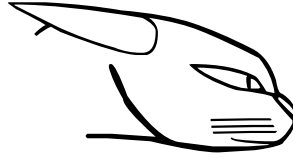


BCAM-WS-22EZ-1-A: Guide: Print Settings

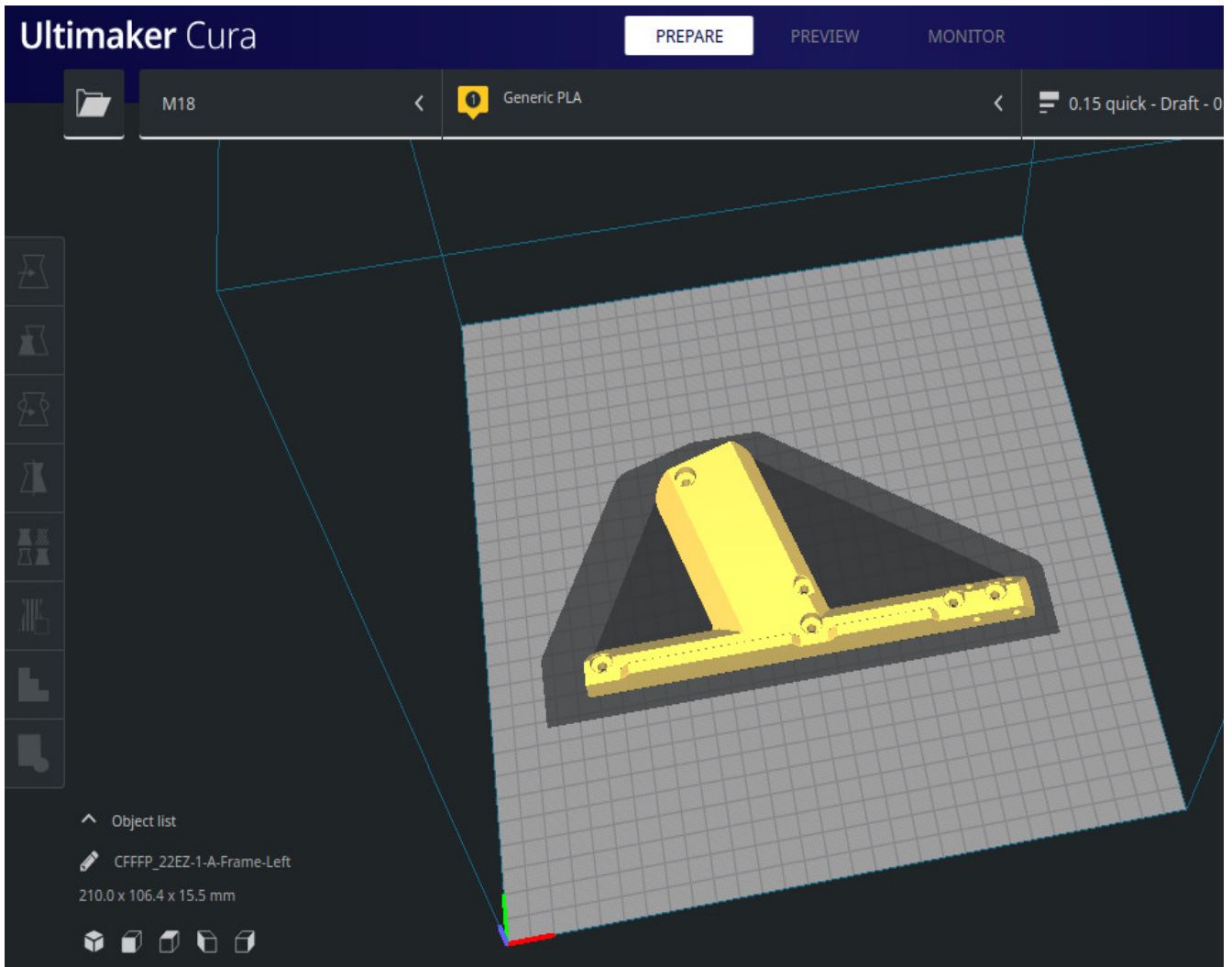


All parts only require cheap PLA as this is designed for standard factory loads of 22LR and everything is over designed/built. Most parts will not have any Infill as there is always 15 Walls and 15 Tops/Bottoms on every part.

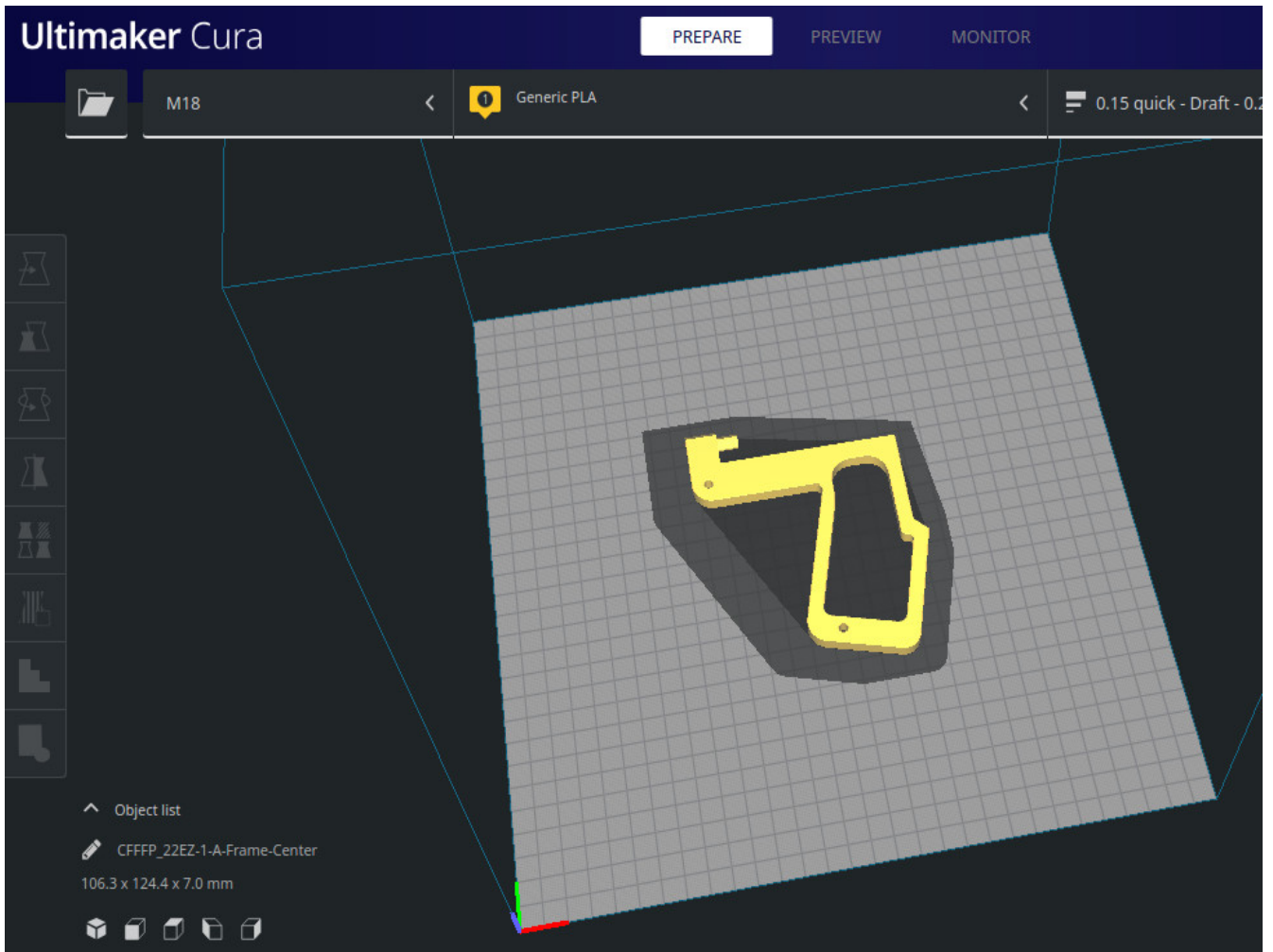
WARNING!!! DO NOT PRINT WITH FEWER WALLS AND TOPS/BOTTOMS, DOING SO COULD RESULT IN AN UNSAFE PRINT.

