Part	Quant. Needed	Time Each (Hours)	Filament Usage Each (grams)	Filament Usage (grams)	Settings
Rise/Fall Block	2	0.983	8	16	0.2 layer height, 3 walls, 50% infill, adaptive layers, tree support with lines interface, flip part so trapezoid mating surface is facing upward
Rise/Fall Knob	2	0.933	9	18	0.2 layer height, 3 walls, 50% infill, supports, adaptive layer height
Tilt Block (front)	1	1.283	10	10	0.2 layer height, 3 walls, 60% infill, adaptive layers, flipped so frame interface slot is down, use normal supports, random z seam
Tilt Block (rear)	1	1.200	8	8	0.2 layer height, 3 walls, 60% infill, flipped so swing mating surface is down, use normal supports, random z seam
M8 plug for Rise/Fall block	2	0.083	1	2	0.2 layer height, 3 walls, 60% infill, adaptive layers
Tilt Knob	2	1.033	7	14	0.16 layer height, 3 walls, 60% infill, adaptive layers, supports, random z seam
Tilt Knob Cap	2	0.117	1	2	0.2 layer height, 3 walls, 20% infill, adaptive layers, random z seam
Front L Arm	1	9.950	84	84	0.2 Layer height, 3 walls, alternate extra wall, 40% infill, supports, suport blockers on zero grooves & detents
Rear L Arm	1	10.083	87	87	0.2 Layer height, 3 walls, alternate extra wall, 40% infill, supports, suport blockers on zero grooves & detents
Repositionable Back	1	6.000	52	52	0.2 layer height, 3 walls, 30% infill, supports, support blockers on all magnet holes.
Repositionable Back Frame	1	7.117	66	66	0.2 layer height, 3 walls, alternate extra wall, 30% infill, supports, support blockers on all M3 holes.
Swing Knob	2	1.500	14	28	0.2 layer height, 3 walls, 50% infill, supports, adaptive layer height
Swing Knob cap	2	0.183	1	2	0.2 layer height, 3 walls, 50% infill
Frame QR Slider	2	2.950	28	56	0.2 layer height, 3 walls, 50% infill, supports
Bellows locking plates	5	0.250	2	10	0.2 layer height, 3 walls, 50% infill
Front Frame	1	5.800	47	47	0.2 layer height, 3 walls, 50% infill, supports
Bellows Frame	2	1.367	11	22	0.2 layer height, 3 walls, 50% infill
Lens Board	1	3.500	31	31	0.2 layer height, 3 walls, alternate extra wall, 50% infill, adaptive layers
Lens Board Sliding Plate	1	0.283	2	2	0.2 layer height, 3 walls, 50% infill
M3 Thumbscrew	2	0.317	1	2	0.2 layer height, 3 walls, 50% infill, supports
M3 Thumbscrew Cap	2	0.033	0.1	0	0.2 layer height, 3 walls, 50% infill
Ground Glass Holder (front)	1	2.500	21	21	0.2 layer height, 3 walls, 50% infill
Ground Glass Holder (rear)	1	2.217	17	17	0.2 layer height, 3 walls, 50% infill
Graflok slider	2	0.617	4	8	0.2 layer height, 3 walls, 50% infill
Graflok slider spacer	4	0.017	0.1	0	0.2 layer height, 3 walls, 50% infill
Graflok slider washer	4	0.017	0.1	0	0.2 layer height, 3 walls, 50% infill
Rear Focusing Mount	1	1.850	14	14	0.2 layer height, 3 walls, 50% infill, supports, flip part so bore is vertical
Front Carriage Focusing Mount	1	0.917	7	7	0.2 layer height, 3 walls, 50% infill, flip part so lead screw nut mount is facing upwards
Lead Screw Sleeve	1	0.150	1	1	0.2 layer height, 4 walls
Magnifying Hood Eye Cup	1	1.250	8	8	0.2 layer height, 3 walls, 50% infill, supports
Magnifying Hood Tunnel	1	5.283	37	37	0.2 layer height, 3 walls, tree supports
Magnifying Hood Lower Lens Holder	1	0.850	6	6	0.2 layer height, 3 walls, supports, 50% infill
Front Carriage	1	3.233	30	30	0.2 layer height, 3 walls, supports, 50% infill
Focus lock knob	1	0.683	5	5	0.2 layer height, 3 walls, supports, 50% infill
Focus lock knob cap	1	0.117	1	1	0.2 layer height, 3 walls, 50% infill
Rail tripod mount	1	2.050	17	17	0.2 layer height, 3 walls, 50% infill, supports, flip so top surface of part faces downward
Front Carriage wheel spacers	2	0.117	0.1	0	0.2 layer height, 3 walls, 50% infill
Bubble Level Holder	1	0.283	1	1	0.16 layer height, 3 walls, 50% infill
Recessed Lens Board	Optional				

Item	Description	Quantity	Example Source URL
Arca quick release plate	Arca compatible quick release plate for horizontal slide and quick disassembly	2	https://www.ebay.com/itm/264632467937?hash=item3d9d5301e1:g:9f4AAOSwfTpfdLnu
M3 button head screws	M3 screws to be used throughout	1	https://www.amazon.com/HELIFOUNER-Pieces-Button-Washers-Stainless/dp/B09WJ1C8JP
M4 x 45mm hex head screws	For tilt knobs, preferably stainless steel	2	https://www.boltdepot.com//Product-Details.aspx?product=23434
1/4-20 x 1.5" Hex head bolts and nuts	For swing knobs, preferably stainless steel	2	Just about any hardware store
M3 heat set threaded inserts		pack of 50	https://www.amazon.com/initeq-M3-0-5-Threaded-Inserts-Printing/dp/B077CL322T
M4 heat set threaded inserts		pack of 20	https://www.amazon.com/initeq-M4-0-7-Threaded-Inserts-Printing/dp/B07457F9ST
20x40 Aluminum extrusion	Length depends upon focal length of lens you want to use	1	https://openbuildspartstore.com/v-slot-20x40-linear-rail/
8mm Lead Screw	Length should be similar to extrusion	1	https://openbuildspartstore.com/8mm-metric-acme-lead-screw/
Jog Knob		1	https://openbuildspartstore.com/jog-knob/
Lock collar		1	https://openbuildspartstore.com/lock-collar/
Round lead screw brass nut		1	https://www.amazon.com/ReliaBot-Thread-Starts-Diameter-Printer/dp/B079HQ386R
Delrin mini v wheels		4	https://openbuildspartstore.com/delrin-mini-v-wheel-kit/
M5 lock nuts		1 pack	https://openbuildspartstore.com/nylon-insert-hex-locknut-m5-10-pack/
Double Tee nut		3	https://openbuildspartstore.com/double-tee-nut/
M5x30mm low profile screws		1 pack	https://openbuildspartstore.com/low-profile-screws-m5-10-pack/
M5x10mm screws		2	Most hardware stores
6mm Eccentric spacer		2	https://openbuildspartstore.com/eccentric-spacer/
M8x20mm Hex head hollow bolts (M4 hole)	Center hole should be 4.2mm to allow M4 bolt, must have hex head	2	https://www.amazon.com/dp/B09VL3D34G
M8 nuts		2	Most hardware stores. If you order the above bolts from Amazon, the nuts come with them
Standard 22mm OD skateboard bearings	608 style, with 8mm inner diameter. No need for expensive bearings!	2	Many, many brands and sources - Amazon or a local skate shop
Ground Glass, 68x78x1.5mm	Plain ground glass is fine and less expensive, but strongly consider bright screen	1	https://rickoleson-brightscreen.com/
Bellows	100x100mm outer dimensions on front & back, 80x80mm inner dimensions on front and back. Length will be determined by focal length of your lens		http://www.custombellows.co.uk/
9mm OD 0.4mm wall thickness steel tubing	Optional - for more durable focusing lock - cut a 10mm section	1	https://www.amazon.com/uxcell-Stainless-Thickness-Seamless-Straight/dp/B081J38P11