

Dornier Do-335 Pfiel 700mm

PRINT SETTINGS

These settings were created from 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. 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%

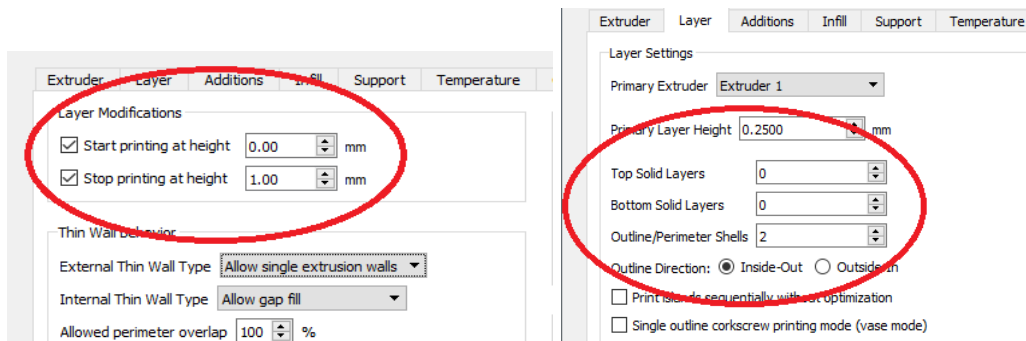
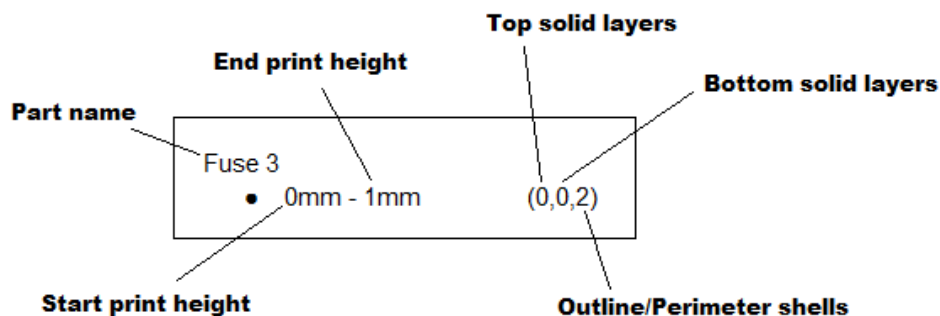
First layer width = 100%
First layer speed = 30%
Print speed = 40mm/s
Outline underspeed = 50%
Solid infill underspeed = 80%
Support structure underspeed = 80%
Cooling fan = 100% for all layers.
Infill percentage is set to 0% unless otherwise stated

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 - 196mm (0,0,1)
- 196mm - end (0,0,2)

Fuse 3

- 0mm - 1mm (0,0,2)
- 1mm - 175mm (0,0,1)
- 175mm - end (0,0,2)

Fuse 4

- 0mm - 4mm (0,0,2)
- 4mm - 141mm (0,0,1)
- 141mm - end (0,0,2)

Fuse 5

- 0mm - 3mm (0,15,1)
- 3mm - 82mm (0,0,1)
- 82mm - end (0,0,2)

Fuse 6

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

wing inner

- 0mm - 3mm (0,0,2)
- 3mm - 173mm (0,0,1)
- 173mm - end (0,0,2)

Wing middle

- 0mm - 1mm (0,0,2)
- 1mm - 121mm (0,0,1)
- 121mm - end (0,0,2)

Wingtips

- 0mm - 1mm (0,0,2)
- 1mm - 14mm (0,0,1)
- 14mm - end (3,0,2)

Canopy front

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

Canopy rear

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

Horizontal stabilizers

- 0mm - 1mm (0,0,2)
- 1mm - 115mm (0,0,1)
- 115mm - end (3,0,2)

Vertical stabilizers

- 0mm - 4mm (0,4,2)
- 4mm - 60mm (0,0,1)
- 60mm - end (3,0,2)

Elevator inner

- 0mm - 1.5mm (0,8,1)
- 0mm - 1.5mm (2,0,2) @ 40% infill

Elevator middle

- 0mm - 1.5mm (0,8,1)
- 1.5mm - 103mm (0,0,1)
- 103mm - end (0,0,2)

Elevator outer

- 0mm - 1mm (0,5,1)
- 1mm - 10mm (0,0,1)
- 10mm - end (3,0,2)

Ailerons

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

Air intakes

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

Settings for PLA parts:

Nozzle temp = 215c
Bed temp = 45c
Nozzle diameter = 0.4mm
Extruder multiplier = .95
Extrusion width = .042
Retraction distance = 8mm
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** , (*support material required 45% infill, 2mm offset from part* **printed at 0.15mm layer height**)

M5 nut

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

Canopy middle **(CLEAR PLA)**

- 0mm - 1mm (0,0,2)
- 1mm - 83mm (0,0,1)
- 83mm - end (0,0,2)