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TM3D-08

PROJECT EV-01

INSTRUCTION 1

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Contains small parts and requires high precision. Your printer may need to be properly calibrated for best results. (Tolerances: Peg 0.15mm, Balljoint 0mm, Slide 0.3mm, Screw 0.4mm)



Settings:

Minimum printer size: 200mmX200mmX200mm
Support : NO
Nozzle: 0.4mm
Layer: 0.15mm (0.1 for the head)
Filamen: PLA
Temperature: 200°C
Speed: 40/s
Skin/top/bottom: 0.8mm
Infill: 20%-25% (100% for crew)

Height

Total : 350 mm
Light Blue : 1 Part, 2 grams
White : 54 Parts, 267 grams
Grey : 178 Parts, 185 grams
Red : 18 Parts, 77 grams
Green : 9 Parts, 19 grams
Yellow : 9 Parts, 10 grams
Purple : 26 Parts, 124 grams
Black : 38 Parts, 91 grams
Blue : 9 Parts, 47 grams

Biggest Part:

Highest : 9e_Ev_Rocket5_WHITE [113 mm H]
Longest : 11b_Ev_Katana2_RED [230 mm L, Positioned diagonally]
Volume : 2a_Ev_Chest1_BLUE [68mm L X 43mm W X 50mm H]

Tools: Cutter, Sand Paper, Super Glue, Nail Polish



Tips & Tricks:

Print result isn't smooth enough and parts aren't fit properly:
- Calibrate your printer properly
- Make sure you print it in right temperature
- If you print it too fast, it may cause ghosting on the surface of the object
- Decrease the layer height (0.15mm for small figure and 1 mm for the head/face)

Object won't stick to the print bed:

- Setup your bed leveling properly
- Use brim for small objects which have small contact to the bed
- Increase first layer extrusion to 125%-150%
- If you are using Buildtak, sand the surface using sand paper
- Set the printing speed of the first layer to 20 m/s

How to fix loose ball joint?

- Material Shrinkage: PLA 0.2%, ABS 0.8%
- Use clear nail polish. Use it on both female and male ball joint section or on friction joint surfaces. Wait until it dry before put them back in place
- If the ball joint is loose right after printing, it may cause by under extrusion. Increase filament flow rate by 110% - 125%

Finishing touch

- Use cutter or sand paper for peg adjustment
- Use super glue to assemble the part
- Spray the finishing object using clear coat to protect the object from the weather for long term use.

SCAN ME



Apple Augmented Reality*

*IPADOS or iOS 12.0+



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FILES:

