

# 3D列印檢查清單

\* Setting terms in Cura (供參考)

## Printing materials profile

- Corresponding profile

## Walls

- Horizontal expansion *-0.05 to -0.15mm*
- Z seam alignment *Shortest / Specified*
- Z seam position *Back*

## Quality

- Layer height *0.12 / 0.2 / 0.3mm*
- Initial layer height *0.28mm*

## Top/Bottom

- # of Top layers *2 - 4 layers*
- # of Bottom layers *2 - 4 layers; 桌遊可為0*

## Infill

- Infill density *10 - 30%*
- Infill pattern *Grid/ Gyroid*

## Support

- Support structure *Tree*
- Support pattern *ZigZag*
- Support Z distance
- Roof *0.4mm*
- Floor *0.4mm*
- Support interface density
- Roof *50 - 75%*
- Floor *10 - 25%*

## Build Plate Adhesion

- Adhension type *Skirt / Brim*
- Tab "Anti wrapping" *if needed*