

UltiMaker Cura 5.6.0 Profile Settings for K1 Max

Using "Custom FFF Printer"

Setting	Default	Fast(Benchy)	Normal	Fine	Personal
Layer Height	0.15	0.25	0.2	0.12	0.2
Infill Density	10	10	15	20	10
Printing Temperature	220	220	220	220	220
Build Plate Temperature	45	50	50	60	50
Flow	100	100	100	100	100
Print Speed	60	600	600	300	300
Top/Bottom Speed	600	200	200	150	150
Travel Speed	120	600	600	300	600
Initial Layer Speed	300	150	150	150	150
Enable Acceleration Control	FALSE	TRUE	TRUE	TRUE	TRUE
Print Acceleration	3000	20000	12000	12000	20000
Outer Wall Acceleration	3000	12000	5000	5000	16000
Inner Wall Acceleration	3000	12000	5000	5000	16000
Top Surface Acceleration	3000	12000	5000	5000	5000
Top/Bottom Acceleration	3000	20000	12000	5000	5000
Enable Jerk Control	FALSE	TRUE	TRUE	TRUE	TRUE
Print Jerk	20	8	8	8	8
Travel Jerk	30	30	30	30	30
Retraction Distance	0.4	0.2	0.2	0.4	0.4
Retraction Speed	40	60	60	40	40
Travel Avoid Distance	0.625	0.5	0.5	0.5	0.5
Minimum Layer Time	3	2	2	2	2
Minimum Speed	10	5	5	5	5
Pressure Advance Control	FALSE	TRUE	TRUE	TRUE	TRUE
Pressure Advance Smooth	FALSE	TRUE	TRUE	TRUE	TRUE
Pressure Advance Factor	0	0.02	0.02	0.02	0.02
Improve Quality					
Initial Layer Height	0.3	0.25	0.2	0.12	0.2
Wall Line Count	1	2	2	3	2
Wall Outer Wipe Distance	0.03	0.03	0.03	0.03	1.2
Wall Ordering	Inside to Out	Outside to In	Outside to In	Outside to In	Outside to In
Seam Corner Preference	Hide Seam	Expose Seam	Expose Seam	Expose Seam	Expose Seam
Top Surface Skin Layers	0	0	1	1	1
Top Surface Skin Line Width	0.6	-	0.34	0.34	0.34
Top Surface Skin Pattern	Zigzag	-	Lines	Lines	Lines
Top Surface Skin Line Direction	[]	-	[90]	[90]	[90]
Top Layers	2	3	4	7	6
Bottom Layers	2	3	3	3	3
Infill Line Multiplier	1	1	2	2	2