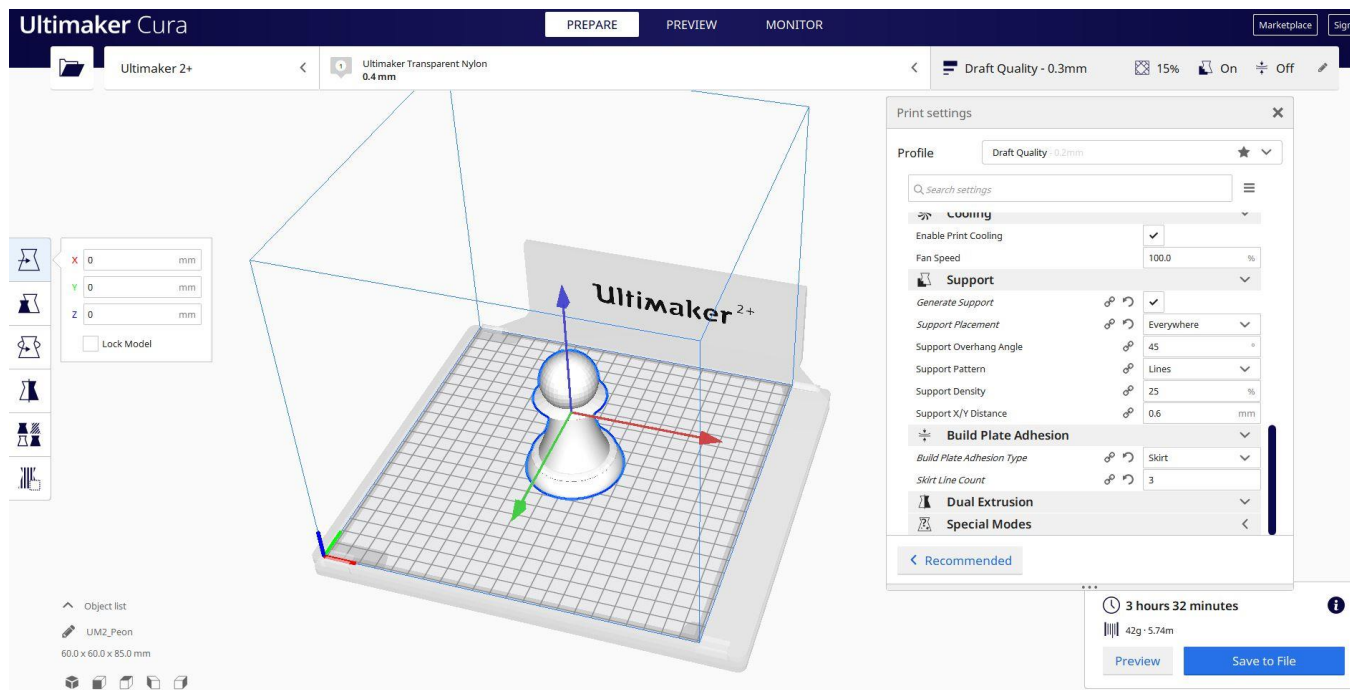




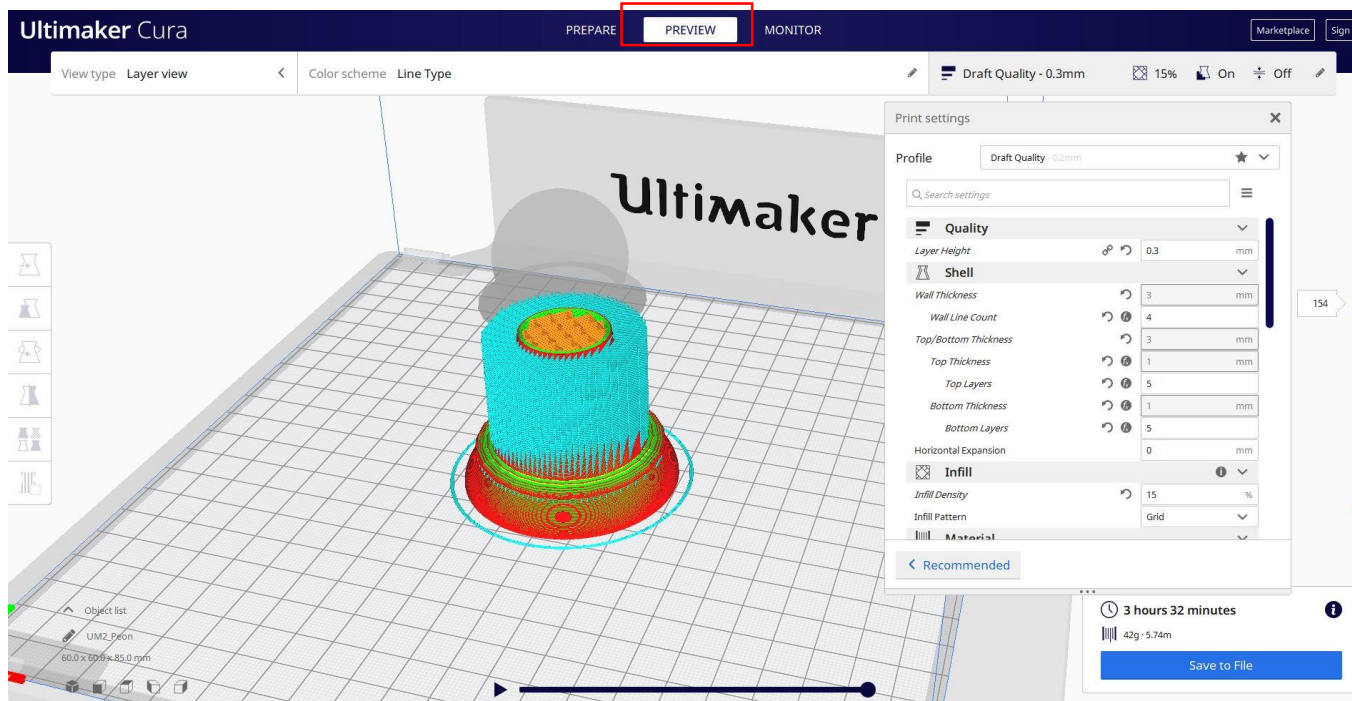
## Document 14 - PEON

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 tickness, 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 peon being prepared for printing. The interface is divided into several sections:

- Top Bar:** Displays the software name 'Ultimaker Cura', the current material 'Ultimaker Transparent Nylon 0.4 mm', and the print profile 'Draft Quality - 0.3 mm'.
- Print settings Panel:** Located on the right, it shows various parameters for the print job, including:
  - Quality:** 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, Bottom Layers: 5
  - Infill:** Horizontal Expansion: 0 mm, Infill Density: 15%, Infill Pattern: Grid
- Save to File Dialog:** A file explorer window is open, showing the file path '210423\_Cesar > File da stampare > Peon'. The file name is 'UM2\_Peon' and the file type is 'G-code File (\*.gcode)'. The 'Salva' button is highlighted with a red circle.
- Object list:** Located at the bottom left, it shows the object 'UM2\_Peon' with dimensions '60.0 x 60.0 x 85.0 mm'.
- Print Summary:** Located at the bottom right, it shows a print time of '3 hours 32 minutes' and a weight of '42g · 5.74m'. There are 'Preview' and 'Save to File' buttons.