

0.300 [min] 0.00

Style | Support | Ext Map | Printer | Printer G-code | Matl | Matl G-code | Misc. | **PRO**

Printer Name: WinPC-NC 25-35 Offset 0.2

Hardware | Firmware | **Speed** | Extruder Hardware

All speeds in [mm/s]

'Fast' (Lower quality)		'Precise' (Slower)	
<input type="text" value="25"/>	>>> Perimeter	<input type="text" value="3.7"/>	> Perimeter
<input type="text" value="35"/>	>>> Loops	<input type="text" value="20"/>	> Loops
<input type="text" value="35"/>	>>> Solid Infill & Support*	<input type="text" value="12"/>	> Solid Infill & Support*
<input type="text" value="35"/>	>>> Sparse Infill*	<input type="text" value="12"/>	> Sparse Infill*

* sets the speed for the Stacked version as well

X,Y Travel Speed
 Rim Speed (Deltas)
 Z-Speed
 1st Layer Max Speed
 Limit Increase / Layer
 XY Accel [mm/s^2]

Show Settings
 Settings Level:

Perim: 14.35 [mm/s]
 Loops: 27.50 [mm/s]
 Solid: 23.50 [mm/s]
 Sparse: 23.50 [mm/s]

|

Style

Support

Ext Map

Printer

Printer G-code

Matl

Matl G-code

Misc.

PRO

Show Settings

Style Name

Layer Thickness [mm]

Num Loops

Infill: 10.0%

Set %
Infill

Extrusion Width [mm]

Loops go
from Inside
to Perimeter

Infill Extrusion
Width [mm]

Skin Thickness [mm]

Inset Surface [mm]

Stacked Layers
(Sparse Infill, Support)

Depth

Seam Hiding

Gap

De-String Wipe

Use Corners

Angle



Jitter°

Settings Level

Perim: 14.35 [mm/s]

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Copy
Style

Center

Delete
Style

Fast Precise

Precision
(vs. Speed)

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Show Settings

Support Name Medium Support

Off [Support: Medium] On

Raft Type: Off

Prime Pillar / Skirt / Wall: No Prime Structure

Support / Object Interface (in [mm])

Solid

XY Gap: 0.5

Z Raft Int: 0

Flow Gain: 0.80

Z Gap: 0.2

Band Layers: 2

Support 45 [deg] Inflation: 0

Sheath Main Support

Raft Grid Options (in [mm])

▲ Stride: 1.5

▲ Thick: 0.25

▲ Width: 0.35

▼ Stride: 2.5

▼ Thick: 0.25

▼ Width: 0.5

Inflation Raft & Support: 1

Z-Roof [mm]: 92

Sheath Z-Roof [mm]: -1

Prime Gap: 1

Brim Dia. [mm]: 0

Brim Ht. [mm]: 0

Fillet:

Settings Level: Expert

Perim: 14.35 [mm/s]
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Style

Support

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Show Settings

Note: this mapping is saved with Printer profile

Extruder 1 Material

PLA 0.85 Flow

Extruder 2 Material

ABS normal

Extruder 3 Material

ABS normal

Extruder 4 Material

ABS normal

Extruder Ordering Optimization

Reuse Latest (least time)

**Default
Extruder Mapping**

Default

Object Ext

Ext 1

Interface Ext

Ext 1

Raft Ext

Ext 1

Support Ext

Ext 1

Settings Level

Expert

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Printer

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Show Settings

Material Name: Color

Diameter [mm]:

Temperature [C] for the <TEMP> token:

Destring [mm]			Fan / Cool			Flow Adjust		
Prime	Suck	Wipe	Loops	Inside	Cool	Flow Tweak	Min [mm ³ /s]	Max [mm ³ /s]
<input type="text" value="4.35"/>	<input type="text" value="4.25"/>	<input type="text" value="5"/>	<input type="text" value="100"/>	<input type="text" value="100"/>	<input type="text" value="100"/>	<input type="text" value="0.85"/>	<input type="text" value="0.02"/>	<input type="text" value="20"/>
▲vP	▲vS		Fan Z [mm]	Min Layer [s]		Other		
<input type="text" value="30"/>	<input type="text" value="15"/>	[mm/s]	<input type="text" value="5"/>	<input type="text" value="20"/>		Z-lift [mm] <input type="text" value="0.2"/>		
Min Jump[mm]	<input type="text" value="1"/>					▼ Coef Calc		
Trigger [mm]	<input type="text" value="10"/>					<input type="text" value="0"/>		
						Warm Time		
						▼ Cost Calc		
						<input type="text" value="0"/>		
						\$ / cm ³		

