PROTOTYPING FORM 1: 3D MODELING + PRINTING

CSE 599 Prototyping Interactive Systems | Lecture 7 | Oct 17

Jon Froehlich • Liang He (TA)

DESIGN USE BUILD

MAKEABILITY LAB

PAUL G. ALLEN SCHOOL OF COMPUTER SCIENCE & ENGINEERING

UNIVERSITY of WASHINGTON

LEARNING GOALS

PROTOTYPING WITH CAD MODELING + 3D PRINTING

How **CAD tools** + **3D printing** can be used to **rapidly prototype form**

An introduction to two primary 3D printing methods: **SLA** and **FDM**

The **3D printing pipeline**

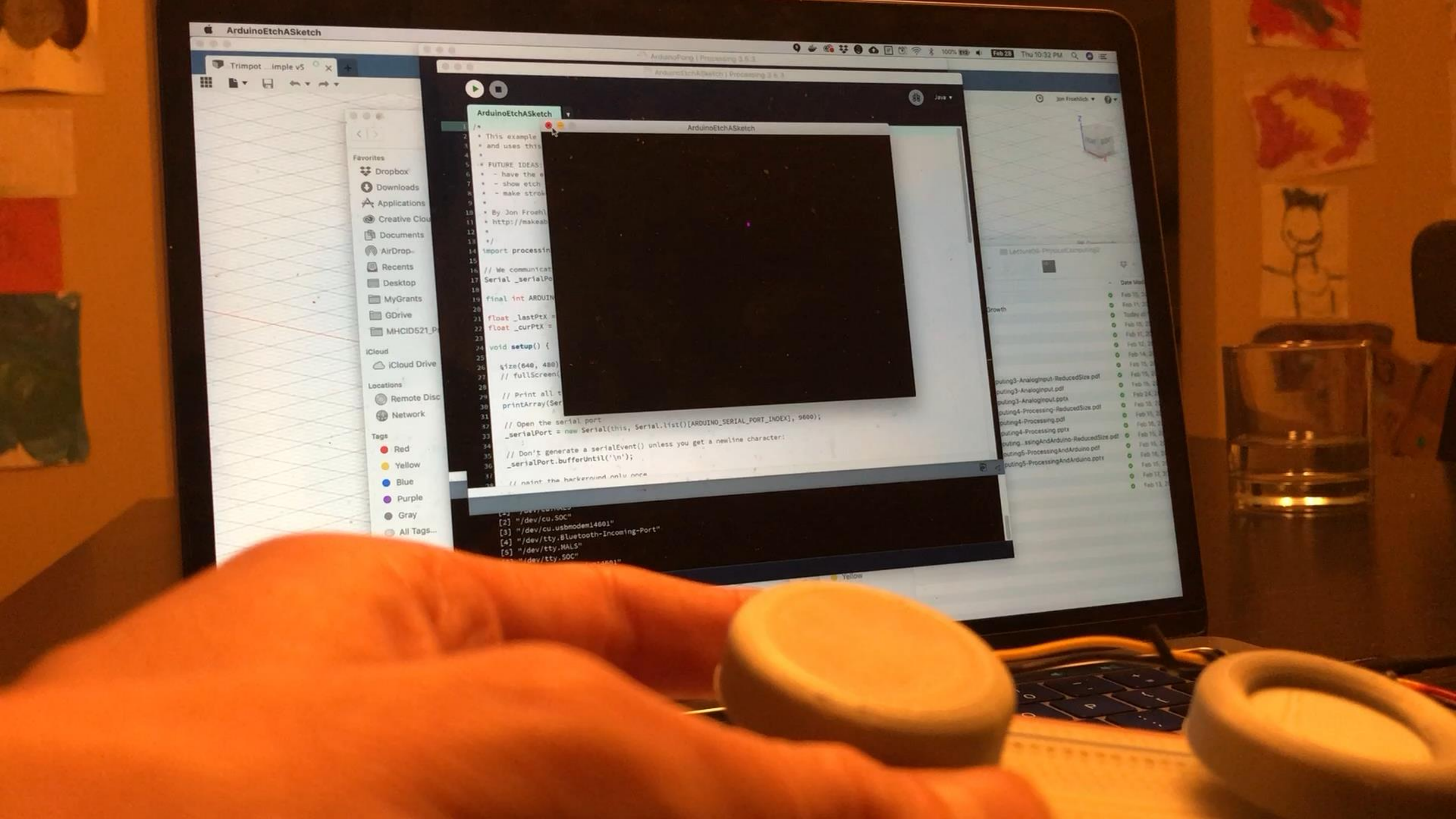
Modeling designs in **Fusion 360**

What is **slicing** and **what do we use it for**

3D PRINTING

PROTOTYPING GAME CONTROLLERS

Design and video by Jon Froehlich


ArduinoEtchASketch
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ArduinoEtchASketch
ArduinoEtchASketch
Favorites
Dropbox
Downloads
Applications
Documents
Recents
Desktop
MyGrants
GDrive
iCloud
iCloud Drive
Locations
Network
Tags
Red
Yellow
Blue
Purple
Gray
All Tags...
import processin
void setup() {
// Open the serial port
_serialPort = new Serial(this, Serial.list()[ARDUINO_SERIAL_PORT_INDEX], 9600);
// Don't generate a serialEvent() unless you get a newline character:
_serialPort.bufferUntil('\n');
[2] "/dev/cu.SOC"
[3] "/dev/cu.usbmodem14601"
[4] "/dev/tty.Bluetooth-Incoming-Port"
[5] "/dev/tty.MALS"

3D PRINTING

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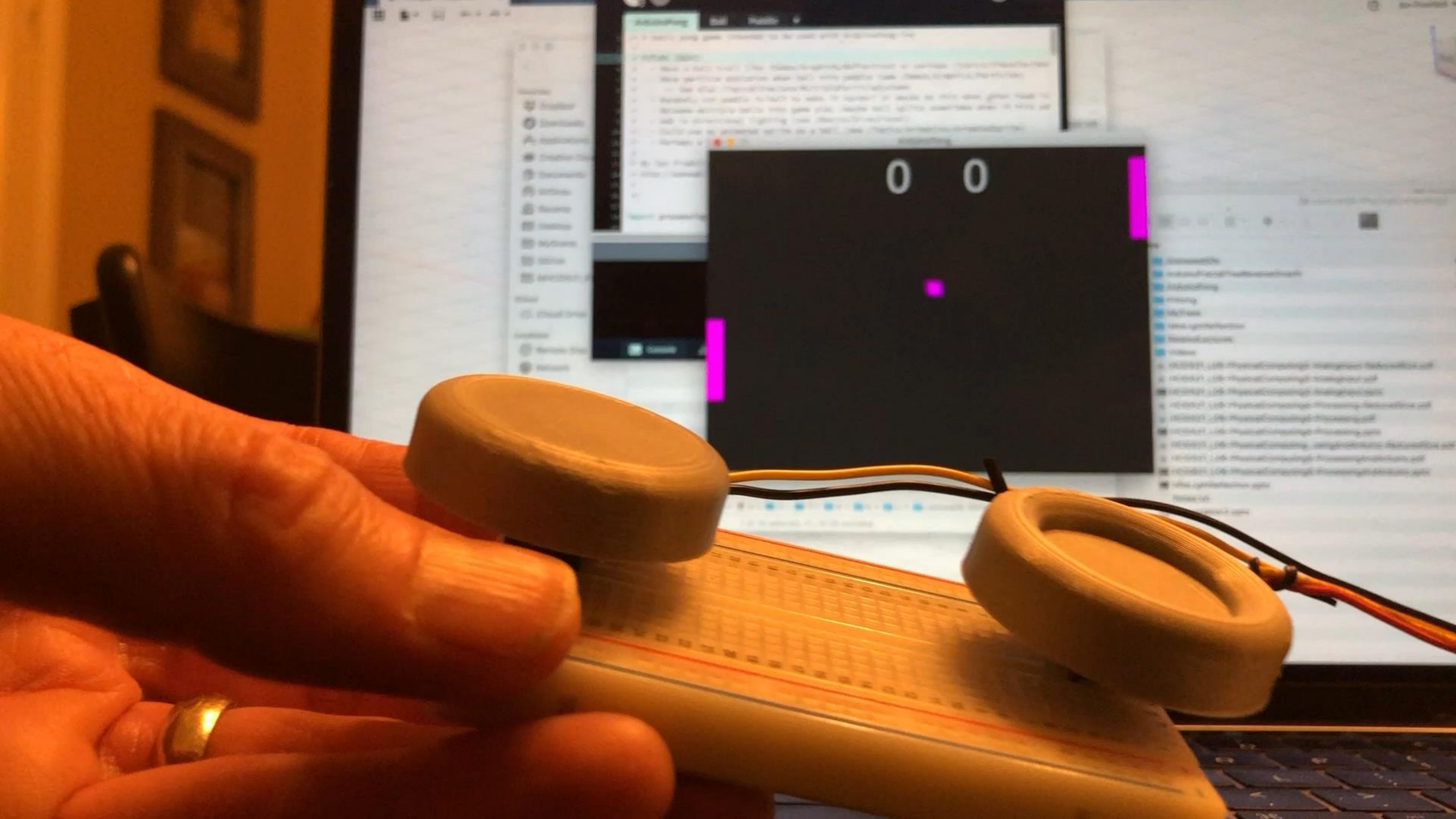
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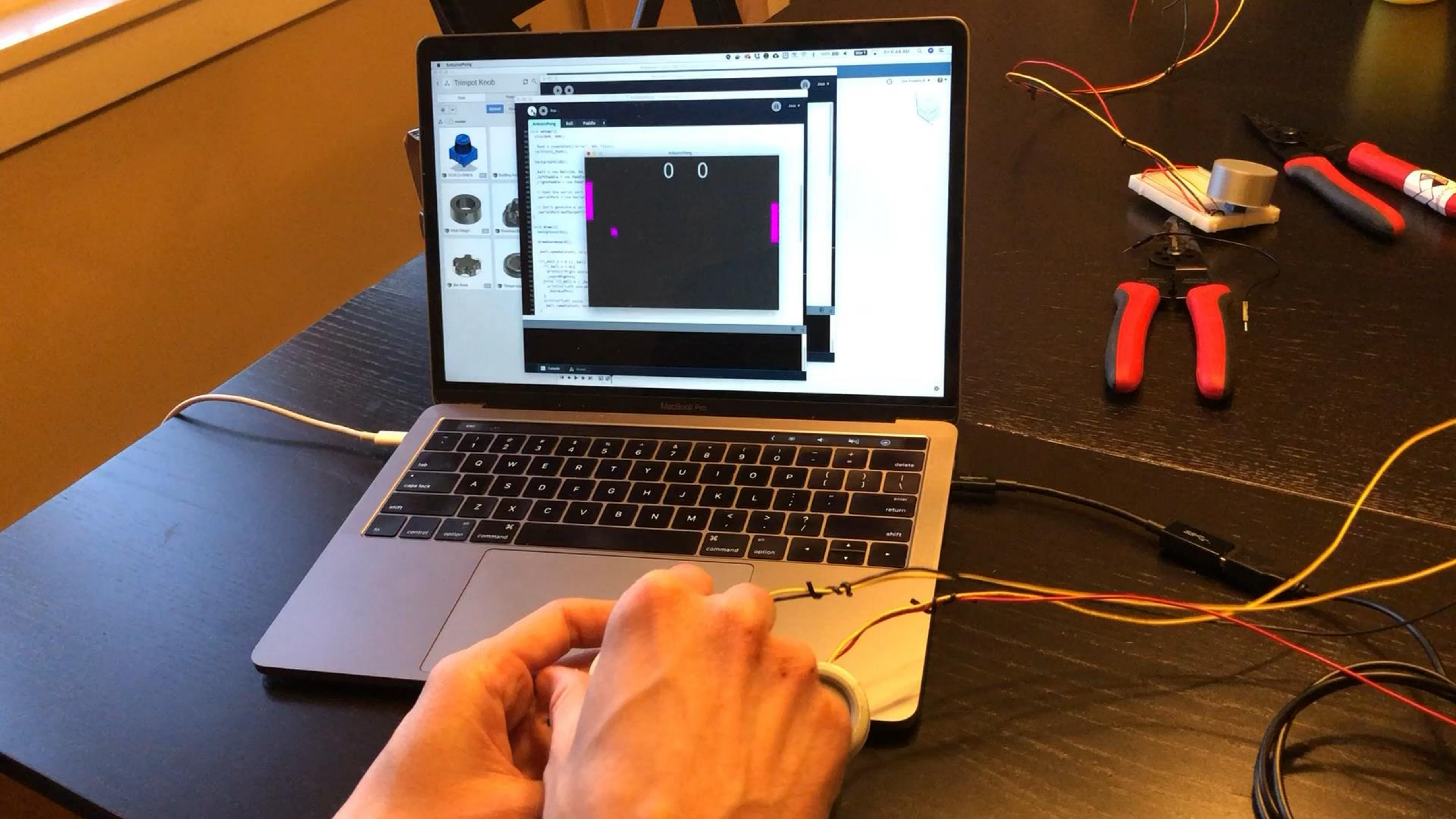
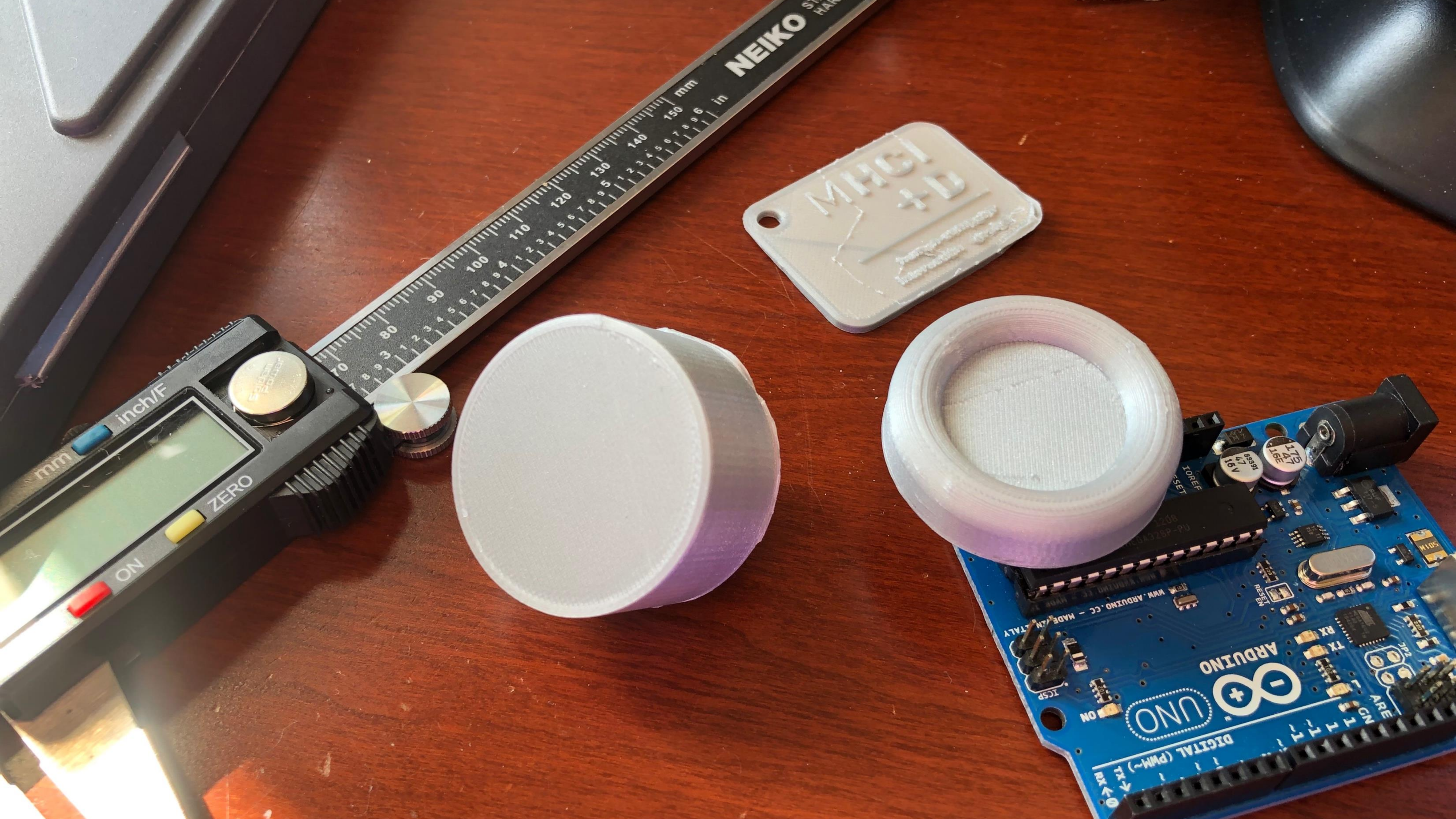
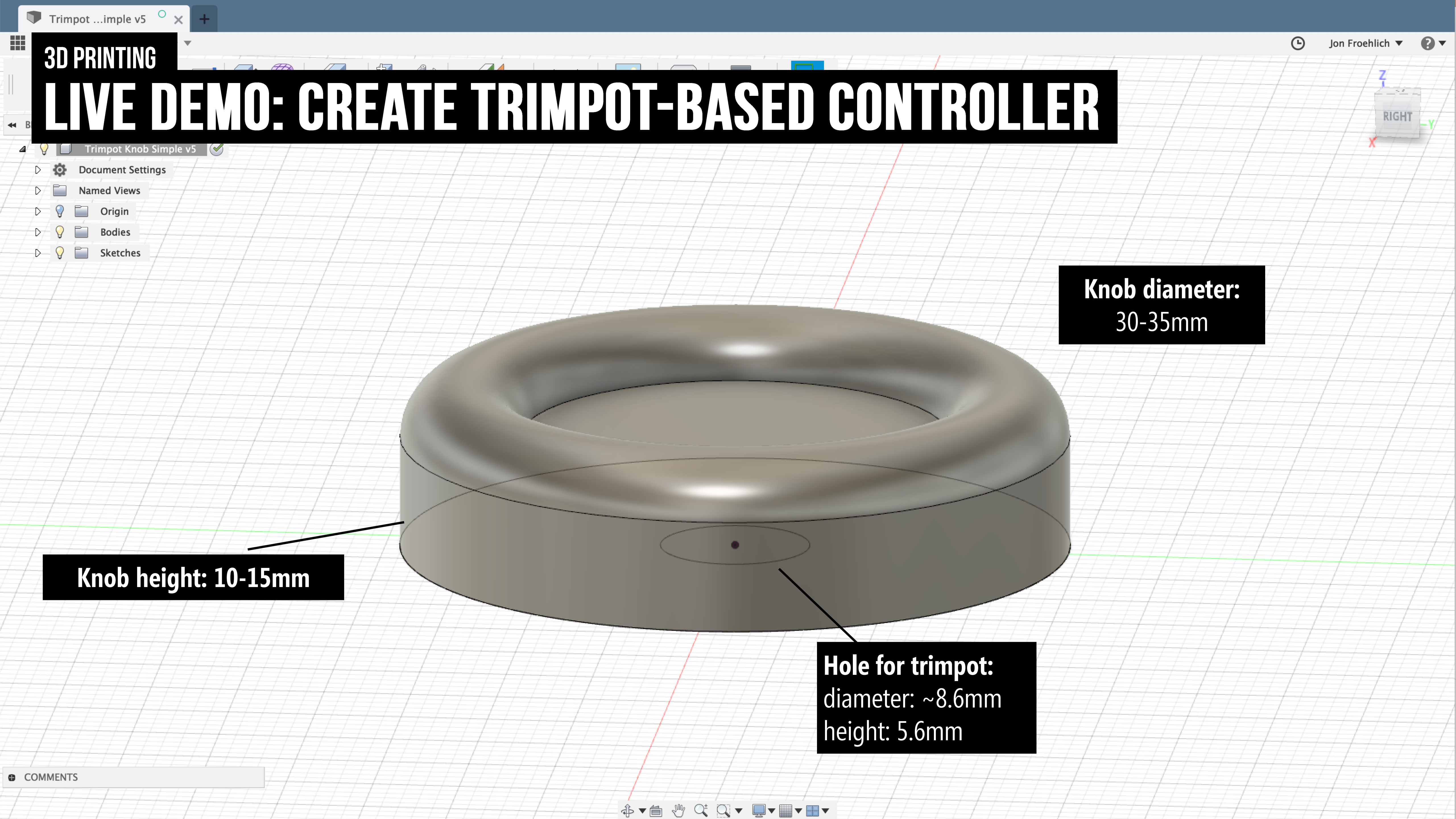


Trimpot Knob
ArduinoPong
Ball
Paddle
0 0
MacBook Pro


NEIKO
mm
in
inch/F
mm
ZERO
ON
MHCI
+D
ARDUINO
UNO
DIGITAL (PWM~)
WWW.ARDUINO.CC
ICSP
IOREF
RESET
TX
RX
ON

3D PRINTING

LIVE DEMO: CREATE TRIMPOT-BASED CONTROLLER

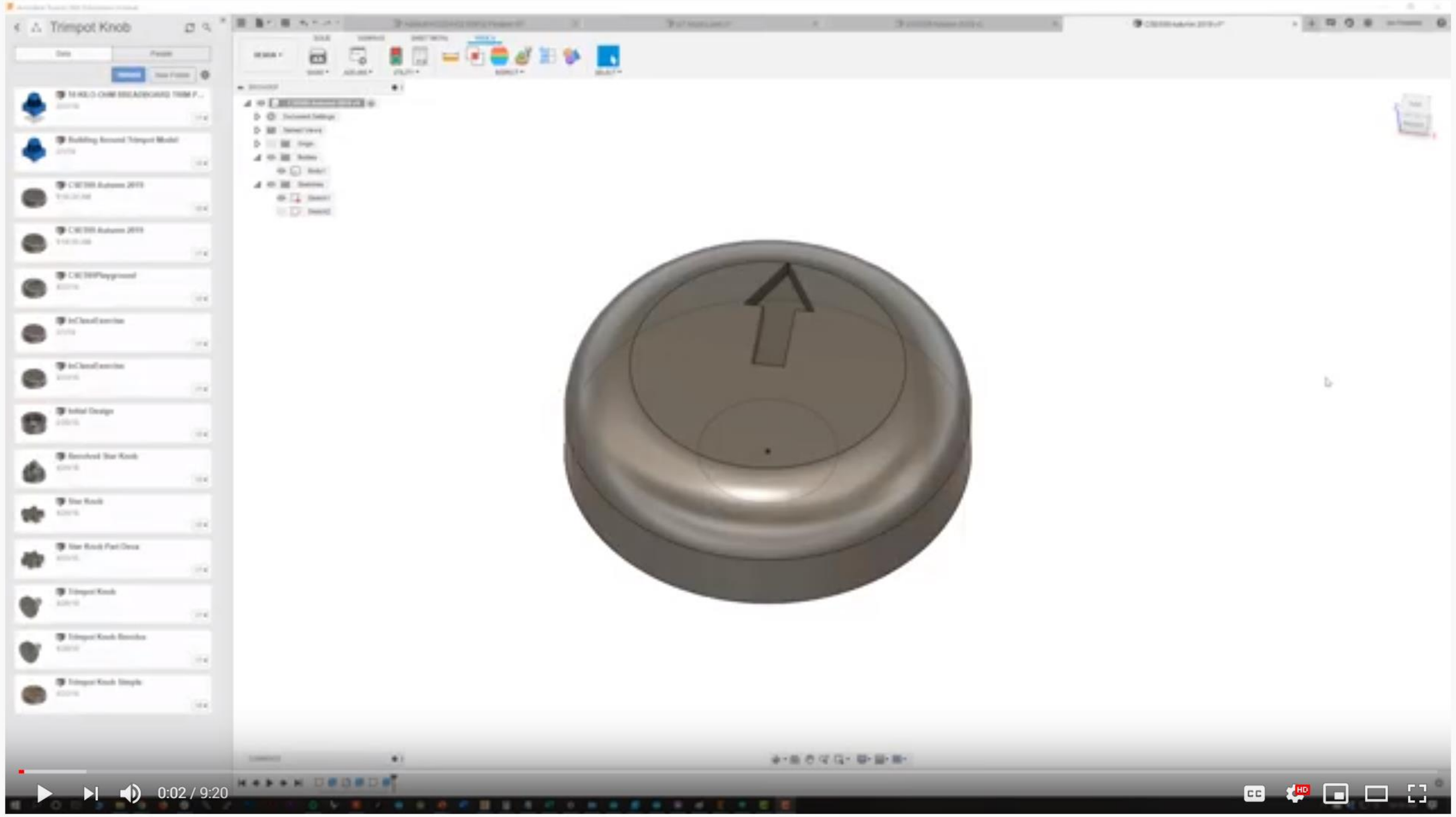


Knob diameter:
30-35mm

Knob height: 10-15mm

Hole for trimpot:
diameter: ~8.6mm
height: 5.6mm

VIDEO RECORDING: CREATE TRIMPOT-BASED CONTROLLER



Rapidly Prototyping an Input Knob Using Fusion 360

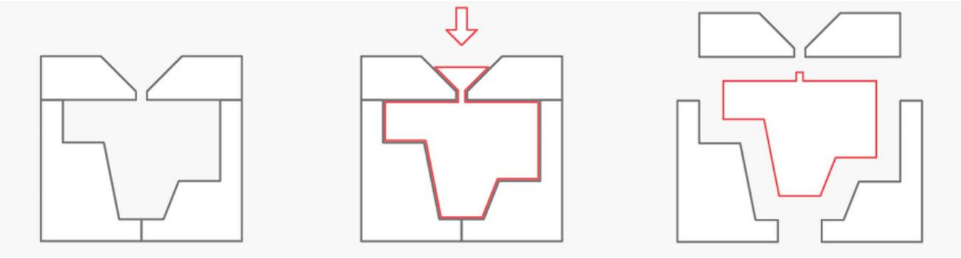
6 views • Oct 17, 2019

0 0 SHARE SAVE

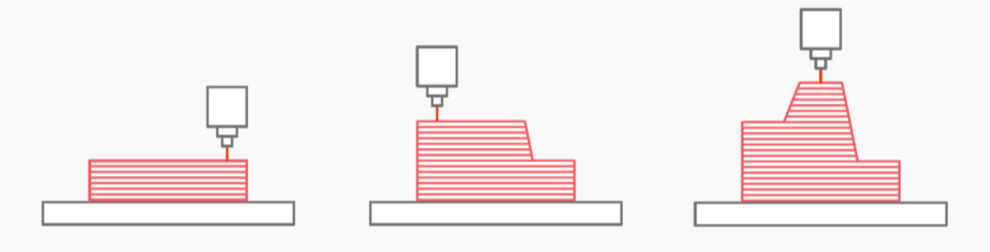
Source: https://youtu.be/bF1hreNH_E0

BACKGROUND

MANUFACTURING TECHNIQUES



Formative manufacturing: best suited for high-volume production of the same part, requiring a large initial investment in tooling (molds) but then being able to produce parts quickly and at a very low unit price.



Additive manufacturing: best suited for low-volume, complex designs that other methods are unable to produce or when a unique, one-off rapid prototype is required.

Subtractive manufacturing: lies in between formative and additive, being best suited for parts with relatively simple geometries, produced at low-to-mid volumes, and where materials like wood or metal are necessary

Source: Redwood *et al.*, The 3d Printing Handbook, 2017

MANUFACTURING TECHNIQUES

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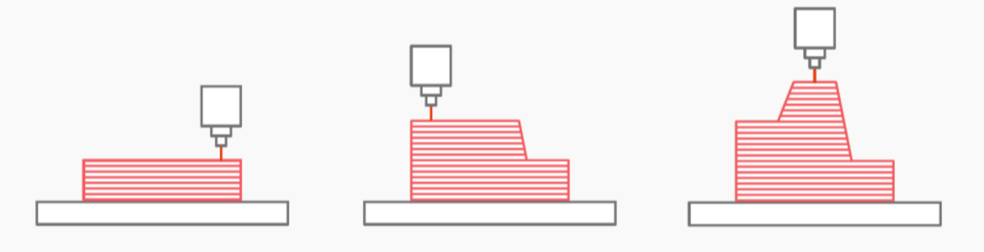

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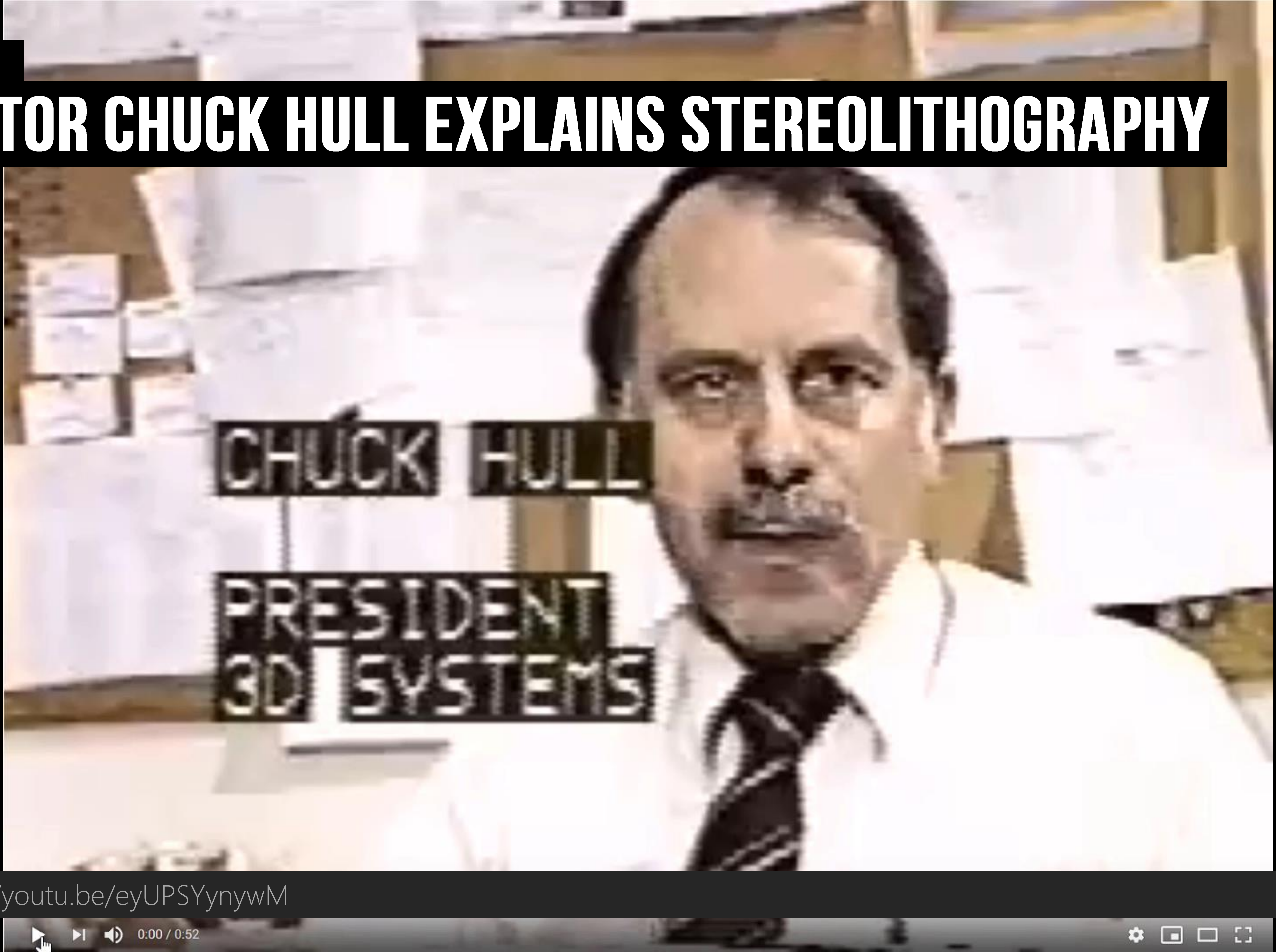
Source: Redwood *et al.*, The 3d Printing Handbook, 2017

1987

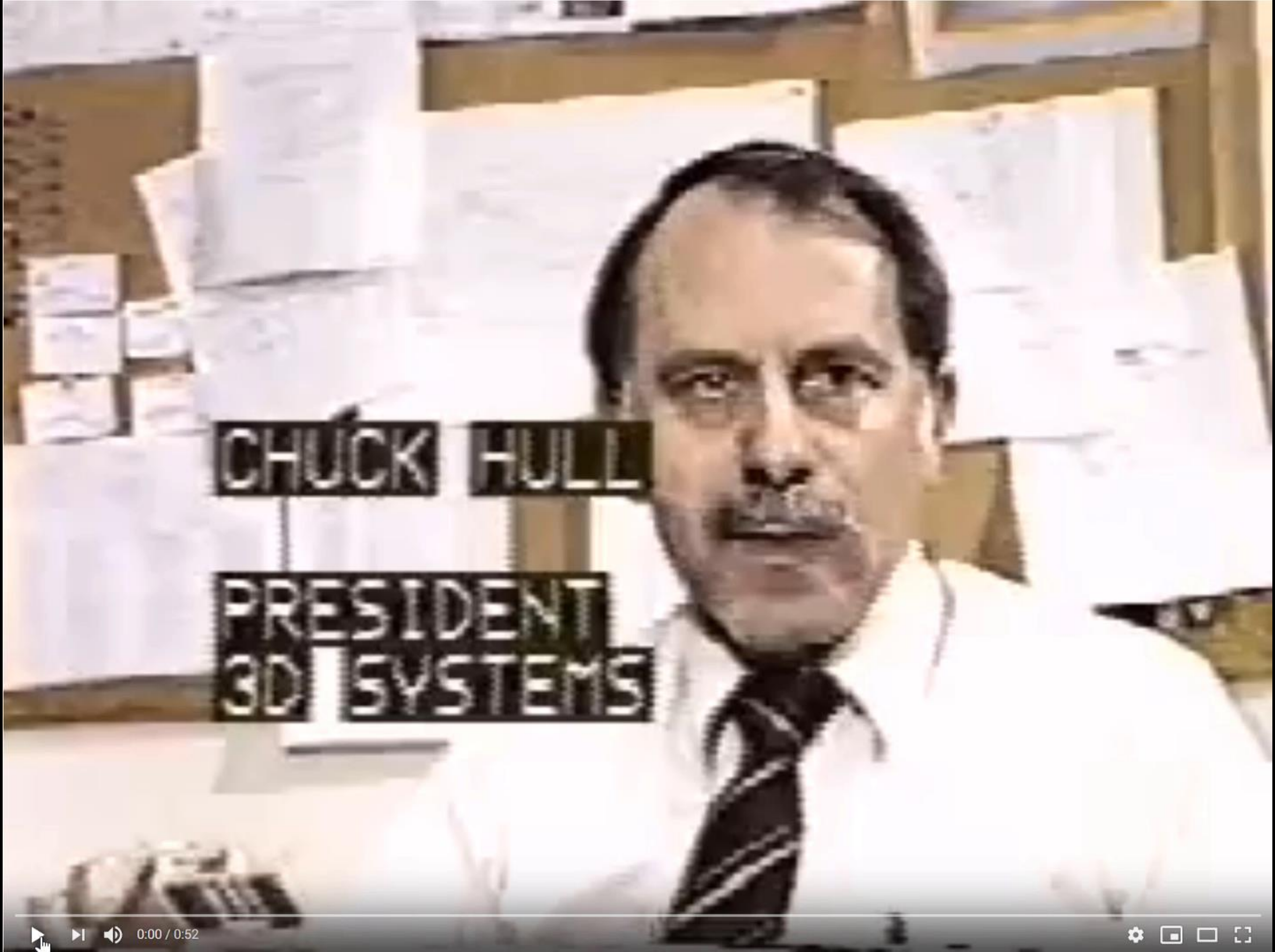
The first commercial 3D printer
SLA-1 printer by 3D Systems Inc.
Invented by Charles Hull

WHAT’S SLA?

