

This printing guide is mostly a collection of guidelines. Feel free to use your own discretion.

Parts should be printed at %20 infill and 4 walls unless otherwise stated.

All of my prints have been in PLA and I've been printing with 210° hotend and 60° bed. If you're printing with different filaments(PETG, ABS) then that will change accordingly.

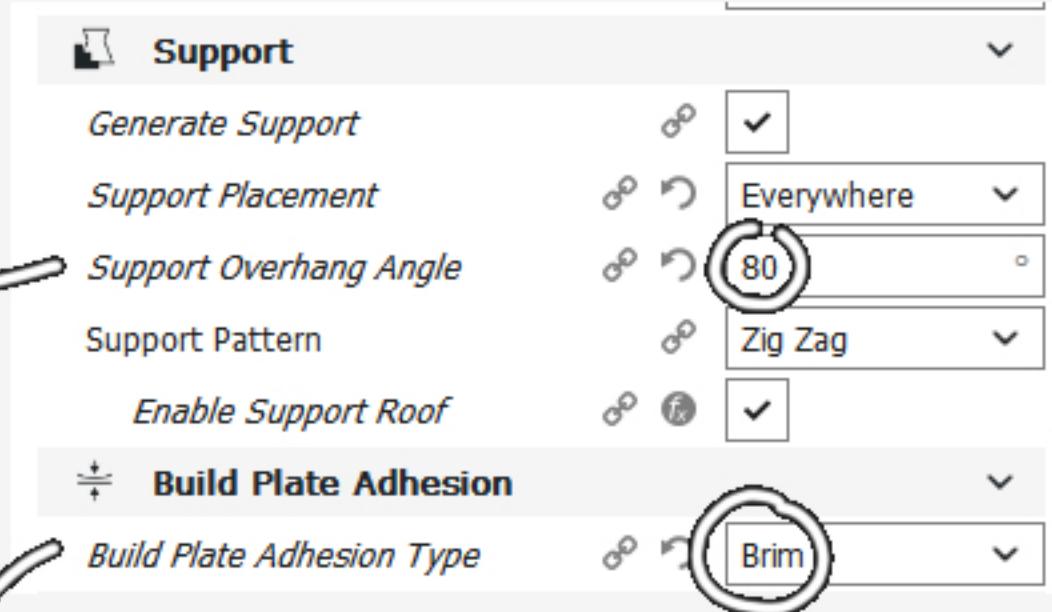
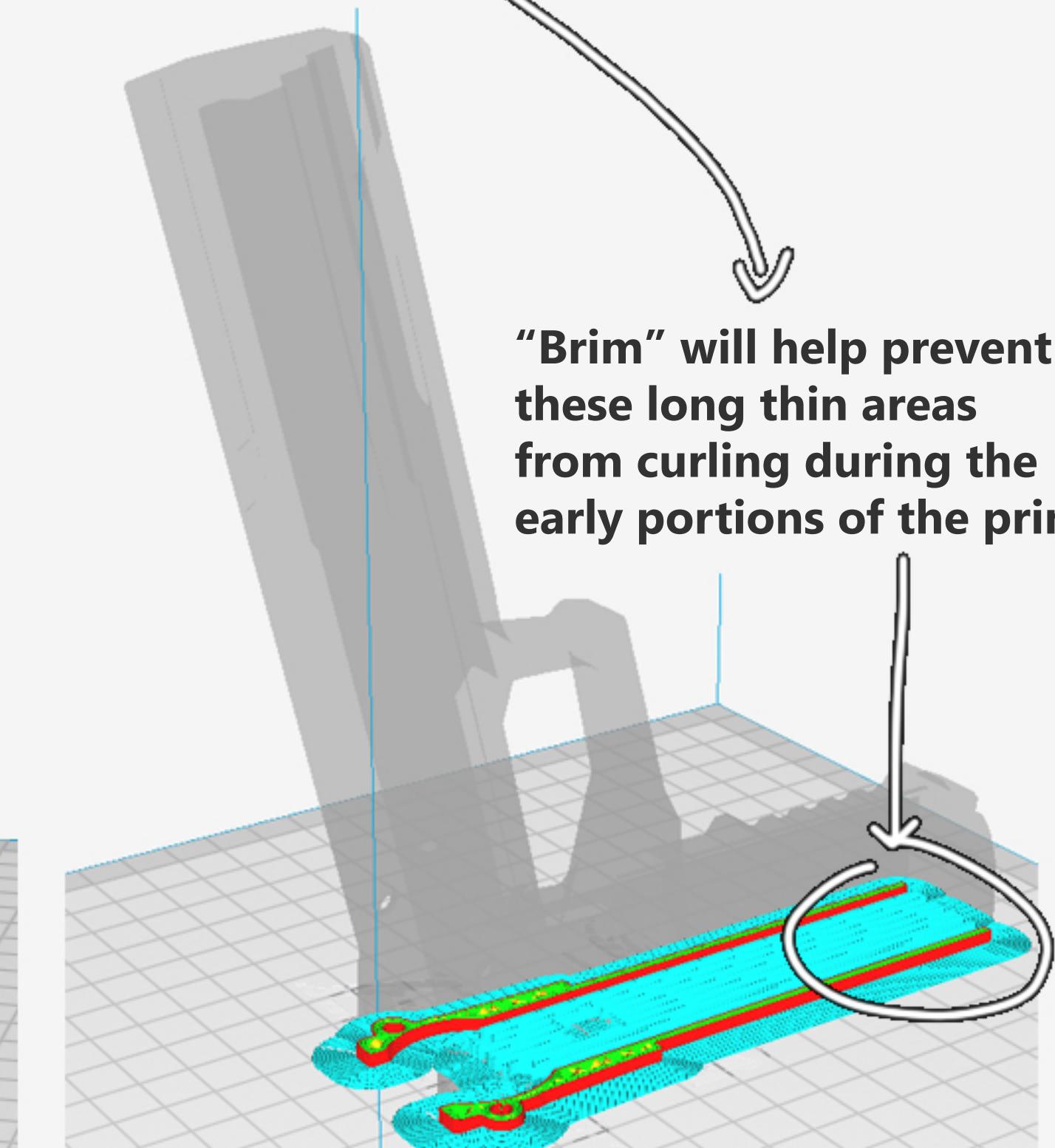
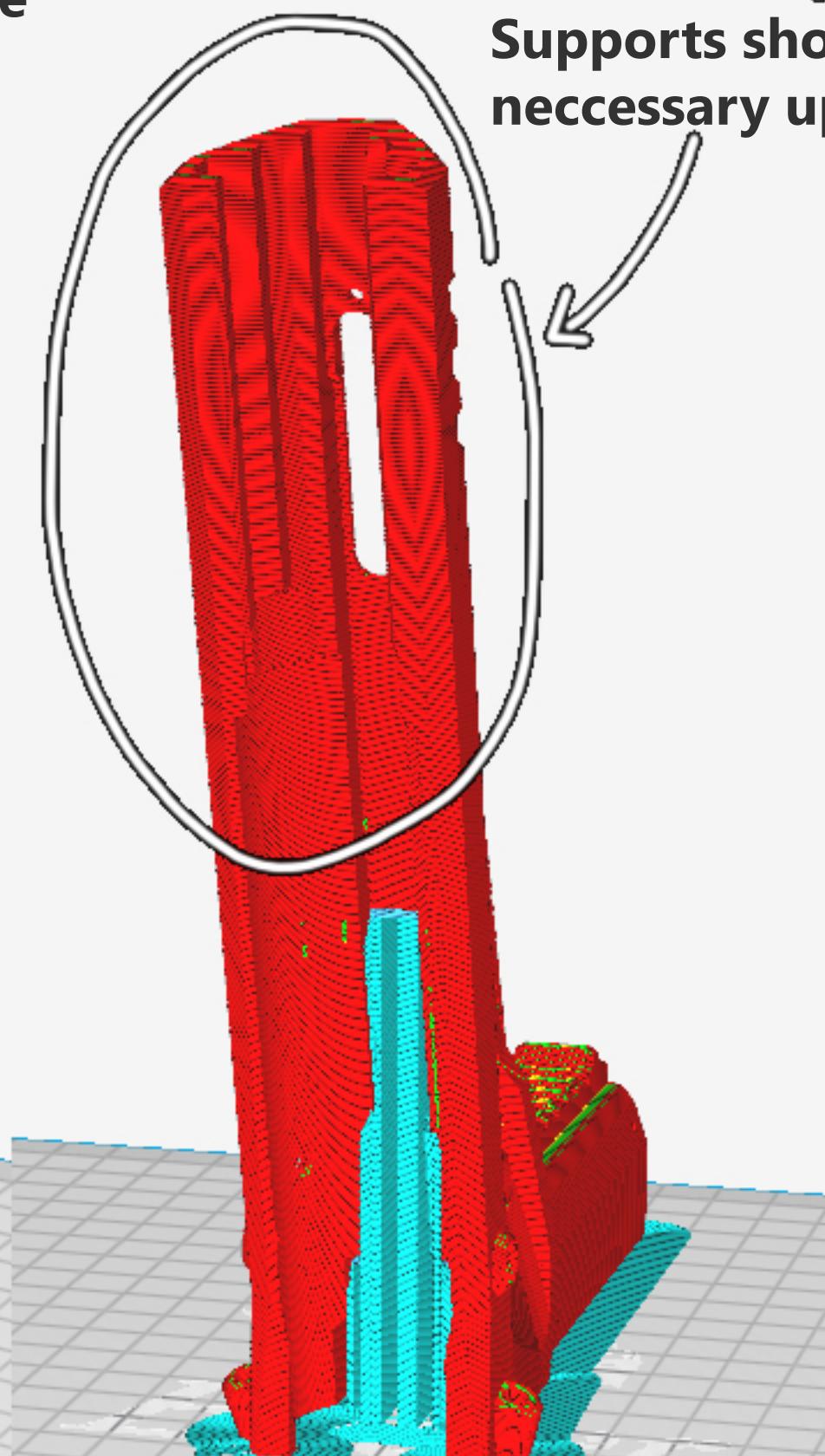
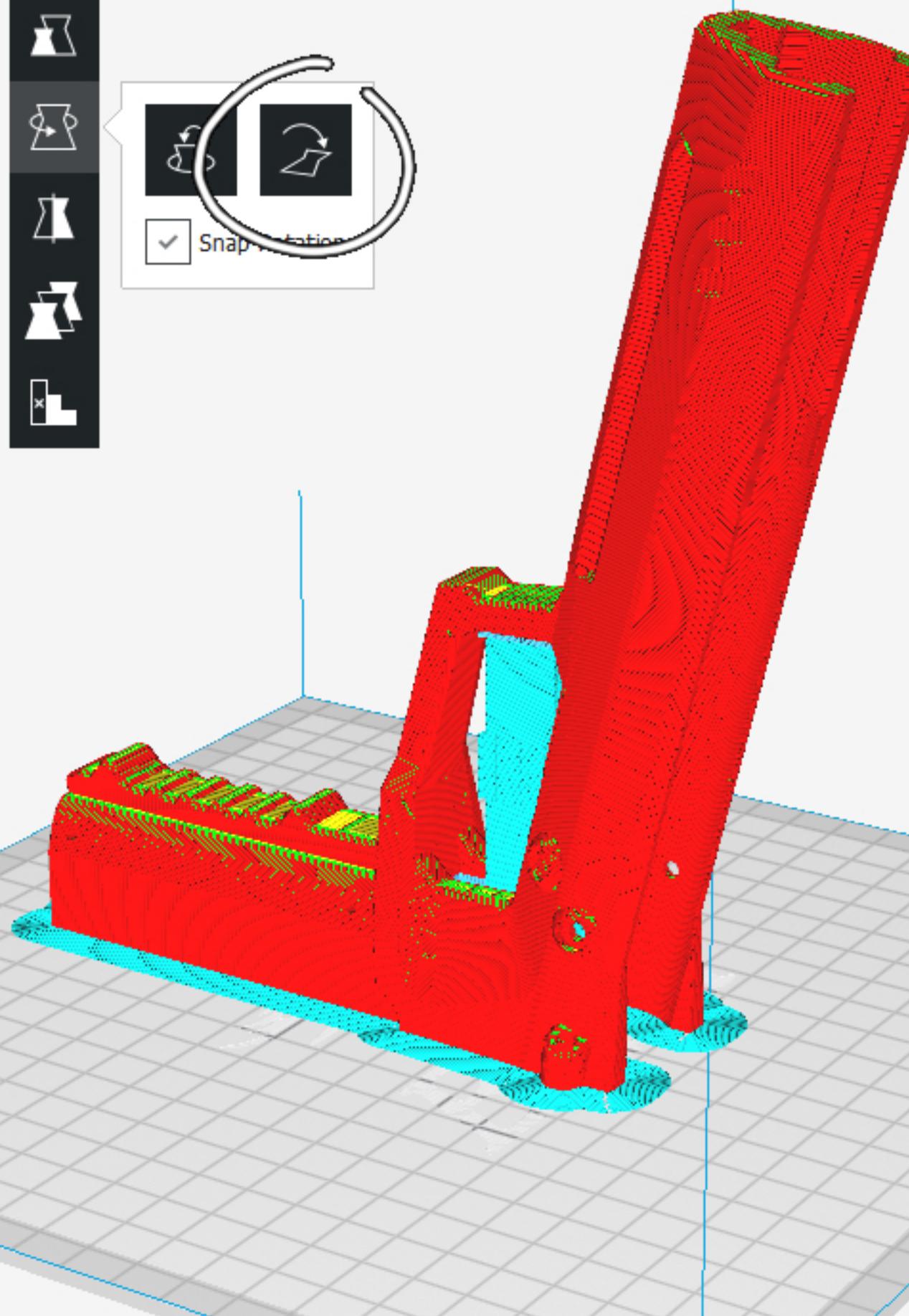
For the most part, the only settings I'm changing between prints is in relation to support material or build plate adhesion.

Frame_front.stl

This part should be printed at %50 infill or higher.



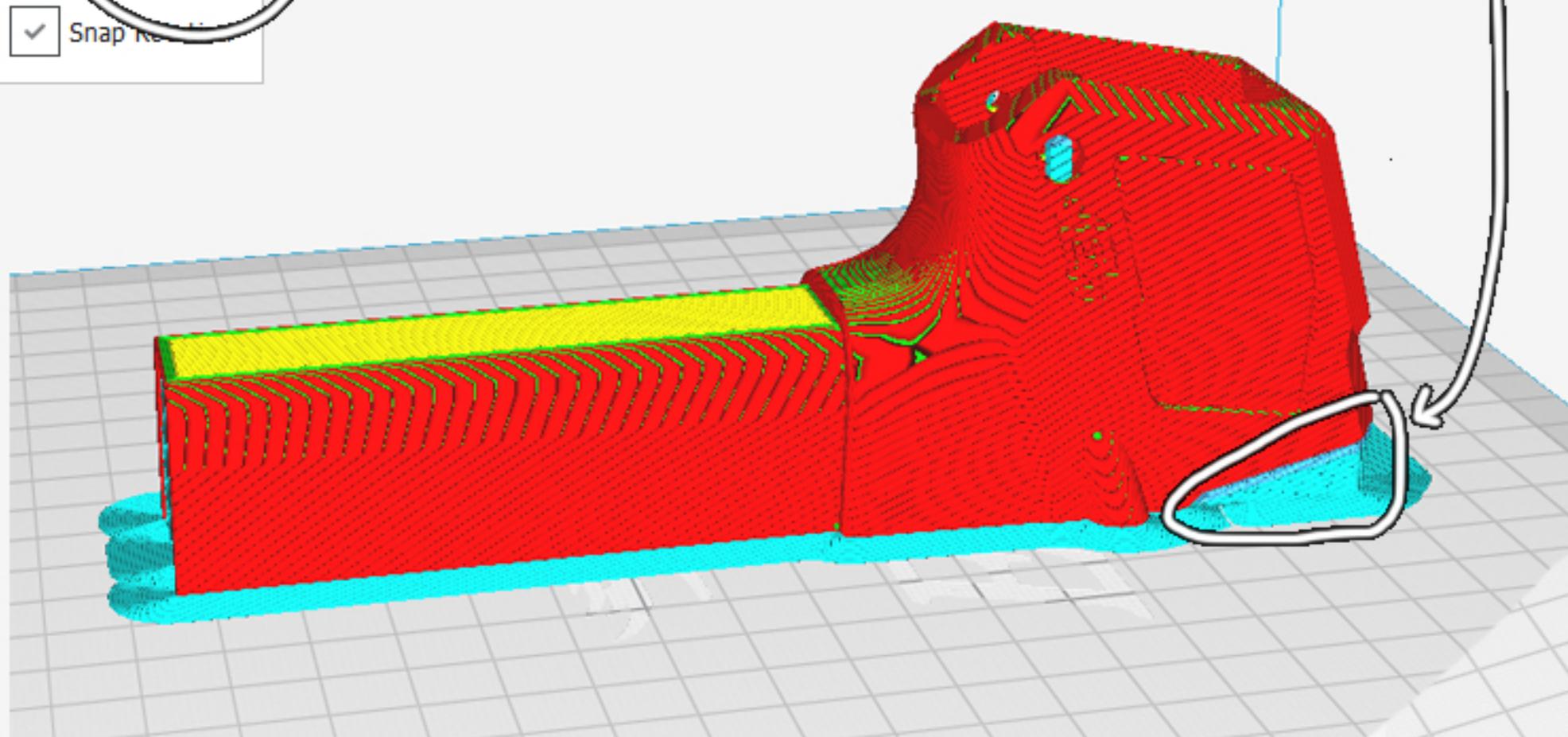
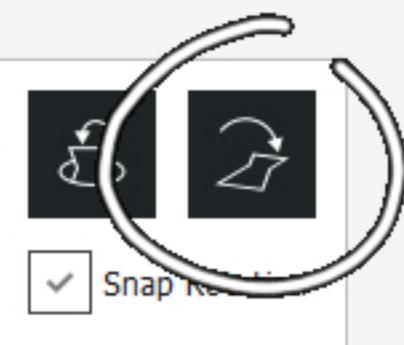
Rotate the frame so it's roughly orientated as shown and then use the "lay flat" button to get the frame to lay against the bed.



