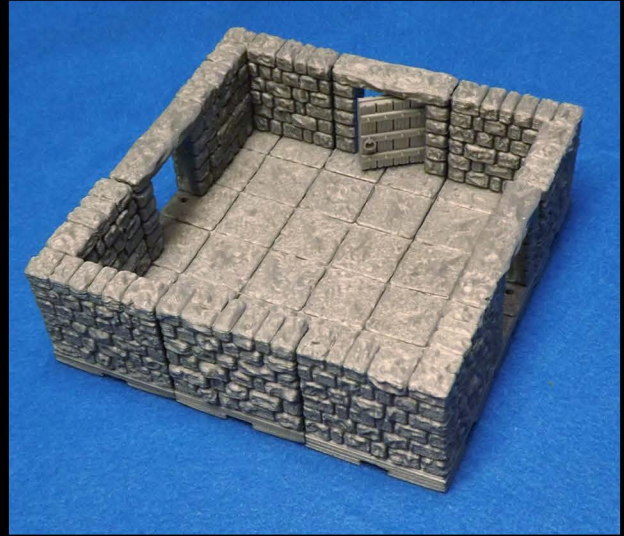
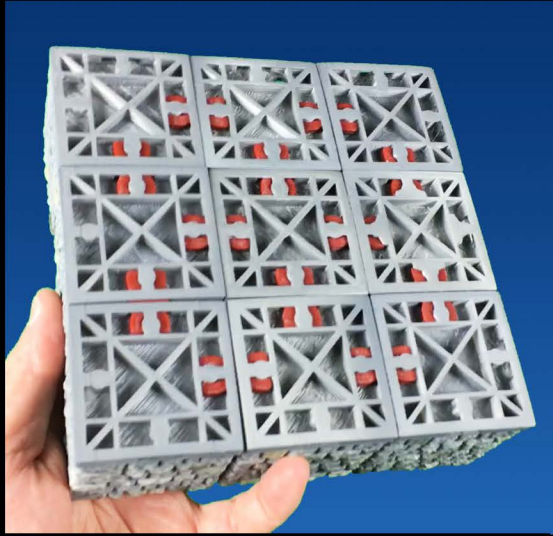


DRAGONLOCK

ULTIMATE



DRAGONBITE™
COMPATIBLE



Miniatures by www.reapermini.com

CAVERNS EXPANSION SET I

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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.)

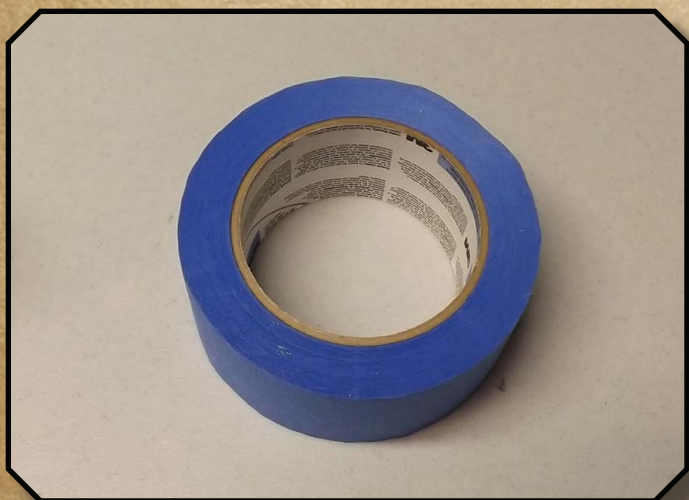


While not necessary, it helps to have a pair of small tweezers on hand. You'll find yourself using them often to pull odd strands of plastic off the model, getting small bits of plastic out of the printer, etc.

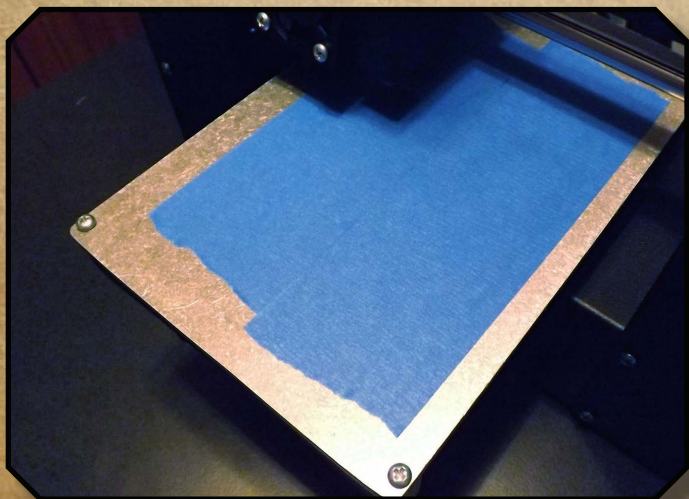
DRAGONLOCK



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).

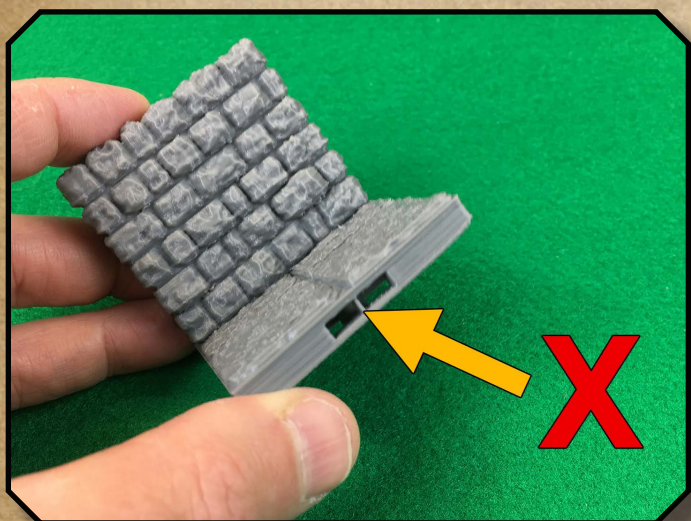
DRAGONLOCK

General printing tips for DRAGONLOCK: Ultimate™ models

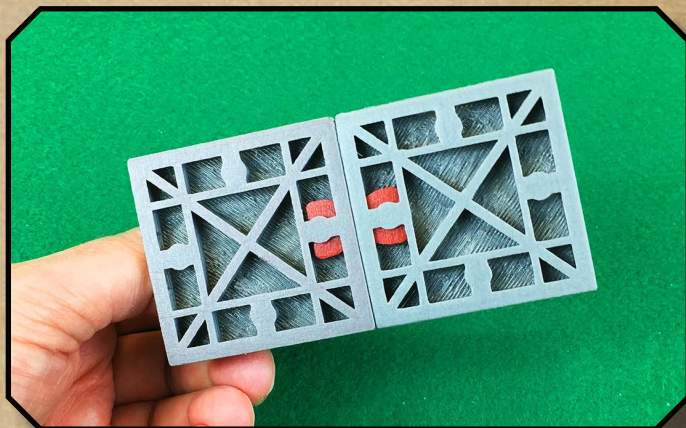
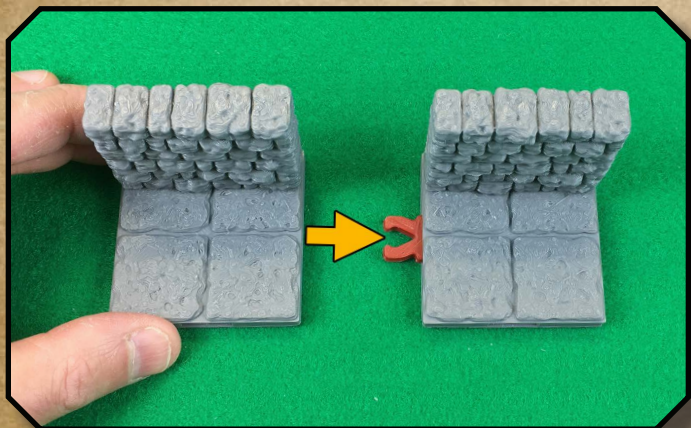
With the wide variety of printers and filaments on the market, it isn't possible for us to list printer settings that will work with multiple machines. Please visit the Fat Dragon Games forums for printer-specific tips and information:

<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 v2.0 clip, there is an optional looser clip included. If your clips are still too tight vertically, just scale them to 90% on the Z AXIS ONLY in your slicer.

