

# Print settings

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 settings are for printing with line width of 0.4mm.

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).

Number	Quantity	Name english	need	wall lines	top/bottom	infill	support	Adhesion
EB09	1	bending aid filter	needed	3	3	100	no	Skirt
EB10	1	sign template	needed	3	3	30	no	Skirt
EB11	2	clamp vice	needed	3	3	60	no	Skirt
Extruder Drive								
ED01	1	coupling bearing surface	needed	3	3	100	no	Skirt
ED02	1	coupling	needed	6	6	80	no	Skirt
ED03	1	bending template threaded rods	needed	2	2	30	no	Skirt
ED04	1	feed zone	needed	3	3	30	no	Skirt
ED05	1	hopper part1	needed	3	3	30	no	Brim 6mm
ED06	1	mounting tool	needed	3	3	30	no	Skirt
ED07	1	hopper part2	needed	3	3	30	no	Brim 6mm
ED08	1	hopper part3	needed	3	3	30	no	Brim 6mm
Spool drive								
SD01	1	Spool holder bracket	needed	6	6	80	no	Skirt
SD02	1	Spacer	needed	3	3	100	no	Brim 6mm
SD03	1	Spool holder disc	needed	6	6	80	only buildplate	Skirt
SD04	1	Spool holder disc lid 1	needed	6	6	100	no	Skirt
SD05	1	Motor mount	needed	6	6	80	no	Skirt
SD06	1	Motor mount lid	needed	6	6	30	no	Skirt
SD07	1	Belt tensioner	needed	6	6	30	no	Brim 6mm

SD08.1	1	Spool adapter 50mm (option)	option	3	3	30	no	Skirt
SD08.2	1	Spool adapter 51mm (option)	option	3	3	30	no	Skirt
SD08.3	1	Spool adapter 52mm(option)	option	3	3	30	no	Skirt
SD08.4	1	Spool adapter 53mm (option)	option	3	3	30	no	Skirt
SD08.5	1	Spool adapter 54mm (option)	option	3	3	30	no	Skirt
SD08.6	1	Spool adapter 55mm (option)	option	3	3	30	no	Skirt
SD08.7	1	Spool adapter 56mm (option)	option	3	3	30	no	Skirt
SD08.8	1	Spool adapter 57mm (option)	option	3	3	30	no	Skirt
SD08.9	1	Spool adapter 58mm (option)	option	3	3	30	no	Skirt
SD08.10	1	Spool adapter 59mm (option)	option	3	3	30	no	Skirt
SD08.11	1	Spool adapter 60mm (option)	option	3	3	30	no	Skirt
SD09	1	Spool holder disc lid 2	needed	6	6	100	no	Skirt

#### Filament Guide

FG01	1	hook left	needed	3	3	100	no	Brim 6mm
FG02	1	hook rechts	needed	3	3	100	no	Brim 6mm
FG03.1	1	swing for 0.7 bis 1.0kg spools	needed	3	3	100	no	Skirt
FG03.2	1	swing for 2.5kg spools (option)	option	3	3	100	no	Skirt
FG04	1	crossbrace 1	needed	3	3	100	no	Skirt
FG05	1	crossbrace 2	needed	3	3	100	no	Skirt
FG06	1	lifter	needed	3	3	30	no	Skirt
FG07	4	Rails	needed	3	3	100	no	Brim 6mm
FG08	1	sledge part1	needed	6	6	50	no	Skirt
FG09	1	sledge part2	needed	6	6	50	no	Skirt
FG10.1	1	Spiral axis for 1,75mm Part1	needed	3	3	30	all	Skirt
FG10.2	1	Spiral axis for 1,75mm Part2	needed	3	3	30	all	Skirt
FG10.3	1	Spiral axis for 2,85mm Part1	option	3	3	30	all	Skirt
FG10.4	1	Spiral axis for 2,85mm Part2	option	3	3	30	all	Skirt
FG11	1	axis holder right	needed	3	3	30	no	Skirt
FG12	1	snap part 1	needed	3	3	100	no	Brim 6mm
FG13	1	snap part 2	needed	3	3	100	no	Brim 6mm
FG14	1	plow	needed	3	3	100	all	Brim 6mm
FG15	1	axis holder left	needed	3	3	30	no	Skirt

FG16	2	stopper	needed	3	3	30	no	Skirt
Filament Puller								
FP01	1	motor mount Part 1	needed	3	3	30	no	Skirt
FP02	1	motor mount Part 2	needed	3	3	30	no	Skirt
FP03	1	motor mount Part 3	needed	3	3	30	no	Skirt
FP04	1	lever	needed	3	3	30	no	Skirt
FP05	1	disc	needed	3	3	100	no	Skirt
FP06	1	filament guide	needed	3	3	30	no	Skirt
Electronics								
EL06	1	arduino case	needed	3	3	30	all	Skirt
EL10	1	terminal block holder	needed	3	3	30	no	Skirt
EL11	1	driver mount	needed	3	3	30	no	Skirt
EL18	1	Arduino top	needed	3	3	30	no	Skirt
EL22	1	strain relief	needed	3	3	30	no	Skirt
EL23	1	LCD cover	needed	3	3	100	no	Skirt
EL25	2	holder ribbon cable	needed	3	3	30	no	Skirt
EL26	1	fan holder	needed	3	3	30	no	Skirt
Sensor optical								
SO01	1	sensor holder	needed	3	3	30	no	Skirt
SO02	1	sensor body	needed	3	3	30	no	Skirt
SO03	1	sensor arm	needed	3	3	100	no	Skirt
SO04	1	sensor shutter	needed	3	3	100	no	Brim 6mm
SO05	1	bending aid	needed	3	3	30	no	Skirt
Insulation								
IN01	1	cover body	needed	3	3	30	no	Skirt
IN03	1	cover top left	needed	3	3	30	no	Skirt
IN04	1	cover top right	needed	3	3	30	no	Skirt