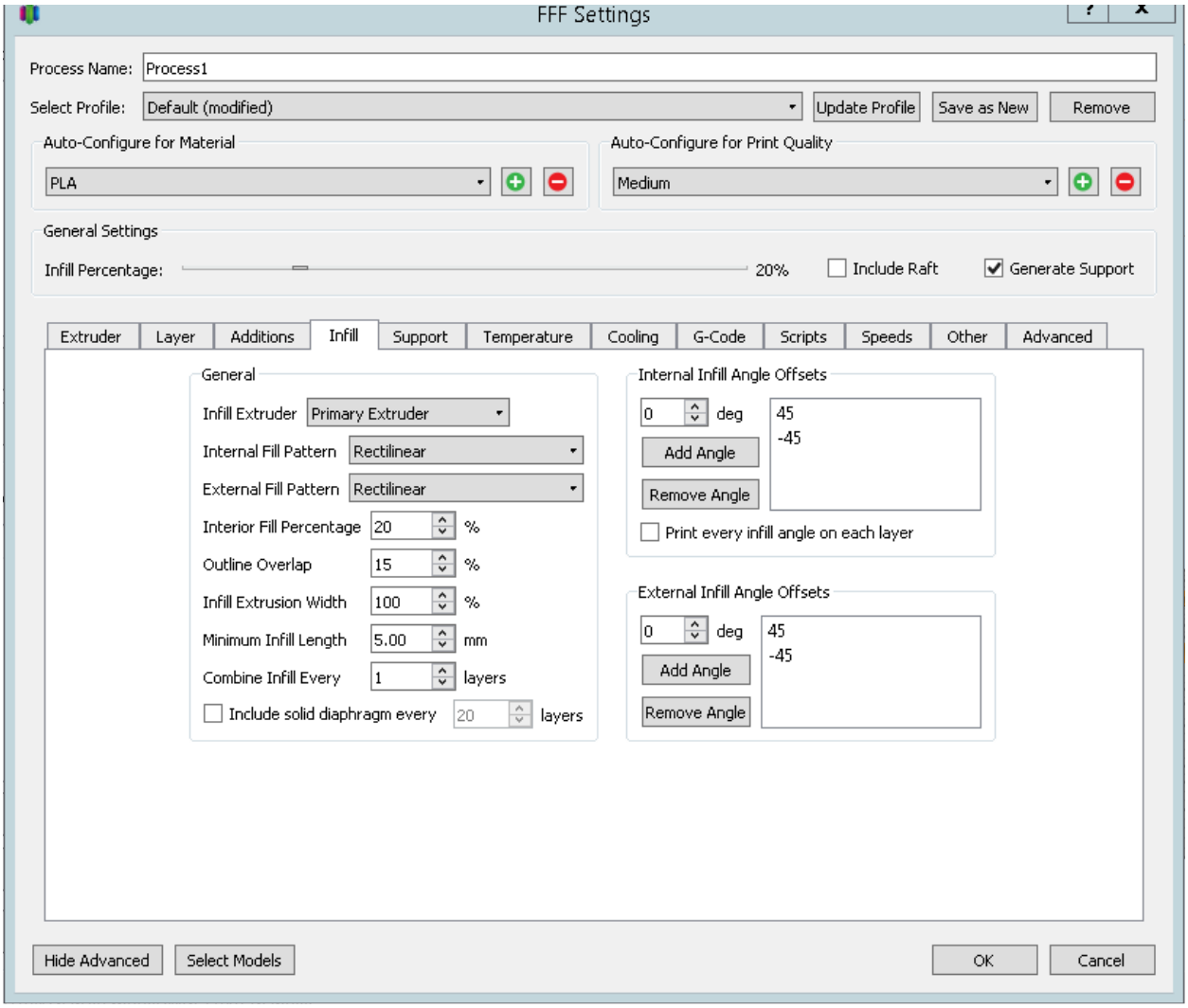
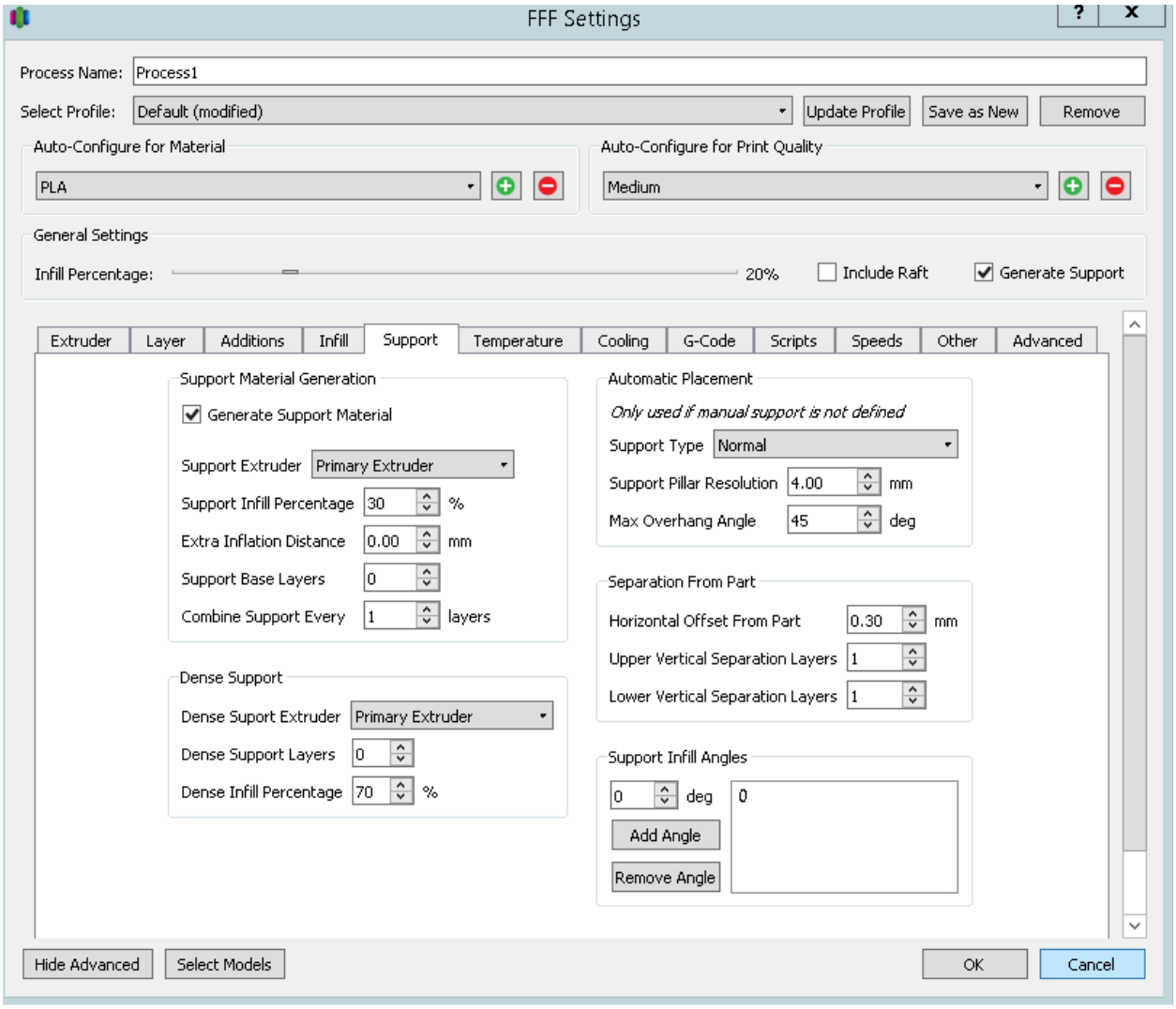
