A picture containing screenshot, rectangle, square, pixel

Description automatically generated

You need to pause the print at 3.6mm if you are printing with 0.2mm layer height!!!  
And add 2x M3 square nuts.

A square object with a hole in the middle

Description automatically generated with low confidence

A picture containing pattern, screenshot, art, creative arts

Description automatically generated

Parts in the image are printed with PA12-CF15,

But you could print it with ABS or ASA. PLA and PETG not supported or tested.

**PA12-CF15 ABS or ASA**

Layer height: 0.2mm Layer height: 0.2mm

Perimeters: 4 Perimeters: 4

Solid layers Top: 5 Solid layers Top: 5

Solid layers Bottom: 5 Solid layers Bottom: 5

Infill: 40% Infill: 40%

Infill pattern: Grid Infill pattern: Grid  
Nozzle Temp.: 280C Nozzle Temp.: 255C  
Bed Temp.: 100C Bed Temp.: 90C  
Chamber Temp.: 48-50C Chamber Temp.: 40-45C  
Outer wall: 40 mm/s Outer wall: 45 mm/s

Inner wall 60 mm/s Inner wall 120 mm/s

Infill 80 mm/s Infill 140 mm/s

**No support needed!!! No support needed!!!**

As you are printing the parts without support. After the print is done, take Knipex Knips and cut out all the supports in red.

A picture containing screenshot

Description automatically generated A picture containing electronics

Description automatically generated