**Ender 3 Cura**

**Best Layer Heights**

Min Resolution : 0.64mm, this takes one full step step to complete, set z height multiples of full step to get better result.

0.04 mm = 1 uStep

0.08 mm = 2 uStep

0.12 mm = 3 uStep

0.16 mm = 4 uStep

0.20 mm = 5 uStep

0.24 mm = 6 uStep

0.28 mm = 7 uStep

0.32 mm = 8 uStep

0.36 mm = 9 uStep

0.40 mm = 10 uStep

0.44 mm = 11 uStep

0.48 mm = 12 uStep

0.52 mm = 13 uStep

0.56 mm = 14 uStep

0.60 mm = 15 uStep

0.64 mm = 16 uStep

1.28 mm = 32 uStep

2.56 mm = 64 uStep

5.12 mm = 128 uStep

This G-Code Remix Improves your Ender 3 Performance by Heating the Bed & Nozzle Simultaneously. It also provides for easy part removal since it causes the build plate to slide forward on completion. Copy & Paste these into your Machine Settings for a “Better Ender”

Start G-Code

G28 ;Home

M104 S{material\_print\_temperature\_layer\_0} ; set extruder temp

M140 S{material\_bed\_temperature\_layer\_0} ; set bed temp

M190 S{material\_bed\_temperature\_layer\_0} ; wait for bed temp

M109 S{material\_print\_temperature\_layer\_0} ; wait for extruder temp

G1 Z15.0 F6000 ;Move the platform down 15mm

;Prime the extruder

G92 E0

G1 F200 E3

G92 E0

M117 Printing @ 1MM.

End G-Code

G91

G1 F1800 E-3

G1 F3000 Z10

G90

G1 X0 Y220 F1000 ; prepare for part removal

M106 S0 ; turn off cooling fan

M104 S0 ; turn off extruder

M140 S0 ; turn off bed

M84 ; disable motors

M117 printed @ 1mm.