

## SURE ANGLE SHARPENER – 3D PRINT INSTRUCTIONS

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Material for clamp should be PA or Nylon 66. Sunlu Easy PA works very well at 265C and a 50C bed with 30% fan. Also, use bed glue on a textured surface and slow your print down.

The Insert for the clamp should be any generic TPU.

All parts print without support. Holes do not need support.

Apply a little oil to the hone wand end where the trigger is assembled if desired, you may have to shave with a knife depending on the accuracy of your printer.

Parts should be printed with at least 20% fill and gyroid infill. I'd recommend 8 walls for the Clamp.

Paint embossed areas with solvent based paint if desired using a pad print or felt tip applicator.

Please see our parts list online or purchase one from [SureAngle.com](http://SureAngle.com)

Thank you and have fun printing!