- 1. 0_Ev_ScrewA_BLUE
- 2. 0_Ev_ScrewB_BLACK
- 3. 0_Ev_ScrewC_BLACK
- 4. 0_Ev_ScrewD_PURPLE
- 5. 0_Ev_ScrewE_GREY
- 6. 0_Ev_ScrewF_BLACK
- 7. 0_Ev_ScrewG_WHITE
- 8. 0_Ev_ScrewH_WHITE
- 9. 0_Ev_ScrewI_WHITE
- 10. 0_Ev_ScrewJ_GREY
- 11. 1a_Ev_Head1_WHITE
- 12. 1b_Ev_Head2_RED
- 13. 1c_Ev_Head3_BLACK
- 14. 1d_Ev_Head4_WHITE
- 15. 1e_Ev_Head5_GREY
- 16. 1f_Ev_Head6_GREY
- 17. 1g_Ev_Head7_WHITE
- 18. 1h_Ev_Head8_RED
- 19. 1i_Ev_Head9_RED
- 20. 2a_Ev_Chest1_BLUE
- 21. 2b_Ev_Chest2_BLUE
- 22. 2c_Ev_Chest3_PURPLE
- 23. 2d_Ev_Chest4_YELLOW
- 24. 2e_Ev_Chest5_BLACK
- 25. 2f_Ev_Chest6_RED
- 26. 2g_Ev_Chest7_WHITE
- 27. 2h_Ev_Chest8_WHITE
- 28. 2i_Ev_Chest9_GREY
- 29. 2j_Ev_Chest10_GREY
- 30. 2k_Ev_Chest11_YELLOW
- 31. 2l_Ev_Chest12_LIGHTBLUE
- 32. 2m_Ev_Chest13_BLACK
- 33. 2n_Ev_Chest14_BLACK
- 34. 2o_Ev_Chest15_BLACK
- 35. 2p_Ev_Chest16_BLUE
- 36. 2q_Ev_Chest17_GREY
- 37. 2r_Ev_Chest18_BLACK
- 38. 2s_Ev_Chest19_WHITE
- 39. 2t_Ev_Chest20_BLACK
- 40. 2u_Ev_Chest21_BLACK
- 41. 3a_Ev_Abdomen1_BLACK
- 42. 3b_Ev_Abdomen2_PURPLE
- 43. 3c_Ev_Abdomen3_BLACK
- 44. 3d_Ev_Abdomen4_BLACK
- 45. 3e_Ev_Abdomen5_BLACK
- 46. 3f_Ev_Abdomen6_GREEN
- 47. 3g_Ev_Abdomen7_BLACK
- 48. 4a_Ev_Waist1_PURPLE
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- 51. 4d_Ev_Waist4_WHITE
- 52. 4e_Ev_Waist5_GREY
- 53. 4f_Ev_Waist6_WHITE
- 54. 4g_Ev_Waist7_RED
- 55. 4h_Ev_Waist8_WHITE
- 56. 4i_Ev_Waist9_GREY
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- 69. 5m_Ev_Hand13_GREY
- 70. 5n_Ev_Hand14_GREY
- 71. 5o_Ev_Hand15_WHITE
- 72. 5p_Ev_Hand16_PURPLE
- 73. 5q_Ev_Hand17_WHITE
- 74. 5r_Ev_Hand18FistL_GREY
- 75. 5r_Ev_Hand18FistR_GREY
- 76. 5r_Ev_Hand18FistIndexFinger
- 77. 6a_Ev_Leg1_BLACK
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- 86. 6j_Ev_Leg10_PURPLE
- 87. 6k_Ev_Leg11_PURPLE
- 88. 6l_Ev_Leg12L_WHITE
- 89. 6l_Ev_Leg12R_WHITE
- 90. 6m_Ev_Leg13_GREEN
- 91. 6n_Ev_Leg14_BLACK
- 92. 6o_Ev_Leg15_YELLOW
- 93. 6p_Ev_Leg16_GREY
- 94. 6q_Ev_Leg17_GREY
- 95. 6r_Ev_Leg18_GREY
- 96. 6s_Ev_Leg19_WHITE
- 97. 6t_Ev_Leg20_WHITE
- 98. 6u_Ev_Leg21_RED
- 99. 6v_Ev_Leg22_RED
- 100. 6w_Ev_Leg23_GREY
- 101. 7a_Ev_Shield1_GREY
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- 104. 7d_Ev_Shield4_GREY
- 105. 7e_Ev_Shield5_WHITE
- 106. 7f_Ev_Shield6_WHITE
- 107. 7g_Ev_Shield7_WHITE
- 108. 7h_Ev_Shield8_RED
- 109. 7i_Ev_Shield9_RED
- 110. 7j_Ev_Shield10_YELLOW
- 111. 7k_Ev_Shield11_GREY
- 112. 7l_Ev_Shield12_YELLOW
- 113. 7m_Ev_Shield13_GREY
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- 115. 8b_Ev_Gun2_GREY
- 116. 8c_Ev_Gun3_GREY
- 117. 8d_Ev_Gun4_GREY
- 118. 9a_Ev_Rocket1_GREY
- 119. 9b_Ev_Rocket2_WHITE
- 120. 9c_Ev_Rocket3_GREY
- 121. 9d_Ev_Rocket4_GREY
- 122. 9e_Ev_Rocket5_WHITE
- 123. 9f_Ev_Rocket6_GREY
- 124. 10a_Ev_Sword1_WHITE
- 125. 10b_Ev_Sword2_RED
- 126. 11a_Ev_Katana1_WHITE
- 127. 11b_Ev_Katana2_RED
- 128. 12a_Ev_Knife1_GREY
- 129. ScrewDriver

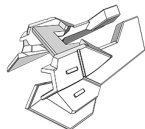


Receive high tension / pressure!
Print these parts at minimum 75% Infill

1f_Ev_Head6_GREY



1d_Ev_Head4_WHITE



2m_Ev_Chest13_BLACK



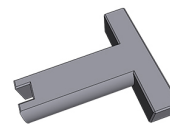
2n_Ev_Chest14_BLACK



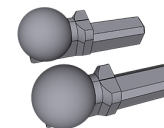
4b_Ev_Waist2_BLACK



Screw driver



6r_Ev_Leg18_GREY



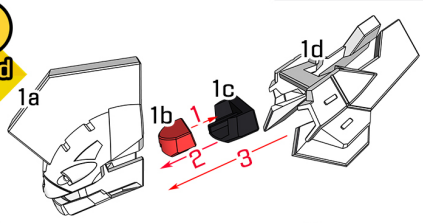


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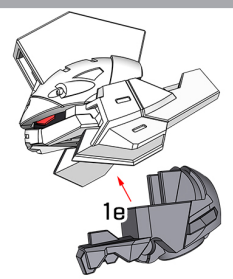
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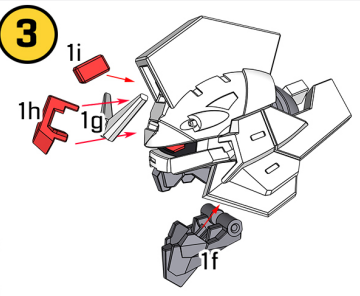
1
Head



