



Kitsune

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.

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

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

Group A:

- 1x Rear Core
- 1x Rear Cap
- 1x Front Cap
- 1x Muzzle
- 1x Mag Release

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

Group B:

- 1x Plunger
- 1x Trigger Nub
- 1x Plunger Top
- 1x T Guard Nub
- 1x Catch Surface
- 1x Trigger
- 1x T Guard
- 1x T Bar Right
- 1x T Bar Left
- 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 Right
- 1x Handle Left
- 1x Slide
- 1x T Pull
- (Optional) 1x Holster
- (Optional) 1x Holster Belt Clip

Nozzle Size: 0.4-0.6mm
 Layer Height: 0.2-0.3mm
 Infill: 25%+ 'Octet' Pattern
 Perimeter Line Count: 5+
 Support Material: Generated only from build plate*
 Ensure that your supports are properly tuned prior to printing!

Group D:

- 1x Monogrip

Nozzle Size: 0.4mm
 Layer Height: 0.1-0.3mm
 Infill: 25%+ 'Octet' Pattern
 Perimeter Line Count: 4+
 Support Material: None

NOTE: To print the Monogrip 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

Group E:

- 1x SN Plate

Nozzle Size: 0.2-0.4mm*
 Layer Height: 0.1-0.25mm
 Infill: 100% 'Lines' Pattern
 Perimeter Line Count: 5+
 Support Material: None

*NOTE: This part has 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.)