

How-To Make Base Supports



How-To Make Base Supports

Printer settings to be mindful of

1. Import file into your preferred slicer program.

2. Settings to be mindful of:

a. **Filament.** Recommended to use PETG or PETG-

CF. These work well in saltwater.

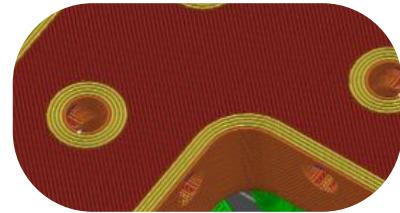
b. **100% infill vs. open model and gyroid infill**

To prevent implosion in deeper waters, the parts should either be **100% infill** or **open** to let water run through. Which setting you should use when depends on the desired durability, and which one we recommend for which part is specified in the guides on the next slides.

Note:

The examples are from the bamboo slicer but equivalent settings will exist on every slicer program. You only need to change the specified settings, the rest is fine as-is.

Airtight and 100% infill



To make the parts airtight increase infill density to **100%**. It is also recommended to set **wall loops/thickness** to **5** for increased durability.

Generic PETG

Process Global Objects Advanced

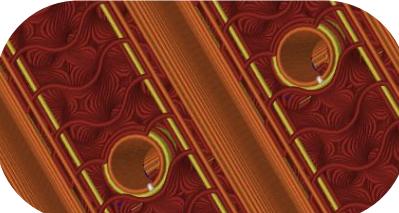
Strength

Walls

Top/bottom shells

Sparse infill

Open model and gyroid infill



To make an open solution, set **top** and/or **bottom shell layer** to **0** and change **sparse infill pattern** to "Gyroid".

Generic PETG

Process Global Objects Advanced

Strength

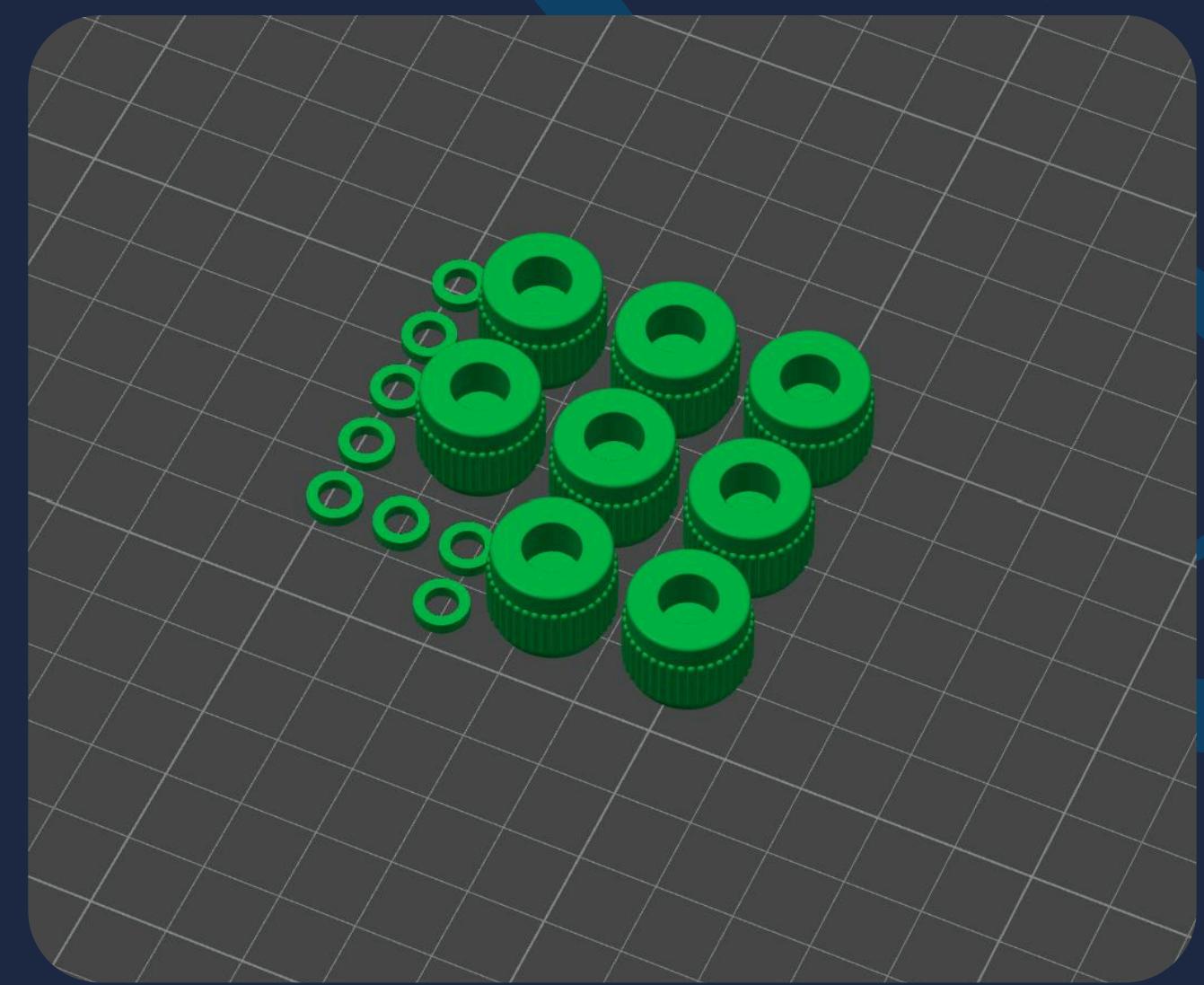
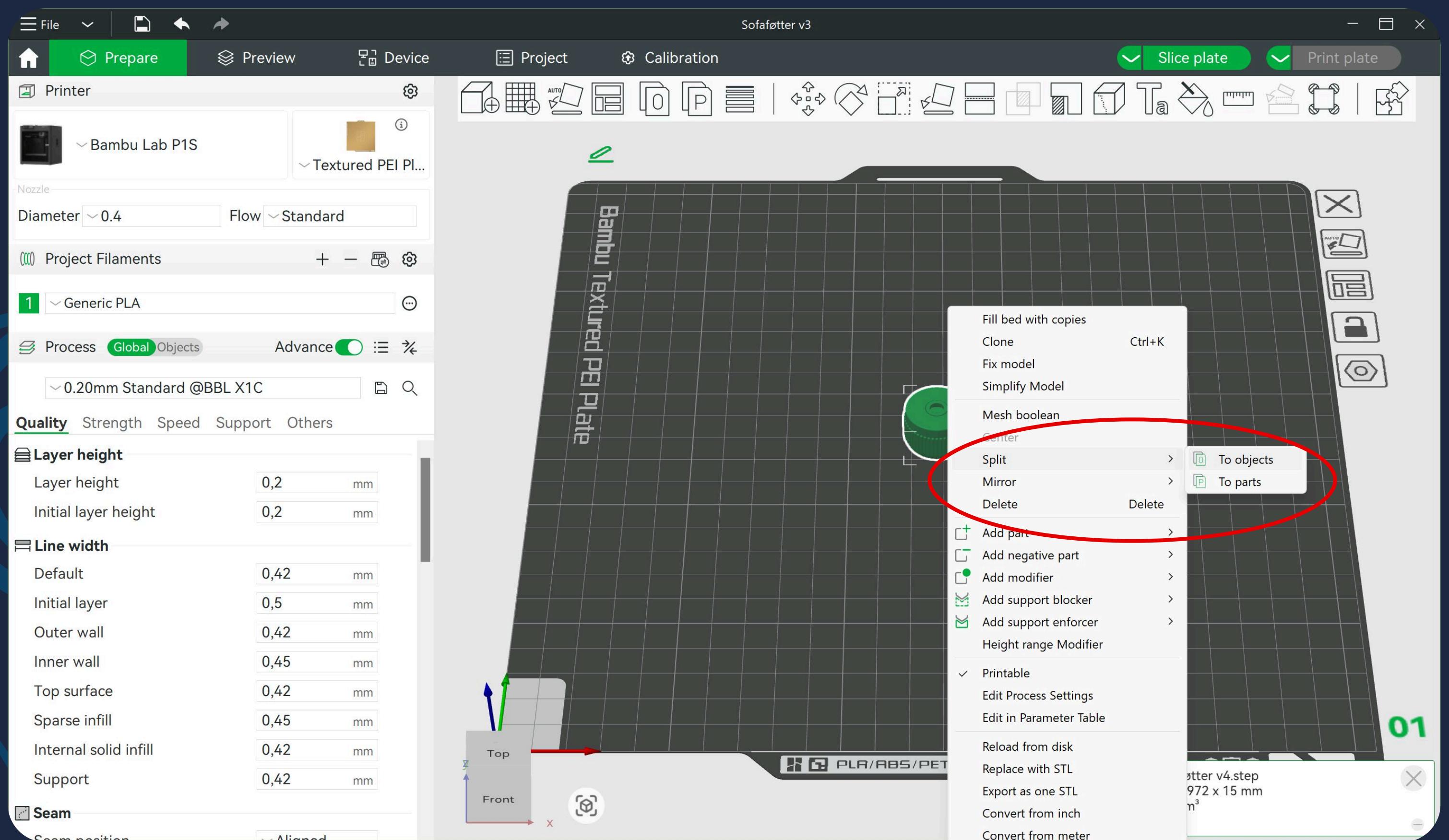
Walls

