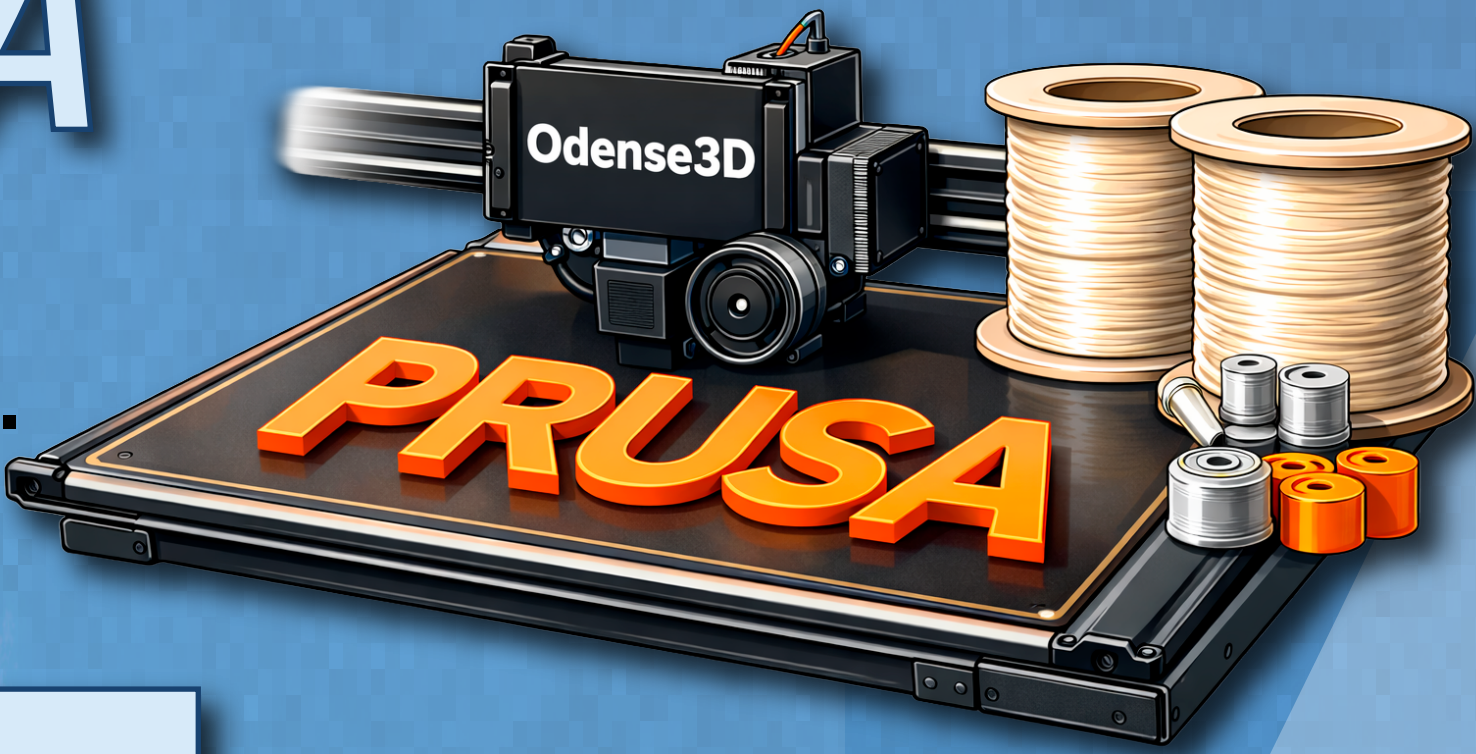


SUPPORT INSTILLINGER

PETG og PLA

Sådan leger man med support indstillinger for PETG og PLA med fokus på god underside + nem support fjernelse efter print.



PETG

PETG er et mere "sejt og klistret" materiale, som har tendens til at smelte sammen med supports.

Det betyder:

- Supports kan svejse fast til modellen
- Kræver højere Contact Z distance
- Færre interface layers er ofte bedre

Typiske problemer:

- Stringing mellem support og model
- Klæbrige kontaktpunkter
- Svært at få pæn underside

Kort sagt:

PETG = nemmere removal med korrekt setup, men dårligere underside finish

PLA

PLA er et relativt "sprødt" materiale, som ikke binder særlig aggressivt til laget ovenover.