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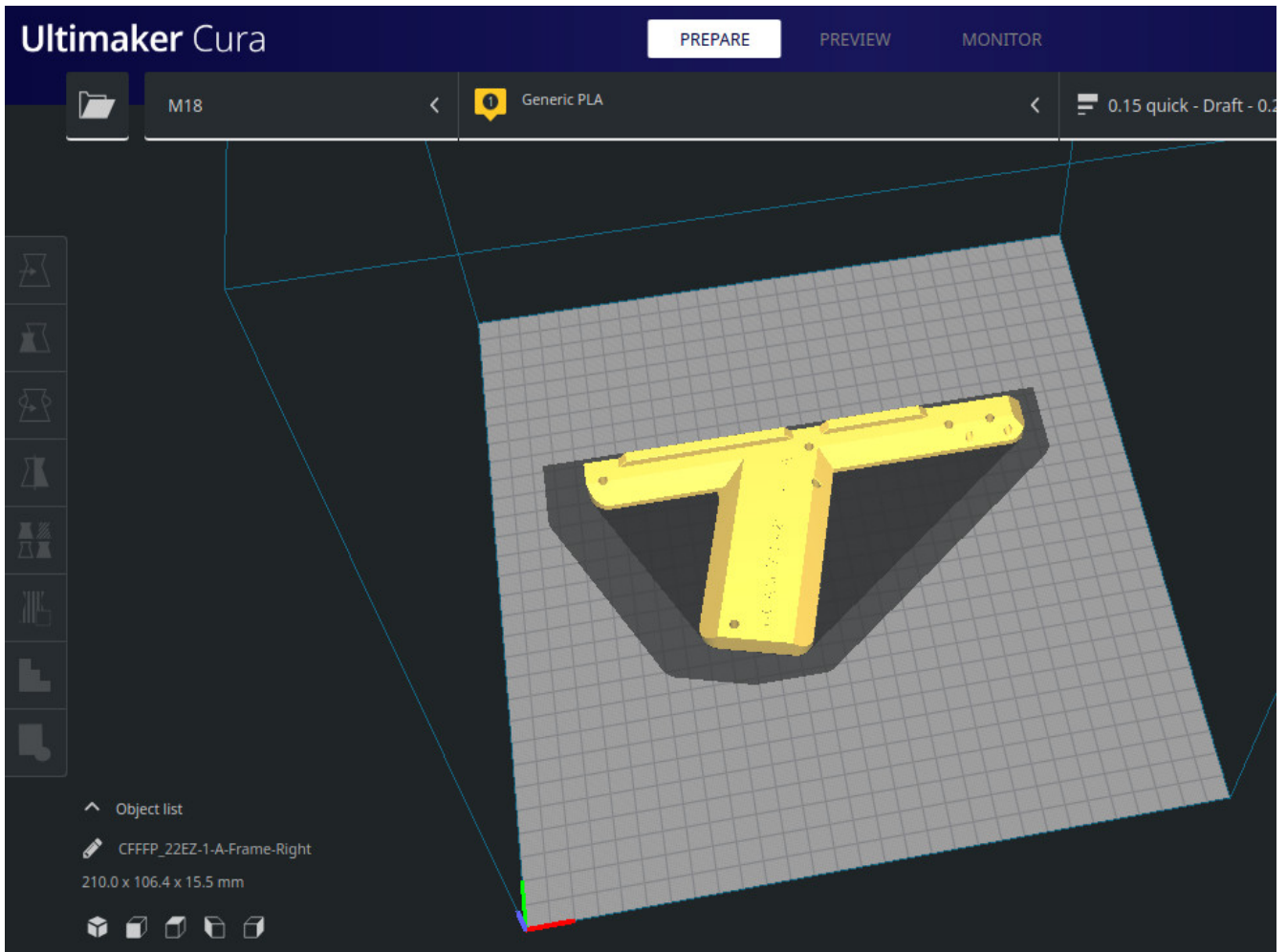
<u>Page:</u>	<u>Part:</u>
2	Frame-Left
3	Frame-Center
4	Frame-Right
5	Slide
6	Trigger
7	Trigger Sear
