

Настройка программы Simplify3D для работы на 3д-принтере ZENIT

Приступим к настройке Simplify3D. Откройте программу и в левом верхнем окне параметров выберите клавишу «Import».Импортируйте объект для печати. (см. рис.1) далее нажмите клавишу настройки слайсера (см.рис.2)



Рис.1





В появившемся окне нажмите клавишу «расширенные настройки» (см. рис.3).

🚺 FFF Settings			? ×
Process Name:	Process1		
Select Profile:	new profile (modified)	•	Update Profile Save as New Remove
-Auto-Configu	re for Material	-Auto-Config	gure for Print Quality
PLA	- • •	Fast	- • •
-General Settir	ngs		
Infil Percenta	ige:	15%	🔲 Include Raft 🛛 🔲 Generate Support
Show Advanc	red Select Models		OK Cancel

Рис.3

Extruder Layer Add	litions Infill Suppo	ort Temperature	Cooling G-Code	Scripts	Other	Advanced
Extruder List (click item to edit settings) Primary Extruder	Overview Extruder Toolhead Nozzle Diameter Extrusion Multiplier Extrusion Width	Index Tool 0 0,40 mm 0,90 Manual 0	ead ▼ ,48 ♀ mm			
	Ooze Control	Ooze Control Image: Retraction Retraction Distance Extra Restart Distance 0,00 mm				
Add Extruder	Coast at End	Retraction Speed Coasting Distance	1800,0 🜩 mm/ 0,20 🜩 mm	'nin		
Remove Extruder	Wipe Nozzle	Wipe Distance	5,00 🚖 mm			

Рис. 4

Устанавливаем диаметр сопла (см. рис. 4)

Extruder Layer Addition	ns Infill Suppo	ort Temperature (Cooling G	-Code Scrip	ts Other	Advanced				
Extruder List (dick item to edit settings)	Primary Ex	truder Toolhe	ad							
Primary Extruder	druder									
	Extruder Toolhead Index Tool 0									
	Nozzle Diameter 0,40 🚔 mm									
	Extrusion Multiplier	0,90 🚖								
	Extrusion Width 🔘 Auto 💿 Manual 0,48 🚖 mm									
	Ooze Control									
	Retraction	Retraction Distance	1,00	mm						
		Extra Restart Distance	0,00	mm						
		Retraction Vertical Lift	0,00	🗧 mm						
		Retraction Speed	1800,0	nm/min						
Add Extruder	Coast at End	Coasting Distance	0,20	🗧 mm						
	Vipe Nozzle Wipe Distance 5,00 🗭 mm									

Рис.5

Устанавливаем множитель экструзии (0.90 норма) (см. рис. 5)

В случае если образуются пустоты при печати, это значение можно увеличить.

xtruder	Layer	Additions	Infill Sup	port Temperature	Cooling G-	Code Script	s Other	Advance	
Ext (click item	truder List to edit set	_{tings)} P	Primary E	xtruder Toolhe	ead				
Primary E	Extruder		Overview						
	Extruder Toolhead Index Tool 0								
			Nozzle Diameter	0,40 🚔 mm					
			Extrusion Multinli	er 0.90 🔺					
		 	Extrusion Width	O Auto O Manual O	,48 🚖 mm	>			
						-			
			Ooze Control						
			Retraction	Retraction Distance	1,00	mm			
				Extra Restart Distance	0,00	mm			
				Retraction Vertical Lift	0,00	mm			
				Retraction Speed	1800,0	mm/min			
Add	d Extruder		🔽 Coast at End	Coasting Distance	0,20	mm			
			Wine Nezzle	Wine Distance	E 00				

Рис. б

Ширина экструзии может рассчитаться автоматически или устанавливается вручную (желательно устанавливать автоматически).

Extruder Layer Additio	ns Infill Suppo	ort Temperature	Cooling	G-Code	Scripts	Other	Advanced
Extruder List (click item to edit settings)	Primary Ex	truder Toolh	ead				
Primary Extruder	Overview Extruder Toolhead Index Nozzle Diameter 0,40 mm Extrusion Multiplier 0,90 Extrusion Width Auto Manual 0,48 mm						
	✓ Retraction	Retraction Distance Extra Restart Distanc Retraction Vertical Lift Retraction Speed	1,00 0,00 0,00 1800,0	mm mm mm mm	nin		
Add Extruder	🔽 Coast at End	Coasting Distance	0,20	🚖 mm			
Remove Extruder	📝 Wipe Nozzle	Wipe Distance	5,00	🖶 mm	<u>ر</u>		

Рис. 7

Ретракт желательно установить с такими значениями (см. рис. 7)

Поставьте галочку "retraction"

- 1. Расстояние ретракта 1.00 mm. (отвод пластика на 1мм)
- 2. Экстра расстояние ретракта 0.00 mm. (отвод пластика на Омм)
- 3. Опускание стола (если есть опасение задеть напечатанные объекты) на 0.00 mm.
- 4. Скорость ретракта 1800.0 mm/min
- 5. Расстояние выбега 0,20 mm.
- 6. Расстояние чистки сопла 5,00 mm.

Extruder	Layer	Additions	Infill	Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced
Layer Setti Primary Ex Primary La	ngs truder P yer Height	rimary Extrud	er	m	Fir Fir Fir	st Layer Setti st Layer Heig st Layer Widt st Layer Spee	ngs ht 90 🖨 h 100 🖨	% % %		
Top Solid L Bottom Sol Outline/Pe Outline Dir Print is Single o	ayers id Layers rimeter Sh ection: @ lands sequ putline cor	3 3 ells 4) Inside-Out uentially witho kscrew printir	Out: out optimiz ng mode (] side-In zation vase mode)	Stz © ©	art Points Use random Optimize sta Choose star X: 0,0	start points art points for t point close	for all perir fastest pri st to specif	neters nting speed ic location mm	1

Рис. 8

Открываем закладку «слои»

Устанавливаем высоту первого слоя (см. рис. 8)

Extruder Layer Additions Infill Support T	emperature	Cooling	G-Code	Scripts	Other	Advanced			
Layer Settings	Firs	t Layer Setti	ngs						
Primary Extruder	Firs	st Layer Heig	ht 90 🍦	%					
Primary Layer Height 0,3000 👚 mm	Firs	First Layer Width 100 💌 %							
Top Solid Layers 3	Firs	st Layer Spee	ed 50 🕀	%					
Bottom Solid Layers 3	Sta	rt Points							
Outline/Perimeter Shells 4	0	\bigcirc Use random start points for all perimeters							
Outline Direction: 💿 Inside-Out 💿 Outside-In	0	Optimize start points for fastest printing speed							
 Print islands sequentially without optimization Single outline corkscrew printing mode (vase mode) 	۲	Choose star X: 0,0	t point close	st to specifi	ìc location mm				

Рис. 9

Кол-во верхних плотных слоев (см. рис.9)

Оптимально 3

Auto-Configure for Mate	erial				Auto	-Configure f	or Print Qua	lity		
PLA General Settings					Fas	t				• • •
Infill Percentage:						15%	6 📃 In	clude Raft	C Ge	enerate Support
Extruder Layer	Additions	Infill	Support	Temper	ature	Cooling	G-Code	Scripts	Other	Advanced
Layer Settings Primary Extruder	Primary Extrud	er mi	•		Firs Firs Firs	t Layer Setti st Layer Heig st Layer Widt st Layer Spee	ngs ht 90 🖨 h 100 🖨 ed 50 🖨	% % %		
Bottom Solid Layers Outline/Perimeter S Outline Direction: (Print islands see Single outline co	3 hells 4 Inside-Out juentially witho	Outs Outs out optimiz ng mode ("	side-In zation vase mode)		Sta	rt Points Use random Optimize star Choose star X: 0,0	start points art points for t point close Y: 30	for all perin fastest printer to specifi 00,0	neters nting speed ic location mm	1

Рис. 10

Кол-во нижних плотных слоев (см. рис.10)

Оптимально 3

xtruder Layer Additions Infill Support Te	perature Cooling G-Code Scripts Other Advance
Layer Settings	First Layer Settings
Primary Extruder	First Layer Height 90 🚔 %
Primary Laver Height 0,3000	First Layer Width 100 🌻 %
	First Layer Speed 50 🚔 %
Top Solid Layers 3	
Bottom Solid Layers 3	Start Points
Outline/Perimeter Shells	Use random start points for all perimeters
Outline Direction: 🔘 Inside-Out 🔘 Outside-In	Optimize start points for fastest printing speed
Print islands sequentially without optimization	Choose start point closest to specific location
Single outline corkscrew printing mode (vase mode)	X: 0,0 🚔 Y: 300,0 🚔 mm

Рис.11

Percentage:	15% 🔲 Include Raft 🕅 Generate Sup
xtruder Layer Additions Infill Support Temp	perature Cooling G-Code Scripts Other Advance
Layer Settings	First Layer Settings
Primary Extruder Primary Extruder 🔻	First Layer Height 90 🚔 %
Primary Layer Height 0,3000 🔭 mm	First Layer Width 100 🔦 %
Top Solid Layers 3 Bottom Solid Layers 3	Start Points
Outline/Perimeter Shells 4	Use random start points for all perimeters
Outline Direction: Inside-Out Outside-In Print islands sequentially without optimization Single outline corkscrew printing mode (vase mode)	 Optimize start points for fastest printing speed Choose start point closest to specific location X: 0,0 Y: 300,0 mm

Линии периметра — оптимально 4

Рис. 12

Порядок заполнения контуров (см. рис. 12)

Из внутреннего в наружный и наоборот.

General Settings						
	15% 🔲 Include Raft 📄 Generate Support					
Extruder Layer Additions Infill Support Temp	erature Cooling G-Code Scripts Other Advanced					
Layer Settings Primary Extruder	First Layer Settings First Layer Height 90 🔮 %					
Primary Layer Height 0,3000 👘 mm	First Layer Width100%First Layer Speed50%					
Top Solid Layers 3 👻 Bottom Solid Layers 3 👻 Outline /Perimeter Shells 4	Start Points Use random start points for all perimeters 					
Outline Direction: Inside-Out Outside-In Print islands sequentially without ontimization	 Optimize start points for fastest printing speed Choose start point closest to specific location 					
Single outline corkscrew printing mode (vase mode)	x: 0,0 v T: 300,0 v mm					

Рис.13

Печать объекта методом спирали (ваза)

Process Name: Process1	
Select Profile: new profile (modified)	Update Profile Save as New Remove
Auto-Configure for Material	Auto-Configure for Print Quality
General Settings Infill Percentage:	15% 🔲 Include Raft 📄 Generate Support
Extruder Layer Additions Infill Support Temp Layer Settings Primary Extruder Primary Extruder Primary Layer Height 0,3000 mm	erature Cooling G-Code Scripts Other Advanced
Top Solid Layers 3 Bottom Solid Layers 3 Outline/Perimeter Shells 4 Outline Direction: Inside-Out Outside-In Print islands sequentially without optimization Single outline corkscrew printing mode (vase mode)	First Layer Speed 50 9% Start Points Item to be address of the start points for all perimeters Optimize start points for fastest printing speed Image: Choose start point dosest to specific location X: 0,0 Y: 300,0 mm

Рис. 14

Настройка первого слоя.

