

Mesh-Type three-dimensional (3D) Printing of Human Organs and Tumors: Fast, Cost-Effective, and Personalized Anatomic Modeling of Patient-Oriented Visual Aids

Table 1. The manufacturer's default parameters of the slicer software.

Basic setting	
Layer Height	0.20
Infill Density	15%
PLA Diameter	1.75 mm
Nozzle Temperature	200°
Build plate Temperature	60°
Shell Wall Thickness	0.8 mm
Support	
Support Pattern	Zig Zag
Support Density	20%
Support Overhang Angle	60°
Support Horizontal Expansion	0.8 mm
Support Z Distance	0.2 mm
Build Plate Adhesion	
Type	Raft
Raft Top Layers	2 mm
Raft Line Width	1 mm
Base Quality	
Line width	0.3 mm
Wall Line Width	1.0 mm
Print Speed	20 mm/s
Speed	
Print Speed	40 mm/s
Travel Speed	130 mm/s
Initial Layer Speed	20 mm/s
Infill	
Infill Type	Auto
Infill Pattern	Lines Pattern
Retraction	
Retraction Speed	30 mm/s
Retraction Distance	6 mm/s
Retraction Mnimum Travel	1.50 mm
Cleaning tower	Used when the tumor size is large