8	Barrel Block
9	BAT-PC
10	Slug Cut Template
11	Tools/Materials
12	Notes



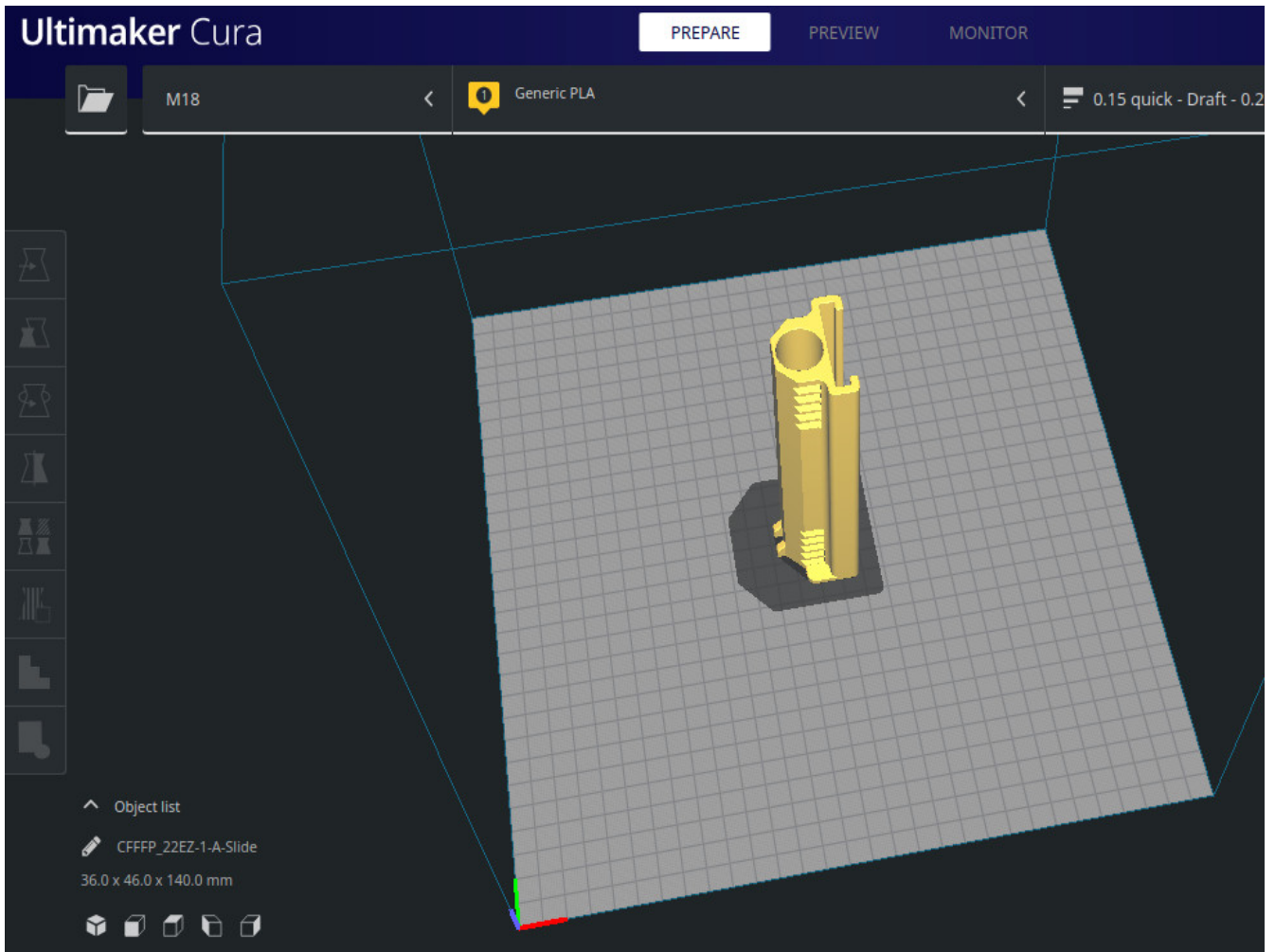
Part Name	Frame-Left
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	



