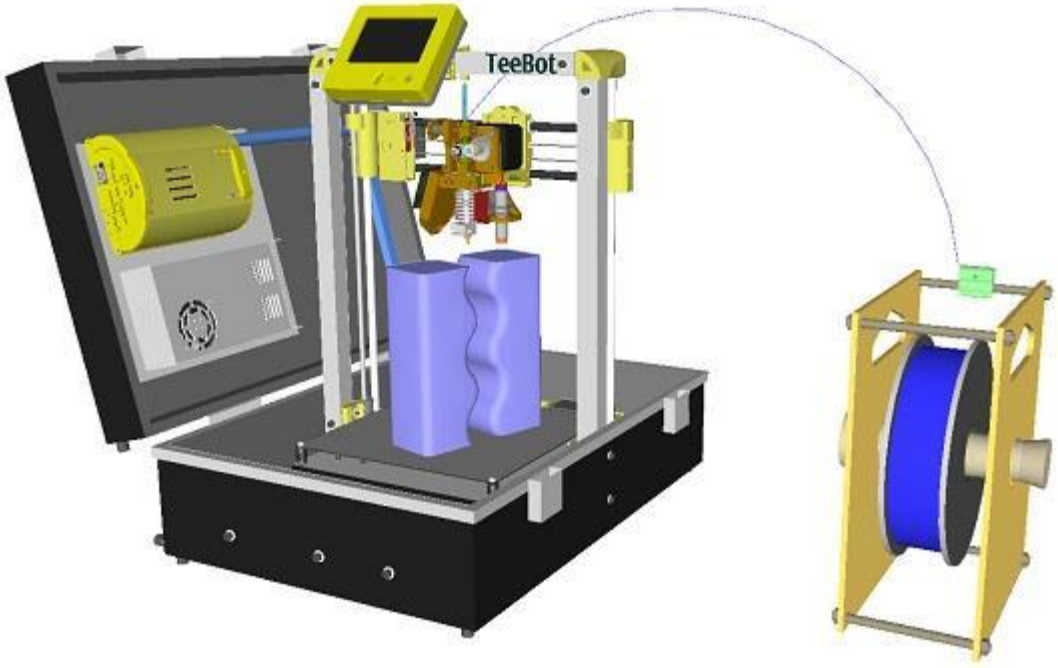


BY:

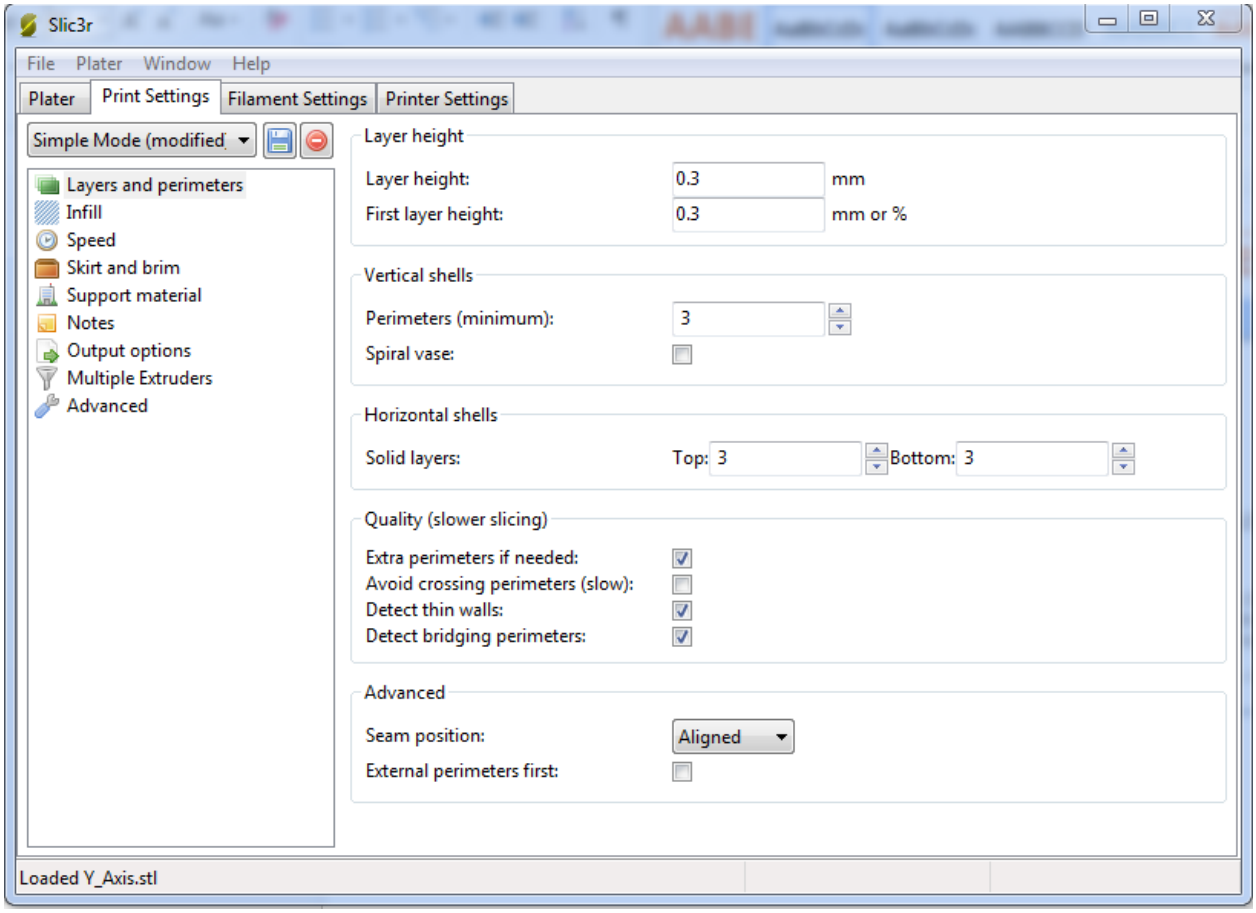
3DSTUFFSNL

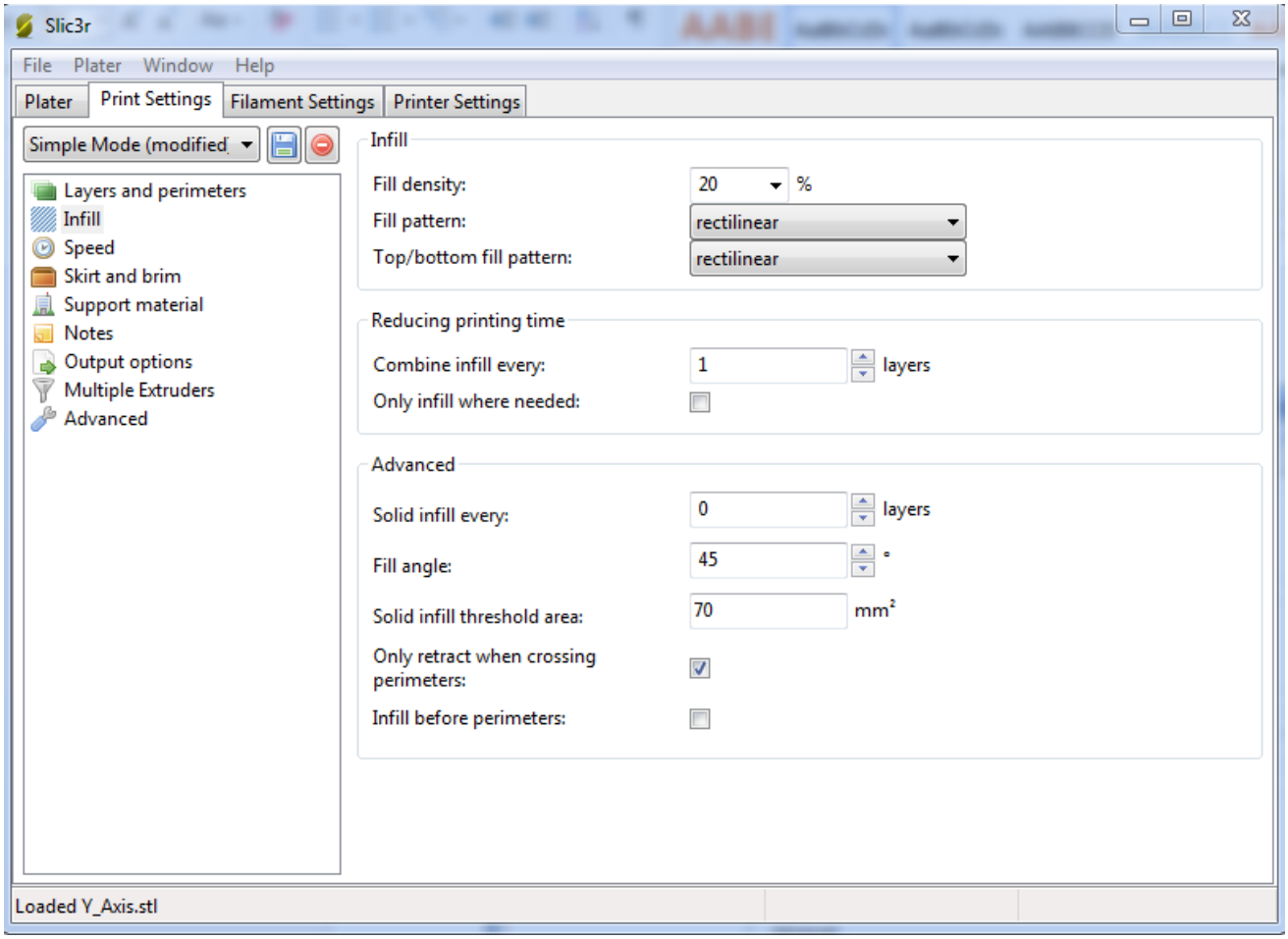
EINDHOVEN

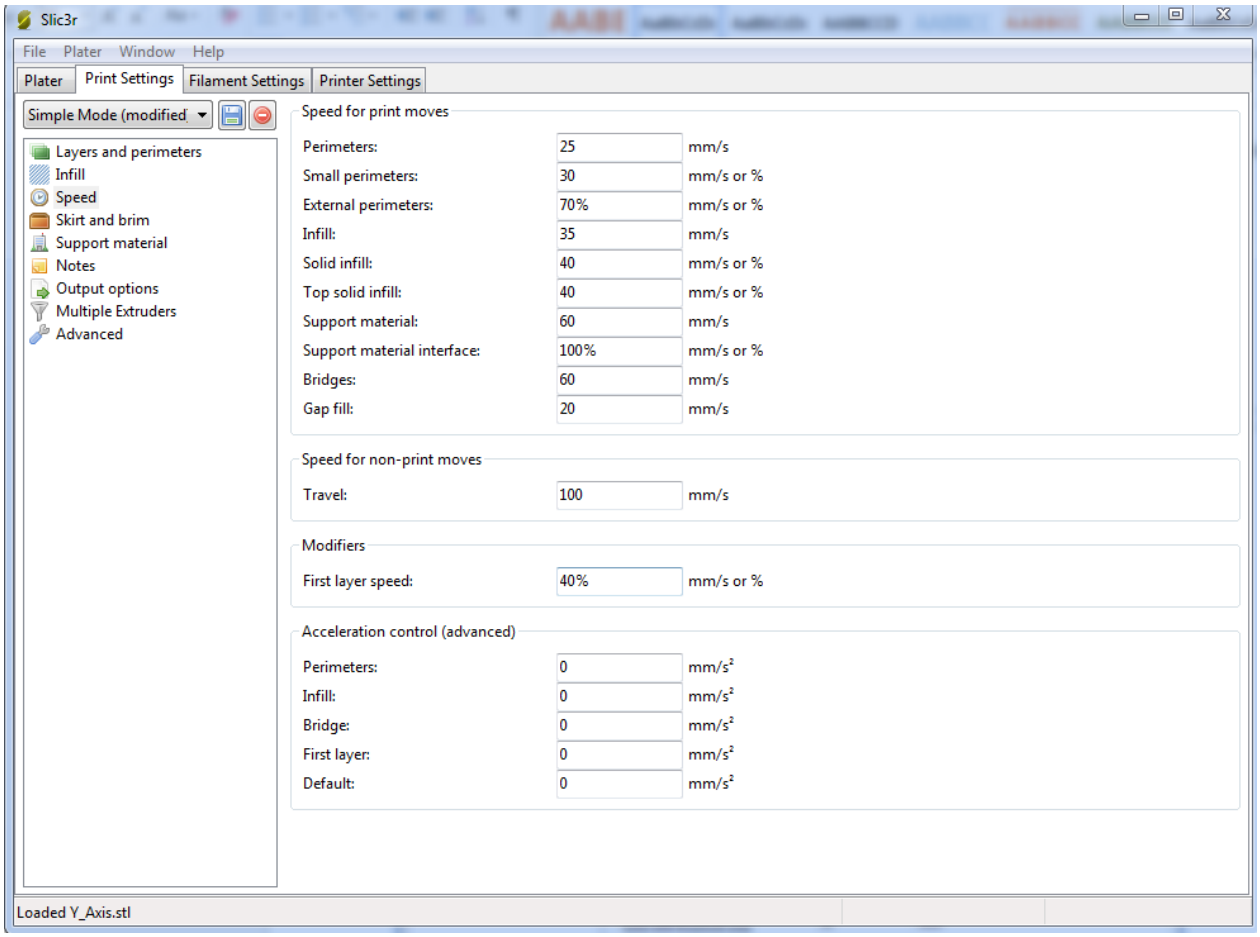
THE NETHERLANDS

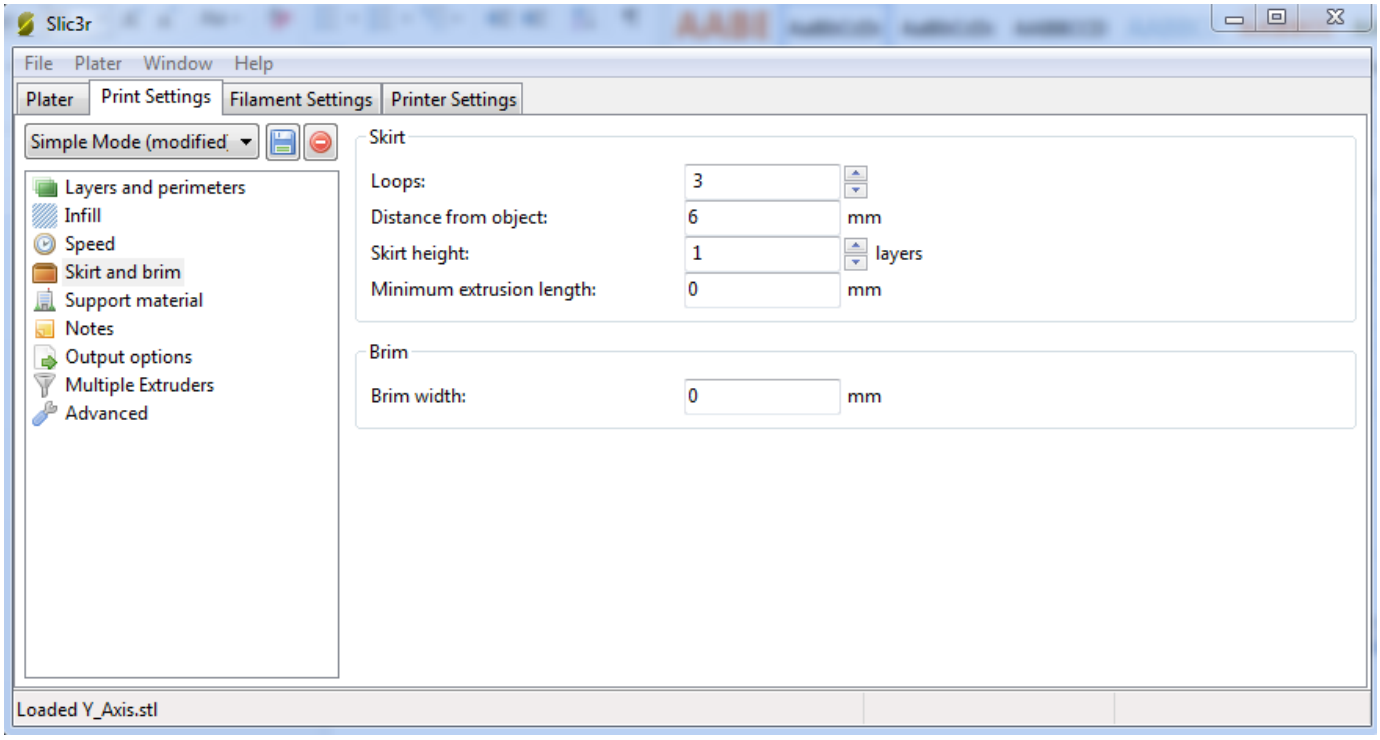
3DstuffsNL
Dream and Create

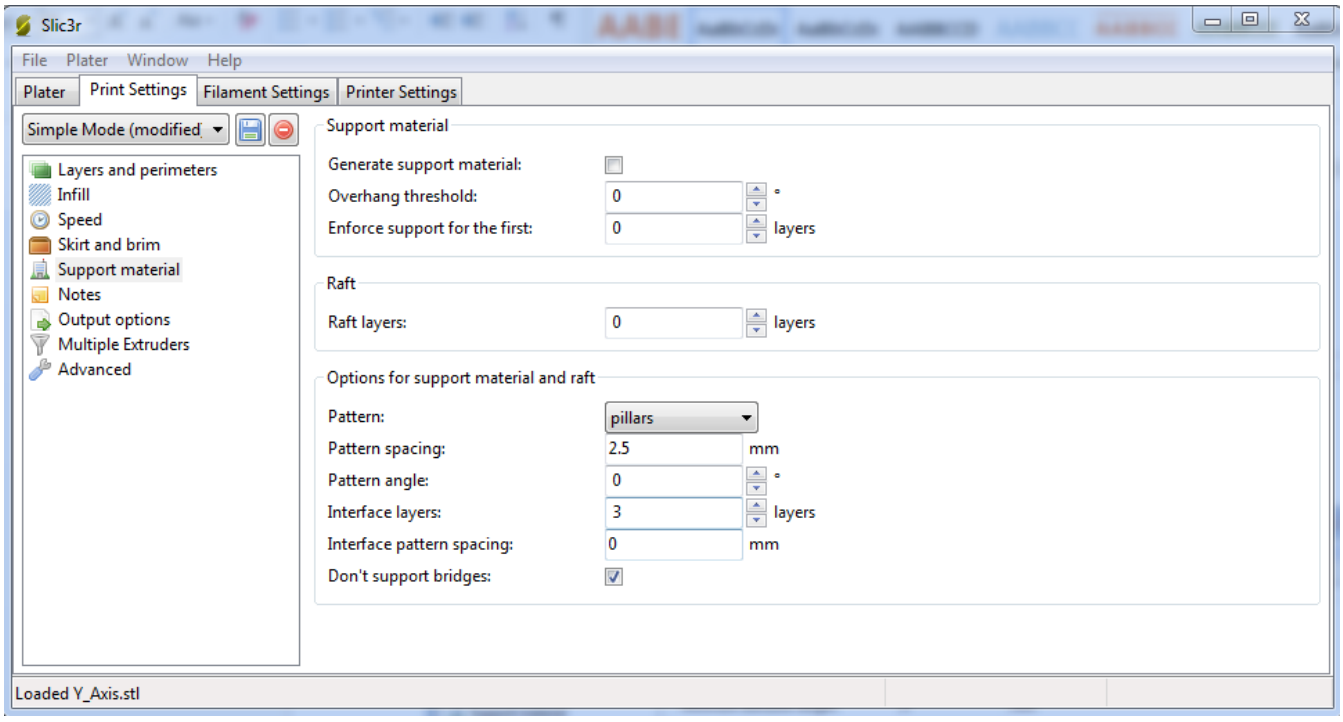
SLICR SETTINGS FOR GENERATING GCODES

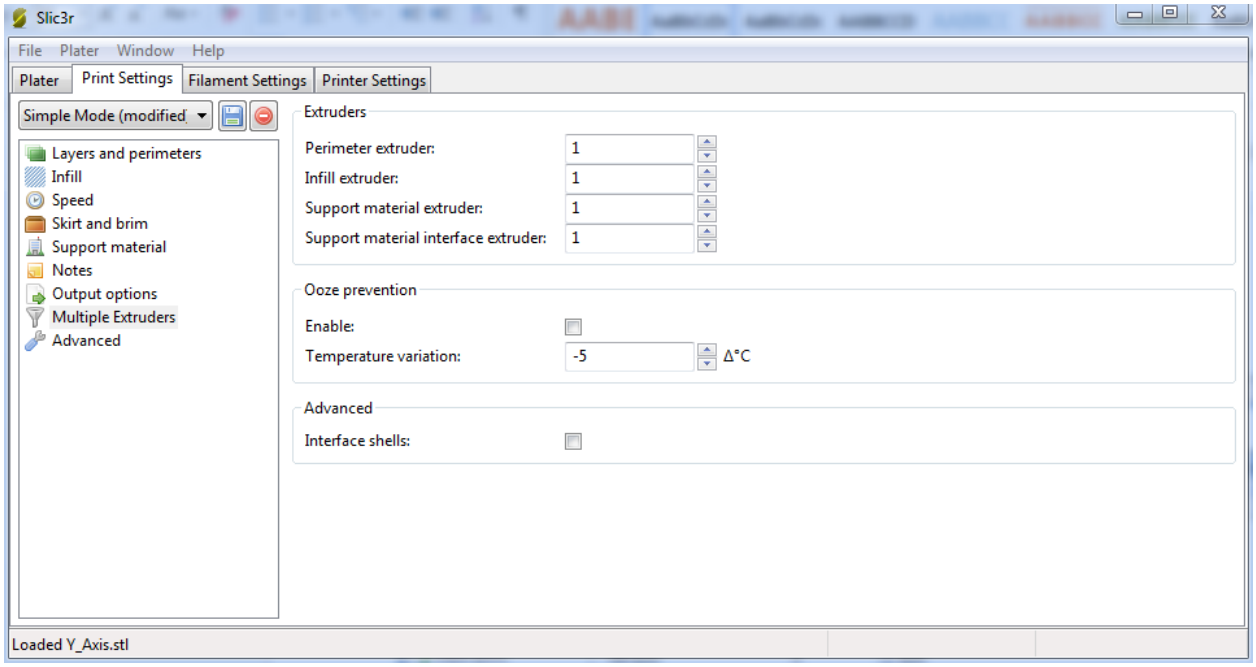

Slic3r
File
Plater
Window
Help
Plater
Print Settings
Filament Settings
Printer Settings
Simple Mode (modified