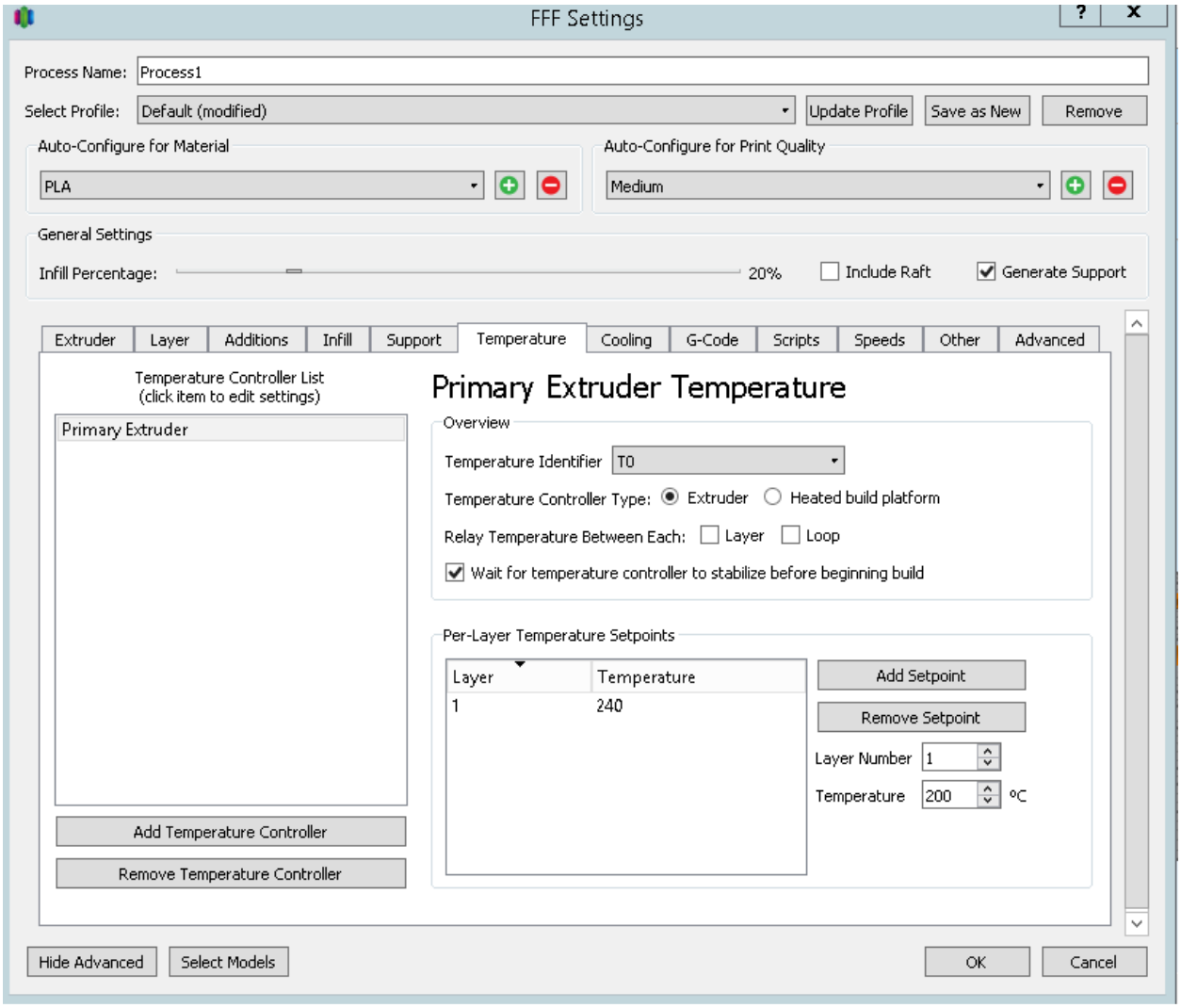

FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Extruder List
(click item to edit settings)
Primary Extruder
Add Extruder
Remove Extruder
Primary Extruder Toolhead
Overview
Extruder Toolhead Index
Tool 0
Nozzle Diameter
0.35
mm
Extrusion Multiplier
0.90
Extrusion Width
Auto
Manual
0.40
mm
Ooze Control
Retraction
Retraction Distance
3.00
mm
Extra Restart Distance
0.00
mm
Retraction Vertical Lift
0.00
mm
Retraction Speed
80.0
mm/s
Coast at End
Coasting Distance
0.20
mm
Wipe Nozzle
Wipe Distance
5.00
mm
Hide Advanced
Select Models
OK
Cancel

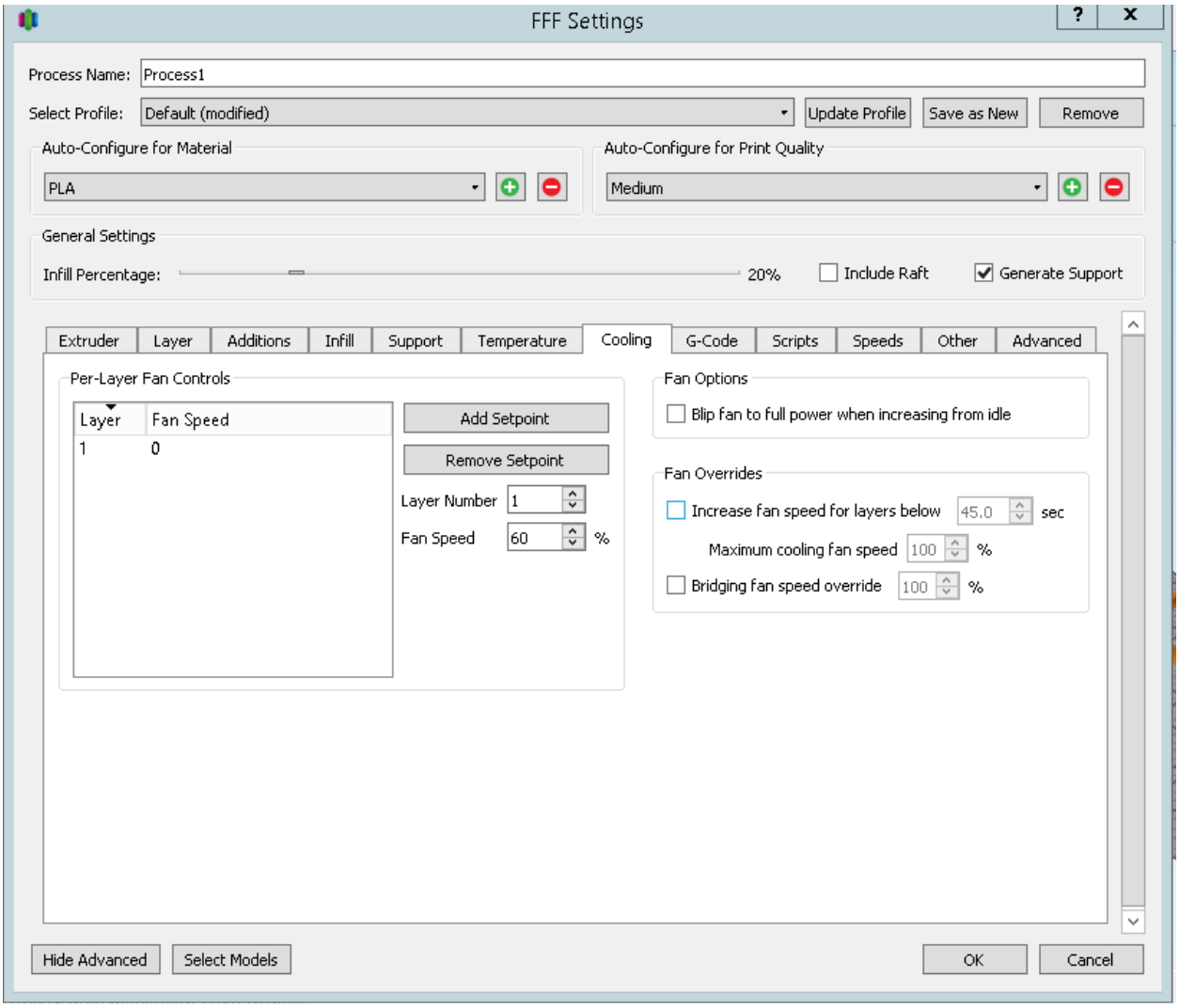

FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Layer Settings
Primary Extruder
Primary Extruder
Primary Layer Height
0.2000
mm
Top Solid Layers
3
Bottom Solid Layers
3
Outline/Perimeter Shells
2
Outline Direction:
Inside-Out
Outside-In
Print islands sequentially without optimization
Single outline corkscrew printing mode (vase mode)
First Layer Settings
First Layer Height
90
%
First Layer Width
100
%
First Layer Speed
50
%
Start Points
Use random start points for all perimeters
Optimize start points for fastest printing speed
Choose start point closest to specific location
X:
0.0
Y:
0.0
mm
Hide Advanced
Select Models
OK
Cancel

