

Generated by Spread the Signal



RULE NUMBER ONE 1

.**

KNOW HOW TO USE YOUR
PRINTER! PRINT ENOUGH TO UNDERSTAND THE BASICS BETWEEN A GOOD PRINT AND A BAD
PRINT!

THESE
STIPPLE PACKs COME WITH 5-6 RANDOM STIPPLES. MORE TO COME IN THE FUTURE.

FILES CAN BE FOUND AT:

<https://odysee.com/@NeutronNick> *****

& *****

<https://cults3d.com/en/users/NeutronNick/creations> *****

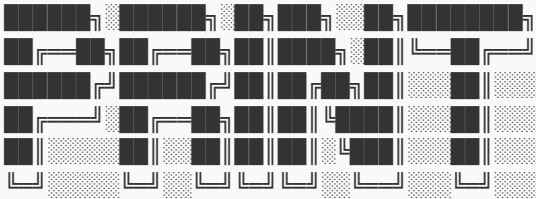


***** PRINT SETTINGS USING CURA *****

*****SOME OF THESE SETTINGS ARE IN THE
ADVANCED TAB IN CURA SO BE SURE TO HAVE THEM ALL VISIBLE BY CLICKING ALL UNDER
YOUR SETTINGS TAB*****

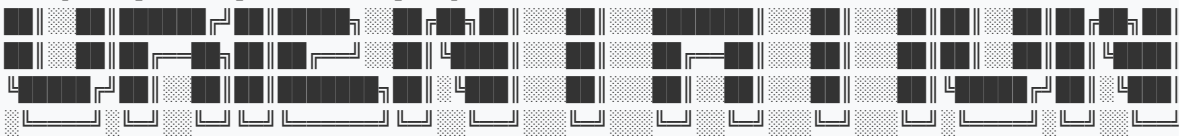
Material: PLA+ Or CARBON FIBER NYLON. These
Instructions However are for PLA+ ## I use Inland, Polymaker, ESun, 3d Fuels
Pro, And Crealitys All With Great Results!

Nozzle Size = .4mm



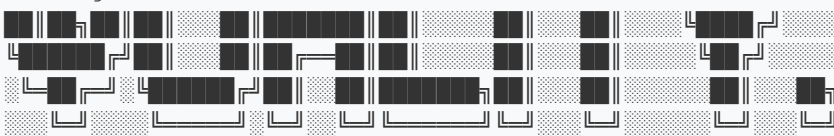
***** I PRINT THESE RAILS DOWN.** I Print in this orientation to obtain a cleaner
underside as well as save time and material on the print.

* This file Can Also be printed rails Up for a cleaner inside. The orientation
is up to you if your already experienced



LAYER HEIGHT: I
suggest using 0.16mm or 0.2mm. I prefer to use .16 for a cleaner underside and
.2 For Speed.

####Leave Other
Settings



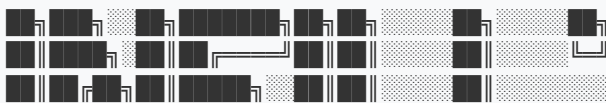


WALL LINE COUNT: You should use a wall line count between 5 and 15 or even more in some cases. I choose to use around 8. Preview your Walls After Slicing



Z SEAM: SHARPEST CORNER
####Leave Other

Settings



INFILL DENSITY: 100%

####Leave Other

Settings



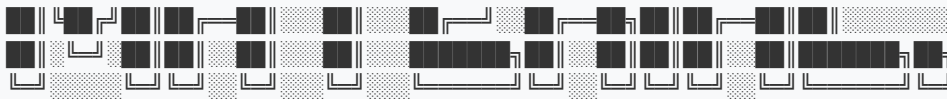
PRINTING TEMPERATURE: 215c



PLATE TEMPERATURE: 60c

BUILD

####Leave Other Settings

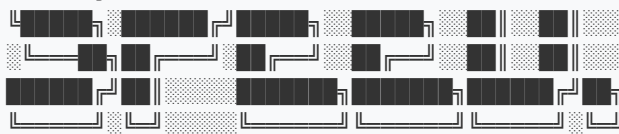


PRINT SPEED: When using the ender 3 print between 45 and 55mm. If you have a Core XY Setup feel free to bump it up to around 80mm



####Leave Other

Settings



ENABLE RETRACTION: (CHECK THE BOX)
RETRACTION DISTANCE: Between 6 and 6.5mm With no Direct Drive. CHAGE
ACCORDINGLY
####Leave Other Settings

COOLING: (CHECK THE BOX)
SPEED: 100%
Settings
ENABLE PRINT
FAN
####Leave Other

GENERATE SUPPORT: (CHECK THE BOX)
STRUCTURE: Tree
PLACEMENT: Touching Buildplate
SUPPORT PATTERN: ZigZag
SUPPORT DENSITY: 1.0%
X/Y DISTANCE: 1.3MM
SUPPORT
SUPPORT
SUPPORT
####Leave Other Settings



BUILD PLATE ADHESION: I use a Brim To help prevent any warping. A glue stick will also work. Feel free to choose between brim or Skirt.



###Leave Other Settings