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Layer height
Layer height:
0.3
mm
First layer height:
0.3
mm or %
Vertical shells
Perimeters (minimum):
3
Spiral vase:
Horizontal shells
Solid layers:
Top:
3
Bottom:
3
Quality (slower slicing)
Extra perimeters if needed:
Avoid crossing perimeters (slow):
Detect thin walls:
Detect bridging perimeters:
Advanced
Seam position:
Aligned
External perimeters first:
Loaded Y_Axis.stl

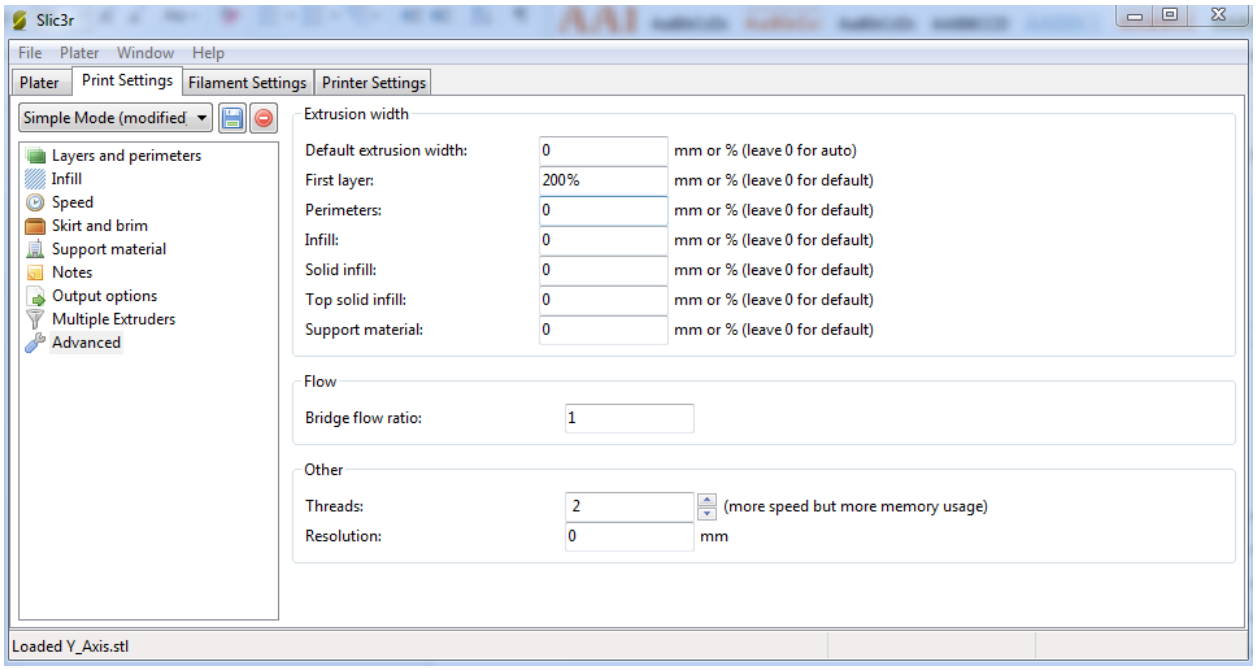

Slic3r
File
Plater
Window
Help
Plater
Print Settings
Filament Settings
Printer Settings
Simple Mode (modified)
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Infill
Fill density:
20
%
Fill pattern:
rectilinear
Top/bottom fill pattern:
rectilinear
Reducing printing time
Combine infill every:
1
layers
Only infill where needed:
Advanced
Solid infill every:
0
layers
Fill angle:
45
°
Solid infill threshold area:
70
mm²
Only retract when crossing perimeters:
Infill before perimeters:
Loaded Y_Axis.stl

