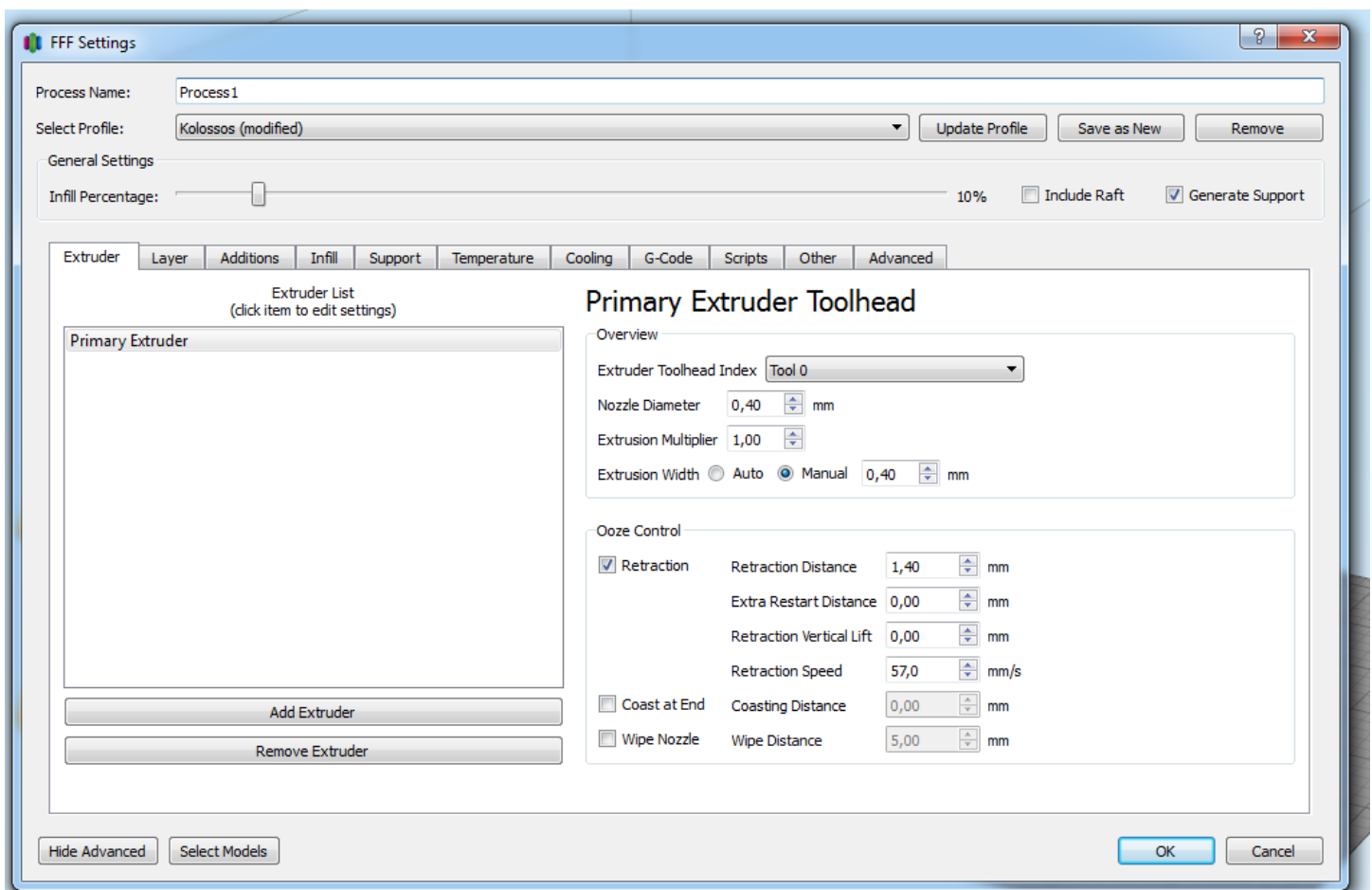


With our partner : www.formgeber-3d-druck.de

we offer the following recommended settings for



FFF Settings

Process Name: Process1

Select Profile: Kolossos (modified)

Update Profile

Save as New

Remove

General Settings

Infill Percentage: 10%

☐ Include Raft

☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Other

Advanced

Layer Settings

Primary Extruder: Primary Extruder

Primary Layer Height: 0,1000 mm

Top Solid Layers: 7

Bottom Solid Layers: 6

Outline/Perimeter Shells: 3

Outline Direction: ☒ Inside-Out ☐ Outside-In

☐ Print islands sequentially without optimization

☐ Single outline corkscrew printing mode (vase mode)

First Layer Settings

First Layer Height: 140 %

First Layer Width: 100 %

First Layer Speed: 100 %

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: 300,0 mm

Hide Advanced

Select Models

OK

Cancel

FFF Settings

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Advanced

☒ Use Skirt/Brim

Skirt Extruder: Primary Extruder

Skirt Layers: 1

Skirt Offset from Part: 1,00 mm

Skirt Outlines: 2

☐ Use Raft

Raft Extruder: Primary Extruder

Raft Layers: 3

Raft Offset from Part: 3,00 mm

Separation Distance: 0,14 mm

Raft Infill: 85 %

☐ Disable raft base layers

☐ Use Prime Pillar

Prime Pillar Extruder: All Extruders

Pillar Width: 12,00 mm

Pillar Location: North-West

Speed Multiplier: 100 %

☐ 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

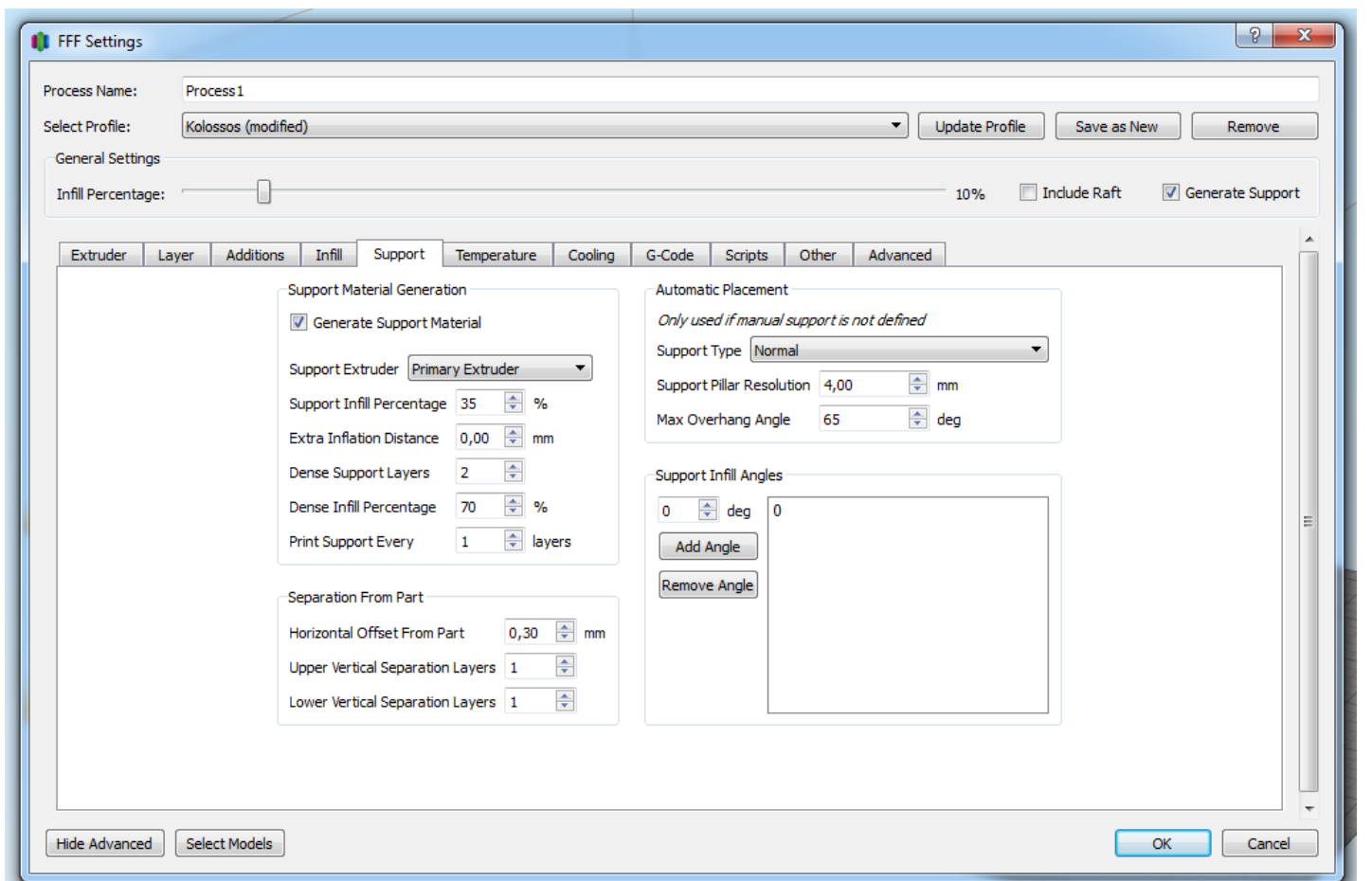
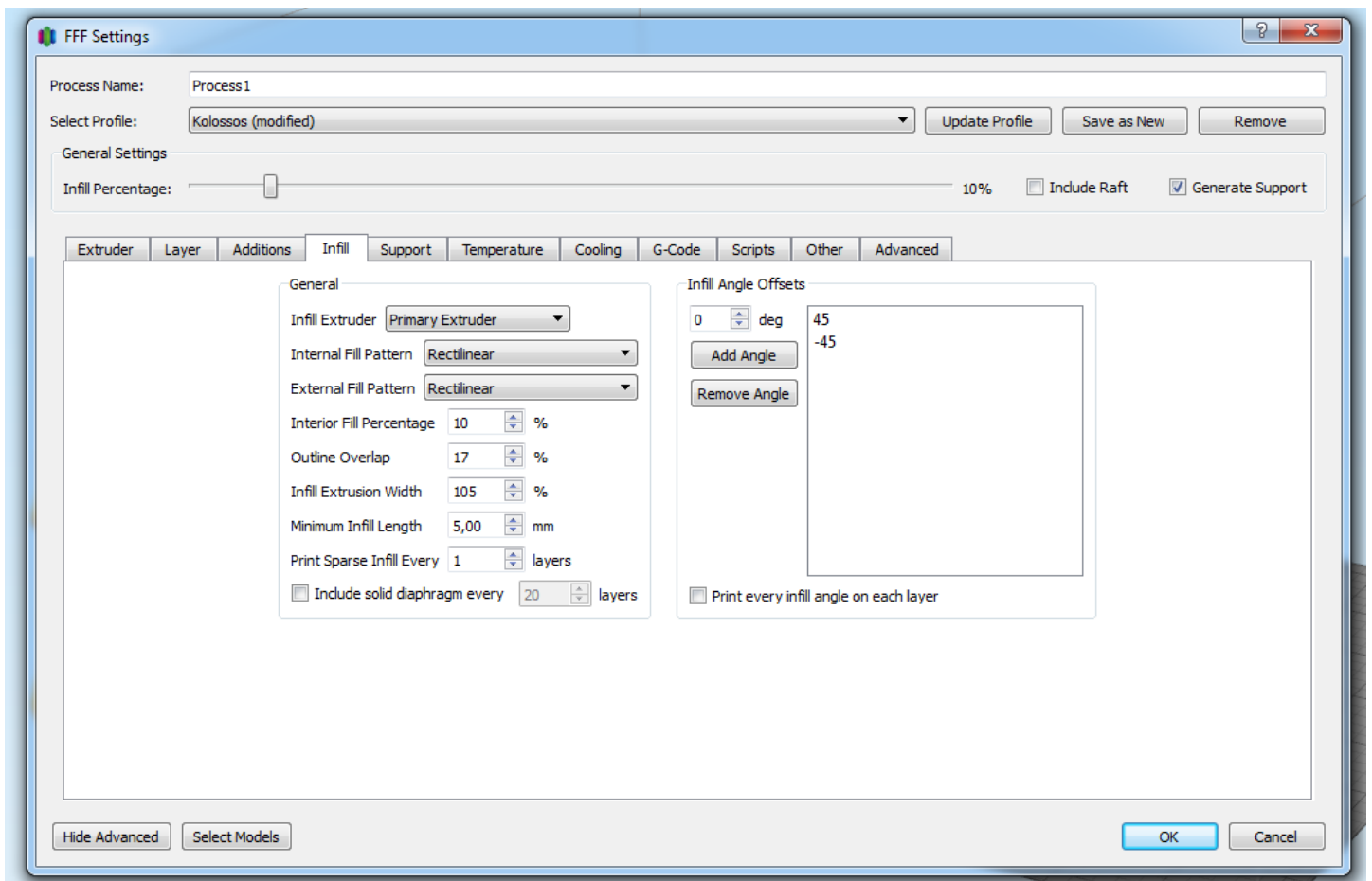
Speed Multiplier: 100 %

