

General guidelines

- Always measure filament diameter!
- Use at least 3 solid infill layers when printing with Infill $\leq 30\%$ to get a closed surface finish.
- Printing thin wall parts can leave residue on the part when doing travel moves without retraction. It is recommended to deactivate "Only retract when crossing open spaces" in such cases.

Layerheight

General

$\leq 80\%$ nozzle diameter

Max values for nozzle diameters

Nozzle	80%
0,25	0,2
0,3	0,24
0,35	0,4375
0,4	0,32
0,5	0,4
0,6	0,48
0,8	0,64
1,0	0,8
1,2	0,96