

TRACER 2000

PRINT SETTINGS

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 = 0.2mm
 Retraction speed = 150mm/s
 Coast at end = 0.5mm
 Wipe nozzle = 2mm
 Layer height = 0.25mm

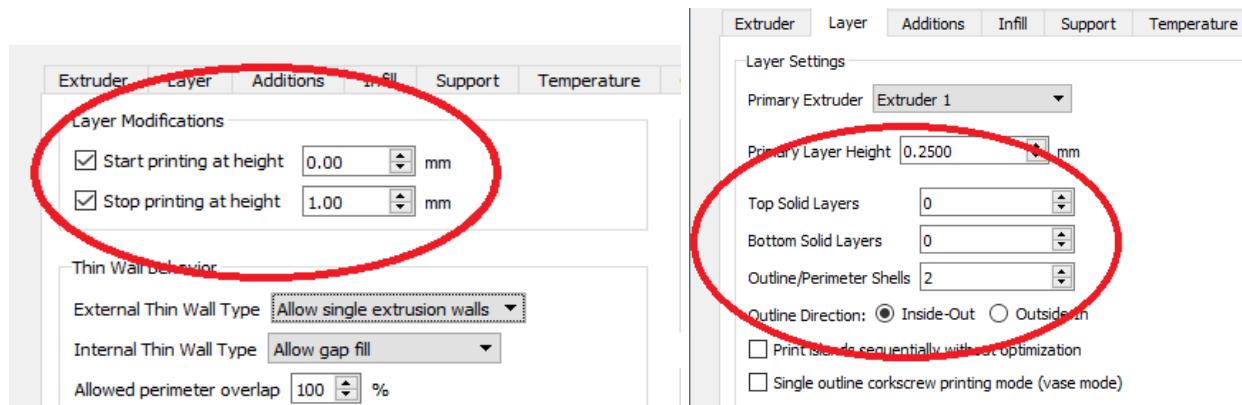
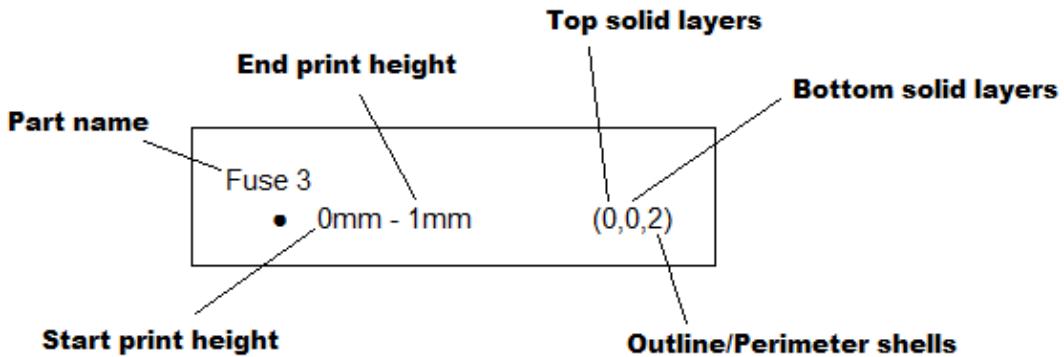
First layer height = 100%
 First layer width = 100%
 First layer speed = 20%
 Print speed = 60mm/s
 Outline underspeed = 50%
 Solid infill underspeed = 80%
 Support structure underspeed = 80%
 Cooling fan = 100% for all layers.
 Infill percentage is set to 0% unless otherwise stated
 Outline direction = 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 - end (0,0,2)

Fuse 2

- 0mm - 3mm (0,12,1)
- 3mm - end (0,0,1)

Fuse 3

- 0mm - 1mm (0,0,2)
- 1mm - 90mm (0,0,1)
- 90mm - end (0,0,3)

Outline direction = outside to inside

Fuse 4

- 0mm - 1mm (0,0,2)
- 1mm - 14mm (0,0,1)
- 14mm - 15mm (3,0,1)
- 15mm - end (0,0,1)

Fuse 5

- 0mm - 2mm (0,0,2)
- 2mm - 176mm (0,0,1)
- 176mm - end (0,0,3)

Outline direction = outside to inside

Fuse 6

- 0mm - 2mm (0,0,2)
- 2mm - 95mm (0,0,1)
- 95mm - end (2,0,2)

Servo covers and servo tray

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

printed at .15mm layer height

Extruder multiplier = 0.95

Aileron inner

- 0mm - 2mm (0,8,1)
- 2mm - 146mm (0,0,1)
- 146mm - end (0,0,2)

Aileron middle

- 0mm - 2mm (0,0,2)
- 2mm - 148mm (0,0,1)
- 148mm - end (0,0,2)

Aileron outer

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

Canopy front and rear

- 0mm - 1mm (0,0,2)
- 1mm - 171mm(0,0,1)
- 171mm - end (3,0,1)

Elevators

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

Propeller blades

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

printed at .1mm layer height

Use raft and support, **see image # 1 and 3**

Propeller hub

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

printed at .15mm layer height

Use raft and support, **see image # 1 and 4**

Propeller spinner

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

printed at .15mm layer height

Use raft and support, **see image # 1 and 4**

Vertical stabilisers

- 0mm - 184mm(0,0,1)
- 184mm - end (0,0,2)

Vertical stabiliser tips

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

V-tail hub

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

infill = 30%

Wing 1

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

Use raft, **see image # 2**

Wing 2

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

Use raft, **see image # 2**

Wing 3

- 0mm - 1mm (0,0,2)
- 1mm - 148mm(0,0,1)
- 148mm - end (0,0,2)

Use raft, **see image # 2**

Wing 4

- 0mm - 1mm (0,0,2)
- 1mm - 148mm(0,0,1)
- 148mm - end (0,0,2)

Use raft, **see image # 2**

Wing 5

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

Use raft, **see image # 2**

Wing 6

- 0mm - 2mm (0,0,2)
- 2mm - 128mm (0,0,1)
- 128mm - end (0,0,2)

Use raft, **see image # 2**

Wing 7

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

Use raft, **see image # 2**

image # 1

Use Raft

Raft Extruder	Extruder 1
Raft Top Layers	2
Raft Base Layers	0
Raft Offset from Part	2.50 mm
Separation Distance	0.20 mm
Raft Top Infill	100 %
Above Raft Speed	30 %

image # 2

Use Raft

Raft Extruder	Extruder 1
Raft Top Layers	2
Raft Base Layers	0
Raft Offset from Part	6.00 mm
Separation Distance	0.15 mm
Raft Top Infill	100 %
Above Raft Speed	30 %

image # 3

Support Material Generation	
<input checked="" type="checkbox"/> Generate Support Material	
Support Extruder	Extruder 1
Support Infill Percentage	30 %
Extra Inflation Distance	1.00 mm
Support Base Layers	0
Combine Support Every	1 layers
Dense Support	
Dense Support Extruder	Extruder 1
Dense Support Layers	0
Dense Infill Percentage	70 %
Automatic Placement	
Only used if manual support is not defined	
Support Type	Normal
Support Pillar Resolution	1.00 mm
Max Overhang Angle	45 deg
Separation From Part	
Horizontal Offset From Part	0.20 mm
Upper Vertical Separation Layers	1
Lower Vertical Separation Layers	1
Support Infill Angles	
0 deg	0 90
Add Angle	
Remove Angle	

image # 4

Support Material Generation	
<input checked="" type="checkbox"/> Generate Support Material	
Support Extruder	Extruder 1
Support Infill Percentage	50 %
Extra Inflation Distance	0.50 mm
Support Base Layers	0
Combine Support Every	1 layers
Dense Support	
Dense Support Extruder	Extruder 1
Dense Support Layers	0
Dense Infill Percentage	70 %
Automatic Placement	
Only used if manual support is not defined	
Support Type	Normal
Support Pillar Resolution	3.00 mm
Max Overhang Angle	45 deg
Separation From Part	
Horizontal Offset From Part	2.00 mm
Upper Vertical Separation Layers	1
Lower Vertical Separation Layers	1
Support Infill Angles	
0 deg	90 0
Add Angle	
Remove Angle	