Bear X axis and Extruder

Print Settings

⚠ Warning

1. The parts have been designed and tested with the parameters below and it is important to follow them to avoid issues like part cracking, bad bridging, not enough stiffness or wrong tolerances.
2. Be sure to have a well calibrated machine and extruder. Check our guide here for calibrating extrusion multiplier

Parameters

- Slicer: PrusaSlicer
- Infill type : Gyroid recommended
- Support : No
- Brim : No
- Detect thin walls : No
- Perimeters width (internal and external) : 0.45mm

Part	Quantity	Layer Height	Infill	Perimeters	Top/Bottom Layers	Filament type	Color
cable_guide_back_a	1	0.20mm	20%	4	5	PETG	
cable_guide_back_b	1	0.20mm	20%	4	5	PETG	
extruder_body	1	0.20mm	20%	4	5	PETG	Black
extruder_cover	1	0.20mm	20%	4	5	PETG	
extruder_idler	1	0.20mm	20%	4	5	PETG	
filament_sensor_cover	1	0.20mm	20%	4	5	PETG	Black
filament_sensor_lever	1	0.20mm	20%	4	5	PETG[1]	Black
hotend_collet_clip	1	0.20mm	20%	3	5	PETG	
nozzle_fan_duct	1	0.20mm	20%	3	5	Read note[2] below	
ptfe_cutter_50mm_60deg	1	0.20mm	20%	3-4	5	PETG	
x_carriage	1	0.20mm	20%	4	5	PETG	
x_carriage_back	1	0.20mm	20%	3	5	PETG	
x_end_idler	1	0.20mm	20%	4	5	PETG	
x_end_idler_tensioner	1	0.20mm	20%	4	5	PETG	
x_end_motor	1	0.20mm	20%	4	5	PETG	

> Note[1]: Avoid eSUN PETG as some user reported that it might not block IR signal correctly. No other PETG have been reported to have this issue yet.

> Note[2]: The nozzle_fan_duct needs to be printed with a heat resistant filament like ABS, Extrudr GreenTec Pro, annealed HTPLA,

> PC and probably much more. Don't forget to compensate for shrinkage accordingly to the filament type you are using.