INVENTOR CHUCK HULL EXPLAINS STEREOLITHOGRAPHY

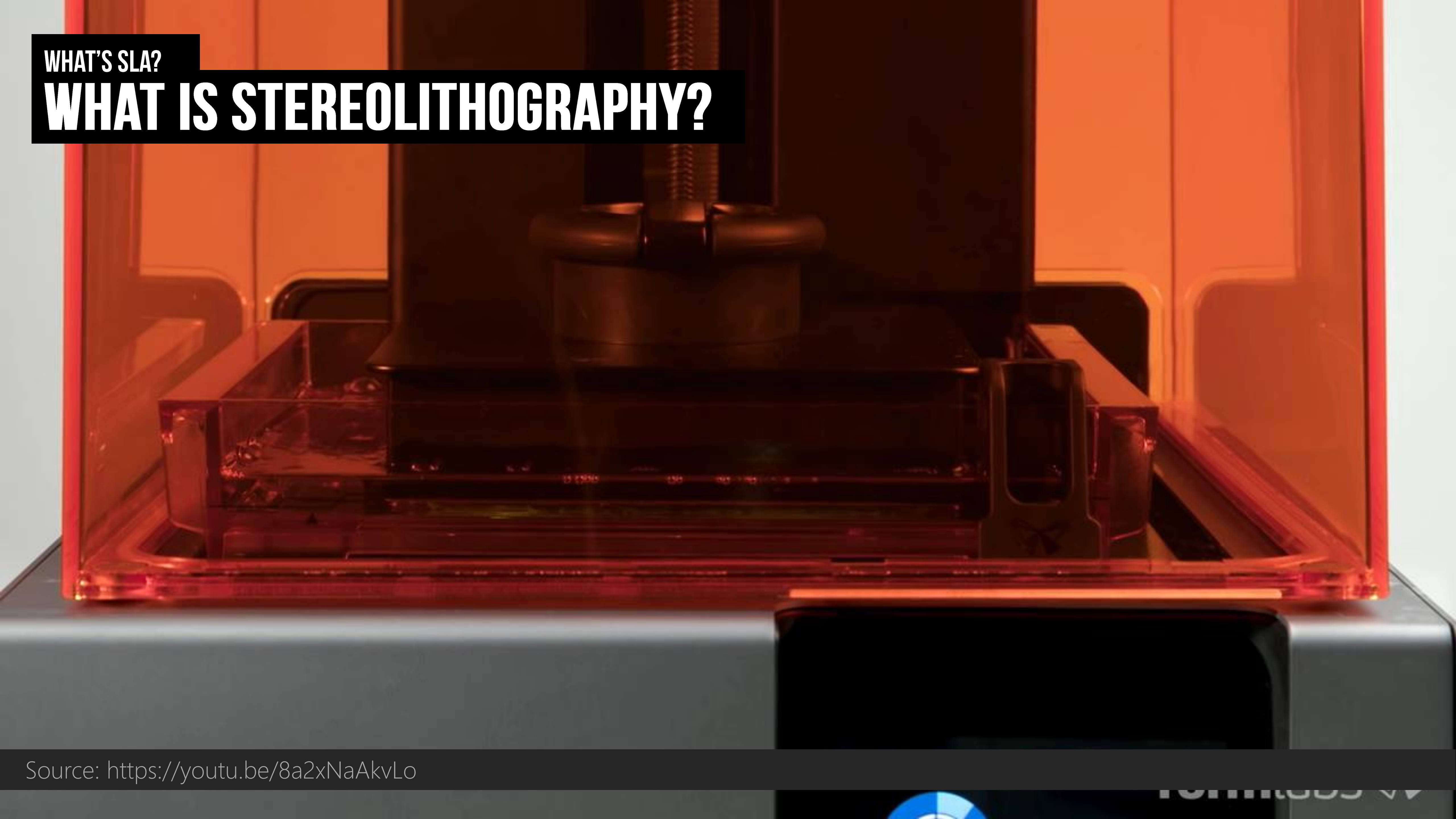


Source: https://youtu.be/eyUPSYynywM

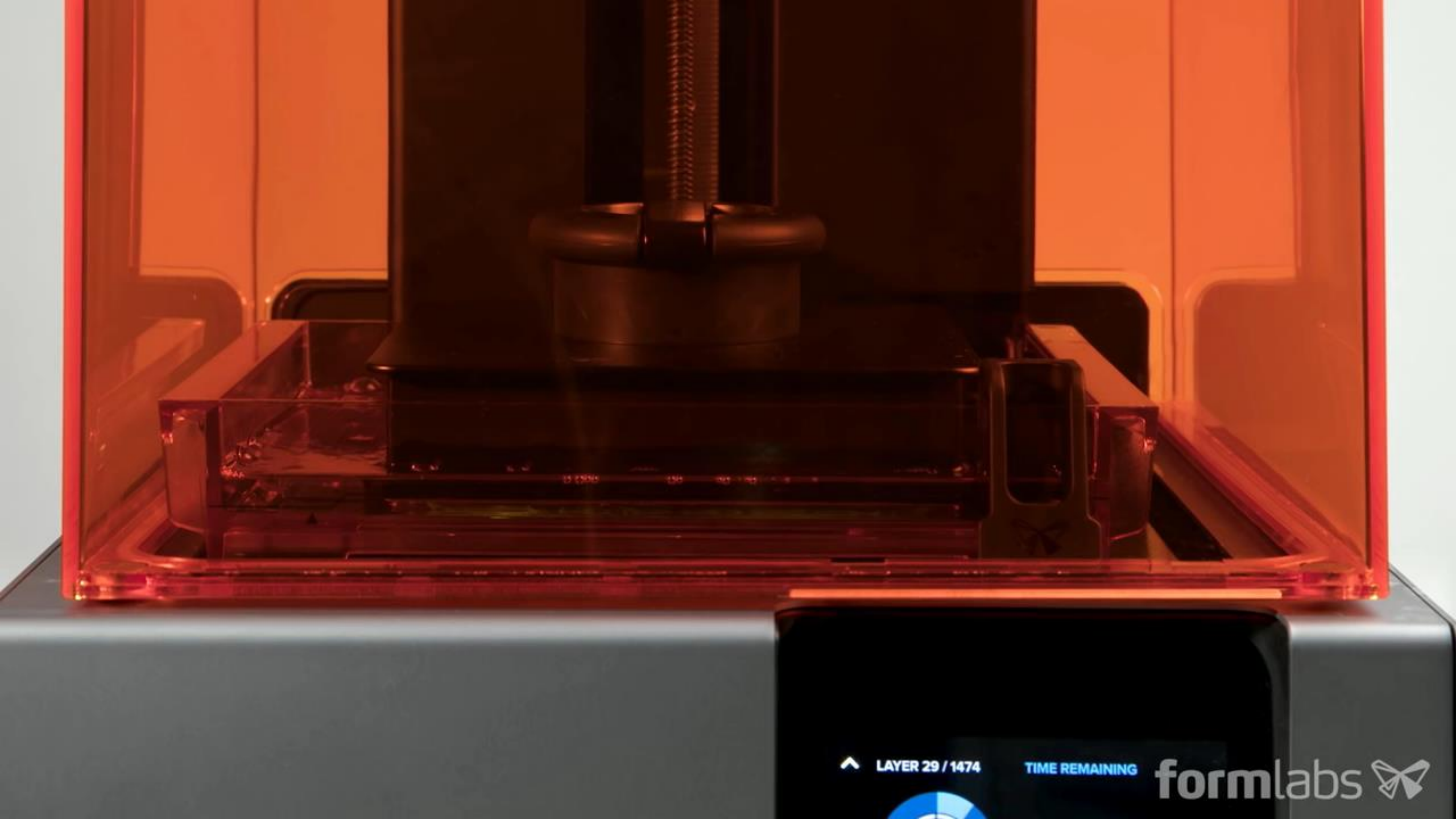

CHUCK HULL
PRESIDENT
3D SYSTEMS
0:00 / 0:52

WHAT'S SLA?

WHAT IS STEREOLITHOGRAPHY?



Source: https://youtu.be/8a2xNaAkvLo


LAYER 29 / 1474
TIME REMAINING
formlabs

THE GOOD

SLA creates **precise & smooth** models

Great for **creating molds** for casting

THE BAD

SLA is **expensive** (both printers & resin)

Resin is **sticky** & **messy**

Prints **require post-processing** by bathing in isopropyl alcohol

1992

The first commercial FDM printer
3D Modeler by Stratasys, Inc.
Invented by Scott & Lisa Crump

Source: https://en.wikipedia.org/wiki/Stratasys

1992

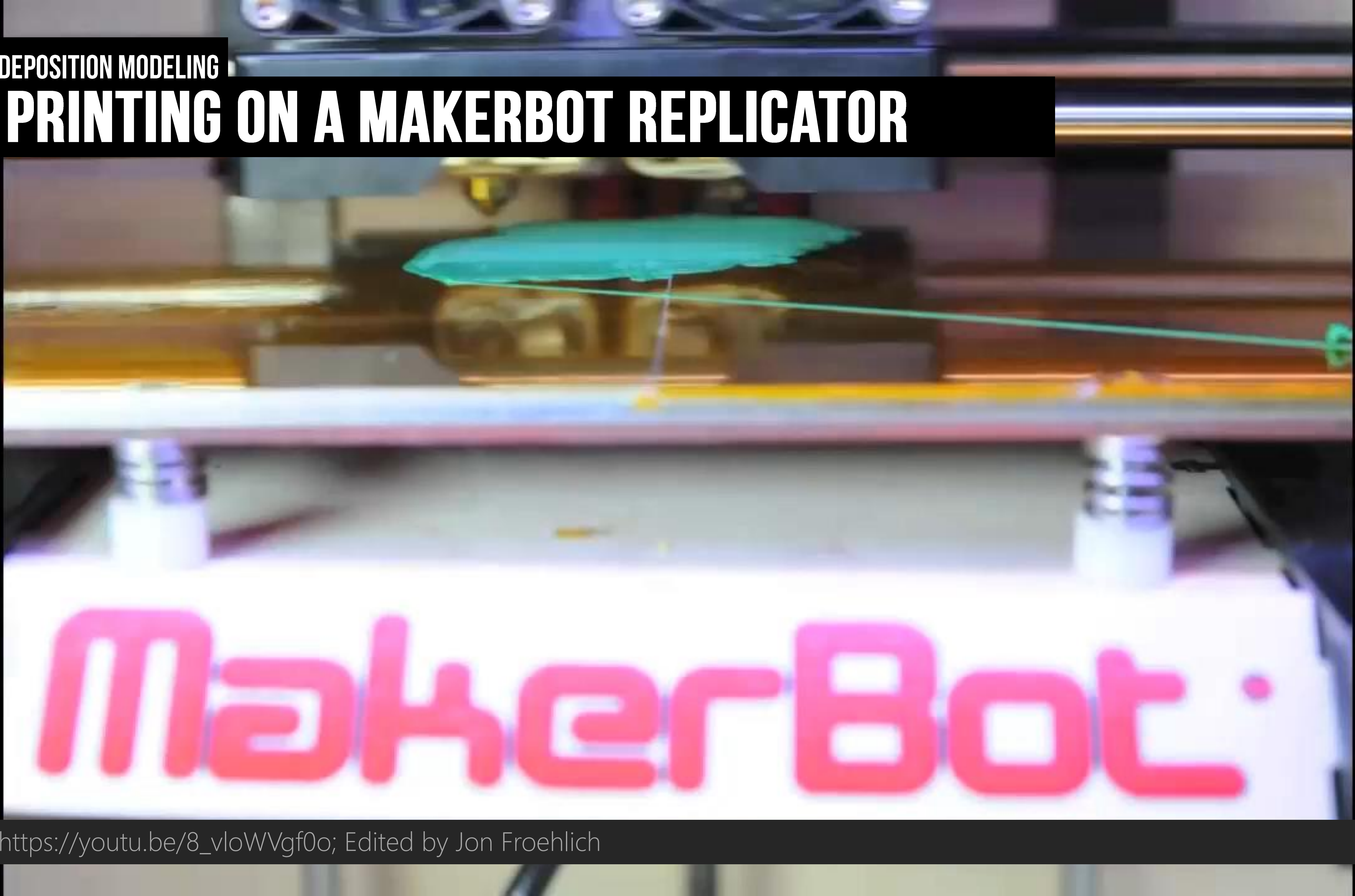
The first commercial FDM printer
3D Modeler by Stratasys, Inc.
Invented by Scott & Lisa Crump

"The idea for the technology came to Crump in 1988 when he decided to make a **toy frog for his young daughter using a glue gun loaded with a mixture of polyethylene and candle wax**. He thought of creating the shape layer by layer and of a way to automate the process. In April 1992, Stratasys sold its first product, the 3D Modeler."

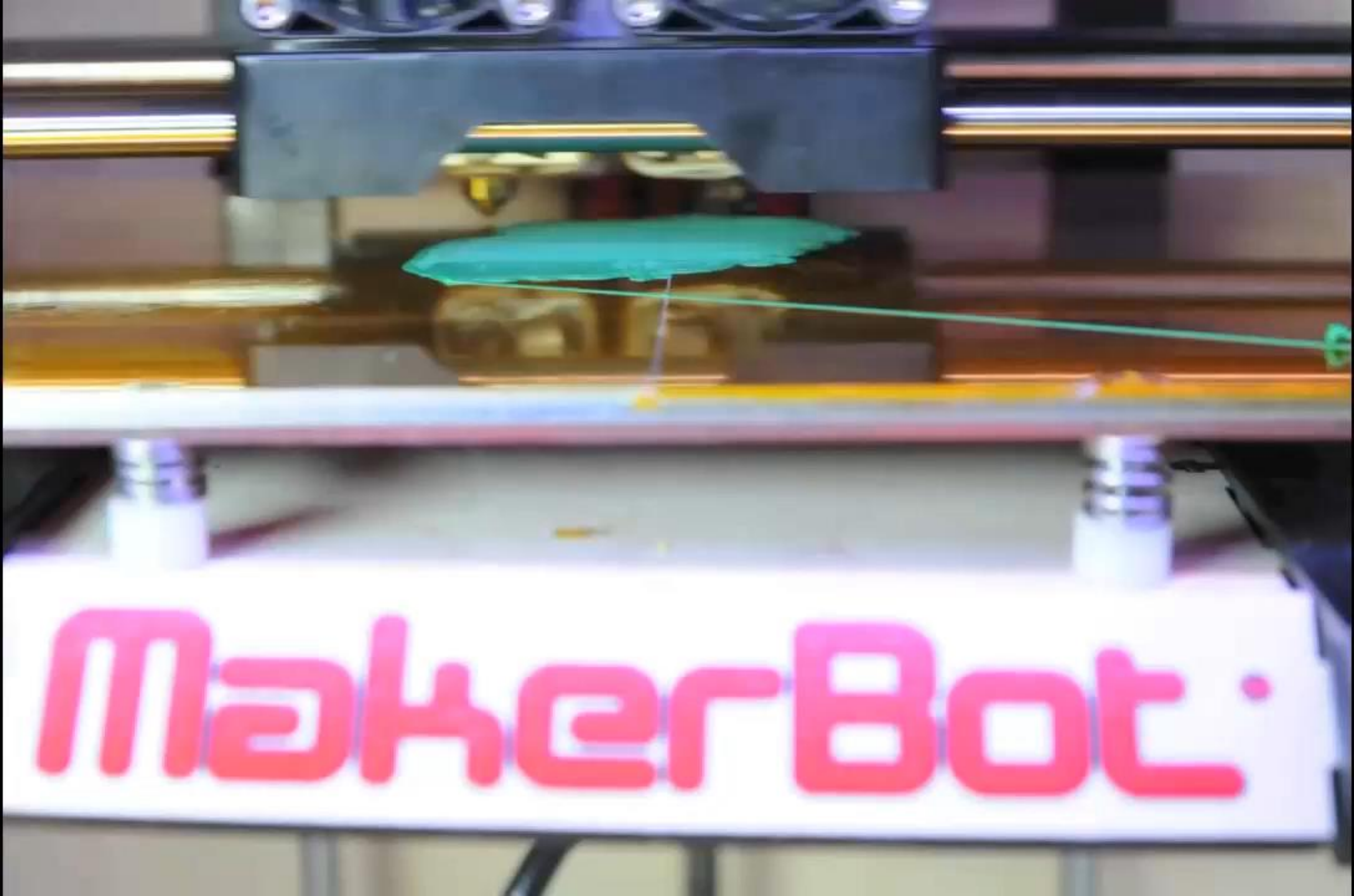
Source: https://en.wikipedia.org/wiki/Stratasys

FUSED DEPOSITION MODELING

3D PRINTING ON A MAKERBOT REPLICATOR



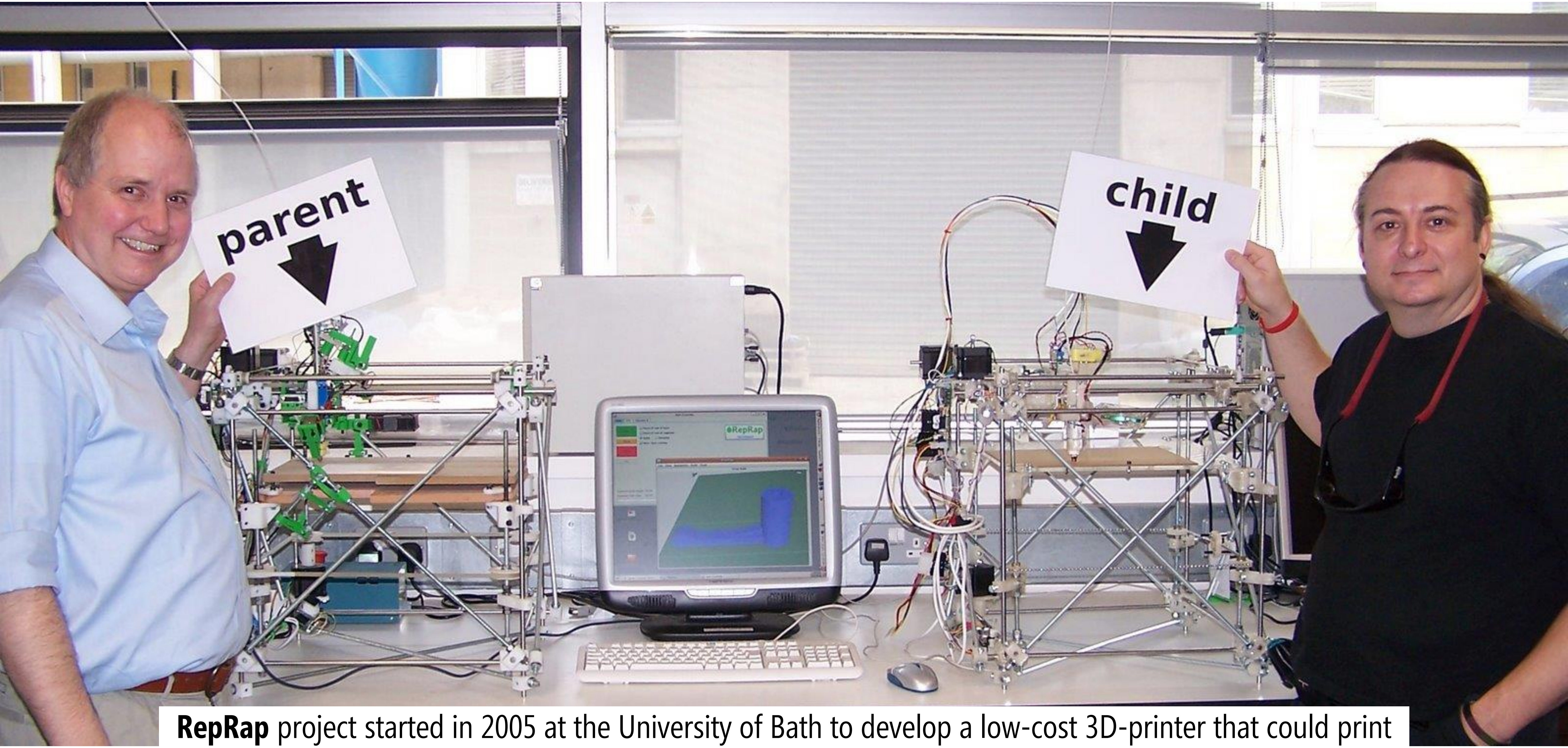
Source: https://youtu.be/8_vloWVgf0o; Edited by Jon Froehlich


MakerBot

FUSED DEPOSITION MODELING

3D PRINTING A MILLENNIUM FALCON ON AN ULTIMAKER 2+

Source: Jon Froehlich, https://youtu.be/BuioPlZ6U7s



RepRap project started in 2005 at the University of Bath to develop a low-cost 3D-printer that could print most of its components. RepRap stands for **replicating rapid prototype**.

MakerBot founded in **2009** by Adam Mayer, Zach "Hoeken" Smith, and Bre Pettis to build on **RepRap project**.

How expiring patents are ushering in the next generation of 3D printing

Filemon Schoffer May 15, 2016

Comment

The year 2016 is quickly shaping up to be one of the hottest years on record for 3D printing innovations. Although there is still a lot of hype surrounding 3D printing and how it may or may not be the next industrial revolution, one thing is for certain: the cost of printing will continue to drop while the quality of 3D prints continues to rise.

This development can be traced to advanced 3D printing technologies becoming accessible due to the expiration of key patents on pre-existing industrial printing processes.

These expiring patents — many of which were issued just before the turn of the century and are reaching the end of their lifespan — are releasing the monopolistic control over processes that have long been held by the original pioneers of the 3D printing industry.

For example, when the Fused Deposition Modeling (FDM) printing process patent expired in 2009, prices for FDM printers dropped from over $10,000 to less than $1,000, and a new crop of consumer-friendly 3D printer manufacturers, like MakerBot and Ultimaker, paved the way for accessible 3D printing.

The next generation of additive manufacturing technologies are making their way down from the industrial market to desktops of consumers and retailers much like FDM did. Among these include patents for three specific 3D printing technologies: liquid-based, powder-based and metal-based printing processes.

Liquid-Based Technology

Filemon Schoffer
Contributor

Filemon Schoffer is the head of community at 3D Hubs.

More posts by this contributor

- 3D printing technologies explained
- Metal 3D printing takes flight

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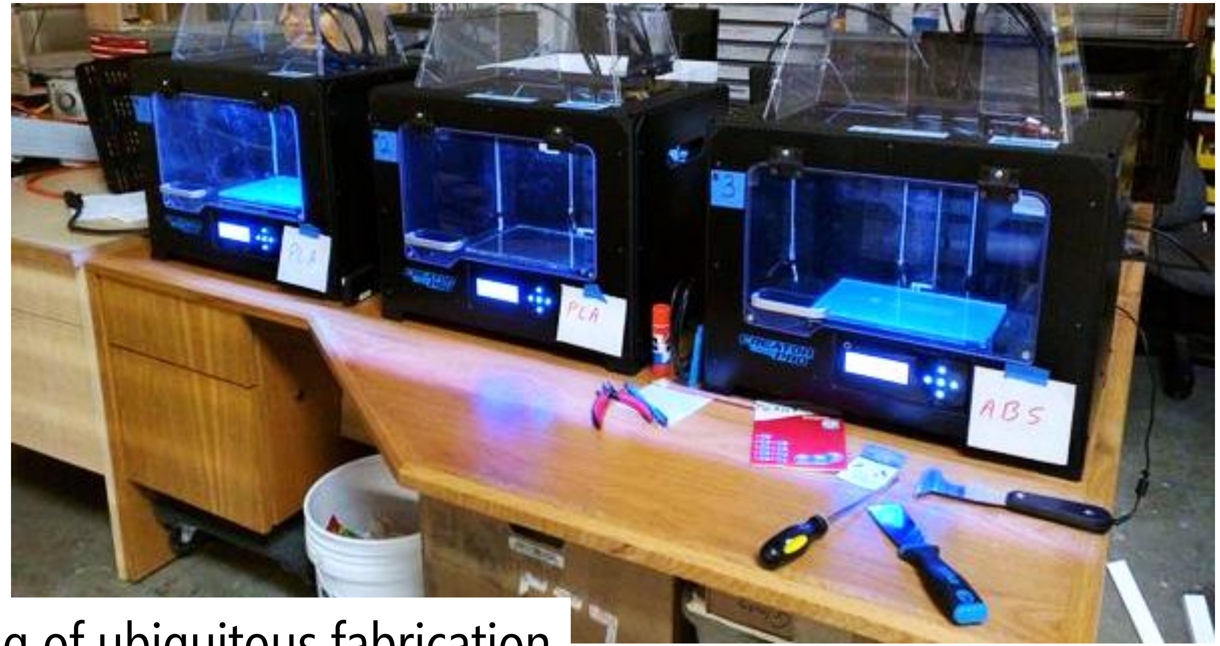
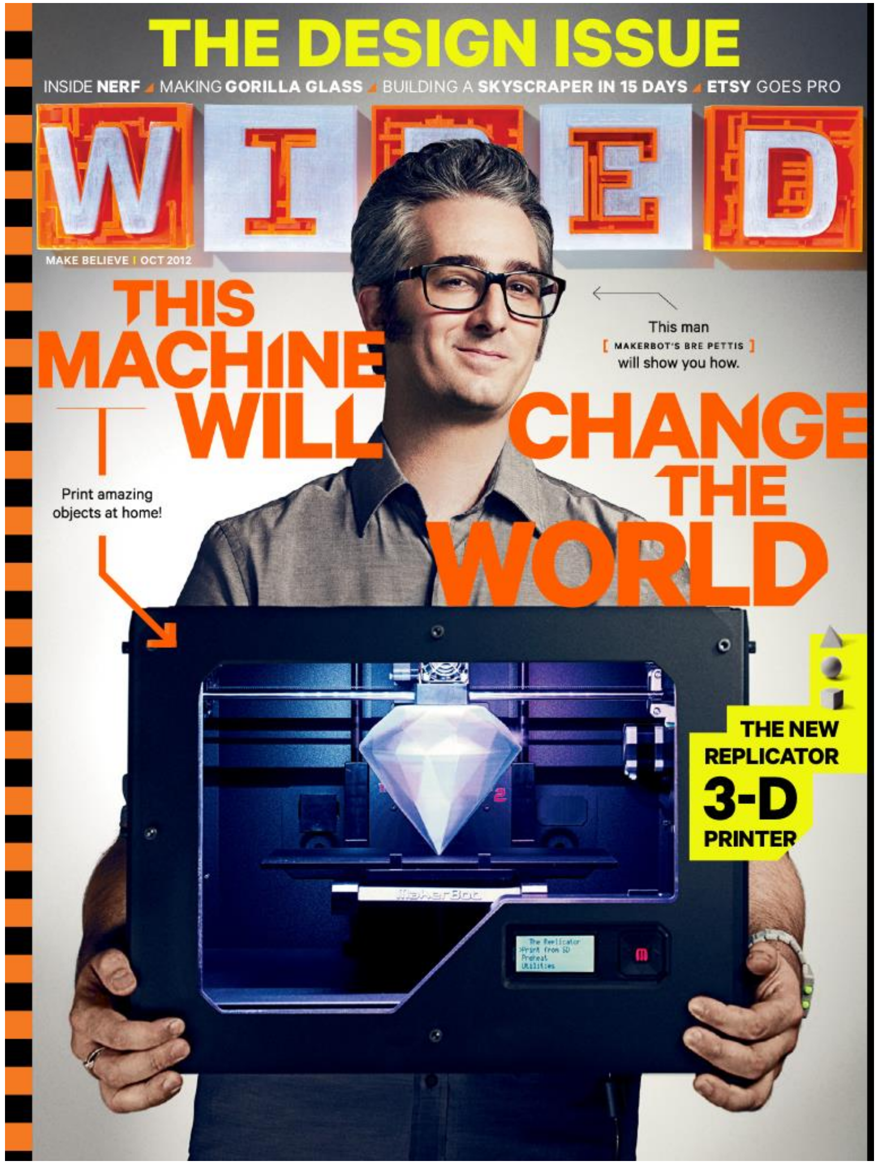


2009 marked the beginning of ubiquitous fabrication

Slide based on Huaishu Peng's job talk;

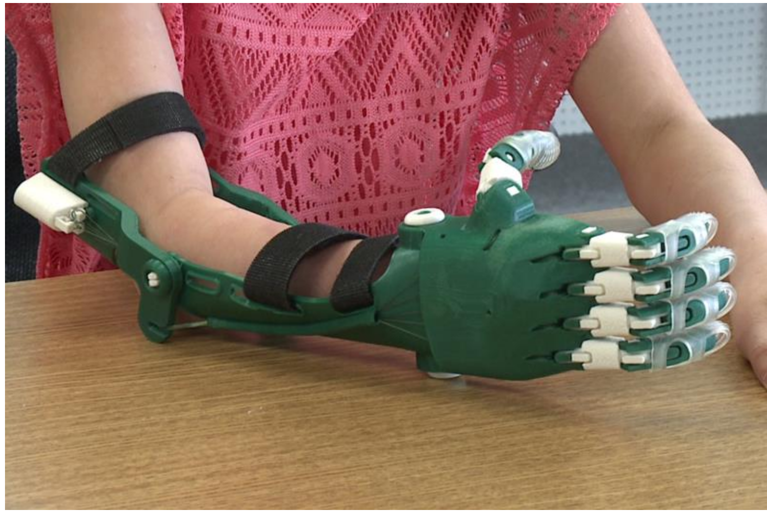
By **2012**
We reached the peak
of the "hype cycle"



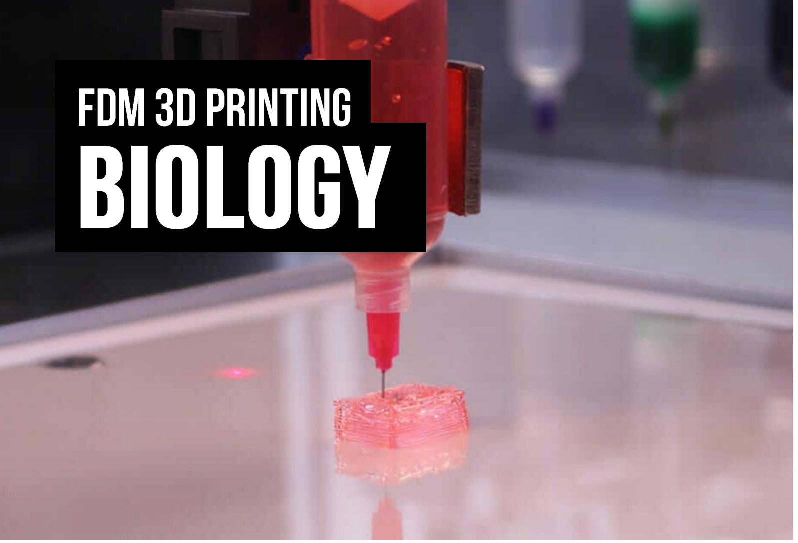
FDM 3D PRINTING
FASHION

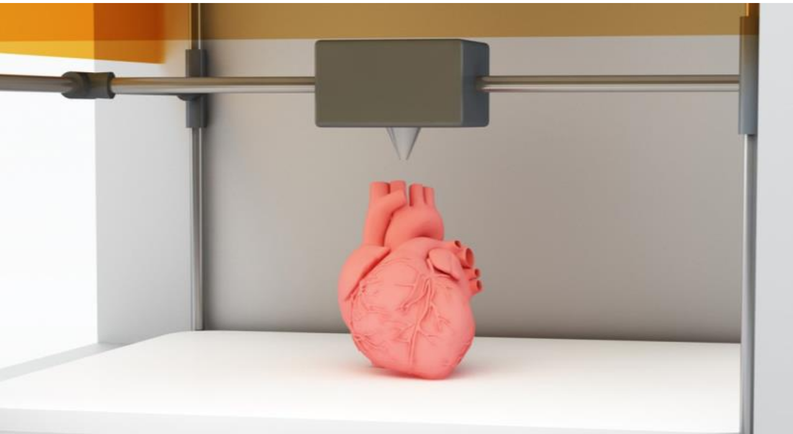
FDM 3D PRINTING

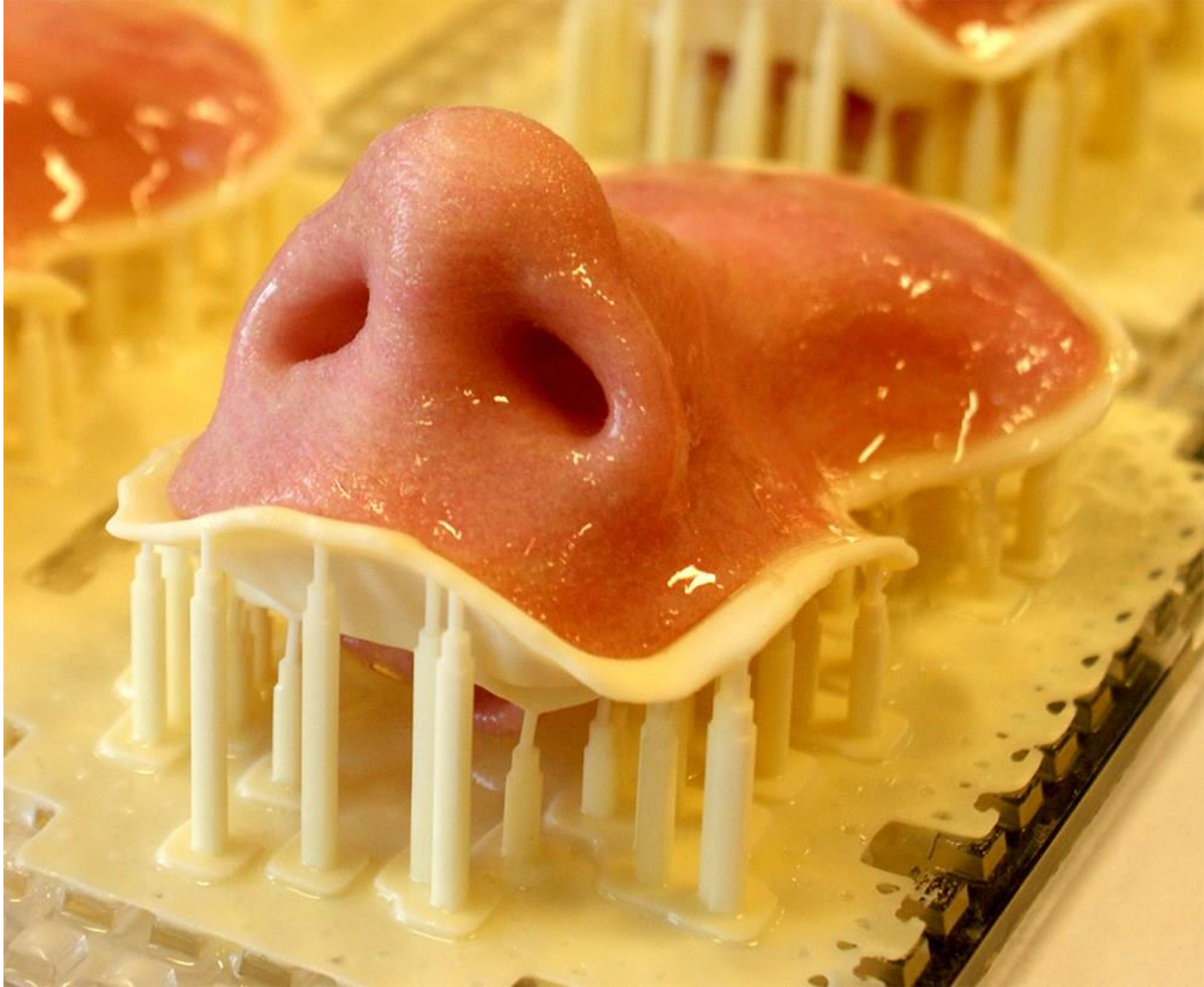
PROSTHETICS



FDM 3D PRINTING
BIOLOGY







FDM 3D PRINTING
BUILDINGS

Source: https://youtu.be/GUdnrtnjT5Q; Company: Apis Cor

FDM 3D PRINTING
CARS

Source: https://youtu.be/iT9A0pBBL2A; Company: Local Motors

Source: https://youtu.be/MKQlys-z7SM; Edited by Jon Froehlich

FDM 3D PRINTING
PANCAKES!

Source: https://youtu.be/6rEHNGPibb0; Company: Pancake Bot

By **2016**

The peak was over & a more realistic attitude set in

WIRED The 3D Printing Revolution That Wasn't SIGN IN | SUBSCRIBE

BUSINESS CULTURE GEAR IDEAS SCIENCE SECURITY TRANSPORTATION

THE RISE AND FALL OF THE EVERYMAN TYCOON

ANDREW ZALESKI BACKCHANNEL 12.01.16 12:00 AM

THE 3D PRINTING REVOLUTION THAT WASN'T

SHARE

13

MAKERBOT MADE A BOLD BET THAT 3D PRINTERS WOULD BECOME AS COMMON AS MICROWAVES. JUST ONE PROBLEM: NO ONE ELSE SHARED THAT DREAM.

