



PRINTING & PROCESSING GUIDE

V1.4

<https://makerworld.com/@MaKim>

Single or Multi-Color?

Although the model files are prepared for multi-color printing, this won't be the best choice for everyone. You can still achieve a good result even with single color prints.

The following pages provide details about print time and filament usage across device types as well as recommendations for reducing the number of unique filaments needed for the project.



File Locations

Because of the size of this project, I've split it into 3 print profiles.

The order of the plates in the files follows the order of the assembly instructions.

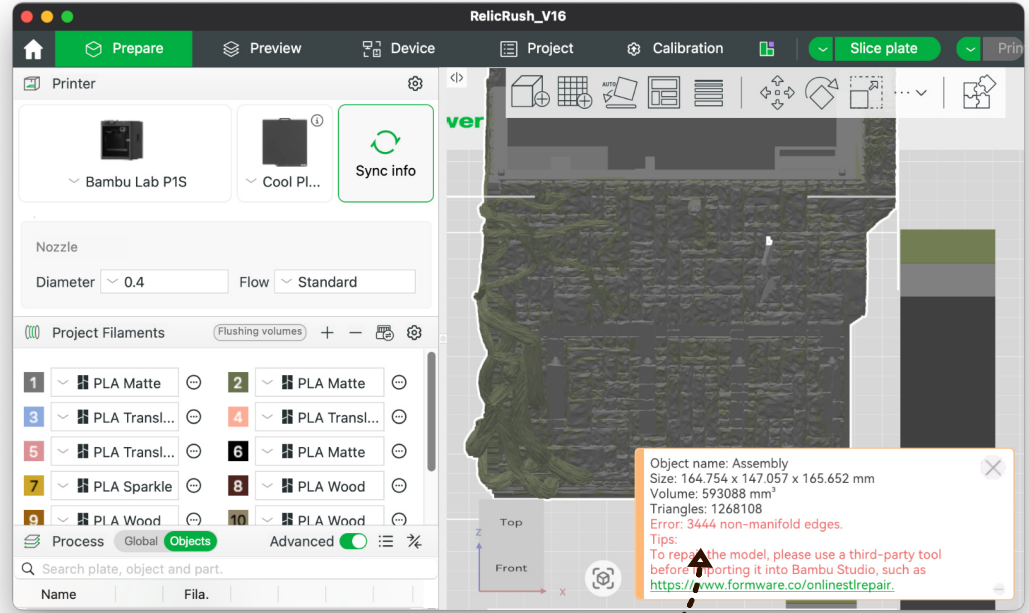


Slicers & Non-Manifold Edges

I have tested and printed these files in Bambu Studio. You'll notice that there are non-manifold edges on some models but these should not cause any issues.

I would not recommend attempting to repair the non-manifold edges as this can cause issues with the manual support painting which could cause your prints to fail.

I have not tested these files in other slicers. You can export STLs from Bambu Studio but pay special attention to custom settings by object along with modifier objects used in the lava objects.



DON'T WORRY ABOUT THIS

Purge Waste

The main parts use two colors which need to change on every layer. It's important to note that the **height** of each part will determine the volume of purge waste.



Taller part = more purge waste



Color Options



If you enjoy **painting** models, choosing this route can save up to 194 hours of print time!

I'm not an expert model painter but these examples show the full model being painted (with darker paint in the cracks and no vines) and also an option printed in gray and painted with green acrylics.

The **fastest** route is to print in a single color without painting. This won't end up looking quite as exciting, though.

Multi-color doesn't require any post-processing and adds a nice texture effect. However, it takes more time and filament and can be wasteful on single-nozzle machines.

Print Times & Filament

These estimates show the total grams of filament and hours required depending on whether you use a single, or multi-nozzle printer.

Want the most detail with the least post-processing?

Print in multi-color but note that for single nozzle printers this will add significant filament usage and print time.

Want to print faster and use less filament?

Print in single colors and paint small areas such as the gold and green.

Want to purchase fewer unique rolls of filament?

Try the 'reduced colors' route which consolidates some similar colors at the expense of detail.

