

# PRINTING THE PARTS – PRINTING PROFILES

Some basic profiles must be created for slicing all Planeprint models.  
Please follow the description at [www.planeprint.com/print](http://www.planeprint.com/print)

However, it can be useful to perfect your 3D printing by making some additional settings depending on the printer and filament used.

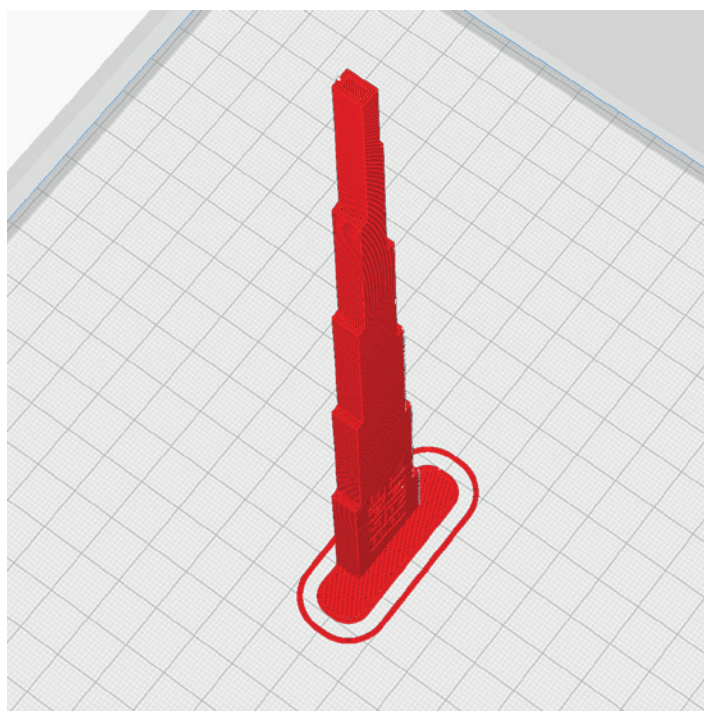
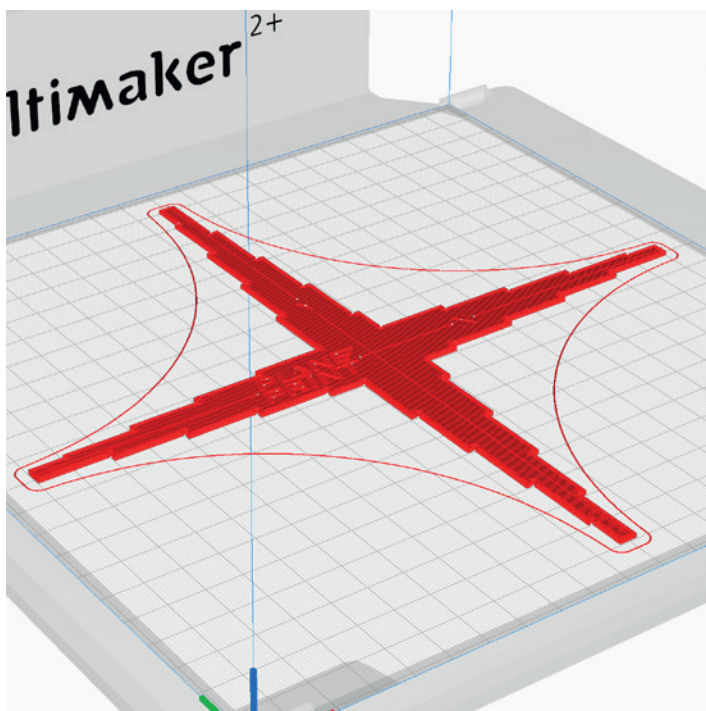
We have tested all profiles and thus get sufficiently stable parts. **Please note that it is solely your responsibility to print parts that are suitable for the safe operation of RC models.** There are many parameters that are not our responsibility (age and quality of the filament, maintenance and quality of the printer and so on...). Please test the settings until you can create sufficiently stable parts! We are not liable for any damage caused by incorrectly printed models.

# Checking the correct calibration of the X, Y and Z axis

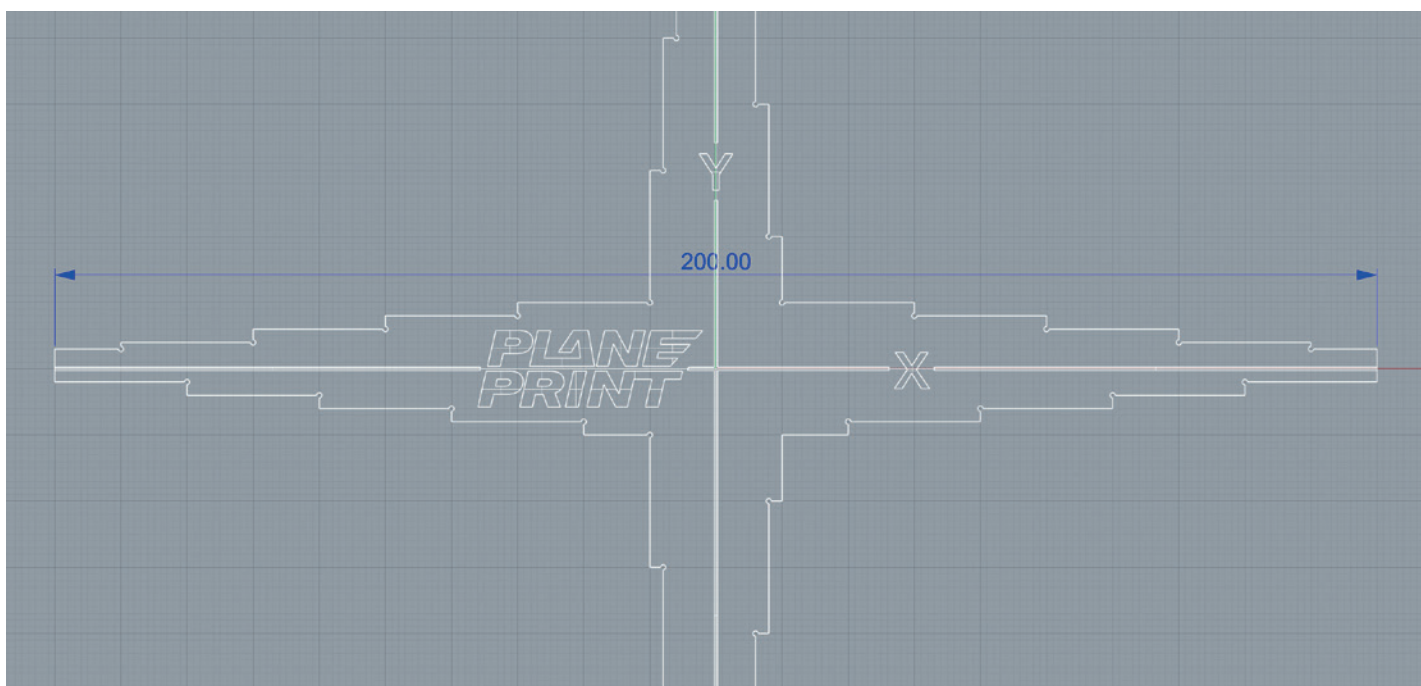
In order to receive **accurately fitting parts in exactly the right size**, we strongly recommend that you calibrate the printer accurately.

First, the **extruder stepper motor should be calibrated** for the correct filament feed rate. There are many tutorials on the Internet.

Secondly, the **three axes should be calibrated**. Use our Calibration Tools for this. Print them (with Profile 2) and measure the distances as accurately as possible. If there are deviations, you can also find tutorials on the Internet on how to calibrate your printer.



The maximum width of the cross and height of the tower must be **exactly 200 mm**. The steps mark the 10 mm pitch (20 mm for the Z tower).



# PROFILE P3 PLA or Tough PLA



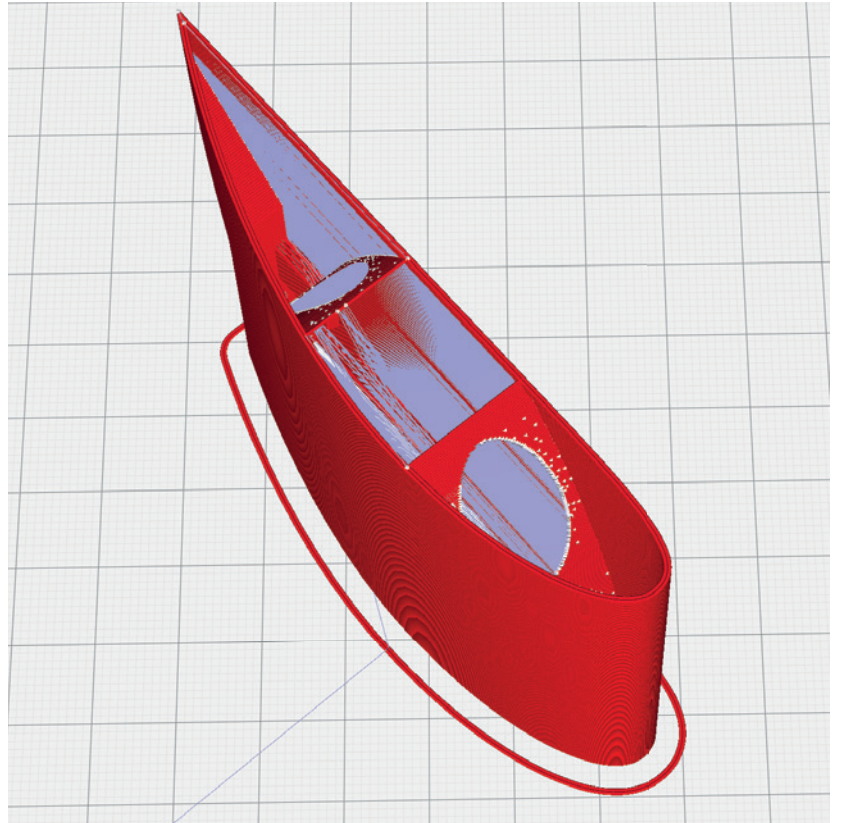
**NOTE** In profile P3\_SURFACE, there should not be more than one STL on the buildplate at the same time, otherwise slicing errors can occur!

## WINGTEST\_P3 PLA\_Planeprint.stl

**MATERIAL** PLA or PLA+, ~ 5 g

### ADDITIONAL SETTINGS

None required

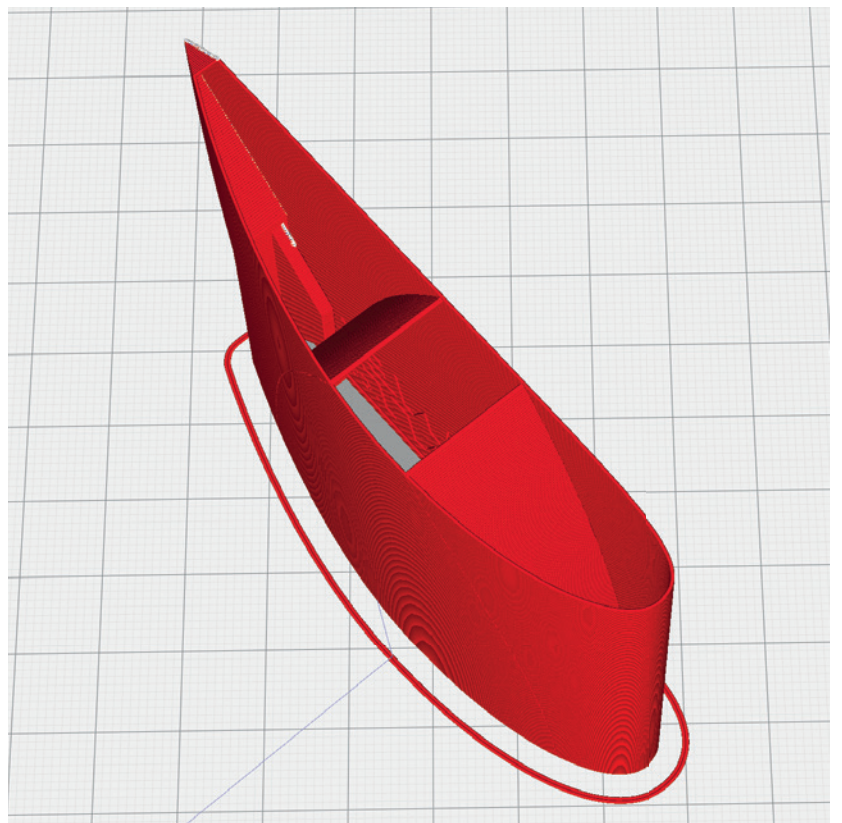


## WINGTEST\_P3 LW\_Planeprint.stl

**MATERIAL** LW-PLA, ~ 3 g

### ADDITIONAL SETTINGS

- Setting Profile3\_Surface
- Flow 60-65 %
- Nozzle temperature 230-240°





# PROFILE P5 Light-Weight LW-PLA!

P5

For the necessary durability it is very important that the LW parts printed with PROFILE\_5 are as stable as possible. Please use a test part to check the strength by breakage tests. It must not break along the layer lines under any circumstances! Also note that the printing temperature for LW-PLA is not too high, according to our tests **the temperature for LW-PLA should be between 230-240°, but not above 245°**. In this temperature range, LW-PLA has the best properties for model aircraft. The wall thickness should be about 0.5 mm.

## WINGTEST\_P5 LW\_Planeprint.stl

**MATERIAL** LW-PLA, ~ 5.5 g

### **ADDITIONAL SETTINGS**

- Flow 60 %
- Nozzle temperature 235-245°

Stop the print about halfway through and measure the wall thickness in several places (including the infill). The wall thickness should be **between 0.40 and 0.55 mm**, correct this by changing the flow.

If the area after the **Z-seam** is too thin, you need to set more **Retract Extra Prime Amount**.

