









Slic3r

File

Plater

Object

Settings

View

Window

Help

Plater

Controller

Print Settings

Filament Settings

Printer Settings

PLA

Layers and perim

Infill

Skirt and brim

Support material

Speed

Multiple extrude

Advanced

Output options

Notes

Shortcuts

Speed for print moves

Perimeters:

40

mm/s

↳ small:

100%

mm/s or %

↳ external:

100%

mm/s or %

Infill:

40

mm/s

↳ solid:

40%

mm/s or %

↳ top solid:

40%

mm/s or %

↳ gaps:

20%

mm/s or %

Bridges:

60

mm/s

Support material:

40

mm/s

↳ interface:

100%

mm/s or %

Speed for non-print moves

Travel:

70

mm/s

Modifiers

First layer speed:

50%

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

Autospeed (advanced)

Max print speed:

80

mm/s

Max volumetric speed:

0

mm³/s

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Loaded test.stl

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File

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Object

Settings

View

Window

Help

Plater

Controller

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Extrusion width

Default extrusion width:

auto

mm or %

First layer:

100%

mm or %

Perimeters:

default

mm or %

↳ external:

auto

mm or %

Infill:

default

mm or %

↳ solid:

default

mm or %

↳ top solid:

default

mm or %

Support interface:

default

mm or %

Support material:

default

mm or %

Overlap

Infill/perimeters overlap:

55%

mm or %

Flow

Bridge flow ratio:

1

Other

XY Size Compensation:

0

mm

Resolution (deprecated):

0

mm

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Loaded test.stl

Slic3r

File

Plater

Object

Settings

View

Window

Help

Plater

Controller

Print Settings

Filament Settings

Printer Settings

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Filament

Cooling

Custom G-code

Notes

Overrides

Filament

Color:

Diameter:

1.75

mm

Extrusion multiplier:

0.93

Temperature (°C)

Extruder:

First layer:

230

Other layers:

215

Bed:

First layer:

80

Other layers:

75

Optional information

Density:

0

g/cm³

Cost:

0

money/kg

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File

Plater

Object

Settings

View

Window

Help

Plater

Controller

Print Settings

Filament Settings

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Overrides

Enable

Keep fan always on:

☐

Enable auto cooling:

☒

If estimated layer time is below ~10s, fan will run at 90% and print speed will be reduced so that no less than 10s are spent on that layer (however, speed will never be reduced below 7mm/s).

If estimated layer time is greater, but still below ~100s, fan will run at a proportionally decreasing speed between 90% and 30%.

During the other layers, fan will be turned off.

Fan settings

Fan speed:

Min:

30

%

Max:

90

%

Bridges fan speed:

90

%

Disable fan for the first:

4

layers

Cooling thresholds

Enable fan if layer print time is below:

100

approximate seconds

Slow down if layer print time is below:

10

approximate seconds

Min print speed:

7

mm/s

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File
Plater
Object
Settings
View
Window
Help

Plater
Controller
Print Settings
Filament Settings
Printer Settings

- default -

General
Custom G-code
Notes
Extruder 1

Size and coordinates

Bed shape:

Z offset:
0
mm

Capabilities

Extruders:
1

Has heated bed:
☒

USB/Serial connection

Serial port:

Speed:
250000

Print server upload

Host type:
Octoprint

Host or IP:

API Key:

Firmware

G-code flavor:
RepRap (Marlin/Sprinter)

Advanced

Use relative E distances:
☐

Use firmware retraction:
☐

Use volumetric E:
☐

Pressure advance:
0

Vibration limit (deprecated):
0
Hz

Z full steps/mm:
0

Use Set-and-Wait GCode (Extruder):
☐

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Bed Shape

Shape
Rectangular

Settings

Size:
x: 185
y: 160

Origin:
x: 85
y: 100

OK
Cancel

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File

Plater

Object

Settings

View

Window

Help

Plater

Controller

Print Settings

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PLA (modi)

General

Custom G-code

Notes

Extruder 1

Size

Nozzle diameter:

0.3

mm

Layer Height Limits

Min:

0.15

mm

Max:

0.3

mm

Position (for multi-extruder printers)

Extruder offset:

x: 0

y: 0

mm

Retraction

Length:

1.5

mm (zero to disable)

Lift Z:

0

mm

Only lift Z:

Above Z: 0

mm Below Z: 0

mm

Speed:

300

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

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