

# 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

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	Black
hotend_collet_clip	1	0.20mm	20%	3	5	PETG	
nozzle_fan_duct	1	0.20mm	20%	3	5	Read note <sup>1</sup> bellow	
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<sup>1</sup>: The nozzle\_fan\_duct needs to be printed with a heat resistant filament like ABS, Extruder GreenTec Pro, annealed HTPLA, PC and probably much more. Don't forget to compensate for shrinkage accordingly to the filament type you are using.