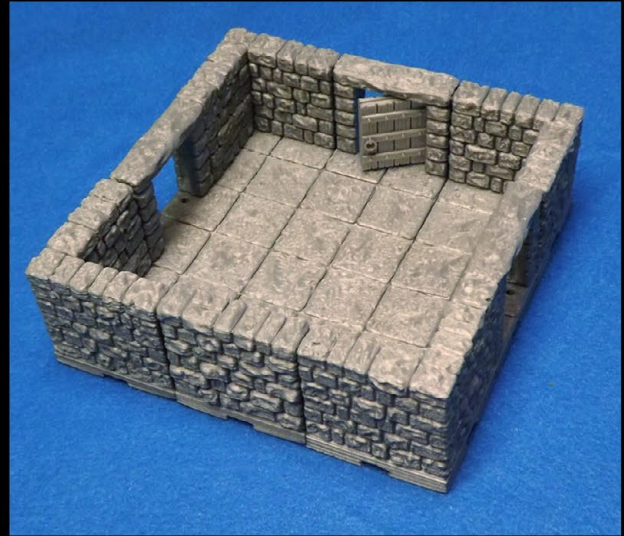
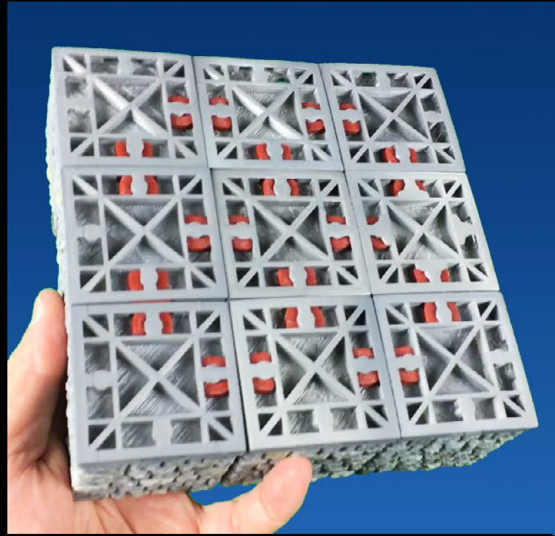


DRAGONLOCK

ULTIMATE



DRAGONBITE™
COMPATIBLE

Miniatures by www.reapermini.com

DUNGEON EXPANSION SET 8

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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.)

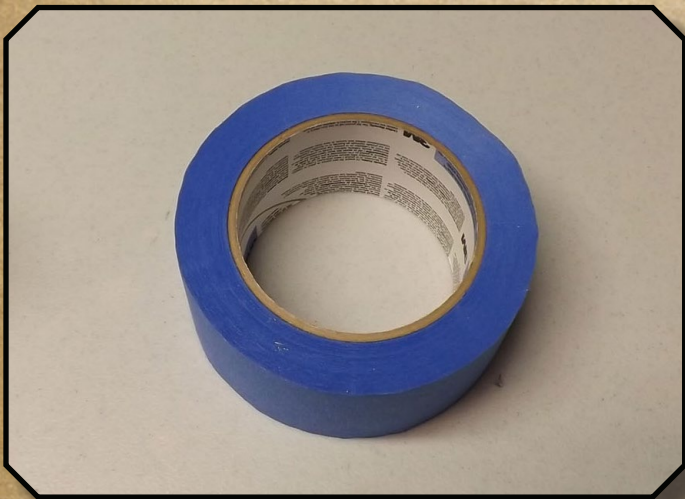


While not necessary, it helps to have a pair of small tweezers on hand. You'll find yourself using them often to pull odd strands of plastic off the model, getting small bits of plastic out of the printer, etc.

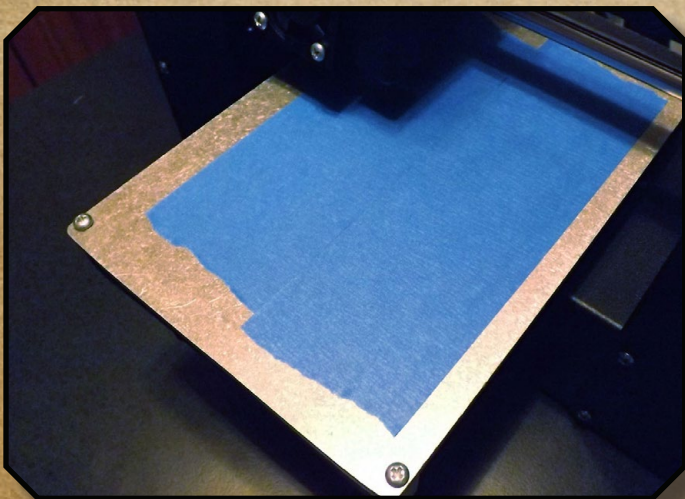
DRAGONLOCK



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).

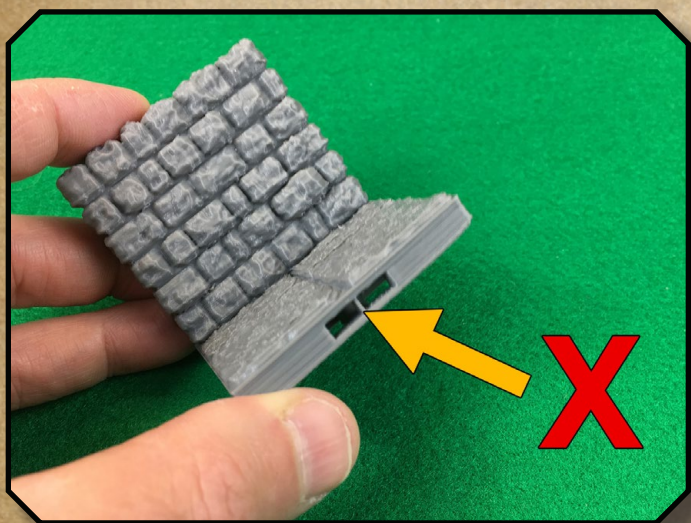
DRAGONLOCK

General printing tips for DRAGONLOCK: Ultimate™ models

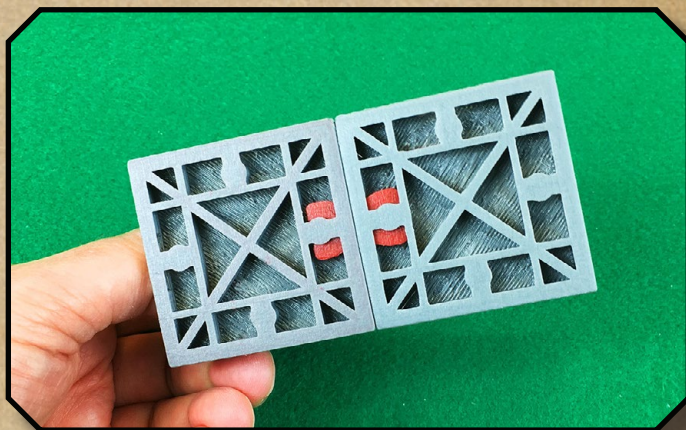
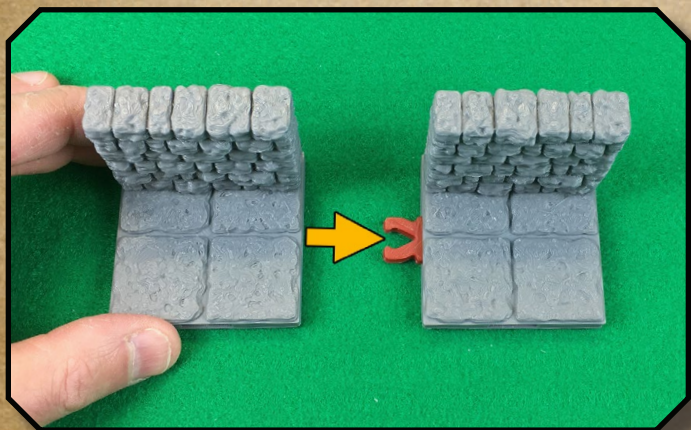
With the wide variety of printers and filaments on the market, it isn't possible for us to list printer settings that will work with multiple machines. Please visit the Fat Dragon Games forums for printer-specific tips and information:

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

Using the DRAGONBITE™ clips



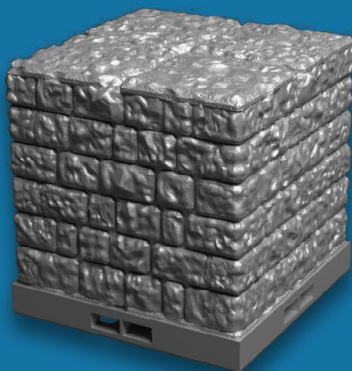
Before inserting a Dragonbite™ clip, you must first remove the printing support present in each slot on all four sides of every model. We recommend using needle-nose pliers to gently twist the support out of place (always wear eye protection when using tools.) Clips can be printed with 0% infill, but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



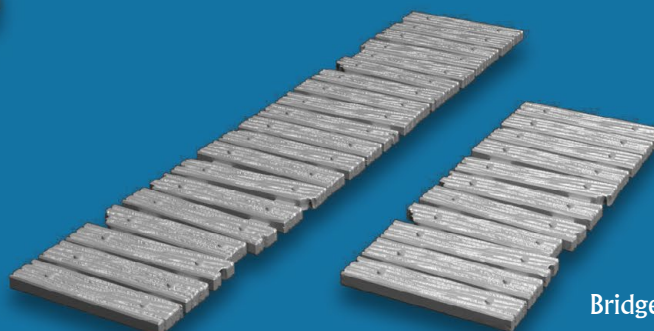
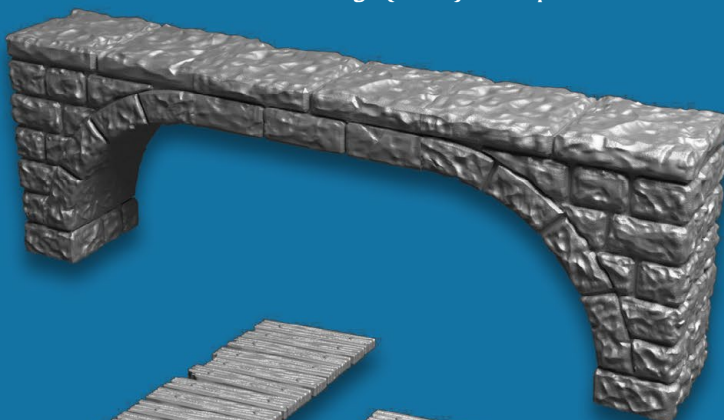
To connect DRAGONLOCK™ Ultimate models together, simply insert a Dragonbite™ clip into the slot of one model, then slide the adjoining model into the opposite side. Four sizes of Dragonbite™ clips are provided (loose, standard, tight, extra tight.) We recommend trying the tight clip first. The clips will work more easily after using them a few times.

DRAGONLOCK

Cube

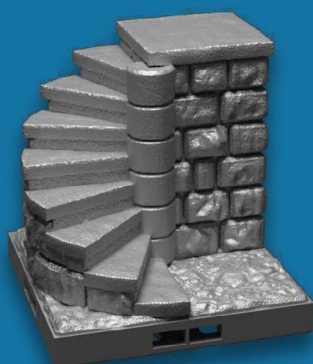


Bridge (stone) multi-piece

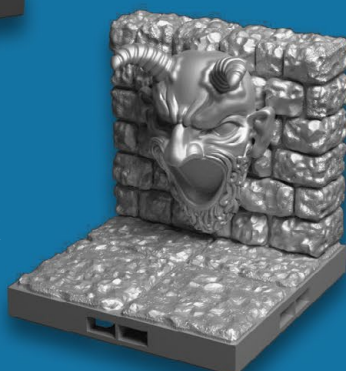


Bridge (wood) long

Bridge (wood) short



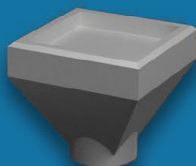
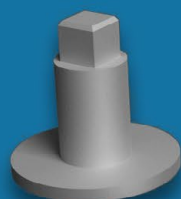
Spiral stairs



