

eSUN Part filament 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
FLA+	Bambu Lab	F1P	Nozzle: 220°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	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.
		X1	Nozzle: 220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	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.
	Creality	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: 200mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brim Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing	
		K1 MINI	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 Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brim Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing	
		Endor-3	Nozzle: 215°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0.9F	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Retract Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	
	Bambu3D	Print Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 200mm/s Inner Shell Speed: 300mm/s Outer Shell Speed: 200mm/s First Layer Speed: 50mm/s Infill Speed: 275mm/s Solid Fill Speed: 100mm/s X/Y Axis Movement Speed: 200mm/s Z Axis Movement Speed: 15mm/s Support Speed: 300mm/s Thin Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Bridging Speed: 50mm/s Overhang Shells Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	
	Prusa	MINI+	Nozzle:215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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:215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 80mm/s infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	/	
	Anker	M5	Nozzle: 215°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 250mm/s Infill Speed: 250mm/s Outer Wall: 100mm/s Inner Wall: 150mm/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	/	

ePLA-BS	Bambu Lab	X1	Nozzle: 220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22ml / 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.
	Creality	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: 200mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		K1 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 Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		Ender-3	Nozzle: 215°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 20mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	UF	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	/
	Bambu Lab	Pr1i Plus	Extruder Temperature: 225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width: 0.4mm	Default Printing Speed: 200mm/s Inner Shell Speed: 300mm/s Outer Shell Speed: 200mm/s First Layer Speed: 50mm/s Solid Fill Speed: 275mm/s Solid Fill Speed: 100mm/s X/Y Axis Movement Speed: 200mm/s Z Axis Movement Speed: 15mm/s Support Speed: 300mm/s Thin Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Bridging Speed: 50mm/s Overhang Shells Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	Prusa	MB3+	Nozzle: 215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm 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	B2	Nozzle: 215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 150mm/s Infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm 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	/
	Anker	M1	Nozzle: 215°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 250mm/s Infill Speed: 250mm/s Outer Wall: 100mm/s Inner Wall: 150mm/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	P1P	Nozzle: 220°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22ml / 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.
		X1	Nozzle: 220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22ml / 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.

ePLA-Lite	Creality	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: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		K1 MINI	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 Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		Ender-3	Nozzle: 215°C Plate: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FF	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	/
	Rails3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 150mm/s Inner Shell Speed: 150mm/s Outer Shell Speed: 100mm/s First Layer Speed: 50mm/s Infill Speed: 100mm/s Solid Fill Speed: 100mm/s X/Y Axis Movement Speed: 200mm/s Z Axis Movement Speed: 15mm/s Support Speed: 200mm/s Thin Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Bridging Speed: 50mm/s Overhang Shell Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MINI+	Nozzle: 215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	B2	Nozzle: 215°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 80mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:5%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Bambu Lab	Aker	B1	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 Infill Speed: 150mm/s Outer Wall: 50mm/s Inner Wall: 50mm/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	/
	F1P		Nozzle: 230°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 250mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22w/ 4s	Default or adjust as required	/
		X1	Nozzle: 230°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: 150mm/s Outer wall: 150mm/s Inner wall: 250mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22w/ 4s	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 Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime 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	K1 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 Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction/Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
	Ender-3	Nozzle: 220°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 60mm/s Retraction Prime Speed: 60mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Raiso3D	Pro3 Plus	Extruder Temperature:225°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: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shells Speed: 30mm/s	0FF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Prusa	MKS+	Nozzle: 220°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 80mm/s Infill: 80mm/s Solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	82	Nozzle: 220°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 100mm/s Small perimeters: 50mm/s External perimeters: 50mm/s Infill: 100mm/s Solid infill: 100mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	/
Anker	M5	Nozzle : 215°C Plate : 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 120mm/s Infill 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	/
Bambu Lab	P1P	Nozzle: 205°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 250mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22w/ 4s	Default or adjust as required	/
	X1	Nozzle: 205°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 250mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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	22w/ 4s	Default or adjust as required	Open the cabin door for printing
Creality	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 Inner Wall Speed: 200mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction/Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 95% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
	K1 MAX	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 Inner Wall Speed: 200mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction/Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 95% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing

aPLA-511k		Ender-3	Nozzle : 200°C Plate : 60°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed : 50mm/s Infill Speed : 50mm/s Wall Speed : 30mm/s Outer Wall Speed : 25mm/s Inner Wall Speed : 30mm/s Top Speed : 25mm/s Travel Speed : 100mm/s Initial Layer Speed : 20mm/s Skirt Speed : 20mm/s Number of Slower Layers : 2	0FF	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	/
	Bambu XB	Print Plus	Extruder Temperature:200°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 : 60mm/s Solid Fill Speed : 60mm/s X/Y Axis Movement Speed : 100mm/s Z Axis Movement Speed : 15mm/s Support Speed : 60mm/s Thin Wall Speed : 40mm/s Gap Filling Speed : 40mm/s Bridging Speed : 30mm/s Overhang Shell Speed : 30mm/s	0FF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MB3+	Nozzle: 200°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters : 50mm/s Small perimeters : 25mm/s External perimeters : 80mm/s Infill : 80mm/s Top solid infill : 40mm/s Support material : 50mm/s Bridges : 25mm/s Gap Fill : 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	B2	Nozzle: 205°C Bed: 60°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters : 120mm/s Small perimeters : 70mm/s External perimeters : 70mm/s Infill : 150mm/s Solid infill : 150mm/s Top solid infill : 70mm/s Support material : 150mm/s Bridges : 40mm/s Gap Fill : 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed : 40mm/s Retract on layer change:ON Wipe while retracting : ON Retract amount before wipe:5%	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 Infill Speed : 200mm/s Outer Wall : 100mm/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	/
	Bambu Lab	P1P	Nozzle : 260°C Plate : 80°C (PEI, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width : default parameters	First layer : 50mm/s First Layer infill : 50mm/s Outer wall : 200mm/s Inner wall : 200mm/s Sparse infill : 200mm/s Internal solid infill : 200mm/s Top surface : 150mm/s Slow down for overhangs : ON Overhang speed : default Bridge : 50mm/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: ON Software default parameter	15ml / 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.
		X1	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 Outer wall : 200mm/s Inner wall : 200mm/s Sparse infill : 200mm/s Internal solid infill : 200mm/s Top surface : 150mm/s Slow down for overhangs : ON Overhang speed : default Bridge : 50mm/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: ON Software default parameter	15ml / 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.
	Creality	K1	Printing Temperature:245°C Build Printing Temperature: 80°C	Layer Height: 0.1-0.2mm(0.4mm) Line width : default parameters	Infill Speed : 200mm/s Outer Wall Speed : 150mm/s Inner Wall Speed : 200mm/s Top/Bottom Speed : 200mm/s Travel Speed : 500mm/s Initial Layer Speed : 50mm/s Skirt/Brim Speed : 50mm/s	Infill Acceleration : 12000 Outer Wall Acceleration : 5000 Inner Wall Acceleration : 5000 TOP Acceleration : 5000 Travel Acceleration : 12000 Initial Layer Print Acceleration : 500 Initial Layer Travel Acceleration : 500	Retract at Layer Change: ON Retract Distance: 2mm Retraction Retract Speed : 40mm/s Other parameters default	Outer Wall Flow : 100% Inner Wall Flow : 100% Top Flow : 100% Infill Flow : 100% Prime Tower 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.
		K1 MAX	Printing Temperature:245°C Build Printing Temperature: 80°C	Layer Height: 0.1-0.2mm(0.4mm) Line width : default parameters	Infill Speed : 200mm/s Outer Wall Speed : 150mm/s Inner Wall Speed : 200mm/s Top/Bottom Speed : 200mm/s Travel Speed : 500mm/s Initial Layer Speed : 50mm/s Skirt/Brim Speed : 50mm/s	Infill Acceleration : 12000 Outer Wall Acceleration : 5000 Inner Wall Acceleration : 5000 TOP Acceleration : 5000 Travel Acceleration : 12000 Initial Layer Print Acceleration : 500 Initial Layer Travel Acceleration : 500	Retract at Layer Change: ON Retract Distance: 2mm Retraction Retract Speed : 40mm/s Other parameters default	Outer Wall Flow : 100% Inner Wall Flow : 100% Top Flow : 100% Infill Flow : 100% Prime Tower 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.
	PEIG	Ender-3	Nozzle : 240°C Plate : 90°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed : 50mm/s Infill Speed : 50mm/s Wall Speed : 30mm/s Outer Wall Speed : 25mm/s Inner Wall Speed : 30mm/s Top Speed : 25mm/s Travel Speed : 100mm/s Initial Layer Speed : 20mm/s Skirt Speed : 20mm/s Number of Slower Layers : 2	0FF	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	/

	Raiso3D	Pro3 Plus	Extruder Temperature:240°C Heated Bed Temperature: 70°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: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 40mm/s Overhang Shell Speed: 30mm/s	0FF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MKS+	Nozzle:240°C Bed: 90°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 40mm/s Top solid infill: 50mm/s Support material: 25mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:3mm Lift Z: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 Small perimeters: 50mm/s External perimeters: 50mm/s Infill: 150mm/s Solid infill: 100mm/s Top solid infill: 150mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:3mm Lift Z: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	/
	Maker	M5	Nozzle : 240°C Plate : 90°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 120mm/s Infill 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	/
Bambu Lab	PiP		Nozzle : 250°C Plate : 100°C (PE, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 200mm/s Sparse infill: 200mm/s Internal solid infill: 200mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/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 On Min Fan Speed: 10% Max Fan Speed: 30%	22ml /s	Default or adjust as required	1. 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.
		11	Nozzle : 250°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 infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap 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 Min Fan Speed: 10% Max Fan Speed: 30%	22ml /s	Default or adjust as required	1. 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.
	Creatality	Ender-3	Nozzle : 240°C Plate : 100°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed : 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retractors Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Raiso3D	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 First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	0FF	Software default parameter	Filament Flowrate: 95%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
ABS	Prusa	MKS+	Nozzle:240°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 40mm/s Top solid infill: 50mm/s Support material: 25mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON 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:240°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 80mm/s Small perimeters: 60mm/s External perimeters: 80mm/s Infill: 150mm/s Solid infill: 80mm/s Top solid infill: 150mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing

	Aukor	H6	Nozzle : 250°C Plate: 100°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Infill Speed: 200mm/s Outer Wall: 80mm/s Inner Wall: 80mm/s First Layer: 50mm/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
Baidu Lab	PJP		Nozzle : 250°C Rate: 100°C (gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 200mm/s Sparse infill: 200mm/s Internal solid infill: 200mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap Infil: 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	23ml / s	Default or adjust as required	1. 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.
	X1		Nozzle : 250°C Rate: 100°C (engineering slab, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap Infil: 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: OFF	23ml / s	Default or adjust as required	1. 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.
Creality	Ender-3		Nozzle : 240°C Rate: 100°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s infil Speed: 50mm/s Wall Speed : 30mm/s Outer Wall Speed: 25mm/s Top Surface Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 150mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number 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: OFF	/	Default or adjust as required	Need to seal box printing
BMS+	Rainbow Print 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 Fast Layer Speed: 20mm/s infil Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging 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	MKS+		Nozzle: 230°C Bed: 100°C (glowing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External Perimeters: 25mm/s infil: 80mm/s Solid infil: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON 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: 235°C Bed: 100°C (glazing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 80mm/s Small perimeters: 60mm/s External perimeters: 80mm/s infil: 150mm/s Solid infil: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer charge: ON Wipe while retracting: ON Retract amount before wipe: 0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing
Aukor	H6		Nozzle : 255°C Plate: 100°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Infill Speed: 200mm/s Outer Wall: 80mm/s Inner Wall: 80mm/s First Layer: 50mm/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
Baidu Lab	PJP		Nozzle : 220°C Rate: 45°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 80mm/s Inner wall: 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap Infil: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5mm Retraction speeds: 30mm/s	Flow ratio: 1.05	Fan: ON Reference default parameter	5ml / s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	X1		Nozzle : 220°C Rate: 30°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 wall: 80mm/s Inner wall: 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap Infil: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5mm Retraction speeds: 30ma/s	Flow ratio: 1.05	Fan: ON Software default parameter	5ml / s	Default or adjust as required	The pullback length inside the material setting needs to be closed.

	Creativity	Ender-3	Nozzle : 220°C Plate : 45°C	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed : 40mm/s Infill Speed : 40mm/s Wall Speed : 15mm/s Outer Wall Speed : 15mm/s Inner Wall Speed : 15mm/s Top Speed : 20mm/s Travel Speed : 100mm/s Initial Layer Speed : 15mm/s Skirt Speed : 15mm/s Number of Slower Layers: 2	OFF	Retract at Layer Change : ON Retraction Distance : 2mm Retraction Speed : 30mm/s Retraction Prime Speed : 30mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
vTPU-95A	Raiso3D	Pico3 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: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shells Speed: 30mm/s	OFF	Software default parameter	Filament Flowrate: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Prusa	MKS3+		Nozzle:220°C Bed: 60°C (glazing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap Fill: 40mm/s	Software default parameters	Retraction Length:1mm Lift Z:0.2mm Retraction Speed: 25mm/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	/
Voron	B2		Nozzle:220°C Bed: 45°C (glazing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 40mm/s External perimeters: 40mm/s Infill: 80mm/s Solid infill: 60mm/s Top solid infill: 60mm/s Support material: 80mm/s Bridges: 20mm/s Gap Fill: 20mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1.05	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Auker	M5		Nozzle : 225°C Plate : 45°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 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	/
Rusho Lab	F3P		Nozzle : 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 Outer wall : 80mm/s inner wall : 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed : default Bridge: 50mm/s Gap infill: 250mm/s Travel speed : 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Lengths : 1.5mm Retraction speed: 30mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	fan / s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	X1		Nozzle : 220°C Plate : 30°C (Low temperature floor, glazing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer : 50mm/s First Layer infill: 50mm/s Outer wall : 80mm/s inner wall : 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed : default Bridge: 50mm/s Gap infill: 250mm/s Travel speed : 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Lengths : 1.5mm Retraction speed: 30mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	fan / s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
Creativity	Ender-3		Nozzle : 220°C Plate : 60°C	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed : 40mm/s Infill Speed : 40mm/s Wall Speed : 15mm/s Outer Wall Speed : 15mm/s Inner Wall Speed : 15mm/s Top Speed : 20mm/s Travel Speed : 100mm/s Initial Layer Speed : 15mm/s Skirt Speed : 15mm/s Number of Slower Layers: 2	OFF	Retract at Layer Change : ON Retraction Distance : 2mm Retraction Speed : 30mm/s Retraction Prime Speed : 30mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
vTPU-B5	Raiso3D	Pico3 Plus	Extruder Temperature:225°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: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shells Speed: 30mm/s	OFF	Software default parameter	Filament Flowrate: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Prusa	MKS3+		Nozzle:220°C Bed: 60°C (glazing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap Fill: 40mm/s	Software default parameters	Retraction Length:1mm Lift Z:0.2mm Retraction Speed: 25mm/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	/

	Voron	B2	Nozzle:230°C Bed: 45°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 40mm/s External perimeters: 40mm/s infill: 80mm/s Solid infill: 60mm/s Top solid infill: 60mm/s Support material: 80mm/s Bridges: 20mm/s Gap fill: 20mm/s	Software default parameters	Retraction Length:1mm Lift Z:0.2mm Retraction Speed: 25mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1.05	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Anker	W0	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 Infill Speed: 100mm/s Outer Wall: 50mm/s Inner Wall: 50mm/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	/
ePi4-CF	Bambu Lab	X1	Nozzle: 280°C Plate: 100°C (engineering slab, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.96	Fan: OFF	10ml/ s	Default or adjust as required	Need to seal box printing
	Rails3D	Pro3 Plus	Extruder Temperature:280°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: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shells Speed: 30mm/s	OFF	Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinkler head, need to replace the hardening nozzle.
	Prusa	MK3+	Nozzle:225°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 80mm/s infill: 80mm/s Solid infill: 40mm/s Top solid infill: 50mm/s Support material: 25mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinkler head, need to replace the hardening nozzle.
	Voron	B2	Nozzle:280°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 60mm/s Small perimeters: 50mm/s External perimeters: 50mm/s infill: 80mm/s Solid infill: 50mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 0.98	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinkler head, need to replace the hardening nozzle.
ePi4I2-CF	Bambu Lab	X1	Nozzle: 280°C Plate: 100°C (engineering slab,gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.96	Fan: OFF	10ml/ s	Default or adjust as required	Need to seal box printing
	Rails3D	Pro3 Plus	Extruder Temperature:280°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: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging 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	MK3+	Nozzle:225°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 80mm/s infill: 80mm/s Solid infill: 40mm/s Top solid infill: 50mm/s Support material: 25mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinkler head, need to replace the hardening nozzle.
	Voron	B2	Nozzle:280°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 60mm/s Small perimeters: 50mm/s External perimeters: 50mm/s infill: 80mm/s Solid infill: 50mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 0.98	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinkler head, need to replace the hardening nozzle.

eFLA-Metal	Bambu Lab	P1P	Nozzle: 220°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/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	22mm/s	Default or adjust as required	/
		X1	Nozzle: 220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/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	22mm/s	Default or adjust as required	/
	Creality	Endor-3	Nozzle: 215°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FF	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) 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: 60mm/s Solid Fill Speed: 60mm/s V/A Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MK3+	Nozzle:215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	/
	Voron	B2	Nozzle:215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 80mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm 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	/
	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 Infill Speed: 150mm/s Outer Wall: 50mm/s Inner Wall: 50mm/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	/
eFLA-PLA	Bambu Lab	P1P	Nozzle: 250°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 Outer wall: 100mm/s Inner wall: 100mm/s Sparse infill: 100mm/s Internal solid infill: 100mm/s Top surface: 100mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/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	22mm/s	Default or adjust as required	/
		X1	Nozzle: 240°C Plate: 50°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 100mm/s Inner wall: 100mm/s Sparse infill: 100mm/s Internal solid infill: 100mm/s Top surface: 100mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/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	22mm/s	Default or adjust as required	/
	Creality	Endor-3	Nozzle: 240°C Plate: 50°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 40mm/s Infill Speed: 40mm/s Wall Speed: 40mm/s Outer Wall Speed: 40mm/s Inner Wall Speed: 40mm/s Top Speed: 40mm/s Travel Speed: 40mm/s Initial Layer Speed: 40mm/s Skirt Speed: 40mm/s Number of Slower Layers: 2	0FF	Retraction:OFF	Flow: 50%	Fan: ON Fan speed:100%	/	Default or adjust as required	/

