Orca Slicer

Gambody printing recommendations for:

Emerald Tablet of Hermes - Illuminated 3D Replica - STL Model

Below you'll find detailed slicing settings for Orca Slicer to help you get the best results when printing this model.

These settings are optimized specifically for this 3D model and should work well in most cases. But they're not set in stone - depending on your printer, material, or even the specific part you're working with, feel free to tweak things.

Every 3D printing setup is different, so feel free to make the changes that work best for your machine. When in doubt, check your printer's manual - or reach out to our Support Team at support@gambody.com

We'll be happy to help with any questions, suggestions, or issues you may have regarding the recommended printing settings!

Quality Tab

Layer height	
Layer Height	**0.20 - 0.20** mm
First layer height	**0.20 - 0.20** mm
Line width	

Default:	0.42 mm
Initial Layer	0.50 - 0.50 mm
Outer wall	0.42 mm
Inner wall	0.45 mm
Top surface	0.42 mm
Sparse infill	0.45 mm
Internal solid infill	0.42 mm
Support	0.42 mm
Seam	
Seam position	Aligned
Staggered inner seams	✘
Role base wipe speed	✘
Wipe on loops	✘
Wipe before external loop	✘
Precision	
Slice gap closing radius	0.490 mm
Resolution	0.012 mm

Arc fitting	✔
Ironing	
Ironing Type	No ironing
Wall generator	
Wall generator	Classic
Walls and surfaces	
Walls printing order	inner/outer
Print infill first	✘
Only one wall on top surfaces	✔
Bridging	
Bridge flow ratio	1.00 - 1.00

Strength

Walls	
Wall loops	4 - 4
Alternate extra wall	✘
Detect thin walls	✘

Top/bottom shells	
Top shell layers	5 layers
Top shell thickness	0.20 mm
Top surface pattern	Monotonic
Bottom shell layers	3 layers
Bottom shell thickness	0.20 mm
Infill	
Sparse infill density	100.0 %
Advanced	
Align infill direction to model	✘
Infill combination	✘
Detect narrow internal solid infill	✘

Speed

First layer speed	
First layer	50.0 - 50.0 mm/sec
First layer infill	105.0 - 105.0 mm/sec

Other layers speed	
Outer wall	200.0 - 200.0 mm/sec
Inner wall	300.0 - 300.0 mm/sec
Small perimeters	50.0 %
Small perimeter threshold	0.0 mm
Sparse infill	270.0 - 270.0 mm/sec
Internal solid infill	250.0 - 250.0 mm/sec
Top surface	200.0 - 200.0 mm/sec
Overhang speed	
Overhang speed 10%, 25%	0.0 mm/sec
Overhang speed 25%, 50%	50.0 mm/sec
Overhang speed 50%, 75%	30.0 mm/sec
Overhang speed 75%, 100%	10.0 mm/sec
Bridge external	50.0 - 50.0 mm/sec
Bridge internal	50.0 mm/sec

Travel speed	
Travel	700.0 - 700.0 mm/sec
Acceleration	
Normal printing	6000.0 mm/sec²
Outer wall	5000.0 mm/sec²
Inner wall	0.0 mm/sec²
Sparse infill	100.0 %
First layer	500.0 mm/sec²
Top surface	2000.0 mm/sec²
Travel	700.0 mm/sec²

Support

Support	
Type	Tree (auto)
Style	Default
Threshold angle	40.0 °
On build plate only	✘

Support critical regions only (only for tree supports)	✘
Remove small overhangs	✘
Filament for Supports	
Support/raft base	default
Support/raft interface	default
Support ironing	
Ironing Support Interface	✘
Advanced	
Top Z distance	0.28 - 0.28 mm
Base pattern spacing	2.50 mm
Pattern angle	0.0 °
Top interface layers	3 layers
Bottom interface layers	2 layers
Top interface spacing	0.10 mm
Normal Support expansion	0.00 mm
Support/object xy distance	0.35 mm

Others

Skirt	
Skirt loops	0
Brim	
Brim type	Auto
Brim width	5.0 mm
Brim-object gap	0.00 - 0.00 mm

Best regards,
your Ge team