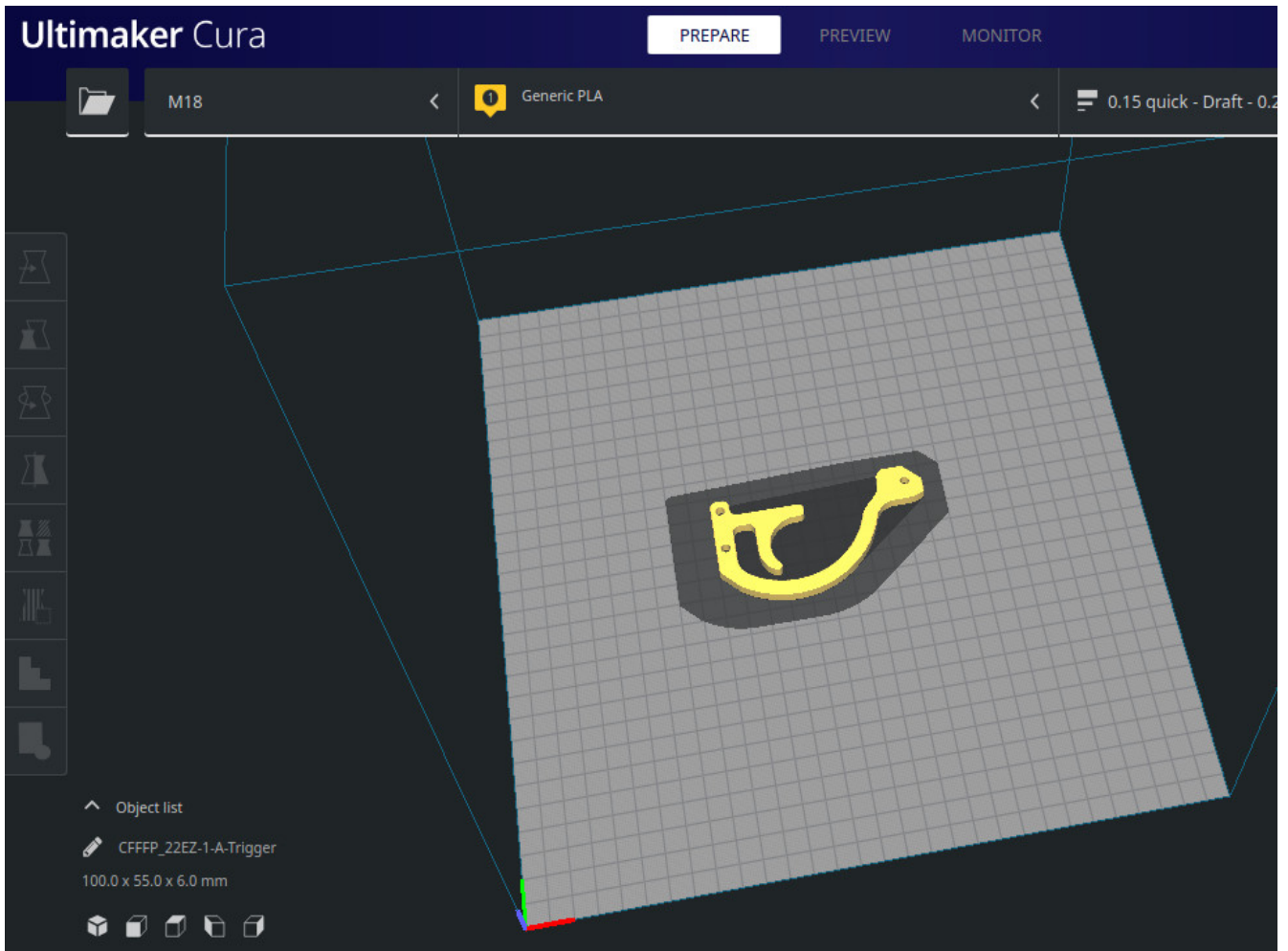
Part Name	Frame-Center
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	



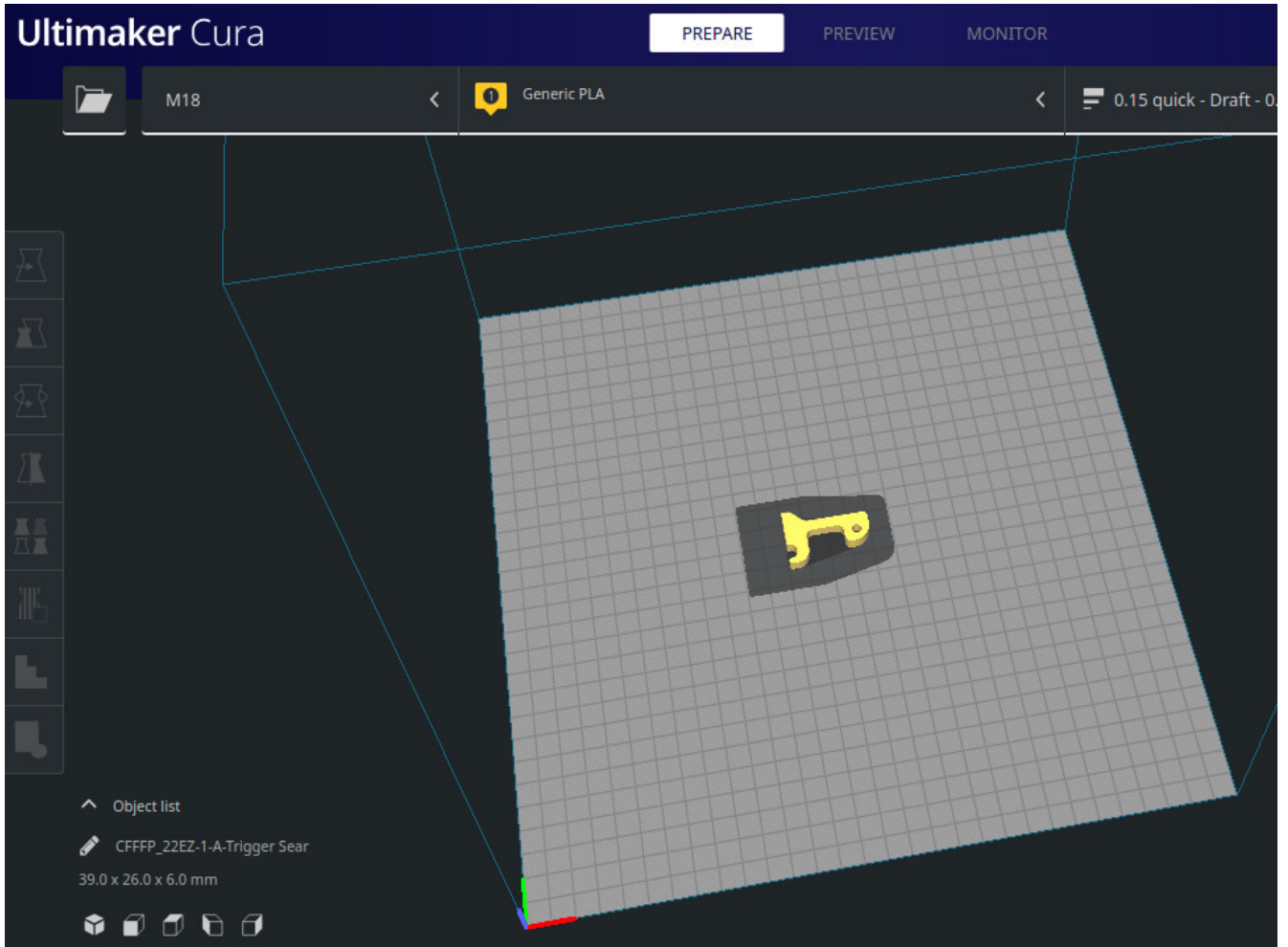
Part Name	Frame-Right
