

eSUN Part filament print parameters												
materials	3D Printer brand	model number	Printing temperature	Layer height/ Line width	printing speed	Acceleration	Retraction	extrusion	cooling	Max volumetric speed	other parameters	matter need attention
PLA	拓竹 Bambu Lab	F1P	Nozzle: 220°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm ³ /s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
		X1	Nozzle: 220°C Plate: 35°C (Low temperature floor, glass)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm ³ /s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
PLA+	创想 Creality	K1	Printing Temperature: 220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		K1 MINI	Printing Temperature: 220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		Ender-3	Nozzle: 215°C Plate: 60°C (glass)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0%	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Retract Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	复志 Bambu3D	Pro3 Plus	Extruder Temperature: 225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width: 0.4mm	Default Printing Speed: 200mm/s Inner Shell Speed: 300mm/s Outer Shell Speed: 200mm/s First Layer Speed: 50mm/s Infill Speed: 275mm/s Solid Fill Speed: 100mm/s X/Y Axis Movement Speed: 200mm/s Z Axis Movement Speed: 15mm/s Support Speed: 300mm/s Thin Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Bridging Speed: 50mm/s Overhang Shells Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	Prusa	MINI+	Nozzle: 215°C Bed: 60°C (glass)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap Fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 50%	Extrusion multiplier: 1	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	Voron	R2	Nozzle: 215°C Bed: 60°C (glass)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 80mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap Fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 0%	Extrusion multiplier: 1	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	安克Anker	M5	Nozzle: 215°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 250mm/s Infill Speed: 250mm/s Outer Wall: 100mm/s Inner Wall: 150mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	拓竹	F1P	Nozzle: 220°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	22mm ³ /s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.

eFLA-ES	宝岛 Lab	11	Nozzle :220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml / s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
	创意 Creativity	K1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		K1 ML	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 200mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		Ender-3	Nozzle :215°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 20mm/s Outer Wall Speed: 30mm/s Inner Wall Speed: 25mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Retract Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	
	复志 Realize3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 200mm/s Inner Shell Speed: 300mm/s Outer Shell Speed: 200mm/s First Layer Speed: 50mm/s Infill Speed: 275mm/s Solid Fill Speed: 100mm/s X/Y Axis Movement Speed: 200mm/s Z Axis Movement Speed: 15mm/s Support Speed: 300mm/s Thin Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Bridging Speed: 50mm/s Overhang Skirt Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MKS+	Nozzle:215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Yonoo	B2	Nozzle:215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 150mm/s Infill: 150mm/s Solid infill: 80mm/s Top solid infill: 150mm/s Support material: 40mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	安克Anker	M5	Nozzle :215°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 250mm/s Infill Speed: 250mm/s Outer Wall: 100mm/s Inner Wall: 150mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	宝岛 Lab	PIP	Nozzle :220°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml / s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.
		11	Nozzle :220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml / s	Default or adjust as required	The printing speed of the same model should not be too big. If the speed is too big, the printing gloss is not the same.

