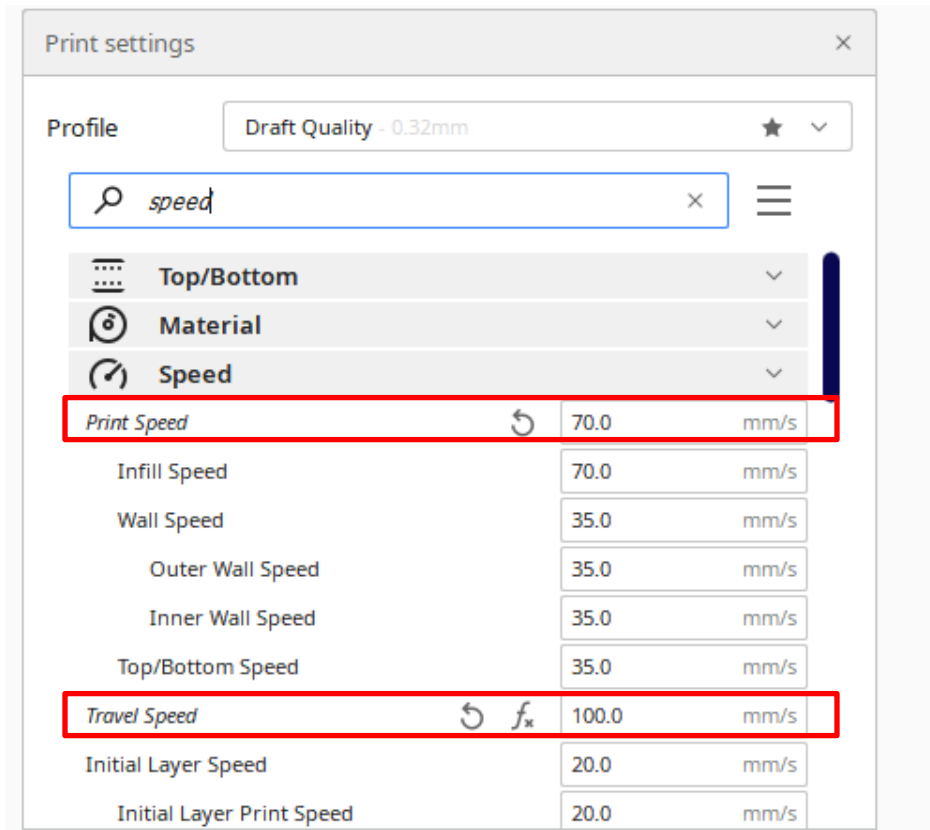
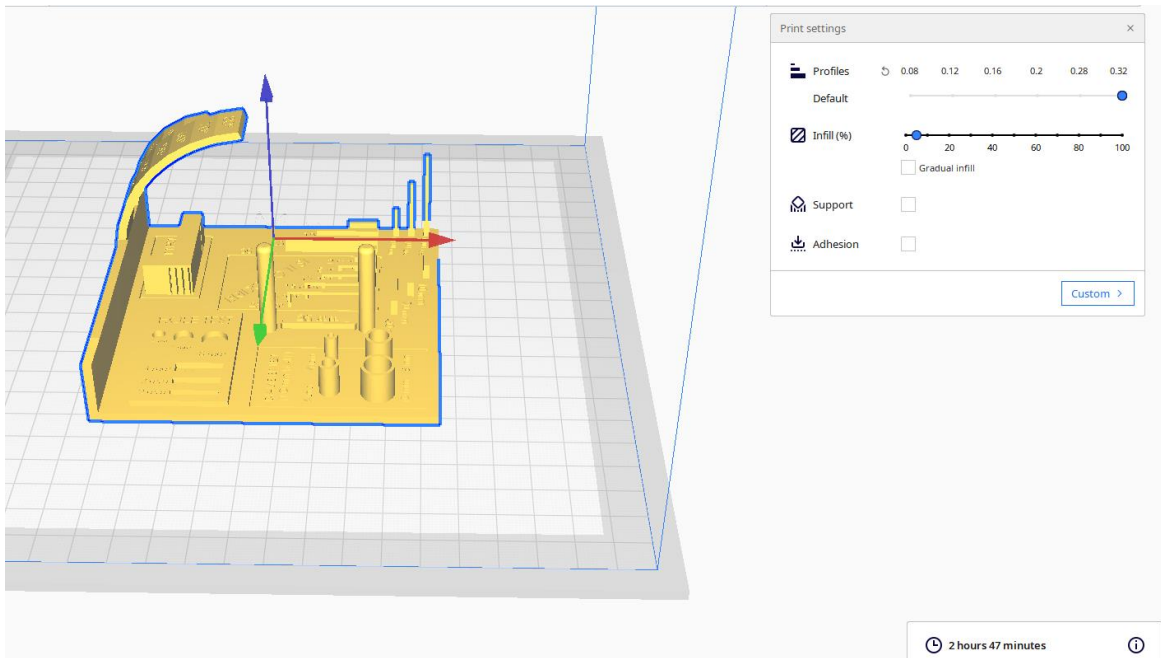
