

### Flow rate table v1.0

Actual diameter	1,60	1,61	1,62	1,63	1,64	1,65	1,66	1,67	1,68	1,69	1,70	1,71	1,72	1,73	1,74	1,75	1,76	1,77	1,78	1,79	1,80	1,81	1,82	1,83	1,84	1,85	1,86	1,87	1,88	1,89	1,90
1,60	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	80%	79%	78%	77%	76%	76%	75%	74%	73%	72%	72%	71%
1,61	101%	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	80%	79%	78%	77%	77%	76%	75%	74%	73%	73%	72%
1,62	103%	101%	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	80%	79%	78%	78%	77%	76%	75%	74%	73%	73%
1,63	104%	102%	101%	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	80%	79%	78%	78%	77%	76%	75%	74%	74%
1,64	105%	104%	102%	101%	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	80%	79%	79%	78%	77%	76%	75%	75%
1,65	106%	105%	104%	102%	101%	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	80%	80%	79%	78%	77%	76%	75%
1,66	108%	106%	105%	104%	102%	101%	100%	99%	98%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	81%	80%	79%	78%	77%	76%
1,67	109%	108%	106%	105%	104%	102%	101%	100%	99%	98%	97%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	81%	81%	80%	79%	78%	77%
1,68	110%	109%	108%	106%	105%	104%	102%	101%	100%	99%	98%	97%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	82%	82%	81%	80%	79%	78%
1,69	112%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	83%	83%	82%	81%	80%	79%
1,70	113%	111%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	84%	84%	83%	82%	81%	80%
1,71	114%	113%	111%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	95%	94%	93%	92%	91%	90%	89%	88%	87%	86%	85%	85%	84%	83%	82%	81%
1,72	116%	114%	113%	111%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	96%	94%	93%	92%	91%	90%	89%	88%	87%	86%	86%	85%	84%	83%	82%
1,73	117%	115%	114%	113%	111%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	96%	94%	93%	92%	91%	90%	89%	88%	87%	87%	86%	85%	84%	83%
1,74	118%	117%	115%	114%	113%	111%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	96%	94%	93%	92%	91%	90%	89%	88%	88%	87%	86%	85%	84%
1,75	120%	118%	117%	115%	114%	112%	111%	110%	109%	107%	106%	105%	104%	102%	101%	100%	99%	98%	97%	96%	95%	93%	92%	91%	90%	89%	89%	88%	87%	86%	85%
1,76	121%	120%	118%	117%	115%	114%	112%	111%	110%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	92%	91%	91%	90%	89%	88%	87%	86%
1,77	122%	121%	119%	118%	116%	115%	114%	112%	111%	110%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%	92%	91%	90%	89%	88%	87%
1,78	124%	122%	121%	119%	118%	116%	115%	114%	112%	111%	110%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%	92%	91%	90%	89%	88%
1,79	125%	124%	122%	121%	119%	118%	116%	115%	114%	112%	111%	110%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%	92%	91%	90%	89%
1,80	127%	125%	123%	122%	120%	119%	118%	116%	115%	113%	112%	111%	110%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%	92%	91%	90%
1,81	128%	126%	125%	123%	122%	120%	119%	117%	116%	115%	113%	112%	111%	109%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%	92%	91%
1,82	129%	128%	126%	125%	123%	122%	120%	119%	117%	116%	115%	113%	112%	111%	109%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%	92%
1,83	131%	129%	128%	126%	125%	123%	122%	120%	119%	117%	116%	115%	113%	112%	111%	109%	108%	107%	106%	105%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%	93%
1,84	132%	131%	129%	127%	126%	124%	123%	121%	120%	119%	117%	116%	114%	113%	112%	111%	109%	108%	107%	106%	104%	103%	102%	101%	100%	99%	98%	97%	96%	95%	94%
1,85	134%	132%	130%	129%	127%	126%	124%	123%	121%	120%	118%	117%	116%	114%	113%	112%	110%	109%	108%	107%	106%	104%	103%	102%	101%	100%	99%	98%	97%	96%	95%
1,86	135%	133%	132%	130%	129%	127%	126%	124%	123%	121%	120%	118%	117%	116%	114%	113%	112%	110%	109%	108%	107%	106%	104%	103%	102%	101%	100%	99%	98%	97%	96%
1,87	137%	135%	133%	132%	130%	128%	127%	125%	124%	122%	121%	120%	118%	117%	116%	114%	113%	112%	110%	109%	108%	107%	106%	104%	103%	102%	101%	100%	99%	98%	97%
1,88	138%	136%	135%	133%	131%	130%	128%	127%	125%	124%	122%	121%	119%	118%	117%	115%	114%	113%	112%	110%	109%	108%	107%	106%	104%	103%	102%	101%	100%	99%	98%
1,89	140%	138%	136%	134%	133%	131%	130%	128%	127%	125%	124%	122%	121%	119%	118%	117%	115%	114%	113%	111%	110%	109%	108%	107%	106%	104%	103%	102%	101%	100%	99%
1,90	141%	139%	138%	136%	134%	133%	131%	129%	128%	126%	125%	123%	122%	121%	119%	118%	117%	115%	114%	113%	111%	110%	109%	108%	107%	105%	104%	103%	102%	101%	100%

Sliced for

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Example: You sliced for 1.75, but have a roll of 1.69mm filament. Locate the 1.75mm row and find the 1.69 column on that row. This tells you that the flow rate to set in your control panel is 107%