

Adventurer 5M PLA retractable-wand profile

3DP-001 / REV A / 2026.09.01

The current standard uses 0.24 mm layers, three walls, four top and bottom layers, 15% grid infill, 220°C first-layer / 215°C later nozzle temperature, 60°C first-layer / 55°C later bed temperature, controlled cooling, and a deliberately fast but bounded motion profile. It is a starting point for this printer, material, and nozzle combination-not a universal profile.

STATUS	Canonical Current Standard
CLASSIFICATION	3DP
MATERIAL	3D PRINT / MAKER
DISPOSITION	PUBLIC / CANONICAL CURRENT STANDARD
CATEGORY	3D Printing
RECORD TYPE	print-profile

TECHNICAL NOTES

Canonical fast-PLA starting profile for the retractable wand on a 0.4 mm nozzle.

GOAL

Produce a fast, strong retractable wand while preserving a reliable first layer.

EQUIPMENT

- Adventurer 5M
- 0.4 mm nozzle
- Slicer project/profile export

MATERIALS

- Standard PLA

METHOD / STEPS

1. Confirm printer, nozzle, material, and plate surface.
2. Enter the starting values and keep the first layer conservative.
3. Print a small motion/strength test before a full wand.
4. Record the finished result and the next revision.

RESULT / WHERE THIS STANDS

Canonical starting point; one confirmation print still validates the setup.

TROUBLESHOOTING

- A slicer preview is not proof that a finished part will fit or move.
 - Change one process variable at a time so the next result is attributable.
 - Keep material identity and nozzle size with every saved revision.
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SAFETY / LIMITATIONS

- Keep hot-end and moving-machine precautions in force.
 - Validate strength and motion before treating the part as finished.
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SPECIFICATION

LAYER	0.24 mm
SHELL	3 walls / 4 top / 4 bottom
INFILL	15% Grid at 45°
TEMPERATURE	220°C first / 215°C later
BED	60°C first / 55°C later
SPEED	40 first / 120 outer / 180 inner / 220 infill

DEVELOPMENT HISTORY

2026.09.01 / Rev A

Imported as an independent manifest record; public copy keeps uncertainty visible.

RELEASED MATERIAL / SOURCE LINKS

3dp-001-public-summary.txt

PUBLIC SUMMARY / RECOVERED NOTES

<https://u225x.com/downloads/manifest-records/3dp-001-public-summary.txt>

RETURN TO THE LIVING RECORD

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This PDF preserves the public notes at this revision. Visit the record for updates and attached images.

<https://u225x.com/record/3DP-001>
