Klipper Config:

FW with Pressure Advance of 0.88 and PA Lookup Time of 0.1, Combing Mode: noskin, Retraction Speed: 65mm/sec, Retraction Distance: 6mm, Initial Layer Horizontal Expansion: -0.2mm, Outer Walls Before Inner Walls: True, Print Speed: 100mm/sec, Infill Density: 10%, In Klipper's Printer.cfg file, I added two lines:, pressure\_advance: 0.88, pressure\_advance\_lookahead\_time: 0.1, If I'm printing a model that needs supports, I usually switch the support pattern to Cross, and the Z-distance to 0.2mm (default is zigzag and 0.1mm, which I find harder to remove). I do not print miniatures, so depending on what you're printing, you may or may not find these settings useful. If I'm printing in vase mode (Spiralize Outer Contour in Cura), I will often bump the flow setting up to ensure that I get a solid, slightly thicker than default wall. This is helpful if you want a water-tight vase. Also may want to increase the number of bottom layers if you want water-tight.

used the default config file titled "Ender 3 2018" that Klipper provides. Only thing changed was the max accel rate from 3000 to 1500. Then I added pressure advance @ 0.50, look ahead rate @ 0.075, and square corner velocity @ 5.0 (default).

0.24 layers @ 60mm/s, 800mm/s accel and 15mm/s square corner velocity, PA 0.450 with 0.01 look ahead, 2.5mm retraction @ 25mm/s with 0.064 extra prime

With capricorn tubing pressure advance 0.400 set retraction to 2-4mm at 25mm/s, max accel :500

retraction distance : 2.0mm, retraction speed : 45mm/s, pressure advance : 0.0100, pressure advance lookahead : 0.010