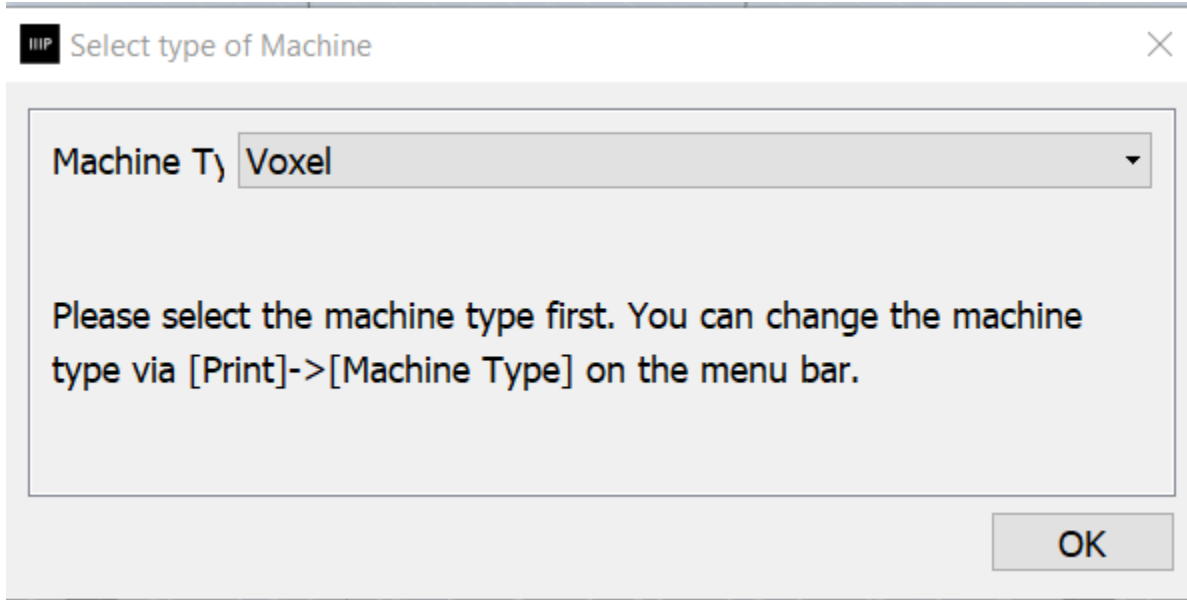


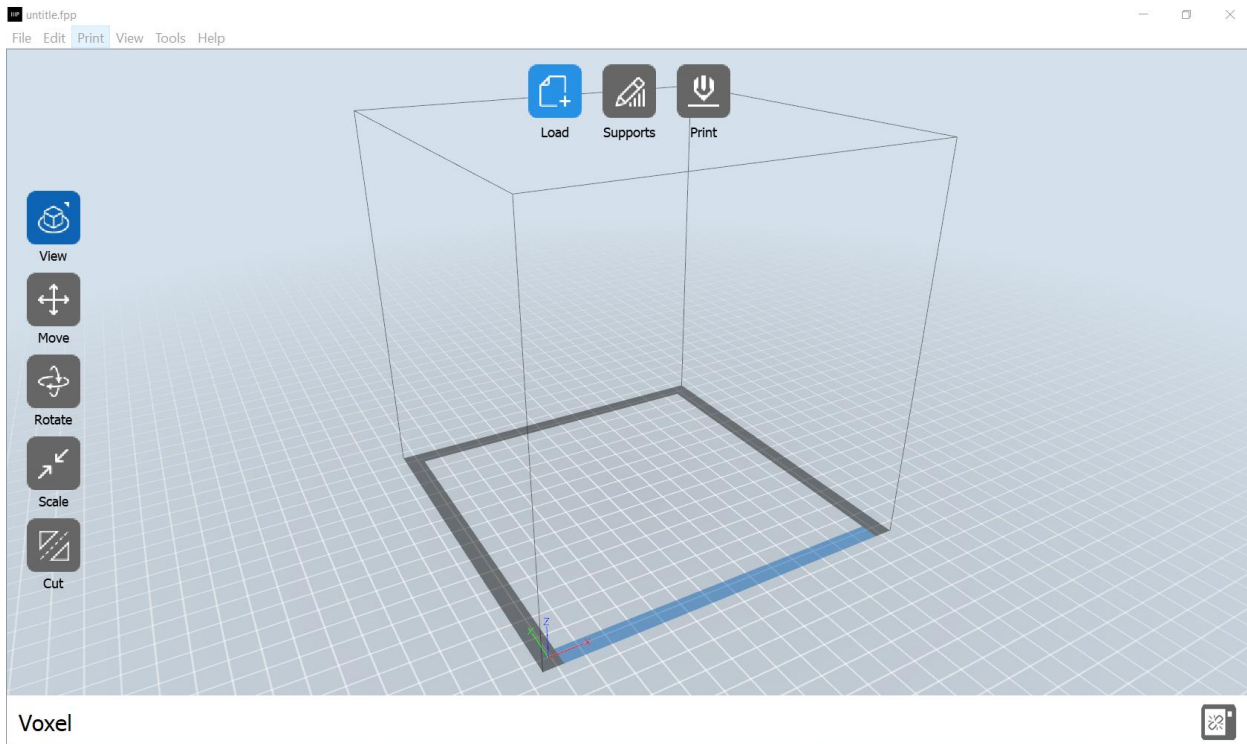
Monoprice Voxel/Vector Printers Setup and Settings

Material: TPU Flexible Filament

1. Choose Printer: Voxel



2. Software Overview



3. TPU Settings

Material Type: PLA

Supports: Disable

Raft Disable

I want to:	<input checked="" type="checkbox"/> Preview	<input type="checkbox"/> Print When Slice Done
Machine Type:	Voxel	
Material Type:	PLA	
Supports:	Disable	
Raft:	Disable	
Resolution:	<input type="radio"/> Low (Faster)	<input type="checkbox"/> Wall
	<input checked="" type="radio"/> Standard	<input type="checkbox"/> Brim
	<input type="radio"/> High (Slower)	
	<input type="radio"/> Hyper	
	More Options >>	

Layer Height: .2

Layer Height	Shells	Infill	Speed	Temperature	Others
Layer Height:	0.20mm				
First Layer Height:	0.27mm				

Shells: Perimeter, Top Solid and Bottom Solid = 2

Layer Height	Shells	Infill	Speed	Temperature	Others
Perimeter Shells:	2				
Top Solid Layers:	2				
Bottom Solid Layers:	2				

Infill: <=15%

Layer Height	Shells	Infill	Speed	Temperature	Others
Fill Density:	15%				
Fill Pattern:	Hexagon				
Combine Infill:	Every 2 Layers				

Print Speed: 20mm/s

Layer Height	Shells	Infill	Speed	Temperature	Others
Print Speed:	20mm/s				
Travel Speed:	80mm/s				

Temperature

Extruder: 220 C

Platform: 60 C

Layer Height	Shells	Infill	Speed	Temperature	Others
Extruder:	220°C				
Platform:	60°C				