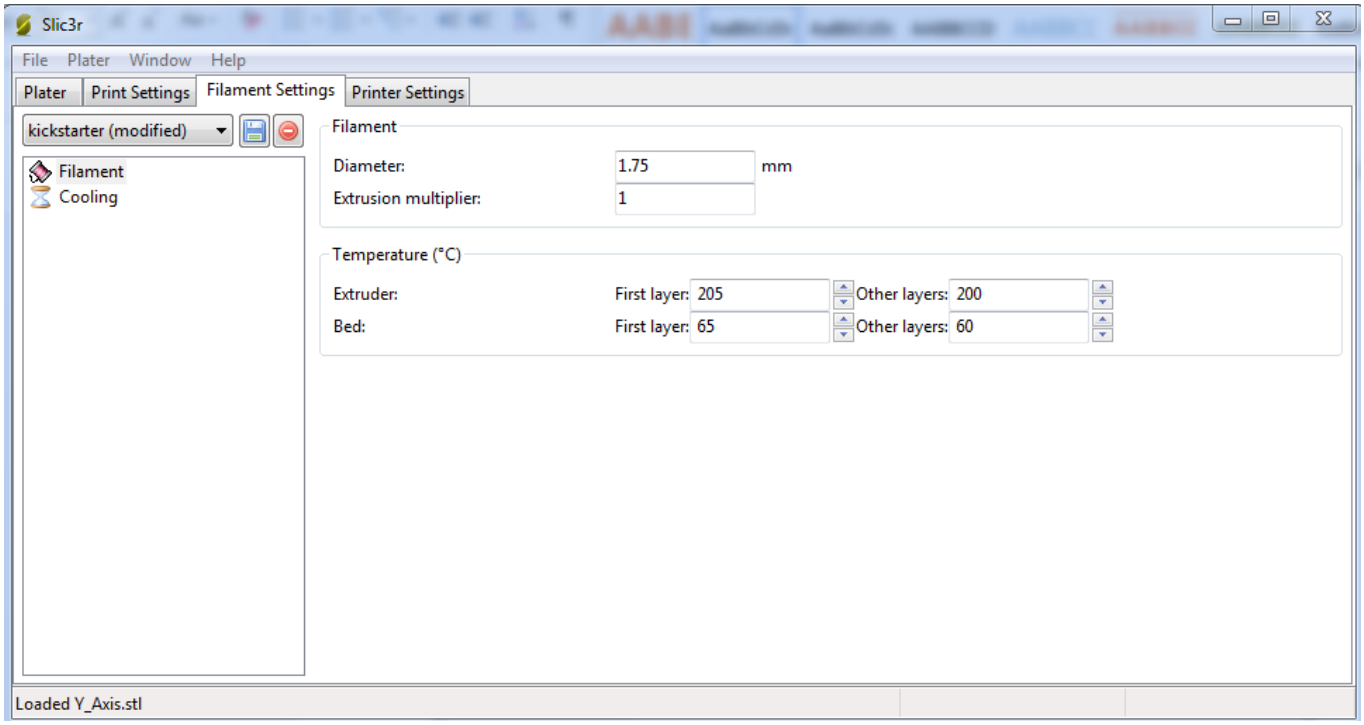

Slic3r
File Plater Window Help
Plater
Print Settings
Filament Settings
Printer Settings
Simple Mode (modified
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Speed for print moves
Perimeters: 25 mm/s
Small perimeters: 30 mm/s or %
External perimeters: 70% mm/s or %
Infill: 35 mm/s
Solid infill: 40 mm/s or %
Top solid infill: 40 mm/s or %
Support material: 60 mm/s
Support material interface: 100% mm/s or %
Bridges: 60 mm/s
Gap fill: 20 mm/s
Speed for non-print moves
Travel: 100 mm/s
Modifiers
First layer speed: 40% mm/s or %
Acceleration control (advanced)
Perimeters: 0 mm/s²
Infill: 0 mm/s²
Bridge: 0 mm/s²
First layer: 0 mm/s²
Default: 0 mm/s²
Loaded Y_Axis.stl

