

# BCAM-WS-22NSS-5-C: Guide: Print Settings



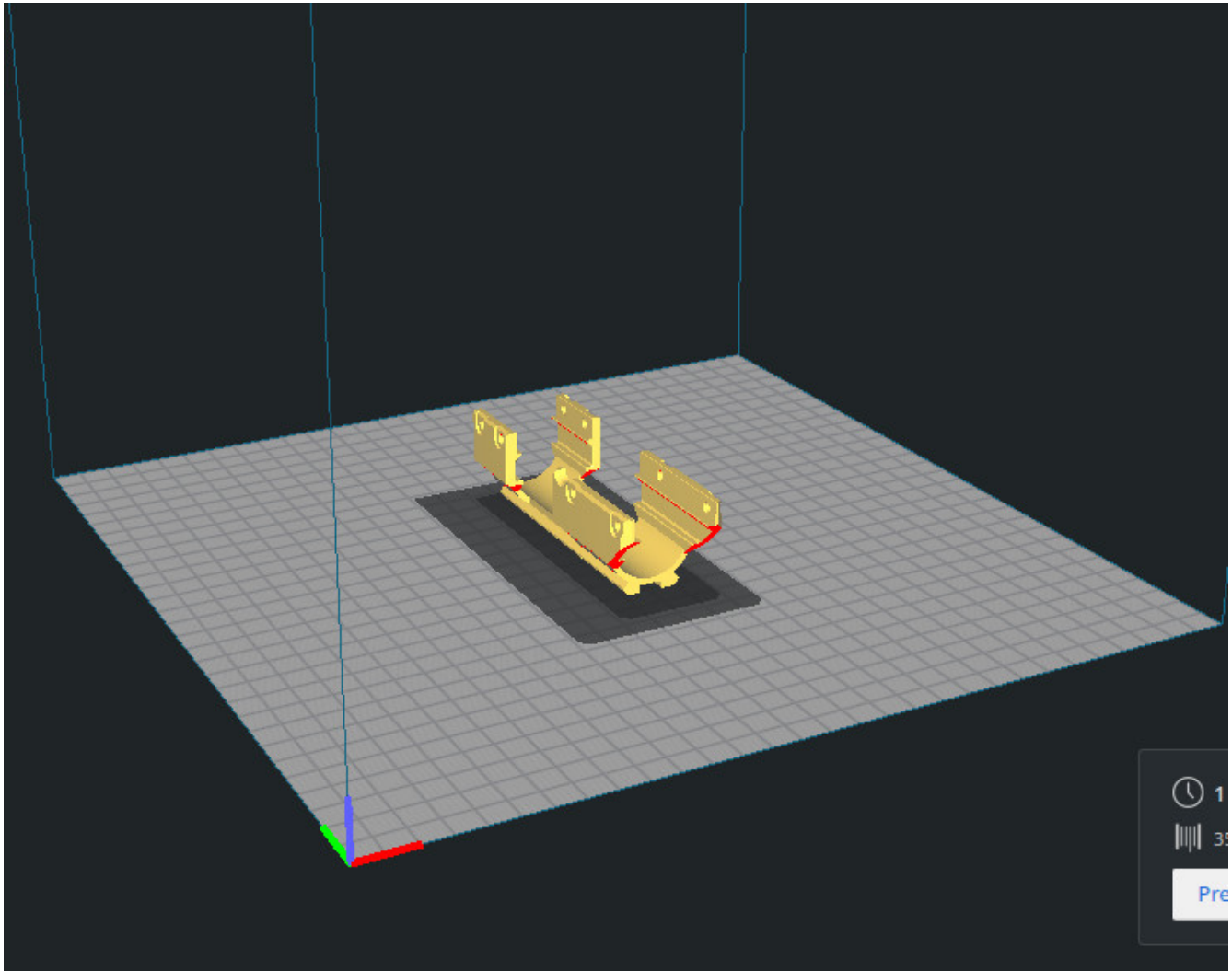
All parts only require cheap PLA as this is designed for standard factory loads of 22LR and everything is over designed/built. Most parts will not have any Infill as there is always 15 Walls and 15 Tops/Bottoms on every part.

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

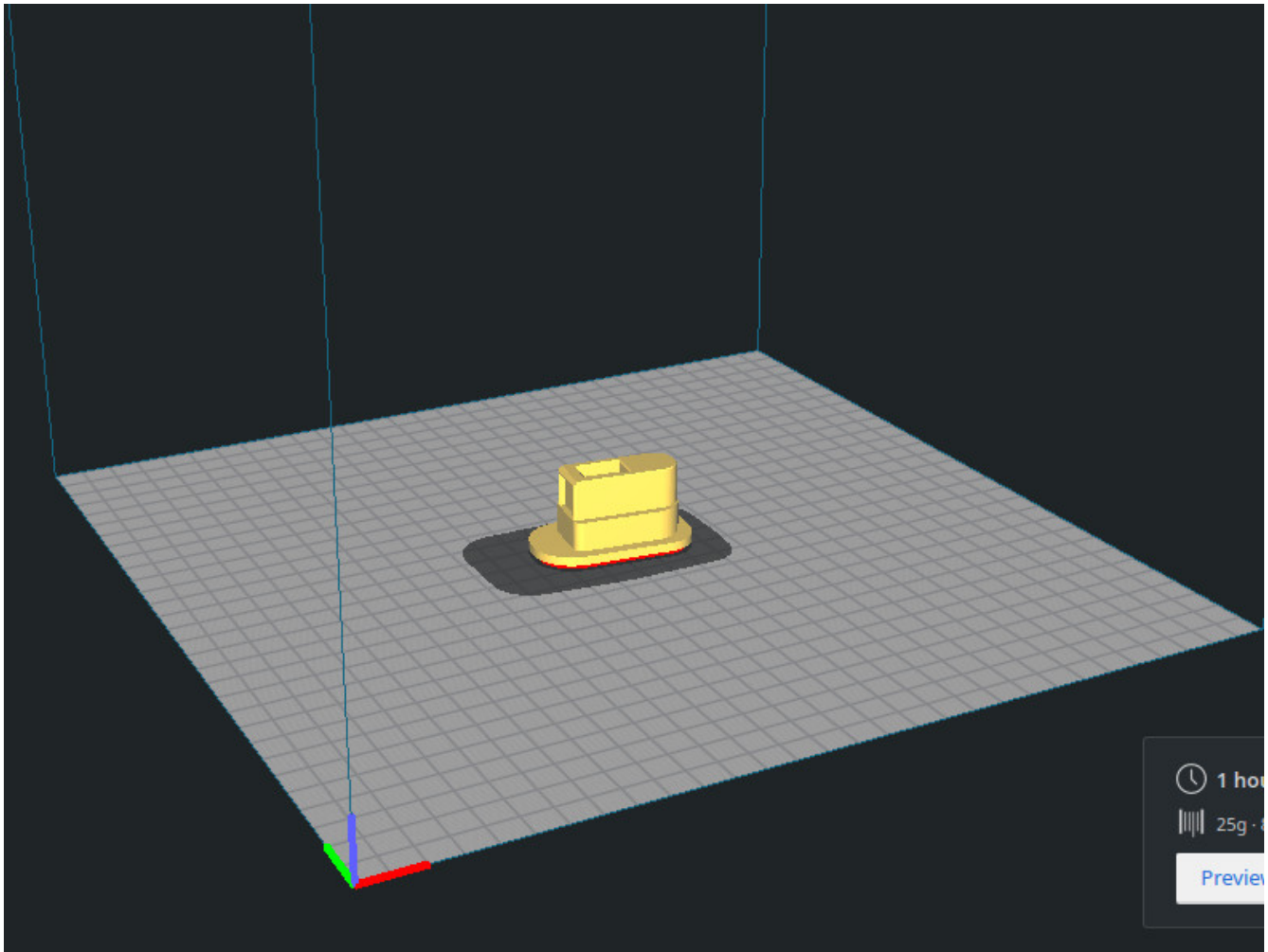
**WARNING!!! DO NOT USE ANYTHING BUT BULK PACK OR SUB SONIC AMMO IN THIS GUN. IT IS NOT DESIGNED TO HANDLE ANYTHING ELSE AND SOME HOTTER AMMO HAS CAUSED FAILURES IN TEST GUNS!!!**

