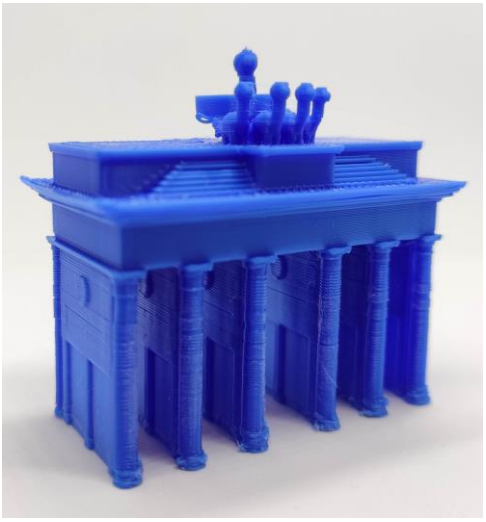
## BRANDENBURGS´ GATE PRINTING PARAMETERS



This model is not hard to print, the only difficulty could be the ¨stringing¨ between the gate pillars, but it is easily removed on post-processing step.

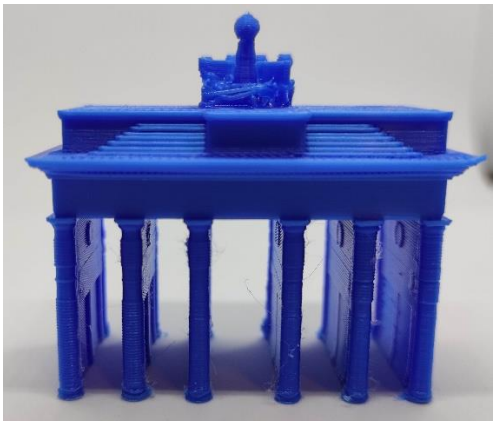
To avoid the ¨stringing¨ we highly recommend the following settings:

- The printing retraction and speed retraction.
- The fuser temperature.
- The printing speed and trajectory.

Every printer and ¨slicer¨ are different, so the best way to get the perfection and avoid ¨stringing¨ is the use of that settings and get familiar with them and reduce that problem as much as possible.

In some websites like ¨thingiverse¨ we can find lot of ¨stringing¨ tests shared by the Maker community, this help can make the setting process easier for us.

Otherwise, on the printed model, we can see that there is a print failure in the chariot due to the lack of thickness the wheels had. To avoid this kind of failures we highly recommend designing the pieces with more thickness, twice the nozzle diameter, it is generally 0.4 mm.



Printing view where we can see the chariot printing problems related to ¨stringing¨.

**<u>Parameters in our Brandenburg's gate printing</u>**

**Printing size:** X: 54mm Y: 30mm Z: 50mm

**Layer height:** 0,20mm

**Printing speed:** 40mm/s

**Travel speed:** 40mm/s

**Expected time:** 3h 21mins