2

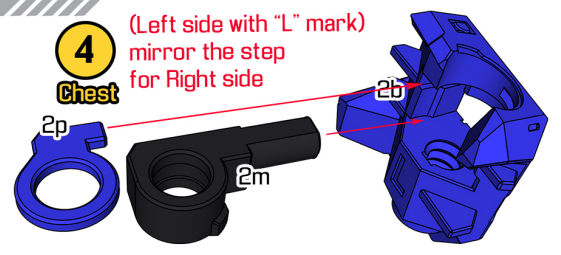


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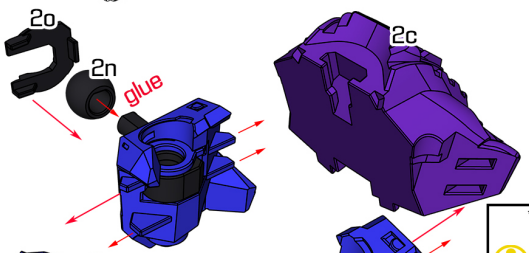


4
Chest

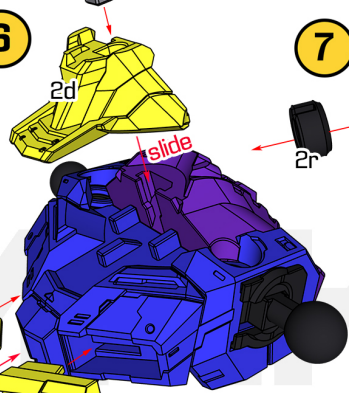
(Left side with "L" mark)
mirror the step
for Right side



5

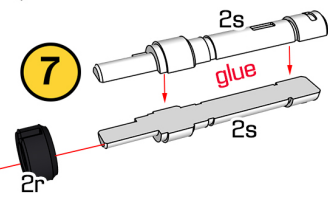


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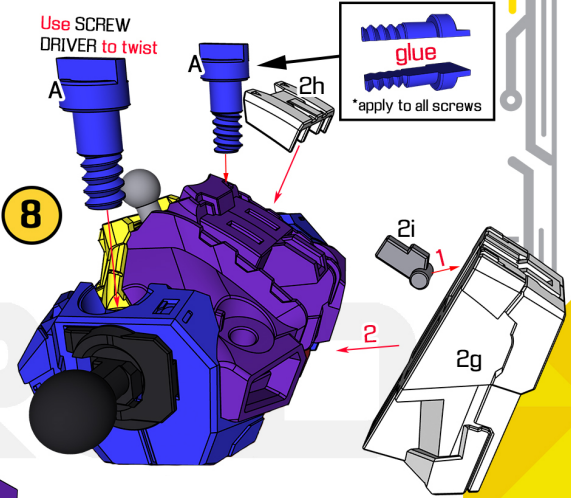


*make sure that the glue is strong enough and not affected by shoulders movement.
Sand 2n with Sand Paper to get maximum smoothness