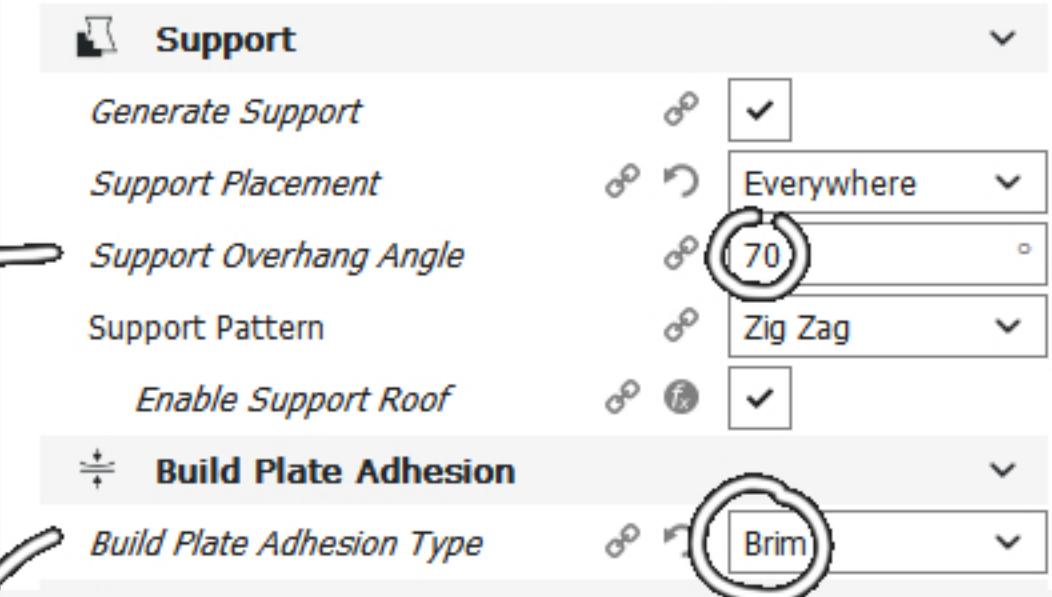
Frame_rear.stl



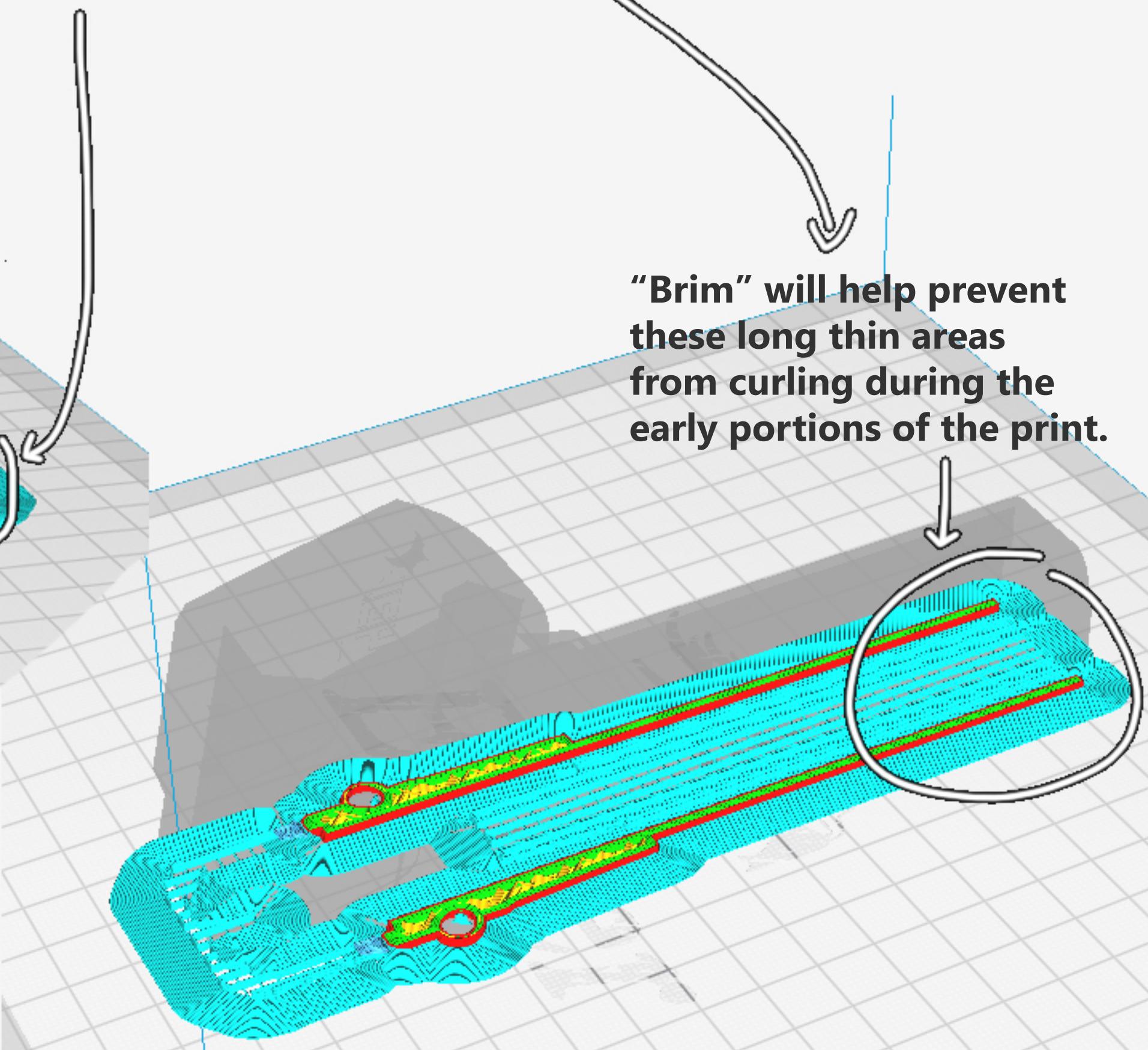
Rotate the frame so it's roughly orientated as shown and then use the "lay flat" button to get the frame to lay against the bed.



Change the "support Overhang Angle" to 70 so this area is fully supported.

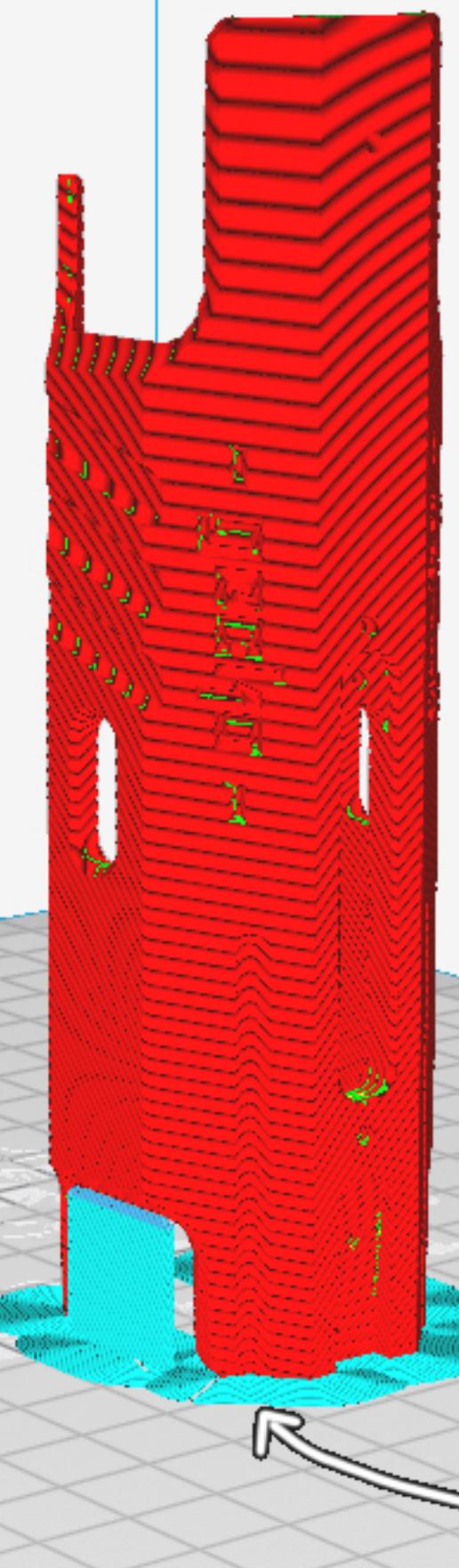


"Brim" will help prevent these long thin areas from curling during the early portions of the print.

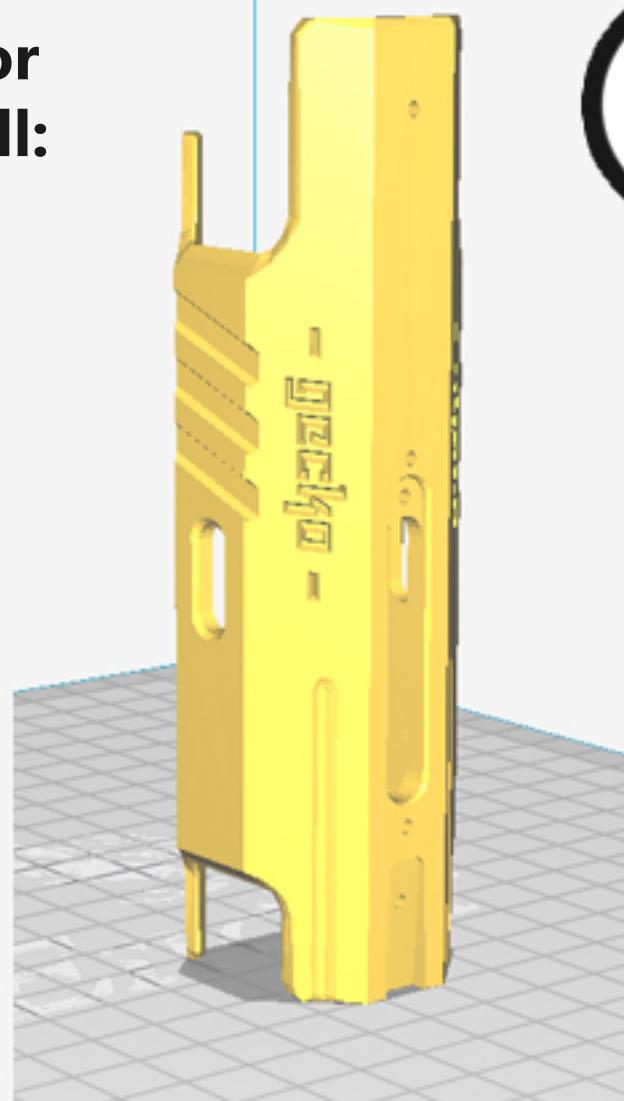


Priming_handle.stl

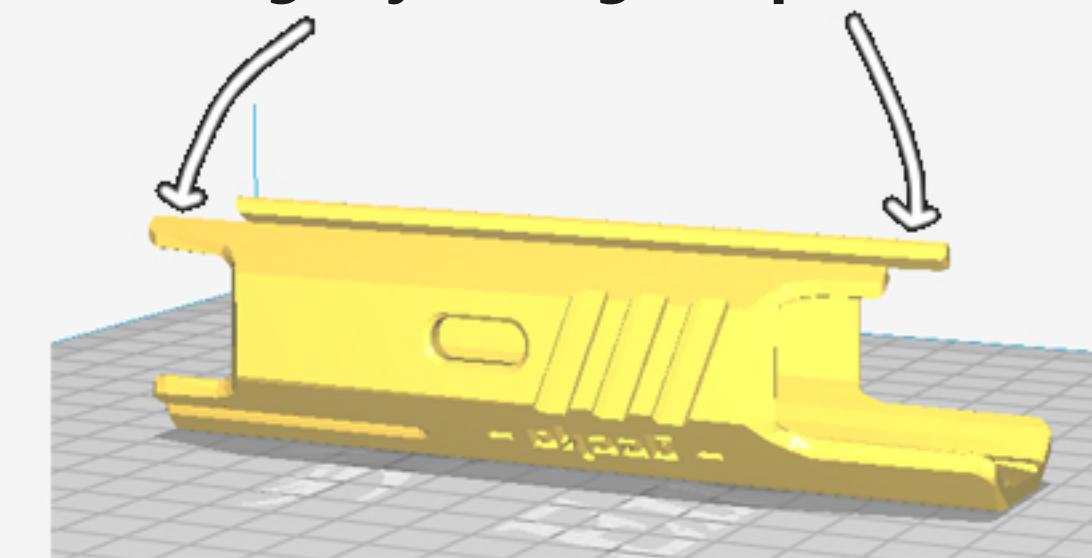
Suggested orientation for best surface finish overall:



OR

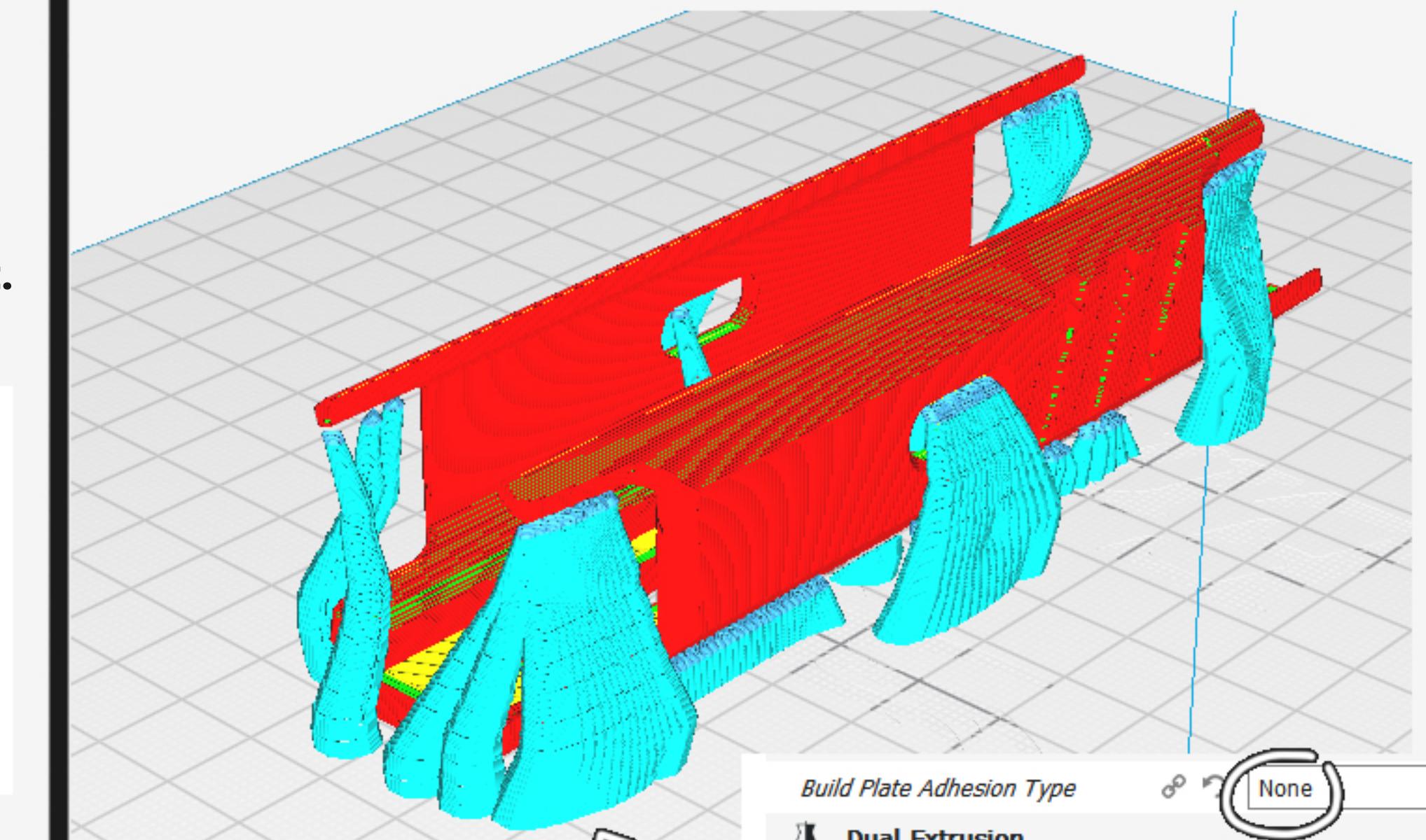
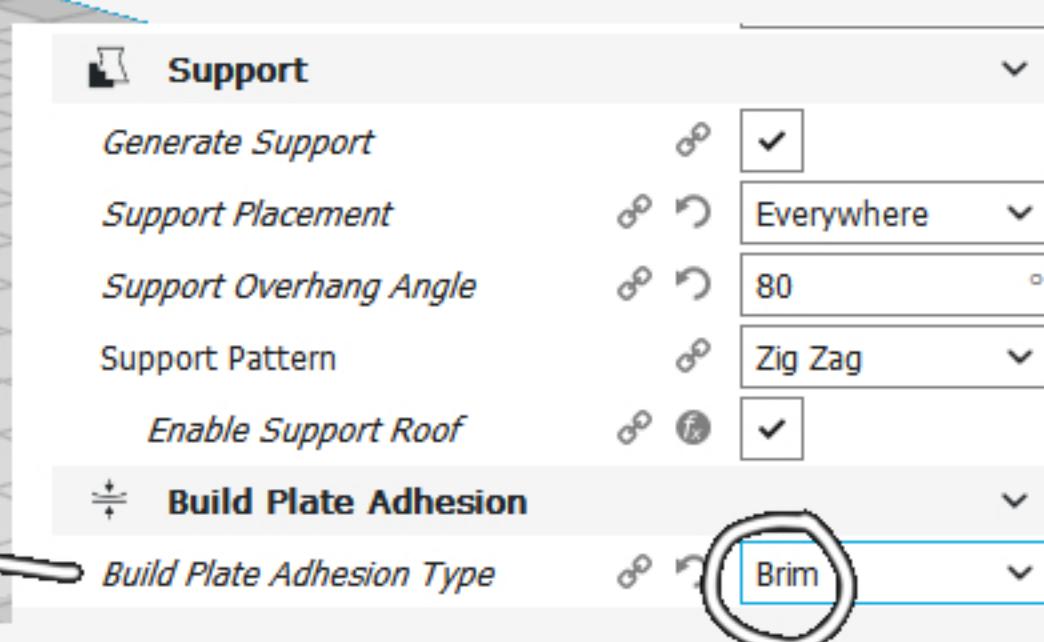


Slightly stronger "spikes":



