

# HUAFAST HS-MINI

## Configuration in Ultimaker Cura

Machine Settings

Huafast HS-Mini

Printer

Printer Settings

X (Width)

200

mm

Y (Depth)

200

mm

Z (Height)

200

mm

Build plate shape

Rectangular

Origin at center

Heated bed

✓

Heated build volume

G-code flavor

RepRap

Start G-code

```
G28 ;Home
G1 Z15.0 F6000 ;Move the platform down 15mm
;Prime the extruder
G92 E0
G1 F200 E3
G92 E0
```

Extruder 1

Printhead Settings

X min

0

mm

Y min

0

mm

X max

0

mm

Y max

0

mm

Gantry Height

0

mm

Number of Extruders

1

End G-code

```
M104 S0
M140 S0
;Retract the filament
G92 E1
G1 E-1 F300
G28 X0 Y0
M84
```

Close

Machine Settings

Huafast HS-Mini

Printer

Nozzle Settings

Nozzle size

0.4

mm

Compatible material diameter

1.75

mm

Nozzle offset X

0

mm

Nozzle offset Y

0

mm

Cooling Fan Number

0

Extruder Start G-code

Extruder End G-code

Close

Print settings

Profile

MiniBox\_V4New\_01 #4 Withe Huafast - Fine - 0,1mm

Search settings

Quality

Layer Height

0.1

mm

Line Width

0.4

mm

Wall Line Width

0.4

mm

Top/Bottom Line Width

0.4

mm

Infill Line Width

0.4

mm

Initial Layer Line Width

100.0

%

Shell

Wall Thickness

2

mm

Wall Line Count

5

Top/Bottom Thickness

1

mm

Top Thickness

1

mm

Top Layers

10

Bottom Thickness

1

mm

Bottom Layers

10

Horizontal Expansion

0

mm

Infill

Infill Density

90

%

Infill Pattern

Lines

Material

Printing Temperature

205

°C

Build Plate Temperature

40

°C

Build Plate Temperature Initial Layer

50

°C

Speed

Print Speed

40

mm/s

Infill Speed

40

mm/s

Travel

Enable Retraction

☒

Retraction Distance

4.54

mm

Retraction Speed

35

mm/s

Z Hop When Retracted

☐

Cooling

Enable Print Cooling

☒

Fan Speed

100.0

%

Minimum Layer Time

5

s

Support

Build Plate Adhesion

Build Plate Adhesion Type

Skirt