## BCAM-WS-22EZ-1-A: Guide: Print Settings



All parts only require cheep PLA as this is designed for standard factory loads of 22LR and everything is over designed/built. Most parts will not have any Infill as there is always 15 Walls and 15 Tops/Bottoms on every part.

WARNING!!! DO NOT PRINT WITH FEWER *WALLS* AND *TOPS/BOTTOMS*, DOING SO COULD RESULT IN AN UNSAFE PRINT.

Table of Contents:

Page: Part:

- 2 Frame-Left
- 3 Frame-Center
- 4 Frame-Right
- 5 Slide
- 6 Trigger
- 7 Trigger Sear
- 8 Barrel Block
- 9 BAT-PC
- 10 Slug Cut Template
- 11 Tools/Materials
- 12 Notes

Ultimaker Cura	PREPARE PREVIEW	MONITOR
M18	Ceneric PLA	< 🚍 0.15 quick - Draft - 0
<u>2</u>		
	2	
<u></u>	0	
▲ Object list		
<ul> <li>CFFFP_22EZ-1-A-Frame-Left</li> <li>210.0 x 106.4 x 15.5 mm</li> </ul>		
210.0 x 106.4 x 15.5 mm		

Part Name	Frame-Left
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	!

<b>Ultimaker</b> Cura		PREPARE	PREVIEW	MONITOR	
М18 <	0 Generic PLA			<	📮 0.15 quick - Draft - 0.2
<u>9</u> -2					
		·			
				曲	
▲ Object list					
CFFFP_22EZ-1-A-Frame-Center 106.3 x 124.4 x 7.0 mm					
* 🗊 🗗 🔂 🗗		Sec.			

Part Name	Frame-Center
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	·

Ultimaker Cura	PREPARE PREVIEW	MONITOR
М18 <	Generic PLA	< 📮 0.15 quick - Draft - 0.2
▲ Object list		
CFFFP_22EZ-1-A-Frame-Right 210.0 x 106.4 x 15.5 mm		
\$ Ø Ø <b>6</b> Ø		

Part Name	Frame-Right
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

<b>Ultimaker</b> Cura		PREPA	RE PREVIEW	MONITOR	
М18	<	Generic PLA		۲	🚍 0.15 quick - Draft - 0.2
<b>E</b>					
<u>5</u>					
IL.					
L,					
▲ Object list					
CFFFP_22EZ-1-A-Slide 36.0 x 46.0 x 140.0 mm					
\$ Ø 0 1 6 0					

Part Name	Slide
Color	Any
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

<b>Ultimaker</b> Cura		PREPARE PREVIEW	MONITOR	
М18 <	Generic PLA		<	🚍 0.15 quick - Draft - 0.2
		-		
▲ Object list				
CFFFP_22EZ-1-A-Trigger 100.0 x 55.0 x 6.0 mm				

Part Name	Trigger	
Color	Second	
Layer Height	0.2mm	
Infill Type	Any Type, As Support, 50Deg Overhang	
Infill Density	15%	
Bed Adhesion	None	
Support From	None	
Support Angle	N/A	
Notes: Scale this down Un-Uniformly only in Z to 5mm and use washers on 1 or both sides as shims.		

<b>Ultimaker</b> Cura	PREPARE PREVIEW	MONITOR
м18 <	0 Generic PLA	< 📮 0.15 quick - Draft - 0.
<u>2-2</u>		
↑ Object list		
CFFFP_22EZ-1-A-Trigger Sear 39.0 x 26.0 x 6.0 mm		
\$ 0 0 C		

Part Name	Trigger Sear
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

<b>Ultimaker</b> Cura		PREPARE PREVIEW	MONITOR	
🗁 м18 <	0 Generic PLA		<	📮 0.15 quick - Draft - 0.2
		6		
▲ Object list	ttt		TH	
CFFFP_22EZ-1-A-barrel block 40.0 x 30.0 x 27.0 mm				
\$ \$ \$ \$ \$				

Part Name	Barrel Block
Color	Any
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

<b>Ultimaker</b> Cura			PREPARE	PREVIEW	MONITOR	
М18	< 🝳	Generic PLA			<	📮 0.15 quick - Draft - 0.2
<u>5</u>						
			Ē	e eue		
			5			
<ul> <li>Object list</li> </ul>		TH			TH	
CFFFP_22EZ-1-A-BAT-PC 125.0 x 70.0 x 24.0 mm						
🕈 🗊 🗗 🔂 🗗						

Part Name	BAT-PC
Color	Any
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

<b>Ultimaker</b> Cura			PREPARE PREVIEW	MONITOR	
M18	<	Generic PLA		<	📕 0.15 quick - Draft - 0.
▲ Object list					
CFFFP_22EZ-1-A-Slug Cut Templ 22.4 x 22.4 x 72.0 mm	ate				

Part Name	Slug Cut Template
Color	Any
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	· · · ·

Tools/Materials:

Tools:

- Metal Saw or Grinder with cutting wheel
- File
- 5.7mm Reamer
- Rotary tool with small stone
- Bit Driver for what ever Hardware you end up using
- 3D Printer
- Drill and Drill bits

Materials:

- PLA approx 0.5-1KG
- 6 ea 5x20-25mm grip head bolts
- 3-6ea 5mm washers or what ever size fits your large bolts
- 4 ea 4x20mm grip head bolts
- 50-200mm of 8mm OD 22 cal Barrel liner
- 18-19mm OD x 71mm long of Steel Round Bar (3/4" is close enough)
- JB Weld
- 8-13.5mm OD x 70-90mm long spring

Notes: