

Printing Instructions

Overview

<https://odysee.com/@GunCad:3> for latest releases

This is a simplified/improved version of the FGC9 ECMing system.

Thanks to those guys for providing the original CAD files.

This modification allows for direction connection to 10 mm ID plastic tubing without the use of brass fittings.

More Details

I have simplified the design to make it use fewer parts and hopefully make it less messy.

I have used general cheapo O-Rings (16 mm) to seal both sides.

The files are designed to be printed using ABS and a 0.4 mm nozzle.

I designed this system with multiple ideas in m ## Print settings See `print_profile.curaprofile`

IMPORTANT only print one file at a time! The printer head moving from part to part causes artifacts that make threading wire through the mandrill impossible. . .

But a brief covering: - ABS - 0.4mm nozzle - 0.2 initial layer height - 0.12mm layer height - 40% fan - 3 layer wall thickness - 100% infill - 12 mm/s outer wall speed - 12 mm/s inner wall speed - 25 mm/s everywhere else - Support brim - Supports under part

I use an Anycubic 4Max Pro 2 - the best printer money can buy. Prints ABS like a boss.

You can print in PLA or PLA+ but the part is designed to take into account ABS shrink (16.8 mm ID vs 16.2 mm)