

Whole Titanic ship

1:2000 Model (App. 13.5cm (L) x 1.5cm (W) x 4cm (H)), set to 50% scale

Printing File:

UseThisOne_T_FullTitanic_ReadyForPrinting.stl

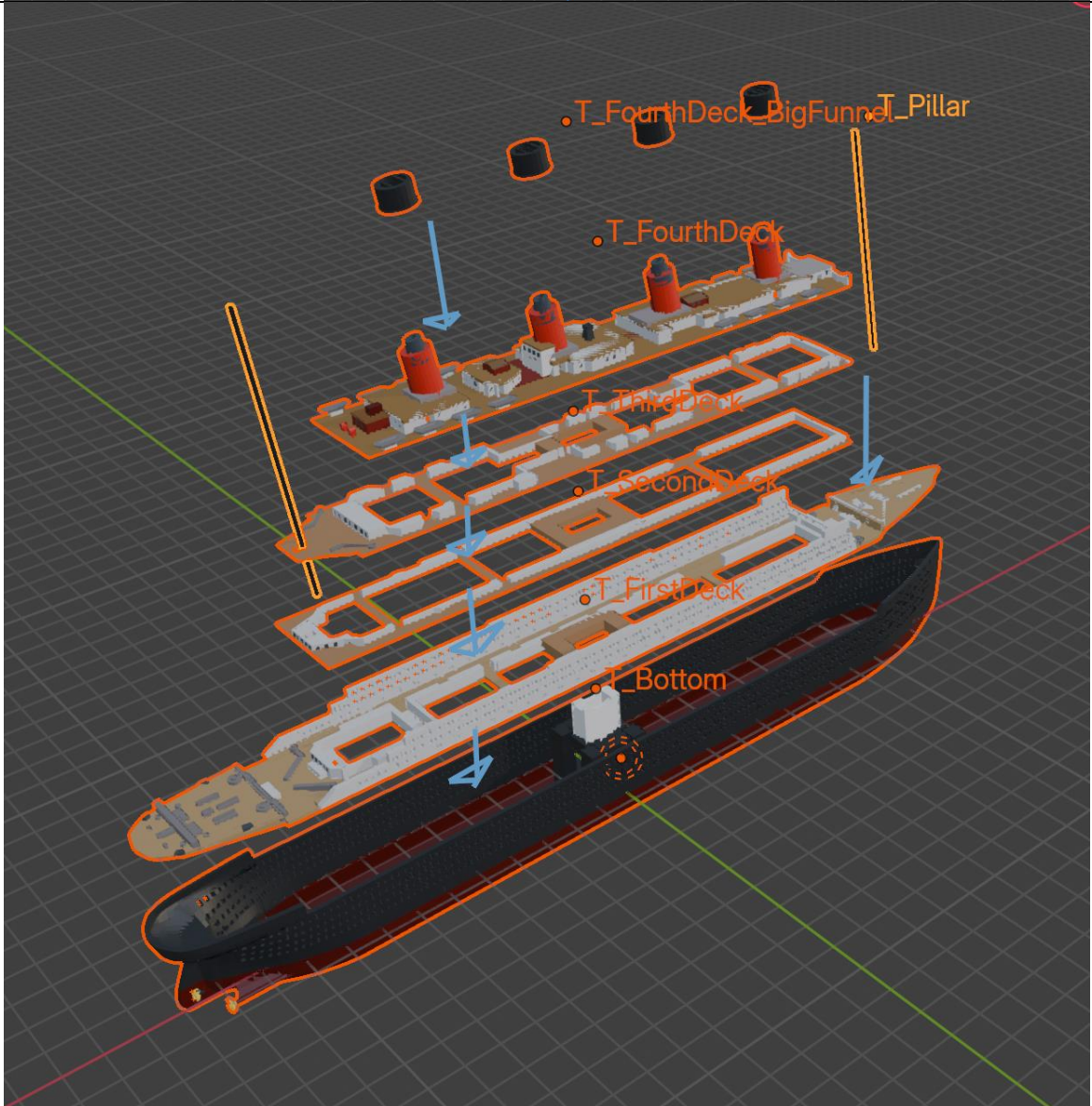
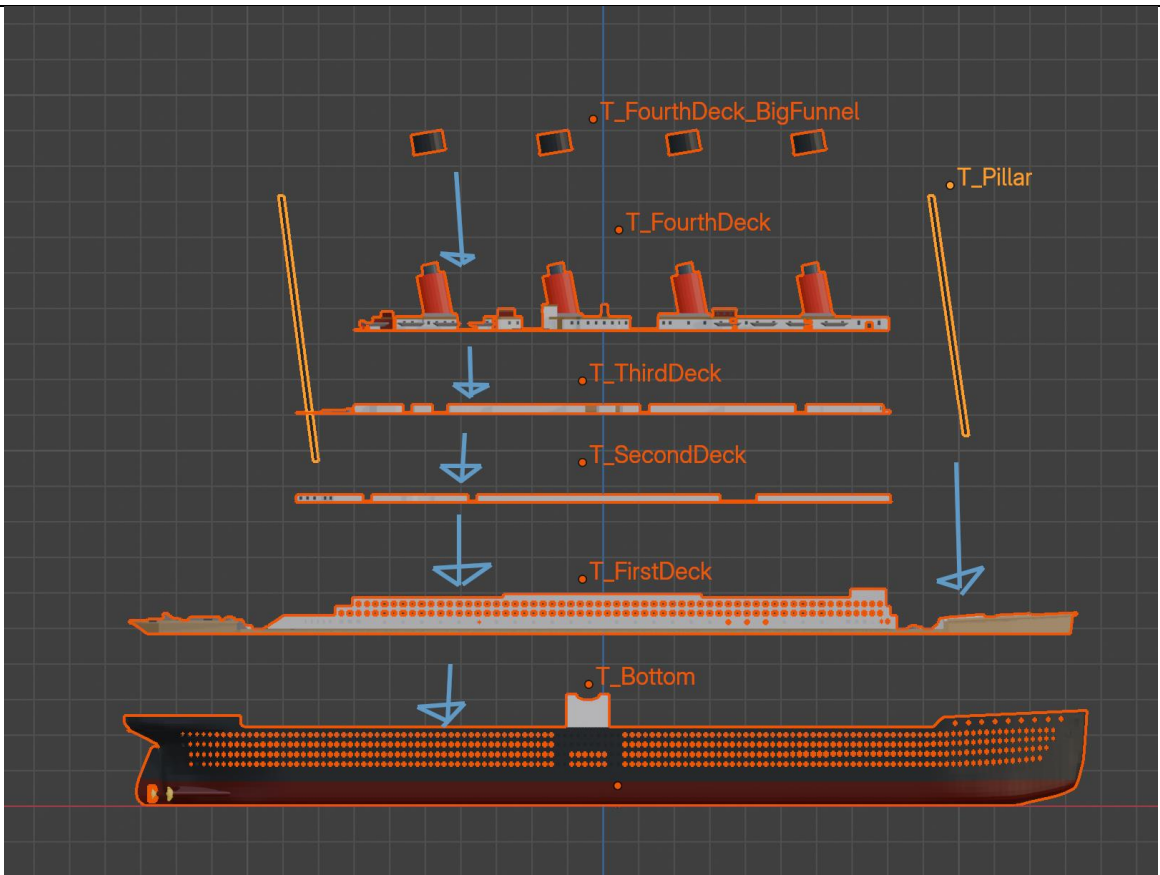
1:2500 Model (App. 11cm (L) x 1.2cm (W) x 2.5cm (H)),set to 40% scale

