

<b>Quality</b>	
Layer height	0,2 mm
<b>Shell</b>	
Wall thickness	2 mm
Wall line count	5
<i>Top/Bottom thickness</i>	0,6 mm
Top/Bottom pattern	Lines
Bottom pattern initial layer	Lines
Compensate wall overlaps	Yes
<b>Infill</b>	
<i>Infill density</i>	30
<i>Infill pattern</i>	Tri-Hexagon
Infill directions	[ ]
Infill overlap	0,04 mm
Skin overlap	0,02 mm
Infill wipe distance	0,1 mm
Infill layer thickness	0,2 mm
Gradual infill steps	0
Infill before walls	No
Skin removal width	2,0 mm
Maximum skin angle for expansion	90°
<b>Material</b>	
Printing temperature	200 °C
Build plate temperature	25 °C
Build plate temperature – initial layer	70 °C
Diameter	1,75 mm
Flow	110 %
Enable retraction	Yes
Retraction distance	5 mm
Retraction speed	40 mm/s

<b>Speed</b>	
Print speed	60 mm/s
Travel speed	120 mm/s
Print acceleration	500 mm/s
<i>Travel acceleration</i>	500 mm/s
Print jerk	20 mm/s
Travel jerk	30 mm/s
<b>Cooling</b>	
Fan speed	100 %
Regular Fan speed	100 %
Maximum fan speed	100 %
Initial fan speed	0 %
<i>Regular fan speed at layer</i>	3
<b>Support</b>	
Generate support	When necessary
<b>Build plate adhesion</b>	
<i>Build plate adhesion type</i>	Brim when necessary / otherwise Skirt
Brim width	8 mm