Settings Level:

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Copy Material | Center

Delete Material

Style	Support	Ext Map	Printer	Printer G-code	Matl	Matl G-code	Misc.	PRO	<input checked="" type="checkbox"/> Show Settings
[*] N Layers 0	Prefix	Select New Ext & Warm	Warm Same Ext	Cool Same Ext	Cool & Retire Old Ext	N [*] Layers	Postfix		Settings Level Expert
<EXT+n> <MAXZ> <X> <Y> <Z> <E> <NEXTX> <NEXTY> <BED> <TEMP> <WARM1> <WARM2> <WARM3> <WARM4> <%> <TELAPSED> <TREMAIN> <TTOTAL> <MATL> <ACCEL>	<pre>G01 F2100 Z190 X10 Y190 ;Parkpos M09 ;Kühlmittel Steckdose aus M30 ;Programmende</pre>							Perim: 14.35 [mm/s] Loops: 27.50 [mm/s] Solid: 23.50 [mm/s] Sparse: 23.50 [mm/s]	
Defaults ▶								Copy Printer	Center
								Delete Printer	

Style	Support	Ext Map	Printer	◀ Printer G-code	Matl	◀ Matl G-code	Misc.	PRO	<input checked="" type="checkbox"/> Show Settings
[*] N Layers 0		Prefix	Select New Ext & Warm	Warm Same Ext	Cool Same Ext	Cool & Retire Old Ext	N [*] Layers	Postfix	Settings Level Expert
<EXT+n> <MAXZ> <X> <Y> <Z> <E> <NEXTX> <NEXTY> <BED> <TEMP> <WARM1> <WARM2> <WARM3> <WARM4> <%> <TELAPSED> <TREMAIN> <TTOTAL> <MATL> <ACCEL>		[G71; [mm] mode G90; absolute mode G28; Home T01 M06 ;Werkzeug 1 G01 F2100 Z20 X20 Y20 ;Startposition M07 ;Kühlmittel Steckdose an							
Defaults ▶		Copy Printer		Delete Printer		Center			
						Perim: 14.35 [mm/s] Loops: 27.50 [mm/s] Solid: 23.50 [mm/s] Sparse: 23.50 [mm/s]			

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Show Settings

Printer Name WinPC-NC 25-35 Offset 0.2

Settings Level
Expert

Hardware | Firmware | Speed | Extruder Hardware

Extruder 1	Gain 1 1	Axis 1 A		
Extruder 2	Gain 2 1	Axis 2 E	X off 2 0	Y off 2 0
Extruder 3	Gain 3 1	Axis 3 E	X off 3 0	Y off 3 0
Extruder 4	Gain 4 1	Axis 4 E	X off 4 0	Y off 4 0

Extruder Clearance (Radius)
0

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Printer Name: WinPC-NC 25-35 Offset 0.2

Hardware | Firmware | Speed | Extruder Hardware

Firmware Type: 5D - Abs E no Reset (makerbot) | File Extension: nc

None | Mark Path Start/Stop | Fan On: M80 | Fan Off: M-80

Include Comments | Fan can do PWM (e.g. 'M106 Snnn')

Post-Process

Show Settings

Settings Level: Expert

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Printer Name WinPC-NC 25-35 Offset 0.2

Hardware | Firmware | Speed | Extruder Hardware

Number of Extruders: 1 | Loop / Solid Infill Overlap: 0.50 | \$ / hour: 0

Bed Size [mm] X: 204 | Y: 204 | Z: 210

Bed Center [mm] X: 102 | Y: 102 | Bed is Round

Bed Roughness [mm]: 0 | Z-Settle [mm]: 0 | Z Offset [mm]: 0.2

Bed STL Model C:\Programmi\KISSlicer_Win32_1_1_0\la4_plate.STL

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