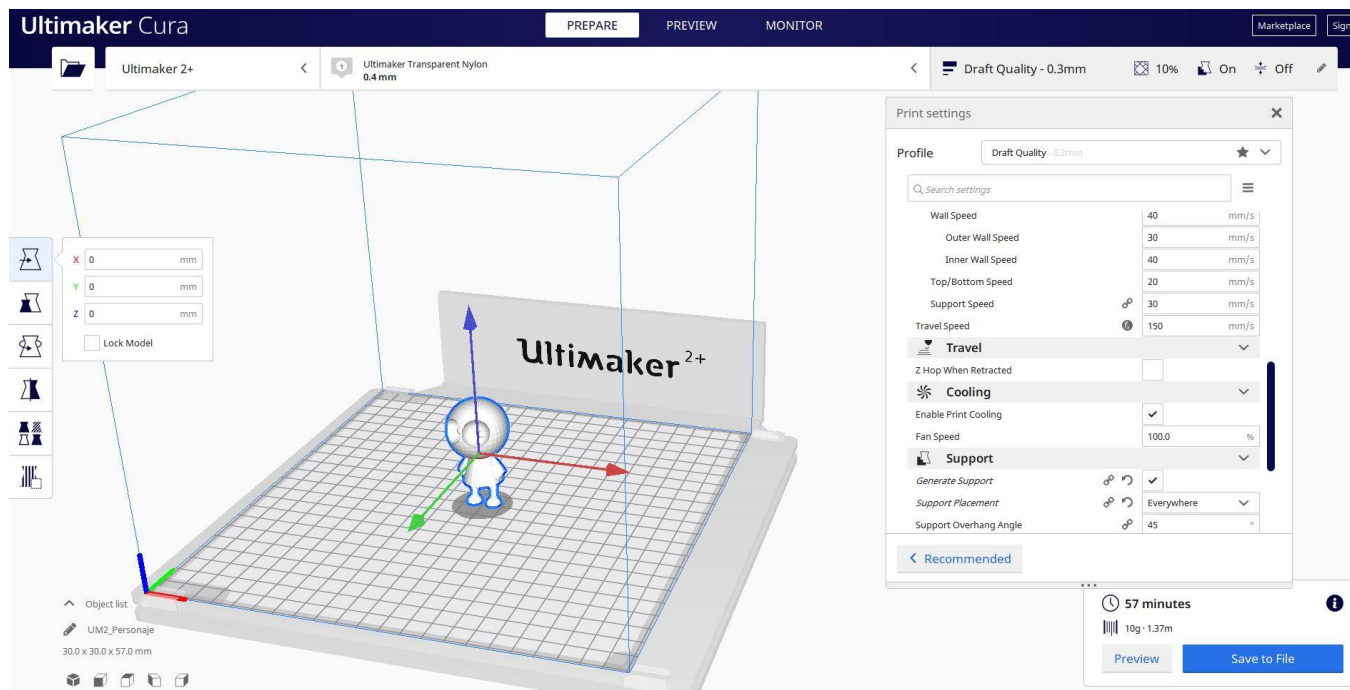




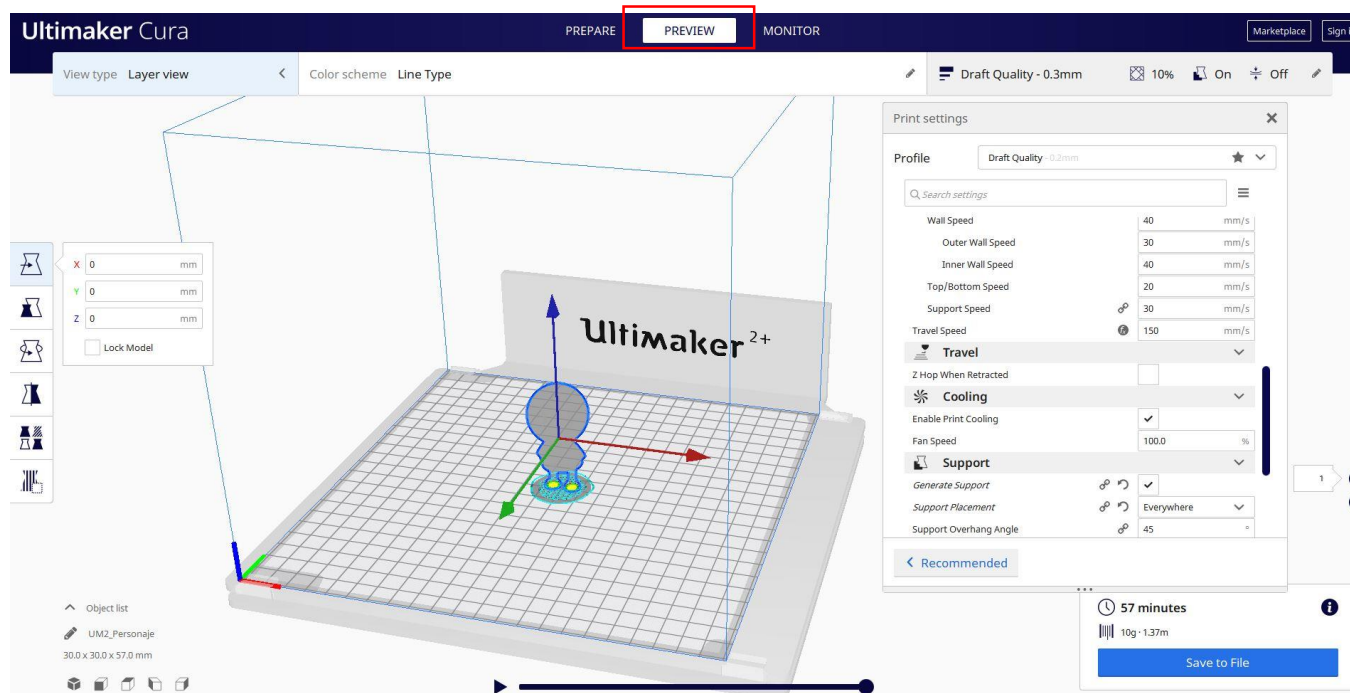
Document 15 - PERSONAJE

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





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





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

The screenshot displays the Ultimaker Cura software interface. The main window shows a 3D model of a printed part on a grid. The 'PREPARE' tab is active. A 'Save to File' dialog box is open, showing the file path '210423_Cesar > File da stampare > Personaje'. The file name is 'UM2_Personaje' and the file type is 'G-code File (*.gcode)'. The 'Salva' button is circled in red. The 'Print settings' panel is also visible, showing various parameters for the print profile 'Draft Quality - 0.2mm'. The estimated print time is 57 minutes.

Parameter	Value	Unit
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
Fan Speed	100.0	%
Support Overhang Angle	45	°