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	



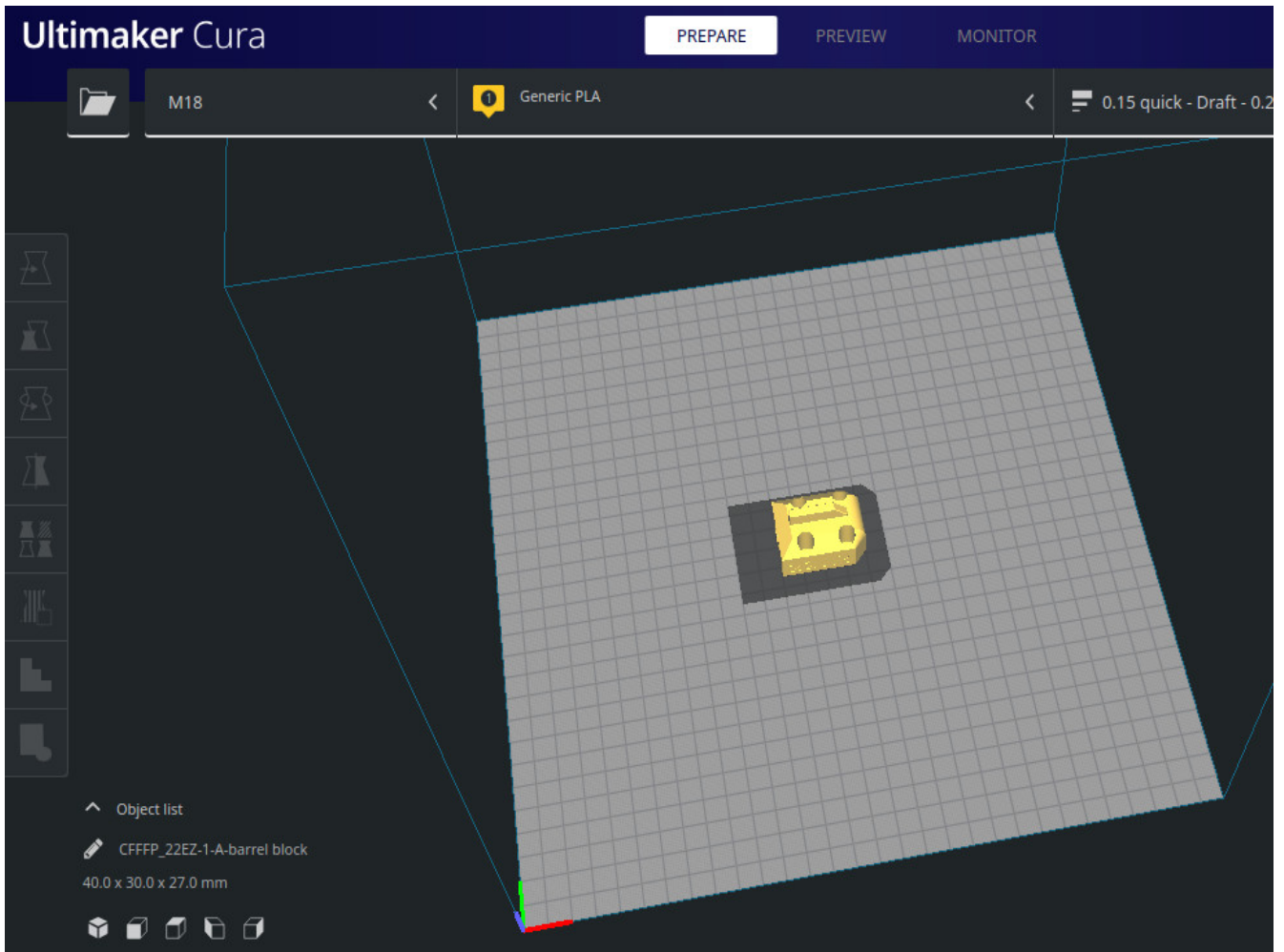
Part Name	Slide
Color	Any
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	



