SSIN Past filements print parameters												
materials	3D Printer brand	model number	Printing temperature	Layer height/ Line width	printing speed	Acceleration	Retraction	extrusion	cooling	Max volumetric speed	other parameters	matters need attention
	Bambu Lab	PIP	Nozzie: 220°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infell: 50mm/s Outer wall: 250mm/s Outer wall: 300mm/s Sparse infell: 300mm/s Internal sold infell: 300mm/s Internal sold infell: 250mm/s Oro purface: 200mm/s Slow down for overhange: ON Overhang speed: default Bridge: 50mm/s Gap infell: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm³/s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
		ΧI	Nozzie: 220°C Plate: 35°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: S0mm/s First layer infill: S0mm/s Outer wall: 250mm/s Outer wall: 350mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhange: ON Overhang speed: default Bridge: 50mm/s Gag infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm²/s	Default or adjust as required	The printing speed of the same model should not be too big. If this speed is too big, the printing gloss is not the same.
		к1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 200mm/s Inspillotton Speed: 200mm/s Inspillotton Speed: 200mm/s Institut Speed: 50mm/s Skirt/Brim Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Irone Wall Acceleration: 5000 Irone Wall Acceleration: 5000 Irone Wall Acceleration: 5000 Infield Layer First Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disance: Olimin Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
	Creality	KI MAX	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 300mm/s Inner Wall Speed: 300mm/s Inner Speed: 300mm/s Somm/s Somm/s Sert/firm Speed: 350mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Inner Long Conference (15000) Inner Acceleration: 12000 Inner Acceleration: 12000 Intibut Layer Travel Acceleration: 500 Intibut Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
PLA+		Ender-3	Nozzie: 215°C Plate: 60°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width 0.42mm (oftware default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infil Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 25mm/s Inner Wall Speed: 25mm/s Inrare Wall Speed: 25mm/s Inrare Speed: 25mm/s Inrare Speed: 25mm/s Namber of Slower Layers: 2	OFF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Raise3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrución Width:0.4mm	Default Printing Speed: 200mm/s Inner Shel Speed: 300mm/s Cuter Shell Speed: 200mm/s First Layer Speed: 200mm/s Hill Speed: 200mm/s Solid Fils Speed: 275mm/s Solid Fils Speed: 1000mm/s Solid Fils Speed: 1000mm/s Z Axis Movement Speed: 15mm/s Support Speed: 300mm/s Thin Wall Speed: 300mm/s Ger Filling Speed: 150mm/s Gertlang Speed: 150mm/s Gertlang Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	ME2S+	Nozzle:215°C Red: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer Anange/N Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voron	R2	Nozzle:215°C Bed: 80°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s Somm/s Sobrens) perimeters: 80mm/s Sobrens) perimeters: 150mm/s Sobrens; 150mm/s Sobren	Software default parameters	Retraction Length2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer AnapseON Wipe while retracting: ON Retract amount before wipe.0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	м5	Nozzle: 215°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 250mm/s Infil Speed: 250mm/s Outer Wal: 100mm/s Infil Speed: 100mm/s Infil Speed: 50mm/s Somm/s Somm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		P1P	Nozzie: 220°C Plate: 60°C (PEI)	Layer height: 0.1-0.2/mm(0.4mm) Line width: default parameters	First layer infili: S0mm/s First layer infili: S0mm/s Outer wail: 250mm/s Outer wail: 250mm/s Outer wail: 300mm/s Sparse infili: 300mm/s Open since wail: 300mm/s Sow down for overhape: ON Overhaps speed: default Bridge: S0mm/s Gog milli S0mm/s Travet speed: 300mm/s Travet speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm² /s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing glass is not the same.

	Bambu Lab	xi	Nozzie: 220°C Plate: 35°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wal: 250mm/s Outer wal: 250mm/s Inner wal: 300mm/s Sparse infill: 300mm/s Oren partice: 300mm/s Overhang speed: 6efault Bridge: 50mm/s Travel speed: 300mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22m²/s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
		К1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infili Speed: 300mm/s Outer Wal Speed: 300mm/s Inner Wal Speed: 300mm/s Top/Bottom Speed: 200mm/s Insidal Jayer Speed: 500mm/s Skirt/Brim Speed: 50mm/s	Infili Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Instial Layer Print Acceleration: 500 Instial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Primer Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
	Creality	KI MAX	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm)0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 200mm/s Insight Speed: 200mm/s Infill Ligher Speed: 50mm/s Skirt/Brim Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Infill Infill Acceleration: 5000 Infill Layer Tinvel Acceleration: 500 Initial Layer Tinvel Acceleration: 500	Retract at Layer Change: ON Retract Disance: Olimin Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	,	Default or adjust as required	Do not seal the box when printing
ePLA-HS		Ender-3	Nozzie: 215°C Plate: 60°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (poftware default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infil Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 25mm/s Inner Wall Speed: 25mm/s Inrar Wall Speed: 25mm/s Inrar Speed: 25mm/s Inrard Speed: 20mm/s Sairt Speed: 20mm/s Namber of Slower Layers: 2	GFF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Disperd: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Raise3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width:0.4mm	Default Printing Speed: 200mm/s Inner Shel Speed: 300mm/s Couter Shell Speed: 200mm/s First Layer Speed: 200mm/s First Layer Speed: 275mm/s Solid Fill Speed: 275mm/s Solid Fill Speed: 275mm/s Z Axin Movement Speed: 150mm/s Inni Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Gap Filling Speed: 50mm/s Operhang Shells Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Prusa	MS-2S+	Nozzle:215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Pointeters: 50mm/s	Software default parameters	Retraction Length 2mm Lift 202mm Retraction Speed: 40mm/s Retract on layer change ON Wipe while retracting: ON Retract amount before wipe 50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	7
	Voron	R2	Nozzle:215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s	Software default parameters	Retraction Langth2mm Lift 20.2mm Retraction Speed: 40mm/s Retraction Speed: 4-0mm/s Retract on layer AnapecON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	м5	Nozzie: 215°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 250mm/s Infil Speed: 250mm/s Outer Wal: 100mm/s Infil Speed: 100mm/s Infil Speed: 50mm/s Somm/s Somm/s Somm/s Skirt Speed: 50mm/s Skirt Sp	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		PIP	Nozzie: 220°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infall: 50mm/s Outer wal: 200mm/s Sparse infall: 250mm/s Sparse infall: 250mm/s Sparse infall: 250mm/s Slow down for overhange: ON Overhang speed: default Bridge: 50mm/s Gag infall: 250mm/s Travel speed: 300mm/s	First layer: 500 Cuter wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22m² /s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big. If the speed is too big. the printing gloss is not the same.
	Banbu Lab	XI	Nozzle: 220°C Plate: 35°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: S0mm/s Frost Layer infall: S0mm/s Frost Layer infall: S0mm/s frost Layer infall: S0mm/s from wall: 270mm/s soner wall: 250mm/s from sold infall: 250mm/s from sold infall: 250mm/s Slow down for overhangs: ON Overhang speed: default Bridge: S0mm/s Gag infall: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22m²/s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.

		K1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 150mm/s Inner Wall Speed: 300mm/s Inties Speed: 300mm/s Inties Speed: 500mm/s Skirt/firer Speed: 50mm/s	Irefill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Interial Layer Prior Acceleration: 500 Instial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disance: Dismm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
	Creality	KI MAX	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 300mm/s Inner Wall Speed: 300mm/s Inraré Speed: 500mm/s Inraré Speed: 500mm/s Inraré Speed: 50mm/s Skert/Brim Speed: 30mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 To Pa Acceleration: 5000 Travel Acceleration: 12000 Intivid Acceleration: 500 Intivid Acceleration: 500 Intitial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disrance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	,	Default or adjust as required	Do not seal the box when printing
eFLA-Lite		Ender-3	Nozzle : 215°C Plate: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm) Lipse width: 0.42mm (o.4mm) Lipse width: 0.42mm (o.4mm) safety Lipse width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Wall Speed: 25mm/s Uner Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Travel Speed: 30mm/s Travel Speed: 100mm/s Intal Jayer Speed: 20mm/s Skit Speed: 20mm/s Namber of Slower Layers: 2	OFF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Special - 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	,
•	Raise@D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width: 0.4mm	Default Printing Speed: 150mm/s inner Shel Speed: 150mm/s inner Shel Speed: 150mm/s Cuter Shell Speed: 150mm/s intil Speed: 150mm/s intil Speed: 150mm/s intil Speed: 150mm/s Solid Fill Speed: 150mm/s S	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Prusa	MK/SS+	Nozzle:215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Sopport material: 50mm/s Indigential: 40mm/s 40mm/s 40mm/s	Soltware default parameters	Retraction Length/2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer Anange ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Voron	R2	Nozzle:215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Sopport material: 150mm/s Bridges: 40mm/s Gap BI: 40mm/s	Soltware default parameters	Retraction Length/2mm Lift 2.0.2mm Retraction Speed: 40mm/s Retract on layer Anange ON Wipe while retracting: ON Retract amount before wipe.0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Anker	M5	Nozzle: 215°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 150mm/s Intill Speed: 150mm/s Outer Wal: 50mm/s Oner Wal: 50mm/s Sent Speed: 50mm/s Sent Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	,	Default or adjust as required	/
		PIP	Nozzie: 230°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: First layer infill: S0mm/s First layer infill: S0mm/s Outer wail: 150mm/s Inner wail: 250mm/s Sparare infill: 250mm/s Internated infill: 250mm/s Internated infill: 250mm/s Internated infill: Slow down for overhangs: ON Overhang speed: default Bridge: Gag infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm²/s	Default or adjust as required	/
	Bambu Lab	XI	Nozzle: 230°C Plate: 35°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First Lyper infill: \$0mm/s First Lyper infill: \$0mm/s Outer wall: \$15mm/s Outer wall: \$15mm/s Outer wall: \$25mm/s 250mm/s Outer wall: \$25mm/s Outer wall: \$250mm/s Oute	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm² /s	Default or adjust as required	,
