

# Sample Slic3r settings for Proto-pasta HTPLA on Prusa MK3

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Protoplant

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## Layers and perimeters

- Infill
- Skirt and brim
- Support material
- Speed
- Multiple Extruders
- Advanced
- Output options
- Notes
- Dependencies

## Layer height

Layer height:  mm

First layer height:  mm or %

## Vertical shells

Perimeters:  (minimum)

Spiral vase:

Recommended object thin wall thickness for layer height 0.20 and 2 lines:  
0.86 mm

## Horizontal shells

Solid layers: Top:  Bottom:

## Quality (slower slicing)

Extra perimeters if needed:

Ensure vertical shell thickness:

Avoid crossing perimeters:

Detect thin walls:

Detect bridging perimeters:

## Advanced

Seam position:

External perimeters first:

0.20mm FAST MK3 HTPLA



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## Infill

Fill density:  50% %Fill pattern:  GridTop/bottom fill pattern:  Rectilinear

## Reducing printing time

Combine infill every:  1 layersOnly infill where needed: 

## Advanced

Solid infill every:  0 layersFill angle:  45 °Solid infill threshold area:  0 mm<sup>2</sup>Bridging angle:  0 °Only retract when crossing perimeters: Infill before perimeters:

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## Speed for print moves

Perimeters:	<input type="checkbox"/>	30	mm/s
Small perimeters:	<input type="checkbox"/>	30	mm/s or %
External perimeters:	<input type="checkbox"/>	30	mm/s or %
Infill:	<input type="checkbox"/>	65	mm/s
Solid infill:	<input type="checkbox"/>	65	mm/s or %
Top solid infill:	<input type="checkbox"/>	65	mm/s or %
Support material:	<input type="checkbox"/>	30	mm/s
Support material interface:	<input type="checkbox"/>	100%	mm/s or %
Bridges:	<input type="checkbox"/>	30	mm/s
Gap fill:	<input type="checkbox"/>	30	mm/s

## Speed for non-print moves

Travel:  200 mm/s

## Modifiers

First layer speed:  30 mm/s or %

## Acceleration control (advanced)

Perimeters:	<input type="checkbox"/>	0	mm/s <sup>2</sup>
Infill:	<input type="checkbox"/>	0	mm/s <sup>2</sup>
Bridge:	<input type="checkbox"/>	0	mm/s <sup>2</sup>
First layer:	<input type="checkbox"/>	0	mm/s <sup>2</sup>
Default:	<input type="checkbox"/>	0	mm/s <sup>2</sup>

## Autospeed (advanced)

Max print speed:	<input type="checkbox"/>	200	mm/s
Max volumetric speed:	<input type="checkbox"/>	0	mm <sup>3</sup> /s
Max volumetric slope positive:	<input type="checkbox"/>	0	mm <sup>3</sup> /s <sup>2</sup>
Max volumetric slope negative:	<input type="checkbox"/>	0	mm <sup>3</sup> /s <sup>2</sup>

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## Extrusion width

Default extrusion width:	<input type="text" value="0.7"/>	mm or % (leave 0 for auto)
First layer:	<input type="text" value="0"/>	mm or % (leave 0 for default)
Perimeters:	<input type="text" value="0"/>	mm or % (leave 0 for default)
External perimeters:	<input type="text" value="0"/>	mm or % (leave 0 for default)
Infill:	<input type="text" value="0"/>	mm or % (leave 0 for default)
Solid infill:	<input type="text" value="0"/>	mm or % (leave 0 for default)
Top solid infill:	<input type="text" value="0"/>	mm or % (leave 0 for default)
Support material:	<input type="text" value="0"/>	mm or % (leave 0 for default)

## Overlap

Infill/perimeters overlap:  mm or %

## Flow

Bridge flow ratio:

## Other

Clip multi-part objects:

Elephant foot compensation:  mm

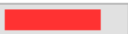
XY Size Compensation:  mm

Resolution:  mm

Proto-pasta HTPLA

- Filament
- Cooling
- Advanced
- Custom G-code
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## Filament

Color: 

Diameter:  mm

Extrusion multiplier:

Density:  g/cm<sup>3</sup>

Cost:  money/kg

## Temperature °C

Extruder: First layer:  Other layers:

Bed: First layer:  Other layers:

Proto-pasta HTPLA

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## Enable

Keep fan always on: Enable auto cooling: 

If estimated layer time is below ~5s, fan will run at 100% and print speed will be reduced so that no less than 5s are spent on that layer (however, speed will never be reduced below 10mm/s).  
During the other layers, fan will always run at 100% except for the first 2 layers

## Fan settings

Fan speed: Min:  % Max:  %Bridges fan speed:  %Disable fan for the first:  layers

## Cooling thresholds

Enable fan if layer print time is below:  approximate secondsSlow down if layer print time is below:  approximate secondsMin print speed:  mm/s

Original Prusa i3 MK3 HTPLA

- General
- Custom G-code
- Extruder 1**
- Notes
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## Size

Nozzle diameter:  mm

## Layer height limits

Min:  mmMax:  mm

## Position (for multi-extruder printers)

Extruder offset:  x:  y:  mm

## Retraction

Length:  mm (zero to disable)Lift Z:  mmOnly lift Z: Above Z:  mm Below Z:  mmRetraction Speed:  mm/sDeretraction Speed:  mm/sExtra length on restart:  mmMinimum travel after retraction:  mmRetract on layer change: Wipe while retracting: Retract amount before wipe:  %

## Retraction when tool is disabled (advanced settings for multi-extruder setups)

Length:  mm (zero to disable)Extra length on restart:  mm

## Preview

Extruder Color: