

Hungarian National Assembly printing parameters



Once we have finished the Hungarian National Assembly design, it is time to print it.

Problems we could find

When printing this structure, we could find two main problems, “bridging” and “stringing”.

How can we solve Stringing problems?

Stringing is one of the most common problems in 3D printing, it appears when the printhead moves between the different printing points, in that movement it extrudes some melted plastic that solidifies and creates a strand.

To avoid the “stringing” we highly recommend the following settings:

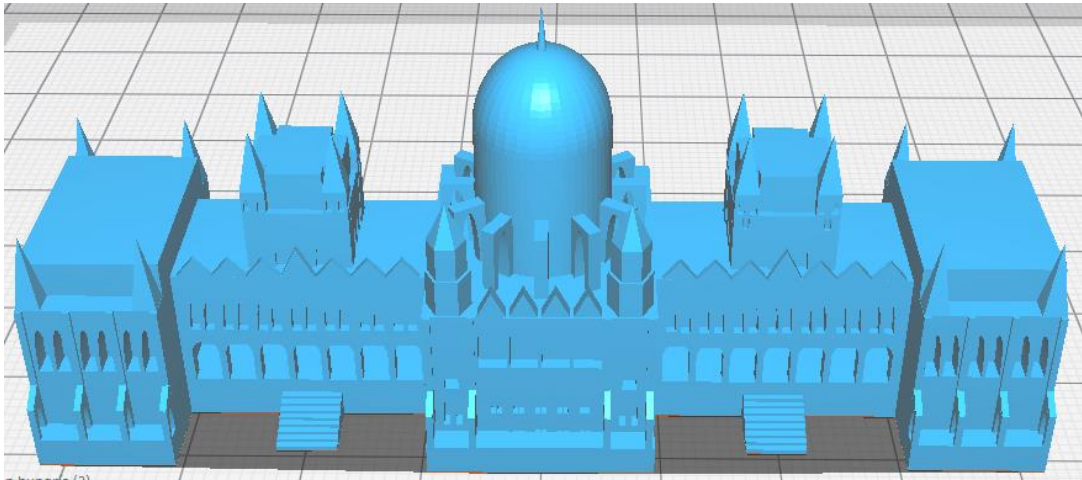
- The print retraction and speed retraction.
- The fuser temperature.
- The printing speed and trajectory.

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.
- If it is impossible to print, we have to add brackets with the slicer.

**Printing parameters**

Size → X:118.99mm Y: 34.50mm Z: 52.62mm

Layer height → 0.18mm/s

Print speed → 60mm/s

Travel speed → 60mm/s

Base → No

Infill pattern → Hexagonal

Infill density → 30%

Expected time → 5h 20 min.