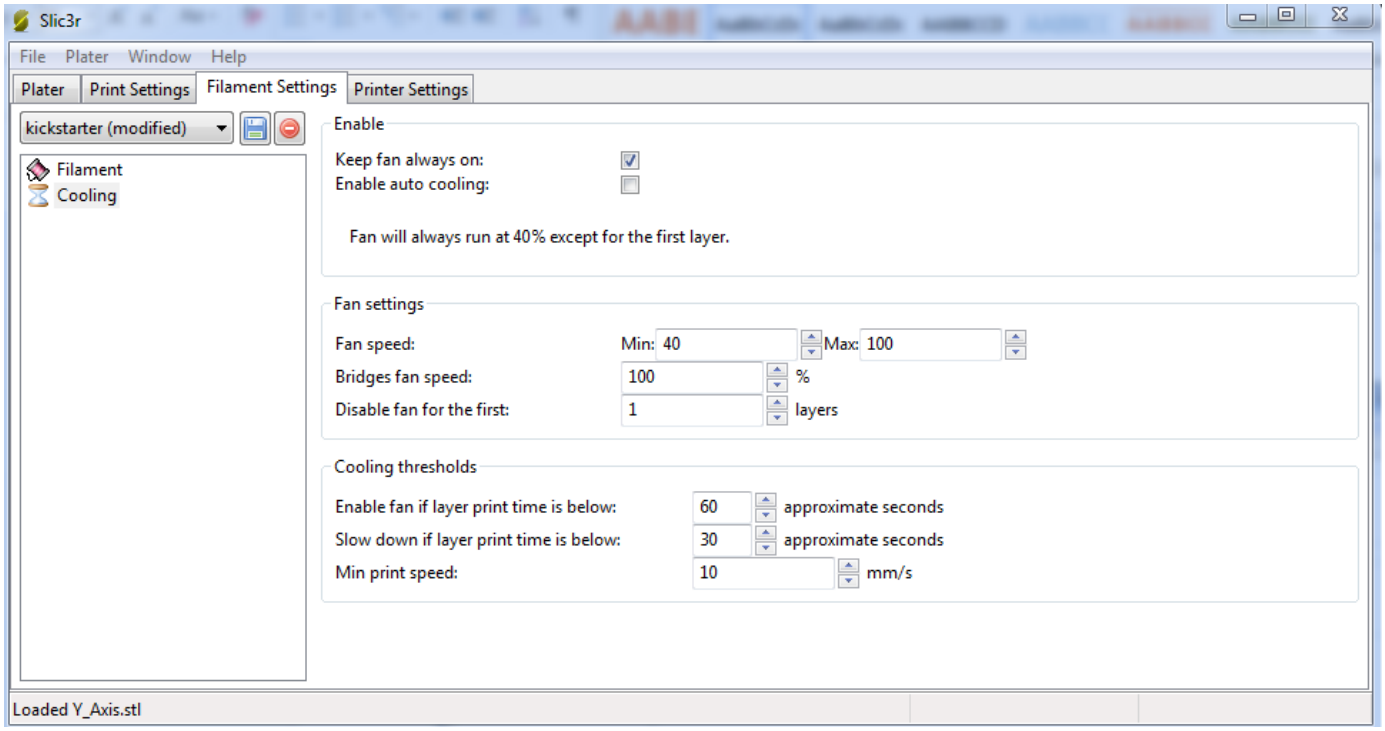

Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
Simple Mode (modified
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Skirt
Loops: 3
Distance from object: 6 mm
Skirt height: 1 layers
Minimum extrusion length: 0 mm
Brim
Brim width: 0 mm
Loaded Y_Axis.stl

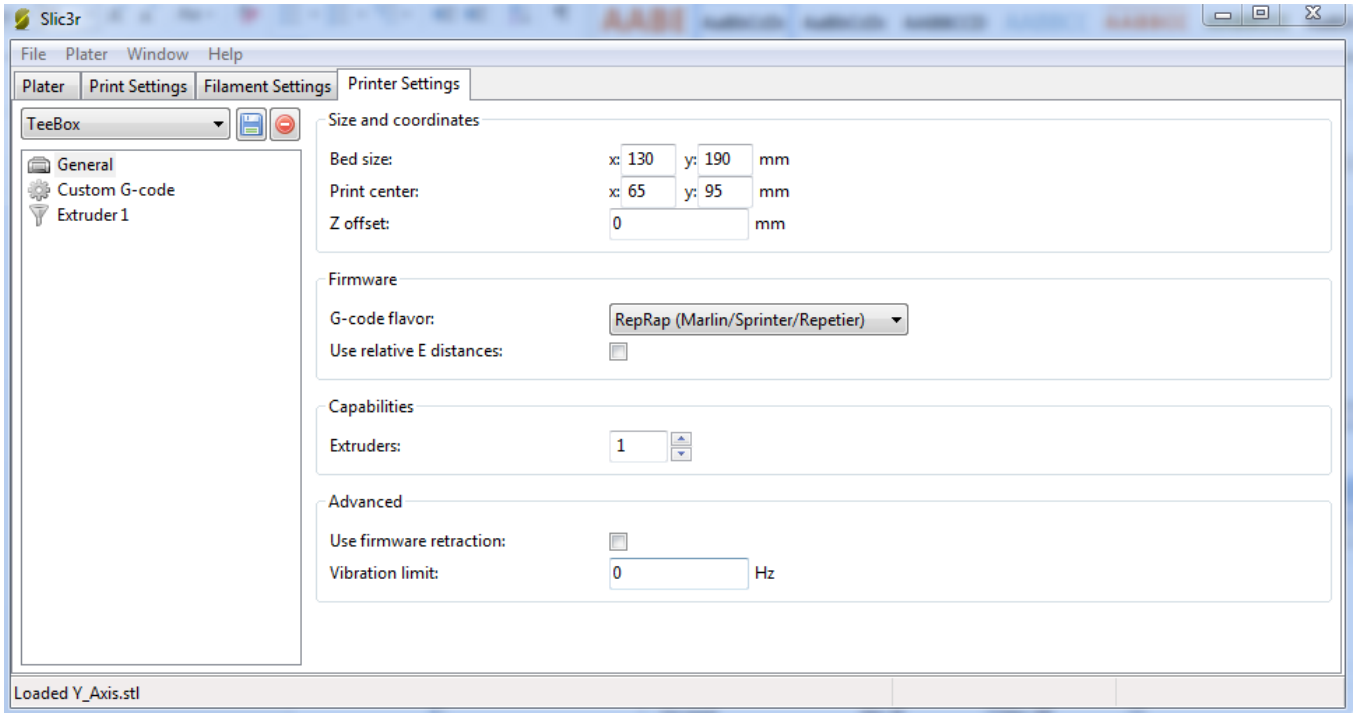

Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
Simple Mode (modified
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Support material
Generate support material:
Overhang threshold: 0 °
Enforce support for the first: 0 layers
Raft
Raft layers: 0 layers
Options for support material and raft
Pattern: pillars
Pattern spacing: 2.5 mm
Pattern angle: 0 °
Interface layers: 3 layers
Interface pattern spacing: 0 mm
Don't support bridges:
Loaded Y_Axis.stl

