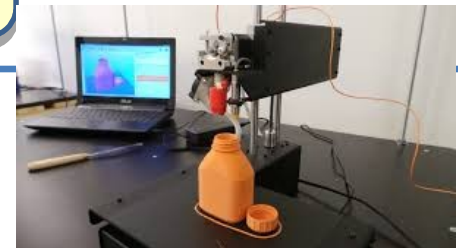
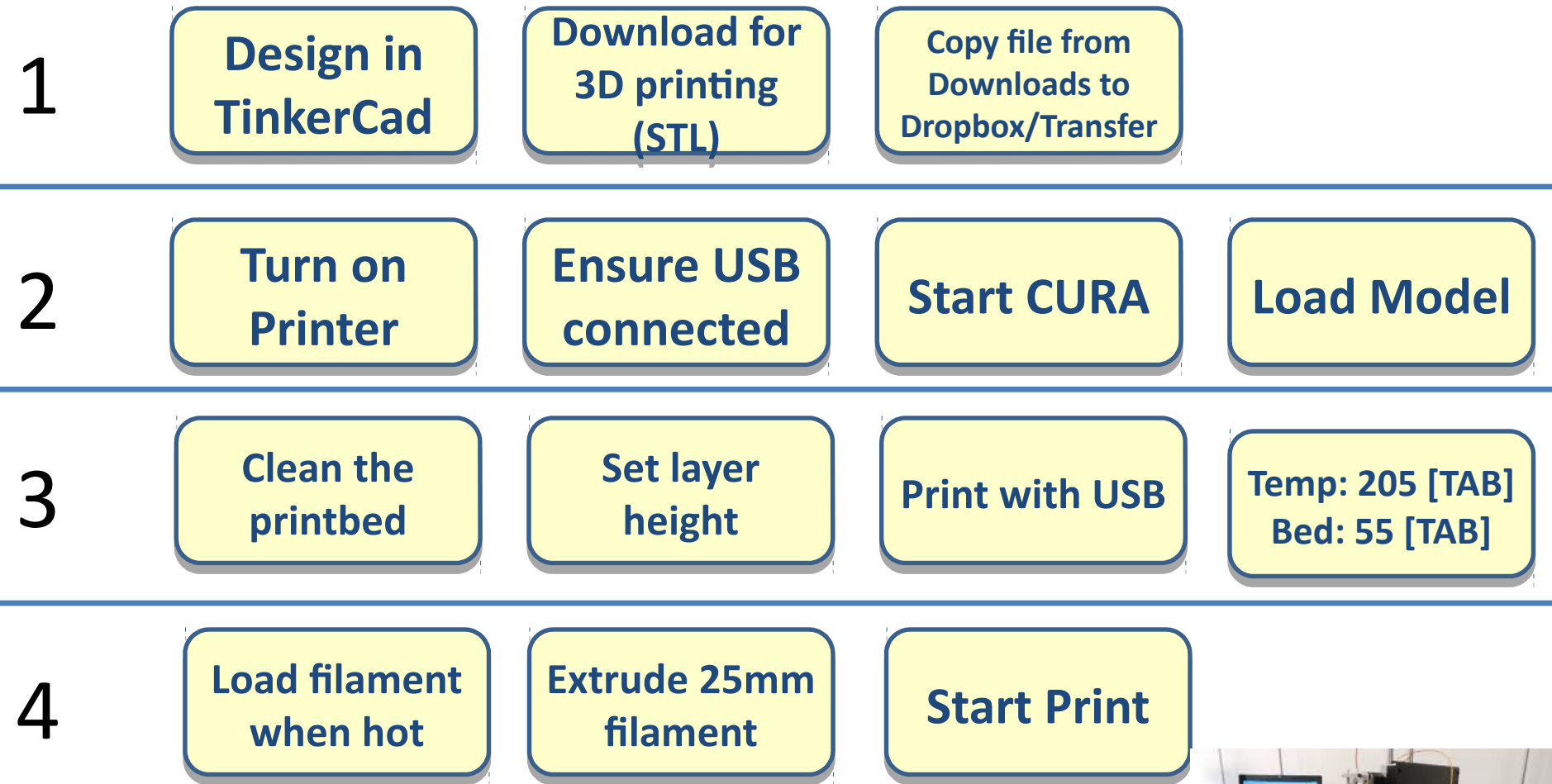


