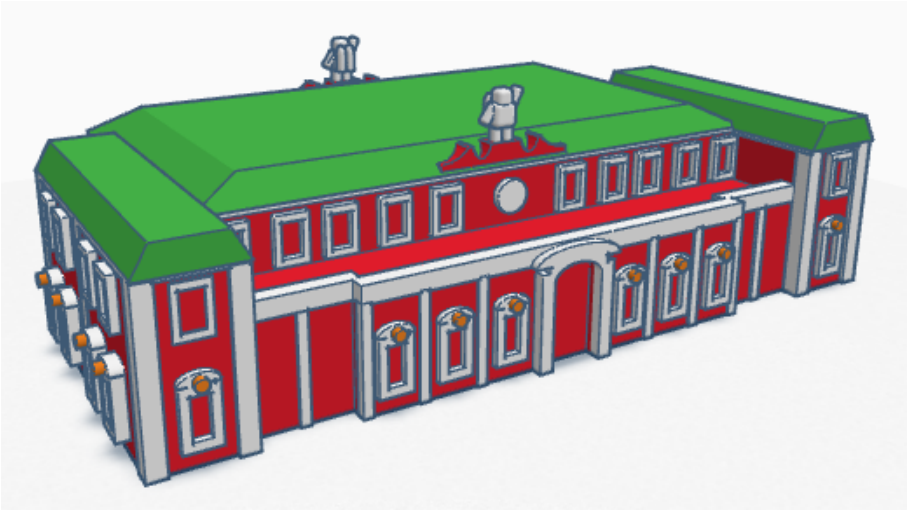
KADRIORG PALACE PRINTING PARAMETERS



Once we have finished our design, we are going to print it.

This design is not difficult to print, the only problem we could find is ‘’stringing’’ or ‘’overhanging’’.

The ¨overhanging¨ refers to that part of the structure that is completely suspending in the air. When printing overhangs, we can find similar problems to the ones of printing bridges. To avoid it we must consider the next things:

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

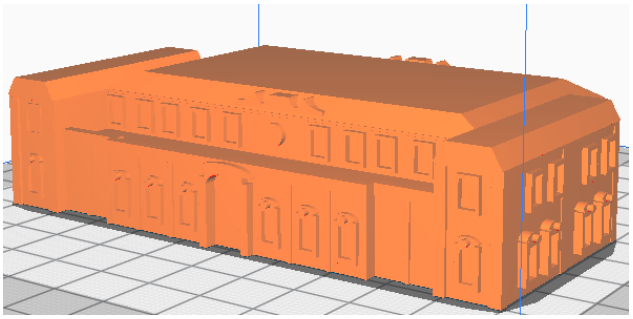
How could we solve Stringing problems?

To improve or delete stringing problems is recommended:

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

How could we solve Overhanging problems?

- Use supports to create an easily removable surface, where we can lay the overhangs.
- Reduce the extrusion temperature, printing and travel speed, and increase the cooling fan speed.
- When designing models with overhang, it is recommended that they never exceed 45 degrees with respect to its horizontal.



Printing parameters

Size→ X:80mm Y: 50mm Z: 18mm

Layer height → 0’20mm/s

Print speed → 40mm/s

Travel speed → 70mm/s

Base → No

Infill pattern → Lineal

Infill density → 15%

Expected time → 2h 22mins.