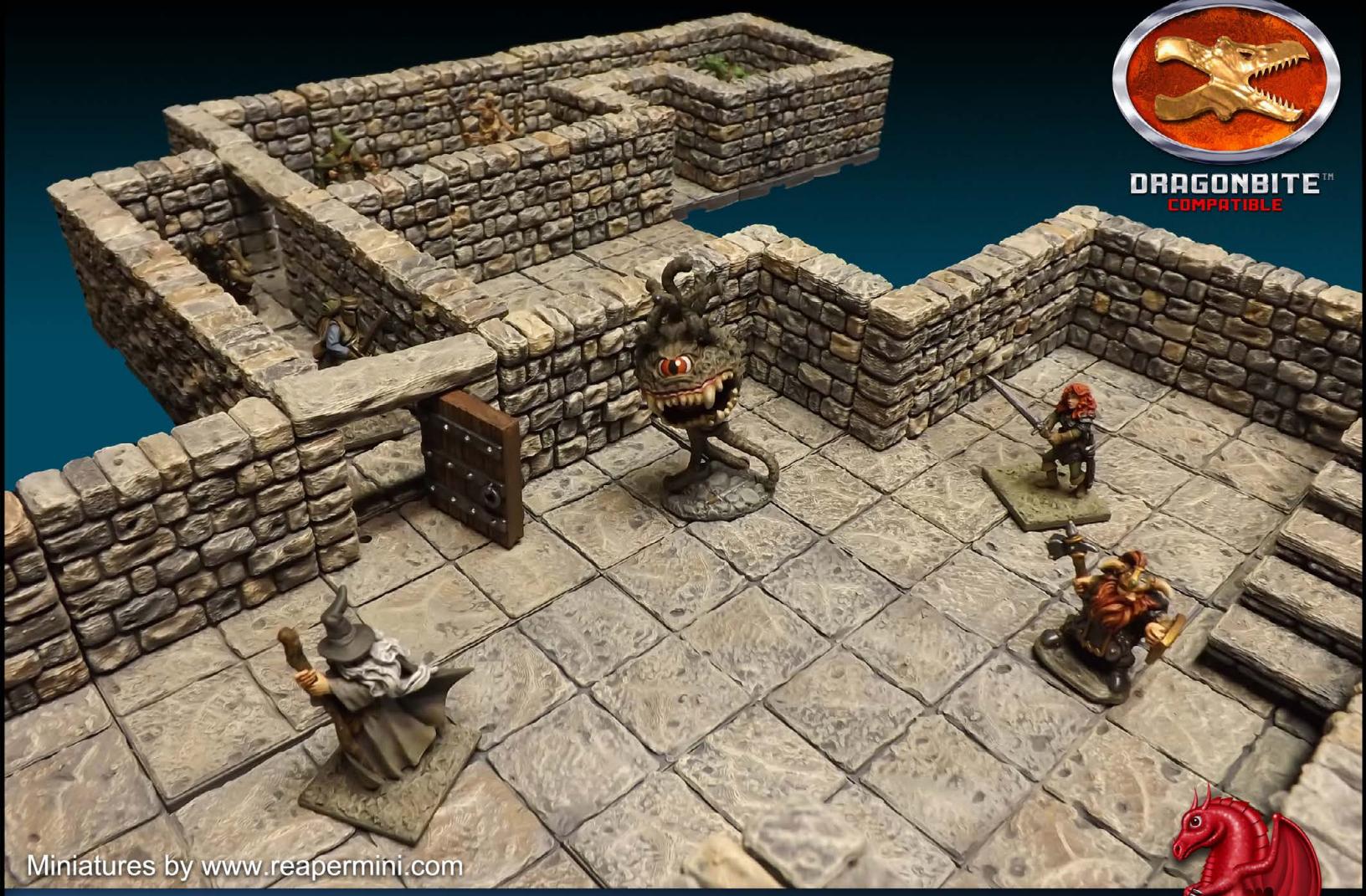
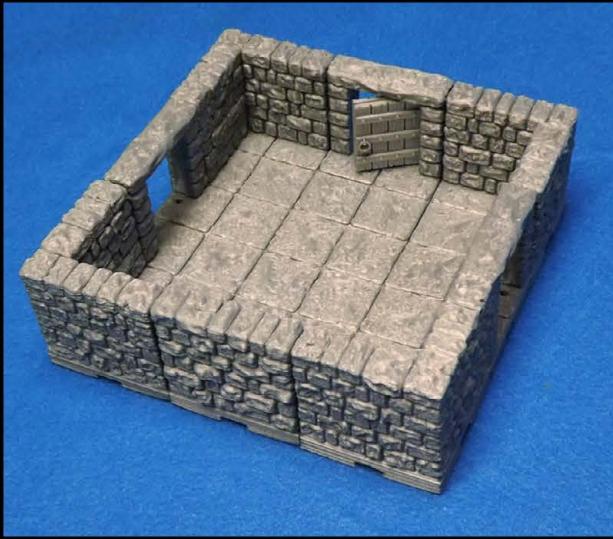
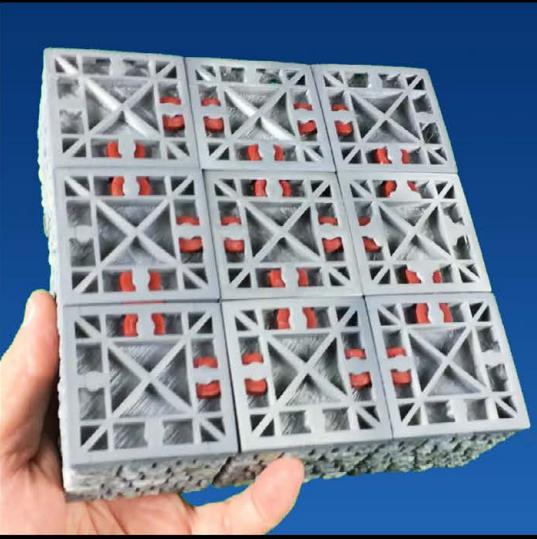


DRAGONLOCK

ULTIMATE



DRAGONBITE™
COMPATIBLE

Miniatures by www.reapermini.com



MOUNTAIN ADVENTURES

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DRAGONLOCK

Getting Started

Welcome to the DRAGONLOCK: Ultimate™ terrain system. This instruction manual will outline some basic materials you will need for 3D printing these models, specific printing information for the models in this set, and links to additional resources.

For more information on getting started with 3D printing, help with choosing a printer, settings for many popular printers, troubleshooting, and more; please visit our 3D Printer forums:
<http://fatdragongames.proboards.com/board/21/3d-printing-dragonlock-terrain>

For painting tutorials on these and other models in the DRAGONLOCK: Ultimate™ product line, please visit our Youtube channel:
<https://www.youtube.com/channel/UC5Lbnd97HV3rU98gcwHklzQ>

Basic Tools and Materials



For gluing models with multiple pieces together, we have found that Gorilla Glue works great (especially the 'gel' type.)

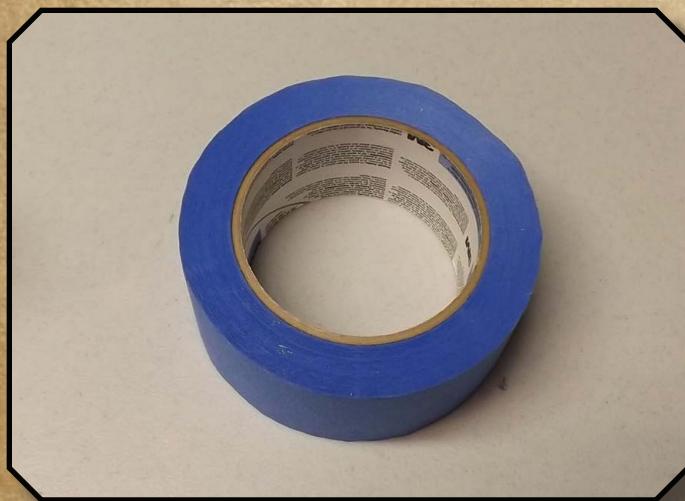


While not necessary, it helps to have a pair of small tweezers on hand. You'll find yourself using them often to pull odd strands of plastic off the model, getting small bits of plastic out of the printer, etc.

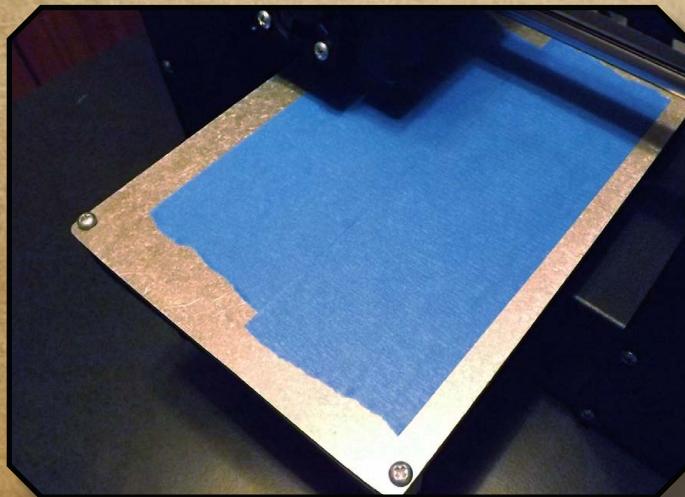
DRAGONLOCK



Absolutely essential is a small metal spatula to help remove models from your build plate. We've found that ones like this from art supply aisles at craft stores work great and should only cost you a few dollars.



When printing PLA on a non-heated build plate, applying blue painter tape to your build-plate works great to help the plastic adhere.



To make your print stick as well as possible, you can wipe off newly applied tape with a paper towel that has a little rubbing alcohol on it (the tape has a wax coating on the back that sometimes inhibits the plastic from properly sticking to it).

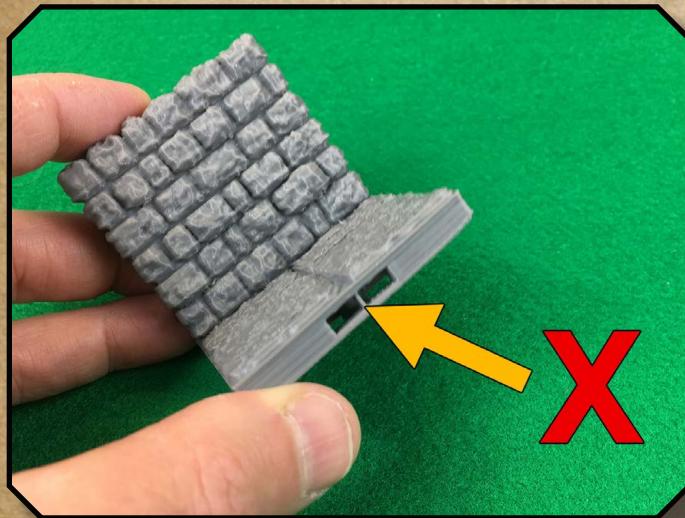


General printing tips for DRAGONLOCK: Ultimate™ models

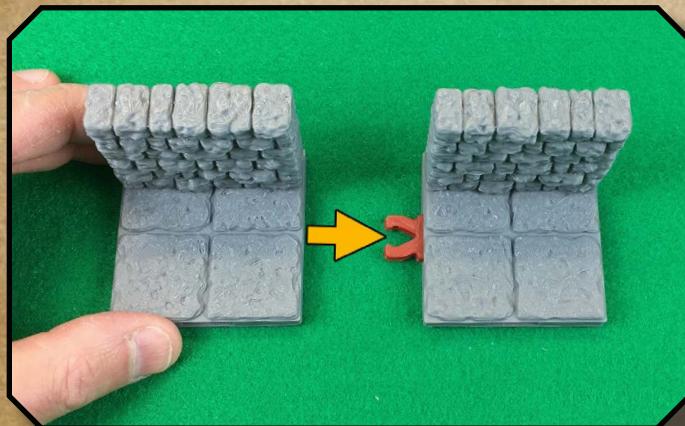
With the wide variety of printers and filaments on the market, it isn't possible for us to list printer settings that will work with multiple machines. Please visit the Fat Dragon Games forums for printer-specific tips and information:

<http://fatdragongames.proboards.com/board/21/3d-printing-dragonlock-terrain>

Using the DRAGONBITE™ clips



Before inserting a Dragonbite™ clip, you must first remove the printing support present in each slot on all four sides of every model. We recommend using needle-nose pliers to gently twist the support out of place (always wear eye protection when using tools.) Clips should be printed with 15-20% infill (but can be printed with 0%.)



To connect DRAGONLOCK™ Ultimate models together, simply insert a Dragonbite™ clip into the slot of one model, then slide the adjoining model into the opposite side. In addition to the standard v3.0 clip, there is an optional clip (the previous 2.0 version) that is slightly looser, should you need it. Unused slots can be covered with Dragonlock™ edge pieces.

DRAGONLOCK

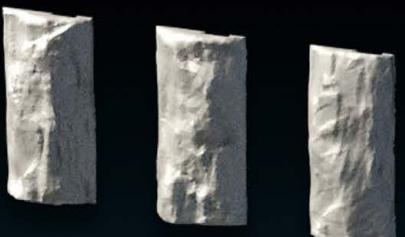
Core 4



Core 3



Side 2A-F



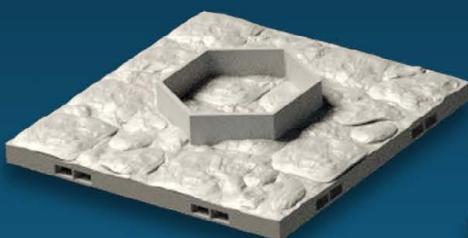
Core 2



Cap A-D



Base with Column

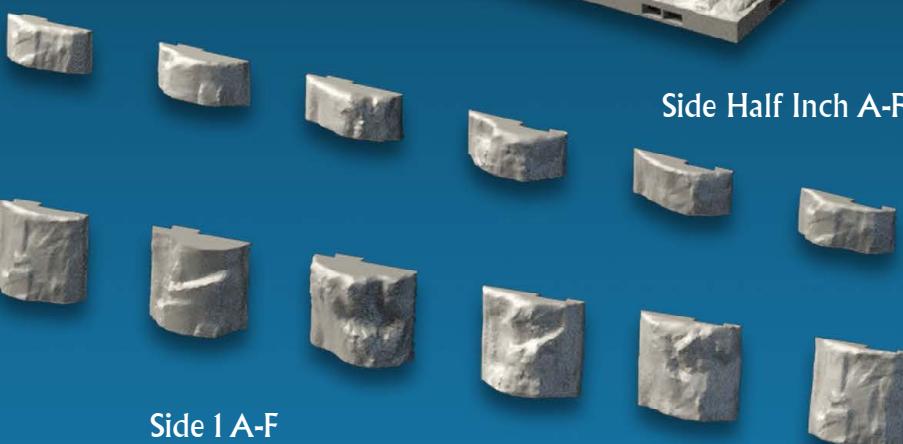


Base Flat

Core 1



Side Half Inch A-F



Core Half Inch



Side 1 A-F

Core Shim

DRAGONLOCK



Side 3 A-F



Side 4 A-F



Side 5 A-F



Nest



Printing info:

Filament:

- We recommend using PLA (we use eSun and Hatchbox in the FDG office)

Layer Height:

- All clips and cliff models 200 micron/.2mm
- Nest: 100 micron/.1mm recommended

Top/Bottom layers:

- 6 layers or .9mm

Infill:

- 0% on Sides, Cores
- 5% Caps, Nest, Bases
- 15% Clips

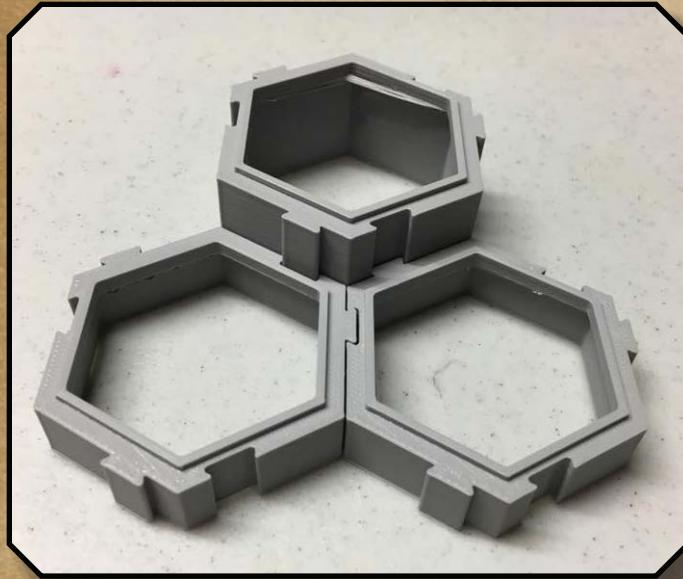
Rafts:

- None

Brim:

- Use a 5-6mm brim for all Side pieces

DRAGONLOCK



Build your general mountain/cliff shape with the core pieces. These can be used with or without a base piece. **NOTE:** If you use a base with column to build on, only use one base with column per mountain structure. The base with column just prevents lateral shifting, and a single one is all you will need.

Add caps and sides to the cores. If you get to the top and there is a mis-alignment due to the varying heights of the cap sculpting, add a shim or two under the cap as necessary.



Adding a shim is easy, just remove the cap piece and place one or two shims under it.

This is what the new support column structure with additional shims looks like with side removed.

DRAGONLOCK



Now that shims have been added the top is flush .

Sides do not need to be the exact size you need to fill vertically. In many cases, using multiple shorter side pieces together creates a more realistic 'jagged' look.



IMPORTANT: Sides A and F are slightly narrower widths than Sides B-E, so A and F sides will be easier to use on inside-corner areas. If you have an inside corner and the sides are touching/rubbing at the inside corner edge, replace one or both with an A/F piece.