

Jeep Wrangler Sahara



Printing and assembly instructions

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Printing Instructions

READ CAREFULLY

Two options are available for printing this model:

1. Use the preassembled printing kits (sprues) and follow this guide (13-step printing process). This method is ideal for simplified and optimized printing.
2. Print each part individually (65 parts in total to print, including multiple copies of certain parts) and adjust settings as needed according to your preferences and equipment constraints.

Download the JeepWrangler_AllFiles.zip to access and print each individual part.

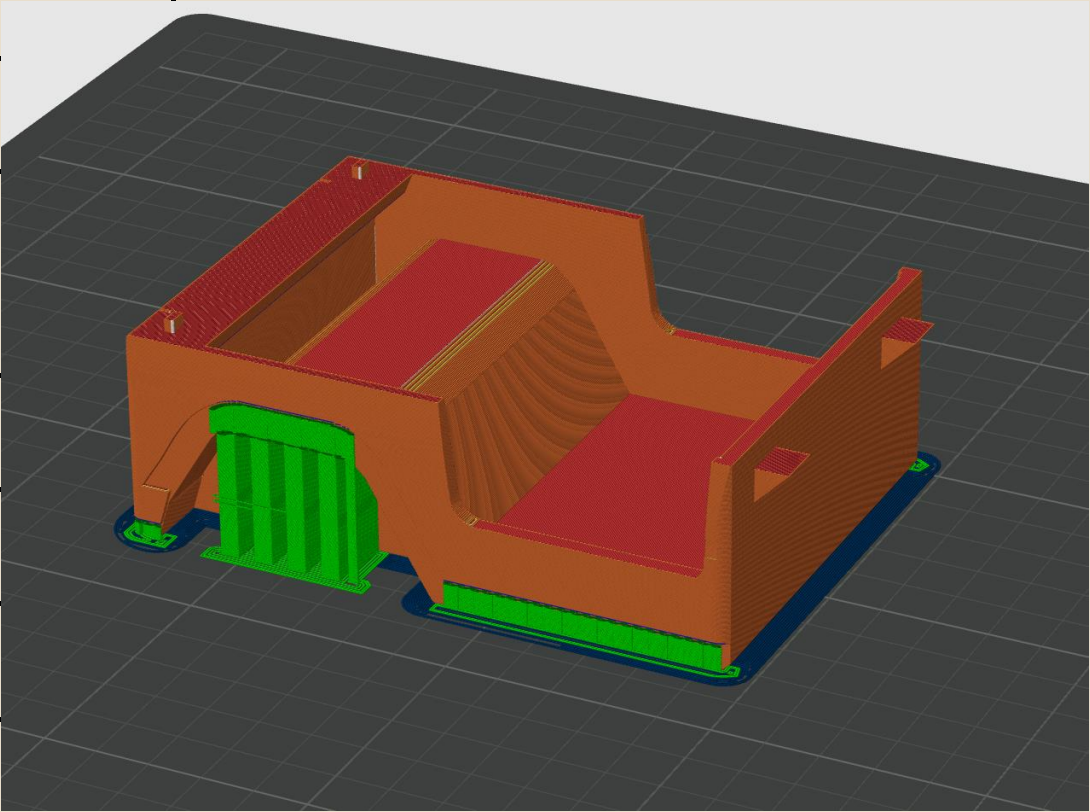
To locate a part, follow the following structure :

structure : <folder>/<part name>

Example : Chassis/BaseFrame — The file is in the “Chassis” folder, and “BaseFrame” is the filename (.stl or .3mf).

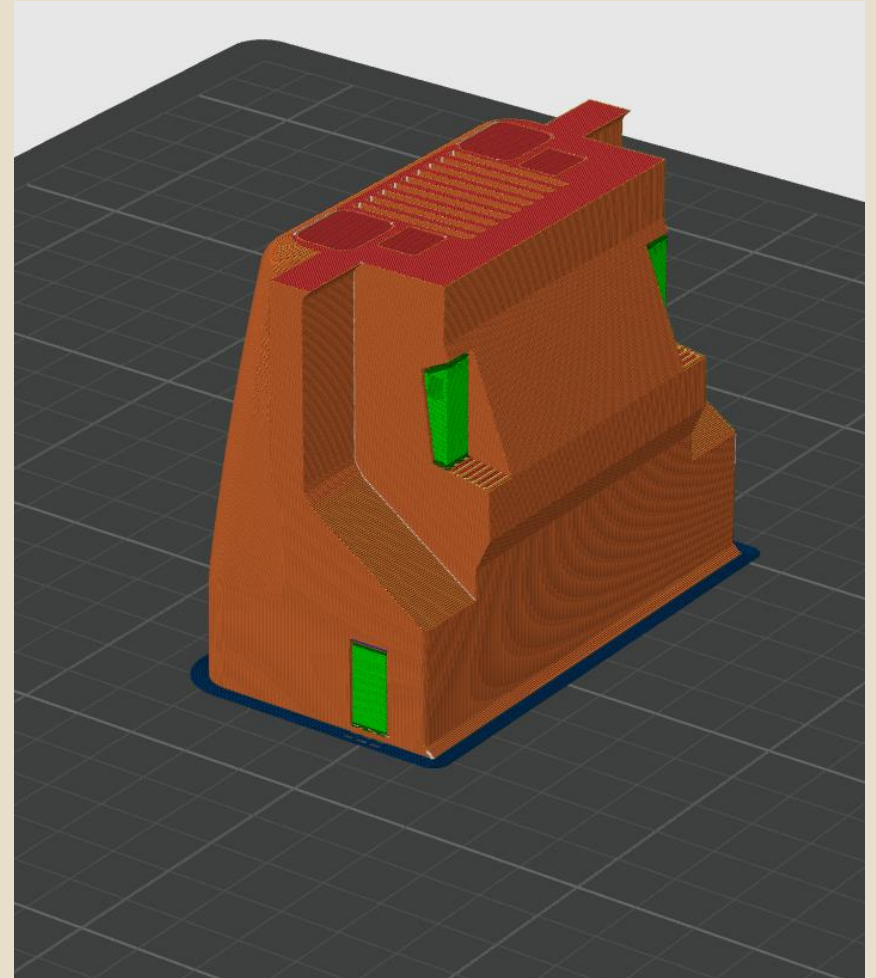
1. Print Chassis/BaseFrame

Setting	Recommanded Value
Filament	Standard PLA
Infill	15%-20%
Support	Normal (Snug) 15-20% density 2 Top Interface layers
Speed	70 mm/s max
Brim	Minimum 6 mm
Cooling	no



2. Print Hood/Hood_NoEngine

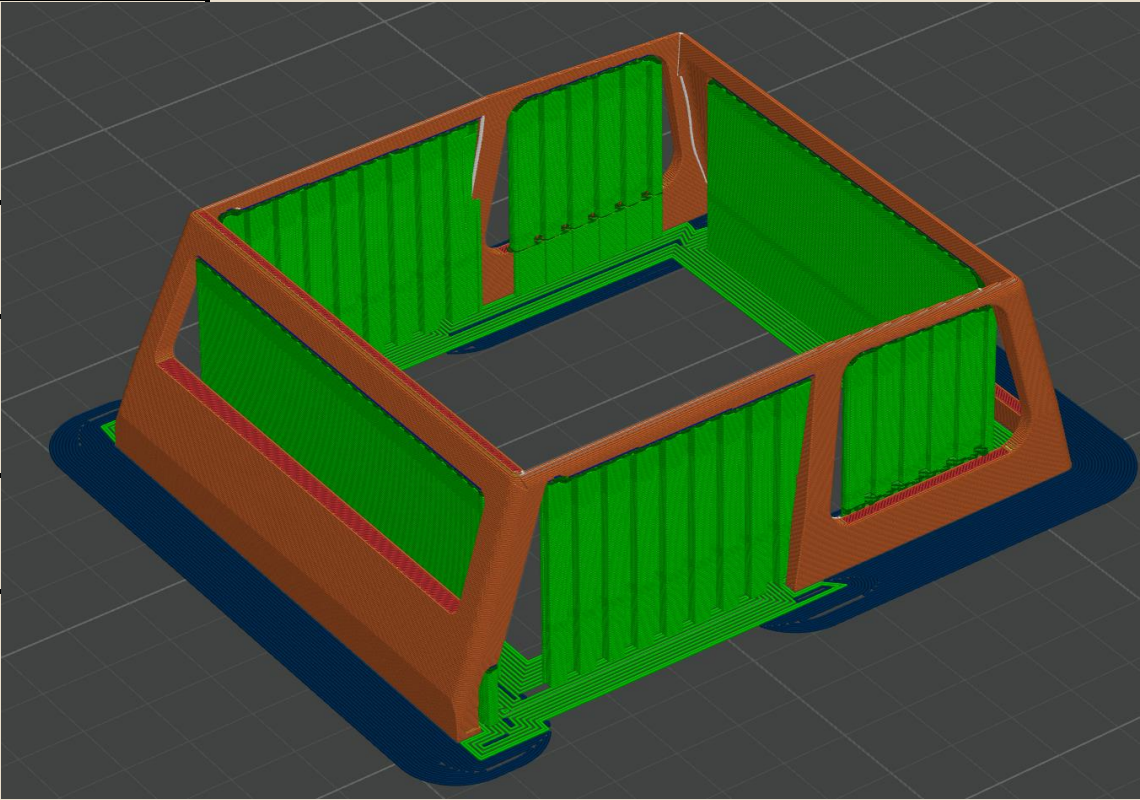
Setting	Recommended Value
Filament	Standard PLA
Infill	15%-20%
Support	Normal (Snug) 15-20% density 2 Top Interface layers
Speed	70 mm/s max
Brim	Minimum 6 mm
Cooling	no



3. Print Chassis/TopFrame

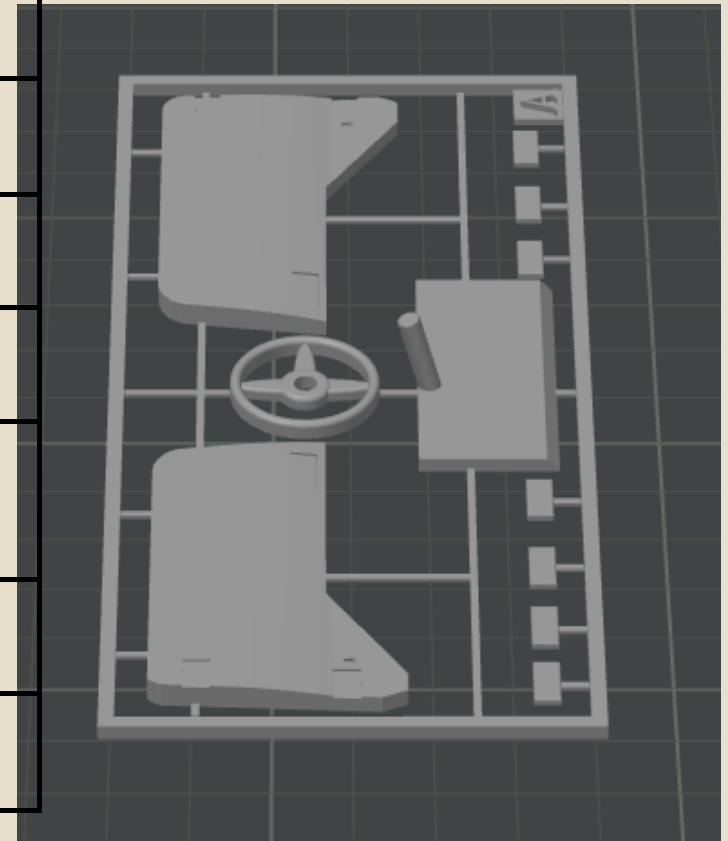
Setting	Recommanded Value
Filament	Standard PLA
Infill	100%
Support	Normal (Snug) 60% density 2 Top Interface layers
Speed	30 mm/s max
Brim	Minimum 9mm Outter and Inner
Cooling	no

NOTE : Carefully remove any remaining support material, then gently sand all the bars to ensure a smooth finish.




4. Print _PartsSprues/WranglerKits_Doors_A

Setting	Recommanded Value
Filament	Standard PLA
Infill	100%
Support	No
Speed	40 mm/s max Use low speed for Acceleration and Travel : 1000 mm/s
Brim	Minimum 6 mm
Cooling	no



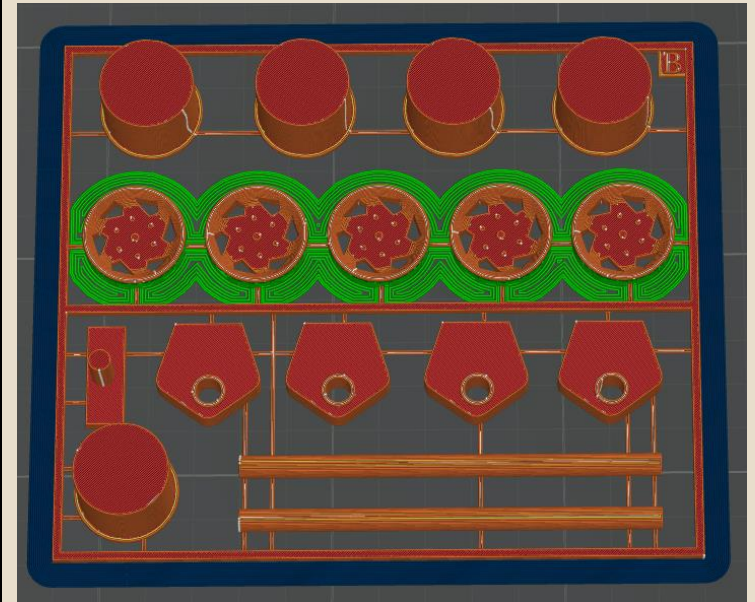
NOTE : A specific part is also available for printing the doors vertically, which results in a finish that better matches the chassis.

 **File name:** *Chassis/Doors_PrintVertically*

5. Print _PartsSprues/WranglerKits_Wheels_B

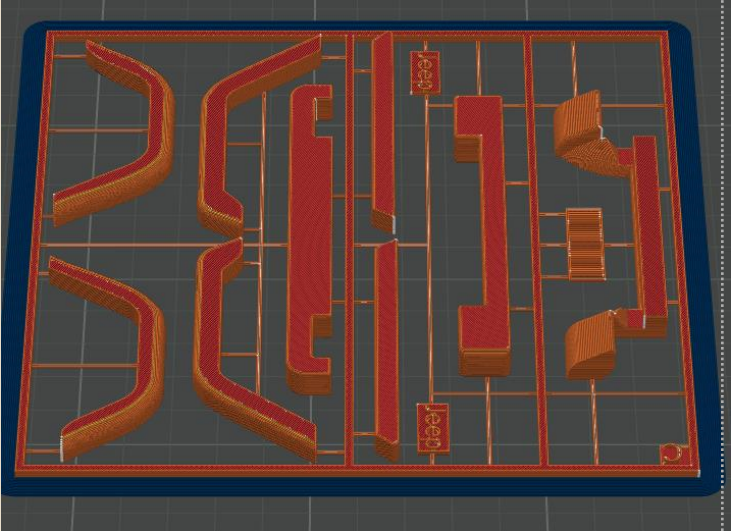
Setting	Recommended Value
Filament	Standard PLA Recommended color : Silk Silver
Infill	100%
Support	Recommended for Hubcaps
Speed	40 mm/s max Use low speed for Acceleration and Travel : 1000 mm/s
Brim	Minimum 6 mm
Cooling	no

NOTE : Make sure both axles are perfectly straight and well-printed.
Sand them to ensure a smooth finish, and check that the ends maintain a precise 90-degree angle.



6. Print _PartsSprues/WranglerKits_Boards_C

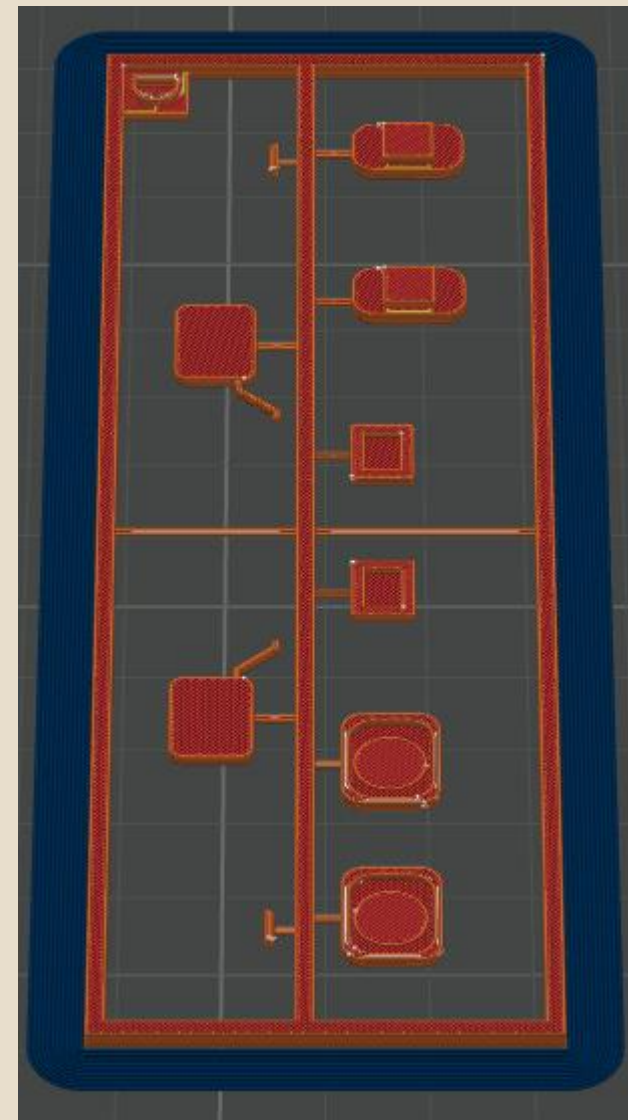
Setting	Recommended Value
Filament	Standard PLA Recommended color : Black
Infill	100%
Support	No
Speed	40 mm/s max Use low speed for Acceleration and Travel : 1000 mm/s
Brim	Minimum 6 mm
Cooling	no



7. Print _PartsSprues/WranglerKits_Lights_D

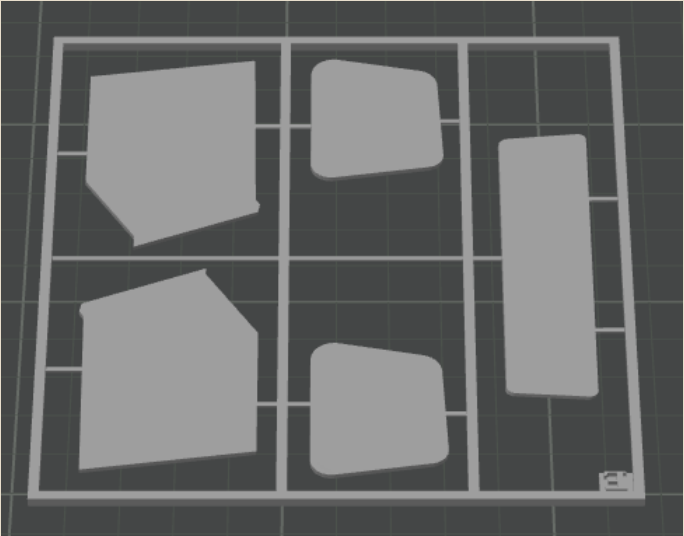
Setting	Recommended Value
Filament	Standard PLA Recommended color : Transparent PLA or PETG
Infill	100%
Support	No
Speed	40 mm/s max Use low speed for Acceleration and Travel : 1000 mm/s
Brim	Minimum 6 mm
Cooling	no

NOTE : To achieve a realistic effect, paint the back of the lights white (2 coats), followed by black. Then, paint the front of the light with the desired color. Use clear paint for the best result.



