

This is a reference list of 3D printing parameter settings used for printing with TPU A95 flexible filament for the Prusa iMK3S+ printer.

Please note that the correct settings may vary depending on the actual printer and filament brand used.

Temperatures:

First layer: 230 degrees
Other layers: 230 degrees
Bed: 80 degrees

Filament and retraction:

Extrusion multiplier: 1.05
No lift
No retraction

Cooling:

Fan speed min.: 100%
Fan speed max.: 100%
Bridges fan speed: 50%
Disable fan for the first: 1 layer
Full fan speed at layer: 2

Other settings:

Infill: 50%
Seam position: aligned
Number of perimeters: 3
Avoid crossing perimeters
No brim
No supports

Speed:

Perimeters: 20 mm/s
Small perimeters: 25%
External perimeters: 50%
Infill: 20 mm/s
Top solid infill: 10 mm/s
Bridges: 20 mm/s
Gap fill: 10 mm/s
Travel: 180 mm/s
First layer speed: 15 mm/s

Optional settings:

Fuzzy-skin: all walls
Fuzzy skin point distance: 0.8 mm
Fuzzy skin thickness: 0.2 mm

Additional notes:

- Always complete individual objects first: don't print several objects at once, layer-by-layer.
- Use only very well-dried filament.