Высота в процентном соотношении (см. рис. 14)

General Settings							
Infill Percentage:	15% 🔲 Include Raft 📄 Generate Support						
Estudes I zuer Additions I tofil Connect Terror							
Additions Innii Support Temp	erature Cooling G-Code Scripts Other Advanced						
Layer Settings	First Layer Settings						
Primary Extruder	First Layer Height 90 🚔 %						
Primary Layer Height 0,3000 🚔 mm	First Layer Width 100 >> %						
Top Solid Layers 3							
Bottom Solid Layers 3	Start Points						
Outline/Perimeter Shells 4	O Use random start points for all perimeters						
Outline Direction: () Inside-Out () Outside-In	Optimize start points for fastest printing speed						
Print islands sequentially without optimization	Choose start point closest to specific location						
Single outline corkscrew printing mode (vase mode)	X: 0,0 文 Y: 300,0 🗭 mm						

Рис. 15

Ширина первого слоя (см. рис. 15).

ctruder Layer Additions Infill Support ler	iperature Cooling G-Code Scripts Other Advanced					
Layer Settings	First Layer Settings					
Primary Extruder	First Layer Height 90 🚔 %					
Primary Laver Height 0.3000 🚖 mm	First Layer Width 100 👻 %					
	First Layer Speed 50 📄 %					
Top Solid Layers 3						
Bottom Solid Layers 3	Start Points					
Outline/Perimeter Shells 4	\bigcirc Use random start points for all perimeters					
Outline Direction; 🔘 Inside-Out 🔘 Outside-In	Optimize start points for fastest printing speed					
Dript islands assumptially without optimization	 Choose start point closest to specific location 					
Print islands sequentially without optimization	Choose start point dosest to specific location					

Рис. 16

Скорость первого слоя.

General Settings	
Infill Percentage:	15% 🔲 Indude Raft 📄 Generate Support
Extruder Layer Additions Infill Support	Temperature Cooling G-Code Scripts Other Advanced
Layer Settings	First Layer Settings
Primary Extruder Primary Extruder	First Layer Height 90 🚔 %
Primary Layer Height 0,3000 👘 mm	First Layer Width 100 🐳 %
Top Solid Layers 3	
Bottom Solid Layers 3	Start Points
Outline/Perimeter Shells 4	 Use random start points for all perimeters
Outline Direction: () Inside-Out () Outside-In	Optimize start points for fastest printing speed
Print islands sequentially without optimization	Choose start point closest to specific location
Single outline corkscrew printing mode (vase mode)	X: 0,0 🗘 Y: 300,0 🗘 mm

Рис. 17

Начальная точка.

Использовать случайное место начальной точки.

Распределяет «узелки» на объекте в случайном порядке

General Settings							
Infill Percentage:		15%	/6 📃 In	dude Raft	G	enerate Support	
Extruder Layer Additions Infill Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced	
Layer Settings	Firs	t Layer Setti	ings				
Primary Extruder Primary Extruder	Fire	st Layer Heig	ht 90 🍦	%			
Primary Layer Height 0,3000 👘 mm	Fire	First Layer Width 100 % First Layer Speed 50 %					
Top Solid Layers 3							
Bottom Solid Layers 3	Sta	rt Points					
Outline/Perimeter Shells 4	0	O Use random start points for all perimeters					
Outline Direction: () Inside-Out () Outside-In		Optimize start points for fastest printing speed					
Print islands sequentially without optimization	۲	Choose star	rt point close	st to specif	ic location		
Single outline corkscrew printing mode (vase mode)		X: 0,0	Y: 30	0,0 ≑	mm		

Рис.18

Оптимизировать стартовые точки для скорости печати.

Немного сокращает время печати.

General Settings									
Infill Percentage:			15%	% 📃 In	dude Raft	📃 Ge	enerate Support		
Extruder Layer Additions Infill	Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced		
Layer Settings	_	Firs	t Layer Sett	ings					
Primary Extruder Primary Extruder	•	Firs	t Layer Heig	ht 90 🍦	%				
Primary Layer Height 0,3000 🚔 mm	Firs	First Layer Width 100 🔷 % First Layer Speed 50 🗣 %							
Top Solid Layers 3									
Bottom Solid Layers 3		Sta	Start Points						
Outline/Perimeter Shells 4	0	$\bigcirc \ $ Use random start points for all perimeters							
Outline Direction: 💿 Inside-Out 💿 Outsid	0	Optimize start points for fastest printing speed							
Print islands sequentially without optimizat	۲	Choose sta	rt point close	st to specif	ic location				
Single outline corkscrew printing mode (va	se mode)		X: 0,0	🔶 Y: 30	0,0 🚖	mm			

Рис. 19

Выбрать начальную точку по координатам. Задаем конкретное место для «узелка».

(Настройка для опытных пользователей)

General Settings		
Infill Percentage:		15% 🗹 Include Raft 📄 Generate Support
Extruder Layer Additions	Infill Support Temp	perature Cooling G-Code Scripts Other Advanced
🖉 Use Skirt/Brim —		Vuse Prime Pillar
Skirt Extruder	Primary Extruder 🔹	Prime Pillar Extruder All Extruders
Skirt Layers	1	Pillar Width 12,00 💭 mm
Skirt Offset from Part	4,00 🚔 mm	Pillar Location North-West
Skirt Outlines	2	Speed Multiplier 100 👻 %
📝 Use Raft		☑ Use Ooze Shield
Raft Extruder	Primary Extruder 🔹	Ooze Shield Extruder All Extruders
Raft Layers	3	Offset from Part 2,00 👘 mm
Raft Offset from Part	3,00 🚔 mm	Ooze Shield Outlines 1
Separation Distance	0,14 🚔 mm	Sidewall Shape Waterfall 💌
Raft Infil	85 🚔 %	Sidewall Angle Change 30 🛓 deg
Disable raft base la	ayers	Speed Multiplier 100 💭 %

Рис. 20

Дополнительные функции.

Использование «юбки» подготавливает экструдер для печати, в некоторых случаях улучшает адгезию.

General Setti	ings							
infill Percent	age:			15%	🔽 In	dude Raft	🔲 Ger	erate Support
E 1 1	Additions				0.0.1	a	Other	
Extruder	Layer Additions	Infill Support	Temperati		G-Code	Scripts	Other	Advanced
	🔽 Use Skirt/Brim			📝 Use Prime Pillar				
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extrud	er 🛛 All Ext	ruders	•]
	Skirt Layers	1		Pillar Width	12,00	≑ mm		
	Skirt Offset from Part	4,00 🚖 mm		Pillar Location	North	West	•]
	Skirt Outlines	2		Speed Multiplier	100	\$ %		
	V Use Raft			V Use Ooze Shiel	d			
	Raft Extruder	Primary Extruder	•	Ooze Shield Extru	der 🛛 All E	xtruders	•]
	Raft Layers	3		Offset from Part	2,0	0 🌻 mm		
	Raft Offset from Part	3,00 🜩 mm		Ooze Shield Outlin	es 1	* *		
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Wat	terfall	•]
	Raft Infill	85 🌲 %		Sidewall Angle Cha	ange 30	🗧 deg		
	Disable raft base la	ayers		Speed Multiplier	100	\$ %		



Слой «юбки»

General Setti Infill Percent	age:			15%	, 🔽 In	dude Raft	C Ge	nerate Suppo
Extruder	Layer Additions	Infill Support	Temperatur	e Cooling	G-Code	Scripts	Other	Advanced
	🔽 Use Skirt/Brim			🔽 Use Prime Pilla	r			
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extru	der All Ext	ruders		·
	Skirt Layers	1		Pillar Width	12,00	🚖 mm		
C	Skirt Offset from Part	4,00 🚔 mm		Pillar Location	North	West	•	·
	Skirt Outlines	2		Speed Multiplier	100	÷ %		
	🔽 Use Raft			🔽 Use Ooze Shie	eld			
	Raft Extruder	Primary Extruder	•	Ooze Shield Extru	uder All E	xtruders	•	·
	Raft Layers	3		Offset from Part	2,00) 🌻 mm		
	Raft Offset from Part	3,00 🚔 mm		Ooze Shield Outli	nes 1	* *		
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Wat	terfall	•	·
	Raft Infill	85 🚔 %		Sidewall Angle Ch	nange 30	🗧 deg		
	Disable raft base la	ivers		Speed Multiplier	100	<u>^</u> %		

Рис. 22

Расстояние от объекта до «юбки».

Если «юбка» применяется в целях повышения адгезии, то ставим 0,00.

General Settin	as							
Infill Percenta	ge:			15%	🔽 Ind	dude Raft	🔲 Gen	erate Support
Extruder	Layer Additions	Infill Support	Temperati	ure Cooling	G-Code	Scripts	Other	Advanced
ا	Use Skirt/Brim			Vise Prime Pillar				
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extrude	er All Extr	uders	•	
	Skirt Layers	1		Pillar Width	12,00	🚖 mm		
	Skirt Offset from Part	4.00		Pillar Location	North-	West	•	
<	Skirt Outlines	2		Speed Multiplier	100	\$ %		
	Ruiss Deft							
ſ	Use Raft			Use Ooze Shield				
	Raft Extruder	Primary Extruder	•	Ooze Shield Extrud	der 🛛 All E	xtruders	•	
	Raft Layers	3 🌩		Offset from Part	2,00	🚖 mm		
	Raft Offset from Part	3,00 🚔 mm		Ooze Shield Outline	es 1	*		
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Wat	erfall	•	
	Raft Infill	85 🚔 %		Sidewall Angle Cha	inge 30	≑ deg		
	Disable raft base la	iyers		Speed Multiplier	100	\$ %		

Рис. 23

Кол-во витков в «юбке»

General Settin	ngs		
Infill Percenta	age:		15% 🗹 Include Raft 📄 Generate Support
Extruder	Layer Additions	Infill Support Tempera	ature Cooling G-Code Scripts Other Advanced
ſ	Use Skirt/Brim		Use Prime Pillar
	Skirt Extruder	Primary Extruder 🔹	Prime Pillar Extruder All Extruders
	Skirt Layers	1	Pillar Width 12,00 🛉 mm
	Skirt Offset from Part	4,00 🚔 mm	Pillar Location North-West
	Skirt Outlines	2	Speed Multiplier 100 🔺 %
6	🔽 Use Raft		Vuse Ooze Shield
	Raft Extruder	Primary Extruder 🔹	Ooze Shield Extruder All Extruders
	Raft Layers	3	Offset from Part 2,00 🚔 mm
	Raft Offset from Part	3,00 🚔 mm	Ooze Shield Outlines 1
	Separation Distance	0,14 🚔 mm	Sidewall Shape Waterfall
	Raft Infill	85 🚔 %	Sidewall Angle Change 30 🚔 deg
	Disable raft base la	ayers	Speed Multiplier 100 🌻 %
- · · ·			

Рис. 24

Коврик или прокладка между столом и объектом.

Для улучшения адгезии.

xtruder	Layer Additions	Infill Support	Temperat	ure Coolir	ng G-C	ode So	cripts	Other	Advance
	Use Skirt/Brim			Use Prim	e Pillar				
	Skirt Extruder	Primary Extruder	-	Prime Pillar I	Extruder (All Extrude	rs	•	
	Skirt Layers	1		Pillar Width	[12,00 🚖	mm		
	Skirt Offset from Part	4,00 🚔 mm		Pillar Locatio	n (North-Wes	t	•	
	Skirt Outlines	2		Speed Multi	plier	100 🌲	%		
	🔽 Use Raft			🔽 Use Ooz	e Shield				
	Raft Extruder	Primary Extruder	•	Ooze Shield	Extruder	All Extru	iders	•]
<	Raft Layers	3		Offset from	Part	2,00	🗧 mm		
	Raft Offset from Part	3,00 🚖 mm		Ooze Shield	Outlines	1	•		
	Separation Distance	0,14 テ mm		Sidewall Sha	ape	Waterfa	ill	•	
	Raft Infill	85 🌻 %		Sidewall Ang	gle Change	e 30 🚦	🗧 deg		
	Disable raft base la	ivers		Speed Multi	olier	100	%		

Рис. 25

Кол-во слоев в прокладке.

General Settings				
Infill Percentage:		15%	🗸 Indude Raft	Generate Support
Extruder Layer Additions Infi	I Support Temperature	Cooling G-Co	de Scripts	Other Advanced
Use Skirt/Brim		Use Prime Pillar		
Skirt Extruder Primar	y Extruder	rime Pillar Extruder	II Extruders	-
Skirt Layers 1	Pi	illar Width 1	2,00 🚔 mm	
Skirt Offset from Part 4,00	🔿 mm Pi	illar Location	lorth-West	-
Skirt Outlines 2	Ş. Sp	peed Multiplier 1	.00 🚔 %	
Use Raft		Use Ooze Shield		
Raft Extruder Primar	y Extruder 🔻 O	oze Shield Extruder	All Extruders	•
Raft Layers 3	• o)ffset from Part	2,00 🚔 mm	
Raft Offset from Part 3,00	🔰 mm 🛛 O	oze Shield Outlines	1	
Separation Distance 0,14	🖈 mm Si	idewall Shape	Waterfall	-
Raft Infill 85	🔹 % Si	idewall Angle Change	30 🚖 deg	
Disable raft base layers	Sf	peed Multiplier	100 🚔 %	

Рис. 26

Выступ края прокладки по периметру.

eneral Settir	ngs nge:			15%	6 🔽 In	dude Raft	C Ger	nerate Suppor
Extruder	Layer Additions	Infill Support	Temperat	ure Cooling	G-Code	Scripts	Other	Advanced
	🔽 Use Skirt/Brim			🔽 Use Prime Pilla	ar			
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extru	der All Ext	ruders	•	
	Skirt Layers	1		Pillar Width	12,00	≑ mm		
	Skirt Offset from Part	4,00		Pillar Location	North-	West	•	
	Skirt Outlines	2		Speed Multiplier	100	\$ %		
	🗸 Use Raft			🔽 Use Ooze Shi	eld			
	Raft Extruder	Primary Extruder	•	Ooze Shield Extr	uder All E	xtruders	•	
	Raft Layers	3		Offset from Part	2,00) 🌲 mm		
	Raft Offset from Part	3,00 ≑ mm		Ooze Shield Outl	ines 1	* *		
<	Separation Distance	0,14 📄 mm		Sidewall Shape	Wat	erfall	•	
	Raft Infill	85 🚖 %		Sidewall Angle C	hange 30	🗧 deg		
	🔲 Disable raft base la	iyers		Speed Multiplier	100	\$ %		

Рис. 27

Разделительная дистанция (один слой)

General Settings			
Infill Percentage:		15% 🔽 Include Raft 🔲 Generate Sup	port
Extruder Layer Additions	Infill Support Tempe	erature Cooling G-Code Scripts Other Advance	d
Use Skirt/Brim		Vse Prime Pillar	
Skirt Extruder	Primary Extruder 🔹	Prime Pillar Extruder All Extruders	
Skirt Layers	1	Pillar Width 12,00 🗭 mm	
Skirt Offset from Part	4,00 🚔 mm	Pillar Location North-West	
Skirt Outlines	2	Speed Multiplier 100 🔦 %	
📝 Use Raft		☑ Use Ooze Shield	
Raft Extruder	Primary Extruder 🔹	Ooze Shield Extruder All Extruders	
Raft Layers	3	Offset from Part 2,00 👘 mm	
Raft Offset from Part	3,00 🚔 mm	Ooze Shield Outlines 1	
Separation Distance	0,14 🚔 mm	Sidewall Shape Waterfall	
Raft Infill	85 🚔 %	Sidewall Angle Change 30 🛓 deg	
Disable raft base	ayers	Speed Multiplier 100 🔷 %	



Плотность прокладки.

Extrudor	Laver Additions	Infil Support	Temperat	ura Cooling C	Code Scripta	Other Advance
LXUUUEI		Innii Support	Temperau	V I lee Prime Pillar -		
	Se Ski (Drin			Se Frine Fild		
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extruder	All Extruders	•
	Skirt Layers	1		Pillar Width	12,00 🖨 mm	
	Skirt Offset from Part	4,00 🖨 mm		Pillar Location	North-West	•
	Skirt Outlines	2		Speed Multiplier	100 🚔 %	
	🔽 Use Raft			🔽 Use Ooze Shield		
	Raft Extruder	Primary Extruder	•	Ooze Shield Extrude	All Extruders	•
	Raft Layers	3		Offset from Part	2,00 🚔 mm	
	Raft Offset from Part	3,00 🚔 mm		Ooze Shield Outlines	1	
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Waterfall	•
	Raft Infill	85 🚔 %		Sidewall Angle Chan	ge 30 🗦 deg	
- C	Disable raft base la	ayers		Speed Multiplier	100 🚔 %	

Рис. 29



Базовые три слоя не имеющие настроек, печатаются по умолчанию.

ill Percent	age:			15%	V Include Raft	Generate Support
Extruder	Layer Additions	Infill Support	Temperat	ure Cooling G-C	ode Scripts	Other Advanced
	🔽 Use Skirt/Brim		(📝 Use Prime Pillar —		
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extruder	All Extruders	•
	Skirt Layers	1		Pillar Width	12,00 🚔 mm	
	Skirt Offset from Part	4,00 🚖 mm		Pillar Location	North-West	•
	Skirt Outlines	2		Speed Multiplier	100 🚔 %	
	🔽 Use Raft			🔽 Use Ooze Shield —		
	Raft Extruder	Primary Extruder	-	Ooze Shield Extruder	All Extruders	•
	Raft Layers	3		Offset from Part	2,00 🖨 mm	
	Raft Offset from Part	3,00 🚔 mm		Ooze Shield Outlines	1	
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Waterfall	•
	Raft Infill	85 🌻 %		Sidewall Angle Change	30 🚖 deg	
	📃 Disable raft base la	ayers		Speed Multiplier	100 🗘 %	

Рис. 30

Столбик очистки сопла.

Применяется в основном при использовании двух и более экструдеров, в целях сбора вытекающего пластика.

neral Setti	ings					
fill Percent	age:			15%	📝 Include Raft	Generate Suppo
Extruder	Layer Additions	Infill Support	Temperati	ire Cooling G	G-Code Scripts	Other Advanced
	🔽 Use Skirt/Brim			🔽 Use Prime Pillar –		
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extruder	All Extruders	•
	Skirt Layers	1	<	Pillar Width	12,00 🚔 mm	
	Skirt Offset from Part	4,00 🖨 mm		Pillar Location	North-West	•
	Skirt Outlines	2		Speed Multiplier	100 ≑ %	
	🔽 Use Raft			👿 Use Ooze Shield		
	Raft Extruder	Primary Extruder	•	Ooze Shield Extrude	All Extruders	-
	Raft Layers	3		Offset from Part	2,00 🚔 mm	
	Raft Offset from Part	3,00 🚔 mm		Ooze Shield Outlines	s 1 🚔	
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Waterfall	•
	Raft Infill	85 🌲 %		Sidewall Angle Chan	nge 30 🚖 deg	
	🔲 Disable raft base la	ayers		Speed Multiplier	100 🌲 %	

Рис. 31

Размерность столбика (стороны квадрата размером) по высоте равно объекту.

General Setti	ngs									
Infill Percenta	age:					15%	6 🔽 Ir	ndude Raft	🔲 Ge	nerate Support
Extruder	Laver Addition	s Infill	Support	Temper	rature	Cooling	G-Code	Scripts	Other	Advanced
Extender	Use Skirt/Brim		oupport	Temper		Use Prime Pill	ar	baipto	outer	Harancea
	Skirt Extruder	Primary Ex	truder	•	Prir	ne Pillar Extru	Ider All Ext	ruders		•
	Skirt Layers	1	* *		Pilla	ar Width	12,00	🚖 mm		
	Skirt Offset from Par	t 4,00	≑ mm		Pilla	ar Location	North	-West	•	•
	Skirt Outlines	2	* *		Spe	ed Multiplier	100	\$ %		
	🔽 Use Raft					Use Ooze Shi	eld			
	Raft Extruder	Primary Ex	truder	-	Oo	ze Shield Extr	uder All E	Extruders	•	·
	Raft Layers	3			Of	set from Part	2,0	0 🚖 mm		
	Raft Offset from Par	t 3,00 🖨	mm		Oo	ze Shield Out	ines 1	*		
	Separation Distance	0,14	mm		Sid	ewall Shape	Wa	terfall		•
	Raft Infill	85 🚖	%		Sid	ewall Angle C	hange 30	≑ deg		
	Disable raft base	layers			Spe	ed Multiplier	100	÷ %		

Рис. 32

Скорость для столбика.

General Sett							د 🗊	Include Paft	C G	enerate Sunnor
11110 Fercen	aye.					157	•	Include Runt		
Extruder	Layer Additions	Infill	Support	Temperat	ure	Cooling	G-Code	Scripts	Other	Advanced
	🔽 Use Skirt/Brim				V	lse Prime Pill	ar			
	Skirt Extruder	Primary Ex	truder	•	Prim	e Pillar Extru	ider All E	Extruders		•
	Skirt Layers	1	* *		Pilla	Width	12,	00 ≑ mm		
	Skirt Offset from Part	4,00	🗧 mm		Pilla	Location	Nor	th-West		•
	Skirt Outlines	2	* *		Spe	ed Multiplier	100	%		
	🔍 Use Raft					lse Ooze Shi	eld			
	Raft Extruder	Primary Ex	truder	•	007	e Shield Extr	uder 🗛	ll Extruders		-
	Raft Lavers	3			Offs	et from Part	· 2	.00 🚔 mm		
	Raft Offset from Part	3.00	mm		Ooz	e Shield Out	ines 1	,00 💽 1111		
	Separation Distance	0.14	mm		Side	wall Shape	V	Vaterfall		-
	Raft Infill	85	%		Side	wall Angle C	hange 3	0 🖨 dec		
	Disable raft base la	ayers	2		Spe	ed Multiplier	1	00 🔷 %	-	
					<u> </u>					

Рис. 33

Щит по периметру объекта для дополнительной защиты.

General Settings							
Infill Percentage:			15%	6 📝 In	dude Raft	🔲 Ger	nerate Support
Extruder Layer Additions	Infill Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced
💟 Use Skirt/Brim			Use Prime Pilla	ar			
Skirt Extruder	Primary Extruder	▼ Pr	ime Pillar Extru	der All Ext	ruders	•]
Skirt Layers	1	Pi	lar Width	12,00	🔹 mm		
Skirt Offset from Part	4,00 🖨 mm	Pi	lar Location	North-	West	•]
Skirt Outlines	2	Sp	eed Multiplier	100	\$ %		
Use Raft			Use Ooze Shi	eld			
Raft Extruder	Primary Extruder	- o	oze Shield Extr	uder All E	xtruders	•	1
Raft Layers	3		ffset from Part	2,00) 🌲 mm		·
Raft Offset from Part	3,00 🚔 mm	0	oze Shield Outl	ines 1	* *		
Separation Distance	0,14 🚔 mm	Si	dewall Shape	Wat	erfall	•]
Raft Infill	85 🌻 %	Si	dewall Angle Cl	hange 30	≑ deg		
Disable raft base la	iyers	Sp	eed Multiplier	100	\$ %		

Рис. 34

Расстояние от щита до объекта.

General Settings							
Infill Percentage:			15%	📝 In	clude Raft	🔲 Ger	erate Support
Extruder Layer Additions	Infill Support	Temperature Pri Pil Pil	Cooling Use Prime Pillar me Pillar Extrud ar Width ar Location eed Multiplier	G-Code r der All Ext 12,00 North-	Scripts ruders mm West	Other -	Advanced
Use Raft Raft Extruder Raft Layers Raft Offset from Part Separation Distance Raft Infill Disable raft base la	Primary Extruder 3 \$\overline\$ 3,00 \$\overline\$ 0,14 \$\overline\$ 85 \$\overline\$ % %	▼ Oc Of Sic Sp	Use Ooze Shiel oze Shield Extru fset from Part oze Shield Outlin lewall Shape lewall Angle Ch eed Multiplier	Id Id Ider All E 2,00 hes 1 Wat ange 30 100	ixtruders	•	

Рис. 35

Кол-во витков в слое.

