

MIDDLETON MADE 3D

# Schnitzel G19 v1.5 Frame - README

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Looking for a build kit? The Middleton Made SHOP is launching October 1st, 2022 and taking pre-orders.

## Links:

- Website / Shop  
<https://www.middletonmade.com/>
- Defcad:  
<https://defcad.com/users/MiddletonMade3D/>
- Odyssey:  
<https://odysee.com/@MiddletonMade:1>
- Paypal:  
<https://www.paypal.com/paypalme/middletonmade3d>
- IG:  
<https://www.instagram.com/middletonmade/>
- Buy Me a Coffee:  
<https://www.buymeacoffee.com/MiddletonMade>
- FB:  
<https://www.facebook.com/MiddletonMade>
- YT:  
<https://www.youtube.com/c/middletonmade3>

## Legal

I'm not a lawyer and you are responsible for your own safety and compliance with the law. Federally, it's still legal to make your own weapons. Check with your state and county for further restrictions and infringement.

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## Credit

This design was created at the behest of the #JSDInvitational2022 competition. Thank you to JSD for creating the competition and encouraging so many designers to create new designs. If you are looking for other g19 designs, you'll find many other quality designs by searching this hashtag.

The base file was the FMDA G19.2 and was further sanitized of all its features before adding features back to be stylized (fillet removal essentially, #chamfersquad)

## Printing

For print orientation, please see the separate file named *"SuggestedPrintOrientation"*

### Filament Type - PLA+, CF/GF Nylon

For any parts that receive stress, do **not** use metallic, silk, glow in the dark, fluorescent, or any other special type of filament. Stick with regular, single color materials.

I've also had an excess of worn/broken parts with GST PLA+. While I don't have a wide range of experience with a variety of brands for testing, eSun has been reliably strong and consistent for me.

### Printing Instructions

In general, ALL parts can be printed 10walls, 60% gyroid infill, a 6mm brim, and tree supports. I recommend rails down and tilted forward at an angle, between 14-17 degrees.

When importing to your slicer, you may have an error appear on screen. Adding the dot texture really created some odd shit to happen so just ignore it... Pretend its our national debt or something.

## Assembly

To start, you'll need:

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## Printed Parts:

- Schnitzel Frame
- Patmos Revolution Clamp Comp (optional - ALPHA FILE)
- Glock Charging Handle Body (optional - ALPHA FILE)
- Glock Charging Handle (optional - ALPHA FILE)

## Pre-manufactured Parts: (Affiliate Links)

- [Glock Parts Kit](#) (JSD includes LPK and Slide Assembly)
- [Glock 19 Magazine](#)
- [x1 M4x35mm Screw & Nut](#)

## Tools

- [Razorblade](#)
- [Snipping/cutting tool](#)

## Step-by-Step

1. Print your parts with the instructions given above. When done, use your tools to clean off any defects, brims, or supports.
  - a. It will also be a big help to ensure the top of the frame is sanded smooth prior to installing parts. Even if you have great support settings, smooth out the top of the frame to ensure the slide will have ample clearance.
2. Install your parts. There are videos that will be a MUCH bigger help than trying to read step by step. Seriously, figuring out how to insert a spring that needs to be upside down until you flip it around and INSIDE the hollow body makes a long more sense if you see it.
3. With no magazine inserted, install the slide assembly and rack it a few times to ensure clear movement.
4. When pointed in a safe area, ensure the weapon is clear and check the function of the trigger. This is just a single dry fire and cycling the slide with the trigger depressed to test its reset.
5. If all is good, Google what a desk pop is and have fun.

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## Optional Parts Step-by-Step

- The clamp NEEDS to be printed in a strong material that can also flex enough to slip over the slide without snapping in half. GST PLA+ **will break**. It is far too brittle. Duramic and eSun seem to have fit just fine.
  - These have **NOT been tested** yet. Use at your own risk. Generally early release is reserved only for my [Buy Me a Coffee](#) members, but thank JSD Supply for the #JSDinvitational2022
1. Remove the Comp and clean it up / remove supports. Make sure the inside of the device is *CLEAN* and doesn't have anything that can interfere with its fitment with the slide.
  2. Line the front of the slide up with the inside wall of the Comp and **carefully** open the clamp and push it into the windows of the slide. This is the hardest and most risky part of the install.
  3. Once installed, this is an Alpha product. **Fire your first rounds safely and with the expectation that the file may fail and send shrapnel outward.**
  4. The charging handle slides on like a regular Glock backplate and inserts with the single m4x35mm screw. This should be a self explanatory install.