

# P-47 THUNDERBOLT “RAZORBACK” 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%

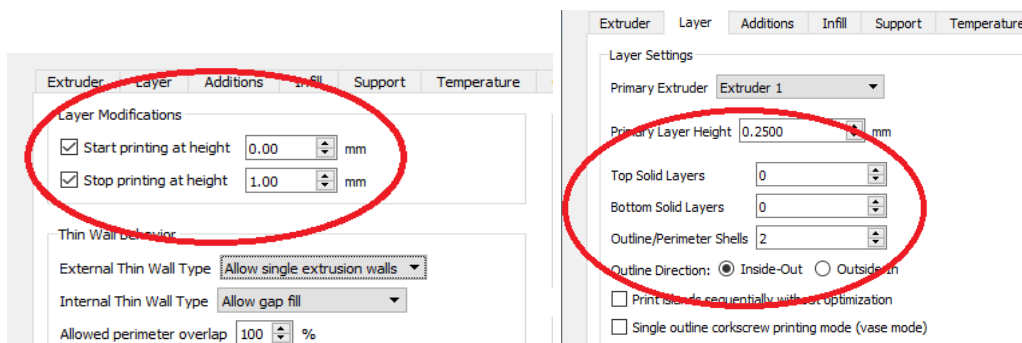
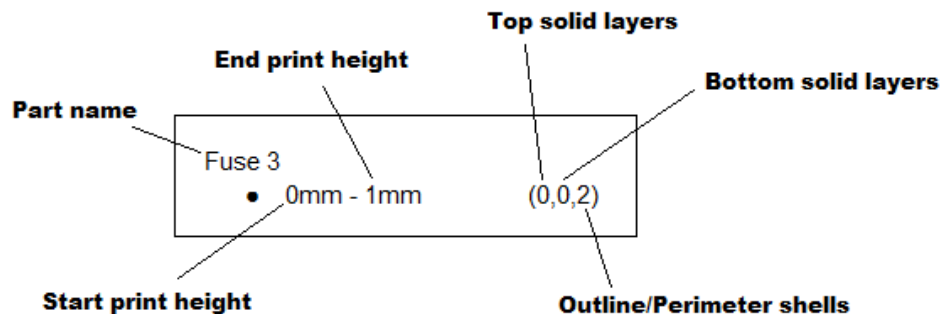
First layer width = 100%  
First layer speed = 30%  
Print speed = 40mm/s  
Outline underspeed = 50%  
Solid infill underspeed = 80%  
Support structure underspeed = 80%  
Cooling fan = 100% for all layers.  
Infill percentage is set to 0% unless otherwise stated

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 - 4mm (0,20,1)
- 4mm - 61mm (0,0,1)
- 61mm - end (0,0,2)

EXT MULTIPLIER = 0.55 or 55%

### Fuse 3

- 0mm - 1mm (0,0,2)
- 1mm - 188mm (0,0,1)
- 188mm - end (0,0,2)

### Fuse 4

- 0mm - 1mm (0,0,2)
- 1mm - 165mm (0,0,1)
- 165mm - 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 - 36mm (0,0,1)
- 36mm - 43mm (3,3,1)
- 43mm - 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 - 65mm (0,0,1)
- 65mm - 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 (0,10,1)
- 2mm - end (0,0,1)

#### Ailerons inner

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

#### Rudder top

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

#### Rudder bottom

- 0mm - 2mm (0,10,1)
- 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** , (*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 rear **(CLEAR PLA)**

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