		K1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 100mm/s Inner Wall Speed: 150mm/s Inner Wall Speed: 200mm/s Infill Speed: 200mm/s Infill Layer Speed: 50mm/s Skirt/filtren Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Infill Super Travel Acceleration: 500 Infill Layer Travel Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disance: OBmm Retraction Retraction Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	,	Default or adjust as required	Do not seal the box when printing

	Creality	KI MAX	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 100mm/s Inner Wall Speed: 150mm/s Topp/Bottom Speed: 200mm/s Travel Speed: 500mm/s Insidal Layer Speed: 50mm/s Skirt/Brin Speed: 50mm/s	Infili Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 Trove Acceleration: 5000 Trove Acceleration: 5000 Travel Acceleration: 12000 Intividial Layer Travel Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disrance: Dismm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Intil Flow: 100% Prinne Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
ePLA-Matte		Ender-3	Nozzle: 220°C Plate: 60°C glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (o.4mm) Line width: 0.42mm (o.6ma) Line width: 120%	Print Speed: 50mm/s Infil Speed: 50mm/s Wall Speed: 30mm/s Cuter Wall Speed: 25mm/s Cuter Wall Speed: 25mm/s Inner Wall Speed: 25mm/s Inner Wall Speed: 25mm/s Inravel Speed: 100mm/s Inravel Speed: 100mm/s Initial Layer Speed: 20mm/s Nair Speed: 20mm/s Namber of Slower Layers: 2	GFF GFF	Retract at Layer Change: ON Retraction Distance: 6mm/ Retraction Speci-60mm/s Retraction Prime Speed: 60mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Raise3D	Prod Plus	Extruder Temperature:225°C Heasted Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width:0.4mm	Default Printing Speed: 60mm/s Innes Snell Speed: 30mm/s Cuter Snell Speed: 30mm/s First Layer Speed: 20mm/s Inst Layer Speed: 20mm/s Inst Layer Speed: 20mm/s Inst Layer Speed: 20mm/s Inst Layer Speed: 50mm/s Snell Speed: 50mm/s Snell Speed: 50mm/s Sapport Speed: 50mm/s Sapport Speed: 40mm/s Sapport Speed: 40mm/s Gap Filling Speed: 40mm/s Gap Filling Speed: 40mm/s Coverhang Shells Speed: 30mm/s	GFF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	,	Default or adjust as required	,
	Prusa	ME3S+	Nozzle:220°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Pointeters: 50mm/s	Software default parameters	Retraction Length/2mm Lift Z02mm Retraction Speed: 40mm/s Retract on layer change(N) Wipe while retracting: ON Retract amount before wipe-50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	,
	Voros	R2	Nozzle:225°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 100mm/s Small perimeters: 50mm/s Sternal perimeters: 50mm/s Intil: 100mm/s Intil: 100m	Software default parameters	Retraction Length:2mm Lift Z-0.2mm Retraction Speed: 40mm/s Retract on layer Amang/N Wipe while retracting: ON Retract amount before wipe.0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	M5	Nozzie: 215°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Proring Speed: 120mm/s Intil Speed: 50mm/s Intil Speed: 100mm/s Intil Speed: 100mm/s Speed: 100mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flore: 100%	Fan: ON Fan speed: 100%	/	Default or adjust as required	,
		PIP	Nozzle: 205°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Sommy's First Layer infill: Sommy's Outer wall: 200mmy's Outer wall: 200mm's Inner wall: 250mmy's Soarse infill: 250mmy's Internal solid infill: 250mmy's Internal solid infill: 250mmy's Slow down for overhangs: ON Overhang speed: default Bridge: Sommy's Gag infill: 250mmy's Travel speed: 300mmy's 17 avel speed: 300mmy's 17 avel speed: 300mmy's 18 average infill: 250mmy's 18 average infill: 250mm's	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm² /s	Default or adjust as required	,
	Banbu Lab	XI	Nozzle: 205°C Flate: 35°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Somm/s First Layer infill: Somm/s Outer wall: 200mm/s Inner wall: 250mm/s Soarse infill: 250mm/s Internal solid infill: 250mm/s Internal solid infill: 250mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gag infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Cuter wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm² /s	Default or adjust as required	Open the cabin door for printing.