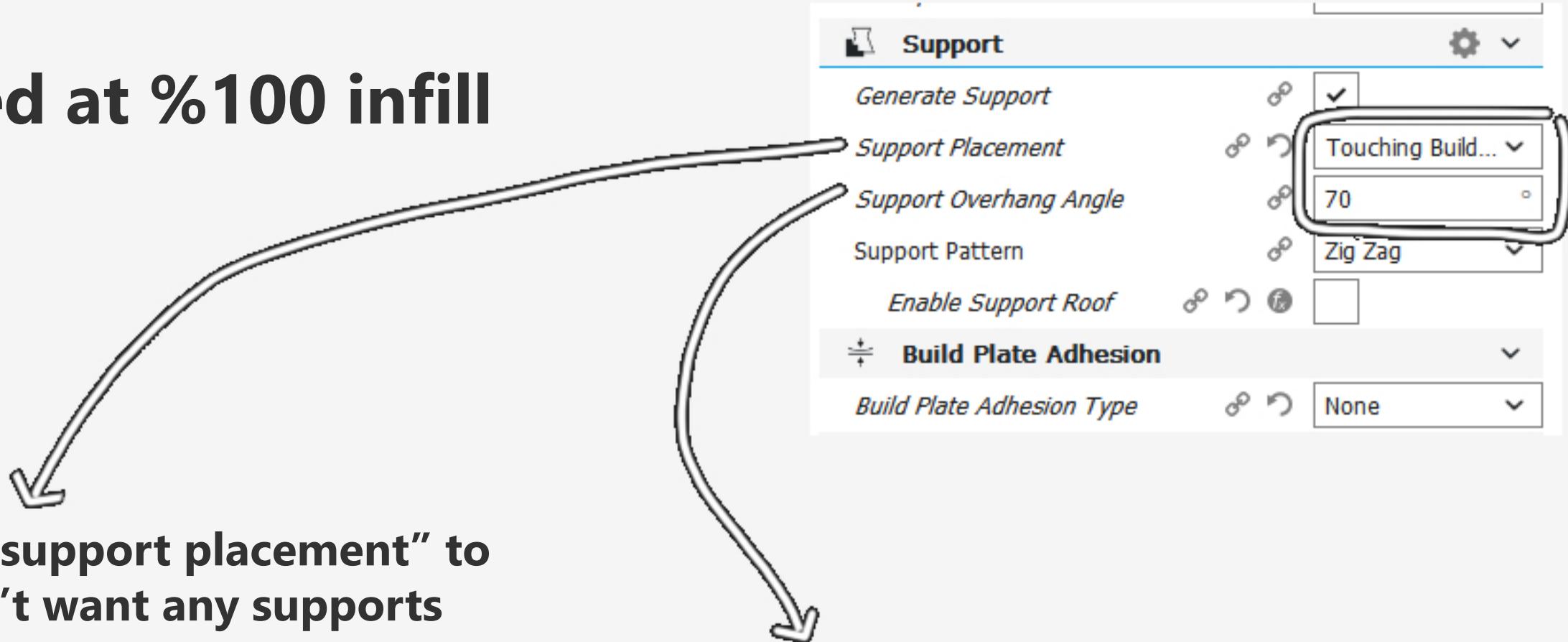
I don't recommend this method as the "spikes" are purely cosmetic. Also, once the handle is installed on your Gecko, there is very little chance of them breaking.

Brim is important again to increase build plate adhesion since the part is tall and has a very small footprint.



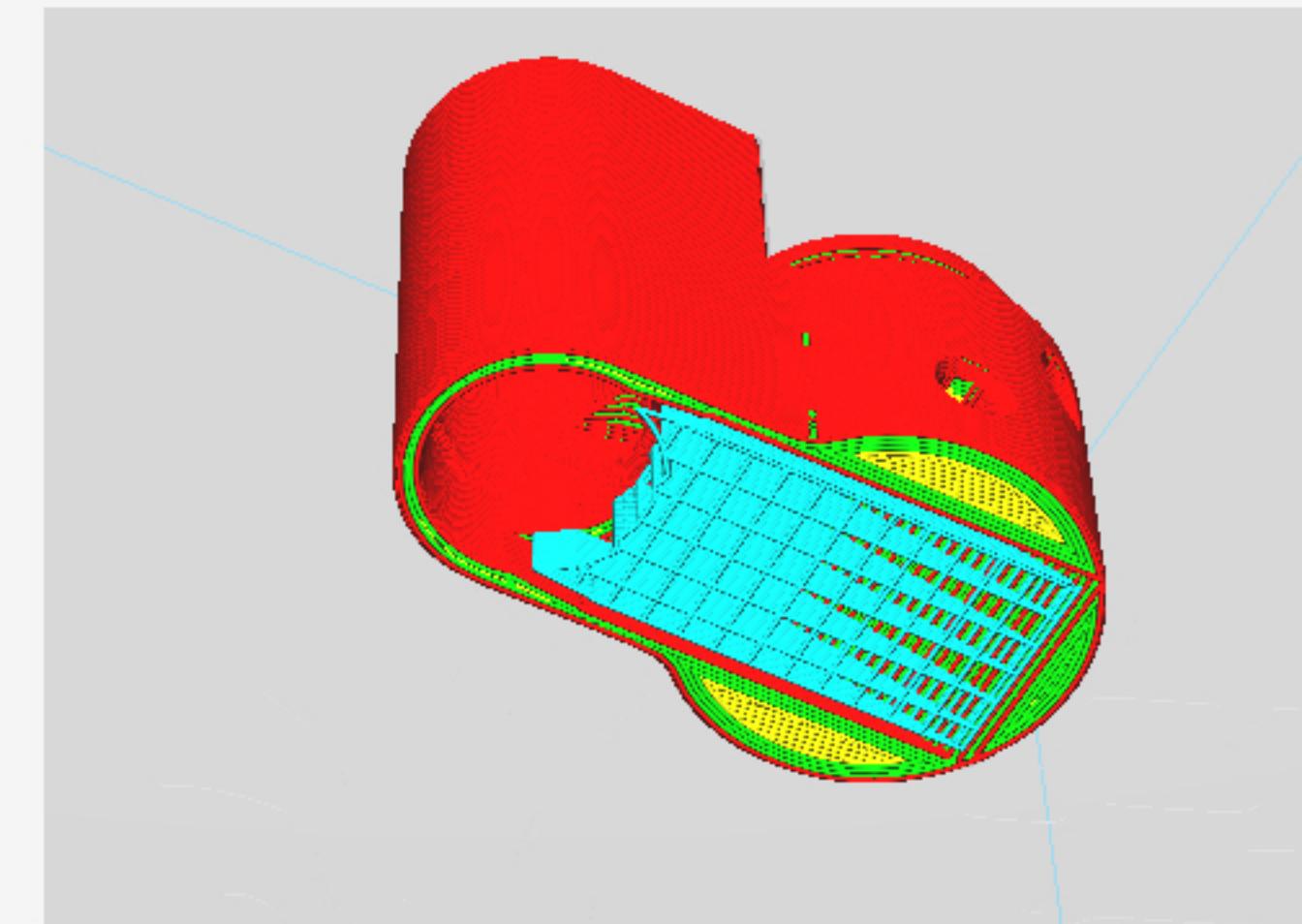
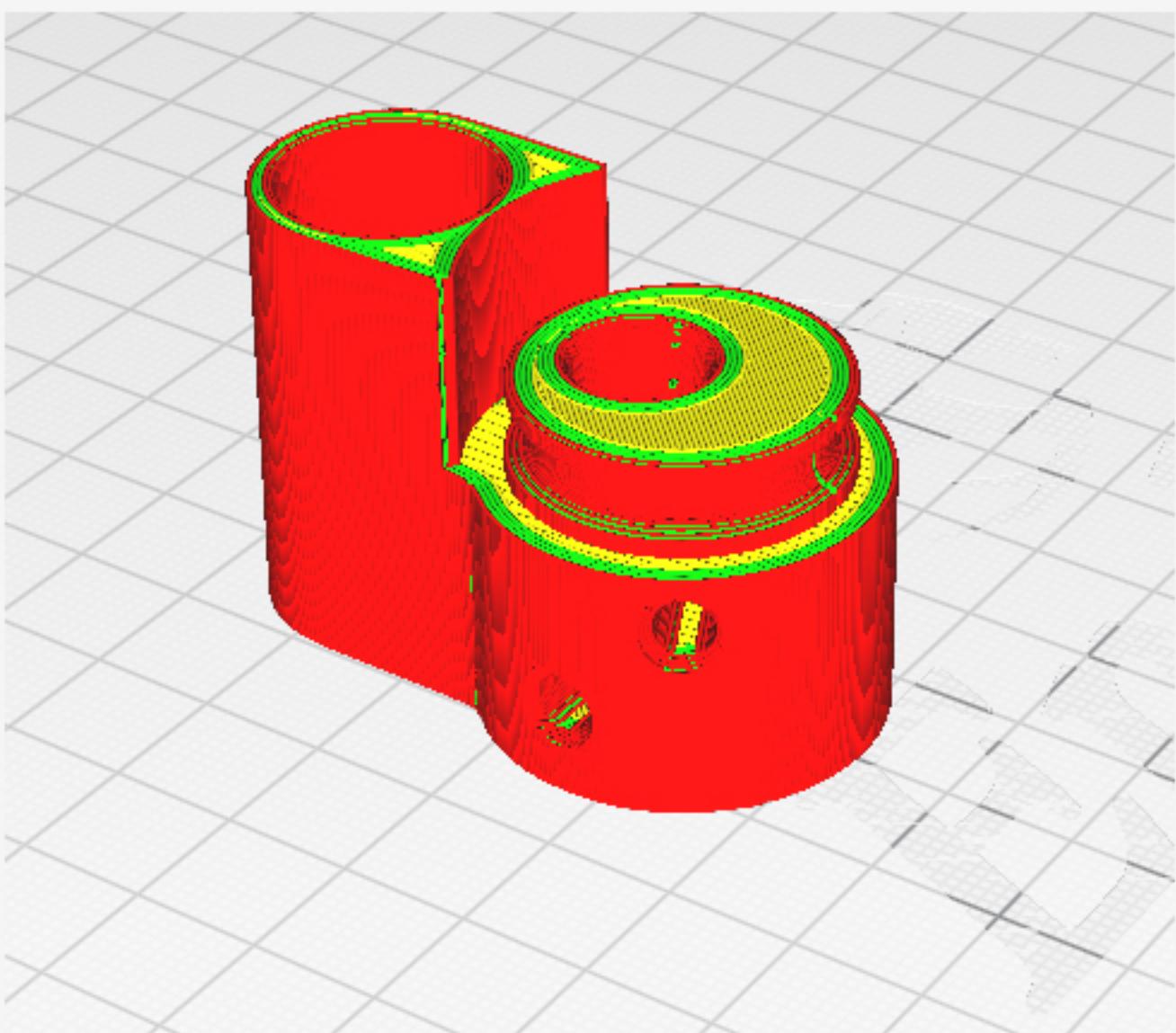
Turnaround.stl