ePLA-Lite	創想 Creality	K1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		K1 MINI	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 300mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 90% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing
		Ender-3	Nozzle: 215°C Plate: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FP	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
ePLA-Lite	雙北 Rainbow	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 150mm/s Inner Shell Speed: 150mm/s Outer Shell Speed: 100mm/s First Layer Speed: 50mm/s Infill Speed: 100mm/s Solid Fill Speed: 100mm/s X/Y Axis Movement Speed: 200mm/s Z Axis Movement Speed: 15mm/s Support Speed: 200mm/s Thin Wall Speed: 150mm/s Gap Filling Speed: 150mm/s Bridging Speed: 50mm/s Overhang Shell Speed: 50mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		MINI+	Nozzle: 215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		B2	Nozzle: 215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 80mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:5%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
ePLA-Lite	安克 Anker	B5	Nozzle: 215°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 150mm/s Infill Speed: 150mm/s Outer Wall: 50mm/s Inner Wall: 50mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
		F1P	Nozzle: 230°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 150mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml /s	Default or adjust as required	/
		B1	Nozzle: 230°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 150mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml /s	Default or adjust as required	/
ePLA-Lite	創想 Creality	K1	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 100mm/s Inner Wall Speed: 150mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing

vPLA-Battle	创想 Creality	K1 ML3	Printing Temperature:220°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 100mm/s Inner Wall Speed: 150mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing	
	Ender-3	Nozzle: 220°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 60mm/s Retraction Prime Speed: 60mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	/	
	复志 Ravoo3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 20mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s XY Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	0FF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	/
	Prusa	MINI+	Nozzle: 220°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 25mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/	/
	Yoroo	R2	Nozzle: 220°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 100mm/s Small perimeters: 50mm/s External perimeters: 50mm/s Infill: 100mm/s Solid infill: 100mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/	/
	安克Anker	M5	Nozzle: 215°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 120mm/s Infill Speed: 50mm/s Outer Wall: 50mm/s Inner Wall: 100mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	/
vPLA-Battle	vPLA Ravoo Lab	PIP	Nozzle: 205°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 250mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml /s	Default or adjust as required	/	/
		11	Nozzle: 205°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 250mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: ON Software default parameter	23ml /s	Default or adjust as required	Open the cabin door for printing	
	创想 Creality	K1 ML3	Printing Temperature:205°C Build Printing Temperature: 60°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 300mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 200mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 0.8mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 95% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	Do not seal the box when printing	

4PLA-511k		Ender-3	Nozzle : 200°C Plate : 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed : 50mm/s Infill Speed : 50mm/s Wall Speed : 30mm/s Outer Wall Speed : 25mm/s Inner Wall Speed : 30mm/s Top Speed : 25mm/s Travel Speed : 100mm/s Initial Layer Speed : 20mm/s Skirt Speed : 20mm/s Number of Slower Layers : 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	雙北 Rain3D	Pro3 Plus	Extruder Temperature:200°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed : 60mm/s Inner Shell Speed : 30mm/s Outer Shell Speed : 20mm/s First Layer Speed : 20mm/s Infill Speed : 60mm/s Solid Fill Speed : 60mm/s X/Y Axis Movement Speed : 100mm/s Z Axis Movement Speed : 15mm/s Support Speed : 60mm/s Thin Wall Speed : 40mm/s Gap Filling Speed : 40mm/s Bridging Speed : 30mm/s Overhang Shell Speed : 30mm/s	0FF	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MKS+	Nozzle : 200°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 50mm/s Support material: 25mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voron	B2	Nozzle : 205°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 120mm/s Small perimeters: 70mm/s External perimeters: 70mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 70mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:5%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	安克Anker	M5	Nozzle : 210°C Plate: 60°C (PEI)	Layer height : 0.1-0.2mm (0.4mm) Line width : default parameters	Travel Speed : 250mm/s Printing Speed : 200mm/s Infill Speed : 200mm/s Outer Wall : 100mm/s Inner Wall : 100mm/s First Layer : 50mm/s Skirt Speed : 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
雙竹 Bambu Lab	PIP	Nozzle : 260°C Plate : 80°C (PEI, gluing)	Layer height : 0.1-0.2mm(0.4mm) Line width : default parameters	First layer : 50mm/s First Layer infill : 50mm/s Outer wall : 200mm/s Inner wall : 200mm/s Sparse infill : 200mm/s Internal solid infill : 200mm/s Top surface : 150mm/s Slow down for overhangs : ON Overhang speed : default Bridge : 50mm/s Gap infill : 200mm/s Travel speed : 200mm/s	First layer : 500 Outer wall : 5000 Top surface : 2000 Normal printing : 10000	Software default parameter	Flow ratio : 0.98	Fan: ON Software default parameter	15ml / s	Default or adjust as required	The printing speed of the same model should not be too big, if the speed is too big, the printing gloss is not the same.	
