Prusa Slicer Suggestion -
nozzle change, extrusion width & dual extruder.

I have a few questions regarding PrusaSlicer:

1. Which setting should I change when I change the nozzle size other than 0.4mm?
2. How can I choose for the extruder when I am using the Creality CR-X (bowden two extruder into one hotend)?

Regards,
Ken

tanken
@tanken
Famed Member
| 45 Posts
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Hi Ken,

Good to hear from you again, sounds like you have an exciting project going on?

Please see answers to your questions below:

1. Which setting should I change when I change the nozzle size other than 0.4mm?

When changing nozzle size you also have to change your extrusion width to match. You can find these values under Print Settings - Advanced - Extrusion Width. For instance when you are changing your nozzle from a 0.4 to a 0.6, you need to change your extrusion widths from 0.4, up to 0.6. If you were going from 0.4 to a 0.2, you would need to reduce your extrusion widths lower to match. This may need some tweaks, like if you notice gaps in top or bottom fills, wall delamination or over extrusion, increase or decrease by multiples of 0.05 to get the best out comes.

2. How can I choose for the extruder when I am using the Creality CR-X (bowden two extruder into one hotend)?

To add a second extruder in PrusaSlicer, first go to Printer Settings and under capabilities increase the number of extruders to 2. Then in the menu to the left you will see that you have "Extruder 1" and "Extruder 2" options. if you click on these and make sure the Extruder Offset value is at 0,0 as you are still using one hotend.

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Once that is all set, you will notice on your print bed in the platter panel, there will be a purge block model which is where colour will be purged between colour changes. To set which extruder prints which part of the model, you will first need a model prepared for multi colour printing. This requires a model split into parts where each part represents the different colour of your model. Please see this model and how it is split in to different parts (https://www.thingiverse.com/thing:2332398). You will see that it is split in to 3 parts which represent the different parts of the lizard that should be different colours.

On the right hand side of the of the plater screen where you can see a list of the STL files, you also have the option to select which extruder handles which part of the model, just double click on the number next to each model part to select. Just above that you will see an option called "Purge Volumes" where you set how much each material purges in to the purge block during a colour change.

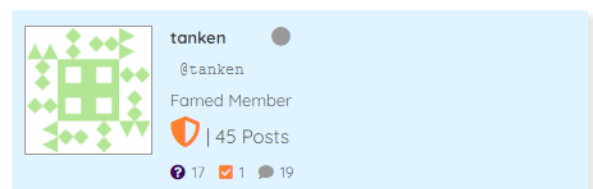Hope that helps and let me know if you have any other questions?

Thanks
David

ThreeDeeDave
(@threedeedave)
Member   Moderator
69 Posts
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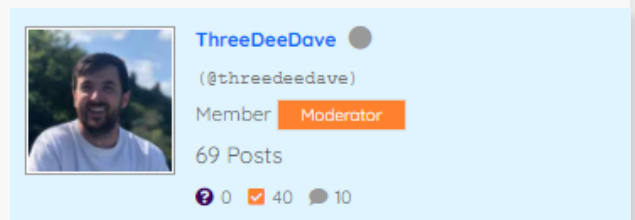
I have a few questions regarding PrusaSlicer:

Hi,
Any recommended percentage for extrusion width?

Regards,
Ken

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Hi Ken,

Short answer is between 100% - 120%. I would recommend 112/113% to get a value of near 0.45mm

There are a number of options you can go for in ways to set extrusion width. You can work in mm (which is what I would recommend as you can be a little more precise and its better to work in the value format that you are setting). You can work in percentage which is used to calculate the width in mm eg 0.4 x 100% = 0.4 or 0.4 x 120%= 0.48. Or alternatively you could set all values to "0" and it will get the values from the set nozzle size. If you hover your mouse over each of the value names, it will give you a description of how it will calculate the extrusion width if left at "0".

Hope that helps

Thanks
David

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69 Posts
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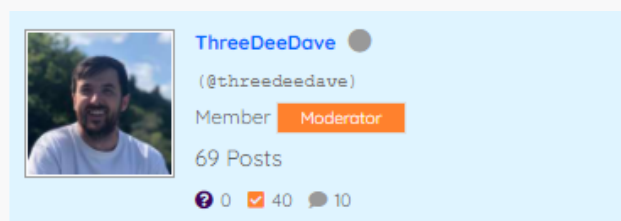
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