



Robert Vergnes <robert.f.vergnes@gmail.com>

[NPC-A038 PROTOTYPING OF ATHENA V1.X (2ET) TURBINES] Re: Production of Athena-A-2ET-v1.65

David Brotherton-Ratcliffe (ActiveCollab) <notifications@activecollab.com> Wed, Jan 23, 2019 at 9:13 PM

Reply-To: notifications-133944@activecollab.com

To: Robert Vergnes <robert.f.vergnes@neva-aero.com>

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New comment posted in:
[Production of Athena-A-2ET-v1.65](#)

DB David Brotherton-Ratcliffe 23 Jan 2019


PC (PolyMaker PC-Max) 260C 110C Bed Temp No fan
Layer Height Fine -0.1mm
Outer Wall line width 0.35
Infill Density : Usually 30% should be OK (if you want more strength then 100%)
Infill Pattern Grid
Supports: Everywhere
Support Overhang Angle: 80
Support Pattern: Zig Zag (or Grid if supports are falling off in printing)
Support Density 20%
Use Towers: NO

Build Plate Adhesion: BRIM is best with the adhesive sheets BRIM WIDTH 15 mm if possible (you will need to have arm at 45 degrees so you have space for this big brim)

or RAFT with Buildtac or glass (with adhesive spray) - but if using raft better to use 5 TOP LAYERS rather than 3.

Always print with door and cover on. Ambient temperature must be around 70-80C.
Ultimaker usually struggles to get near 70C...

Older comments


















 Tomas Valaitis 23 Jan 2019






@David Brotherton-Ratcliffe

Did you could advice to set some specific parameters for Cura slicing for the arm to be printed? Maybe you could upload your Cura settings (profile) you found best for arms?

DB David Brotherton-Ratcliffe 18 Jan 2019

Here are the latest stl files for v1.64
Note the Arm file is the latest which gives you an extra clearance between the hubs...

-  [Top External Plug 4.stl](#) 146.57kb
-  [Top External Plug 2.stl](#) 158.19kb
-  [Top External Plug 1.stl](#) 179.87kb
-  [Bottom External Plug 1.stl](#) 198.13kb
-  [BEP2.stl](#) 198.13kb
-  [Outlet Hub.stl](#) 262.88kb
-  [Arm.stl](#) 1.99MB
-  [BEP4.stl](#) 317.17kb
-  [BIP4.stl](#) 667.95kb
-  [Top Internal Plug 2.stl](#) 902.04kb
-  [Inlet Hub.stl](#) 263.27kb
-  [Cap.stl](#) 2.87MB
-  [Outlet Blade.stl](#) 1.12MB
-  [Inlet Blade.stl](#) 1.13MB
-  [Bottom Internal Plug 3.stl](#) 650.18kb
-  [Bottom External Plug 3.stl](#) 246.66kb
-  [Bottom Internal Plug 1.stl](#) 766.29kb

-  BIP2.stl 766.29kb
-  Top External Plug 3.stl 146.57kb
-  Top Internal Plug 1.stl 0.95MB
-  Top Internal Plug 3.stl 505.94kb
-  Top Internal Plug 4.stl 505.94kb




Robert Vergnes 18 Jan 2019

@David Brotherton-Ratcliffe

the latest I have are those from October :

does the arms and rotor hub are the latest version and blades as well?

 STL-Files-Date-Athena-1.64.png 219.74kb



Robert Vergnes 18 Jan 2019

@David Brotherton-Ratcliffe

can you post all latest Athena 1.64/1.65 SETP files here:

shroud

rotor

arms

blades

we are struggling to find all files back with Tomas

Project: NPC-A038 PROTOTYPING OF ATHENA V1.X (2ET) TURBINES

Task List: Inbox

People in this task: David Brotherton-Ratcliffe, Robert Vergnes, Tal Stokes and Tomas Valaitis

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