	X1	Nozzle : 260°C Plate : 80°C (Engineering slab, gluing)	Layer height : 0.1-0.2mm(0.4mm) Line width : default parameters	First layer : 50mm/s First Layer infill : 50mm/s Outer wall : 200mm/s Inner wall : 200mm/s Sparse infill : 200mm/s Internal solid infill : 200mm/s Top surface : 150mm/s Slow down for overhangs : ON Overhang speed : default Bridge : 50mm/s Gap infill : 200mm/s Travel speed : 200mm/s	First layer : 500 Outer wall : 5000 Top surface : 2000 Normal printing : 10000	Software default parameter	Flow ratio : 0.98	Fan: ON Software default parameter	15ml / s	Default or adjust as required	The printing speed of the same model should not be too big, if the speed is too big, the printing gloss is not the same.	
雙德 Creality	K1	Printing Temperature:245°C Build Printing Temperature: 80°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 200mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 200mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 2mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	The printing speed of the same model should not be too big, if the speed is too big, the printing gloss is not the same.	
	K1 MAX	Printing Temperature:245°C Build Printing Temperature: 80°C	Layer Height: 0.1-0.2mm(0.4mm) Line width: default parameters	Infill Speed: 200mm/s Outer Wall Speed: 150mm/s Inner Wall Speed: 200mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brm Speed: 50mm/s	Infill Acceleration: 12000 Outer Wall Acceleration: 5000 Inner Wall Acceleration: 5000 TOP Acceleration: 5000 Travel Acceleration: 12000 Initial Layer Print Acceleration: 500 Initial Layer Travel Acceleration: 500	Retract at Layer Change: ON Retract Distance: 2mm Retraction Retract Speed: 40mm/s Other parameters default	Outer Wall Flow: 100% Inner Wall Flow: 100% Top Flow: 100% Infill Flow: 100% Prime Tower Flow: 100% Initial Layer Flow: 100%	Fan: ON Software default parameter	/	Default or adjust as required	The printing speed of the same model should not be too big, if the speed is too big, the printing gloss is not the same.	
	Ender-3	Nozzle : 240°C Plate : 90°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed : 50mm/s Infill Speed : 50mm/s Wall Speed : 30mm/s Outer Wall Speed : 25mm/s Inner Wall Speed : 30mm/s Top Speed : 25mm/s Travel Speed : 100mm/s Initial Layer Speed : 20mm/s Skirt Speed : 20mm/s Number of Slower Layers : 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	
PEIG		Ender-3	Nozzle : 240°C Plate : 90°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed : 50mm/s Infill Speed : 50mm/s Wall Speed : 30mm/s Outer Wall Speed : 25mm/s Inner Wall Speed : 30mm/s Top Speed : 25mm/s Travel Speed : 100mm/s Initial Layer Speed : 20mm/s Skirt Speed : 20mm/s Number of Slower Layers : 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/

复志 RuiZhi	Pro3 Plus	Extruder Temperature:240°C Heated Bed Temperature: 70°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed : 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	(FF)	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/	
Prusa	MKS+	Nozzle:240°C Bed: 90°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s		Software default parameters	Retraction Length:3mm Lift Z:0mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Voron	R2	Nozzle:240°C Bed: 90°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 100mm/s Small perimeters: 50mm/s External perimeters: 50mm/s Infill: 150mm/s Solid infill: 100mm/s Top solid infill: 50mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s		Software default parameters	Retraction Length:3mm Lift Z:0mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:50%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
安克Maker	M5	Nozzle :240°C Plate: 90°C (PE)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 120mm/s Infill Speed: 50mm/s Outer Wall: 50mm/s Inner Wall: 100mm/s First Layer: 50mm/s Skirt Speed: 50mm/s		Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
拓竹 Bambu Lab	PIP	Nozzle :250°C Plate: 100°C (PE, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 200mm/s Sparse infill: 200mm/s Internal solid infill: 200mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 200mm/s Travel speed: 200mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: On Min Fan Speed: 10% Max Fan Speed: 30%	22ml/s	/	Default or adjust as required	1. It needs to be sealed for printing. 2. The printing speed of the same model should not differ too much, as the speed difference is too large and the printing glossiness is different.
	11	Nozzle :250°C Plate: 100°C (engineering slab, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: On Min Fan Speed: 10% Max Fan Speed: 30%	22ml/s	/	Default or adjust as required	1. It needs to be sealed for printing. 2. The printing speed of the same model should not differ too much, as the speed difference is too large and the printing glossiness is different.
创想 Creality	Ender-3	Nozzle :240°C Plate: 100°C (glueing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed : 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Sparse infill: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	(FF)		Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
ABS	复志 RuiZhi	Extruder Temperature:250°C Heated Bed Temperature: 100°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed : 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	(FF)	Software default parameter	Filament Flowrate: 95%	Fan: OFF	/	Default or adjust as required	Need to seal box printing	
Prusa	MKS+	Nozzle:240°C Bed: 80°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 25mm/s Bridges: 25mm/s Gap fill: 40mm/s		Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing
Voron	R2	Nozzle:240°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 80mm/s Small perimeters: 60mm/s External perimeters: 80mm/s Infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s		Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing

	安克Anker	WS	Nozzle: 250°C Plate: 100°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Infill Speed: 200mm/s Outer Wall: 80mm/s Inner Wall: 80mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
研竹 Baohu Lab	PIP		Nozzle: 250°C Plate: 100°C (PEI, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 150mm/s Inner wall: 200mm/s Sparse infill: 200mm/s Internal solid infill: 200mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 200mm/s Travel speed: 200mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: OFF	23ml/s	Default or adjust as required	1. It needs to be sealed for printing. 2. The printing speed of the same model should not differ too much, as the speed difference is too large and the printing glossiness is different.
	11		Nozzle: 250°C Plate: 100°C (engineering slab, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 200mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.98	Fan: OFF	23ml/s	Default or adjust as required	1. It needs to be sealed for printing. 2. The printing speed of the same model should not differ too much, as the speed difference is too large and the printing glossiness is different.
	创想 Creality	Ender-3	Nozzle: 240°C Plate: 100°C (glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 20mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	OFF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
ABS+	复志 Revo3D	Pro3 Plus	Extruder Temperature: 250°C Heated Bed Temperature: 100°C	Layer Height: 0.1-0.2mm(0.4mm) Extrusion Width: 0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Skirt Speed: 30mm/s	OFF	Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Prusa	MKS+	Nozzle: 250°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm(0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Yonoo	B2	Nozzle: 250°C Bed: 100°C (glueing)	Layer Height: 0.1-0.2mm(0.4mm)	Perimeters: 80mm/s Small perimeters: 60mm/s External perimeters: 150mm/s Infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 0%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	安克Anker	WS	Nozzle: 255°C Plate: 100°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 200mm/s Infill Speed: 200mm/s Outer Wall: 80mm/s Inner Wall: 80mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
研竹 Baohu Lab	PIP		Nozzle: 220°C Plate: 45°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 80mm/s Inner wall: 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5m Retraction speed: 30mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	5ml/s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	11		Nozzle: 220°C Plate: 30°C (Low temperature floor, glueing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 80mm/s Inner wall: 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5m Retraction speed: 30mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	5ml/s	Default or adjust as required	The pullback length inside the material setting needs to be closed.

