Indoor Table

Estimated Print time: 46 Minutes
Estimated Filament Used: 1311.92mm

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Indoor Table

Recommended Settings

Print bed temperature for the first layer = 60 degrees

Print bed temperature for the remaining layers = 55 degrees

Extruder temperature for the first layer = 215 degrees

Extruder temperature for the remaining layers = 210 degrees

Adhesive applied to the print-bed

Infill density = 10%

Infill pattern = Rectilinear

Infill angle = 45 degrees

Solid top layers = 6

Solid bottom layers = 6

First layer height = 0.2mm

Remaining layer height = 0.1mm

Perimeters = 2

Raft = Set to off

Brim = Set to off

Skirt = Original Prusa i3 MK2 default of 1

Skirt distance = 6mm

Skirt height = 1 layer

Support material = Set to off

Overhang Threshold = 3 degrees

Speed for perimeters = 40mm/s

Speed for small perimeters = 20mm/s

Speed for external perimeters = 30mm/s

Speed for infill = 60mm/s

Speed for solid infill = 40mm/s

Speed for support material = 50mm/s

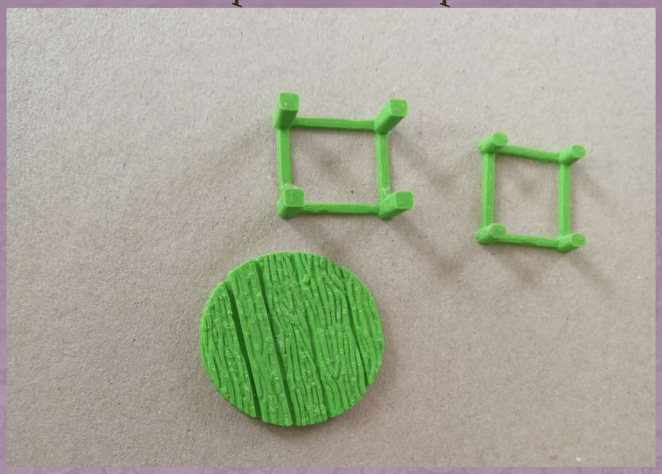
Speed for bridges = 20mm/s

First layer speed modifier = 30% of original speed

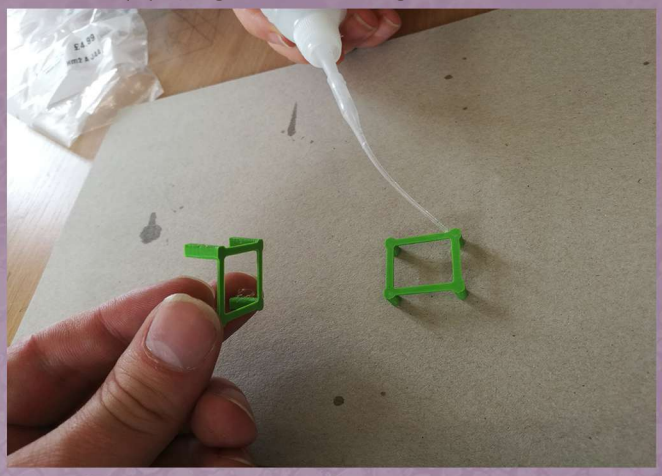
Product Assembly

Indoor Table

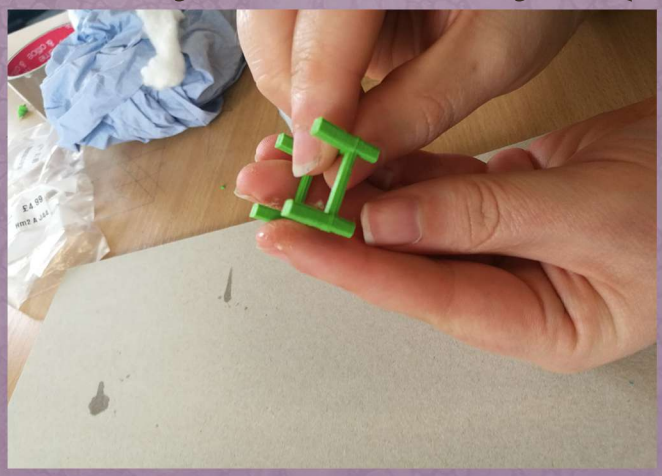
Remove parts from printbed



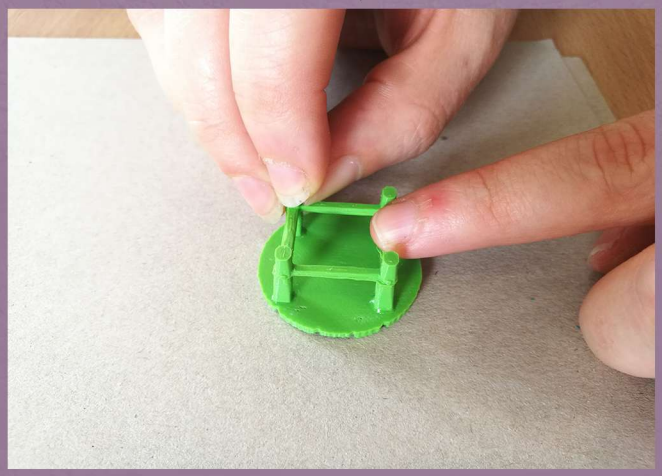
Apply glue to Legs 'Bottom'



