Simplify3D 4.2.1 [Multi] Serial Key ((FREE))

as previously mentioned, simplify3d trained only using extruded thermoplastic pla, so it is possible that the network has learnt that an optimal extrusion should be the same for all materials. to test this, multiple extruded parts for different materials were printed with varying extrusion rates and initial z offsets (fig. 4c). the network was successfully able to correct the extrusion rate and z offset for each material. in addition, we tested the network's ability to learn that the optimal extrusion rate is not the same for all z offsets. multiple extruded parts for varying extrusion rates and initial z offsets were printed in a single session (fig. 4e). this example demonstrates that the network is capable of learning to adapt the extrusion rate and z offset to optimise the initial layer for each z offset. f examples of the printed filament size distribution for the multiple extruded parts. the mean filament size is reduced significantly in the cases where the network is able to correct the z offset and extrusion rate. for the extrusion rate, the mean filament widths are 0.15 mm at an extrusion rate of 0.2 mm/s for pla and 0.17 mm at an extrusion rate of 0.25 mm/s for abs. for the z offset, the mean filament widths are 0.10 mm at an initial z offset of -0.15 mm and 0.07 mm at an initial z offset of -0.20 mm. the printed surface finish of the printed parts can be improved by reducing the initial layer on the substrate and by optimising the extrusion rate and z offset. to test this, we printed different initial thicknesses of print bed thermoplastic on a flat surface using an unmodified simplify3d printer (fig. 4f). the initial layer was almost completely removed for the samples that were printed with a thick print bed, and the initial layer was almost completely retained for the samples printed with a thin print bed. the z offset and extrusion rate was then optimised, and it was found that the initial layer thickness was reduced for the samples printed with a thick print bed while the initial layer thickness was retained in the case of a thin print bed. the samples printed with a thick print bed have a better surface finish than the samples printed with a thin print bed due to the improved initial layer. the initial layer height (z) is typically the main factor that determines the surface finish of a printed part. this is demonstrated in fig. 4f, as the samples printed with a thin print bed (blue) have a much smoother surface finish than the samples printed with a thick print bed (red). g mean absolute differences in initial layer height of 0.5 mm for samples printed with a thin print bed (blue) and samples printed with a thick print bed (red). the difference in initial layer height is less than 0.02 mm for samples printed with a thin print bed, whereas the difference is 0.1 mm for samples printed with a thick print bed.

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by using the attention maps, the network can make a prediction without having to look at the input image. in fig. 4, the network has incorrectly predicted a low flow rate along with low hotend temperature. however, when looking at the attention map for the hotend temperature, the network notes that this is likely too low, so it offers an alternative solution. it notes the current flow rate is too low and also notes that the temperature is too low, so it suggests increasing the flow rate by some amount. the network is able to make this prediction without having to look at the input image. as such, these attention maps may aid debugging mistakes in the network and allow the network to suggest alternative solutions. to automatically classify images, we use a multi-head deep residual attention network 58 with a single backbone and four output heads, one for each parameter. this network has two main components. the first is a resnet 59 with 18-layer blocks with residual connections between successive layers. this architecture has the ability to efficiently learn higher resolution features whilst being light-weight, easy to train, and fast to run. the second component is a single output head that classifies the input image for each parameter. its purpose is to extract multi-parameter features from the resnet and generate predictions from these to produce high-resolution feature representations for each parameter. for multi-head networks, multi-class predictions require only a single output head but, as we have four different labels, we have four different output heads. each output head contains three output neurons for classifying the input as low, good, or high. we found that there are significant improvements to the feature extraction by using resnet layers. 5ec8ef588b

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