

P-47 THUNDERBOLT “BUBBLE TOP” 600mm PRINT SETTINGS

These settings are created using results obtained from testing using a **Bowden style printer** with **Colourfabb LW-PLA** filament. If using other styles of printer or brands of filament, the results could vary.

Settings for LW-PLA parts:

Nozzle temp = 250c
Bed temp = 60c
Nozzle diameter = 0.4mm
Extruder multiplier = 0.35
Extrusion width = .042
Retraction distance = 6mm
Extra restart distance = 0.45mm
Retraction speed = 150mm/s
Layer height = 0.2mm
First layer height = 100%

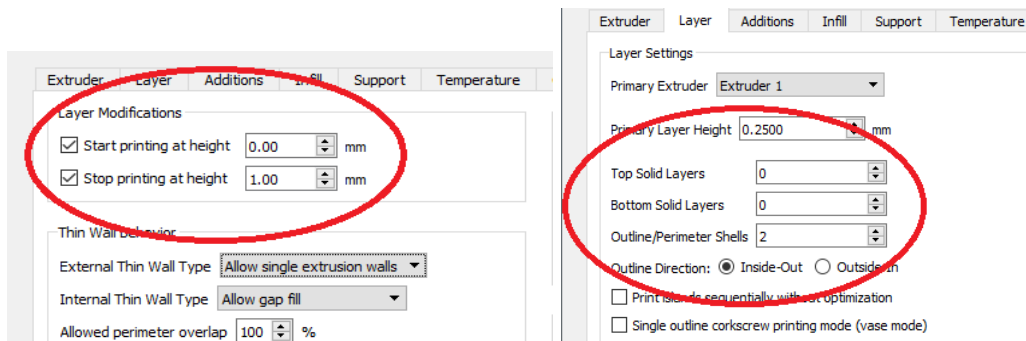
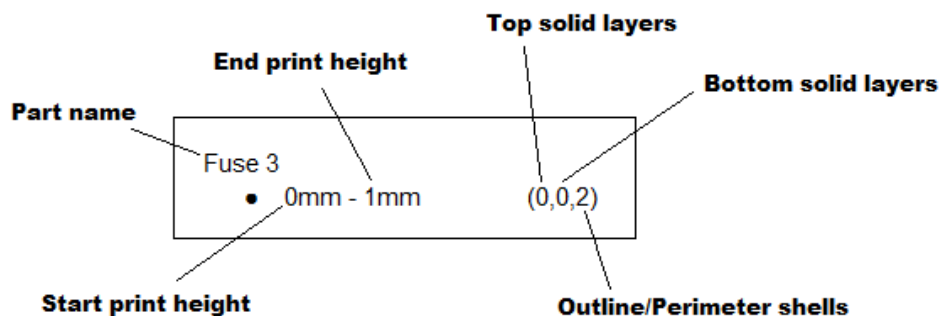
First layer width = 100%
First layer speed = 30%
Print speed = 40mm/s
Outline underspeed = 50%
Solid infill underspeed = 80%
Support structure underspeed = 80%
Cooling fan = 100% for all layers.
Infill percentage is set to 0% unless otherwise stated

Unless otherwise stated, the start point for each layer is set to Y=0mm and x=100mm.

- 100mm on “x” axis for 200mm X 200mm bed (middle of the “x” axis)

Eg **s.p x=100mm** (start point is 100mm along “x” axis)

Example :



LW-PLA PARTS:

Fuse 1

- 0mm - end (2,0,2)

Fuse 2

- 0mm - 4mm (0,50,1)
- 4mm - 57mm (0,0,1)
- 57mm - end (0,0,2)

Fuse 3

- 0mm - 1mm (0,0,2)
- 1mm - 137mm (0,0,1)
- 137mm - end (0,0,2)

Fuse 4

- 0mm - 1mm (0,0,2) *support material required 30% infill, .5mm offset from part*
- 1mm - 168mm (0,0,1) *support material required 30% infill, .5mm offset from part*
- 168mm - end (0,0,2)

Fuse 5

- 0mm - 1mm (0,3,2)
- 1mm - 69mm (0,0,1)
- 69mm - end (0,0,2)

wing inner (NO GEAR)

- 0mm - 4mm (0,0,2)
- 4mm - 131mm (0,0,1)
- 131mm - end (0,0,2)

wing inner (WITH GEAR SLOT)

- 0mm - 4mm (0,0,2)
- 4mm - 39.5mm (0,0,1)
- 39.5mm - 45mm (3,3,1)
- 45mm - 131mm (0,0,1)
- 131mm - end (0,0,2)

Wing middle

- 0mm - 1mm (0,0,2)
- 1mm - 109mm (0,0,1)
- 109mm - end (0,0,2)

Wingtips

- 0mm - end (2,0,2)

Canopy front

- 0mm - 1mm (0,0,2)
- 1mm - 90mm (0,0,1)
- 90mm - end (2,0,1)

Horizontal stabilizer

- 0mm - 2mm (0,0,2)
- 2mm - 110mm (0,0,1)
- 110mm - end (2,0,2)

Elevator inner

- 0mm - end (0,500,1)

Elevator outer

- 0mm - 2mm (0,20,1)
- 2mm - end (0,0,1)

Ailerons inner

- 0mm - 2mm (0,20,1)
- 2mm - end (0,0,1)

Rudder top

- 0mm - 2mm (0,20,1)
- 2mm - end (0,0,1)

Rudder bottom

- 0mm - 2mm (0,20,1)
- 2mm - end (2,0,2) @ 100% infill

Settings for PLA parts:

Nozzle temp = 215c
Bed temp = 45c
Nozzle diameter = 0.4mm
Extruder multiplier = 1.0
Extrusion width = .042
Retraction distance = 4mm
Extra restart distance = 0.3mm
Retraction speed = 150mm/s
Layer height = 0.2mm
First layer height = 100%
First layer width = 100%
First layer speed = 30%
Print speed = 50mm/s
Outline underspeed = 50%
Solid infill underspeed = 80%
Support structure underspeed = 80%
Cooling fan = 100% for all layers.
Infill percentage is set to 0% unless otherwise stated

PLA PARTS:

Motor mount

- 0mm - end (0,500,2)

Propeller blade

- 0mm - end (0,500,1) (*support material required 25% infill, .3mm offset from part* **printed at 0.1mm layer height**)

Spinner

- 0mm - end (0,0,2) **@ 100% infill** , (**printed at 0.15mm layer height**)

Propeller hub

- 0mm - end (4,4,2) **@ 70% infill** , (**printed at 0.15mm layer height**)

M5 nut

- 0mm - end (0,0,2) **@ 100% infill** , (**printed at 0.15mm layer height**)

Canopy rear **(CLEAR PLA)**

- 0mm - 1mm (0,0,2)
- 1mm - end (0,0,1) **PRINT IN VASE MODE**