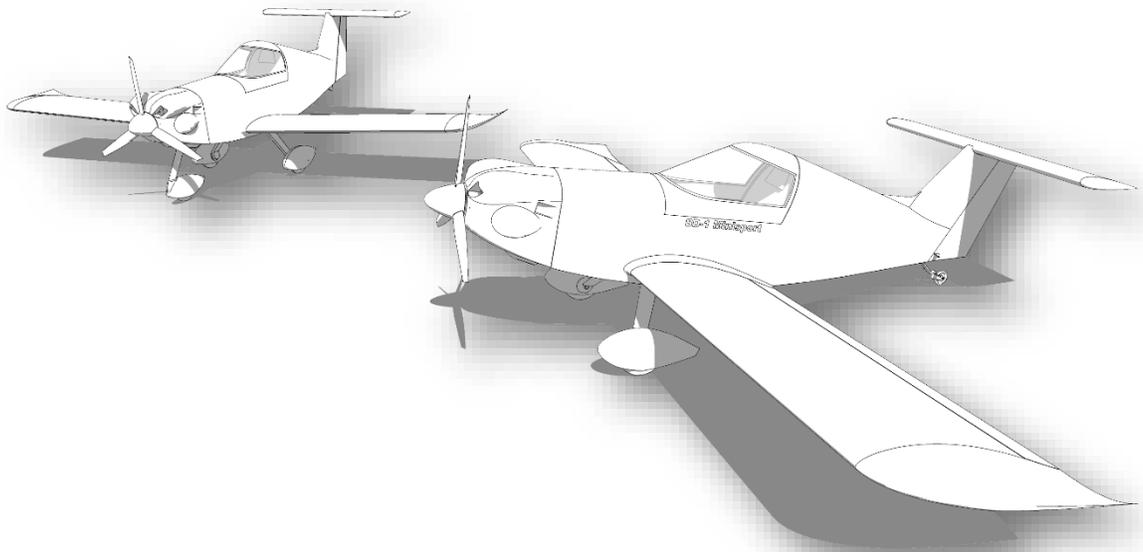


Spacek

# SD-1 Minisport

Manual for the 3d printing model



### 3d Printing Model SD-1 Minisport

Hello 3d-printing enthusiasts and friends of aviation. Here a small instruction about printing and assembling of the model.

I use the program Simplify3d as slicer software, my experience has shown that I get the best results with it.

However, you can also use any other slicer such as CURA or Repetier-Host.

I print all my models in PLA. This filament has the advantage that almost no warping occurs.

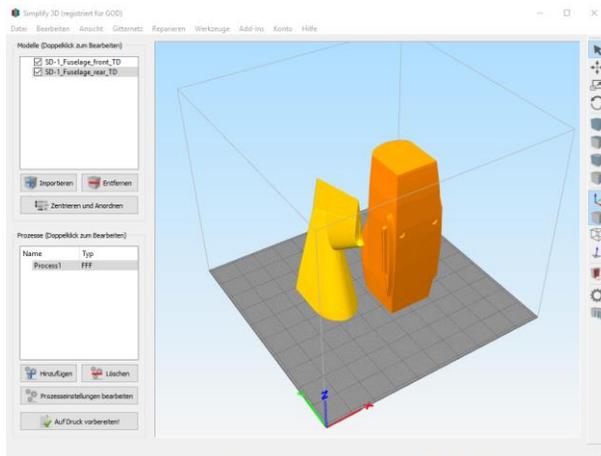
#### Basic settings of the Slicer:

Extruder	200 ° C
Heating bed	55 ° C
Print speed	60 mm / sec (see below)
Fan	from 3 layer 100%
Layer height	0.2 (0.1) mm (see below)
Infill	0 - 50% (see below)
Support	no

The large parts (fuselage, wings, tailplane and engine hull) I print in 0.2 mm layer height, contour / shell 2, solid layer top & bottom each 3, without infill and with 60 mm / sec.