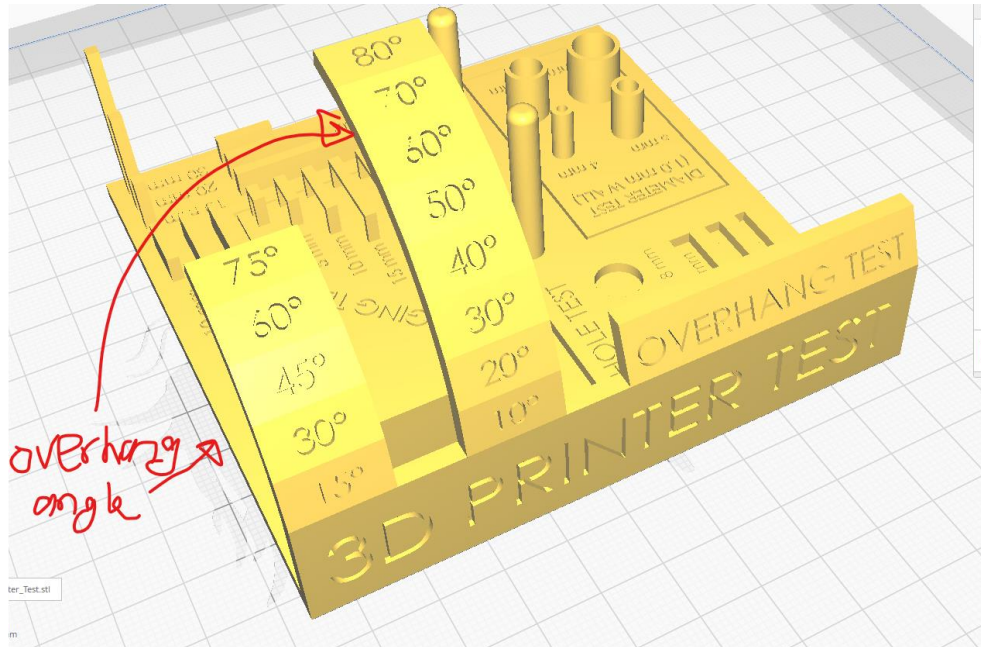


Printer Settings

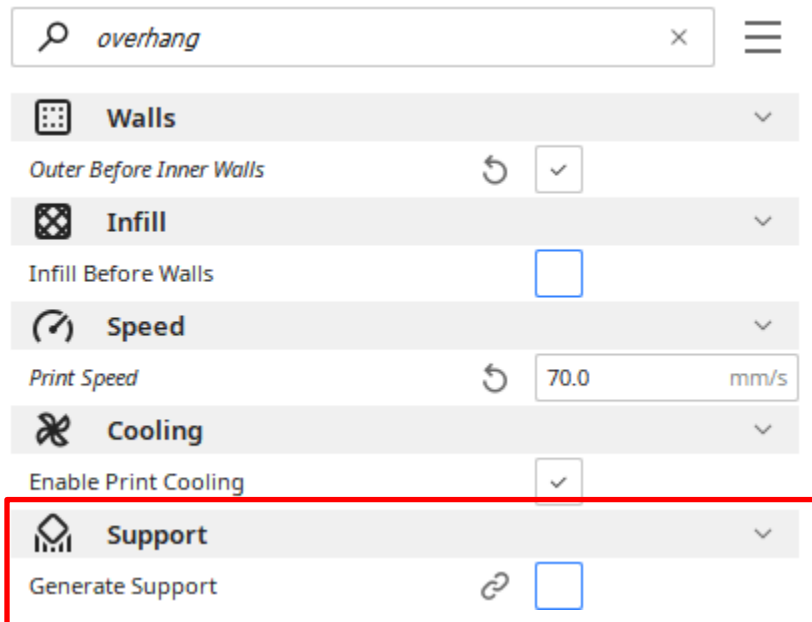
Settings	Settings used	Additional Notes
Minimum Layer Height – Determines the finest detail the printer can achieve.	Layer height used was 0.32mm	
Print Speed – Affects quality and precision, balancing speed vs. accuracy	Print speed 70 mm/s Travel speed 100mm/s	
Overhang Angle – Tests how steep an overhang can be printed without support	No overhang angle selected in settings because supports were not enabled	Evaluate on Model
Bridging Capability – Checks how well the printer can span gaps without support	Bridge minimum distance 5mm	
Extrusion Accuracy – Ensures consistent filament flow and layer adhesion.	Flow rate set to 100%. Model needs to be evaluated to determine if there is over extrusion or under extrusion	Evaluate on Model
Dimensional Accuracy – Tests how close the printed part is to the intended dimensions	Model needs to be evaluated to determine dimensional accuracy	Evaluate on Model
First Layer Adhesion – Evaluates bed leveling and adhesion quality	Model needs to be evaluated to	Evaluate on Model
Cooling Efficiency – Important for printing small details and overhangs	Fan speed was set to 100%	
Tolerance & Fit – Tests how well printed parts fit together (clearance tests)	Model needs to be evaluated to test for tolerance and fits	Evaluate on Model
Stringing & Retraction – Checks for unwanted filament strings between gaps	Retraction was set at 4mm with a speed of 25mm/s	Evaluate on Model
Warping & Shrinkage – Evaluates how well materials resist warping	Model needs to be evaluated to determine if there was warping/shrinkage that took place. No adhesion was used on the first layer	Evaluate on Model
Material Compatibility – Tests how well different filaments (PLA, ABS, PETG, etc.) print	Material used to Print is PLA	
Nozzle Clogging & Maintenance Needs – Determines how often the printer requires maintenance.	-	Our printers are well maintained



Overhang Angle (on model)



No overhang selected on printer settings because supports are not added on model



Bridge settings

Bridge

Experimental

Enable Bridge Settings	<input checked="" type="checkbox"/>
Minimum Bridge Wall Length	5.0 mm
Bridge Skin Support Threshold	50.0 %
Bridge Sparse Infill Max Density	0.0 %
Bridge Wall Coasting	100.0 %
Bridge Wall Speed	17.5 mm/s
Bridge Wall Flow	50.0 %
Bridge Skin Speed	17.5 mm/s
Bridge Skin Flow	60.0 %
Bridge Skin Density	100.0 %
Bridge Fan Speed	100.0 %

< Recommended

Extrusion accuracy
Flow rate set to 100%

Flow Rate Compensation Factor	100.0 %
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Retraction settings

Travel

Enable Retraction	<input checked="" type="checkbox"/>
Retract at Layer Change	<input type="checkbox"/>
Retraction Distance	4.0 mm
Retraction Speed	25.0 mm/s
Retraction Retract Speed	25.0 mm/s
Retraction Prime Speed	25.0 mm/s