Unofficial Print Guide for WTF/MOD9

These settings were not based on engineer/designer recs. Other people may have different opinions/suggestions on printing, but these are what I used and what worked for me and others. Print settings are all based on CURA stock Ender 3 profile settings. Keep all stock profile settings and change only what is noted in red text.

Print temps are not suggested because location, filament brand, and atmosphere vary. Print out a tempature test tower from thingaverse to see what temps will work best for you.

Support blocker tool will make things much easier. If you do not know how to use support blocker, look it up on youtube. It is very easy to use. Use support blocker for all small holes. Holes are designed small to be reamed out with drill bits because perfect circles are not consistent with 3D printers. Support density should be set at 10 with all parts requiring supports. Be sure to keep a clean build plate, use iso alcohol to clean bed and let the heat evaporate it fully before printing. For help with printing, I reccomend youtube videos by "Tomb Of 3D Printed Horrors". He should have a video for anything you need help with, for both slicing and printing. Be sure to know all your local, state, and federal laws and regulations. Don't call a magazine a "clip" and ALWAYS practice gun saftey at all times. The development and hosting of 3D printed firearm/files is legal and protected under free speech at the time of this writing. The WTF9 is identified as a pistol under ATF specifications and NFA.

Special thanks to Derwood and Mussy for making the WTF9 design available to the public.

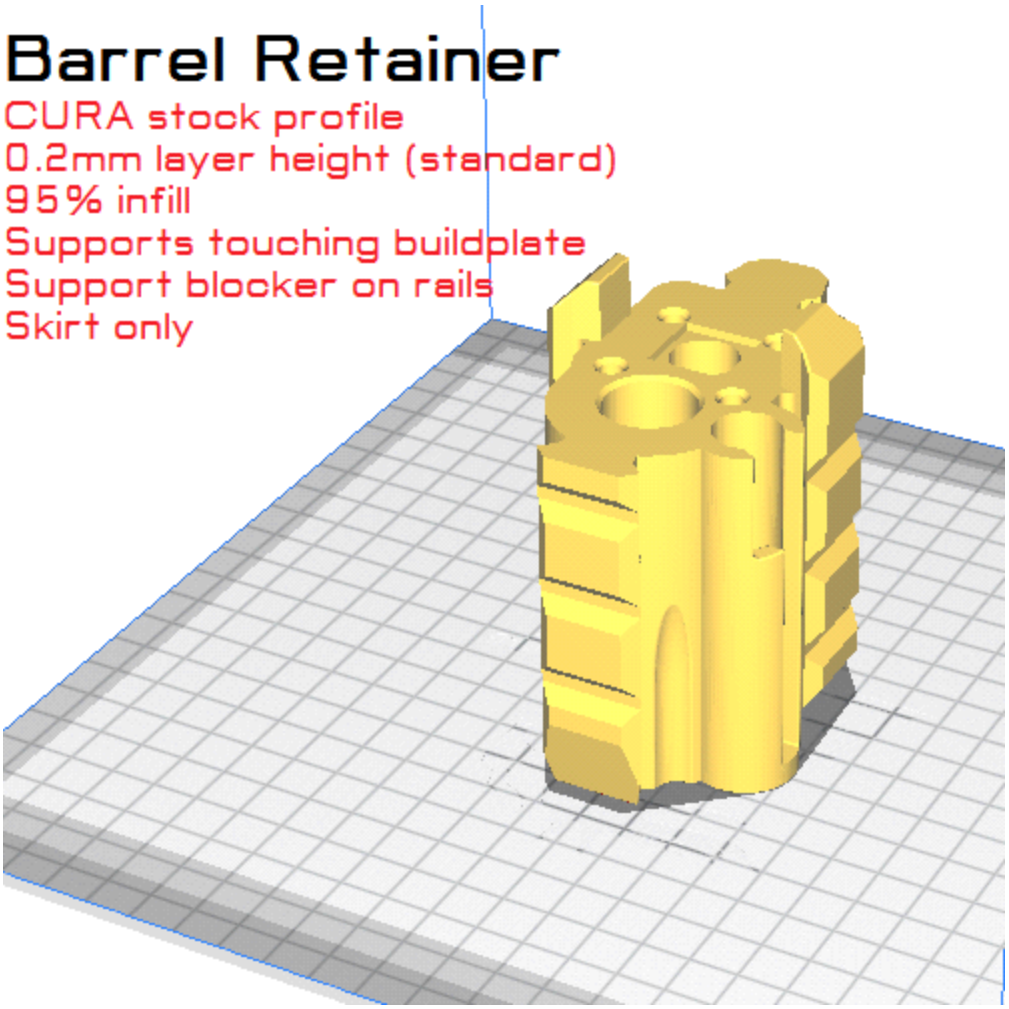
This print guide should be universal to WTF9MV, WTF9H, MOD9, and other variants of the WTF9.

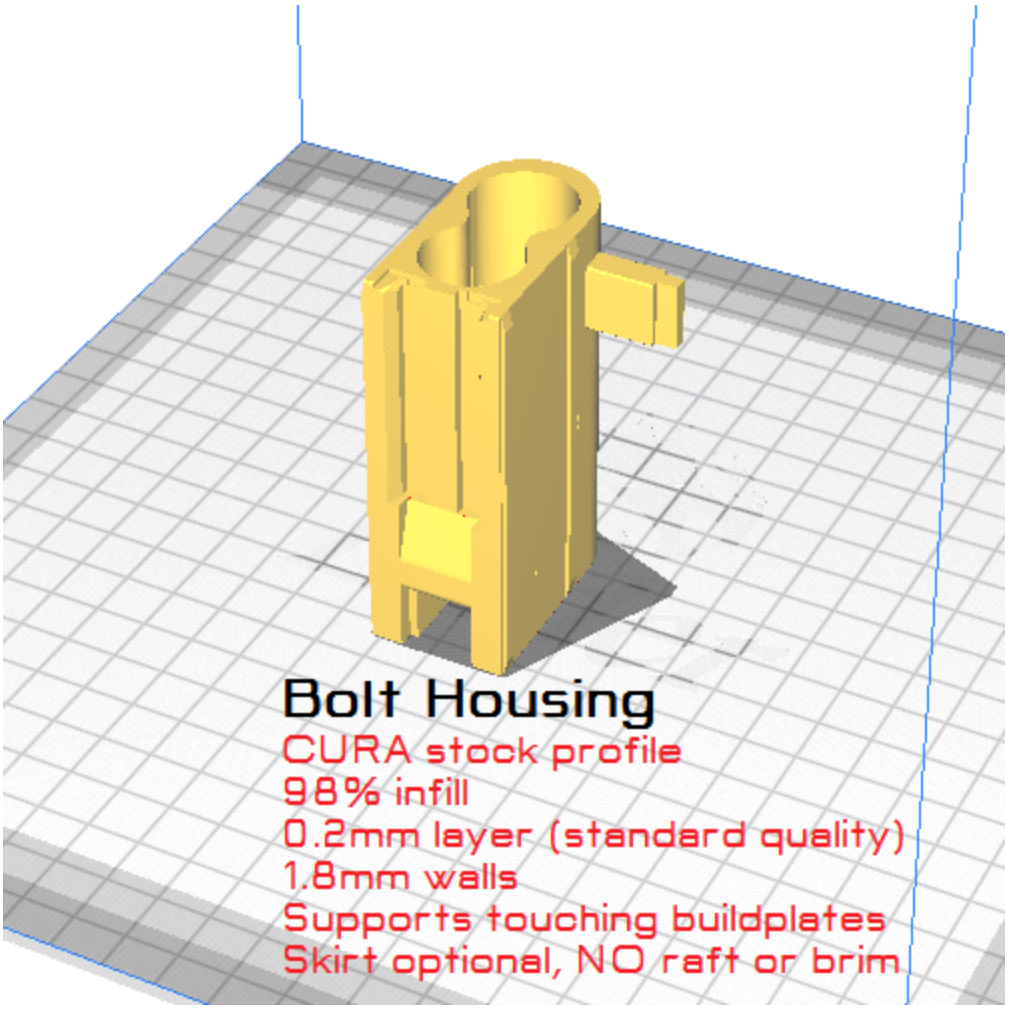
Feel free to view public folder on keybase for custom/remixed/modified parts for MOD9

-chuckschumer (keybase)

Barrel Retainer

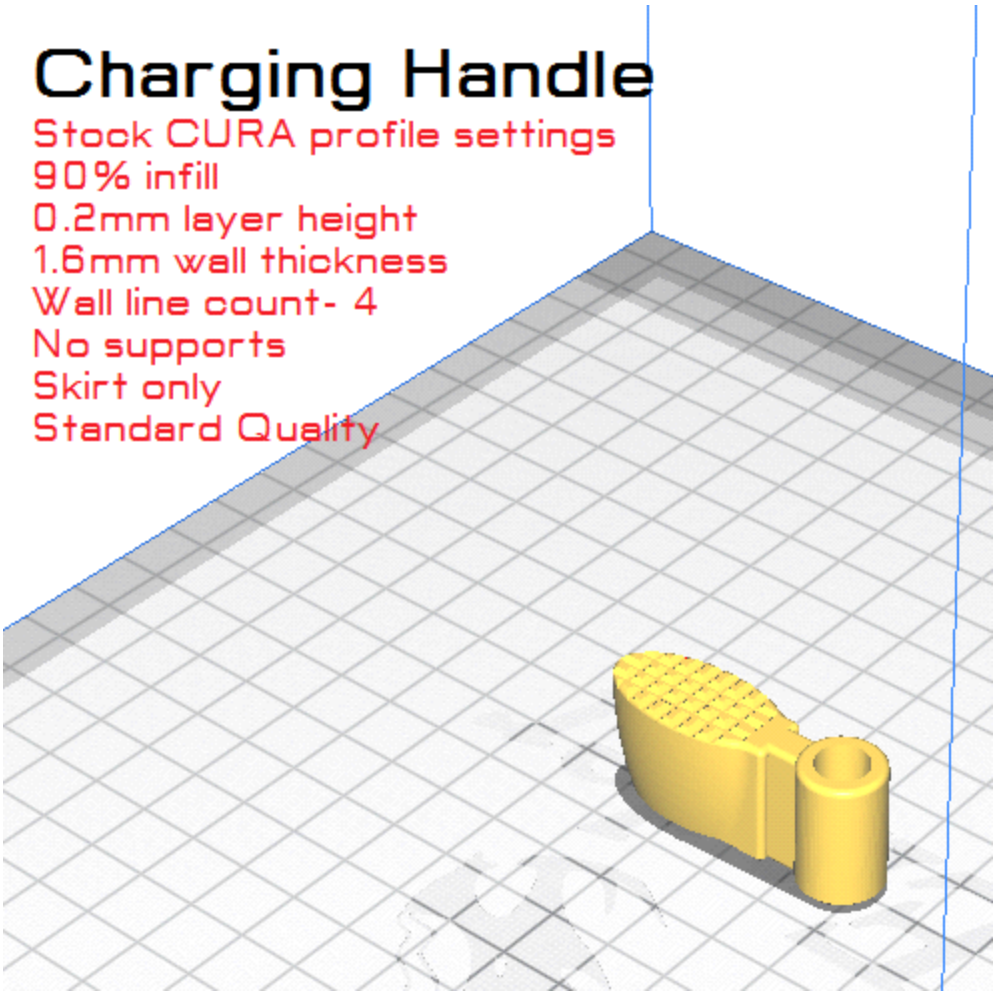
CURA stock profile
0.2mm layer height (standard)
95% infill
Supports touching buildplate
Support blocker on rails
Skirt only




Bolt Housing
CURA stock profile
98% infill
0.2mm layer (standard quality)
1.8mm walls
Supports touching buildplates
Skirt optional, NO raft or brim

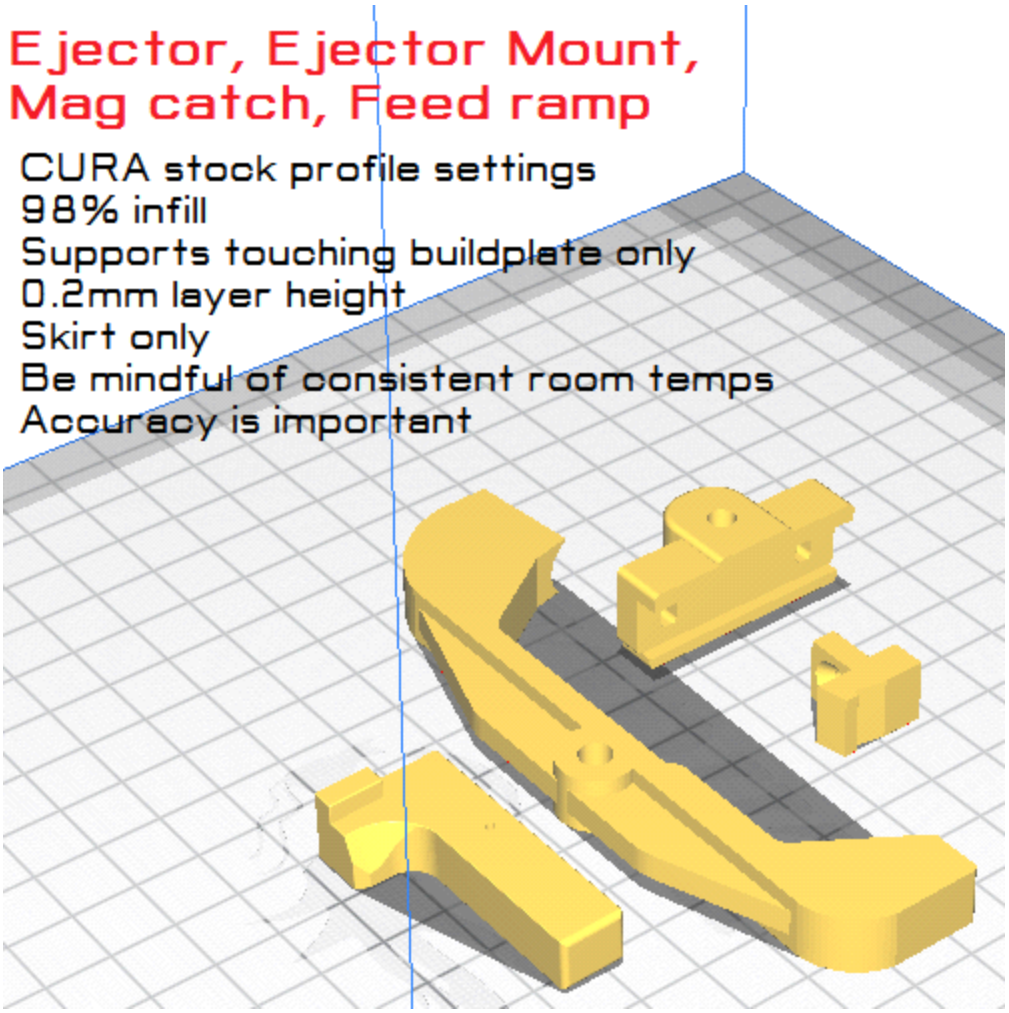
Charging Handle

Stock CURA profile settings
90% infill
0.2mm layer height
1.6mm wall thickness
Wall line count- 4
No supports
Skirt only
Standard Quality



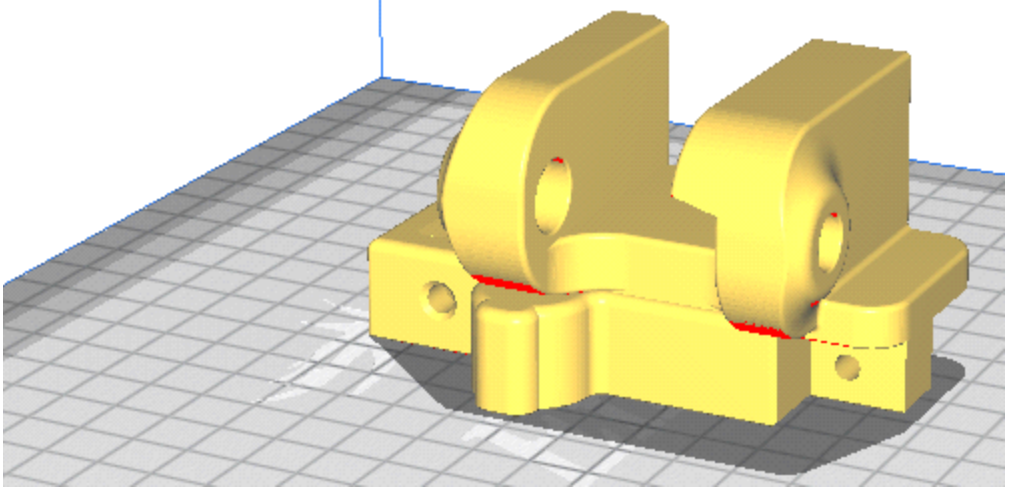
Ejector, Ejector Mount, Mag catch, Feed ramp

CURA stock profile settings
98% infill
Supports touching buildplate only
0.2mm layer height
Skirt only
Be mindful of consistent room temps
Accuracy is important



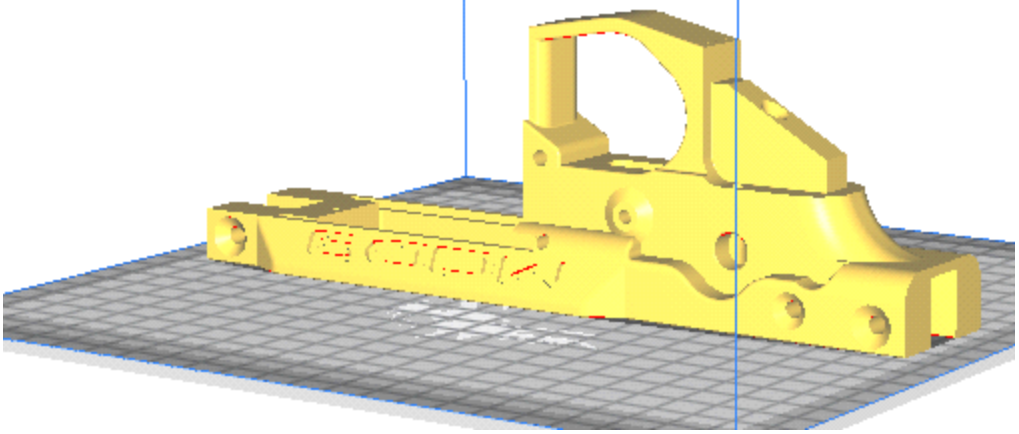
End Cap

Stock CURA profile settings
0.2mm layer height
Standard quality
90% infill
2 walls
Supports touching buildplate only
Skirt only



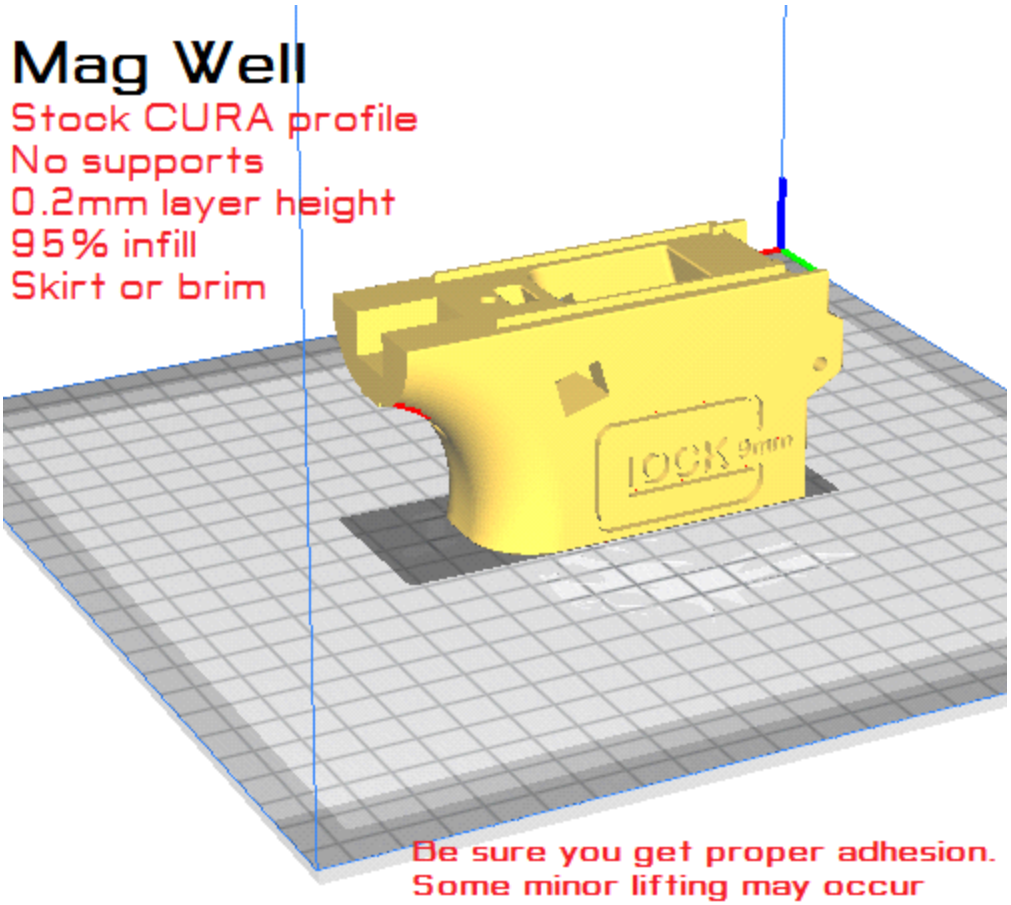
Lower Reciever

Stock CURA profile settings
0.2mm layer height
Standard quality
1.6mm walls (4 walls)
95% infill
Supports everywhere
Support blockers in small holes
No skirt, brim, or raft
Proper adhesion important



Mag Well

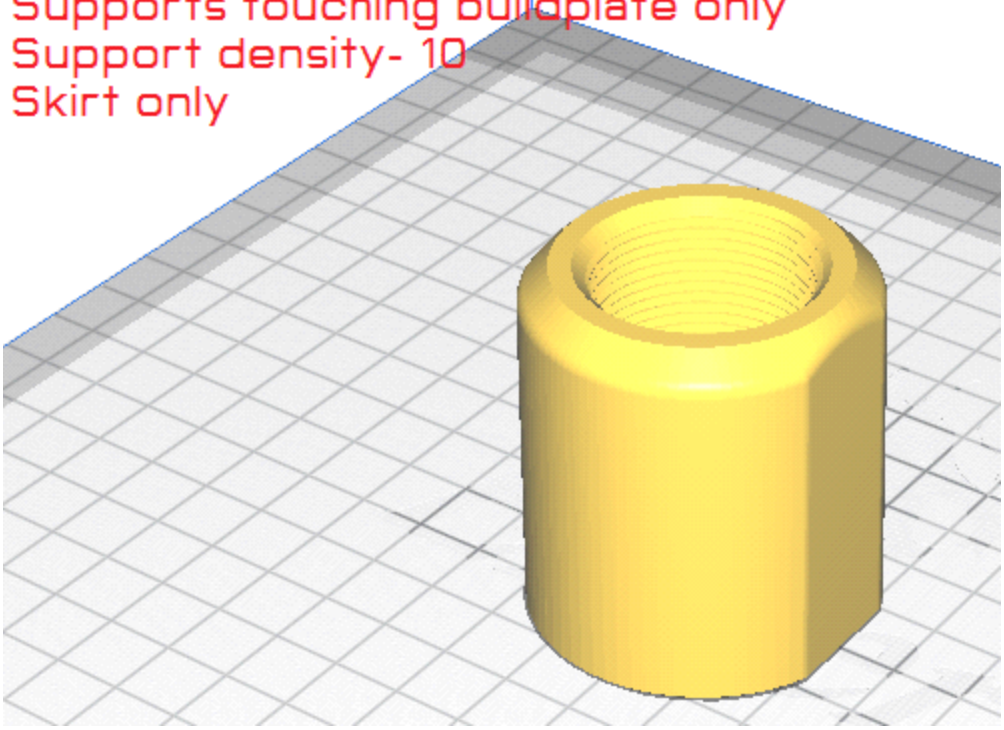
Stock CURA profile
No supports
0.2mm layer height
95% infill
Skirt or brim



Be sure you get proper adhesion. Some minor lifting may occur with bottom layers the on back, use a brim if you're worried about adhesion issues. No raft.

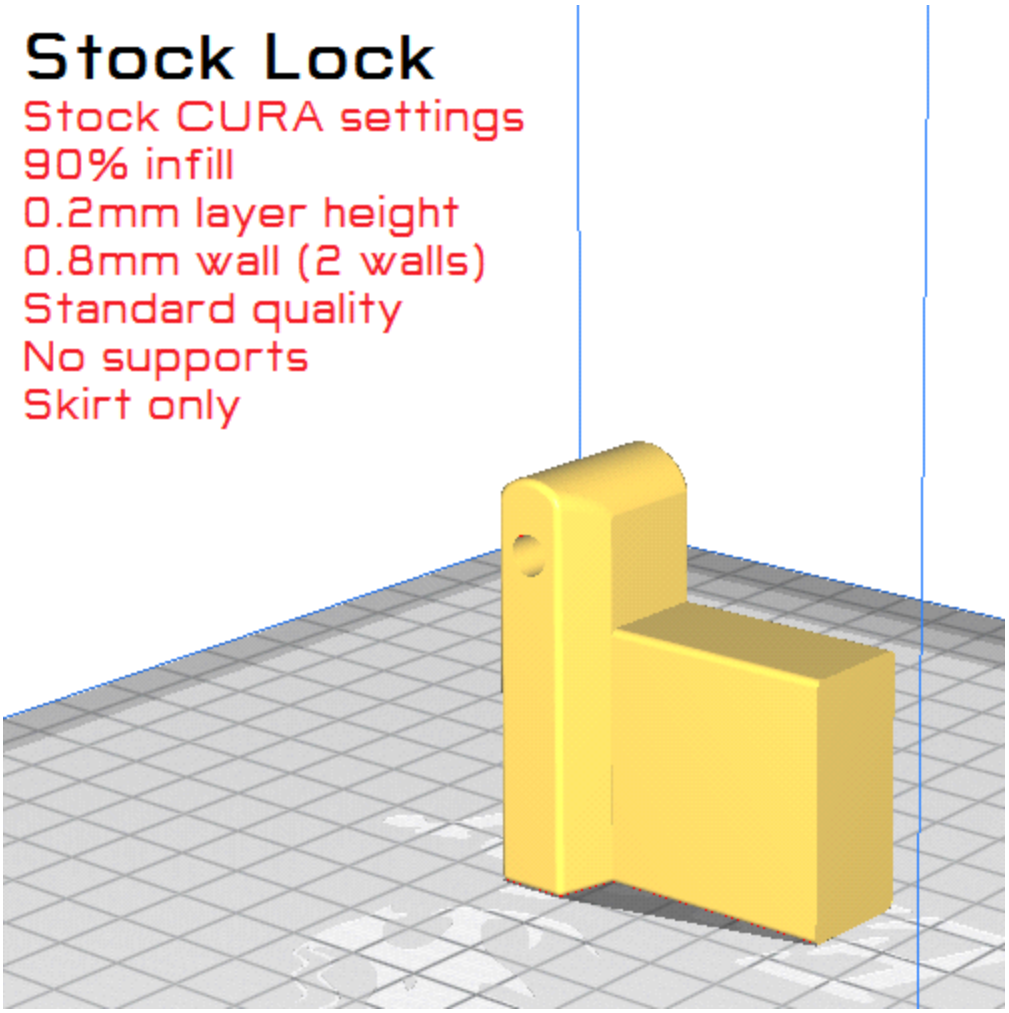
Stock Adapter (threaded)

Stock CURA profile settings
90% infill
0.2mm layer height
Standard Quality
Supports touching buildplate only
Support density- 10
Skirt only



Stock Lock

Stock CURA settings
90% infill
0.2mm layer height
0.8mm wall (2 walls)
Standard quality
No supports
Skirt only



Upper

CURA stock settings
95% infill
0.2mm layer (standard quality)
Supports everywhere
Support blocker in all holes
Skirt only