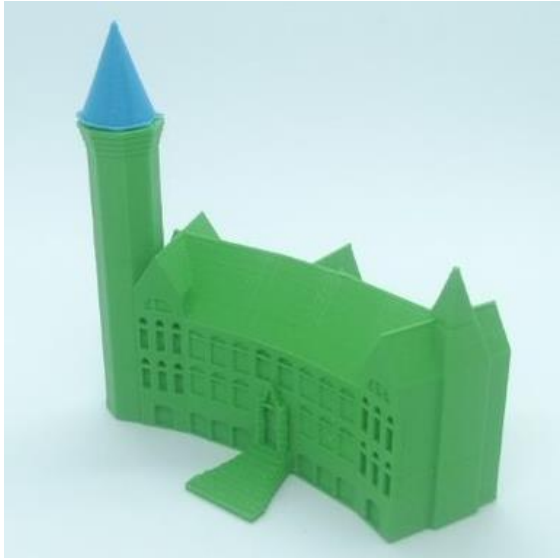


BANK MUSEUM PRINTING PARAMETERS



Once we have finished the bank museum it is time to print it.

This structure is not difficult to print because of its shape, anyways we have to be aware of stringing, we could find this problem when printing windows.

Depending on the scale we have to consider bridging also with the windows, if we print the museum on a large scale this problem could appear, but if we print it on a short scale, the window details could overlap each other.

How could we solve Bridging problems?

We define “Bridging” as the moment when our printer extrudes filaments in the air, without a support, creating imperfect layers that will affect to other layers that would be printed over them and to the final print result.

To improve or delete bridging problems is recommended:

- Reduce the printing speed.
- Reduce the filament extrusion temperature and increase the layer fan cooling speed.
- In the process of design, consider that the bigger the bridge distance is the higher the probabilities of something going wrong are.

How could we solve Stringing problems?

The stringing appears when the extruder travels from one position to another extruding filament. We can solve this problem with a good postprocessing.

To improve or delete stringing problems is recommended:

- Reduce printing temperature.
- Modify retraction.
- Modify trajectory speed.

Applied parameters to our museum printout

Dimensions: X: X: 80 Y: 40 Z: 79

Layer height: 0'20mm

Printing speed: 40 mm/s

Trajectory speed: 70 mm/s

Height pause: 61 mm

Expected time: 3h 13 min