		K1	Printing Temperature:205°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 150mm/s Informer Wall Speed: 200mm/s Transit Speed: 200mm/s Transit Speed: 50mm/s Skirt/Bren Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Irone Wall Acceleration: 5000 Irone Wall Acceleration: 5000 Irone Wall Acceleration: 5000 Infield Layer Travel Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: Distance to Seminal Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 95% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	,	Default or adjust as required	Do not seal the box when printing
	Creality	KI MAX	Printing Temperature:205°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	hefill Speed: 300mm/s Outer Wall Speed: 150mm/s Topflortom Speed: 200mm/s Topflortom Speed: 200mm/s Toraed Speed: 500mm/s Skirt/Brim Speed: 50mm/s	Intill Acceleration: 12000 Outer Wall Acceleration: 3000 Outer Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 5000 Instital Layer Fravel Acceleration: 500 Instital Layer Travel Acceleration: 500	Retract at Layer Change : ON Retract Disrance : 0.8mm Retraction Retract Speed : 40mm/s Other parameters default	Outer Wall Flow: 95% Inner Wall Flow: 100% Top Flow: 100% Top Flow: 100% Infili Flow: 100% Primme Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	,	Default or adjust as required	Do not seal the box when printing

ePLA-Silk		Ender-3	Nozzle: 200°C Plate: 60°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (o.0mm) default parameter) Starfing layer line width: 120%	Paint Speed: S0mm/s Intelligence: S0mm/s Intelligence: S0mm/s Intelligence: S0mm/s Cuter Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Ing Speed: 25mm/s Ing Speed: 25mm/s Ing Speed: 25mm/s Intelligence: 20mm/s Saint Speed: 20mm/s Number of Slower Layers: 2	GSF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Raise3D	Pro3 Plus	Extruder Temperature:200°C Heasted Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s Chuter Shell Speed: 20mm/s First Layer Speed: 60mm/s Shell Speed: 60mm/s Shell Speed: 60mm/s Shell Speed: 60mm/s Speed: 60mm/s Speed: 60mm/s Speed: 60mm/s Speed: 60mm/s Speed: 40mm/s Speed: 40mm/s Speed: 40mm/s Speed: 40mm/s Speed: 40mm/s Speed: 40mm/s Speed: 30mm/s	GF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	W22+	Nozzle:200°C Bedr 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: \$0mm/s	Software default parameters	Retraction Length/2mm Lift 202mm Retraction Speed: 40mm/s Retract on layer change(DN Wipe while retracting: DN Retract amount before wipe-50%	Estrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voron	R2	Nozzle:205°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 120mm/s	Software default parameters	Retraction Length-2mm Lift 202mm Retraction Speed: 40mm/s Retract on layer change ON Wipe while retracting: ON Retract amount before wipe 0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	M5	Nozzle: 210°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Intill Speed: 200mm/s Outer Wall: 100mm/s Inter Wall: 100mm/s Skert Speed: 50mm/s	Software default parameters	Software default parameters	Flore: 100%	Fan: ON Fan speed:100%	,	Default or adjust as required	,
		PIP	Nozzle: 260°C Plate: 80°C (PEI, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parametens	First layer: Sommy's First Layer infill: Sommy's Cuter wall: 200mmy's Cuter wall: 200mmy's Inner wall: 200mmy's Inner wall: 200mmy's Internal solid infill: 200mmy's Internal solid infill: 200mmy's Slow down for overhangs: ON Overhang speed: default Bridge: Sommy's Gap infill: 200mmy's Travel speed: 200mmy's Travel speed: 200mmy's	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	15mm²/s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
	Bambu Lab	XI	Nozzle : 260°C Plate: 80°C (engineering slab, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First layer infill: 50mm/s Cuter wall: 200mm/s Inner wall: 200mm/s Inner wall: 200mm/s Inner wall: 200mm/s Internal solid infill: 200mm/s Internal Intern	First layer: 500 Cuter wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	15mm²/s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
		K1	Printing Temperature:245°C Build Printing Temperature: 80°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	hofill Speed: 200mm/s Outer Wall Speed: 150mm/s Topillotron Speed: 200mm/s Topillotron Speed: 500mm/s Initial Jayer Speed: 50mm/s Skirt/firm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 TOP Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 5000 Install Layer Prior Acceleration: 500 Install Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disance: Zmm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is not big, the printing gloss is not the same.
	Creality	K1 MAX	Printing Temperature:245°C Build Printing Temperature: 80°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Indill Speed: 200mm/s Couter Wall Speed: 150mm/s Couter Wall Speed: 200mm/s Topflietnon Speed: 200mm/s Topflietnon Speed: 500mm/s Indill Layer Speed: 500mm/s Skirt/Brin Speed: 50mm/s	Intill Acceleration: 12000 Outer Wall Acceleration: 5000 Incere Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Fravel Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Disrance: 2mm Retraction Steats Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Infill Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	,	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
PETG		Ender-3	Nozzle: 240°C Plate: 90°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (coftware default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 30mm/s Wall Speed: 25mm/s Outer Wall Speed: 25mm/s Top Speed: 25mm/s Top Speed: 100mm/s Initial Layer Speed: 20mm/s Sistri Speed: 20mm/s Number of Slower Layers: 2	GIP	Betract at Leyer Change: ON Betraction Detarror: form Betraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flore: 1006	Fan: ON Fan speed:100%	,	Default or adjust as required	,

	Raise3D	Prod Plus	Extruder Temperature:240°C Heated Bed Temperature: 70°C	Layer Height: 0.1-0.2mm (0.4mm) Gurudon Widdh:0.4mm	Datus Printing Speed: 60mm/s were Self Speed: 30mm/s . 30	GFF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Prusa	MC25+	Nozzle:240°C Bed: 90°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: S0mm/s	Software default parameters	Retraction Length:3mm Lift 2:0mm Retraction Speed: 40mm/s Retract on layer change;ON Wipe while retracting: ON Retract amount before wipe;50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voron	R2	Nozzle:240°C Bed: 90°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 100mm/s	Software default parameters	Retraction Length'amm Lift 20mm Retraction Speed: 40mm/s Retraction Speed: 40mm/s Retract on layer change(N) Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Anker	M5	Nozzie: 240°C Plate: 90°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 120mm/s Infili Speed: 50mm/s Outer Wall: 50mm/s Inner Wall: 100mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		PIP	Nazzie: 250°C Plate: 100°C (PEI, glueing)	Layer height: 0.1-0.2/mm(0.4mm) Une width: default parameters	First layer: S0mm/s First layer infill: S0mm/s First layer infill: S0mm/s First layer infill: S0mm/s First layer infill: S0mm/s First layer layer First layer Firs	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: On Min Fan Speed: 10% Max Fan Speed: 30%	22m²/s	Default or adjust as required	It needs to be sealed for printing. 2. The printing speed of the same model should not differ too much, as the speed difference is too large and the printing glossiness is different.
