Bambu Studio

Gambody printing recommendations for:

Nürburgring 3D Track Model: Nordschleife and GP Circuit

Below you'll find detailed slicing settings for Bambu Studio 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	**0.10** - mm
First layer height	**0.20** - mm
Line width	

Default:	0.42 mm
Initial Layer	0.50 - mm
Outer wall	0.40 mm
Inner wall	0.40 mm
Top surface	0.40 mm
Sparse infill	0.45 mm
Internal solid infill	0.42 mm
Support	0.42 mm
Seam	
Seam position	Aligned
Seam placement away from overhangs(experimental)	✘
Smart scarf seam application	✔
Scarf application angle threshold	155.0 °
Scarf around entire wall	✘
Scarf steps	10.0
Scarf joint for inner walls	✔
Override filament scarf seam setting	✘

Role-based wipe speed	✔
Precision	
Slice gap closing radius	0.0240 mm
Resolution	0.0060 mm
Arc fitting	✔
X-Y hole compensation	0.000 - mm
X-Y contour compensation	0.000 - mm
Auto circle contour-hole compensation	✘
Elephant foot compensation	0.10 - mm
Precise Z height	✘
Ironing	
Ironing Type	No ironing
Wall generator	
Wall generator	Arachne
Wall transitioning threshold angle	10.0 °
Wall transitioning filter margin	25.0 %
Wall transition length	125.0 %

Wall distribution count	2
Minimum wall width	85.0 %
Minimum feature size	25.0 %
Advanced	
Order of walls	inner wall/outer wall/inner wall
Print infill first	✘
Bridge flow	1.00
Thick bridges	✘
Only one wall on top surfaces	Top surfaces
Only one wall on first layer	✔
Smooth speed discontinuity area	✔
Smooth coefficient	4.0
Avoid crossing wall	✘
Smoothing wall speed along (experimental)	✔

Strength

Walls	
Wall loops	2 -
Detect thin wall	✘
Top/bottom shells	
Top surface pattern	Monotonic line
Top shell layers	8
Top shell thickness	0.80 mm
Bottom surface pattern	Monotonic
Bottom shell layers	5
Internal solid infill pattern	Rectilinear
Sparse infill	
Sparse infill density	10.0 %
Sparse infill pattern	Grid
Length of sparse infill anchor	400.0 %
Maximum length of sparse infill anchor	20.0 mm
Advanced	

Infill/Wall overlap	35.0 - %
Infill direction	45.0 °
Bridge direction	0.0 °
Minimum sparse infill threshold	15.0 mm²
Infill combination	✔
Detect narrow internal solid infill	✔
Ensure vertical shell thickness	Enabled
Detect floating vertical shells	✔

Speed

Initial layer speed	
Initial layer	50.0 - mm/sec
Initial layer infill	105.0 - mm/sec
Other layers speed	
Outer wall	60.0 - mm/sec
Inner wall	150.0 - mm/sec
Small perimeters	50.0 %
Small perimeter threshold	0.0 mm

Sparse infill	180.0 - mm/sec
Internal solid infill	180.0 - mm/sec
Vertical shell speed	80.0 %
Top surface	150.0 - mm/sec
Slow down for overhangs	✔
Overhang speed	
Overhang speed 10%	60.0 mm/sec
Overhang speed 25%	30.0 mm/sec
Overhang speed 50%	10.0 mm/sec
Overhang speed 75%	10.0 mm/sec
Overhang speed 100%	10.0 mm/sec
Slow down by height	✘
Bridge	50.0 - mm/sec
Gap infill	250.0 - mm/sec
Support	150.0 - mm/sec
Support interface	80.0 - mm/sec
Travel speed	
Travel	500.0 - mm/sec

Acceleration	
Normal printing	4000.0 - mm/sec²
Travel	10000.0 - mm/sec²
Initial layer travel	6000.0 - mm/sec²
Initial layer	500.0 - mm/sec²
Outer wall	2000.0 - mm/sec²
Inner wall	0.0 - mm/sec²
Top surface	2000.0 - mm/sec²
Sparse infill	100.0 - %

Support

Support	
Enable support	✘

Others

Bed adhesion	
Skirt loops	0
Brim type	Auto

Brim-object gap	0.10 - mm
Prime tower	
Enable	✔
Skip points	✔
Internal ribs	✘
Width	200.0 mm
Max speed	90.0 mm/sec
Brim width	0.0 mm
Infill gap	100.0 %
Rib wall	✘
Flush options	
Flush into objects' infill	✔
Flush into objects support	✔
Special mode	
Slicing Mode	Regular
Print sequence	By layer
Spiral vase	✘

Timelapse	Smooth
Fuzzy Skin	None
Advanced	
Use beam interlocking	✘
G-code output	
Reduce infill retraction	✔

Best regards,
your Ge team