




Models (double-click to edit)

- treefrog\_45\_cut

 Import  Remove

 Center and Arrange

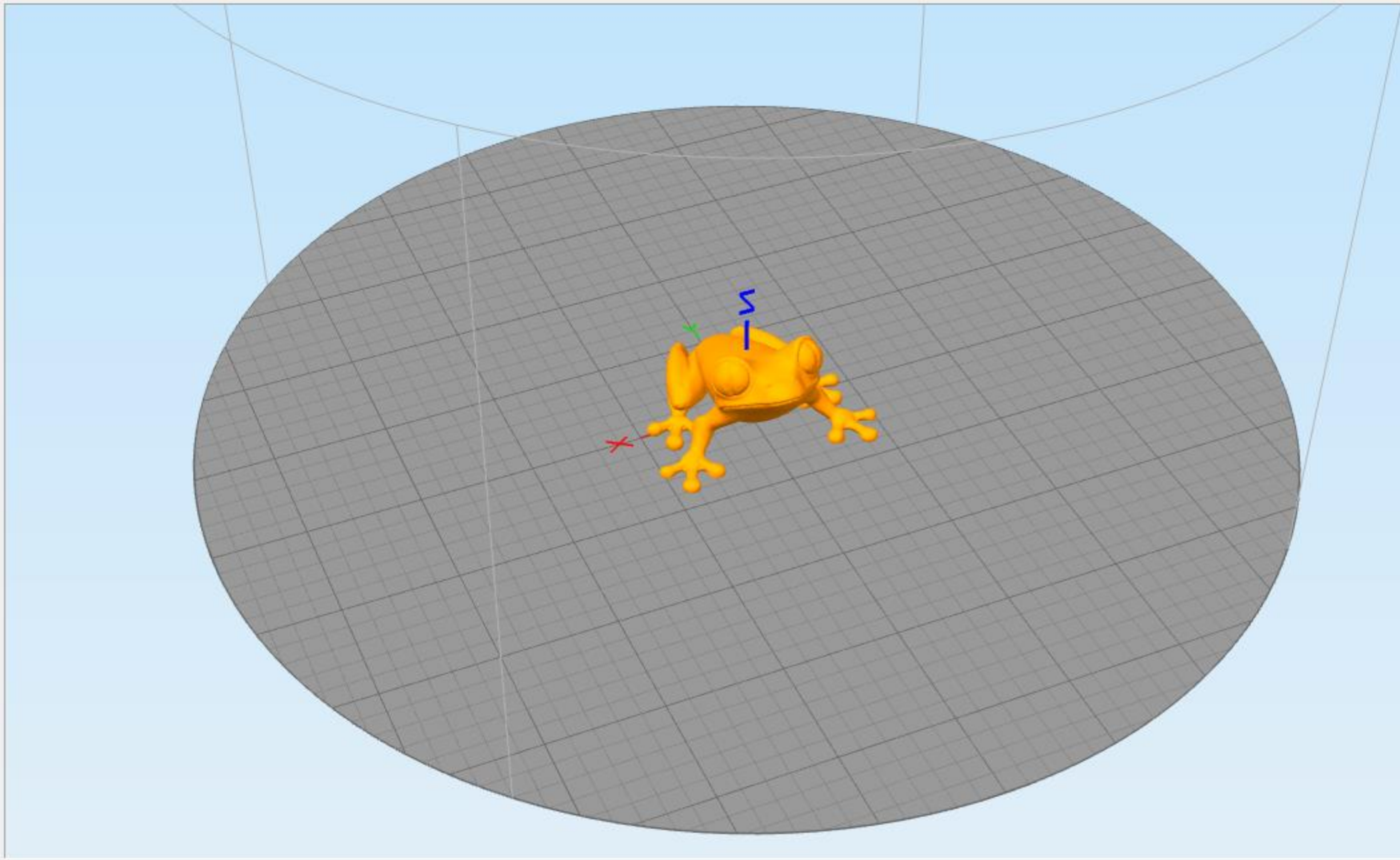
Processes (double-click to edit)

Name	Type
Process1	FFF

 Add  Delete

 Edit Process Settings

 Prepare to Print!



