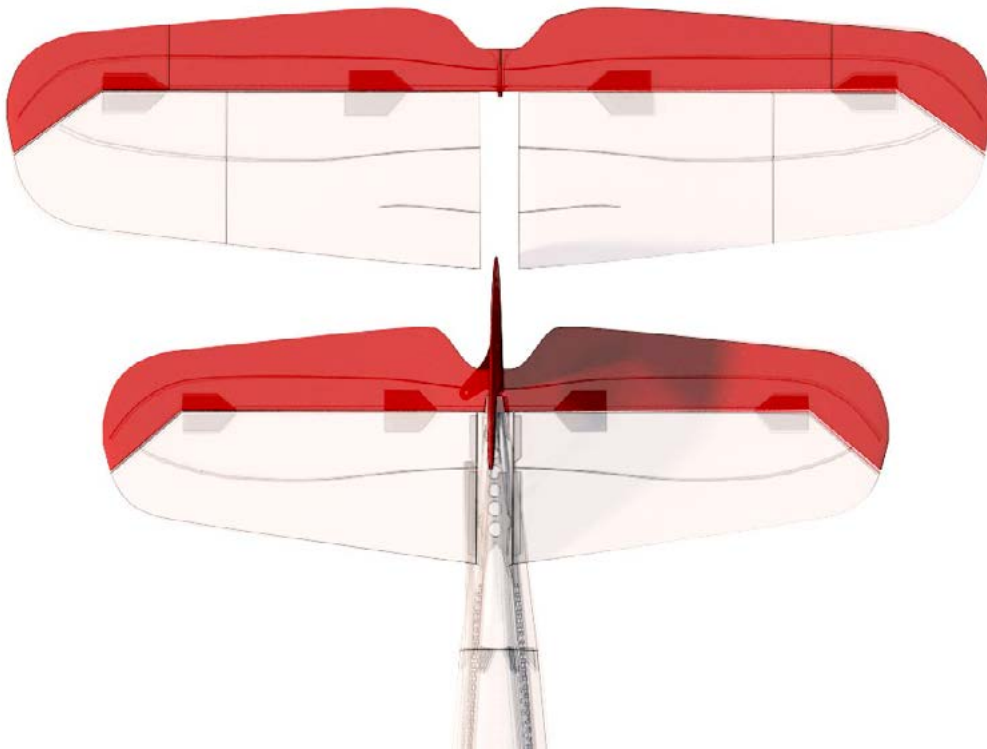




User Guide

rev. 2016/08



Fully 3d printable

Bigger horizontal stabilizer Me 109

for better flight behavior, if you do not need exact scale look... (all Me109 version)

3D Lab Print bigger horizontal stabilizer (+25%) conversion for Messerschmitt Bf 109

Future of flying - Print your own plane

We still trying move things further, so this project is again full of other improvements for better durability , easier assembly , better geometry solution and so on..., we hope you enjoy it, although this print may test your competencies to and quality of your printer (welcome to the thin wall printing)

For better flight behavior if you use this bigger horizontal stabilizer and elevator instead the standard one you will get nicer flight behavior. So if you do not need exact scale look we recommend to do this. It increase horizontal stability and it will be easier to fly... This part is compatible with Me 109 H, F and T version. Please proceed via Me 109 userguide...

Included:

1. STL 3d files (only stabilizer and elevator parts)

universal STL files designed for use with desktop FMD 3d printers and slicer software as Simplify3D (recommend) CURA or MatterControl (this STLs are not compatible with Slic3r).

2. Factory files for Simplify3D slicer

with all our setting, this Factory files included all you need, note: we use PRUSA i3 ORIGINAL printers so you may need adjust the basic printing parameters to match your printer or use it as a start point for you, please give a look to [Simplify3D](#)

3. Gcodes

Basic Gcodes prepared for direct use, so universal as is possible. Should work with i3 style printers, you can try it out, but We can not guarantee that it will work with your printer. 100% works with PRUSA i3 ORIGINAL 3d printers...

4. Prepared settings for CURA and MatterControl slicers

If you dont like Simplify3D for any reason, there is always possibility to use another free slicer you can use our basic setting (setting files) as a start point and edit it as you need.

Step By Step PDF/VIDEO userguide

1. Choose airplane at www.3DLabPrint.com, our [Facebook](#) for live information...



Basic requirements (Me 109 H/F):

min volume 195/195/150mm (250/120/150)

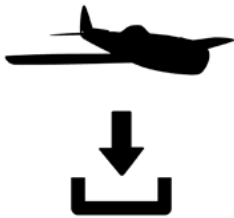
nozzle 0.4mm recommended (0.35 or 0.5mm alternatively)

Heated Bed recommended

PLA filament (or PETG, APLA, htPLA, PC-max....) not ABS

If you feel a little bit confused you can [download wing test part](#) from our websites or thingiverse, (the biggest part). Or contact support@3dlabprint.com

2. Create account, download

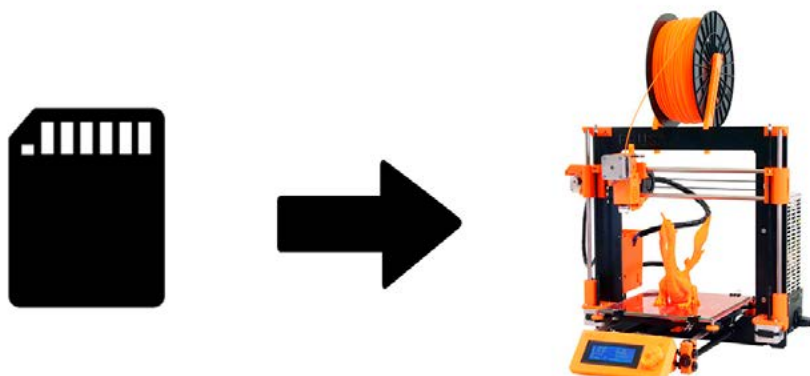


You will get download link for all files to your email (zipped) or you can log in to your account and download directly from our websites.

3. Gcodes preparing

options A Gcodes:

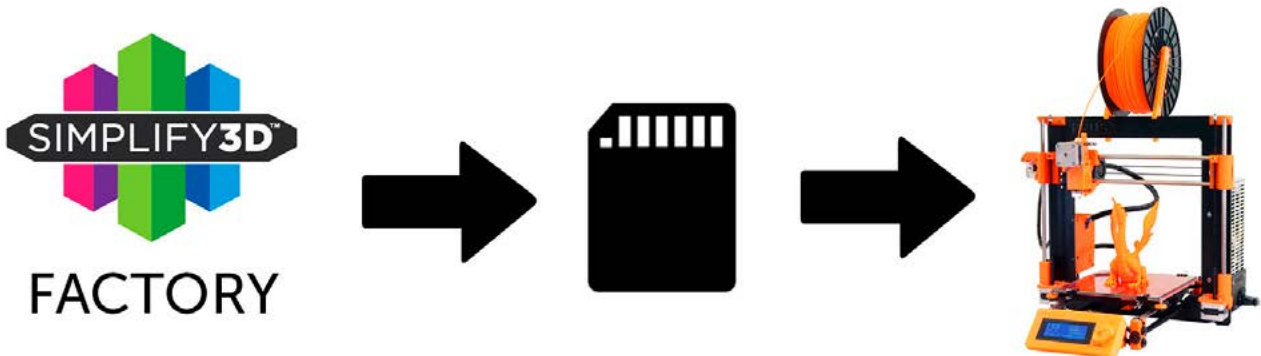
if your printer is i3 compatible you can directly use [prepared gcodes](#), simply save each to SD card and let 3d printer do his job, HE temperature is set to 230 for best layer bonding, you can edit speed and temperature on your printer LCD only. If Gcodes does not work please proceed to the next options.



options B Factory files Simplify3D (recommended)

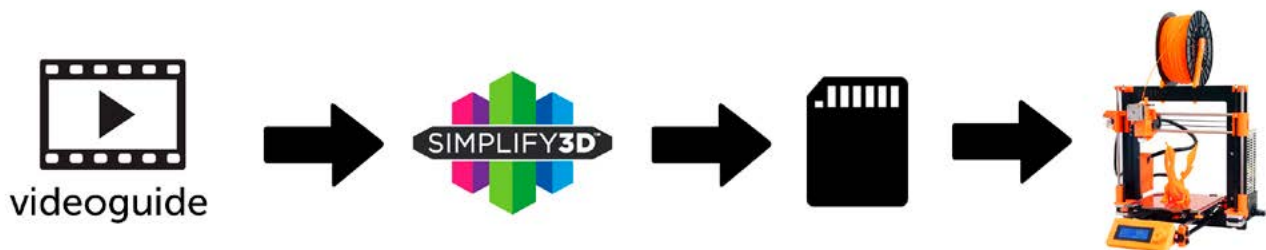
We prepare all you need in this files (basic FFF, parts arranged and so on...)

You can use this our setting as a start point and edit it as you need (adapt it for your printer), print only parts you need and so on... On moust 3d printers it should work as it is, but please give a look to the setting and edit it if is different to your printer, we are not liable for damages resulting from the use of our settings. If this does not work please proceed to the next option.



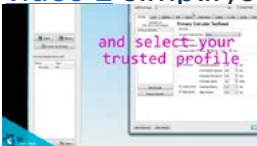
options C Simplify3D manual setting (for experts)

Use our [video guide 2](#) for proper setting... this is very good option and you will learn a lot about Simplify3d and become an 3d expert. Of course you spend a lot of time and youtube pause button will become your friend.



AND... please give a look to VideoGuides:

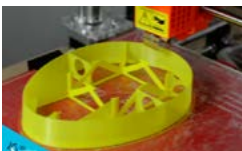
[video 2 Simplify3D setting](#)



[video 2.1 before start printing](#)



[video about Thin Wall Printing](#)



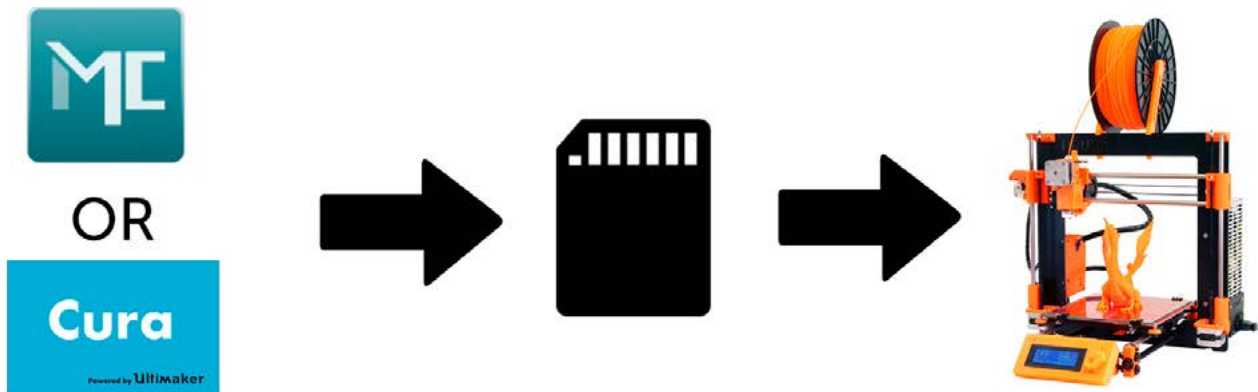
[options D CURA or MatterControl](#)

MatterControl and CURA are free :-)) and also gives very good results and airframe is still strong enough, slicer setting is very easy.

Please try [find right extrusion multiplier and temperature](#) for good weight and bets layer bonding, give a look to parts weight list for proper multiplier setting.

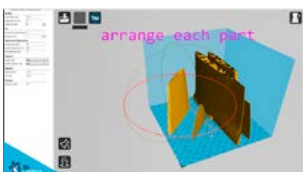
You can also use our [predefined](#) CURA or MC slicer setting file included in package (always adapt it for your printer, change build volume, filament diameter and so on... depends on your printer!!!):

- [CURA_wing_fuse.ini](#) (wing and fuselage and so on... parts)
- [CURA_ailer_elev.ini](#) (only ailerons, elevator and rudder parts)
- [CURA_thick.ini](#) (motor mount, battery holder, spinner)
- OR
- [MC_wing_fuse.slice](#) (wing and fuselage and so on... parts)
- [MC_ailer_elev.slice](#) (only ailerons, elevator and rudder parts)
- [MC_thick.slice](#) (motor mount, battery holder, spinner)



AND... please give a look to [VideoGuides](#):

[video CURA slicer setting](#)



[video CMatterControl slicer setting](#)