Hide Advanced

Select Models

OK

Cancel



FFF Settings

?

X

Process Name:

Process1

Select Profile:

Kolosos (modified)

Update Profile

Save as New

Remove

General Settings

Infill Percentage:

10%

☐ Include Raft
 ☒ Generate Support

Extruder

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Advanced

Temperature Controller List

(click item to edit settings)

Hotend

Heizbett

Add Temperature Controller

Remove Temperature Controller

Hotend 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	205

Add Setpoint

Remove Setpoint

Layer Number

1

Temperature

200

°C

Hide Advanced

Select Models

OK

Cancel

FFF Settings

?

X

Process Name:

Process1

Select Profile:

Kolosos (modified)

Update Profile

Save as New

Remove

General Settings

Infill Percentage:

10%

☐ Include Raft
 ☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Other

Advanced

Per-Layer Fan Controls

Layer	Fan Speed
1	0
2	100

Add Setpoint

Remove Setpoint

Layer Number

1

Fan Speed

60

%

Fan Options

☐ Blip fan to full power when increasing from idle

Speed Overrides

☒ Adjust printing speed for layers below

5,0

 sec

Allow speed reductions down to

95

 %

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: Kolossos (modified)Update ProfileSave as NewRemove

General Settings

Infill Percentage: 10%☐ Include Raft☒ Generate Support

ExtruderLayerAdditionsInfillSupportTemperatureCoolingG-CodeScriptsOtherAdvanced

Speeds

Default Printing Speed50,0 mm/s

Outline Underspeed80 %

Solid Infill Underspeed95 %

Support Structure Underspeed100 %

X/Y Axis Movement Speed150,0 mm/s

Z Axis Movement Speed10,0 mm/s

Dimensional Adjustments

Horizontal size compensation0,00 mm

Filament Properties

Filament diameter1,7430 mm

Filament price46,00 price/kg

Filament density1,25 grams/cm^3

Bridging

Unsupported area threshold50,0 sq mm

Extra inflation distance0,00 mm

Bridging extrusion multiplier100 %

Bridging speed multiplier100 %

Hide AdvancedSelect ModelsOKCancel