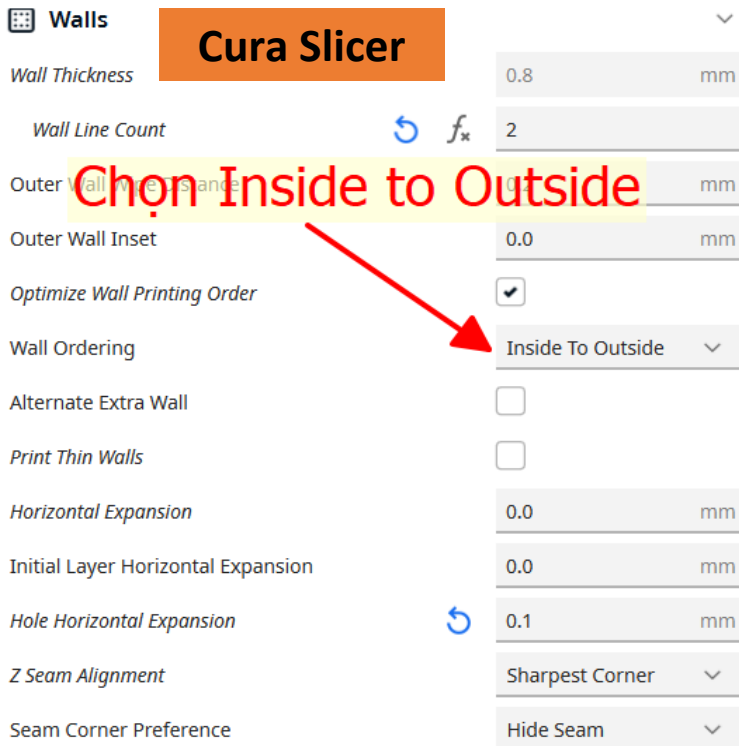
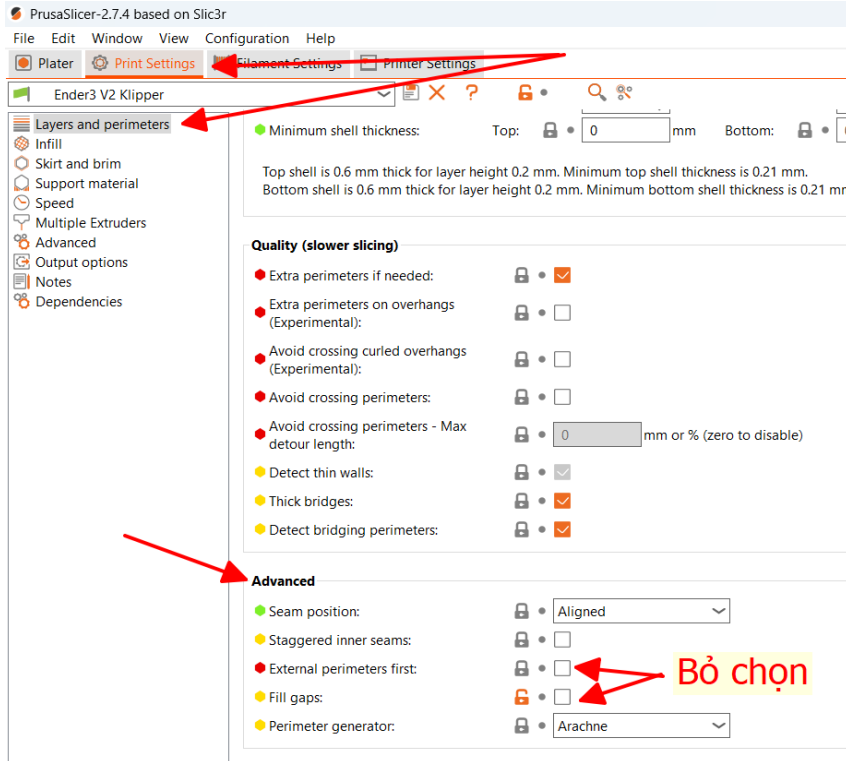


Tốc độ in mm/s	Nhiệt độ Nozzle độ C	Nhiệt độ bàn in độ C	Retraction Distance mm	Retraction Speed mm/s	Wall line count	Acceleration (tùy vào máy của bạn có thể đáp ứng)
60	235-240	70+	2.5	60	3	4000-8000
80	240-245	70+	2.5	60	3	4000-8000
120	245-250	70+	2.5	60	3	4000-8000
200	250-255	70+	2.5	60	3	4000-8000
300	260	70+	2.5	60	3	4000-8000



Printer

Sigma_X

Bed type Smooth PEI Plate / High Temp Plate

Orca Slicer

Filament

1 Sigmalab_PETG_60mms_0.6

Process Global Objects Advanced

* 60 0.6

Quality Strength Speed Support Others Notes

Minimum feature size	25	%
Minimum wall length	0.5	

Walls and surfaces

Walls printing order Inner/Outer/...

- Print infill first Inner/Outer
- Wall loop direction Outer/Inner
- Top surface flow ratio Inner/Outer/Inner
- Bottom surface flow ratio 1.05
- Only one wall on top surfaces
- Only one wall on first layer
- Avoid crossing walls
- Small area flow compensation (beta)

Bridging