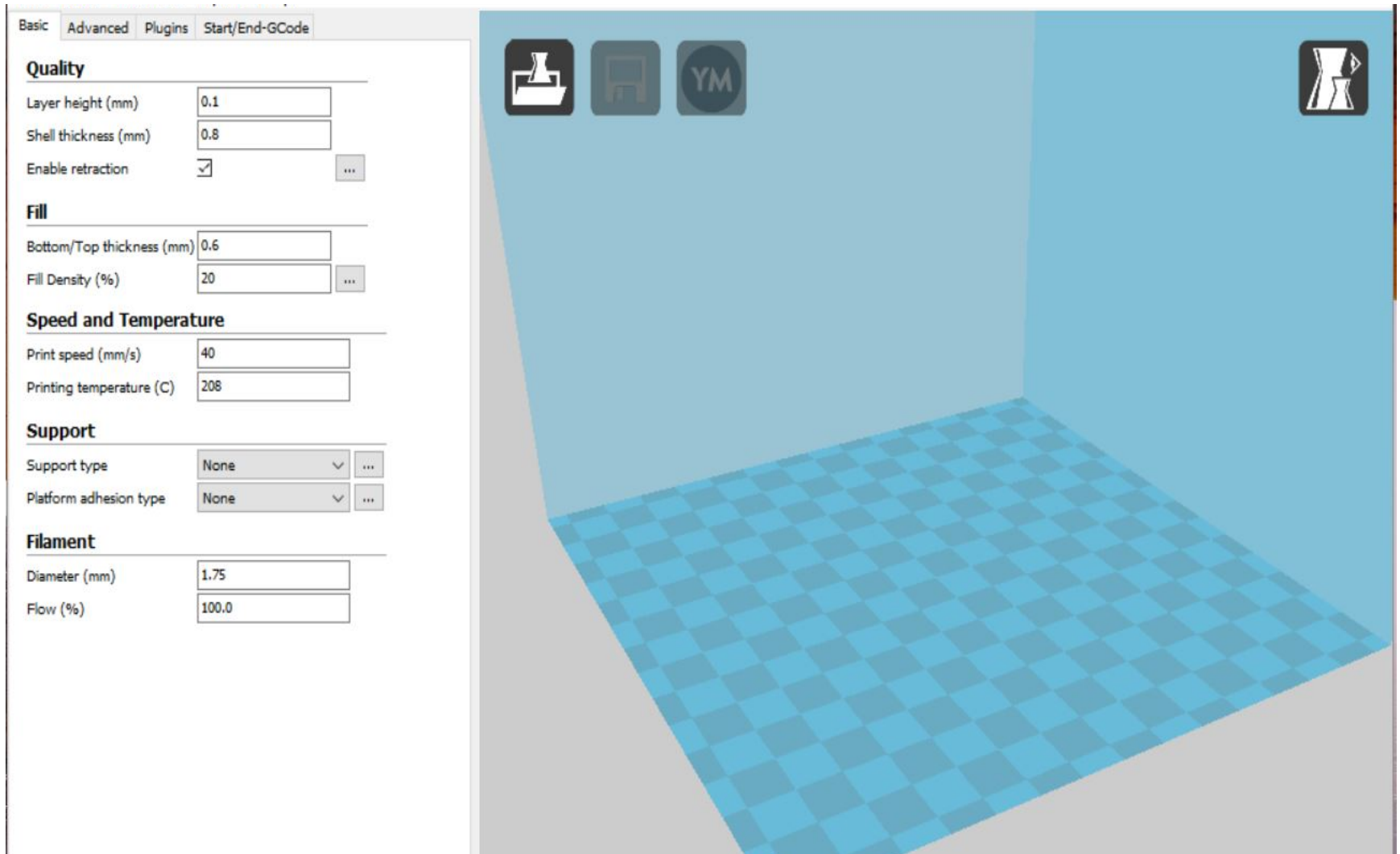


Cura



Cura - 15.02.1

File Tools Machine Expert Help

Basic Advanced Plugins Start/End-GCode

Machine

Nozzle size (mm)

Retraction

Speed (mm/s)

Distance (mm)

Quality

Initial layer thickness (mm)

Initial layer line width (%)

Cut off object bottom (mm)

Dual extrusion overlap (mm)

Speed

Travel speed (mm/s)

Bottom layer speed (mm/s)

Infill speed (mm/s)

Top/bottom speed (mm/s)

Outer shell speed (mm/s)

Inner shell speed (mm/s)

Cool

Minimal layer time (sec)

Enable cooling fan



Cura - 15.02.1

File Tools Machine Expert Help

Basic Advanced Plugins Start/End-GCode

start.gcode
end.gcode

```
;Sliced at: {day} {date} {time}
;Basic settings: Layer height: {layer_height}
;Print time: {print_time}
;Filament used: {filament_amount}m {filament_color}
;Filament cost: {filament_cost}
;M190 S{print_bed_temperature} ;Uncomment to prevent overheating the bed
;M109 S{print_temperature} ;Uncomment to add preheat for the nozzle
G21 ;metric values
G90 ;absolute positioning
M82 ;set extruder to absolute mode
M107 ;start with the fan off
G28 X0 Y0 ;move X/Y to min endstops
G28 Z0 ;move Z to min endstops
G1 Z15.0 F{travel_speed} ;move the platform down
G92 E0 ;zero the extruded length
G1 F200 E3 ;extrude 3mm of feedstock
G92 E0 ;zero the extruded length again
G1 F{travel_speed}
;Put printing message on LCD screen
M117 Printing...
```

Line count

1

Start distance (mm)

3.0

Minimal length (mm)

150.0

Cool

Fan full on at height (mm)

0.5

Fan speed min (%)

100

Fan speed max (%)

100

Minimum speed (mm/s)

10

Cool head lift

Infill

Solid infill top

Solid infill bottom

Infill overlap (%)

15

Black Magic

Spiralize the outer contour

Only follow mesh surface

Brim

Brim line amount

20

Raft

Extra margin (mm)

5.0

Line spacing (mm)

3.0

Base thickness (mm)

0.3

Base line width (mm)

1.0

Interface thickness (mm)

0.27

Interface line width (mm)

0.4

Airgap

0.0

First Layer Airgap

0.22

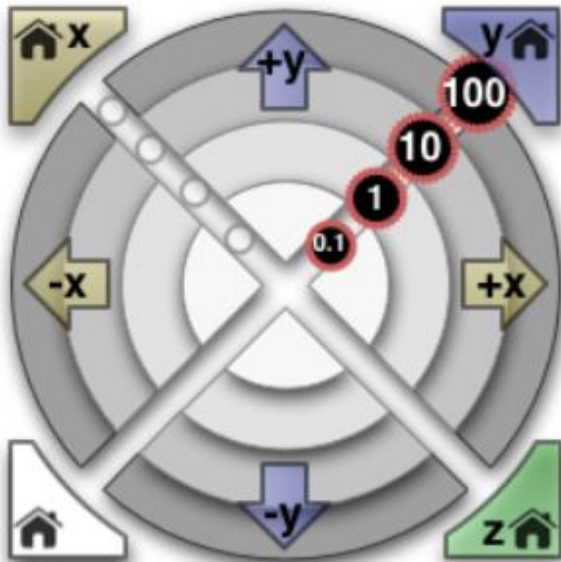
Surface layers

2

Connect

Print

Cancel



TOOL UP

+Z

10

1

0.1

TOOL DOWN (mm)

-Z

RETRACT (mm)

+E

10

1

0.1

RETRACT (mm)

-E

250									
200									
150									
100									
50									
0									

Temperature

Bed temp

