EN

PRINTING & CONSTRUCTION MANUAL

PLANE PRINT.com

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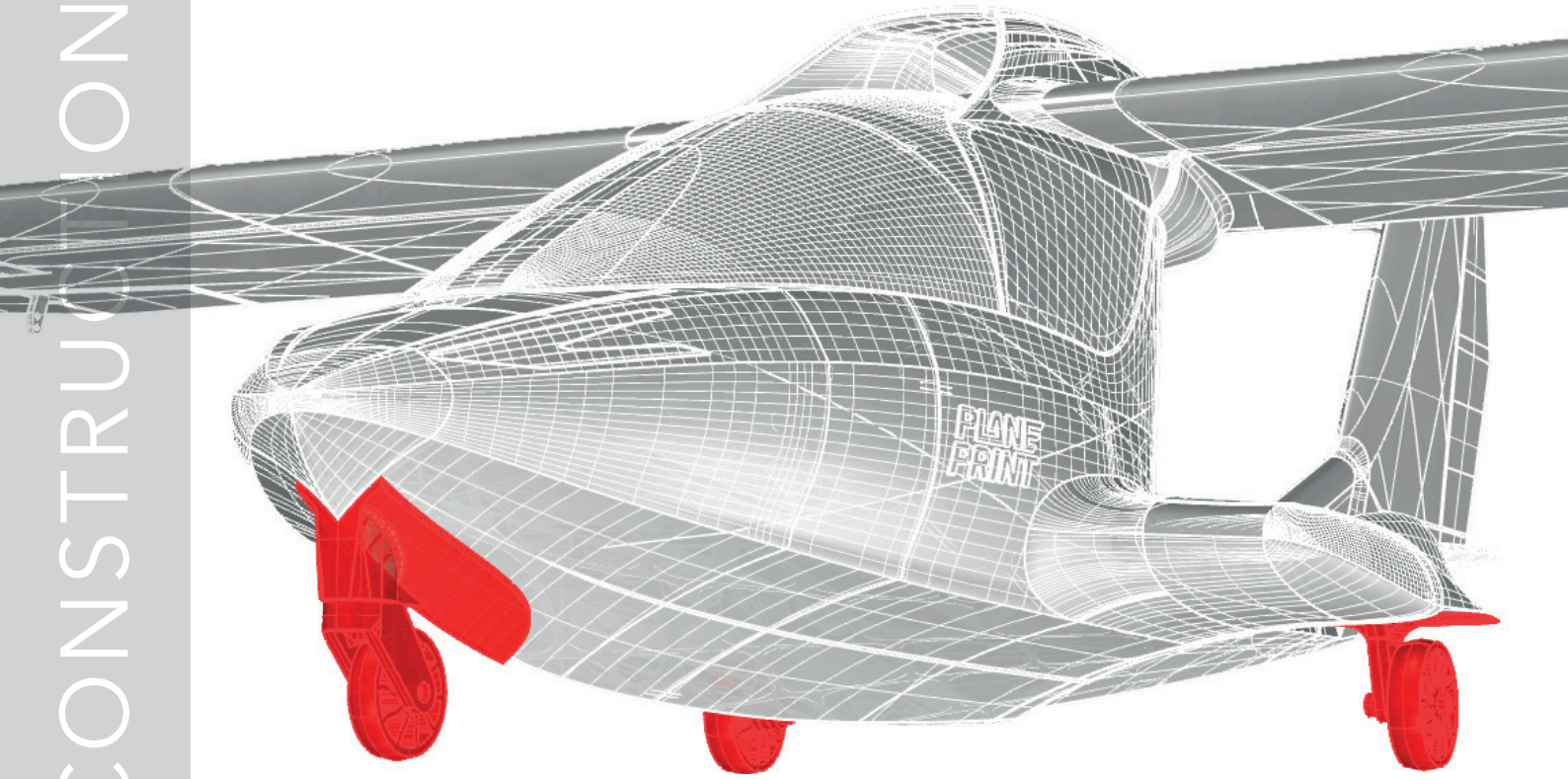


ICON A5 LANDING GEAR

- Is subsequently attached with double-sided adhesive tape
- No Servo needed (The nose wheel does not require active steering, a little engine speed is enough for the rudder to exert its steering effect.
- PLA and FLEX TPU needed

WATCH OUT!
This 3D print model is specially optimized for CURA.

FAIR USE DATA ©

STL DATA FOR DOWNLOADING AT **www.planeprint.com**

V1.0/12-2019

CREATION OF THE PRINTING PROFILES

PROFILE P1_FULLBODY

Start with an new and unmodified CURA PLA profile when creating any of the following profiles. You must use a **0.4 mm nozzle** in all cases. Modify the CURA profile with the following parameters and save each profile with the suggested name.

QUALITY

• Layer Height	0,25 mm
• Line Width	0,40 mm

MATERIAL

• Printing Temperature (all)**	220-225 °C
• Build Plate Temperature	~60 °C

SHELL

• Z Seam Alignment	Sharpest Corner or User Specified*

BUILD PLATE ADHESION

• Build plate Adhesion Type	Skirt

INFILL

• Infill Density	100 %
• Infill Pattern	Grid

MESH FIXES

• Union Overlapping Volumes	Checked

FINISHED! Save these settings under a new profile named **P1_FULLBODY!**

* By entering the coordinates and aligning the components on the print bed, you can place the Z-seam so that it extends along a part edge and becomes almost invisible.

** The high printing temperature is necessary in aircraft models to achieve a stable layer connection. The exact setting varies from printer to printer and must be determined by test prints

CREATION OF THE FOUR PRINTING PROFILES

PROFILE P4_FLEX

Start with an new and unmodified CURA PLA profile when creating any of the following profiles. You must use a **0.4 mm nozzle** in all cases. Modify the CURA profile with the following parameters and save each profile with the suggested name.

QUALITY

• Layer Height	0,25 mm
• Line Width	0,40 mm

MATERIAL

• Printing Temperature (all)**	according to manufacturer
• Build Plate Temperature	according to manufacturer

SHELL

• Wall Line Count	1
• Top Layers	3
• Bottom Layers	3
• Z Seam Alignment	Sharpest Corner or User Specified*

BUILD PLATE ADHESION

• Build plate Adhesion Type	Skirt

FÜLLUNG INFILL

• Infill Density	10 %
• Infill Pattern	Grid

MESH FIXES

• Union Overlapping Volumes	Checked

FINISHED! Save these settings under a new profile named **P4_FLEX!**

* By entering the coordinates and aligning the components on the print bed, you can place the Z-seam so that it extends along a part edge and becomes almost invisible.

** The high printing temperature is necessary in aircraft models to achieve a stable layer connection. The exact setting varies from printer to printer and must be determined by test prints

PRINTING MANUAL

PROFILE P1_FULLBODY

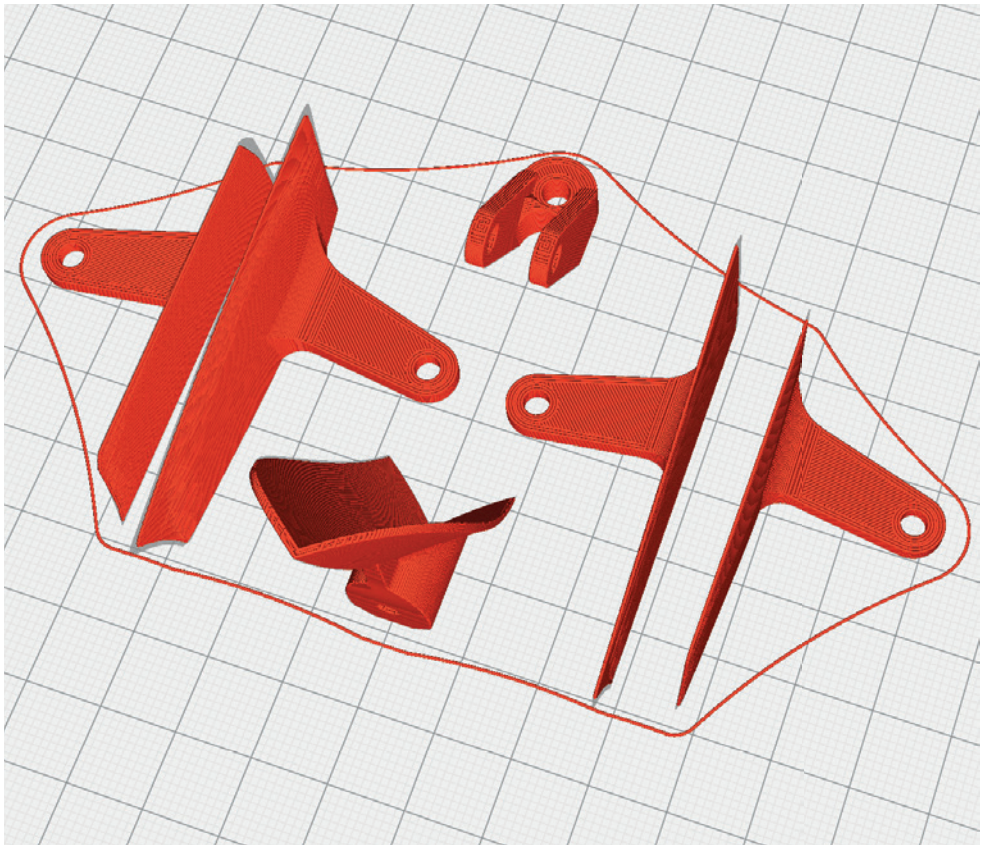
The following parts must be sliced with the profile P1_FULLBODY.
Recommended additional settings are listed in the screenshots.