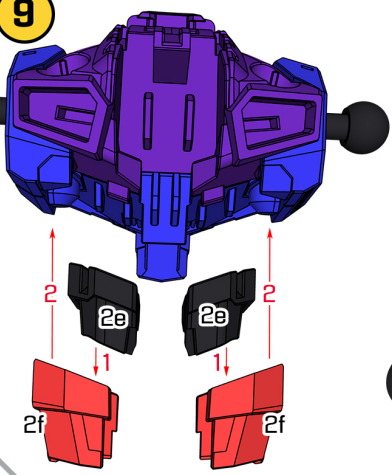
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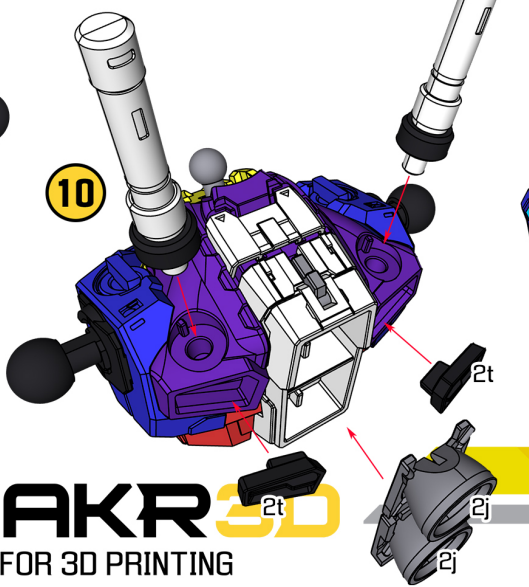
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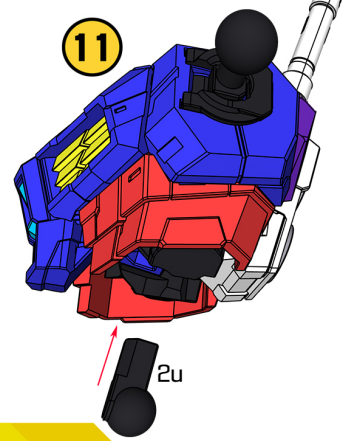
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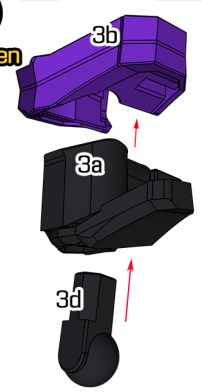
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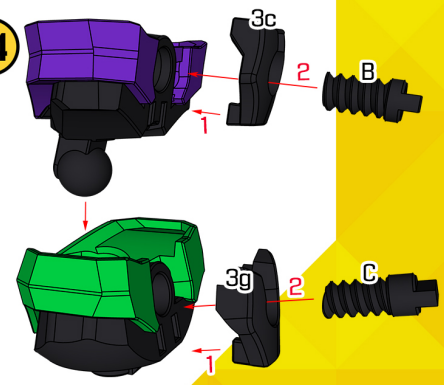
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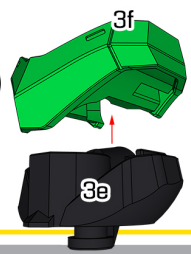
12
Abdomen



14



13





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15 **Waist**

Slide

16

Slide

17

glue

glue*

18

Slide

19

20 **Leg**

(Left leg with "L" mark) mirror the step for Right leg

21

22

23

24 **Thigh**

H

*make sure that the glue is strong enough and not affected by hips movement
Sand 2n with Sand Paper to get maximum smoothness