	Multi-Color Multi-Nozzle	Multi-Color Single Nozzle	Reduced Colors Single Nozzle	Single Color Single Nozzle
 PLA Matte - Nardo Gray	2,923g	3,285g	3297g	3,430g
 PLA Matte - Dark Green	1,245g	1,142g	1142g	[paint]
 PLA Translucent - Ice Blue	72g	72g	72g	[use any blue]
 PLA Translucent - Orange	96g	90g	255g	[use any orange]
 PLA Translucent - Red	64g	133g	[use orange]	[use any orange]
 PLA Matte - Charcoal	229g	278g	264g	[use gray]
 PLA Sparkle - Gold	2g	9g	[paint]	[paint]
 PLA Wood - Rosewood	320g	351g	392g	[use any brown]
 PLA Wood - Clay Brown	31g	21g	[use rosewood]	[use any brown]
 PLA Wood - Classic Birch	24g	22g	[use rosewood]	[use any brown]
 PLA Wood - Black Walnut	28g	50g	[use rosewood]	[use any brown]
 TPU 90A - Black	3g	3g	[use gray]	[use gray]

5,038g
270 hours
↑
Most detailed

5,456g
344 hours
↑
Fewer unique rolls

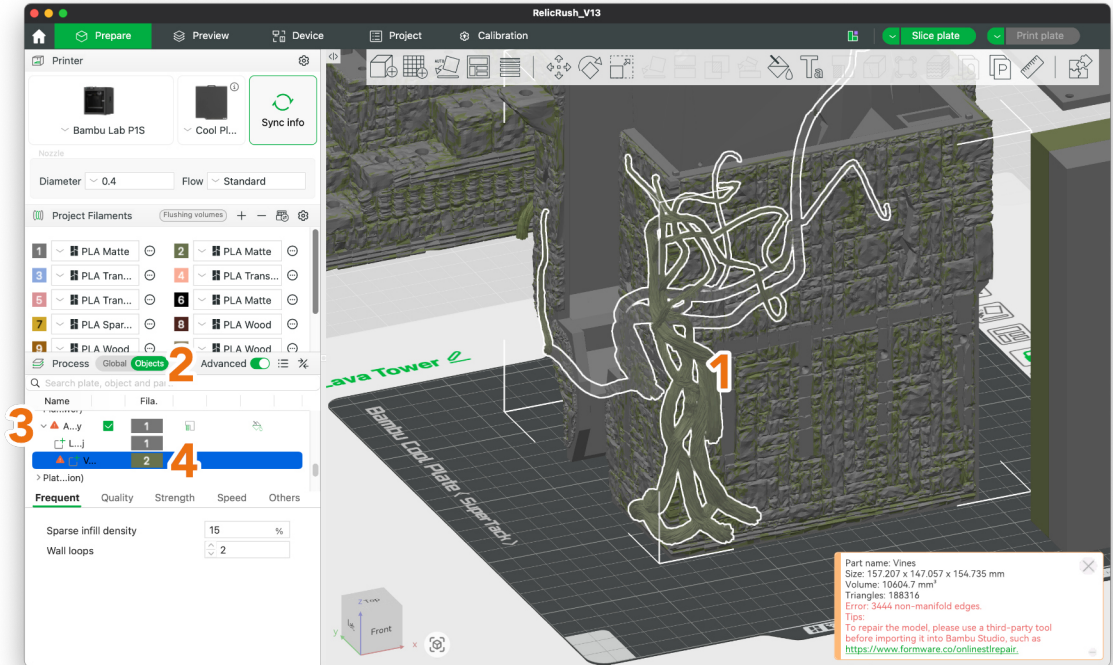
5,421g
338 hours
↑
Fastest print

3,431g
150 hours
↑
Fastest print

Removing the vine details

If you'd like a faster print that uses less filament (but looks a little less fun) you can remove the vine elements before printing.

1. Select the object in Bambu Studio
2. Open the Objects panel
3. Open the disclosure triangle
4. Select the green layer
5. Press delete on your keyboard



Bed Adhesion for River and Lava Belts

The River and Lava belts in particular can be challenging to print due to their small surface details (which print face down). In testing, I've printed these many times and have learned:

- It's essential to have a clean build plate.
- Drying your filament can improve success rates. Even if you're using PLA, I've found that translucent filaments can be sensitive to moisture.
- Smooth or Supertack plates provide the best surface since the visible side of the belts print 'down'.
- I've had the best luck for adhesion with Supertack plates.
- Be sure to watch the first few layers and look for any tiny bits that haven't adhered. It's better to stop the print and re-start vs. letting it run and cause issues with nearby parts.
- 0.4 is the intended nozzle size but 0.2 may have more chance of success if you're having issues. However, this will result in slightly looser belts.
- Although I recommend PLA, I have also printed these in PETG.
- Thanks to **Mimi Home Decoration** for this tip and image: if your parts are sticking, try using a sharp blade between the slats of the lava to break the connection.



Pip Colors

In the photos on the project page, I used green matte PLA for the pips in the game board. I like how this looks but it can be challenging for accessibility and new players. You can print the pips in any color you'd like - including ones that are much higher contrast. Here are a few examples for consideration:

1. PLA Wood - Classic Birch
2. PLA Matte - Desert Tan
3. PLA Sparkle - Gold
4. PLA Wood - Clay Brown

