

PRINTING OF KIMYA'S 3D FILAMENTS ON THE ULTIMAKER S5 (SLICER CURA)

MAIN SETTINGS	3D FILAMENTS PLA-R	3D FILAMENTS ABS-ESD NATURAL
Platform	Glass Platform with blue tape 3M (ref.2090)	Glass Platform
Printer	Ultimaker S5 printer	Ultimaker S5 printer
Nozzle	0.4mm Brass Nozzle (Print Core AA)	0.4mm Brass Nozzle (Print Core AA)
Default Printing Temperature	205 °C	260 °C
Build Plate Temperature	60°C	85 °C
Cooling – Fan Control	Initial Fan Speed : 0 % Regular Fan Speed : 100 % (layers ≥ 3)	Initial Fan Speed : 0 % Regular Fan Speed : 2 % (layers ≥ 6)
Infill Speed	70 mm/s	40 mm/s
Wall Speed	55 mm/s	30 mm/s
Top / Bottom Speed	40 mm/s	30 mm/s
Recommended Layer Height	0.2 mm	0.1 mm
Printing Temperature Initial Layer	195 °C	245 °C
Initial Layer Height	0,20 mm	0,27 mm
Initial Layer Line Width	120 %	120 %
Initial Layer Print Speed	20 mm/s	20 mm/s
Flow	100 %	100 %
Infill Overlap Percentage	0%	0%

Ultimaker S5

Extruder 1 Extruder 2

Material: PLA R KIMYA

Print core: AA 0.4

[Check compatibility](#)

Print Setup Recommended Custom

Layer Height: 0.06 0.1 0.15 **0.2** 0.3 0.4

Print Speed: Slower **●** Faster

Ultimaker S5

Extruder 1 Extruder 2

Material: ABS ESD NAT

Print core: AA 0.4

[Check compatibility](#)

Print Setup Recommended Custom

Layer Height: 0.06 **0.1** 0.15 0.2 0.3 0.4

Print Speed: Slower **●** Faster

For your information, these settings are examples of general settings. These settings must be modified and optimized for each model. Don't hesitate to come back to us if need.