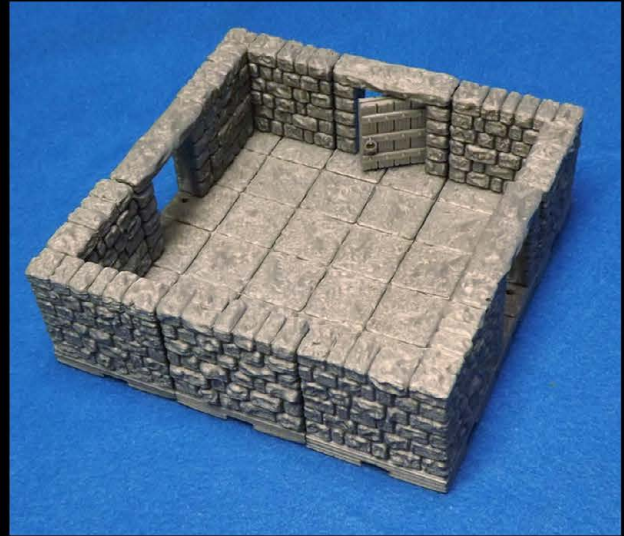
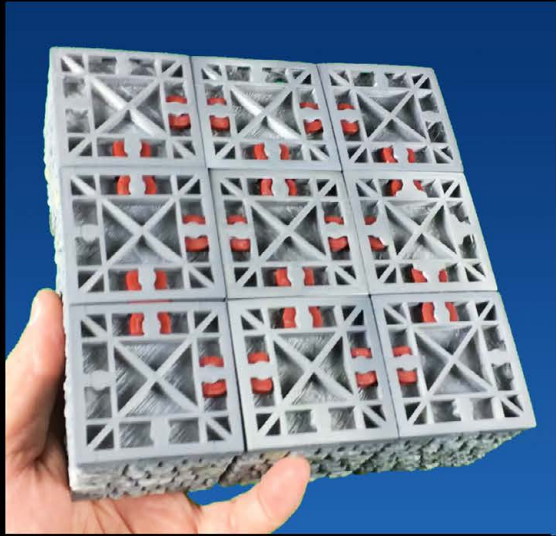


# DRAGONLOCK

## ULTIMATE



**DRAGONBITE™**  
COMPATIBLE

Miniatures by [www.reapermini.com](http://www.reapermini.com)

# DUNGEON STARTER SET

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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.)



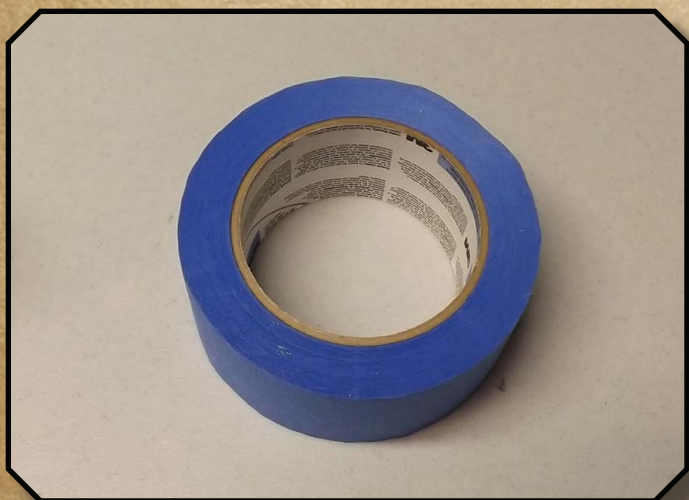
While not necessary, it helps to have a pair of small tweezers on hand. You'll find yourself using them often to pull odd strands of plastic off the model, getting small bits of plastic out of the printer, etc.



