

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

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

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.

**Ultimaker S5**

Extruder **1** Extruder **2**

Material: PLA R KIMYA

Print core: AA 0.4

[Check compatibility](#)

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**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](#)

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**Print Setup** Recommended Custom

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

Print Speed: Slower ● Faster

## PRINTING OF KIMYA'S 3D FILAMENTS ON THE ULTIMAKER 3 EXTENDED PRINTER USING THE CURA SLICER (V.3.2.1)

MAIN SETTINGS	3D FILAMENTS PLA-S	3D FILAMENTS PLA-HI	3D FILAMENTS PS
<b>Platform</b>	Glass Platform with blue tape 3M (Réf. 2090)	Glass Platform with blue tape 3M (Réf. 2090)	Glass platform with adhesion product (DIMAFIX) Use of a Brim
<b>Nozzle</b>	Brass	Brass	Brass
<b>Extruder Temperature</b>	205 °C	230 °C	240 °C
<b>Bed Temperature</b>	60 °C	60 °C	80 °C
<b>Cooling – Fan Control</b>	Layers 1 to 4 : Fan speed 0 % Layers ≥ 5 : Fan speed 100 %	Layers 1 to 4 : Fan speed 0 % Layers ≥ 5 : Fan speed 100 %	Layers 1 à 6 : Fan speed 0 % Layers ≥ 7 : Fan speed 5 %
<b>Infill speed</b>	70 mm/s	70 mm/s	60 mm/s
<b>Wall printing speed</b>	35 mm/s	35 mm/s	45 mm/s
<b>Top/Bottom printing speed</b>	35 mm/s	35 mm/s	35 mm/s
<b>First Layer temperature</b>	210 °C	240 °C	245 °C
<b>First Layer Height</b>	Example : 0.27 mm (in the case of a layer height of 0.2 mm)	Example : 0.27 mm (in the case of a layer height of 0.2 mm)	Example : 0.27 mm (in the case of a layer height of 0.2 mm)
<b>First Layer Width</b>	100 %	100 %	100 %
<b>First Layer Speed</b>	20 mm/s	20 mm/s	20 mm/s
<b>Flow rate</b>	100 %	110 %	100 %
<b>Filling line width</b>	Example : 0.5 mm (for Print Core AA of 0,4 mm)	Example : 0.5 mm (for Print Core AA of 0,4 mm)	Example : 0.5 mm (for Print Core AA of 0,4 mm)
<b>Shell line width</b>	Example : 0.35 mm (for Print Core AA of 0,4 mm)	Example : 0.35 mm (for Print Core AA of 0,4 mm)	Example : 0.35 mm (for Print Core AA of 0,4 mm)
<b>Top/bottom line width</b>	Example : 0.35 mm (for Print Core AA of 0,4 mm)	Example : 0.35 mm (for Print Core AA of 0,4 mm)	Example : 0.35 mm (for Print Core AA of 0,4 mm)
<b>Infill overlap %</b>	0%	0%	0%

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## PRINTING OF KIMYA'S 3D FILAMENTS ON THE ULTIMAKER 3 EXTENDED PRINTER USING THE CURA SLICER (V.3.2.1)

MAIN SETTINGS	3D FILAMENTS ABS CARBON	3D FILAMENTS ABS KEVLAR	
<b>Platform</b>	Glass platform with adhesion product (DIMAFIX) Use a raft (Raft Air Gap: 0.15mm)	Glass platform with adhesion product (DIMAFIX) Use a raft (Raft Air Gap: 0.15mm)	
<b>Printer Cover</b>	With Printer Cover	With Printer Cover	
<b>Nozzle</b>	0.4mm Hardened Steel (with Hardcore)	0.4mm Hardened Steel (with Hardcore)	
<b>Extruder Temperature</b>	240 °C	240 °C	
<b>Bed Temperature</b>	80 °C	80 °C	
<b>Cooling – Fan Control</b>	Layers 1 to 5 : Fan speed 0 % Layers ≥ 6 : Fan speed 5 %	Layers 1 to 5 : Fan speed 0 % Layers ≥ 6 : Fan speed 5 %	
<b>Infill speed</b>	60 mm/s	60 mm/s	
<b>Wall printing speed</b>	45 mm/s	45 mm/s	
<b>Top/Bottom printing speed</b>	35 mm/s	35 mm/s	
<b>First Layer temperature</b>	235 °C	235 °C	
<b>First Layer Height</b>	Example : 0.27 mm (in the case of a layer height of 0.2 mm)	Example : 0.27 mm (in the case of a layer height of 0.2 mm)	
<b>First Layer Width</b>	100 %	100 %	
<b>First Layer Speed</b>	20 mm/s	20 mm/s	
<b>Flow rate</b>	100 %	110 %	
<b>Filling line width</b>	Example : 0.5 mm (for Print Core AA of 0,4 mm)	Example : 0.5 mm (for Print Core AA of 0,4 mm)	
<b>Shell line width</b>	Example : 0.35 mm (for Print Core AA of 0,4 mm)	Example : 0.35 mm (for Print Core AA of 0,4 mm)	
<b>Top/bottom line width</b>	Example : 0.35 mm (for Print Core AA of 0,4 mm)	Example : 0.35 mm (for Print Core AA of 0,4 mm)	
<b>Infill overlap %</b>	0%	0%	

