

E-PLA - Cura

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E-PLA

Introduction

Welcome to this comprehensive material settings guide!

Here you will find the settings we have found to produce the best results in our quality lab. However, every printer is unique in a sense, so we cannot guarantee these settings will work flawlessly on every printer out there. Therefore, please view these parameters more like a place to start than failsafe, fixed settings. Remember, you can always reach out to support@addnorth.com, should you encounter any errors or have any other questions.

Good luck and happy printing!

Drying table

Temp (°C) 55

Time (h) 2-4

Instructions

To be able to modify the settings below, select 'custom' as your print setup and click on the cog-wheels in the topic rows and enable the desired settings to make them modifiable

Load with built-in material profile (Cura) PLA

Settings

Quality

Layer height 0.15

Initial layer height 0.25

Line width 0.35

Initial layer line width 1.1

Shell

Wall thickness	1.2
Top Thickness	0.6
Bottom Thickness (4 layers)	0.6
Compensate wall overlaps	Yes
Fill gaps between walls	Everywhere
Seam corner preference	Hide seam

Material

Printing temperature (+-5°C, depending on setup)	215
Printing temperature initial layer	215
Build plate temperature	60
Build plate temperature initial layer	60
Flow	98
Retraction distance (direct drive)	0.8mm
Retraction distance (bowden)	5.5mm
Retraction speed (mm/s)	35

Speed

Print speed	60mm/s
Wall speed	45mm/s
Outer wall speed	30mm/s
Initial layer speed	20mm/s

Travel

Combing Mode	All
Retract before outer wall	Yes
Z Hop when retracted	Yes

Cooling

Fan speed	100
Initial fan speed	0
Regular fan speed at layer	2
Minimum layer time	5

Build plate adhesion

Build plate adhesion type	Brim
Brim width	5mm

Recommended printer upgrades

Special nozzle	None
Extra bed adhesion	None