

## Conch Hotend Printing Parameters and Printing Results Reference

### ● Retraction Setting Parameter

Filament	Cooling	Setting Overrides	Advanced	Notes
Retraction				
<input checked="" type="checkbox"/>	Length	0.8	mm	↻
<input type="checkbox"/>	Z hop when retract	N/A	mm	
<input type="checkbox"/>	Z Hop Type	∨		
<input checked="" type="checkbox"/>	Retraction Speed	30	mm/s	↻
<input type="checkbox"/>	Deretraction Speed	N/A	mm/s	
<input type="checkbox"/>	Travel distance threshold	N/A	mm	
<input type="checkbox"/>	Retract when change layer	<input type="checkbox"/>		
<input type="checkbox"/>	Wipe while retracting	<input type="checkbox"/>		
<input type="checkbox"/>	Wipe Distance	N/A	mm	
<input type="checkbox"/>	Retract amount before wipe	N/A	%	
<input type="checkbox"/>	Long retraction when cut (experimental)	<input type="checkbox"/>		

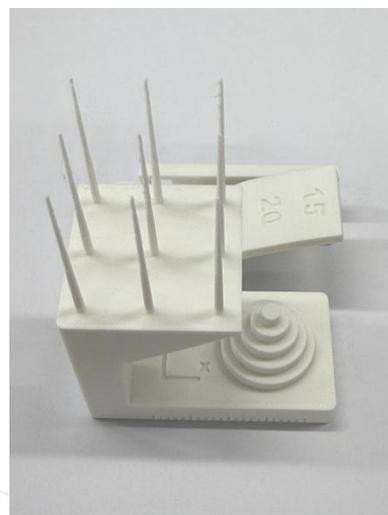
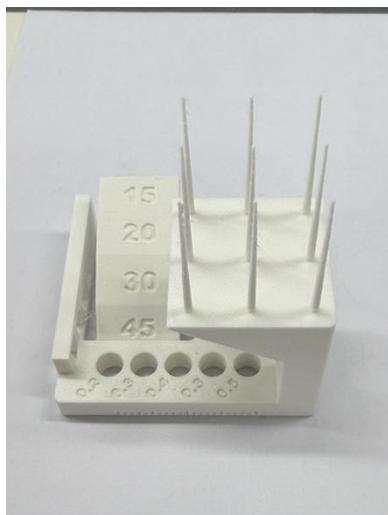
### ● PLA Printing Slice Parameters

