

STINGRAY 800mm

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 PLA parts:

Nozzle temp = 215c

Bed temp = 45c

Nozzle diameter = 0.4mm

Extruder multiplier = 1.0

Extrusion width = .042

Retraction distance = 7mm

Extra restart distance = 0.18mm

Retraction speed = 150mm/s

Coast at end = 0.5mm

Wipe nozzle = 2mm

Layer height = 0.25mm

First layer height = 100%

First layer width = 100%

First layer speed = 20%

Print speed = 60mm/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

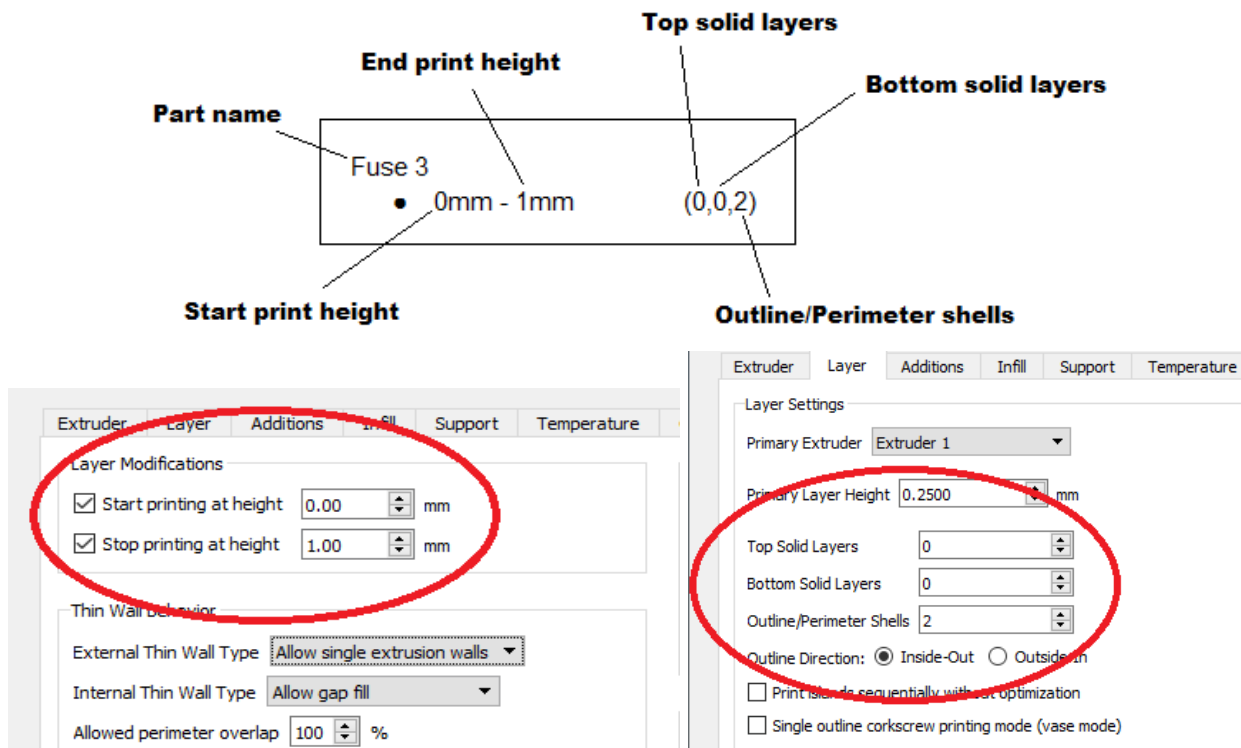
Outline direction = inside to outside

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)

Key for part layer height settings:



Fuse 1

- 0mm - 1mm (0,0,2)
- 1mm - 45mm (0,0,1)
- 45mm - end (2,0,2)

Fuse 2

- 0mm - 1mm (0,0,2)
- 1mm - 125mm (0,0,1)
- 125mm - end (0,0,2)

Fuse 3

- 0mm - 1mm (0,0,2)
- 1mm - 179mm (0,0,1)
- 179mm - end (0,0,2)

Fuse 4

- 0mm - 1mm (0,0,2)
- 1mm - 34.5mm (0,0,1)
- 34.5mm - 40mm (3,0,1)
- 40mm - 90mm (0,0,1)
- 90mm - 96mm (0,3,1)
- 96mm - 128mm (0,0,1)
- 128mm - endmm (0,0,2)

Fuse 5

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

Fuse 6

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

Servo covers and motor mount

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

Tail boom center

- 0mm - 1mm (0,0,2)
- 1mm - 176mm (0,0,1)
- 176mm - end (0,0,2)

Tail boom 1

- 0mm - 1mm (0,0,2)
- 1mm - 120mm (0,0,1)
- 120mm - end (0,0,2)

Tail boom 2

- 0mm - 1mm (0,0,2)
- 1mm - 191mm (0,0,1)
- 191mm - end (0,0,2)

Tail boom 3

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

Wing 1 rear left

s.p x= closest corner to trailing edge

- 0mm - 2mm (0,0,2)
- 2mm - 46mm (0,0,1)
- 46mm - 87mm (0,0,1) support structure required @ 30% with 1mm resolution
- 87mm - end (0,0,2) support structure required @ 30% with 1mm resolution

Wing 1 rear right

s.p x= closest corner to trailing edge

- 0mm - 2mm (0,0,2)
- 2mm - 87mm (0,0,1)
- 87mm - end (0,0,2)

Wing 2

s.p x= closest corner to trailing edge

- 0mm - 1mm (0,0,2)
- 1mm - 126mm (0,0,1)
- 126mm - end (0,0,2)

Wing 3

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

Wingtips

- 0mm - 1mm (0,0,2)
- 1mm - 30mm (0,0,1)
- 30mm - end (2,0,2)

Canopy

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

Ailerons and Elevator

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