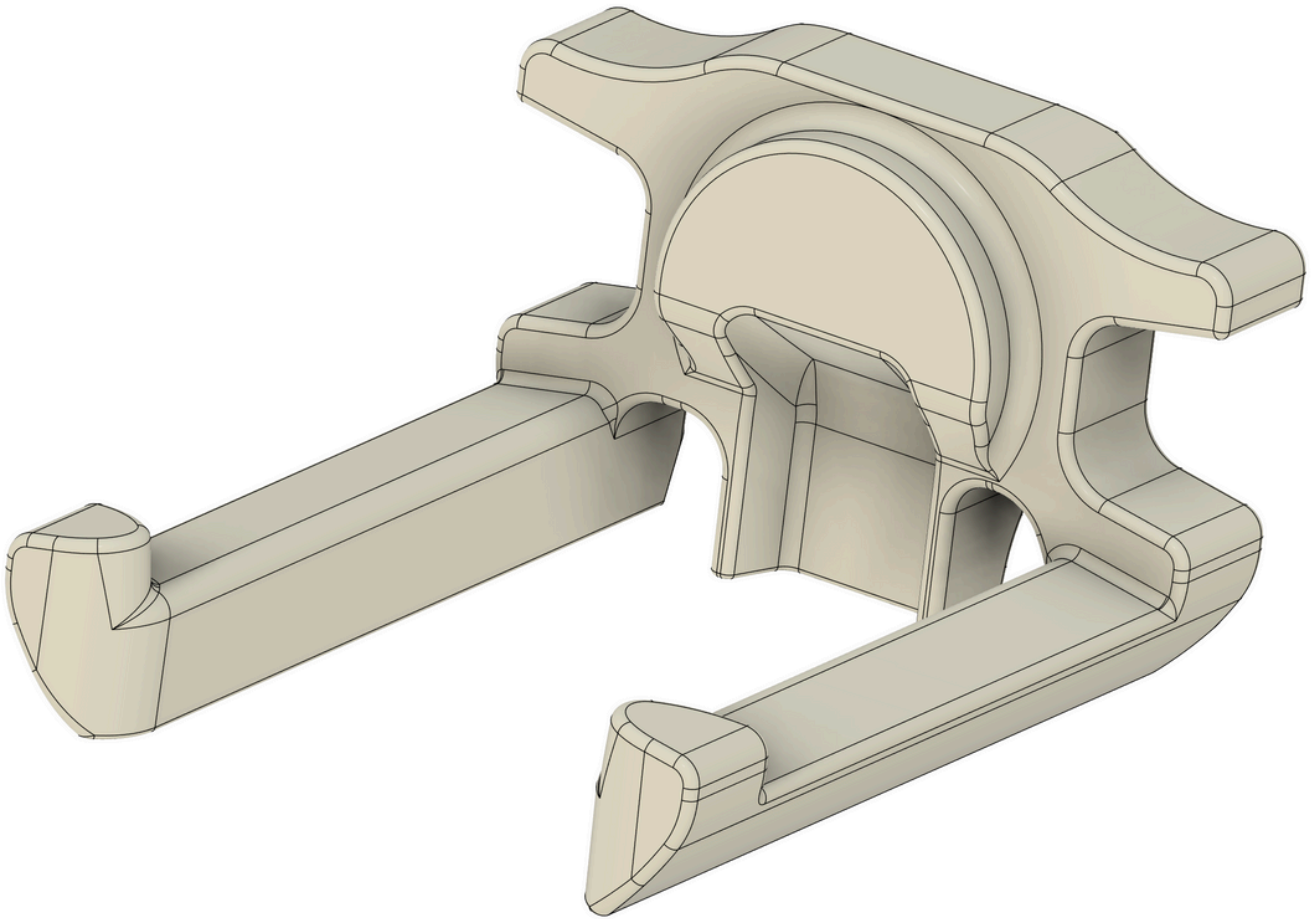


MP5 Trip Slip V3



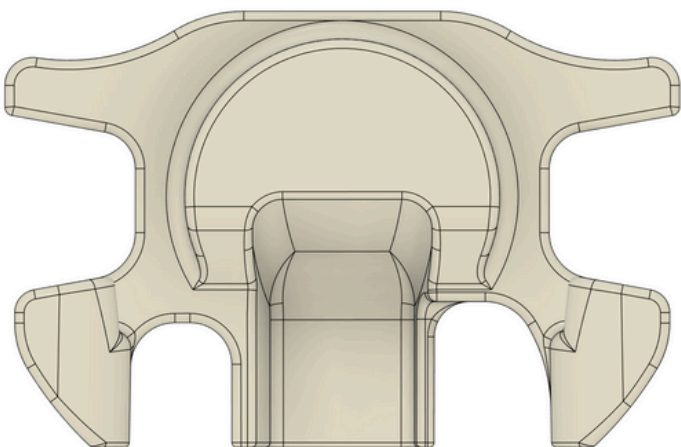
Warning about metal slip trips

The printed slip trip is designed around pla pro not metal so making it in metal will end up making it weigh at least 6x as much as one printed in pla pro. The durability of a printed slip trip should be well past 1000 rounds even with below average print settings. I had a slip trip last over 3 thousand rounds of 124 grain NATO.

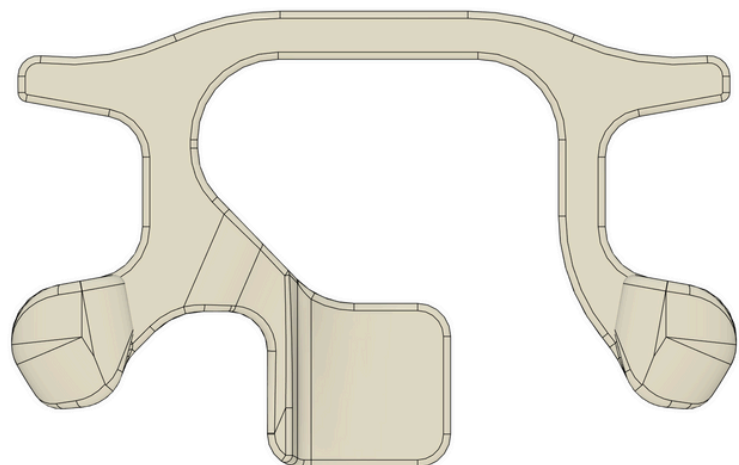
This added weight from making the slip trip in metal can cause the slip trip to slam forward potentially causing damage. I would recommend you all to just print slip trip in PLA pro or nylon as intended. Regardless of what i say i know people will attempt to have them made in metal so i will be releasing a metal version on my odysee @s3igu2 so look around for that version if you must make it in metal. That said please do not attempt to make the version of this slip trip in this pack in metal.

Here is how you can tell the Printed Slip trip apart from the Metal slip trip.

3D Printed in PLA Pro or
Nylons ONLY Slip trip



Slip trip designed to be made
in metal



Slip Trip Durability

The printed slip trips in basic PLA Pro have lasted past 3,000 rounds and could have lasted much longer if the firearm was configured to reduce stress on the trip.

There are a few factors that determine the lifespan of a slip trip.

Print Settings: The print settings you use will be a significant factor in how durable the slip trip is. Any under-extrusion or poor layer adhesion will cause the trip to break sooner than expected.