Printing Temperature: 220°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



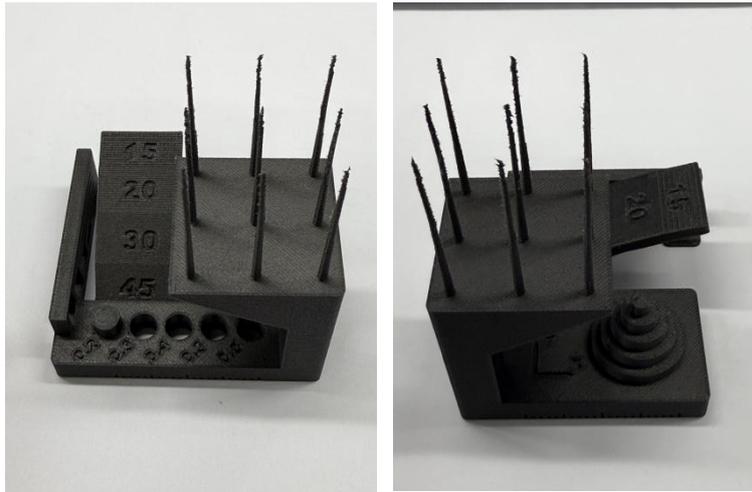
- **PA-CF Printing Slice Parameters**

Printing Temperature: 290°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



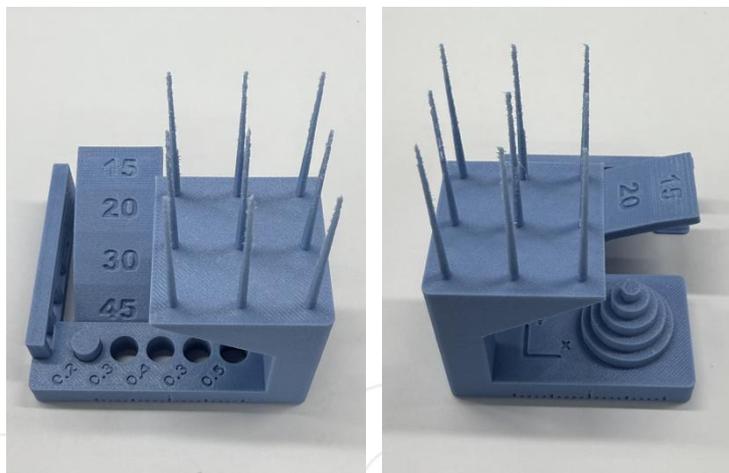
- **PET-GF Printing Slice Parameters**

Printing Temperature: 290°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



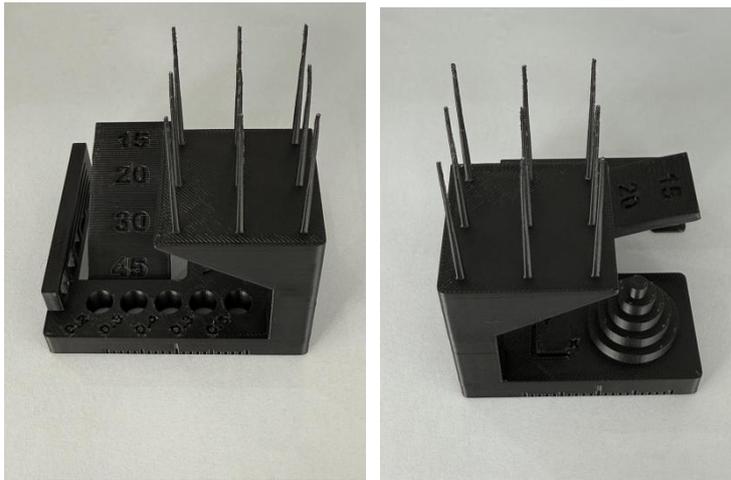
- **ABS Printing Slice Parameters**

Printing Temperature: 250°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



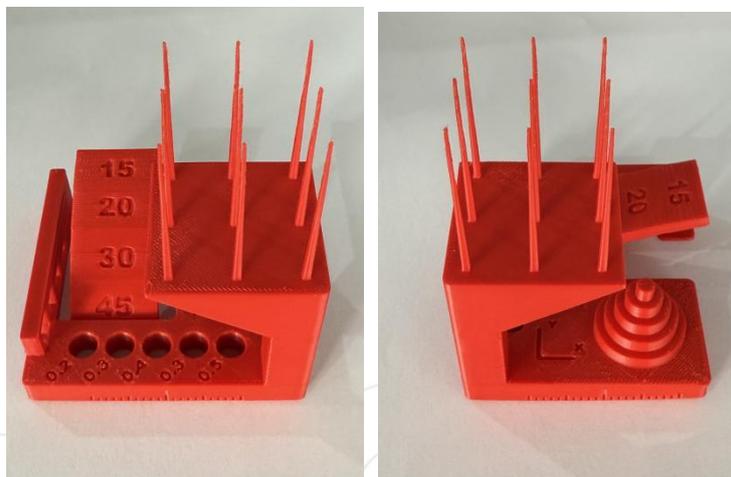
- **ASA Printing Slice Parameters**

Printing Temperature: 250°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



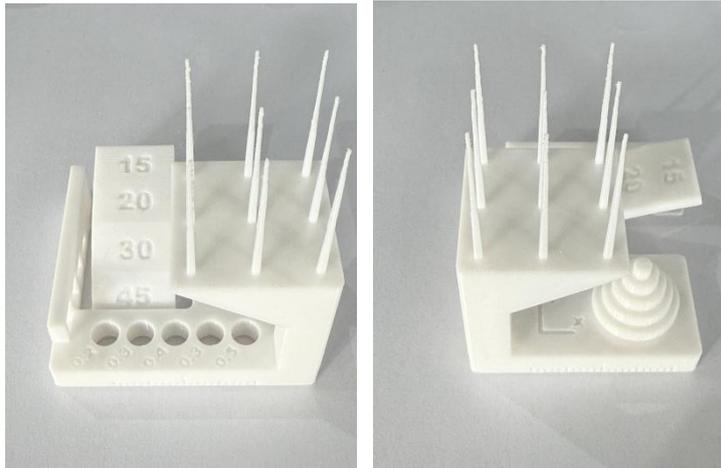
- **PETG Printing Slice Parameters**

Printing Temperature: 230°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



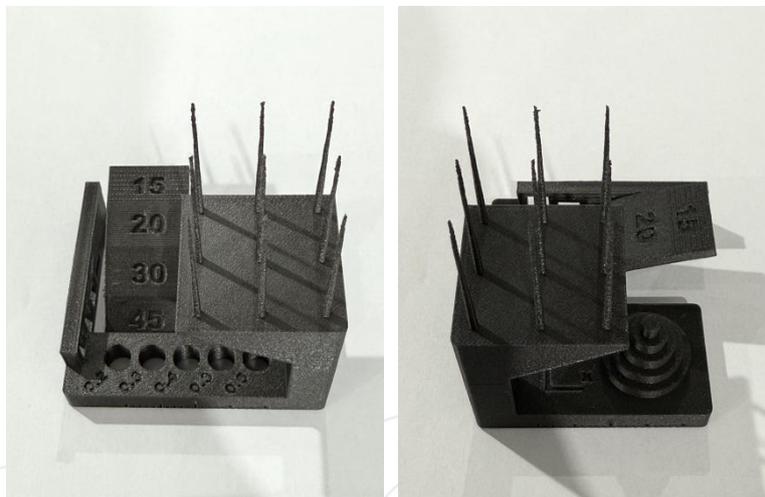
- **PETG-CF Printing Slice Parameters**

Printing Temperature: 240°C

Retraction Length: 0.8mm (default)

Retraction Speed: 30mm/s (default)

Printing Result:



## Suggestions for Optimizing Print String

1. Filaments will absorb moisture when left in the air. If there is string during printing, it is recommended to check whether filaments are wet or not, you can dry them or use a new filament to print for comparison.
2. It is recommended to set the retraction length to 0.8mm (default) - 1.5mm, there may be a risk of clogging if the retraction length is too long. If a clogging occurs, it can be reduced appropriately.