3D Printing Workflow



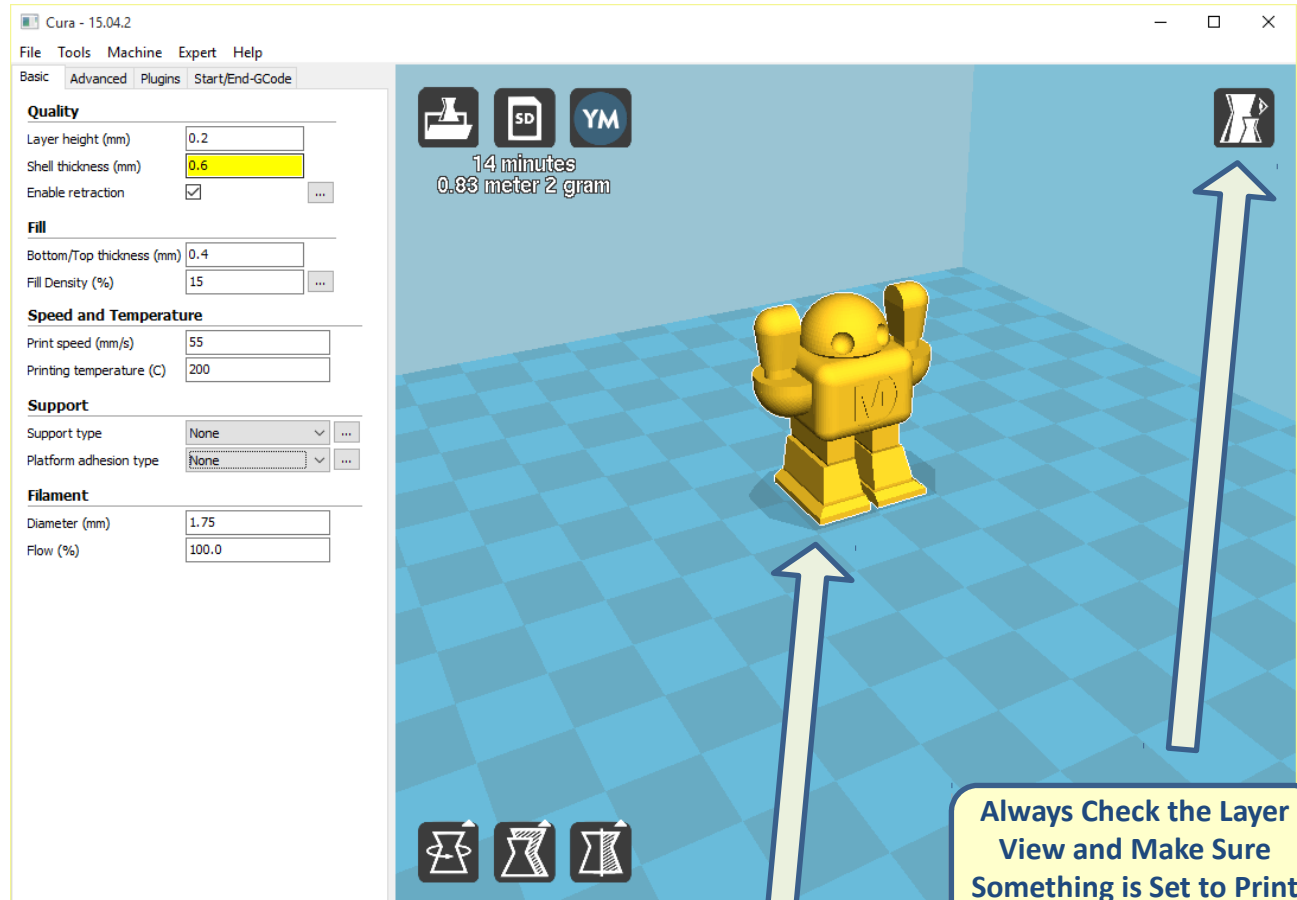
Layer Height:
Low res: 0.3mm
Med res: 0.2mm
High res: 0.1mm

