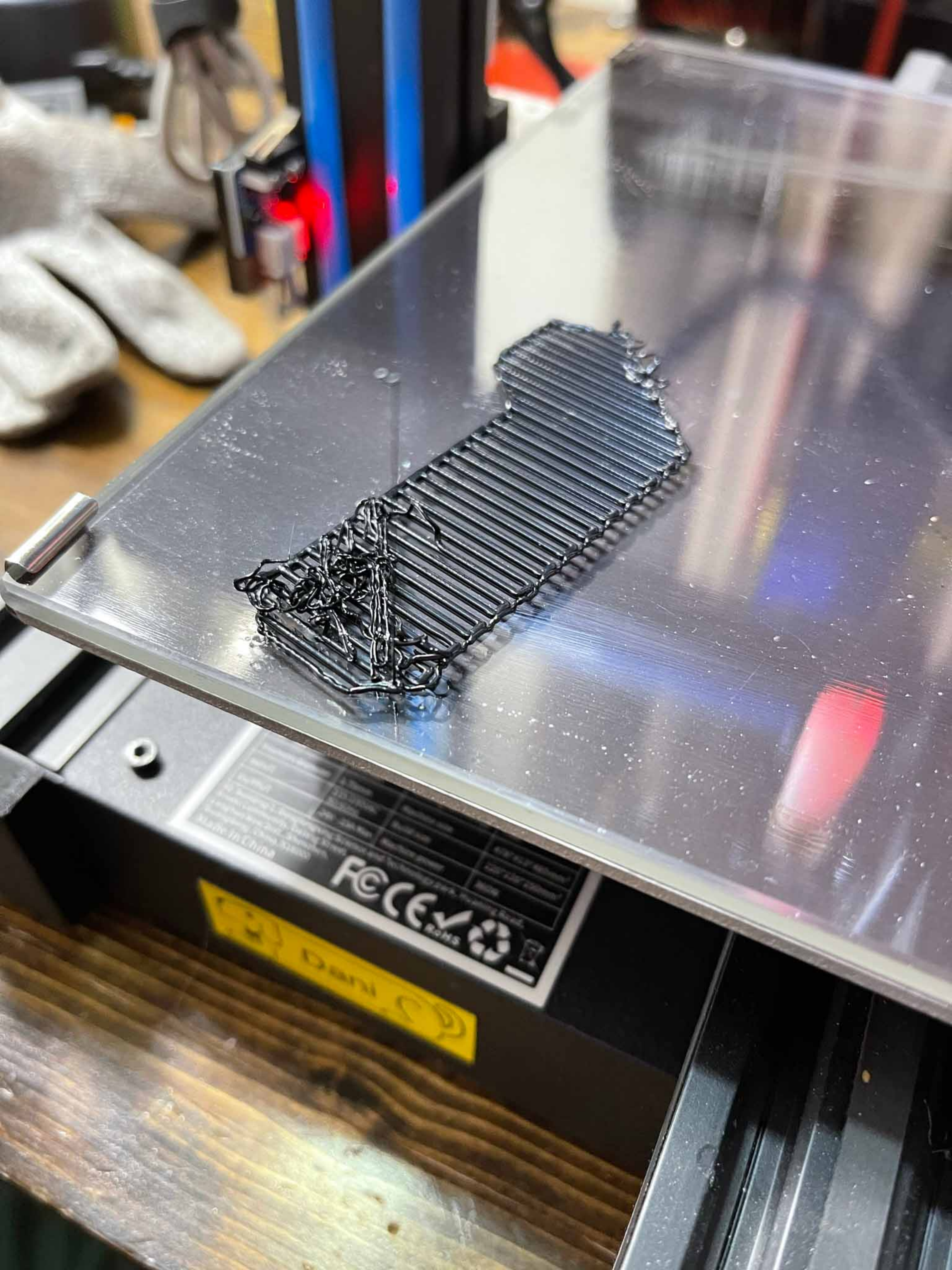




Model: 1000N
Capacity: 1000g
Accuracy: 0.001g
Max Load: 1000g
Max Count: 9999.99g
Power: 2.5W
Dimensions: 150x100x50mm
Made in China

FC CE ✓

0.001g

Process Name:

Select Profile:

A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS

+

-

Auto-Configure for Print Quality

High

+

-

Auto-Configure Extruders

All Extruders

▼

General Settings

Infill Percentage:

100%

☒ Include Raft

☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Extruder List
(click item to edit settings)

Right Extruder

Center Extruder

Left Extruder

Add Extruder

Remove Extruder

Left Extruder Toolhead

Overview

Extruder Toolhead Index

Tool 2

Nozzle Diameter

0.40

 mm

Extrusion Multiplier

1.00

Extrusion Width

☐ Auto

☒ Manual

0.40

 mm

Ooze Control

☒ Retraction

Retraction Distance

15.00

 mm

Extra Restart Distance

0.00

 mm

Retraction Vertical Lift

0.00

 mm

Retraction Speed

6000.0

 mm/min

☐ Coast at End

Coasting Distance

0.20

 mm

☐ Wipe Nozzle

Wipe Distance

5.00

 mm

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

Auto-Configure for Print Quality

Auto-Configure Extruders

ABS

+

-

High

+

-

All Extruders

▼

General Settings

Infill Percentage: 100% ☒ Include Raft ☒ Generate Support

- Extruder
- Layer
- Additions
- Infill
- Support
- Temperature
- Cooling
- G-Code
- Scripts
- Speeds
- Other
- Advanced

Layer Settings

Primary Extruder

Left Extruder

 ▼

Primary Layer Height

0.3000

mm

Top Solid Layers

4

Bottom Solid Layers

4

Outline/Perimeter Shells

2

Outline Direction: ☒ Inside-Out ☐ Outside-In

☐ Print islands sequentially without optimization

☐ Single outline corkscrew printing mode (vase mode)

First Layer Settings

First Layer Height

125

 %

First Layer Width

125

 %

First Layer Speed

50

 %

Start Points

☐ Use random start points for all perimeters

☒ Optimize start points for fastest printing speed

☐ Choose start point closest to specific location

X:

0.0

 Y:

0.0

 mm

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS



Auto-Configure for Print Quality

High



Auto-Configure Extruders

All Extruders

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

☐ Use Skirt/Brim

Skirt Extruder

Right Extruder

Skirt Layers

2

Skirt Offset from Part

4.00

mm

Skirt Outlines

3

☐ Use Prime Pillar

Prime Pillar Extruder

All Extruders

Pillar Width

35.00

mm

Pillar Location

South

Speed Multiplier

100

%

☒ Use Raft

Raft Extruder

Left Extruder

Raft Top Layers

3

Raft Base Layers

2

Raft Offset from Part

10.00

mm

Separation Distance

0.35

mm

Raft Top Infill

86

%

Above Raft Speed

30

%

☐ Use Ooze Shield

Ooze Shield Extruder

All Extruders

Offset from Part

2.00

mm

Ooze Shield Outlines

1

Sidewall Shape

Waterfall

Sidewall Angle Change

30

deg

Speed Multiplier

100

%

Hide Advanced

Select Models

OK

Cancel

Process Name:

Select Profile: Update Profile Save as New Remove

Auto-Configure for Material

+ -

Auto-Configure for Print Quality

+ -

Auto-Configure Extruders

General Settings

Infill Percentage: 100% ☒ Include Raft ☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

General

Infill Extruder

Internal Fill Pattern

External Fill Pattern

Interior Fill Percentage %

Outline Overlap %

Infill Extrusion Width %

Minimum Infill Length mm

Combine Infill Every layers

☐ Include solid diaphragm every layers

Internal Infill Angle Offsets

deg

Add Angle

Remove Angle

45

-45

☒ Print every infill angle on each layer

External Infill Angle Offsets

deg

Add Angle

Remove Angle

45

-45

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified) ▼

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS ▼



Auto-Configure for Print Quality

High ▼



Auto-Configure Extruders

All Extruders ▼

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

Support Material Generation

☒ Generate Support Material

Support Extruder Left Extruder ▼

Support Infill Percentage 25 %

Extra Inflation Distance 0.20 mm

Support Base Layers 0

Combine Support Every 1 layers

Dense Support

Dense Support Extruder Left Extruder ▼

Dense Support Layers 8

Dense Infill Percentage 70 %

Automatic Placement

Only used if manual support is not defined

Support Type From Build Platform Only ▼

Support Pillar Resolution 4.00 mm

Max Overhang Angle 45 deg

Separation From Part

Horizontal Offset From Part 0.40 mm

Upper Vertical Separation Layers 2

Lower Vertical Separation Layers 1

Support Infill Angles

0 deg

25

45

Add Angle

Remove Angle

Hide Advanced

Select Models

OK

Cancel

FFF Settings

?