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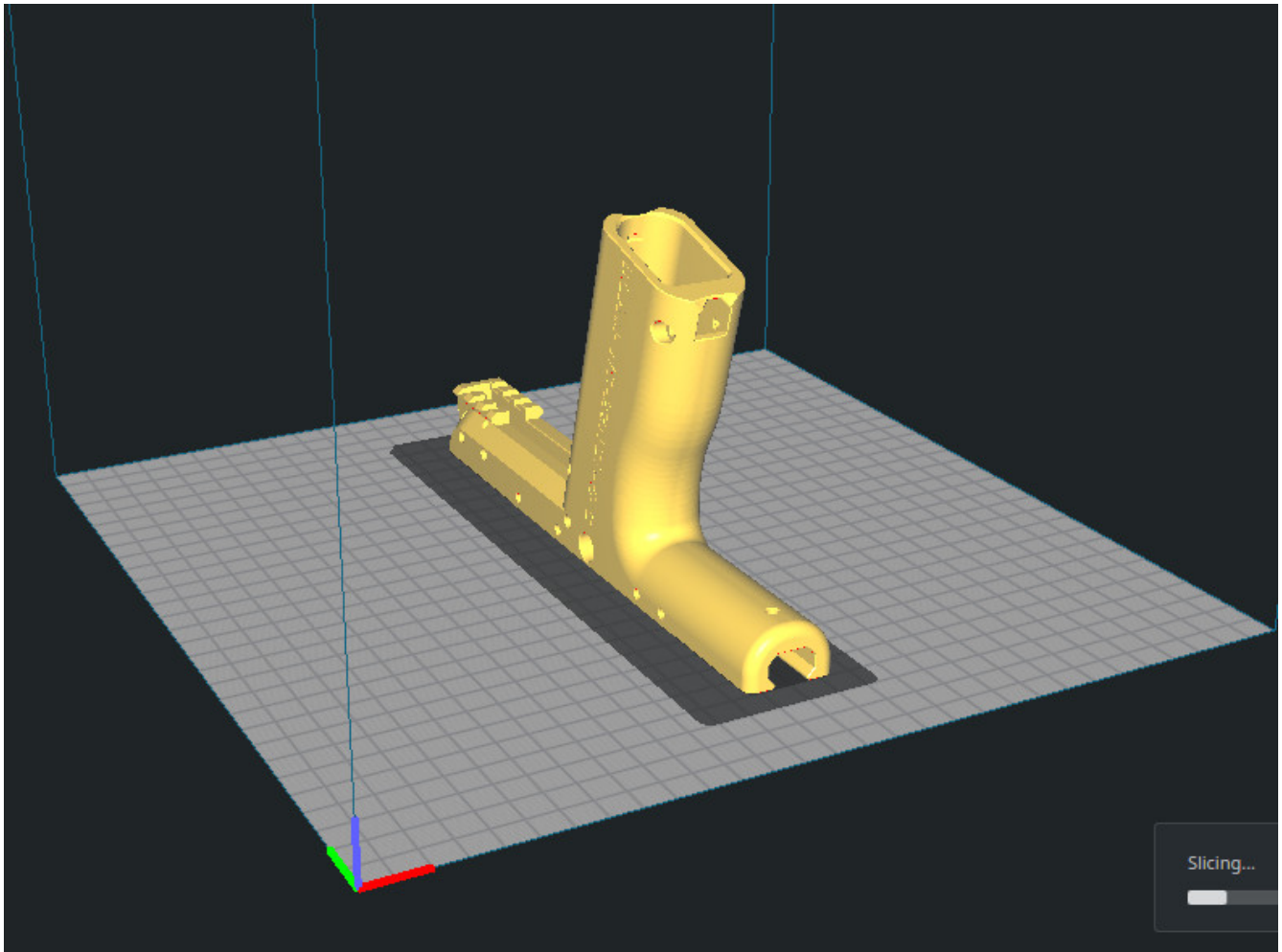
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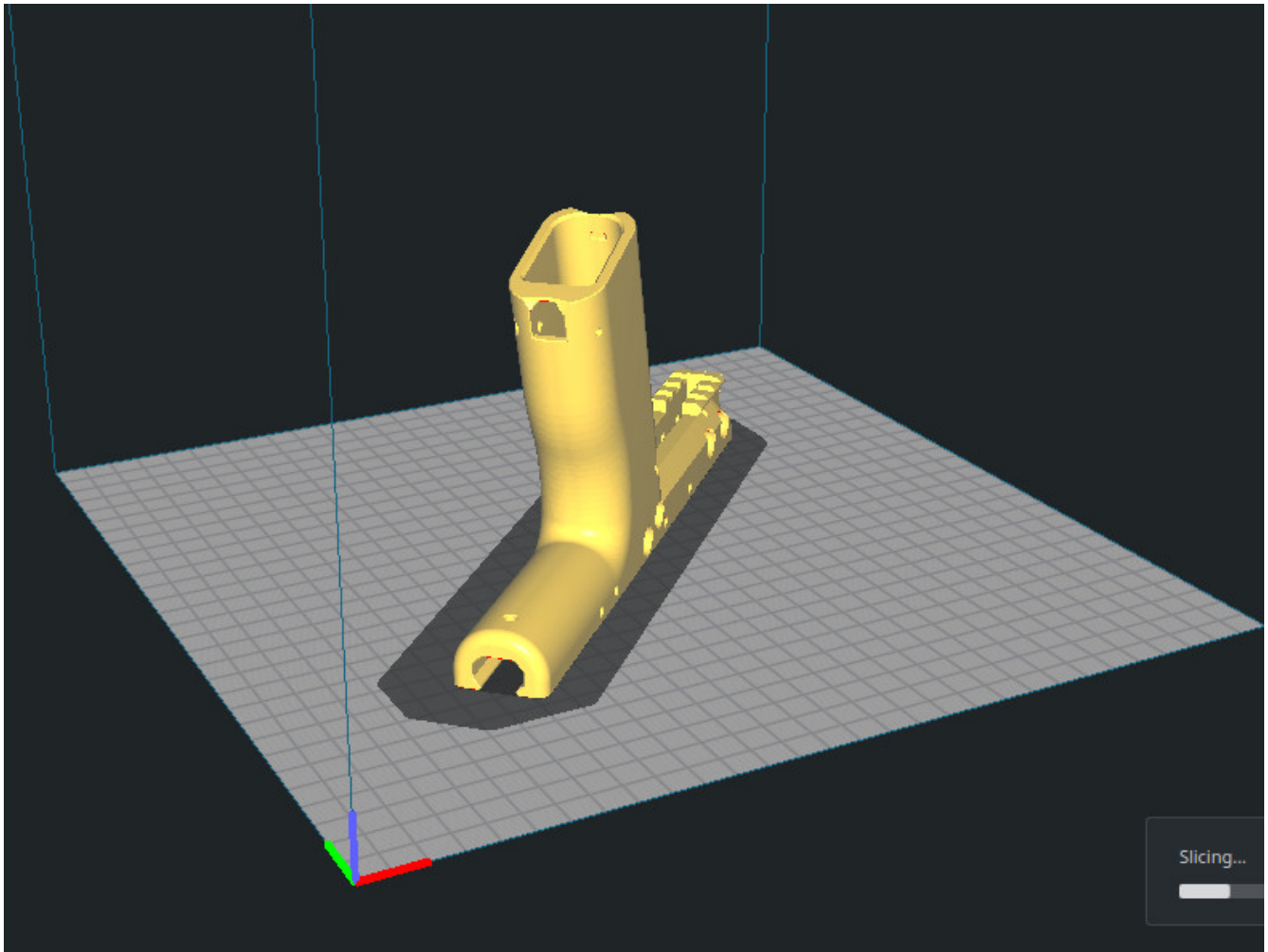
Part Name	Bridge
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	43Deg
Notes: Start with Second Color and change to Main color at 6mm/Layer 30	



