**Settings for SCSU Stack Printing Process of Face Shields**

**Printers:** Stratasys - Uprint and F123-Series printers - ABS Material with Soluble Support

**Settings:** for fastest print time, strongest part, and least support material (that we have been able to determine)

- **SOLID Material Fill** with **THICKEST Layer height (0.0130)**

- **BASIC Support** (do not use the default "SMART Support") with **SELF Supporting Angle Set to 30 Degrees** (see screen shot below)