

- 1) FDM material can be PLA plus (sometimes labeled as “pro” or +).
- 2) The following slicer settings are highly recommended:
 - a) Use 100% fill; small parts need to be solid.
 - b) Use the smallest layer thickness available
 - c) Use a support “Tree” attached only to the build platform; makes it easy to remove the supports after printing. Also should minimize post processing work on the part.
 - d) Orient the V8 part on the build plate like this print preview shows (blue layers are the support tree).

