

Process Global Objects

Other layers speed

Outer wall	100	mm/s
Inner wall	150	mm/s
Small perimeters	50%	mm/s or %
Small perimeters threshold	0	mm
Sparse infill	150	mm/s
Internal solid infill	150	mm/s
Top surface	100	mm/s
Gap infill	50	mm/s

Overhang speed

Slow down for overhangs	<input checked="" type="checkbox"/>
Classic mode	<input type="checkbox"/>
Slow down for curled perimeters	<input type="checkbox"/>
Overhang speed	0 mm/s or % (10%, 25%, 50%, 75%, 100%)
Bridge	25 mm/s External 70 mm/s or % Internal

Acceleration

Normal printing	12000 mm/s <sup>2</sup>
Outer wall	5000 mm/s <sup>2</sup>

Scarf joint seam (beta)