**3D Printer:**

**3D Model format:** .stl or .obj

**Recommended Material/Filament:** PLA (brand : esun, filatech, creality) Optional: ABS, TPU, Nylon CF, PETG etc..

**Filament Diameter:** 1.75mm, Approx Price: 100AED for 1 kg.

**Slicer Software for Printers:**

Creality Print for K1 Max & K2 Plus Printer: <https://www.creality.com/pages/download-software>

Flash Print for Adventure 3 & Creator 3: <https://enterprise.flashforge.com/pages/flashprint>

**Default Print Setting for PLA:**

Extruder Temperature: 220 Deg C

Bed temperature: 50 deg C

Print Speed: 200- 300 mm/s

Layer Height: 0.2mm

Infill Density: Low Strength: 20%, Medium Strength: 35% and high strength: 65%

Infill Type: Rectilinear, honeycomb

Supports: required for hanging / bridging model

Base layer: Required for lean base and wide top features in the model.

**Laser Machine:**

**Format:** .dxf file (2D) or adobe Pdf as 2D drawings