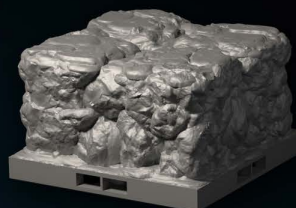
DRAGONLOCK



Cave Elevation B



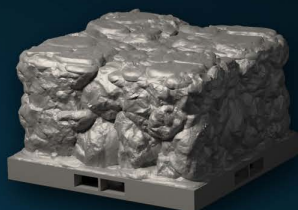
Cave Elevation A



Cave Elevation F



Cave Elevation E



Cave Elevation G



Cave Elevation D



Cave Elevation C



Cave Wall Elevation
End A



Cave Wall Elevation
Straight B



Cave Wall Elevation
End A



Cave Wall Elevation
Straight A



Cave Wall Elevation
Corner B



Cave Wall Elevation
Corner A

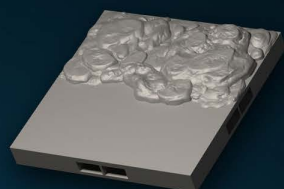


Cave Waterflow

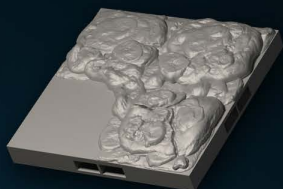


Cave Wall Waterflow

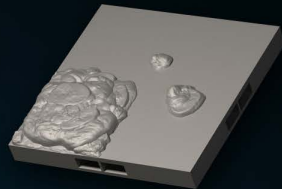
DRAGONLOCK



Cave Water Floor
2x2 B



Cave Water Floor
2x2 C



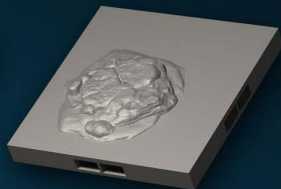
Cave Water Floor
2x2 D



Cave Water Floor
2x2 E



Cave Water Floor
2x2 I



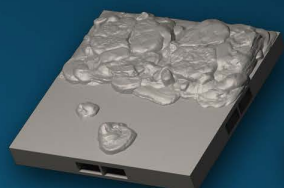
Cave Water Floor
2x2 H



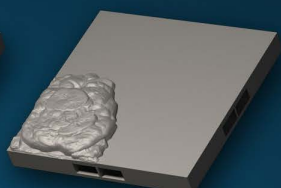
Cave Water Floor
2x2 G



Cave Water Floor
2x2 F



Cave Water Floor
2x2 A



Cave Water Floor
2x2 K

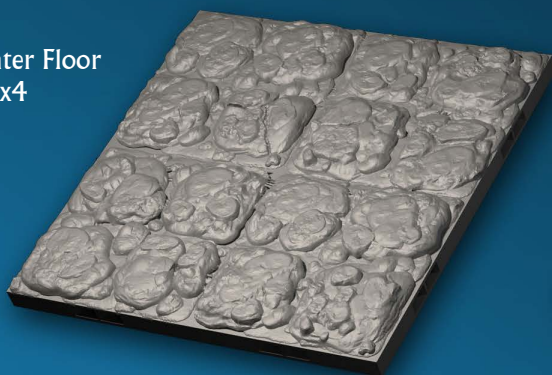


Cave Water Floor
2x2 J



Cave Water Floor
2x2 L

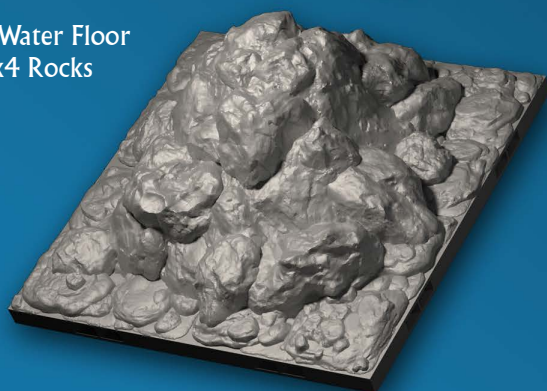
Cave Water Floor
4x4



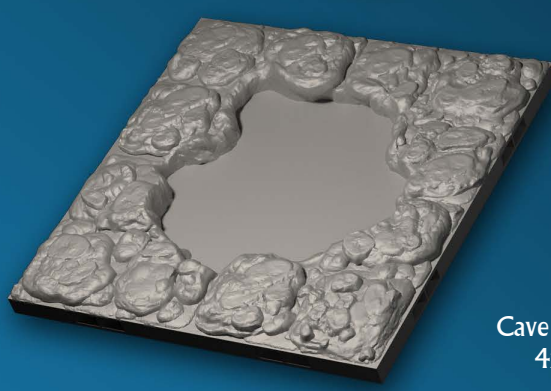
Cave Water Floor
4x4 Hole



Cave Water Floor
4x4 Rocks



Cave Water Floor
4x4 Water





Printing info:

Filament:

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

Layer Height:

- All clips, wall models & stairs: 200 micron/.2mm

Top/Bottom layers:

- 5 layers or 1 mm

Infill:

- 10-15 (15-20% for clips)%

Rafts:

- None

Brim:

- None

FDG0193 Dragonlock Ultimate

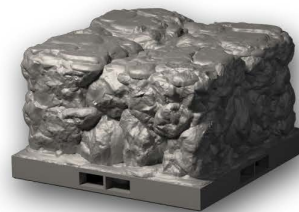
Cavern Expansion Set 1



Cave Elevation B



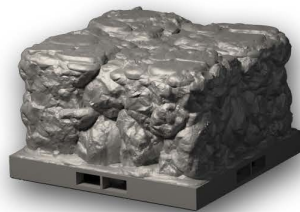
Cave Elevation A



Cave Elevation F



Cave Elevation E



Cave Elevation G



Cave Elevation D



Cave Elevation C



Cave Wall Elevation
End A



Cave Wall Elevation
Straight B



Cave Wall Elevation
End A



Cave Wall Elevation
Straight A



Cave Wall Elevation
Corner B



Cave Wall Elevation
Corner A



Cave Waterflow

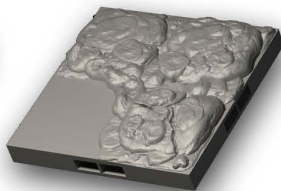


Cave Wall Waterflow

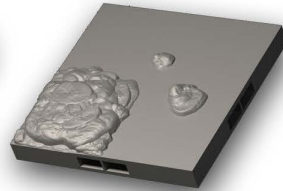
FDG0193 Dragonlock Ultimate Cavern Expansion Set 1



Cave Water Floor
2x2 B



Cave Water Floor
2x2 C



Cave Water Floor
2x2 D



Cave Water Floor
2x2 E



Cave Water Floor
2x2 I



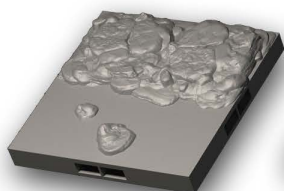
Cave Water Floor
2x2 H



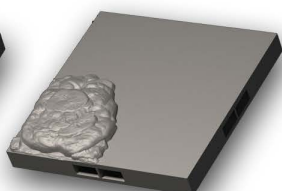
Cave Water Floor
2x2 G



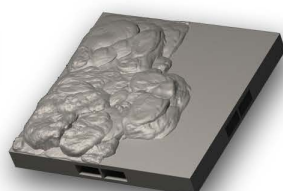
Cave Water Floor
2x2 F



Cave Water Floor
2x2 A



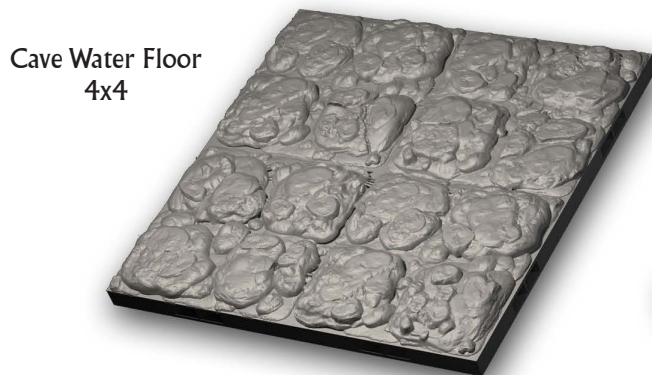
Cave Water Floor
2x2 K



Cave Water Floor
2x2 J



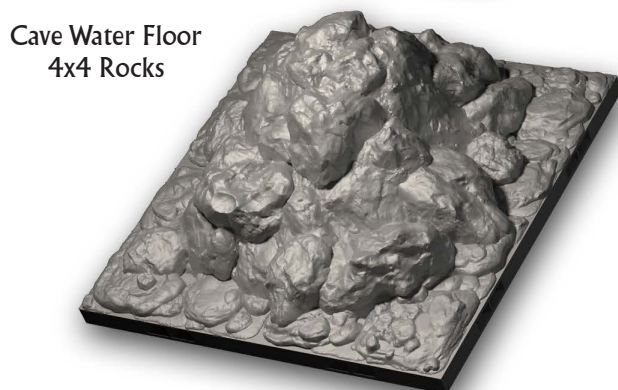
Cave Water Floor
2x2 L



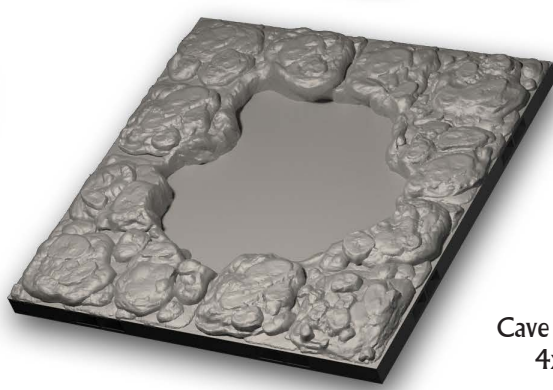
Cave Water Floor
4x4



Cave Water Floor
4x4 Hole



Cave Water Floor
4x4 Rocks



Cave Water Floor
4x4 Water