При печати высоких объектов желательно применить более одного витка.

fill Percent	tage:			15%	6 📝 Ir	iclude Raft	Ce Ge	nerate Sup
Extruder	Layer Additions	Infill Support	Temperat	ure Cooling	G-Code	Scripts	Other	Advance
	🔽 Use Skirt/Brim			🔽 Use Prime Pill	ar			
	Skirt Extruder	Primary Extruder	•	Prime Pillar Extru	Ider All Ext	ruders	•	
	Skirt Layers	1		Pillar Width	12,00	≑ mm		
	Skirt Offset from Part	4,00 🚔 mm		Pillar Location	North	West	•	
	Skirt Outlines	2		Speed Multiplier	100	€ %		
	🔽 Use Raft			🔽 Use Ooze Shi	eld			
	Raft Extruder	Primary Extruder	•	Ooze Shield Extr	uder All E	Extruders	•	
	Raft Layers	3		Offset from Part	2,0	D ≑ mm		
	Raft Offset from Part	3,00 ≑ mm		Ooze Shield Out	ines 1	*		
	Separation Distance	0,14 🚔 mm		Sidewall Shape	Wa	terfall	•	
	Raft Infill	85 🚔 %		Sidewall Angle C	hange 🕑	🗧 deg		
	🔲 Disable raft base la	iyers		Speed Multiplier	100	\$ %		

Рис. 36

Изменение угла наклона боковой стенки.

fill Percent	age:					15%	6	🔽 Ind	clude Raft	🔲 Ge	nerate Supp
Extruder	Layer Additions	Infill	Support	Tempera	ture	Cooling	G-C	ode	Scripts	Other	Advanced
	📝 Use Skirt/Brim				r 🔽 l	Jse Prime Pilla	ar				
	Skirt Extruder	Primary Ex	truder	-	Prim	e Pillar Extru	ider (All Extr	uders	•	·
	Skirt Layers	1	*		Pilla	r Width	[12,00	🚖 mm		
	Skirt Offset from Part	4,00	÷ mm		Pilla	r Location	(North-\	West		·
	Skirt Outlines	2	* *		Spe	ed Multiplier	[100	\$ %		
	🔽 Use Raft				- 🔽 l	Jse Ooze Shi	eld				
	Raft Extruder	Primary Ex	truder	•	Ooz	e Shield Extr	uder	All E:	xtruders		·
	Raft Layers	3			Off	set from Part	:	2,00	🚖 mm		
	Raft Offset from Part	3,00 🌲	mm		Ooz	e Shield Outl	ines	1	*		
	Separation Distance	0,14	mm		Side	wall Shape		Wat	erfall	•	·
	Raft Infil	85	%		Side	wall Angle C	hange	30	≑ deg		
	🔲 Disable raft base la	ayers			Spe	ed Multiplier	5	100	\$ %		

Рис. 37

Скорость печати щита.

General Settings	
Infill Percentage:	15% 🔲 Include Raft 📄 Generate Support
Extruder Layer Additions Infill Support Temperature	Cooling G-Code Scripts Other Advanced
General	Infill Angle Offsets
Infill Extruder Primary Extruder 🔻	0 🔄 deg 45
Internal Fill Pattern	Add Angle -45
External Fill Pattern Rectilinear	Remove Angle
Interior Fill Percentage 15 🔪 %	
Outline Overlap 15 👻 %	
Infill Extrusion Width 100 👻 %	
Minimum Infill Length 5,00 👻 mm	
Print Sparse Infill Every 1 avers	
Include solid diaphragm every 20 🛓 layers	Print every infill angle on each layer

Рис. 38

Внутреннее заполнение.

Выбор узора заполнения (подберите опытным методом).

neral Settings		
Ill Percentage:	15% Include Raft Genera	ate Supp
xtruder Layer Additions Infill Support Temperature	Cooling G-Code Scripts Other Ad	dvanced
General	Infill Angle Offsets	
Infill Extruder Primary Extruder	0 🚖 deg 45	
Internal Fill Pattern Rectilinear	Add Angle -45	
External Fill Pattern Dectilinear	Remove Angle	
Interior Fill Percentage 15 🚔 %		
Outline Overlap 15 🚔 %		
Infill Extrusion Width 100 👻 %		
Minimum Infill Length 5,00 👘 mm		
Print Sparse Infill Every 1 📄 layers		
☐ Include solid diaphragm every 20 ↓ layers	Print every infill angle on each layer	

Рис. 39

Узор верхних и нижних плотных слоев заполнения.

Process Name:	Process1	
Select Profile:	new profile (modified)	Update Profile Save as New Remove
-Auto-Configur	e for Material	Auto-Configure for Print Quality
PLA	▼ 🕄 🔵	Fast 🔹 💿 🕒
General Settin	lgs	
Infill Percenta	ge:	15% 🔲 Indude Raft 📄 Generate Support
Extruder	Layer Additions Infill Support Temperature	e Cooling G-Code Scripts Other Advanced
	General	Infill Angle Offsets
	Infill Extruder Primary Extruder	0 🚖 deg 45
	Internal Fill Pattern Rectilinear	Add Angle -45
	External Fill Pattern Rectilinear	Remove Angle
	Interior Fill Percentage 📑 🚔 %	
	Outline Overlap 15 👻 %	
	Infill Extrusion Width 100 👻 %	
	Minimum Infill Length 5,00 🚔 mm	
	Print Sparse Infill Every 1 🚔 layers	
	Include solid diaphragm every 20 🖈 layers	Print every infill angle on each layer

Рис. 40

Процент заполнения.

Process Name:	Process1
Select Profile:	new profile (modified)
-Auto-Configur	e for Material Auto-Configure for Print Quality
PLA	▼ 💽 🖨 Fast ▼ 💽 🖨
General Settin	igs
Infill Percenta	ge: 15% 🔲 Include Raft 📃 Generate Support
Extruder	Layer Additions Infill Support Temperature Cooling G-Code Scripts Other Advanced
	General Infill Angle Offsets
	Infill Extruder Primary Extruder
	Internal Fill Pattern Rectilinear
	External Fill Pattern Rectilinear
	Interior Fill Percentage 15 🗣 %
	Outline Overlap 15 🚔 %
	Infill Extrusion Width 100 🚔 %
	Minimum Infill Length 5,00 🚔 mm
	Print Sparse Infill Every 1 🚔 layers
	Include solid diaphragm every 20 🐳 layers

Рис. 41

Контур перекрытия.

Layer Additions Infil	Support Temperature	Cooling	G-Code	Scripts	Other	Advanc
General		Infill Angle	Offsets			
Infill Extruder Primary Extru	der 🔻	0 🌻	deg 45			
Internal Fill Pattern Rectiline	ar 🔻	Add Ar	ngle -4	5		
External Fill Pattern Rectiline	ar 🔻	Remove	Angle			
Interior Fill Percentage 15						
Outline Overlap 15	∲ %					
Infill Extrusion Width 100	. ⇒ %					
Minimum Infill Length 5,00) 🚖 mm					
Print Sparse Infill Every 1	layers					
	Layer Additions Intil General Infill Extruder Primary Extrud Internal Fill Pattern Rectiline External Fill Pattern Rectiline Interior Fill Pattern Rectiline Interior Fill Percentage 15 Outline Overlap 15 Infill Extrusion Width 100 Minimum Infill Length 5,00 Print Sparse Infill Every 1	Layer Additions Innii Support Temperature General Infill Extruder Primary Extruder Infill Extruder Primary Extruder Internal Fill Pattern Rectilinear External Fill Pattern Rectilinear Interior Fill Percentage 15 % Infill Extrusion Width 100 % Minimum Infill Length Print Sparse Infill Every	Layer Additions Intil Support Temperature Cooling General Infill Extruder Primary Extruder Infill Angle Infill Extruder Primary Extruder Infill Angle Internal Fill Pattern Rectilinear Add Angle External Fill Pattern Rectilinear Add Angle Interior Fill Percentage 15 % Outline Overlap 15 % Infill Extrusion Width 100 % Minimum Infill Length 5,00 mm Print Sparse Infill Every 1 Jayers	Layer Additions Infill Support Temperature Cooling G-Code General Infill Angle Offsets 0 deg 45 Infill Extruder Primary Extruder 0 deg 45 Internal Fill Pattern Rectilinear Add Angle -41 External Fill Pattern Rectilinear Remove Angle -41 Interior Fill Pattern Rectilinear Add Angle -41 Interior Fill Percentage 15 % Remove Angle Infill Extrusion Width 100 % % Print Sparse Infill Every 1 jayers jayers <td< td=""><td>Layer Additions Intil Support Temperature Cooling G-Code Scripts General Infill Angle Offsets Infill Angle Offsets 0 deg 45 Internal Fill Pattern Rectilinear Add Angle -45 External Fill Pattern Rectilinear Remove Angle -45 Interior Fill Percentage 15 % 0 mm Infill Extrusion Width 100 % Minimum Infill Length 5,00 mm Print Sparse Infill Every 1 layers layers Image: Support State Image: Support State Image: Support State Image: Support State</td><td>Layer Additions Intil Support Temperature Cooling G-Code Scripts Other General Infill Extruder Primary Extruder Infill Angle Offsets Infill Angle Offsets 0 deg 45 Internal Fill Pattern Rectilinear Interior Fill Pattern Remove Angle -45 Interior Fill Percentage 15 % 0 outline Overlap 15 % Infill Extrusion Width 100 % % mm print Sparse Infill Every 1 jayers</td></td<>	Layer Additions Intil Support Temperature Cooling G-Code Scripts General Infill Angle Offsets Infill Angle Offsets 0 deg 45 Internal Fill Pattern Rectilinear Add Angle -45 External Fill Pattern Rectilinear Remove Angle -45 Interior Fill Percentage 15 % 0 mm Infill Extrusion Width 100 % Minimum Infill Length 5,00 mm Print Sparse Infill Every 1 layers layers Image: Support State Image: Support State Image: Support State Image: Support State	Layer Additions Intil Support Temperature Cooling G-Code Scripts Other General Infill Extruder Primary Extruder Infill Angle Offsets Infill Angle Offsets 0 deg 45 Internal Fill Pattern Rectilinear Interior Fill Pattern Remove Angle -45 Interior Fill Percentage 15 % 0 outline Overlap 15 % Infill Extrusion Width 100 % % mm print Sparse Infill Every 1 jayers



Ширина экструзии при заполнении.

				01	
truder Layer Additions Infili Support I	emperature Cooling	G-Code	Scripts	Other	Advanc
General	Infill An	gle Offsets —			
Infill Extruder Primary Extruder 🔹	0	🗧 deg 🛛 🗛	i		
Internal Fill Pattern Rectilinear	▼ Add	-4 Angle	5		
External Fill Pattern Rectilinear	▼ Remo	ve Angle			
Interior Fill Percentage 15 🚔 %					
Outline Overlap 15 🚔 %					
Infill Extrusion Width 100 🚔 %					
Minimum Infill Length 5,00 🚔 mm					
Print Sparse Infil Every 1					

Рис. 43

Минимально заполняемая длинна.

В участках меньше этой длины заполнение не будет.

xtruder Layer	Additions	Infill Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced
Gener	al			Infill Angle	Offsets			
Infill E	xtruder Primary	Extruder 🔹		0 🌻	deg 45			
Intern	al Fill Pattern Re	ectilinear	•	Add Ar	ngle -49	5		
Exterr	al Fill Pattern Re	ectilinear	•	Remove	Angle			
Interio	or Fill Percentage	15 🚖 %						
Outline	e Overlap	15 🚖 %						
Infill E	xtrusion Width	100 🚖 %						
Minimu	um Infill Length	5,00 🚖 mm						
Print S	parse Infill Every)1 🗦 layer	s					



Печать редкого заполнения каждый...

Каждый слой это-1, через слой это-2, два пропустить третий печатать это-3 и т.д.

xtruder Lay	ver Additions	Infill Support	Temperature	Cooling	G-Code	Scripts	Other	Advance
G	eneral			Infill Angle	Offsets			
Ir	nfill Extruder Primary	Extruder 🔻	•	0 🌲	deg 45			
Ir	nternal Fill Pattern	ectilinear	•	Add An	ngle -4	5		
E	xternal Fill Pattern	ectilinear	•	Remove	Angle			
Ir	nterior Fill Percentage	15 🔶 %						
C	utline Overlap	15 🔷 %						
Ir	fill Extrusion Width	100 🌲 %						
м	inimum Infill Length	5,00 🚖 mm						
p	rint Sparse Infill Every	/ 1 📥 laver						

Рис. 45

Печать твердой диафрагмы каждый указанный слой (например, каждый 20).

ktruder	Layer Additions Infill Support Temperature	Cooling G-Code Scripts Other Advance
	General	Infill Angle Offsets
	Infill Extruder Primary Extruder	0 🚔 deg) 45
	Internal Fill Pattern Rectilinear	Add Angle -45
	External Fill Pattern Rectilinear	Remove Angle
	Interior Fill Percentage 15 🐳 %	
	Outline Overlap 15 🐳 %	
	Infill Extrusion Width 100 🗣 %	
	Minimum Infill Length 5,00	
	Briet Searce Infil Every 1	

Рис. 46

Задать угол направления заполнения относительно оси «х».

Percentage:	15% Include Raft Generate Sup
truder Layer Additions Infill Support Temperature	Cooling G-Code Scripts Other Advance
General	Infill Angle Offsets
Infill Extruder Primary Extruder	0 🖨 deg 45
Internal Fill Pattern Rectilinear	Add Angle -45
External Fill Pattern Rectilinear	Remove Angle
Interior Fill Percentage 15 🗣 %	
Outline Overlap 15 🗣 %	
Infill Extrusion Width 100 🗣 %	
Minimum Infill Length 5,00 💭 mm	
Print Sparse Infill Every 1 🚔 layers	
🔲 Include solid diaphragm every 🛛 20 🔶 layers	Print every infill angle on each layer

Рис. 47

Печатать каждую кромку угла на каждом слое.

General Settings Infill Percentage:		15% 🔲 Include Raft 📄 Generate S	upport
Extruder Layer Additions 1	Infill Support Temperature	Cooling G-Code Scripts Other Advan	ced
General		Infill Angle Offsets	
Infill Extruder Primary	Extruder	0 🜩 deg 45	
Internal Fill Pattern Re	ectilinear 🔻	Add Angle	
External Fill Pattern	ectilinear 🔻	Remove Angle	
Interior Fill Percentage	15 🔶 %		
Outline Overlap	15 🔶 %		
Infill Extrusion Width	100 🔶 %		
Minimum Infill Length	5,00 🚖 mm		
Print Sparse Infill Every	1 🚔 layers		
Include solid diaphra	agm every 20 🌲 layers	Print every infill angle on each layer	

Рис. 48

Кнопки для подтверждения угла или отмены.

Extruder	Laver	Additions	Infill	Support	Temperature	Coolina	G-Code	Scripts	Other	Adva
	Suppor Suppor Suppor Extra I Dense Print S	rt Material Genu nerate Support rt Extruder Pr rt Infill Percent Inflation Distan Support Layer Infill Percentag upport Every	eration t Material age 25 oce 0,000 s 0 ge 70 1	ruder % % mm % laye		Automatic Place Only used if ma Support Type Support Pillar R Max Overhang Support Infill Ar 0 🗼 deg Add Angle	ement anual supp Normal essolution Angle ngles	4,00	fined mm deg	
	Separa Horizor Upper Lower	ation From Part ntal Offset Fro Vertical Separa Vertical Separa	m Part ation Layer	0,30 rs 1	▲ mm ↓	Remove Angle				

Рис. 49

truder	Layer Additions Inf	ill Support	Temperature	Cooling	G-Code	Scripts	Other	Adv
	Support Material Generati	on terial	Au O Su	utomatic Place Inl <i>y used if ma</i> upport Type	ment <i>inual supp</i> Normal	ort is not defi	ined	
	Support Infill Percentage Extra Inflation Distance	25 ∲ % 0,00 ∲ mm	SU	upport Pillar R ax Overhang	esolution Angle	4,00 🔹	mm deg	
	Dense Support Layers Dense Infill Percentage Print Support Every	0 🔷 70 🌩 % 1 🗣 layer:	s	upport Infill Ar) 📄 deg Add Angle	ngles			
	Separation From Part	art 0,30 📑	F mm	Remove Angle)			
	Upper Vertical Separation	Layers 1						

Сформировать материал поддержки.

Рис. 50



Extruder	Layer Additions Ir	nfill Support	Temperature	Cooling	G-Code	Scripts	Other	Adva
ſ	Support Material General Generate Support M Support Extruder Prima Support Infill Percentage Extra Inflation Distance Dense Support Layers Dense Infill Percentage Print Support Every	tion aterial ary Extruder 2 % 0,00 - mm 0 70 - % 1 - laye	TS AU	utomatic Place <i>Dnly used if ma</i> upport Type (upport Pillar R lax Overhang upport Infill Ar 0	ement anual support Normal esolution Angle ngles	4,00 🜲	ined T	
	Separation From Part Horizontal Offset From F Upper Vertical Separatio Lower Vertical Separatio	Part 0,30 n Layers 1 n Layers 1		Remove Angle				

Рис. 51

Support Material Generation Image: Support Material Generation Automatic Placement Image: Generate Support Material Only used if manual support is not defined Support Extruder Support Extruder Support Infill Percentage 25 Fxtra Infilition Distance 0.00 Image: Support Infill Percentage 0.00 Image: Support Infill Percentage	fined
Image: Support Extruder Only used if manual support is not defined and support is not defined and support is not defined and support Extruder Support Extruder Image: Support Infill Percentage Support Infill Percentage 25 Support Infill Percentage 0.00 Image: Support Infill Percentage 0.00 Image: Support Infill Percentage 0.00 Image: Support Percentage 0.00 Image: Pe	rfined
Support Extruder Support Extruder Support Infil Percentage 25 Support Infil Percentage 0.00 Max Overhang Angle 45	-
Support Extruder Visiting Primary Extruder Support Infill Percentage 25 Extra Inflation Distance 0.00 mm Max Overhang Angle	
Support Infill Percentage 25 👻 % Max Overhang Angle 45	- mm
Extra Inflation Distance 0.00 Amm	a
	deg
Dense Support Layers 0	
Add Angle	
Separation From Part Remove Angle	
Horizontal Offset From Part 0,30 🚔 mm	
Upper Vertical Separation Layers 1	

Процент заполнения поддержки.

Рис. 52

Дополнительная дистанция инфляции.

General Settings	
Infill Percentage:	15% 📝 Include Raft 📝 Generate Suppo
Extruder Layer Additions Infill Support Temperate Support Material Generation Image: Construct of the support Material Support Extruder Image: Construct of the support Material Support Extruder Primary Extruder Image: Construct of the support extruder Image: Construct of the support extruder Support Extruder Primary Extruder Image: Construct of the support extruder Image: Construct of the support extruder Dense Infill Percentage Image: Construct of the support extrustory Image: Construct of the support extrustory Image: Construct of the support extrustory Dense Infill Percentage Image: Construct of the support extrustory Image: Construct of the support extrustory Image: Construct of the support extrustory Separation From Part Horizontal Offset From Part Image: Construct of the superation extrustory Image: Construct of the superation extrustory Upper Vertical Separation Layers Image: Construct of the superation extrustory Image: Construct of the superation extrustory Image: Construct of the superation extrustory	ure Cooling G-Code Scripts Other Adva Automatic Placement Only used if manual support is not defined Support Type Normal Support Pillar Resolution 4,00 mm Max Overhang Angle 45 deg Add Angle Remove Angle
Hide Advanced Select Models	OK

Рис. 53

General Settings Infill Percentage:		15%	i 🔽 Ir	ndude Raft	🔽 Ge	nerate Suppo
Extruder Layer Additions Infill Support Support Material Generation Image: Comparison of the support Material Support Material Support Extruder Primary Extruder Support Extruder Primary Extruder Support Infill Percentage 25 9 Extra Inflation Distance 0,00 Image: Comparison of the support Layers 0 1 Dense Support Layers 0 Image: Comparison of the support Every 1 1 Dense Infill Percentage 70 Image: Comparison of the support Every 1 1 Separation From Part Horizontal Offset From Part 0,30 Upper Vertical Separation Layers 1 Lower Vertical Separation Layers 1 1 1 1	Temperature Au Su Su Su Ma n Vers R R	Cooling tomatic Place aly used if ma pport Type pport Pillar R ax Overhang port Infill Ar enove Angle emove Angle	G-Code ement anual support Normal essolution Angle 0	Scripts	Other mm deg	Adva ()
Hide Advanced Select Models					ОК	Cance

Плотные слои поддержки.

Рис. 54

ill Percentage:	15% 📝 Indude Raft 📝 Generate Supp
Ill Percentage:	15% Include Raft Generate Support Temperature Cooling Generate Support Automatic Placement Only used if manual support is not defined Support Type Normal Support Pillar Resolution 4,00 Tmm Max Overhang Angle 45 Tmm Support Infill Angles 0 Add Angle 0
Separation From Part Horizontal Offset From Part 0,30 Upper Vertical Separation Layers 1	mm

Плотное заполнение поддержки.





Extruder	Layer Add	litions Infill	Support	Temperature	Cooling	G-Code	Scripts	Other	Adva
	Support Mate Generate Support Extr Support Infill Extra Inflatio Dense Support Dense Infill P Print Support	erial Generation e Support Materia ruder Primary E I Percentage 25 on Distance 0, ort Layers 0 Percentage 70 t Every 1	al xtruder \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$	TS Au	utomatic Place Inly used if ma upport Type (upport Pillar R ax Overhang upport Infill Ar 0	ement anual support Normal esolution Angle ngles 0	4,00 🗘	mm deg	
	Separation F Horizontal Of Upper Vertica Lower Vertica	rom Part ffset From Part al Separation Lay al Separation Lay	0,30 ers 1	₩m €	Remove Angle				

Рис. 56

Горизонтальное смещение части.

General Settings	
Infill Percentage:	15% V Indude Raft Generate Support
Support Material Generation Generate Support Material Support Extruder Primary Extruder Support Infil Percentage 25 \checkmark % Extra Inflation Distance 0,00 \checkmark mm Dense Support Layers 0 \checkmark Dense Infil Percentage 70 $令$ % Print Support Every 1 \diamondsuit layers	Automatic Placement Only used if manual support is not defined Support Type Normal Support Pillar Resolution 4,00 Max Overhang Angle 45 Support Infill Angles 0 Add Angle 0
Separation From Part Horizontal Offset From Part 0,30 🐑 mm Upper Vertical Separation Layers 💭 Lower Vertical Separation Layers 1 👽	Remove Angle

Зазор между поддержкой и объектом.



Верхний слой вертикального разделения.

General Settings	15% 🛛 Include Raft 📝 Generate Suppo
Extruder Layer Additions Infill Support Temperation Support Material Generation Image: Comparison of the support Material Support Extruder Image: Comparison of the support Material Support Extruder Primary Extruder Image: Comparison of the support Extruder Image: Comparison of the support Extruder Support Infill Percentage 25 % Model Dense Support Layers 0 1mm Dense Support Every 1 1mm Dense Infill Percentage 70 % Print Support Every 1 1mm Separation From Part 0,30 mm Upper Vertical Separation Layers 1 Imm Lower Vertical Separation Layers Imm Imm	ature Cooling G-Code Scripts Other Adva Automatic Placement Only used if manual support is not defined Support Type Normal Image: Cooling Image: Cooling

Рис. 58

Нижний слой вертикального разделения.

fill Percentag	je:						15%	V I	nclude Raft	t 🔽 G	enerate Sup
Extruder	Layer	Additions	Infill	Support	Temperatu	re Coolir	ng	G-Code	Scripts	Other	Adva 4
	Suppo	ort Material Gen	eration			Automatic	Place	ment			
	🗸 Ge	enerate Suppor	t Materia	I.		Only used	l if ma	nual suppl	ort is not de	efined	
	_					Support T	ype	ormal		-	
	Suppo	ort Extruder Pr	imary Ex	truder	•	Support P	illar Re	esolution	4,00	🗧 mm	
	Suppo	ort Infill Percent	age 25	€ %		Max Over	hang	Angle	45	🗧 deg	
	Extra	Inflation Distan	ce 0,0	00 🚖 mm							
	Dense	e Support Layer	s 0	*		-Support Ir	nfill An	gles			
	Dense	e Infill Percentag	ge 70	\$ %		0	deg	0			
	Print S	Support Every	1	≑ laye	rs	Add An	ngle				
						Remove	Anale				
	Separa	ation From Part			_						
	Horizo	ontal Offset Fro	m Part	0,30	≑ mm						
	Upper	Vertical Separa	tion Lay	ers 1	÷						
	Lower	Vertical Separa	tion Lay	ers 1	÷						

Рис. 59

Тип поддержки.

truder	Layer Additions Infill Support Temperat	ture Cooling G-Code Scripts Other Adv
	Support Material Generation	Automatic Placement
	🕼 Generate Support Material	Only used if manual support is not defined
		Support Type Normal 🔻
	Support Extruder Primary Extruder	Support Pillar Resolution 4,00 🚔 mm
	Support Infill Percentage 25 🚔 %	Max Overhang Angle 45 🚔 deg
	Extra Inflation Distance 0,00 🚔 mm	
	Dense Support Layers 0	Support Infill Angles
	Dense Infill Percentage 70 🛓 %	0 🚔 deg 0
	Print Support Every 1 📄 layers	Add Angle
	Separation From Part	Remove Angle
	Horizontal Offset From Part 0,30 🚖 mm	

Рис. 60

Поддержка стойки разрешения.

General Setting)S						
Infill Percentag	e:			15%	📝 Include	Raft 📝 🤇	Generate Support
Infill Percentag	e: Additions Support Material Gene Generate Support Support Extruder Fri Support Extruder Extra Inflation Distance Dense Support Layers Dense Infill Percentag Print Support Every Separation From Part Horizontal Offset From Upper Vertical Separate	Infill Support eration Material Material Material mary Extruder age 25 ♥ % ce 0,00 ♥ mm ce 70 ♥ % 1 ♥ layer m Part 0,30 € tion Layers 1 €	Temperature A C S S S S C C C S C C C C S C C C S C C S C C S C S C C S C S C S C S C S C S C S S C S C S S S C S	15% Cooling utomatic Placen Duly used if man upport Type N upport Pillar Rei ax Overhang A upport Infill Ang o 🗼 deg Add Angle Remove Angle	✓ Include G-Code Scr hent	Raft V C	Generate Support
	Dense Infill Percentage Print Support Every Separation From Part Horizontal Offset From Upper Vertical Separat Lower Vertical Separat	e 70 🔹 % 1 🔹 layer n Part 0,30 [tion Layers 1 [tion Layers 1 [rs	Add Angle	0		

Рис.61

Максимальный угол свеса.

xtruder	Layer	Additions	Infill	Support	Temper	ature	Cooling	G-Code	Scripts	Other	Adva 🖣 e
	Suppor	rt Material Ger	neration			AL	tomatic Plac	ement			
	Ger	nerate Suppo	rt Material			0	nly used if m	anual suppo	ort is not dei	fined	
		-			_	Su	pport Type	Normal		•	
	Suppor	rt Extruder [F	Primary Ext	ruder	•	Su	ipport Pillar F	Resolution	4,00 🌲	mm	
	Suppor	rt Infill Percen	tage 25	≑ %		M	ax Overhand	Angle	45	dea	
	Extra I	Inflation Dista	nce 0,00) ≑ mm							
	Dense	Support Laye	rs O	*		Su	pport Infill A	ngles			
	Dense	Infill Percenta	age 70	\$ %			🖨 dea	0			
	Print S	upport Every	1	🖨 layer	s	ſ	Add Angle	1			
						R	emove Anale				
	Separa	ation From Par	t								
	Horizor	ntal Offset Fr	om Part	0,30	🗧 mm						
	Upper	Vertical Separ	ation Laye	rs 1	*						
	Lower	Vertical Separ	ation Lave	rs 1							

Рис.62

Заполнение поддержки в углах.

General Settings										
Infill Percentage:						15%	6 🔽 I	nclude Raft	🔽 G	enerate Suppor
				1						
Extruder Lay	er Additions	Infill	Support	Temperat	ure	Cooling	G-Code	Scripts	Other	Adva 🔹 🌔
S	upport Material Gen	eration			A	utomatic Place	ement			
8	// Generate Suppor	t Materia	I		0	nly used if ma	anual suppl	ort is not defi	ined	
			ter of each		Su	upport Type	Normal		•	
5	upport Extruder	rimary Ex	uruder	•	Su	upport Pillar R	esolution	4,00 🗘	mm	
S	upport Infill Percent	age 25	~ %		м	ax Overhang	Angle	45 🌲	deg	
E	xtra Inflation Distar	nce 0,0)0 🚖 mm							
D	ense Support Layer	s 0	-		Su	ıpport Infill Aı	ngles			
D	ense Infill Percenta	ge 70	\$ %		C	🚖 deg	0			
P	rint Support Every	1	≑ laye	rs	0	Add Angle	D .			
						emove Angle				
S	eparation From Part					centove Angle	9			
н	orizontal Offset Fro	m Part	0,30	≑ mm						
U	pper Vertical Separa	ation Laye	ers 1	÷						
L	ower Vertical Separa	ation Laye	ers 1	* *						

Рис.63

Добавить угол.

	Layer	Additions	Infill Support	Temperatur	e Cooling	G-Code	e Scripts (Other Advanced
Te (f	emperature click item to	Controller List edit settings)	Prin	nary Exti	ruder Ter	nper	ature	
Primary P	Extruder		Over	view				
			Temp	erature Identifie	er TO		•	
			Temp	erature Controll	er Type: D Ext	ruder (Heated build pla	atform
			Temp	cratare control	er type, by ext		, neuteu bana pr	
				Terrer and the D	a huu a a a Ea alau III	1 aver		
			Relay	r lemperature B	etween Each:	Layer	Loop	
			Relay	ait for temperature b	ture controller to	stabilize	before beginning	build
				ait for temperature be	ture controller to	stabilize	before beginning	build
			Per-Li	/ait for temperature be /ait for temperat ayer Temperatur	ture controller to re Setpoints	stabilize	before beginning	build
			Per-Li	/ iemperature be /ait for temperature ayer Temperatur er	ture controller to re Setpoints Temperature	stabilize	before beginning	build Setpoint
			Per-Li Lay	/ iemperature Br /ait for temperat ayer Temperatur er	ture controller to re Setpoints Temperature 200	stabilize	before beginning	build Setpoint
			Per-Lay	/ iemperature bi /ait for temperat ayer Temperatur er	ture controller to re Setpoints Temperature 200	stabilize	Add :	build Setpoint
			Per-Lay	/ait for temperature br /ait for temperatur ayer Temperatur er	ture controller to re Setpoints Temperature 200	stabilize	Add : Remov Layer Number	build Setpoint e Setpoint
			Per-Li Lay	/ iemperature Br /ait for temperat ayer Temperatur er	ture controller to re Setpoints Temperature 200	stabilize	Add : Cayer Number Temperature	Setpoint e Setpoint 1 + 200 + °C

Рис.64

Температурный контроль сборки.

General Settings				
Infill Percentage:		15%	Include Raft	Generate Support
Extruder Layer Additions Infill Temperature Controller List (click item to edit settings) Image: Controller List (Primary Extruder	Support Temperature Co Primary Extruder Overview Temperature Identifier T0 Temperature Controller Type: Relay Temperature Between E Wait for temperature cont	oling G-Code r Temper	e Scripts O ature Heated build pla Loop before beginning b	ther Advanced
Add Temperature Controller Remove Temperature Controller	Per-Layer Temperature Setpoin Layer Temper 1 200	ature	Add S Remove Layer Number Temperature	etpoint Setpoint 1 200 C

Рис.65

General Settings							
Infill Percentage:			15	% 🔽 1	Include Raft		Generate Support
Extruder Layer Additions Infill Temperature Controller List (click item to edit settings) Primary Extruder	Support Prima Overview Temperat Relay Ter	Temperature ITY Extru ture Identifier (ture Controller T mperature Betwo for temperature	Cooling der Ter TO TO TO TO TO TO TO TO TO TO TO TO TO	G-Code mpera truder taver stabilize be	Scripts ture Heated build	Other I platform	Advanced
	Per-Layer	r Temperature S	etpoints		Δ	dd Setpoint	
Add Temperature Controller	1	200)		Rem Layer Num Temperatu	ove Setpoi ber 1 re 200	nt
Remove Temperature Controller							

Температура каждого слоя или петли.

Рис.66

Ждать пока температура дойдет до нужного значения.

General Settings					
Infill Percentage:			15%	📝 Include Ra	ft 📃 Generate Support
Extruder Layer Additions Infill	Support Te	emperature	Cooling	G-Code Scripts	Other Advanced
Temperature Controller List (dick item to edit settings) Primary Extruder	Primar Overview Temperatur Temperatur Relay Temp Wait fo	y Extruc re Identifier re Controller Ty perature Betwe r temperature	der Tem o ype: @ Extru een Each: controller to st	perature ter Heated bu Layer Loop abilize before begin	uild platform nning build
	Per-Layer T	Temperature Se	etpoints		
	1	200	nperature	Layer Nu Tempera	Add Setpoint
Add Temperature Controller					
Remove Temperature Controller					

Рис.67

Номер слоя и температура.

General Settings				
Infill Percentage:		15%	/ Include Raft	Generate Support
Extruder Layer Additions Infill State Temperature Controller List (click item to edit settings) Primary Extruder	Support Temperature Primary Extrud Overview Temperature Identifier TO Temperature Controller Typ Relay Temperature Betwee Wait for temperature c	Cooling G-Code ler Temper	Scripts Oth Tature Heated build platfo Loop before beginning buil	er Advanced
Add Temperature Controller Remove Temperature Controller	Per-Layer Temperature Set	perature	Add Set Remove S Layer Number	point etpoint L ↓ 200 ↓ °C

Рис.68



General Settings	
Infill Percentage:	15% 📝 Include Raft 📄 Generate Support
Extruder Layer Additions Infill Support Temperature Per-Layer Fan Controls Add Setpoint Image: Control Setting the set of the s	Cooling G-Code Scripts Other Advanced Speed Overrides Image: Speed for layers below 15,0 ♥ sec Sec Allow speed reductions down to 20 ♥ % Image: Speed for layers below 45,0 ♥ sec Fan Overrides Increase fan speed for layers below 45,0 ♥ sec Maximum cooling fan speed 100 ♥ % Image: Bridging fan speed override 100 ♥ % Image: Speed override 100 ♥ %

Рис.69

Слой и скорость

fill Percentage:	15% 📝 Include Raft 📄 Generate Support
Extruder Layer Additions Infill Support Temperature Per-Layer Fan Controls Add Setpoint Infill Infill Infill Infill Support Temperature Layer Fan Speed Add Setpoint Infill Infill Infill Infill 2 100 Infill Remove Setpoint Infill Infill Infill Infill 2 100 Infill Remove Setpoint Infill Infill Infill Infill Fan Speed 60 Infill Infill Infill Infill Infill Infill	Cooling G-Code Scripts Other Advanced Speed Overrides Image: Adjust printing speed for layers below 15,0 ★ sec Allow speed reductions down to 20 ★ % Fan Overrides Increase fan speed for layers below 45,0 ★ sec Maximum cooling fan speed 100 ★ %

Рис.70

Изменение слоя и скорости.

eneral Settings fill Percentage: Extruder Layer Additions Per-Layer Fan Controls Layer Fan Speed 1 0 2 100	Infill Support Temperature Add Setpoint Remove Setpoint Layer Number 1 😴 Fan Speed 60 荣 %	15% ✓ Include Raft Generate Support Cooling G-Code Scripts Other Advanced Speed Overrides ✓ Adjust printing speed for layers below 15,0 ÷ sec Allow speed reductions down to 20 ÷ % % Fan Overrides ✓ Increase fan speed for layers below 45,0 ÷ sec Maximum cooling fan speed 100 ÷ % % Bridging fan speed override 100 ÷ %
Fan Options	easing from idle	Bridging fan speed override 100 🖈 %

Рис.71

Подтверждение.	
----------------	--

Рис.72

Отрегулировать скорость печати слоев ниже.

Рис.73

Снизить скорость до ...%

truder Layer Additions	Infill Support Temperature	Cooling G-Code Scripts Other Advanced
Layer Fan Speed 1 0 2 100	Add Setpoint Remove Setpoint Layer Number 1 💭 Fan Speed 60 🔷 %	 Adjust printing speed for layers below 15,0 ÷ sec Allow speed reductions down to 20 * % Fan Overrides Increase fan speed for layers below 45,0 ÷ sec Maximum cooling fan speed 100 * % Bridging fan speed override 100 * %



Увеличить скорость вентилятора для нижних слоев.

General Settings	15% 📝 Indude Raft 📄 Generate Support
Extruder Layer Additions Infill Support Temper Per-Layer Fan Speed Add Setpoint Image: Controls Image: Control Control Image:	rature Cooling G-Code Scripts Other Advanced Speed Overrides Image: Adjust printing speed for layers below 15,0 + sec Allow speed reductions down to 20 + % Allow speed reductions down to 20 + % % Fan Overrides Increase fan speed for layers below 45,0 + sec Maximum cooling fan speed 00 + % % Bridging fan speed override 100 + %

Рис.75

eneral Settings nfill Percentage:		15% 🗹 Include Raft 📄 Generate Support
Extruder Layer Additions Per-Layer Fan Controls Layer Fan Speed 1 0 2 100 Fan Options Blip fan to full power when incression	Infill Support Temperature Add Setpoint Image: Constraint of the set o	Cooling G-Code Scripts Other Advanced Speed Overrides Image: Cooling and the section of th

Максимальная скорость вентилятора.



Изменение скорости вращения вентилятора при печати моста

truder Layer Additions Per-Layer Fan Controls Layer Fan Speed 1 0 2 100	Infill Support Temperature Add Setpoint Remove Setpoint	Cooling Generate Support Cooling Generate Support Speed Overrides Image: Cooling Speed for layers below Image: Adjust printing speed for layers below 15,0 + sec Allow speed reductions down to 20 + %
	Layer Number 1 🖈 Fan Speed 60 🛧 %	Fan Overrides Increase fan speed for layers below 45,0 🔹 sec Maximum cooling fan speed 100 👻 % Bridging fan speed override 100 👻 %

Рис.77

Включение вентилятора на полную мощность при увеличении холостого хода.

General Settings	
Infill Percentage:	15% 📝 Include Raft 🛛 🖾 Generate Support
Extruder Layer Additions Infill Support	Temperature Cooling G-Code Scripts Other Advanced IV Update Machine Definition
Relative extrusion distances	X-Axis Y-Axis Z-Axis
Allow zeroing of extrusion distances (i.e. G92 E0)	Build volume 240,0 🚔 210,0 🖨 230,0 🖨 mm
Use independent extruder axes	Origin offset 0,0 🔹 0,0 🐳 0,0 👘 mm
Include M101/M102/M103 commands	Homing dir Min 💌 Min 💌 Min 💌
Firmware supports "sticky" parameters	Flip build table axis 🔲 X 🔍 Y 📃 Z
Apply toolnead offsets to G-Code coordinates	Toolhead offsets Tool 0 🔻 X 0,00 🛉 Y 0,00 🛉
Global G-Code Offsets X-Axis Y-Axis Z-Axis Offset 0,00 ♀ 0,00 ♀ mm	Update Firmware Configuration Firmware type RepRap (Marlin/Repetier/Sprinter)
	GPX profile Replicator 2 (default config)
	Baud rate 115200 v bits/sec

Рис.78

Определение обновления машины.

General Settings	
Infill Percentage:	15% 📝 Include Raft 📝 Generate Support
Extruder Layer Additions Infill Support G-Code Options I 5D firmware (include E-dimension)	Temperature Cooling G-Code Scripts Other Advanced Image: Ima
 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 	X-Axis Y-Axis Z-Axis Build volume 240,0 ⊋ 210,0 ⊋ 230,0 Ţmm Origin offset 0,0 ⊋ 0,0 ⊋ 0,0 Ţmm Homing dir Min Min Min ✓ Flip build table axis X Y Z Toolhead offsets Tool 0 ▼ X 0,00 Ţ Y 0,00
Global G-Code Offsets X-Axis Y-Axis Z-Axis Offset 0,00 + 0,00 + 0,00 mm	Update Firmware Configuration Firmware type RepRap (Marlin/Repetier/Sprinter) GPX profile Replicator 2 (default config) Baud rate 115200 bits/sec



Габариты рабочего объема.

General Settings	
Infill Percentage:	15% 📝 Indude Raft 📝 Generate Support
Extruder Layer Additions Infill Support T G-Code Options Image: Code Op	Temperature Cooling G-Code Scripts Other Advanced Image: Update Machine Definition Machine type Cartesian robot (rectangular volume) Image: Cartesian robot (rectangular volume) X-Axis Y-Axis Z-Axis Build volume 240.0 210.0 230.0 mm
 Include M101/M102/M103 commands Firmware supports "sticky" parameters Apply toolhead offsets to G-Code coordinates 	Duild voldnie 210,0 210,0 210,0 100 Origin offset 0,0 0,0 0,0 100 Homing dir Min Min Min 100 Flip build table axis X Y Z Toolhead offsets Tool 0 X 0,00 Y 0,00
Global G-Code Offsets X-Axis Y-Axis Z-Axis Offset 0,00 I 0,00 I 0,00 mm	Update Firmware Configuration Firmware type RepRap (Marlin/Repetier/Sprinter) GPX profile Replicator 2 (default config) Baud rate 115200 bits/sec

Рис.80

Настоящее смещение.

neral Settir fill Percenta	ngs age:				15% 📝 Include Raft 🛛 📝 Generate Sup
xtruder	Layer	Additions	Infill	Support	Temperature Cooling G-Code Scripts Other Advanced
G-Code C	ptions				Update Machine Definition
🔽 5D fir	mware (ind	lude E-dimensi	on)		Machine type Cartesian robot (rectangular volume)
📃 Relati	ive extrusio	on distances			X-Axis Y-Axis Z-Axis
Allow	zeroing of	extrusion dista	ances (i.e.	G92 E0)	Build volume 240,0 🐑 210,0 荣 230,0 🐑 mm
📃 Use ir	ndependent	t extruder axe	S		Origin offset 0,0 🚖 0,0 🖨 0,0 🗣 mm
Include	de M101/M	102/M103 com	mands		Homing dir Min 🔻 Min 💌
Firmw	are suppor	ts "sticky" par	ameters		Flip build table axis 🔲 X 🔍 Y 🔲 Z
Apply	toolhead o	offsets to G-Co	ode coordi	nates	Toolhead offsets Tool 0 🔹 X 0,00 🚔 Y 0,00
-Global G-(Code Offse	ts			
-	X-Axis	Y-Axis	Z-Axis	_	Eirmusra huna Dan Marlia Danatiar (Carintar)
Offset (0,00 🚖	0,00 🚖	0,00	mm	
					GPX profile (Replicator 2 (default config)
					Baud rate 115200 v bits/se

Рис. 81

Смещение каретки.

xtruder Layer Additions	Infill Support	Temperature	Cooling G-C	ode Script	s Othe	er Advanced
Speeds			Filament Properties			
Default Printing Speed	3600,0 🚖 mm/min		Filament diameter	1,7500 🚖	mm	
Outline Underspeed	50 🔷 %		Filament price	46,00 🚖	price/kg	
Solid Infill Underspeed	80 🚔 %		Filament density	1,25 🌲	grams/cm	1^3
Support Structure Underspeed	80 🚔 %					
X/Y Axis Movement Speed	4800,0 🚖 mm/min		Bridging			
Z Axis Movement Speed	1000,0 🚔 mm/min		Unsupported area t	hreshold 50,	0 ෫	sq mm
			Extra inflation dista	nce 0,0	0 ෫	mm
Dimensional Adjustments			Bridging extrusion n	nultiplier 100	*	%
Horizontal size compensation	00 🖻 mm		Bridging good mult	iolior 100		0/_

Рис.82

Скорость печати по умолчанию.

truder Layer Addition	ns Infill Support	Temperature Coolir	ng G-Code	Scripts Other Advanced
Speeds		Filament	Properties	
Default Printing Speed	3600,0 🚔 mm/min	Filament	diameter 1,750	00 🚖 mm
Outline Underspeed	50 🔶 %	Filament	price 46,00) 🚔 price/kg
Solid Infill Underspeed	80 🚖 %	Filament	density 1,25	grams/cm^3
Support Structure Underspeed	80 🚔 %			
X/Y Axis Movement Speed	4800,0 🚔 mm/min	Bridging		
Z Axis Movement Speed	1000,0 🚔 mm/min	Unsuppo	rted area thresh	old 50,0 🚖 sq mm
		Extra inf	ation distance	0,00 🚖 mm
Dimensional Adjustments		Bridging	extrusion multipli	ier 100 🛋 %

Рис.83

neral Settings				
ll Percentage:			15% 🔽 1	Include Raft 🛛 📝 Generate Suppo
xtruder Layer Additions	Infill Support	Temperature	Cooling G-Code S	Scripts Other Advanced
Speeds			Filament Properties	
Default Printing Speed	3600,0 🚔 mm/mir	n	Filament diameter 1,7500	📥 mm
Outline Underspeed	50 🔶 %		Filament price 46,00	🚔 price/kg
Solid Infill Underspeed	80 🌲 %		Filament density 1,25	🚔 grams/cm^3
Support Structure Underspeed	80 🚔 %			
X/Y Axis Movement Speed	4800,0 🚔 mm/mir	1	Bridging	
Z Axis Movement Speed	1000,0 🚔 mm/mir	1 I	Unsupported area threshold	50,0 🚖 sq mm
			Extra inflation distance	0,00 🚖 mm
Dimensional Adjustments			Bridging extrusion multiplier	100 🔷 %
Horizontal size compensation),00 🚖 mm		Bridging speed multiplier	100 🚔 %

Понижение скорости печати контура.

Рис.84

Понижение скорости при внутреннем заполнении.

	Filament Properties
,0 🚖 mm/min	Filament diameter 1,7500 🚔 mm
∲ %	Filament price 46,00 🚔 price/kg
⇒ %	Filament density 1,25 🚖 grams/cm^3
⇒ %	
,0 🚖 mm/min	Bridging
,0 🚖 mm/min	Unsupported area threshold 50,0 Sq mm
	Extra inflation distance 0,00 🖨 mm
	Bridging extrusion multiplier 100 🚔 %
	▲ % ▲ % ▲ % 0,0 ▲ mm/min 0,0 ▲

Рис.85

Понижение скорости при печати поддержки.

xtruder Layer Additions	Infill Support	Temperature Cooling G-Code Scripts Other Advanced
Speeds		Filament Properties
Default Printing Speed	3600,0 🚔 mm/min	Filament diameter 1,7500 💭 mm
Outline Underspeed	50 🔶 %	Filament price 46,00 price/kg
Solid Infill Underspeed	80 🚔 %	Filament density 1,25 🚔 grams/cm^3
Support Structure Underspeed	80 🚖 %	
X/Y Axis Movement Speed	4800,0 🚔 mm/min	Bridging
Z Axis Movement Speed	1000,0 🚖 mm/min	Unsupported area threshold 50,0 🚖 sq mm
		Extra inflation distance 0,00 🖨 mm
Dimensional Adjustments		Bridging extrusion multiplier 100 🔷 %
Horizontal size compensation	0.00 🚔 mm	Bridaina speed multiplier 100 🚔 %



Скорость движения осей «X/Y»

eral Settings					
Percentage:			15%	6 🔽 Include	Raft 🛛 🕅 Generate Supp
xtruder Layer Additions	Infill Support	Temperature	Cooling G-	Code Scripts	Other Advanced
Speeds		F	ilament Propertie	s	
Default Printing Speed	3600,0 🚔 mm/min	F	Filament diameter	1,7500 🗘 r	nm
Outline Underspeed	50 🌲 %	F	Filament price	46,00 🗘 p	orice/kg
Solid Infill Underspeed	80 🚔 %	F	Filament density	1,25 🗘	grams/cm^3
Support Structure Underspeed	80 🚔 %				
X/Y Axis Movement Speed	4800,0 🚔 mm/min	В	Bridging		
Z Axis Movement Speed	1000,0 🗦 mm/min	U	Unsupported area	threshold 50,0	sq mm
		E	Extra inflation dist	tance 0,00	💼 mm
Dimensional Adjustments		В	Bridging extrusion	multiplier 100	
Horizontal size compensation),00 🚖 mm	В	Bridging speed mu	ltiplier 100	÷ %

Рис. 86

Скорость движения по оси «Z».

truder Layer Additions	Infill Support	Temperature Cooling G-Code Scripts Other Advanced
peeds		Filament Properties
efault Printing Speed	3600,0 🚔 mm/min	Filament diameter 🔿 7500 テ mm
Outline Underspeed	50 🔶 %	Filament price 46,00 🚔 price/kg
olid Infill Underspeed	80 🚖 %	Filament density 1,25 🚔 grams/cm^3
upport Structure Underspeed	80 🔶 %	
/Y Axis Movement Speed	4800,0 🚔 mm/min	Bridging
Axis Movement Speed	1000,0 🚔 mm/min	Unsupported area threshold 50,0 sq mm
		Extra inflation distance 0,00 🖨 mm
imensional Adjustments		Bridging extrusion multiplier 100 🗣 %
	0.00 🖻 mm	

Рис.87 Диаметр филамента.

truder Layer Additions	Infill Support	Temperature	Cooling G-Code Scripts	Other Advanced
Speeds			Filament Properties	
Default Printing Speed	3600,0 🚔 mm/min		Filament diameter 1,7500 🚔 mm	
Dutline Underspeed	50 🌲 %	 	Filament price 🔰 46,00 🚔 pric	ie/kg
Solid Infill Underspeed	80 🚖 %		Filament density 1,25 🚔 gra	ms/cm^3
Support Structure Underspeed	80 🚖 %			
(/Y Axis Movement Speed	4800,0 🚔 mm/min		Bridging	
Z Axis Movement Speed	1000,0 🚔 mm/min		Unsupported area threshold 50,0	🚖 sq mm
			Extra inflation distance 0,00	🚔 mm
Dimensional Adjustments			Bridging extrusion multiplier 100	≑ %
) 00 🕒 mm		Bridging speed multiplier 100	A 9/

Рис.88

	.ge.				15	% 1	nciude Ra	Generate Sup
xtruder	Layer Add	itions Infill	Support	Temperature	Cooling (G-Code S	Scripts	Other Advanced
Speeds				(¹	Filament Propert	es		
Default P	rinting Speed	3600,0	🚖 mm/min		Filament diamete	er 1,7500	🔹 mm	
Outline U	nderspeed	50	€ %		Filament price	46,00	🚖 price	e/kg
Solid Infil	Underspeed	80	€ %	(Filament density	1,25	🗧 gran	ms/cm^3
Support S	Structure Unders	eed 80	€ %					
X/Y Axis I	Movement Speed	4800,0	🚖 mm/min		Bridging			
Z Axis Mo	vement Speed	1000,0	🗧 mm/min		Unsupported are	a threshold	50,0	≑ sq mm
					Extra inflation di	stance	0,00	🚖 mm
						1		A

Цена филамента.

Рис.89

Плотность филамента.

reitentage:		15% V Indude Kart V Geherate S
truder Layer Additions	Infill Support	Temperature Cooling G-Code Scripts Other Advanced
Speeds		Filament Properties
Default Printing Speed	3600,0 🚔 mm/min	Filament diameter 1,7500 🚔 mm
Outline Underspeed	50 🔷 %	Filament price 46,00 🚖 price/kg
Solid Infill Underspeed	80 🔹 %	Filament density 1,25 🚔 grams/cm^3
Support Structure Underspeed	80 🔹 %	
X/Y Axis Movement Speed	4800,0 🚔 mm/min	Bridging
Z Axis Movement Speed	1000,0 🚔 mm/min	Unsupported area threshold 0,0 👻 sq mm
		Extra inflation distance 0,00 荣 mm
Dimensional Adjustments		Bridging extrusion multiplier 100 👻 %
Horizontal size compensation).00 🚔 mm	Bridging speed multiplier 100 🔮 %



Seneral Settings								
Infill Percentage:					15%	V Include	Raft	Generate Support
Extruder Layer Addition	ıs Infill	Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced
Speeds				Filament Prop	erties			
Default Printing Speed	3600,0	🗧 mm/min		Filament diam	neter 1,750	00 ≑	mm	
Outline Underspeed	50	\$%		Filament price	46,00) 🌲	price/kg	
Solid Infill Underspeed	80	\$%		Filament dens	sity 1,25	*	grams/cm^	3
Support Structure Underspeed	80	\$%						
X/Y Axis Movement Speed	4800,0	🗧 mm/min		Bridging				
Z Axis Movement Speed	1000,0	🗧 mm/min		Unsupported	area thresh	old 50,0	:	sq mm
			<	Extra inflation	n distance	0,00		nm
Dimensional Adjustments				Bridging extru	usion multipl	ier 100	†	%
Horizontal size compensation	0,00 🚖 m	nm		Bridging spee	d multiplier	100	* *	%

Порог неподдерживаемой области.



Дополнительное расстояние инфляции.

•

Extruder	Layer Add	litions	Infil	Support	Temperature	Cooling	G-Code	Scripts	Other	Advanced
Speeds						Filament Prope	rties			
Default Pr	inting Speed	360	0,0 🚦	mm/min		Filament diame	eter 1,7500	≑ m	m	
Outline Ur	nderspeed	50		%		Filament price	46,00	🌲 pr	rice/kg	
Solid Infill	Underspeed	80		%		Filament densi	ty 1,25	🌲 gr	rams/cm^3	
Support S	tructure Unders	peed 80		%						
X/Y Axis M	lovement Speed	480	0,0 🚦	mm/min		Bridging				
Z Axis Mo	vement Speed	100	0,0	mm/min		Unsupported a	area threshold	d 50,0	≑ sq	mm
						Extra inflation	distance	0,00	≑ mn	n
Dimension	al Adjustments -				<	Bridging extrus	sion multiplier	100	\$ %	
Horizontal	size compensat	ion 0,00	🗧 m	m		Bridging speed	multiplier	100	\$ %	

Рис.92

Экструзия для моста.

General Settings					
Infill Percentage:			15% 🔽]	Include Raft	Generate Support
Extruder Layer Additions	s Infill Support T	Temperature Cooling	G-Code S	Scripts Othe	r Advanced
Speeds		Filament Pro	perties		
Default Printing Speed	3600,0 🚖 mm/min	Filament dia	meter 1,7500	🚖 mm	
Outline Underspeed	50 🚔 %	Filament pric	46,00	🗧 price/kg	
Solid Infill Underspeed	80 🚔 %	Filament der	nsity 1,25	🚖 grams/cm	^3
Support Structure Underspeed	80 🚖 %				
X/Y Axis Movement Speed	4800,0 🚔 mm/min	Bridging			
Z Axis Movement Speed	1000,0 ≑ mm/min	Unsupported	d area threshold	50,0 🚖	sq mm
		Extra inflatio	on distance	0,00 🔶	mm
Dimensional Adjustments		Bridging ext	rusion multiplier	100	%
Horizontal size compensation	0,00 🚔 mm	Bridging spe	ed multiplier	100 🗘	%

Рис.93

Скорость для печати моста.

cess Name: Process1cost		
ect Profile: new profile (modified)	Update Profile Save as New Remov
uto-Configure for Material		Auto-Configure for Print Quality
BS		Fast
aneral Settings		
		table Deft County Ourse
fill Percentage:		15% Include Raft Generate Suppo
Futurday Laway Additions	Trefil Conserve T	manuture Casting Code Carinte Other Advanced
Extruder Layer Additions		Emperature Cooling G-Code Scripts Outer Advanced
Speeds		Filament Properties
Default Printing Speed	3600,0 🚖 mm/min	Filament diameter 1,7500 🚔 mm
Outline Underspeed	50 🚖 %	Filament price 46,00 📄 price/kg
Solid Infill Underspeed	80 🚔 %	Filament density 1,25 🚔 grams/cm^3
Support Structure Underspeed	80 🖨 %	
X/Y Axis Movement Speed	4800,0 🚔 mm/min	Bridging
Z Axis Movement Speed	1000.0 🚔 mm/min	Unsupported area threshold 50,0 🚔 sq mm
		Extra inflation distance 0,00 🚔 mm
Dimensional Adjustments		Bridging extrusion multiplier 100 🚔 %
Horizontal size compensation),00 🚔 mm	Bridaina speed multiplier 100 🚔 %
riorizoritar size compensation re	100	

Рис.94

Для сохранения ваших настроек надо нажать клавишу «Save as New» (см. рис. 94)

📫 Profile Name	? <mark>×</mark>
Enter a name for the new	N profile.
new profile	
	OK Cancel

Рис.95

В появившемся окне укажите ваш новый профиль (см. рис.95)

После настройки слайсера можно создать G-Code, нажав на клавишу (см. рис. 96)







Рис.97

Для включения нагрева надо вызвать панель управления (см. рис. 97)





Установите желаемую температуру стола и включите нагрев, нажав клавишу «on» в строке «Heated Bed».





Чтобы запустить процесс печати, надо нажать клавишу «Begin Printing over USB» или сохранить на съемный носитель, клавиша «Save Toolpaths to Disk»