		Print Settings						Filament Settings							Printer Settings							Actual Printer	Results											
Test Num	Test File	System Preset	Only Retract when crossing perimeters	avoid crossing perimeters	external perimeters first	Top Solid Layers	Bottom Solid Layers	Filament File	MVS	nozzle temp 1st	nozzle temp rest	Bed Temp	AutoCool	Fan Cooling	Bridging Fan Speed	Physical Printer	Retraction Length	Retraction Speed	Wipe While Retracting	Lift Height	Retract on layer change	Use Firmware Retraction	Idle Screws	Quality	Stringing	Blobs/Zits	Fingers	Gouges	Bed Adhesion	Layer Strength	Bridging	Geometry	Surface Quality	Print Finished	Observations
1	retractionTowersv4	0.20mm SPEED @MK4IS 0.4	OFF	OFF	OFF	5	4	Amazon Basics TPU @ MK4	4	235	235	50	ON	50	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.2	40	ON	0.2	ON	OFF	Loosen 2 turns	-2.1	-4	-1	-3	0	-2	0	NA	-3	-4	Y	Popping noise
2	retractionTowersv4	0.20mm SPEED @MK4IS 0.4	OFF	OFF	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	225	225	50	ON	30	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.2	40	ON	0.2	ON	OFF	Loosen 2 turns	-2.3	-4	-2	-4	0	-2	0	NA	-2	-4	Y	
3	retractionTowersv4	0.20mm SPEED @MK4IS 0.4	OFF	OFF	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	205	205	50	ON	30	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.2	40	ON	0.2	ON	OFF	Loosen 2 turns	-1.0	-3	-1	0	0	-2	0	NA	-1	-1	Y	
4	retractionTowersv4	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	195	195	50	ON	30	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.2	40	ON	0.2	ON	OFF	Loosen 2 turns	-0.8	-2	0	0	0	-2	0	NA	-1	-1	Y	
5	retractionTowersv4	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	185	185	50	ON	20	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.4	50	ON	0.1	ON	OFF	Loosen 2 turns	-0.6	-1	0	0	0	-2	0	NA	-1	-1	Y	Stringing worst on one of the towers
6	retractionTowersv4	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	175	175	50	ON	30	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.4	55	ON	0.05	ON	OFF	Loosen 2 turns	-4.1	-1	0	0	-3	-2	-4	NA	-4	-4	N	Clogged extruder
7	retractionTowersv4	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	185	185	35	OFF	NA	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.4	55	ON	0.05	ON	OFF	Loosen 2 turns	-1.1	0	0	0	-2	-1	0	NA	-4	-2	Y	
8	retractionTowersv4	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	5	4	Amazon Basics TPU @ MK4 modified	4	190	190	30	ON	10	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.4	55	ON	0.05	ON	OFF	Loosen 2 turns	-0.8	-2	0	0	0	-1	0	NA	-2	-1	Y	
9	retractionTowersv4	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	ON	5	4	Amazon Basics TPU @ MK4 modified	4	187	187	30	OFF	NA	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	2	55	ON	0.05	ON	OFF	Loosen 2 turns	-1.4	0	-1	0	-2	-1	0	NA	-4	-3	Y	
10	retractionTowersv5	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	ON	3	4	Amazon Basics TPU @ MK4 modified	3	190	190	30	ON	20	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	2	55	OFF	0.05	OFF	ON	Loosen 2 turns	-1.7	-4	-2	-4	0	-1	0	-1	-1	-2	Y	
11	retractionTowersv5	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	4	4	Amazon Basics TPU @ MK4 modified	4	190	190	25	ON	20	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.4	55	ON	0.1	ON	OFF	Loosen 2 turns												
12	retractionTowersv5	0.20mm SPEED @MK4IS 0.4 modified	ON	ON	OFF	4	4	Amazon Basics TPU @ MK4 modified	4	190	190	25	ON	20	100	MakrSpacrMK4 * Original Prusa MK4 Input Shaper 0.4 nozzle - Copy Modified	1.4	55	ON	0.1	ON	OFF	Loosen 2 turns												

Saved settings for each file for AmazonBasicTPU