

Print settings

E1.5.4

Please print all parts in PETG. In case of need it also works in PLA.

Thermally stressed parts may need to be replaced from time to time, If you use PLA.

The part ED04_feed zone is the most thermally stressed and should be printed in petg, better ind ABS or ASA.

The part EL13_sensor shutter must be printed in white and as solid as possible (without any air in the infill).

Part	Need	Quantity	Line width	Wall line count	Top/Bottom Layers	Infill	Support	Adhesion	Material in g	Material sum
EB08	needed	1	0,4	3	3	100	no	Skirt	7	7
EB09	optional	1	0,4	3	3	30	no	Skirt	1	1
EB10	optional	2	0,4	3	3	100	no	Skirt	21	42
ED01	needed	1	0,4	3	3	100	no	Skirt	8	8
ED02	needed	1	0,4	5	5	40	no	Skirt	31	31
ED03	needed	1	0,4	2	2	20	no	Skirt	27	27
ED04	needed	1	0,4	3	3	20	no	Skirt	8	8
ED05	needed	1	0,4	3	3	20	no	Brim 6mm	53	53
ED06	needed	1	0,4	3	3	20	no	Skirt	7	7
ED07	needed	1	0,4	3	3	20	no	Brim 6mm	21	21
ED08	needed	1	0,4	3	3	20	no	Brim 6mm	81	81
EL06	needed	1	0,4	3	3	20	yes	Skirt	85	85
EL10	needed	1	0,4	3	3	20	no	Skirt	8	8
EL11	needed	1	0,4	3	3	20	no	Skirt	6	6
EL12	needed	1	0,4	3	3	20	no	Skirt	2	2
EL13	needed	1	0,3	3	3	100	no	Brim 6m	1	1
EL14	needed	1	0,4	3	3	20	no	Skirt	23	23
EL21	needed	1	0,4	3	3	20	no	Skirt	42	42

									Total weight:	805
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