SETTINGS TIED TO MATERIAL

			MATERIAL TYPE				
Tab	***Name***	***XML Parameter Name***	***ABS***	***HIPS***	***910***	***T-Glase***	***PLA***
Layer	First Layer Width %	FirstLayerWidthPercentage	110%	110%	130%	120%	120%
	First Layer Speed %	FirstLayerUnderspeed	30%	30%	20%	50%	30%
Temperature	Primary Extruder	GlobalExtruderTemperature	240	240	235	240	205
	Heated Bed	GlobalBedTemperature	100 *	90 *	90 *	60	60
Cooling	Per-Layer Fan Controls	FanSpeed <layer setpoints>	1:0%, 2:40%	1:0%, 2:40%	1:0%, 2:30%	1:0%, 2:40%	1:0%, 2:75%
	Speed Overrides, Adjust…	AdjustSpeedForCooling	Yes	Yes	Yes	Yes	Yes
	Speed Overrides, Adjust for layers…	MinSpeedLayerTime	15 sec	20 sec	5 sec	45 sec	20 sec
	Speed Overrides, Allow speed…	MinCoolingSpeedSlowdown	20%	20%	20%	15%	20%
	Fan Overrides, Increase?	IncreaseFanForCooling	Yes	Yes	Yes	Yes	Yes
	Fan Overrides, Increase fan speed for…	MinFanLayerTime	15 sec	20 sec	5 sec	45 sec	20 sec%
	Fan Overrides, Maximum cooling fan speed	MaxCoolingFanSpeed	60%	50%	40%	50%	100%
	Fan Overrides, Increase for Bridging?	IncreaseFanForBridging	Yes	Yes	Yes	Yes	Yes
	Fan Overrides, Bridging Fan Speed	BridgingFanSpeed	70%	60%	50%	60%	100%
Scripts	Starting Script	StartingGcode	LzB** 150/170	LzB** 150/170	LzB** 160/170	LzB** 140/160	LzB** 140/140
	Ending Script	EndingGcode	LzB*** 60/50	LzB*** 60/50	LzB*** 50/50	LzB*** 50/50	LzB*** 50/40
Other	Default Printing Speed (i.e., Infill)	DefaultSpeed (mm/s)	50	50	50	20	50
	Filament Diameter	FilamentDiameter	2.87	2.93	2.92	2.80	2.85
	Filament Price	FilamentPricePerKg	43	25	75	75	43
	Filament Density, g/cm^3	FilamentDensity	1.04	1.04	0.97	0.97	1.25

SETTINGS TIED TO QUALITY

			QUALITY LEVEL				
Tab	***Name***	***XML Parameter Name***	***High Detail***	***Medium***	***Fast***	***Clarity (Tglase)***	***Strgth (Tglase)***
Extruder	Nozzle Diameter	Diameter	0.5 mm	0.5 mm	0.5 mm	0.5mm	0.5mm
	Extrusion Multiplier	GlobalExtrusionMultiplier	0.95	97.00	97.00	1.00	0.95
	Extrusion Width	AutoWidth, Width	Auto (0.6mm)	Auto (0.6mm	Auto (0.6mm)	0.72mm	Auto (0.6mm)
	Retraction?	UseRetract	Yes	Yes	Yes	Yes	Yes
	Retraction Distance	RetractionDistance	1.5 mm	1.00 mm	1.00 mm	1.50 mm	1.00 mm
	Extra Restart Distance	ExtraRestartDistance	0.00	0.00	0.00	0.00	0.00
	Retraction Vertical Lift	RetractionZLift	0.15 mm	0.10 mm	0.10 mm	0.15 mm	0.10 mm
	Retraction Speed	RetractionSpeed	10 mm/s	10 mm/s	10 mm/s	10 mm/s	10 mm/s
	Coast?	UseCoasting	No	No	No	No	No
	Coasting Distance	CoastingDistance	0.10	0.10	0.10	0.10	0.10
	Wipe Nozzle?	UseWipe	Yes	Yes	Yes	Yes	Yes
	Wipe Distance	WipeDistance	1.50 mm	1.50 mm	1.50 mm	1.50 mm	1.50 mm
Layer	Primary Layer Height ****	LayerHeight	0.1801	0.2501	0.3001	0.5001	0.3001
	Top Solid Layers	TopSolidLayers	6	3	2	2	4
	Bottom Solid Layers	BottomSolidLayers	4	3	2	2	4
	Outline/Perimeter Shells	PerimeterOutlines	2	2	2	2	3
	First Layer Height %	FirstLayerHeightPercentage	200%	150%	125%	100%	125%
	Start Points - Random, Fast, SpecificXY	startPointOption	Random	Random	Fast	Random	Random
	Start Points - SpecificXY Location	startPointOriginX,Y	0,0	0,0	0,0	0,0	0,0
Infill	Interior Fill Percentage	InfillPercentage	35%	20%	15%	30%	85%
	Outline Overlap %	OutlineOverlapPercentage	20%	18%	15%	10%	15%
	Infill Extrusion Width	InfillExtrusionWidthPercentage	100%	100%	100%	110%	110%
	Minimum Infill Length	MinInfillLength	2.00 mm	3.00 mm	4.00 mm	3.00 mm	2.00 mm
Support	Support Infill Percentage	SupportInfillPercentage	40%	30%	20%	30%	30%
Other	Outline Underspeed %	OutlineUnderspeed	60%	75%	90%	75%	75%
	Solid Infill Underspeed %	SolidInfillUnderspeed	60%	75%	80%	50%	50%
	Support Structure Underspeed %	SupportUnderspeed	80%	80%	90%	80%	80%
Advanced	Only Retract when Crossing Open Spaces?	OnlyRetractWhenCrossingOutline	No	No	Yes	No	No
	Force Retraction between Layers?	RetractBetweenLayers	Yes	Yes	No	Yes	Yes
	Minimum travel for Retraction?	UseRetractionMinTravel	Yes	Yes	Yes	No	Yes
	Minimum travel for Retraction (mm)	RetractionMinTravel	1.5 mm	1.5 mm	1.5 mm	(NA)	1.5 mm

* Spec is 10C higher; my bed runs hot at higher temps, so temps above 70C are reduced 10C from spec. YMMV.

** Standard Lulzbot starting script with bed leveling; includes T1/T2, where T1=Retraction Temp and T2=Cleaning/Probing Temp

*** Standard Lulzbot ending script includes T3/T4, where T3=Highest Recommended Removal Temp and T4=Lowest Recommended Removal Temp

**** 0.0001 added to avoid layer boundary issue S3D has with some models