

Cura GCode scripts

Materials

	PLA	PETG	TPU
Z Offset (mm)	0.00	0.12 / 0.16	0.00
speed (mm/s)			
print	60	60	40
perimeters	30	30	20
1st layer	30	30	20
travel	150	180	150
infill	90	60	60
temperature (°C)			
nozzle	190-210	235-250	230-240
bed: glass	60/50	70/60	60/50
bed: fiberglass/buildtak	0/0	70/30	0/0
retraction			
length (mm)	4	2.5	0
speed (mm/s)	30	35	0
cooling			
start	0 %	0 %	0 %
max (@ layer)	100 % (2)	50 % (3)	100 % (2)
supports			
Z distance (mm)	0.12	0.2	0.16 (*)
X/Y distance (mm)	0.2	0.4	0.6
Angle	70 °	60 °	60°

(*) Enable support interface to improve surface quality.

Quality

Based on PLA, adapt accordingly to other materials.

	Standard	Detailed	Best	Fast	Stupid Fast	Vase (*)
layer height	0.2 mm	0.16 mm	0.08 mm	0.28 mm	0.32 mm	0.28 mm
top/bottom layers	3/2	6/4	10/6	3/2	3/2	2
speed (mm/s)						
print	60	50	50	60	100	60
walls	30	25	25	30	70	60
infill	90	60	60	100	200	N/A
1st layer	30	25	25	30	100	30
travel	150	150	120	170	170	170
acceleration (mm/s²)						
print	750	750	600	800	800	600
infill	1000	750	600	1500	1500	N/A
travel	2500	2500	2500	2500	2500	2500
jerk (mm/s)						
print	15	15	15	20	20	20

(*) Use post-processing to set nozzle temperature to +10 °C and 200% flow rate starting from the first *non bottom* layer.

Source : [GitHub](#)