This part should be printed at %100 infill



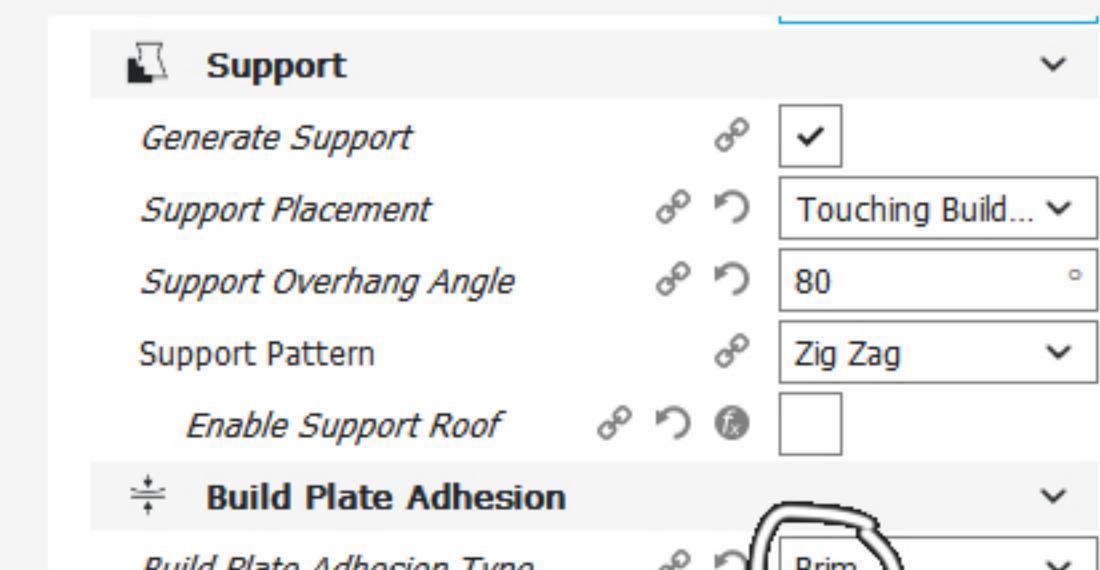
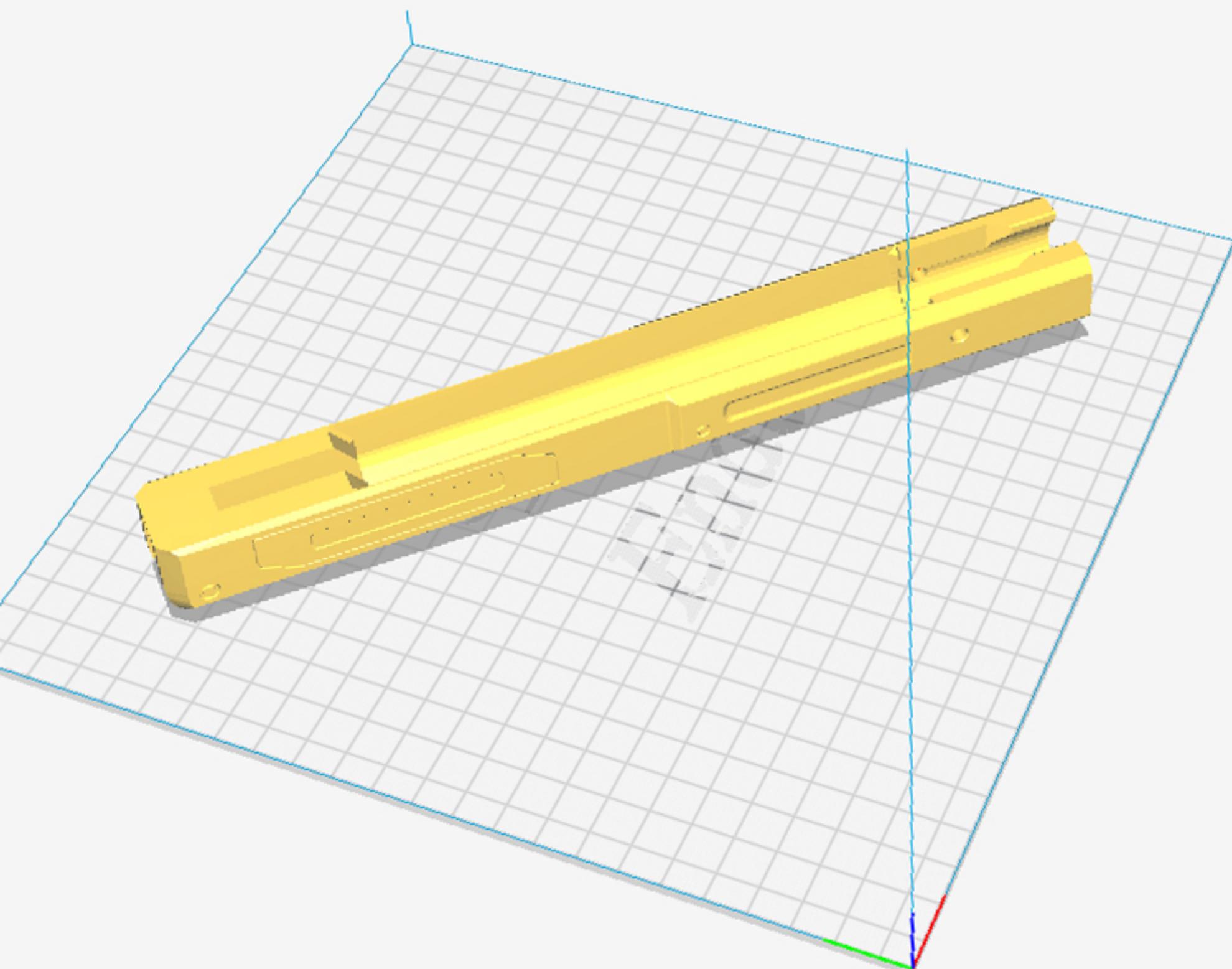
The turnaround lays flat on its rear. Set "support placement" to "Touching Buildplate Only" since we don't want any supports to generate inside the turnaround's air passage.

Set "Support Overhang Angle" to 70 so that this space under the part is fully supported. I've also turned off "Build Support Roof" as it can cause supports to be stubborn to remove from this part.