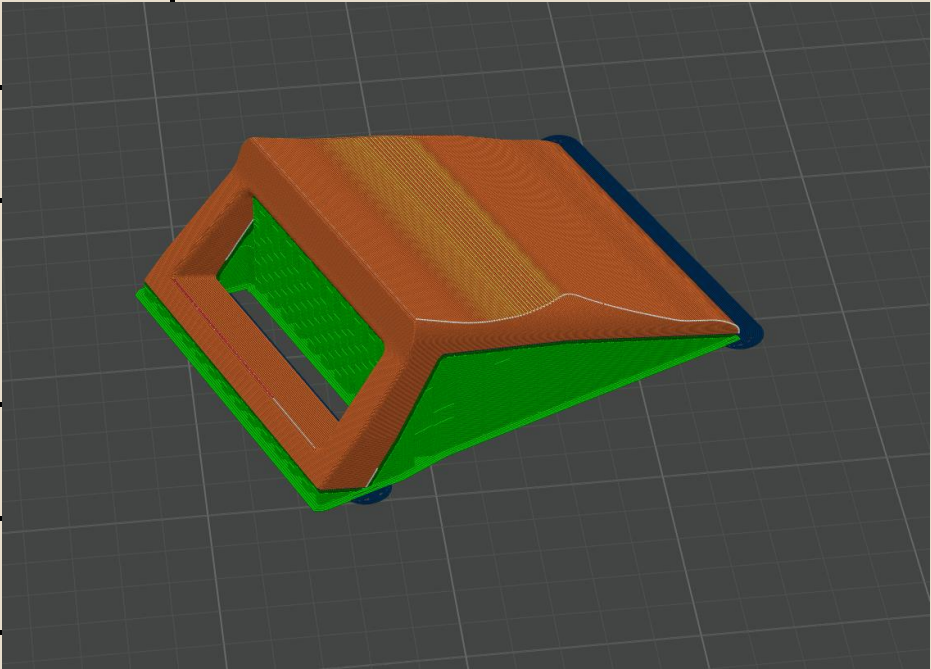
8. Print **_PartsSprues/WranglerKits_Glasses_E** (OPTIONNAL)

Setting	Recommanded Value
Filament	Standard PLA or PETG Recommanded color : Transparent PETG
Infill	100% Use 0.8mm Nozzle Print only 1 Layer at max temperature
Support	No
Speed	40 mm/s max Use low speed for Acceleration and Travel : 1000 mm/s
Brim	Minimum 6 mm
Cooling	no



9. Print **Accessories/RetractableRoof**

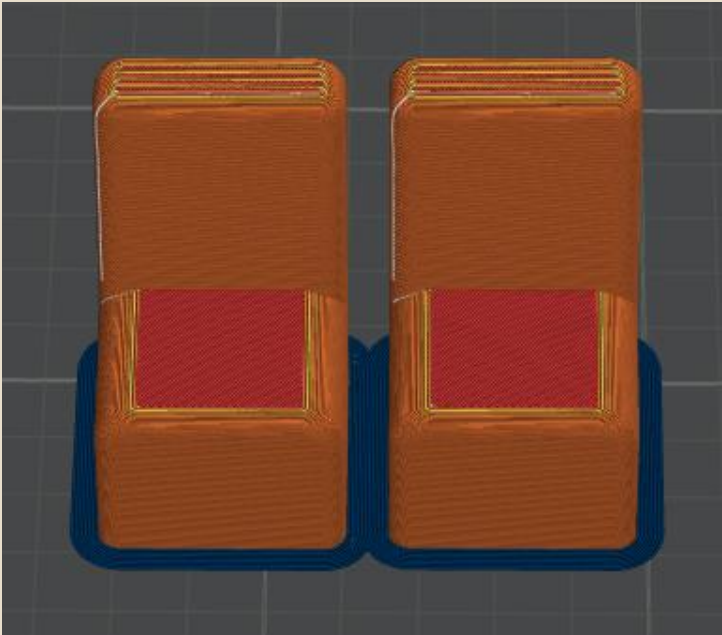
Setting	Recommanded Value
Filament	Standard PLA
Infill	15%-20%
Support	Normal (Snug) 15-20% density 2 Top Interface layers
Speed	70 mm/s max
Brim	Minimum 6 mm
Cooling	no



NOTE : Carefully remove any remaining support material, then gently sand the uprights that support the sunroof to ensure a smooth finish

10.Print Accessories/Seat

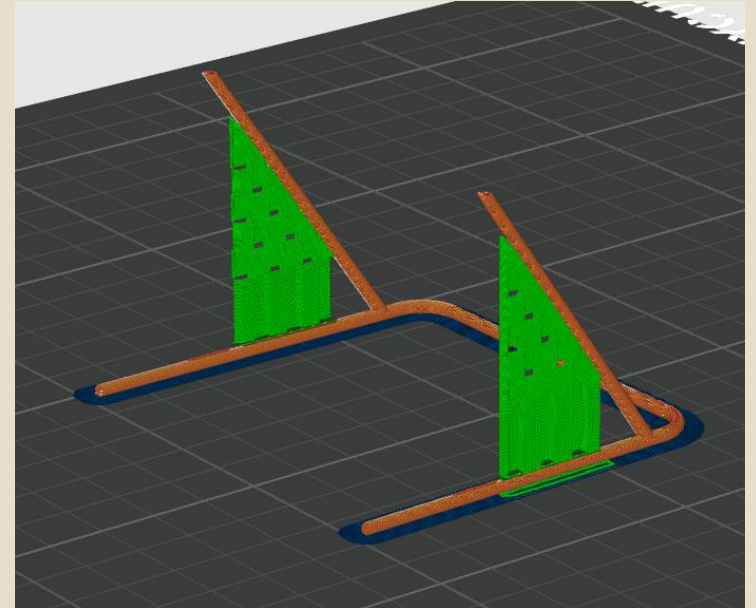
Setting	Recommanded Value
Filament	Standard PLA
Infill	100%
Support	No
Speed	90 mm/s max
Brim	Minimum 6 mm
Cooling	no



11.Print Accessories/RollBar

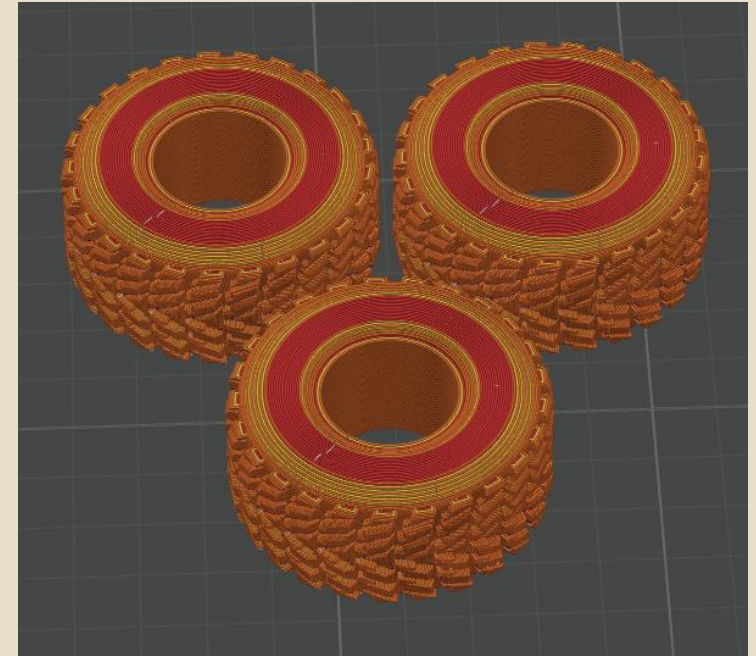
Setting	Recommended Value
Filament	Standard PLA Recommended color : Silk Silver
Infill	100%
Support	Normal (Snug) 40% density 2 Top Interface layers
Speed	30 mm/s max Use low speed for Acceleration and Travel : 1000 mm/s
Brim	Minimum 6 mm
Cooling	no

**NOTE : Carefully remove any remaining support material,
then gently sand all the bars to ensure a smooth finish.**



12.Print Accessories/Tires/PassengerSideTire (x3)

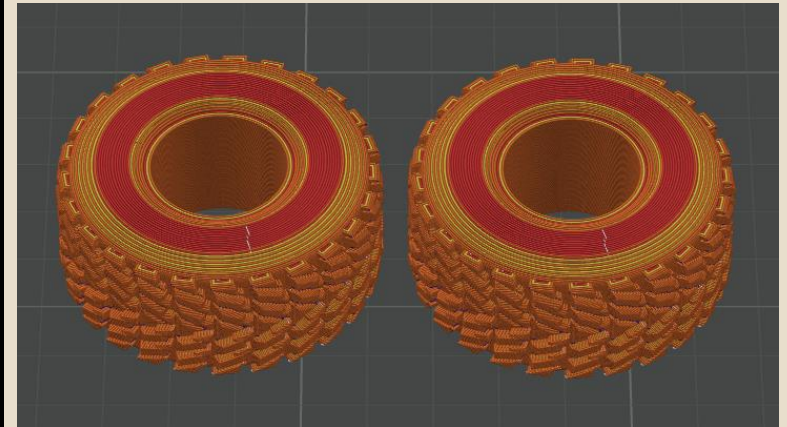
Setting	Recommanded Value
Filament	TPU at max temperature Recommanded color : Black TPU
Infill	40% - Use Gyroid Infill Pattern Use Concentric Top Surface Pattern Use Rectilinear Bottom Surface Pattern
Support	No
Speed	50 mm/s max
Brim	NO BRIM
Cooling	40%



**NOTE : Tires are directional. Make sure to print the appropriate tire model for each wheel.
The third tire printed here is the spare tire.**

13.Print Accessories/Tires/DriverSideTire (x2)

Setting	Recommanded Value
Filament	TPU at max temperature Recommanded color : Black TPU
Infill	40% - Use Gyroid Infill Pattern Use Concentric Top Surface Pattern Use Rectilinear Bottom Surface Pattern
Support	No
Speed	50 mm/s max
Brim	NO BRIM
Cooling	40%



NOTE : Tires are directional. Make sure to print the appropriate tire model for each wheel.

Assembly Instructions

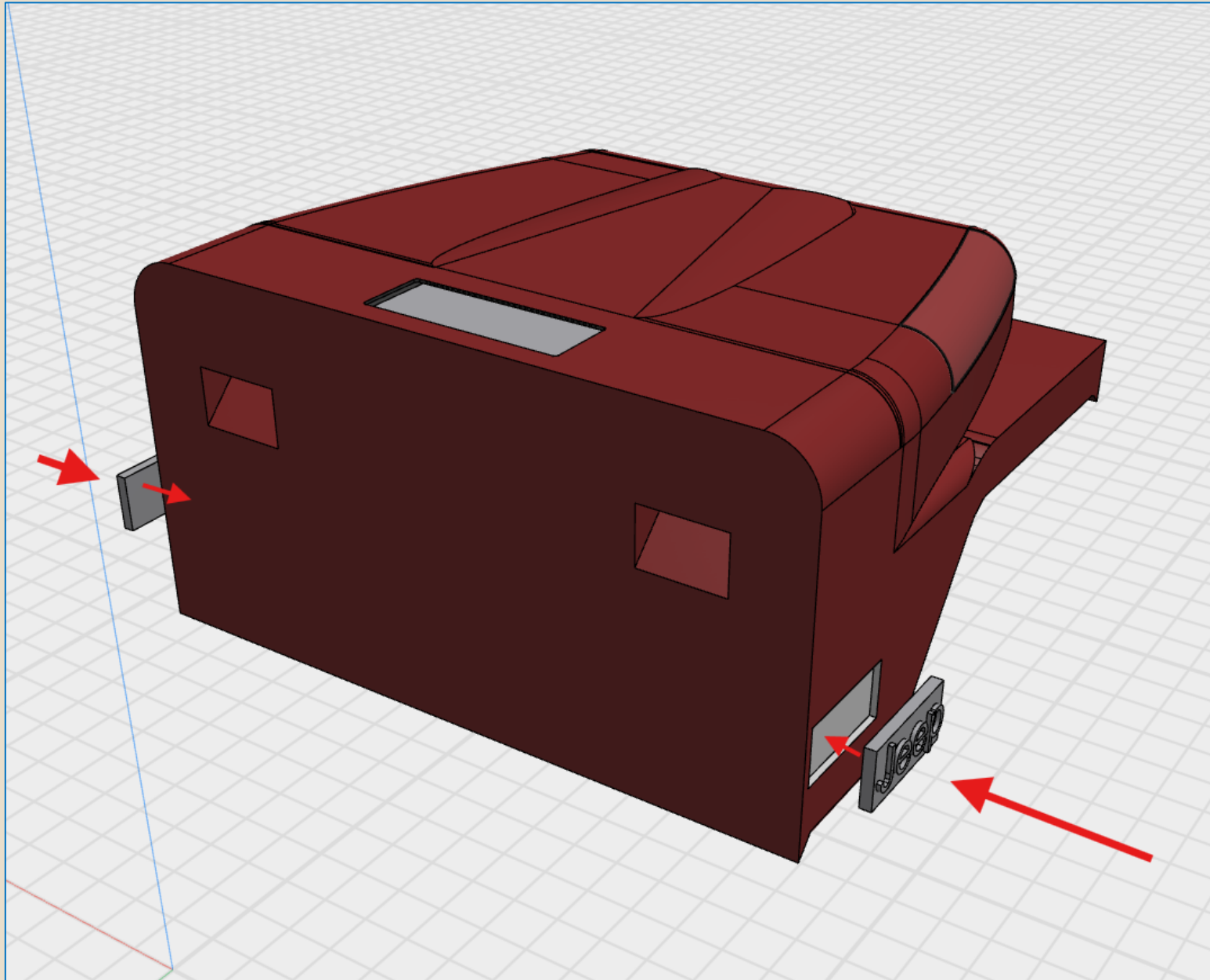
READ CAREFULLY

1. For optimal results, detach all pieces from the sprue using a model kit sprue cutter. Then, carefully sand away any remaining sprue residue for a smooth finish;
2. If desired, paint each part while it's still attached to the sprue for better stability and a more uniform finish.
3. Glue : Lepage **GEL** Multi-Surface Adhesive Recommended;

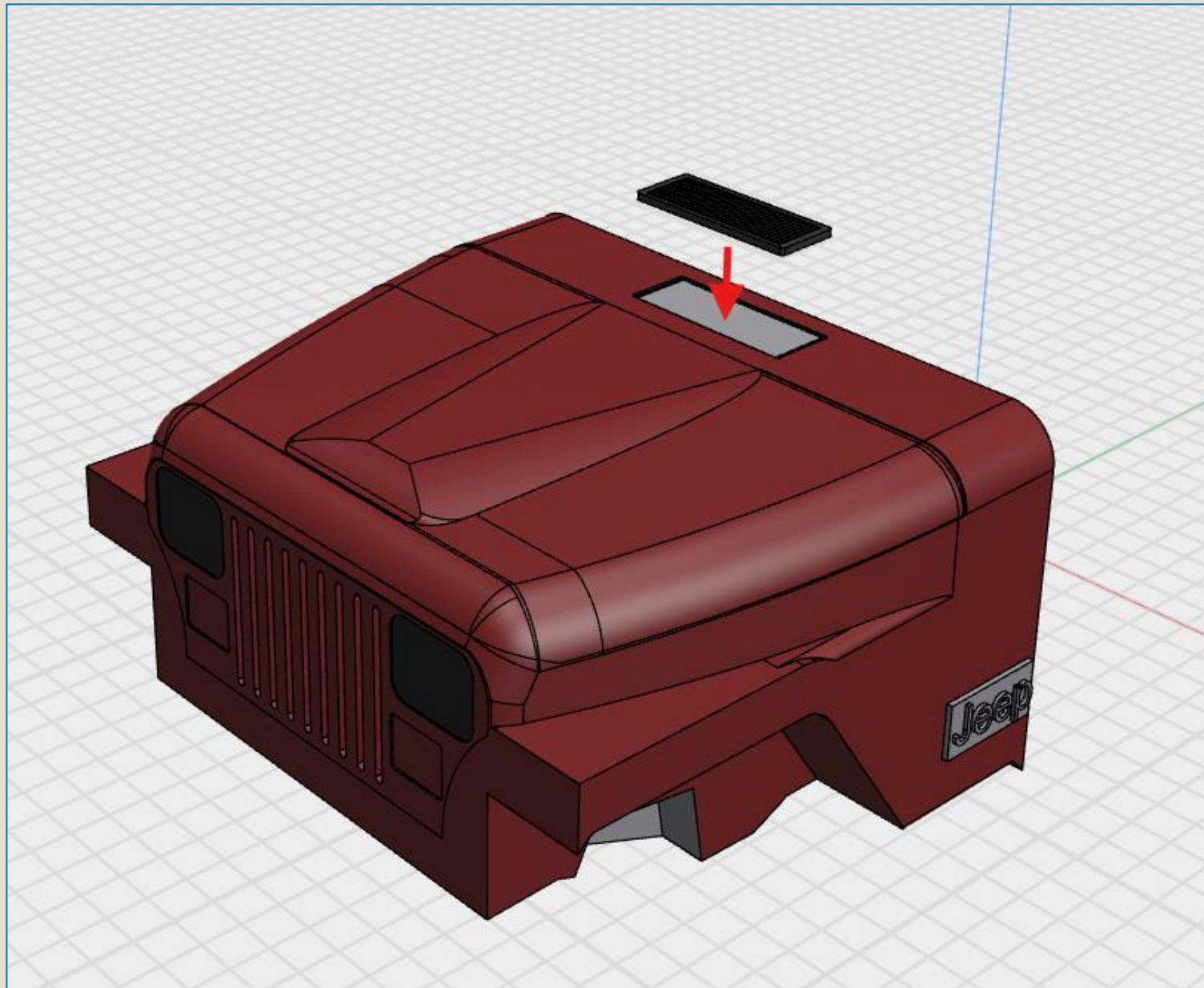


4. = No Glue needed;

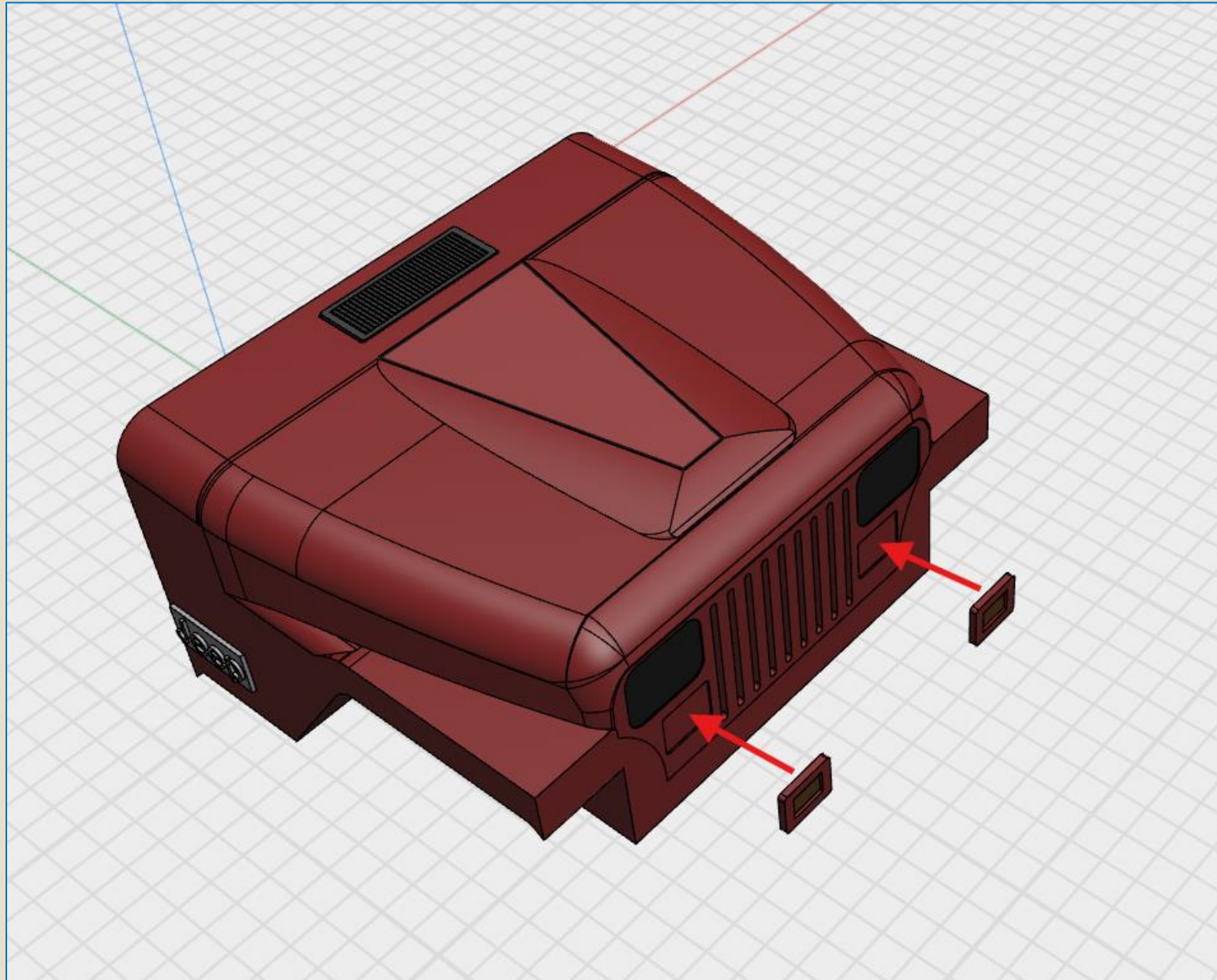
STEP 1 - Hood\JeepLogo - Sprue C



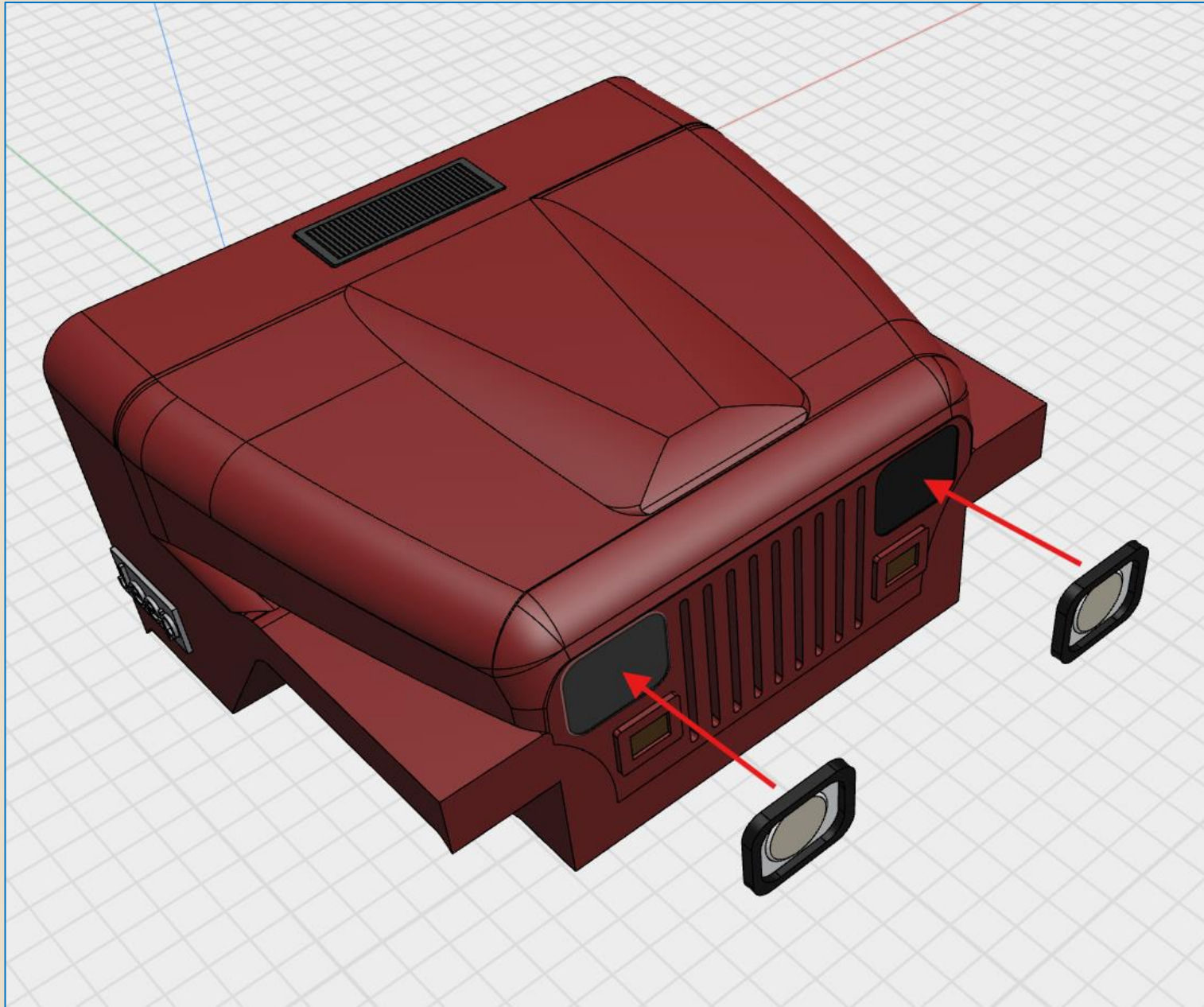
STEP 2 - Hood\HoodGrid - Sprue C



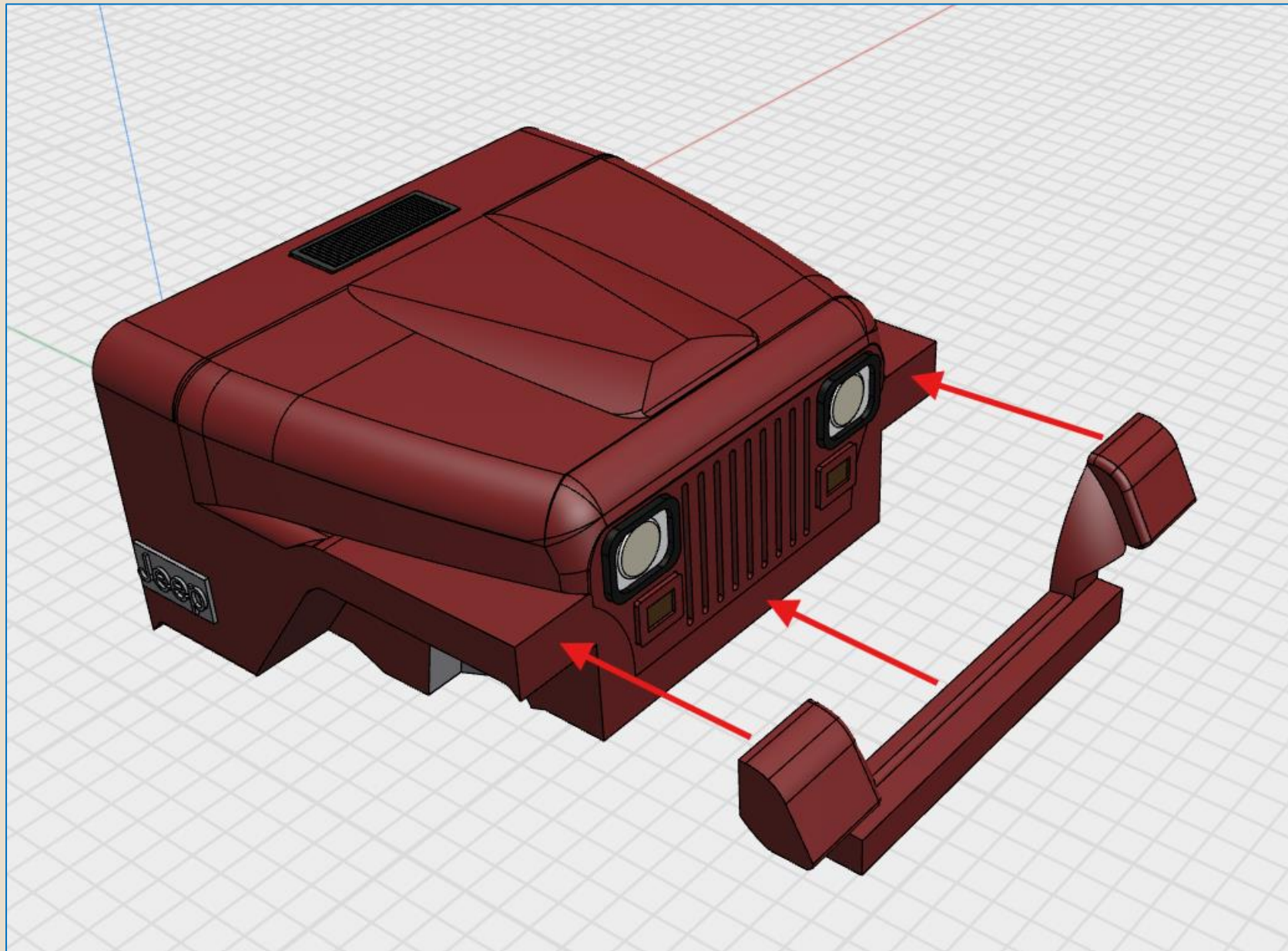
STEP 3 - Lights\FrontSignalLight - Sprue D x2



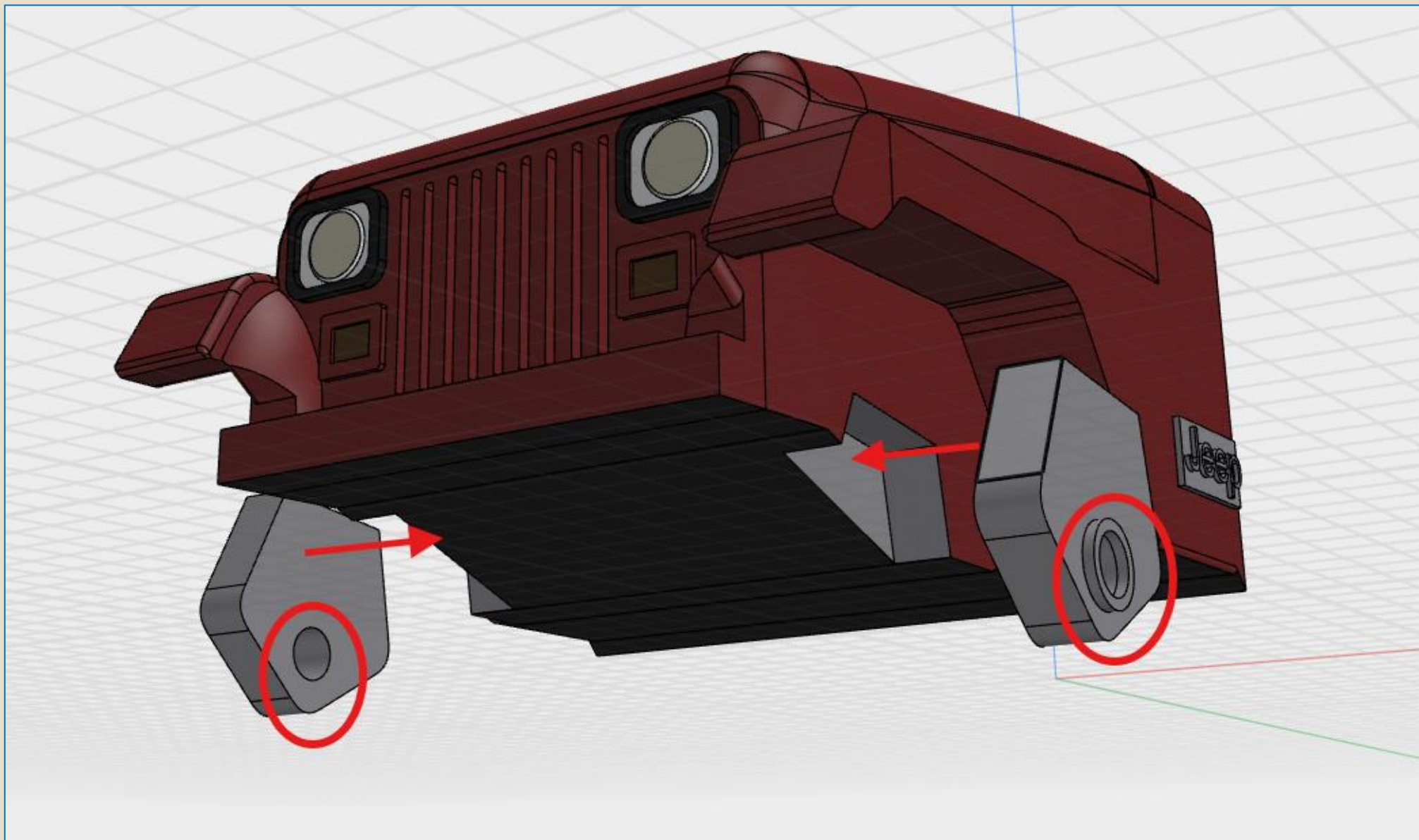
STEP 4 - Lights\HeadLight - Sprue D x2



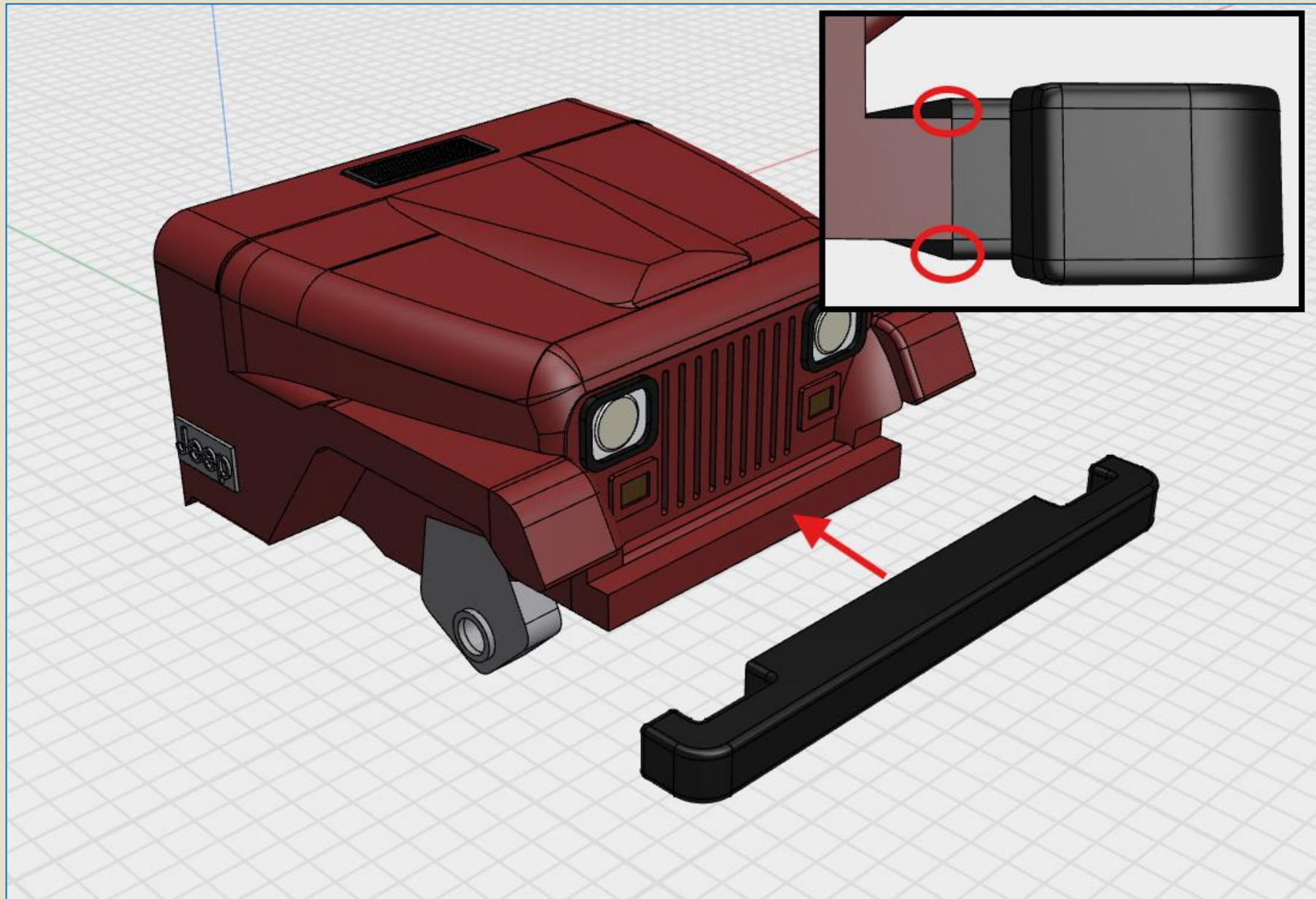
STEP 5 - Hood\HoodExt - Sprue C



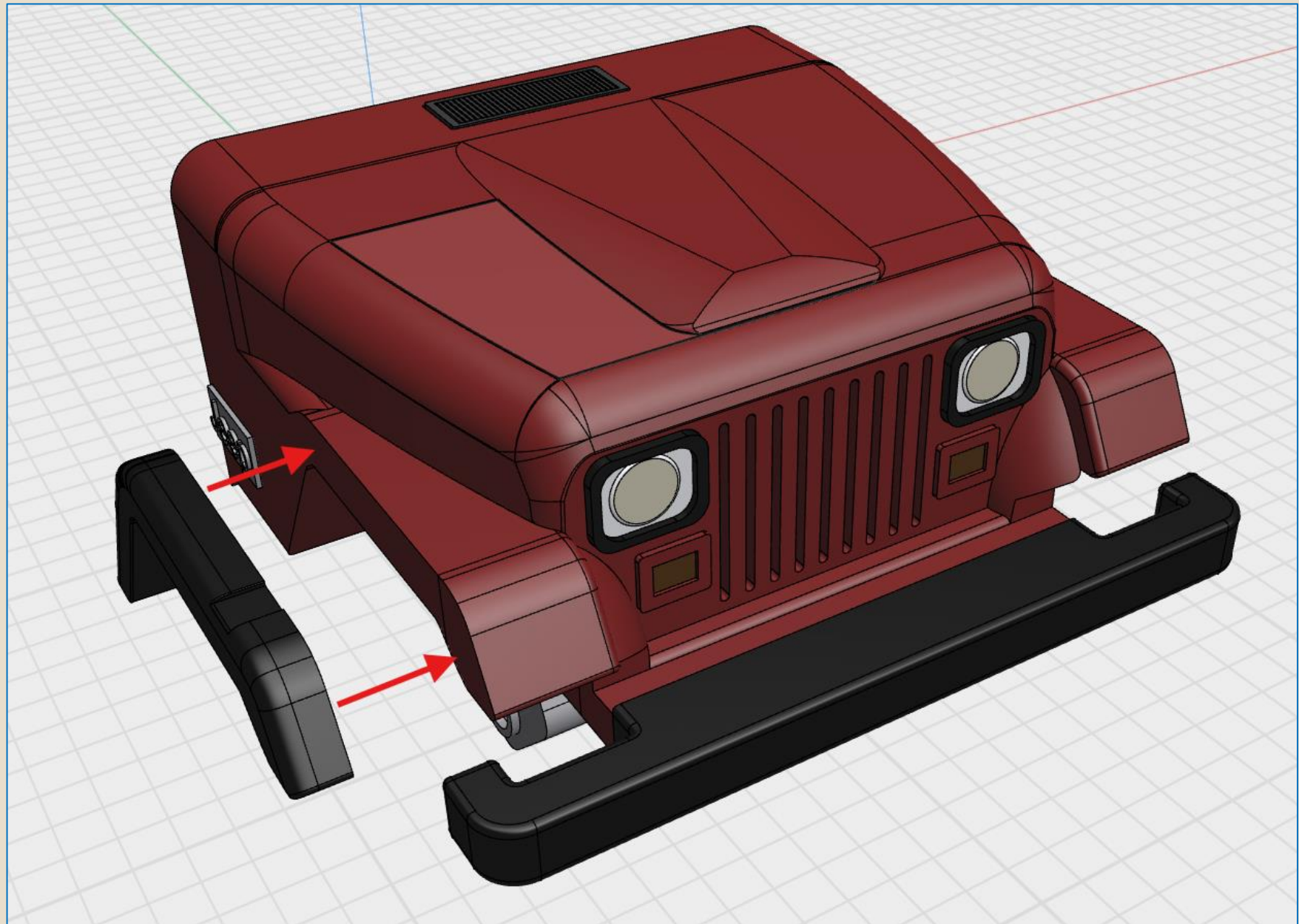
STEP 6 - Wheels\AxleSupport - Sprue B x2



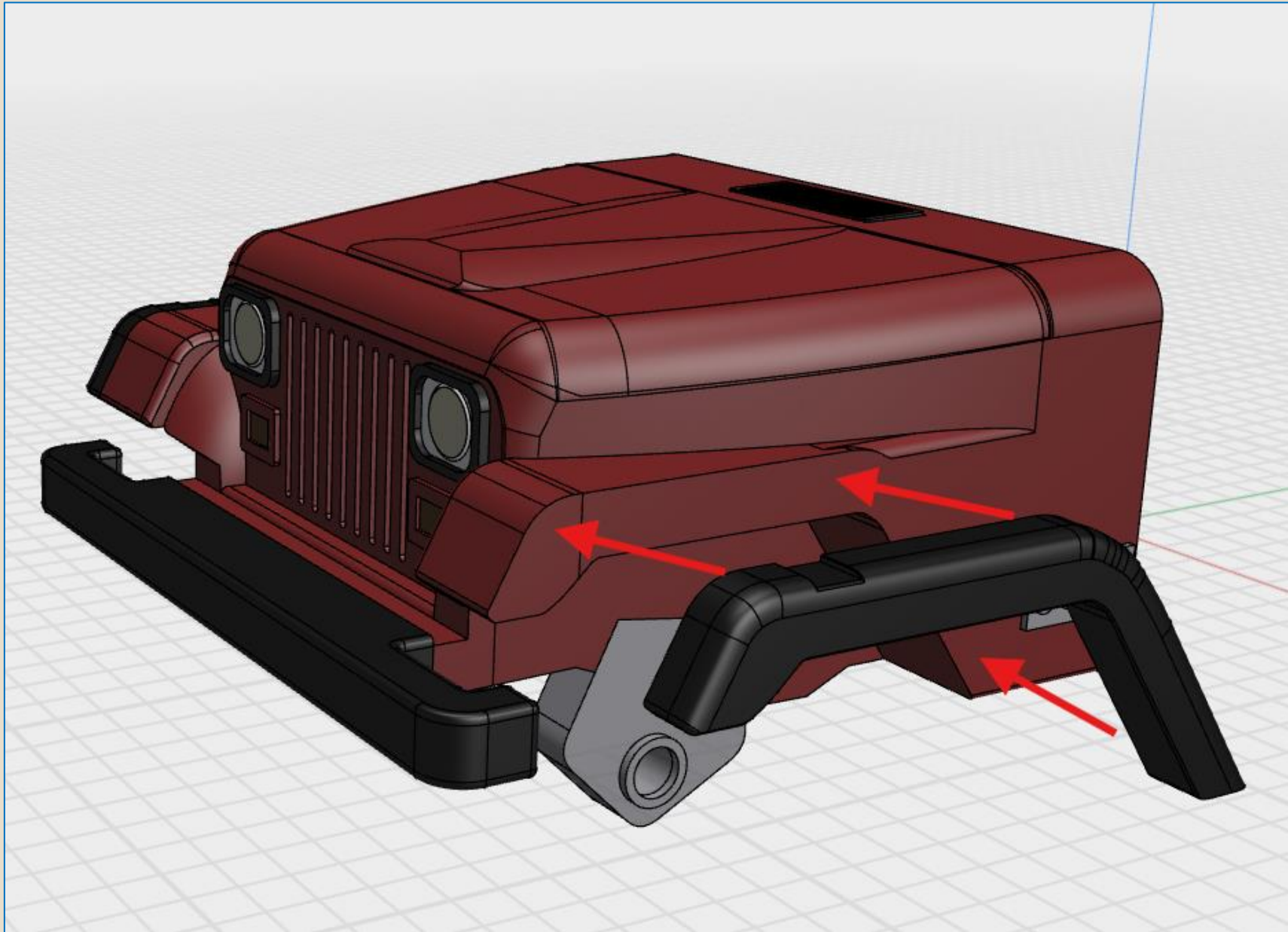
STEP 7 - Boards\FrontBumper - Sprue C



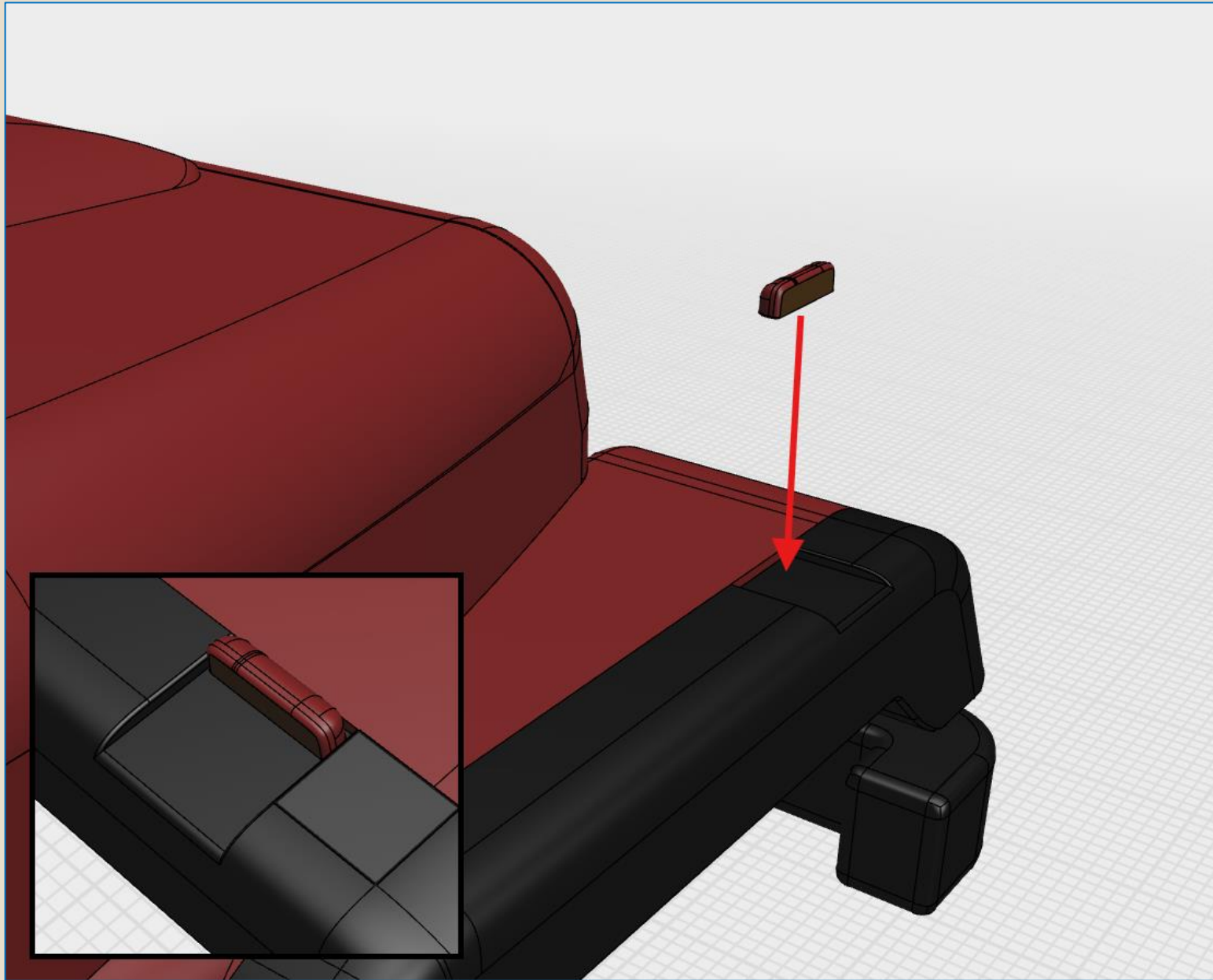
STEP 8 - Boards\FrontGardPassExt - Sprue C



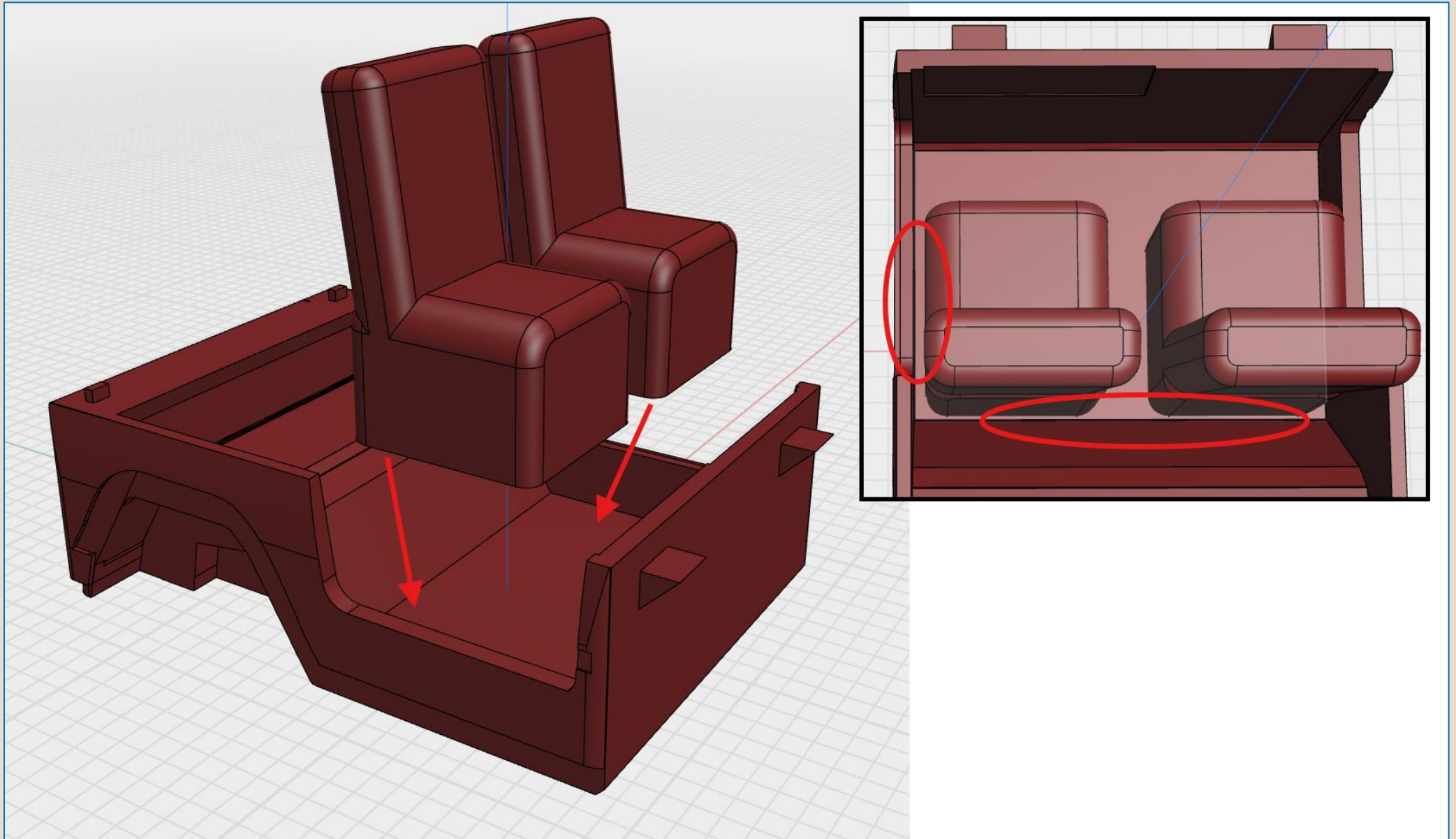
STEP 9 - Boards\ FrontGardDrExt - Sprue C



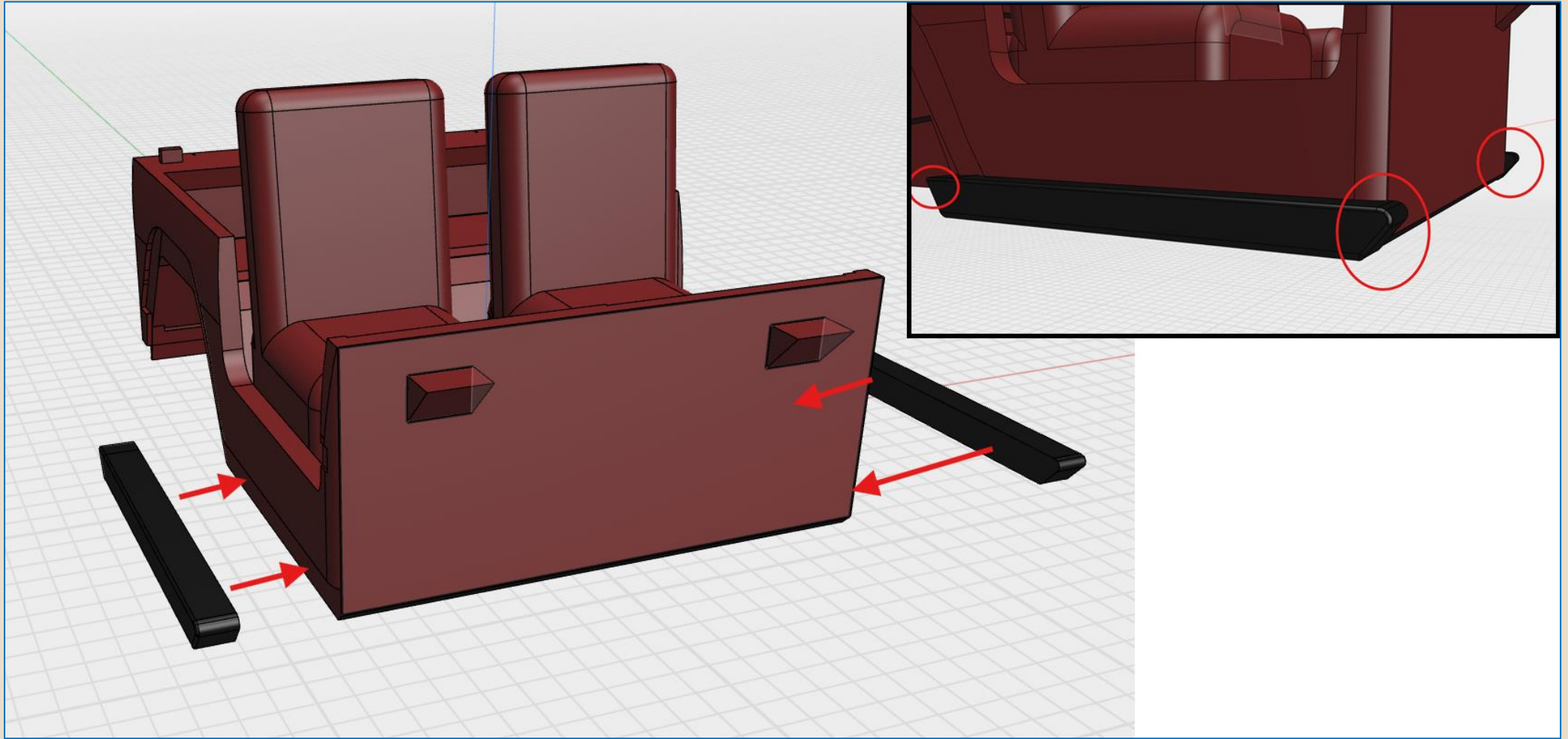
STEP 10 – Lights\SideLight - Sprue C x2



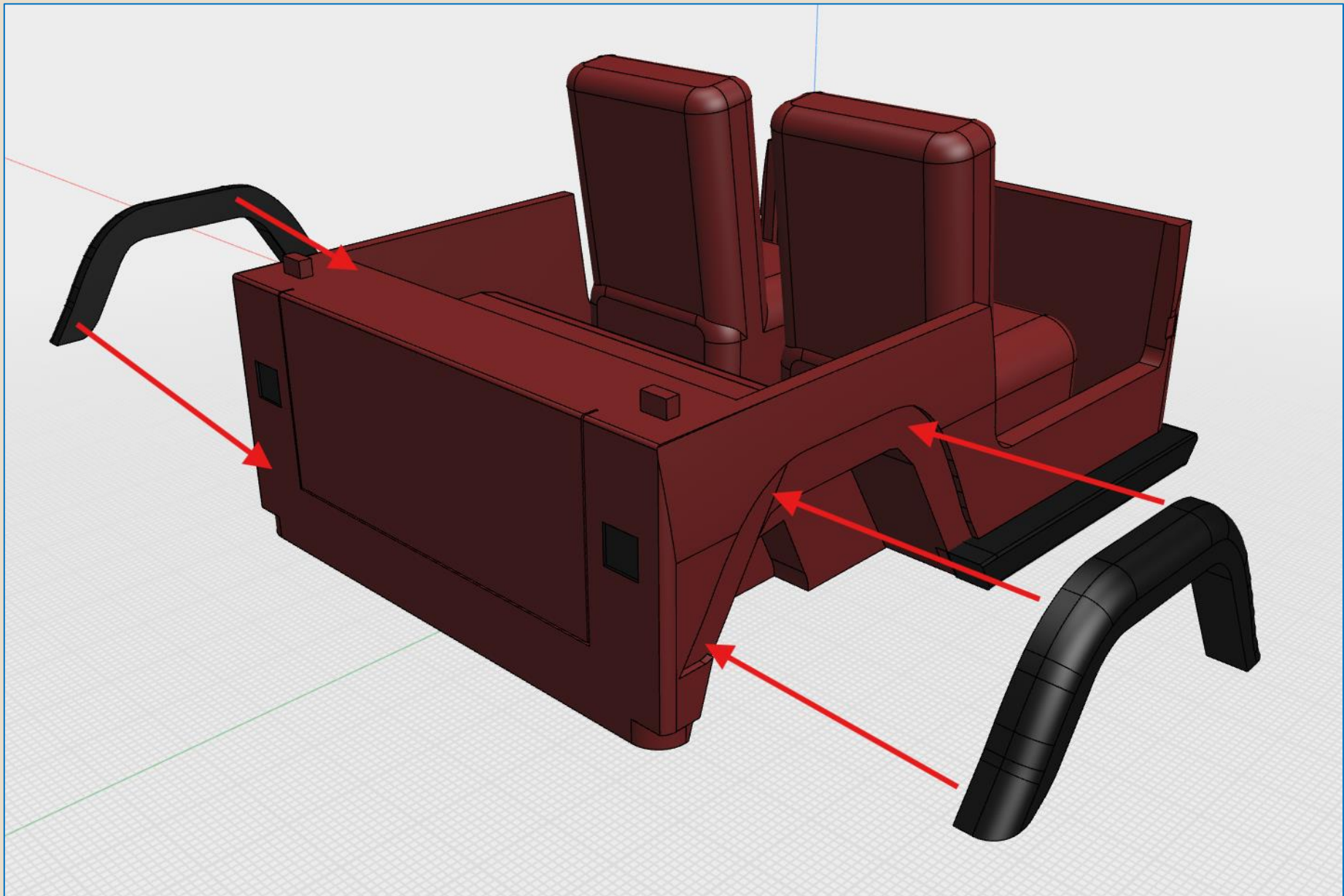
STEP 11 - Accessories\Seat x2 - NOT ON A SPRUE



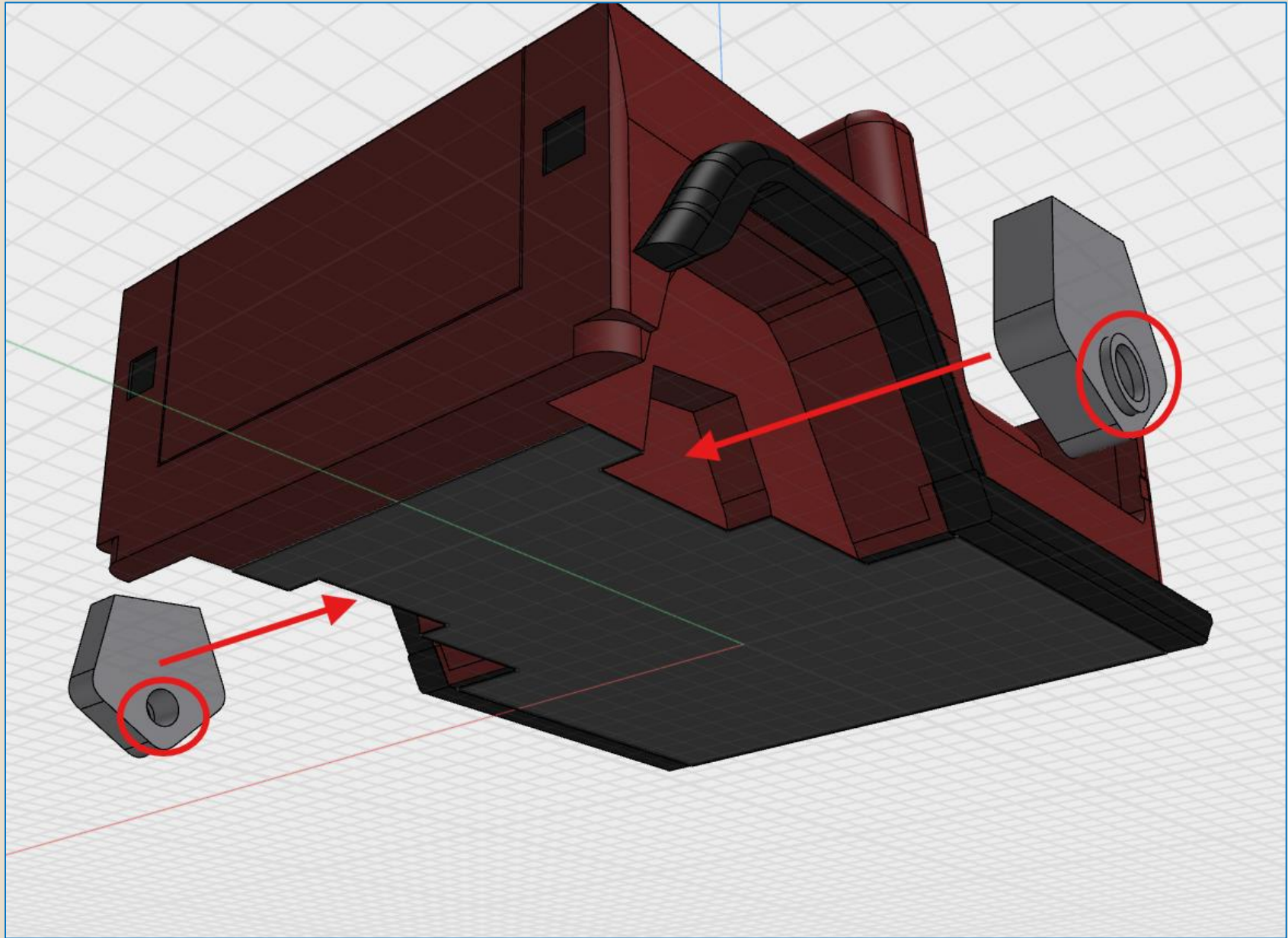
STEP 12 – Boards\FootingPass + FootingDr - Sprue C



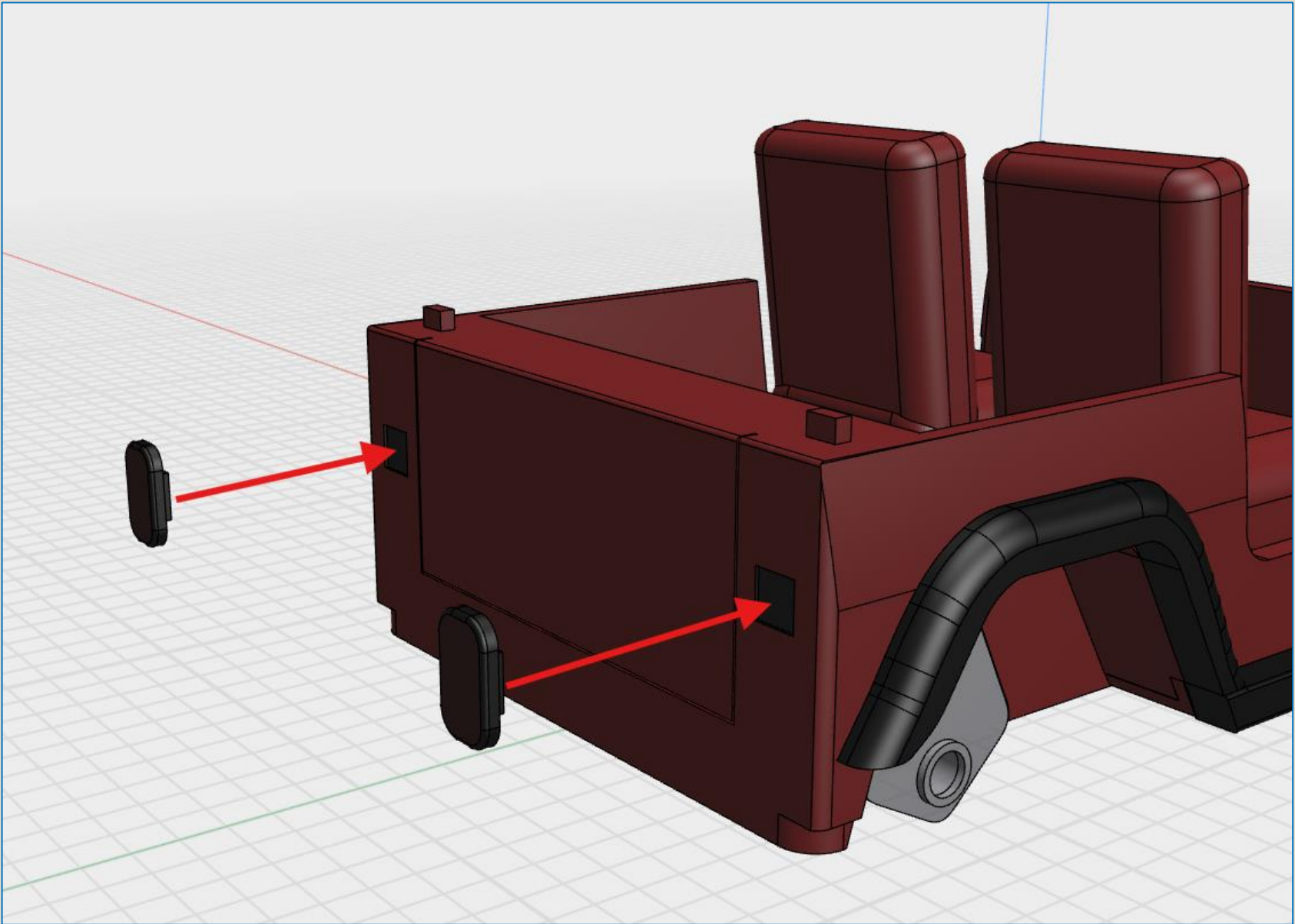
STEP 13 - Boards\RearGardPass + RearGardDr - Sprue C



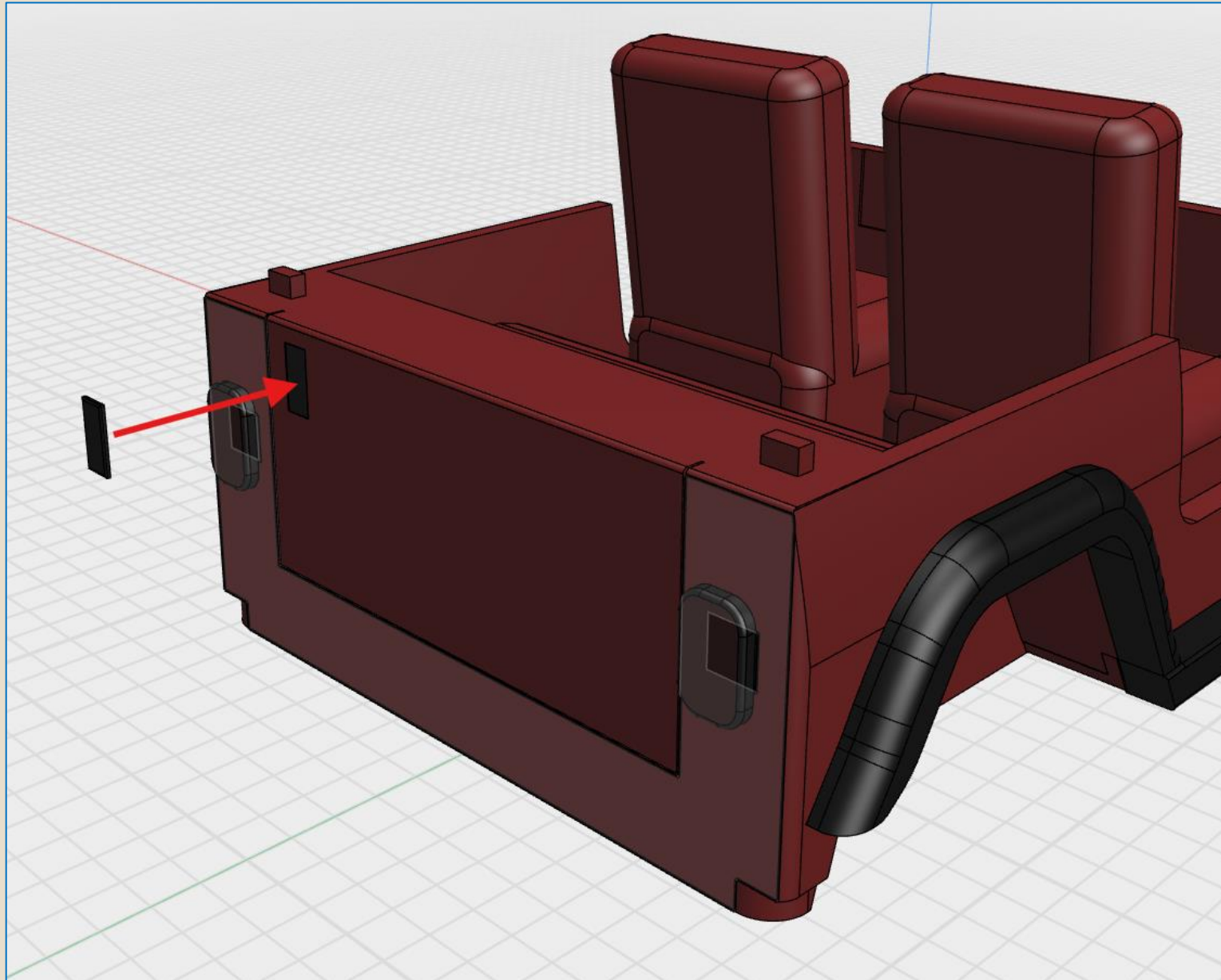
STEP 14 - Wheels\AxleSupport - Sprue B x2



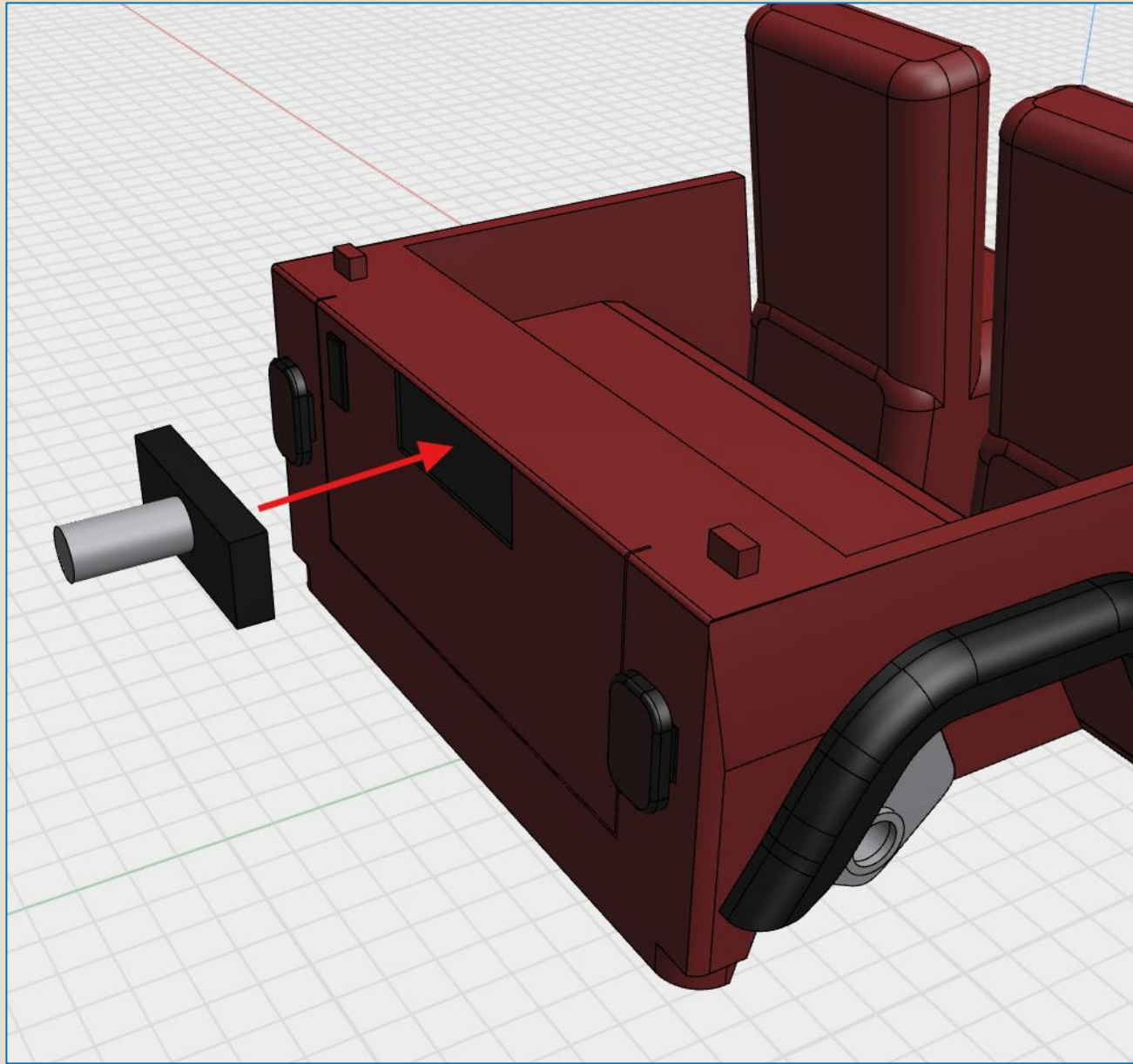
STEP 15 – Lights\RearLight



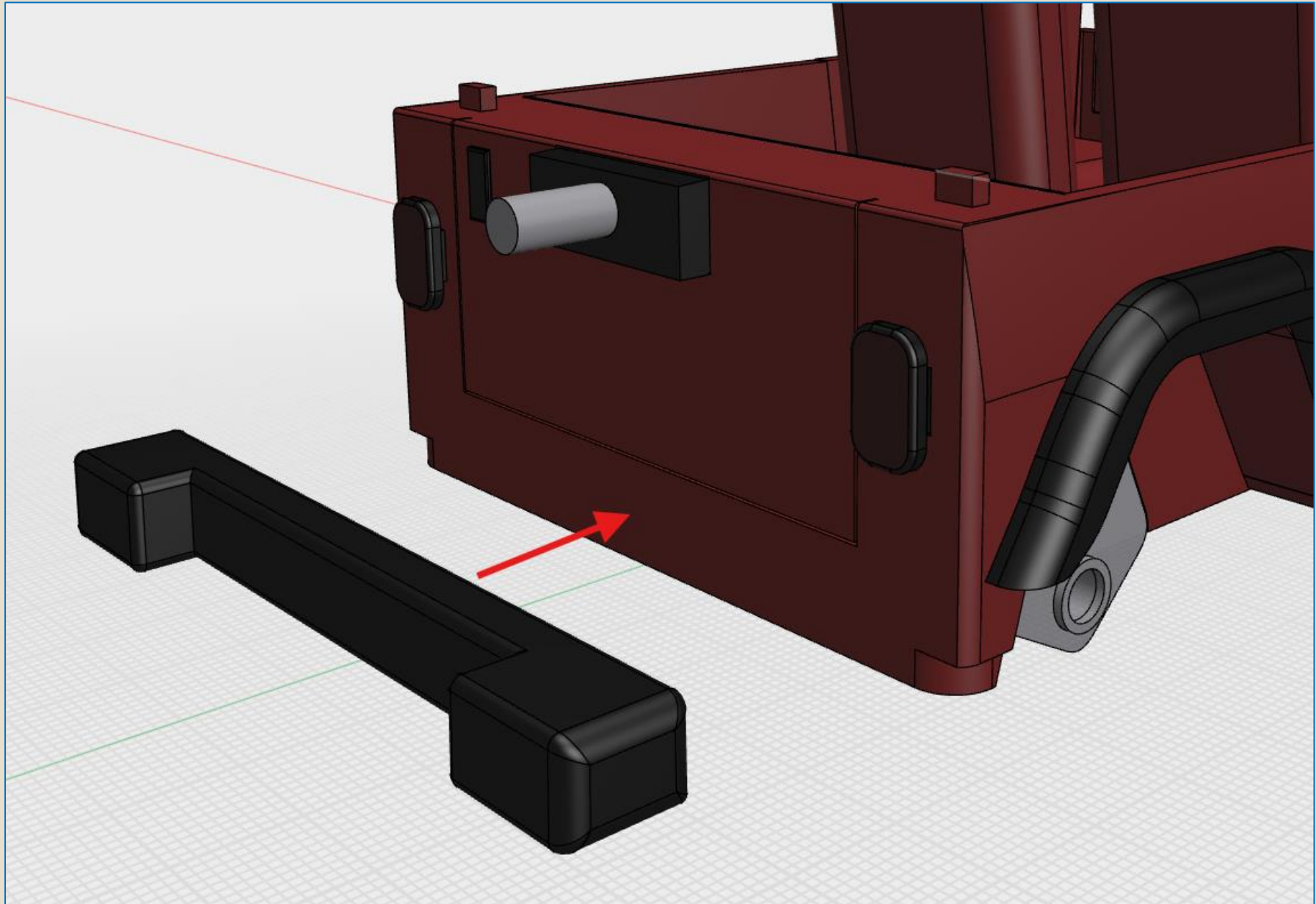
STEP 16 – Chassis\DoorLock – Sprue A



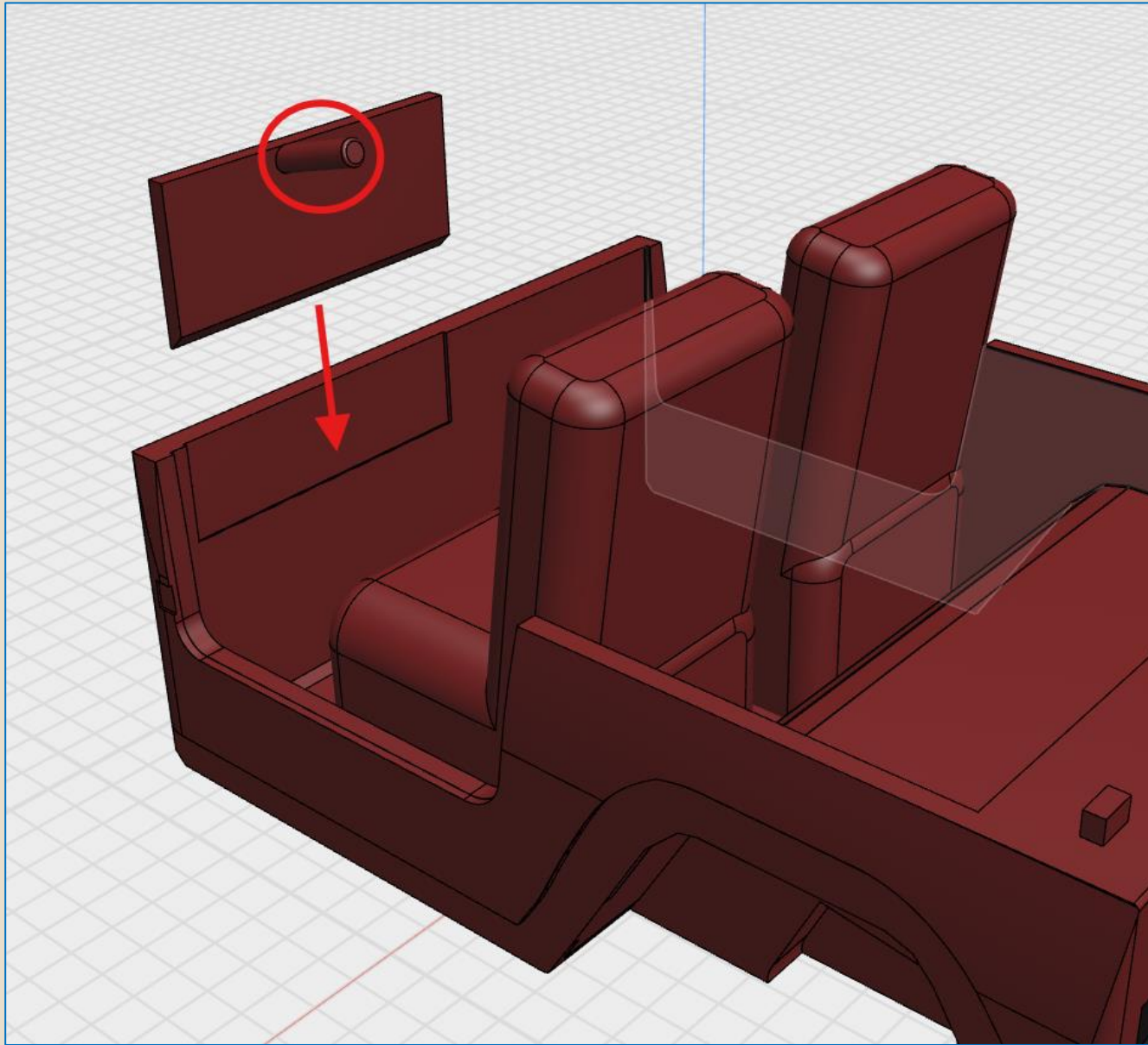
STEP 17 – Wheels\ SpareTireSupport - Sprue B



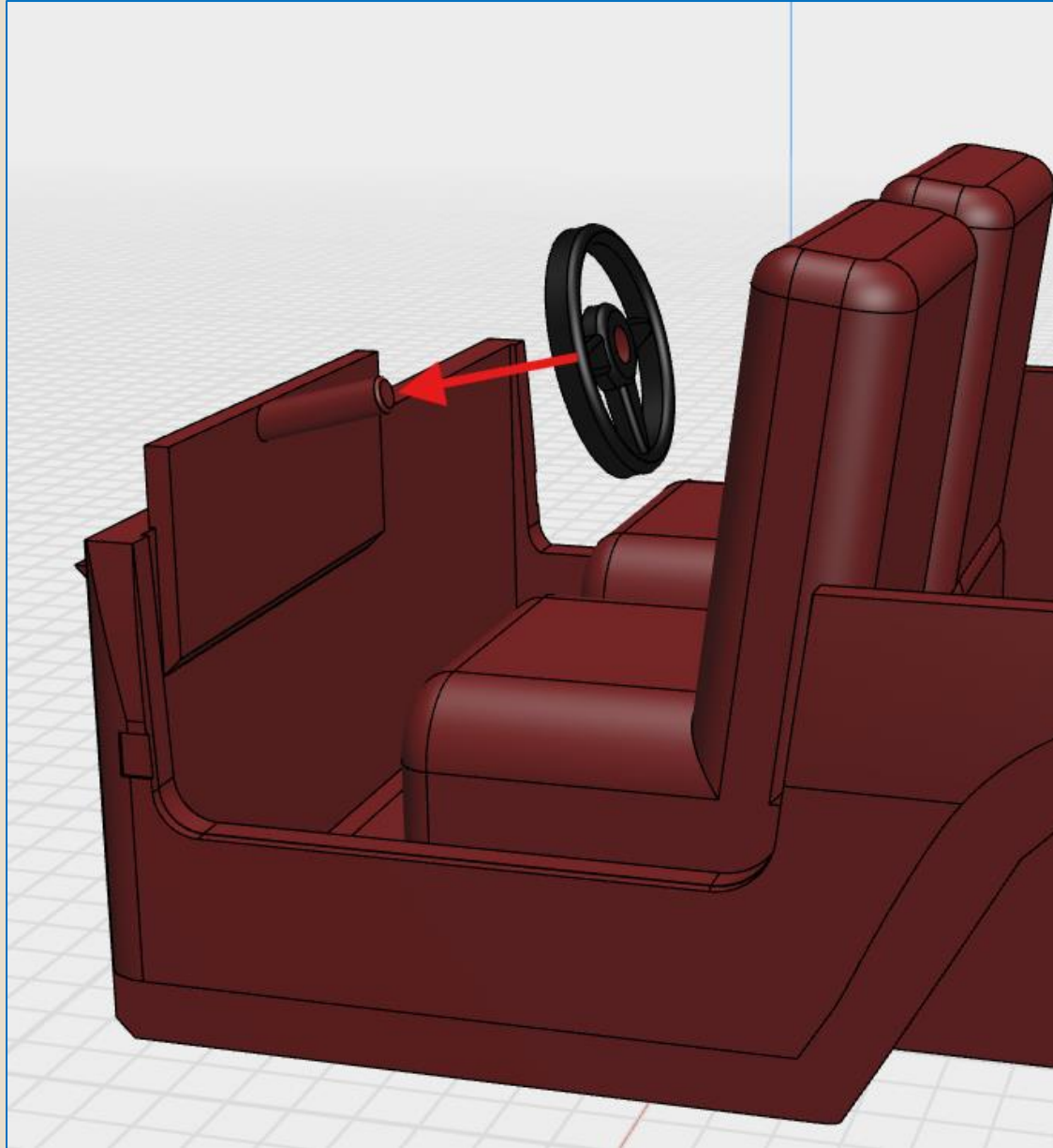
STEP 18 – Boards\RearBumper - Sprue C



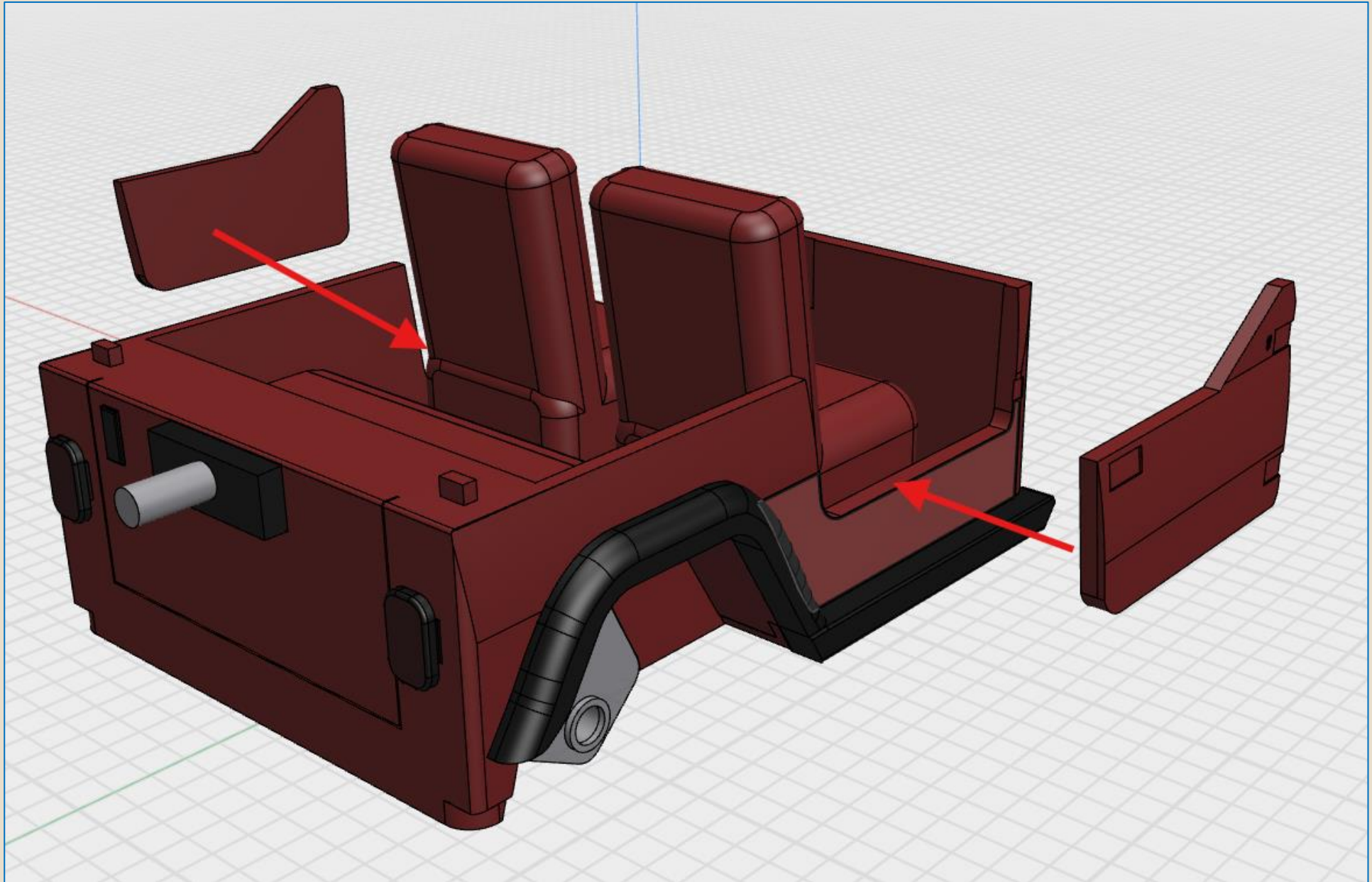
STEP 19 - Accessories\Dashboard - Sprue A



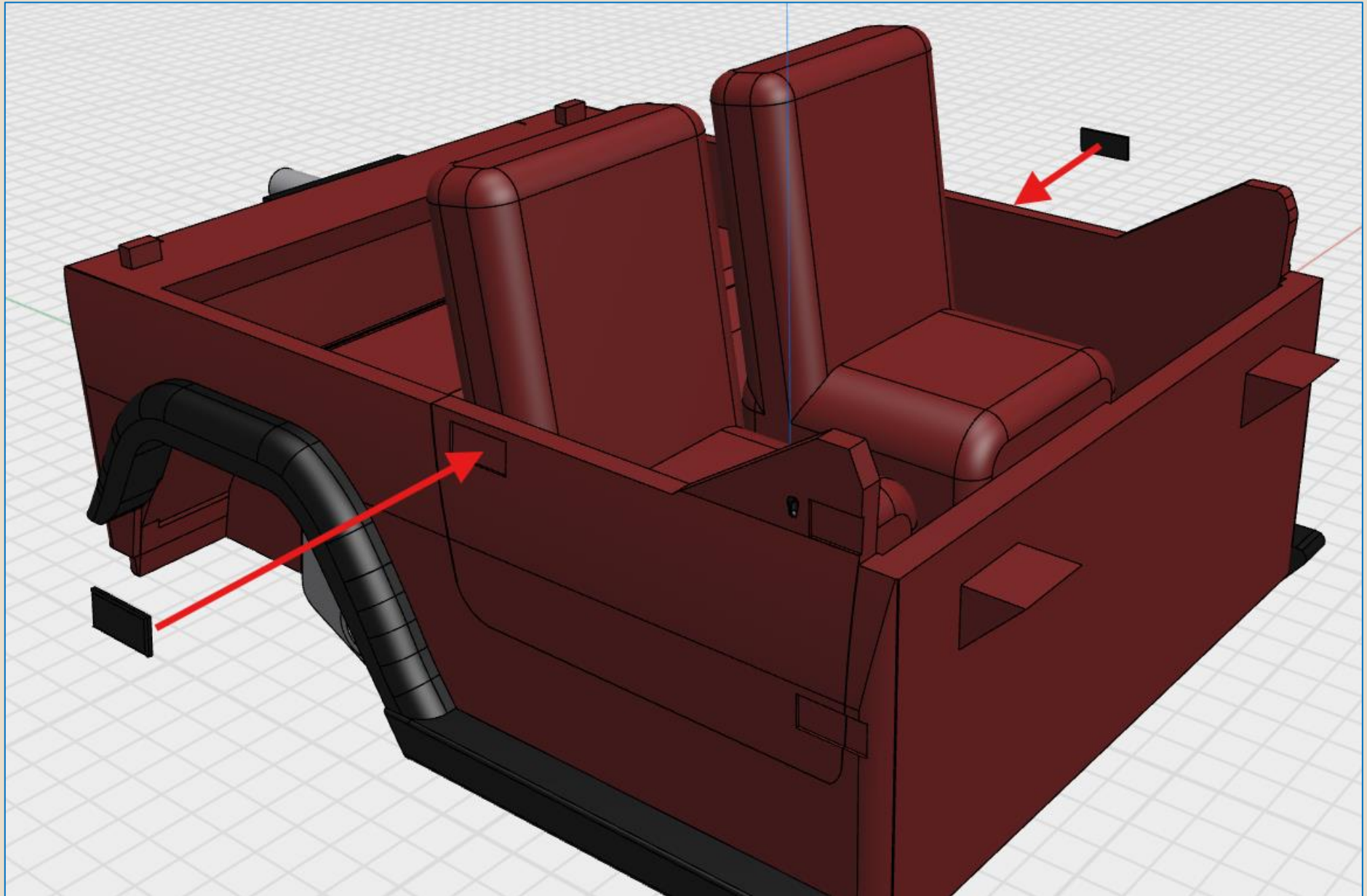
STEP 20 - Accessories\DrivingWheel - Sprue A



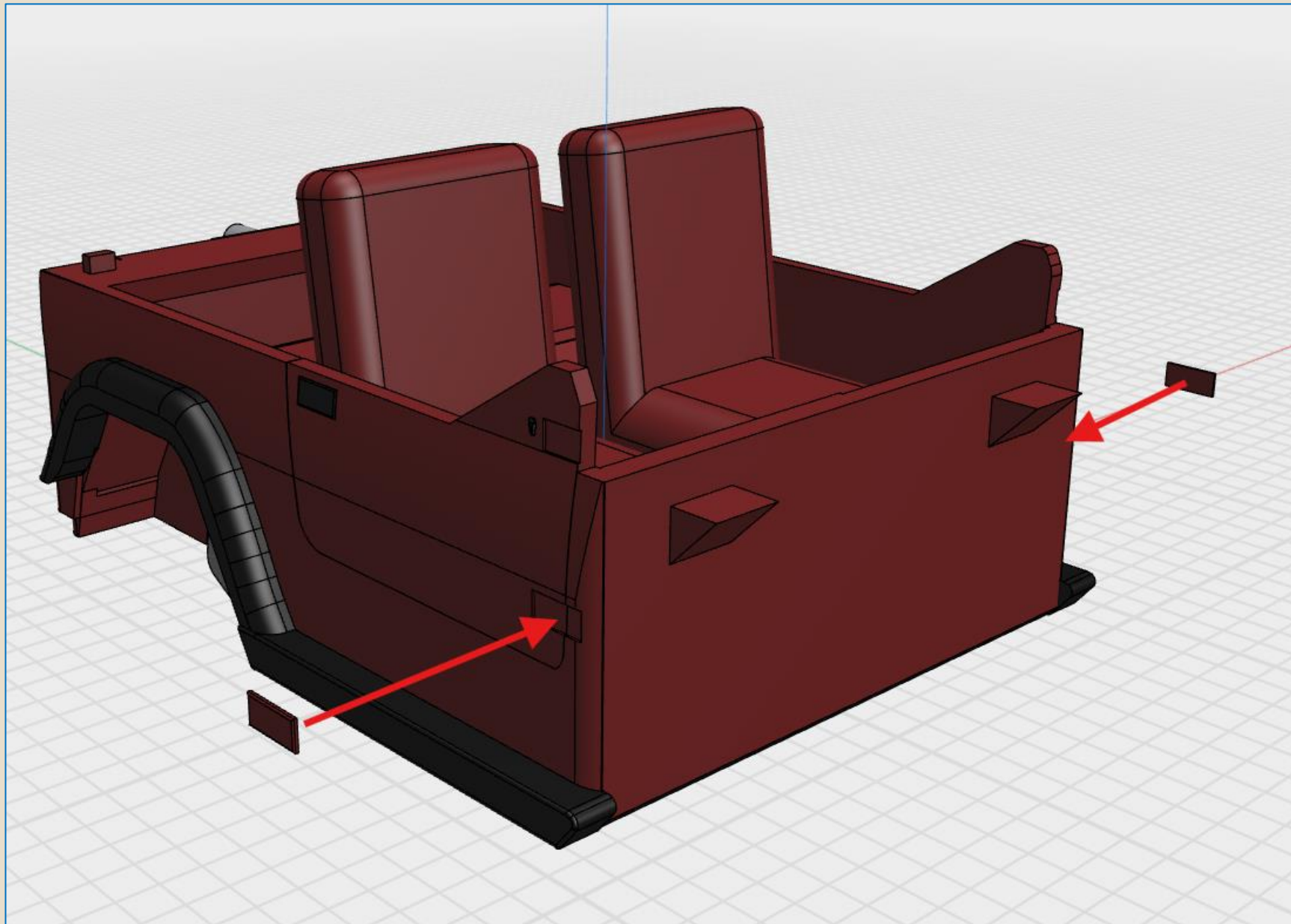
STEP 21 - Chassis\DoorPass + DoorDr - Sprue A



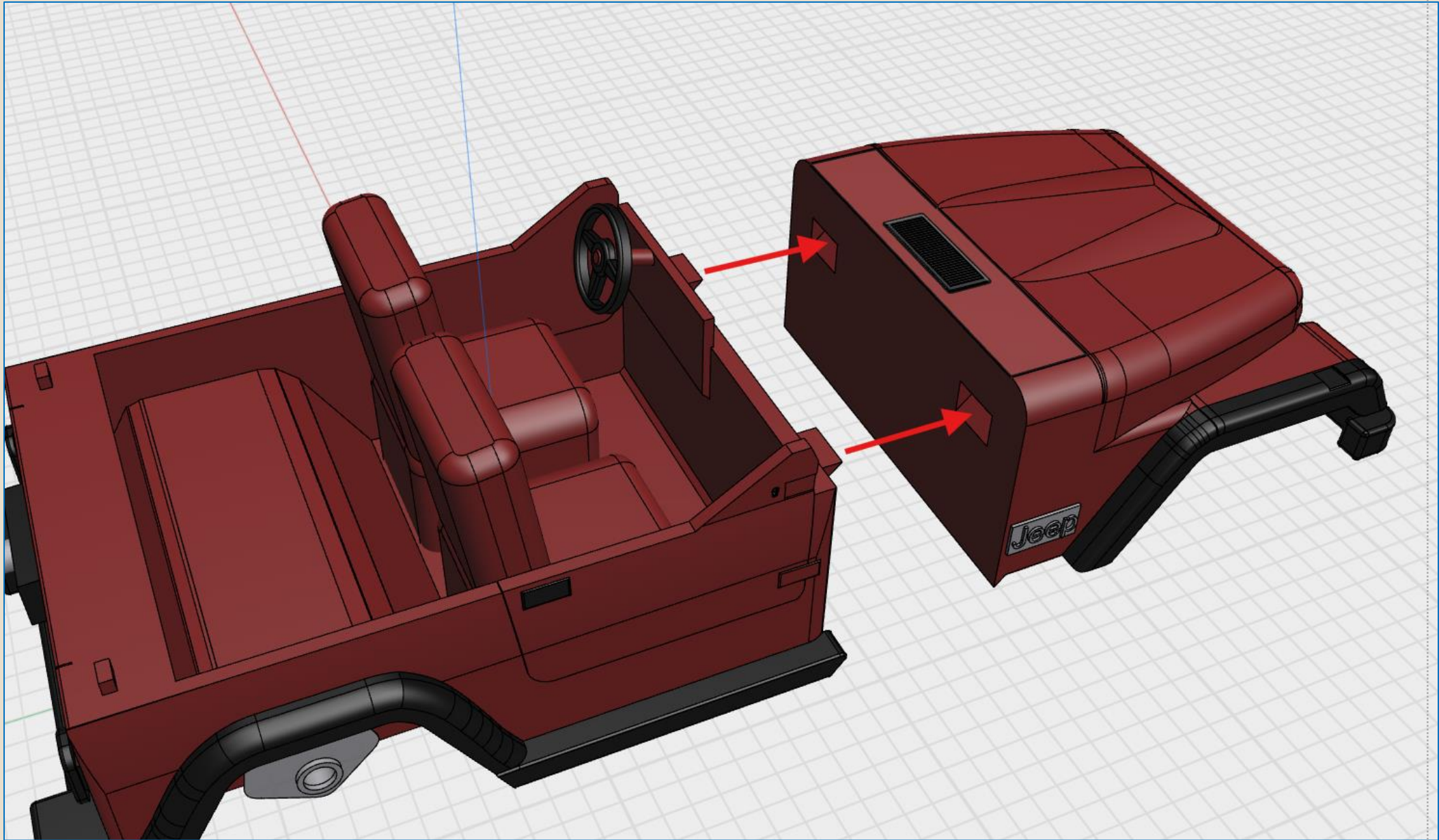
STEP 22 - Chassis\DoorLock – Sprue A x2



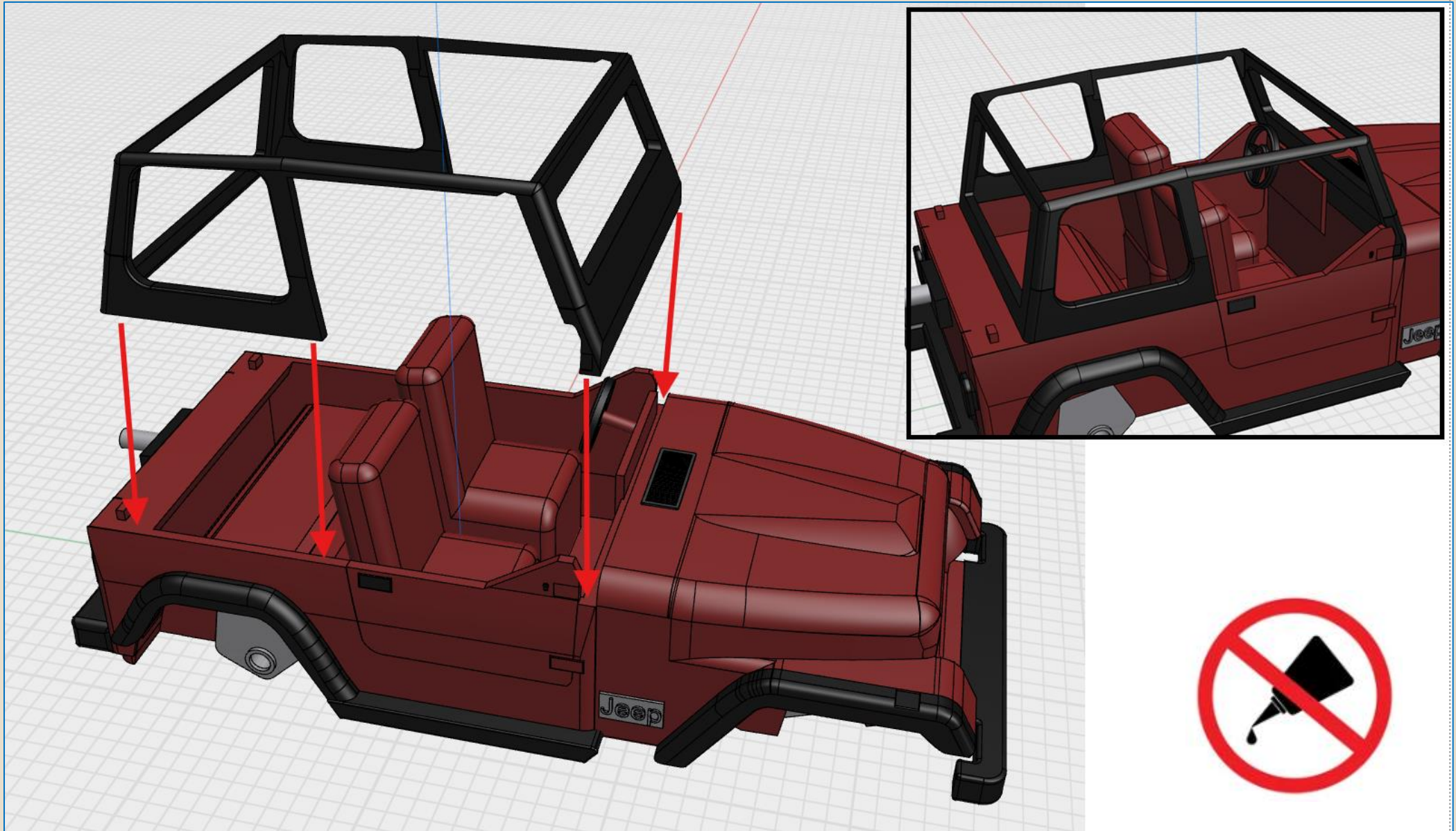
STEP 23 - Chassis\DoorHinge – Sprue A x2



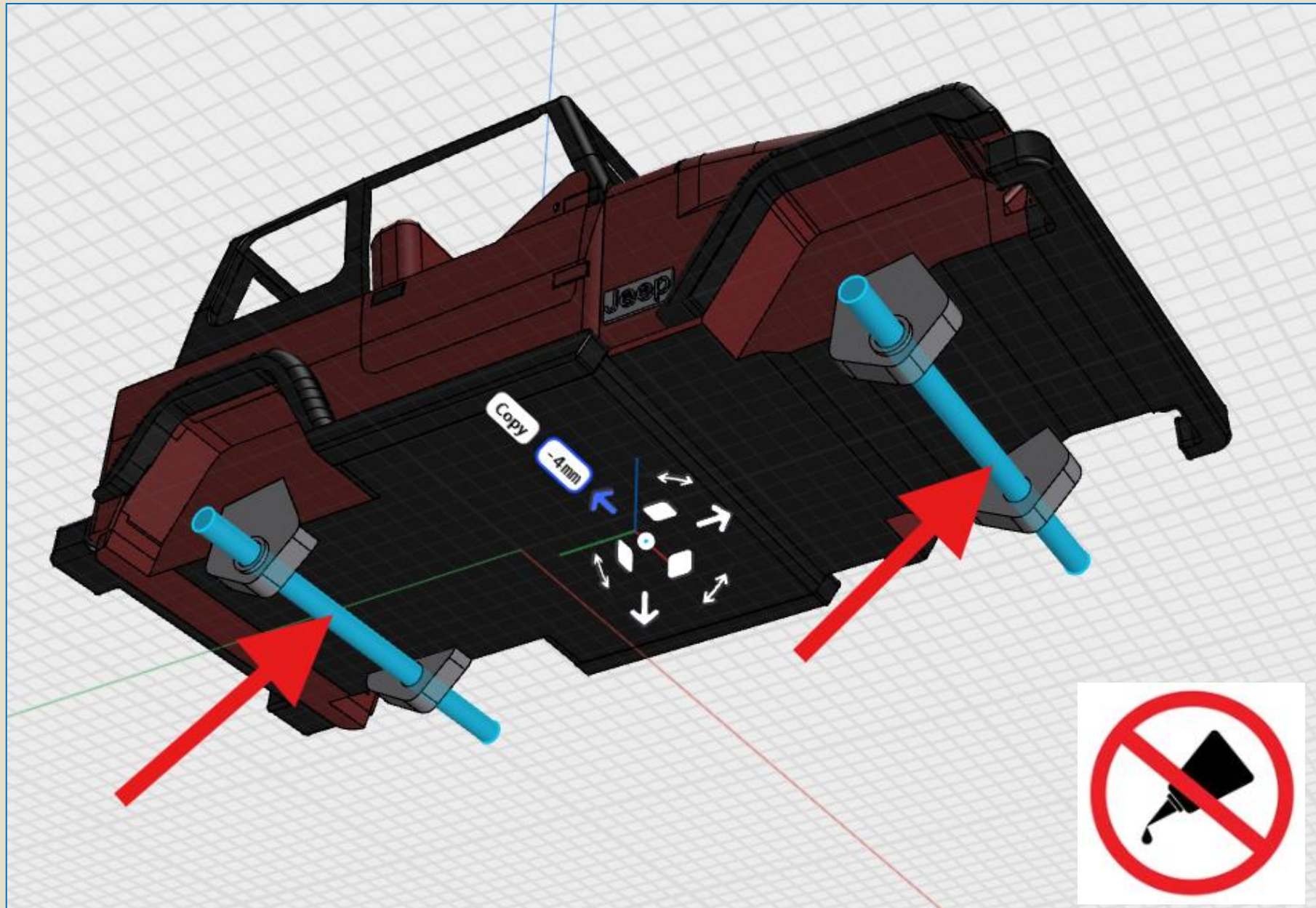
STEP 24 - Chassis\BaseFrame + Hood\Hood_NoMotor – NOT ON SPRUE



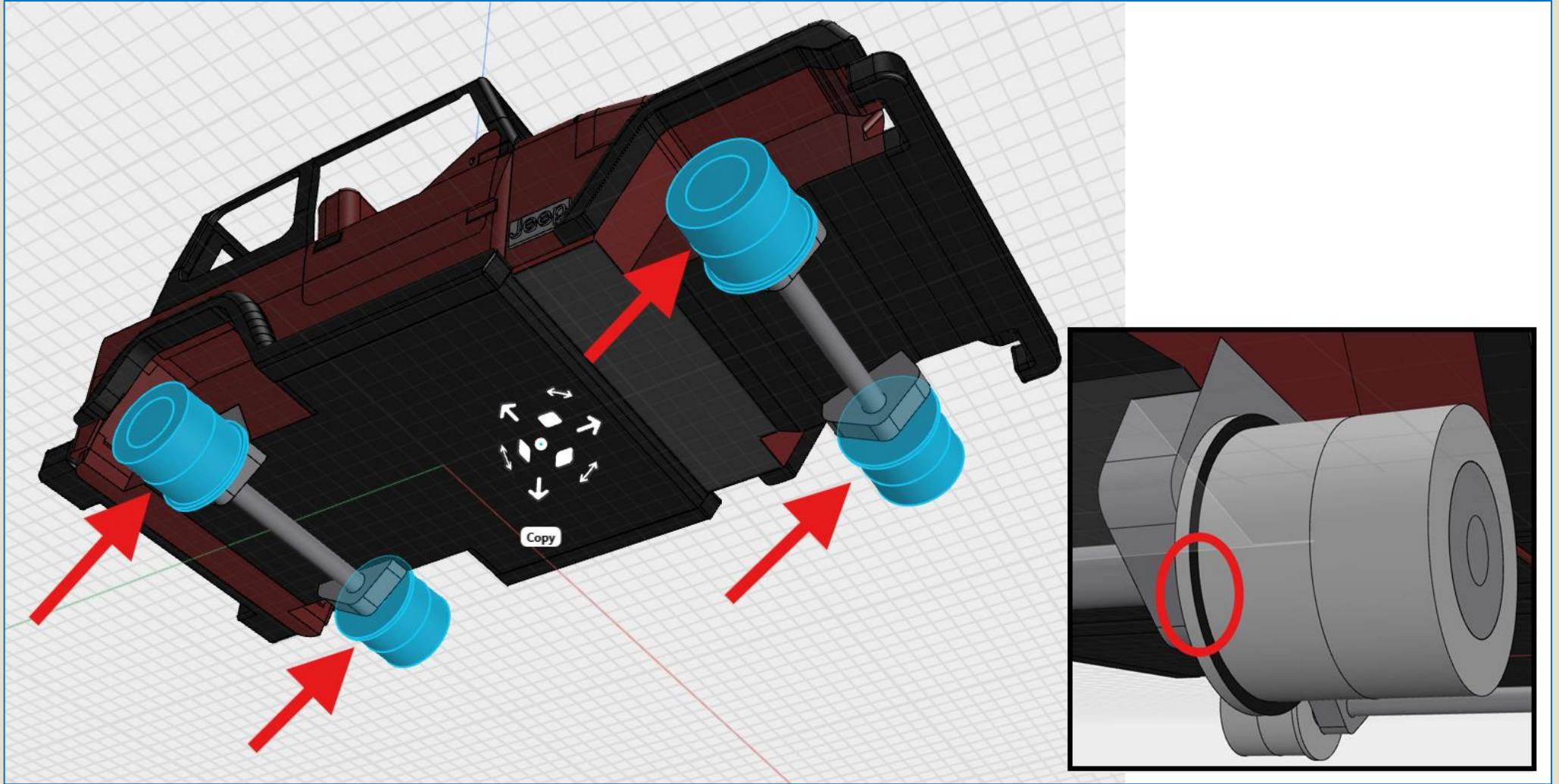
STEP 25 - Chassis\TopFrame – NOT ON SPRUE