	Banbu Lab	xı	Nozzle: 250°C Plate: 100°C (engineering slab, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Somm/s First layer infill: Somm/s Somm/s Outer wal: 200mm/s Inner wal: 270mm/s Sparae infill: 250mm/s Interwal solid infill: 250mm/s Interwal solid infill: 250mm/s Slow down for overhaaps: ON Overhang speed: default Bridge: Somm/s Travel speed: 300mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: On Min Fan Speed: 10% Max Fan Speed: 30%	22mm² /s	Default or adjust as required	1. It needs to be sealed for printing. 2. The printing speed of the same model thought of the form to much, as the speed difference is too large and the printing glossiness is different.
	Creality	Ender-3	Nozzie: 240°C Plate: 100°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (o.fmme cefeault parameter) Starting layer line width: 1.20%	Print Speed: 50mm/s Infili Speed: 50mm/s Wall Speed: 50mm/s Outer Wall Speed: 25mm/s Outer Wall Speed: 25mm/s Outer Wall Speed: 25mm/s Filine Wall Speed: 25mm/s Filine Speed: 25mm/s Filine Speed: 25mm/s Speed: 20mm/s Number of Slower Layers: 2	OFF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prims Speed: 40mm/s	Flow: 100%	Fan: OFF	,	Default or adjust as required	Need to seal box printing
ABS	Raise3D	Pro3 Plus	Extruder Temperature:250°C Heated Bed Temperature: 100°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width: 0.4mm	Default Printing Speed: 60mm/s inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s Outer Shell Speed: 20mm/s Hill Speed: 20mm/s Hill Speed: 60mm/s Will Speed: 60mm/s S	OFF	Software default parameter	Filament Flowrate: 95%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Prusa	W.S+	Nozzle:240°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Intell: 80mm/s Solid infill: 80mm/s Solid infill: 80mm/s Solid infill: 80mm/s Gappert material: 50mm/s Gappert material: 40mm/s Gap III: 40mm/s	Software default parameters	Retraction Length 2mm Lift 20.2mm Retraction Speed: - 40mm/s Retract on layer - 40mg/S Wipe while retracting: ON Retract amount before wipe 0%	Extrusion multiplier: 1	Fan: OFF	,	Default or adjust as required	Need to seal box printing
	Voros	R2	Nozzle:240°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 80mm/s	Software default parameters	Retraction Length2mm Uif 202mm Retraction Speed: 40mm/s Retraction Speed: 40mm/S Retract on layer change/S Wipe while retracting: ON Retract amount before wipe 0%	Extrusion multiplier: 1	Fam: OFF	,	Default or adjust as required	Need to seal box printing

1 3				1	i	1	1	1	1	1	1	
	Anker	м5	Nozzie: 250°C Plate: 100°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Une width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Infili Speed: 200mm/s Outer Wall: 80mm/s Inner Wall: 80mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
		PIP	Nozzle: 250°C Plate: 100°C (PEI, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer : Sommn/s First Layer infill: Somm/s Outer wall: 150mm/s Inter wall: 200mm/s Sparse infill: 200mm/s For surface: 150mm/s For surface: 150mm/s For surface: 150mm/s Gap infill: 200mm/s Travel speed: 200mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: OFF	22mm²/s	Default or adjust as required	It needs to be sealed for printing 2. The printing year of the same model should not differ too much, as the speed difference is too large and the printing glossiness is different.
	Banbu Lab	XI	Nozzle: 250°C Plate: 100°C (engineering slab, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Somm/s- First layer infill: Somm/s- First layer infill: Somm/s- Somm/s- Somm/s- Somm/s- Somm/s- Somm/s- Somm infill: 250mm/s- Som down for overhangs: ON Overhang speed: default Bridge: Somm/s- Gosp infill: 250mm/s- Travel speed: 300mm/s-	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fam: OFF	22m²/s	Default or adjust as required	It needs to be sealed for printing 2. The printing speed of the same model thould not differ too much, as the speed difference is too large and the printing glossiness is different.
	Creality	Ender-3	Nozzie: 240°C Plate: 100°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (p.fhvane default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infil Speed: 50mm/s Wall Speed: 25mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 20mm/s Initial Layer Speed: 20mm/s Number of Slower Layers: 2	GFF	Retract at Layer Change: ON Retraction Distance: 6mm s Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
ABS+	Raise3D	Pro3 Plus	Extruder Temperature:250°C Heasted Bed Temperature: 100°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Courer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 60mm/s Support Speed: 15mm/s Support Speed: 40mm/s Support Speed: 40mm/s Gap Filling Speed: 40mm/s Gap Filling Speed: 30mm/s Overhang Shells Speed: 30mm/s	OFF	Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Prusa	ME3S+	Nozzle:250°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: \$0mm/s Small perimeters: 25mm/s Softersal perimeters: 25mm/s Indit: 80mm/s Soft perimeters: 80mm/s Top politi nifil: 80mm/s Sogport material: \$0mm/s Bridger: 25mm/s Gap fil: 40mm/s	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer change(N Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Voron	R2	Nozzle:255°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters:	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer-brangeON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Anker	м5	Nozzie: 255°C Plate: 100°C (PEI)	Layer height: 0.1-0.2nm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Infili Speed: 200mm/s Outer Wall: 80mm/s Inner Wall: 80mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
		PIP	Nozzie: 220°C Plate: 45°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Cuter wail: 80mm/s Forest State 150mm/s General State 150mm/s General State 150mm/s Sow down for overhangs: 00 Overhang speed: default Bridge: 50mm/s Gag infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 500 Top surface: 2000 Normal printing: 10000	Length: L.Smm Botraction speeds 20mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	Smm²/s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	Banbu Lab	XI	Nozzle: 220°C Flate: 30°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Somm/s- First layer infill: Somm/s- First layer infill: Somm/s- Somm/s- Somm/s- Somm/s- Somm/s- Somm/s- Somm infill: 150mm/s- Sow down for overhangs: ON Overhang speed: default Bridge: Somm/s- Gosp infill: 250mm/s- Travel speed: 300mm/s-	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Longth: 1.5mm Retraction speeds 30mm/s	Flow ratio: 1.05	Fam: ON Software default parumeter	Seed /s	Default or adjust as required	The pullback length inside the material setting needs to be closed.

	Creality	Ender-3	Nozzie: 220°C Plate: 45°C	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (coftware default parameter) Starting Jayer line width 1.20%	Print Speed: 40mm/s Infill Speed: 15mm/s Wall Speed: 15mm/s Outer Wall Speed: 15mm/s Inner Wall Speed: 15mm/s Top Speed: 20mm/s Travel Speed: 100mm/s Skirt Speed: 15mm/s Namber of Slower Layers: 2	099	Retract at Layer Change: ON Retraction Distance: Zmm Retraction Speed: 30mm/s Retraction Prime Speed: 30mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
eTPU-95A	Raise3D	Pro3 Plus	Extruder Temperature:220°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 60mm/s Fill Speed: 60mm/s Fill Speed: 50mm/s Support Speed: 50mm/s Gap Filling Speed: 40mm/s Bridging Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shells Speed: 30mm/s	s (097	Software default parameter	Filament Flowrate: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	W.25+	Nozzle:220°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s	Software default parameters	Retraction Length:1mm Lift 20.2mm Retraction Speed: 25mm/s Retract on layer changeON Wips while retracting: ON Retract amount before wipe.0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voron	R2	Nozzle:229°C Bedr 45°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s	Software default parameters	Retraction Length:2mm Lift 2:0.2mm Retraction Speed: 40mm/s Retract on layer change(N Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1.05	Fan: ON Fan speed:100%	,	Default or adjust as required	/
	Anker	М5	Nozzie: 225°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 100mm/s Infill Speed: 100mm/s Outer Wall: 50mm/s Inner Wall: 50mm/s Siert Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		P1P	Nozzie: 220°C Plate: 45°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First Isyer: Somm/s First Isyer infile: Somm/s First Isyer infile: Somm/s Cuter wal: Somm/s Inner wal: Somm/s Inner wal: 150mm/s Inner wal: 150mm/s Internal solid infill: 150mm/s Internal solid infill: 150mm/s Internal solid infill: 150mm/s Slow down for overhangs: ON Overhang speed: Momm/s Gag infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5mm Retraction speeds 20mm/s	Flow ratio: 1.05	Fam: ON Software default parameter	Sount /s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	Banbu Lab	xı	Nozzie: 220°C Plate: 30°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First layer: 50mm/s Outer wall: 50mm/s Outer wall: 150mm/s Sparrie infill: 150mm/s Sparrie infill: 150mm/s Information infill: 150mm/s Information infill: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gag infill: 250mm/s Travel speed: 300mm/s	First Lyver: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length, 1.5mm Rotraction speeds 20mm/s	Flow ratio: 1.05	Fam: ON Software default parameter	Sma*/s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	Creality	Ender-3	Nozzie: 220°C Plate: 60°C	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (o.fwan default; 120%	Print Speed: 40mm/s Infili Speed: 40mm/s Wall Speed: 1 5mm/s Cuter Wall Speed: 15mm/s Cuter Wall Speed: 15mm/s Top Speed: 20mm/s Travel Speed: 20mm/s Travel Speed: 15mm/s Top Speed: 15mm/s Namber of Slower Layers: 2	OFF	Retract at Layer Change: ON Retraction Distance: Zmm Retraction Special Johnny's Retraction Prime Speed: 30mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
