



About STEMFIE Essentials

This ZIP file contains an assortment of commonly used STEMFIE parts in different sizes nestled into compact build plates measuring less than 140x140x140 mm (5 ½ inches squared), which fits comfortably in most 3D printers' build volume.

Start by importing each .3mf file into your 3D printer's slicing software. All components are oriented to 3D-print optimally **without support structures**. Please ensure a flat, clean build plate and calibrate it well.

If you use a filament-based 3D printer (FDM/FFF), I recommend PLA or PETG material for making STEMFIE parts. In addition, the following printing settings work well for making STEMFIE parts.

- Material: PLA filament
- Layer height: 0.2 mm
- Perimeters (shells): 3
- Top solid layer count: 4
- Bottom solid layer count: 3
- Infill: 15%
- Generic print speed: 50 mm/s
- No support structures

For more information about the STEMFIE project and to download the complete range of parts, please visit <https://stemfie.org/download>.

Make sure to be the first to know about new releases of STEMFIE parts and projects! Please subscribe to the newsletter (<https://newsletter.stemfie.org>) and follow @Stemfie3D #Stemfie3D on social media: <https://stemfie.org/news/socialmedia>.

STEMFIE is a **free and open-source** educational toy! So have fun 3D-printing lots of parts and inventing your project builds!

Paulo Kiefe
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