STEP 26 - Wheels\Axle – Sprue E x2

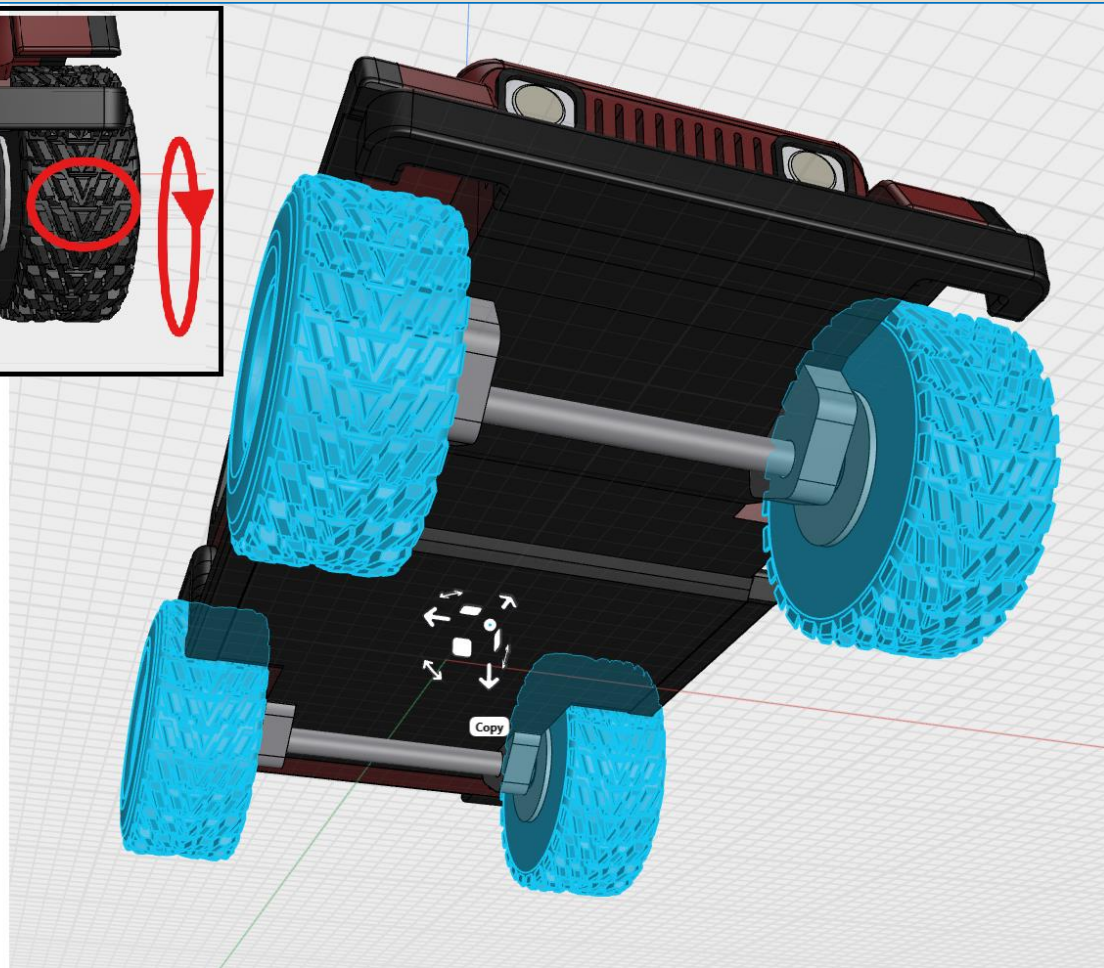


STEP 27 - Wheels\Wheel – Sprue E x4

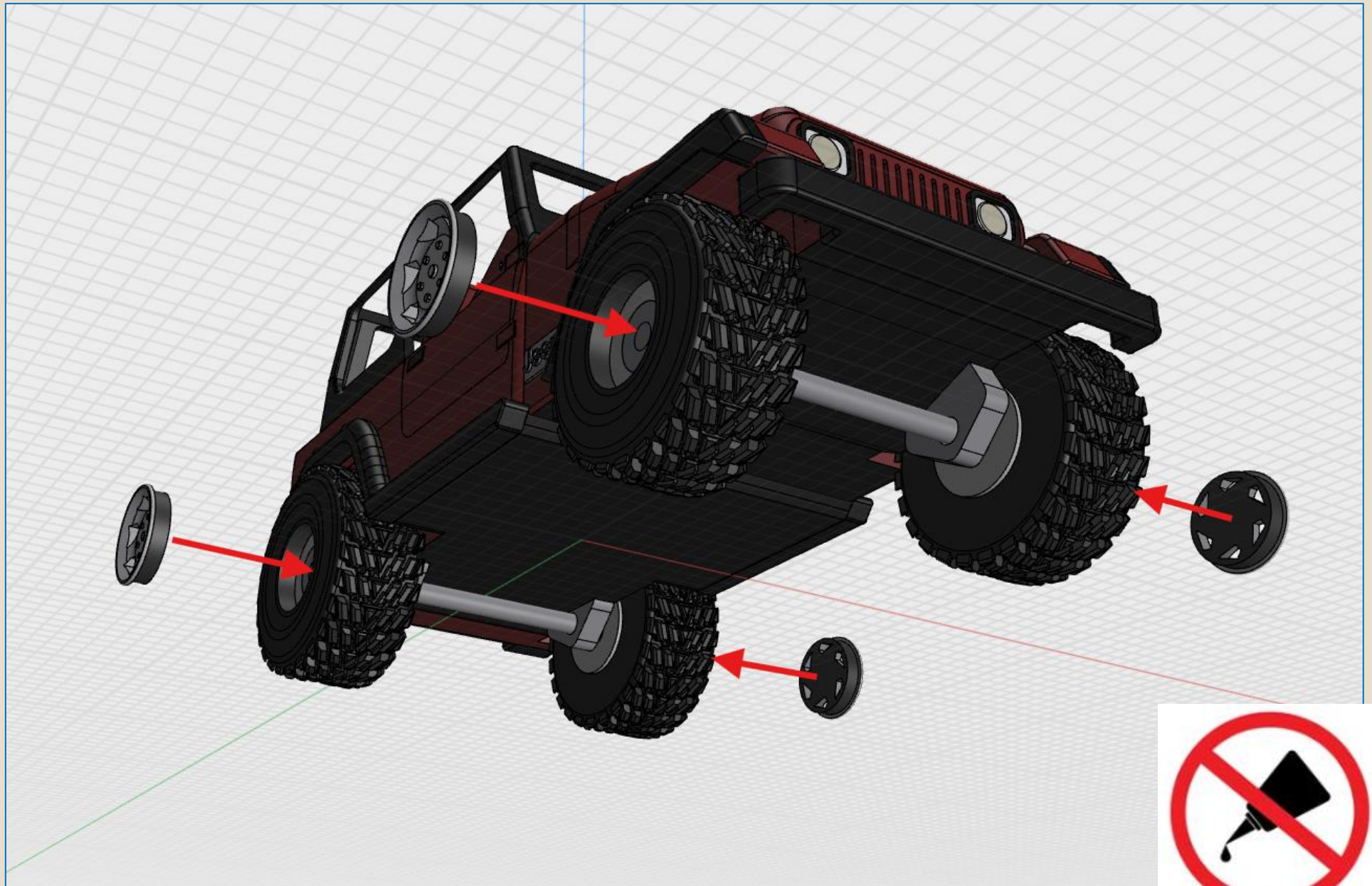


STEP 28 – DRIVER SIDE : Wheels\Tires\DriverSideTire x2 - NOT ON SPRUE

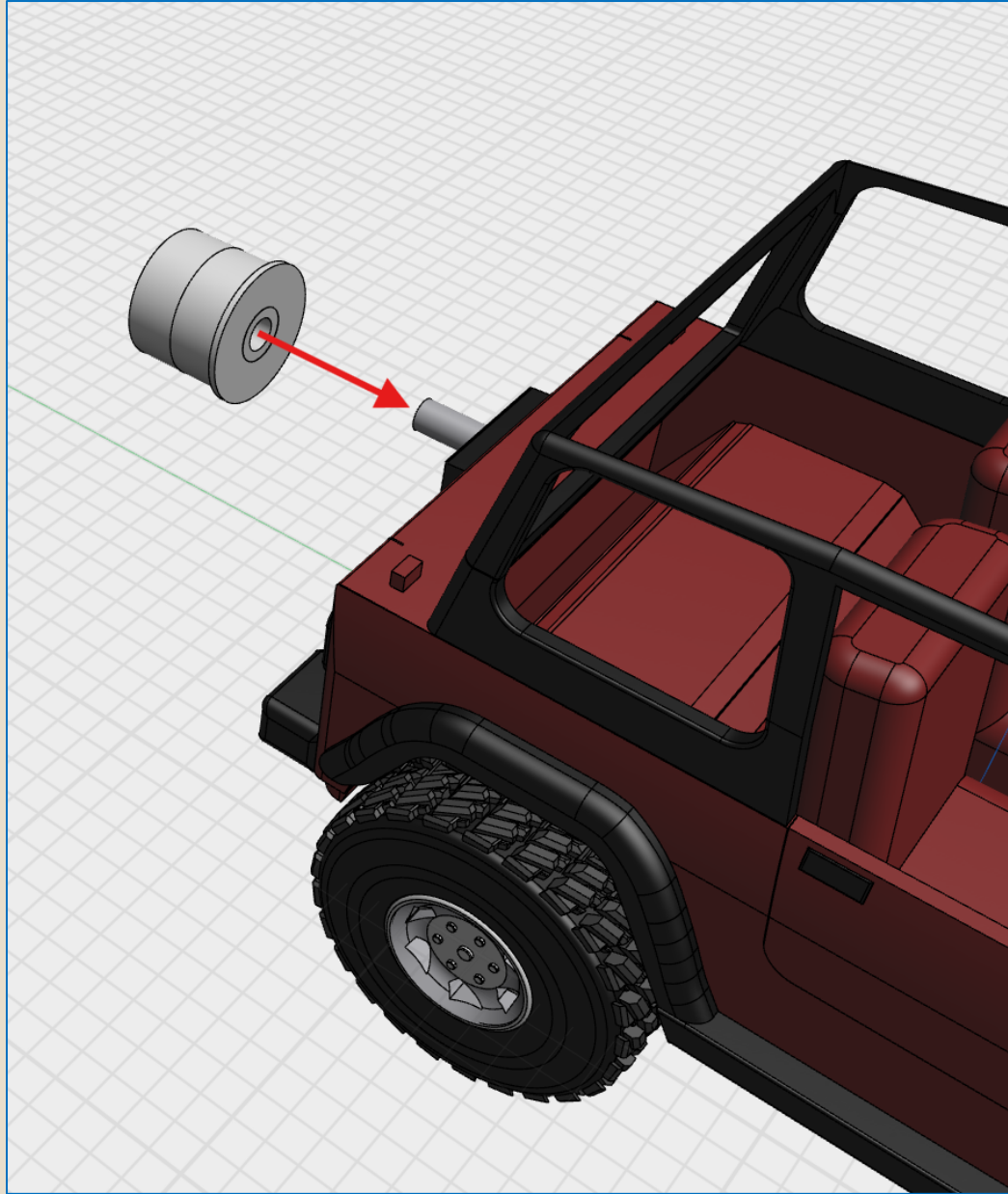
PASSENGER SIDE : Wheels\Tires\PassengerSideTire x2 - NOT ON SPRUE



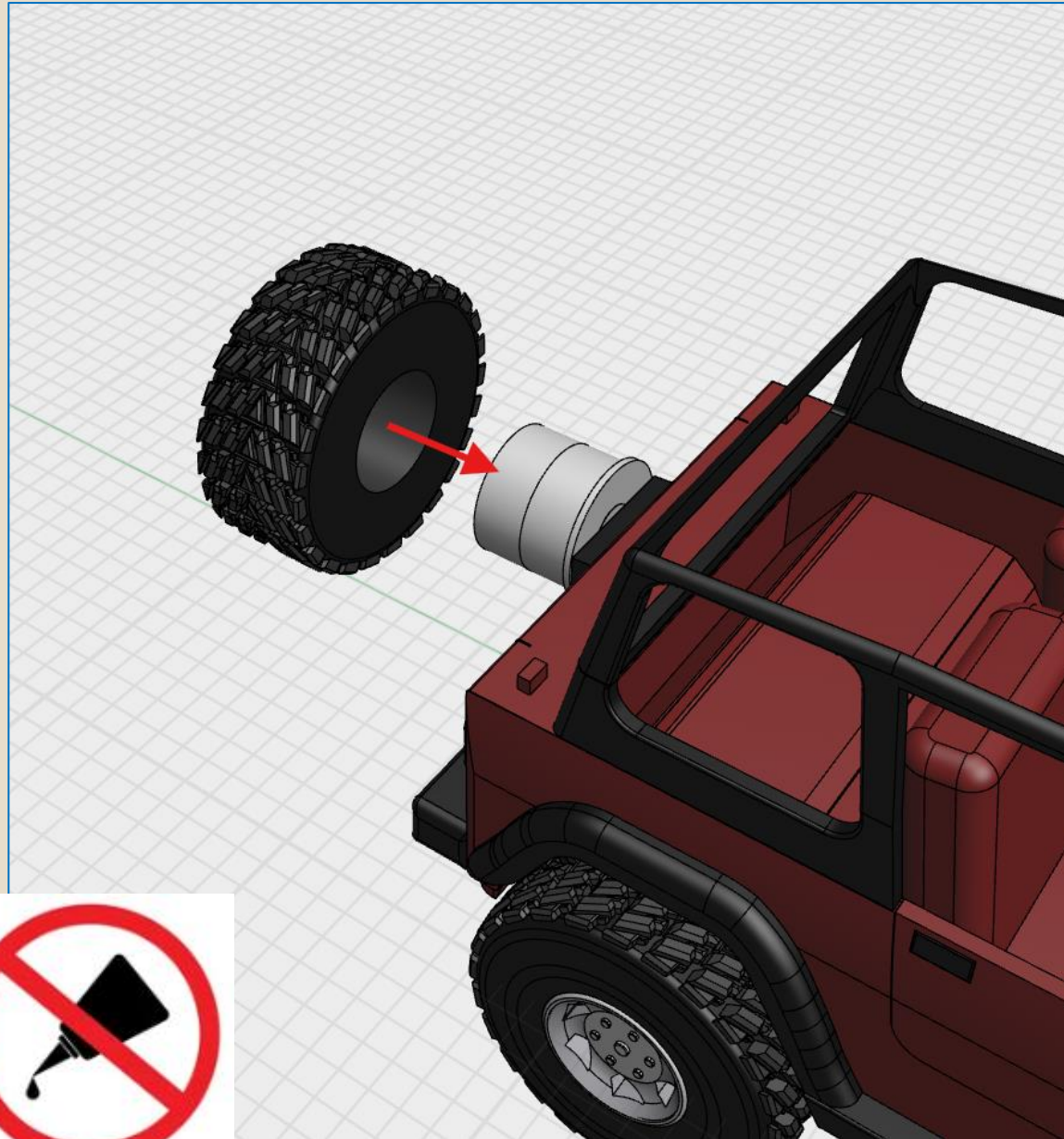
STEP 29 - Wheels\RimCover – Sprue E x4



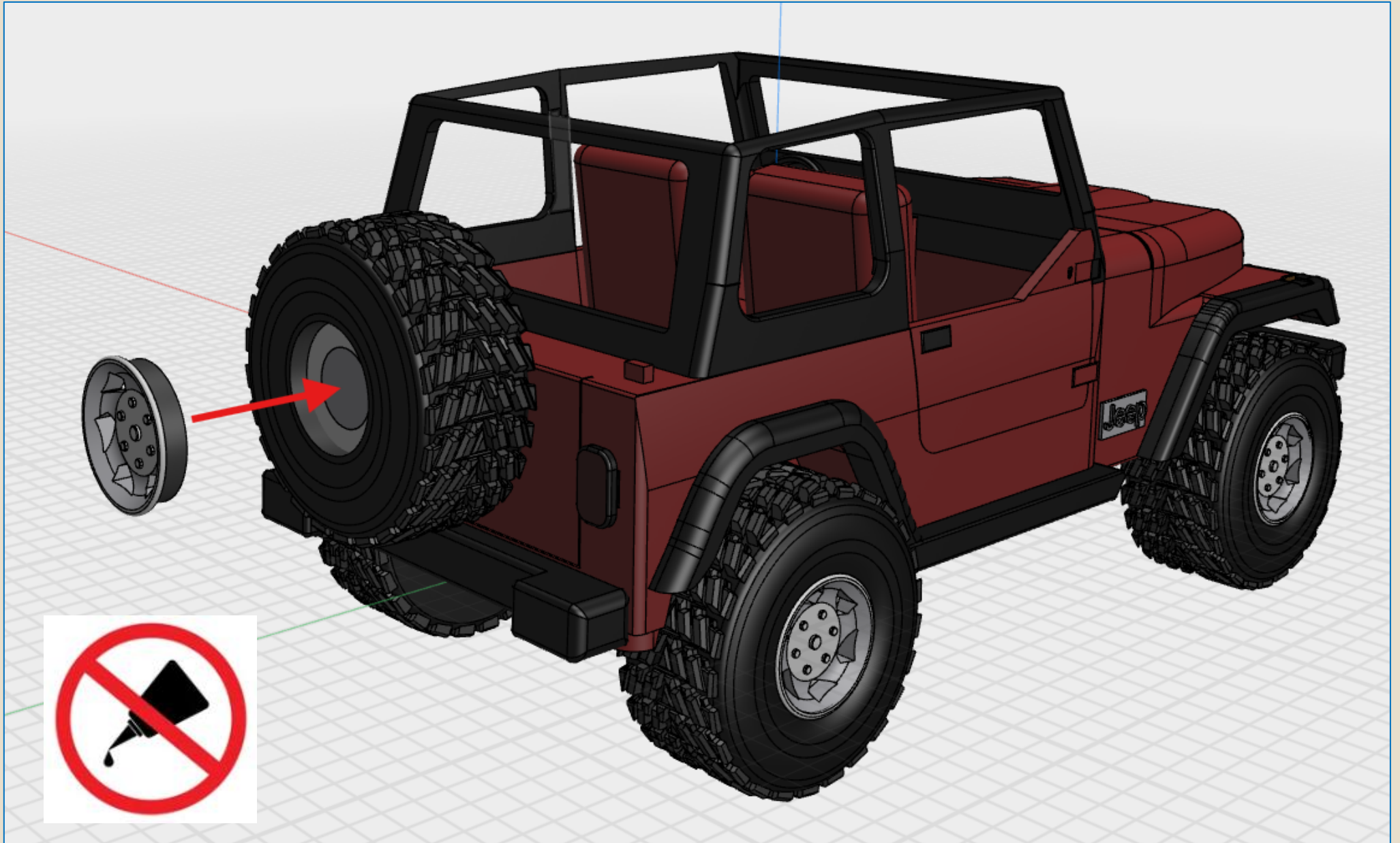
STEP 30 - Wheels\Wheel – Sprue E



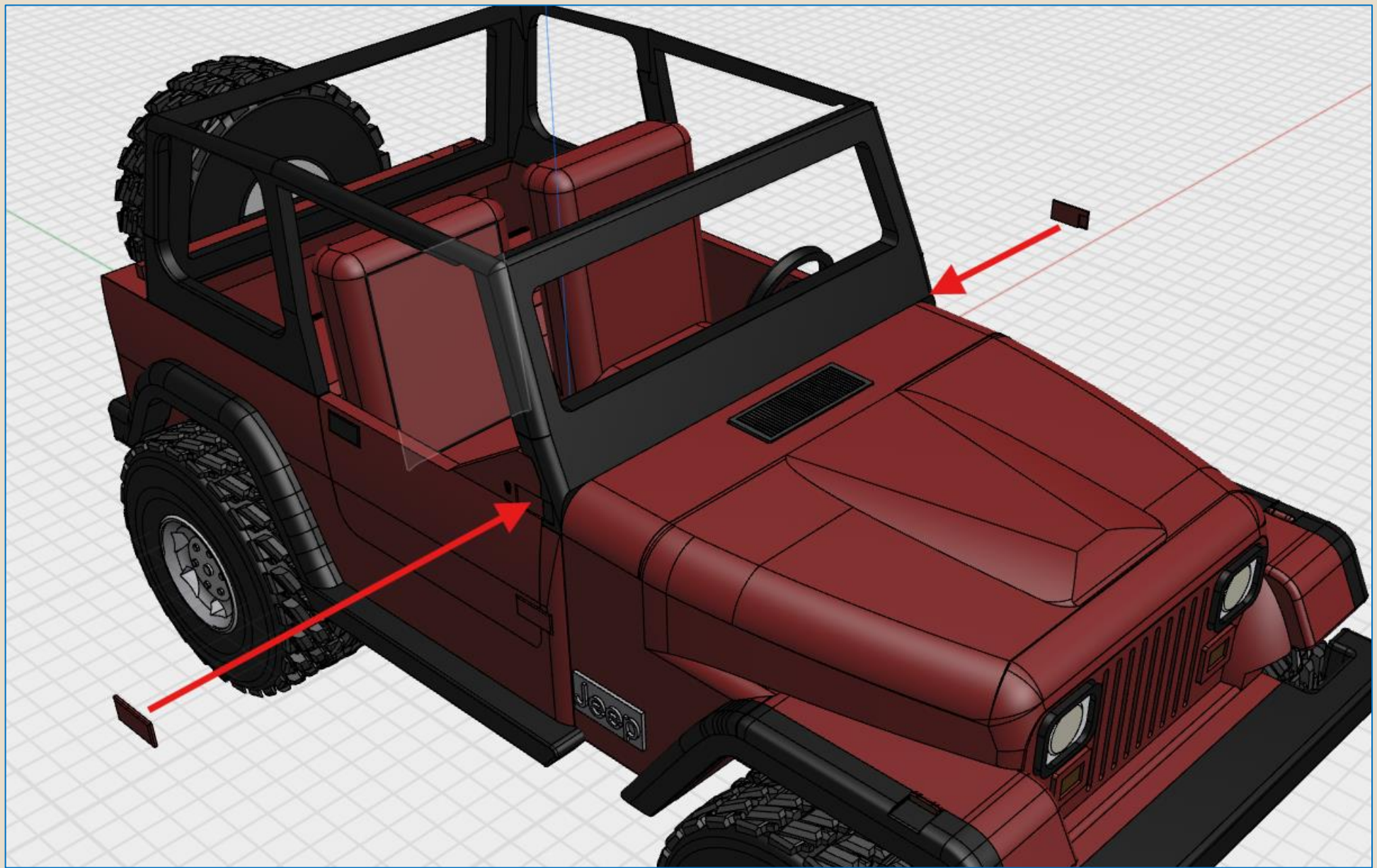
STEP 31 - Wheels\Tires\DriverSideTire - NOT ON SPRUE



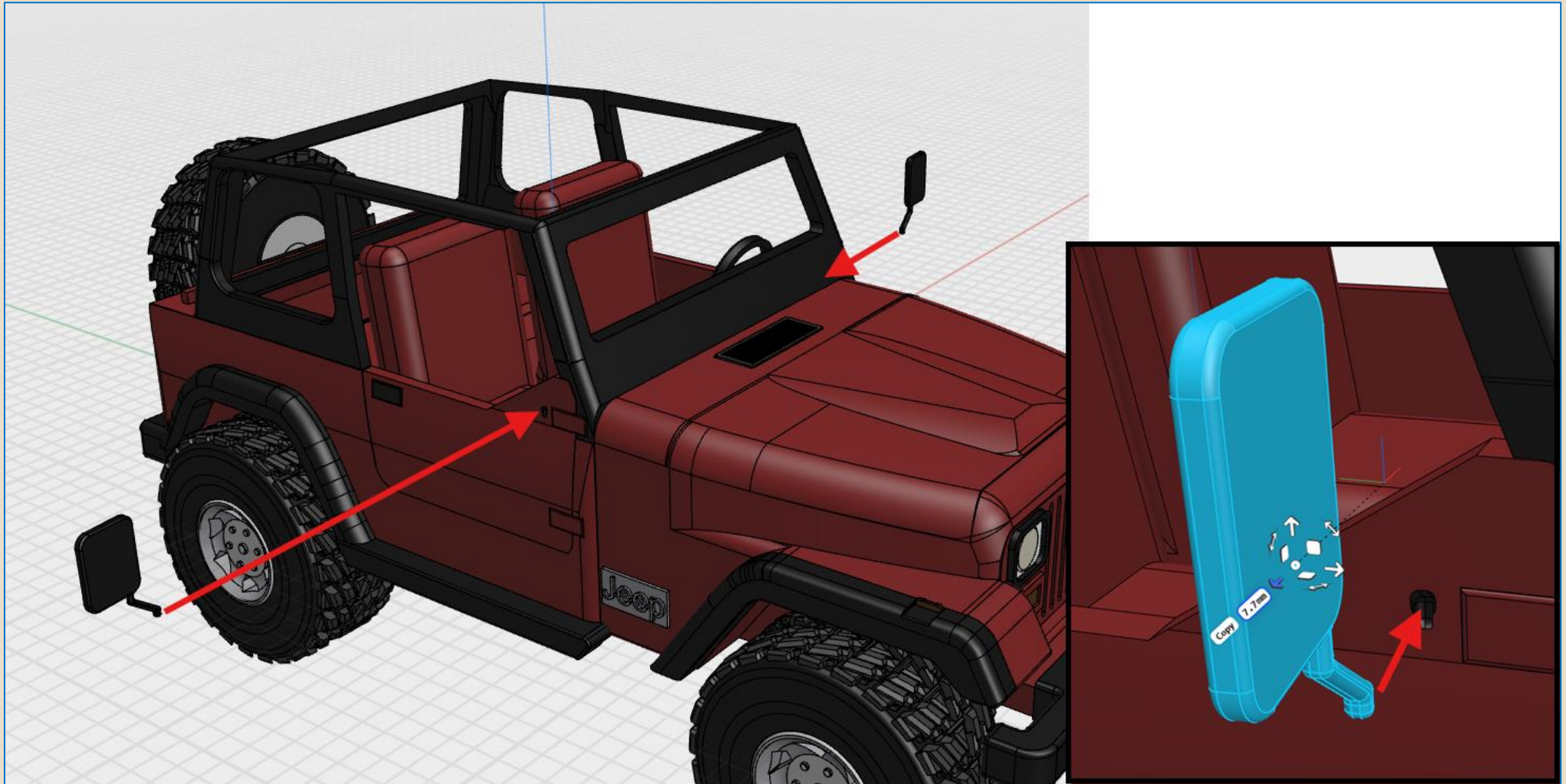
STEP 32 - Wheels\RimCover – Sprue E



STEP 33 - Chassis\DoorHinge – Sprue A x2



STEP 34 - Accessories\MirrorDr + MirrorPass – Sprue B



STEP 35- Accessories\RetractableRoof – NOT ON SPRUE

