



Chimera mk7 Printing Guide

This guide will detail all the recommended print settings for all parts. They are all fairly easy to print, but still make sure your printer is properly maintained and calibrated to ensure your parts are strong and beautiful. All parts are designed to be printed in PLA. You can try other materials if you want to, but PLA is recommended. A high quality part cooling fan/duct is highly recommended, with a few sharp overhangs that may require support if your printer isn't up to the task.

There are two versions of a couple of the parts, labeled either "AT", or "ST". AT parts are designed to use Angled Talon magazines, ST parts are designed to use Straight Talon magazines (Non-angled). The versions are not cross compatible, so print the right parts for the magazines you intend to use.

AT Parts:

-Receiver AT
-Release AT

ST Parts:

-Receiver ST
-Release ST

List of FDM Parts needed to build one (1) MK7 Chimera:

For recommended print orientations, see the images located in each group's STL folder.

Group A:

-1x Muzzle
-1x Receiver (AT/ST)
-1x Front Rail
-1x Release (AT/ST)
-1x Magwell Shroud
-1x Butt Plate
-1x Stock

Nozzle Size: 0.4-0.6mm
Layer Height: 0.2-0.35mm
Infill: 25%+
Perimeter Line Count: 4+
Support Material: None

Group B:

-1x Plunger
-1x Plunger Top
-1x Catch Surface
-1x T Guard
-2x T Link Knuckle Front
-2x T Link Knuckle Rear
-1x Trigger
-2x T Link Pivot
-1x Actuator

Nozzle Size: 0.4-0.6mm
Layer Height: 0.2-0.3mm
Infill: 100% 'Lines' Pattern
Perimeter Line Count: 5+
Support Material: None

Group C:

-1x Handle
-1x Pump Grip
-1x Cheek Guard

Nozzle Size: 0.4-0.6mm
Layer Height: 0.2-0.3mm
Infill: 25%+
Perimeter Line Count: 4+
Support Material: Generated only from bed

Group D:

-4x M4 Thumb screws
-1x Feed Ramp
-1x Feed Cover
-1x SNIP Plate

Nozzle Size: 0.2-0.4mm
Layer Height: 0.2-0.3mm
Infill: 25%+
Perimeter Line Count: 5+
Support Material: None

*NOTE: These parts have small features that require a 0.4mm or smaller nozzle. Ideally you want to use a 0.2-0.3mm nozzle, but they will work with a 0.4mm. (0.4mm is the standard nozzle size on most printers.)

Group E:

-1x Grip Panel

Nozzle Size: 0.4-0.6mm
Layer Height: 0.2-0.35mm
Infill: 25%+
Perimeter Line Count: 4+
Support Material: None

NOTE: To print the Grip Panel with a textured surface, enable the "Fuzzy Skin" option in Cura, under the "Experimental" menu.

Fuzzy skin settings:

Fuzzy skin thickness: 0.3mm
Fuzzy skin density: 1.25mm
Fuzzy skin point distance: 0.8mm

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