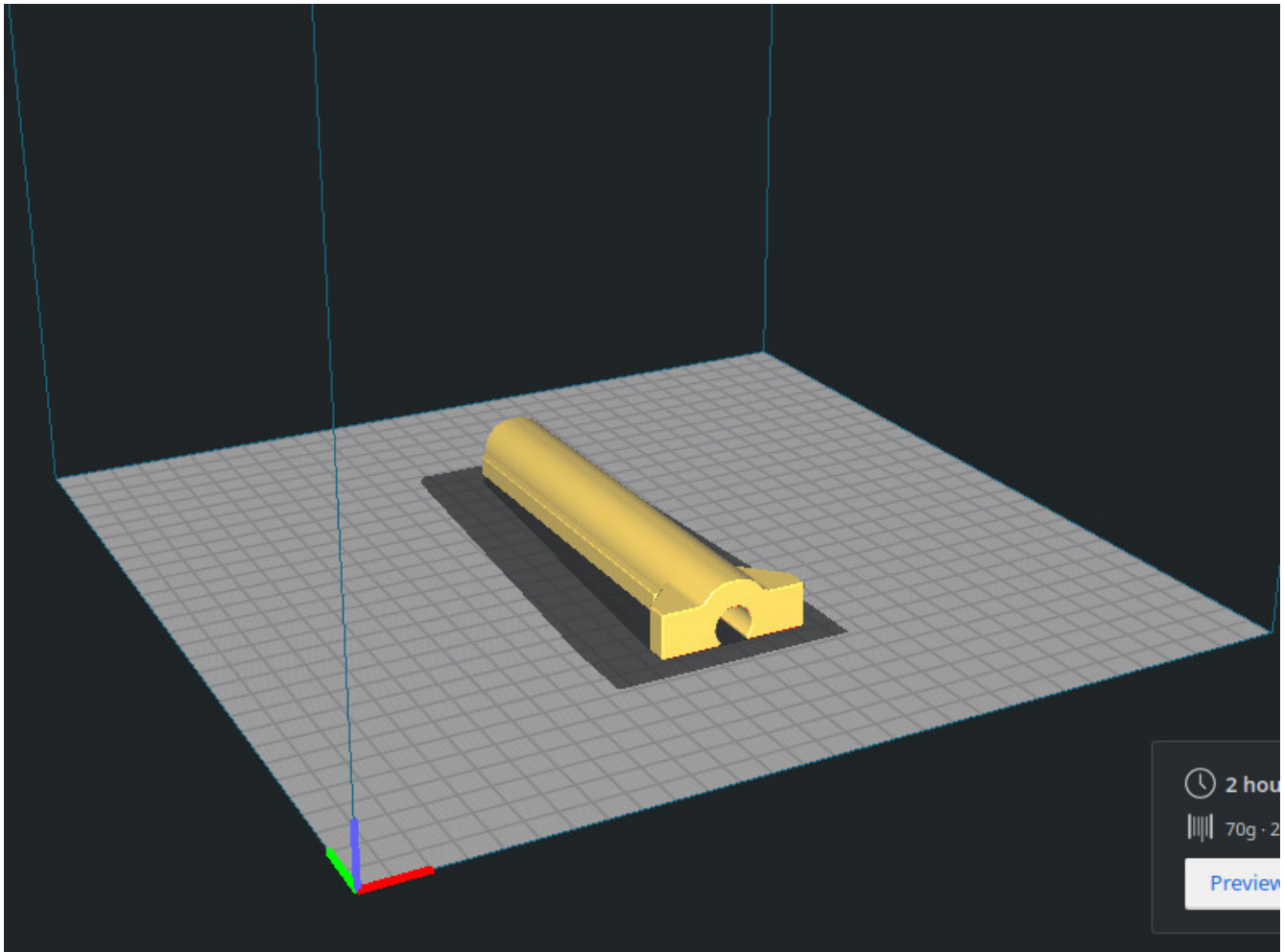
Part Name	Butt Plate
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Everywhere
Support Angle	50Deg
Notes:	



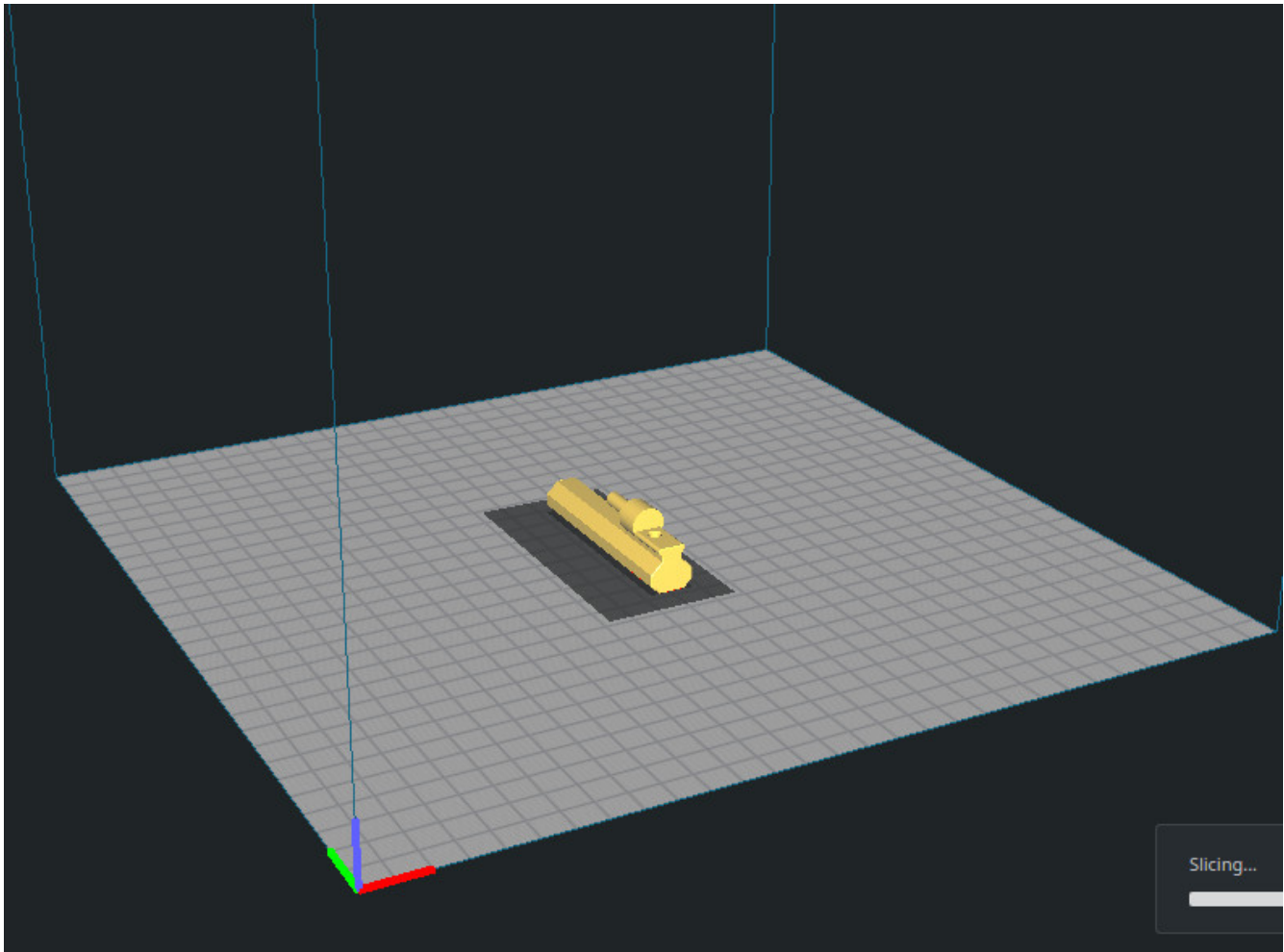
Part Name	Frame Large Machine
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	43Deg
Notes:	



