Quality

Quality | Strength | Speed | Support | Others

Layer height

Layer height	0.08 mm
Initial layer height	0.2 mm
Mixed color sublayer	☐

Line width

Default	0.42 mm
Initial layer	0.5 mm
Outer wall	0.42 mm
Inner wall	0.45 mm
Top surface	0.42 mm
Sparse infill	0.45 mm
Internal solid infill	0.42 mm
Support	0.42 mm

Seam

Seam position	Aligned
Seam placement away from overhangs(experimental)	☐
Smart scarf seam application	☑
Scarf application angle threshold	155 °
Scarf around entire wall	☐
Scarf steps	10
Scarf joint for inner walls	☑
Override filament scarf seam setting	☐
Role-based wipe speed	☑

Precision

Slice gap closing radius	0.049 mm
Resolution	0.012 mm
Arc fitting	☑
X-Y hole compensation	0 mm
X-Y contour compensation	0 mm
Auto circle contour-hole compensation	☐
Elephant foot compensation	0.075 mm
Precise Z height	☐
Ironing Type	No ironing

Wall generator

Wall generator	Classic

Advanced

Order of walls	inner/outer
Print infill first	☐
Bridge flow	1
Thick bridges	☐
Bridge counterbore holes	None
Only one wall on top surfaces	Top surfaces
Only one wall on first layer	☐
Smooth speed discontinuity area	☑
Smooth coefficient	80
Avoid crossing wall	☐
Smoothing wall speed along Z(experimental)	☐

Strength

Walls

Wall loops	2
Alternate extra wall	☐
Embedding the wall into the infill	☐
Detect thin wall	☐

Top/bottom shells

Top surface pattern	Monotoni...
Top surface density	100 %
Top shell layers	9
Top shell thickness	0.8 mm
Top paint penetration layers	9
Bottom surface pattern	Monotonic
Bottom surface density	100 %
Bottom shell layers	7
Bottom shell thickness	0 mm
Bottom paint penetration layers	7
Internal solid infill pattern	Rectilinear

Sparse infill

Sparse infill density	4 %
Fill multiline	1
Sparse infill pattern	Gyroid
Length of sparse infill anchor	400% mm or %
Maximum length of sparse infill anchor	20 mm or %
Maximum length of sparse infill anchor	20 mm or %

Advanced

Infill/Wall overlap	15 %
Infill direction	45 °
Bridge direction	0 °
Minimum sparse infill threshold	15 mm²
Infill combination	☐
Detect narrow internal solid infill	☑
Ensure vertical shell thickness	Enabled
Detect floating vertical shells	☑

Support

Support

Enable support	☑
Type	tree(auto)
Style	Default
Threshold angle	15 °
On build plate only	☑
Support critical regions only	☐
Remove small overhangs	☑

Raft

Raft layers	0 layers

Filament for Supports

Support/raft base	Default
Support/raft interface	Default

Advanced

Initial layer density	90 %
Initial layer expansion	-1 mm
Support wall loops	-1
Top Z distance	0.08 mm
Bottom Z distance	0.08 mm
Base pattern	Default
Base pattern spacing	2.5 mm
Pattern angle	0 °
Top interface layers	2 layers
Interface pattern	Default
Top interface spacing	0.5 mm
Normal Support expansion	0 mm
Support/object xy distance	0.35 mm
Z overrides X/Y	☐
Support/object first layer gap	0.2 mm
Max bridge length	0 mm
Independent support layer height	☑

Tree Support

Branch distance	5 mm
Branch diameter	2 mm
Branch angle	45 °
Branch diameter angle	5 °

Others

Bed adhesion

Skirt loops	0
Skirt height	1 layers
Brim type	Auto
Brim width	5 mm
Brim-object gap	0.1 mm

Prime tower

Enable	☑
Skip points	☑
Internal ribs	☐
Width	35 mm
Max speed	90 mm/s
Brim width	3 mm
Infill gap	150 %
Rib wall	☑
Extra rib length	0 mm
Rib width	8 mm
Fillet wall	☑

Purge options

Purge into objects' infill	☐
Purge into objects' support	☑

Special mode

Slicing Mode	Regular
Print sequence	By layer
Spiral vase	☐
Timelapse	Traditional
Fuzzy Skin	None(allow...

Fuzzy Skin	None(allow...
Fuzzy skin generator mode	Displaceme...
Fuzzy skin noise type	Classic
Fuzzy skin point distance	0.8 mm
Fuzzy skin thickness	0.3 mm
Apply fuzzy skin to first layer	☐

Advanced

Use beam interlocking	☐
Interlocking depth of a segmented region	0 mm

G-code output

Reduce infill retraction	Auto