

0.4mm nozzle, PLA

0.15 layer height

0.2 first layer height

2 perimeters (1 when printing letters)

minimum 3 solid layers on top and bottom

rear seam position

minimum 15% fill density

combine infill every 1 layer

draft shield only when printing letters and linkage

supports when printing lock and paper frame slides, from the
build plate only

0.45mm extrusion width

0.4mm extrusion width for top solid infill

infill/perimeters overlap 25%

0.2mm elephant foot compensation