1. Nozzle not jetting, back pressure change or nozzle clogged.
2. Nozzle jetting droplets with very small satellite droplets, nozzle slightly clogged. Can influence the top surface smoothness and accuracy of the boundary. Sometimes hard to detect by eyes.
3. Droplets too small, will generate rough surface.
4. Droplets too large, will ball up the top surface.
5. Certain position always not printing, will leave a line gap, nozzle problem.
6. Previous surface not fully cured, latter printed material can act with previous layer and generate air bubbles, especially two layers with different materials. Hard to detect by eyes, only see the bubbles and know it happened.
7. Printing at wrong location, always g-code problem.