# 3D Printing Summary

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| --- | --- | --- | --- | --- | --- | --- | --- |
| **Metrics** | **Button Faces** | **Button Tails** | **Case** | **Dock** | **Face** | **Joystick** | **Trigger** |
| Total Print Time (min) | 65 | 32 | 596 | 224 | 610 | 389 | 384 |
| Total Number of Components | 11 | 11 | 1 | 1 | 1 | 10 | 10 |
| Typical Total Mass (g) | 7 | 3 | 71 | 31 | 96 | 47 | 45 |
| Typical Number of Print Setups | 1 | 1 | 1 | 1 | 1 | 1 | 1 |

# 3D Printing Settings

## Components to Print in PLA

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| **Print File Name** | **Qty** | **Total Print Time (hr:min)** | **Mass (g)** | **Infill (%)** | **Support**  **(Y/N)** | **Layer Height/ Nozzle Diameter(mm)** | **Notes (orientation, special settings, etc.)** |
| All\_Button\_Faces.stl | 1 | 1:05 | 7 | 20 | N | 0.2/0.4 | - Print in orientation given in STL |
| Case.stl | 1 | 9:56 | 71 | 20 | N | 0.2/0.4 | - Print in orientation given in STL |
| Dock.stl | 1 | 3:44 | 31 | 20 | Y | 0.2/0.4 | - Print in orientation given in STL  -Supports are required for the front tab |
| Face.stl | 1 | 10:10 | 96 | 20 | N | 0.2/0.4 | - Print in orientation given in STL |
| Joystick.stl | 1 | 6:29 | 47 | 20 | N | 0.2/0.4 | - Print in orientation given in STL |
| Trigger.stl | 1 | 6:24 | 45 | 20 | N | 0.2/0.4 | - Print in orientation given in STL |

## Components to Print in PETG (If available)

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| --- | --- | --- | --- | --- | --- | --- | --- |
| **Print File Name** | **Qty** | **Total Print Time (hr:min)** | **Mass (g)** | **Infill (%)** | **Support**  **(Y/N)** | **Layer Height/ Nozzle Diameter(mm)** | **Notes (orientation, special settings, etc.)** |
| Button\_Tails.stl | 1 | 0:32 | 3 | 20 | N | 0.2/0.4 | - Print in orientation given in STL |

**Note:** The “Button Tails” transfer the force from the buttons on the case to the buttons on the controller. Due to repeated stress, it is recommended that these components are printed in PETG to help prolong their lifespan. If unavailable, PLA can be used but the part may need to be replaced over time.

# Customization Options

Users may request their choice of print colour. It is recommended to print the “All\_Button\_Faces.stl” in a different colour than the “Face.stl” to help with visibility.

# Post-Processing

The “Dock” is the only component that requires support material to be removed. Inspect and ensure that all components are smooth, and holes are free of print material. Sharp edges and rough surfaces can be smoothed down with sandpaper.

# Examples of Quality Prints

## Photos of All\_Button\_Faces.stl

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|  |

## Photos of Button\_Tails.stl

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## Photos of Case.stl

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## Photos of Dock.stl

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## Photos of Face.stl

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| --- |
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## Photos of Joystick.stl

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| --- |
|  |

## Photos of Trigger.stl

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|  |

**Note:** The “Trigger Mounts” (in the centre of the photo) have print in place moving parts. Ensure that the hinge can rotate freely.