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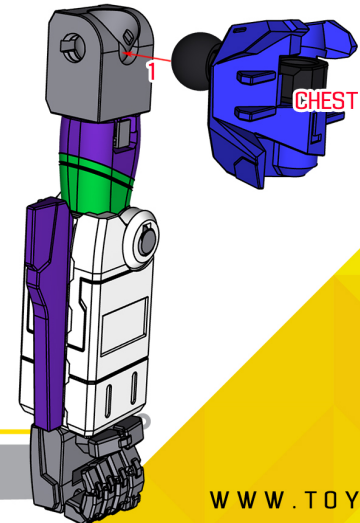
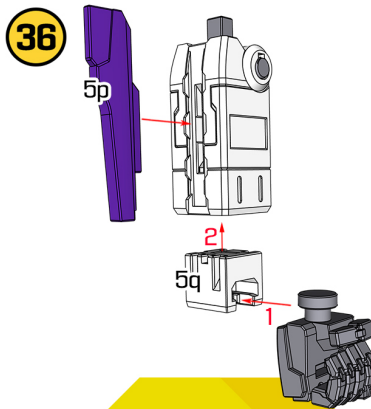
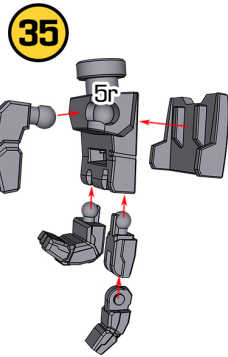
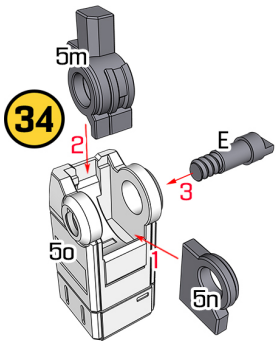
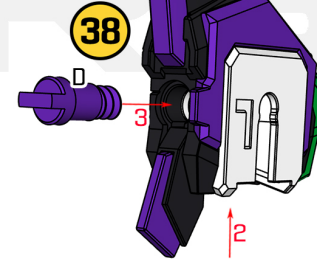
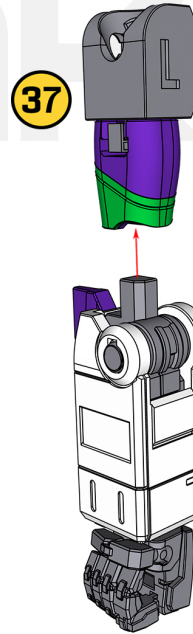
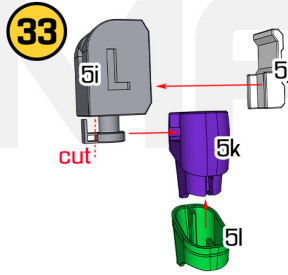
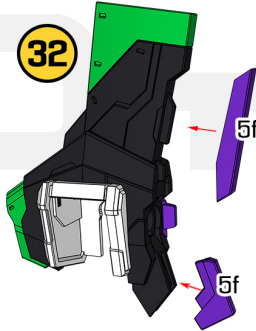
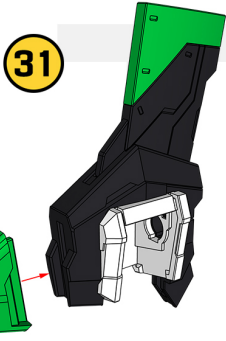
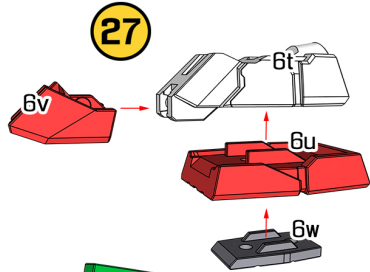
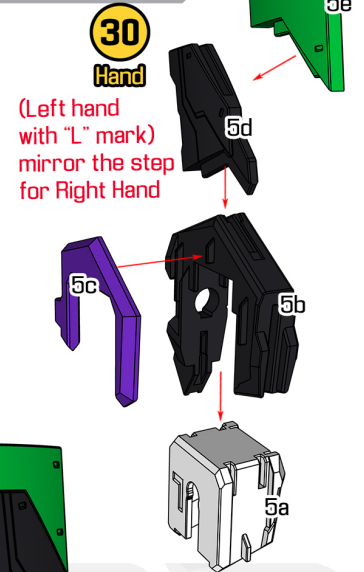
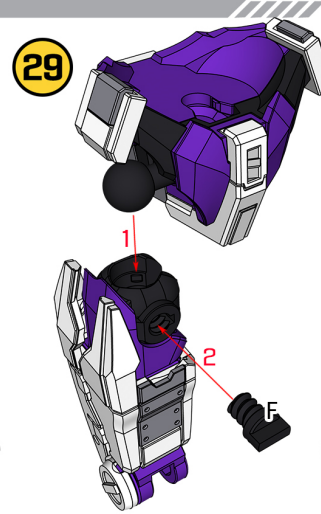
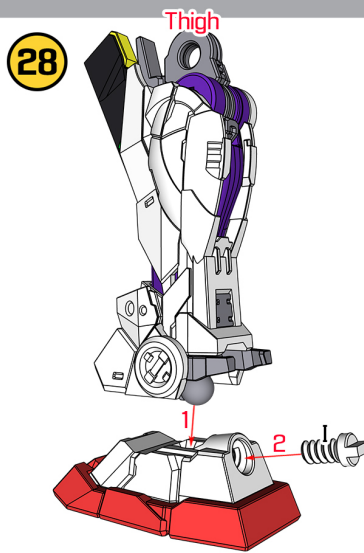
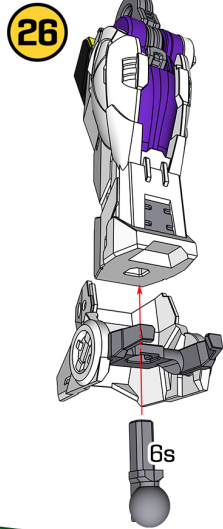
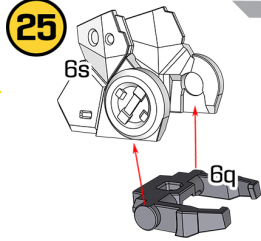
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INSTRUCTION 5

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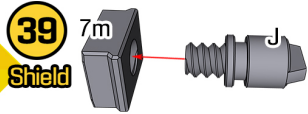




