

Perimeter Gap Process Comparison

profile name="Default PLA"	Default PLA	eSun PLA+ Blue	Airscapes Gapless PLA+
diameter	0.35	0.35	0.35
width	0.4	0.4	0.4
extrusionMultiplier	0.9	0.9	0.93
useRetract	1	1	1
retractionDistance	1	0.7	0.7
extraRestartDistance	0	-0.05	0
retractionZLift	0	0.2	0
retractionSpeed	2400	2400	3000
extruder			
primaryExtruder	0	0	0
layerHeight	0.2	0.2	0.2
topSolidLayers	3	3	3
bottomSolidLayers	3	4	4
perimeterOutlines	3	3	3
printPerimetersInsideOut	1	0	1
startPointOption	2	2	2
startPointOriginX	0	0	0
startPointOriginY	0	0	0
firstLayerHeightPercentage	90	100	100
firstLayerWidthPercentage	100	100	100
firstLayerUnderspeed	0.5	0.5	0.5
infillExtruder	0	0	0
internalInfillPattern	Rectilinear	Rectilinear	Rectilinear
externalInfillPattern	Rectilinear	Rectilinear	Rectilinear
infillPercentage	20	20	20
outlineOverlapPercentage	15	15	15
infillExtrusionWidthPercentage	100	100	100
minInfillLength	5	5	0.01
infillLayerInterval	1	1	1
internalInfillAngles	45,-45	45,-45	45,-45
overlapInternalInfillAngles	0	0	0
externalInfillAngles	45,-45	45,-45	45,-45
temperatureController name="Primary Extruder"			
setpoint layer=	"1" temperature="220"	"1" temperature="210"	"1" temperature="210"

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temperatureController name="Heated Bed"			
setpoint layer=	"1" temperature="75"	"1" temperature="65"	"1" temperature="65"
fanSpeed			
setpoint layer="1" speed="0"	"1" speed="0"	"1" speed="0"	"1" speed="0"
setpoint layer="2" speed="100"	"2" speed="100"	"3" speed="45"	"3" speed="100"
		"4" speed="50"	
fanSpeed			
blipFanToFullPower	1	1	1
adjustSpeedForCooling	1	1	1
minSpeedLayerTime	15	15	15
minCoolingSpeedSlowdown	20	20	20
gcodeZoffset	0	-0.02	-0.02
defaultSpeed	4800	4000	2700
outlineUnderspeed	0.5	0.3	0.75
rapidXYspeed	18000	18000	18000
rapidZspeed	1200	1200	1200
useMinPrintHeight	0	1	1
minPrintHeight	0	0	0
useMaxPrintHeight	0	1	1
maxPrintHeight	0	5	2.2
onlyRetractWhenCrossingOutline	1	0	0
retractBetweenLayers	1	1	0
onlyWipeOutlines	1	1	0
avoidCrossingOutline	0	1	0
maxMovementDetourFactor	3	4	4
externalThinWallType	0	0	0
internalThinWallType	2	1	1
thinWallAllowedOverlapPercentage	10	70	15
singleExtrusionMinLength	1	0.2	0.01
singleExtrusionMinPrintingWidthPercentage	50	70	50
singleExtrusionMaxPrintingWidthPercentage	200	150	200
singleExtrusionEndpointExtension	0.2	0.2	0.3