	创想 Creality	Ender-3	Nozzle :220°C Plate : 45°C	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 40mm/s Infill Speed: 40mm/s Wall Speed: 15mm/s Outer Wall Speed: 15mm/s Inner Wall Speed: 15mm/s Top Speed: 20mm/s Travel Speed: 100mm/s Initial Layer Speed: 15mm/s Skirt Speed: 15mm/s Number of Slower Layers: 2	0FF	Retract at Layer Change: ON Retraction Distance: 2mm Retraction Speed: 30mm/s Retraction Prime Speed: 30mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
eTPU-66A	复志 Raisorb	Pro3 Plus	Extruder Temperature:220°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	0FF	Software default parameter	Filament Flowrate: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MKS+	Nozzle:220°C Bed: 60°C (glassing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:1mm Lift Z:0.2mm Retraction Speed: 25mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voron	B2	Nozzle:220°C Bed: 45°C (glassing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 40mm/s External perimeters: 40mm/s Infill: 80mm/s Solid infill: 60mm/s Top solid infill: 60mm/s Support material: 80mm/s Bridges: 20mm/s Gap fill: 20mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1.05	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	安克Anker	M5	Nozzle: 225°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm (0.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 100mm/s Infill Speed: 100mm/s Outer Wall: 50mm/s Inner Wall: 50mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	创想 Bambu Lab	PIP	Nozzle :220°C Plate : 45°C (PEI)	Layer height: 0.1-0.2mm (0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 80mm/s Inner wall: 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5m Retraction speed: 30mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	5m/s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	创想 Bambu Lab	X1	Nozzle :220°C Plate: 30°C (Low temperature floor, glassing)	Layer height: 0.1-0.2mm (0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 80mm/s Inner wall: 150mm/s Sparse infill: 150mm/s Internal solid infill: 150mm/s Top surface: 150mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Length: 1.5m Retraction speed: 30mm/s	Flow ratio: 1.05	Fan: ON Software default parameter	5m/s	Default or adjust as required	The pullback length inside the material setting needs to be closed.
	创想 Creality	Ender-3	Nozzle :220°C Plate : 60°C	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameter) Starting layer line width: 120%	Print Speed: 40mm/s Infill Speed: 40mm/s Wall Speed: 15mm/s Outer Wall Speed: 15mm/s Inner Wall Speed: 15mm/s Top Speed: 20mm/s Travel Speed: 100mm/s Initial Layer Speed: 15mm/s Skirt Speed: 15mm/s Number of Slower Layers: 2	0FF	Retract at Layer Change: ON Retraction Distance: 2mm Retraction Speed: 30mm/s Retraction Prime Speed: 30mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
eTPU-66	复志 Raisorb	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s X/Y Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	0FF	Software default parameter	Filament Flowrate: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MKS+	Nozzle:220°C Bed: 60°C (glassing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:1mm Lift Z:0.2mm Retraction Speed: 25mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/

	Vorus	R2	Nozzle: 220°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 50mm/s Small perimeters: 40mm/s External perimeters: 40mm/s Infill: 80mm/s Solid infill: 60mm/s Top solid infill: 60mm/s Support material: 80mm/s Bridges: 20mm/s Gap fill: 20mm/s	Software default parameters	Retraction Length: 1mm Lift Z: 0.2mm Retraction Speed: 25mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 0%	Extrusion multiplier: 1.05	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	安克Anker	WS	Nozzle: 225°C Plate: 60°C (PE)	Layer height: 0.1-0.2mm(Ø.4mm) Line width: default parameters	Travel Speed: 250mm/s Printing Speed: 100mm/s Infill Speed: 100mm/s Outer Wall: 50mm/s Inner Wall: 50mm/s First Layer: 50mm/s Skirt Speed: 50mm/s	Software default parameters	Software default parameters	Flow: 100%	Fan: ON Fan speed: 100%	/	Default or adjust as required	/
	拓竹 Bambu Lab	X1	Nozzle: 280°C Plate: 100°C (Engineering slab, gluing)	Layer height: 0.1-0.2mm (Ø.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.96	Fan: OFF	100%/s	Default or adjust as required	Need to seal box printing
ePA-CP	复志 Raison3D	Pro3 Plus	Extruder Temperature: 280°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (Ø.4mm) Extrusion Width: 0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 30mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s V/V Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	0.9F	Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinker head, need to replace the hardening nozzle.
	Prusa	MKS+	Nozzle: 225°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 40mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 50%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinker head, need to replace the hardening nozzle.
	Vorus	R2	Nozzle: 280°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 60mm/s Small perimeters: 50mm/s External perimeters: 50mm/s Infill: 80mm/s Solid infill: 50mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 50%	Extrusion multiplier: 0.98	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinker head, need to replace the hardening nozzle.
ePA12-CP	拓竹 Bambu Lab	X1	Nozzle: 280°C Plate: 100°C (Engineering slab, gluing)	Layer height: 0.1-0.2mm (Ø.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 270mm/s Sparse infill: 250mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 0.96	Fan: OFF	100%/s	Default or adjust as required	Need to seal box printing
	复志 Raison3D	Pro3 Plus	Extruder Temperature: 280°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (Ø.4mm) Extrusion Width: 0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 30mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s V/V Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	0.9F	Software default parameter	Filament Flowrate: 100%	Fan: OFF	/	Default or adjust as required	Need to seal box printing
	Prusa	MKS+	Nozzle: 225°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 80mm/s Solid infill: 40mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 50%	Extrusion multiplier: 1	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinker head, need to replace the hardening nozzle.
	Vorus	R2	Nozzle: 280°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 60mm/s Small perimeters: 50mm/s External perimeters: 50mm/s Infill: 80mm/s Solid infill: 50mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length: 2mm Lift Z: 0.2mm Retraction Speed: 40mm/s Retract on layer change: ON Wipe while retracting: ON Retract amount before wipe: 50%	Extrusion multiplier: 0.98	Fan: OFF	/	Default or adjust as required	1. Thermostatic sealing printing is required. 2. Easy to wear sprinker head, need to replace the hardening nozzle.

vFLA-Metal	拓竹 Bambu Lab	PIP	Nozzle: 220°C Plate: 60°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 200mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 250mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 1.0	Fan: ON Software default parameter	22mm/s	Default or adjust as required	/
		X1	Nozzle: 220°C Plate: 35°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 250mm/s Inner wall: 300mm/s Sparse infill: 300mm/s Internal solid infill: 250mm/s Top surface: 200mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Software default parameter	Flow ratio: 1.0	Fan: ON Software default parameter	22mm/s	Default or adjust as required	/
	创想 Creality	Ender-3	Nozzle: 215°C Plate: 60°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 50mm/s Infill Speed: 50mm/s Wall Speed: 30mm/s Outer Wall Speed: 25mm/s Inner Wall Speed: 30mm/s Top Speed: 25mm/s Travel Speed: 100mm/s Initial Layer Speed: 20mm/s Skirt Speed: 20mm/s Number of Slower Layers: 2	0FF	Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s	Flow: 100%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	复志 Raison3D	Pro3 Plus	Extruder Temperature:225°C Heated Bed Temperature: 60°C	Layer Height: 0.1-0.2mm (0.4mm) Extrusion Width:0.4mm	Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer Speed: 20mm/s Infill Speed: 60mm/s Solid Fill Speed: 60mm/s I/V Axis Movement Speed: 100mm/s Z Axis Movement Speed: 15mm/s Support Speed: 60mm/s Thin Wall Speed: 40mm/s Gap Filling Speed: 40mm/s Bridging Speed: 30mm/s Overhang Shell Speed: 30mm/s	Software default parameters	Software default parameter	Filament Flowrate: 95%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Prusa	MKS+	Nozzle: 215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
