

FAIRPHONE CASE - DESIGN DAY 1

instruction manual



3D HUBS


FAIRPHONE

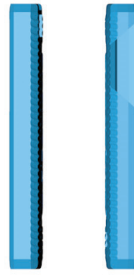
Fairphone case printing set up



front



back



sides



bottom

These instructions are meant as a guideline for printing Fairphone cases. We experienced the best results with the following settings in Makerware for our Replicator 1, 2 and 5th Gen.

These settings are meant as guidelines. You may tweak them to optimize results. Just bear in mind that the result has to be usable as an end product.

General

Material:	PLA
Raft:	yes

Quality

Infill:	10%
Number of Shells:	3
Layer Height:	0.20 mm

Temperature

Extruder:	230 °C
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Speed

Speed while extruding:	60 mm/s
Speed while traveling:	150 mm/s



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Additional tips & tricks

Additional tips:

- Print the object vertical, this will improve the printing of details.
- In the expert settings, use a minimal brim line amount of 5 lines.
- Slow is good - slow printing provides better results, especially at the top of the casing

Post treatment:

- Remove the brim with a knife
- Remove other sharp ends with a knife or lighter

Head over here for more tips and tricks:

https://groups.google.com/forum/#!forum/3dhubs_fairphone



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Shipping Instructions



Item list: small box • scissors • wrapping paper • tape • label seal • UPS label • Fairphone case



stuff the box with enough cushion



make sure the case is embedded fully



close the box with tape both top and bottom



fold the shipping label without hiding any info



make sure the courier can scan the label



Check the order page for instructions about calling a UPS courier



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