✕

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified) Update Profile Save as New Remove

Auto-Configure for Material

ABS + -

Auto-Configure for Print Quality

High + -

Auto-Configure Extruders

All Extruders

General Settings

Infill Percentage: 100% Include Raft Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Temperature Controller List
(click item to edit settings)

Shared Heater

Heated Bed

Add Temperature Controller

Remove Temperature Controller

Heated Bed Temperature

Overview

Temperature Identifier T0

Temperature Controller Type: Extruder Heated build platform

Wait for temperature controller to stabilize before beginning build

Per-Layer Temperature Setpoints

Layer	Temperature
1	100
2	85

Add Setpoint

Remove Setpoint

Layer Number 1

Temperature 200 °C

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS



Auto-Configure for Print Quality

High



Auto-Configure Extruders

All Extruders

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Temperature Controller List
(click item to edit settings)

Shared Heater

Heated Bed

Add Temperature Controller

Remove Temperature Controller

Shared Heater Temperature

Overview

Temperature Identifier T0

Temperature Controller Type: ☒ Extruder ☐ Heated build platform☒ Wait for temperature controller to stabilize before beginning build

Per-Layer Temperature Setpoints

Layer	Temperature
1	222

Add Setpoint

Remove Setpoint

Layer Number 1

Temperature 200 °C

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified) ▼

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS ▼



Auto-Configure for Print Quality

High ▼

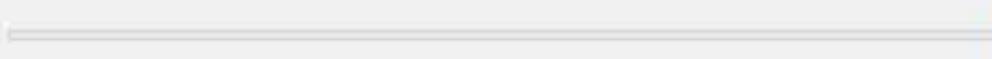


Auto-Configure Extruders

All Extruders ▼

General Settings

Infill Percentage:

 100%☒ Include Raft☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

Per-Layer Fan Controls

Layer Fan Speed

0 0

Add Setpoint

Remove Setpoint

Layer Number 1

Fan Speed 60 %

Fan Options

☐ Blip fan to full power when increasing from idle

Fan Overrides

☐ Increase fan speed for layers below 45.0 sec

Maximum cooling fan speed 100 %

☐ Bridging fan speed override 100 %

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS



Auto-Configure for Print Quality

High



Auto-Configure Extruders

All Extruders

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

G-Code Options

- ☒ 5D firmware (include E-dimension)
- ☐ Relative extrusion distances
- ☒ Allow zeroing of extrusion distances (i.e. G92 E0)
- ☐ Use independent extruder axes
- ☐ Include M101/M102/M103 commands
- ☒ Firmware supports "sticky" parameters
- ☐ Apply toolhead offsets to G-Code coordinates

Global G-Code Offsets

	X-Axis	Y-Axis	Z-Axis	
Offset	0.00	0.00	0.00	mm

☒ Update Machine Definition

Machine type Cartesian robot (rectangular volume)

	X-Axis	Y-Axis	Z-Axis	
Build volume	220.0	220.0	250.0	mm
Origin offset	0.0	0.0	0.0	mm
Homing dir	Min	Min	Min	
Flip build table axis	☐ X	☒ Y	☐ Z	
Toolhead offsets	Tool 0	X 0.00	Y 0.00	

☒ Update Firmware Configuration

Firmware type RepRap (Marlin/Repetier/Sprinter)

GPX profile Replicator 2 (default config)

Baud rate 250000 bits/sec

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS



Auto-Configure for Print Quality

High



Auto-Configure Extruders

All Extruders

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

Starting Script

Layer Change Script

Retraction Script

Tool Change Script

Ending Script

```
G28 ; home all axes
M205 X10 Y10 ; set XY jerk to 10
M163 S0 P1.0
M163 S1 P0.0
M163 S2 P0.0
M164 S0 ; set T0 mixing ratio to full right
M163 S0 P0.0
M163 S1 P1.0
M163 S2 P0.0
M164 S1 ; set T1 mixing ratio to full center
M163 S0 P0.0
M163 S1 P0.0
```

Post Processing

Export file format: Standard G-Code (.gcode)

☐ Add celebration at end of build (for .x3g files only)

Looney Toons

Additional terminal commands for post processing

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified) ▼

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS ▼



Auto-Configure for Print Quality

High ▼



Auto-Configure Extruders

All Extruders ▼

General Settings

Infill Percentage:

 100%☒ Include Raft☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

Starting Script

Layer Change Script

Retraction Script

Tool Change Script

Ending Script

```
;T2 ; select right extruder  
;G92 E0 ; Set Extruder to 0  
;G1 E-5 ; Retract 5 mm  
M104 S0 ; turn off extruder  
M140 S0 ; turn off bed  
G91 ; relative positioning  
G1 Z1 F600 ; lift nozzle  
;G90 ; absolute positioning  
;G1 X0 Y250 F2400 ; move head away;M84 ; disable motors
```

Post Processing

Export file format Standard G-Code (.gcode) ▼

☐ Add celebration at end of build (for .x3g files only) Looney Toons ▼

Additional terminal commands for post processing

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified) ▼

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS ▼



Auto-Configure for Print Quality

High ▼



Auto-Configure Extruders

All Extruders ▼

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder Layer Additions Infill Support Temperature Cooling G-Code Scripts Speeds Other Advanced

Speeds

Default Printing Speed 1800.0 mm/min

Outline Underspeed 50 %

Solid Infill Underspeed 80 %

Support Structure Underspeed 80 %

X/Y Axis Movement Speed 6000.0 mm/min

Z Axis Movement Speed 1002.0 mm/min

Speed Overrides

☒ Adjust printing speed for layers below 15.0 sec

Allow speed reductions down to 20 %

Hide Advanced

Select Models

OK

Cancel

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified)

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS

+

-

Auto-Configure for Print Quality

High

+

-

Auto-Configure Extruders

All Extruders

▼

General Settings

Infill Percentage: 100%

☒ Include Raft

☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Bridging

Unsupported area threshold50.0sq mm

Extra inflation distance0.00mm

Bridging extrusion multiplier100%

Bridging speed multiplier100%

☐ Use fixed bridging infill angle0deg

☐ Apply bridging settings to perimeters

Dimensional Adjustments

Horizontal size compensation0.00mm

Filament Properties

Filament Toolhead IndexTool 0

Filament diameter1.7500mm

Filament price46.00price/kg

Filament density1.25grams/cm^3

Tool Change Retraction

Tool change retraction distance8.00mm

Tool change extra restart distance0.00mm

Tool change retraction speed1800.0mm/min

Process Name: Jeep Clip

Select Profile: A10T Left ABS (modified) ▼

Update Profile

Save as New

Remove

Auto-Configure for Material

ABS ▼



Auto-Configure for Print Quality

High ▼



Auto-Configure Extruders

All Extruders ▼

General Settings

Infill Percentage:

100%

☒ Include Raft☒ Generate Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Layer Modifications

☐ Start printing at height 0.00 mm☐ Stop printing at height 0.00 mm

Thin Wall Behavior

External Thin Wall Type Perimeters only ▼

Internal Thin Wall Type Allow gap fill ▼

Allowed perimeter overlap 10 %

Single Extrusions

Minimum Extrusion Length 1.00 mm

Minimum Printing Width 50 %

Maximum Printing Width 200 %

Endpoint Extension Distance 0.20 mm

Ooze Control Behavior

☒ Only retract when crossing open spaces☒ Force retraction between layers☐ Minimum travel for retraction 3.00 mm☐ Perform retraction during wipe movement☒ Only wipe extruder for outer-most perimeters

Movement Behavior

☐ Avoid crossing outline for travel movements

Maximum allowed detour factor 3.0

Slicing Behavior

Non-manifold segments: ☐ Discard ☒ Heal☐ Merge all outlines into a single solid model

Hide Advanced

Select Models

OK

Cancel