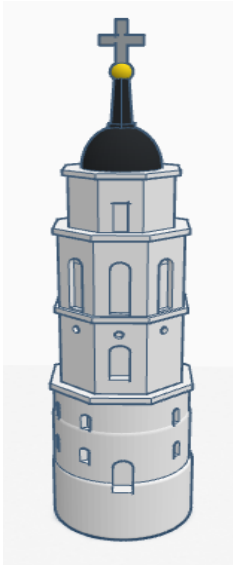


BELL TOWER OF VILNIUS CATHEDRAL PRINTING PARAMETERS.



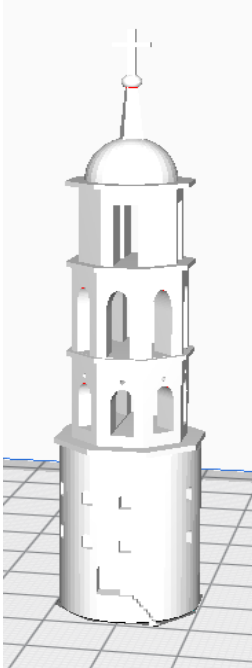
The bell tower is not hard to print due to the basic shapes it has, so we can modify the parameters easily. It could only appear "stringing" when printing the arches but it will not be a problem we cannot fix.

The 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.

"Stringing solutions":

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

In our design we have added a pause at height (66,5/67mm) so we can change the filament and get a double colour print.



Parameters in bell tower of Vilnius cathedral

Size → X: 20mm Y: 20mm Z: 90mm

Layer height: 0,20mm/s

Print speed: 40mm/s

Travel speed: 60mm/s

Infill pattern → Lineal

Infill density → 30%

Expected time → 40 minutos.