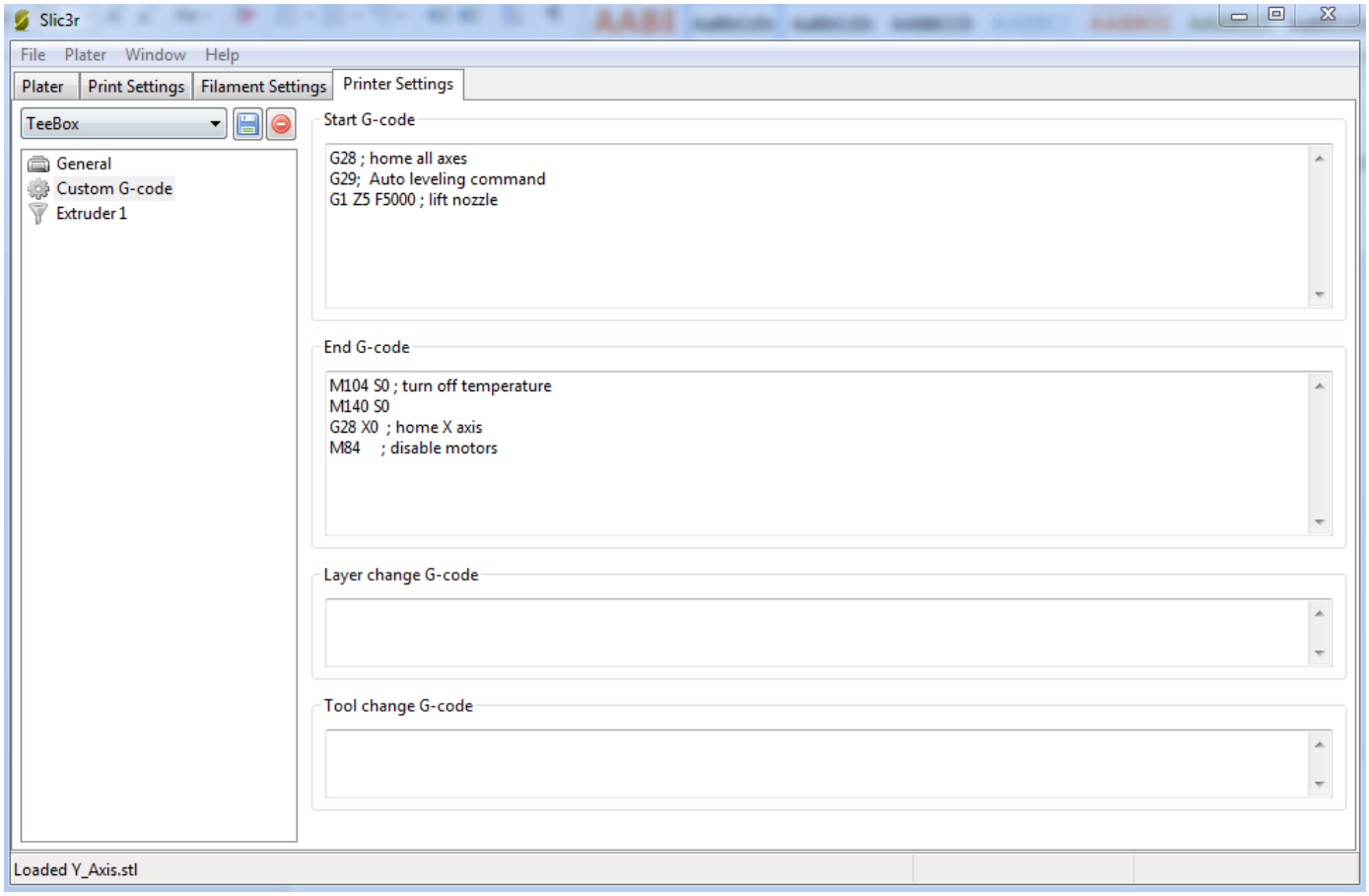

Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
Simple Mode (modified
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Extruders
Perimeter extruder: 1
Infill extruder: 1
Support material extruder: 1
Support material interface extruder: 1
Ooze prevention
Enable:
Temperature variation: -5 Δ°C
Advanced
Interface shells:
Loaded Y_Axis.stl

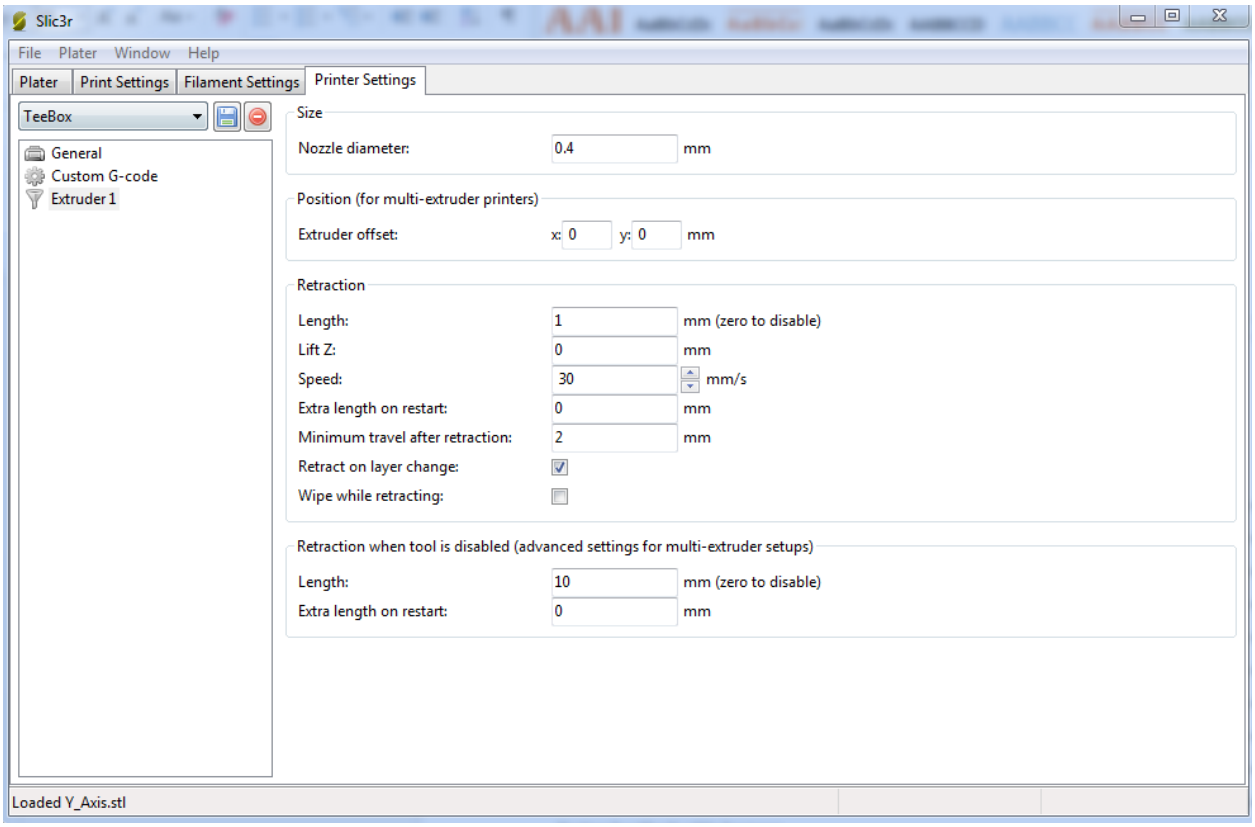

Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
Simple Mode (modified
Layers and perimeters
Infill
Speed
Skirt and brim
Support material
Notes
Output options
Multiple Extruders
Advanced
Extrusion width
Default extrusion width: 0 mm or % (leave 0 for auto)
First layer: 200% mm or % (leave 0 for default)
Perimeters: 0 mm or % (leave 0 for default)
Infill: 0 mm or % (leave 0 for default)
Solid infill: 0 mm or % (leave 0 for default)
Top solid infill: 0 mm or % (leave 0 for default)
Support material: 0 mm or % (leave 0 for default)
Flow
Bridge flow ratio: 1
Other
Threads: 2 (more speed but more memory usage)
Resolution: 0 mm
Loaded Y_Axis.stl

