



Setting specific material for supports and skirts

Written By: Mosaic Support

Extruder

Layer

Additions

Infill

Support

Temperature

Cooling

G-Code

Scripts

Speeds

Other

Advanced

Extruder List
(click item to edit settings)

Primary Extruder

Skirt Extruder

Support Extruder

Add Extruder

Remove Extruder

Support Extruder Toolhead

Overview

Extruder Toolhead Index

Tool 0

Nozzle Diameter

0.30

 mm

Extrusion Multiplier

1.00

Extrusion Width ☒ Auto ☐ Manual

0.36

 mm

Ooze Control

☒ Retraction

Retraction Distance

1.00

 mm

Extra Restart Distance

0.00

 mm

Retraction Vertical Lift

1.00

 mm

Retraction Speed

1800.0

 mm/min

☐ Coast at End

Coasting Distance

0.20

 mm

☐ Wipe Nozzle

Wipe Distance

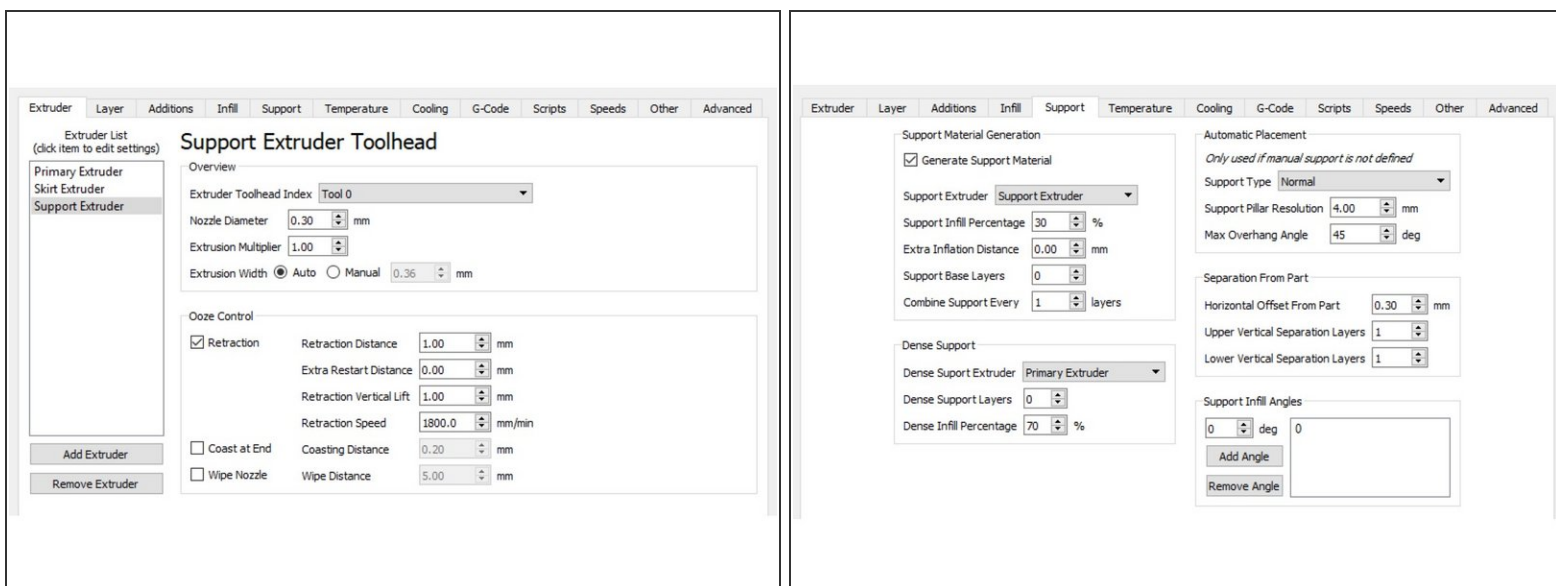
5.00

 mm

INTRODUCTION

This guide describes how to set a specific material for supports, skirts, and/or rafts in Simplify3D.

Step 1 — Setting A Specific Material For Supports And Skirts.



- With Simplify3D open, select your Process and go to the Extruder tab.
- Add an Extruder ('Support Extruder') and make sure that it has the same settings as your Primary Extruder (nozzle diameter, retraction settings, etc.).
- The only change to make is the Extruder Toolhead Index. The Tool number corresponds to the Drive number of your Palette+ (Tool 0 is Drive 1, Tool 1 is Drive 2, etc.). Select the Tool/Drive which your support material will be inserted. In this example, our support material will be fed into Drive 1 of Palette+.
- Click on the Support tab.
- Make sure that "Generate Support Material" is checked, and that you assign the Support Extruder as your Support Extruder.

If you have any questions, please contact us at support@mosaicmfg.com