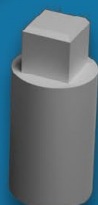
Demon face wall



Flight stand base

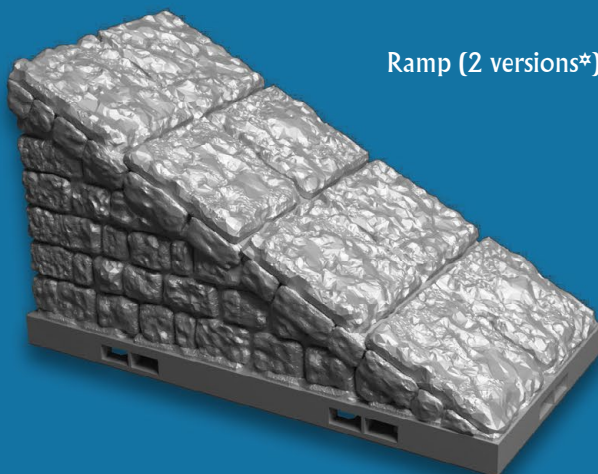


Square miniature base cap



Flight Extension

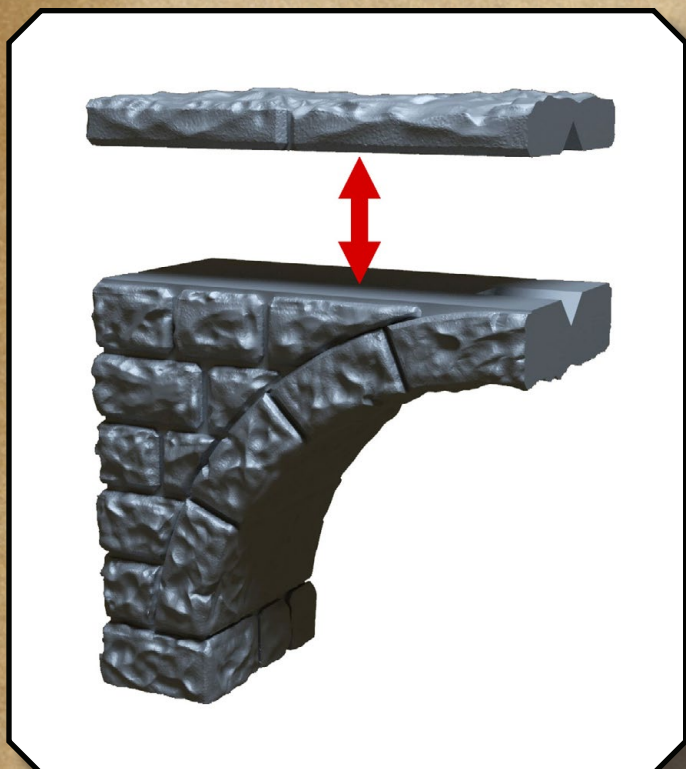
Ramp (2 versions*)



Round miniature base cap

* This set includes an optional ramp with non-slide bumpers to prevent miniatures from sliding down.

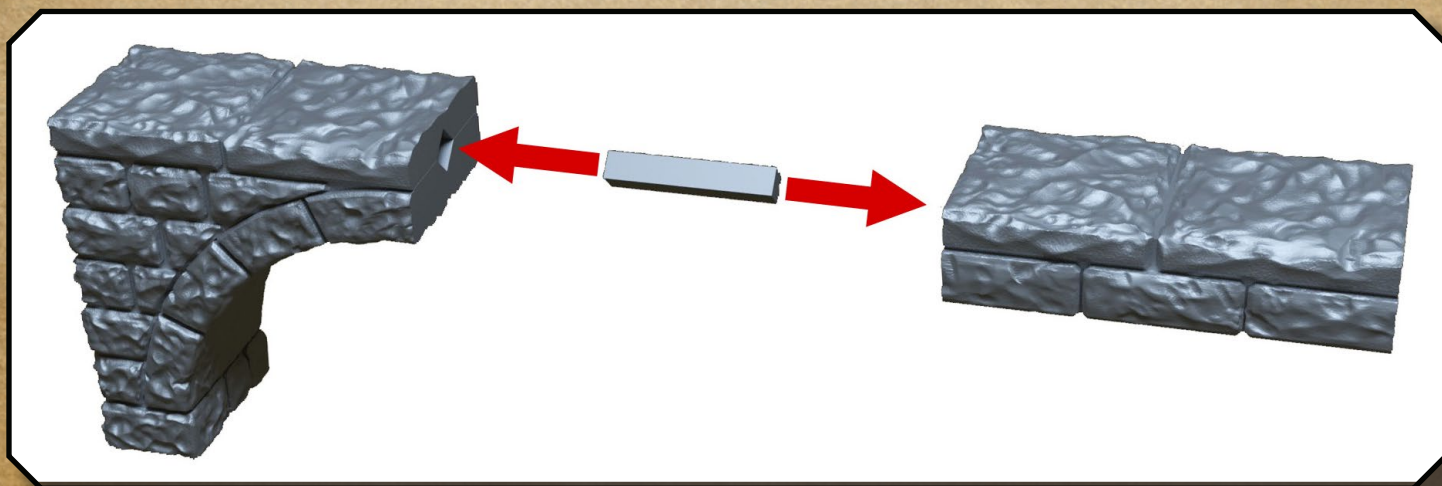
DRAGONLOCK



Glue the top and bottom pieces of the bridge together, pay close attention to the peg hole on the front for alignment.



The large lintel is designed to fit on the dungeon side door models from Dungeon Expansion Set 2 (<http://www.drivethrurpg.com/product/175723/DRAGON-LOCK-Ultimate-Dungeon-Expansion-Set-2>)



Use the pegs to attach bridge sections. If your peg is too loose or too tight, just adjust its size in small (1% or less) increments in your slicing software.



Printing info:

Filament:

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

Layer Height:

- All clips and wall models: 150-200 micron/.15-.2 mm recommended

Top/Bottom layers:

- 6 layers or .9mm for .15mm layer height resolution, 4 layers/.8mm for .2mm layer height resolution

Side layers/shells:

- 2 shells (.8mm with a .4mm nozzle)

Infill:

All models: 15%

Rafts & Brim:

None except the flight stand caps and extension, these three models may require a small brim.