

How To Print Glass



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Summary

How to print GLASS! The first thing to understand is a very slow speed is necessary, so patience is a must.



0.13 hrs



1 pcs



0.10 mm



0.40 mm



PET



1 g



Other

[Hobby & Makers](#) > [Other Ideas](#)

Tags: [petg](#) [glass](#) [clear](#) [cristal](#)

How to print GLASS! The first thing to understand is a very slow speed is necessary, so patience is a must.

The key is three different factors.

1. 20mm/s speed
 2. 0.1000mm layer height
 3. No top or bottom layers, along with one single direction for infill
- By following the three keys above you can create a very translucent print. Several factors in positioning the printed object and direction the filament is laid down will give veering results. The Best filament to use believe it or not is: OVERTURE CLEAR PETG. It even beat out Formfutura HD Glass.

(https://www.amazon.com/Filament-Transparent-Consumables-Dimensional-Accuracy/dp/B07SB761QR/ref=sr_1_1_sspa?keywords=overture+clear+petg&tag=tv-auto-20)

This is for everyone not using simplify3D

EXTRUDER

Nozzle Diameter: 0.40 mm
Extrusion Multiplier: 1.01
Extrusion Width: 0.50 mm
Retraction Distance: 3.05 mm
Retraction Speed: 30.00 mm/s
Coasting Distance: 1.00 mm
Wipe Distance: 3.00 mm

LAYER

Primary Layer Height: 0.1000 mm
Top Solid Layers: 0
Bottom Solid Layers: 0
Outline/Perimeter Shells: 2

INFILL

Interior Fill Percentage: 100%
Outline Overlap 35%
Infill Extrusion Width: 103%

Internal Infill Angle Offset: -45

THE INFILL MUST NOT ALTERNATE EACH LAYER. EVERY LAYER MUST BE LAID DOWN THE SAME DIRECTION.

TEMPERATURE

Hot End: 265c
Hot Bed: 70c

COOLING

NO! This will cloud the print.

SPEED

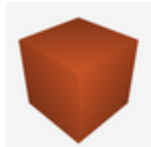
Default Printing Speed: 20.0 mm/s
Outline Underspeed: 50%
Solid Infill Underspeed: 30%
Support Structure Underspeed: 80%
X/Y Axis Movement Speed: 150.0 mm/s
Z Axis Movement Speed: 20.0 mm/s

Some of the settings are from Simplify3D, just use what's familiar to you. If you have any questions ask, I'd be glad to help.

Print instructions

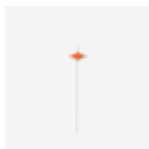
Category: 3D Printing

Model files





20mm_cube.stl

Print files



glass_test.gcode

 PET  0.40 mm  0.10 mm  0.13 hrs  1 g

[Find source .stl files on Thingiverse.com](#)

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