

Test Procedures

Please run the experiment according to the parameters set out below and record the results according to the document "Test report 2019v42".

About environmental conditions

Temperature:	between 10 °C and 40 °C
Humidity:	between 10 % and 90 %
Air stream:	None. Should be as low as possible
Solar irritation:	No direct sunlight

About the 3D Printer

Additive Manufacturing method:	Fused deposition modeling (FDM)
3D Printer:	preferably Ultimaker S5
Nozzle size / Print core:	0.4 mm / AA 0.4
Material:	preferably PLA 2.85 mm ; colour: silver ; brand "Ultimaker"

About Slicing Software

Software:	preferably Cura v3.6.0
Parameters:	use Profile "Normal – 0.15 mm" as initial settings
• Material:	PLA
• Layer Height:	0.15 mm
• Print Core:	AA 0.4
• Infill Density:	100 %
• Printing Temperature:	200 °C
• Build Plate Temperature:	60 °C
• Enable Retraction:	activated
• Print Speed:	70 mm/s
• Initial Layer Speed:	20 mm/s
• Enable print cooling:	activated
• Fan Speed:	100 %
• Generate Support:	deactivated
• Enable Prime Blob:	deactivated
• Build Plate Adhesion Type:	None

About Test Object

• File name:	Test_Object_v4_2.stl
• Scale:	100 %
• Dimensions:	84.0 x 84.0 x 26.0 mm
• Mass:	about 29 g (~3,62 m Filament)
• Production time:	about 5 h 12 min
• Orientation:	Direction X (wrote at the model) should be parallel to the front door