

BLUE ANGEL

PRINT SETTINGS for 200x200x200 bed

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

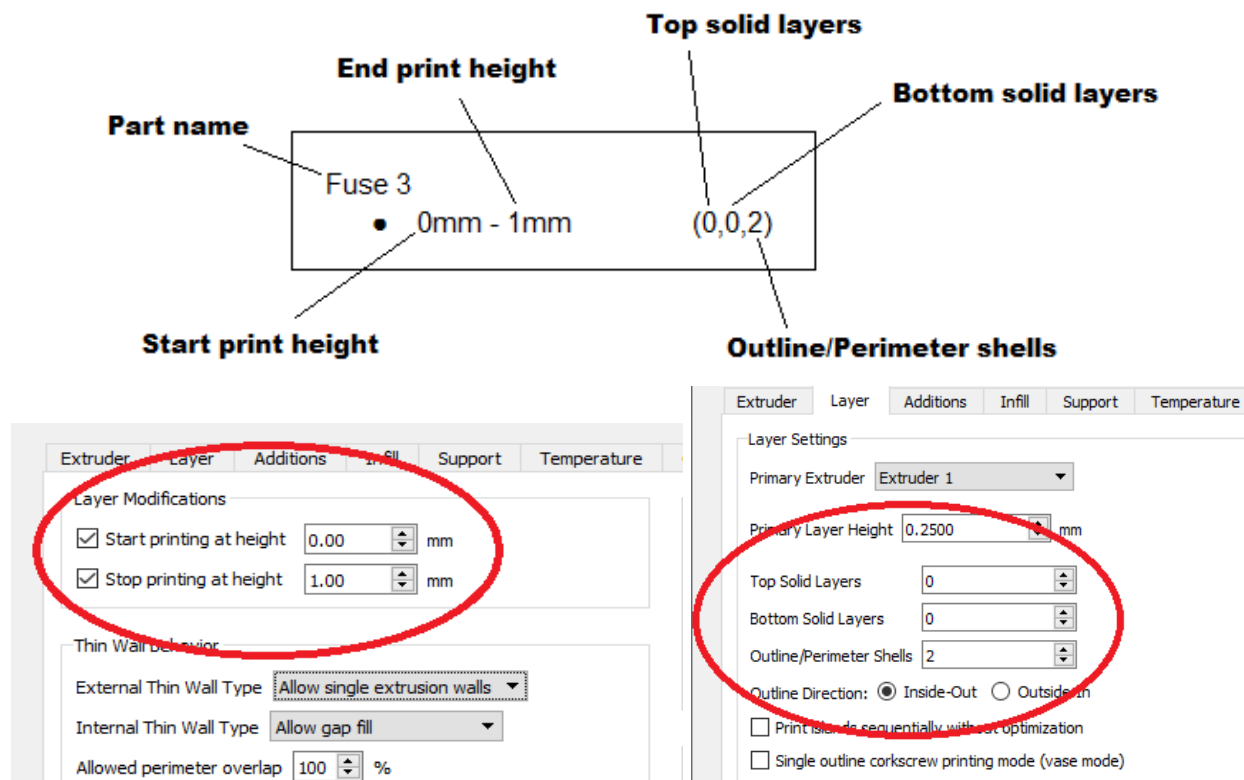
First layer height = 100%
First layer width = 100%
First layer speed = 20%
Print speed = 60mm/s
Outline underspeed = 50%
Solid infill underspeed = 80%
Support structure underspeed = 80%
Cooling fan = 100% for all layers.
Infill percentage is set to 0% unless otherwise stated
Outline direction = inside 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 - 48mm (0,0,1)
- 48mm - end (0,0,2)

Fuse 2

- 0mm - 4mm (0,16,1)
- 4mm - 135mm (0,0,1)
- 135mm - end (0,0,3)

Outline direction = outside to inside

Fuse 3

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

Fuse 4

- 0mm - 169mm (0,0,1)
- 169mm - end (0,0,3)

Outline direction = outside to inside

Fuse 5

- 0mm - 181mm (0,0,1)
- 181mm - end (0,0,3)

Outline direction = outside to inside

Fuse 6

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

Outline direction = outside to inside

Fuse 7

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

Servo covers

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

printed at .15mm layer height

Extruder multiplier = 0.95

Canopy front

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

Canopy rear

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

Aileron inner 1

- 0mm - 98mm (0,0,1)
- 98mm - end (0,0,2)

Aileron middle 2

- 0mm - 2mm (0,8,1)
- 2mm - 115mm (0,0,1)
- 115mm - end (0,0,2)

Aileron middle 3

- 0mm - 2mm (0,8,1)
- 2mm - 163mm (0,0,1)
- 163mm - end (0,0,2)

Aileron outer 4

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

Elevator inner

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

Elevator middle

- 0mm - 2mm (0,8,1)
- 2mm - 116mm (0,0,1)
- 116mm - end (0,0,2)

Elevator outer

- 0mm - 1mm (0,0,2)
- 1mm - 99mm (0,0,1)
- 99mm - end (0,0,2)

Fuselage belly plate

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

Horizontal stabiliser inner

- 0mm - 1mm (0,0,2)
- 1mm - 156mm (0,0,1)
- 156mm - end (0,0,3)

Outline direction = outside to inside

Horizontal stabiliser outer

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

Horizontal stabiliser tip

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

Nose gear steering arm, nose gear washers and main gear locks

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

Motor mount

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

Rudder lower

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

Rudder upper

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

Propeller hub and spinner

printed at .15mm layer height/Extruder multiplier = 0.95

- 0mm - end (0,500,1) Use support, **see image # 4**

Wing inner

Use raft, **see image # 2**

- 0mm - 3mm (0,12,1)
- 3mm - 166mm (0,0,1)
- 166mm - end (0,0,3)

Outline direction = outside to inside

Wing middle

Use raft, **see image # 2**

- 0mm - 188mm (0,0,1)
- 188mm - end (0,0,3)

Outline direction = outside to inside

Wing outer

Use raft, **see image # 2**

- 0mm - 175mm (0,0,1)
- 175mm - end (0,0,3)

Outline direction = outside to inside

Wing tip

Use raft and support, **see image # 2 and 3**

- 0mm - 3.5mm (0,0,1)
- 3.5mm - end (4,2,2)

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

☒ 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

☒ 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