



General print profile

LW-PLA

Setting	LW_PLA
▼ Layer	
Layer Height	0.1600 mm
Maximum Shells Overlap Percentage	100 %
Print Shells in Optimal Order	Enabled
First Layer Flowrate	150.0 %
First Layer Extrusion Width Percen...	103 %
Layer Start Point Type	Nearest
Fixed Layer Start Point X	N/A
Fixed Layer Start Point Y	N/A
Place Seam on	None
Print External Shells First	Enabled
Enable Small Features Detection	Enabled
Small Features Diameter	10.00 mm
Small Features Hole Diameter	7.00 mm
Small Features Speed Multiplier	50 %
Enable Small Features Infill Density	Enabled
Small Features Infill Density	100 %

Setting	LW_PLA
▼ Infill	
Infill Density	100 %
Infill Overlap	20 %
Infill Flowrate	56.0 %
Infill Pattern Type	Cubic
Infill Outline Shells	1
Infill Angle List	0

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▼ Solid Fill	
Bottom Solid Fill Layers	0
Top Solid Fill Layers	0

▼ Platform Additions	
Skirt/Brim Speed	15.0 mm/s
Skirt Loop Lines	3
Skirt Offset Distance	1.10 mm

▼ Cooling	
Enable Cooling Fans	Disabled
Slow Down Printing Speed	Disabled

▼ Temperature	
Heated Bed Temperature	60 °C
Left Extruder Temperature	215 °C

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Speed	
Outer Shell Speed	50.0 mm/s
Infill Speed	25.0 mm/s
Bottom Solid Fill Speed	25.0 mm/s
Top Solid Fill Speed	25.0 mm/s
Top Surface Solid Fill Speed	25.0 mm/s
Bottom Surface Solid Fill Speed	25.0 mm/s
X/Y Axis Movement Speed	100.0 mm/s
Z Axis Movement Speed	100.0 mm/s
Gap Filling Speed	60.0 mm/s
Slow Down First Few Layers	2
Advanced	
Enable Jerk Control	Enabled
Printing Jerk	5.00 mm/s
Inner Shell Jerk	5.00 mm/s
Outer Shell Jerk	5.00 mm/s
Infill Jerk	5.00 mm/s
Bottom Solid Fill Jerk	5.00 mm/s
Top Solid Fill Jerk	5.00 mm/s
Top Surface Solid Fill Jerk	5.00 mm/s
Bottom Surface Solid Fill Jerk	5.00 mm/s
Travel Jerk	1.00 mm/s
Left Filament Flowrate (Override Fil...	68.0 %

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▾ Ooze	
Force Retraction On Layer Change	Disabled
Avoid Traveling Through Holes	Enabled
Enable Maximum Travel Path Length	Disabled
Force Retraction if Travel Length E...	0.00 mm
Enable Wipe Wall	Disabled
Wipe Wall Mode	N/A
Wipe Wall Offset	N/A
Wipe Wall Angle	N/A
Wipe Wall Loop Lines	N/A
Wipe Wall Type	N/A
Wipe Wall Speed	N/A
▾ Other	
Minimal Extrusion Width Percentage	25 %
Enable Bridging Fan Speed	N/A

Group and Layer Settings

> Advanced	
▾ Ooze	
Avoid Traveling Through Holes	Enabled
▾ Other	
Fill Gaps in Shells	Enabled

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