

BF109 G10 MESSERSCHMITT 600mm

PRINT SETTINGS

These settings were created from results obtained from testing using a **Bowden style printer** with **Colorfabb LW-PLA** filament. If using other styles of printer or brands of filament, the results could vary. Adjusting the flow rate and retraction settings may be required.

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%

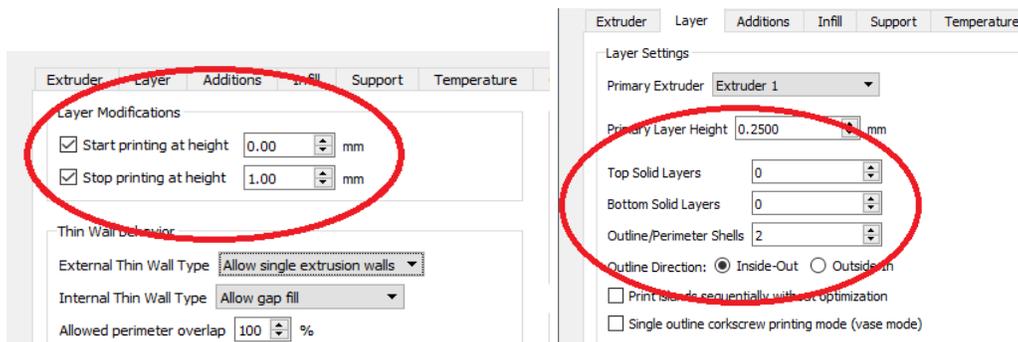
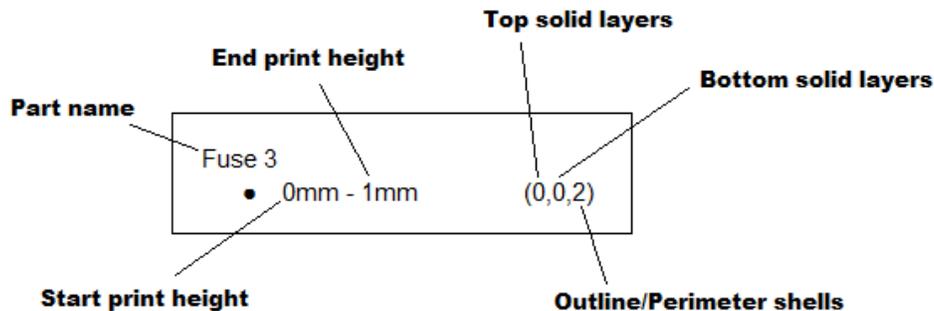
First layer width = 100%
First layer speed = 30%
Print speed = 40mm/s
Outline underspeed = 50%
Solid infill underspeed = 80%
Support structure underspeed = 80%
Cooling fan = 100% for all layers.
Infill percentage is set to 0% unless otherwise stated

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 - 3mm (0,15,1)
- 3mm - 195mm(0,0,1)
- 195mm - end (0,0,2)

Fuse 3

- 0mm - 1mm (0,0,2)
- 1mm - 171mm(0,0,1)
- 171mm - end (0,0,2)

Fuse 4

- 0mm - 2mm (0,2,1)
- 2mm - 81mm (0,0,1)
- 81mm - end (0,0,2)

Wing inner

- 0mm - 4mm (0,0,2)
- 4mm - 155mm(0,0,1)
- 155mm - end (0,0,2)

Wing outer

- 0mm - 1mm (0,0,2)
- 1mm - 74mm (0,0,1)
- 74mm - end (0,0,2)

Wingtips

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

Canopy front

- 0mm - 1mm (0,0,2)
- 1mm - 112mm(0,0,1)
- 112mm - end (2,0,2)

Horizontal stabiliser

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

Elevator inner

- 0mm - 1mm (0,5,1) @ 40% infill
- 2mm - end (2,2,1)

Elevator outer

- 0mm - 1mm (0,5,1)
- 1mm - end (0,0,1)

Air intake + radiator scoops

- 0mm - end (0,0,2) *support material required 30% infill, 0.5mm offset from part*

Ailerons inner

- 0mm - 2mm (0,10,1)
- 2mm - end (0,0,1)

Rudder top and bottom

- 0mm - 1mm (0,5,1)
- 1mm - end (0,0,2)

Settings for PLA parts:

Nozzle temp = 215c
Bed temp = 45c
Nozzle diameter = 0.4mm
Extruder multiplier = 1.0 eg. **100% EXT (% indicated if different)**
Extrusion width = .042
Retraction distance = 7mm
Extra restart distance = 0.18mm
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 6x4.5

- 0mm - end *support material required 25% infill, .3mm offset from part*
(0,500,1) **@85% EXT** (**printed at 0.1mm layer height**)

Spinner

- 0mm - end **printed at 0.15mm layer height**
(1,0,2) **@85% EXT @ 100% infill**

Propeller hub

- 0mm - end **printed at 0.15mm layer height**
(3,3,2) **@85% EXT @ 30% infill**

M5 nut

- 0mm - end **printed at 0.15mm layer height**
(0,0,2) **@85% EXT @ 100% infill** ,

Canopy rear (**CLEAR PLA**)

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