3. Check Z hop when retraction value is good for reducing string. Hop height can use the default 0.4mm, Z Hop Type can choose Spiral or Oblique, both of which have better inhibition effect on string.
4. Check Retraction when changing layer, and Wipe while retracting is also conducive to reducing string.
5. Appropriate reduction in printing temperature can also reduce the string.

Example: The recommended printing temperature of General PLA is 200-230 °C. If printing at 220 or 230 °C with more string, it is recommended that you can reduce to 200 or 210 °C printing.

The print flow may not be as high as it was while the temperature is lowered, so you can adjust the print speed accordingly.

Filament settings ✕

↻ \* Generic PLA 📄 🔍 Advanced

Filament Cooling **Setting Overrides** Advanced Notes

**Retraction**

<input checked="" type="checkbox"/> Length	1.5 mm <span>↻</span>
<input checked="" type="checkbox"/> Z hop when retract	0.4 mm <span>↻</span>
<input checked="" type="checkbox"/> Z Hop Type	∨ Spiral <span>↻</span>
<input checked="" type="checkbox"/> Retraction Speed	30 mm/s <span>↻</span>
<input type="checkbox"/> Deretraction Speed	N/A mm/s
<input type="checkbox"/> Travel distance threshold	N/A mm
<input checked="" type="checkbox"/> Retract when change layer	<input checked="" type="checkbox"/> <span>↻</span>
<input checked="" type="checkbox"/> Wipe while retracting	<input checked="" type="checkbox"/> <span>↻</span>
<input type="checkbox"/> Wipe Distance	N/A mm
<input type="checkbox"/> Retract amount before wipe	N/A %
<input type="checkbox"/> Long retraction when cut (experimental)	<input type="checkbox"/>