

Slicer test: overhang, support and wall thickness.

version d

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www.CraftBot.nl

Using the Support test object of the great Sandor (Psanyi), and my own test objects.

<http://www.thingiverse.com/thing:2225140>

<http://www.thingiverse.com/thing:875237>

<http://www.thingiverse.com/thing:2152246>

Settings: 0.2mm Layer height and 0.4mm Path width.

The Gcode imported in CraftWare to have the same 'look and feel'.

The test results are reviewed just as slice results. Some tweaking to do for some slicers to get printable Gcode for the CraftBot.

	Slic3r 1.34.0 Prusa edition	KISSlicer 1.5	CraftWare 1.14	Simplify3D 3.1.1	Cura 2.5 beta	Mattercontrol 1.7
General slice result	++	+/-	-	-	+/-	+
Automatic support detection of small areas	++	-	-	-	++	++
Automatic support generation with a given angle	+	+	+	+	+/-	+
Manual support placing	--	--	+	+	-	--
Support interface tweaking (easy to remove, but good support)	+	++	-	+	+	+
Thin wall detection	++	+	-	-	-	+/-
Filling extrusions in remaining gaps between loops (Crowning)	++	++	--	--	+	++
Architectural objects slicing general	+	-	Layer errors --	+	-	-
Printing small islands and logical path	++	--	+	++	+/-	+/-
Bridging	-	-	-	-	-	-
Influence seam placing	+/-	++	+	+/-	+/-	--
Dimension tweak (XY compensation)	+	+	+	+	+	-
Different layer height on layer range	++	--	-	+/-	-	--
Support accuracy using small Nozzles as 0.2mm	+	++	+/-	+/-	+/-	+
Support accuracy using large Nozzles as 0.8mm	+	++	-	+/-	+	+
Max Flow setting for the extruder	++	++	?	?	?	?
Forgive small stl errors	+	--	+	+	+	+
Vase mode (spiraling the perimeter)	+/-	--	-	++	+/-	+/-
Number of settings / tweaks	+	+	+/-	+	++	+/-
3D Gcode preview	+	+	++	++	+	+/-
Simple Installation / first user / school slicer	+/-	+	+/-	+/-	-	+/-
OS	Win/Mac/Lin	Win/Mac/Lin	Win (old Mac and Lin)	Win/Mac/Lin	Win/Mac/Lin	Win(older Mac/Lin)
Price	Free	Free/\$42	Free	\$140	Free	Free
Speed of slicing	+/-	+/-	++	+	+	--
Everyday General slicer	+	+	+	+	+/-	+/-
Thin Wall slicer with crowning	+	+/-	-	-	-	+
Architectural model slicer	+	--	--	+	--	--
Tweakable specialist slicer	+	+	+/-	+	++	+/-
Great auto support generating slicer	++	+/-	-	-	+	++
Out of the box performance as large layer heights	++	+	+	+	+	+
Dual or More extrusion	6 +	4 (Pro)	1	6	5	6 +
Multi extrusion: binding extruders to meshes and support	?	++	NA	?	?	?
Extruder change Gcode / post processing	?	++	+/-	?	++	?
Stacking (small layer perimeter, large infill and support)	+/-	+	-	-	-	-
Profiles available for the CraftBot	+	++	++	+	(only for 15.04) +/-	errors --
Bug solving / listening to customers	+	-	+/-	+	+	??
Host for direct steering the CraftBot	+	+	CraftPrint	??	+	??
Interface easy for different printer types	+	+	-	-	-	??
Logical Interface	++	+	+/-	-	+	??
Wow Interface and info feedback	+/-	-	+	+/-	+/-	??