Affix Legs 'Bottom' and Legs 'Top'



Apply glue to 'Table top'



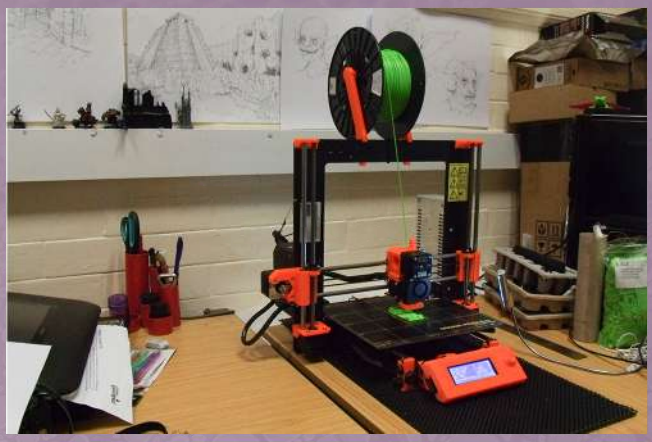
Affix 'Table Top' and 'Legs'

Time to fill the tables with sweet sweet ale.

Necessary Materials

3D Printer

All Hobgobin 3D ltd products were test printed on a number of printers but have been optimised for use with the Original Prusa i3 Mk2. Printing information found later in this document will refer to the Original Prusa i3 Mk2 and related software, therefore settings may not be the same if the product is printed using a different system. It is recommended to always adhere to your 3D printer manufacturer's instructions. You should never leave a printer unattended, and never leave children under the age of 16 unsupervised with a 3D printer.



Filament

To print the files, filament will be required. The Original Prusa i3 Mk2 can print in a range of materials, at Hobgoblin 3D ltd we tend to print using 1.75 PLA filament. This can be purchased in a range of styles and colours and can be readily sourced online.

Bed Adhesive

Most Hobgoblin 3D ltd products will not require adhesive to be applied to the print bed, however it is advisable that the customer purchase some form of bed adhesive in case a print fails and extra adhesion is required. Hobgoblin 3D ltd uses Prit Stick glue for adhesion, however Blue painters Tape can also be used to provide a print surface for other printers, again always refer to you manufacturer's instructions

Necessary Materials

Scraper

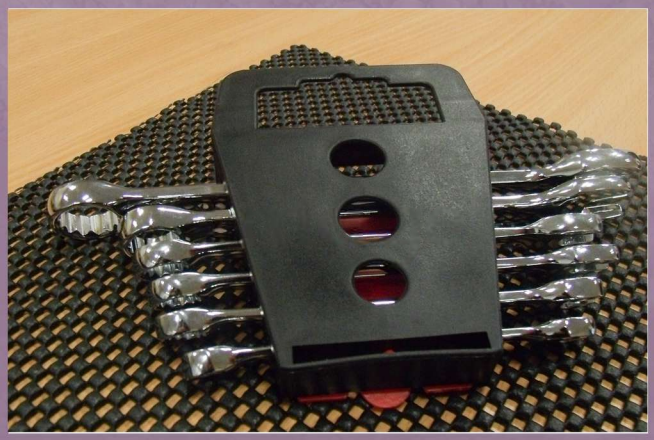
A number of Hobgoblin 3D ltd products will be difficult to remove form the print bed. For this reason it is suggested that the customer purchase a scraper so that they can get under the product and remove it from the print bed.

Isopropyl alcohol or window cleaner

The print bed will require intermittent cleaning in order to remove any applied glue. To achieve this without damaging the surface of the print bed it is suggested that Isopropyl alcohol is purchased. If you cannot source Isopropyl alcohol, window cleaner can be used in its place as per Prusa recommendations. If using a different printer you should refer to you manufacturers instructions.

Allen Keys and Wrenches

If you are printing using an Original Prusa i3 Mk2, then it is recommended that you have a range of Allen Keys and Wrenches. These will be used to tighten and re-align parts of the machine should they become loose or require adjustments. Other printers may require different tools to ensure adequate upkeep.



Necessary Materials

Craft knife and files

Some products will require the removal of support material or general clean-up of printing errors. For this reason, a range of files and a craft knife may prove useful. Adult supervision is strongly advised should children under 16 be involved in the process.

Super Glue

A few Hobgoblin 3D ltd products will need to be constructed from several separate parts. To assemble these files, Super Glue or an adhesive of similar strength will have to be utilised. Again adult supervision is highly recomended.