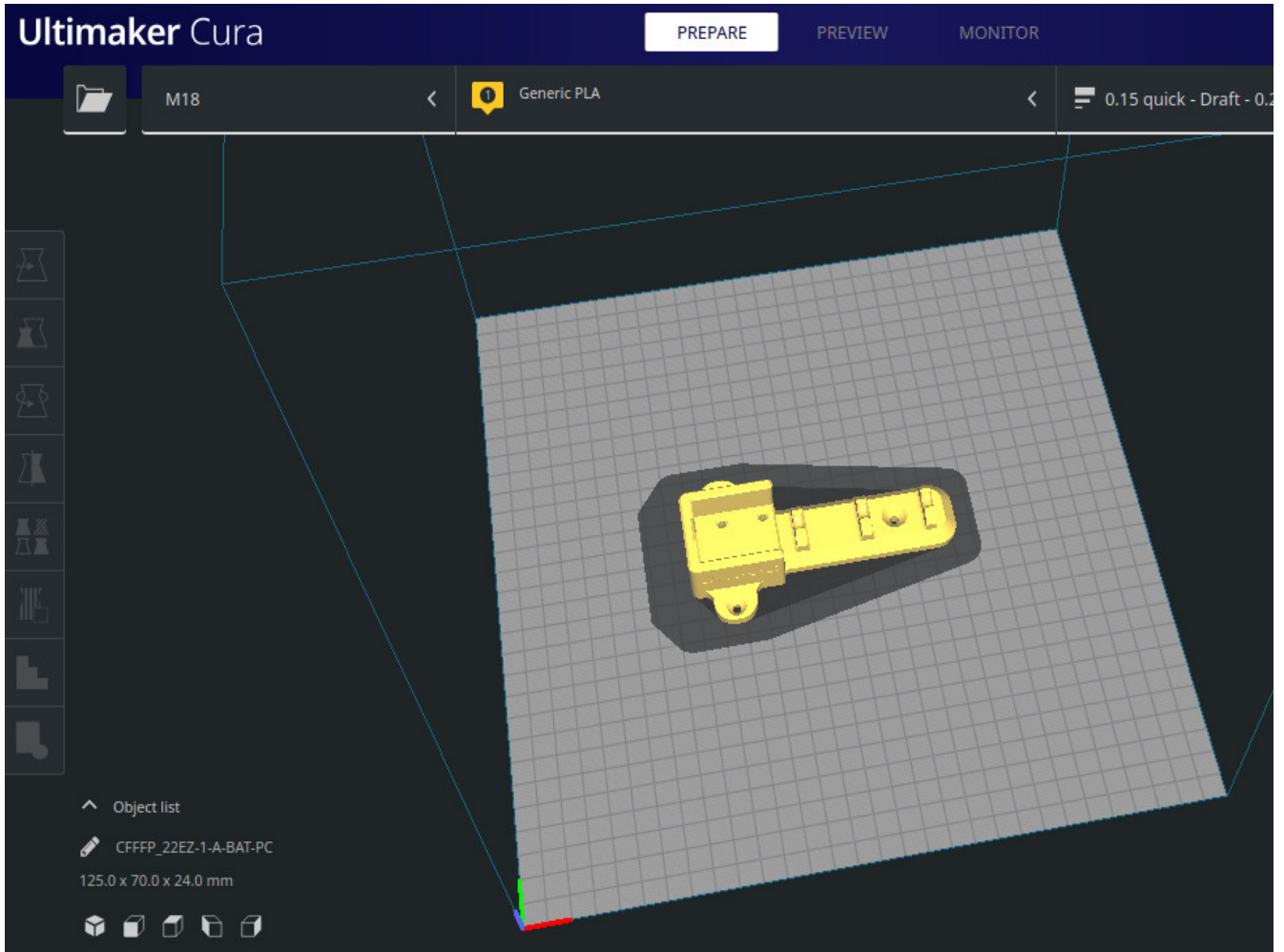
Part Name	Trigger
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes: Scale this down Un-Uniformly only in Z to 5mm and use washers on 1 or both sides as shims.	



