

3D PLUS

Parameter	Value
Material	CW2000
Initial Time (s)	10
Attach Floor	50
Thickness (μm) 10	2.5
Thickness (μm) 25	4.0
Thickness (μm) 35	5.0
Thickness (μm) 50	6.0
Initial Layer Overlift (mm)	2.0
Initial Layer Breathe (s)	0.0
Initial Layer Settle (s)	3.0
Attach Layer Overlift (mm)	0.2
Attach Layer Breathe (s)	0.0
Attach Layer Settle (s)	0.5
Z-Axis Compensation (Up)	0.0
Overad Size Compensation (Z)	0.0