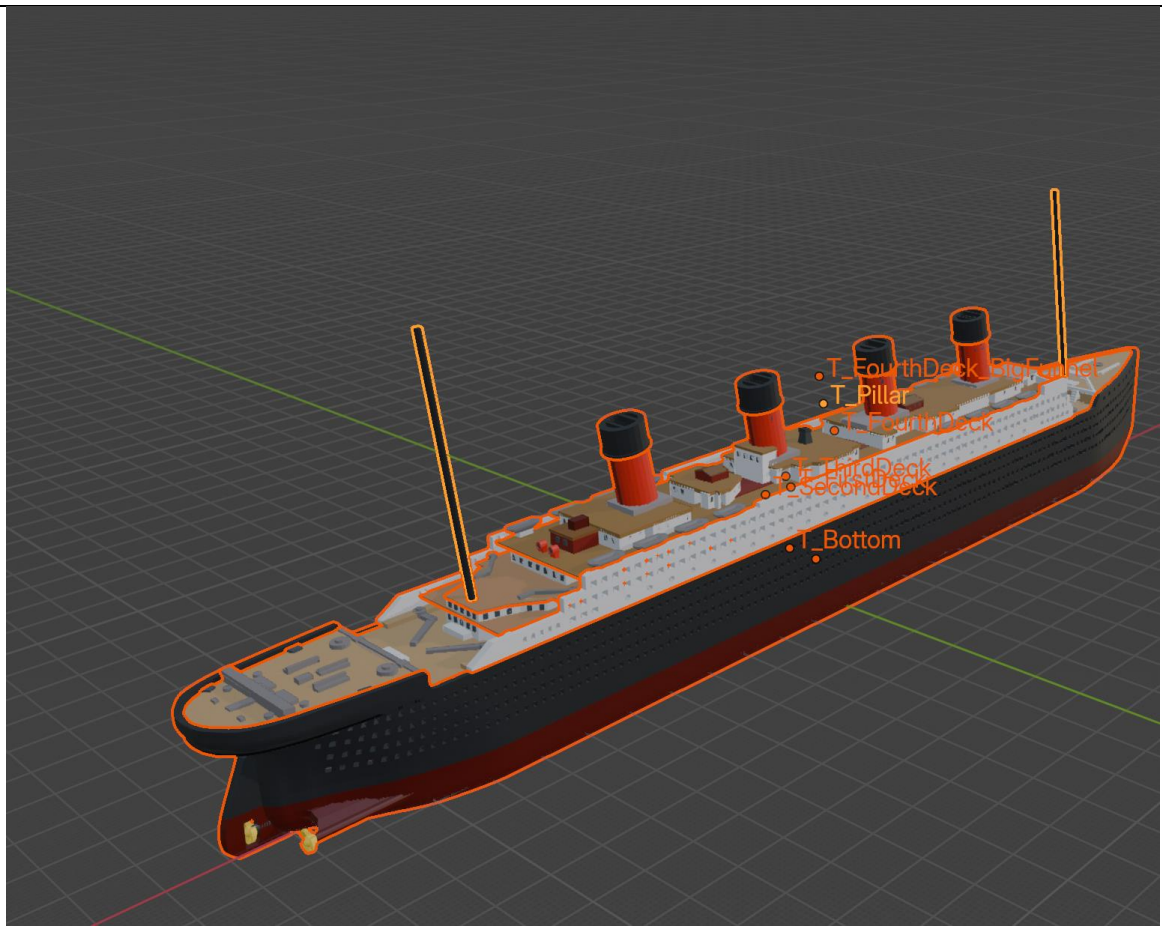
Printing File:

UseThisOne_T_FullTitanic_1To2500Scale_ReadyForPrinting.stl

Check List


















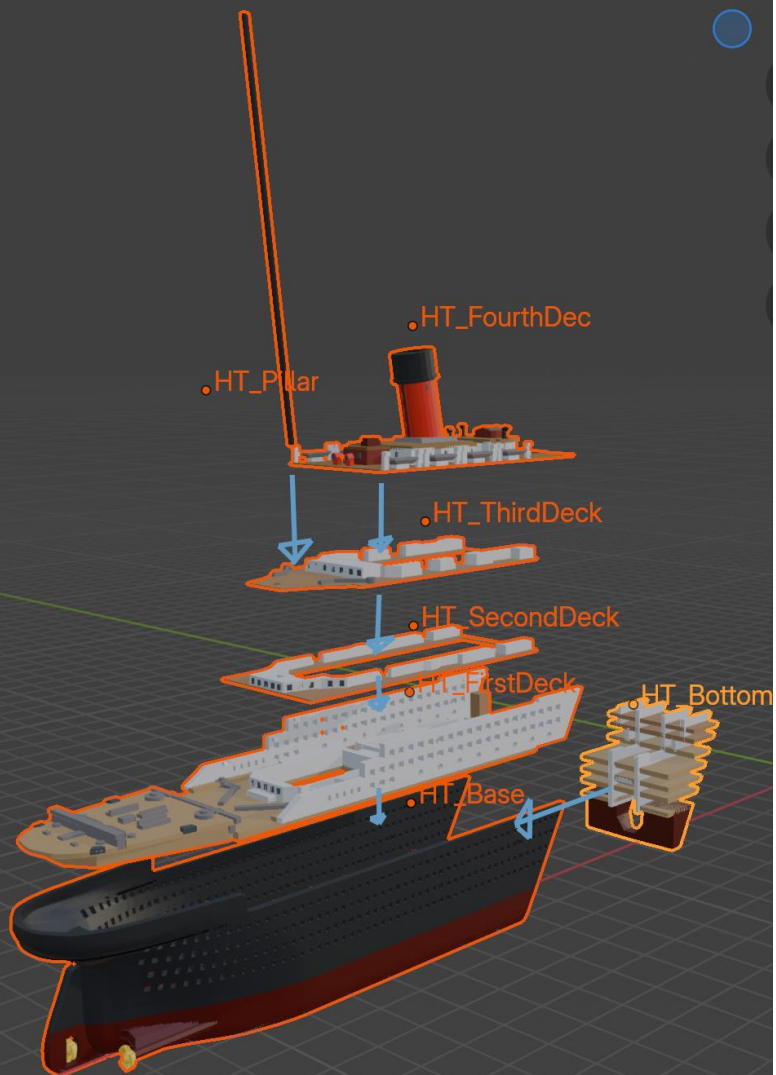
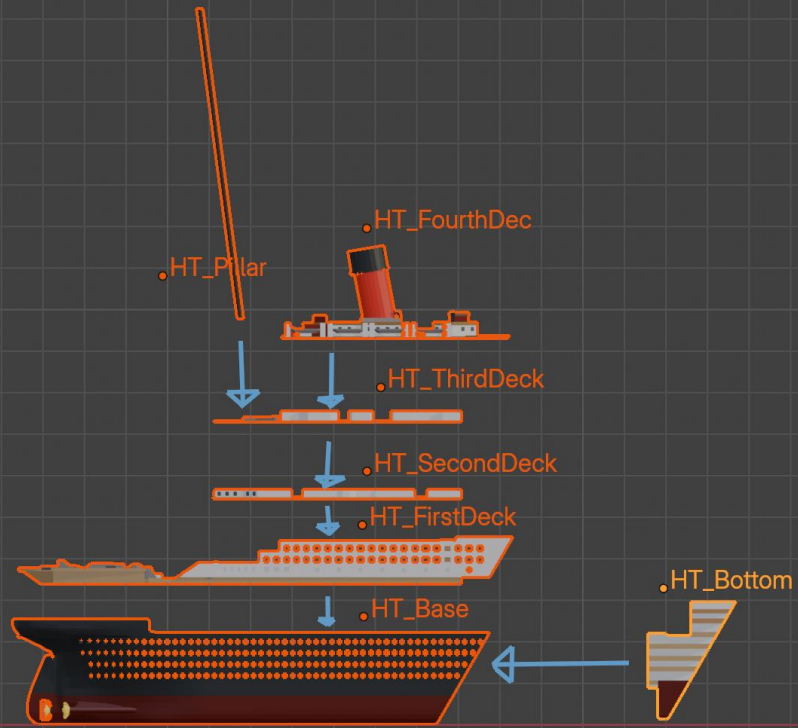
30DegreeRotate

