Wall

Wall line count   3

Minimum Wall Line Width   0.34 - Change to 0.015 or 0.15

Print Thin Walls   Check the box

Top Bottom

Top Layers   5

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