

NEUTRONNICK DESIGNS

STIPPLE PACK

***** RULE NUMBER ONE 1 *****

KNOW HOW TO USE YOUR PRINTER! PRINT ENOUGH TO UNDERSTAND THE BASICS BETWEEN A GOOD PRINT AND A BAD PRINT!

THESE STIPPLE PACKS COME WITH 5-6 RANDOM STIPPLES. MORE TO COME IN THE FUTURE.

FILES CAN BE FOUND AT:

***** <https://odysee.com/@NeutronNick> *****
&
***** <https://cults3d.com/en/users/NeutronNick/creations> *****



***** PRINT SETTINGS USING CURA *****

*****SOME OF THESE SETTINGS ARE IN THE ADVANCED TAB IN CURA SO BE SURE TO HAVE THEM ALL VISIBLE BY CLICKING ALL UNDER YOUR SETTINGS TAB*****

Material: PLA+ Or CARBON FIBER NYLON. These Instructions However are for PLA+ ## I use Inland, Polymaker, ESun, 3d Fuels Pro, And Creality All With Great Results!

Nozzle Size = .4mm

PRINT

ORIENTATION!

** I PRINT THESE RAILS DOWN.** I Print in this orientation to obtain a cleaner underside as well as save time and material on the print.
* This file Can Also be printed rails Up for a cleaner inside. The orientation is up to you if your already experienced

QUALITY:

LAYER HEIGHT: I suggest using 0.16mm or 0.2mm. I prefer to use .16 for a cleaner underside and .2 For Speed.
####Leave Other Settings

WALLS:

WALL LINE COUNT: You should use a wall line count between 5 and 15 or even more in some cases. I choose to use around 8. Preview your Walls After Slicing
Z SEAM: SHARPEST CORNER
####Leave Other Settings

INFILL:

INFILL DENSITY: 100%
####Leave Other Settings

MATERIAL:

PRINTING TEMPERATURE: 215c
BUILD PLATE TEMPERATURE: 60c
####Leave Other Settings

SPEED:

PRINT SPEED: When using the ender 3 print between 45 and 55mm. If you have a Core XY Setup feel free to bump it up to around 80mm
####Leave Other Settings

RETRACTION:

ENABLE RETRACTION: (CHECK THE BOX)
RETRACTION DISTANCE: Between 6 and 6.5mm With no Direct Drive. CHAGE ACCORDINGLY
####Leave Other Settings

COOLING:

ENABLE PRINT COOLING: (CHECK THE BOX)
FAN SPEED: 100%
####Leave Other Settings

SUPPORT:

GENERATE SUPPORT: (CHECK THE BOX)
SUPPORT STRUCTURE: Tree
SUPPORT PLACEMENT: Touching Buildplate
SUPPORT PATTERN: ZigZag
SUPPORT DENSITY: 1.0%
SUPPORT X/Y DISTANCE: 1.3MM
####Leave Other Settings

BUILD PLATE

ADHESION:

BUILD PLATE ADHESION: I use a Brim To help prevent any warping. A glue stick will also work. Feel free to choose between brim or Skirt.
####Leave Other Settings

**LEAVE ALL OTHER SETTINGS ALONE
AND SAVE YOUR NEW PROFILE**