	Voroo	B2	Nozzle: 215°C Bed: 60°C (gluing)	Layer Height: 0.1-0.2mm (0.4mm)	Perimeters: 150mm/s Small perimeters: 80mm/s External perimeters: 80mm/s infill: 150mm/s Solid infill: 150mm/s Top solid infill: 80mm/s Support material: 150mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction Length:2mm Lift Z:0.2mm Retraction Speed: 40mm/s Retract on layer change:ON Wipe while retracting: ON Retract amount before wipe:0%	Extrusion multiplier: 1	Fan: ON Fan speed:100%	/	Default or adjust as required	/
拓竹 Bambu Lab	P1P	Nozzle: 250°C Plate: 45°C (PEI)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 100mm/s Inner wall: 100mm/s Sparse infill: 100mm/s Internal solid infill: 100mm/s Top surface: 100mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Retraction:OFF	Flow ratio: 0.5	Fan: ON Software default parameter	22mm/s	Default or adjust as required	/	
		X1	Nozzle: 240°C Plate: 50°C (Low temperature floor, gluing)	Layer height: 0.1-0.2mm(0.4mm) Line width: default parameters	First layer: 50mm/s First Layer infill: 50mm/s Outer wall: 100mm/s Inner wall: 100mm/s Sparse infill: 100mm/s Internal solid infill: 100mm/s Top surface: 100mm/s Slow down for overhangs: ON Overhang speed: default Bridge: 50mm/s Gap infill: 250mm/s Travel speed: 300mm/s	First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000	Retraction:OFF	Flow ratio: 0.5	Fan: ON Software default parameter	22mm/s	Default or adjust as required	/
	创想 Creality	Ender-3	Nozzle: 240°C Plate: 50°C (gluing)	Layer height: 0.1-0.2mm (0.4mm) Line width: 0.42mm (software default parameters) Starting layer line width: 120%	Print Speed: 40mm/s Infill Speed: 40mm/s Wall Speed: 40mm/s Outer Wall Speed: 40mm/s Inner Wall Speed: 40mm/s Top Speed: 40mm/s Travel Speed: 40mm/s Initial Layer Speed: 40mm/s Skirt Speed: 40mm/s Number of Slower Layers: 2	0FF	Retraction:OFF	Flow: 50%	Fan: ON Fan speed:100%	/	Default or adjust as required	/

星卓 Bambu	Prüf Plus	Extruder Temperature:240°C Heated Bed Temperature: 50°C	Layer Height: 0.1-0.2mm (Ø.4mm) Extrusion Width:0.4mm	Default Printing Speed: 40mm/s Inner Shell Speed: 40mm/s Outer Shell Speed: 40mm/s First Layer Speed: 40mm/s Infill Speed: 40mm/s Solid Fill Speed: 40mm/s XY Axis Movement Speed: 40mm/s Z Axis Movement Speed: 15mm/s Support Speed: 40mm/s	Software default parameters	Retraction:OFF	Filament Flowrate: 55%	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Prusa	MKS+	Nozzle:240°C Bed: 65°C (glassing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 40mm/s Small perimeters: 40mm/s External perimeters: 40mm/s Infill: 40mm/s Solid infill: 40mm/s Top solid infill: 40mm/s Support material: 40mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction:OFF	Extrusion multiplier: 0.55	Fan: ON Fan speed:100%	/	Default or adjust as required	/
Yoroa	B2	Nozzle:240°C Bed: 65°C (glassing)	Layer Height: 0.1-0.2mm (Ø.4mm)	Perimeters: 40mm/s Small perimeters: 40mm/s External perimeters: 40mm/s Infill: 40mm/s Solid infill: 40mm/s Top solid infill: 40mm/s Support material: 40mm/s Bridges: 40mm/s Gap fill: 40mm/s	Software default parameters	Retraction:OFF	Extrusion multiplier: 0.55	Fan: ON Fan speed:100%	/	Default or adjust as required	/

***The above data is sourced from the eSUN tech center testing, with testing environment temperatures ranging from 18 to 28°C; The printing parameters may also vary under different environmental temperatures. Please note that when there is a significant difference in printing speed, the model's surface will present different glossiness. Please set the printing speed of the model surface to be consistent. When printing TPU on the Bambu Lab printer, the Retraction Length in the material settings must be turned off.**