Top/bottom shells

Sparse infill

How-To Make Base Supports

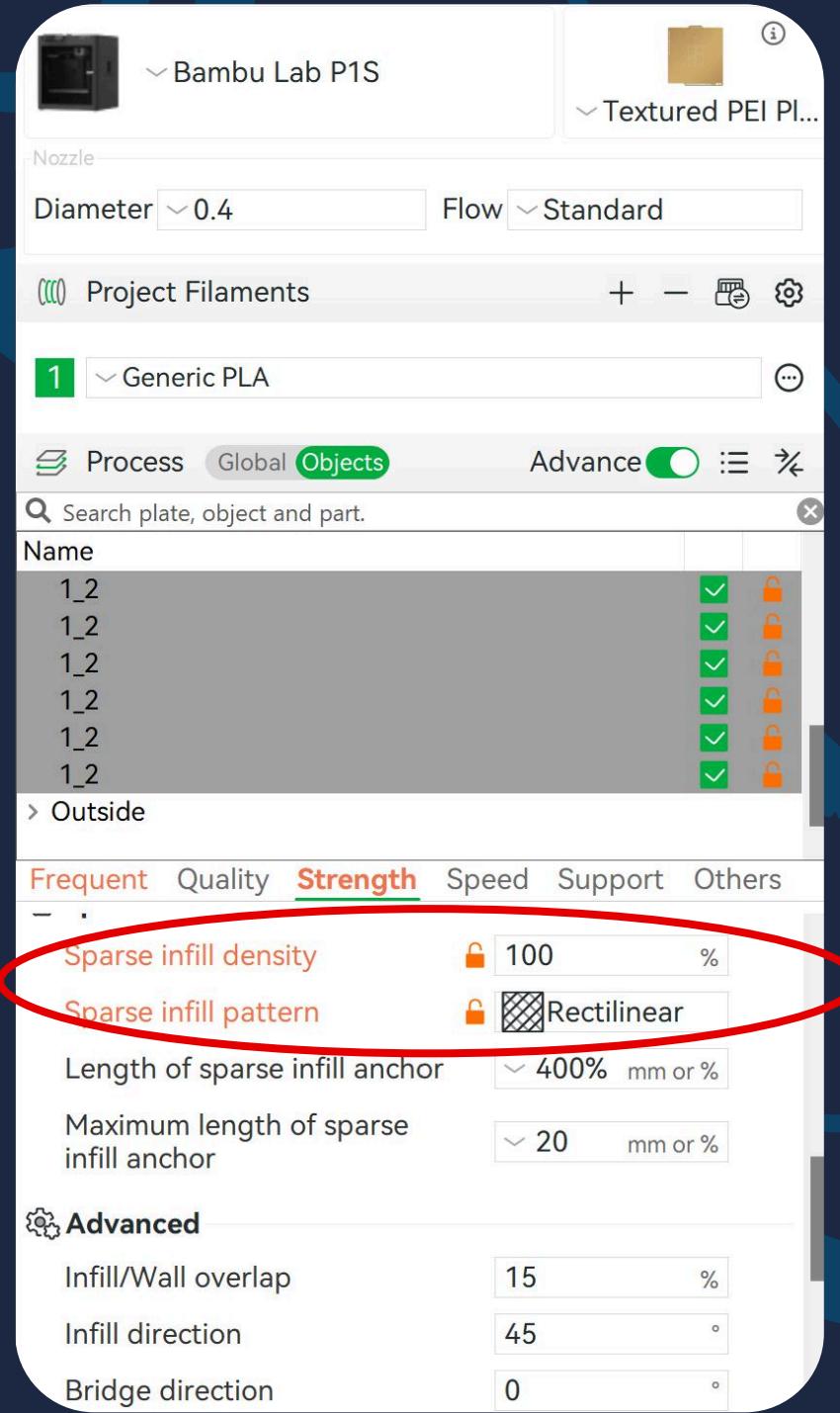
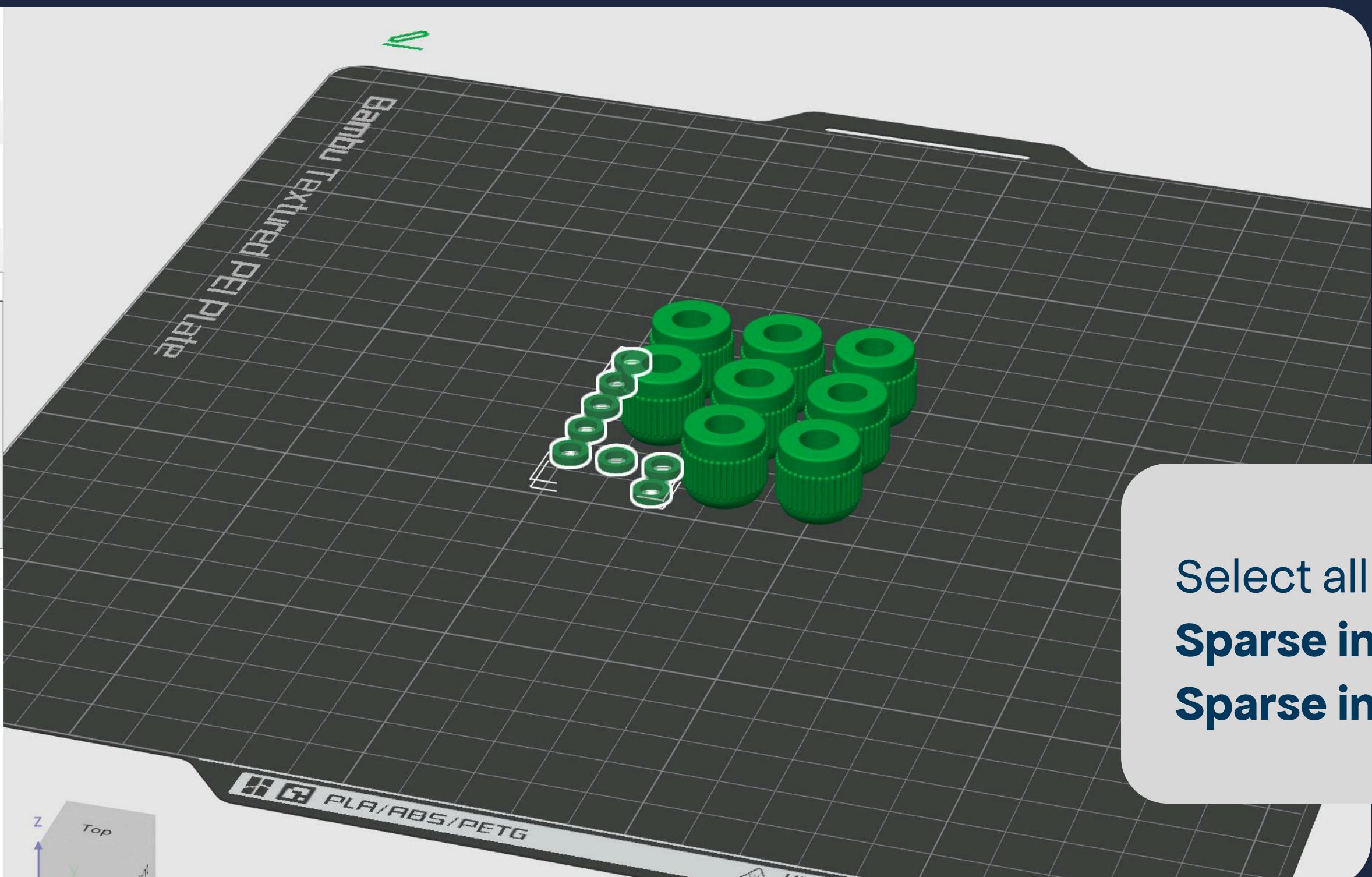
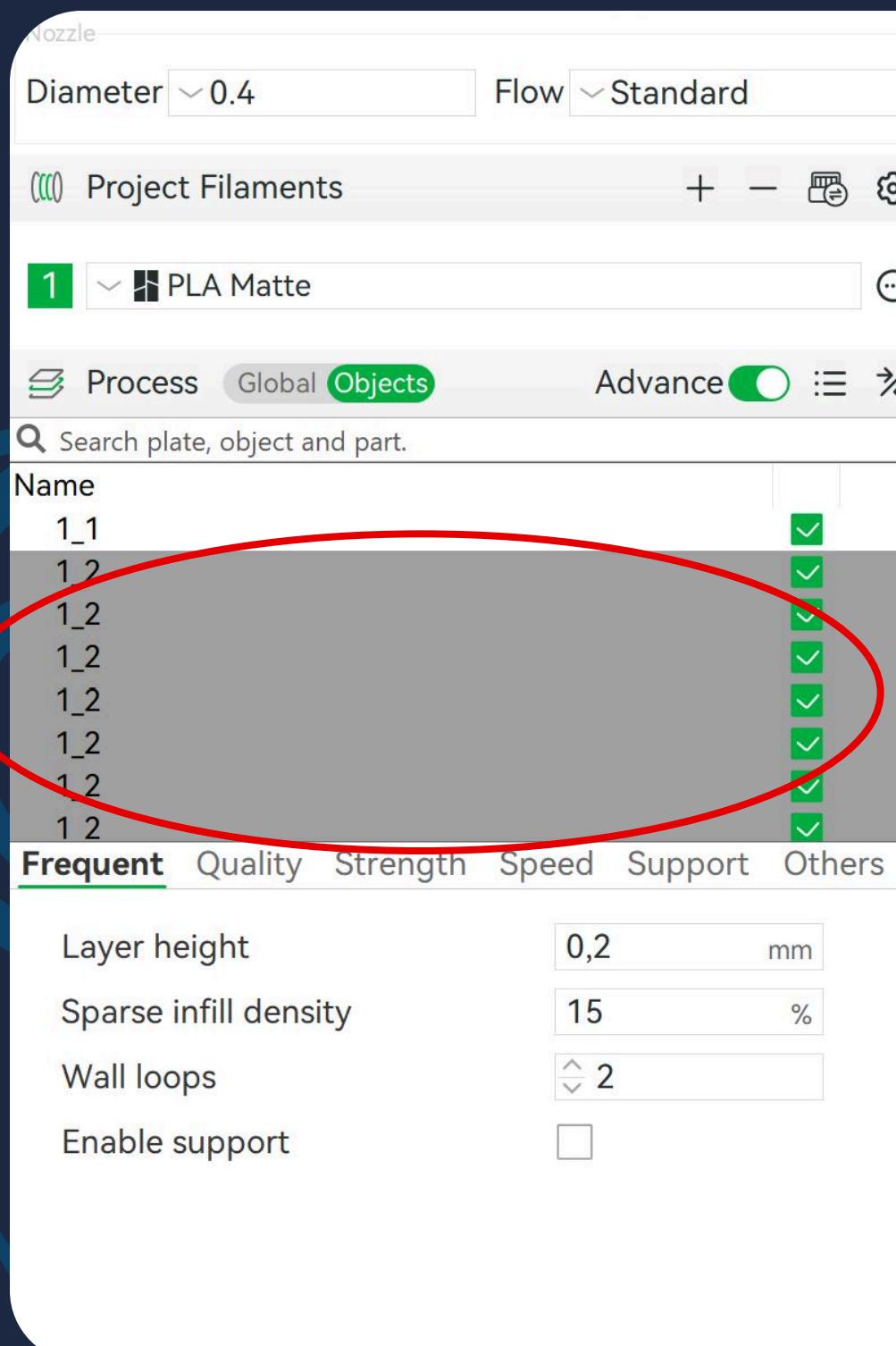
Separating objects



Import the 3D-file and split object to work with the parts separately. Copy the 3D-parts till you have 8 base supports and 8 rings

