



Recommended printer: PRUSA MK3 scale: 1/72, 1/40

PRUSA MINI scale: 1/72, 1/40

Recommended print material: PLA, ASA, PETG

type of material	Manufacturer of filament	submarine construction	advantage	Disadvantages	note
PLA	Plasty Mladec https://www.filament-pm.com/	Static model	Great print surface, easy printing, no distortion	It degrades and deforms in the sun , sucks water, wrong grinding	use a spray for a smooth surface (BodyFill 360)
	PRUSA https://shop.prusa3d.com/en/				
ASA	Plasty Mladec https://www.filament-pm.com/	RC model	Resistant to sun and water, holds paints and adhesives well, grinds well. (The best variant for the Rc model.)	Minor deformation on the surface, Possible deformation on the mat when printing. Demanding printing	Cover the printer, after printing it is good to cover the part to cool longer, otherwise there is a risk of cracking layers. For a smooth surface use spray (BodyFill 360)
	PRUSA https://shop.prusa3d.com/en/				
	Spectrum ASA 275 https://www.smart3d.cz/				
PETG	Plasty Mladec https://www.filament-pm.com/	RC model or static model	Easy printing, minimal distortion (Tower type XXI Print)	wrong grinding, badly holds adhesives and paints (there is also a risk of peeling off the PE deck due to thermal expansion, and poor adhesion of the adhesive.)	use a spray for a smooth surface (BodyFill 360)
	PRUSA https://shop.prusa3d.com/en/				

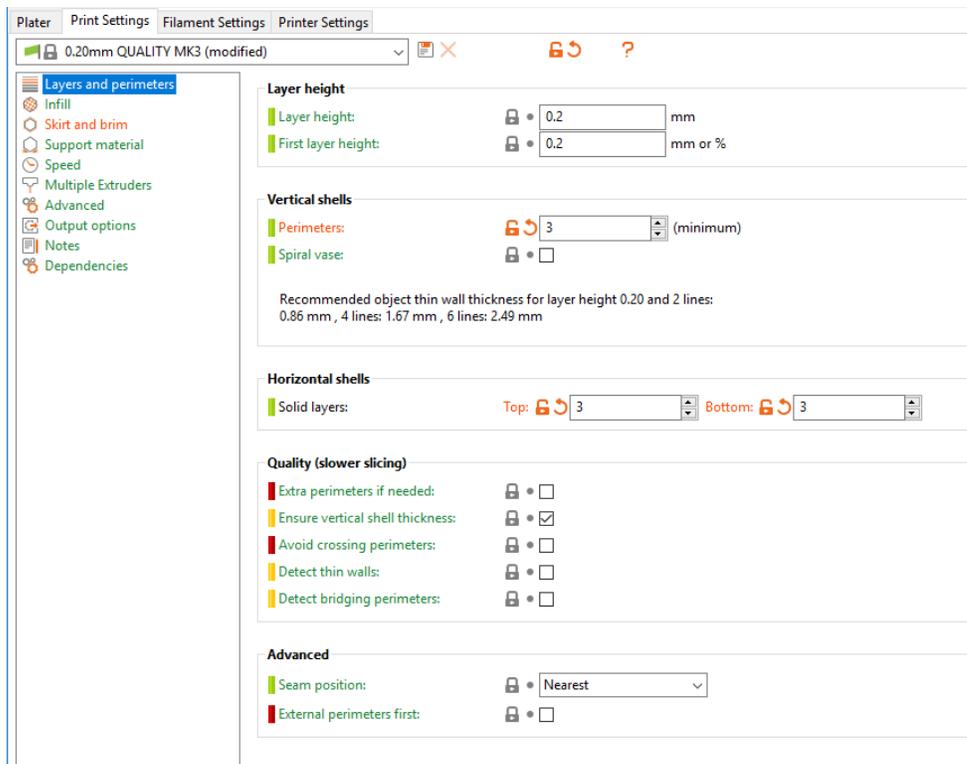
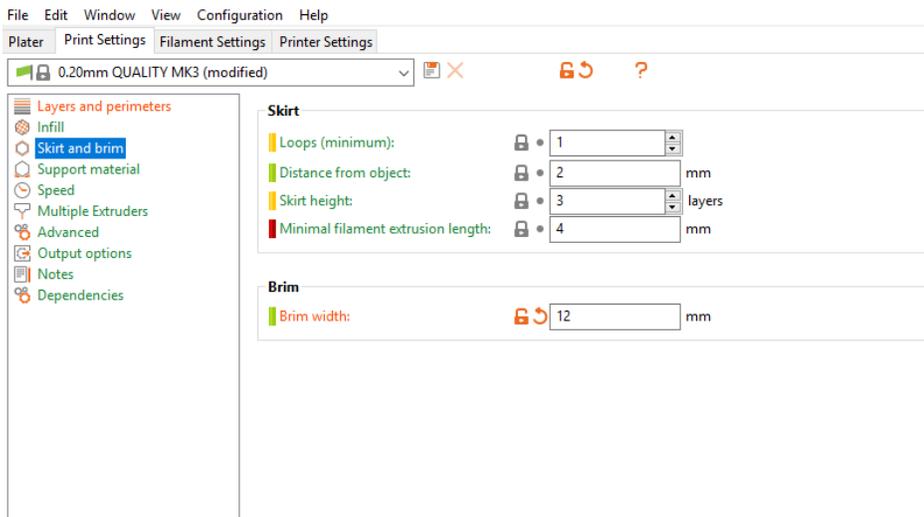
On our website you have the opportunity to download one part of the hull of the submarine and print and test the choice of material.

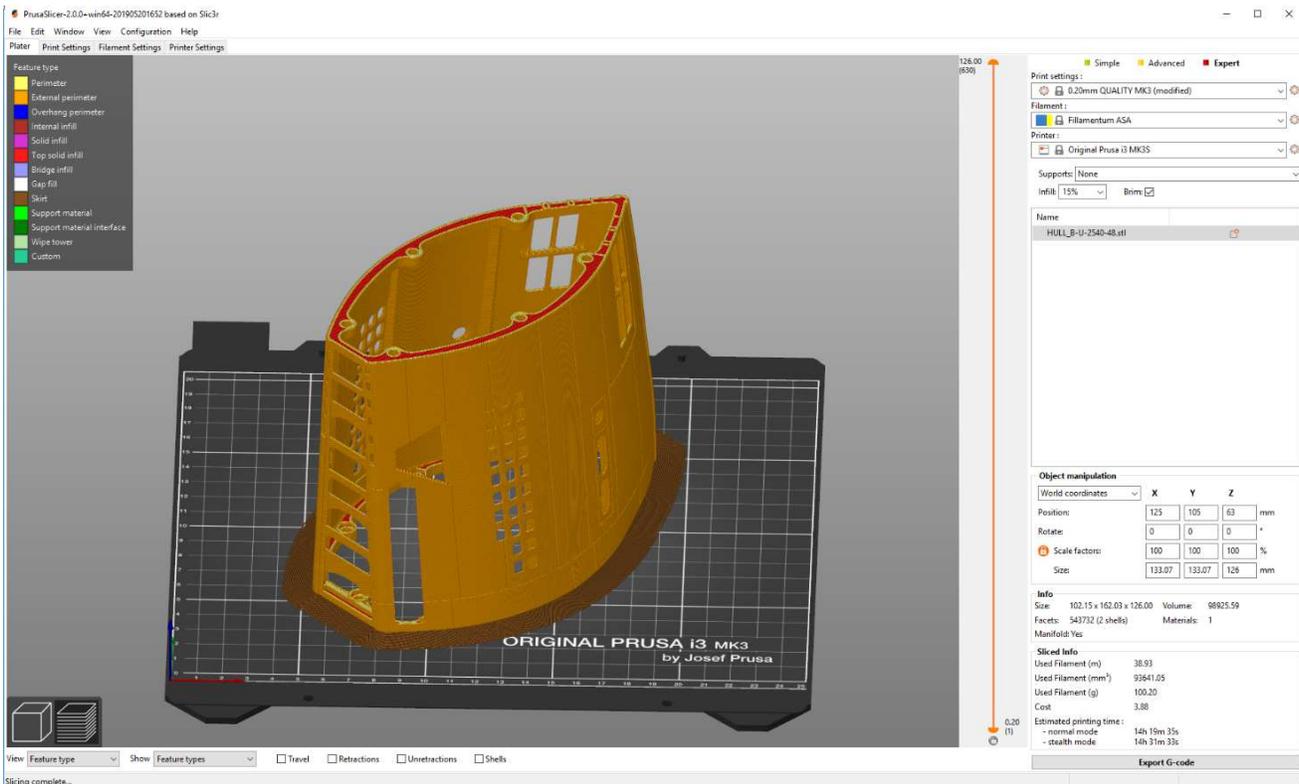
you can also open this STL file on a regular computer and look at the processing quality of the 3D model. If you can't download the 3d model, right-click and open the link in a new tab or write to us and we will send you a sample of the STL submarine 3D model.