Process Name:

Select Profile:

Auto-Configure for Material  
 PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality  
 Fast  Medium  High

General Settings  
Infill Percentage:  14%  Include Raft  Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Other

Extruder List  
(click item to edit settings)

- Primary Extruder

### Primary Extruder Toolhead

Overview

Extruder Toolhead Index:

Nozzle Diameter:  mm

Extrusion Multiplier:

Extrusion Width:  Auto  Manual  mm

Ooze Control

Retraction  
 Retraction Distance:  mm  
 Extra Restart Distance:  mm  
 Retraction Vertical Lift:  mm  
 Retraction Speed:  mm/s

Coast at End  
 Coasting Distance:  mm

Wipe Nozzle  
 Wipe Distance:  mm

Process Name:

Select Profile:

Auto-Configure for Material  
 PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality  
 Fast  Medium  High

General Settings  
Infill Percentage:  14%  Include Raft  Generate Support

- Extruder
- Layer
- Additions
- Infill
- Support
- Temperature
- Cooling
- G-Code
- Scripts
- Other
- Advanced

Layer Settings

Primary Extruder:

Primary Layer Height:  mm

Top Solid Layers:

Bottom Solid Layers:

Outline/Perimeter Shells:

Outline Direction:  Inside-Out  Outside-In

Print islands sequentially without optimization

Single outline corkscrew printing mode (vase mode)

First Layer Settings

First Layer Height:  %

First Layer Width:  %

First Layer Speed:  %

Start Points

Use random start points for all perimeters

Optimize start points for fastest printing speed

Choose start point closest to specific location

X:  Y:  mm



# FFF Settings



Process Name:

Select Profile:

Auto-Configure for Material  
 PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality  
 Fast  Medium  High

General Settings  
Infill Percentage:  14%  Include Raft  Generate Support

Skirt Settings  
 Include Skirt/Brim Skirt Extruder:   
Skirt Layers:   
Skirt Offset:  mm  
Skirt Outlines:

Raft Settings  
 Include Raft Raft Extruder:   
Raft Layers:   
Raft Offset:  mm  
Separation:  mm  
Raft Infill:  %  
 Disable raft base layers



# FFF Settings



Process Name:

Select Profile:

Auto-Configure for Material  
 PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality  
 Fast  Medium  High

General Settings  
Infill Percentage:  14%  Include Raft  Generate Support

General  
Infill Extruder   
External Fill Pattern   
Interior Fill Percentage  %  
Outline Overlap  %  
Infill Extrusion Width  %  
Minimum Infill Length  mm  
Print Sparse Infill Every  layer(s)  
 Include solid diaphragm every  layers  
 Use random infill placement for each layer

Infill Angles  
 deg

# FFF Settings

Process Name:

Select Profile:  Import Remove Export

Auto-Configure for Material  
 PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality  
 Fast  Medium  High

General Settings  
 Infill Percentage:  14%  Include Raft  Generate Support

- Extruder
- Layer
- Additions
- Infill
- Support
- Temperature
- Cooling
- G-Code
- Scripts
- Other
- Advanced

Support Material Generation

Generate Support Material

Support Extruder

Support Infill Percentage  %

Extra Inflation Distance  mm

Dense Support Layers

Dense Infill Percentage  %

Print Support Every  layer(s)

Automatic Placement  
*Only used if manual support is not defined*

Support Pillar Resolution  mm

Max Overhang Angle  deg

Seperation From Part

Horizontal Offset From Part  mm

Upper Vertical Separation Layers

Lower Vertical Separation Layers

Support Infill Angles

deg

Add Angle

Remove Angle

Hide Advanced Select Models OK Cancel

Process Name:

Select Profile:

Auto-Configure for Material:  PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality:  Fast  Medium  High

General Settings

Infill Percentage:  14%  Include Raft  Generate Support

- Extruder
- Layer
- Additions
- Infill
- Support
- Temperature
- Cooling
- G-Code
- Scripts
- Other
- Advanced

Temperature Controller List  
(click item to edit settings)

Primary Extruder
------------------

### Primary Extruder Temperature

Overview

Temperature Identifier:

Temperature Controller Type:  Extruder  Heated build platform

Relay Temperature Between Each:  Layer  Loop

Wait for temperature controller to stabilize before beginning build

Per-Layer Temperature Setpoints

Layer	Temperature
1	210

Layer Number:

Temperature:  °C

### FFF Settings

Process Name:

Select Profile:

Auto-Configure for Material:  PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality:  Fast  Medium  High

General Settings

Infill Percentage:  14%  Include Raft  Generate Support

Extruder | Layer | Additions | Infill | Support | Temperature | Cooling | **G-Code** | Scripts | Other | Advanced

**G-Code Options**

- 5D firmware (include E-dimension)
- Relative extrusion distances
- Allow zeroing of extrusion distances (i.e. G92 E0)
- Use independent extruder axes
- Include M101/M102/M103 commands
- Firmware supports "sticky" parameters

**G-Code Offsets**

	X-Axis	Y-Axis	Z-Axis	
Offset	<input type="text" value="0.00"/>	<input type="text" value="0.00"/>	<input type="text" value="0.00"/>	mm

**Update Machine Definition**

Update Machine Definition using settings below

*This is a convenient way to update your machine definition along with your FFF profile. It is especially useful if you are constantly switching between different printers.*

Machine type:

	X-Axis	Y-Axis	Z-Axis	
Build volume	<input type="text" value="170.0"/>	<input type="text" value="170.0"/>	<input type="text" value="149.7"/>	mm
Origin offset	<input type="text" value="85.0"/>	<input type="text" value="85.0"/>	<input type="text" value="0.0"/>	mm
Homing dir	<input type="text" value="Center"/>	<input type="text" value="Center"/>	<input type="text" value="Max"/>	

Flip build table axis  X  Y  Z



## FFF Settings

Process Name: Select Profile: 

Auto-Configure for Material

 PLA ABS PVA Nylon

Auto-Configure for Print Quality

 Fast Medium High

General Settings

Infill Percentage:

14%

 Include Raft Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Other

Advanced

Starting G-Code

Layer Change G-Code

Tool Change G-Code

Ending G-Code

```
G28 ; home all axes
G1 Z1 F1200 ; lower towers
```

End Code csak lusta vagyok minden ablakot menteni msáhol Üres:

```
M104 S0 ; turn off extruder
M140 S0 ; turn off bed
G28 ; home axes
M84 ; disable motors
```

Post Processing

 Create .x3g file for MakerBot printers using GPX plugin (see Tools > Firmware Configuration for conversion settings) Add celebration at end of build (for .x3g files only) Create .makerbot file for 5th Gen MakerBot printers

Additional terminal commands for post processing



# FFF Settings



Process Name:

Select Profile:

Auto-Configure for Material  
 PLA  ABS  PVA  Nylon

Auto-Configure for Print Quality  
 Fast  Medium  High

General Settings  
Infill Percentage:  14%  Include Raft  Generate Support

- Extruder
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Speeds

Default Printing Speed	<input type="text" value="50.0"/>	mm/s
Outline Underspeed	<input type="text" value="40"/>	%
Solid Infill Underspeed	<input type="text" value="50"/>	%
Support Structure Underspeed	<input type="text" value="80"/>	%
X/Y Axis Movement Speed	<input type="text" value="50.0"/>	mm/s
Z Axis Movement Speed	<input type="text" value="50.0"/>	mm/s

Filament Properties

Filament diameter	<input type="text" value="1.7500"/>	mm
Filament price	<input type="text" value="6500.00"/>	price/kg

Bridging

Unsupported area threshold	<input type="text" value="50.0"/>	sq mm
Bridging extrusion multiplier	<input type="text" value="95"/>	%
Bridging speed multiplier	<input type="text" value="70"/>	%

## FFF Settings

Process Name: Process1

Select Profile: Kossel Mini

Import

Remove

Export

Auto-Configure for Material

 PLA ABS PVA Nylon

Auto-Configure for Print Quality

 Fast Medium High

General Settings

Infill Percentage:

14%

 Include Raft Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Other

Advanced

Layer Modifications

 Start printing at height 0.00 mm Stop printing at height 0.00 mm

Slicing Behavior

Non-manifold segments:  Discard  Heal Merge all outlines into a single solid model

Thin Wall Behavior

 Only use perimeters for thin walls Allow gap fill when necessary

Allowed perimeter overlap 10 %

Ooze Control Behavior

 Only retract when crossing open spaces Force retraction between layers Minimum travel for retraction 3.00 mm Extruder ooze rate 100.0 mm/s Only wipe extruder for outer-most perimeters

Tool Change Retraction

Tool change retraction distance 12.00 mm

Tool change extra restart distance -0.50 mm

Tool change retraction speed 10.0 mm/s

Hide Advanced

Select Models

OK

Cancel

### Build Statistics

Build time: 0 hours 54 minutes  
Filament length: 1881.6 mm  
Plastic weight: 5.66 g (0.01 lb)  
Material cost: 36.77

### Show in Preview

- Build table
- Travel moves
- Toolhead
- Retractions

### Real-time Updates

Live preview tracking

Update interval  sec



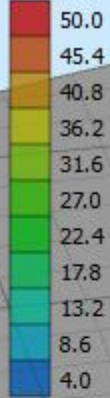
Begin Printing over USB



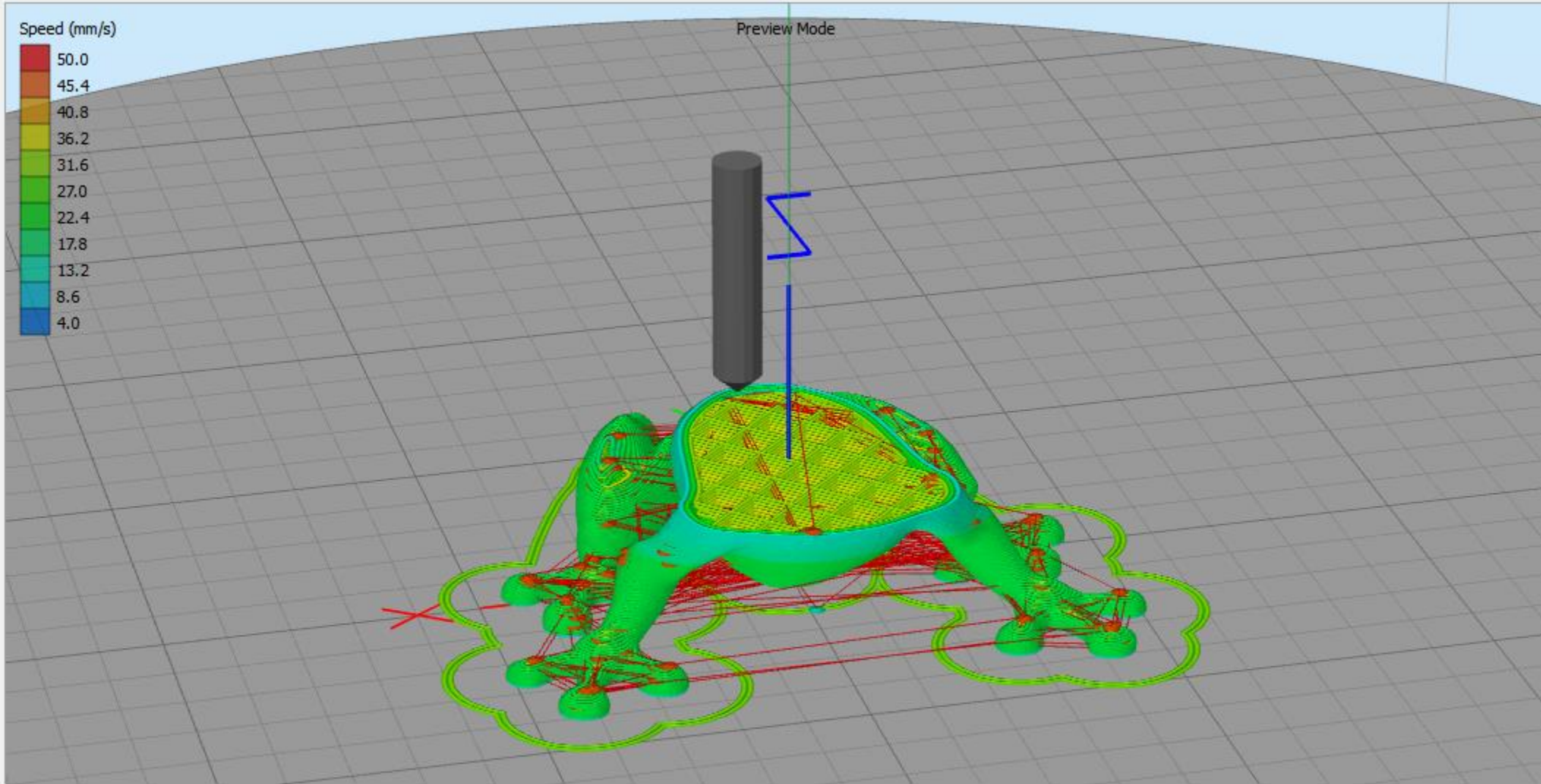
Save Toolpaths to Disk

Exit Preview Mode

### Speed (mm/s)



Preview Mode



Play/Pause

Preview By

- Layer
- Line

Start

End

Speed:

Single line only

