# 3D Printing Summary

|  |  |  |
| --- | --- | --- |
| Metric | Individual Parts | Set |
| Total Print Time (min) |  | 2:23 |
| Total Number of Components | 4 | 4 |
| Typical Total Mass (g) | 30 | 30 |
| Typical Number of Print Setups | 4 | 1 |

# Customization Options

If available, it may be desirable to print the FreedomWing\_Lid in transparent filament to better allow the LED light to be seen.

# 3D Printing Settings

Parts should be printed in PLA or PETg. The parts can be printed individually or as a set.

## Individual Parts

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| Print File Name | Qty | Total Print Time (hr:min) | Mass (g) | Infill (%) | Support (Y/N) | Layer Height/ Nozzle Diameter (mm) | Notes |
| FreedomWing\_Case.stl | 1 | 1:35 | 18 | 20 | N | 0.2/0.4 |  |
| FreedomWing\_Lid.stl | 1 | 0:34 | 9 | 20 | N | 0.2/0.4 | Consider transparent filament |
| FreedomWing\_NutTrapperA.stl | 1 | 0:05 | 1 | 20 | N | 0.2/0.4 |  |
| FreedomWing\_NutTrapperB.stl | 1 | 0:17 | 2 | 20 | N | 0.2/0.4 |  |

## Set – Single Color

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| Print File Name | Qty | Total Print Time (hr:min) | Mass (g) | Infill (%) | Support (Y/N) | Layer Height/ Nozzle Diameter (mm) | Notes |
| FreedomWing\_Set.stl | 1 | 2:23 | 30 | 20 | N | 0.2/0.4 |  |

# Post-Processing

Standard post-processing to remove any bumps or zits.