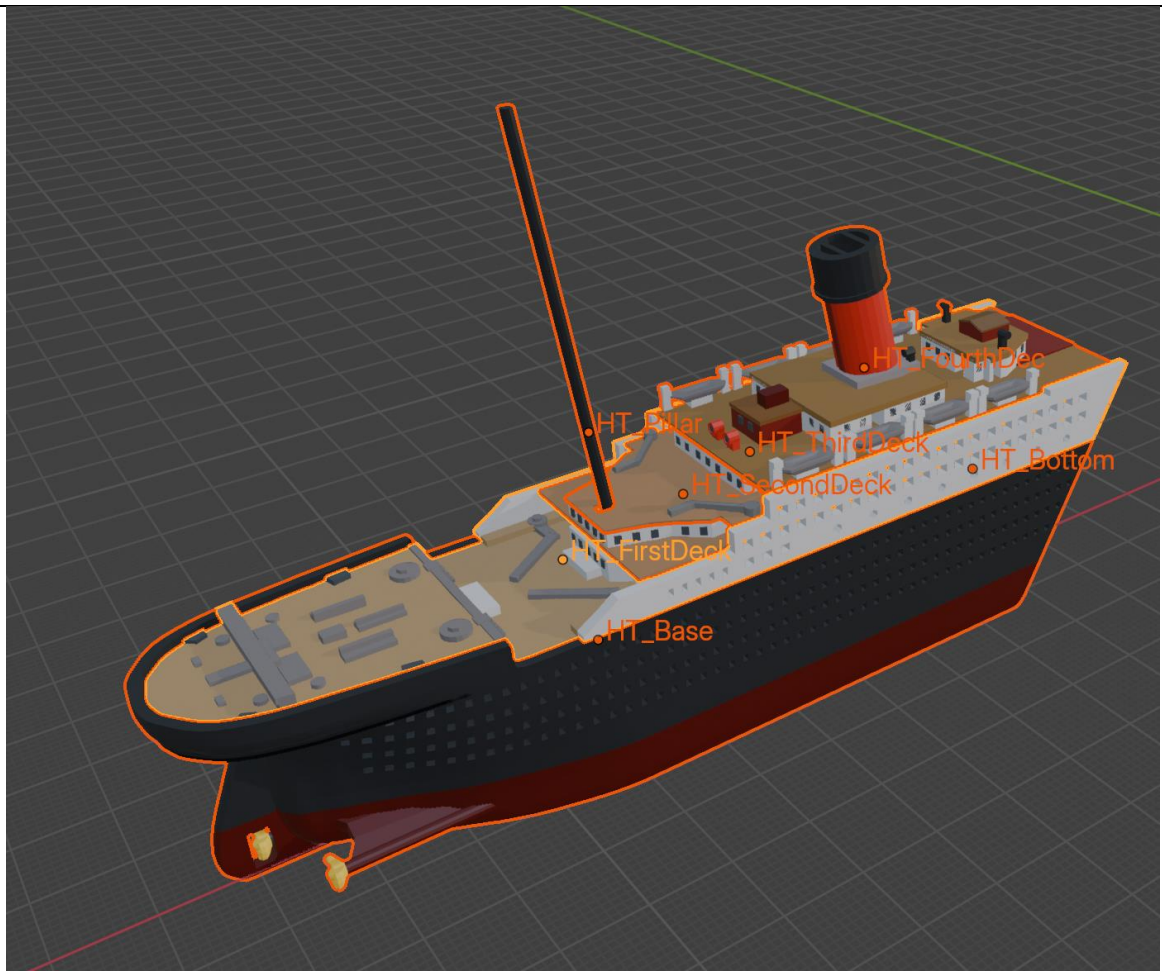
Printing file:

UseThisOne_HT_30DegreeRotate_ReadyForPrinting.stl

Check list

- ▼  30DegreeRotate
- > ▼ HT_2_5mm2000scaleMagnet 
- > ▼ HT_2_5mm2500ScaleMagnet 
- > ▼ HT_Base 
- > ▼ HT_Bottom 
- > ▼ HT_FirstDeck 
- > ▼ HT_FourthDec 
- > ▼ HT_Pillar 
- > ▼ HT_SecondDeck 
- > ▼ HT_SupportingForFirstDeck 
- > ▼ HT_ThirdDeck 






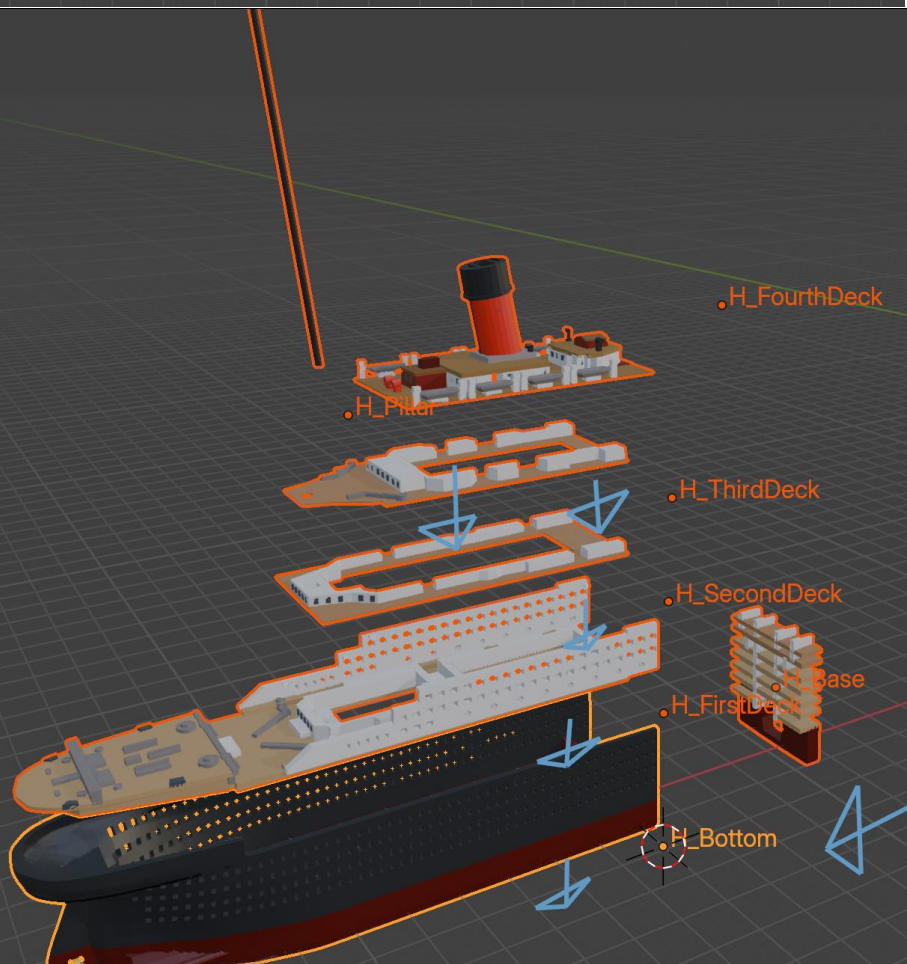
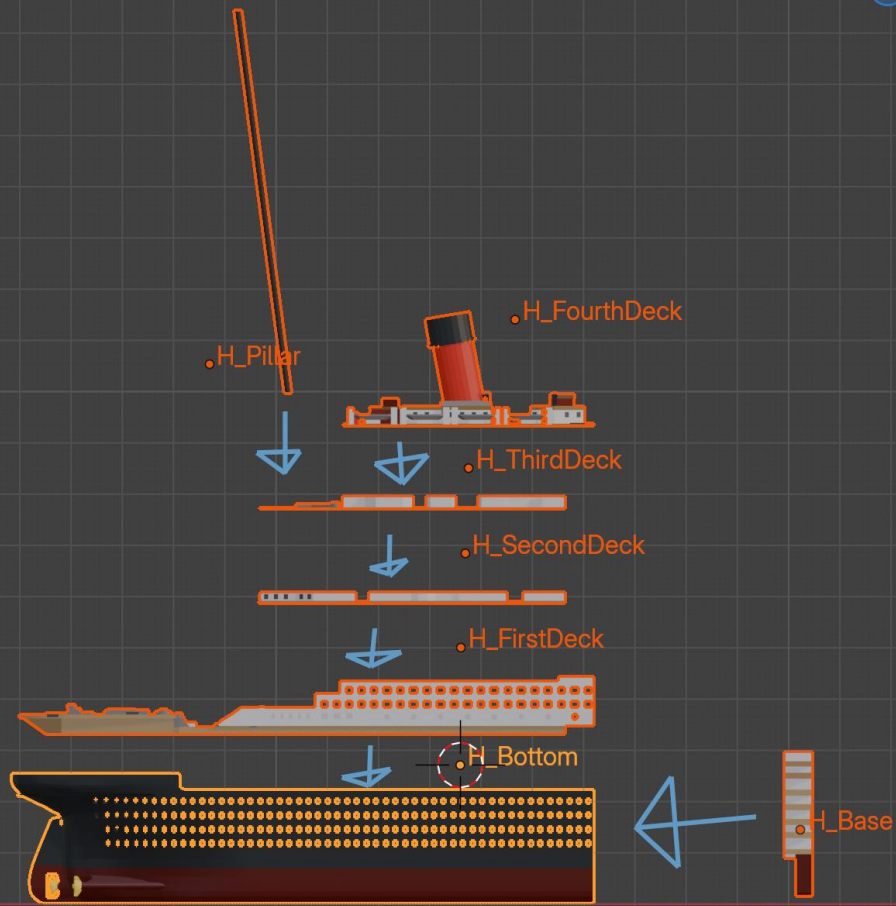
Half Titanic

