



FILAMENTS

POLYPLUS

POLYMAX

POLYFLEX

POLYWOOD

SOFTWARE + SETTINGS



PRINTER:
Makerbot Replicator Mini



PERIMETER SPEED:
Default (20mm/s)



PRINTING SOFTWARE:
Makerbot Desktop Beta



RETRACTION: Default
(Speed= 25mm/s, Distance= 1.3mm)



PRINT TEMP:
230°C



FLOW RATE:
Default (1.07)



PRINT SPEED:
45mm/s



HEAT BED TEMP:
None



INFILL SPEED:
45mm/s



FAN CONTROL: Default
(Fan Power= 0.1- 0.5, Fan Layer= 1)

TIPS + TRICKS

- 1. Print Temp:** The most important factor for PolyFlex in the Mini is the temperature. Because of the smart extruder in the Mini, our flexible filament needs a higher temperature to avoid jamming.
- 2. Load Filament:** We recommend loading the filament in the extruder by hand as the temperature of "Load Filament" in the smart extruder is not very high and cannot be adjusted.
- 3. Printer Bed Height:** To ensure a suitable distance between extruder and bed, place a piece of paper (100g) in between the extruder and bed. Paper should not be loose but should not tear when being pulled from between them