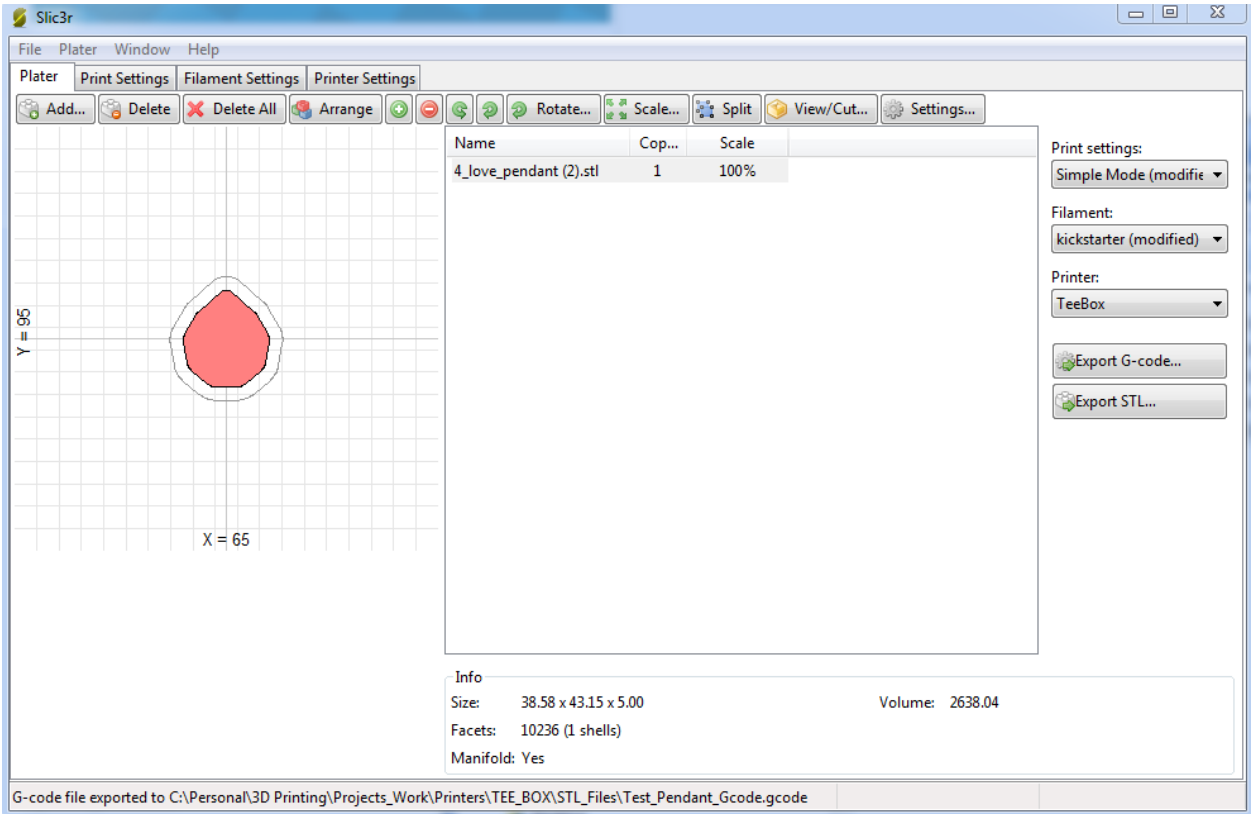

Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
kickstarter (modified)
Filament
Cooling
Filament
Diameter: 1.75 mm
Extrusion multiplier: 1
Temperature (°C)
Extruder: First layer: 205 Other layers: 200
Bed: First layer: 65 Other layers: 60
Loaded Y_Axis.stl


Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
kickstarter (modified)
Filament
Cooling
Enable
Keep fan always on:
Enable auto cooling:
Fan will always run at 40% except for the first layer.
Fan settings
Fan speed: Min: 40 Max: 100
Bridges fan speed: 100 %
Disable fan for the first: 1 layers
Cooling thresholds
Enable fan if layer print time is below: 60 approximate seconds
Slow down if layer print time is below: 30 approximate seconds
Min print speed: 10 mm/s
Loaded Y_Axis.stl


Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
TeeBox
General
Custom G-code
Extruder 1
Size and coordinates
Bed size: x: 130 y: 190 mm
Print center: x: 65 y: 95 mm
Z offset: 0 mm
Firmware
G-code flavor: RepRap (Marlin/Sprinter/Repetier)
Use relative E distances:
Capabilities
Extruders: 1
Advanced
Use firmware retraction:
Vibration limit: 0 Hz
Loaded Y_Axis.stl


Slic3r
File Plater Window Help
Plater Print Settings Filament Settings Printer Settings
TeeBox
General
Custom G-code
Extruder 1
Start G-code
G28 ; home all axes
G29; Auto leveling command
G1 Z5 F5000 ; lift nozzle
End G-code
M104 S0 ; turn off temperature
M140 S0
G28 X0 ; home X axis
M84 ; disable motors
Layer change G-code
Tool change G-code
Loaded Y_Axis.stl


Slic3r
File
Plater
Window
Help
Plater
Print Settings
Filament Settings
Printer Settings
TeeBox
General
Custom G-code
Extruder 1
Size
Nozzle diameter:
0.4
mm
Position (for multi-extruder printers)
Extruder offset:
x: 0
y: 0
mm
Retraction
Length:
1
mm (zero to disable)
Lift Z:
0
mm
Speed:
30
mm/s
Extra length on restart:
0
mm
Minimum travel after retraction:
2
mm
Retract on layer change:
Wipe while retracting:
Retraction when tool is disabled (advanced settings for multi-extruder setups)
Length:
10
mm (zero to disable)
Extra length on restart:
0
mm
Loaded Y_Axis.stl



TEST PANDANT ADDED