

Country marker nozzle & finish guide

Use the same physical nozzle size in the Country Marker Maker app and in Bambu Studio. These are dependable PLA starting points for the app's 10 mm-thick clock markers; your printer and filament may need small adjustments.

NOZZLE	LAYER HEIGHT	FIRST LAYER	WALL GENERATOR	WALL LOOPS	TOP / BOTTOM	INFILL	IRONING
0.2 mm	0.10 mm	0.15 mm	Arachne	4	8 / 6 layers	15% Gyroid	Topmost surface
0.4 mm RECOMMENDED	0.20 mm	0.20 mm	Arachne	3	5 / 4 layers	12% Gyroid	Topmost surface
0.6 mm	0.28 mm	0.28 mm	Arachne	3	4 / 4 layers	10% Gyroid	Topmost surface
0.8 mm	0.36 mm	0.36 mm	Arachne	3	3 / 3 layers	10% Gyroid	Topmost surface

01 Smooth top Enable Ironing and choose Topmost surface . Set the top surface pattern to Monotonic line . Start with Bambu's default ironing flow and spacing.	02 Smoothest visible face For the cleanest finish, put the visible face down on a clean smooth PEI plate. Dry the filament and run flow-dynamics calibration if the finish is uneven.	03 Useful extras Supports: Off. Wall order: Inner/Outer. Seam: Back or Nearest. Elephant-foot compensation: 0.15 mm. Brim: Off normally; use 3-5 mm only if narrow tips lift.	04 Missing detail If a narrow feature vanishes in the slicer, enlarge the marker or use a smaller nozzle. Keep uniform scaling - the scale padlock - enabled so the country is never stretched.
---	--	---	---

BEST ALL-ROUND CHOICE

Use a 0.4 mm nozzle for most country markers. Choose 0.2 mm for the finest coastlines; 0.6 or 0.8 mm prints faster but removes more small detail.