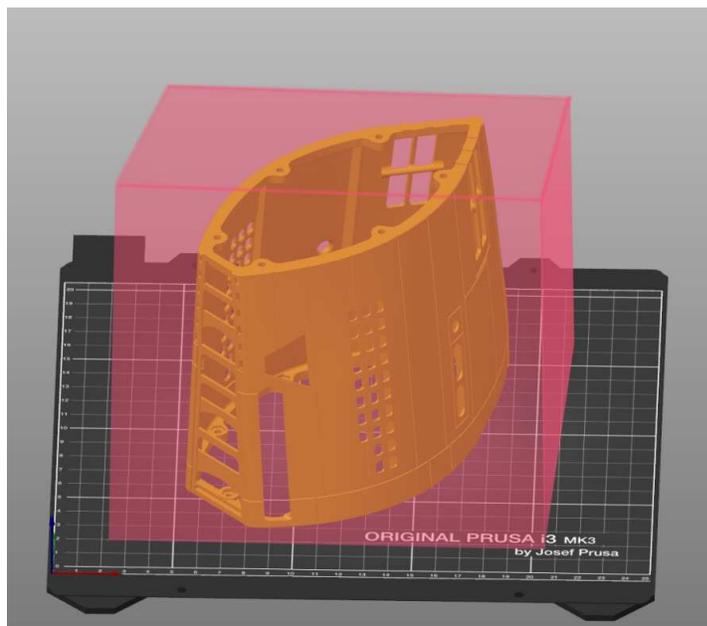
example of ASA printing

Slicer Prusa





After printing, it is recommended to **cover** the part with a box. If the part cools quickly, there is a risk of cracking or twisting.



(materials from different suppliers behave differently.

Some have better print quality and quality, and others may be poor.

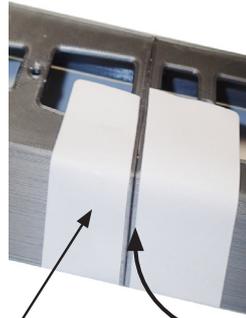
PET-G material here is a problem with the adhesion of glue and brass parts. Therefore, there is a risk of the brass parts peeling off due to thermal expansion and poor adhesion of the adhesive.

PLA material achieves the best print quality and no deformation. But there is a problem that it is not resistant to the sun and also absorbs water.

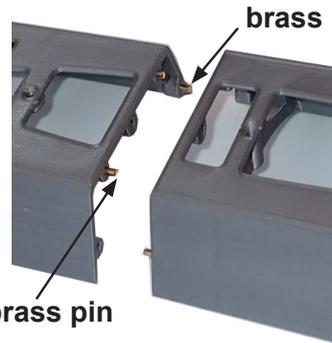
ASA the best choice for a functional model. Brass parts can be well adhered to the material. Paints and glue adhere well to the surface. It is also possible to grind and smooth the surface very well. Resistant to sun and water. There is a problem with printing and there are slight deformations that need to be sealed.

SKU-0204

Products with 3D printing



When melting, use a paper insulator as a protection.



brass pin

brass pin

filament PLA



For good joining of parts, we recommend welding surfaces with solder and PLA filament.

example



For large brass sheets (decks) use flexible mammoth glue. Brass can be glued directly to the rough surface of the 3D print parts. Etched the overlapped parts with an insulator, before painting to BodyFill360.



We recommend using a filler (BodyFill 360) that covers the print lines on the product.

You can then sand the surface with sandpaper for a smooth surface.

If the product is designed for a functional model in water, all surfaces of the product must be colored by the filler.

original surface

surface after use of the filler
BodyFill360

finish



version: black / gray



small etched parts stick
super glue



Do not expose to direct sunlight.

The printing material is PLA. This is the same material as the RC models of aircraft. yet it is not recommended to leave it in the sun.