It was October 2009 when Bre Pettis — his unmistakable sideburns and dark-rimmed rectangular glasses framing his face — took the stage at Ignite NYC, threw his hand in the air, and shouted "Hooray!" two times. A PowerPoint slide lit up behind him, revealing a photo of a hollow wood box crisscrossed with wiring. Bouncing up and down, his profuse mop of graying hair flopping about, Pettis began: "I'm going to talk about MakerBot and the future and an industrial revolution that we're beginning — that's begun." A former art teacher, Pettis had emerged as a key character in the growing maker movement of the late 2000s, a worldwide community of tinkerers who holed away in makeshift workshops and hackerspaces, equally at home with tools like old-school lathes and contemporary laser cutters. Pettis had begun his ascent in 2006, producing weekly videos for *MAKE* magazine—the maker movement's Bible—that featured him navigating goofy

Brooklyn, lay off even more workers, and move all manufacturing to a contractor in China, even as the company celebrated the sale of its 100,000th 3D printer. Analysis of those same annual reports published by Stratasys shows that MakerBot sold a paltry 1,421 printers through the first three months of 2016.

"In 2014, MakerBot was convinced there was a consumer market ripe and ready. In 2015, we realized the consumer market is not where we thought it was," Jaglom told me the day MakerBot announced it was closing its Brooklyn factory.

Here's the thing about 3D printing: It's not as revolutionary as it was made out to be, at least not yet. Big companies, like General Electric and Ford, experiment with 3D printing and even use it to produce some parts. GE this year even spent $1.4 billion to acquire two 3D printing companies. But 3D printing technology still isn't reliable enough, fast enough, or cheap enough to supplant injection molding or traditional, subtractive manufacturing processes.

It's also not a simple process. If you want to print out original pieces, you need to know how to do 3D design, which admittedly has become much simpler thanks to online software like TinkerCAD. But an extruder head might become jammed during printing. The print bed might warp. The finished print might be crooked, which means you have to re-orient the part for printing. "There's a ton of work involved. It's not a thing where you can push a button and get what you were imagining," says Rockhold.

During the heady days of 3D printing, these weren't questions that were ignored so much as problems to be solved at a later date. What's happening now is what Jaglom calls the "de-hyping" of the industry, as the public perception of 3D printing finally catches up to reality. Stratasys' stock price took a tumble, from an all-time high of $136 in January 2014 to $25 in October 2015, when MakerBot announced its second round of layoffs.

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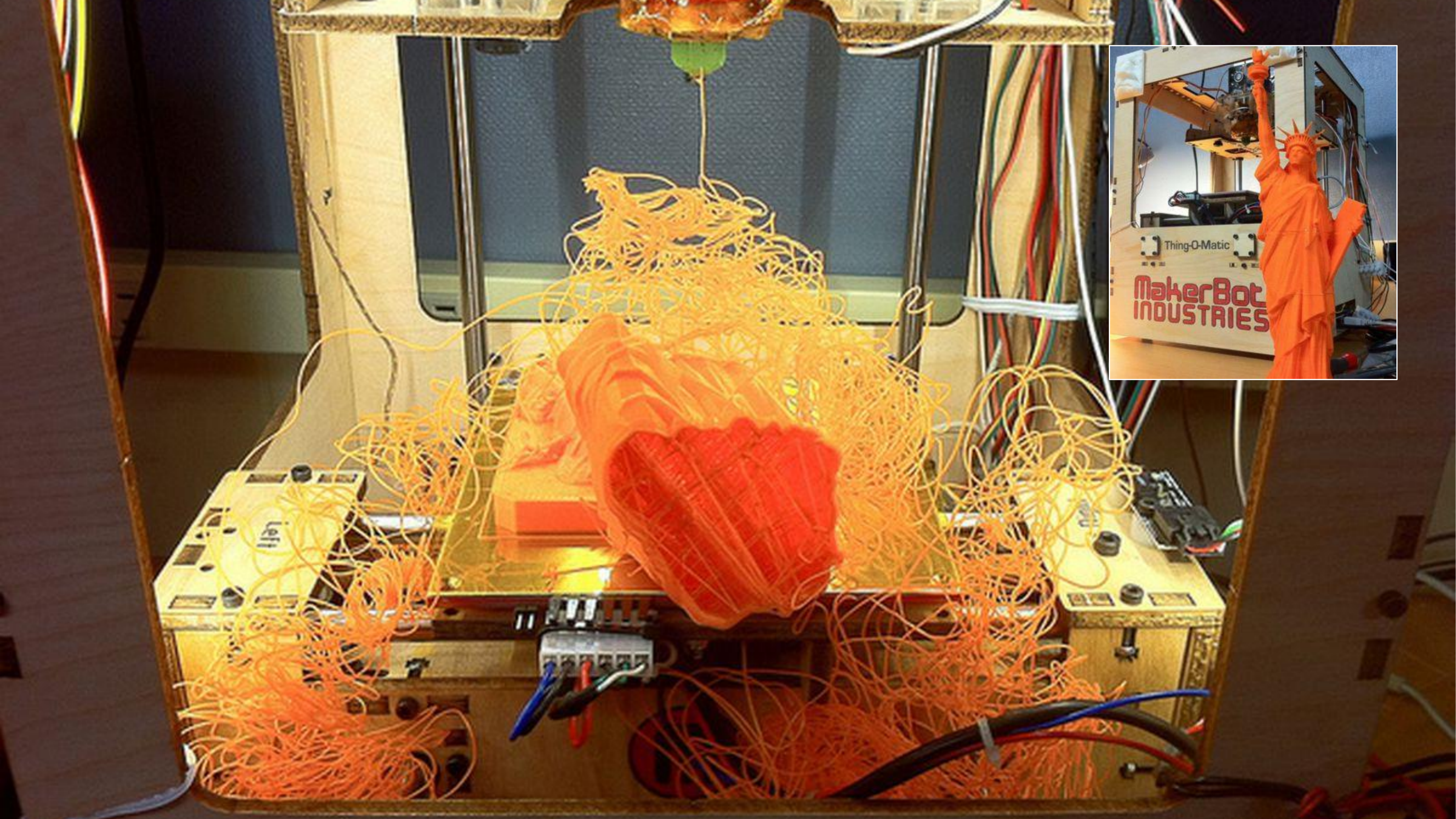
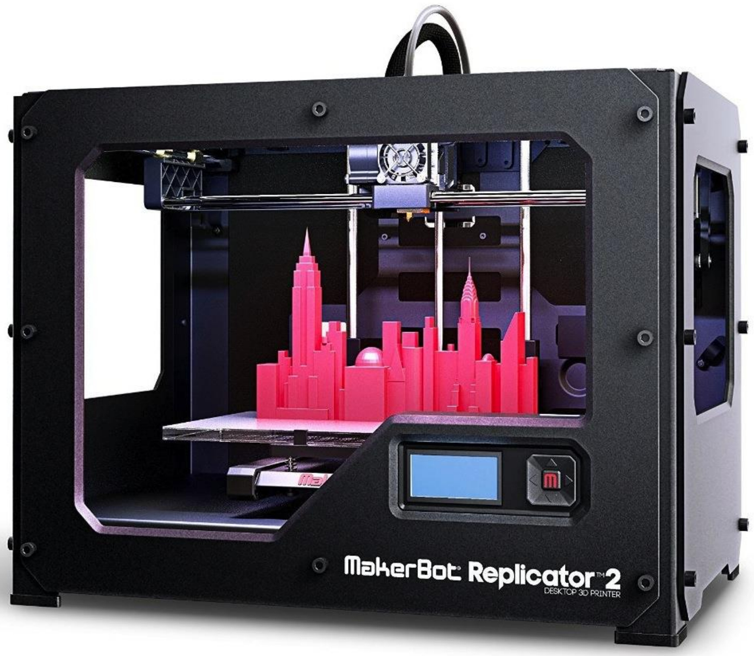
Source: https://www.wired.com/2016/12/the-3d-printing-revolution-that-wasnt/


Thing-O-Matic
MakerBot
INDUSTRIES

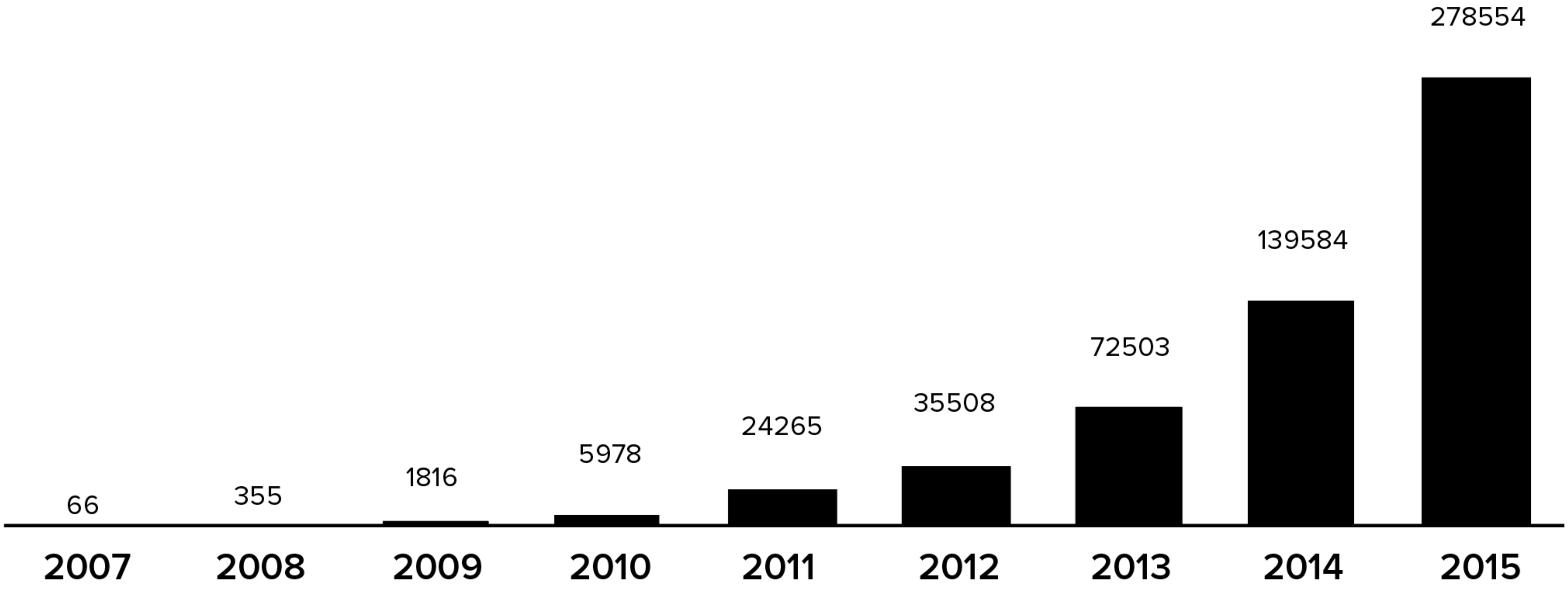
!=


MakerBot Replicator 2
DESKTOP 3D PRINTER

With the right skillset, **3D modeling + printing** can be a powerful (and fast) form prototyping method

CONSUMER-GRADE 3D PRINTERS SOLD IN 2015

Printers all < $5000 sold globally per year



Source: https://www.3dhubs.com/knowledge-base/advantages-3d-printing; Original source: Wohlers Report, 2015

WHY 3D PRINT?

Speed. Designers can build, print, solicit feedback, & iterate on ideas quickly. 3D-printing allows the designer and other stakeholders to get a tangible, physical experience of a design.

Iteration. Digital models can be easily tweaked & reprinted.

Cost. Cost at low-volumes (*i.e.*, one-offs) is quite competitive compared to alternatives. Injection molding, for example, requires expensive mold-making equipment and each mold is expensive to produce. 3D-printers themselves are far cheaper than formative and subtractive machines.

Personalization. Certain industries (*e.g.*, dental, prosthetics) can use high-grade 3D-printers to quickly produce personalized devices for each patient (user)

Complex geometries. 3D-printers can create physical forms with complex geometries that would be impossible or very difficult using other manufacturing processes.

Source: Redwood *et al.*, The 3d Printing Handbook, 2017; https://www.3dhubs.com/knowledge-base/advantages-3d-printing

WHY 3D PRINT?

MAKE THINGS NOT POSSIBLE WITH OTHER APPROACHES

Source: https://youtu.be/qBHg1xhANxU; Edited by Jon Froehlich

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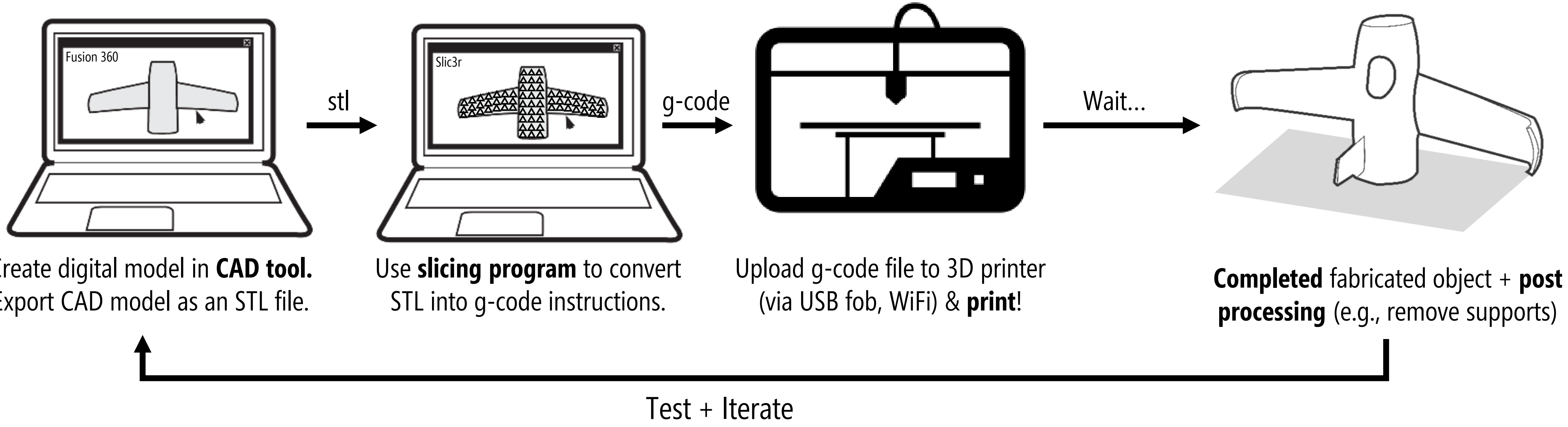
Ease of access. Unlike injection molding or even subtractive processes like CNC mills or laser cutters, 3D-printers are relatively cheap to buy and operate. Many public libraries and other community spaces provide access as well.

Sustainability. Subtractive methods remove significant amounts of material that is not used, resulting in high waste volumes. 3D-printable ABS plastic can be recycled & PLA is compostable. Check with local recycling/compost centers.

Source: Redwood *et al.*, The 3d Printing Handbook, 2017; https://www.3dhubs.com/knowledge-base/advantages-3d-printing

3D-PRINTING PROCESS

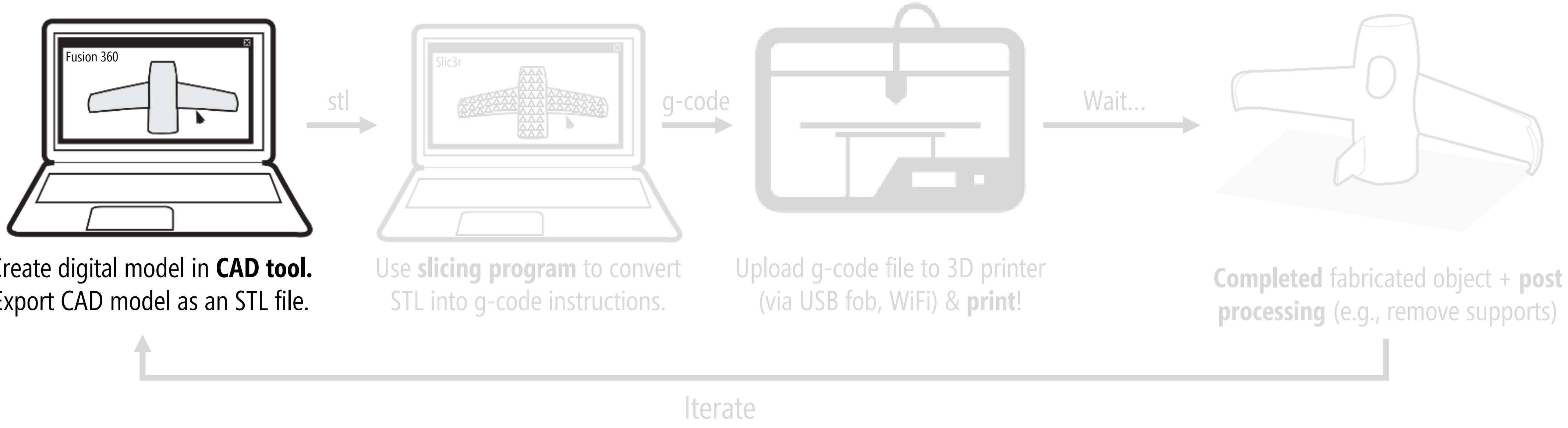
6-STEP ITERATIVE PROCESS FROM MODELING TO PRINTING



Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

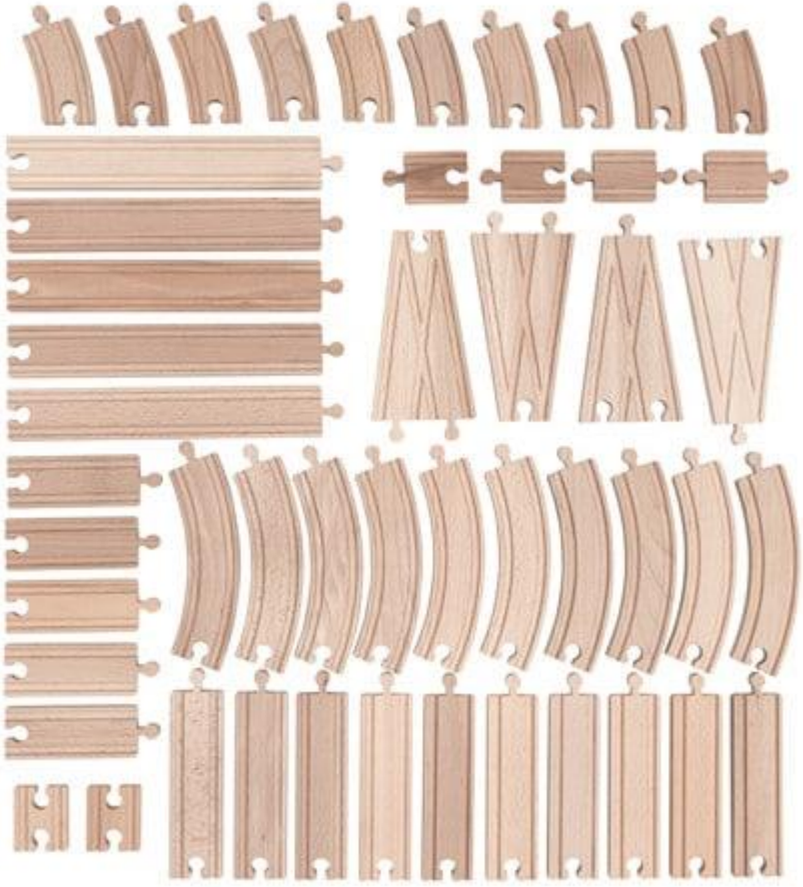
3D-PRINTING PROCESS

1. CREATE DIGITAL MODEL IN CAD TOOL



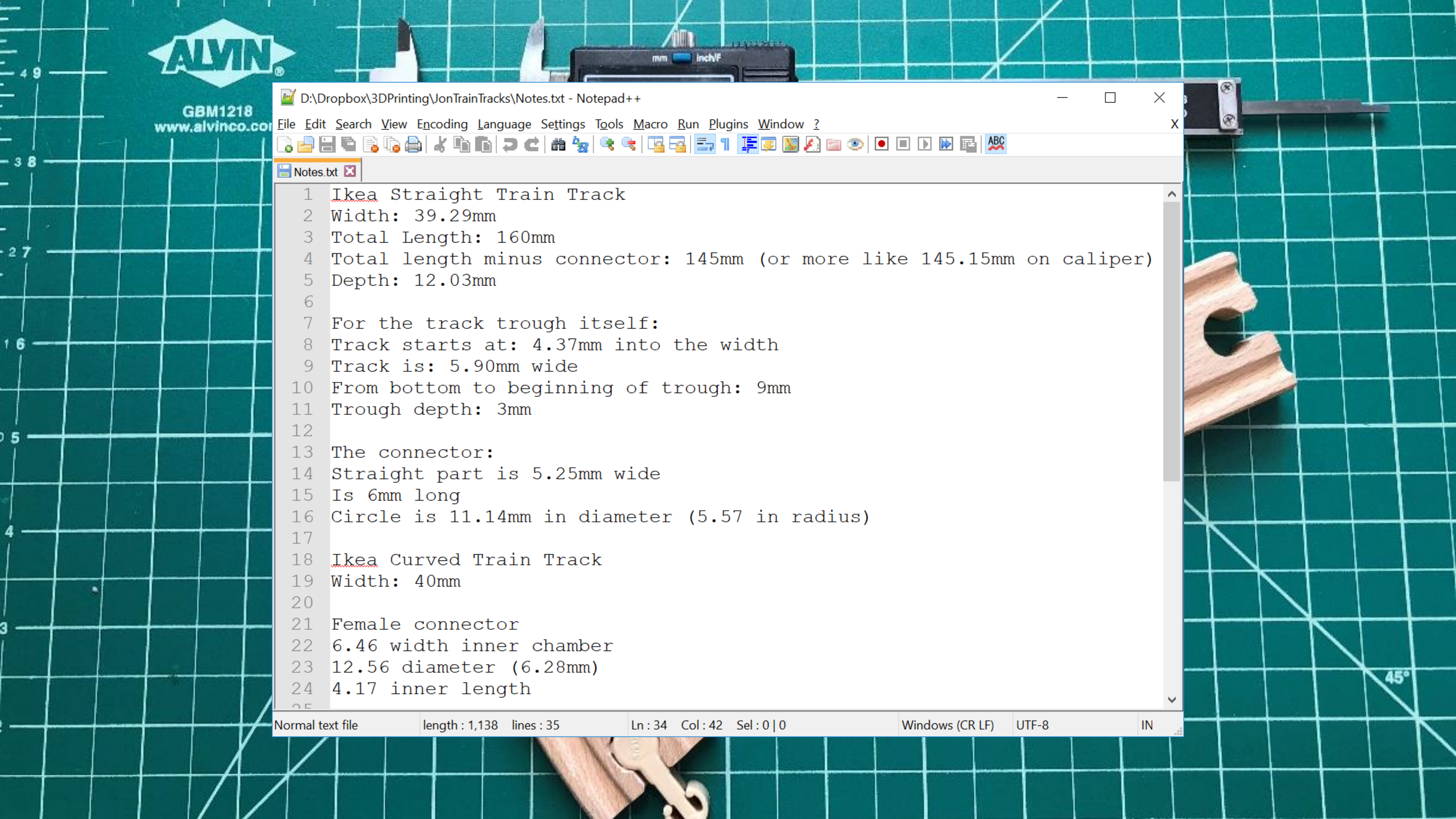
Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

EXAMPLE: TRAIN TRACKS



STEP 0: MEASUREMENT

MEASURING!


ALVIN
GBM1218
www.alvinco.co
mm inch/F
D:\Dropbox\3DPrinting\JonTrainTracks\Notes.txt - Notepad++
File Edit Search View Encoding Language Settings Tools Macro Run Plugins Window ?
Notes.txt
Ikea Straight Train Track
Width: 39.29mm
Total Length: 160mm
Total length minus connector: 145mm (or more like 145.15mm on caliper)
Depth: 12.03mm

For the track trough itself:
Track starts at: 4.37mm into the width
Track is: 5.90mm wide
From bottom to beginning of trough: 9mm
Trough depth: 3mm

The connector:
Straight part is 5.25mm wide
Is 6mm long
Circle is 11.14mm in diameter (5.57 in radius)

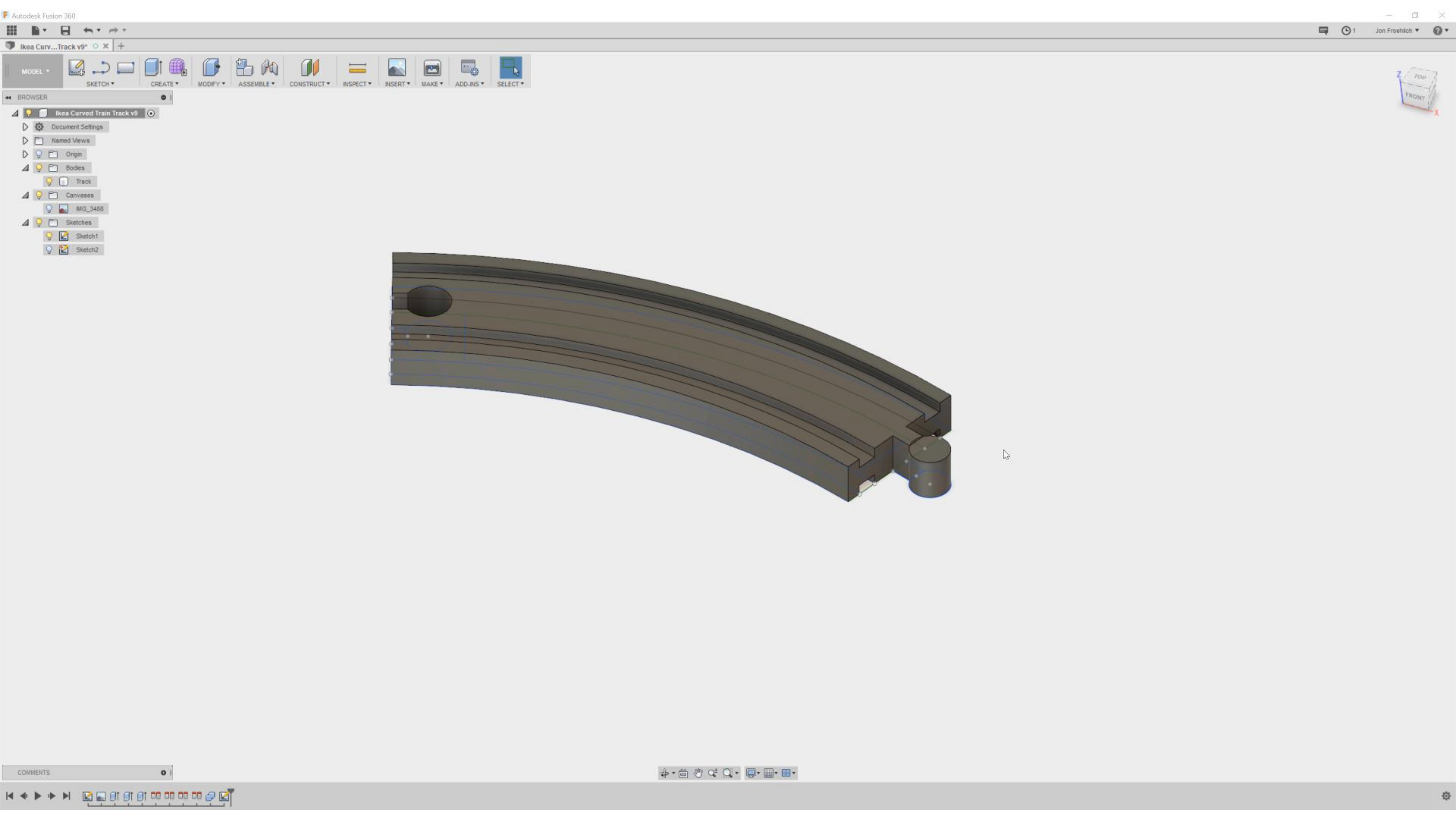
Ikea Curved Train Track
Width: 40mm

Female connector
6.46 width inner chamber
12.56 diameter (6.28mm)
4.17 inner length
Normal text file
length : 1,138 lines : 35
Ln : 34 Col : 42 Sel : 0 | 0
Windows (CR LF)
UTF-8
IN
45°

STEP 1: CAD MODELING

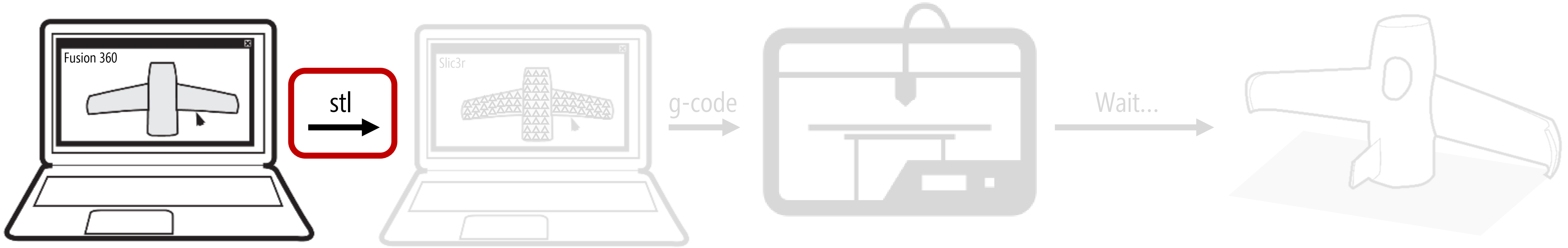
CREATING CUSTOM TRAIN TRACKS

Source: Jon Froehlich


Autodesk Fusion 360
Ikea Curv...Track v9*
Jon Froehlich
MODEL
SKETCH
CREATE
MODIFY
ASSEMBLE
CONSTRUCT
INSPECT
INSERT
MAKE
ADD-INS
SELECT
BROWSER
Ikea Curved Train Track v9
Document Settings
Named Views
Origin
Bodies
Track
Canvases
IMG_3488
Sketches
Sketch1
Sketch2
COMMENTS
TOP
FRONT

3D-PRINTING PROCESS

2. EXPORT CAD MODEL AS STL



Create digital model in **CAD tool.** Export CAD model as an STL file.

Use **slicing program** to convert STL into g-code instructions.

Upload g-code file to 3D printer (via USB fob, WiFi) & **print**!

Completed fabricated object + **post processing** (e.g., remove supports)

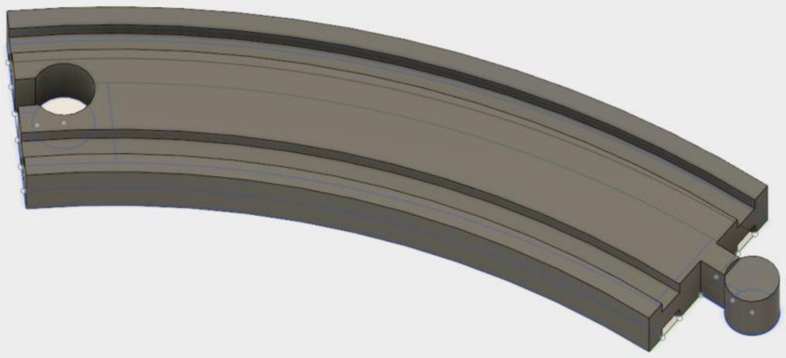
Iterate

Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

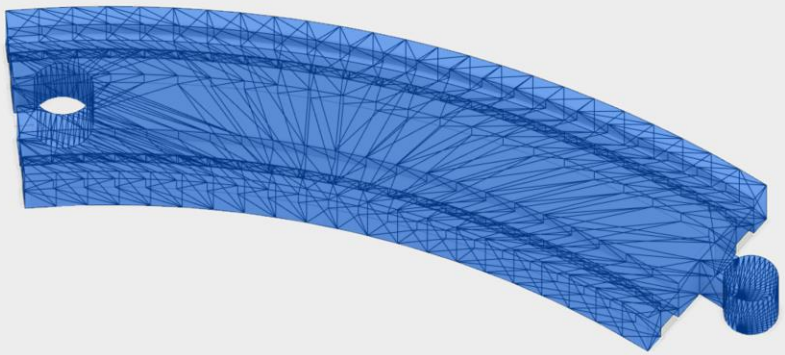
STEP 2: EXPORT TO STL FILE

EXPORT CAD MODEL AS STL (TRIANGLE MESH)

The STL (Standard Triangle Language) is the industry standard file type for 3D printing. It uses linked triangles to represent the geometry of the solid model (aka a triangle mesh). All modern CAD tools allow you to export their native file format into STL.



Raw CAD Model

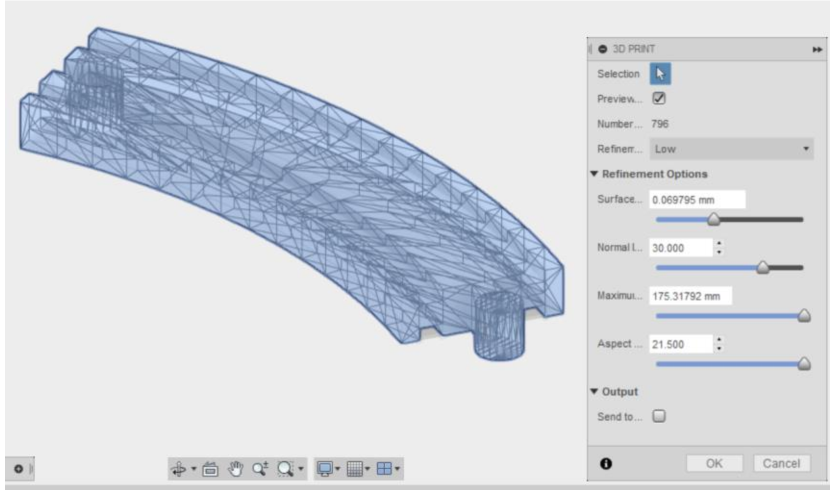


Converted to STL

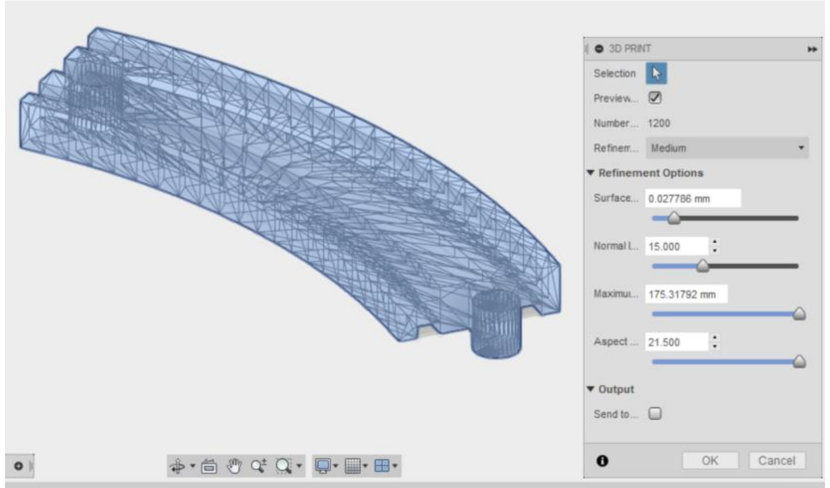
See also: https://www.3dhubs.com/knowledge-base/3d-printing-stl-files-step-step-guide

STEP 2: EXPORT TO STL FILE

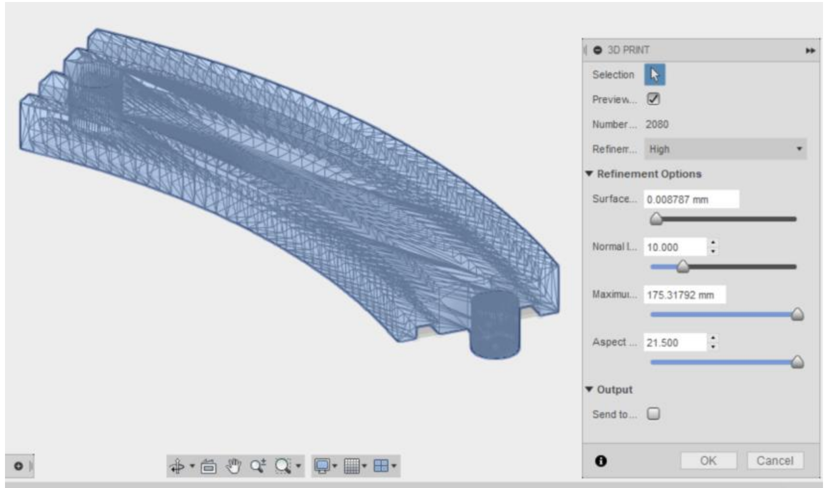
CONFIGURING EXPORT RESOLUTION (# OF TRIANGLES)



Export Quality: Low
Number of triangles: 796



Export Quality: Medium
Number of triangles: 1200



Export Quality: High
Number of triangles: 2080

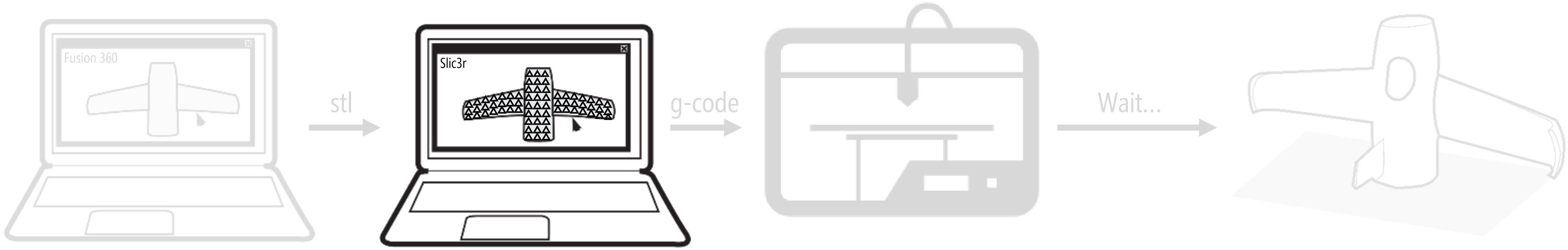
Number of triangles

Typically the default export quality is fine. If you export at too low of resolution, the model will have visible triangles on its surface when printed. Increasing the resolution too much (*e.g.,* beyond capabilities of printer) will just lead to file bloat and print difficulties.