Det betyder:

- Supports slipper lettere
- Man kan bruge lavere Contact Z distance
- Giver mulighed for pænere underside

Ulempe:

- Supports kan sidde lidt fast ved meget lav Z distance
- Kræver flere interface layers for helt glat finish

Kort sagt:

PLA = bedre finish, men lidt sværere removal hvis man presser settings

PETG 1 – Supports Snug PETG anbefaling

Snug PETG anbefaling	0.10 FAST DETAIL	0.15 SPEED	0.15 STRUCTURAL	0.20 SOLUBLE FULL	0.20 SOLUBLE INTERFACE	0.20 SPEED	0.20 STRUCTURAL
Contact Z distance	0.2-0.25	0.25-0.3	0.25-0.3	0.3	0.3	0.3	0.3
Interface layers	3-4	2-3	2-3	3	3	2-3	2-3
Interface spacing	0.25-0.3	0.3-0.35	0.3-0.35	0.35	0.35	0.35	0.35
Support pattern	Snug	Snug	Snug	Grid	Grid	Snug	Snug
Support density %	12-15	10-12	12-15	20	20	8-10	12-15
Top contact layers	3-4	2-3	2-3	3	3	2-3	2-3
XY separation	100%	100%	100%	100%	100%	100%	100%

PETG 2 – Supports Organic PETG anbefaling

Organic PETG anbefaling	0.10 FAST DETAIL	0.15 SPEED	0.15 STRUCTURAL	0.20 SOLUBLE FULL	0.20 SOLUBLE INTERFACE	0.20 SPEED	0.20 STRUCTURAL
Contact Z distance	0.25-0.3	0.3-0.35	0.3-0.35	0.35	0.35	0.3-0.35	0.3-0.35
Interface layers	2-3	2	2-3	2-3	2-3	2	2-3
Interface spacing	0.3	0.35	0.35	0.35-0.4	0.35-0.4	0.35	0.35
Support density %	10-12	8-10	10-12	15-20	15-20	8-10	10-12
Branch density	3	2-3	3	3-4	3-4	2-3	3
Branch diameter	2.5-3 mm	2-2.5 mm	2.5-3 mm	3 mm	3 mm	2-2.5 mm	2.5-3 mm
XY separation	100%	100%	100%	100%	100%	100%	100%

PLA 1 – Support Snug PLA anbefalinger

Snug PLA anbefalinger	0.10 FAST DETAIL	0.15 SPEED	0.15 STRUCTURAL	0.20 SOLUBLE FULL	0.20 SOLUBLE INTERFACE	0.20 SPEED	0.20 STRUCTURAL
Contact Z distance	0.1-0.12	0.15-0.2	0.15-0.2	0.2	0.2	0.2	0.2
Interface layers	4-5	3-4	3-4	3	3	3	3
Interface spacing	0.2	0.25	0.25	0.3	0.3	0.3	0.3
Support pattern	Snug	Snug	Snug	Grid	Grid	Snug	Snug
Support density %	15-20	12-15	15-20	20-25	20-25	10-12	15-20
Top contact layers	4-5	3-4	3-4	3	3	3	3
XY separation	60-80%	80%	80%	100%	100%	80-100%	80%

PLA 2 – Supports Organic PLA anbefaling

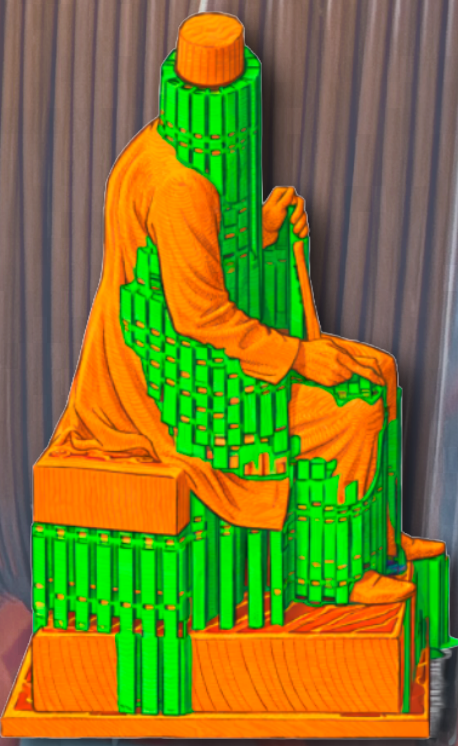
Organic PLA anbefaling	0.10 FAST DETAIL	0.15 SPEED	0.15 STRUCTURAL	0.20 SOLUBLE FULL	0.20 SOLUBLE INTERFACE	0.20 SPEED	0.20 STRUCTURAL
Contact Z distance	0.12-0.15	0.18-0.22	0.18-0.22	0.22-0.25	0.22-0.25	0.2-0.25	0.2-0.25
Interface layers	3-4	2-3	2-3	2-3	2-3	2-3	2-3
Interface spacing	0.2	0.25-0.3	0.25-0.3	0.3-0.35	0.3-0.35	0.3	0.3
Support density %	10-15	8-12	10-15	15-20	15-20	8-10	10-15
Branch density	3-4	2-3	3	3-4	3-4	2-3	3
Branch diameter	2-3 mm	2-3 mm	2.5-3 mm	3 mm	3 mm	2-2.5 mm	2.5-3 mm
XY separation	80-100%	100%	100%	100%	100%	100%	100%



Organic



Fleksibel Support



Snug



Fast Support