

## Wall

Wall line count	3
Minimum Wall Line Width	Default 0.34 - Change to 0.015
Print Thin Walls	Check the box

## Top Bottom

Top Layers	5
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## Material

Printing Temp Initial Layer	205
Building Plate Temp Initial	65

## Speed

Initial Layer Speed	15
Skirt/Brim	25

## Travel

Retractions	Check the box
Retraction Distance	4 or 3
Retraction Speed	40

## Build Plate Adhesion

Build Plate Adhesion	Skirt
Skirt Line Count	3

## Special Modes

Specialize Outer Contour	Check the box
Smooth Spiralized	Check the box

## Preferences

Configure Cura	
Printer	
Machine Settings	
G28G29	