**3D Printer parameters**

For Layer Height of 0.2mm,

Printing Temp. : 185oC

Build Plate Temp. : 50oC

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Print Speed : 50mm/s

Travel Speed : 130mm/s

Initial Layer Speed : 20mm/s

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Ensure Retraction is Enabled

Retraction Distance : 3.75mm

Retraction Speed : 30mm/s

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Ensure Print Cooling is enabled

Fan Speed : 100%

Initial Fan Speed : 0%

Build Plate Adhesion : \*Up to your own preference\*

NOTE :

<https://support.ultimaker.com/hc/en-us/articles/360012480959-How-to-manage-printing-profiles-in-Ultimaker-Cura> -----> Use this if you plan to import settings into Cura