INFO

STL File: ICON-GEAR-p1.stl
Material: PLA
Weight: ~ 13 g

ADDITIONAL SETTINGS

Use a high nozzle temperature
(~ 230 ° C) for good layer adhesion.

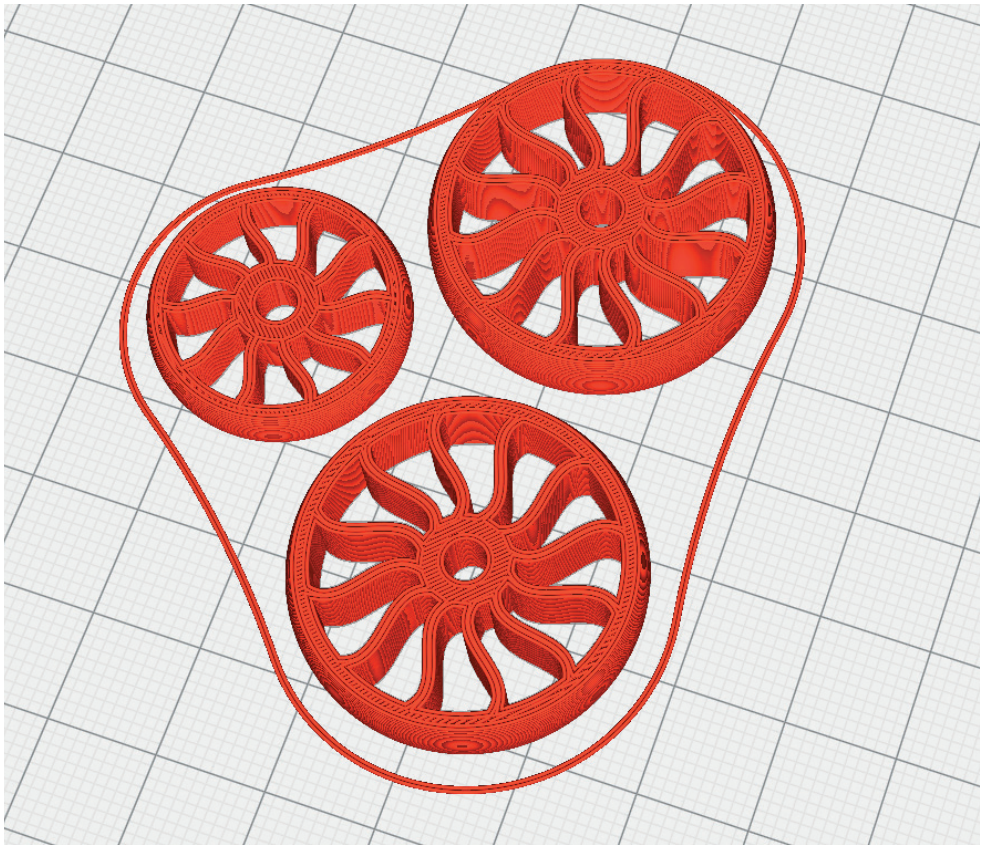


PROFILE P4_FLEX

The following parts must be sliced with the profile PROFILE P4_FLEX (flexible materials).
Recommended additional settings are listed in the screenshots.

INFO

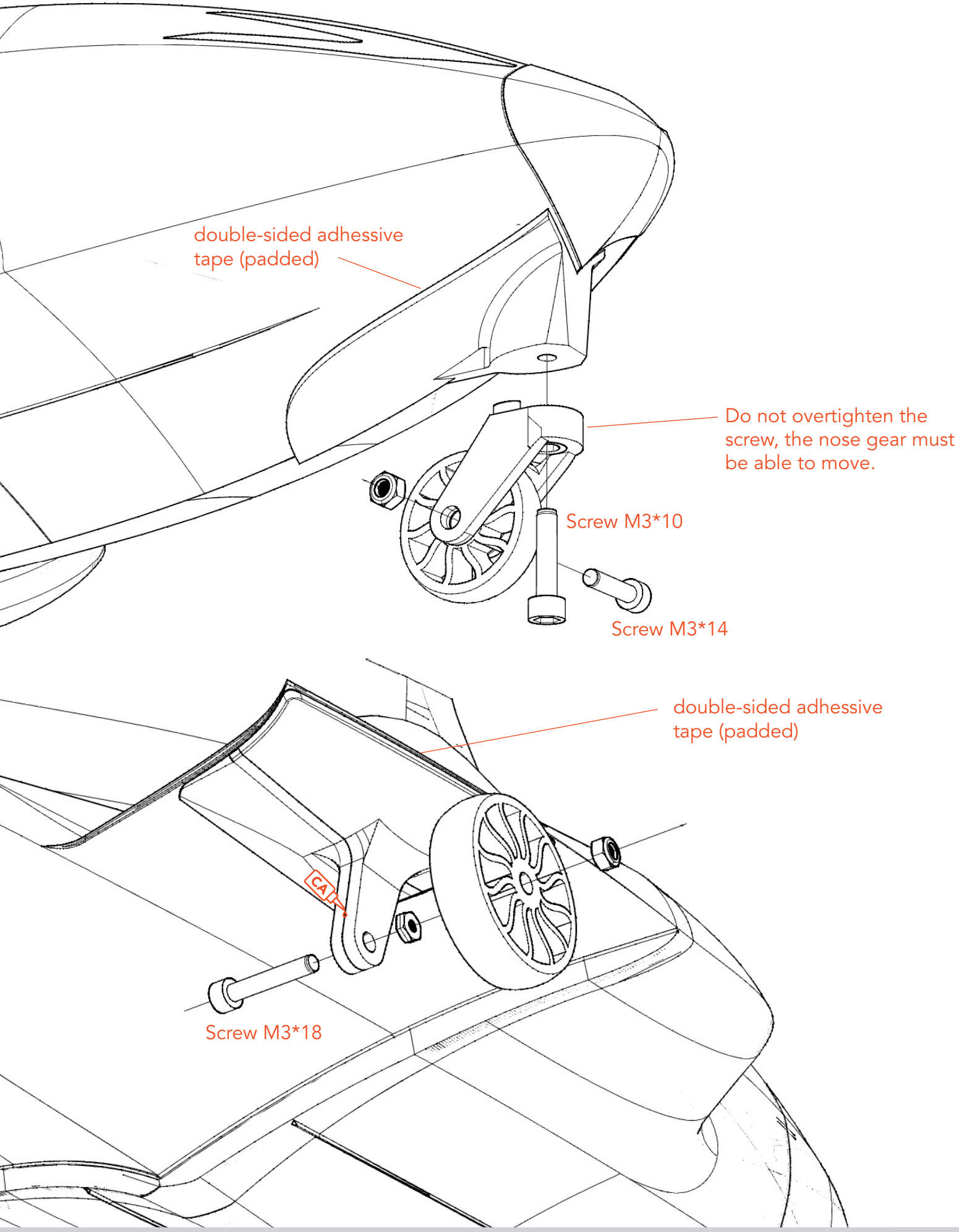
STL file: ICON-WHEELS-p4.stl
Material: TPU soft or middel
Weight: ~ 9 g



ADDITIONAL SETTINGS

Infill Density: 100 %

CONSTRUCTION MANUAL



DETAIL PHOTOS