

3D Printing guide for the KAPtery [Shutter Timer](#) case

Assembly and User Guide at KAPtery.com/guides

For spare parts: KAPtery.com

Technical support: <http://kaptery.com/contact/>

[Files at Thingiverse](#)

Below are some typical settings for printing on a Makerbot Replicator 1 with PLA filament, single 0.4 mm MK8 nozzle, 205° to 215°C, build plate at 45°C. These are hot temperatures for PLA, but with many brands, cooler temperatures will not produce parts strong enough to survive typical use.

Layer height = 0.2 mm, base print speed = 120 mm/second, travel speed = 200 mm/second (acceleration is ON).

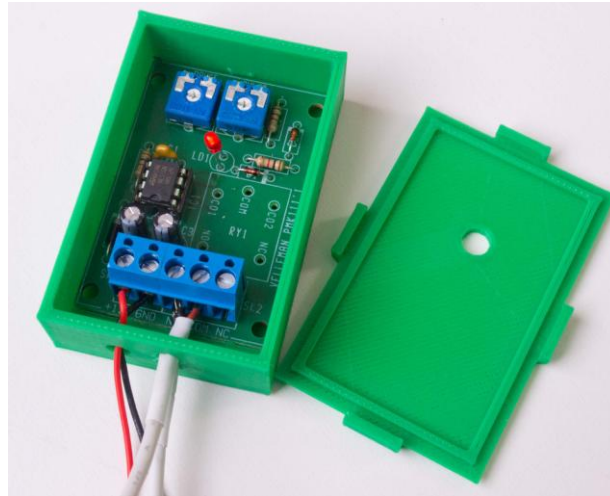
Slicing: I have sliced these parts with good results in both MakerWare and Simplify 3D.

For other printers, slicers, and materials different settings may be appropriate.

Picavet cross:

- *Position:* The box and lid should be in the positions shown above with their flat sides down.
- *Size:* The long dimension of the box should be 6.9 cm and the long dimension of the top should be 7.35 cm.
- *Support:* OFF
- *Infill:* 25% to 100%
- *Shells:* 2
- *Time:* 1 hour

The tabs on the box top must be strong enough to flex a little without breaking. So make sure your slicer does not make the tabs hollow and use a high enough temperature to ensure good bonding.



The box and lid are printed in the positions shown. No support is needed.