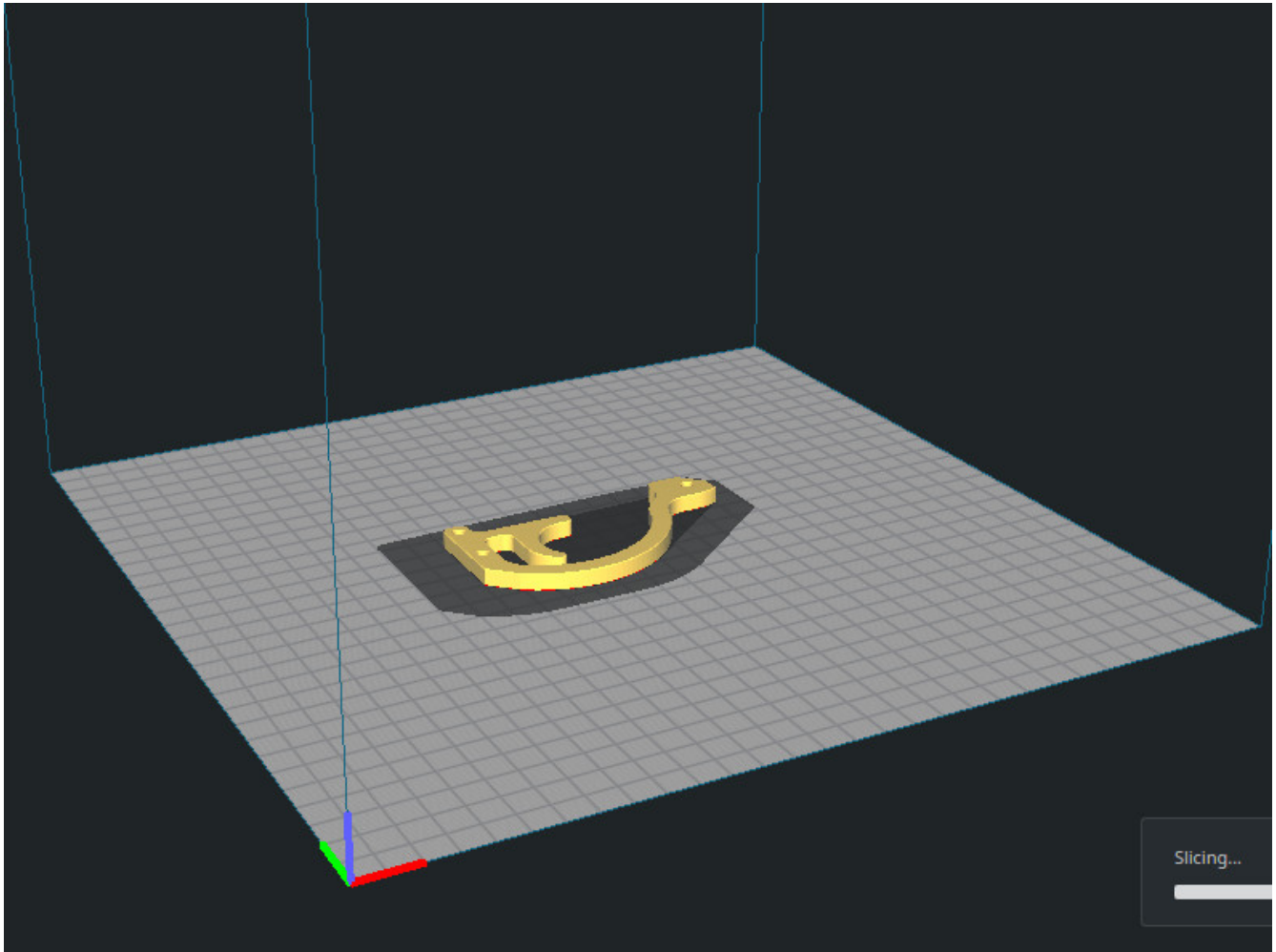
Part Name	Frame Small Machine
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	43Deg
Notes:	



Part Name	Slide
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Everywhere
Support Angle	43Deg
Notes:	

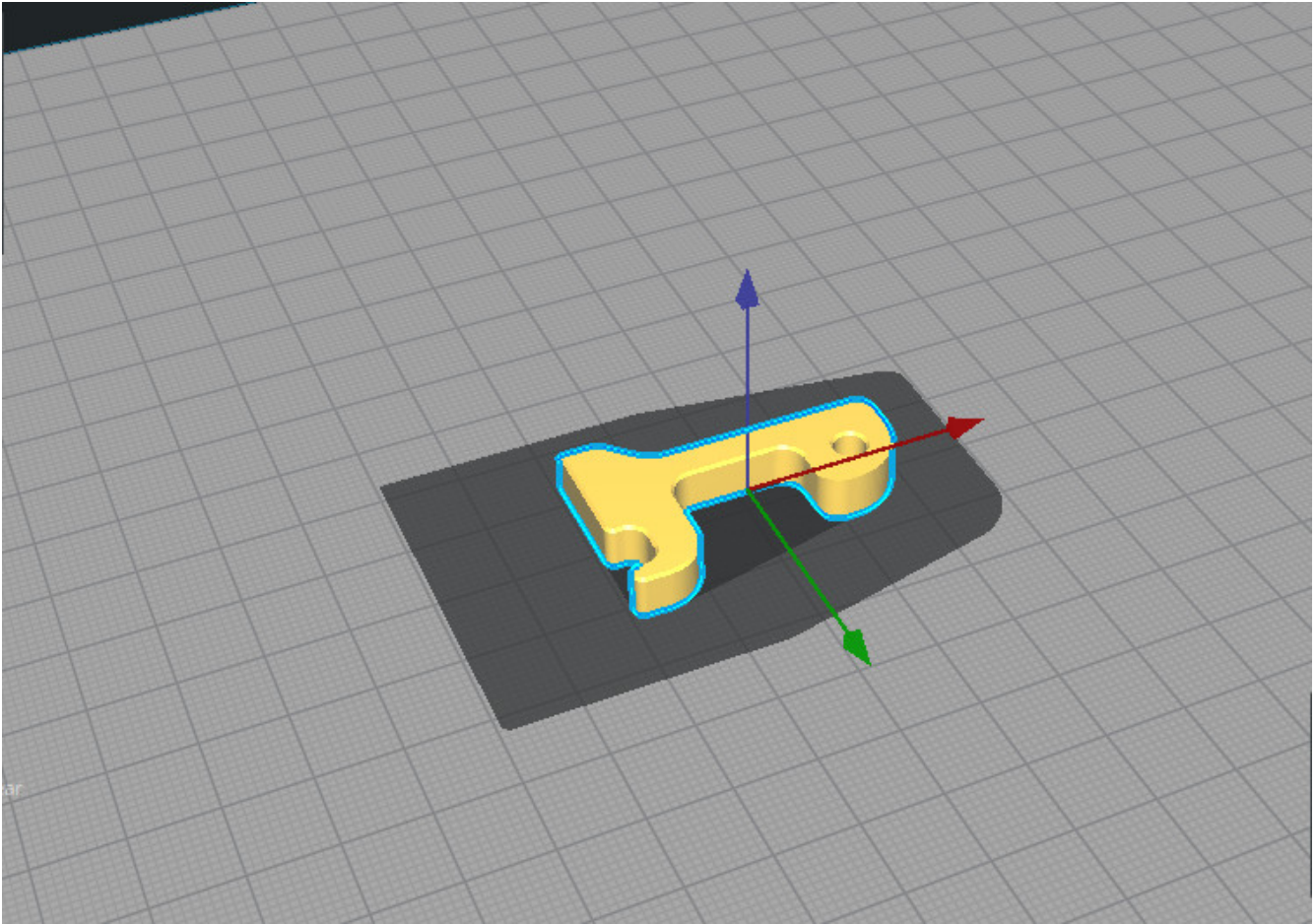


Part Name	Spring Block
Color	Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Everywhere
Support Angle	43Deg
Notes:	