eTPU-RS	Raise:2D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width:0.4mm	Default Printing Speed: 60mm/s immer Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infili Speed: 20mm/s Infili Speed: 60mm/s Solid Fili Speed: 60mm/s Solid Fili Speed: 60mm/s Support Speed: 100mm/s Support Speed: 40mm/s Bright Speed: 40mm/s Brighing Speed: 40mm/s Brighing Speed: 40mm/s Speed: 30mm/s Overhang Shells Speed: 30mm/s	s (UP	Software default parameter	Filament Flowrate: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	W.S+	Nozzle:220°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: S0mm/s	Software default parameters	Retraction Length: Imm Lift 2:0.2mm Retraction Speed: 25mm/s Retract on layer changeON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/

	Voron	R2	Nozzle:220°C Bed: 45°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Reimeters: 50mm/s Small perimeters: 40mm/s External perimeters: 40mm/s Infil: 80mm/s Solid infil: 60mm/s Top solid infil: 60mm/s Support material: 80mm/s Gap fil: 20mm/s	Software default parameters	Retraction Length: Imm Lift 20.2mm Retraction Speed: 25mm/s Retract on Jayer change: ON Wips while retracting: ON Retract amount before wipe: 0%	Extrusion multiplier: 1.05	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	мS	Nozzle: 225°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 100mm/s Intelli Speed: 100mm/s Intelli Speed: 100mm/s Inter Wall: 50mm/s Inter Wall: 50mm/s Start Lyper: 50mm/s Start Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	,
	Banbu Lab	XI	Nozzle: 280°C Plate: 100°C (engineering slab, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infil: 50mm/s First Layer infil: 20mm/s former wal: 20mm/s former wal: 20mm/s Soarate infil: 250mm/s interwal solid infili: 250mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infili: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.96	Fam: OFF	10m²/s	Default or adjust as required	Need to seal box printing
ePA-OF	Raise3D	Pro3 Plus	Extruder Temperature:280°C Heasted Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Wildth: 0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 20mm/s Outer Shell Speed: 20mm/s Outer Shell Speed: 20mm/s Intell Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 60mm/s Support Speed: 50mm/s Support Speed: 40mm/s Bridging Speed: 40mm/s Gap Filing Speed: 40mm/s Gap Filing Speed: 40mm/s Speed: 50mm/s Speed: 50mm/s S		Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	Thermostatic sealing printing is required 2. Easy to wear sprinkler head, need to replace the hardening nozzle.
era-cr	Prusa	版25+	Nozzle:275°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: S\(\text{Omm/s}\) Small perimeters: 25mm/s	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed : 40mm/s Retract on layer change/N Wips while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Thermostatic sealing printing is required 2. Easy to wear sprinkler head, need to replace the hardening nozzie.
	Voron	R2	Nozzle:280°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 60mm/s Small perimeters: 50mm/s Sterral perimeters: 50mm/s Sterral perimeters: 50mm/s Solid infill: 50mm/s Solid	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer Ahrange ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 0.98	Fan: OFF	/	Default or adjust as required	Thermostatic sealing printing is required 2. Easy to wear sprinkler head, need to replace the hardening nozzle.
	Banbu Lab	xı	Nozzle: 280°C Plate: 100°C (engineering slab_glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First layer: 50mm/s First layer infil: 50mm/s 50mm/s 60mm/s	First Layer: 500 Outer wail: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.96	Fan: OFF	10m²/s	Default or adjust as required	Need to seal box printing
	Raise3D	Pro3 Plus	Extruder Temperature:280°C Heated 8ed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 20mm/s Outer Shell Speed: 20mm/s Outer Shell Speed: 20mm/s Infil Speed: 20mm/s Infil Speed: 60mm/s Novement Speed: 50mm/s Infil Speed: 60mm/s Novement Speed: 50mm/s Export Speed: 60mm/s Admirus Export Speed: 60mm/s Outer Speed: 60mm/s O		Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
ePA12-CF	Prusa	展25+	Nozzle:275°C Bed: 80°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s Sternal perimeters: 25mm/s Infal: 35mm/s Sternal perimeters: 25mm/s Sold infal: 80mm/s Sold infal: 40mm/s Gap sold insal: 25mm/s Gap sold insal: 25mm/s Gap sold insal: 40mm/s	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed : 40mm/s Retract on layer change/ON Wips while retracting: ON Retract amount before wipe:50%	Estrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Thermostatic sealing printing is required. 2. Easy to wear sprintler head, need to replace the hardening nozzle.
	Voros	R2	Nozzle:280°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 60mm/s Small perimeters: 50mm/s Small perimeters: 50mm/s Sterral perimeters: 50mm/s Sterral perimeters: 50mm/s Sterral perimeters: 50mm/s Sterral perimeters: 50mm/s Support material: 40mm/s Support material: 25mm/s Gap 6II : 40mm/s	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed : 40mm/s Retract on layer change/N Wips while retracting: ON Retract amount before wipe:50%	Estrusion multiplier: 0.98	Fan: OFF	/	Default or adjust as required	Thermostatic sealing printing is required 2. Easy to wear sprinkler head, need to replace the hardening nozzle.

