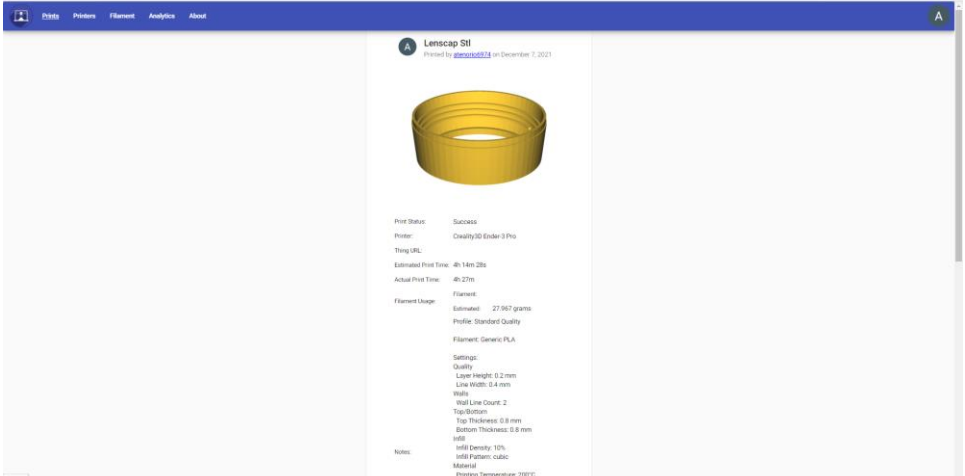


# 3d Printing Build Documentation Sheet

A 'Build' is any time you generate G-Codes and load them on a machine a it runs long enough to complete the first layer

Name	Ailin Tenorio	Date/Time	12/7/2021
Lab/Project	LENSCAP	Build #	4

## Build Log Entry



**Lencap Stl**  
Printed by [Ailin Tenorio](#) on December 7, 2021

**Print Status:** Success

**Printer:** Creality3D Ender 3 Pro

**Print Job:**

**Estimated Print Time:** 4h 14m 28s

**Actual Print Time:** 4h 27m

**Filament Usage:**

**Estimated:** 27.967 grams

**Profile:** Standard Quality

**Filament:** Generic PLA

**Settings:**

**Quality:**

**Layer Height:** 0.2 mm

**Line Width:** 0.4 mm

**Wall:**

**Wall Line Count:** 2

**Top Bottom:**

**Top Thickness:** 0.8 mm

**Bottom Thickness:** 0.8 mm

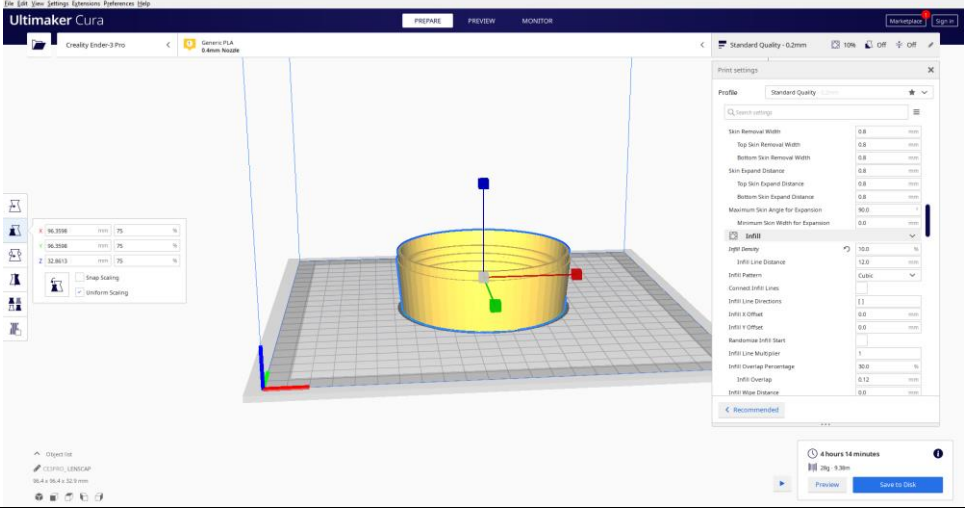
**Infill:**

**Infill Density:** 10%

**Infill Pattern:** cubic

**Material:**

**Printing temperature:** 205°C



**Ultimaker Cura**

**Print settings**

**Profile:** Standard Quality

**Search settings**

**Skin Removal Width:** 0.8 mm

**Top Skin Removal Width:** 0.8 mm

**Bottom Skin Removal Width:** 0.8 mm

**Skin Expand Distance:** 0.8 mm

**Top Skin Expand Distance:** 0.8 mm

**Bottom Skin Expand Distance:** 0.8 mm

**Maximum Skin Angle for Expansion:** 90.0 mm

**Minimum Skin Width for Expansion:** 0.0 mm

**Infill**

**Infill Density:** 10.0 %

**Infill Line Distance:** 12.0 mm

**Infill Pattern:** Cubic

**Connect Infill Lines:**

**Infill Line Directions:** 11

**Infill X Offset:** 0.0 mm

**Infill Y Offset:** 0.0 mm

**Separate Infill Start:**

**Infill Line Multiplier:** 1

**Infill Overlap Percentage:** 80.0 %

**Infill Overlap:** 0.12 mm


**Infill Wave Distance:** 0.0 mm

**4 hours 14 minutes**


**2h 53m**

**Preview** **Save to G-Code**

## Preview in Slicer



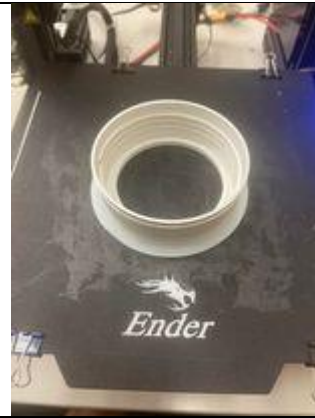
**Machine Control Panel after 1<sup>st</sup> Layer Complete**



**Build plate after 1<sup>st</sup> layer has printed**



Machine Control at end of Build



Build(parts) on Build plate after job completed or aborted

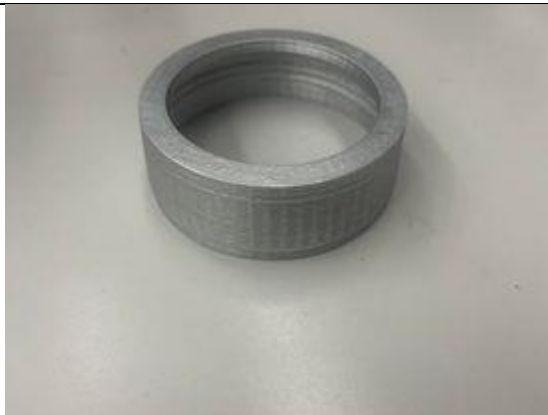


Photo of Build after removal from machine

1. To finish the piece, sand the piece with the machine shown in the photo.



2. For the final finish I used paint.



**3.Final product with the part assembled with the Flashlight**



**Description/Comments**