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## PRINTING OF KIMYA'S 3D FILAMENTS ON THE ULTIMAKER 3 EXTENDED PRINTER USING THE CURA SLICER (V.3.2.1)

MAIN SETTINGS	3D FILAMENTS TPU-92A	3D FILAMENTS PETG	3D FILAMENTS TPC-91A
<b>Platform</b>	Glass Platform with blue tape 3M (Réf. 2090)	Glass Platform with blue tape 3M (Réf. 2090)	Glass Platform with blue tape 3M (Réf. 2090)
<b>Nozzle</b>	Brass	Brass	Brass
<b>Extruder Temperature</b>	212 °C	260 °C	250 °C
<b>Bed Temperature</b>	70 °C	60 °C	60 °C
<b>Cooling – Fan Control</b>	Layers 1 to 6 : Fan speed 20 % Layers ≥ 7 : Fan speed 100 %	Layers 1 to 2 : Fan speed 0 % Layers ≥ 3 : Fan speed 70 %	Layers 1 to 5 : Fan speed 0 % Layers ≥ 6 : Fan speed 20 %
<b>Infill speed</b>	25 mm/s	70 mm/s	30 mm/s
<b>Wall printing speed</b>	25 mm/s	35 mm/s	30 mm/s
<b>Top/Bottom printing speed</b>	25 mm/s	35 mm/s	30 mm/s
<b>First Layer temperature</b>	212 °C	255 °C	252 °C
<b>First Layer Height</b>	Example : 0,27 mm (in the case of a layer height of 0.2 mm)	Example : 0,27 mm (in the case of a layer height of 0.2 mm)	Example : 0,27 mm (in the case of a layer height of 0.2 mm)
<b>First Layer Width</b>	100 %	120 %	120 %
<b>First Layer Speed</b>	18 mm/s	35 mm/s	22 mm/s
<b>Flow rate</b>	140 %	90 %	106 %
<b>Filling line width</b>	Example : 0,38 mm (for a 0.4mm Print Core AA)	Example : 0,4 mm (for a 0.4mm Print Core AA)	Example : 0,38 mm (for a 0.4mm Print Core AA)
<b>Shell line width</b>	Example : 0,28 mm (for a 0.4mm Print Core AA)	Example : 0,35 mm (for a 0.4mm Print Core AA)	Example : 0,38 mm (for a 0.4mm Print Core AA)
<b>Top/bottom line width</b>	Example : 0,38 mm (for a 0.4mm Print Core AA)	Example : 0,35 mm (for a 0.4mm Print Core AA)	Example : 0,38 mm (for a 0.4mm Print Core AA)
<b>Infill overlap %</b>	60%	0%	0%

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## PRINTING OF KIMYA'S 3D FILAMENTS ON THE ULTIMAKER 2 PRINTER USING THE CURA SLICER

MAIN SETTINGS	3D FILAMENTS ABS CARBON KIMYA	3D FILAMENTS ABS KEVLAR KIMYA	
<b>Platform</b>	Glass platform with 3DLAC lacquer Use of a Brim	Glass platform with 3DLAC lacquer Use of a Brim	
<b>Nozzle</b>	Steel	Steel	
<b>Extruder Temperature</b>	260 °C	260 °C	
<b>Bed Temperature</b>	100 °C	100 °C	
<b>Nozzle diameter</b>	2.85 mm	2.85 mm	
<b>Cooling – Fan Control</b>	30%	30%	
<b>Flow rate</b>	100%	100%	
<b>Infill speed</b>	60 mm/s	60 mm/s	
<b>Wall printing speed</b>	30 mm/s	30 mm/s	
<b>Top/Bottom printing speed</b>	30 mm/s	30 mm/s	
<b>Filling line width</b>	0.4 mm	0.4 mm	
<b>Shell line width</b>	0.3 mm	0.3 mm	
<b>Top/bottom line width</b>	0.4 mm	0.4 mm	

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