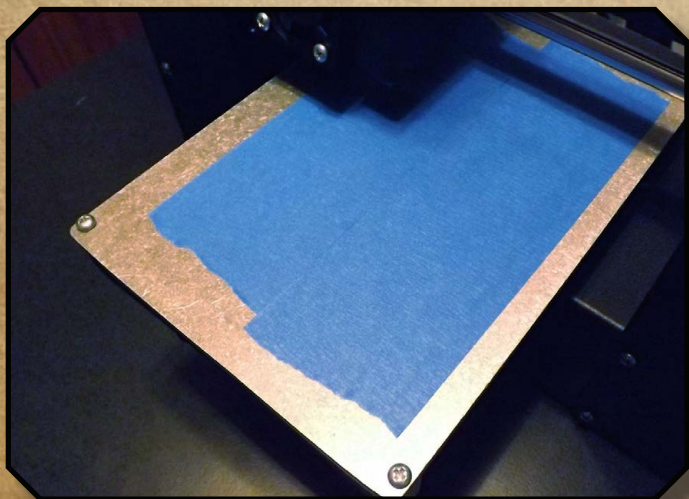
# DRAGONLOCK



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

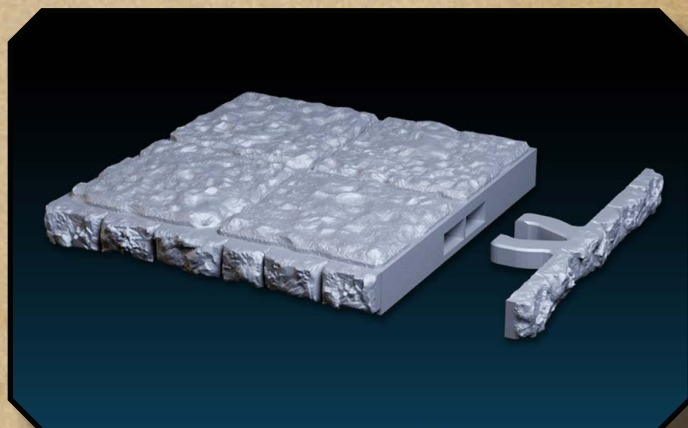
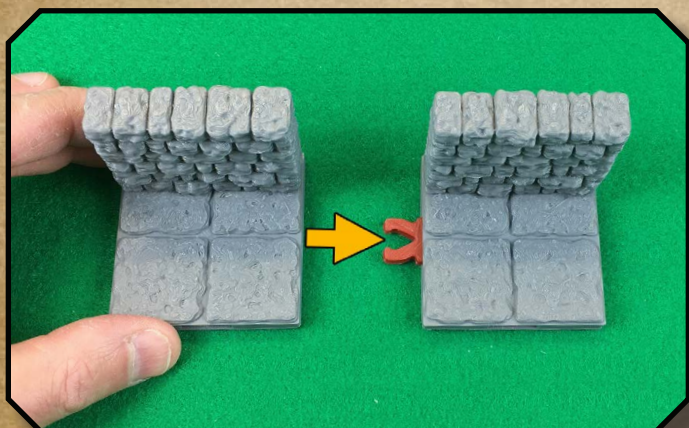
With the wide variety of printers and filaments on the market, it isn't possible for us to list printer settings that will work with multiple machines. Please visit the Fat Dragon Games forums for printer-specific tips and information:

<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 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

## 'DUNGEON STARTER SET' Model List

Wall 1



Corner Pillar



Stairs



Dungeon Floor



Door Frame, Lintel,  
and Door



Corner



Wall 2







## Printing info:

### Filament:

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

### Layer Height:

- All clips, wall models & stairs: 150 micron/.15mm recommended (200 micron/.2mm works great as well)
- Door: 100 micron/.1mm recommended

### Top/Bottom layers:

- 6 layers or .9mm

### Infill:

- 0% on Corner, Door, Dungeon Floor, Lintel, Wall 1 and Wall 2
- 15% on Stairs and Clips
- 25% on Door Frame and Corner Pillar

### Rafts:

- None

### Brim:

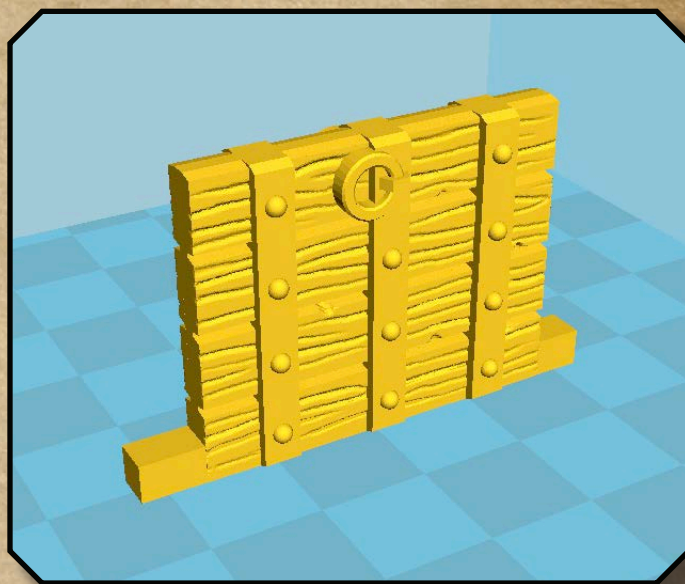
- None



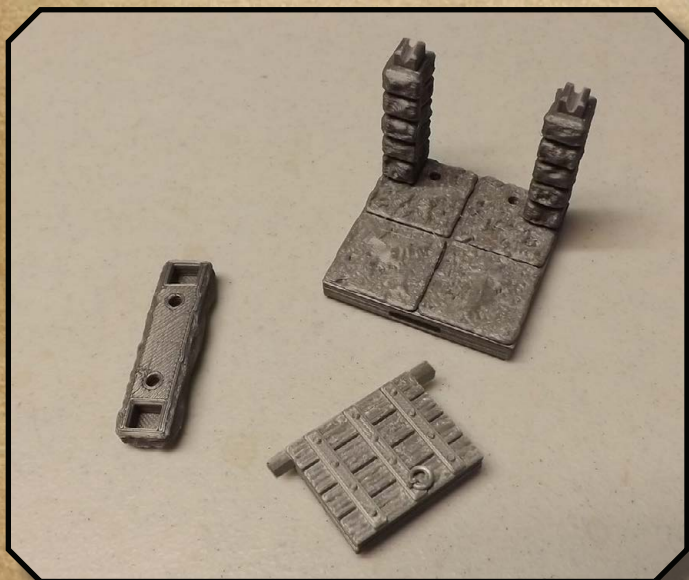
# DRAGONLOCK



Use the stair adapter to support minis on the stairs.



Print the door model vertically as depicted above. The door prints best at 100 micron layer height (.1mm.)



Be sure to print the door frame with at least 25% infill for added post strength.



As long as you do not glue the top lintel to the lower door frame, you can make alternate doors (available in other model sets) and swap them out without having to make additional door frames.