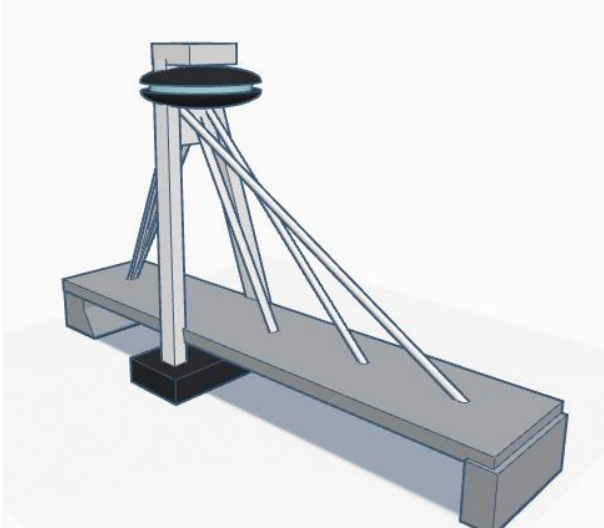


## MOST SNP PRINT PARAMETERS



It is a structure with some difficulties when we have to print it, the main problem is the material printed in the air for a long time (it depends on the scale), this problem is known as bridging.

On the other hand, both support cables and most part of the restaurant have overhanging with less than 45° angles, that can complicate the printing project because of some parts of the material printed in the air and solid parts, there could be landslides or imperfections in the structure.

To solve these problems, we highly recommend adding brackets in every part that needs a support, this way, with standard settings in the slicer we can easily print this structure.

We have printed our model without any brackets and even with several problems in one part of the structure, landslide of some material, we have finished our design without difficulties

### Printing parameters

Printing size → X: 16,93mm Y: 75,04mm Z: 38,43mm

Layer height: 0,20mm/s      Initial layer height: 0,20 mm/s

Print temperature: 205 °C      Printing speed: 30mm/s

Travel speed: 60mm/s

As we can observe, in the settings, we have reduced the printing temperature 10° and the printing speed 30mm/s because of the material in the air, so it gets cold earlier and we increase the chance of success.