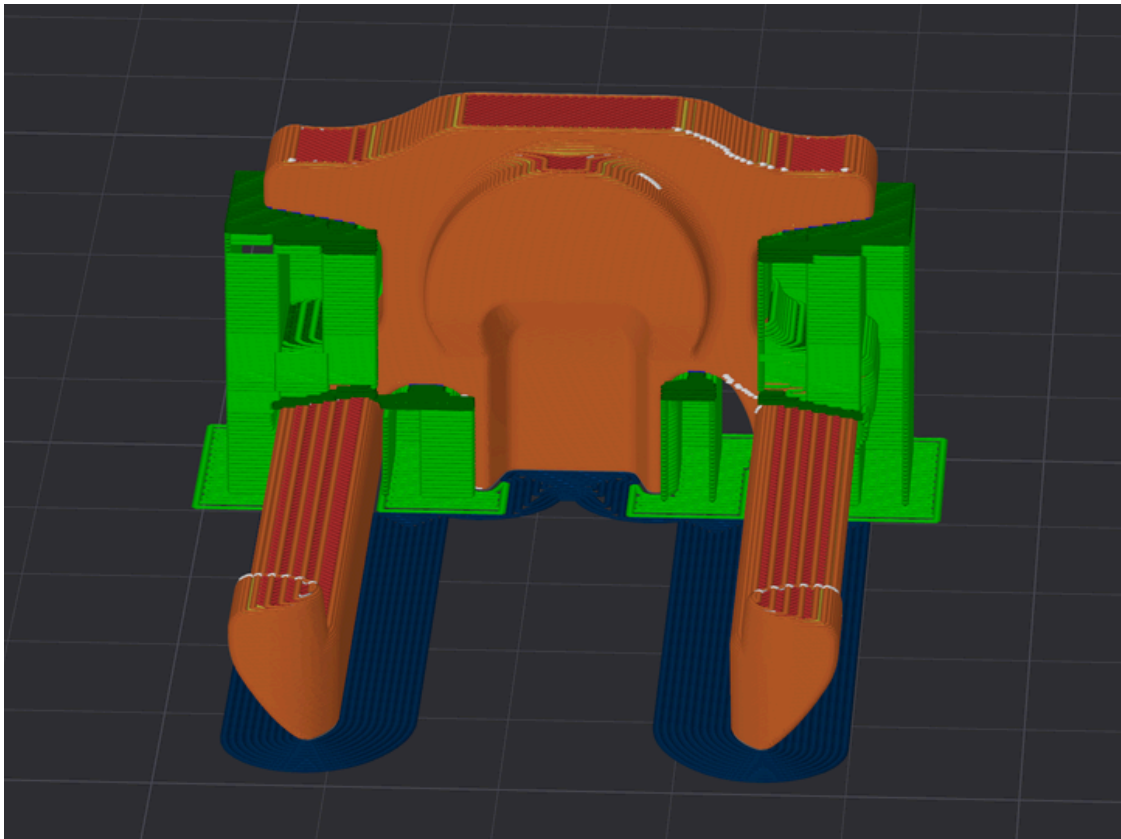
Material Selection: PLA Pro is currently the most durable option as it allows for strong layer adhesion as well as good flexibility, meaning it is much less likely to break.

Full Auto Carrier Denial Fitment: If the carrier denial in the receiver is misaligned or abnormal, it can make contact with the slip trip, causing premature damage. This can be fixed by modifying the slip trip to fit past the carrier smoothly.

Carrier Energy: If your gun is running abnormally hard due to a suppressor, high-locking piece, or high-powered ammo (especially in combination with a suppressor and a high-locking piece), you need to reduce carrier velocity with a lower locking piece. You should be doing this anyway to avoid unnecessary wear on the gun. A high rate of fire is a clear sign that something needs to be corrected.

Lee Sporting Lowers: Lee Sporting lowers are known to break slip trips much faster than the Leber V1, Leber V2, ARMP5 V2, and ARMP5 V3. This is due to the optimal FCG placement in those models.

Print Settings



Everything is designed to work in PLA Pro, other options - Polymaker PA6-CF if you want a more high temp option see my odysee guide @s3igu2 for exact settings if you plan to print in polymakers pa6-CF.

STL files are orientated correctly make sure you have a brim for the trip face.

- Temp: 220/60C (PLA PRO)
- Nozzle: 0.4mm
- First Layer Height - 0.20 (Or 0.15)
- Layer Height - 0.15
- Wall Loops - 4 Walls Max
- Infill - 100% Rectilinear

Print speed should be below 70MM/s

After printing make sure the brim and all support structures are removed

Trip Slip Install

- The trip slip grabs onto the back of the bolt carrier like so and is pulled as the carrier moves forward.



- When fully collapsed the trip slip should sit flush against the back of the bcg without pushing the 2 front arms out.



- Slide the Bolt carried group into the receiver with the trip slip sitting half way on the bolt carrier like so, it should slide easily into the receiver with no issues.

