

# Dragonscale Controller Cover

## 3D MODEL DESCRIPTION

Unleash the beast in your game.

- This STL file is recommended for **FDM** Printers!
- 3D Printing Time Based on **Ender 3: PS5** - **16 Hours, 39 Minutes** (will vary accord to you printer model)  
**XBOX** - **17 Hours, 45 Minutes** (will vary accord to you printer model)
- **Approximately Length: 17x10 cm**

## 3D PRINT FILE SETTINGS (FOR 0.4 MM NOZZLE)

- **Line Width/ Nozzle:** 0.4 mm
- **First Layer Line Width:** 0.48 mm / 120%
- **Average Speed:** 20mm/s (First Layer) / 50mm/s (All the other layers) | 20 mm/s (First Layer) / 500 mm/s (All the other layers on Bambu Lab)
- **Recommended Initial Layer Height:** 0.16 mm
- **Recommended Layer Height:** 0.16 mm
- **Recommended Perimeters/ Walls:** 3.
- **Recommended Infill (%):** None
- **Needs Support:** Yes. (Tree Support) you can adapt them according to your preferences.
- **Build Plate Adhesion:** Brim.

The parameters above are recommendations made by our staff; if you prefer, you can adapt them according to your preferences.

*Happy Printing!*



## Final finishing steps



Use a pair of needle-nose pliers to remove the supports. Be very careful not to damage the thinner areas.



if your slicing profile is not totally accurate, it may cause some overhang due to filament expansion on the support tree mode. You may trim the excesses with a scalpel for better finishing results.



This will ensure a more precise fit in your print.