

Project: Leviathan

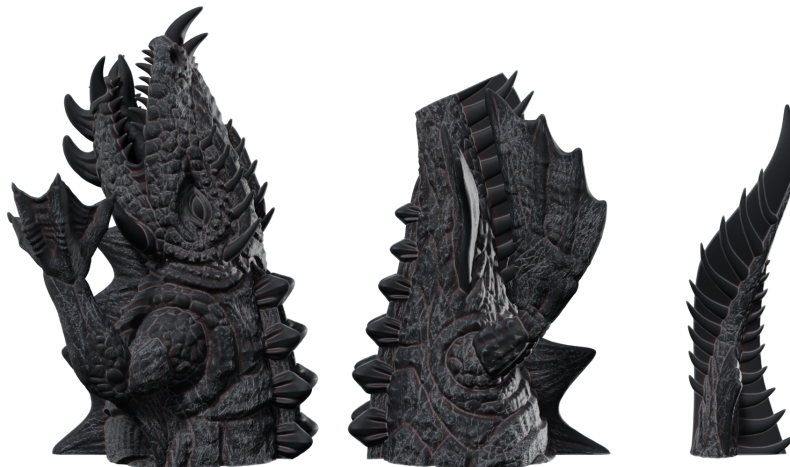
Dragon of the Deep

By xykit.com



3D printing Guide

Thank you for purchasing the Leviathan Model. This model is rather large and measures almost 2 feet long when printed at full-size and fully assembled. In order to print the model support-free, we've included a variety of pre-cut versions. The larger your printer, the less pieces you will need to print. The models are cut into pieces to fit on a 180mm x 180mm x 180mm build volume.



(Full size model measure approx. 586mm long, 171mm wide, and 137mm tall)

This set also includes a un-cut, full size version of the model should you wish to scale the model and cut / support the model yourself.

There is also a Bonus “half-size” version of the Leviathan itself for use with tabletop games. This version is cut in half for easy printing. It has a single OpenLock clip slot in the middle for quick joining.

Bases

There is the standard wood base that uses 4 prongs to hold the leviathan, we recommend gluing the prongs in place.

There are also 2 Bonus bases, a water texture base that uses the same 4 stand prongs, and a water wave base that uses the wave to rest the Leviathan on. The bases have openLOCK joints cut into them for clipping together, you will need to remove the built in support from the mouth of the joints with pliers before clipping together. There are no resin specific variants of the bases, they are sized for 180mm square build volumes.

Recommended Print Settings

The Leviathan model is ideal for FDM printers and can be pre-joined together with OpenLOCK clips (use `_OpenLOCK_Clip_v5.4`). For a more solid connection, we recommend using glue. You do not need to use all OpenLOCK clip slots, as it can make it difficult to press together, for a weaker connection, use less clips.



FDM Printers

- **Layer Height:** .2mm (.12-.16 will give you more details)
- **Infill:** 10-15%
- **Shells:** 3
- **Supports:** None

(to speed up printing, you can use a .6mm nozzle and 2 shells, which is what we used for our sample prints. You can also increase the layer height, however you will lose details.)

Resin Printers

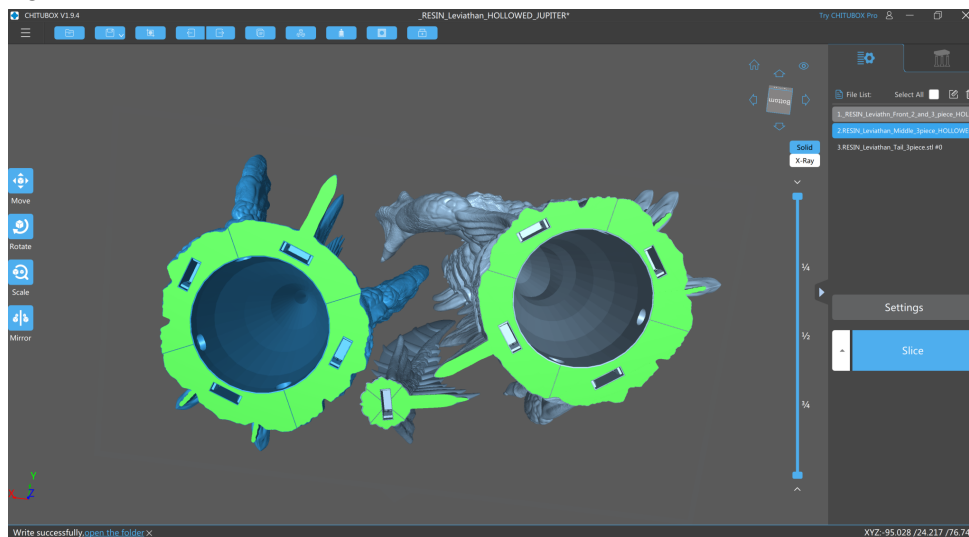
To print the Leviathan on a resin printer you will need a large format model. Our sample resin print was printed on an Elegoo Jupiter, in 3 pieces.

Included are a 3 piece, 5 piece, and 8 piece version for resin printing that will need to be glued together.

- **Layer Height:** .05mm
- **Supports:** None required for pre-cut, full size versions. Print directly on the build-plate.

****For resin printers please read the following notes:***

The Resin versions of the model have an extra .2mm pad built into the base of many of the pieces where it will touch the build plate. There is also a hollowed version of the larger pieces with drain holes cut out. If the pad doesn't "squash" all the way, you may need to sand the pad, and/or use the slightly longer included variants of the OpenLOCK clips, that have an extra .1mm or .2mm length built in.



If you do not wish to have the extra pad, you may print the FDM versions of the models, however those versions are not pre-hollowed.

You may also scale the single piece version of the models down to fit your resin printer, and add your own resin supports to fit your specific needs.