

Part	Main	Modifier	Width external wall	Width others	Flow external wall	Flow others	Wall count	Infill (Gyroid) +	Top	Bottom	Weight (L+R)	Nozzle temp	Bed temp		
R05.0	X		0.42 mm	0.38mm		65 %		1	4 %	2	2	24 g	230°C	60°C	
R05.1		X							6 %						
R05.2		X							12 %						
R04.0	X		0.42 mm	0.38mm		65 %		1	4 %	2	2	51 g	230°C	60°C	
R04.1		X							6 %						
R04.2		X							12 %						
R04.3		X							12 %						
R03.0	X		0.42 mm	0.38mm		65 %		1	4 %	2	2	92 g	230°C	60°C	
R03.1		X							6 %						
R03.2		X							12 %						
R03.3		X			2			1	12 %	2	2				
R03.Block		Support Blocker													
R02.0	X		0.42 mm	0.38mm		65 %		1	4 %			104 g	230°C	60°C	
R02.1		X						1	6 %						
R02.2		X							12 %						
R02.3		X						2	12 %	2	0				
R02.4		X						3	36 %	2	2				
R01.0	X		0.42 mm	0.38mm		65 %		1	4 %			114 g	230°C	60°C	
R01.1		X							6 %						
R01.2		X							12 %						
R01.3		X						2	24 %	3	3				
R01.4		X						3	36 %	2	2				
R01.Block		Support Blocker													
R00.0	X		0.42 mm	0.38mm		65 %		1	4 %			130 g	230°C	60°C	
R00.1		X							6 %						
R00.2		X							12 %						
R00.3		X						2	24 %	2	2				
R00.4		X						2	24 %	2	2				
SLW00.0	X			0.38 mm		60 %		1			2	16 g	230°C	60°C	Spiral mode in
SLW01.0	X			0.38 mm		65 %		1	6 %	2	2		230°C	60°C	
Covers	X			0.38mm				1	20 %	2	2				
Servo Horns	X			0.38mm				50							
Helling	X			0.4mm				2	20 %	4	4		230°C	60°C	