

eSUN Fast filaments 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 | matters need attention |
|--------------------|------------------|---|---|--|---|---|---|---|---------------------------------------|-------------------------------|-------------------------------|--|
| PETG Reelto Lab | | P1P | Nozzle: 220°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22mm³/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, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22mm³/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 Nozzle) 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/Brim 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% Prinme 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 MAX | Printing Temperature: 220°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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/Brim 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% Prinme 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 Nozzle) 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 Thin Wall Speed: 150mm/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 Retract Speed: 40mm/s Retraction Prime Speed: 40mm/s | Flow: 100% | Fan: ON speed:100% | / | Default or adjust as required | / |
| 尼龙 Nylon30 | Prusa Plus3 | Extruder Temperature: 225°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 XY 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 Shell Speed: 50mm/s | Software default parameters | Software default parameter | Filament Flowrate: 95% | Fan: ON Fan speed: 100% | / | Default or adjust as required | / | |
| Prusa | MIN+ | Nozzle: 215°C Bed: 60°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 speed:100% | Fan | / | Default or adjust as required | / |
| PETG Reelto Lab | | P1P | Nozzle: 220°C Plate: 65°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22mm³ /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, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22mm³ /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. |

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| 4PLA-B5 | 创想 Creality | K1 | Printing Temperature:220°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 Retraction 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% Prinme 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 Nozzle) 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 Retraction 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% Prinme 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 (glueing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: 0.2mm (software 4/fault 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: 0.8mm Retraction Retract Speed: 40mm/s Retraction Prime Speed: 40mm/s | Flow: 100% | Fan: ON Fan speed:100% | Fan | / | Default or adjust as required |
| | 复志 Ruitaich | Pro3 Plus | Extruder Temperature:225°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 Shell 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 (glueing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | / |
| | Voroo | R2 | Nozzle:215°C Bed: 60°C (glueing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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:50% | Extrusion multiplier: 1 | Fan: ON Fan speed:100% | / | Default or adjust as required | / |
| 安克Anker | WS | Nozzle: 215°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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% | Fan | / | Default or adjust as required | / |
| 新竹 Banan Lab | PIP | Nozzle: 220°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22m 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, glueing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22m 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. | |
| 创想 Creality | K1 | Printing Temperature:220°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 Retraction 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% Prinme 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 Nozzle) 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 Retraction 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% Prinme Tower Flow: 100% Initial Layer Flow: 100% | Fan: ON Software default parameter | / | Default or adjust as required | Do not seal the box when printing | |

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| vPLA-Lite | Ender-3 | Nozzle :215°C Plate: 60°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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% | Fan | / | Default or adjust as required | / |
| | 复志 Raisoo3D | Extruder Temperature:225°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 | / |
| | Prusa | MKS+ | Nozzle:215°C Bed: 60°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 60mm/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 | E2 | Nozzle:215°C Bed: 60°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | WS | Nozzle :215°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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% | Fan | / | Default or adjust as required | / |
| vPLA-White | F1P | Nozzle :230°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | First layer: First Layer infill: 50mm/s Outer wall: 150mm/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 | 22ml / s | / | Default or adjust as required | / |
| | T1 | Nozzle :230°C Plate: 35°C (Low temperature floor, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | First layer: First Layer infill: 50mm/s Outer wall: 150mm/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 | 22ml / s | / | Default or adjust as required | / |
| vPLA-White | K1 | Printing Temperature:220°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | Infill Speed: 300mm/s Outer Wall Speed: 100mm/s Inner Wall Speed: 200mm/s Top/Bottom Speed: 200mm/s Travel Speed: 500mm/s Initial Layer Speed: 50mm/s Skirt/Brim 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 | |
| | K1 MAX | Printing Temperature:220°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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/Brim 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 Nozzle) 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: 60mm/s Retraction Prime Speed: 60mm/s | Flow: 100% | Fan: ON Fan speed:100% | Fan | / | Default or adjust as required | / |
| 复志 Raisoo3D | Extruder Temperature:225°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) Extrusion Width:0.4mm | Default Printing Speed: 60mm/s Inner Shell Speed: 30mm/s Outer Shell Speed: 20mm/s First Layer 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 | Software default parameter | Filament Flowrate: 95% | Fan: ON Fan speed:100% | / | / | Default or adjust as required | / |

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| Prusa | MKS+ | Nozzle: 230°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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: 230°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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% | Fan | / | Default or adjust as required | / |
| 创想 Bambu Lab | PIP | Nozzle: 205°C Plate: 60°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22w/ s | / | Default or adjust as required | / |
| | X1 | Nozzle: 205°C Plate: 35°C (Low temperature floor, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | 22w/ s | / | Default or adjust as required | Open the cabin door for printing. |
| 创想 Creality | K1 | Printing Temperature: 205°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 | |
| | K1 MAX | Printing Temperature: 205°C Build Printing Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 | |
| | Ender-3 | Nozzle: 200°C Plate: 60°C (gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | (0F) | Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s | Flow: 100% | Fan: ON Fan speed: 100% | Fan | / | Default or adjust as required | / |
| 创想 Raisor | Pro3 Plus | Extruder Temperature: 200°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 | (0F) | Software default parameter | Filament Flowrate: 95% | Fan: ON Fan speed: 100% | / | Default or adjust as required | / | |
| Prusa | MKS+ | Nozzle: 230°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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: 230°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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: 0% | Extrusion multiplier: 1 | Fan: ON Fan speed: 100% | / | Default or adjust as required | / | |

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| | 安克Anker | WS | Nozzle: 210°C Plate: 60°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 speed:100% | Fan | / | Default or adjust as required | / |
| 邦竹 Bozhe Lab | PIP | | Nozzle: 260°C Rate: 80°C (PEI, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 overhang: 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 | | 11waf /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 Rate: 80°C (engineering slab, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 overhang: 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 | | 11waf /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. |
| 创想 Creality | K1 | | Printing Temperature: 245°C Build Printing Temperature: 80°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 | 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 Nozzle) 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 | 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 Rate: 90°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | | | Retract at Layer Change: ON Retraction Distance: 6mm Retraction Retract Speed: 40mm/s | Flow: 100% | Fan: ON speed:100% | Fan | / | Default or adjust as required |
| 安克 Anker3D | Pro3 Plus | | Extruder Temperature: 240°C Heated Bed Temperature: 70°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 | | Software default parameter | Filament Flowrate: 95% | Fan: ON Fan speed:100% | / | Default or adjust as required | / | |
| Prusa | MINI+ | | Nozzle: 240°C Rate: 90°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s infill: 60mm/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: 20mm 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 Rate: 90°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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: 20mm 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Anker | WS | | Nozzle: 240°C Plate: 90°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 speed:100% | Fan | / | Default or adjust as required | / |
| 邦竹 | PIP | | Nozzle: 250°C Rate: 100°C (PEI, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 overhang: 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% | | 12waf /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. |

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| Baoku Lab | | | X1 | Nozzle: 250°C Plate: 100°C (engineering slab, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | <p>First layer: 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</p> | <p>First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000</p> | Software default parameter | Flow ratio: 0.98 | Fan: On Min Fan Speed: 10% Max Fan Speed: 30% | 22w / 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 (gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: 0.42mm (software default parameter) Starting layer line width: 120% | <p>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</p> | 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 | 创想 Raise3D | Pro3 Plus | | Extruder Temperature: 250°C Heated Bed Temperature: 100°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) Extrusion Width: 0.4mm | <p>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</p> | OFF | Software default parameter | Filament Flowrate: 95% | Fan: OFF | / | Default or adjust as required | Need to seal box printing |
| Prusa | | MEGA+ | | Nozzle: 230°C Bed: 60°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | <p>Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 20mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap Fill: 40mm/s</p> | 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 |
| Voroo | | R2 | | Nozzle: 230°C Bed: 100°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | <p>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</p> | 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 |
| 安凡Anker | | WS | | Nozzle: 250°C Plate: 100°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | <p>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</p> | Software default parameters | Software default parameters | Flow: 100% | Fan: OFF | / | Default or adjust as required | Need to seal box printing |
| 创想 Creality | | Ender-3 | | Nozzle: 250°C Plate: 100°C (PEI, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | <p>First layer: 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</p> | <p>First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000</p> | Software default parameter | Flow ratio: 0.98 | Fan: OFF | 22w / 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: 250°C Plate: 100°C (engineering slab, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | <p>First layer: 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</p> | <p>First layer: 500 Outer wall: 5000 Top surface: 2000 Normal printing: 10000</p> | Software default parameter | Flow ratio: 0.98 | Fan: OFF | 22w / 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 (gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: 0.42mm (software default parameter) Starting layer line width: 120% | <p>Print 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</p> | 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+ | 创想 Raise3D | Pro3 Plus | | Extruder Temperature: 250°C Heated Bed Temperature: 100°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) Extrusion Width: 0.4mm | <p>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</p> | OFF | Software default parameter | Filament Flowrate: 100% | Fan: OFF | / | Default or adjust as required | Need to seal box printing |
| Prusa | | MEGA+ | | Nozzle: 230°C Bed: 100°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | <p>Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 20mm/s Infill: 80mm/s Solid infill: 80mm/s Top solid infill: 40mm/s Support material: 50mm/s Bridges: 25mm/s Gap Fill: 40mm/s</p> | 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 |