See also: https://www.3dhubs.com/knowledge-base/3d-printing-stl-files-step-step-guide

3D-PRINTING PROCESS

3. USE SLICING PROGRAM TO CONVERT STL TO G-CODE



Create digital model in **CAD tool.** Export CAD model as an STL file.

Use **slicing program** to convert STL into g-code instructions.

Upload g-code file to 3D printer (via USB fob, WiFi) & **print**!

Completed fabricated object + **post processing** (e.g., remove supports)

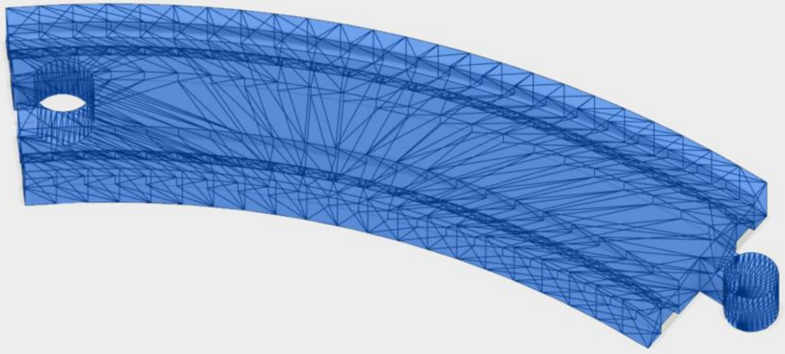
Iterate

Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

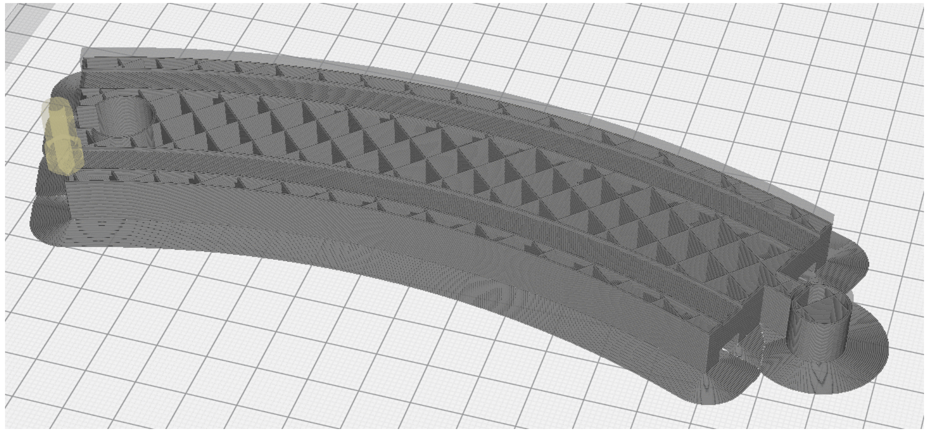
STEP 3: SLICING & GENERATING G-CODE

SLICERS CONVERT STLS INTO PRINTER INSTRUCTIONS

While STL is an industry standard file type for geometrical models, this needs to be converted into printing instructions your 3D printer can understand (g-code). Slicers cut the model into horizontal slices (layers), generate toolpaths to fill them, and calculate the amount of material to be extruded.



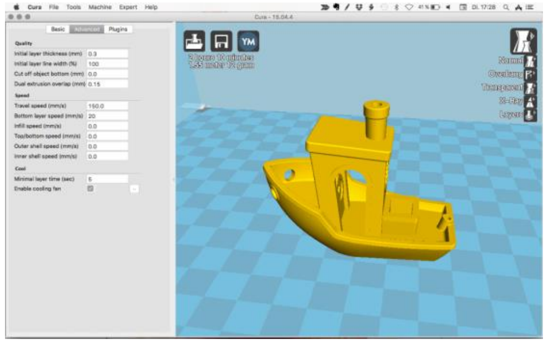
Load STL file into slicing program

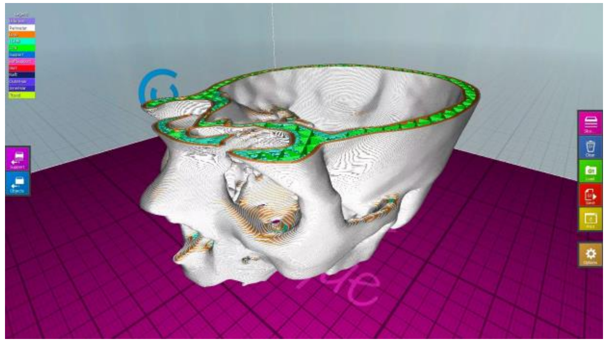


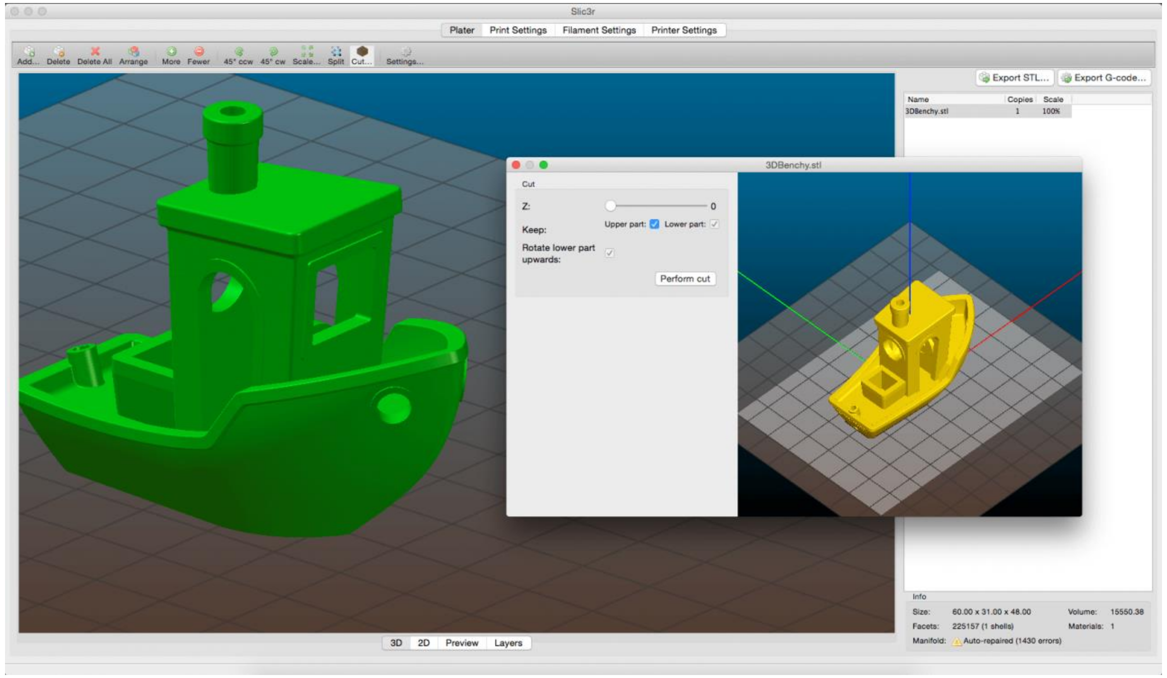
Slicer will create g-code (toolpath) instructions for printer

STEP 3: SLICING & GENERATING G-CODE

SLICER PROGRAMS

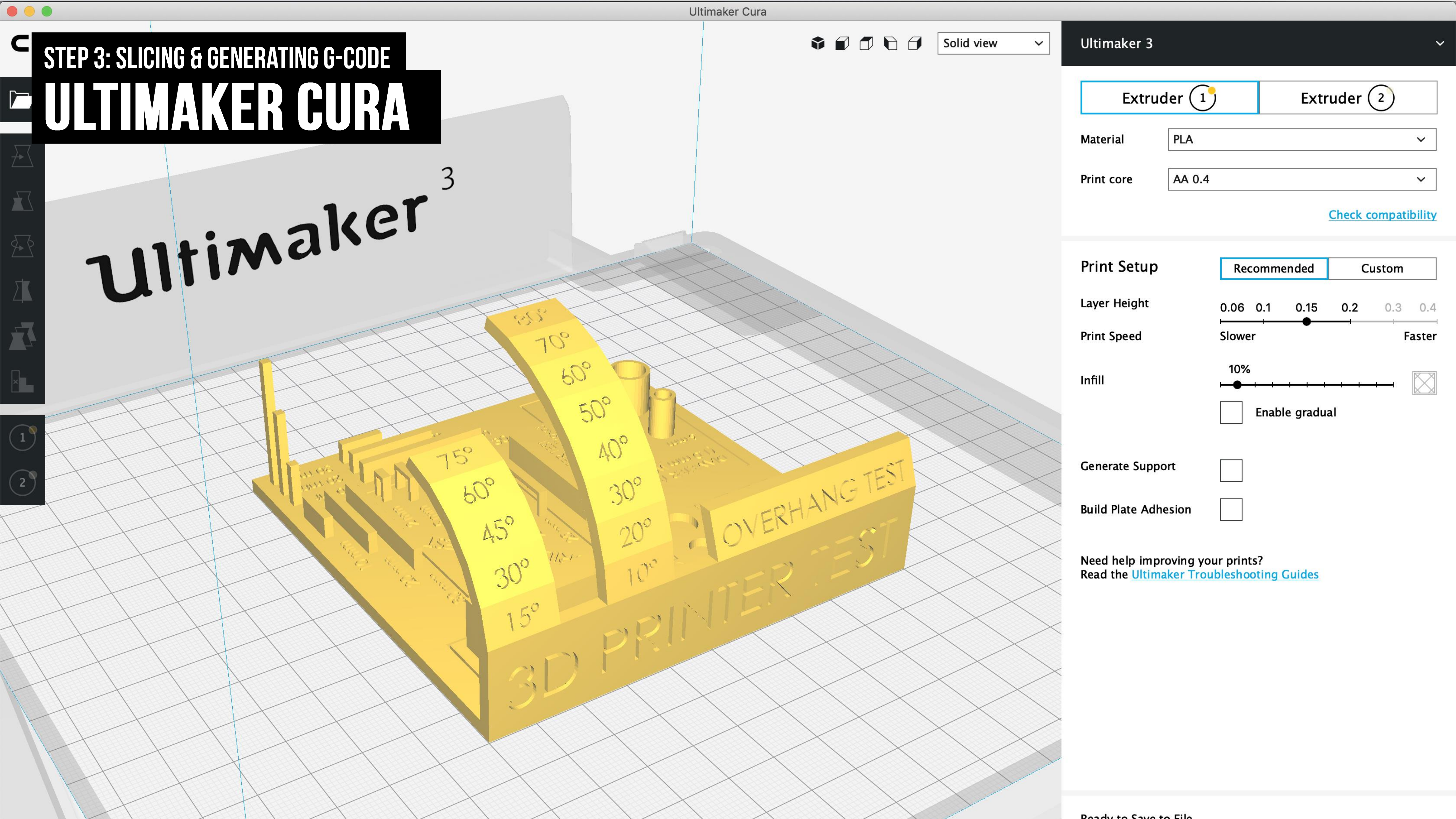






Software	User	Price	OS
3DPrinterOS	Beginners, Advanced Users	Freemium	Browser, Windows, Mac
Astroprint	Beginners, Advanced Users	Freemium	Browser, Raspberry Pi, pcDuino
CraftWare	Beginners, Advanced Users	Free	Windows, Mac, Linux
Cura	Beginners, Advanced Users	Free	Windows, Mac, Linux
IceSL	Advanced Users	Free	Windows, Linux
ideaMaker	Beginners, Advanced Users	Free	Windows, Mac, Linux
KISSlicer	Beginners, Advanced Users	Free/$35	Windows, Mac, Linux, Raspberry Pie
MakerBot Print	Beginners	Free	Windows, Mac
MatterControl	Beginners, Advanced Users	Free	Windows, Mac, Linux
Netfabb Standard	Intermediate Users, Advanced Users	$1,000 to $4,300 (annual subscription)	Windows
OctoPrint	Intermediate Users, Advanced Users	Free	Raspberry Pi, Windows, Mac Linux
Repetier	Intermediate Users, Advanced Users	Free	Windows, Mac, Linux
SelfCAD	Beginner, Advanced Users	Free trial, $9.99/month	Browser
Simplify3D	Beginners, Advanced Users	$150	Windows, Mac
Slic3r	Advanced Users, Professional Users	Free	Windows, Mac, Linux
SliceCrafter	Advanced Users	Free	Browser
Tinkerine Suite	Beginners	Free	Windows, Mac
Z-Suite	Beginners	Free	Windows, Mac

https://all3dp.com/1/best-3d-slicer-software-3d-printer/


Ultimaker Cura
STEP 3: SLICING & GENERATING G-CODE
ULTIMAKER CURA
Solid view
Ultimaker 3
Extruder 1
Extruder 2
Material
PLA
Print core
AA 0.4
Check compatibility
Print Setup
Recommended
Custom
Layer Height
0.06 0.1 0.15 0.2 0.3 0.4
Print Speed
Slower
Faster
Infill
10%
Enable gradual
Generate Support
Build Plate Adhesion
Need help improving your prints?
Read the Ultimaker Troubleshooting Guides
Ultimaker 3
OVERHANG TEST
3D PRINTER TEST

STEP 3: SLICING & GENERATING G-CODE

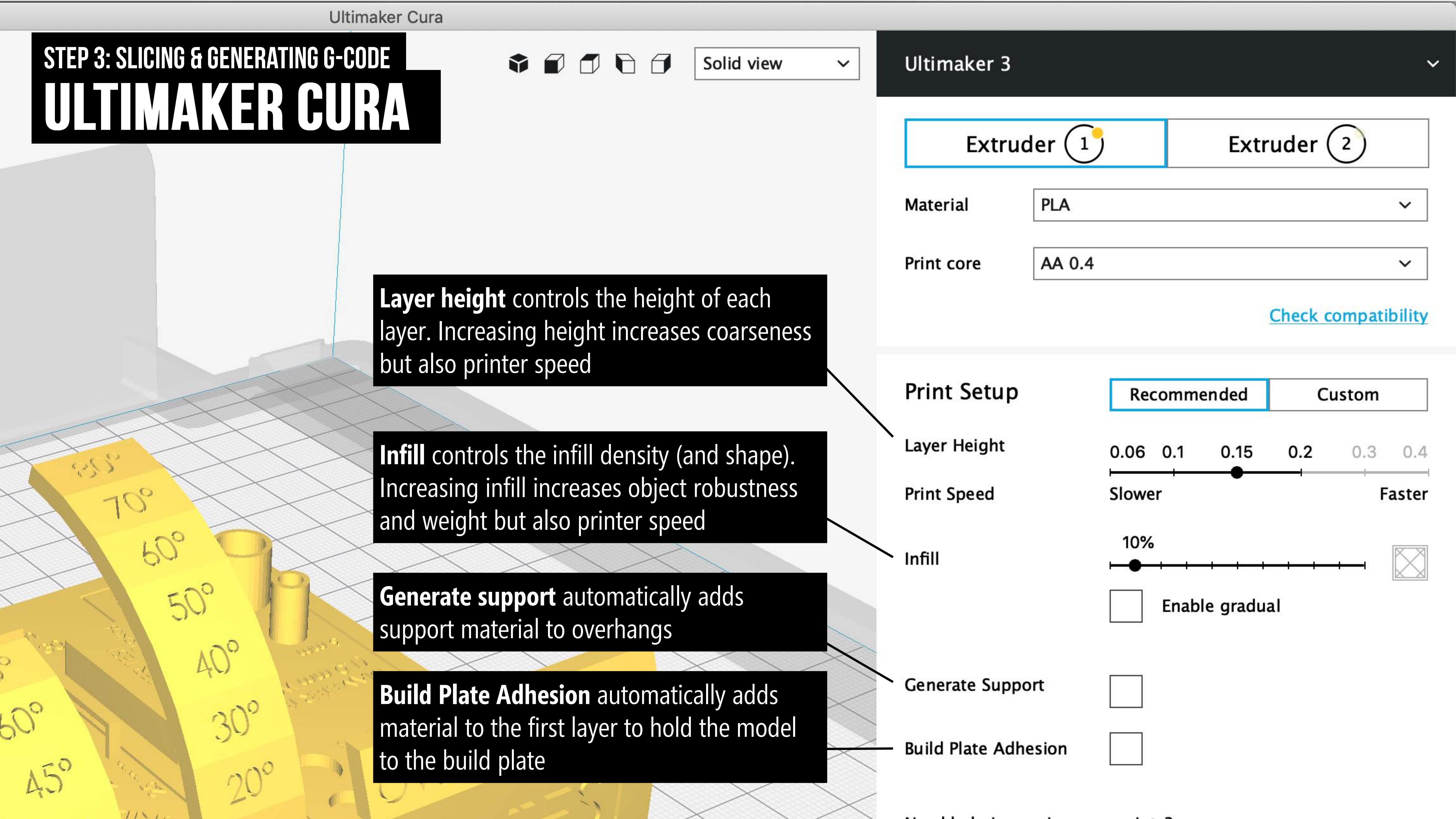
ULTIMAKER CURA

Layer height controls the height of each layer. Increasing height increases coarseness but also printer speed

Infill controls the infill density (and shape). Increasing infill increases object robustness and weight but also printer speed

Generate support automatically adds support material to overhangs

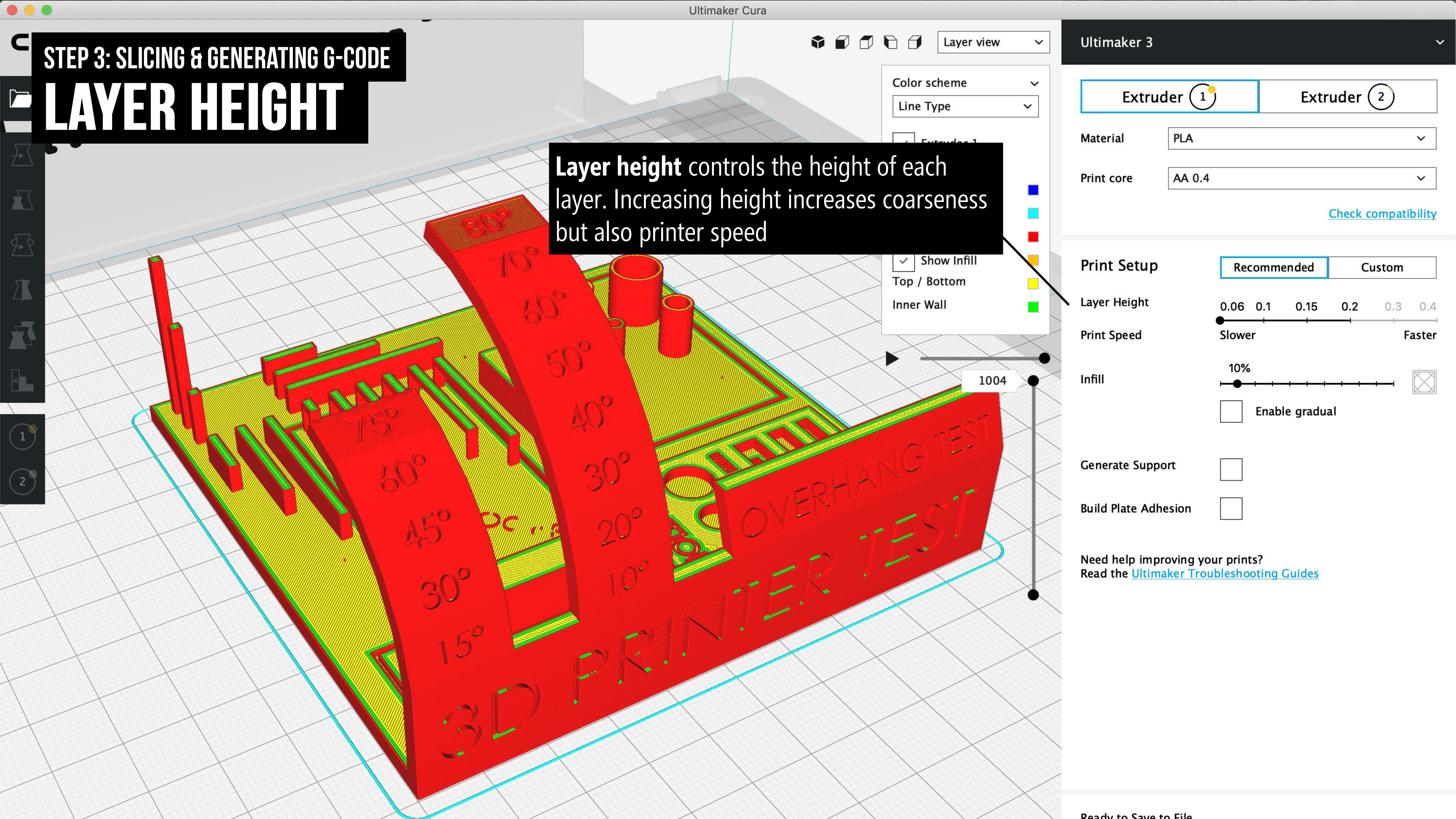
Build Plate Adhesion automatically adds material to the first layer to hold the model to the build plate

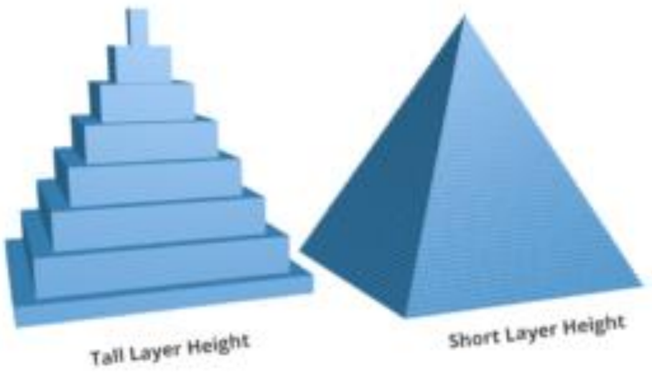


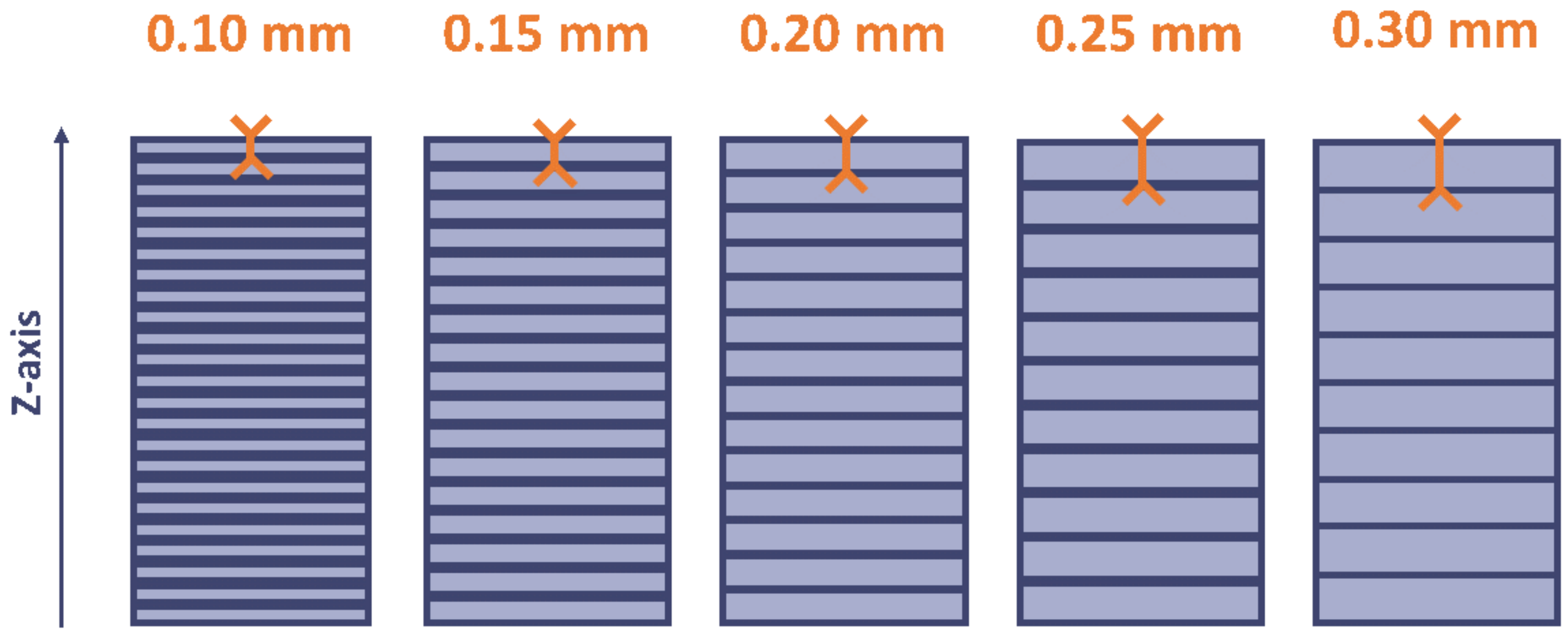
STEP 3: SLICING & GENERATING G-CODE

LAYER HEIGHT

Layer height controls the height of each layer. Increasing height increases coarseness but also printer speed

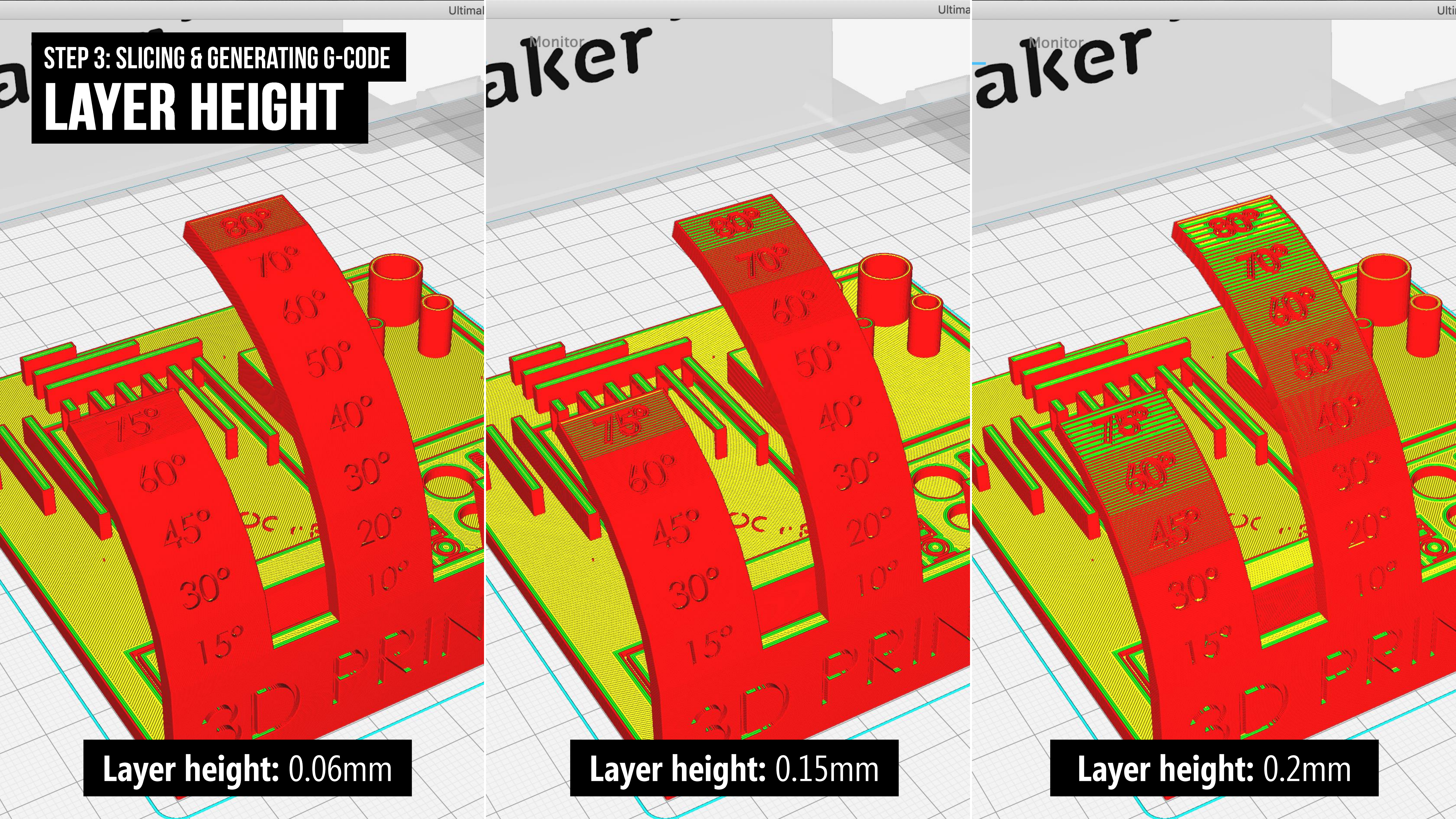



Tall Layer Height
Short Layer Height


0.10 mm
0.15 mm
0.20 mm
0.25 mm
0.30 mm
Z-axis

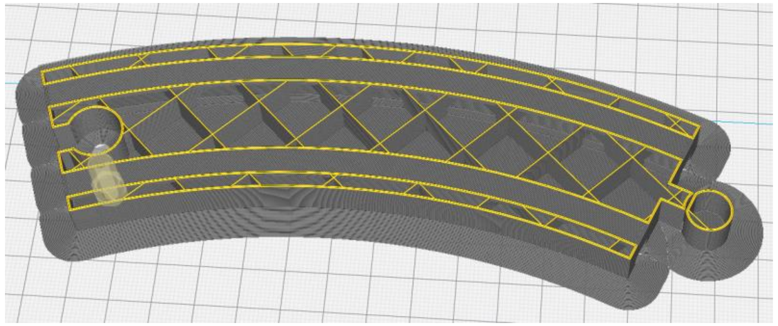
Layer Heights

0.8 mm 0.6 mm 0.45 mm 0.3 mm 0.1mm


STEP 3: SLICING & GENERATING G-CODE
LAYER HEIGHT
Layer height: 0.06mm
Layer height: 0.15mm
Layer height: 0.2mm

STEP 3: SLICING & GENERATING G-CODE

SETTING INFILL



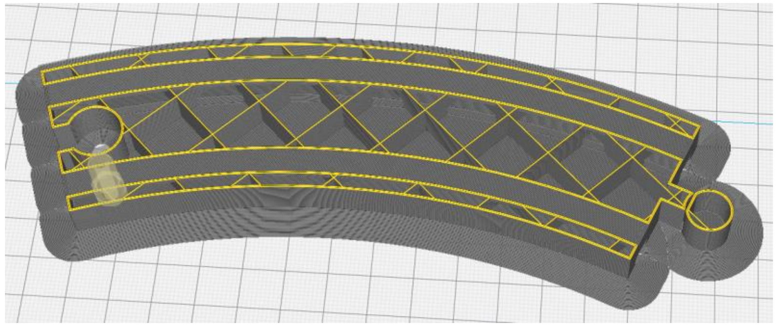
Infill Density: 5%

Estimated print time: 2h 53min

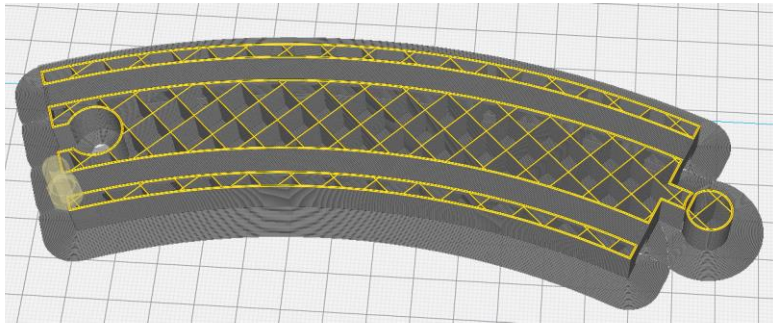
Estimated filament: 2.92 m / ~23g

STEP 3: SLICING & GENERATING G-CODE

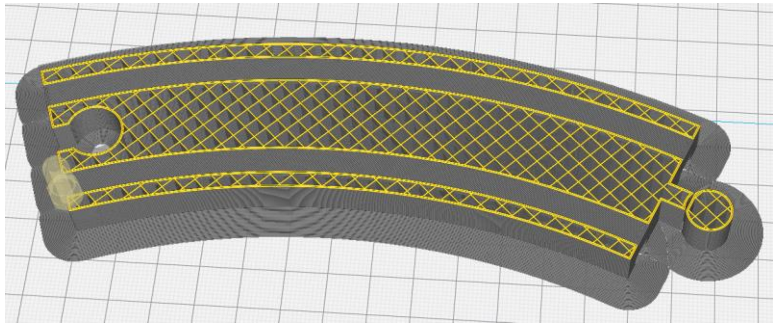
SETTING INFILL



Infill Density: 5%
Estimated print time: 2h 53min
Estimated filament: 2.92 m / ~23g



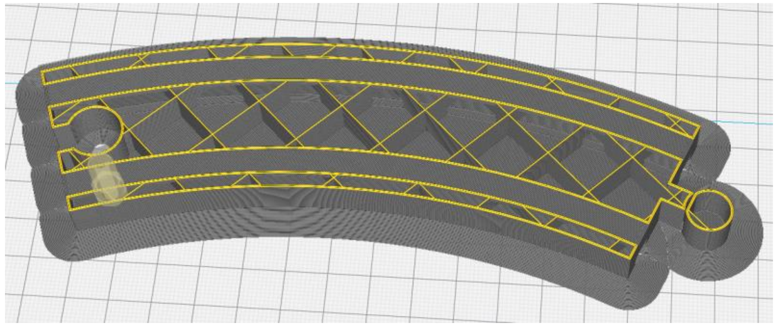
Infill Density: 10%
Estimated print time: 3h 06min
Estimated filament: 3.28 m / ~26g



