

# 3D printing

Filament and Resin printing

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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		<a href="#">link</a>
AnyCubic	Water-Wash Resin+	Grey	\$41 USD / \$47 CAD		<a href="#">link</a>
AnyCubic	Water-Wash Resin+	Aqua Blue	\$41 USD / \$47 CAD		<a href="#">link</a>
					<a href="#">link</a>

# Easy 3D model posing

Human Model Software

[Daz3D](#)

Free models

[3dcu.com stls](#)

From Model to Print

[Blog](#)

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

Additional: <https://www.daz3d.com/forums/discussion/52354/what-steps-are-needed-to-print-3d-model>

# Prints Library

Prints Library

# Artists

Galaad Miniatures