Cura 3.5.1 settings for an Ultimaker 2+
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Print Setup   Recommended | Custom |

Profile: p398DLP_UM2+_set_nozzle – 0.... ∨

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▬ **Quality** ∨

Layer Height	⬯ 0.1	mm
Initial Layer Height	⬯ 0.4	mm
Line Width	0.53	mm
Wall Line Width	0.53	mm
Outer Wall Line Width	0.53	mm
Inner Wall(s) Line Width	0.53	mm
Top/Bottom Line Width	0.53	mm
Infill Line Width	0.53	mm
Skirt/Brim Line Width	0.53	mm
Initial Layer Line Width	100.0	%

⧖ **Shell** ∨

Wall Thickness	1.59	mm
Wall Line Count	3	
Outer Wall Wipe Distance	0.3	mm
Top Surface Skin Layers	0	
Top/Bottom Thickness	1.2	mm
Top Thickness	1.2	mm
Top Layers	12	
Bottom Thickness	1.2	mm
Bottom Layers	12	
Top/Bottom Pattern	Lines	∨
Bottom Pattern Initial Layer	Lines	∨
Top/Bottom Line Directions	[ ]	
Outer Wall Inset	0.035	mm
Optimize Wall Printing Order	✓	
Outer Before Inner Walls	☐	
Alternate Extra Wall	☐	

Compensate Wall Overlaps	✓	
Compensate Outer Wall Overlaps	✓	
Compensate Inner Wall Overlaps	✓	
Minimum Wall Flow 🔗	0	%
Fill Gaps Between Walls	Everywhere ⌄	
Filter Out Tiny Gaps	✓	
Print Thin Walls		
Horizontal Expansion	0	mm
Initial Layer Horizontal Expansion	0	mm
Z Seam Alignment	Sharpest Corner ⌄	
Seam Corner Preference	Hide Seam ⌄	
Ignore Small Z Gaps	✓	
Extra Skin Wall Count	1	
Enable Ironing		
⊠ Infill	⌄	
Infill Density	20	%
Infill Line Distance	5.3	mm
Infill Pattern	Grid ⌄	
Connect Infill Lines		
Infill Line Directions	[ ]	
Infill X Offset	0	mm
Infill Y Offset	0	mm
Infill Line Multiplier	1	
Extra Infill Wall Count	0	
Infill Overlap Percentage	10	%
Infill Overlap	0.053	mm
Skin Overlap Percentage	5	%
Skin Overlap	0.0265	mm

Infill Wipe Distance	0.1325	mm
Infill Layer Thickness	0.1	mm
Gradual Infill Steps	0	
Infill Before Walls	✓	
Minimum Infill Area	0	mm²
Infill Support	☐	
Skin Removal Width	1.59	mm
Top Skin Removal Width	1.59	mm
Bottom Skin Removal Width	1.59	mm
Skin Expand Distance	1.59	mm
Top Skin Expand Distance	1.59	mm
Bottom Skin Expand Distance	1.59	mm
Maximum Skin Angle for Expansion	90	°
Minimum Skin Width for Expansion	0.0	mm

||||| Material ⌄

Initial Layer Flow	100	%
Enable Retraction	✓	
Retract at Layer Change	✓	
Retraction Extra Prime Amount	0	mm³
Retraction Minimum Travel	1.06	mm
Maximum Retraction Count	90	
Minimum Extrusion Distance Window	6.5	mm
Nozzle Switch Retraction Distance	20	mm
Nozzle Switch Retraction Speed	20	mm/s
Nozzle Switch Retract Speed	20	mm/s
Nozzle Switch Prime Speed	20	mm/s

⏱ Speed ⌄

Print Speed	55	mm/s

Infill Speed	55	mm/s
Wall Speed	40	mm/s
Outer Wall Speed	25	mm/s
Inner Wall Speed	40	mm/s
Top/Bottom Speed	20	mm/s
Travel Speed	120	mm/s
Initial Layer Speed fx	15	mm/s
Initial Layer Print Speed fx	15	mm/s
Initial Layer Travel Speed	32.7273	mm/s
Skirt/Brim Speed 🔗	15	mm/s
Maximum Z Speed	0	mm/s
Number of Slower Layers 🔗	2	
Equalize Filament Flow	☐	
Enable Acceleration Control 🔗	☐	
Enable Jerk Control 🔗	☐	

☷ Travel ⌄

Combing Mode 🔗	All ⌄	
Max Comb Distance With No Retract	0	mm
Retract Before Outer Wall 🔗	☐	
Avoid Printed Parts When Traveling	✓	
Avoid Supports When Traveling	☐	
Travel Avoid Distance	0.7812	mm
Layer Start X	0.0	mm
Layer Start Y	0.0	mm
Z Hop When Retracted	✓	
Z Hop Only Over Printed Parts	✓	
Z Hop Height	2	mm

❋ Cooling ⌄

Enable Print Cooling	✓	
Fan Speed	100.0	%
Regular Fan Speed	100.0	%
Maximum Fan Speed	100.0	%
Regular/Maximum ... Speed Threshold	10	s
Initial Fan Speed	0	%
Regular Fan Speed at Height	0.4	mm
Regular Fan Speed at Layer	2	
Minimum Layer Time	5	s
Minimum Speed	10	mm/s
Lift Head		

◣ Support   ⌄

Generate Support	🔗	

÷ Build Plate Adhesion   ⌄

Build Plate Adhesion Type	🔗	Brim ⌄
Skirt/Brim Minimum Length		250 mm
Brim Width	🔗	8.0 mm
Brim Line Count	🔗	16
Brim Only on Outside	🔗	

⃟ Dual Extrusion   ‹

◿ Mesh Fixes   ⌄

Union Overlapping Volumes	✓	
Remove All Holes		
Extensive Stitching		
Keep Disconnected Faces		
Merged Meshes Overlap	0.15	mm
Remove Mesh Intersection	🔗	
Remove Empty First Layers	🔗	✓

Merged Meshes Overlap		0.15	mm
Remove Mesh Intersection	🔗	☐	
Remove Empty First Layers	🔗	✓	

⌛ Special Modes ⌄

Print Sequence	🔗	All at Once ⌄
Mold		☐
Surface Mode		Normal ⌄
Spiralize Outer Contour	🔗	☐

⚗ Experimental ⌄

Tree Support	🔗	☐	
Slicing Tolerance		Middle ⌄	
Infill Travel Optimization		☐	
Minimum Polygon Circumference	🔗	1.0	mm
Maximum Resolution		0.01	mm
Maximum Travel Resolution		0.0218	mm
Enable Draft Shield	🔗	☐	
Make Overhang Printable		☐	
Enable Coasting		☐	
Alternate Skin Rotation		☐	
Spaghetti Infill		☐	
Fuzzy Skin		☐	
Flow rate compens... extrusion offset	🔗	0	mm
Flow rate compensation factor	🔗	100	%
Wire Printing	🔗	☐	
Use adaptive layers	🔗	☐	
Overhanging Wall Angle		90	°
Overhanging Wall Speed		100	%
Enable Bridge Settings	🔗	☐	