# 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 | 600 |
| Top/Bottom Speed | 600 | 200 | 200 | 150 | 200 |
| 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 | 12000 |
| Inner Wall Acceleration | 3000 | 12000 | 5000 | 5000 | 12000 |
| Top/Bottom Acceleration | 3000 | 20000 | 12000 | 5000 | 20000 |
| 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 | 0.2 |
| Retraction Speed | 40 | 60 | 60 | 40 | 60 |
| 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 | 3 |
| 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 Line Direction | [] | - | [90] | [90] | [90] |
| Top Layers | 2 | 3 | 4 | 7 | 4 |
| Infill Line Multiplier | 1 | 1 | 2 | 2 | 2 |
| Build Plate Adhesion Type | Brim | None | None | None | None |