**Shell Thickness &
Top/Bottom Thickness:**
0.4-0.6mm

Fill Density:
Low: 10-15%
Med: 20-30%
High: 35-50%

Print Speed:
Slow: 50
Fast: 60

Temp:
Hotend: 205
Bed: 55



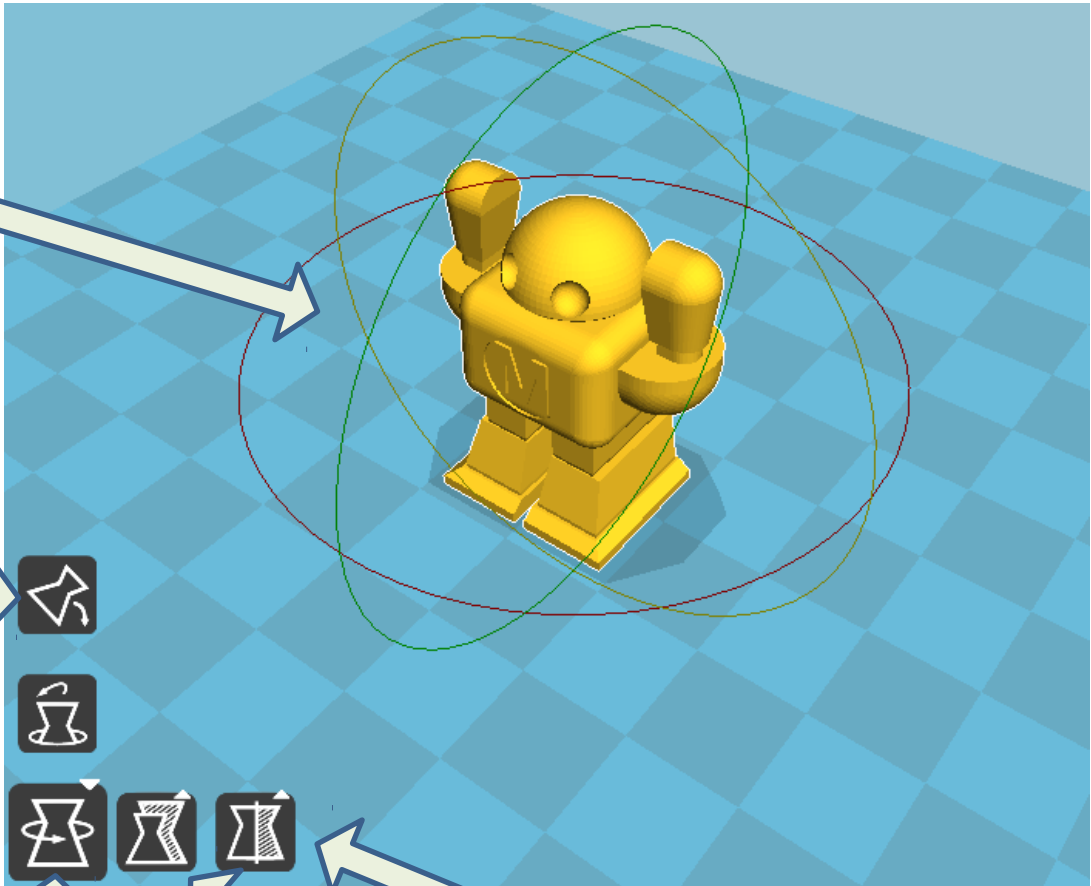
If your model is not
Yellow, it will not print.
It's probably too big!

Always Check the Layer
View and Make Sure
Something is Set to Print
on Layer 1

Cura Modifications

Right Click in Model:
Center on platform
Delete Object
Multiply Object
Split Object into Parts

Lay Flat on Build plate



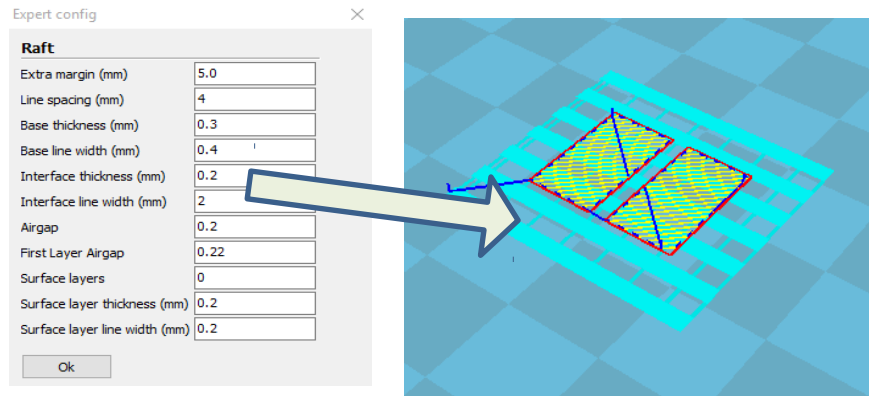
ROTATE

SCALE

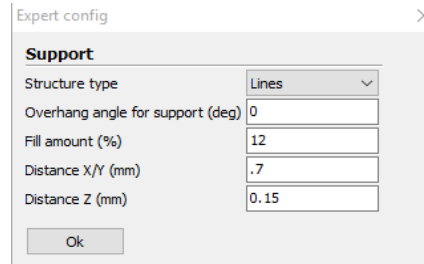
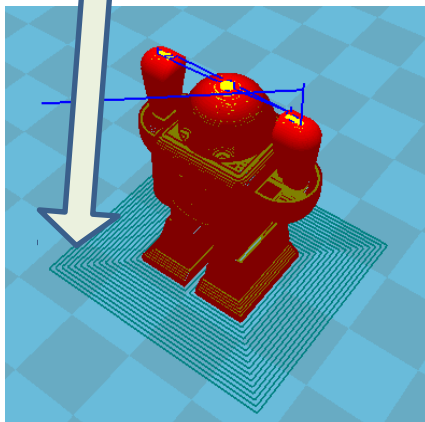
MIRROR

Platform Adhesion & Support

RAFT: Places layers underneath object



BRIM: Adds lines around object to improve stick area



Overhang angle determines what gets support build underneath

Experiment with Touching Buildplate or Everywhere....look at Layer View

