

Overhang speed

20

mm/s or %

[50%, 75%, 100%]

10

mm/s or %

[75%, 100%]

Bridge

25

mm/s

External

70

mm/s or %

Internal

Acceleration

Normal printing

12000

mm/s²

Outer wall

5000

mm/s²

Inner wall

5000

mm/s²

Bridge

50%

mm/s² or %

Sparse infill

100%

mm/s² or %

Internal solid infill

100%

mm/s² or %

First layer

500

mm/s²

Top surface

2000

mm/s²

Travel

12000

mm/s²

Jerk(XY)

Default

9

mm/s

Outer wall

9

mm/s

Inner wall

9

mm/s

Infill

9

mm/s

Top surface

9

mm/s

First layer

9

mm/s

Travel

9

mm/s

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Scarf joint seam (beta)