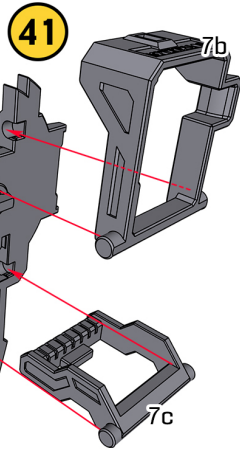
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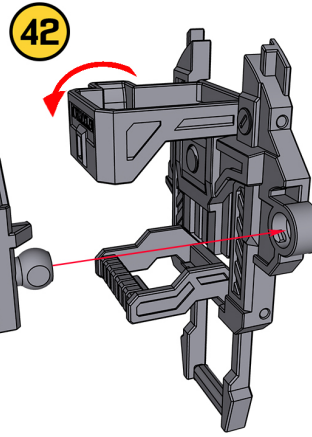
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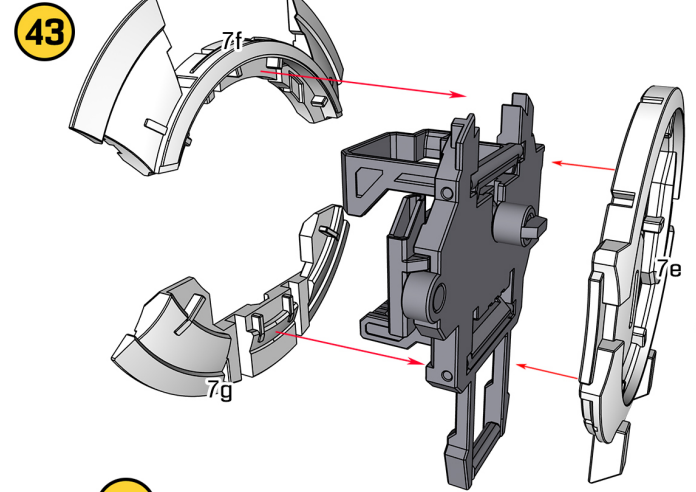
39
Shield



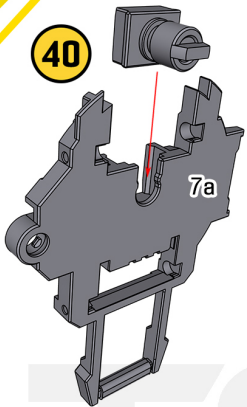
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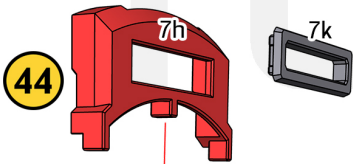
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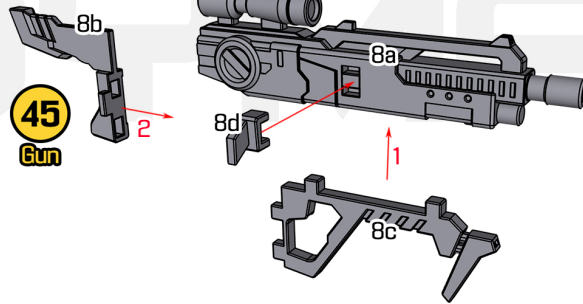
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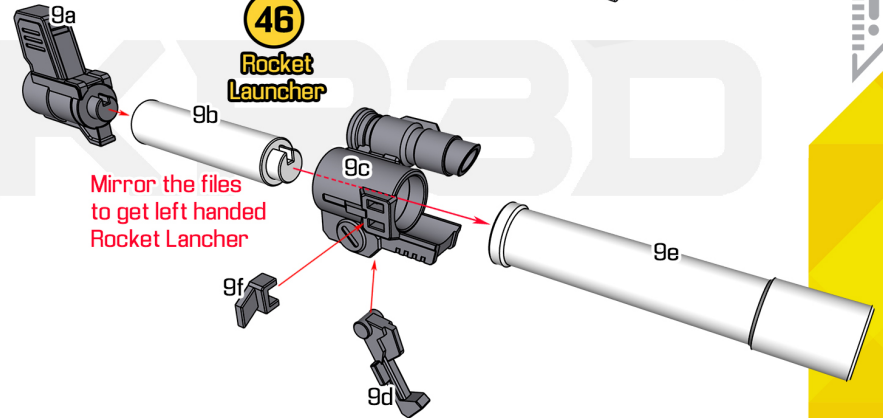
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44

