This model was tested in **Cura 2.3.1**. (Type FDM). To avoid printing problems, we recommend the following settings:

Quality

Layer Height: 0.1 mm
Initial Layer Height: 0.3 mm
Line Width: 0.4 mm
Wall Line Width: 0.4 mm
Outer Wall Line Width: 0.4 mm
Inner Wall(s) Line Width: 0.4 mm
Top/Bottom Line Width: 0.4 mm
Infill Line Width: 0.4 mm
Skirt/Brim Line Width: 0.4 mm
Support Line Width: 0.4 mm

Shell

Wall Thickness: 0.8 mm
Wall Line Count: 2
Top/Bottom Thickness: 0.8 mm
Top Thickness: 0.8 mm
Top Layers: 8
Bottom Thickness: 0.8 mm
Bottom Layers: 8
Top/Bottom Pattern: Lines
Outer Wall Inset: 0 mm
Compensate Wall Overlaps: Check
Compensate Outer Wall Overlaps: Check
Compensate Inner Wall Overlaps: Check
Horizontal Expansion: 0 mm
Z Seam Alignment: Shortest

Infill

Infill Density: 25%
Infill Line Distance: 3.2 mm
Infill Pattern: Grid
Infill Overlap Percentage: 10%
Infill Overlap: 0.04 mm
Skin Overlap Percentage: 5%
Skin Overlap: 0.02 mm
Infill Wipe Distance: 0.1 mm
Infill Layer Thickness: 0.1 mm
Gradual Infill Steps: 0
Infill Before Walls: Check

Material

Enable Retraction: Check
Retraction Extra Prime Amount: 0 mm3
Retraction Minimum Travel: 0.8 mm
Maximum Retraction Count: 90

Minimum Extrusion Distance Window: 6.5 mm
Standby Temperature: 175°C
Nozzle Switch Retraction Distance: 16 mm
Nozzle Switch Retraction Speed: 20 mm/s
Nozzle Switch Retract Speed: 20 mm/s
Nozzle Switch Prime Speed: 20 mm/s

Speed

Print Speed: 60 mm/s
Infill Speed: 80 mm/s
Wall Speed: 30 mm/s
Outer Wall Speed: 30 mm/s
Inner Wall Speed: 60 mm/s
Top/Bottom Speed 15 mm/s
Support Speed: 60 mm/s
Support Infill Speed: 60 mm/s
Travel Speed: 120 mm/s
Initial Layer Speed: 15 mm/s
Initial Layer Print Speed: 15 mm/s
Initial Layer Travel Speed: 30 mm/s
Skirt/Brim Speed 15 mm/s
Maximum Z Speed: 0 mm/s

Travel

Combing Mode: All
Avoid Printed Parts when Traveling: Check
Travel Avoid Distance: 0.625 mm

Cooling

Enable Print Cooling: Check
Fan Speed: 100%
Regular Fan Speed: 100%
Maximum Fan Speed: 100%
Regular/Maximum Fan Speed Threshold: 10 s
Regular Fan Speed at Height: 0.3 mm
Regular Fan Speed at Layer: 2
Minimum Layer Time: 5 s
Minimum Speed: 10 mm/s

Support

Enable Support: Check
Support Placement: Everywhere
Support Overhang Angle: 50°
Support Pattern: Zig Zag
Connect Support ZigZags: Check
Support Density: 30 %
Support Line Distance: 1.3333 mm
Support Z Distance: 0.1 mm
Support Top Distance: 0.1 mm

Support Bottom Distance: 0.1 mm
Support X/Y Distance: 0.7 mm
Support Distance Priority: Z overrides X/Y
Minimum Support X/Y Distance: 0.2 mm
Support Stair Step Height: 0.3 mm
Support Join Distance: 2.0 mm
Support Horizontal Expansion: 0.2 mm
Use Towers: Check
Tower Diameter: 3.0 mm
Minimum Diameter: 3.0 mm
Tower Roof Angle: 65°

Build Plate Adhesion

Build Plate Adhesion Type: Brim
Skirt/Brim Minimum Length: 250 mm
Brim Width: 8.0 mm
Brim Line Count: 20
Brim Only on Outside: Check

Mesh Fixes

Union Overlapping Volumes: Check

Special Modes

Print Sequence: All at Once
Surface Mode: Normal

Experimental

Extra Skin Wall Count: 0

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