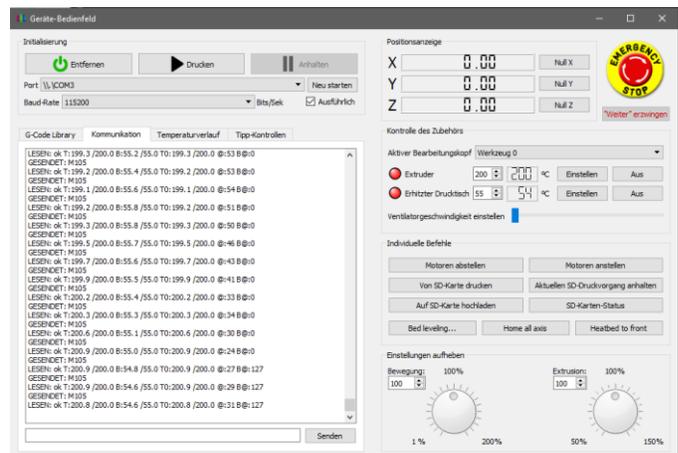
The small parts (landing gear, wheel covers) with 0.1 mm layer height and at least 50% infill (nose wheel / tail wheel and propeller with 100%), speed 30 - 40 mm / sec.

Good cooling is important! The leading edge of the rudder is a problem zone.

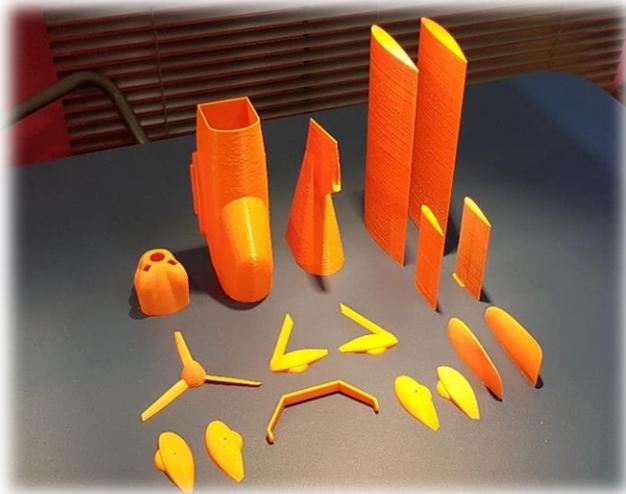


View in the slicer

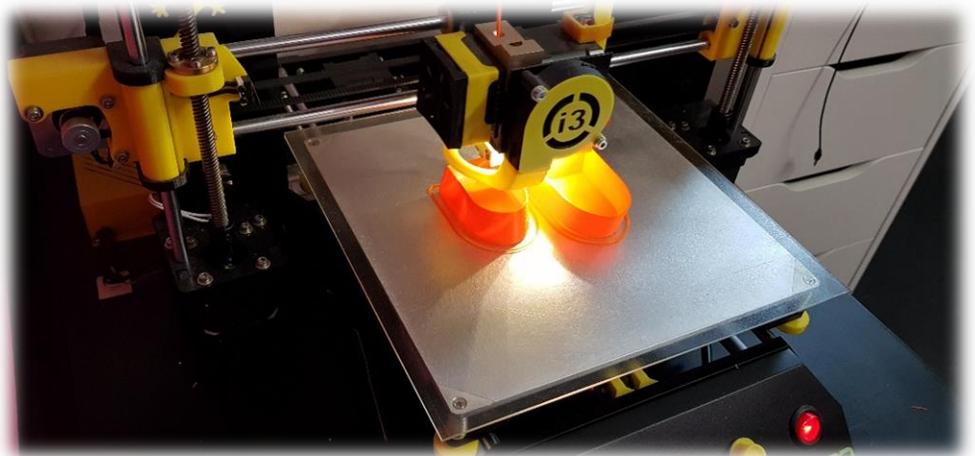
Monitoring in the slicer



The model is in scale 1: 13.333, this gives a wingspan of 450 mm.  
The individual parts are designed in such a way that the model can be printed on any standard 3D printer with a built volume of least 200x200x180 mm.



Parts of SD-1 TG



printing...

**And now, have fun with printing the SD-1 ...**



### **Assembly of the model:**

First, the fuselage front/rear part, wing/wingtips, horizontal stabilizer, wheel covers and front and rear wheels are glue together.

I use super glue , if that's too fast, you can also use an epoxy glue.

The propeller is available in different variants, flat or realistic.

If you use the profiled propeller, the back must be grind down.

After drying must be sanded. Depending on the desired finish, more or less.

Priming with acrylic primer and filler, varnishing in the desired color with acrylic, decoration and matriculation from foil.

With the help of the printed template, the cabin hood is cut out of a piece of self-adhesive film.

### **Please note:**

For the model to stand correctly, the TG version needs 50 gr., The TD version 25 gr. Lead in the hood.

**As a thank you for my work I would like to receive a photo of every printed SD-1 by email.**

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Have fun

Martin