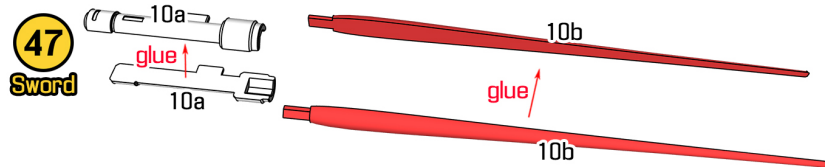


45
Gun

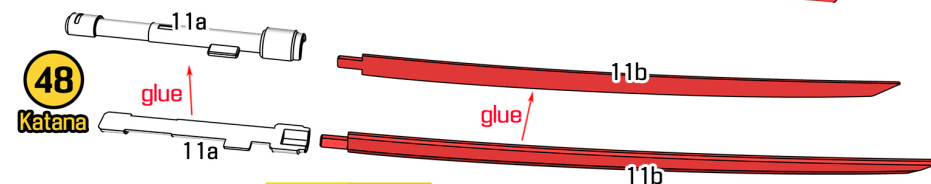


46
Rocket Launcher

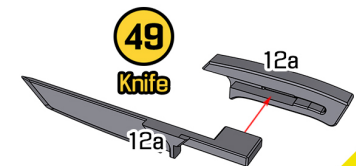
Mirror the files to get left handed Rocket Launcher



