

Extrusion Test Structure



CNC Kitchen

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Summary

Meandering Structure to test the maximum extrusion speed of your printer

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Test the maximum printing speed of your extrusion system!

The model can be scaled in X and Y to fit your buildplate. There is a small notch every 2 mm to indicate a speed change.

GUIDE

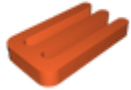
1. Load, orient and scale the part to your liking
2. Enable Vase printing mode
3. Enable brim
4. Set the layer height to 0.35 mm
5. Set the extrusion width to 0.7 mm
6. Set the speed for external perimeters to 100 mm/s
7. Limit the maximum flow under advanced filament settings to 10 mm³/s (this should lead to the whole structure being printed at 10 mm/s, which is nice to factorize)
8. Slice the part
9. Add a Custom G-Code every 2 mm where you change the speed multiplier. Start at a low value e.g. 60% (=6mm³/s) and increase it step by step

e.g.:

M220 S60 ;60% speed which means 6 mm³/s

M220 S220 ; 220% speed which means 22 mm³/s

Model files



speedteststructure.stl

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