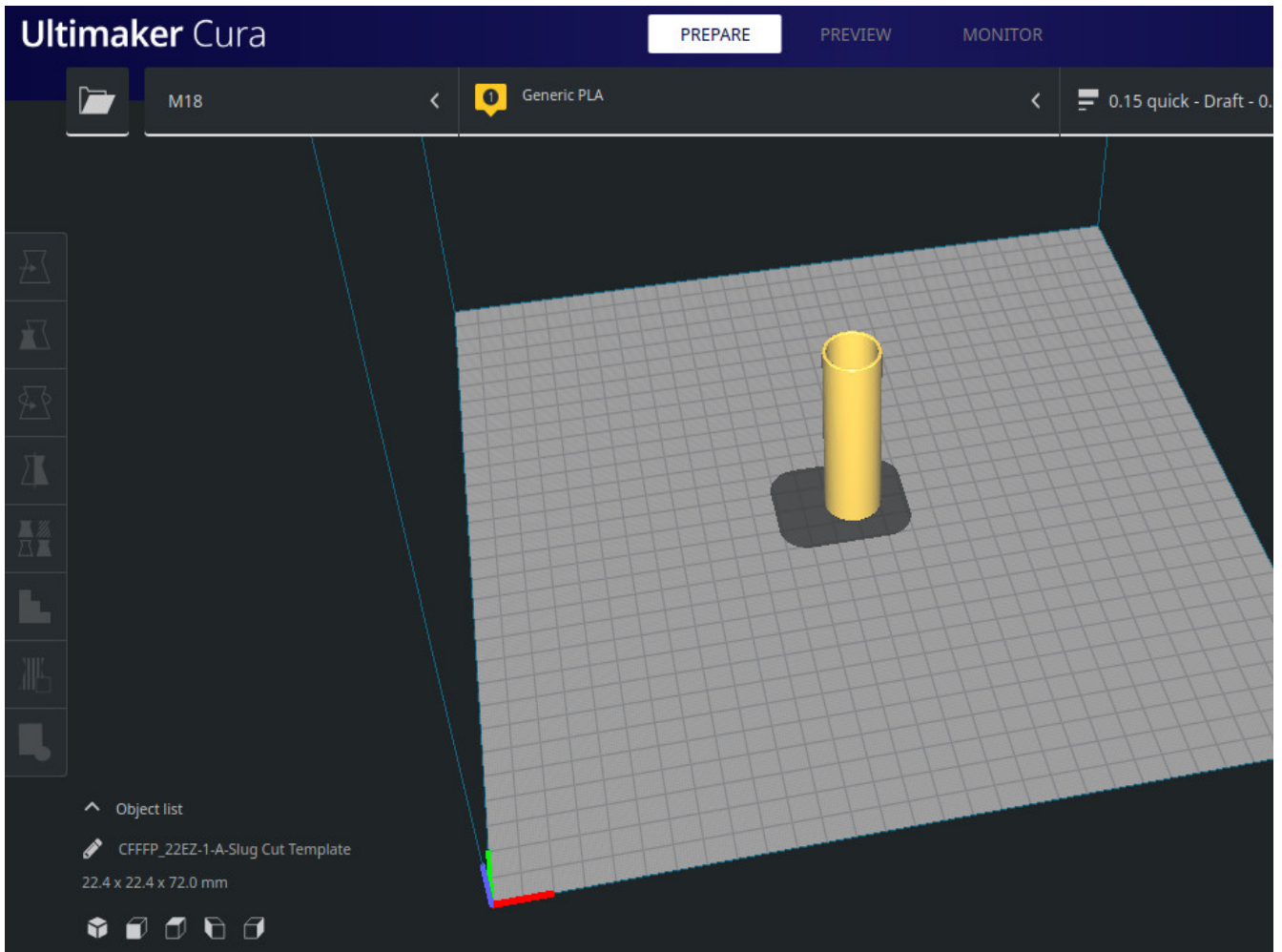
Part Name	Trigger Sear
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	



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:	



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:	



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: