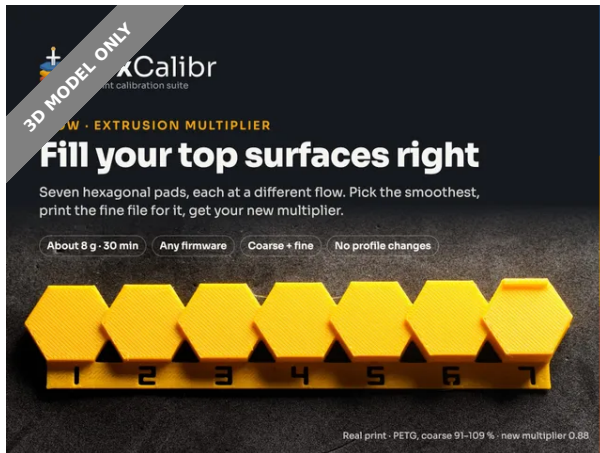




Flow & Extrusion Multiplier Test for PrusaSlicer - Hexagon Pads | HexCalibr



Teo

[VIEW IN BROWSER](#)

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Summary

Seven hexagon pads, each at its own flow: pick the smoothest top, print the fine file, get your new multiplier.

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Seven hexagonal pads in a staircase, each top printed at its own flow. Pick the smoothest one, print the fine file for it, and the guide gives you the new extrusion multiplier. No profile edits: the file sets the flow and the speed of every pad, then puts them back to 100 %.

Step-by-step guide

Photos of too little, right and too much, plus a selector that names the fine file and works out the new value: hexcalibr.ui4.eu/flow.html

What it does

The pads rise one step each, and the top of every pad is printed at a different flow: 91, 94, 97, 100, 103, 106 and 109 % on the coarse file. The file sends a flow factor (M221) at the layer where each top begins, and a speed factor (M220) so every pad prints at 60 mm/s with the lines running the same way. Hold a light low across the tops: too little leaves dark grooves, too much makes lines stand up as ridges. Then the fine file for your best pad prints seven more pads, 1 % apart.

Why HexCalibr

- **No profile edits.** Your printer, print and filament profiles stay as they are; flow and speed go back to 100 % at the end, with a message on the screen.
- **Same top on every pad.** Same speed, same direction of the lines, four top layers over real sparse infill: the only thing that changes is the flow.
- **Two prints, one number.** Coarse finds the zone (3 % steps), fine pins it down (1 %), and the selector in the guide does the maths.

Which file to download

- **First:** flow_coarse_91-109.3mf.
- **Then:** the one fine file for your best coarse pad: flow_fine_88-94, 91-97, 94-100, 97-103, 100-106, 103-109 or 106-112 (.3mf). The guide's selector names it.
- **IDEX and multi-tool:** assign the object to the tool you calibrate (right-click > Change extruder).

Quick steps

1. Write down the extrusion multiplier in your filament profile.
2. Download the coarse file (not "Download all" as a ZIP) and open it in PrusaSlicer 2.9 with **File > Open project**, never Import. Slice and print.
3. Look at the middle of each top with a low, raking light. Tick the best pad in the guide: it names the fine file.
4. Print the fine file, tick its best pad, type your multiplier: the guide gives the new value. Save it in the filament preset.

A real result

PETG on a RatRig V-Core 4 IDEX (RatOS, T0), multiplier 0.85 in the profile. Coarse: pads 1 to 3 showed grooves, pad 5 (103 %) looked best. Fine flow_fine_100-106: pad 5 (104 %), so $0.85 \times 1.04 = \mathbf{0.88}$. Check print flow_fine_97-103 with 0.88 saved: pad 4 (100 %) is the best, as it should be. The lines are still there under a fingernail: that is the shape of each printed line, not a flow error.

Share your Make

Printed it? Post a **Make** with a photo of the pads under raking light, and say which pad you picked and your new multiplier. Makes help other people read their own pads.

Watch the trailer

<https://www.youtube.com/watch?v=4DVof70cOv8>

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Version 0.6 · made for PrusaSlicer 2.9 (2.7 minimum).

Italiano

Sette pad esagonali a scala, ognuno con la faccia superiore stampata a un flusso diverso: scegli il più liscio, stampa il file fine per quel pad e la guida ti dà il nuovo moltiplicatore di estrusione. Nessuna modifica ai profili. Apri il file con **File > Apri progetto**. Guida completa in italiano, con il selettore: hexcalibr.ui4.eu/it/flow.html

Model files



Coarse

1 file



flow_coarse_91-109.3mf



Fine

7 files



flow_fine_88-94.3mf



flow_fine_91-97.3mf



flow_fine_94-100.3mf



flow_fine_97-103.3mf



flow_fine_100-106.3mf



flow_fine_103-109.3mf



flow_fine_106-112.3mf

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