

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

REGULAR PLA - Fine - 0.25mm 0% Off Off

Print settings

Profile: REGULAR PLA - Fine - 0.25mm

Search settings

- Quality**
 - Layer Height: 0.25 mm
- Walls**
 - Wall Thickness: 0.4 mm
 - Wall Line Count: 1
 - Print Thin Walls:
 - Horizontal Expansion: 0.0 mm
- Top/Bottom**
 - Top/Bottom Thickness: 0.0 mm
 - Top Thickness: 0.0 mm
 - Top Layers: 0
 - Bottom Thickness: 3.0 mm
 - Bottom Layers: 12
 - Extra Skin Wall Count: 1
- Infill**
 - Infill Density: 0.0 %
- Material**
 - Printing Temperature: 205.0 °C
 - Build Plate Temperature: 45.0 °C
 - Flow: 100.0 %
- Speed**

REGULAR PLA - Fine - 0.25mm 0% Off Off

Print settings

Profile: REGULAR PLA - Fine - 0.25mm

Search settings

- Retraction**
 - Enable Retraction:
 - Retract at Layer Change:
 - Retraction Distance: 8.0 mm
 - Retraction Speed: 100.0 mm/s
 - Retraction Extra Prime Amount: 0.1 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: Skirt
- Special Modes**
 - Print Sequence: All at Once
 - Surface Mode: Surface
- Experimental**
 - Slicing Tolerance: Exclusive

Colorfabb LW-PLA

COLORFABB LW-PLA - Fine - 0.2mm 0% Off On

Print settings

Profile: COLORFABB LW-PLA - Fine - 0.2mm

Search settings

- Quality**
 - Layer Height: 0.2 mm
- Walls**
 - Wall Thickness: 0.4 mm
 - Wall Line Count: 1
 - Print Thin Walls:
 - Horizontal Expansion: 0.0 mm
- Top/Bottom**
 - Top/Bottom Thickness: 0.0 mm
 - Top Thickness: 0.4 mm
 - Top Layers: 0
 - Bottom Thickness: 0.0 mm
 - Bottom Layers: 0
- Infill**
 - Infill Density: 0.0 %
- Material**
 - Printing Temperature: 250.0 °C
 - Build Plate Temperature: 60.0 °C
 - Flow: 40.0 %
- Speed**
- Travel**

COLORFABB LW-PLA - Fine - 0.2mm 0% Off On

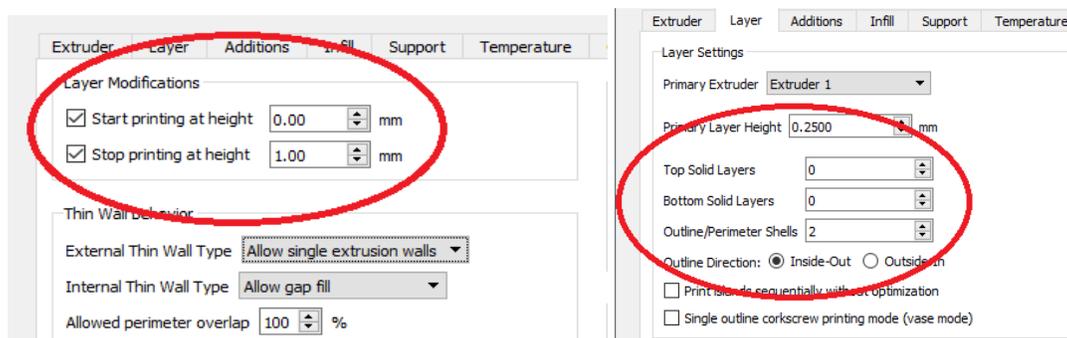
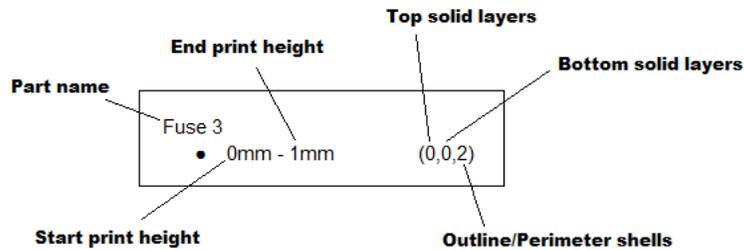
Print settings

Profile: COLORFABB LW-PLA - Fine - 0.2mm

Search settings

- Retraction**
 - Enable Retraction:
 - Retract at Layer Change:
 - Retraction Distance: 10.0 mm
 - Retraction Speed: 100.0 mm/s
 - Retraction Extra Prime Amount: 0.45 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: Exclusive

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>