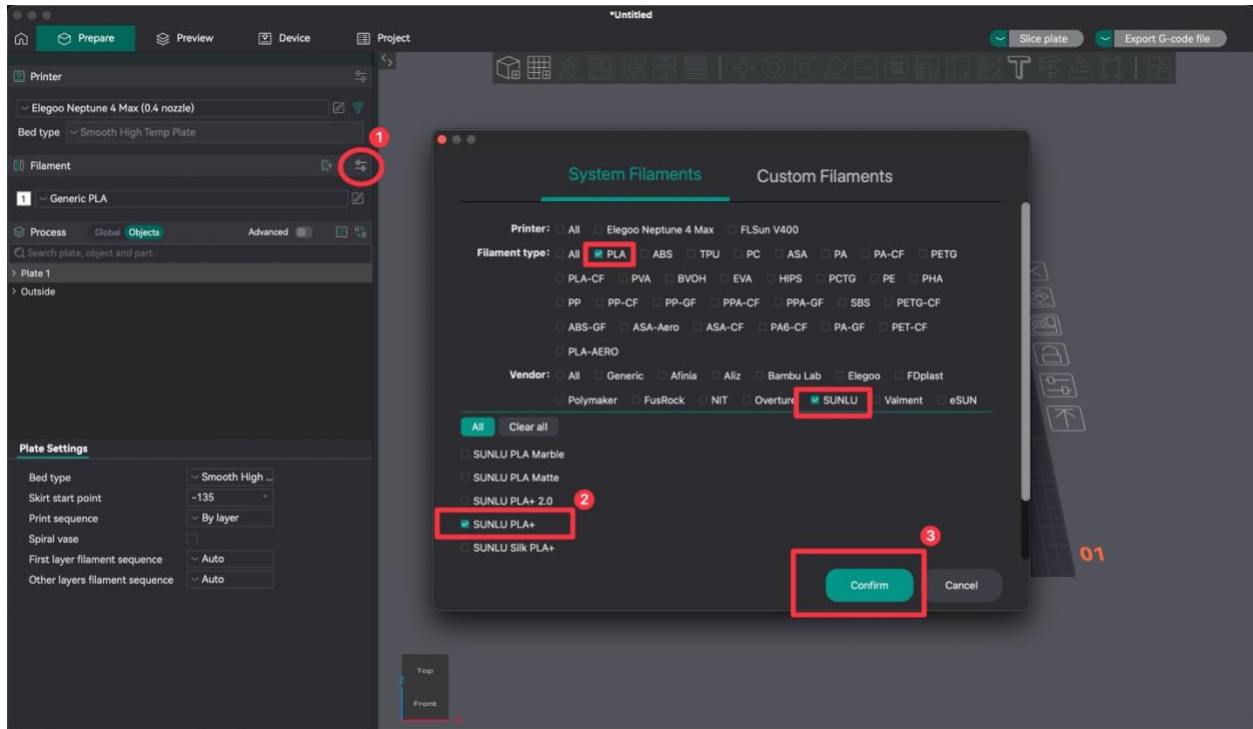


Sunlu Meta PLA settings

STEP 0

Make sure to enable the built in **SUNLU PLA+** filament profile. As this profile builds on it.

Open an empty project, then:



A central concept in OrcaSlicer's profile architecture is inheritance. This means that profiles can derive settings from other "parent" profiles, forming a hierarchical structure. For example, a specific filament profile like "Sunlu PLA Basic Matte" might inherit most of its base properties from a broader "Generic PLA" profile.

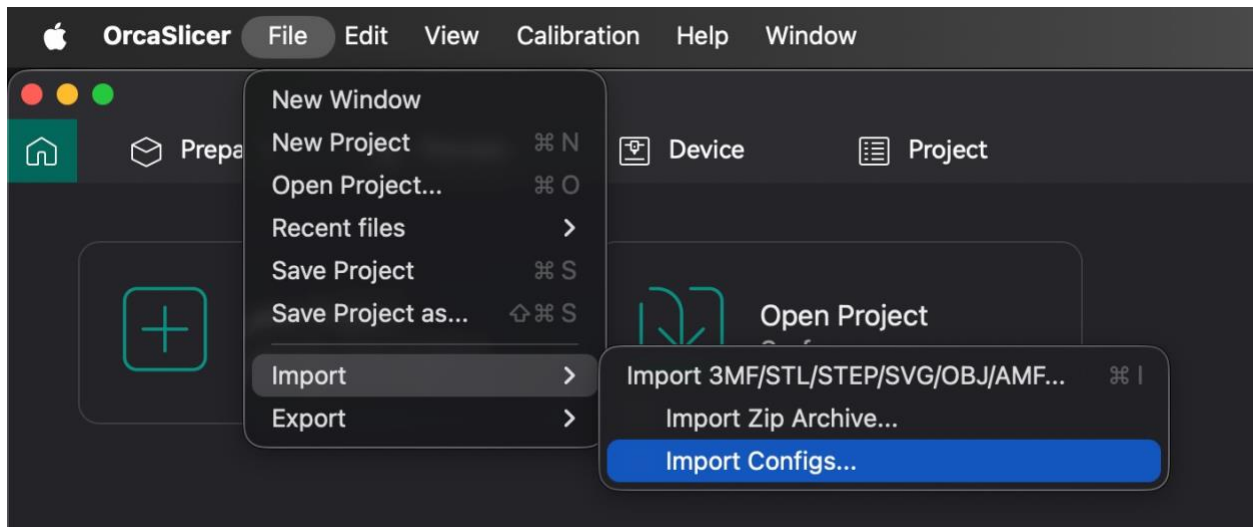
More on this:

<https://www.obico.io/blog/orcaslicer-comprehensive-profile-management-guide/#the-power-of-inheritance>

Step 1

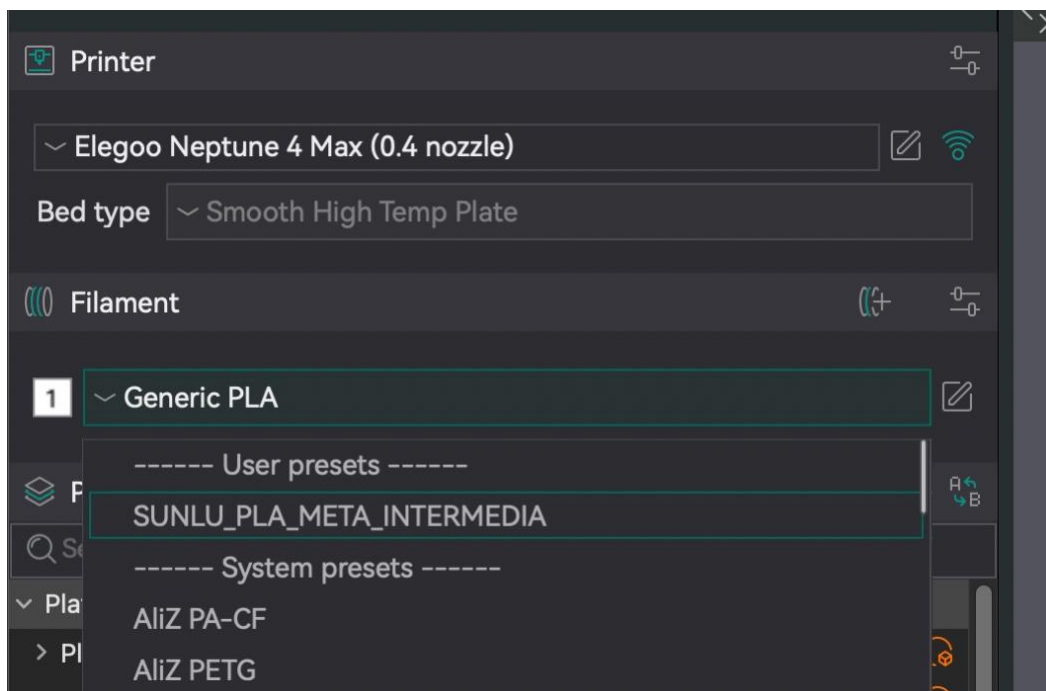
Import the provided .JSON file.

File -> Import -> Import configs



Step 2

Select the installed filament profile.



Done.

The modified settings are:

Filament -> Flow ratio and Pressure advance:

Flow ratio **0.95**

Enable pressure advance

Pressure advance **0.025**

Filament -> Print temperature

First layer **230 °C**

Other layers **225 °C**

The manufacturer's recommended range is 215-225°C.

I tested the range of 190-230°C, the performance was nearly the same across all temps. [Lower, if you notice stringing.](#)

Filament -> Volumetric speed limitation

Max volumetric speed **25 mm³/s**

[Lower, if you notice layer adhesion issues.](#)