

Face shield in 33 minutes (stack version)

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Summary

Top part of face shield. Compatible with Prusa Face Shield.



5.50 hrs



1 pcs



0.20 mm



0.40 mm



PET



320 g



Prusa
MK3/S/S+

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Tags: [mask](#) [facemask](#)

Top part of face shield. Compatible with Prusa Face Shield.

- full height (20 mm)
- 0.4 mm nozzle (E3D v6)
- 0.2 mm layer
- prints in ~33 minutes per piece !

Add 2nd stack (20 pcs) for total print time 11 hours - 640 g (overnight printing).

Print instructions

There is a diagonal cut in the front. This is by purpose to trigger vase mode with double wall thickness. You have to set "Slice gap closing radius" to 0.001 or less to work. Otherwise, the print will be slower and stringy.

Settings in 3MF are tuned for i3 MK3S. Due to slow processor i3 MK3S cannot print so fast so don't be afraid of so high accelerations and print speeds. And don't believe estimated print time.

For other printers, keep high speeds just decrease acceleration and/or max volumetric speed.

First layer is set to 0.15 mm for great adhesion so make sure your printer is calibrated precisely. Or you can increase it.

Temperature is 270°C to provide good melting. Extruder looses steps at the top layer only (no big deal).

E3D V6 nozzle is wide flat at the tip which allows printing of 1 mm threads. If you have narrower it can cause rough surface.

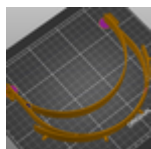
There is a gap between parts to divide them. Due to empty layer check of PrusaSlicer, I had to add a connector which is harder to break and causes sharper edge.

Pins are overhangs. Bottom layers will hang down a little but the rest is OK so don't be afraid. You can cut the excesing threads after the print.

There are no chins. They are not crucial but could be needed as well. If you need them, print them separately because it is faster.

If you want brim on the ends for better adhesion, you can enable it in .scad file. Also, you can reduce/increase number of pieces on the stack.

This remix is based on



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by espr14

Model files



face-shield-esprit-mod.scad

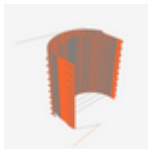


face-shield-esprit-mod-stack-10.3mf



face-shield-esprit-mod-10pcs.stl

Print files



face-shield-esprit-mod-stack-10_04mm_petg_mk3s_.gcode

🌀 PET 📏 0.40 mm 📐 0.20 mm ⌚ 5.50 hrs ⚖️ 320 g 🖨️ Prusa MK3/S/S+

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