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1 {
2   "comment" : [
3     "This is a custom profile for MakerBot Slicer. Editing it will modify your",
4     "slice settings. For documentation on MakerBot Slicer parameters, see here:",
5     "http://www.makerbot.com/support/makerware/documentation/slicer"
6   ],
7   "version": "3.0.0",
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9   "layerHeight": 0.20,
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11  "layerWidthMinimum": 0.4,
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14  "startX": -110.4,
15  "startY": -74.0,
16  "startZ": 0.2,
17  "defaultExtruder": 0,
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19  "rapidMoveFeedRateXY": 100,
20  "rapidMoveFeedRateZ": 23,
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22  "minLayerDuration": 5.0,
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28  "dynamicSpeedSlowdownRatio": 0.3,
29  "doDynamicSpeedGradually": true,
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31  "dynamicSpeedTransitionShape": 0.6,
32  "doDynamicSpeedOutermostShell" : true,
33  "doDynamicSpeedInteriorShells" : false,
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35  "doSplitLongMoves": true,
36  "splitMinimumDistance": 0.4,
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39  "extruderTemp1": 230,
40  "platformTemp": 0,
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43  "shellsLeakyConnections": false,
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49  "roofAnchorMargin": 0.4,
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51  "floorLayerCount_disabled": 4,
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53  "coarseness": 0.0001,
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55  "sparseInfillPattern": "hexagonal",
56  "infillDensity": 0.1,
57  "infillOrientationOffset": 0,
58  "infillOrientationInterval": 90,
59  "infillOrientationRange": 90,
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61  "gridSpacingMultiplier": 1.0,
62  "solidFillOrientationOffset" : -45,
63  "solidFillOrientationInterval": 90,
64  "solidFillOrientationRange": 90,
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66  "doBacklashCompensation": false,
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68  "backlashFeedback": 0.9,
69  "backlashX": 0.0,
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72  "doBridging": true,
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76 "bridgeSpacingMultiplier": 1.0,
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78 "doExternalSpurs": true,
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81 "minSpurLength": 0.4,
82 "minSpurWidth": 0.12,
83 "spurOverlap": 0.001,
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85 "doRaft": true,
86 "defaultRaftMaterial": 0,
87 "doMixedRaft": true,
88 "raftAligned": true,
89 "raftBaseAngle": 0,
90 "raftBaseDensity": 0.7,
91 "raftBaseLayers": 1,
92 "raftBaseRunGapRatio": 0.8,
93 "raftBaseRunLength": 15.0,
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96 "raftInterfaceAngle": 45,
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104 "raftSurfaceLayers": 2,
105 "raftSurfaceThickness": 0.27,
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115 "purgeBucketSide" : 4.0,
116 "purgeWallXLength" : 30,
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118 "anchorWidth": 2.0,
119 "anchorExtrusionAmount": 5.0,
120 "anchorExtrusionSpeed": 2.0,
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122 "doSupport": false,
123 "defaultSupportMaterial": 0,
124 "doMixedSupport": true,
125 "doSupportUnderBridges": false,
126 "supportAligned": true,
127 "supportLeakyConnections": true,
128 "supportDensity": 0.2,
129 "supportExtraDistance": 0.5,
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131 "supportModelSpacing": 0.4,
132 "supportExcessive": false,
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134 "doFanCommand": true,
135 "fanLayer": 1,
136 "weightedFanCommand": -1,
137 "doFanModulation": false,
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141 "doPrintProgress": true,
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155     "preOozeFeedstockDistance": 0.1,
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157     "firstLayerRaftExtrusionProfile": "firstlayerraft",
158     "infillsExtrusionProfile": "infill",
159     "insetsExtrusionProfile": "insets",
160     "nozzleDiameter": 0.4,
161     "outlinesExtrusionProfile": "outlines",
162     "raftBaseExtrusionProfile": "raftbase",
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164     "retractDistance": 1.3,
165     "retractRate": 25,
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167     "toolchangeRetractRate" : 6.0,
168     "toolchangeRestartDistance" : 18.5,
169     "toolchangeRestartRate" : 6.0
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173     "feedDiameter": 1.77,
174     "feedstockMultiplier": 0.93,
175     "oozeFeedstockDistance": 0.1,
176     "preOozeFeedstockDistance": 0.1,
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178     "firstLayerRaftExtrusionProfile": "firstlayerraft",
179     "infillsExtrusionProfile": "infill",
180     "insetsExtrusionProfile": "insets",
181     "nozzleDiameter": 0.4,
182     "outlinesExtrusionProfile": "outlines",
183     "raftBaseExtrusionProfile": "raftbase",
184     "restartExtraDistance": 0.0,
185     "retractDistance": 1.3,
186     "retractRate": 25,
187     "toolchangeRetractDistance" : 19.0,
188     "toolchangeRetractRate" : 6.0,
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190     "toolchangeRestartRate" : 6.0
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193 "extrusionProfiles": {
194     "bridges": {
195         "feedrate": 40,
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223 }
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