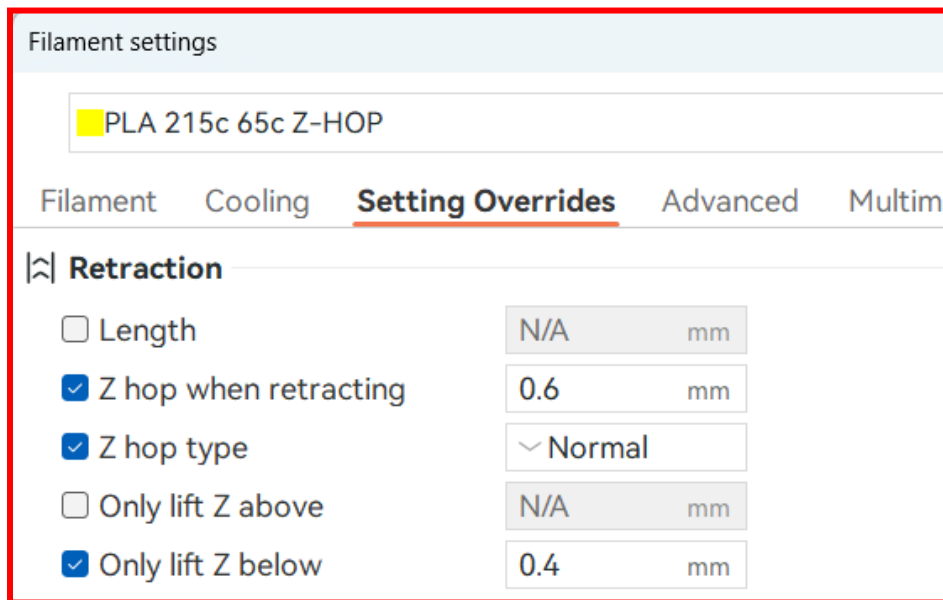


# ***Inlay Technique with ORCA slicer***

## **STEP 1 - Create a setup in Orca**

1. Create a filament with Z-HOP  
(These settings are for a layer height of 0.2 and a two layer tall inlay of 0.4)



Filament settings

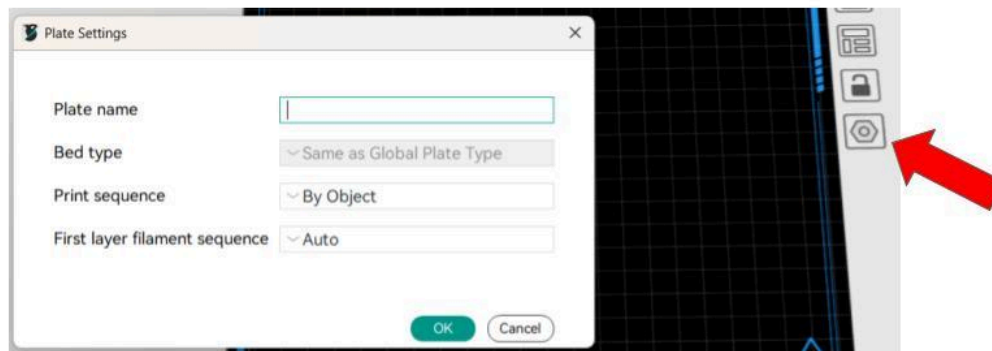
PLA 215c 65c Z-HOP

Filament Cooling **Setting Overrides** Advanced Multima

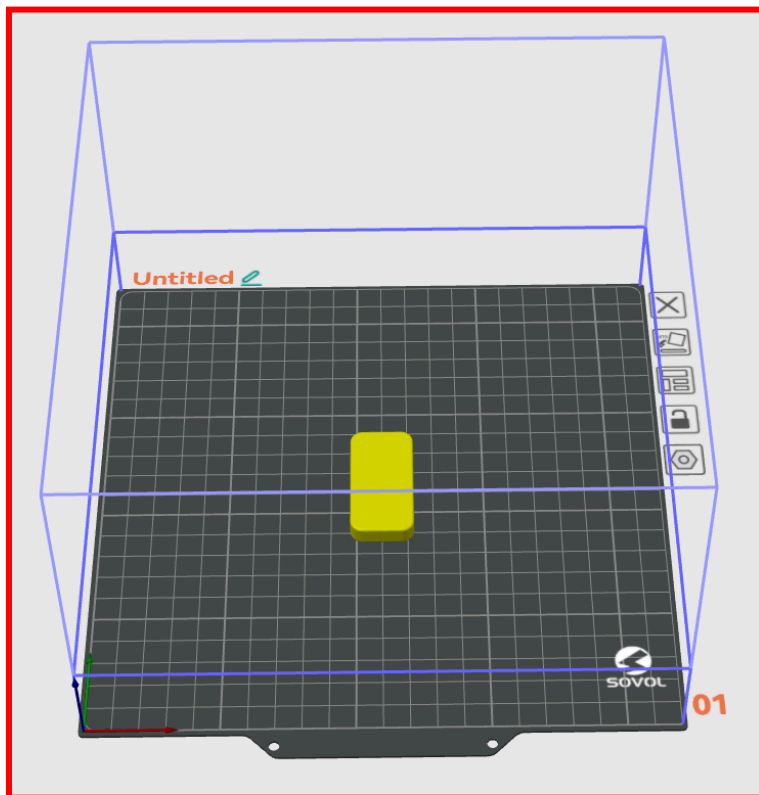
**Retraction**

<input type="checkbox"/> Length	N/A	mm
<input checked="" type="checkbox"/> Z hop when retracting	0.6	mm
<input checked="" type="checkbox"/> Z hop type	~ Normal	
<input type="checkbox"/> Only lift Z above	N/A	mm
<input checked="" type="checkbox"/> Only lift Z below	0.4	mm

2. Adjust the plate Print Sequence to "By Object"



3. Your build plate will have this blue wire frame to show the print-by-object boundaries.



If you want to get rid of them, change your extruder clearances to 1:

Printer settings

▼ Sovol SV07

**Basic information** Machine G-code Multimaterial

G-code thumbnails 32x32, 300x300

Format of G-code thumbnails ▼ PNG

Use relative E distances ☒

Use firmware retraction ☐

Time cost 0 money/h

**Cooling Fan**

Fan speed-up time 0.5 s Only on

Fan kick-start time 0.2 s

**Extruder Clearance**

Radius 1 mm

Height to rod 1 mm

Height to lid 1 mm

## STEP 2 - Import your parts

Import the main part into Orca (not the inlay)

Right click and choose ADD PART - LOAD and add the inlay part

Switch to Objects mode and change the inlay to filament 2

Name		Fila.
✓ Plate 1		
✓ Group 11 8 thru 10 tiles.stl	✓	1
✚ Group 11 8 thru 10 tiles.stl		1
✚ Group 11 8 thru 10 inlay.stl		2

Slice the plate and preview. Use the path and layer sliders to check your setup. On the first layer, it will print the main part first, then the inlay. On the second layer, it should continue with the inlay filament, then switch to the main part filament.