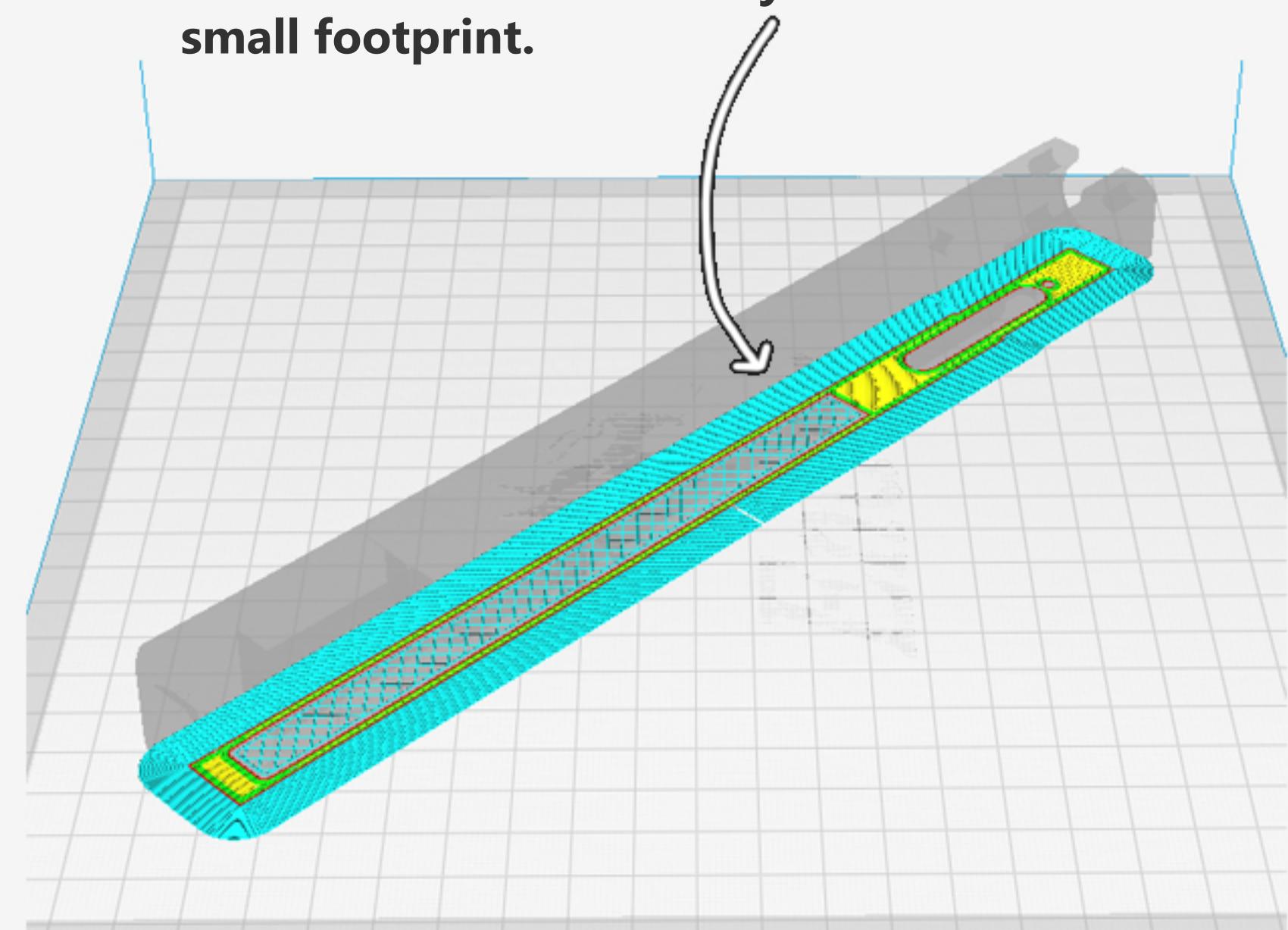


Slide.stl

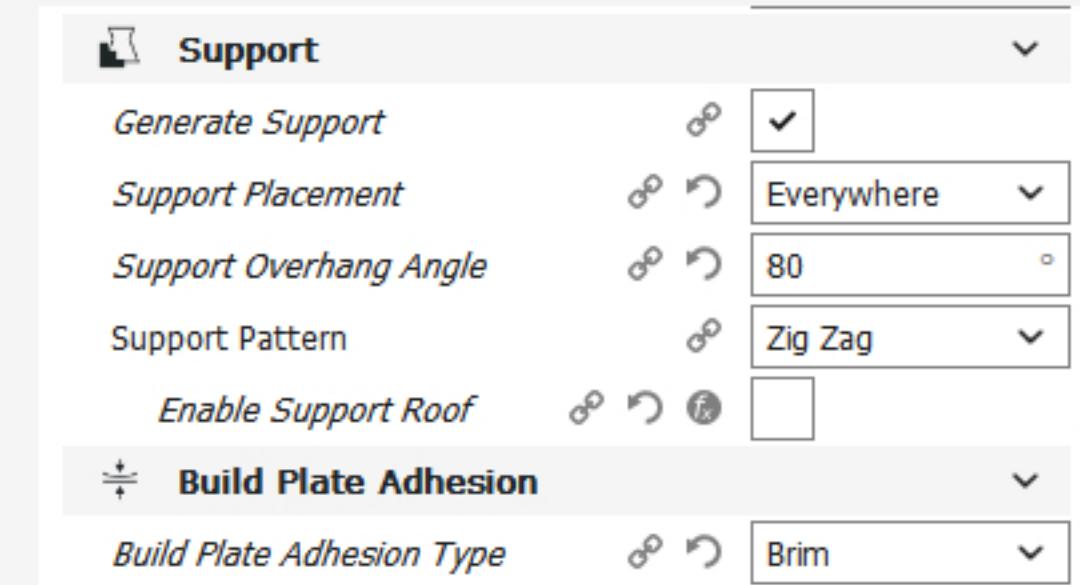
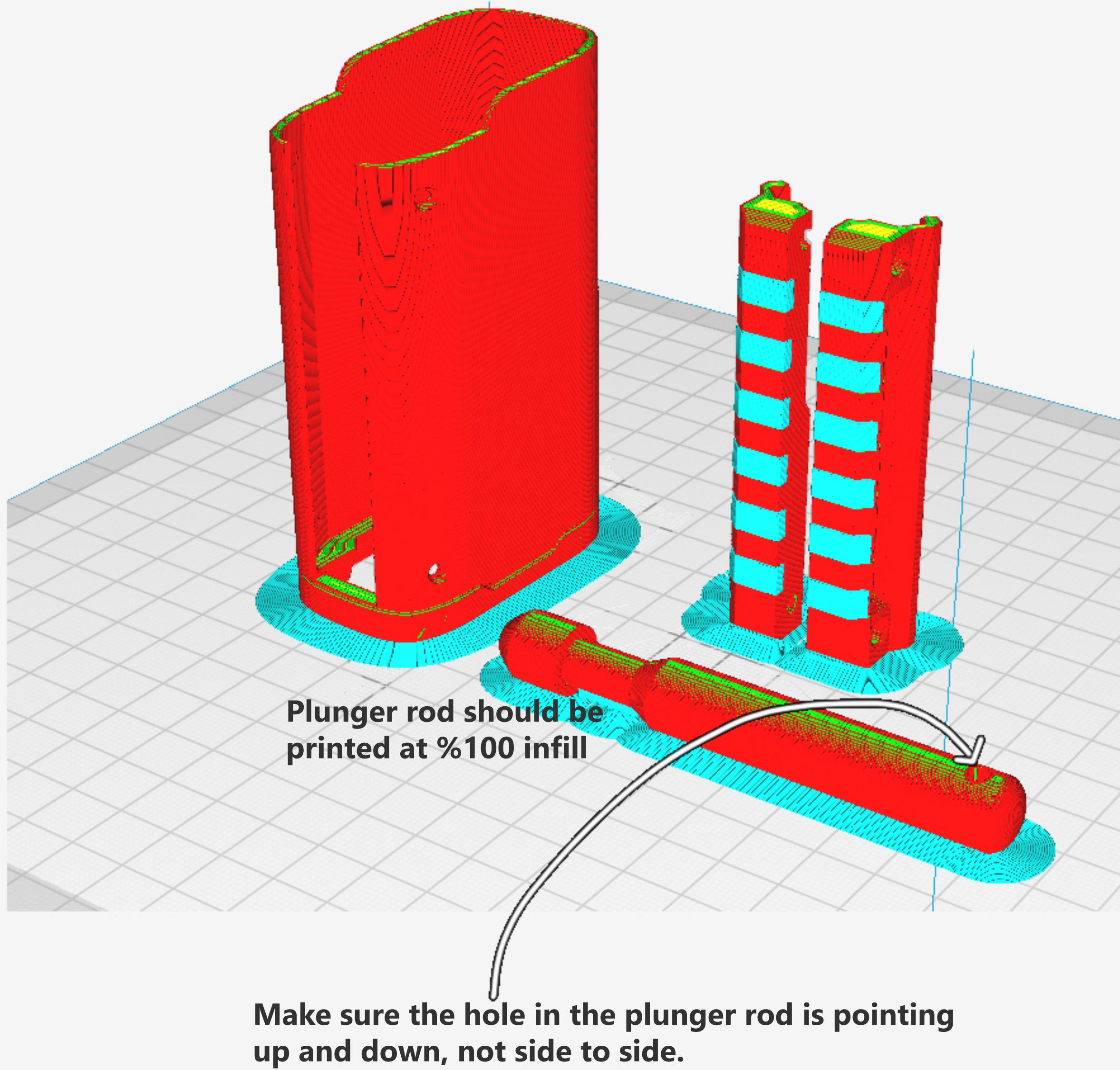
The slide fits on the bed of my Ender 3 diagonally.



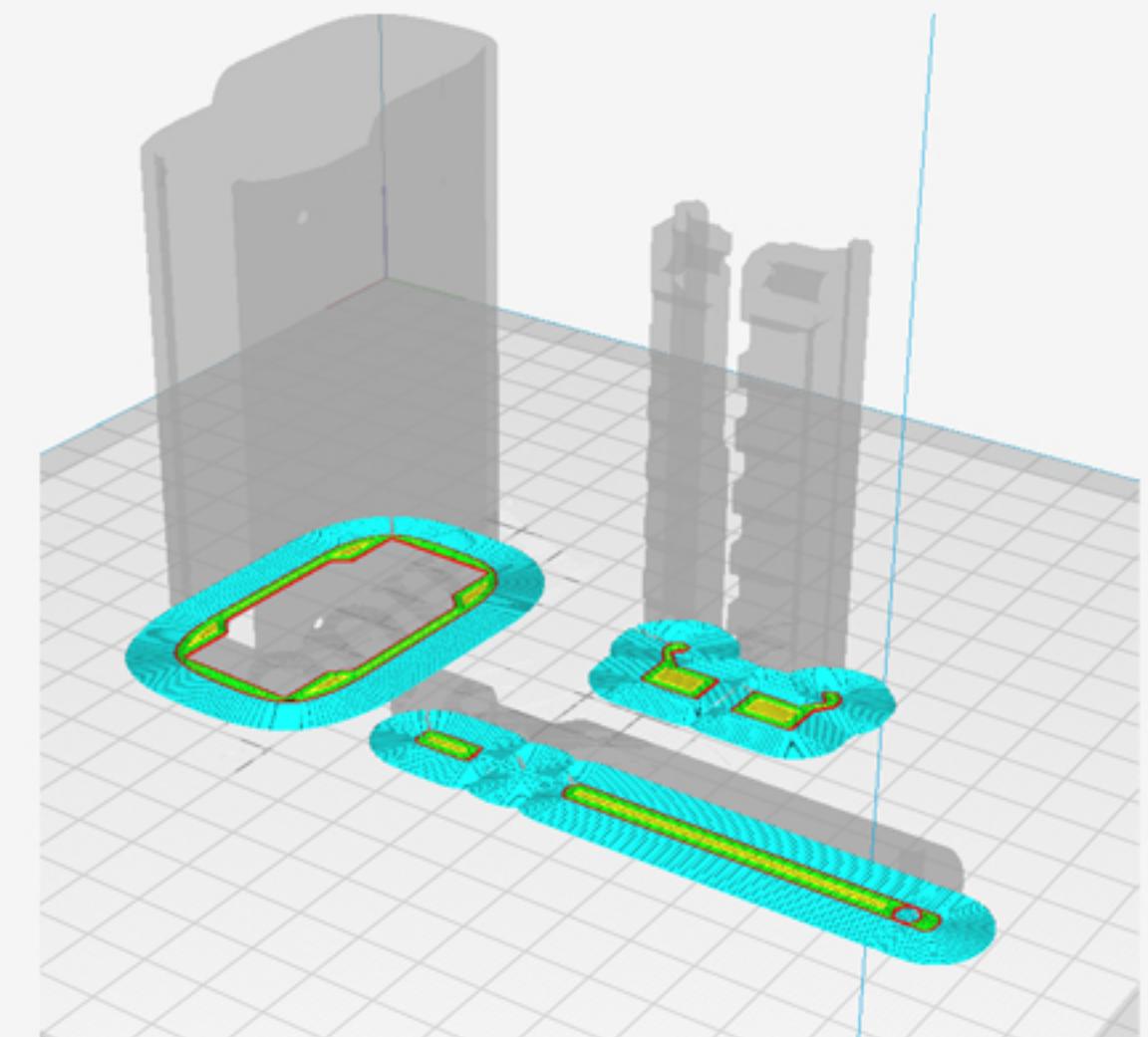
Again, I am suggesting a “Brim” on this part as I’ve had long, narrow parts curl up off the bed in the past. It will also help the part adhere to the bed as the first few layers have a somewhat small footprint.



Grip, plunger rod and rail



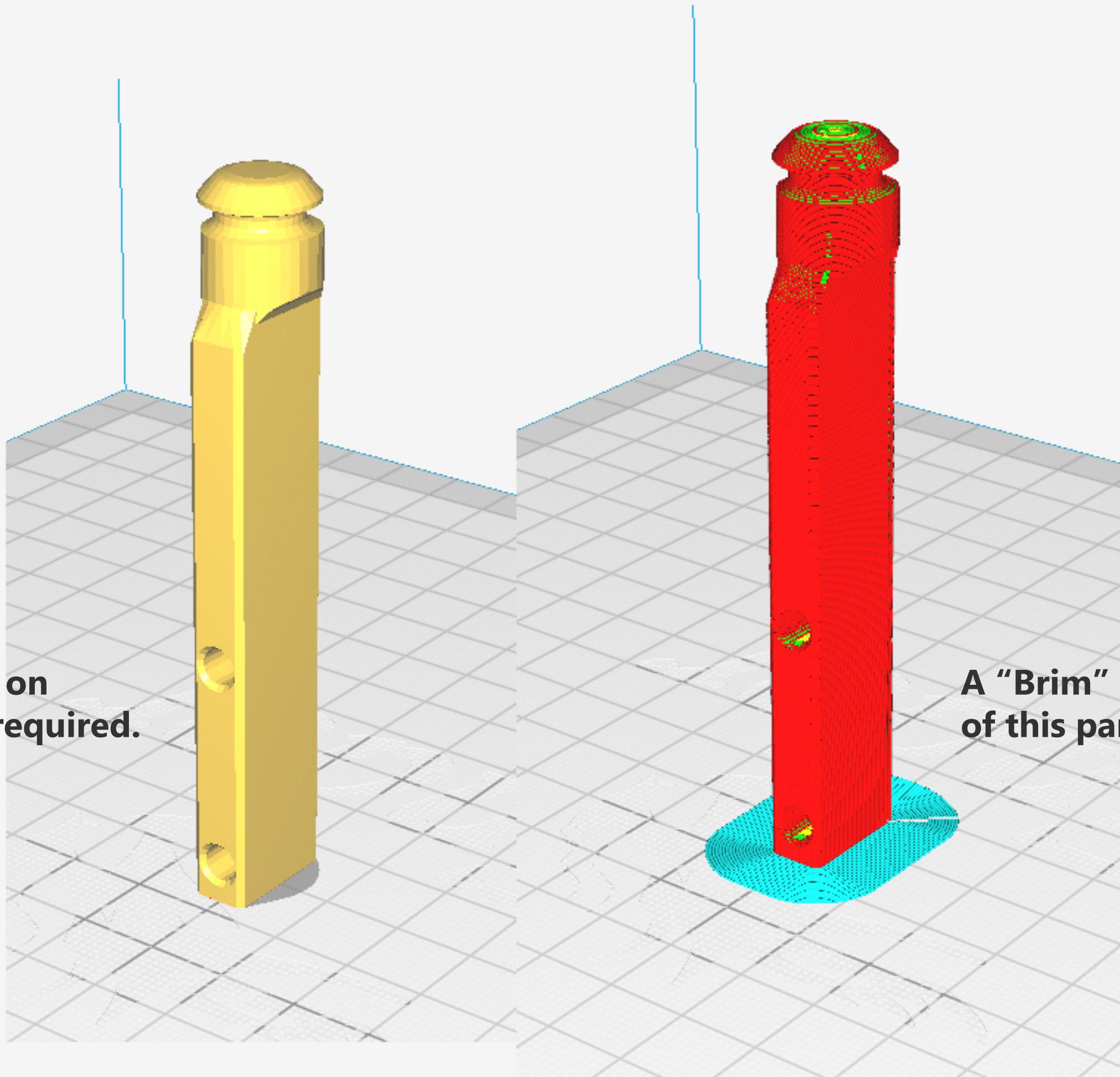
A “Brim” is suggested since the footprint of these parts are small compared to their size/height.



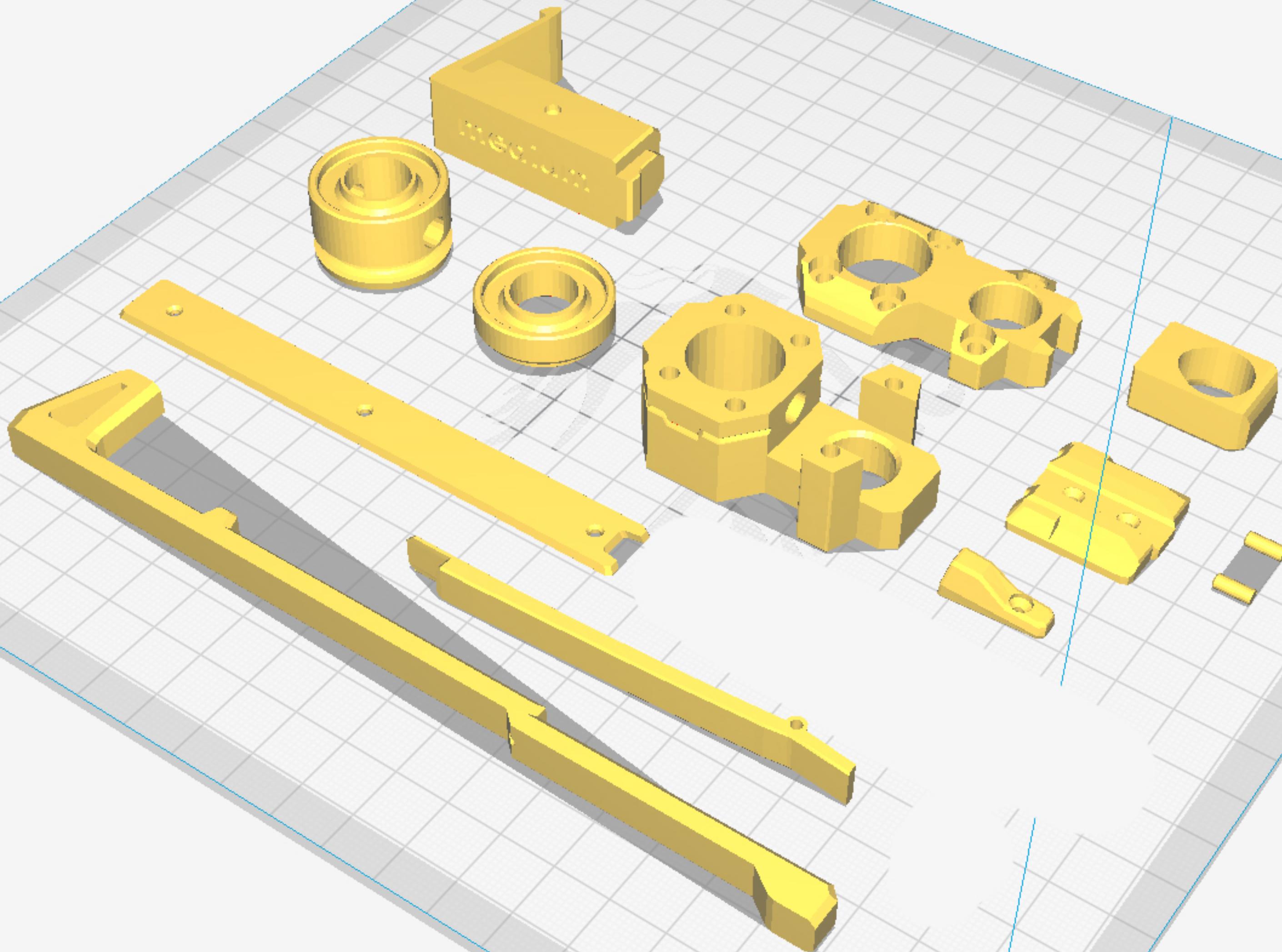
Pusher

**Print the pusher standing on
it's rear. No supports are required.**

**A "Brim" is suggested since the footprint
of this part is small compared to it's height.**



Orientations for the remainder of the parts.



Magazine