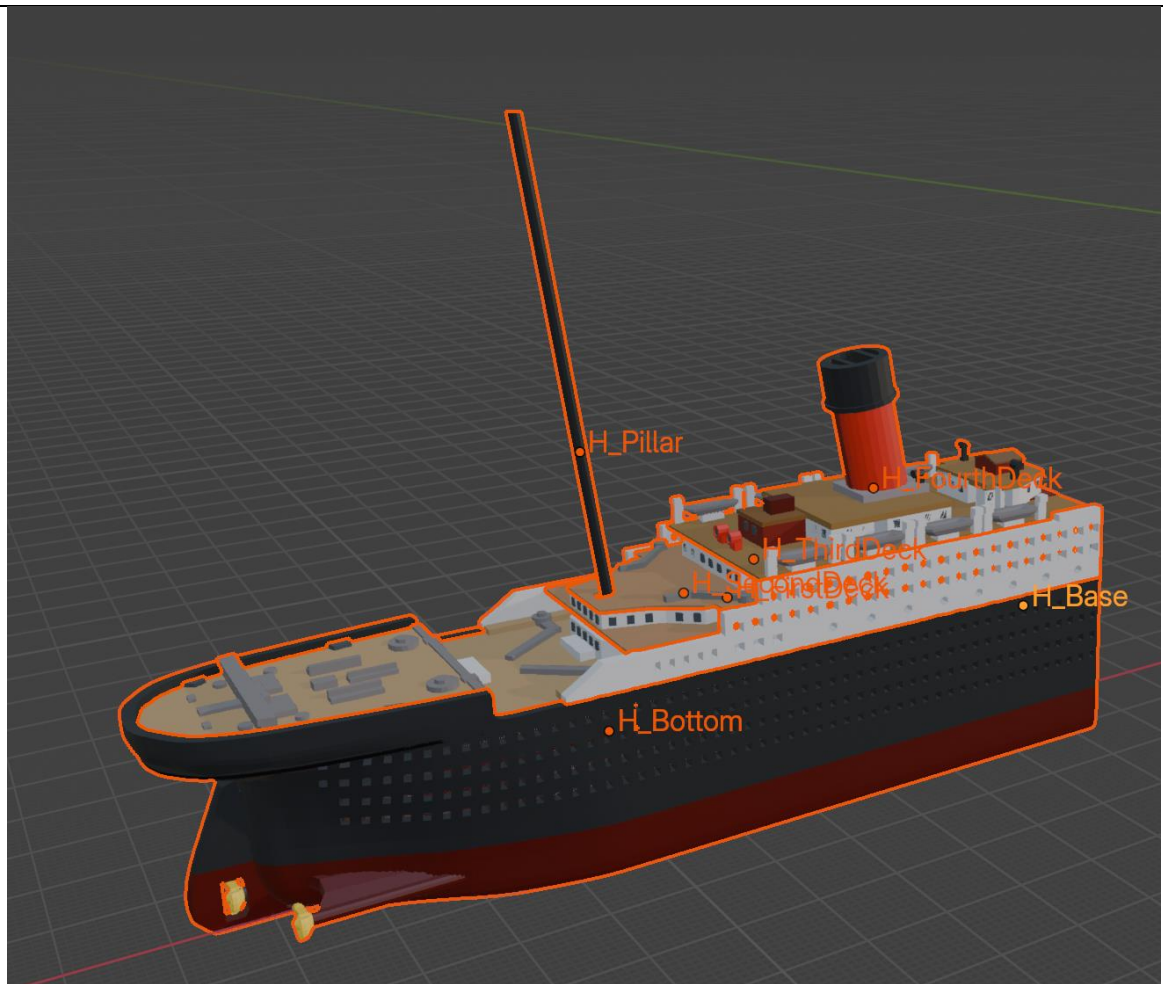
Printing file:

UseThisOne_H_HalfTitanic_ReadyForPrinting.stl

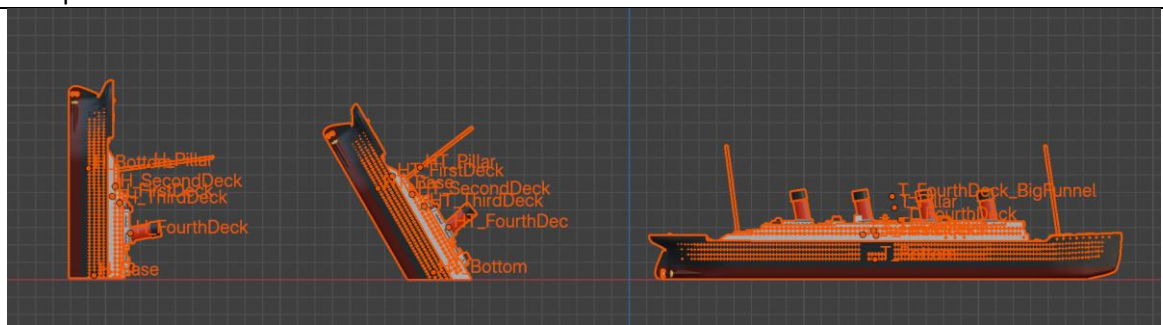
Check List

- ▼  Half_Titanic
 - > ▼ H_2_5mm2000ScaleMagnet 
 - > ▼ H_2_5mm2500ScaleMagnet 
 - > ▼ **H_Base** 
 - > ▼ H_Bottom 
 - > ▼ H_FirstDeck 
 - > ▼ H_FourthDeck 
 - > ▼ H_Pillar 
 - > ▼ H_SecondDeck 
 - > ▼ H_SupportingForFirstDeck 
 - > ▼ H_ThirdDeck 





Completed



Printing Setting (Suggested Value)

1:2000 (Please set the model scale to 50%)

1:2500 (Please set the model scale to 40%)

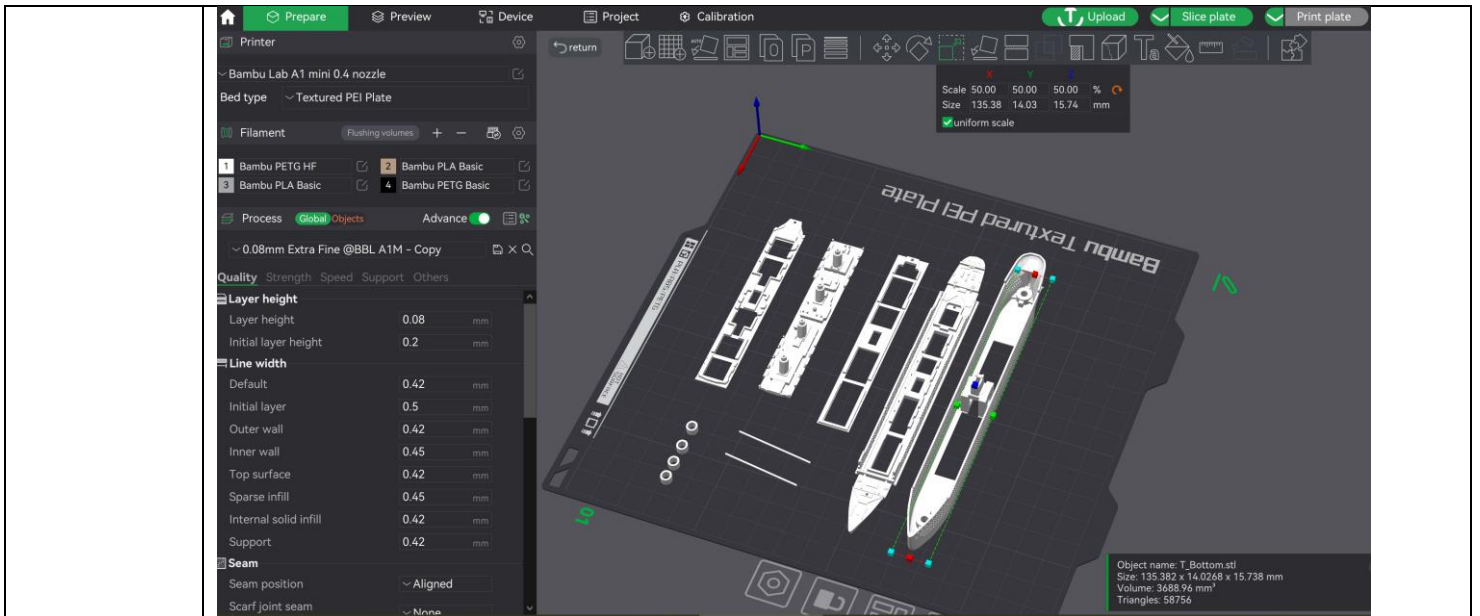
Use 0.08mm extra Fine for layer height

Use different colour filament as well

Use sufficient glue to join the parts

Use 1mm wire instead of printing the pillar

Add 2.5mm diameter magnet, add LED light to the bottom of the ship (Optional)



0.08mm Extra Fine @BBL A1M - Copy

Quality **Strength** Speed Support Others

Walls

- Wall loops: 2
- Detect thin wall:

Top/bottom shells

- Top surface pattern: Monotonic I...
- Top shell layers: 9
- Top shell thickness: 0.8 mm
- Bottom surface pattern: Monotonic
- Bottom shell layers: 7
- Bottom shell thickness: 0 mm
- Internal solid infill pattern: Rectilinear

Sparse infill

- Sparse infill density: 15 %
- Sparse infill pattern: Grid
- Length of sparse infill anchors: 100%

Initial layer speed

- Initial layer: 50 mm/s
- Initial layer infill: 105 mm/s

Other layers speed

- Outer wall: 200 mm/s
- Inner wall: 350 mm/s
- Small perimeters: 50% mm/s or %
- Small perimeter threshold: 0 mm
- Sparse infill: 450 mm/s
- Internal solid infill: 350 mm/s
- Top surface: 200 mm/s
- Slow down for overhang:
- 60 mm/s (10%, 25%)
- 30 mm/s [25%, 50%]

0.08mm Extra Fine @BBL A1M - Copy

Quality Strength Speed **Support** Others

Support

- Enable support:
- Type: tree(auto)
- Style: Default
- Threshold angle: 15 °
- On build plate only:
- Support critical regions only:
- Remove small overhangs:

Raft

- Raft layers: 0 layers

Support filament

- Support/raft base: Default
- Support/raft interface: Default

Advanced

- Initial layer expansion: 2 mm

0.08mm Extra Fine @BBL A1M - Copy

Quality Strength Speed Support **Others**

Bed adhesion

- Skirt loops: 0
- Skirt height: 1 layers
- Brim type: No-brim
- Brim width: 5 mm
- Brim-object gap: 0.1 mm

Prime tower

- Enable:
- Width: 35 mm
- Prime volume: 45 mm³
- Brim width: 3 mm

Flush options

- Flush into objects' infill:
- Flush into objects' support:

Special mode

Thanks!!

Please do not resale the model.

If you need blender file, please search keyword "Titanic" in my website:

<https://businessyuen.com>

For Enquiries, please email me at businessyuen@gmail.com