



Skeleton Pistol Grip Shifter Handle for Thrustmaster



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Summary

Lightweight pistol grip with truss cut-outs and soft finger waves. Threaded mount for Thrustmaster shifters.

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A lightweight pistol grip with zig-zag truss windows through the body, four soft finger waves and big 6 mm rounded edges, for a moulded look. The window edges are rounded too, so there are no sharp corners in your hand. There's a small hole in the top front corner for a lanyard or a pop of colour.

The lower part is solid, with the original Thrustmaster mount thread built in, so it screws straight onto the shifter.

SIZE

50 × 30 × 132 mm (W × T × H)

FILES

3_skeleton_grip.stl – thread built in

insert-pocket/3_skeleton_grip_insert-pocket.stl – plain pocket to press or glue in the original metal mount piece

PRINT SETTINGS

Option A – threaded version

Upright, threaded hole down

Supports from build plate inside the windows (the tops of the triangles are flat overhangs)

Option B – insert-pocket version (cleanest look)

Lay it flat on its side: the windows print perfectly with no supports

Glue or press in the original metal mount piece

Layer height: 0.12–0.16 mm, walls 4, infill 30–40 %

Material: ABS (best if you want to smooth it, see below), ASA, PETG or PLA+. Matte or silk colours show off the shape best (the renders use magenta).

ABS ACETONE SMOOTHING

With this design you can use acetone smoothing. The big rounded edges and soft finger waves come out glossy and injection-moulded, with no visible layer lines.

Before you start

Print in ABS with 4+ walls. Smoothing eats a little of the surface, and the extra walls keep the thin struts strong.

Protect the thread. Acetone softens it and it may not fit afterwards. Use the insert-pocket version and glue the metal mount piece in after smoothing, or screw a matching bolt into the threaded version as a plug (a little grease on the bolt keeps it from sticking).

Remove all support material and lightly sand any support marks first, because smoothing won't hide them.

Cold vapour method

1. Line the walls of an airtight glass or metal container with paper towels and dampen them with acetone (damp, not dripping).

2. Stand the grip on its base on a small stand (a glass jar lid or a block wrapped in foil) so it doesn't touch any liquid.

3. Close the lid and wait. It usually takes 30–90 minutes depending on temperature. Check every 15 minutes: it's done when the surface turns evenly glossy.
4. Don't overdo it. Too long and the edges go soft, the struts can sag and the finger grooves lose their shape.
5. Take it out carefully without touching the surface, and let it harden for at least 24 hours before handling or fitting it to the shifter.

Safety

Acetone is highly flammable. Work outdoors or in a well-ventilated room, away from flames, heaters, sparks and your printer.

Never heat acetone on a hot plate or in a heated chamber.

Wear nitrile gloves and avoid breathing the vapour.

Let the part air out until the acetone smell is completely gone.

Only use this method with ABS (ASA works too, more slowly). PLA and PETG don't react to acetone.

Model files



3_skeleton_grip.stl



3_skeleton_grip_insert-pocket.stl

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