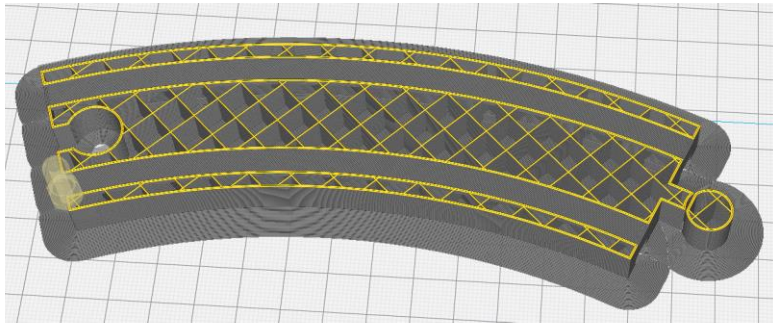
Infill Density: 25%
Estimated print time: 3h 35min
Estimated filament: 3.99 m / ~32g

STEP 3: SLICING & GENERATING G-CODE

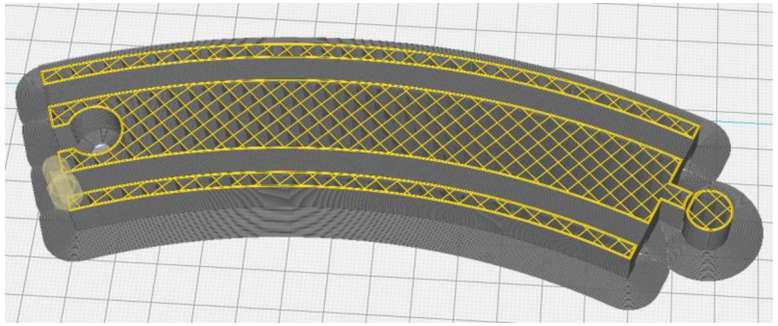
SETTING INFILL



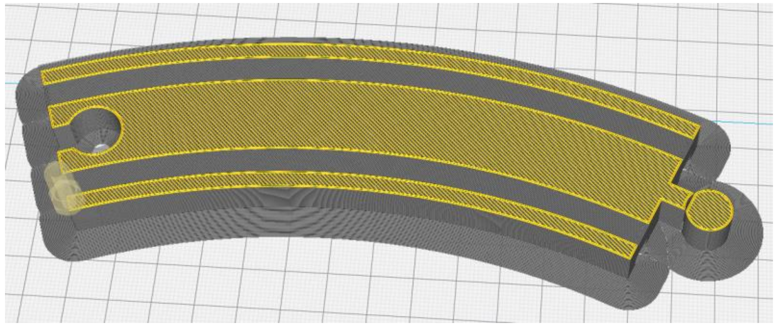
Infill Density: 5%
Estimated print time: 2h 53min
Estimated filament: 2.92 m / ~23g



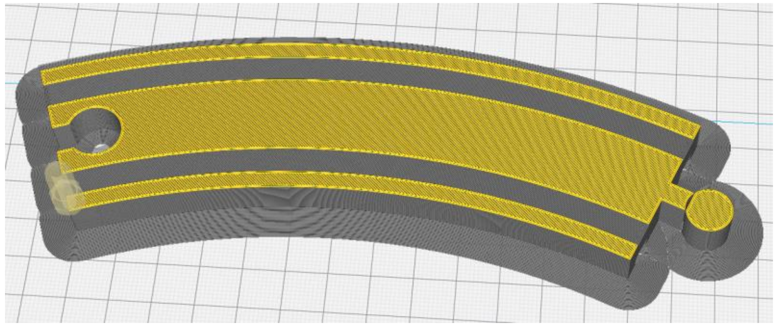
Infill Density: 10%
Estimated print time: 3h 06min
Estimated filament: 3.28 m / ~26g



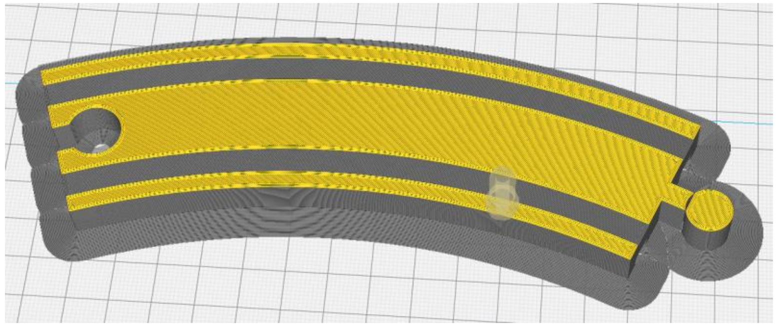
Infill Density: 25%
Estimated print time: 3h 35min
Estimated filament: 3.99 m / ~32g



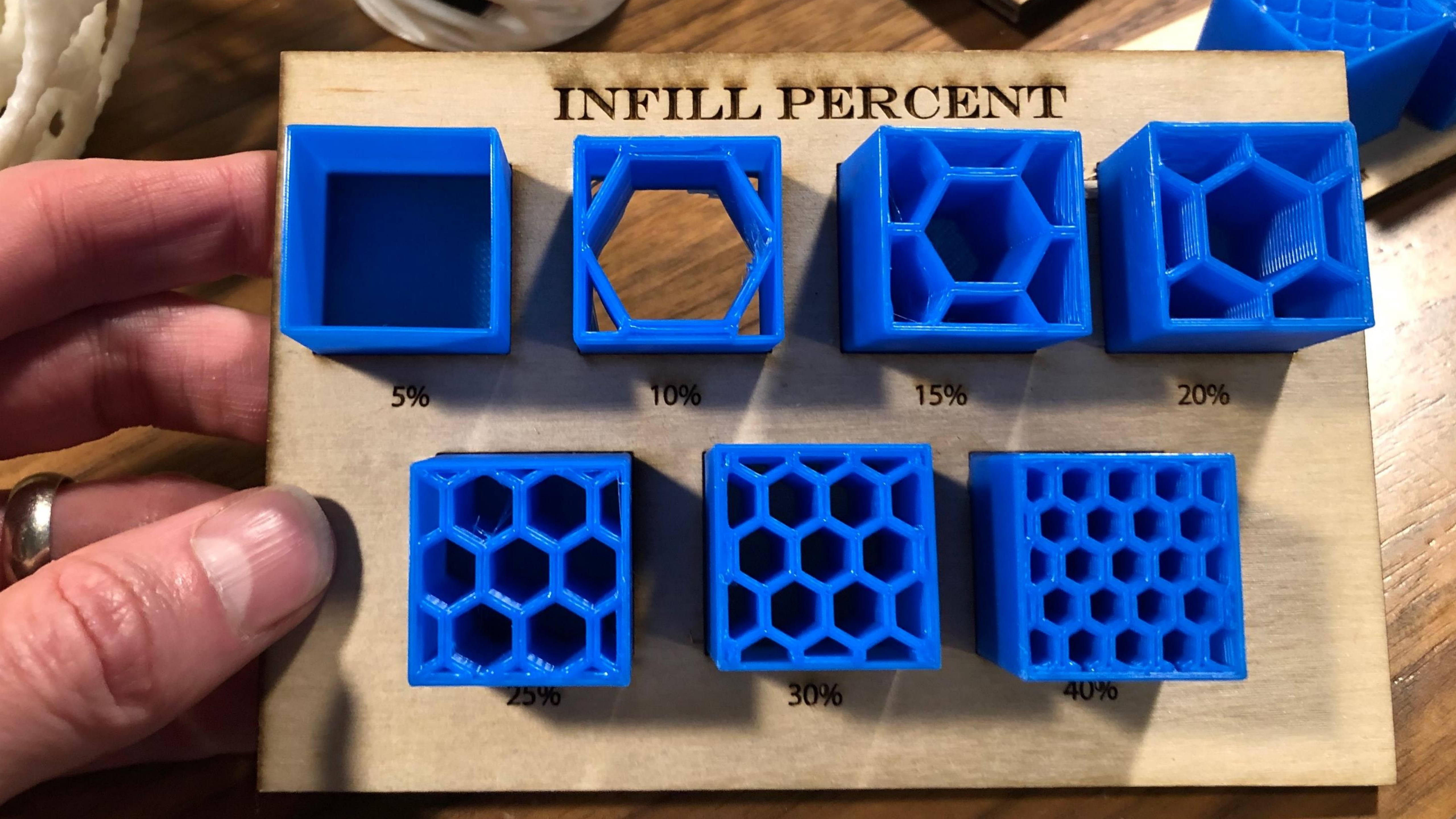
Infill Density: 50%
Estimated print time: 4h 58min
Estimated filament: 6.13 m / ~48g

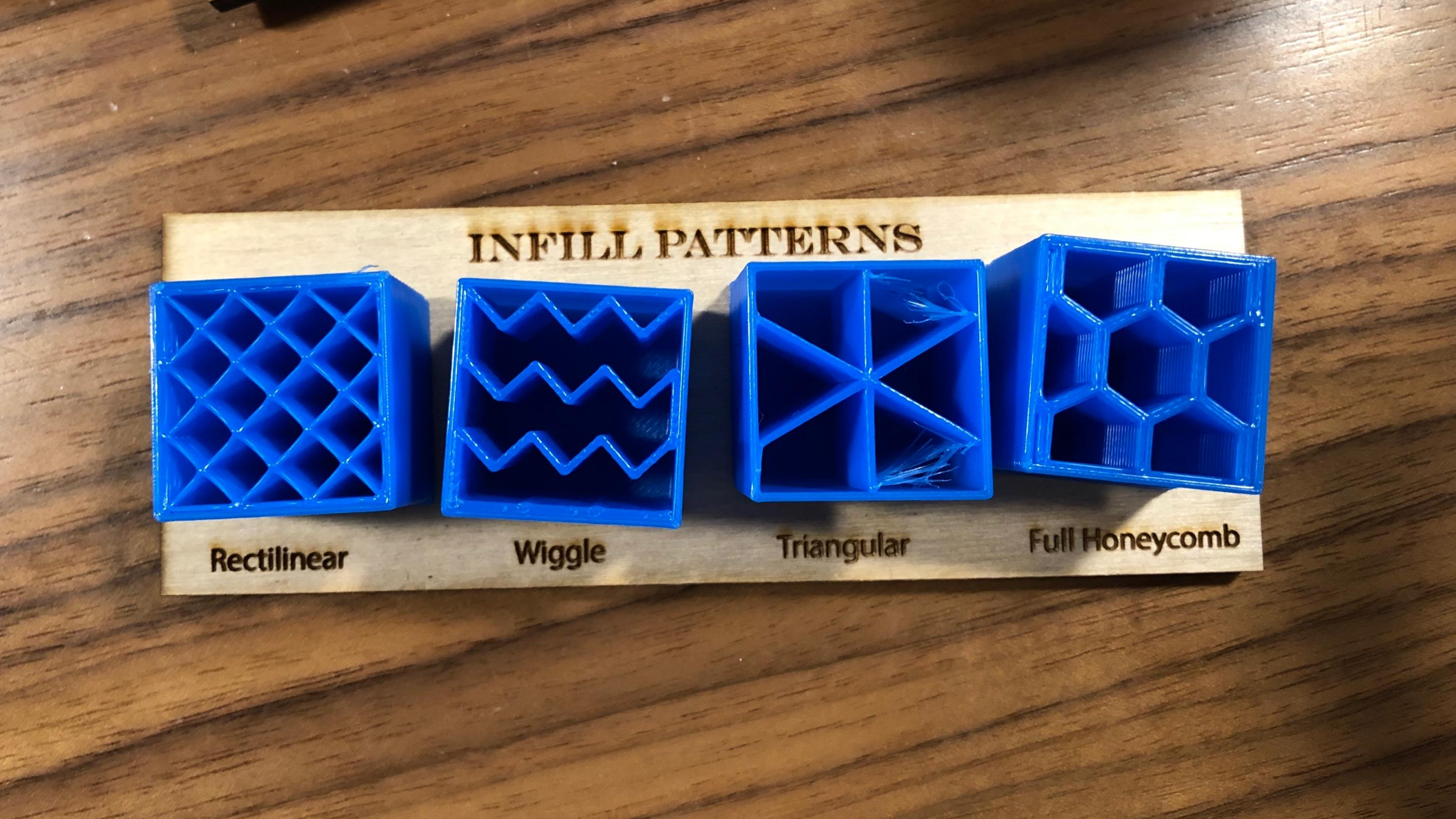


Infill Density: 70%
Estimated print time: 4h 58min
Estimated filament: 6.13 m / ~48g



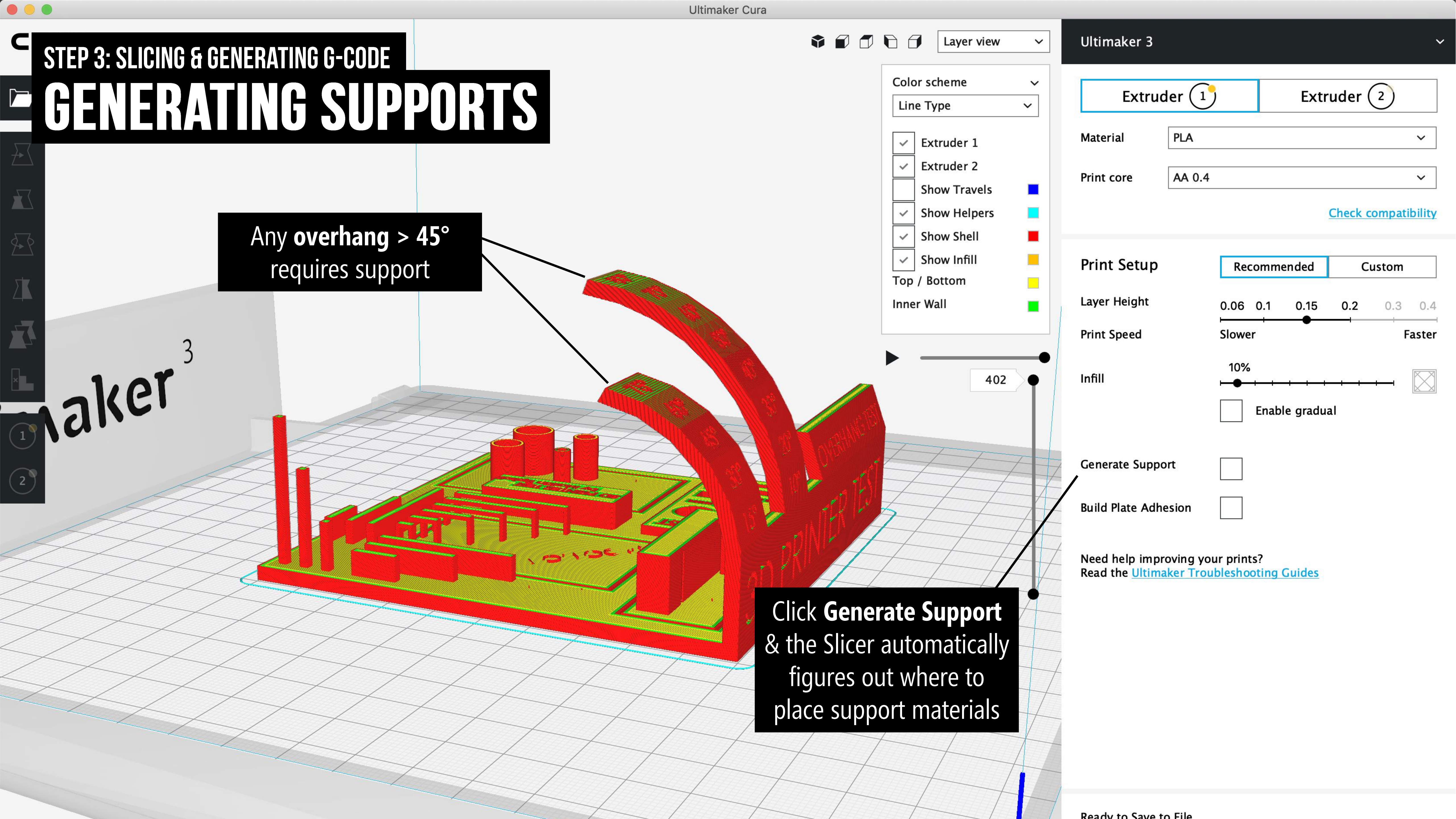
Infill Density: 100%
Estimated print time: 10h 53min
Estimated filament: 9.65 m / ~76g


INFILL PERCENT
5%
10%
15%
20%
25%
30%
40%


INFILL PATTERNS
Rectilinear
Wiggle
Triangular
Full Honeycomb

STEP 3: SLICING & GENERATING G-CODE

GENERATING SUPPORTS



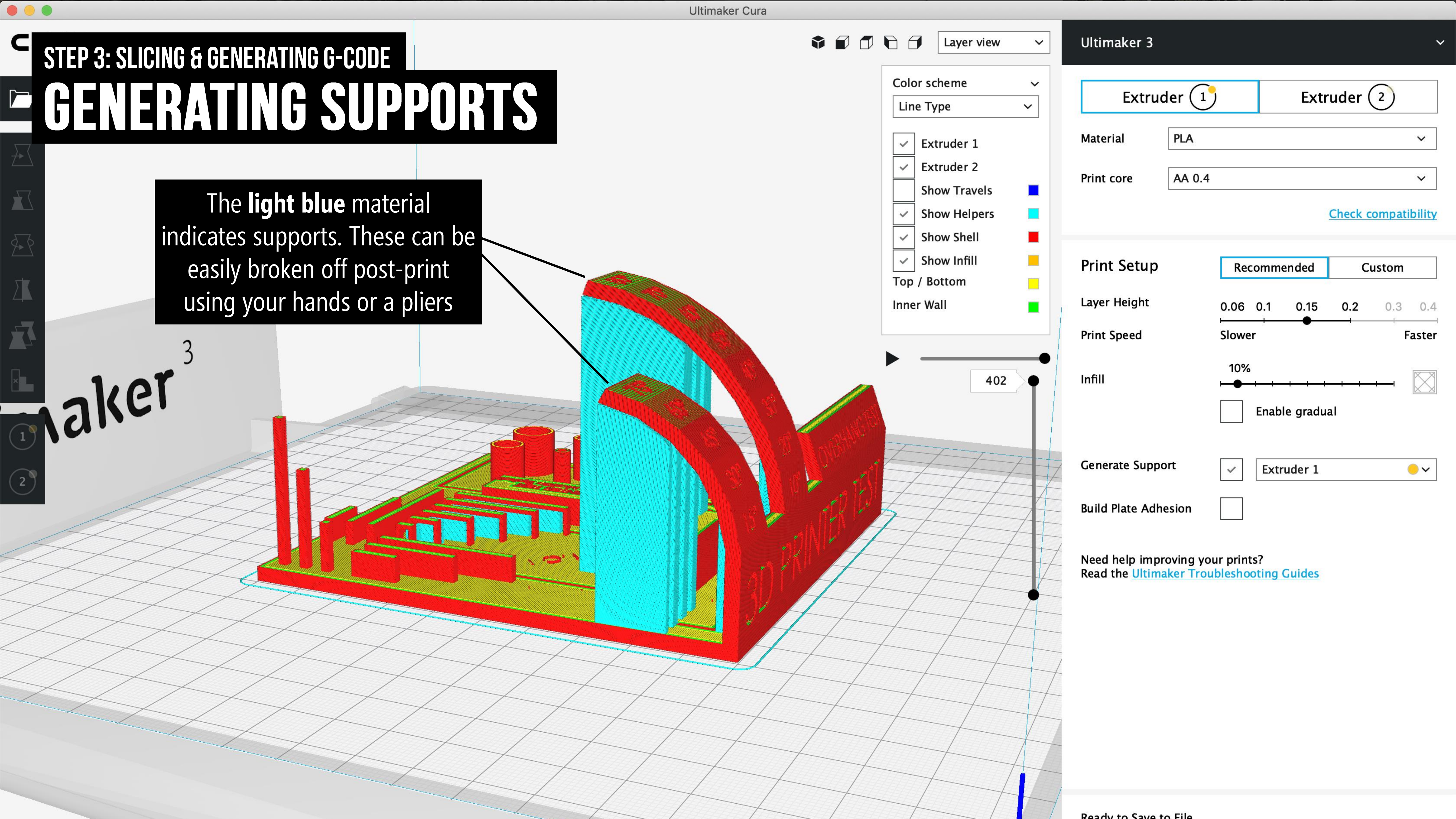
Any **overhang > 45°** requires support

Click **Generate Support** & the Slicer automatically figures out where to place support materials

STEP 3: SLICING & GENERATING G-CODE

GENERATING SUPPORTS

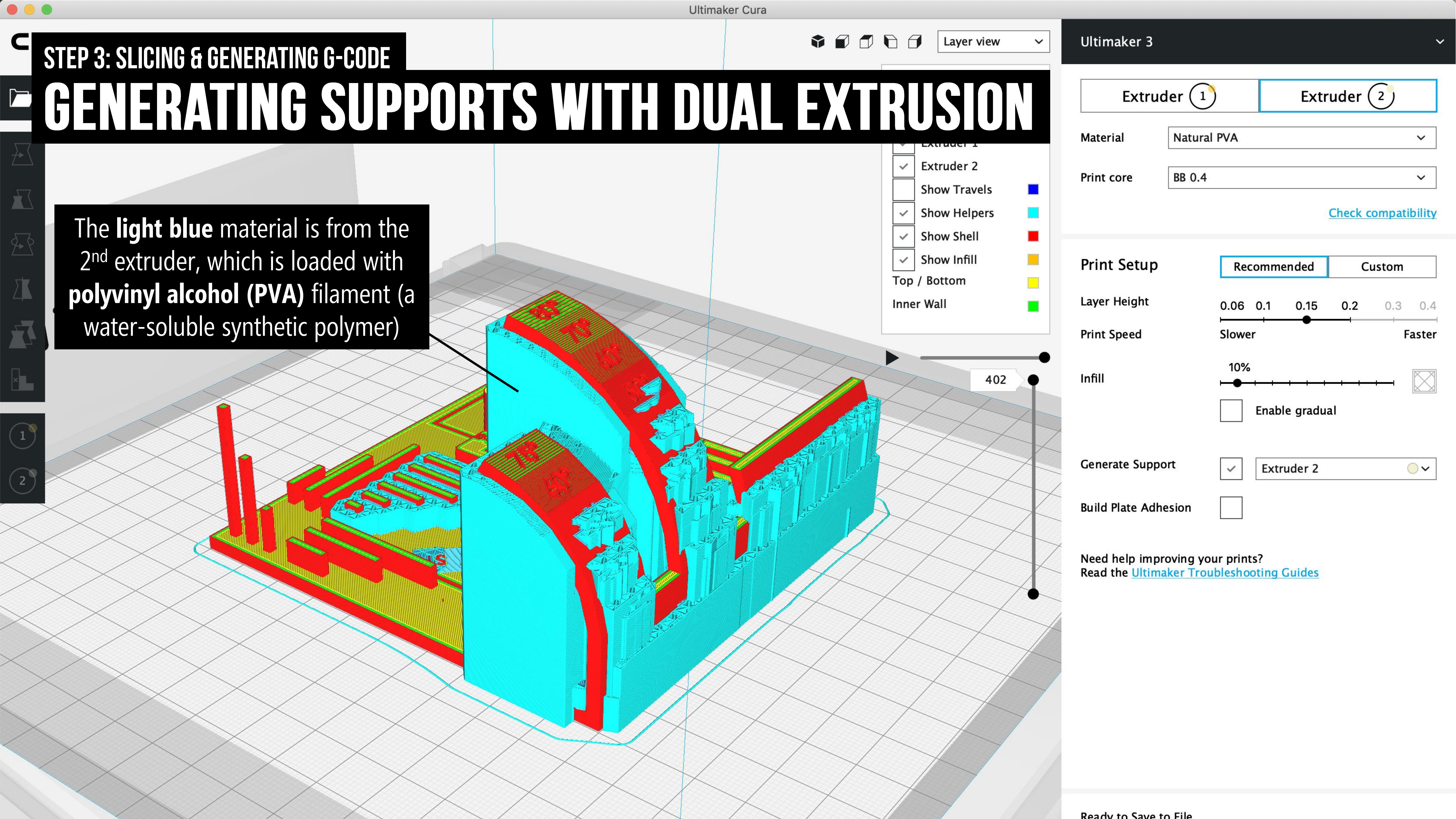
The **light blue** material indicates supports. These can be easily broken off post-print using your hands or a pliers



STEP 3: SLICING & GENERATING G-CODE

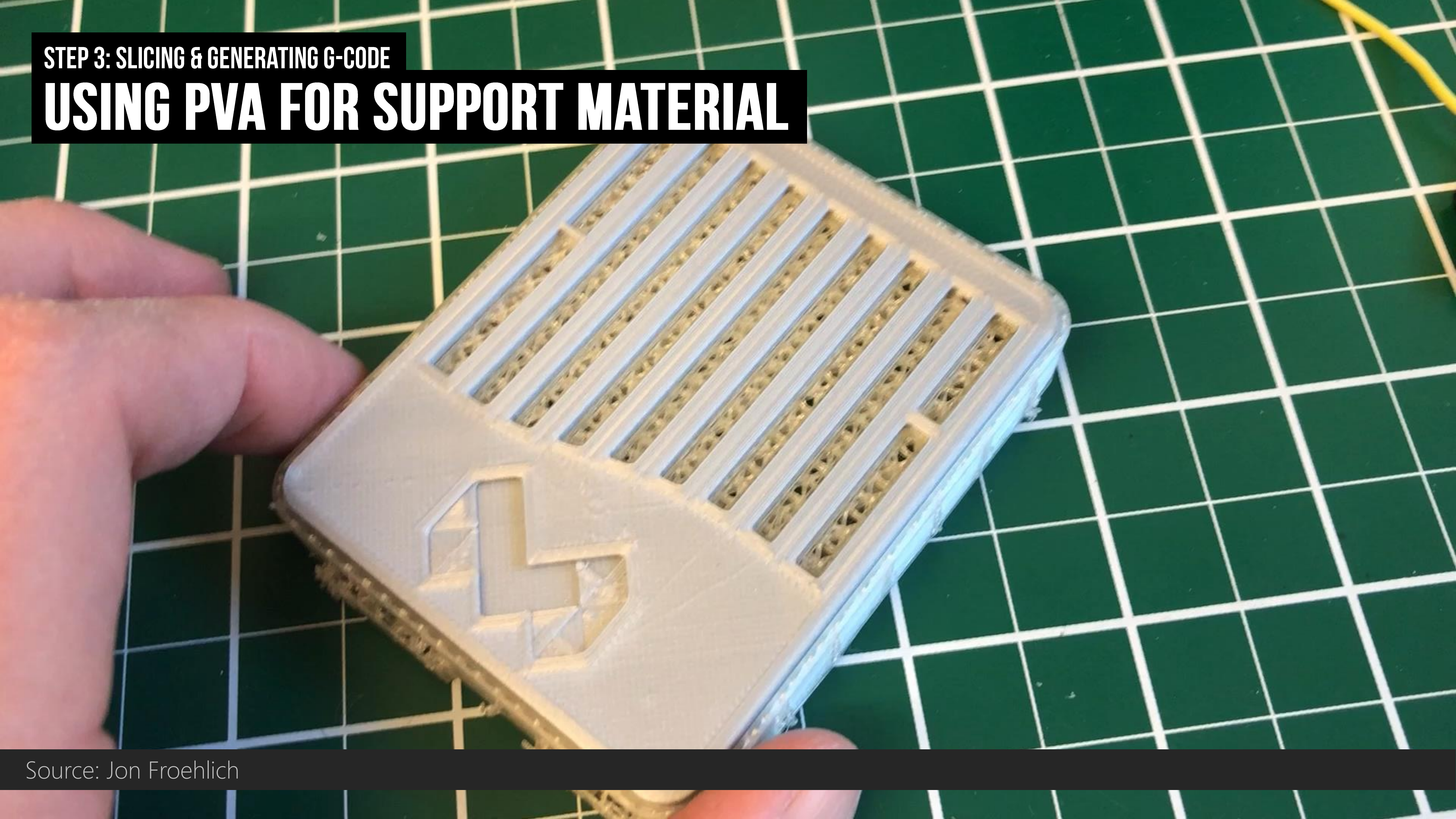
GENERATING SUPPORTS WITH DUAL EXTRUSION

The **light blue** material is from the 2nd extruder, which is loaded with **polyvinyl alcohol (PVA)** filament (a water-soluble synthetic polymer)



