# 3D printing

Filament and Resin printing

- Slicers
- AnyCubic Photon Mono X 6K
- Resin
- Easy 3D model posing
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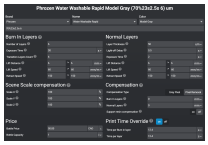
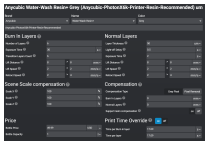
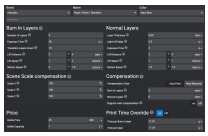
# Slicers

Lychee Slicer

# AnyCubic Photon Mono X 6K

Firmware and RERF file

# Resin

| Brand | Line | Colour | Price | Exposure Settings | Link |
|---|---|---|---|---|---|
| Phrozen | Water Washable Rapid | Model Gray | $45 CAD |  | link |
| AnyCubic | Water-Wash Resin+ | Grey | $41 USD / $47 CAD |  | link |
| AnyCubic | Water-Wash Resin+ | Aqua Blue | $41 USD / $47 CAD |  | link |
| | | | | | link |

# Easy 3D model posing

Human Model Software

Daz3D

Free models

3dcu.com stls

From Model to Print

Blog

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Export the model as an OBJ file keeping the body and hair as separate objects
Import the model into Blender - the hair and body should be separately selectable
Hide the hair temporarily
Select the body and go into point edit mode
Pick any vertex and then use Ctrl-L to select all linked vertices. Now press H to hide these points. This is a really easy way to identify any internal components
Select all of the eyelashes,teeth, gums and tongue and delete them
Keep the front of the eyes but delete the iris, lens and non-visible parts.
Use Alt-H to un-hide any hidden vertices
From the side view, select all the points in the bottom 1-2 mm of the model and scale to zero on the Z axis - this makes a flat base for the model
Now in object mode, hide the body and un-hide the hair
Add a high density icosphere mesh so that it surrounds the hair
Shrink-wrap the sphere around the hair target using the negative projection setting so that all the points move towards the centre until they meet the hair surface
Now delete the hair object and keep the sphere which has taken on the shape of the hair, but in a single closed mesh
Un-hide the body and save the body and hair together as an STL file
Open the STL file in Cura
In the Expert settings, use FixHorrible-Type B - this removes any internal holes and prints much more reliably
Turn on the default support settings
Use Z-lift on retract to stop the nozzle from catching on edges as it travels from area to area
I printed at 0.15 mm resolution with some fairly aggressive cooling from a new fan mounted on the hot-end
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Additional: https://www.daz3d.com/forums/discussion/52354/what-steps-are-needed-to-print-3d-model

# Prints Library

# Artists

Galaad Miniatures