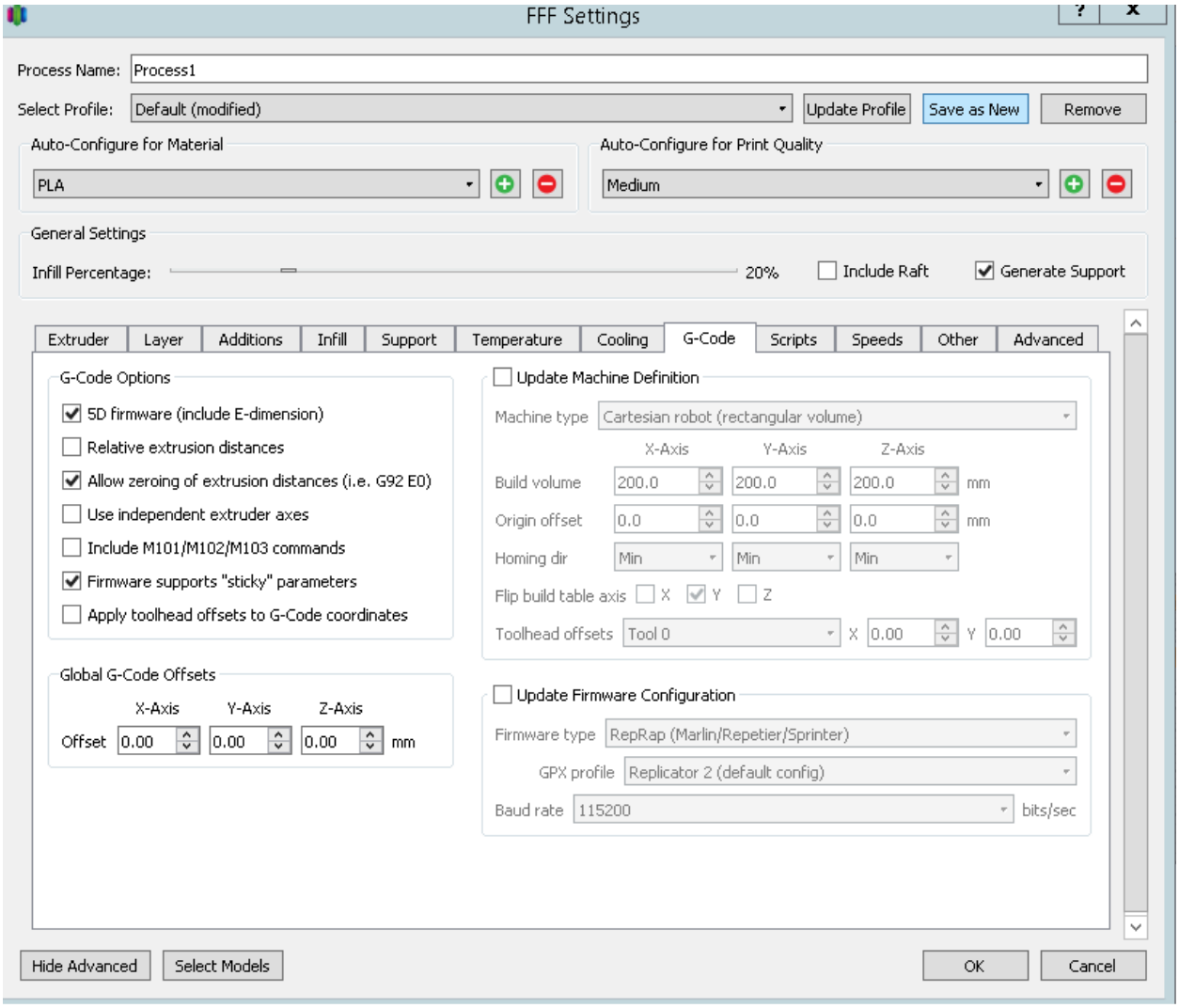

FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Use Skirt/Brim
Skirt Extruder
Primary Extruder
Skirt Layers
1
Skirt Offset from Part
4.00
mm
Skirt Outlines
2
Use Prime Pillar
Prime Pillar Extruder
All Extruders
Pillar Width
12.00
mm
Pillar Location
North-West
Speed Multiplier
100
%
Use Raft
Raft Extruder
Primary Extruder
Raft Top Layers
3
Raft Base Layers
2
Raft Offset from Part
3.00
mm
Separation Distance
0.14
mm
Raft Top Infill
100
%
Above Raft Speed
30
%
Use Ooze Shield
Ooze Shield Extruder
All Extruders
Offset from Part
2.00
mm
Ooze Shield Outlines
1
Sidewall Shape
Waterfall
Sidewall Angle Change
30
deg
Speed Multiplier
100
%
Hide Advanced
Select Models
OK
Cancel

