



SmartAgain® printing settings

Version 2023 QS01

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Nozzle	Suitable Lay height
0,4 mm	0,1mm; 0,15mm; 0,2mm; 0,3mm
0,8 mm	0,15mm; 0,2mm; 0,3 mm

		Standard Setting			
	Layer height	0,4mm Nozzle	0,8mm Nozzle	Remark	
1 Quality					
101 Layer height	mm	0,2	0,3	Keep this value for all nozzles/layer heights	
102 Initial layer height	mm	0,2	0,2		
103 Line width	mm	0,4	0,8		
104 Support line width	mm	0,4	0,4	Keep this value for all nozzles/layer heights	
105 Initial layer line width	%	100	100		
2 Walls					
201 Wall thickness	mm	0,8	0,8	Especially important for overhangs	
202 Wall-line count		2	1		
203 Outerwall wiper distance	mm	0,2	0,3		
204 Optimize wall printing order		Yes	Yes		
205 Outer before innerwalls		No	No		
206 Compensate outer wall overlaps		Yes	Yes		
207 Compensate inner wall overlaps		Yes	Yes		
208 Horizontal expansion	mm	0	0		
209 Initial layer horizontal expansion	mm	0	0		
3 Top/Bottom					
301 Top surface skin layers		1	1	minimal 3 layers, max 6 layers	
302 Top thickness	mm	1	1		
303 Bottome thickness	mm	1	1		
304 Top/bottom pattern		Lines	Lines	minimal 3 layers, max 6 layers	
305 Top/bottom line directions		[]	[]		
306 Extra skin wall count		1	1		
307 Skin overlap percentage	%	10	10	45° - 90°	
308 Maximum skin angle for expansion	°	90	90		
309 Maximum skin width for expansion	mm	0	0		
4 Infill					
401.1 Infill density	%	40	40	For demonstration models only	
402.1 Infill pattern		Gyroid	Gyroid		
402.2 Infill pattern		Lightening	Lightening		
403 Connect infill lines		No	No		
404 Infill line direction		[]	[]		
405 Infill overlap percentage	%	0	0		
406 Infill wipe distance	mm	0,2	0,3		
408 Infill before walls		Yes	Yes		
5 Material					
501 Printing temperature	°C	250	250		245°C - 265°C
502 Build plate temeprature	°C	35	35	Some low-cost printers require calibration 80% of normal printing flow	
503 Flow	%	100	100		
504 Support Flow	%	80	80		
6 Speed					
601 Print speed	mm/s	30	30	Max: 0,4 nozzle 100mm/s; 0,8 nozzle 80 mm/s	
602 Infill speed	mm/s	40	40		
603 Outer wall speed	mm/s	30	30	Max: 0,4 nozzle 90mm/s; 0,8 nozzle 60 mm/s	
604 Inner wall speed	mm/s	30	30	Max: 0,4 nozzle 100mm/s; 0,8 nozzle 80 mm/s	
605 Top/bottom speed	mm/s	30	30	Max: 0,4 nozzle 100mm/s; 0,8 nozzle 80 mm/s	
606 Initial layer speed	mm/s	30	30	Keep this value for all nozzles/layer heights	
607 Skirt/Brim speed	mm/s	30	30	Keep this value for all nozzles/layer heights	
608 Equalize filament flow		Yes	Yes		
609 Maximize speed for flow equalization	mm/s	150	150		
610 Enable acceleration control		Yes	Yes	For normal quality prints disable this function	
611 Print acceleration	mm/s ²	3000	3000		
612 Outer wall acceleration	mm/s ²	500	500		
613 Inner wall acceleration	mm/s ²	1000	1000		



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614	Top/Bottom acceleration	mm/s ²	500	500	
615	Support acceleration	mm/s ²	1000	1000	
616	Travel acceleration	mm/s ²	4000	4000	
617	Initial layer acceleration	mm/s ²	500	500	
618	Skirt / brim acceleration	mm/s ²	500	500	
619	Enable jerk control	Yes	Yes	For normal quality prints disable this function	
620	Print jerk	mm/s	25		25
621	Infill Jerk	mm/s	25		25
622	Outer wall jerk	mm/s	5		5
623	Inner wall jerk	mm/s	10		10
624	Top/Bottom jerk	mm/s	5		5
625	Support jerk	mm/s	15		15
626	Travel jerk	mm/s	30		30
627	Initial layer jerk	mm/s	5		5
628	Initial layer print jerk	mm/s	5		5
629	Initial layer travel jerk	mm/s	6	6	
630	Skirt/Brim jerk	mm/s	5	5	
7 Travel					
701	Enable reaction	Yes	Yes		
702	Retract at layer change	No	No		
703	Retraction distance Bowden extruders	mm	4,5	4,5	
704	Retraction distance Direct extruders	mm	2,00	2,00	
705	Retraction speed	mm/s	35	35	
706	Retraction extra prime amount	mm ³	0	0	
707	Retraction minimum travel	mm	0,8	1,6	
708	Maximum retraction count		25	25	
709	Minimum extrusion distance window	mm	0,8	1,6	
710	Limit support retraction	Yes	Yes		
711	Combing mood	Not on outer surface			
712	Retract before outerwall	No	No		
713	Avoid print parts when travelling	Yes	Yes		
714	Avoid support parts when travelling	Yes	Yes		
715	Z hop when retracted	No	No		
8 Cooling					
801	Enable print cooling	Yes	Yes		
802	Regular fan speed	%	2	5	
803	Max fan speed	%	100	100	
804	Initial fan speed	%	0	0	
805	Regular/max fan speed threshold	s	10	15	
806	Regular fan speed at height	mm	0,2	0,2	
807	Minimal layer time	s	6	6	
808	Minimal speed	mm/s	5	5	
809	Lift head	No	No		
9 Support					
901	Generate support	No	No	Yes, when printing with support	
902	Support placement	everywhere	everywhere		
903	Support overhang angle	°	55		55
904	Support pattern	Zig zag	Zig zag		
905	Connect support zig zags	No	No		
906	Support density	%	10		10
907	Support infill line directions	[]	[]		
908	Enable support brim	Yes	Yes		
909	Support brim width	mm	12		12
910	Support top distance	mm	0,2		0,3
911	Support bottom distance	mm	0,4		0,3
912	Support XY distance	mm	0,8		1,0
913	Support distance priority	Z overrides XY	Z overrides XY		



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		Standard Setting		
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914	Minimum support XY distance	mm	0,4	Increase this value for low-cost printers
915	Support stair step height	mm	0,2	
916	Enable support roof	Yes	Yes	
917	Support roof density	%	100	
918	Support roof line pattern	Lines	Lines	
919	Support roof line direction	[]	[]	
920	Use towers	Yes	Yes	
921	Tower roof angle	°	65	65
10 Build plate adhesion				
1001	Enable prime blob	Yes	Yes	
1002	Build plate adhesion type	Brim	Brim	
1003	Skirt/brim minimal length	mm	250	
1004	Brim width	mm	10	8 - 12mm
1005	Brim replaces support	Yes	Yes	
1006	Brim only on outside	No	No	