

# PARAGON 9R

**INTRODUCTION:** The Paragon-9 was originally designed by Nofsky Industries / iPrintShit. *The Paragon 9R is a modified model, and re-texture by Macnay Arms.*

## INSTRUCTIONS:

- 1) For the **Paragon 9R**, there are **THREE** different options for printing:
  - A. **MA\_Paragon-9R\_GB-Mini.stl** – Hole for Goonbeam Mini Light.
  - B. **MA\_Paragon-9R\_GB-Mini\_MOD.stl** – Hole for Goonbeam Mini Light, and for light actuation.
  - C. **MA\_Paragon-9R.stl** – Standard version, no holes.
- 2) \*Want to save filament? This step is **OPTIONAL**, but recommended - See **Eye Zee Eye's** quick and great video on how to save filament on specific areas of your prints using Cura (and follow their social media) at: [instagram.com/p/Ci8Ak4ojvZH/](https://www.instagram.com/p/Ci8Ak4ojvZH/) or try printing "Paragon9S\_MainFrame\_01\_HOLLOW.stl"

## FDM SETTINGS [suggestions are in purple – not all settings, just a baseline]

Resolution/Layer Height:	.16-.2
Walls:	8 (or more)
Bottom Layers:	8 (or more)
Top Layers:	8 (or more)
Infill:	99% - 100% or 9999 lines OR use per model settings*
Print Speed:	85% - 100% (normal)
Supports:	YES*
Raft:	Always optional, but not required / NO
Build Plate Adhesion:	Brim
Filament:	PLA, PLA+, Nylon 12, PA12-CF, etc