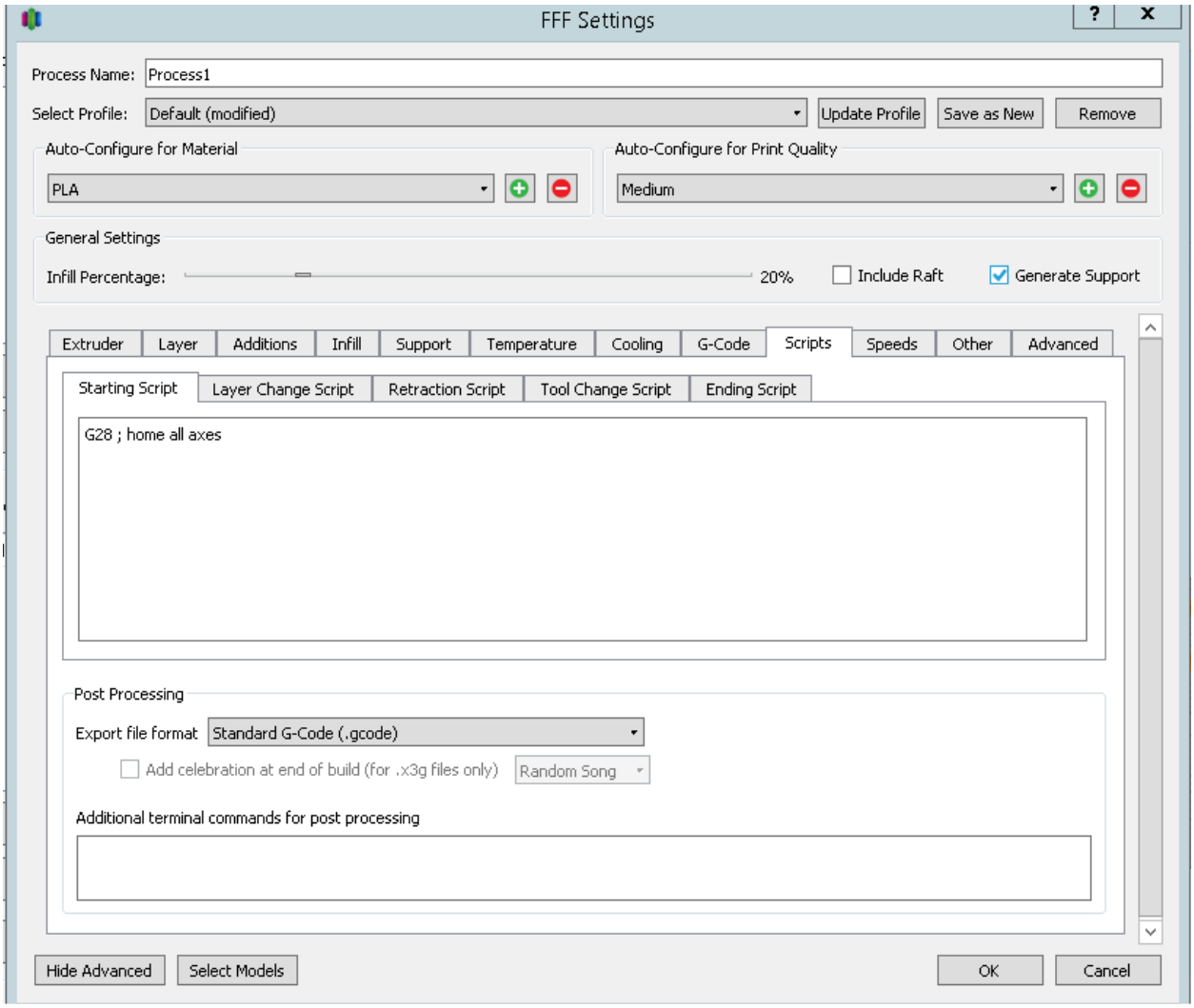

FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
General
Infill Extruder
Primary Extruder
Internal Fill Pattern
Rectilinear
External Fill Pattern
Rectilinear
Interior Fill Percentage
20
%
Outline Overlap
15
%
Infill Extrusion Width
100
%
Minimum Infill Length
5.00
mm
Combine Infill Every
1
layers
Include solid diaphragm every
20
layers
Internal Infill Angle Offsets
0
deg
Add Angle
Remove Angle
45
-45
Print every infill angle on each layer
External Infill Angle Offsets
0
deg
Add Angle
Remove Angle
45
-45
Hide Advanced
Select Models
OK
Cancel

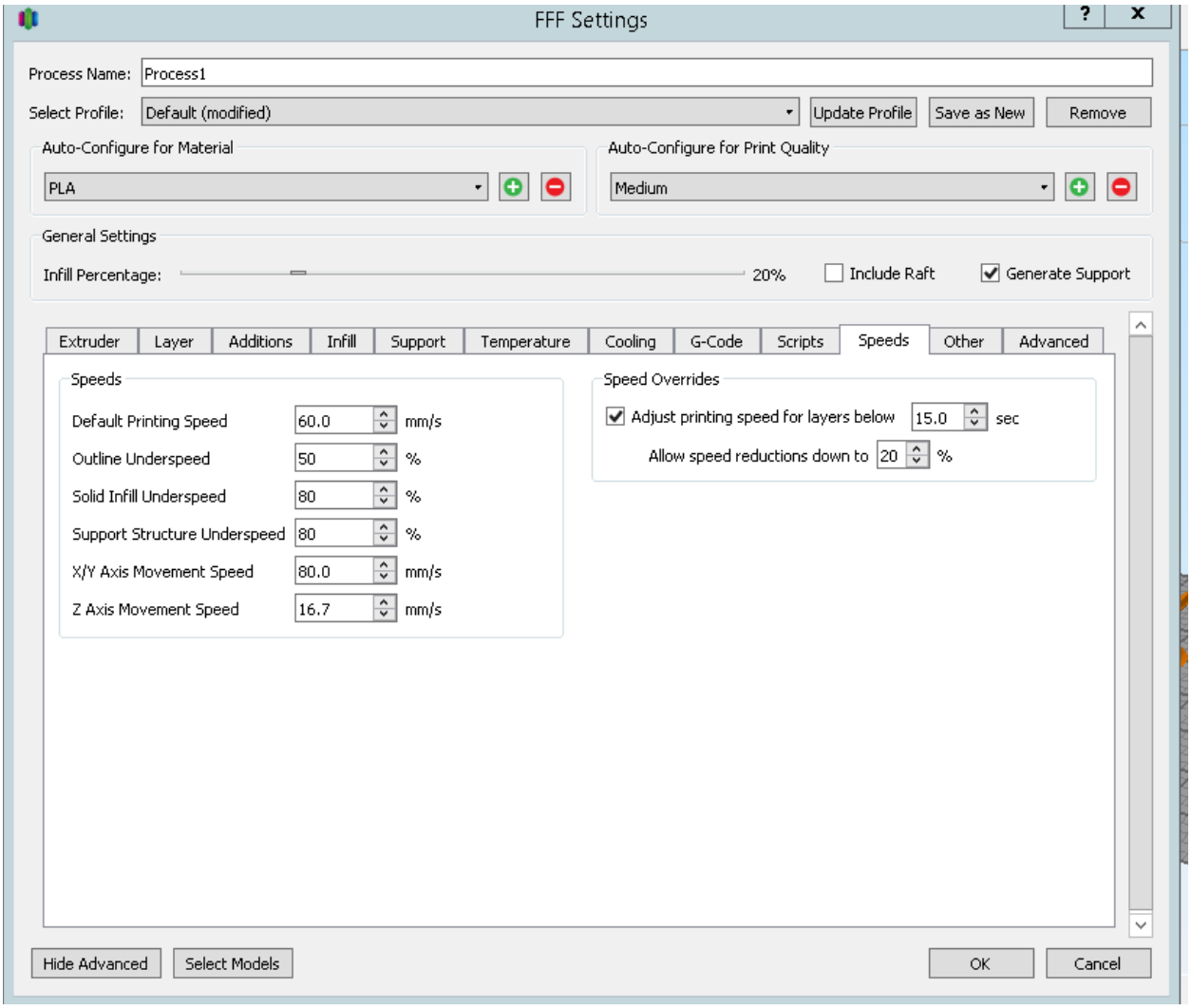

FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage: 20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Support Material Generation
Generate Support Material
Support Extruder Primary Extruder
Support Infill Percentage 30 %
Extra Inflation Distance 0.00 mm
Support Base Layers 0
Combine Support Every 1 layers
Dense Support
Dense Suport Extruder Primary Extruder
Dense Support Layers 0
Dense Infill Percentage 70 %
Automatic Placement
Only used if manual support is not defined
Support Type Normal
Support Pillar Resolution 4.00 mm
Max Overhang Angle 45 deg
Separation From Part
Horizontal Offset From Part 0.30 mm
Upper Vertical Separation Layers 1
Lower Vertical Separation Layers 1
Support Infill Angles
0 deg
0
Add Angle
Remove Angle
Hide Advanced
Select Models
OK
Cancel

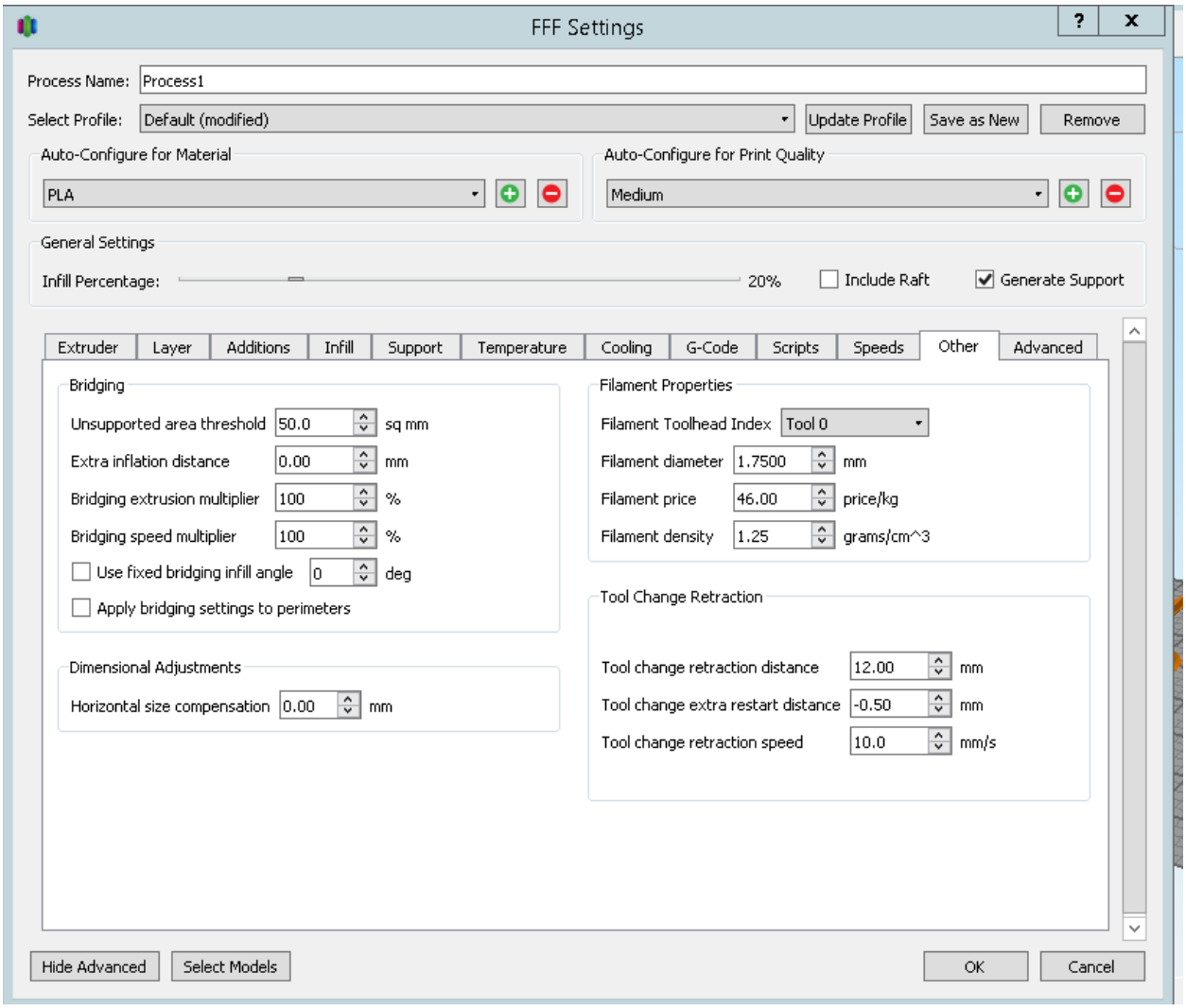

FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Temperature Controller List
(click item to edit settings)
Primary Extruder
Add Temperature Controller
Remove Temperature Controller
Primary Extruder Temperature
Overview
Temperature Identifier T0
Temperature Controller Type: Extruder Heated build platform
Relay Temperature Between Each: Layer Loop
Wait for temperature controller to stabilize before beginning build
Per-Layer Temperature Setpoints
Layer
Temperature
1
240
Add Setpoint
Remove Setpoint
Layer Number 1
Temperature 200 °C
Hide Advanced
Select Models
OK
Cancel

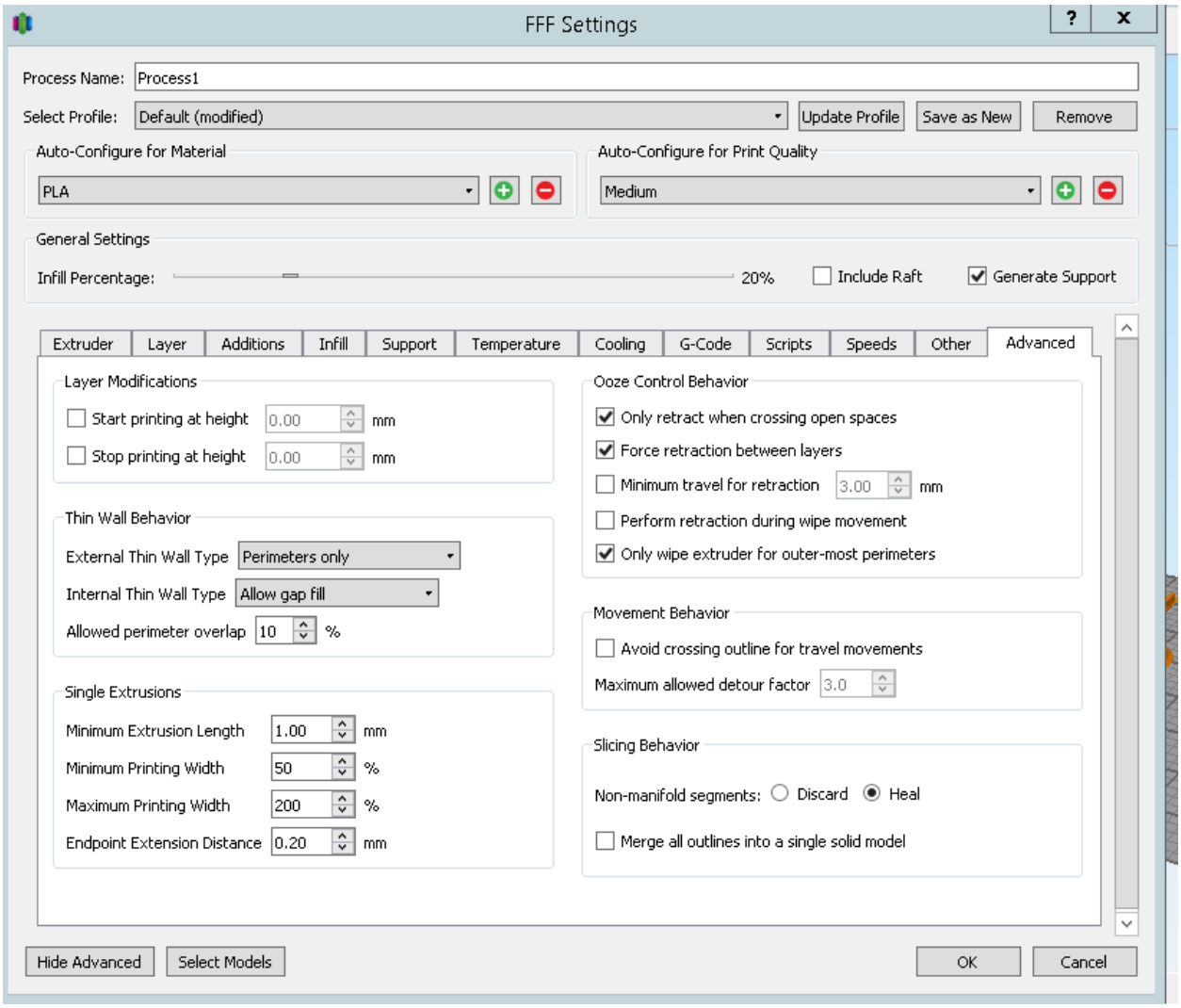

FFF Settings
Process Name:
Process1
Select Profile:
Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Per-Layer Fan Controls
Layer
Fan Speed
1
0
Add Setpoint
Remove Setpoint
Layer Number
1
Fan Speed
60
%
Fan Options
Blip fan to full power when increasing from idle
Fan Overrides
Increase fan speed for layers below
45.0
sec
Maximum cooling fan speed
100
%
Bridging fan speed override
100
%
Hide Advanced
Select Models
OK
Cancel


FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage: 20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
G-Code Options
5D firmware (include E-dimension)
Relative extrusion distances
Allow zeroing of extrusion distances (i.e. G92 E0)
Use independent extruder axes
Include M101/M102/M103 commands
Firmware supports "sticky" parameters
Apply toolhead offsets to G-Code coordinates
Global G-Code Offsets
X-Axis Y-Axis Z-Axis
Offset 0.00 0.00 0.00 mm
Update Machine Definition
Machine type Cartesian robot (rectangular volume)
X-Axis Y-Axis Z-Axis
Build volume 200.0 200.0 200.0 mm
Origin offset 0.0 0.0 0.0 mm
Homing dir Min Min Min
Flip build table axis X Y Z
Toolhead offsets Tool 0 X 0.00 Y 0.00
Update Firmware Configuration
Firmware type RepRap (Marlin/Repetier/Sprinter)
GPX profile Replicator 2 (default config)
Baud rate 115200 bits/sec
Hide Advanced
Select Models
OK
Cancel


FFF Settings
Process Name:
Process1
Select Profile:
Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Starting Script
Layer Change Script
Retraction Script
Tool Change Script
Ending Script
G28 ; home all axes
Post Processing
Export file format
Standard G-Code (.gcode)
Add celebration at end of build (for .x3g files only)
Random Song
Additional terminal commands for post processing
Hide Advanced
Select Models
OK
Cancel


FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage: 20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Speeds
Default Printing Speed 60.0 mm/s
Outline Underspeed 50 %
Solid Infill Underspeed 80 %
Support Structure Underspeed 80 %
X/Y Axis Movement Speed 80.0 mm/s
Z Axis Movement Speed 16.7 mm/s
Speed Overrides
Adjust printing speed for layers below 15.0 sec
Allow speed reductions down to 20 %
Hide Advanced
Select Models
OK
Cancel


FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Bridging
Unsupported area threshold 50.0 sq mm
Extra inflation distance 0.00 mm
Bridging extrusion multiplier 100 %
Bridging speed multiplier 100 %
Use fixed bridging infill angle 0 deg
Apply bridging settings to perimeters
Dimensional Adjustments
Horizontal size compensation 0.00 mm
Filament Properties
Filament Toolhead Index Tool 0
Filament diameter 1.7500 mm
Filament price 46.00 price/kg
Filament density 1.25 grams/cm^3
Tool Change Retraction
Tool change retraction distance 12.00 mm
Tool change extra restart distance -0.50 mm
Tool change retraction speed 10.0 mm/s
Hide Advanced
Select Models
OK
Cancel


FFF Settings
Process Name: Process1
Select Profile: Default (modified)
Update Profile
Save as New
Remove
Auto-Configure for Material
PLA
Auto-Configure for Print Quality
Medium
General Settings
Infill Percentage:
20%
Include Raft
Generate Support
Extruder
Layer
Additions
Infill
Support
Temperature
Cooling
G-Code
Scripts
Speeds
Other
Advanced
Layer Modifications
Start printing at height
0.00
mm
Stop printing at height
0.00
mm
Thin Wall Behavior
External Thin Wall Type
Perimeters only
Internal Thin Wall Type
Allow gap fill
Allowed perimeter overlap
10
%
Single Extrusions
Minimum Extrusion Length
1.00
mm
Minimum Printing Width
50
%
Maximum Printing Width
200
%
Endpoint Extension Distance
0.20
mm
Ooze Control Behavior
Only retract when crossing open spaces
Force retraction between layers
Minimum travel for retraction
3.00
mm
Perform retraction during wipe movement
Only wipe extruder for outer-most perimeters
Movement Behavior
Avoid crossing outline for travel movements
Maximum allowed detour factor
3.0
Slicing Behavior
Non-manifold segments:
Discard
Heal
Merge all outlines into a single solid model
Hide Advanced
Select Models
OK
Cancel