Built for the filament forge

Twelve ancient beasts.
Flesh forgotten. Instinct endures.

The Sunderbone March is designed for FDM printing, with substantial creature forms and scenic bases. Preserve the supplied size for your first print and use supports.

The inspected models measure approximately 60.3-96.9 mm tall including their bases. The saved process name contains "75MM"; it is not the measured height of every model.

This guide uses the 12 saved Bambu Studio projects and the owner's November 15, 2026 screenshots. Sliced previews are not physical print-test results.



01 Match the project to your equipment

Open a 3MF as a project to inspect its saved settings. Select your actual printer, installed nozzle, plate and loaded filament. For mesh imports into another slicer, configure that machine from its own profile. Never send another machine's G-code.

02 Keep the base flat and check every layer

Use millimeters and uniform scaling. Inspect jaws, horns, claws, belly overhangs, tails and scenic details. Confirm the model and supports fit the plate. The reference slices use one filament; the saved spool list does not require multicolor printing.

03 Re-slice after changes

Supports are enabled in all 12 saved projects and visible in the supplied previews. Re-slice after changing printer, size, filament or process. Review support contact areas before starting.

The reference FDM setup

Setting	All 12 saved projects
Printer / nozzle	Bambu Lab H2S / 0.4 mm
Layer / initial layer	0.16 mm / 0.20 mm
Walls / infill	4 walls / 5% gyroid
Top / bottom shell layers	6 / 5
Supports	Tree (auto); enabled; 25-degree threshold
Build plate only	Off; supports can start on the model
Top / bottom support Z gap	0.31 mm / 0.18 mm
Support/object XY gap	0.25 mm
Top / bottom interface layers	4 / 2
Top interface spacing	0 mm
Support base pattern spacing	2.5 mm
Brim	Auto; 5 mm configured
Filament / plate	PLA Basic / Cool Plate SuperTack

The settings above were read from the saved Sunderbone projects. The screenshots show 0.16 mm layers and the resulting estimates, but do not expose every advanced setting. Re-slice for your setup; a screenshot and an older save may differ.

Use the current temperature, cooling and motion profile for your actual printer, filament and plate. Support-gap changes affect both removal and underside quality; test adjustments before committing to a full miniature. Source projects have not been changed.

Time, material and dimensions

ID / character	W x D x H (mm)	Total time	PLA total
SM-001 / Varkhoss	98.0 x 86.9 x 73.4	5h 42m	67.70 g
SM-002 / Mournhorn	98.0 x 98.0 x 73.9	6h 08m	81.72 g
SM-003 / Gravemallet	97.0 x 98.0 x 70.4	6h 13m	80.62 g
SM-004 / Cairnspine	98.0 x 86.3 x 60.3	4h 07m	51.61 g
SM-005 / Siltmaw	98.0 x 72.9 x 61.2	3h 31m	43.97 g
SM-006 / Ashscar	98.0 x 80.1 x 61.8	4h 02m	48.89 g
SM-007 / Knellskull	98.0 x 94.1 x 63.9	4h 54m	63.69 g
SM-008 / Dirgecrest	98.0 x 85.5 x 61.8	4h 03m	51.43 g
SM-009 / Rakeveil	98.0 x 97.4 x 96.9	10h 50m	70.13 g
SM-010 / Gravetread	97.9 x 86.0 x 60.3	5h 05m	65.64 g
SM-011 / Dolmara	98.1 x 96.5 x 93.0	6h 02m	76.46 g
SM-012 / Nightsplinter	98.0 x 84.3 x 63.8	4h 27m	53.75 g

One of each: 755.61 g including supports; 65h 04m summed machine time. Parallel printers can reduce elapsed time, but not the summed machine hours.

Times and totals are transcribed from the supplied slices, including preparation and supports. Re-slice for current estimates and keep extra filament available. Small differences between displayed component weights and totals come from slicer rounding.

Dimensions are measured from the saved 3MF meshes with identity scale/rotation. They include bases and projecting details: these are full bounding boxes, not base diameters. All 12 archive numbers are included.

Protect the detail

04 Cool, then remove

Follow your plate manufacturer's release instructions and allow the print to cool. Wear eye protection when clipping supports. Support the base and keep the cutting area clear.

05 Work from trunks toward contact tips

Cut supports into small sections. Brace the nearest jaw, horn, claw, neck or tail while freeing each branch. Avoid twisting a complete tree against the sculpt. Keep sharp tools pointed away from your hands.

06 Finish with light passes

Trim remaining nubs carefully and sand only where needed. Use a compatible primer and thin paint coats to preserve fossil textures. Heat can deform PLA; a heat gun is not required.

Rakeveil needs extra cleanup time

SM-009 is the support-heavy exception: 26.03 g model, 44.11 g supports, 70.13 g total and 10h 50m in the supplied slice. Supports account for about 63% of its total material. Protect the claws, beak and burial-stone contacts. Do not reduce support coverage solely to save material without reviewing and testing the new slice.

Detail loss or slow slicing

Return to the supplied size and inspect the toolpaths. Scaling down makes teeth, horns and claws thinner. These meshes contain roughly 1.9-2.0 million triangles each. Allow processing time; if simplifying, keep the original and inspect the fine detail and slice afterward.

Reference for support-gap tradeoffs: Bambu Lab P2S 3D Printing User Manual, Chapter 5. Collection settings and estimates come from the supplied Sunderbone projects and screenshots.

The twelve of Sunderbone

SM-001 Varkhoss, the Crown-Eater

Brace the jaw and short arms while clipping supports beneath the chest; protect the teeth and tail tip.

SM-002 Mournhorn, the Last Bulwark

Support the frill and each horn from behind; cut branches away from their tips.

SM-003 Gravemallet, the Barrow Warden

Free the belly and tail-club underside in small sections without levering against the armored back.

SM-004 Cairnspine, the Procession Guard

Brace the back plates and tail spikes while freeing nearby support contacts.

SM-005 Siltmaw, the Drowned Oracle

Protect the long snout and sail edge. Clear the belly without pulling on the tail.

SM-006 Ashscar, the Horned Pursuer

Support the horns, jaw and small arms; work carefully beneath the chest.

Collection page | Aurelion registry
The separate Registry QR PDF connects to all 12 permanent records. Registry access does not grant a model license.

The twelve of Sunderbone

SM-007 Knellskull, the Tombbreaker

Brace the head and tombstone contact. Cut supports without twisting the head against the stone.

SM-008 Dirgecrest, the Herdcaller

Support the curved crest and neck. Remove underside contacts without using the crest as a handle.

SM-009 Rakeveil, the Sepulcher Harvester

Work slowly around the claws, beak and burial stone. Clip the dense supports into small pieces and brace the nearest detail.

SM-010 Gravetread, the Nestkeeper

Protect the eggs and forefeet; clear the nest without levering against small scenic details.

SM-011 Dolmara, the Walking Barrow

Brace the long neck and head. Free supports around the ruin and chest a little at a time.

SM-012 Nightsplinter, the Last Hunter

Protect the narrow claws, jaw and feather-like edges. Brace the tail while removing nearby branches.

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