	Banbu Lab	PIP	Nozzie: 220°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Somm/s Frost Layer infall: Somm/s Frost Layer infall: Somm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 1.0	Fan: ON Software default parameter	22mm³/s	Default or adjust as required	/
		ΧI	Nozzie: 220°C Plate: 35°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Sommy's First Layer infill: Sommy's Cuter wall: 250mmy's Cuter wall: 250mmy's Inner wall: 300mmy's Sparse infill: 300mmy's Sparse infill: 250mmy's Computage: 200mmy's Slow down for overhangs: ON Overhang speed: default Bridge: 50mmy's Gag infill: 250mmy's Travel speed: 300mmy's	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 1.0	Fan: ON Software default parameter	22mm³/s	Default or adjust as required	/
	Creality	Ender-3	Nozzie : 215°C Plate : 60°C (glueing)	Layer beight: 0.1-0.2mm (0.4mm) Line widitt 0.42mm (orthware default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Choter Wall Speed: 30mm/s Tone Wall Speed: 30mm/s Tone Speed: 25mm/s Toned Speed: 25mm/s Wall Speed: 25mm/s	OFF	Retract at Layer Change : ON Retraction Distance: 6mm Retraction Speed : 40mm/s Retraction Prime Speed : 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	,
eFLA-Metal	Raise3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Estrusion Width: 0.4mm	Default Printing Speed: 60mm/s inner Shell Speed: 20mm/s Cuter Shell Speed: 20mm/s Cuter Shell Speed: 20mm/s Institute Speed: 60mm/s Solid Fill Speed: 60mm/s Solid Fill Speed: 50mm/s Institute Speed: 50mm/s Speed: 50mm/s Speed: 50mm/s Speed: 50mm/s Speed: 50mm/s Speed: 50mm/s Speed: 40mm/s Gap Filling Speed: 40mm/s Gap Filling Speed: 30mm/s Cuerhang Shells Speed: 30mm/s Cuerhang Shells Speed: 30mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MC2S+	Nozzle:215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters:	Software default parameters	Retraction Length:2mm Lift 20.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voros	R2	Nozzle:215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s	Software default parameters	Retraction Length2mm Lift 202mm Retraction Speed: 40mm/s Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	MS	Nozzie: 215°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Proting Speed: 150mm/s Intil Speed: 350mm/s Intil Speed: 50mm/s Intil Speed: 50mm/s Somm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	,
	Bambu Lab	PIP	Nozzie: 250°C Plate: 45°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: Somm/s First Layer infill: Somm/s Outer wall: 100mm/s Inner wall: 100mm/s Inner wall: 100mm/s Internal sold infill: 100mm/s Internal sold infill: 100mm/s Slow down for overhangs: ON Overhang speed: default Bridge: Somm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Retraction.OFF	Flow ratio: 0.5	Fan: ON Software default parameter	22mm³/s	Default or adjust as required	,
		χı	Nozzie: 240°C Plate: 50°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: S0mm/s First layer infill: S0mm/s Outer wall: 100mm/s Inner wall: 100mm/s Inner wall: 100mm/s Internal sold infill: 100mm/s Internal sold infill: 100mm/s Slow down for overhangs: ON Overhang speed: default Bridge: S0mm/s Gag infill: 250mm/s Inverse speed: 300mm/s Inverse speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Retraction.OFF	Flow ratio: 0.5	Fan: ON Software default parameter	22mm³/s	Default or adjust as required	,
	Creality	Ender-3	Nozzle : 240°C Plate : 50°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (coftware default parameter) Starting layer line width: 120%	Print Speed: 40mm/s Infili Speed: 40mm/s Wall Speed: 40mm/s Usal Speed: 40mm/s Chote Wall Speed: 40mm/s Chote Wall Speed: 40mm/s Infili Speed: 40mm/s Infili Speed: 40mm/s Infili Speed: 40mm/s Speed: 40mm/s Number of Slower Layers: 2	GFF	Retraction:OFF	Flow 55h	Fan: ON Fan speed:100%	/	Default or adjust as required	,

WEL-														
		Raise3D	Pro3 Plus	Extruder Temperature:240°C Heasted Bed Temperature: 50°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	inner Shell Speed: 40r Outer Shell Speed: 40r First Layer Speed: 40r Infill Speed: 40r Solid Fill Speed: 40r X/Y Axis Movement Speed: 40r Z Axis Movement Speed: 15rr	mm/s)mm/s	Software default parameters	Retraction:OFF	Filament Flowrate: SS%	Fan: ON Fan speed:100%	,	Default or adjust as required	,
	1	Prusa	麗22+	Nozzle:240°C Bed: 45°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 40mm Small perimeters: 40mm Esternal perimeters: 40mm Esternal perimeters: 40mm Solid Infill: 40mm 50mid Infill: 40mm 50mid Infill: 40mm 50mp port material: 40mm 6mg psill: 40mm	m/s m/s m/s m/s m/s im/s im/s	Software default parameters	Retraction:OFF	Extrusion multiplier: 0.55	Fan: ON Fan speed:100%		Default or adjust as required	/
	,	Vorom	R2	Nozzle:240°C Bed: 45°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 40mm Small perimeters: 40mm Esternal perimeters: 40mm Small perimeters: 40mm Solid infill: 40mm Solid infill: 40mm Solid infill: 40mm Soupport material: 40mm Support material: 40mm Gap fill: 40mm	m/s m/s m/s m/s m/s im/s im/s	Software default parameters	Retraction:OFF	Extrusion multiplier: 0.55	Fan: ON Fan speed:100%		Default or adjust as required	/

The above data is sourced from the aSUN tech center testing, with testing environment temperatures ranging from 18 to 28°C; The printing parameters may also vary under different environmental temperatures.

Please note that when there is a significant difference in printing speed, the model's surface will present different glossiness. Please so the printing speed of the model surface to be consistent. When printing TPU on the Basbu Lab printer, the Retraction Length in the meterial settings sunt be turned off.