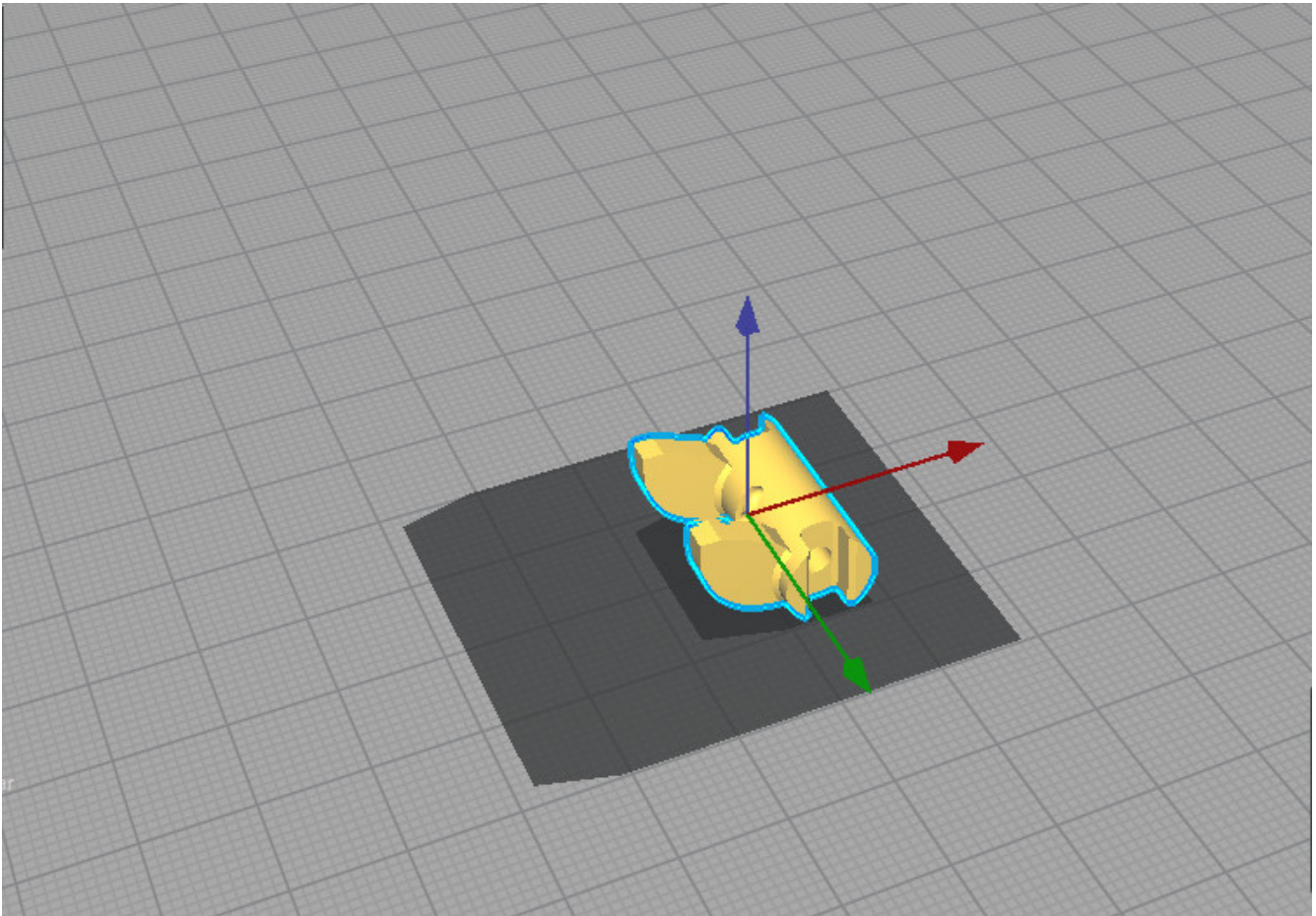


Part Name	Trigger
Color	Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

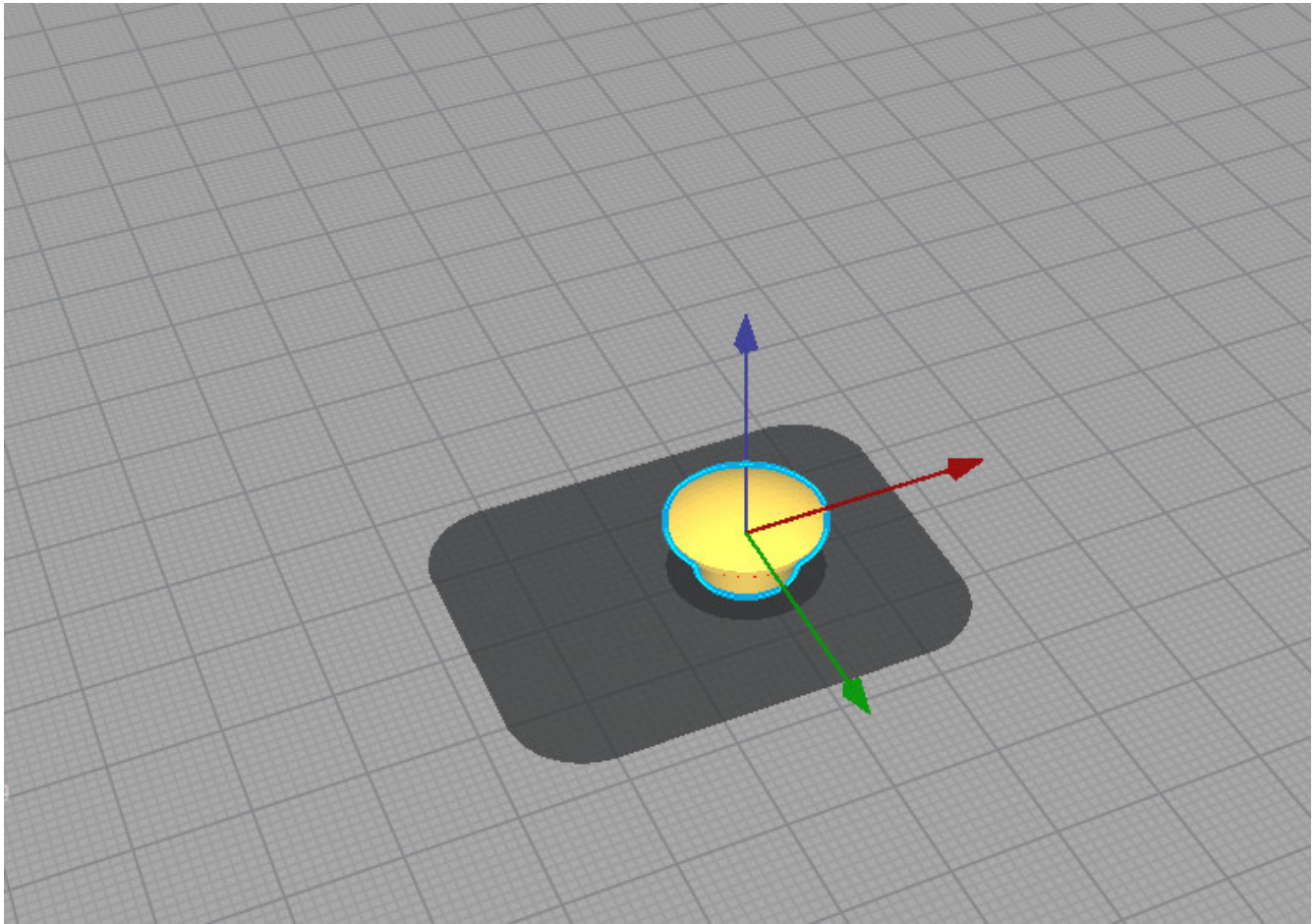




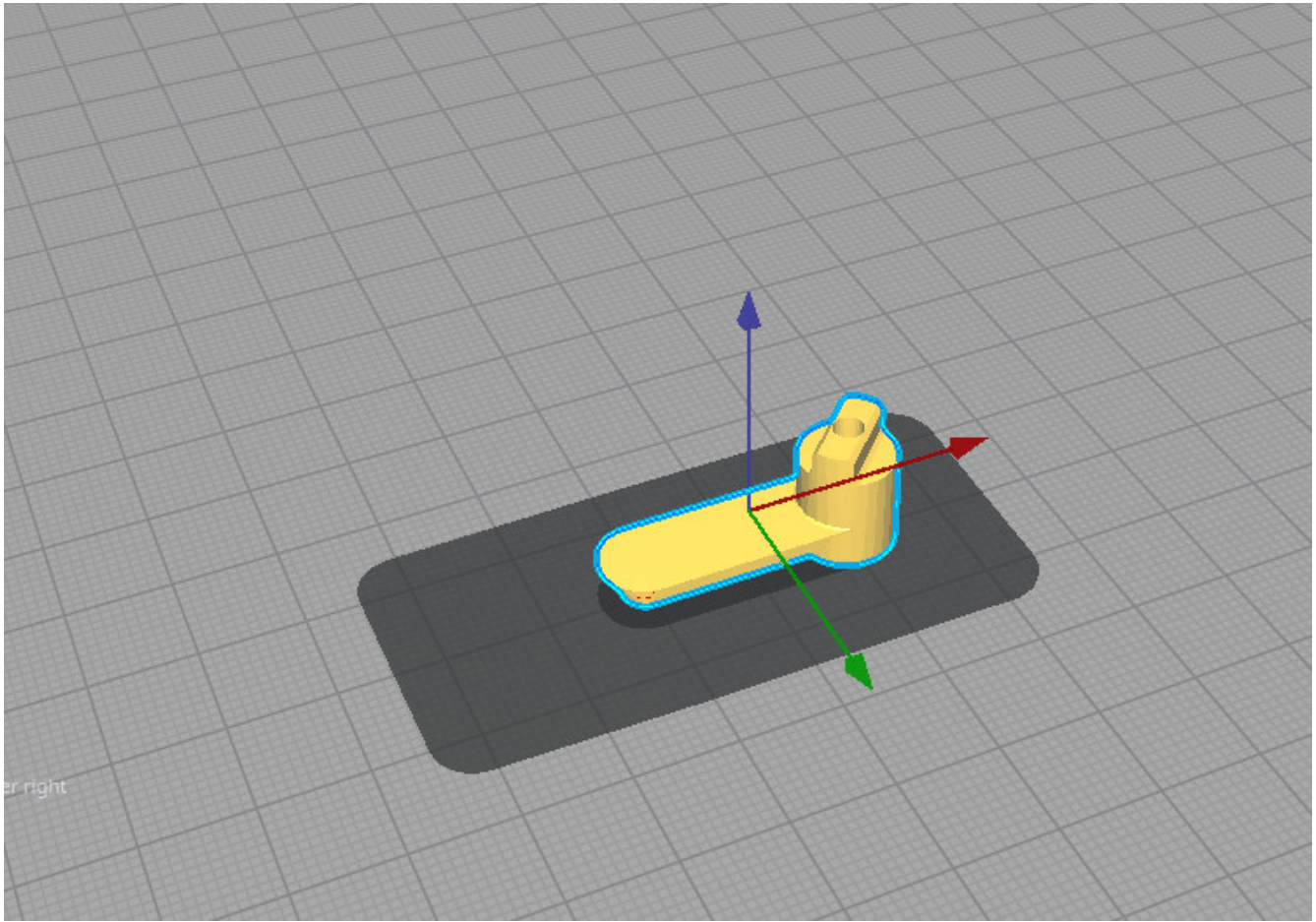
Part Name	Trigger Sear
Color	Second or Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	



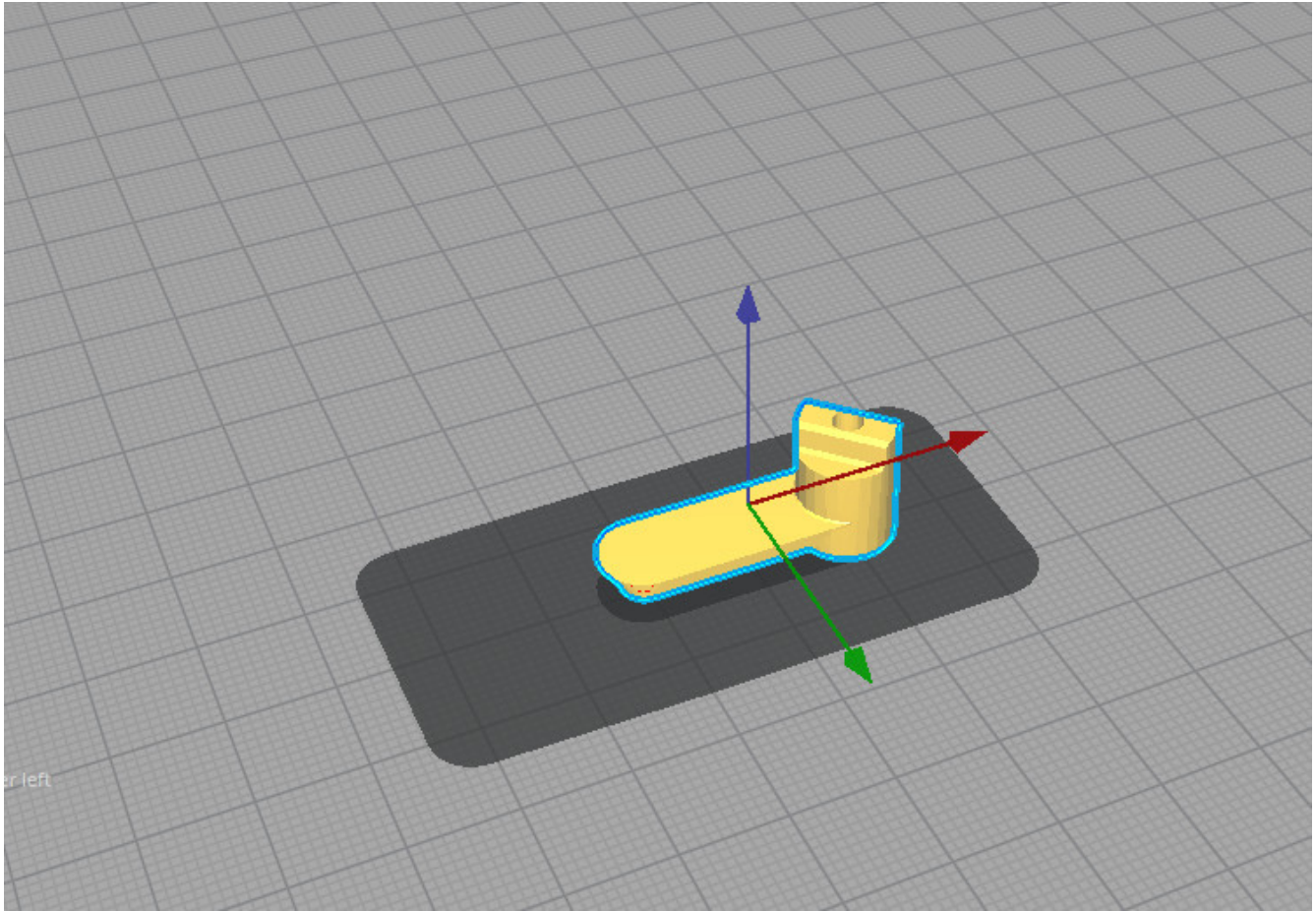
Part Name	Safety Sear
Color	Third
Layer Height	0.1mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	Raft
Support From	Touching Bed
Support Angle	43Deg
Notes: This part must be printed very precisely or it will not function correctly	



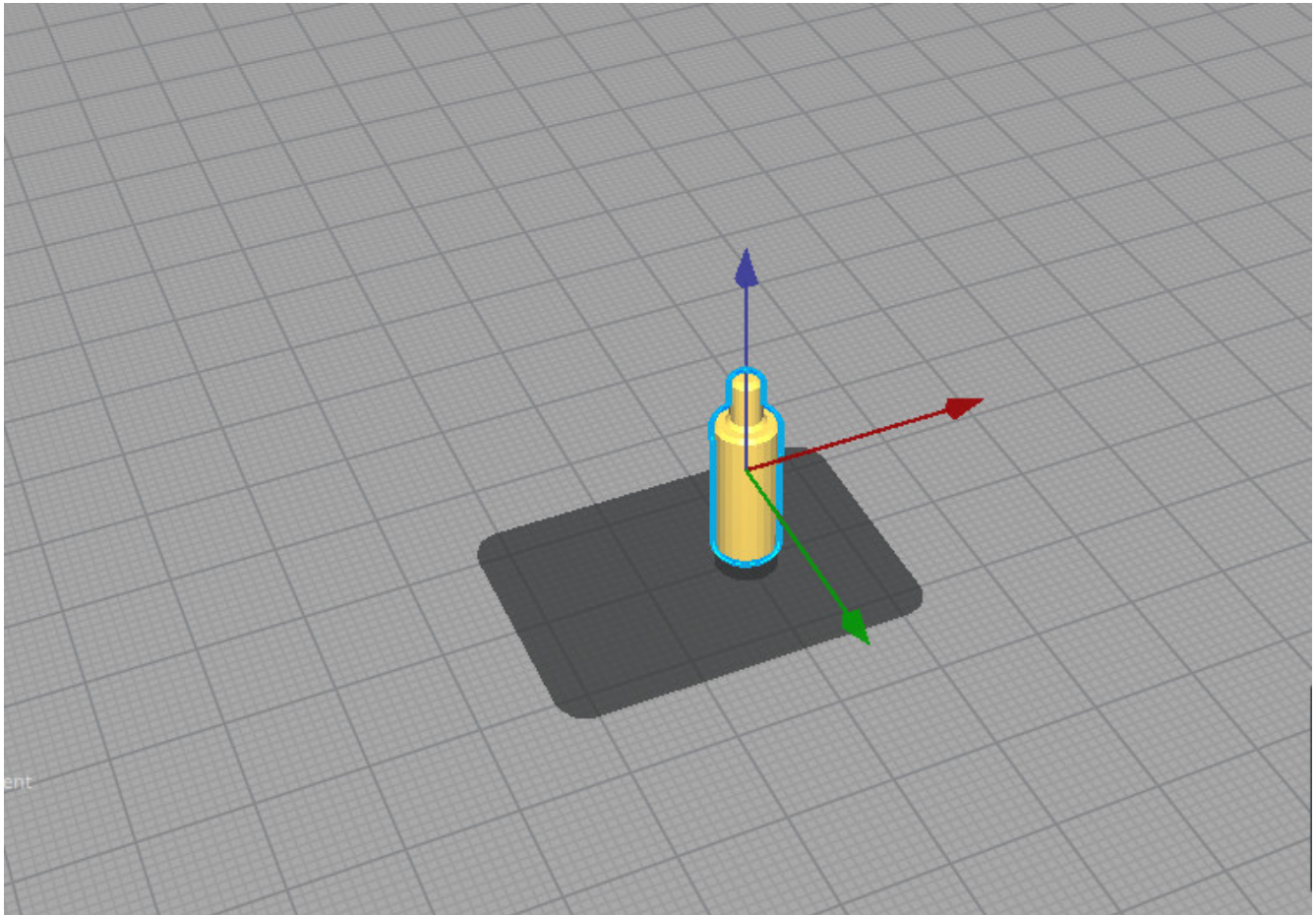
Part Name	Safety Plug
Color	Second or Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	50Deg
Notes:	



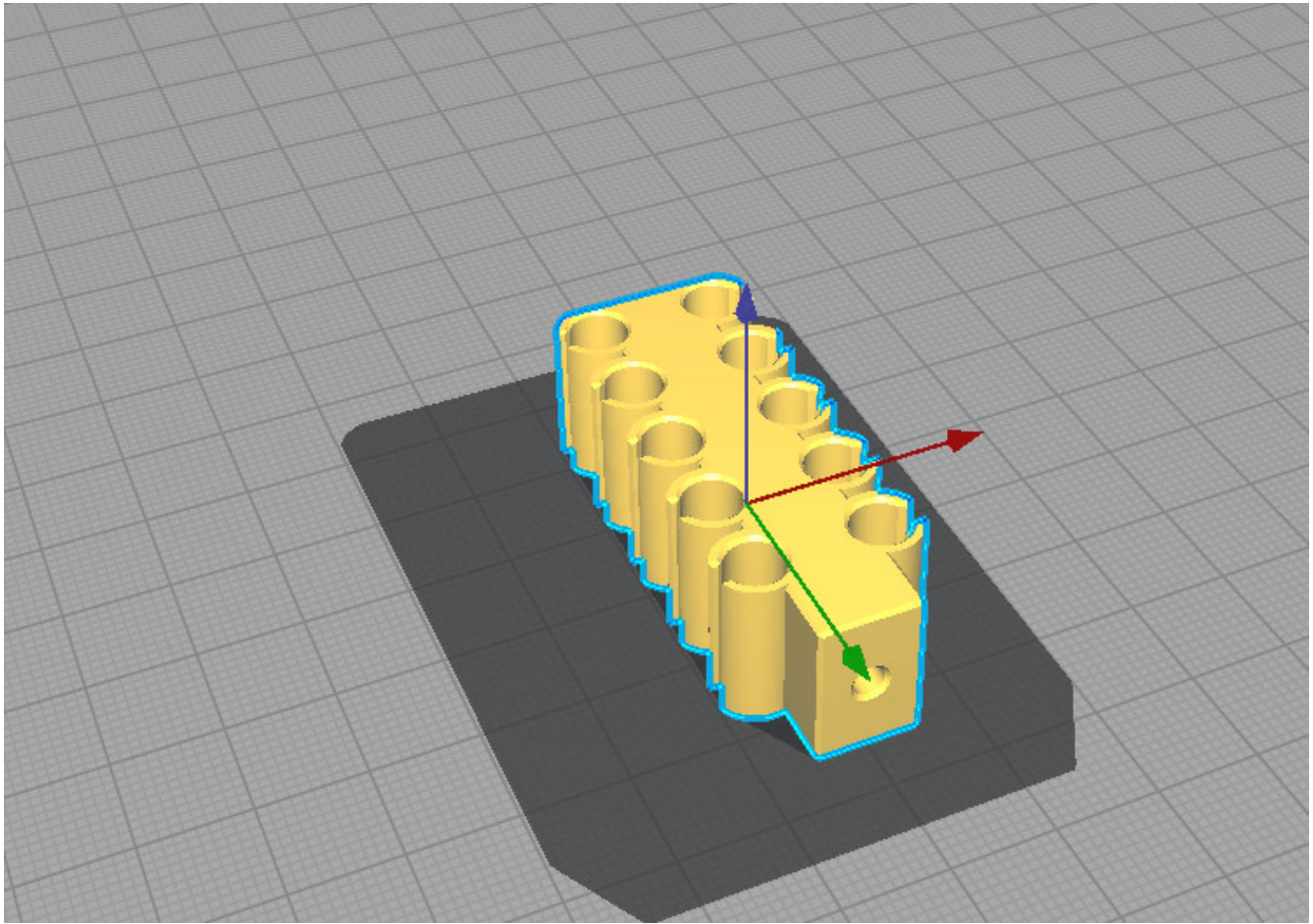
Part Name	Safety Lever Right
Color	Second or Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	43Deg
Notes:	



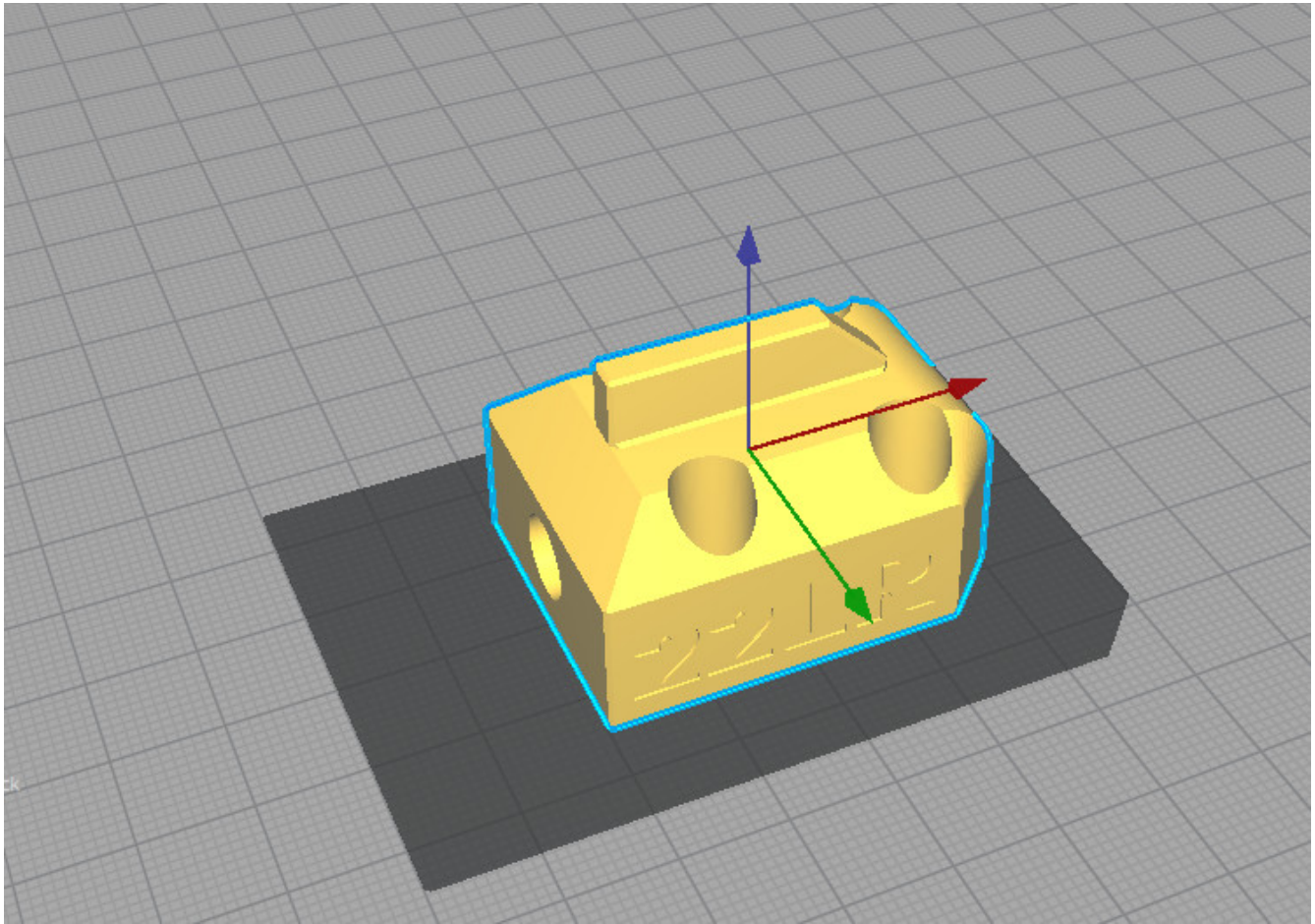
Part Name	Safety Lever Left
Color	Second or Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	50Deg
Notes:	



