

3D Printing guide for the KAPtery Picavet Cross

Parts List and User Guide at KAPtery.com/guides

For spare parts: KAPtery.com

Technical support: <http://kaptery.com/contact/>

Files at Thingiverse

Below are some typical settings for printing on a Makerbot Replicator 1 with PLA filament, single 0.4 mm MK8 nozzle, 205° to 215°C, build plate at 45°C. These are hot temperatures for PLA, but with many brands, cooler temperatures will not produce parts strong enough to trust with your camera in the air.

Layer height = 0.2 mm, base print speed = 120 mm/second, travel speed = 200 mm/second (acceleration is ON).

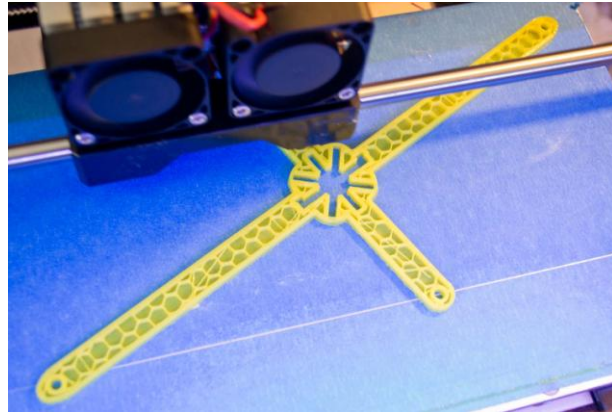
Slicing: I have sliced these parts with MakerWare and Simplify 3D. See below.

For other printers, slicers, and materials different settings may be appropriate.

Picavet cross:

- *Position:* The cross must be upside down. It must be rotated to fit diagonally on the Replicator build plate.
- *Size:* The long dimension of the part should be 222 mm.
- *Support:* ON or OFF depending on version. See below.
- *Shells:* 2
- *Time:* 2.3 hours

Two versions of this model are at Thingiverse. One must be printed with support under the “star.” The other has support structures incorporated into the model and prints well when sliced with MakerWare. When sliced with Simplify 3D, those support structures are ignored so support must be added manually (automatic support is too hard to remove).



A yellow Picavet cross being printed. The honeycomb internal structure is characteristic of the MakerWare slicer. The current model of the Picavet has a 16 pointed star at the center.