SETTINGS FOR CURA

The following are images of the Cura profiles developed for printing using Colorfabb LW-PLA and regular PLA. We found that depending on the version of Cura, the profiles may or may not work. So we have created this document to aid in users being able to print with any slicer.

The images indicate the critical settings required to achieve the same standard of print as the test model.

Regular PLA

Colorfabb LW-PLA

Column 1

Print settings ✕

Profile: COLORFABB LW-PLA - Fine - 0.2mm ★ ⌄

🔍 Search settings ☰

Quality ⌄
| Layer Height | 🔗 | 0.2 | mm |

Walls ⌄
Wall Thickness	ƒx	0.4	mm
Wall Line Count		1	
Horizontal Expansion		0.0	mm

Top/Bottom ⌄
Top/Bottom Thickness		0.0	mm
Top Thickness	ƒx	0.4	mm
Top Layers	ƒx	0	
Bottom Thickness		0.0	mm
Bottom Layers	ƒx	0	

Infill ⌄
| Infill Density | | 0.0 | % |

Material ⌄
Printing Temperature	↺ ƒx	250.0	°C
Build Plate Temperature	🔗	60	°C
Flow	↺	35.0	%

Speed ⌄
Print Speed	↺	40.0	mm/s
Wall Speed	↺ ƒx	40.0	mm/s
Inner Wall Speed	↺ ƒx	40.0	mm/s
Travel Speed	↺ ƒx	80.0	mm/s

Travel ⌄
Enable Retraction		✓	
Retract at Layer Change	↺	✓	
Retraction Distance	↺	6.0	mm

Column 2

Print settings ✕

Profile: COLORFABB LW-PLA - Fine - 0.2mm ★ ⌄

🔍 Search settings ☰

Speed ⌄
Print Speed	↺	40.0	mm/s
Wall Speed	↺ ƒx	40.0	mm/s
Inner Wall Speed	↺ ƒx	40.0	mm/s
Travel Speed	↺ ƒx	80.0	mm/s

Travel ⌄
Enable Retraction		✓	
Retract at Layer Change	↺	✓	
Retraction Distance	↺	6.0	mm
Retraction Speed	↺	100.0	mm/s
Retraction Extra Prime Amount	↺	0.35	mm³
Combing Mode	🔗	All	
Layer Start X	↺	100.0	mm
Layer Start Y		0.0	mm
Z Hop When Retracted		☐	

Cooling ⌄
| Enable Print Cooling | | ✓ | |
| Fan Speed | | 100.0 | % |

Support ⌄
| Generate Support | 🔗 | ☐ | |

Build Plate Adhesion ⌄
| Build Plate Adhesion Type | 🔗 | Brim | |

Special Modes ⌄
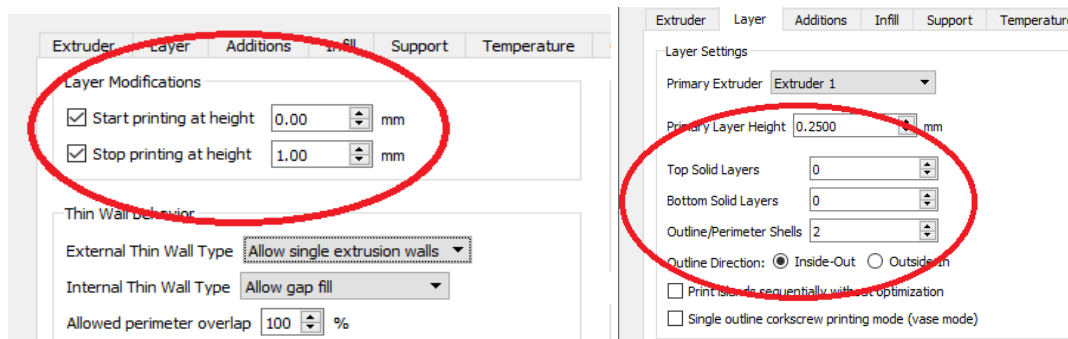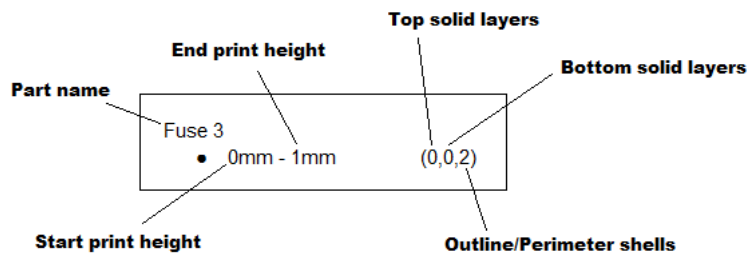| Print Sequence | 🔗 | All at Once | |
| Surface Mode | ↺ | Surface | |

Experimental ⌄
| Slicing Tolerance | | Middle | |

In the "Print settings" document provided, the settings change at certain Z-heights throughout parts of the model. Generally the settings that will change are the number of TOP or BOTTOM layers within the region, or the WALL LINE COUNT.

Please follow the link for instructions on how to adjust the settings based on Z-height:

https://www.youtube.com/watch?v=8e1QpC5oty8