



Venturi MK8 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:

-Handle Right AT
-Handle Left AT
-T Gaurd AT

ST Parts:

-Handle Right ST
-Handle Left ST
-T Gaurd ST

List of FDM Parts needed to build one (1) MK8 Venturi:

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

Group A:

-1x PT Mount -1x Dart Tooth
-1x Muzzle -1x Slide R
-1x Catch House -1x Slide L
-1x Catch Roof -1x Release Internal
-1x Pusher -2x Release External

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 Plunger Top
-1x Catch Surface
-1x T Gaurd (AT / ST)
-1x T Pull

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 Trigger
-1x Actuator

Nozzle Size: 0.4-0.6mm
Layer Height: 0.2-0.3mm
Infill: 100% 'Lines' Pattern
Perimeter Line Count: 5+
Support Material: Generated Everywhere

Group D:

-1x Handle Right (AT / ST)
-1x Handle Left (AT / ST)

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*

*NOTE: Ensure that your supports are properly tuned prior to printing the handle halves! If your supports don't break away easily, you could end up scooping support material out of the magwell for ages. A brim is highly recommended to ensure proper adhesion to the bed.

Group E:

-2x M4 Thumbscrew
-1x M5 Thumbscrew
-1x Pusher Top
-1x Release Nub
-1x Dummy Cap
-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: 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 F:

-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

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NORTHEAST DESIGNS