

Basic ABS Settings for Taz with Repetier Host software (with Cura slicer)

Printer Settings

Printer: Taz

Connection Printer Extruder Printer Shape Scripts Advanced

Connector: Serial Connection Help

Port: COM5

Baud Rate: 115200

Transfer Protocol: Autodetect

Reset on Emergency Send emergency command and reconnect

Receive Cache Size: 127

Communication Timeout: 40 [s]

Use Ping-Pong Communication (Send only after ok)

The printer settings always correspond to the selected printer at the top. They are stored with every OK or apply. To create a new printer, just enter a new printer name and press apply. The new printer starts with the last settings selected.

OK Apply Cancel

Printer Settings

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Travel Feed Rate: 4800 [mm/min]

Z-Axis Feed Rate: 100 [mm/min]

Manual Extrusion Speed: 2 20 [mm/s]

Manual Retraction Speed: 30 [mm/s]

Default Extruder Temperature: 200 °C

Default Heated Bed Temperature: 55 °C

Check Extruder & Bed Temperature

Remove temperature requests from Log

Check every 3 seconds. [Slider]

Park Position: X: 0 Y: 0 Z min: 0 [mm]

Send ETA to printer display Go to Park Position after Job/Kill

Disable Extruder after Job/Kill Disable Heated Bed after Job/Kill

Disable Motors after Job/Kill Printer has SD card

Add to comp. Printing Time 8 [%]

Invert Direction in Controls for X-Axis Y-Axis Z-Axis Flip X and Y

OK Apply Cancel

Printer Settings

Printer: Taz

Connection Printer **Extruder** Printer Shape Scripts Advanced

Number of Extruder: 1

Max. Extruder Temperature: 280

Max. Bed Temperature: 120

Max. Volume per second: 12 [mm³/s]

Printer has a Mixing Extruder (one nozzle for all colors)

Extruder 1

Name:

Diameter: 0.5 [mm] Temperature Offset: 0 [°C]

Color:

Offset X: 0 Offset Y: 0 [mm]

OK Apply Cancel

Printer Settings

Printer: Taz

Connection Printer Extruder **Printer Shape** Scripts Advanced

Printer Type: Classic Printer

Home X: Min Home Y: Min Home Z: Min

X Min: 0 X Max: 298 Bed Left: 0

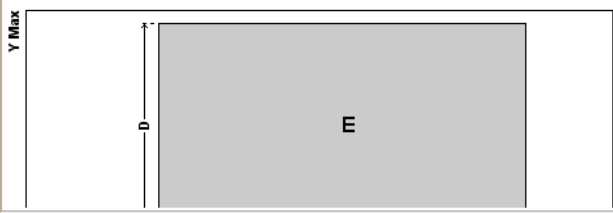
Y Min: 0 Y Max: 275 Bed Front: 0

Print Area Width: 298 mm

Print Area Depth: 275 mm

Print Area Height: 250 mm

The min and max values define the possible range of extruder coordinates. These coordinates can be negative and outside the print bed. Bed left/front define the coordinates where the printbed itself starts. By changing the min/max values you can even move the origin in the center of the print bed, if supported by firmware.



OK Apply Cancel

Object Placement Slicer Print Preview Manual Control SD Card

Slice with CuraEngine Kill Slicing

Slicer: CuraEngine Manager

Configuration

Print Settings:

Print Configuration: ABStest

Adhesion Type: None

Quality: 0.2 mm

Support Type: Everywhere

Speed:

Print Speed: 51 mm/s
Outer Perimeter Speed: 47 mm/s
Infill Speed: 82 mm/s

Infill Density 20%

Enable Cooling

Filament Settings:

Extruder 1: Default

CuraEngine is separate, external program developed by David Braam. For more informations visit <https://www.ultimaker.com>

CuraEngine Settings

Print Filament

ABStest

Speed and Quality Structures Extrusion G-Codes Advanced

Speed

	Slow	Fast	
Print:	40	60	[mm/s]
Travel:	150	150	[mm/s]
First Layer:	30	30	[mm/s]
Outer Perimeter	30	60	[mm/s]
Inner Perimeter	40	80	[mm/s]
Infill:	60	100	[mm/s]
Skin Infill:	30	60	[mm/s]

Quality

Default Quality: 0.2 mm

0.2 mm

Selected Quality Setting

Name:	0.2 mm	
Layer Height:	.2	[mm]
First Layer Height:	0.3	[mm]
First Layer Extrusion Width:	100	[%]

CuraEngine Settings

Default

Filament

Filament Diameter: [mm]

Flow: [%]

Temperature

Print Temperature: [°C]

Bed Temperature: [°C]

Cooling

Min. Fan Speed: [%]

Max. Fan Speed: [%]

Minimum Layer Time: [s]

CuraEngine only supports one extruder diameter and flow value, because it assumes identical extruders. If materials is no problem. For cooling the highest values of all extruders are used.

The screenshot shows the CuraEngine interface. On the left, a 3D model of a blue robot is displayed on a green grid. On the right, a sidebar contains various controls and information:

- Printer Settings: Easy Mode Emergency
- Object Placement | Slicer | Print Preview | Manual Control | SD Card
- Print | Edit G-Code
- Save to File | Save for SD Print
- Printing Statistics**
 - Estimated Printing Time: 2h:49m:57s
 - Layer Count: 167
 - Total Lines: 270700
 - Filament needed: 5214 mm
- Visualization**
 - Show Travel Moves
 - Show complete Code
 - Show Single Layer
 - Show Layer Range
 - First Layer:
 - Last Layer: