



## Document 3 – CAMELO

1. Import the file on the Slicing Software ("Cura") and orient the piece in the best way to be printed.

The screenshot displays the Ultimaker Cura software interface. The main window shows a 3D model of a 'CAMELO' candy on a print bed. The interface includes a top navigation bar with 'PREPARE', 'PREVIEW', and 'MONITOR' tabs. The left sidebar contains various tool icons. The right sidebar shows the 'Print settings' panel, which is currently open to the 'Speed' section. The 'Print settings' panel includes a search bar, a profile dropdown set to 'Draft Quality - 0.2mm', and a list of settings for Speed, Travel, and Cooling. The 'Speed' section is expanded, showing the following values:

| Setting          | Value | Unit |
|------------------|-------|------|
| Print Speed      | 45    | mm/s |
| Infill Speed     | 45    | mm/s |
| Wall Speed       | 40    | mm/s |
| Outer Wall Speed | 30    | mm/s |
| Inner Wall Speed | 40    | mm/s |
| Top/Bottom Speed | 20    | mm/s |
| Support Speed    | 30    | mm/s |
| Travel Speed     | 150   | mm/s |

The 'Travel' section is also visible, with 'Z Hop When Retracted' set to 'Off'. The 'Cooling' section is expanded, showing 'Enable Print Cooling' set to 'On'. At the bottom right, a summary box displays the estimated print time as '4 hours 5 minutes' and the material usage as '43g - 5.92m'. There are 'Preview' and 'Save to File' buttons in this summary box.



2. I enter all the correct printing parameters (layer height, wall tickness, infill, support, speed, temperature, ...) and check for any problems from the "Preview"

The screenshot displays the Ultimaker Cura software interface. At the top, the navigation bar includes 'PREPARE', 'PREVIEW' (highlighted with a red box), and 'MONITOR'. Below this, the 'View type' is set to 'Layer view' and the 'Color scheme' is 'Line Type'. The main workspace shows a 3D model of a red vase-like object on a grid. The 'Print settings' panel on the right is open, showing various parameters:

| Category      | Parameter            | Value | Unit |
|---------------|----------------------|-------|------|
| Quality       | Layer Height         | 0.3   | mm   |
|               | Wall Thickness       | 3     | mm   |
| Shell         | Wall Line Count      | 4     |      |
|               | Top/Bottom Thickness | 3     | mm   |
|               | Top Thickness        | 1     | mm   |
|               | Top Layers           | 5     |      |
|               | Bottom Thickness     | 1     | mm   |
| Bottom Layers | Bottom Layers        | 5     |      |
|               | Horizontal Expansion | 0     | mm   |
| Infill        | Infill Density       | 10    | %    |
|               | Infill Pattern       | Grid  |      |
|               | Material             |       |      |

At the bottom right of the settings panel, a summary box shows a print time of '3 hours 15 minutes' and a weight of '36g - 4.90m'. A blue arrow points to the 'Save to File' button.



3. At this point I can save the ".Gcode" file to send to the machine.

The screenshot displays the Ultimaker Cura software interface. A 'Save to File' dialog box is open, showing the file path '210423\_Cesar > File da stampare > Caramelo'. The file name is 'UM2\_Caramelo' and the file type is 'G-code File (\*.gcode)'. The 'Salva' button is circled in red. The 'Print settings' panel on the right shows the 'Draft Quality - 0.2mm' profile. The 'Quality' section is expanded, showing settings for Layer Height (0.3 mm), Shell, Wall Thickness (3 mm), Wall Line Count (4), Top/Bottom Thickness (3 mm), Top Thickness (1 mm), Top Layers (5), Bottom Thickness (1 mm), and Bottom Layers (5). The 'Infill' section shows Infill Density (10 %) and Infill Pattern (Grid). The 'Material' section is partially visible. At the bottom right, a summary box shows a print time of 3 hours 15 minutes and a volume of 36g · 4.90m. The 'Save to File' button is highlighted in blue.

| Section        | Parameter            | Value          | Unit |
|----------------|----------------------|----------------|------|
| Quality        | Layer Height         | 0.3            | mm   |
|                | Wall Thickness       | 3              | mm   |
|                | Wall Line Count      | 4              |      |
|                | Top/Bottom Thickness | 3              | mm   |
|                | Top Thickness        | 1              | mm   |
|                | Top Layers           | 5              |      |
|                | Bottom Thickness     | 1              | mm   |
|                | Bottom Layers        | 5              |      |
|                | Horizontal Expansion | 0              | mm   |
|                | Infill               | Infill Density | 10   |
| Infill Pattern |                      | Grid           |      |
| Material       |                      |                |      |