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| | Voroo | R2 | Nozzle: 255°C Bed: 100°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | M5 | Nozzle: 255°C Plate: 100°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 |
| EBC Baohe Lab | EBC Baohe Lab | FIP | Nozzle: 220°C Plate: 45°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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. |
| | | X1 | Nozzle: 220°C Plate: 30°C (Low temperature floor, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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: 45°C | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: 0.42mm (software default parameters) 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 | OFF | Retract at Layer Change: ON Retraction Distance: 2mm Retraction Speed: 30mm/s Retraction Prime Speed: 30mm/s | Flow: 100% | Fan: ON Speed: 100% | Fan | Default or adjust as required | / |
| 4TPU-65A | 复志 Raise3D | Pro3 Plus | Extruder Temperature: 220°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 I/F Axis Movement Speed: 100/100mm/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 | OFF | Software default parameter | Filament Flowrate: 100% | Fan: ON Fan speed: 100% | / | Default or adjust as required | / |
| | Prusa | MKS+ | Nozzle: 220°C Bed: 60°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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: 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 | / |
| | Voroo | R2 | Nozzle: 220°C Bed: 45°C (gluing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 Nozzle) 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 | / |
| EBC Baohe Lab | EBC Baohe Lab | FIP | Nozzle: 220°C Plate: 45°C (PEI) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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. |
| | | X1 | Nozzle: 220°C Plate: 30°C (Low temperature floor, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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. |

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| | 创想 Creality | Ender-3 | Nozzle: 220°C Plate: 60°C | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: 0.42mm (software default parameters) 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% | Fan | / | Default or adjust as required | / |
| eTPU-BS | 复志 Raise3D | Pro3 Plus | Extruder Temperature:255°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 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: 100% | Fan: ON Fan speed:100% | / | Default or adjust as required | / | |
| | Prusa | MKS+ | Nozzle:220°C Bed: 60°C (glueing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 60mm/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 | R2 | Nozzle:220°C Bed: 60°C (glueing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | M5 | Nozzle: 225°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | Travel Speed: 250mm/s Retract 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, glueing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | First layer: 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 | 10w/ s | Default or adjust as required | Need to seal box printing | |
| eTPU-CF | 复志 Raise3D | Pro3 Plus | Extruder Temperature:280°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 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: 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:220°C Bed: 60°C (glueing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | Perimeters: 50mm/s Small perimeters: 25mm/s External perimeters: 25mm/s Infill: 60mm/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: OFF | / | Default or adjust as required | 1. Thermostatic sealing printing is required. 2. Easy to wear sprinker head, need to replace the hardening nozzle. | |
| | Voron | R2 | Nozzle:280°C Bed: 60°C (glueing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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. | |
| | 拓竹 Bambu Lab | X1 | Nozzle: 280°C Plate: 100°C (engineering slab, glueing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) Line width: default parameters | First layer: 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 | 10w/ s | Default or adjust as required | Need to seal box printing | |
| | 复志 Raise3D | Pro3 Plus | Extruder Temperature:280°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 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: 100% | Fan: OFF | / | Default or adjust as required | Need to seal box printing | |

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| | Prusa | MKS+ | Nozzle:210°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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: OFF | / | Default or adjust as required | 1. Thermostatic sealing printing is required. 2. Easy to wear sprinkler head, need to replace the hardening nozzle. | |
| | Yorus | B2 | Nozzle:280°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 sprinkler head, need to replace the hardening nozzle. | |
| RIT Baohu Lab | FIP | | Nozzle :220°C Plate: 60°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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: 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 | / | |
| | 11 | | Nozzle :220°C Plate: 35°C (Low temperature floor, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 Nozzle) 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 | OFF | Retract at Layer Change: ON Retraction Distance: 6mm Retraction Speed: 40mm/s Retraction Prime Speed: 40mm/s | Flow: 100% | Fan: ON Fan speed:100% | Fan | / | Default or adjust as required | / |
| 复志 Raise3D | Pro3 Plus | | Extruder Temperature:255°C Heated Bed Temperature: 60°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 XYZ 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:210°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | / | |
| Yorus | B2 | | Nozzle:210°C Bed: 60°C (glassing) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 Nozzle) 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% | Fan | / | Default or adjust as required | / |
| RIT Baohu Lab | FIP | | Nozzle :250°C Plate: 45°C (PE) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 | / | |
| | 11 | | Nozzle :240°C Plate: 50°C (Low temperature floor, gluing) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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 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 | / | |

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| ePLA-18 | 创想 Creality | Ender-3 | Nozzle: 240°C Rate: 50°C (g/weight) | Layer height: 0.1-0.2mm (0.4mm Nozzle) 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: 55% | Fan: ON speed:100% | Fan | / | Default or adjust as required | / |
| | 复志 Raise3D | Pro3 Plus | Extruder Temperature:240°C Heated Bed Temperature: 50°C | Layer Height: 0.1-0.2mm (0.4mm Nozzle) 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 X/Y 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 (g/weight) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | / | |
| | Voroo | E2 | Nozzle:240°C Bed: 65°C (g/weight) | Layer Height: 0.1-0.2mm (0.4mm Nozzle) | 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 | / | |
| <p>*The above data is sourced from the eSIN 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.</p> | | | | | | | | | | | | | |