Part Name	Safety Detent
Color	Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	Brim
Support From	Touching Bed
Support Angle	50Deg
Notes:	

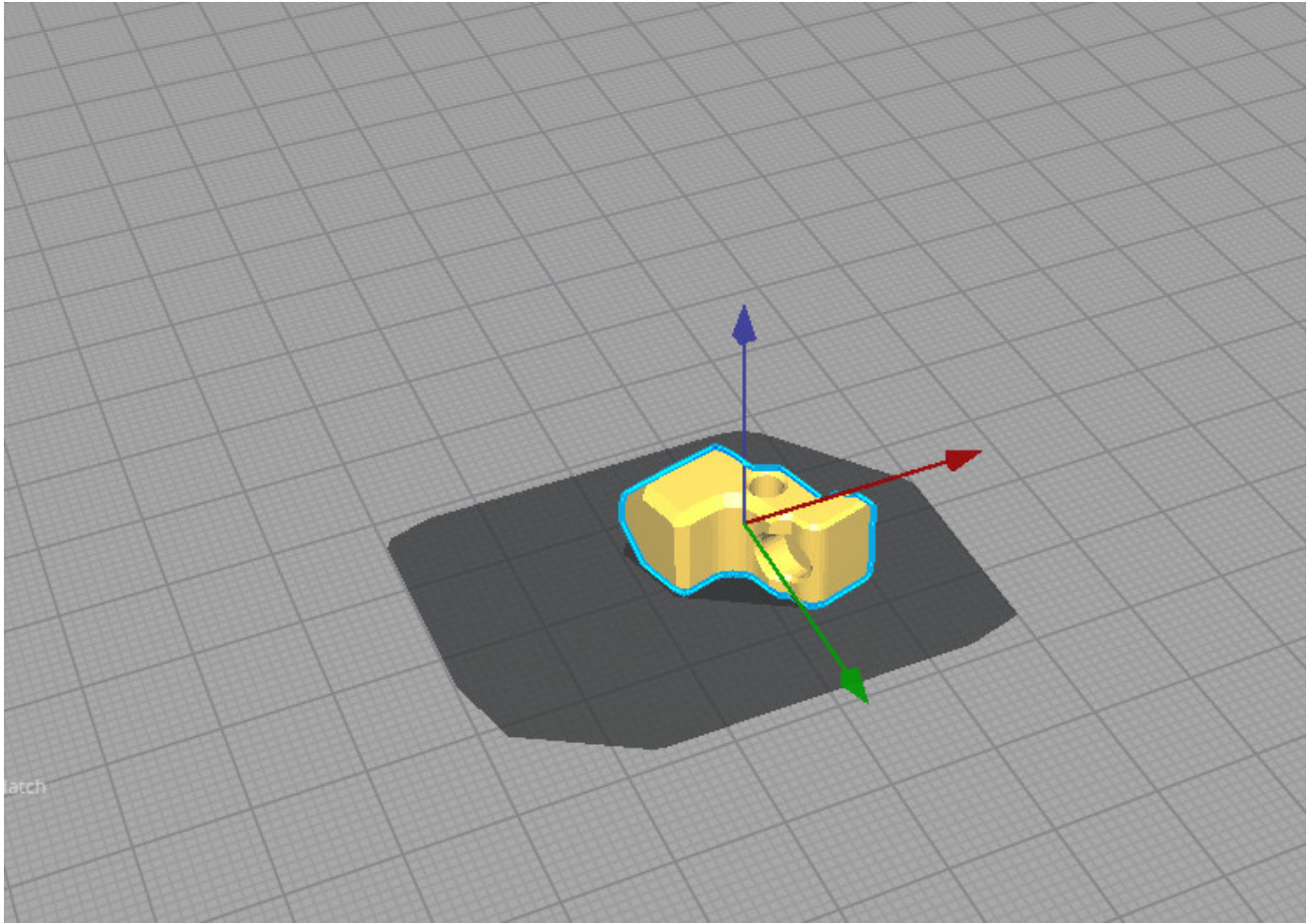


Part Name	Mag
Color	Second or Third
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	

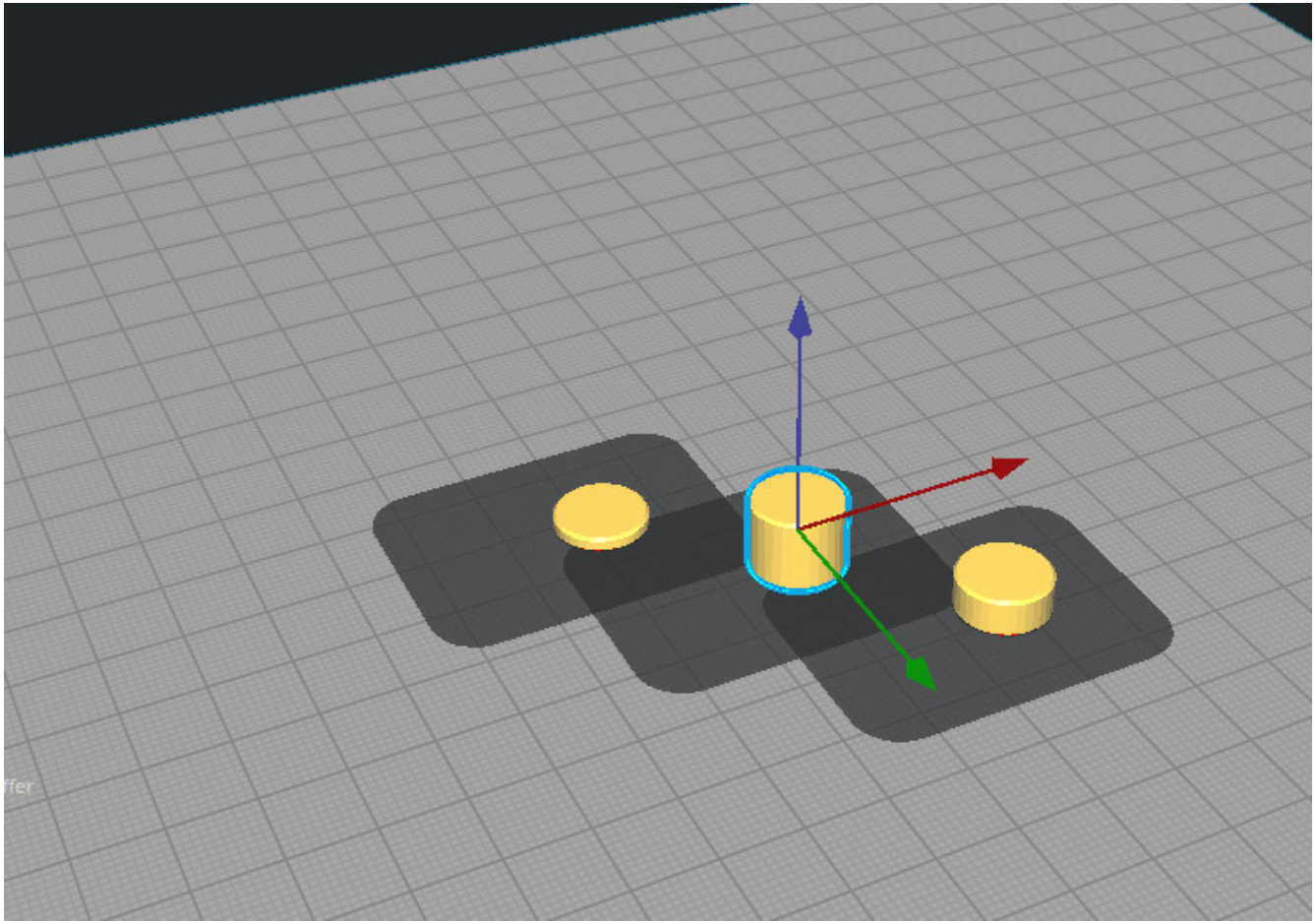


Part Name	Barrel Block
Color	Main
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	None
Support Angle	N/A
Notes:	





Part Name	Butt Plate Latch
Color	Third or Second
Layer Height	0.2mm
Infill Type	Any Type, As Support, 50Deg Overhang
Infill Density	15%
Bed Adhesion	None
Support From	Touching Bed
Support Angle	43Deg
Notes:	



Part Name	Buffers
Color	Third or 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: 2mm, 10mm, 5mm. Print as you need to make the main spring you use work.	

Notes: