less Name: Process1						
ct Profile: New Printer(2) (m	odified)			<ul> <li>Update Prof</li> </ul>	file Save as N	New Remove
uto-Configure for Material		Aut	o-Configure f	for Print Quality		
'LA	•	Me     Me	dium			- 0 (
eneral Settings	Π					
fill Percentage:			2	0% 🔲 Include	e Raft	Generate Suppo
Extruder Layer Additi	ons Infill Support	Temperature	Cooling	G-Code Scripts	Other	Advanced
	Extruder Toolhead In Nozzle Diameter Extrusion Multiplier Extrusion Width ©	dex Tool 0 0.40 🚔 mm 0.90 🚔 Auto () Manual	0.40	mm		
	Ooze Control					
	Retraction	Retraction Distance	1.00	🚖 mm		
		Extra Restart Distanc	ce 0.00	🚖 mm		
		Retraction Vertical Lif	t 0.00			
		Retraction Speed	1800.0	🚔 mm/min		
Add Extruder	Coast at End	Coasting Distance	0.20	mm		
	Wipe Nozzle	Wipe Distance	5.00	mm w		
Remove Extruder						

lect Profile: New Printer(2) (modified)   Auto-Configure for Material   PLA   PLA   PLA   Color   General Settings   Infill Percentage:   20%   Indude Raft   Generate Sup   Extruder   Layer   Additions   Infill   Support   Temperature   Cooling   G-Code   Scripts   Other   Advanced   First Layer Settings First Layer Height 0.2000 mm Top Solid Layers 3 Start Points Outline/Perimeter Shells 2 Outline Direction: Inside-Out Outside-In Outside-In Update Profile Save as New Rem Auto-Configure for Print Quality Medium Medium Outside-In Update Profile Save as New Rem Rem Rem Cooling G-Code Scripts Other Advanced First Layer Settings First Layer Height 90 % First Layer Width 100 % First Layer Speed 50 % 6 Optimize start points for all perimeters © Optimize start points for fastest printing speed © Choose start point deset to specific location
Auto-Configure for Material     PLA     PLA     Auto-Configure for Print Quality     Medium     Medium     Medium     Medium     Primary Layer Additions     Infill     Support     Top Solid Layers     Bottom Solid Layers     Image: Cooling     Guttine/Perimeter Shells     Coutine/Perimeter Shells     Coutine Direction:     Inside-Out     Coutine Direction:     Auto-Configure for Print Quality     Medium     Medium     Medium     Quarter     Layer     Additions     Infill     Support     Temperature   Cooling   Gotting   Guttine/Perimeter Shells   Coutine Direction:     Inside-Out     Coutine Direction:     Inside-Out     Coutine Direction:     Inside-Out     Coutine Direction:     Inside-Out     Image: Content Configure for Print Quality     Medium     Medium     Medium     Inductor     Image: Content Configure for Print Quality
PLA <ul> <li>Medium</li> <li>Medium</li> <li>Medium</li> <li>Medium</li> </ul> eneral Settings              fill Percentage: <ul> <li>20%</li> <li>Include Raft</li> <li>Generate Support</li> </ul> Extruder         Layer         Additions         Infill         Support         Temperature         Cooling         G-Code         Scripts         Other         Advanced         Advanced         First Layer Settings         First Layer Settings         First Layer Settings         First Layer Height         90         %         %         First Layer Width         100         %         %         First Layer Settings         First Layer Width         100         %         %         First Layer Settings         First Layer Width         100         %         %         First Layer Settings         Start Points         Start Points         Start Points         Use random start points for all perimeters         ©         User random start points for fastest printing speed         ©         Choose start points for fastest printing         Printing         Printing         Printing         Printing         Printing
eneral Settings   fill Percentage:   20%   Include Raft   Cayer Settings   Primary Extruder   Primary Layer Height   0.2000   mm   Top Solid Layers   3   Outline/Perimeter Shells   2   Outline Direction:   Inside-Out   Outside-In
Extruder       Layer       Additions       Infill       Support       Temperature       Cooling       G-Code       Scripts       Other       Advanced         Layer Settings       Primary Extruder       Extruder 1                 First Layer Settings               First Layer Height 90              %             First Layer Height 90              %             First Layer Height 90              %             First Layer Width 100              %             First Layer Speed 50              %             Start Points             Outline/Perimeter Shells 2
Layer Settings   Primary Extruder   Extruder 1   Primary Layer Height   0.2000   mm   Top Solid Layers   3   Bottom Solid Layers   3   Outline/Perimeter Shells   2   Outline Direction:   Inside-Out   Outside-In   First Layer Settings First Layer Height 90   90
<ul> <li>Print islands sequentially without optimization</li> <li>Single outline corkscrew printing mode (vase mode)</li> <li>Cindose start point dosest to specific location</li> <li>X: 0.0 Y: 300.0 mm</li> </ul>

cess Name:	Process1						
ct Profile:	New Printer(2) (modifie	ed)		*	Update Profile	Save as New	Remove
uto-Configu	re for Material			Auto-Configure for Pr	int Quality		
LA		- C		Medium			- 🖸 🖕
eneral Settir fill Percenta	ngs age:			20%	🔲 Indude Rat	ft 📃 Gene	erate Support
Extruder	Layer Additions	Infill Support	Temperatu	re Cooling G-Co	ode Scripts	Other Adva	anced
	🔽 Use Skirt/Brim			🔲 Use Prime Pillar			
	Skirt Extruder	Extruder 1	•	Prime Pillar Extruder	All Extruders	*	
	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			Creates	s a pillar that is us	ed to prime the	e extruder af
	Raft Extruder	Extruder 1	*	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 🔺 %		

lect Profile: N Auto-Configure 1					
Auto-Configure	lew Printer(2) (modified)		•	Update Profile Save as	New Remove
	for Material		Auto-Configure for Pri	nt Quality	
PLA		- 🔾 🗢	Medium		- 🖸 🤇
General Settings	5				
infill Percentage	»		20%	🔲 Include Raft 🛛 🛛	Generate Suppor
Extruder	Layer Additions Infill s	Support Temperatu	re Cooling G-Coo	de Scripts Other	Advanced
	General		Infill Angle Offset	s	
	Infill Extruder Extruder 1	•	0 🚖 deg	45	
	Internal Fill Pattern Rectilinear		Add Angle	-45	
	External Fill Pattern Rectilinear	*	Remove Angle		
	Interior Fill Percentage 20	* %			
	Outline Overlap 15	* %			
	Infill Extrusion Width 100	* %			
	Minimum Infill Length 5.00	mm			
	Print Sparse Infill Every 1	layers			
	Include solid diaphragm ever	y 20 🔹 layers	Print every inf	fill angle on each layer	

cess mame.	Process1	
ect Profi <mark>l</mark> e:	New Printer(2) (modified)	▼ Update Profile Save as New Remove
uto-Configu	re for Material	Auto-Configure for Print Quality
PLA	- 💿 🕒	Medium 🔹 💽 🧲
eneral Settir	ngs	
nfill Percenta	ge: /	20% 🔲 Include Raft 📃 Generate Suppor
Extruder	Layer Additions Infill Support Temperat	ture Cooling G-Code Scripts Other Advanced
	■ Generate Support Material   Support Extruder Extruder 1   Support Infill Percentage 30   30 0   © 0   Extra Inflation Distance 0.00   Dense Support Layers 0   Dense Infill Percentage 70   Ø %   Print Support Every 1   Image: Support Every 1   Vertical Offset From Part 0.30   Upper Vertical Separation Layers 1   Image: Support Every 1	Only used if manual support is not defined   Support Type   Normal   Support Pillar Resolution   4.00   mm   Max Overhang Angle   45   Ø   deg   Add Angle   Remove Angle

ext Profile: New Printer(2) (modified)   uto-Configure for Material   Auto-Configure for Print Quality   PLA   Medium   eneral Settings nfill Percentage:   20%   Indude Raft Generate Support   Extruder   Layer   Additions   Infill   Support   Temperature   Cooling   G-Code   Scripts   Other   Advanced   Temperature Controller   Extruder 1 Temperature   Heated Bed   Overview   Temperature Controller   Wait for temperature Controller Type:   Extruder 1 Temperature   Heated Bed   Overview   Temperature Controller   Wait for temperature Between Each:   Layer   Layer   Temperature Controller   Wait for temperature Setpoints   Layer   Layer   Imperature Controller   Per-Layer Temperature   Add Temperature Controller   Add Temperature Controller   Remove Temperature Controller	cess Name: P	rocess1				
Auto-Configure for Material Auto-Configure for Print Quality Medium Additions Infill Support Temperature Controller  Add Temperature Controller  Add Temperature Controller  Add Temperature Controller	ct Profile: N	lew Printer(2) (modified)		▼)	Update Profile Save as New F	Remov
LA <ul> <li>Medium</li> <li>Medium&lt;</li></ul>	uto-Configure	for Material		Auto-Configure for Prin	nt Quality	
eneral Settings         fill Percentage:       20%       Indude Raft       Generate Support         Extruder       Layer       Additions       Infill       Support       Temperature       Cooling       G-Code       Scripts       Other       Advanced         Temperature Controller List (click item to edit settings)       Heated Bed       Heated Bed       Overview         Extruder 1 Temperature       Temperature Identifier       To       Temperature Controller       Temperature Controller Type:       Extruder       Heated build platform         Relay Temperature Between Each:       Layer       Loop       Wait for temperature Setpoints       Image: Temperature Setpoint         Layer       Temperature Setpoints       Image: Temperature Setpoint       Layer Temperature 200 © °C         Add Temperature Controller       Add Setpoint       Image: Setpoint       Layer Number 1       Image: Setpoint         Remove Temperature Controller       Remove Temperature Controller       O       °C       °C	LA		- 💿 💿	Medium	▼][	0
Extruder       Layer       Additions       Infill       Support       Temperature       Cooling       G-Code       Scripts       Other       Advanced         Temperature Controller List (click item to edit settings)       Heated Bed Temperature         Extruder 1 Temperature Heated Bed       Overview         Temperature Controller Types:       Extruder       Heated build platform         Relay Temperature Between Each:       Layer       Loop         Wait for temperature Setpoints       Per-Layer Temperature       Add Setpoint         Layer       Temperature 200       °C	eneral Settings fill Percentage	· · · · · · · · · · · · · · · · · · ·		20%	Include Raft Generate	Suppo
Relay Temperature Between Each: Layer Loop   Wait for temperature controller to stabilize before beginning build     Per-Layer Temperature Setpoints   Layer Temperature   Add Setpoint   Layer Number   Add Temperature Controller     Remove Temperature Controller	Temp (dick Extruder 1 To Heated Bed	erature Controller List k item to edit settings) emperature	Heated Bed Overview Temperature Identifi Temperature Contro	Temperature	● ● Heated build platform	
Layer       Temperature       Add Setpoint         1       70       Remove Setpoint         Layer Number       1       1         Add Temperature Controller       Add Temperature Controller       Image: Controller				25-25 ( <u>15-25</u> )	10.00	
I 70     Remove Setpoint     Layer Number     Layer Number     Temperature Controller     Remove Temperature Controller			Relay Temperature E	Between Each: 🔲 Layer ature controller to stabilize ure Setpoints	r 🔲 Loop e before beginning build	
Add Temperature Controller           Remove Temperature Controller			Relay Temperature E Wait for temperature Per-Layer Temperature Layer	Between Each: 🔲 Layer ature controller to stabilize ure Setpoints Temperature	r 🔲 Loop e before beginning build Add Setpoint	20
Remove Temperature Controller			Relay Temperature E Wait for temperature Per-Layer Temperature Layer	Between Each: 🔲 Layer ature controller to stabilize ure Setpoints Temperature 70	r 🔲 Loop e before beginning build Add Setpoint Remove Setpoint Layer Number 1 🐳 Temperature 200 🐳 °C	
	Add	Temperature Controller	Relay Temperature E Wait for temperature E Per-Layer Temperature Layer	Between Each: 🔲 Layer ature controller to stabilize ure Setpoints Temperature 70	r Loop e before beginning build Add Setpoint Remove Setpoint Layer Number 1 🐳 Temperature 200 🐳 °C	

cess Name:	Process1		
ect Profi <mark>l</mark> e:	New Printer(2) (modi	fied)	▼ Update Profile Save as New Remove
uto-Configu	re for Material		Auto-Configure for Print Quality
PLA		- 💿 🕒	Medium 🔻 💽 🤇
eneral Setti nfill Percenti	ngs age:		20% 🔲 Include Raft 📃 Generate Suppor
Extruder	Layer Additions	Infill Support Temperatu	re Cooling G-Code Scripts Other Advanced
Per-Laye	r Fan Controls		Speed Overrides
Layer	Fan Speed	Add Setpoint	Adjust printing speed for layers below 15.0 🚔 sec
1	0	Remove Setpoint	Allow speed reductions down to 20 🚔 %
2	100	Layer Number 1	
		Fan Speed 60 🚔 %	Fan Overrides
			Increase fan speed for layers below 45.0 = sec
			Maximum cooling fan speed 100 - %
Fan Optio	ons		
📃 Blip f	an to full power when i	ncreasing from idle	

cess Name:	Process1												
ct Profile:	New Printer	(2) (modified	J)					🔹 Up	odate Pr	ofile Sav	e as Nev	Rem	ove
uto-Configur	e for Materia	al				Auto-Co	nfigure fo	or Print Q	uality				
LA				•	•	Medium	la la					- 0	0
eneral Settin Ifill Percenta	igs ge:						20	1% [	Inclu	de Raft	C G	enerate Sup	port
Extruder	Layer	Additions	Infill	Support	Temperatur	e Coo	ling (	G-Code	Scrip	ts Othe	er Ar	dvanced	
<ul> <li>SD fin</li> <li>Relati</li> <li>Allow</li> <li>Use in</li> <li>Includ</li> <li>Firmw</li> <li>Apply</li> </ul>	mware (inclue ve extrusion zeroing of ex dependent e de M101/M10 vare supports toolhead off	de E-dimensi distances ktrusion dista extruder axe 2/M103 com s "sticky" par sets to G-Co	on) ances (i.e. s mands ameters ode coordi	G92 E0) nates	Machine Build vol Origin o Homing Flip build Toolhead	type Ca ) lume 254 ffset 0.0 dir Min d table axis d offsets	rtesian ro (-Axis .0 .0 .0 .0 .0 .0 .0 .0 .0 .0 .0	bot (rect Y-/ Over 0.0 Min	Axis rides th T Z X X	volume) Z-Axis e current l 0.0 (Min	Machine	e Dimensio n 0 €	ns w
Offset (	X-Axis	Y-Axis 0.00	Z-Axis	mm	Vpda Firmwar Gi Baud ra	e type Re PX profile te 25000	re Config epRap (M Replicat	uration arlin/Rep or 2 (def	etier/Sp ault conf	rinter) ig)		▼ ▼ bits/sec	

ess Name:	Process	1													
ct Profi <mark>l</mark> e:	New Prin	nter(2) (modifie	d)					•	Update	Profile	Save	as New		Rem	ove
ito-Configur	re for Mat	erial					Auto-Configu	re for Prir	nt Quality	-					
LA				•	0		Medium						•	0	C
neral Settin	ngs														
fill Percenta	age: —							20%	🔲 In	dude Ra	aft	🔲 Ge	nerate	e Sup	por
	-	Ū.													
Extruder	Layer	Additions	Infill	Support	Tempera	ature	Cooling	G-Cod	le Sc	ripts	Other	Ad	vance	d	-
Starting	Script	Layer Change	Script	Retraction	Script	Tool (	Change Script	Endir	ng Script						
														- I I	
M104 S0 M140 S0 M84 ; dis G28	0 ; turn of 0 ; turn of isable mot	f extruder f bed ors Cors G28 tells	s printer	r to return h	home whe	en do	one								
M104 S0 M140 S0 M84 ; dis G28	0 ; turn of 0 ; turn of isable mot	f extruder f bed ors <del>C</del> G28 tells	s printer	r to return h	home whe	en do	one								
M104 S0 M140 S0 M84 ; dis G28	0 ; turn of 0 ; turn of isable mot	f extruder f bed ors G28 tells	s printer	r to return h	home whe	en do	one				Cu	stom G	-Cod	e tha	it is
M104 S0 M140 S0 M84 ; dis G28	) ; turn of ) ; turn of isable mot	f extruder f bed ors G28 tells	s printer	r to return h	home whe	en do	one				Cu	stom G	-Cod	e tha	it is
M104 S0 M140 S0 M84 ; dis G28 Post Proce	0 ; turn of 0 ; turn of isable mot ressing te .x3g file	f extruder f bed ors G28 tells	printers u	r to return h	home whe	en do	one Firmware Con	figuration	for conv	ersion s	Cu settings	stom G	i-Cod	e tha	it is
M 104 SO M140 SO M84 ; dis G28 Post Proce	) ; turn of ) ; turn of isable mot essing te .x3g file Add cele	f extruder f bed ors G28 tells G28 tells for MakerBot p pration at end c	printers u	r to return h using GPX plu	ngin (see Tor	en do ols > l	one Firmware Con	figuration	for conv	ersion s	Cu settings]	stom G	-Cod	e tha	it is
M 104 S0 M140 S0 M84 ; dis G28 Post Proce	0 ; turn of 0 ; turn of isable mot essing te .x3g file Add celet	f extruder f bed ors G28 tells e for MakerBot p oration at end o oot file for 5th 0	printers u of build (f	using GPX plu for .x3g files	home whe	ols > andom	one Firmware Con	figuration	for conv	ersion s	Cu settings)	stom G	i-Cod	e tha	it is
M104 S0 M140 S0 M84 ; dis G28 Post Proce Creat	); turn of ); turn of isable mot sable mot essing te .x3g file Add celet te .makerb	f extruder f bed ors <b>G28 tells</b> e for MakerBot p oration at end o oot file for 5th G	printers u of build (f Gen Make	using GPX plu for .x3g files erBot printers	ngin (see Tor only) Ra	ols >	Firmware Con	figuration	for conv	ersion s	Cu	stom G	i-Cod	e tha	it is
M 104 S0 M140 S0 M84 ; dis G28 Post Proce Creat	); turn of ); turn of isable mot sable mot essing te .x3g file Add celet te .makerb al terminal	f extruder f bed ors G28 tells e for MakerBot p oration at end o pot file for 5th G commands for p	printers u of build (f Gen Make	r to return h using GPX plu for .x3g files erBot printers cessing	ngin (see Tor only) Ra	ols > ndom	one Firmware Con n Song ▼	figuration	for conv	ersion s	Cu	stom G	-Cod	e tha	ıt is
M 104 S0 M140 S0 M84 ; dis G28 Post Proce Creat	0 ; turn of 0 ; turn of isable mot sable mot eessing te .x3g file te .makerb al terminal	f extruder f bed ors G28 tells e for MakerBot p oration at end o oot file for 5th G commands for p	printers u of build (f Gen Make	using GPX plu for .x3g files erBot printers	ngin (see Too only) Ra	ols > ndom	one Firmware Con	figuration	for conv	ersion s	Cu settings	stom G	i-Cod	e tha	it is

	Process 1								
ct Profile:	New Printer(2) (modi	fied)				▼ Upda	te Profile	e Sav	ve as New Remo
uto-Configur	re for Material				Auto-Configure for	Print Qua	lity		
LA			-		Medium				- 0
eneral Settin	ngs								
fill Percenta	ge:				201	%	Include I	Raft	🔲 Generate Supp
Extruder	Layer Additions	Infill	Support Te	emperature	e Cooling G	-Code	Scripts	Oth	er Advanced
-Speeds					Filament Properties				
Default Pr	rinting Speed	3600.0	mm/min		Filament diameter	1.7500	🖨 mn	1	
Outline Ur	nderspeed	50	%		Filament price	46.00	🌻 pri	ce/kg	
Solid Infill	Underspeed	80	%		Filament density	1.25	😫 gra	ams/cm	^3
Support S	Structure Underspeed	80	%						
X/Y Axis M	Movement Speed	4800.0	mm/min	6	Bridging		12000		
Z Axis Mo	vement Speed	1000.0	mm/min		Unsupported area	threshold	50.0	<b></b>	sq mm
					Extra inflation dist	ance	0.00	1	mm
Dimension	nal Adjustments	-			Bridging extrusion	multiplier	100	1	%
Horizonta	l size compensation	).00 🚖 m	m		Bridging speed mul	tiplier	100	-	%

tess Name: Process1		
ct Profile: New Printer(2) (m	odified)	▼ Update Profile Save as New Remov
uto-Configure for Material		Auto-Configure for Print Quality
LA	- 🖸 🕻	Medium
eneral Settings fill Percentage:		20% 🔲 Include Raft 📃 Generate Suppo
Extruder Layer Additio	ons Infill Support Temp	perature Cooling G-Code Scripts Other Advanced
<ul> <li>Start printing at height</li> <li>Stop printing at height</li> <li>Slicing Behavior</li> <li>Non-manifold segments: </li> </ul>	0.00 🛊 mm 0.00 🛊 mm Discard 💿 Heal	<ul> <li>Only retract when crossing open spaces</li> <li>Force retraction between layers</li> <li>Minimum travel for retraction 3.00 mm</li> <li>Perform retraction during wipe movement</li> <li>Only wipe extruder for outer-most perimeters</li> </ul>
Merge all outlines into a s	ingle solid model	Movement Behavior Avoid crossing outline for travel movements
Only use perimeters for t	hin walls	Maximum allowed detour factor 3.0
Allow gap fill when neces Allowed perimeter overlap	sary 10 🚔 %	Tool Change Retraction
		Tool change retraction distance12.00mmTool change extra restart distance-0.50mmTool change retraction speed600.0mm/min