

Special settings for BODY:

Layer height	
● Layer height:	0.1 mm
● First layer height:	0.2 mm

Support material	
● Generate support material:	<input checked="" type="checkbox"/>
● Auto generated supports:	<input checked="" type="checkbox"/>
● Overhang threshold:	45 °
● Enforce support for the first:	0 layers
● First layer density:	90 %
● First layer expansion:	3 mm

Options for support material and raft	
● Style:	Organic
● Top contact Z distance:	0.2 (detachable) mm
● Bottom contact Z distance:	0.2 mm
● Pattern:	Rectilinear
● With sheath around the support:	<input type="checkbox"/>
● Pattern spacing:	2.5 mm
● Pattern angle:	0 °
● Closing radius:	2 mm
● Top interface layers:	2 (default) layers
● Bottom interface layers:	Same as top layers
● Interface pattern:	Rectilinear
● Interface pattern spacing:	0.5 mm
● Interface loops:	<input type="checkbox"/>
● Support on build plate only:	<input checked="" type="checkbox"/>
● XY separation between an object and its support:	0.35 mm or %
● Don't support bridges:	<input checked="" type="checkbox"/>
● Synchronize with object layers:	<input type="checkbox"/>

Organic supports	
● Maximum Branch Angle:	45 °
● Preferred Branch Angle:	25 °
● Branch Diameter:	2 mm
● Branch Diameter Angle:	5 °
● Branch Diameter with double walls:	3 mm
● Tip Diameter:	2 mm
● Branch Distance:	5
● Branch Density:	15 %

Advanced	
● Seam position:	Rear
● Seam gap distance:	15% mm or %
● Staggered inner seams:	<input type="checkbox"/>
● Scarf joint placement:	Nowhere
● Scarf joint only on smooth perimeters:	<input type="checkbox"/>
● Scarf start height:	0 %
● Scarf joint around entire perimeter:	<input type="checkbox"/>
● Scarf joint length:	20 mm
● Max scarf joint segment length:	1 mm
● Scarf joint on inner perimeters:	<input type="checkbox"/>
● External perimeters first:	<input type="checkbox"/>
● Fill gaps:	<input checked="" type="checkbox"/>
● Perimeter generator:	Arachne

Speed for print moves

- Perimeters: 50 mm/s
- Small perimeters: 25 mm/s or %
- External perimeters: 25 mm/s or %
- Infill: 60 mm/s
- Solid infill: 50 mm/s or %
- Top solid infill: 30 mm/s or %
- Support material: 40 mm/s
- Support material interface: 100% mm/s or %
- Bridges: 20 mm/s
- Gap fill: 10 mm/s
- Ironing: 20 mm/s

Slicing

- Slice gap closing radius: 0.049 mm
- Slicing Mode: Regular
- Slice resolution: 0 mm
- G-code resolution: 0.0125 mm
- Arc fitting: Disabled
- XY Size Compensation: 0 mm
- Elephant foot compensation: 0 mm

Arachne perimeter generator

- Perimeter transitioning threshold angle: 10 °
- Perimeter transitioning filter margin: 25% mm or %
- Perimeter transition length: 100% mm or %
- Perimeter distribution count: 1
- Minimum perimeter width: 100% mm or %
- Minimum feature size: 25% mm or %

speed and minimal perimetr width could be diferent for every printer. I specially have problem with thin walls so I set minimal perimetr width to 100%.

If you have any problems you can contact me and I will do my best to help you.

Also big thanks to Andrew Jr. for making this awesome model.

Enjoy

This remix is based on



LUCY (EDGERUNNER) - Download Free 3D model

by Adwerd Jr. (@Adwerd.Jr.)