STEP 3: SLICING & GENERATING G-CODE

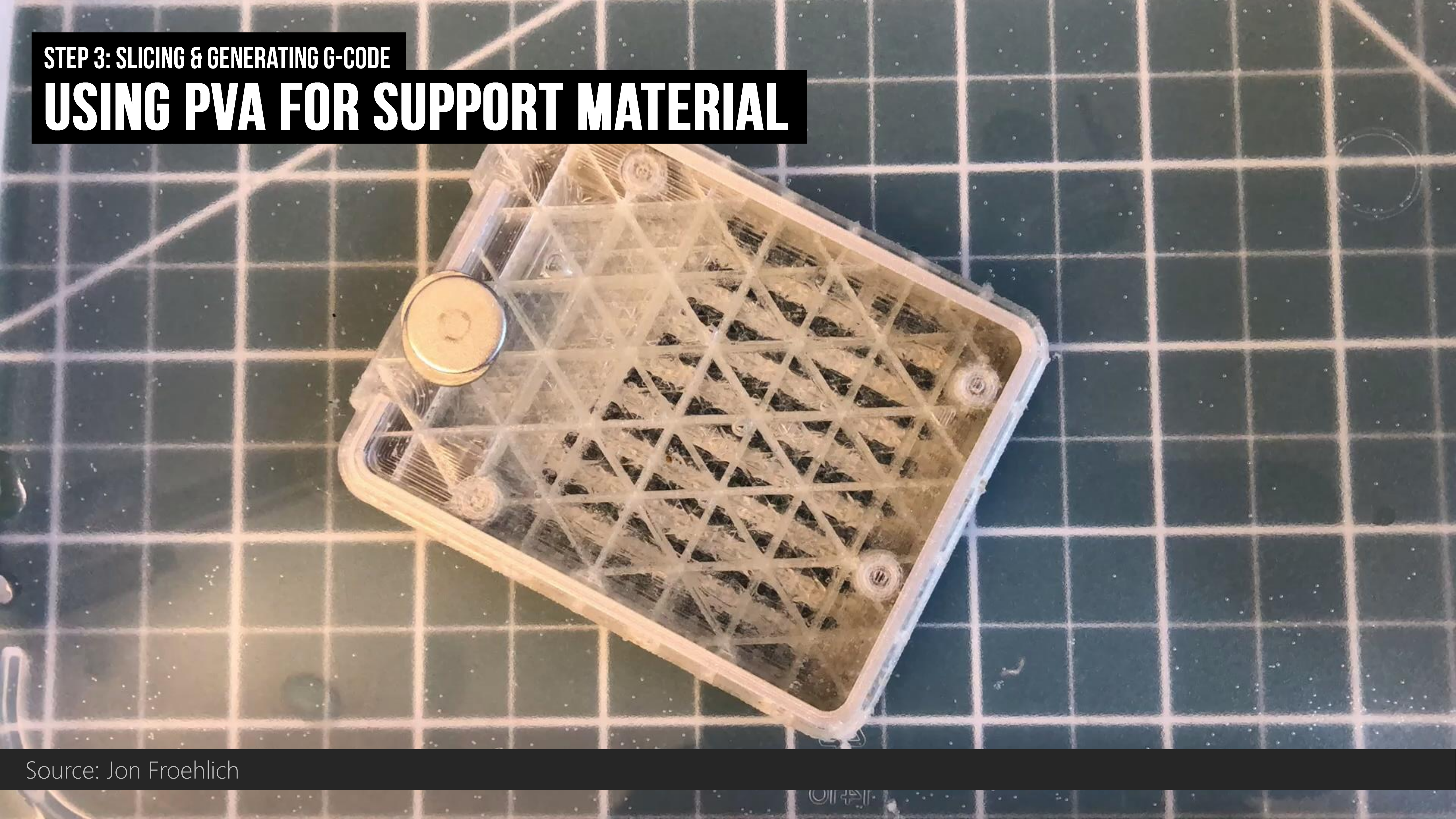
USING PVA FOR SUPPORT MATERIAL



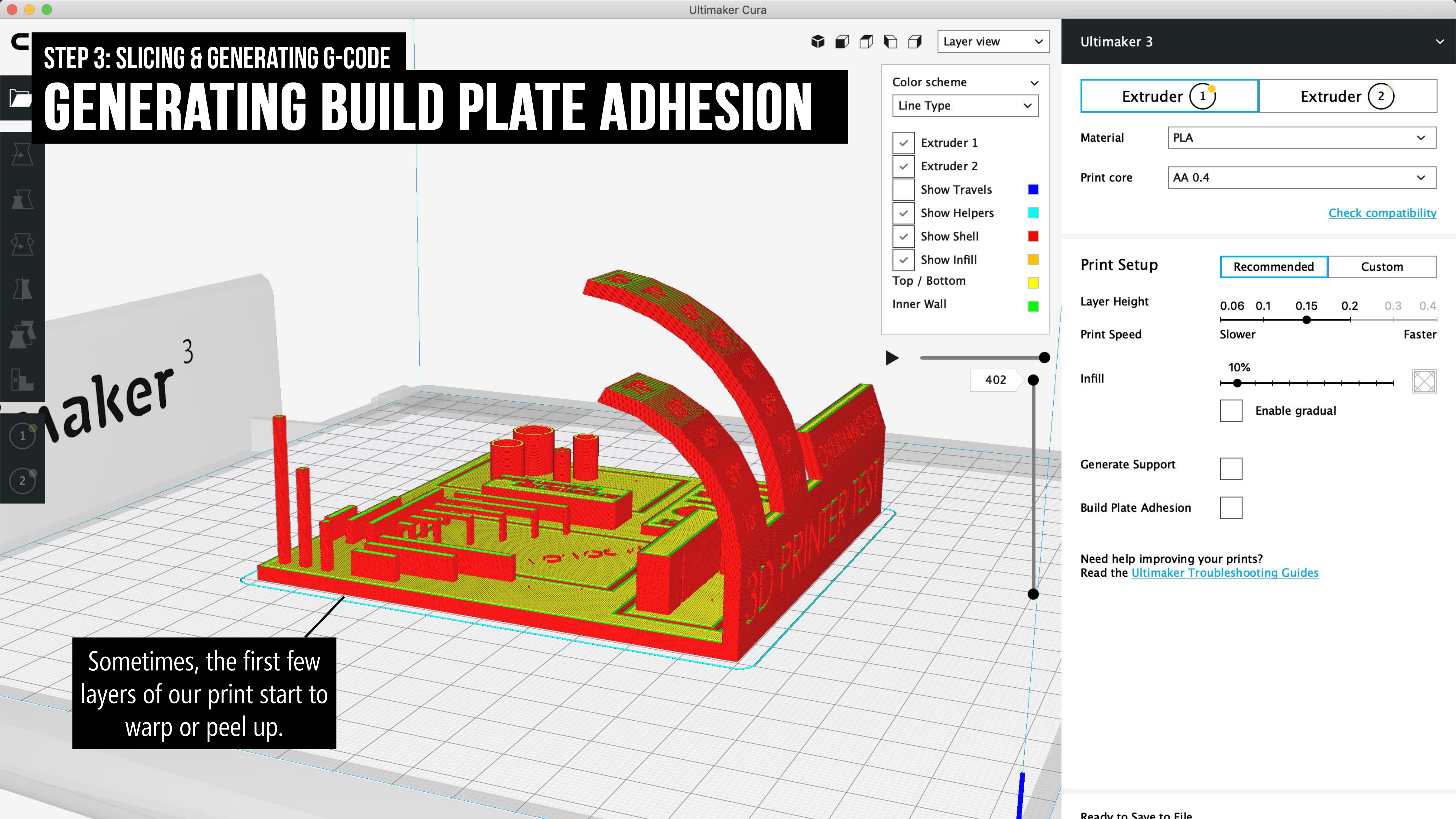
Source: Jon Froehlich

STEP 3: SLICING & GENERATING G-CODE

USING PVA FOR SUPPORT MATERIAL

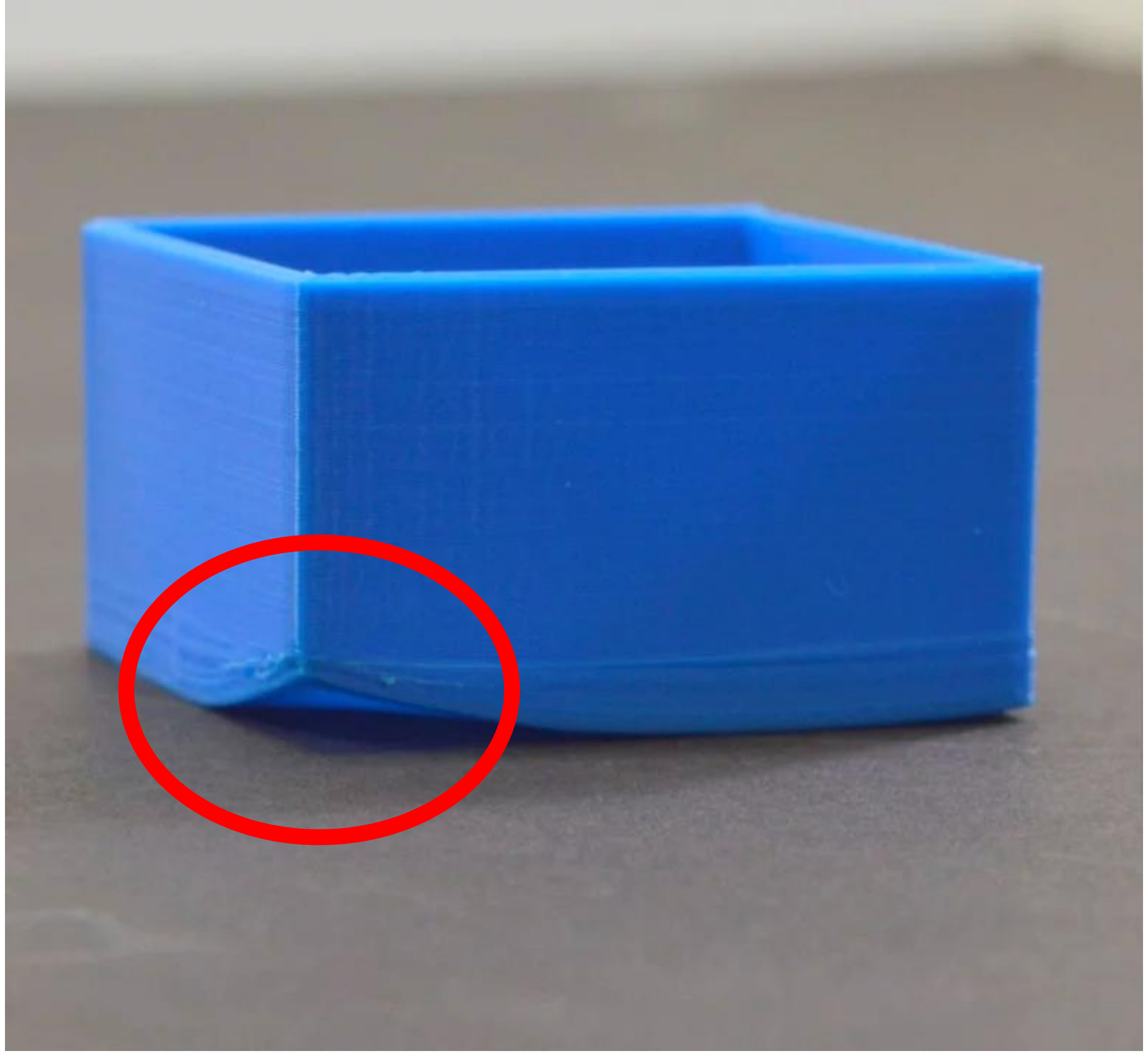


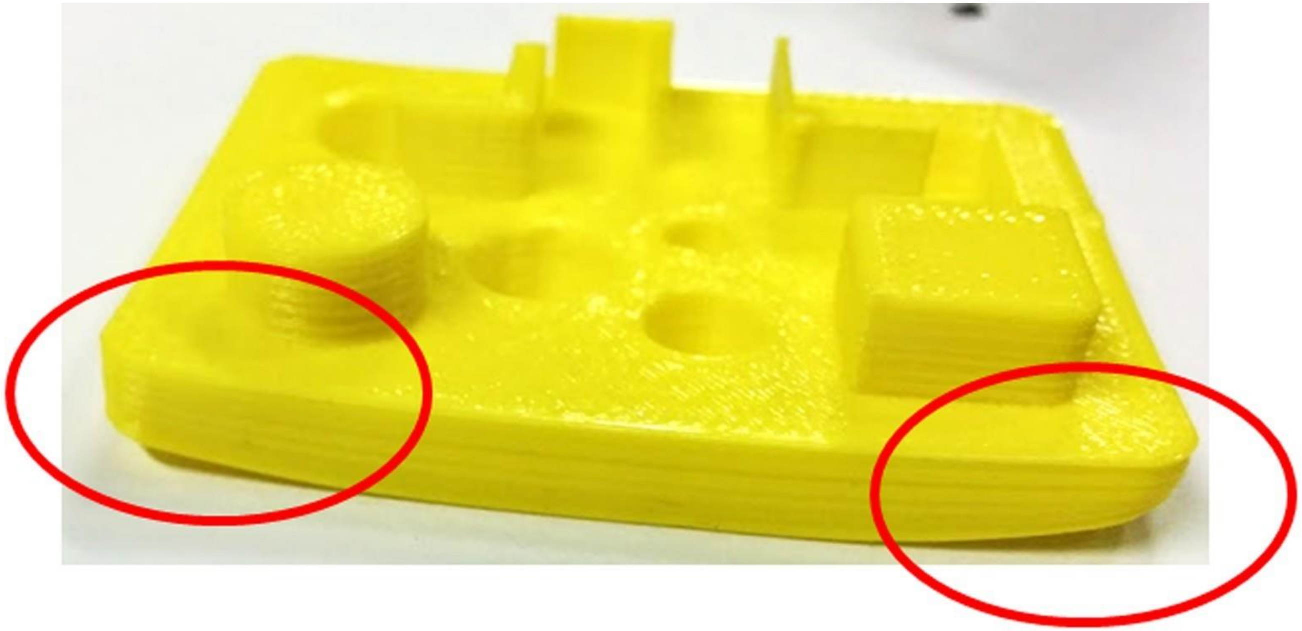
Source: Jon Froehlich

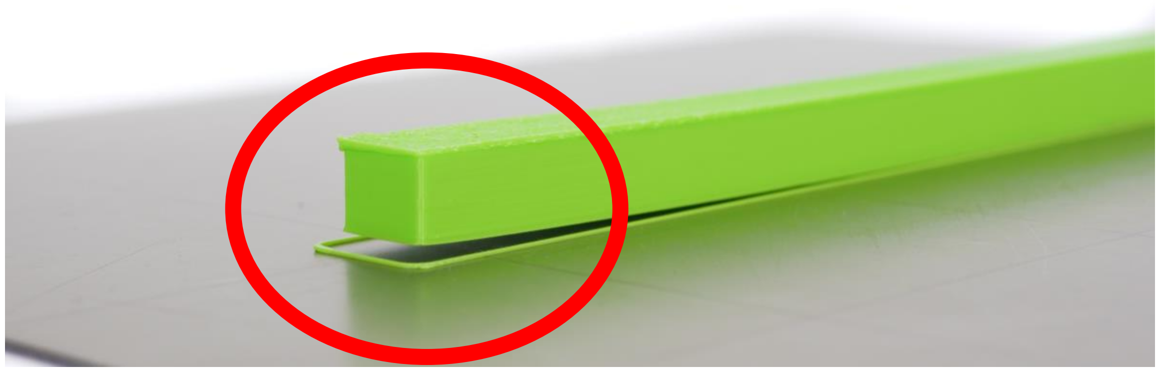

STEP 3: SLICING & GENERATING G-CODE
GENERATING BUILD PLATE ADHESION
Sometimes, the first few layers of our print start to warp or peel up.
Ultimaker Cura
Layer view
Color scheme
Line Type
Extruder 1
Extruder 2
Show Travels
Show Helpers
Show Shell
Show Infill
Top / Bottom
Inner Wall
402
Ultimaker 3
Extruder 1
Extruder 2
Material
PLA
Print core
AA 0.4
Check compatibility
Print Setup
Recommended
Custom
Layer Height
0.06 0.1 0.15 0.2 0.3 0.4
Print Speed
Slower
Faster
Infill
10%
Enable gradual
Generate Support
Build Plate Adhesion
Need help improving your prints?
Read the Ultimaker Troubleshooting Guides
Ready to Save to File

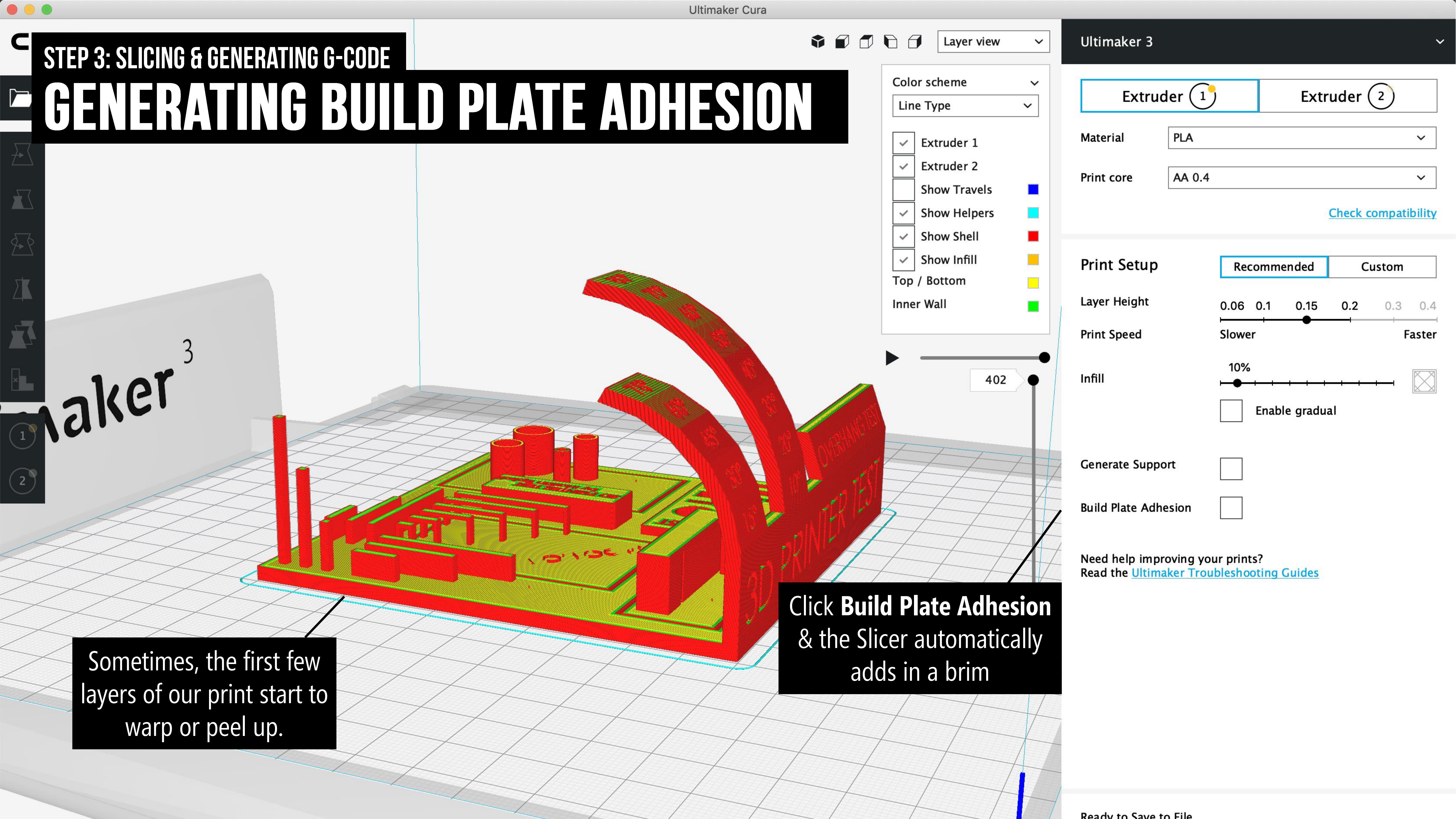
STEP 3: SLICING AND GENERATING G-CODE

WARPING DUE TO POOR BUILD PLATE ADHESION





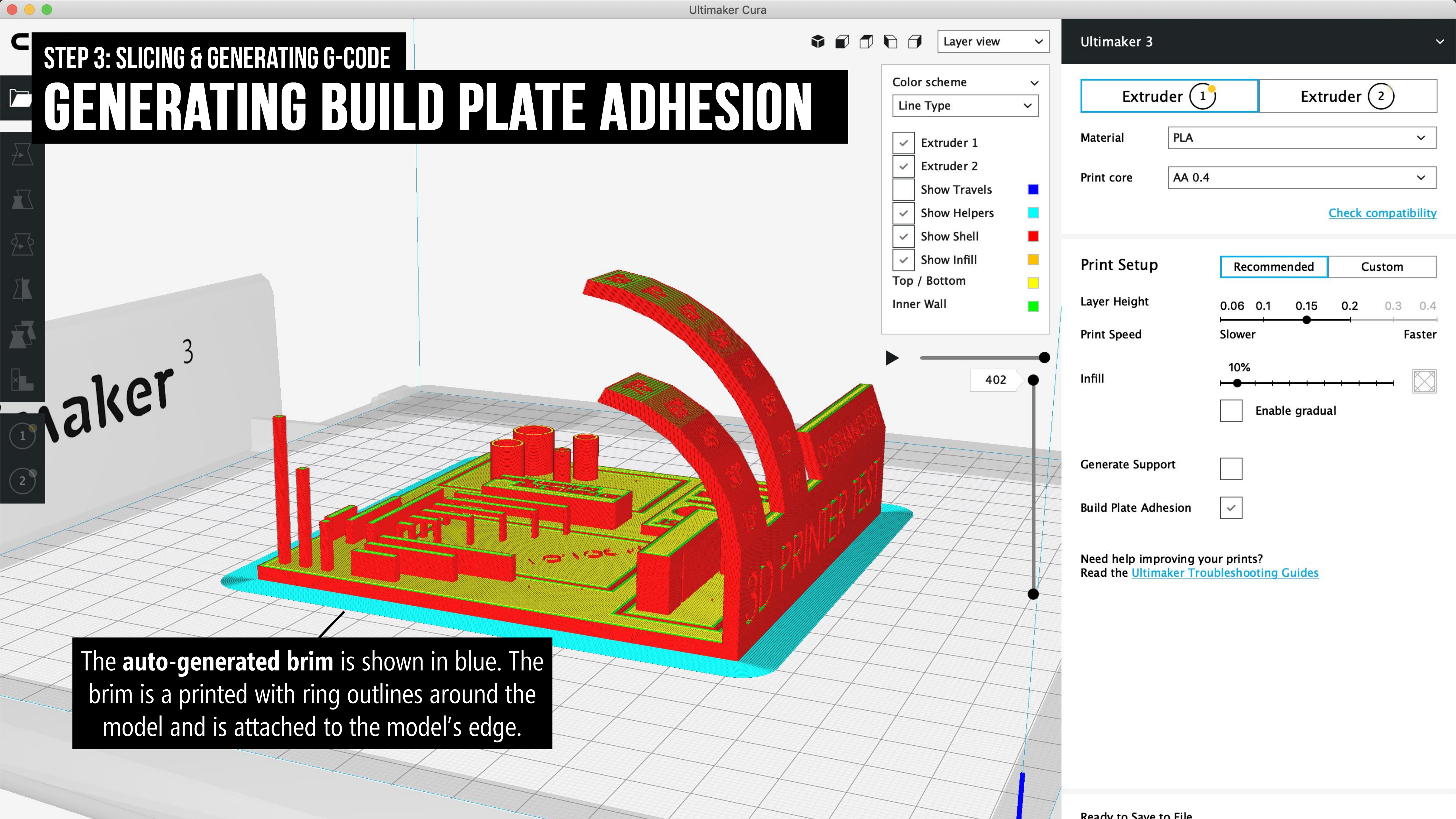




Ultimaker Cura
STEP 3: SLICING & GENERATING G-CODE
GENERATING BUILD PLATE ADHESION
Layer view
Color scheme
Line Type
Extruder 1
Extruder 2
Show Travels
Show Helpers
Show Shell
Show Infill
Top / Bottom
Inner Wall
402
Ultimaker 3
Extruder 1
Extruder 2
Material
PLA
Print core
AA 0.4
Check compatibility
Print Setup
Recommended
Custom
Layer Height
0.06 0.1 0.15 0.2 0.3 0.4
Print Speed
Slower
Faster
Infill
10%
Enable gradual
Generate Support
Build Plate Adhesion
Need help improving your prints?
Read the Ultimaker Troubleshooting Guides
Ready to Save to File
Sometimes, the first few layers of our print start to warp or peel up.
Click Build Plate Adhesion & the Slicer automatically adds in a brim

STEP 3: SLICING & GENERATING G-CODE

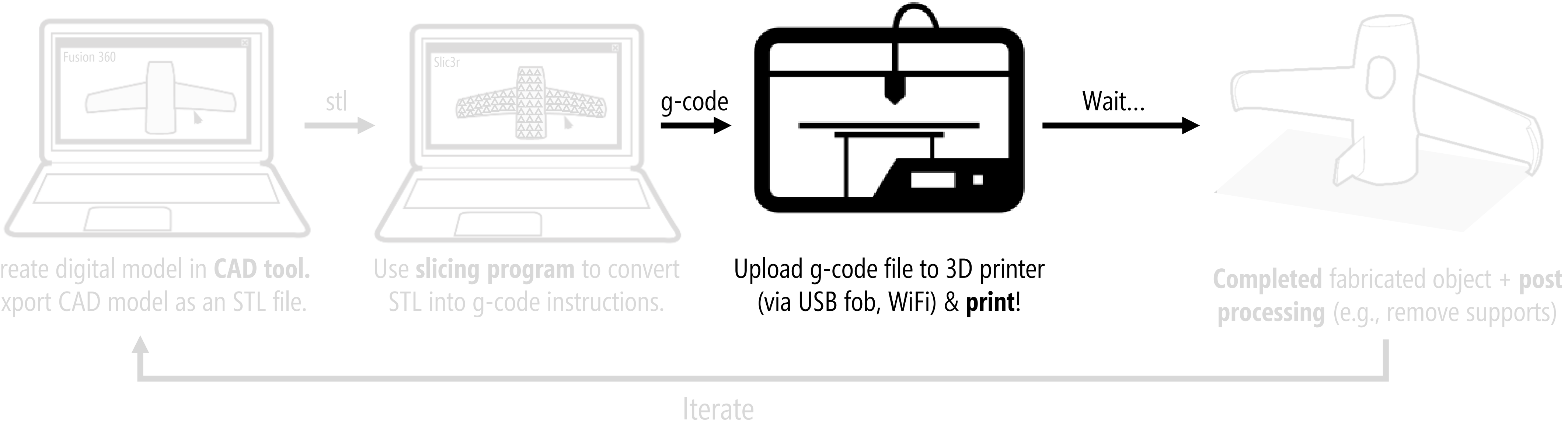
GENERATING BUILD PLATE ADHESION



The **auto-generated brim** is shown in blue. The brim is a printed with ring outlines around the model and is attached to the model's edge.

3D-PRINTING PROCESS

4. LOAD G-CODE INTO PRINTER AND PRINT!

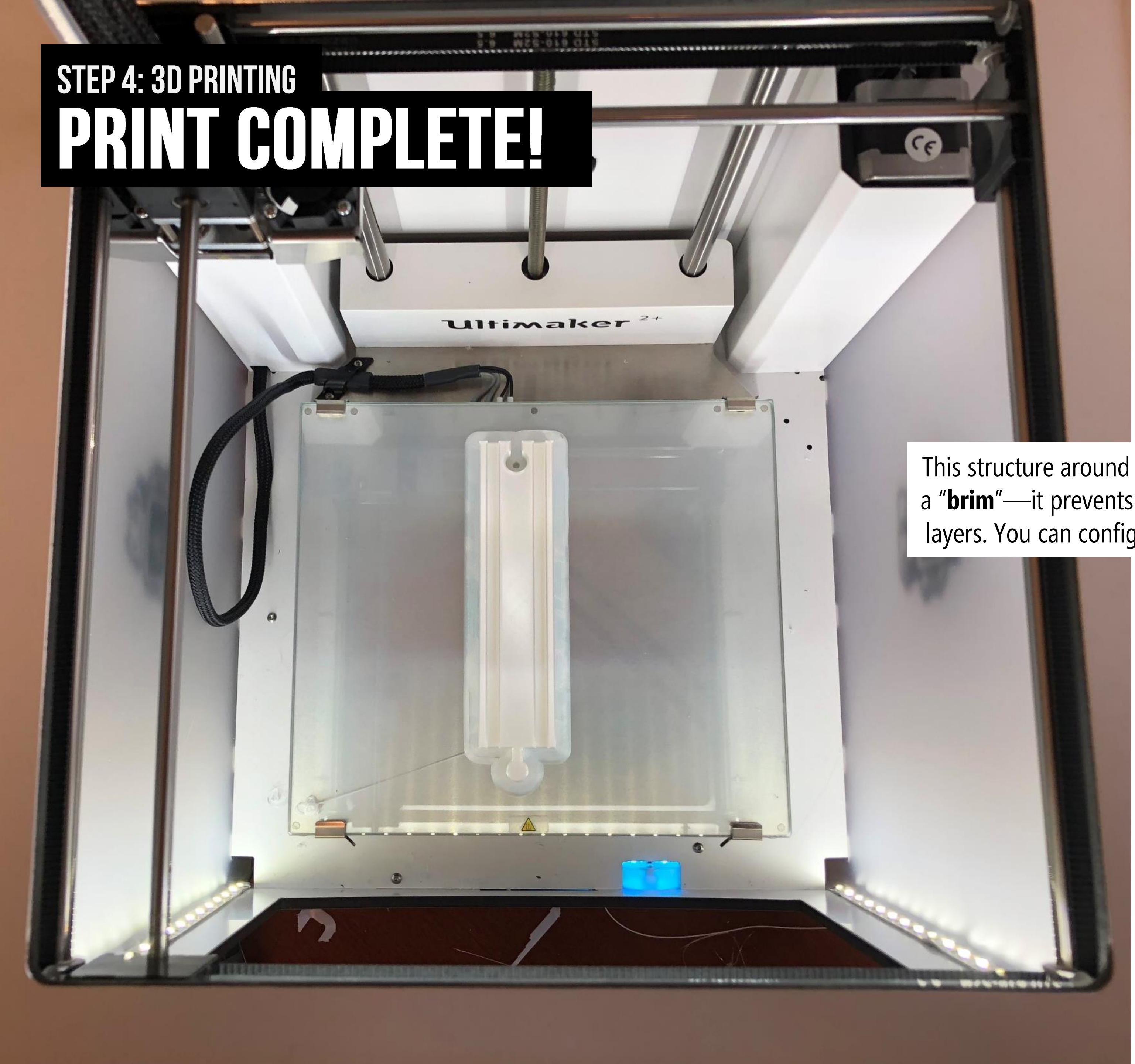


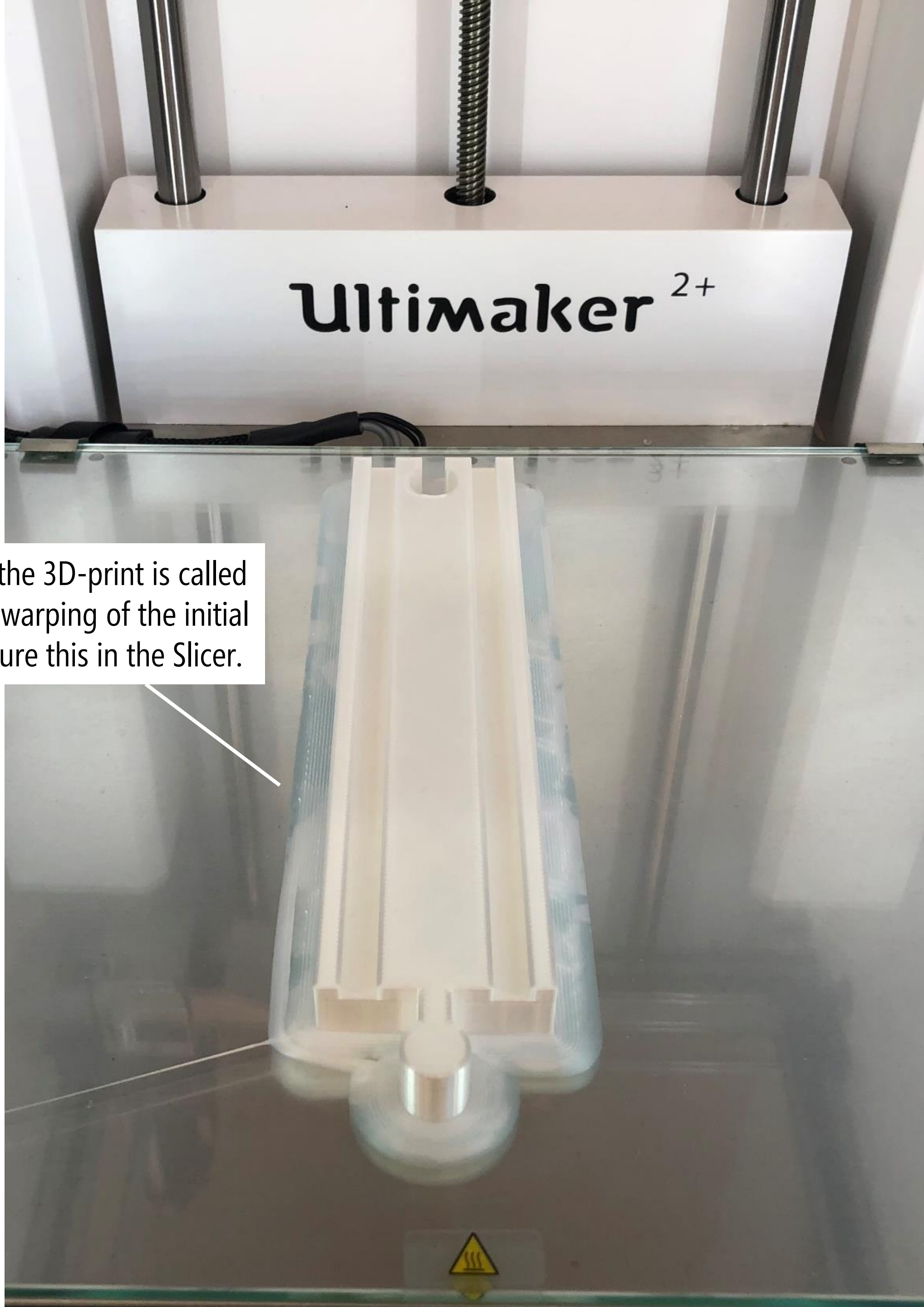
Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process


STEP 4: 3D PRINTING
PRINTING ON AN ULTIMAKER 2+
Source: Jon Froehlich

STEP 4: 3D PRINTING

PRINT COMPLETE!

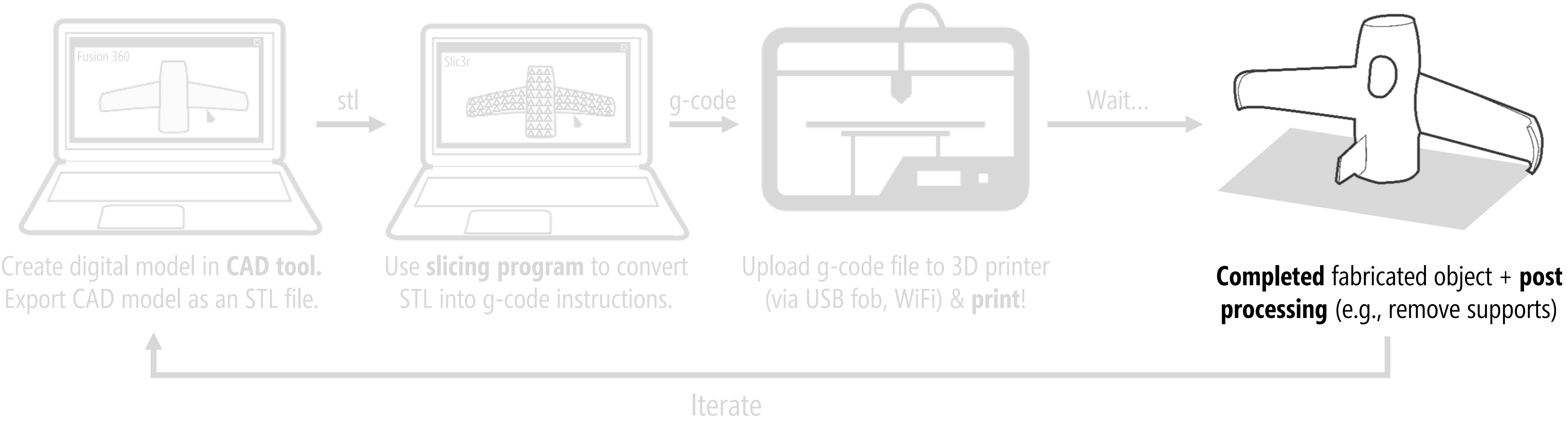




This structure around the 3D-print is called a “**brim**”—it prevents warping of the initial layers. You can configure this in the Slicer.

3D-PRINTING PROCESS

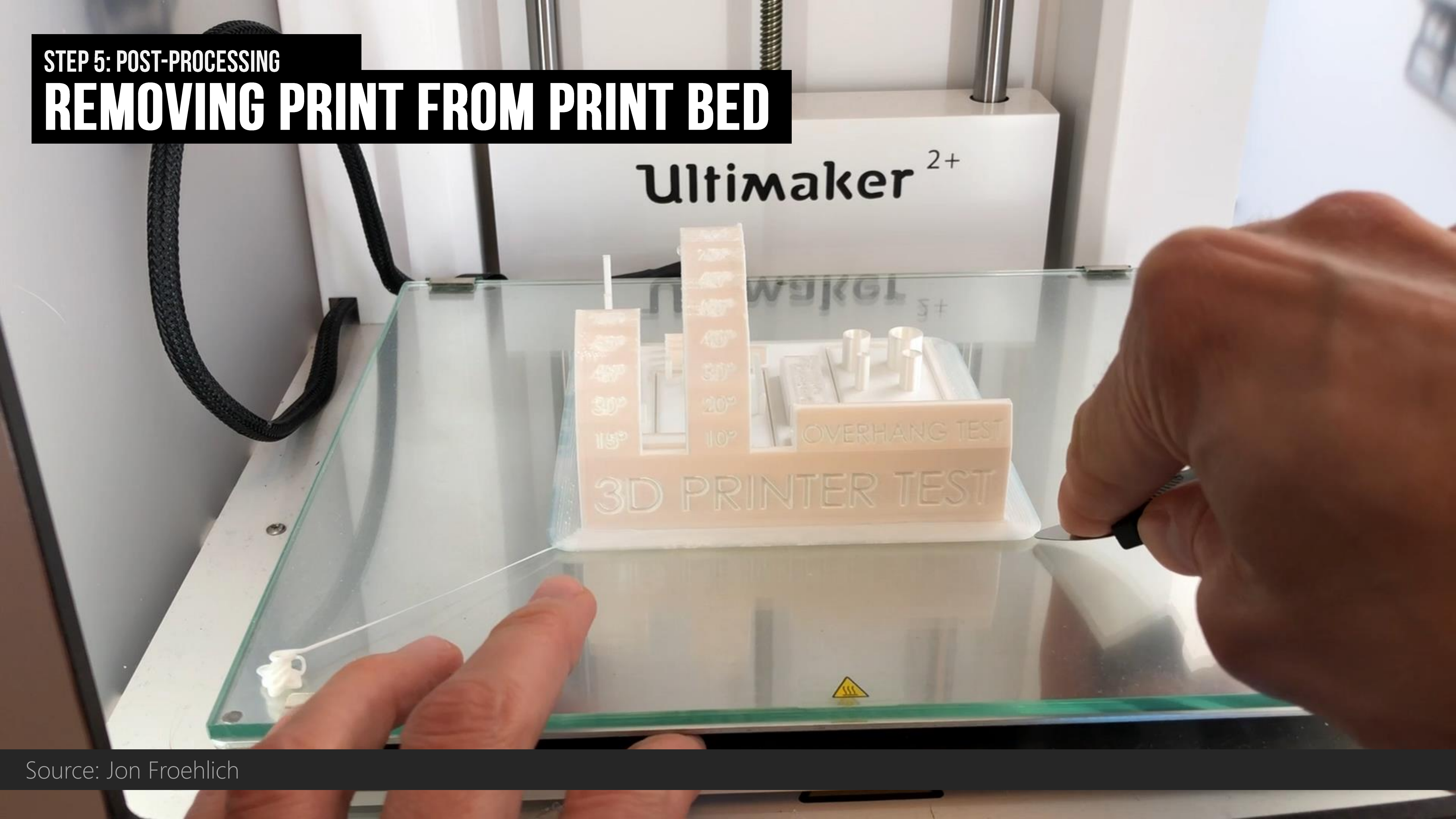
5. TAKE PRINTED OBJECT OFF PLATE + POST-PROCESSING



Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

STEP 5: POST-PROCESSING

REMOVING PRINT FROM PRINT BED



Source: Jon Froehlich

Ultimaker 2+
OVERHANG TEST
3D PRINTER TEST

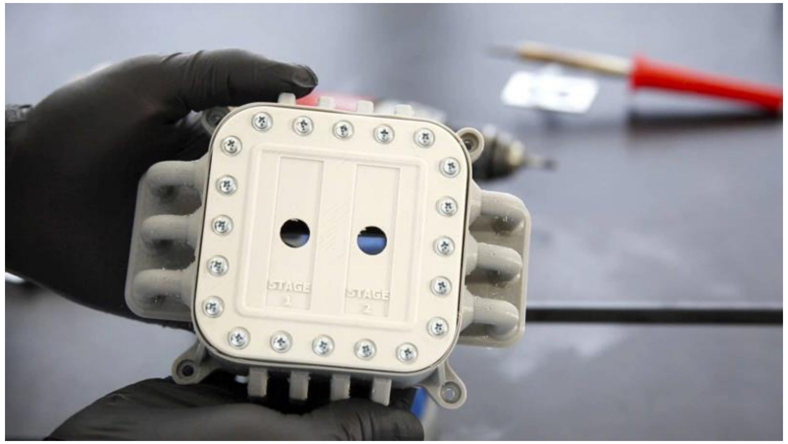
STEP 7: POST-PROCESSING

POST-PROCESSING TECHNIQUES

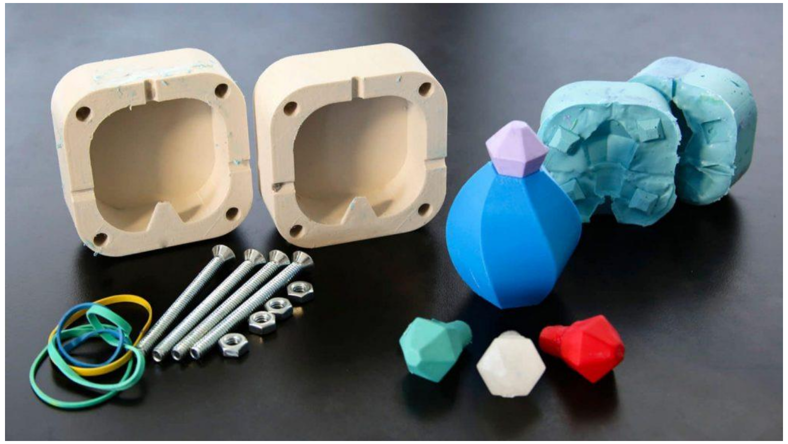
Sanding

Gluing

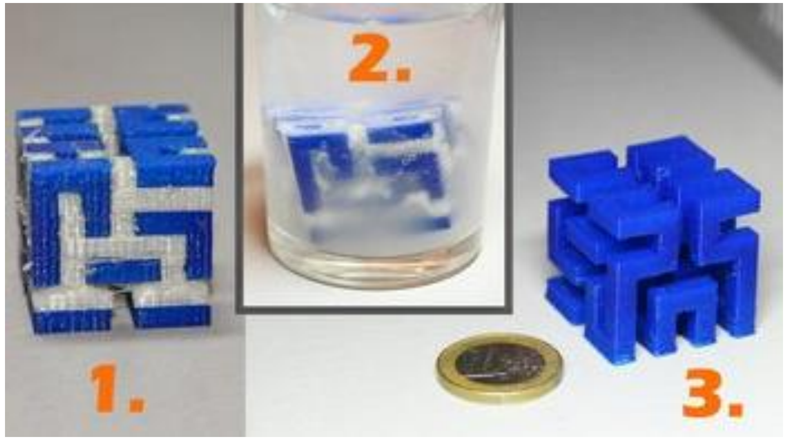
Painting



Inserts



Silicone Molding



Support Removal

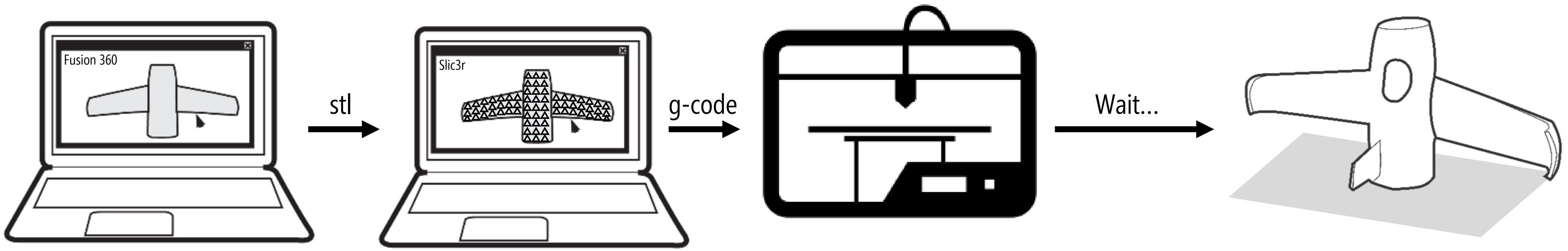
Sources: https://www.makerbot.com/professional/post-processing/ and https://all3dp.com/2/fdm-3d-printing-post-processing-an-overview-for-beginners/

STEP 6: TEST YOUR DESIGNS! ☺

TEST AND ITERATE ON YOUR DESIGNS

3D-PRINTING PROCESS

6-STEP ITERATIVE PROCESS FROM MODELING TO PRINTING



Create digital model in **CAD tool.** Export CAD model as an STL file.

Use **slicing program** to convert STL into g-code instructions.

Upload g-code file to 3D printer (via USB fob, WiFi) & **print**!

Completed fabricated object + **post processing** (e.g., remove supports)

Test + Iterate

Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

3D-PRINTING PROCESS

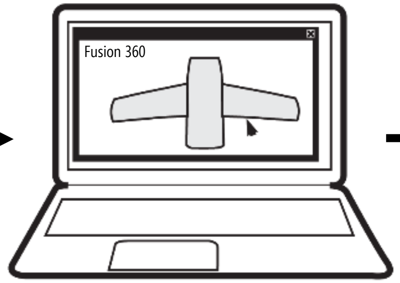
6-STEP ITERATIVE PROCESS FROM MODELING TO PRINTING

0. IDEATION & EXPERTISE

Determining **what to make**, for who, and why.

idea →

1. DESIGNING MODELS

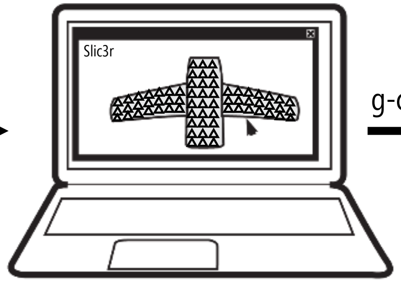


Create digital model in **CAD tool.** Export CAD model as an STL file.

2. EXPORTING STL

stl →

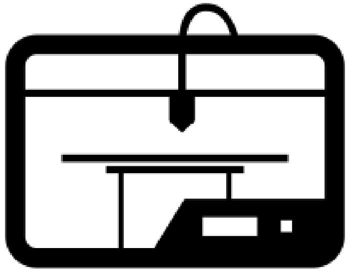
3. TRANSLATING TO PRINTER CODE



Use **slicing program** to convert STL into g-code instructions.

g-code →

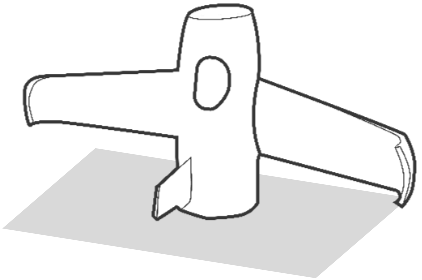
4. PRINTING HARDWARE & MATERIALS



Upload g-code file to 3D printer (via USB fob, WiFi) & **print**!

Wait... →

5. EXAMINING PRINT & POST-PROCESSING



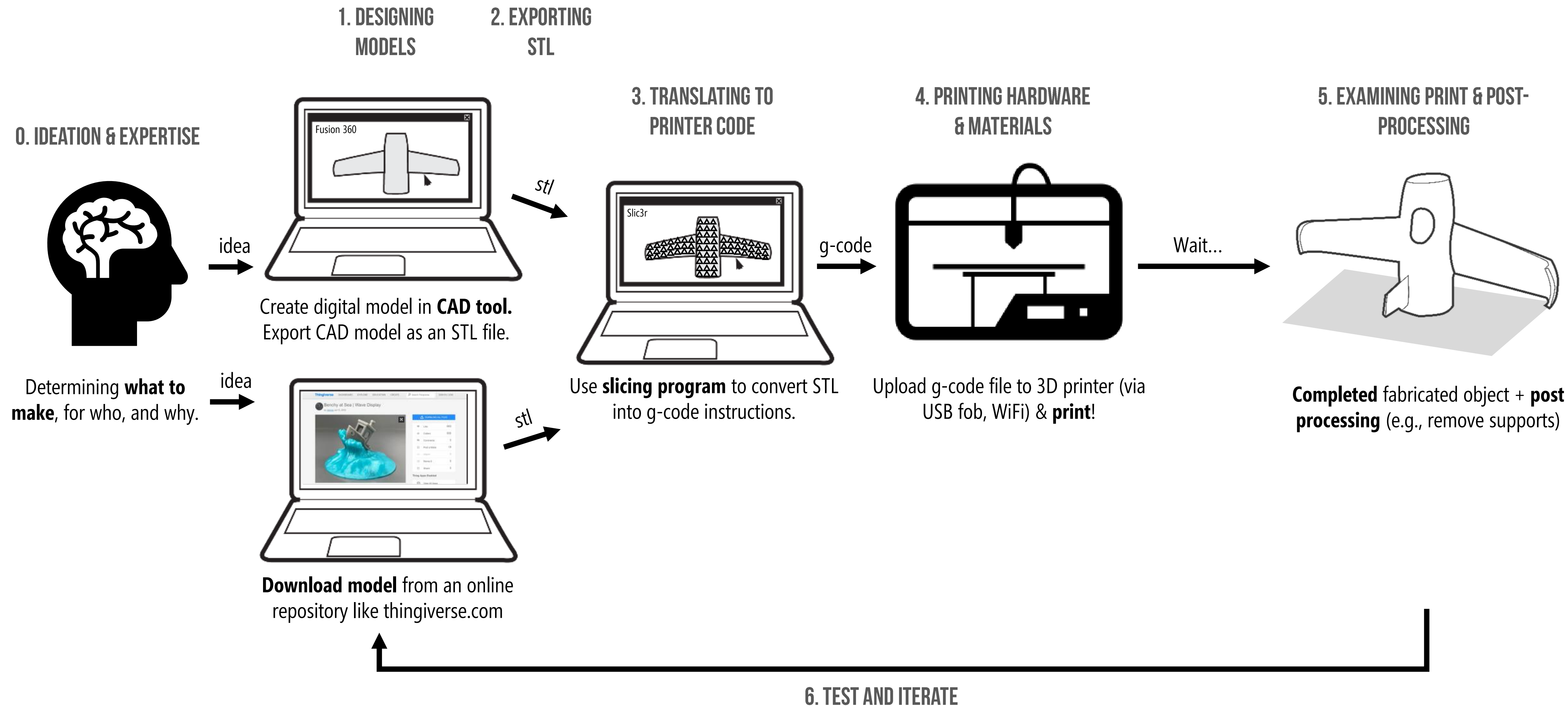
Completed fabricated object + **post processing** (e.g., remove supports)

6. TEST AND ITERATE

Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

3D-PRINTING PROCESS

6-STEP ITERATIVE PROCESS FROM MODELING TO PRINTING



Slide based on Huaishu Peng's job talk; See also: https://www.3dhubs.com/knowledge-base/additive-manufacturing-process

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MAX THE MEGAPOD

Max is a giant hexapod robot that can dance, scamper, and even has game attachments. Megapod jousting, anyone?

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Latest Thingiverse Activity

- Chermansen collected Kanan Jarrus' Lightsaber (Star Wars Rebels)
- TanTanDGMT started using Customizer
- aronlasvegas2016 collected Gargoyle Sculpture (Statue 3D Scan)
- Radioactiv collected PlayStation 3 controller mini wheel
- Cinefil001 liked MTB Bicycle helmet hanger hook to keep track of all your bicycle (MTB) helmets
- YoDommo collected Lego Ninjago life-size Shuriken

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star wars

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fillenium malcon
by aaskedall — Jul 10, 2015

19440 | 24292 | 200

Han Solo Blaster DL-44
by PortedtoReality — Nov 25, 2016

6174 | 7567 | 176

Han Solo Blaster
by Smirf123 — Apr 19, 2016

5393 | 6220 | 53

Mars Bars Scuttle
by aaskedall — Jun 9, 2015

2811 | 4176 | 41

AT-ST Scout Walker
by MaakMijnIdee — Jun 6, 2012

4136 | 5955 | 58

Fillenium Malcon Easy Print Remix
by wbrucem — Mar 5, 2018

7697 | 9032 | 53

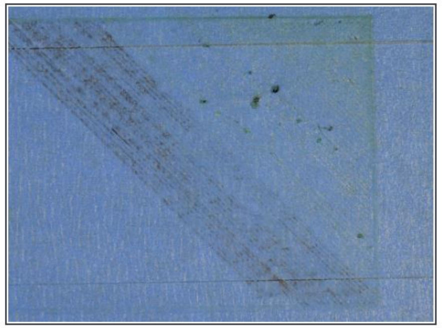
TROUBLESHOOTING

Print Quality Troubleshooting Guide

This guide is a great place to start if you are trying to improve the quality of your 3D printed parts. We have compiled an extensive list of the most common 3D printing issues along with the software settings that you can use to solve them. Best of all, the guide uses a large collection of real-world images to make each issue easy to identify when examining your own 3D printed parts. So let's get started!

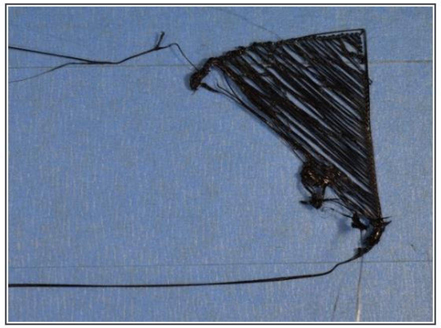
Thumbnail Overview

Use the thumbnails below to identify the picture that most closely represents the quality issue that you are seeing in your own 3D printed parts. You can click on the thumbnail to jump that that portion of the guide for immediate recommendations on how to resolve the issue. If you are not able to locate your issues from the thumbnails, feel free to scroll down and read through each section of the guide in more detail. There are plenty of useful tips to learn that can help improve your 3D printed results!



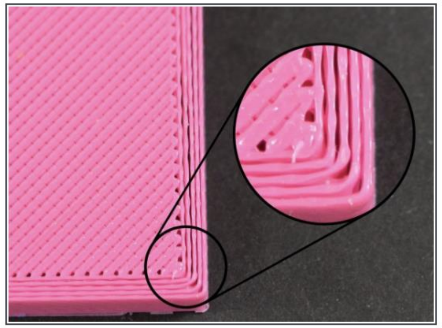
Not Extruding At Start

Printer does not extrude plastic at the beginning of the print



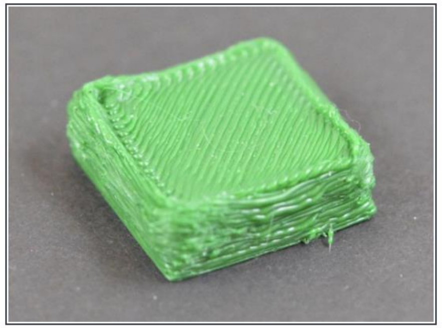
Not Sticking To Bed

The first layer does not stick to the bed and the print quickly fails



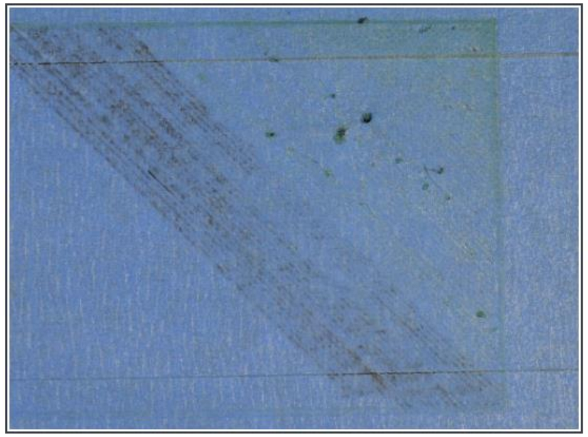
Under-Extrusion

Printer does not extrude enough plastic, gaps between perimeters and infill



Over-Extrusion

Printer extrudes too much plastic, prints looks very messy



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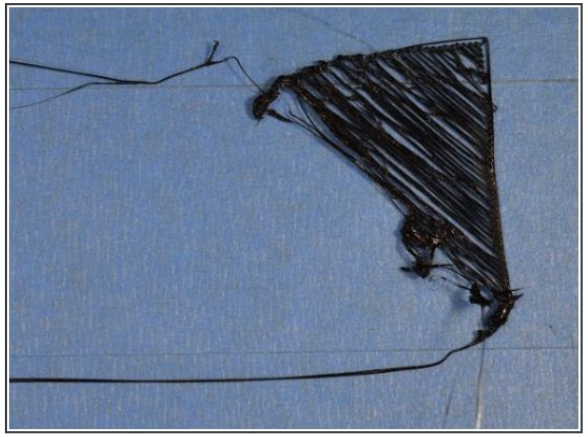

Not Sticking To Bed

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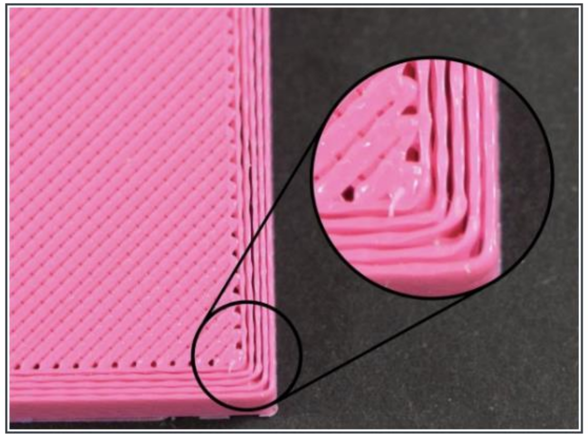
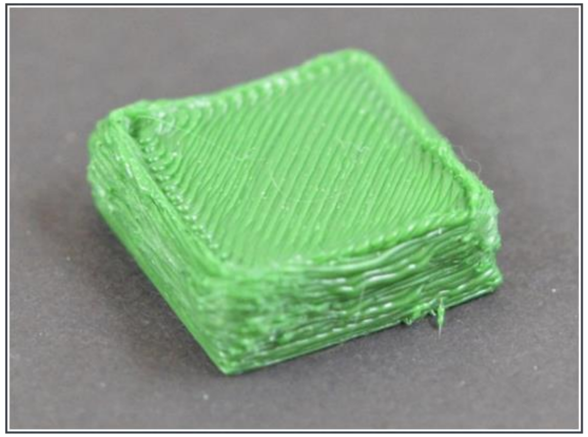


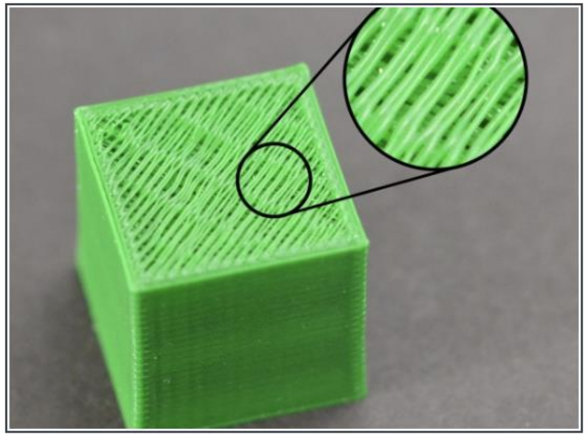
Under-Extrusion

Printer does not extrude enough plastic, gaps between perimeters and infill



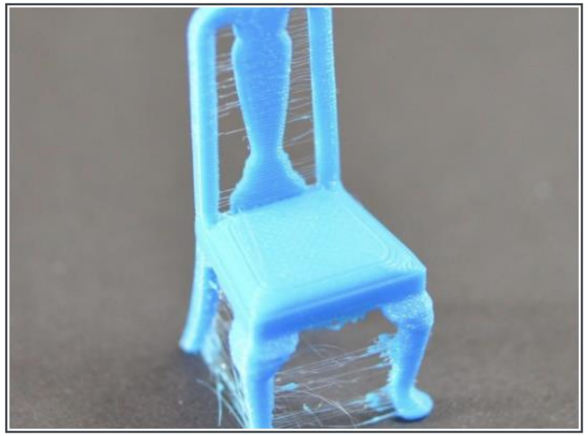
Over-Extrusion

Printer extrudes too much plastic, prints looks very messy



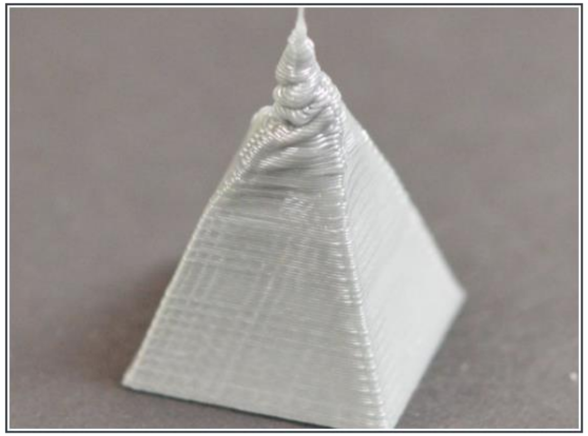
Gaps in Top Layers

Holes or gaps in the top layers of the print



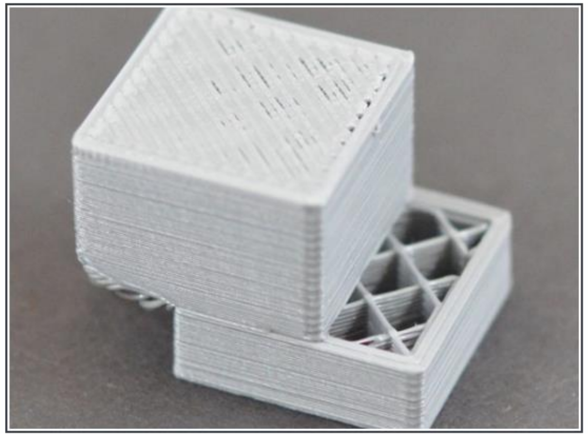
Stringing or Oozing

Lots of strings and hairs left behind when moving between different sections of the print



Overheating

Small features become overheated and deformed

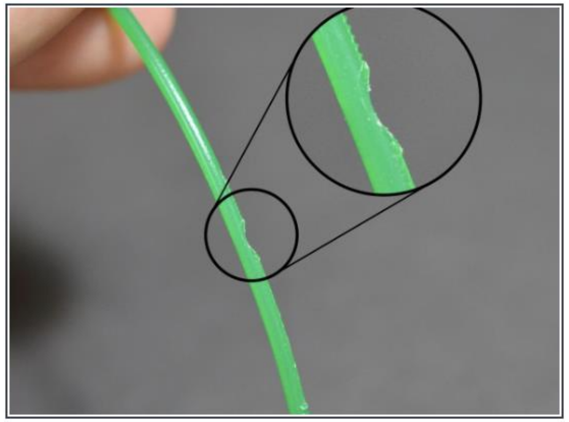


Layer Shifting

Layers are misaligned and shift relative to one another

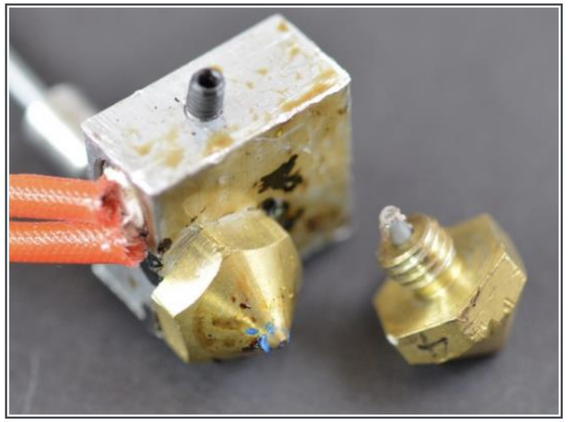
Layer Separation and Splitting

Layers are separating and splitting apart while printing



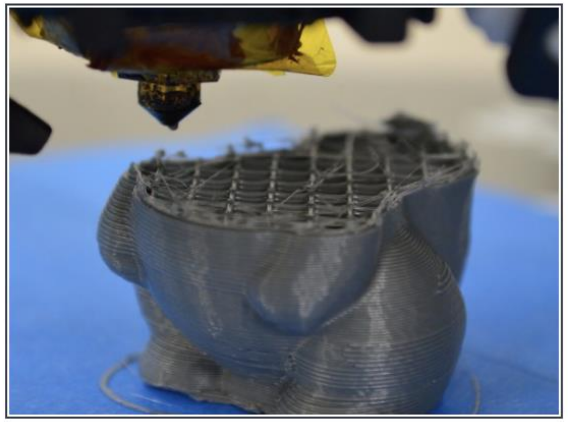
Grinding Filament

Plastic is being ground away until the filament no longer moves, otherwise known as "stripped" filament



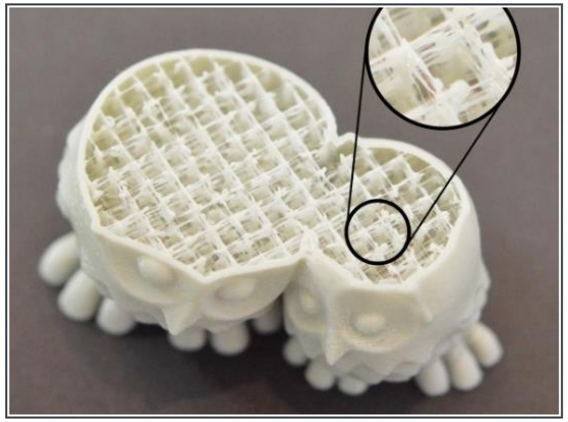
Clogged Extruder

Extruder is clogged or jammed and will no longer extrude plastic from the nozzle tip



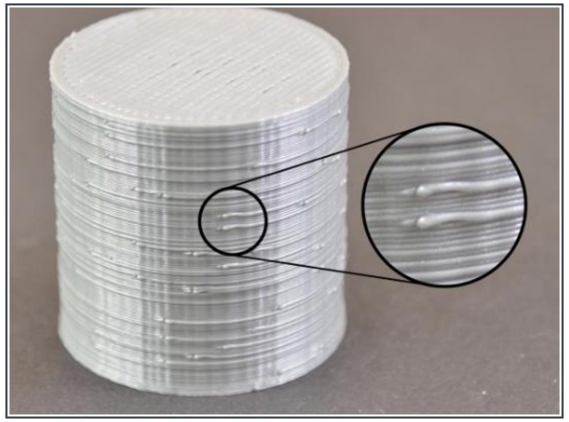
Stops Extruding Mid Print

Printer stops extruding plastic randomly in the middle of a print



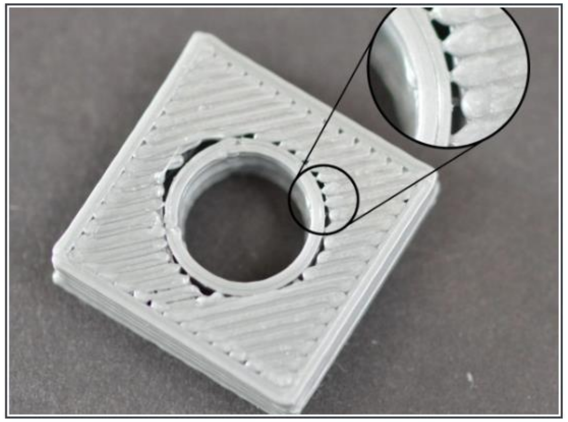
Weak Infill

Very thin, stringy infill that creates a weak interior and does not bond together well



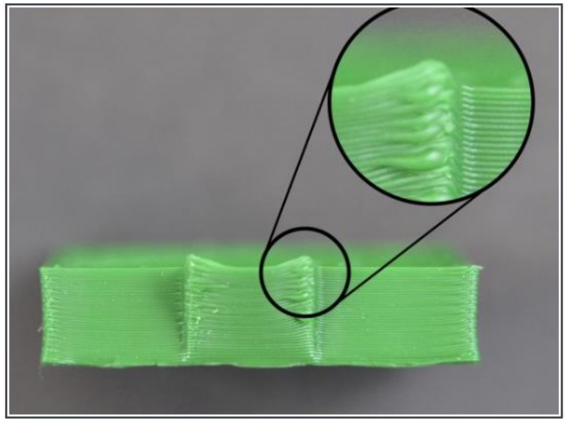
Blobs and Zits

Small blobs on the surface of print, otherwise known as zits



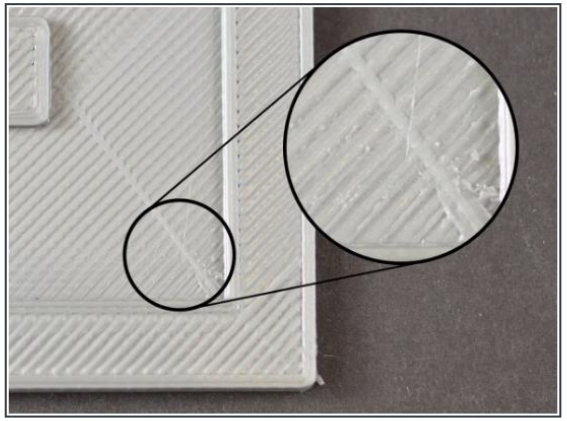
Gaps Between Infill and Outline

Gaps between the outline of the part and the outer solid infill layers



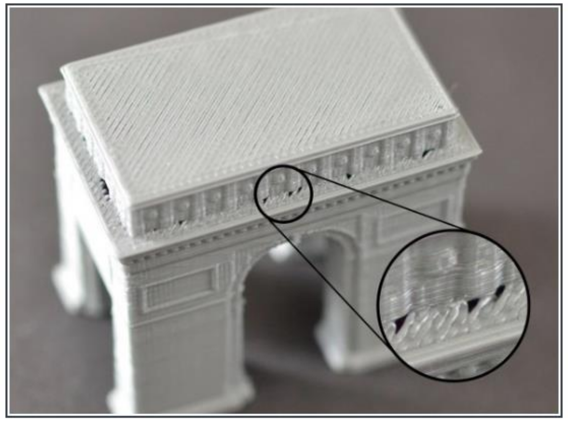
Curling or Rough Corners

Corners of the print tend to curl and deform after they are printed



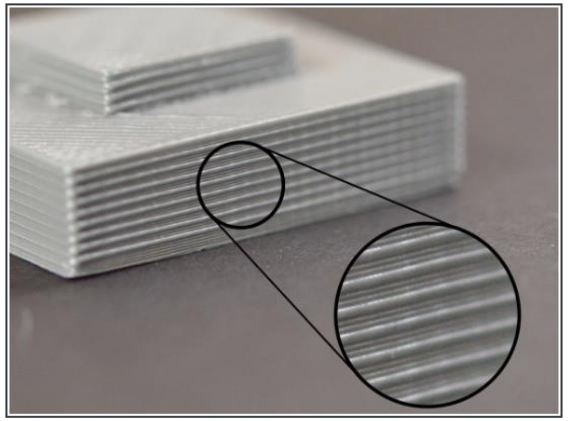
Scars on Top Surface

The nozzle drags across the top of the print and creates a scar on the surface



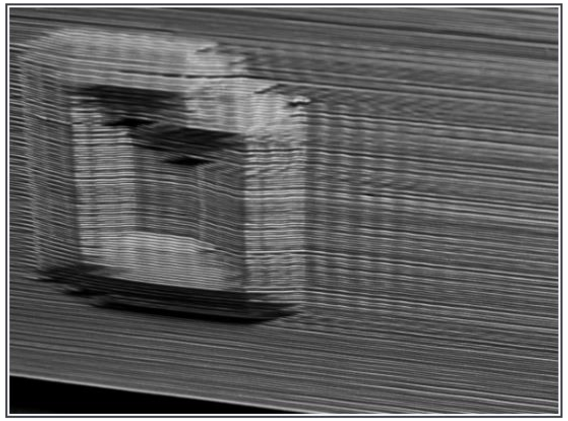
Gaps in Floor Corners

Gaps in the corners of the print, where the top layer does not join to the outline of the next layer



Lines on the Side of Print

Side walls are not smooth, lines are visible on the side of the print



Vibrations and Ringing

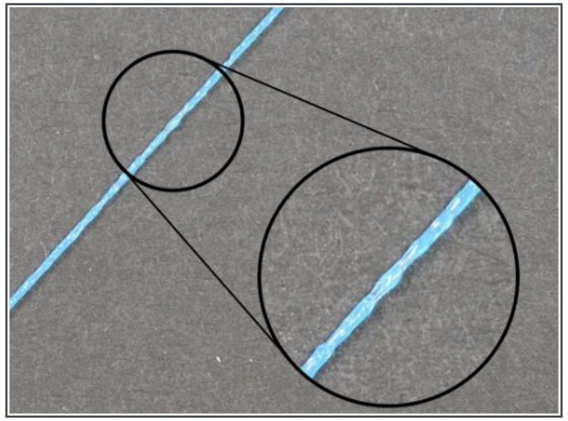
Vibrations that cause oscillations on the surface of the print, otherwise known as "ringing"

Gaps in Thin Walls

Gaps between thin walls of the print where the perimeters do not touch

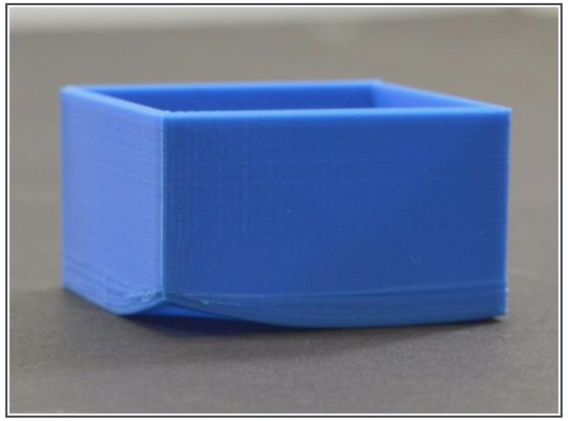
Small Features Not Printed

Very small features are not printed or are missing from the software preview



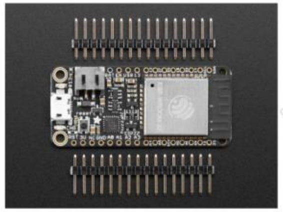
Inconsistent Extrusion

Extrusion amount tends to vary and is not consistent enough to produce an accurate shape



Warping

Warping of large parts, particularly with high temperature materials such as ABS



Adafruit HUZZAH32 - ESP32 Feather

WiFi, Bluetooth, peripherals galore!

Contributors

lady ada

Feedback? Corrections?

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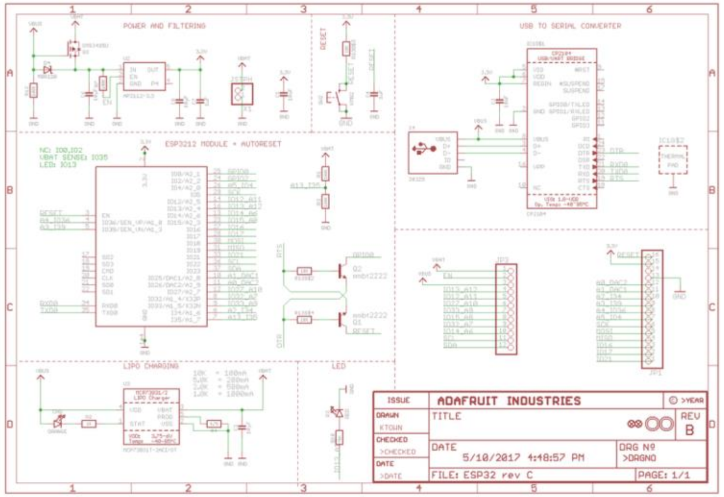
Downloads

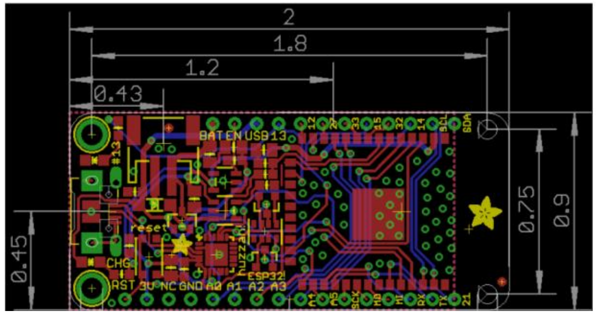
by lady ada

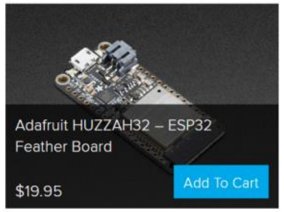
Files

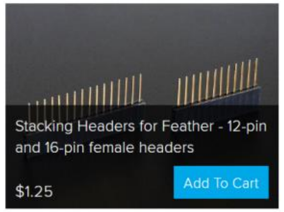
- ESP32 WROOM32 Datasheet
- ESP32 Technical Manual
- *Don't forget to visit esp32.com for the latest and greatest in ESP32 news, software and gossip!*
- EagleCAD PCB files on github
- Fritzing object in the Adafruit Fritzing library

Schematic and Fabrication print









adafruit/Adafruit-HUZZAH32-ESP32-Feather-PCB

github.com/adafruit/Adafruit-HUZZAH32-ESP32-Feather-PCB

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PCB files for the Adafruit HUZZAH32 ESP32 Feather

4 commits | 1 branch | 0 releases | 2 contributors | View license

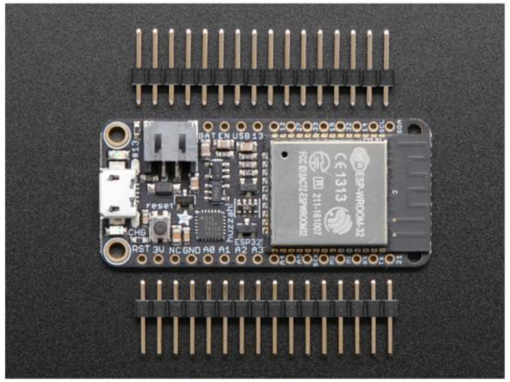
Branch: master | New pull request | Create new file | Upload files | Find file | Clone or download

TheKitty Update README.md — Latest commit 4d9d4c7 on Jun 28

assets	Add files via upload	4 months ago
Adafruit HUZZAH32 ESP32 Feather.brd	w000t	3 years ago
Adafruit HUZZAH32 ESP32 Feather.sch	w000t	3 years ago
README.md	Update README.md	4 months ago
license.txt	Add files via upload	4 months ago

README.md

Adafruit HUZZAH32 ESP32 Feather



Click here to purchase one from the Adafruit shop

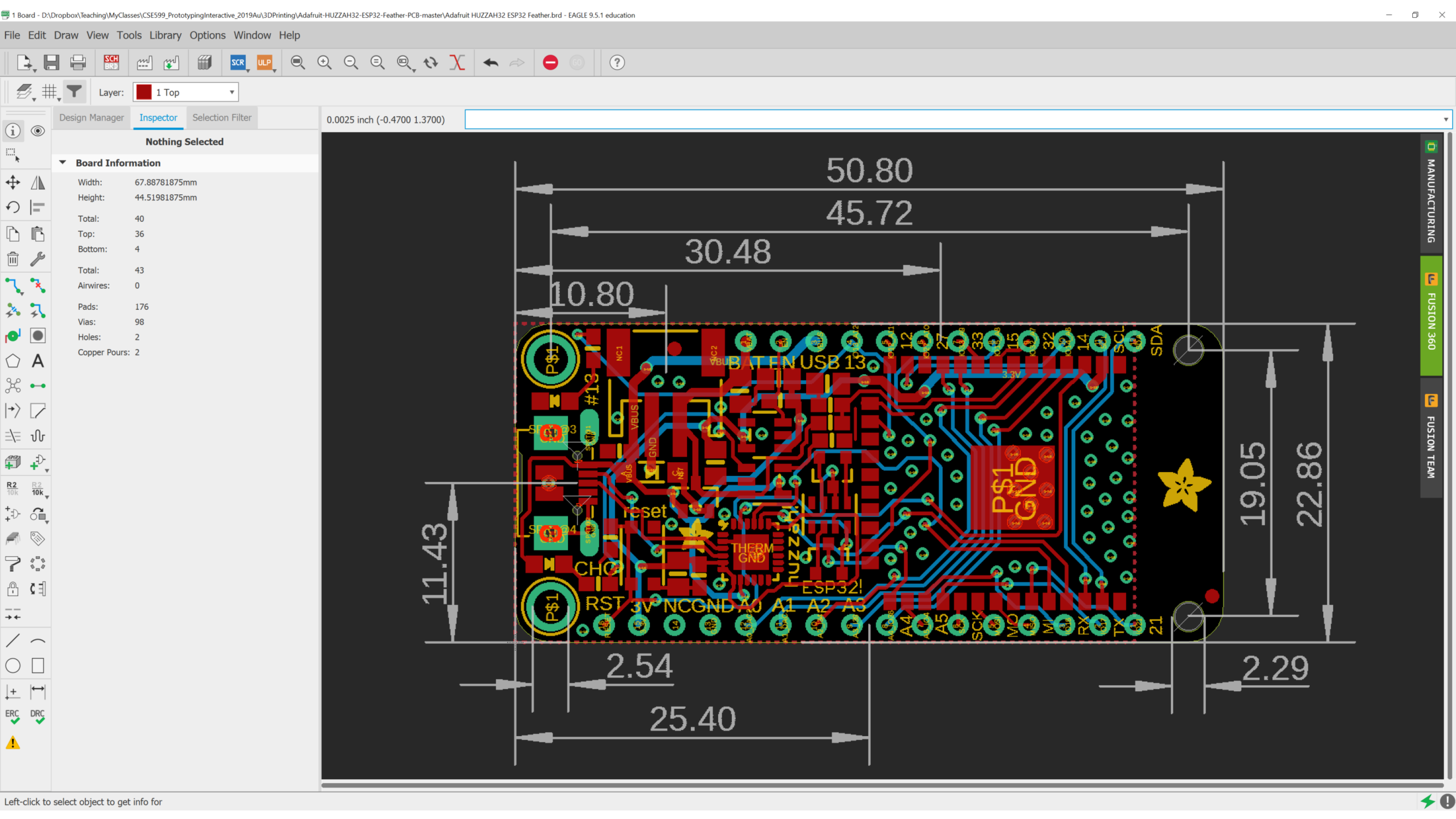
PCB files for the Adafruit Feather ESP32 HUZZAH32. Format is EagleCAD schematic and board layout

For more details, check out the product page at

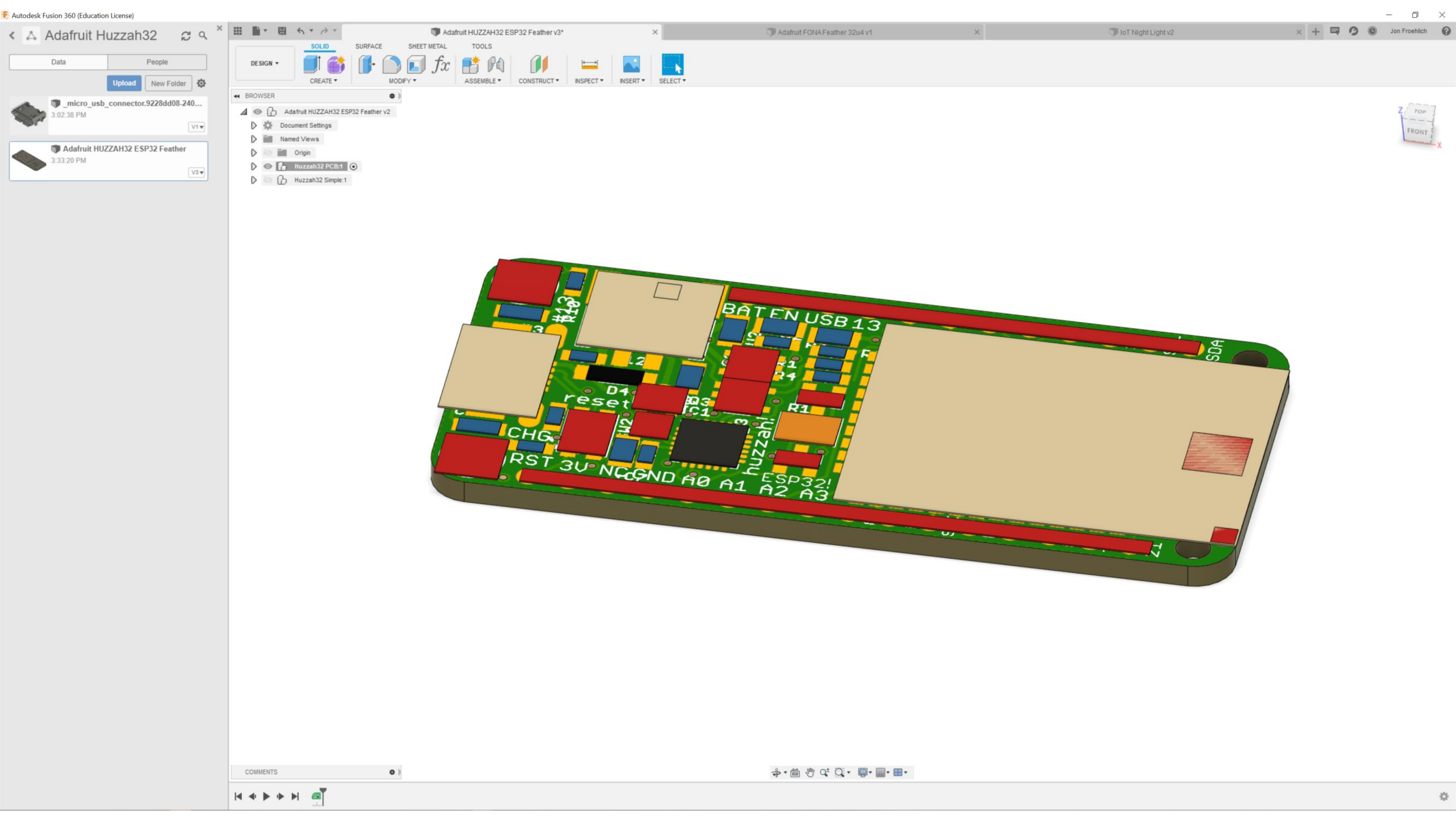
- https://www.adafruit.com/product/3405

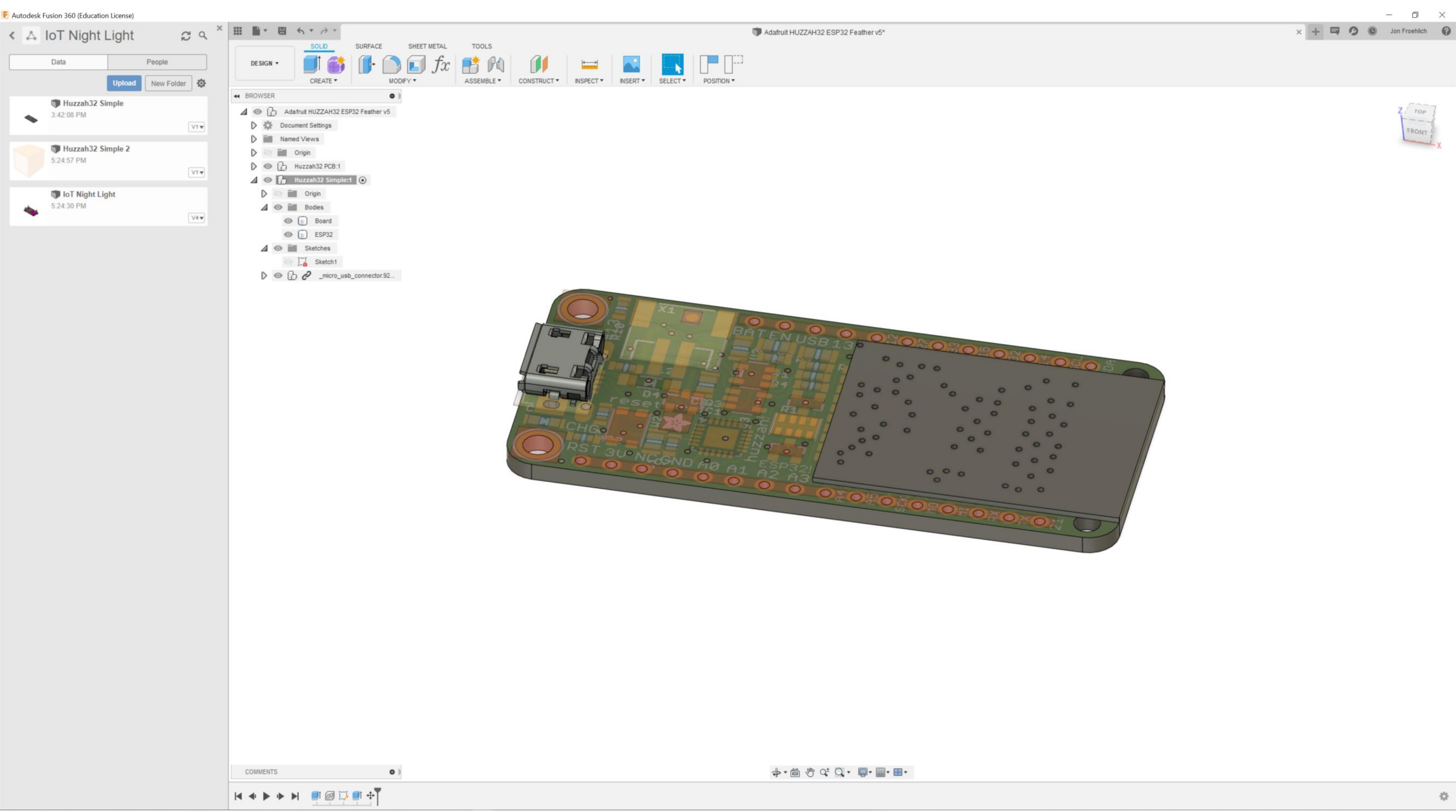
Description

Aww yeah, it's the Feather you have been waiting for! The HUZZAH32 is our ESP32-based Feather, made with the official WROOM32 module. We packed everything you love about Feathers: built in USB-to-Serial converter, automatic bootloader reset, Lithium Ion/Polymer charger, and just about all of the GPIOs brought out so you can use it with any of our Feather



1 Board - D:\Dropbox\Teaching\MyClasses\CSE599_PrototypingInteractive_2019Au\3DPrinting\Adafruit-HUZZAH32-ESP32-Feather-PCB-master\Adafruit HUZZAH32 ESP32 Feather.brd - EAGLE 9.5.1 education
File Edit Draw View Tools Library Options Window Help
Layer: 1 Top
Design Manager
Inspector
Selection Filter
0.0025 inch (-0.4700 1.3700)
Nothing Selected
Board Information
Width: 67.88781875mm
Height: 44.51981875mm
Total: 40
Top: 36
Bottom: 4
Total: 43
Airwires: 0
Pads: 176
Vias: 98
Holes: 2
Copper Pours: 2
50.80
45.72
30.48
10.80
19.05
22.86
11.43
2.54
2.29
25.40
MANUFACTURING
FUSION 360
FUSION TEAM
Left-click to select object to get info for


Autodesk Fusion 360 (Education License)
Adafruit Huzzah32
Data
People
Upload
New Folder
_micro_usb_connector.9228dd08-240...
3:02:38 PM
V1
Adafruit HUZZAH32 ESP32 Feather
3:33:20 PM
V3
Adafruit HUZZAH32 ESP32 Feather v3*
Adafruit FONA Feather 32u4 v1
IoT Night Light v2
Jon Froehlich
DESIGN
SOLID
SURFACE
SHEET METAL
TOOLS
CREATE
MODIFY
ASSEMBLE
CONSTRUCT
INSPECT
INSERT
SELECT
BROWSER
Adafruit HUZZAH32 ESP32 Feather v2
Document Settings
Named Views
Origin
Huzzah32 PCB:1
Huzzah32 Simple:1
TOP
FRONT
BAT EN USB 13
reset
CHG
RST 3V NC GND A0 A1 A2 A3
huzzah
ESP32!
SDA
COMMENTS


Autodesk Fusion 360 (Education License)
IoT Night Light
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People
Upload
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Huzzah32 Simple
3:42:08 PM
V1
Huzzah32 Simple 2
5:24:57 PM
V1
IoT Night Light
5:24:30 PM
V4
Adafruit HUZZAH32 ESP32 Feather v5*
Jon Froehlich
SOLID
SURFACE
SHEET METAL
TOOLS
DESIGN
CREATE
MODIFY
ASSEMBLE
CONSTRUCT
INSPECT
INSERT
SELECT
POSITION
BROWSER
Adafruit HUZZAH32 ESP32 Feather v5
Document Settings
Named Views
Origin
Huzzah32 PCB:1
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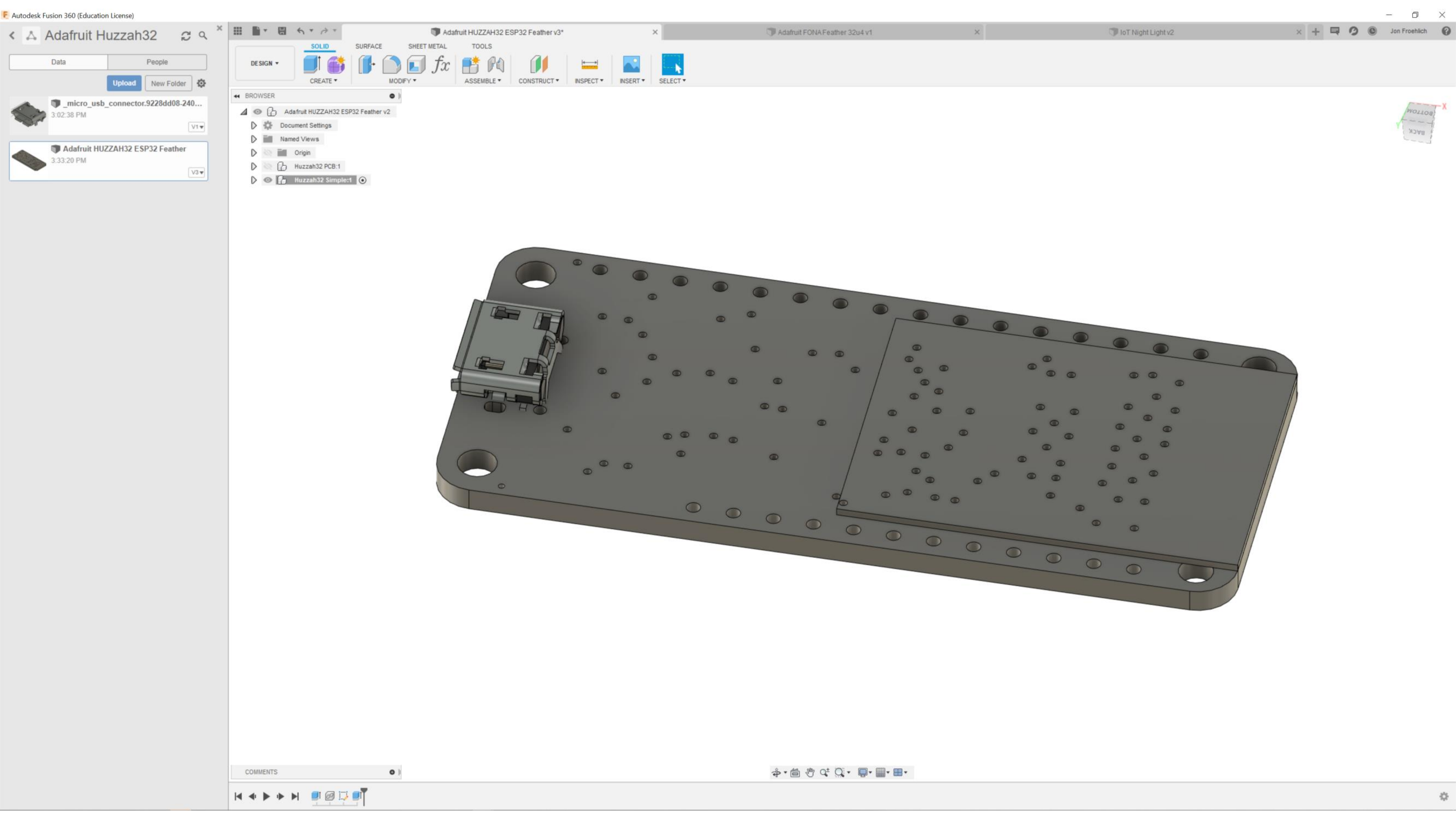
TOP
FRONT
COMMENTS


Autodesk Fusion 360 (Education License)
Adafruit Huzzah32
Data
People
Upload
New Folder
_micro_usb_connector.9228dd08-240...
3:02:38 PM
V1
Adafruit HUZZAH32 ESP32 Feather
3:33:20 PM
V3
Adafruit HUZZAH32 ESP32 Feather v3*
Adafruit FONA Feather 32u4 v1
IoT Night Light v2
Jon Froehlich
SOLID
SURFACE
SHEET METAL
TOOLS
DESIGN
CREATE
MODIFY
ASSEMBLE
CONSTRUCT
INSPECT
INSERT
SELECT
BROWSER
Adafruit HUZZAH32 ESP32 Feather v2
Document Settings
Named Views
Origin
Huzzah32 PCB:1
Huzzah32 Simple:1
COMMENTS

USB Micro Socket F360 Sheet Me ×

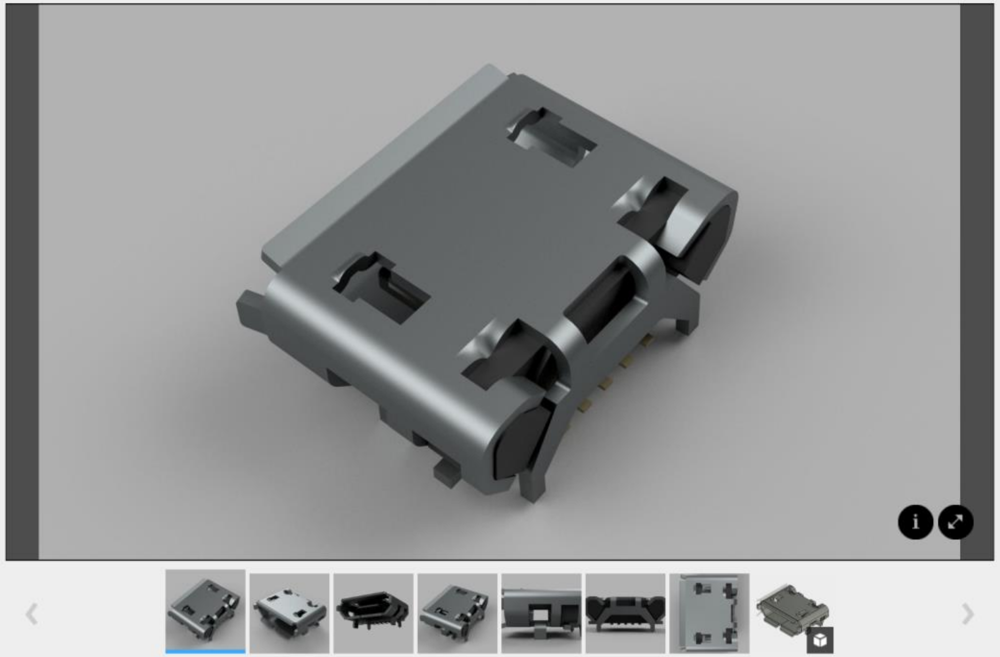
gallery.autodesk.com/projects/104555/usb-micro-socket-f360-sheet-metal

AUTODESK. ONLINE GALLERY > USB MICRO SOCKET F360 SHEET METAL

English

FEATURED

USB Micro Socket F360 Sheet Metal 9/3/2017



Aron Rubin

NJ, UNITED STATES OF AMERICA

OPEN/DOWNLOAD THE MODEL

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_micro_usb_con....f3d 3.55 MB

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Industries

Architecture, Engineering & Constru...

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Categories

Electronics

Products

Fusion 360

Tags

socket molex usb micro connector

Description

Molex 1013594 USB Micro-B Socket modeled mostly using Fusion 360's sheet metal environment

Comments

Please add your comment...

Add Comment

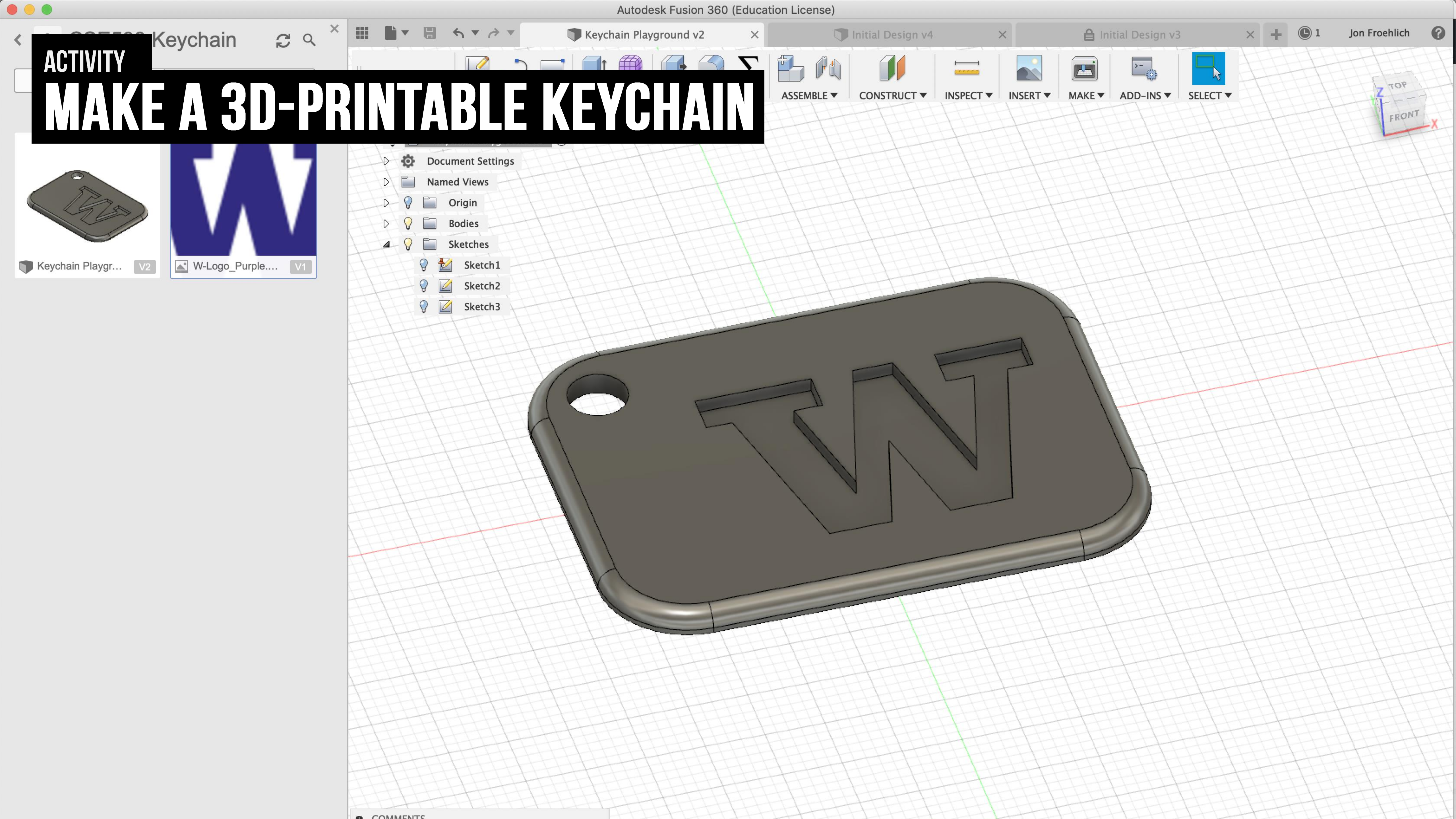
Great model, thank you.

10 months ago

More from the publisher

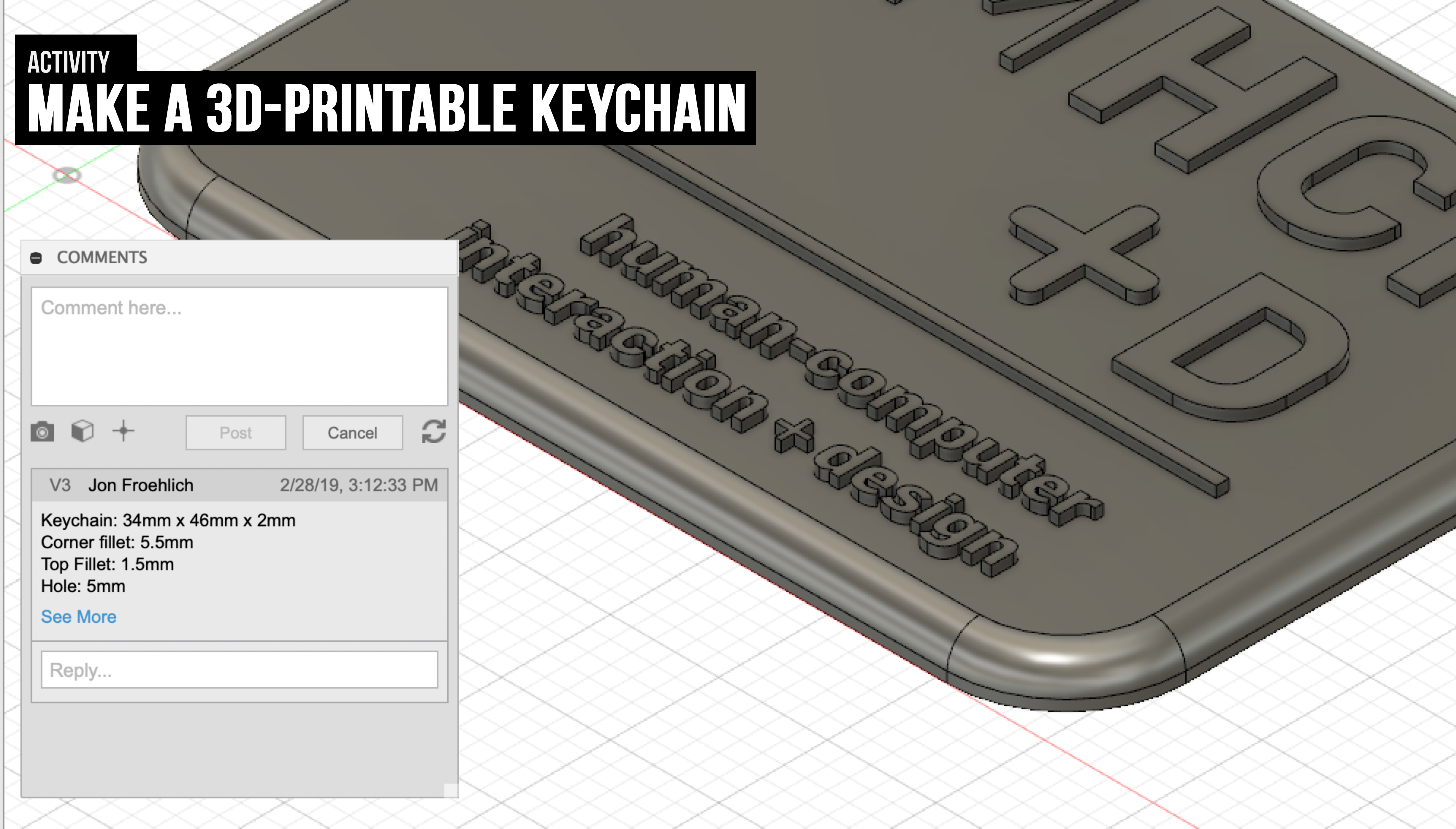
ACTIVITY

MAKE A 3D-PRINTABLE KEYCHAIN



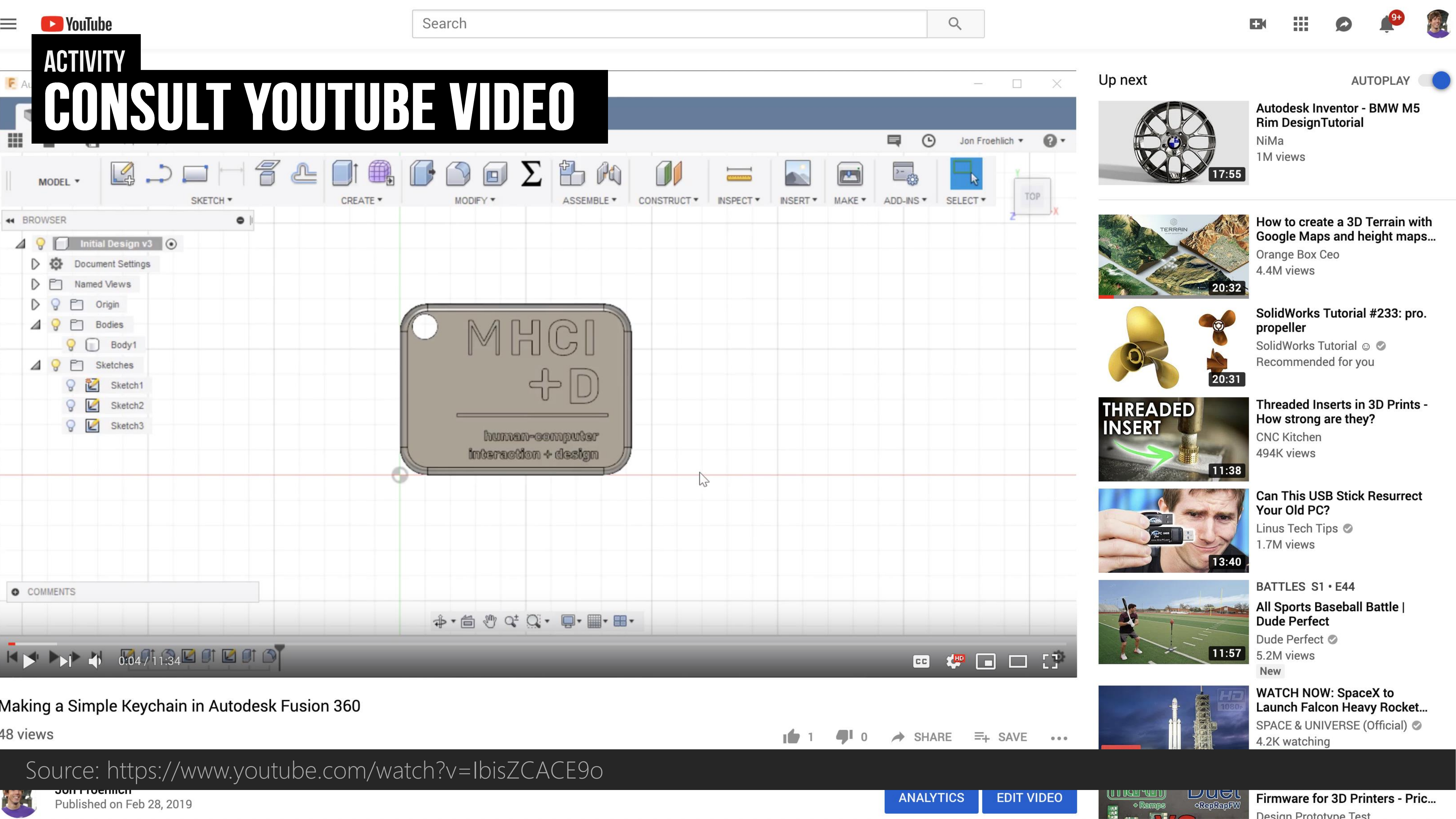
ACTIVITY

MAKE A 3D-PRINTABLE KEYCHAIN



ACTIVITY

CONSULT YOUTUBE VIDEO



Source: https://www.youtube.com/watch?v=IbisZCACE9o

LEARNING GOALS

PROTOTYPING WITH CAD MODELING + 3D PRINTING

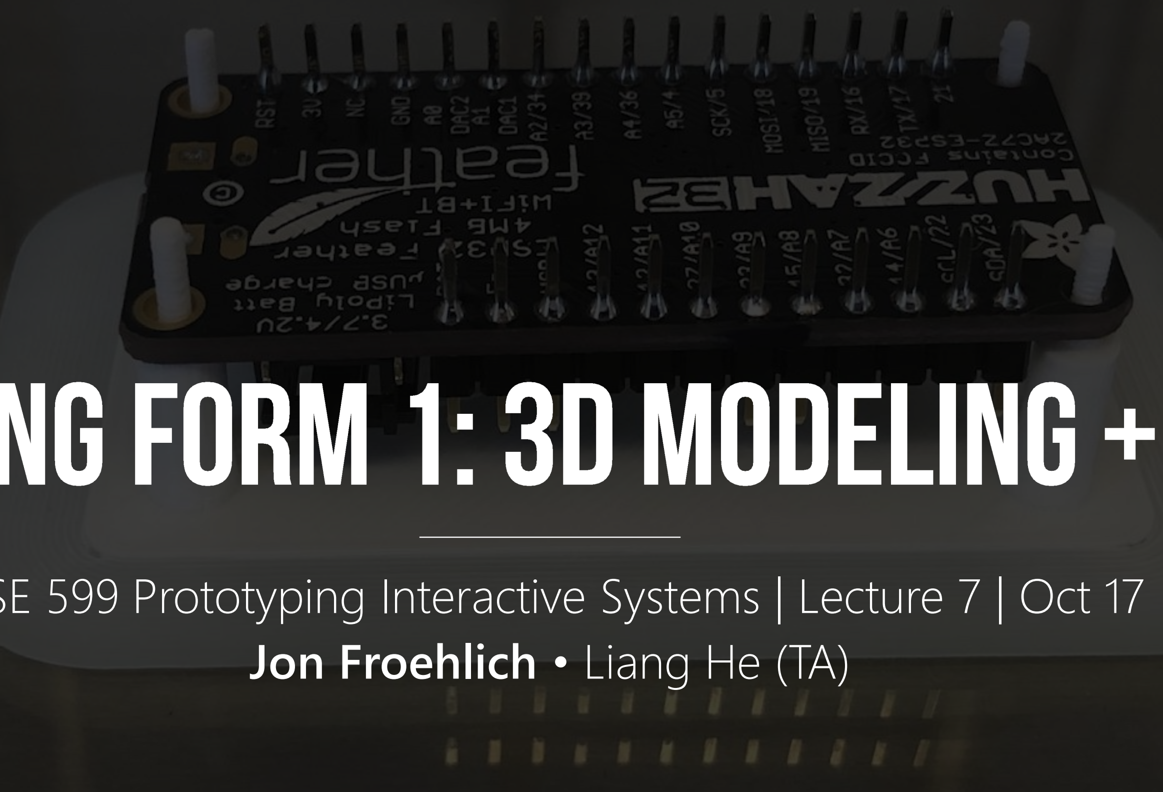
How **CAD tools** + **3D printing** can be used to **rapidly prototype form**

An introduction to two primary 3D printing methods: **SLA** and **FDM**

The **3D printing pipeline**

Modeling designs in **Fusion 360**

What is **slicing** and **what do we use it for**



PROTOTYPING FORM 1: 3D MODELING + PRINTING

CSE 599 Prototyping Interactive Systems | Lecture 7 | Oct 17

Jon Froehlich • Liang He (TA)

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