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Wanhao Duplikator i3 Plus

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Cura Profile

Vor dem Ändern der Cura (Standard) Profile ist es ratsam eine Kopie der Originale anzulegen.

Wanhao Duplikator i3 Plus

Druckerprofil

Drucker Definition mit angepassten Standard-Werten: Speichern in

- Windows:
 - <CuraProgrammOrdner>\resources\definitions\wanhao_i3plus_jhe.def.json (alle Benutzer) oder
 - <Benutzer>\AppData\Roaming\cura\4.4\definitions\wanhao_i3plus_jhe.def.json (einzelner Benutzer)
- Linux ApplImage:
 - \$HOME/.local/share/cura/<CuraVersion>/

Retraction/Einzug („retraction_amount“) nicht über 1.6 mm (max 2.0 mm)

wanhao_i3plus_jhe.def.json

```
{
  "version": 2,
  "name": "Wanhao i3 Plus (JHE)",
  "inherits": "wanhao_i3plus",

  "metadata":
  {
    "visible": true,
    "author": "Josef Huber",
    "manufacturer": "Wanhao",
    "file_formats": "text/x-gcode",
    "has_materials": true,
    "has_machine_quality": true,
    "platform": "wanhao_200_200_platform.obj",
    "platform_texture": "Wanhaobackplate.png",
    "machine_extruder_trains":
    {
      "0": "wanhao_i3plus_extruder_0"
```

```
    },
    "overrides":
    {
        "machine_name":
        {
            "default_value": "Wanhao i3 Plus (JHE)"
        },
        "retraction_amount":
        {
            "default_value": 1.0
        },
        "adhesion_type":
        {
            "default_value": "skirt"
        },
        "layer_height_0":
        {
            "default_value": 0.2
        },
        "speed_print":
        {
            "default_value": 40
        },
        "wall_thickness":
        {
            "value": "(line_width * 3) if infill_sparse_density <
85 else line_width"
        },
        "top_bottom_thickness":
        {
            "value": "wall_thickness"
        }
    }
}
```

Qualitätsprofile

- <CuraProgrammOrdner>\resources\quality\wanhao_global_*.inst.cfg (alle Benutzer) oder
- <Benutzer>\AppData\Roaming\cura\4.4\quality\wanhao_global_*.inst.cfg (einzelner Benutzer)
- definition = wanhao_i3plus_jhe2 Referenz zu Druckerprofil

Diese Qualitätsprofile werden geladen wenn das Druckerprofil `wanhao_i3plus_jhe2` aktiv ist und kein materialspezifisches Profil existiert.

Normal 0.2 mm

- Cura quality_type = draft

[wanhao_global_normal.inst.cfg](#)

```
[general]
version = 4
name = Normal
definition = wanhao_i3plus_jhe2

[metadata]
setting_version = 10
type = quality
quality_type = draft
weight = -2
global_quality = True

[values]
layer_height = 0.2
speed_print = 50
```

Fein 0.15 mm

- Cura quality_type = fast

[wanhao_global_fein.inst.cfg](#)

```
[general]
version = 4
name = Fein
definition = wanhao_i3plus_jhe2

[metadata]
setting_version = 10
type = quality
quality_type = fast
weight = -1
global_quality = True
```

```
[values]
layer_height = 0.15
speed_print = 45
```

Hoch 0.1 mm

- Cura quality_type = normal

wanhao_global_hoch.inst.cfg

```
[general]
version = 4
name = Hoch
definition = wanhao_i3plus_jhe2

[metadata]
setting_version = 10
type = quality
quality_type = normal
weight = 0
global_quality = True

[values]
layer_height = 0.1
speed_print = 40
```

Materialspezifische Qualitäts-Profile

Materialspezifische Profile werden im selben Ordner gespeichert und referenzieren das Material und mit folgenden Keys:

quality_type	Cura quality_type	z.B. <i>verydraft, draft, fast, normal, high</i>
material	Material	z.B. generic_pla referenziert alle PLA Materialprofile außer es existiert ein spezifisches z.B. w3ip_pla_abc referenziert w3ip_pla_abc.xml.fdm_material

```
[metadata]
quality_type = high
material = generic_pla
```

Wanhao Duplicator i3+ Profile

- [ABS \(extruder\)](#)
- [DuraPro ASA \(extruder\)](#)
- [ecoPLA bronze \(3Djake\)](#)
- [ecoPLA dunkelgrau \(3Djake\)](#)
- [PETG \(Nunus\)](#)
- [PLA \(Holz/Wood\) \(JANBEX\)](#)
- [PolyFlex \(Polymaker\)](#)