

3D Printing Failure

Part ID/File name	D_shot-glass
Material (PLA, ABS, etc.)	PLA
Distance between A and B on the template	7.5"
Distance between B and C on the template	7.5"
Failure type	Did not stick to print bed
Printer model	Athenall
Slicer used	Cura
Nozzle diameter, mm	0.4
Layer height, mm	0.25
Initial layer height, mm	0.25
Line width, mm	0.25
Infill line width, mm	0.4
Top/Bottom pattern, type	shell
Top/Bottom thickness, mm	0.8
Infill pattern, type	grid
Infill density, %	25
Support pattern, type	none
Support density, %	N/A
Printing temperature, °C	205
Material flow rate, %	100
Retraction distance, mm	10
Retraction speed, mm/s	100
Infill speed, mm/s	70
Outer wall speed, mm/s	70
Inner wall speed, mm/s	70
Support speed, mm/s	N/A
Travel speed, mm/s	70
Fan speed, %	60
Error height (at what height your print began to fail), mm	35
Error height (at what layer your print began to fail), layer number	142
Camera model (it will help us to retrieve the image distortions caused by your camera)	LGV40 cell phone

Firmware Coefficients

For Franklin						Max travel speed, mm/s
u (switch position), mm	v (switch position), mm	w (switch position), mm	e (coupling), steps/mm	Extrusion, %	Feedrate, %	
227.5	224.3	232.6	93	100	100	70