How-To Make Base Supports

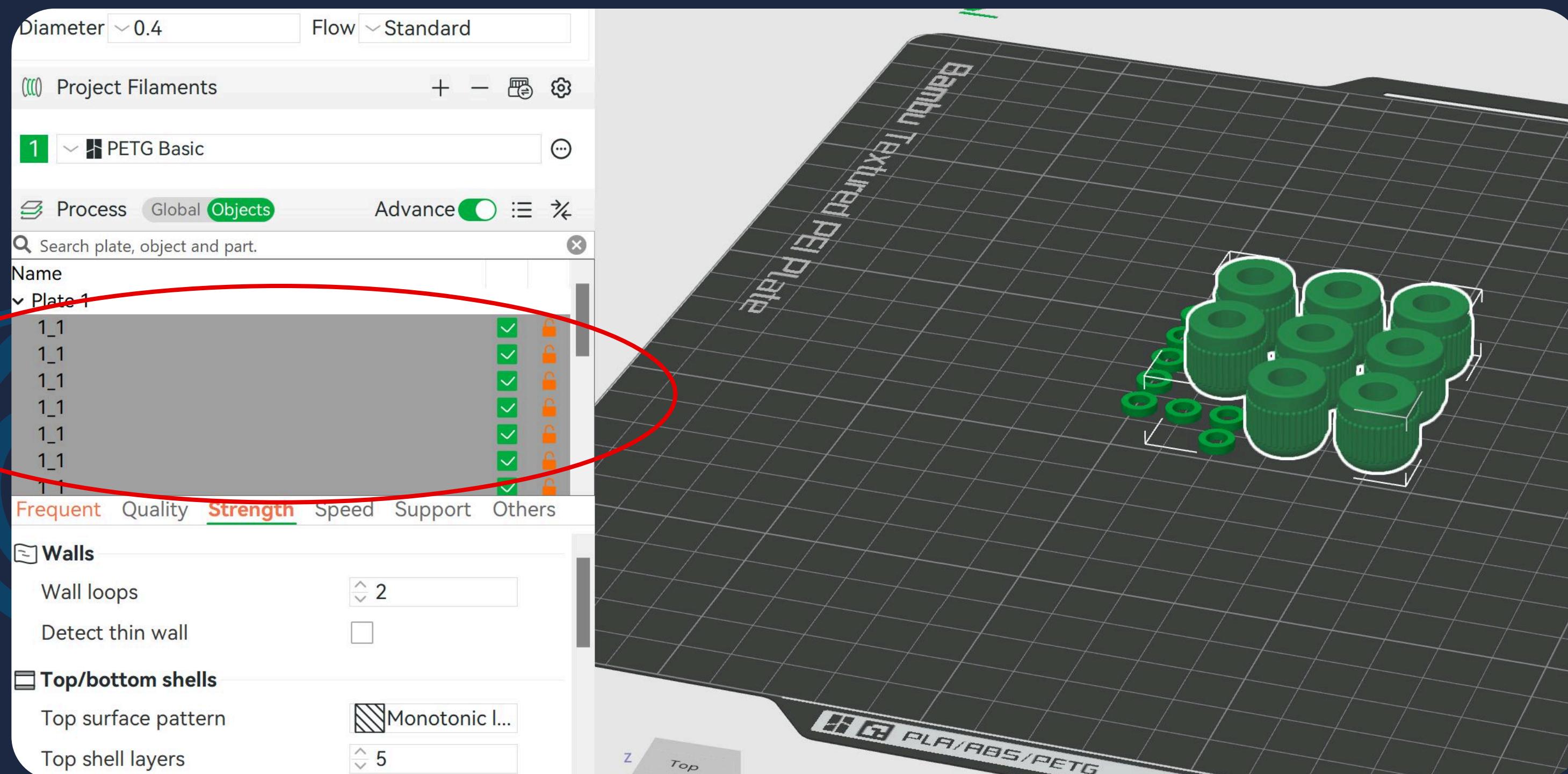
Print settings for rings



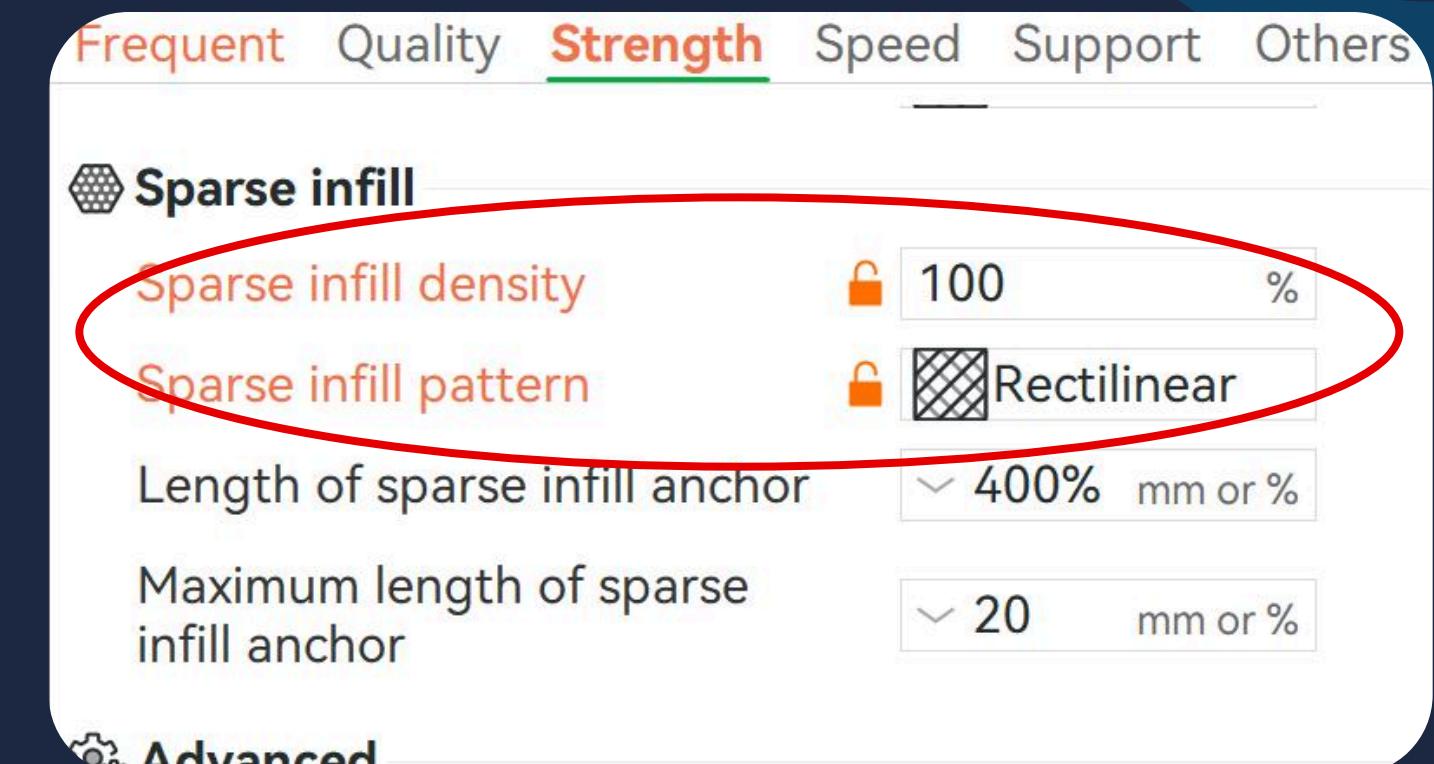
Select all rings
Sparse infill: 100%
Sparse infill pattern: Rectilinear

How-To Make Base Supports

Print settings for base supports

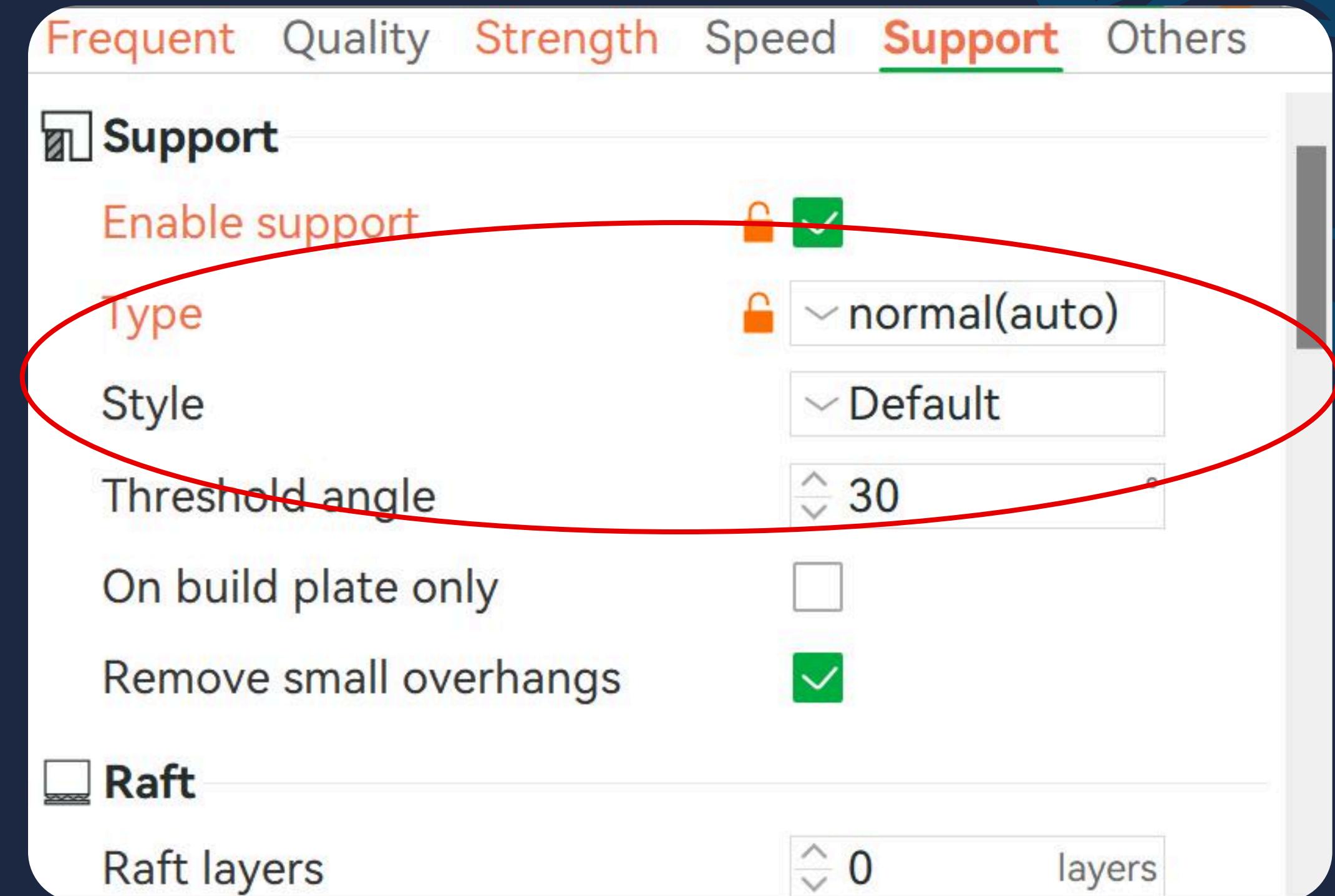
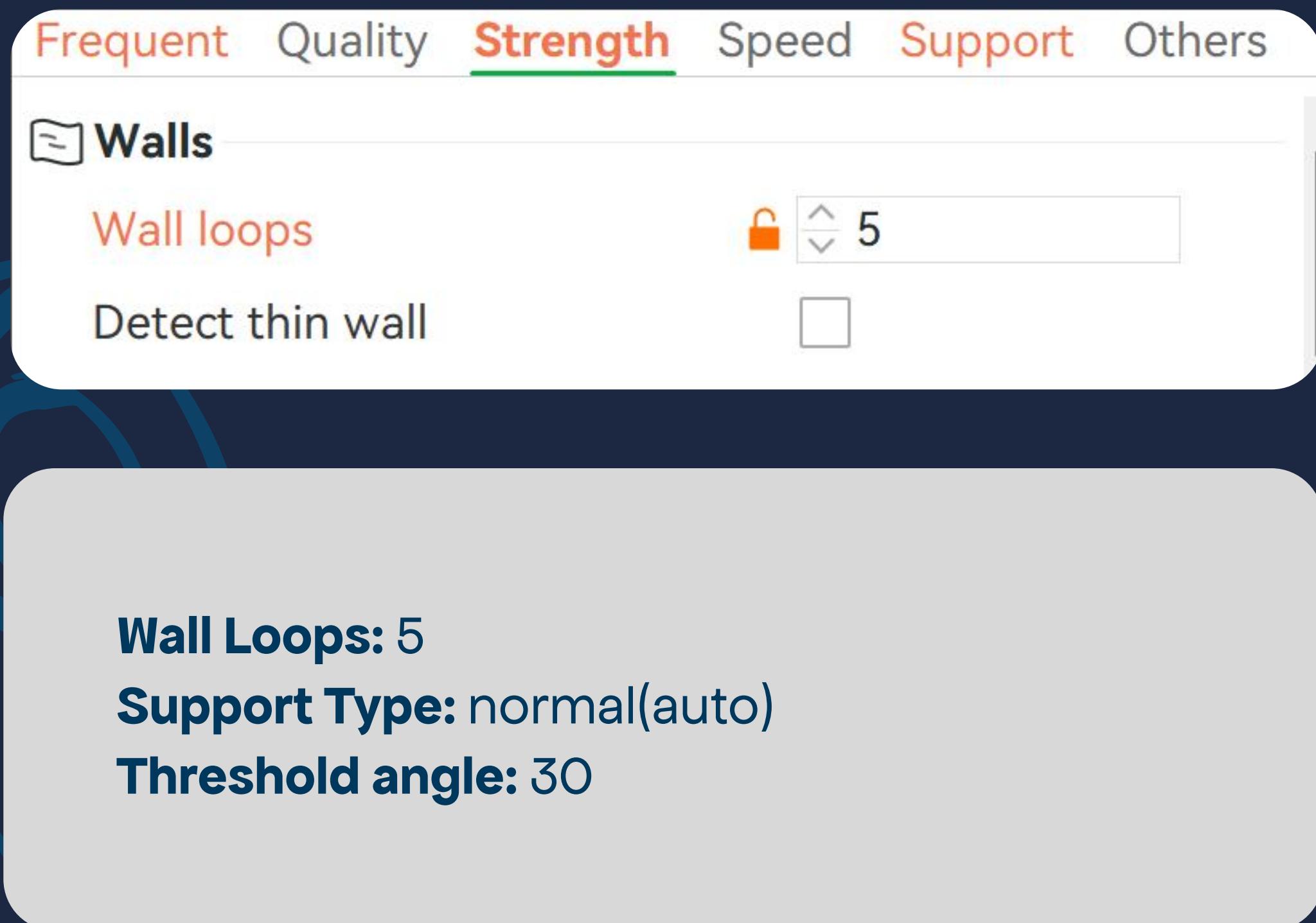


Select all feet
Sparse infill: 100%
Sparse infill pattern:
Rectilinear



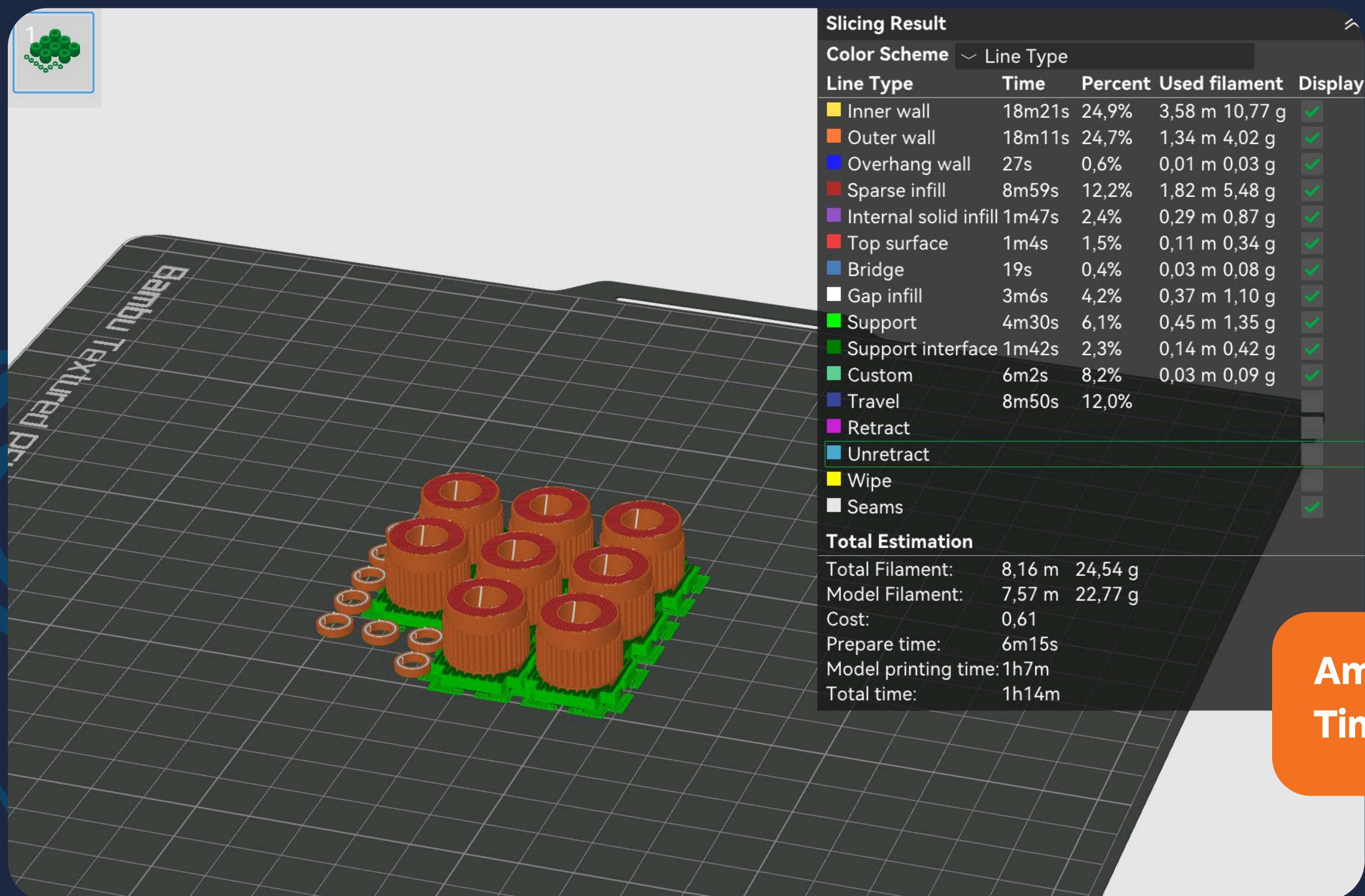
How-To Make Base Supports

Print settings for base supports



How-To Make Base Supports

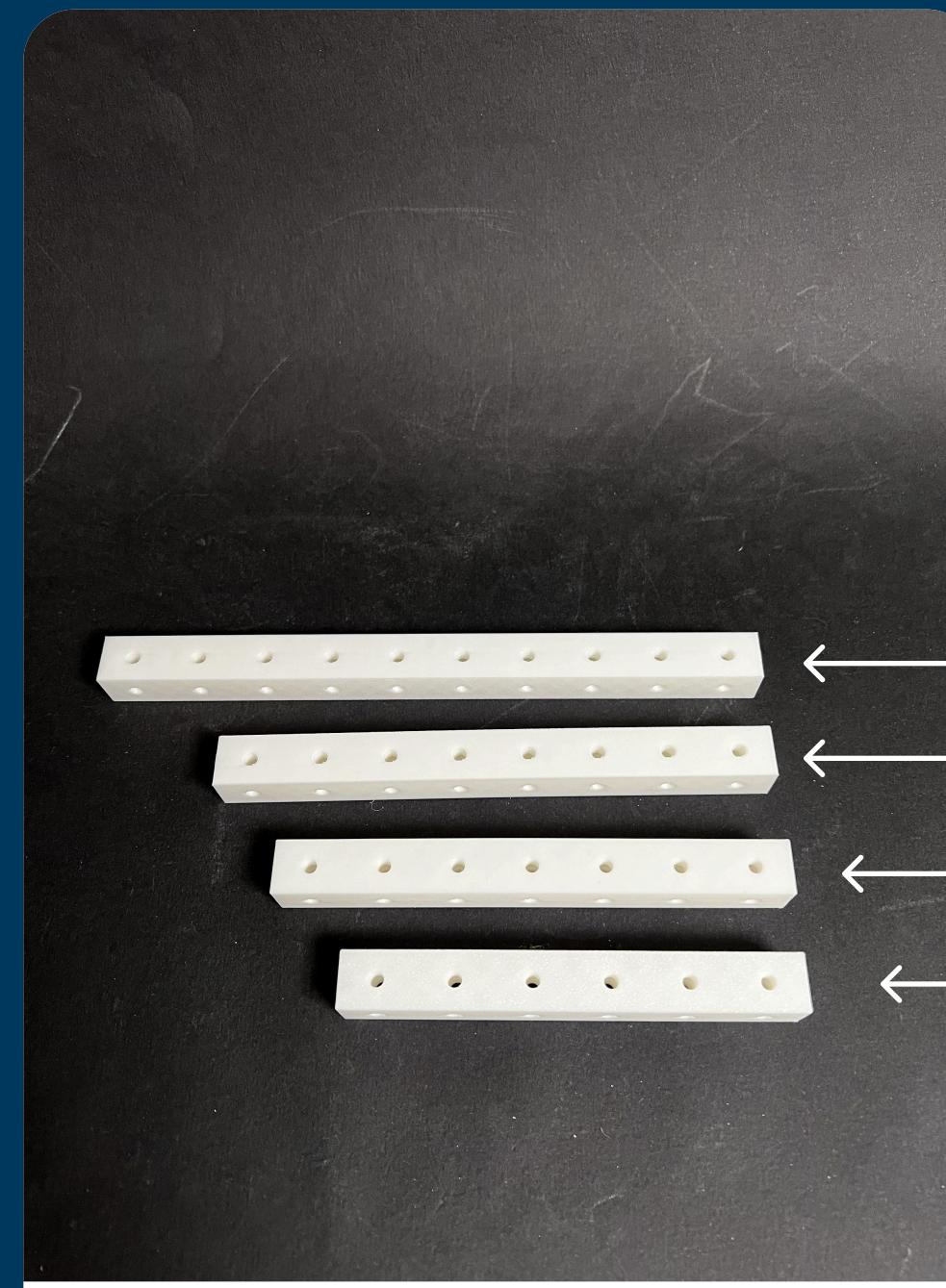
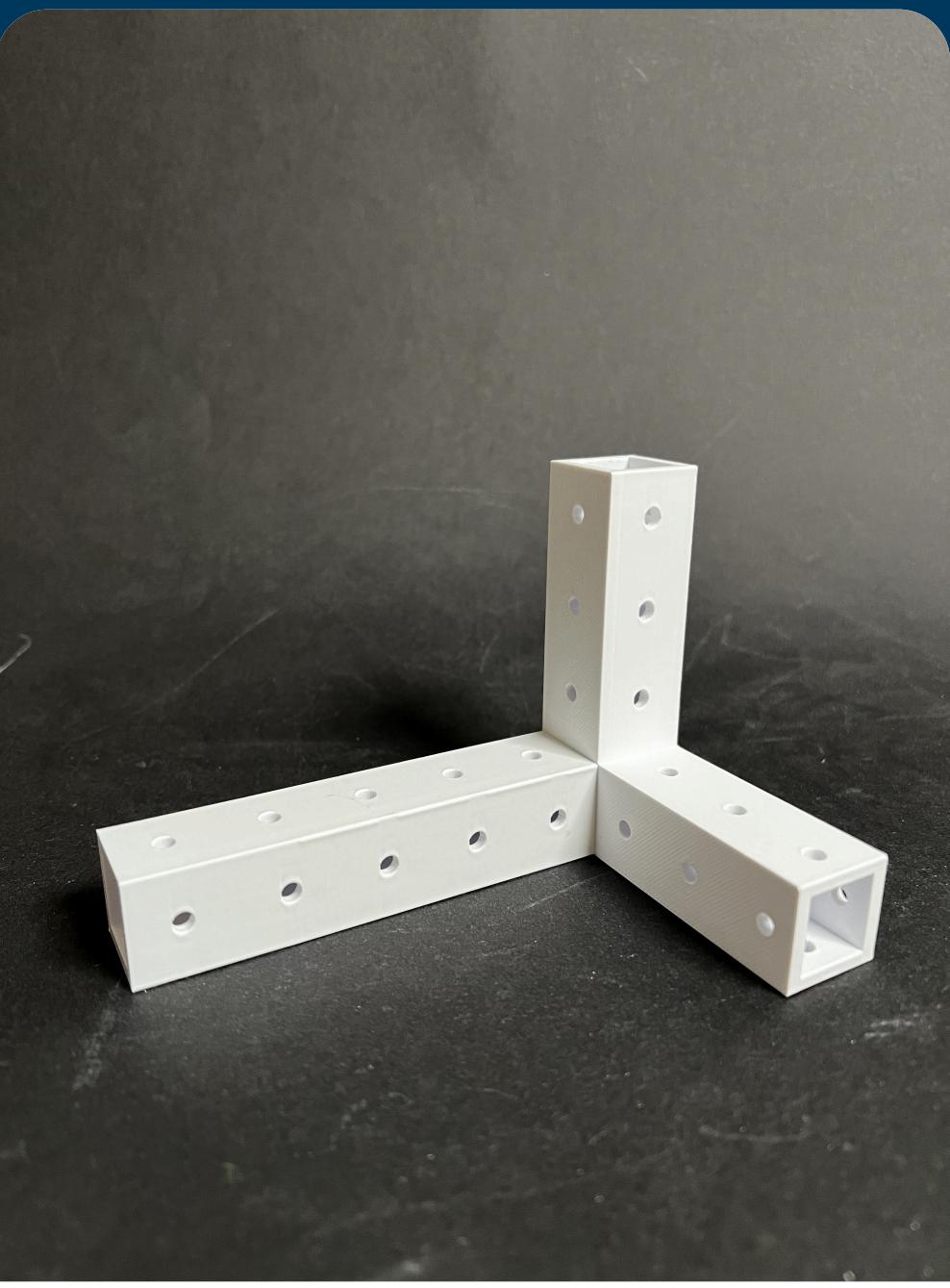
Slice plate



Amount: 8
Time: ca.1 hour

How-To Set Up Frame

Pieces



How-To Make Base Supports

Pieces



What you need

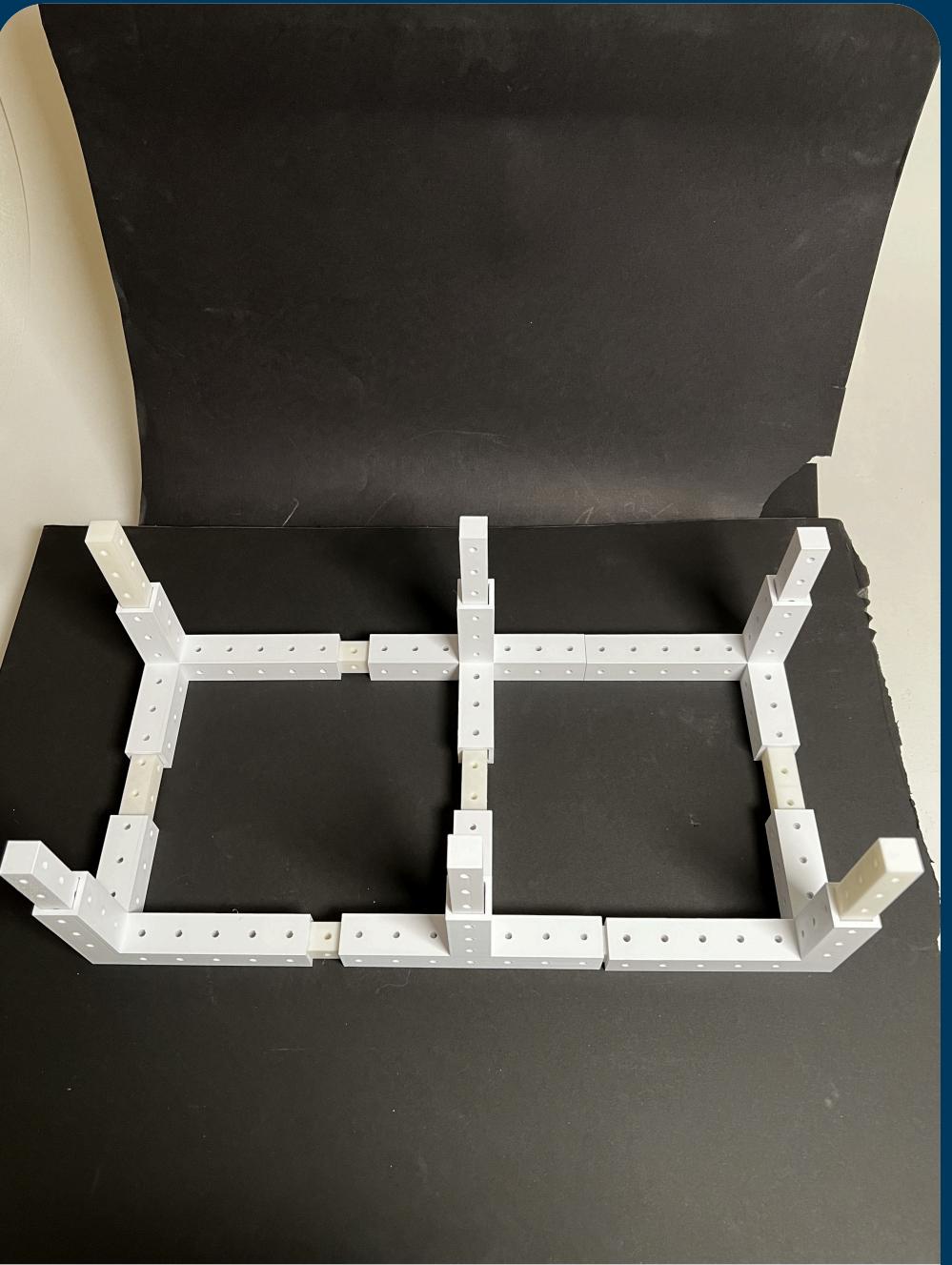
- 8x printed base supports and rings**
- 8x screws**
- Glue for plastic and metal**

How-To Set Up Frame

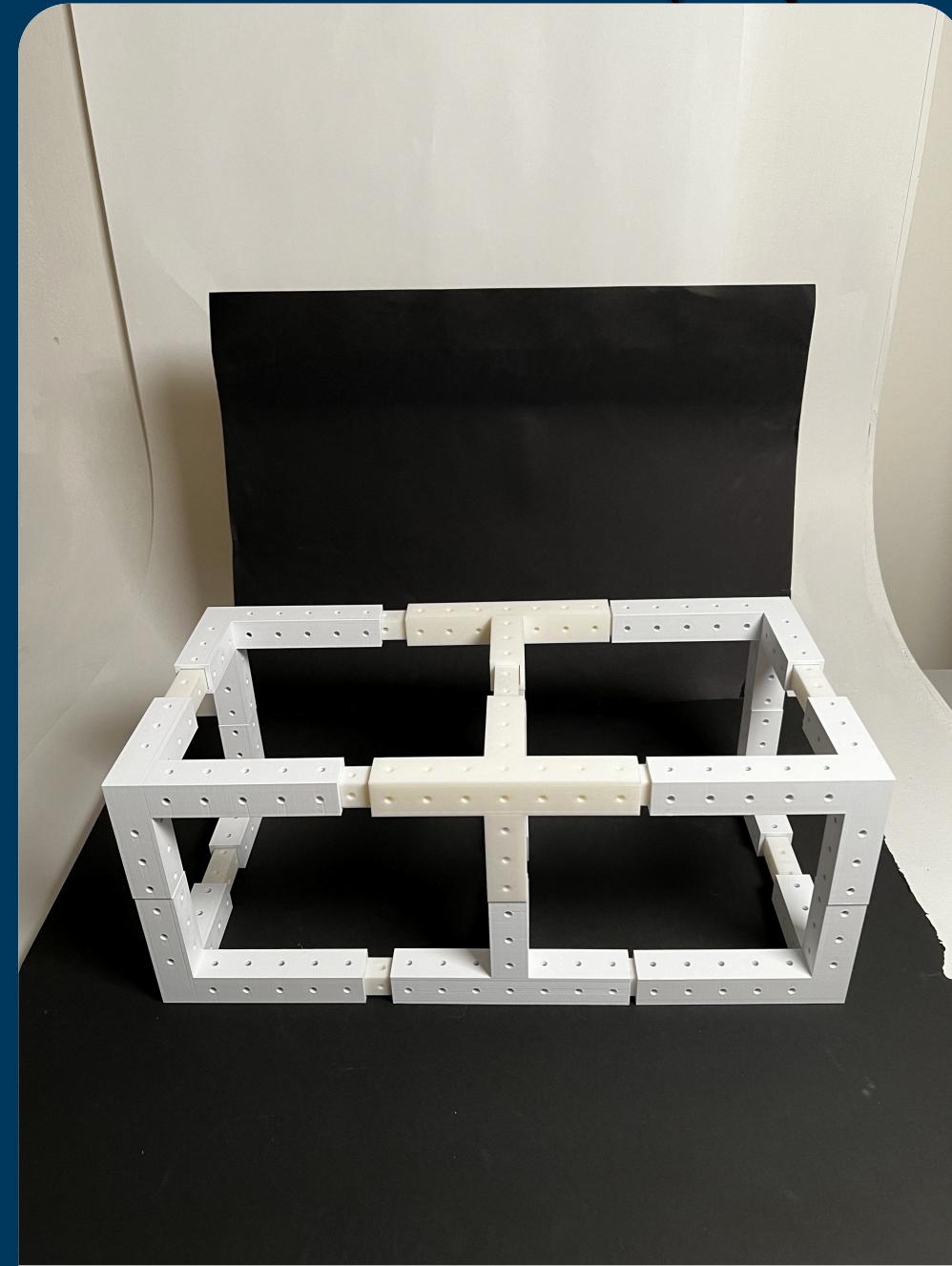
Steps



Step 1



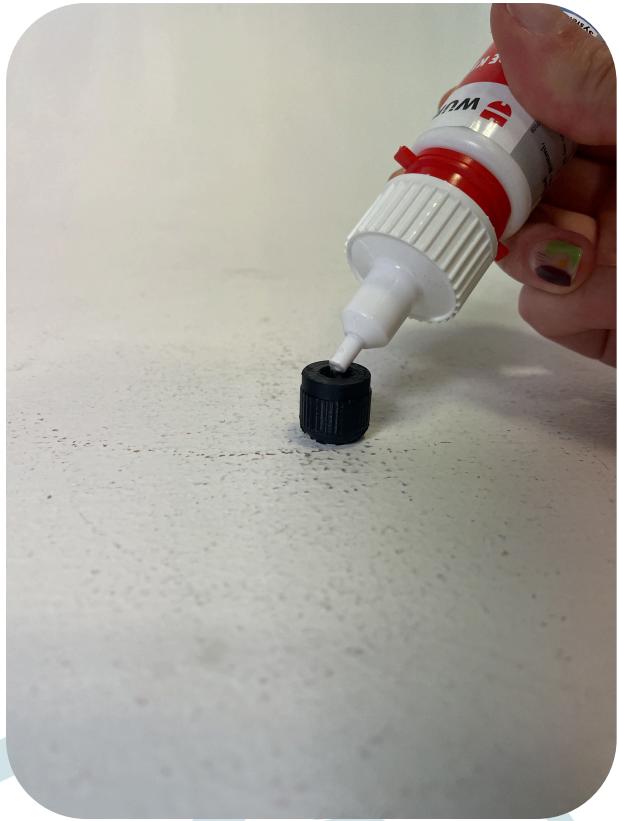
Step 2



Step 3

How-To Make Base Supports

Steps



Step 1

Put glue in the base support and put in the screw with the head down.



Step 2

Put glue over the screw head and cover with the ring.



Step 3

Cover the ring with glue and repeat this process to make 7 more.