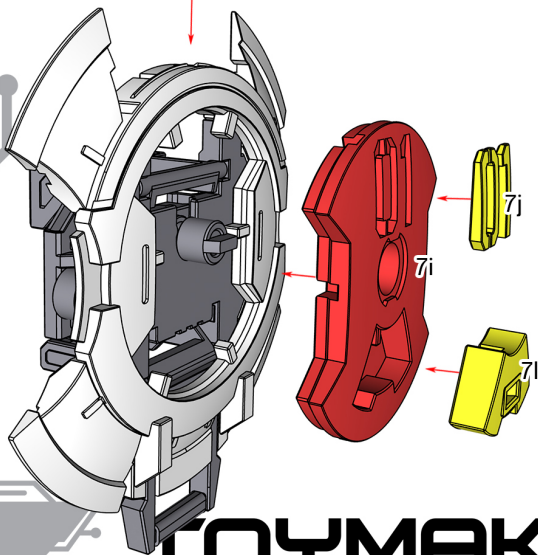
47
Sword



48
Katana



49
Knife





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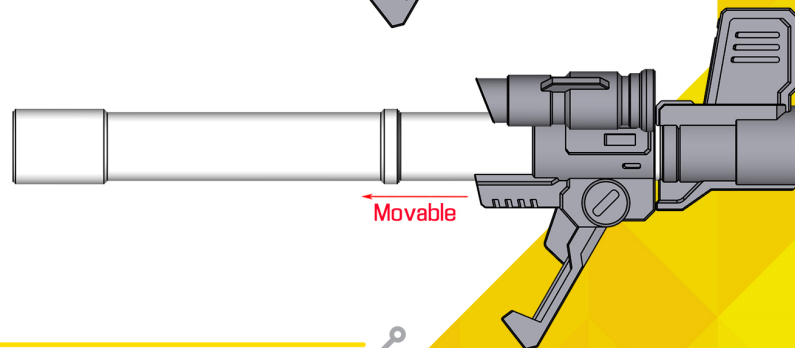
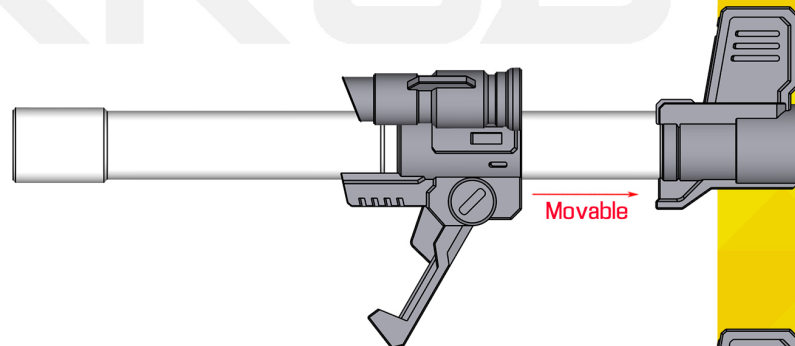
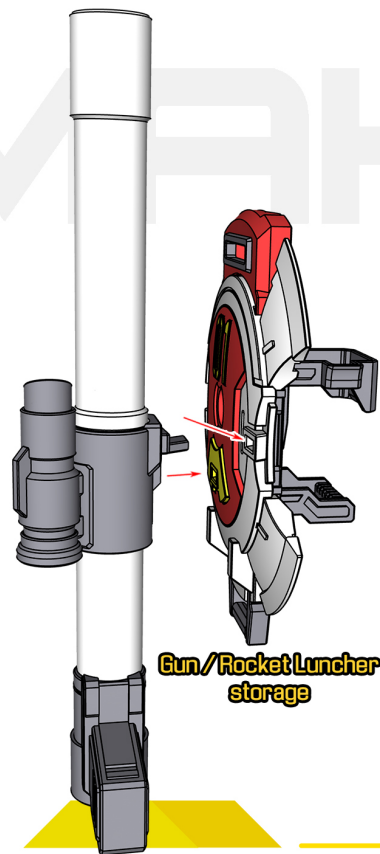
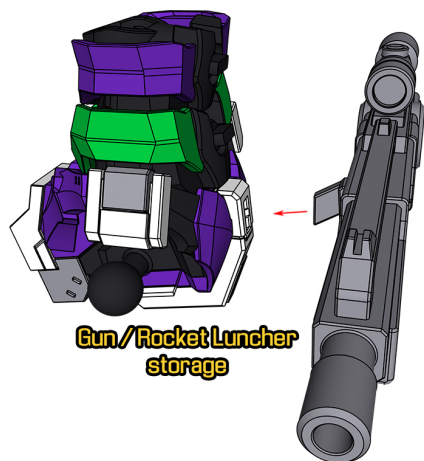
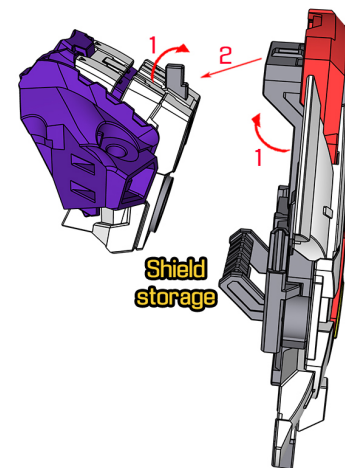
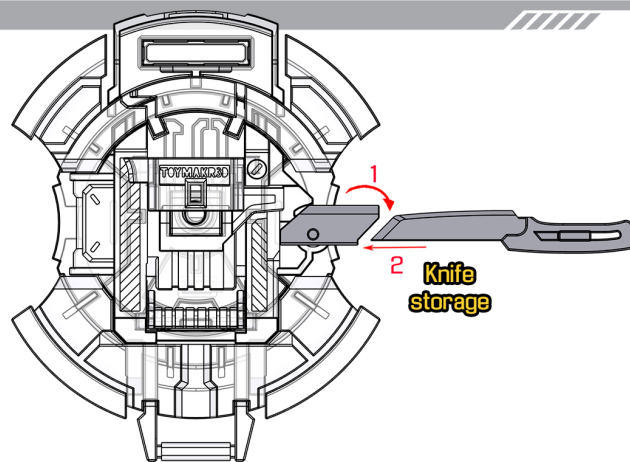
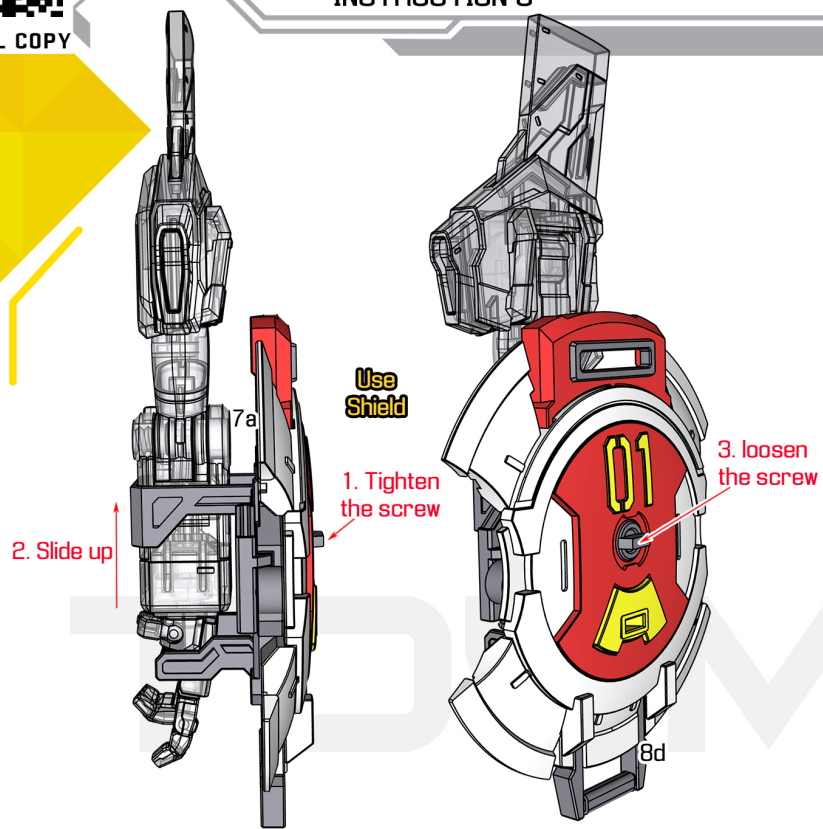
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