



## "Block Man" Sand Mold 16" (40 cm) tall



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## Summary

The "Block Man" is a sand mold of the iconic character for the beach. The molds are hollow for wet sand compaction.

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The "Block Man" Sand Mold is optimized for 3D printing and fun at the beach. The molds (4 parts) will allow you to leave the iconic sand character sunbathing on the sand (laying down). The parts are made so that you do not have to use supports. There are no overhangs, so it should be very printable. It was tested using PETG which is durable outdoors but a bit flexible. Here are some more details about the model.

### Model Parts:

When put together, the character comes out to 16 inch. or 40 cm. in the longest dimension.

1. **Head Mold**- Shaped in the iconic character's head. It prints face down and the mold is used face up. It has a slit on the top to guarantee sand compaction and proper wetness (you can add more sand or water).

2. **Torso Mold** - This is just the torso of the character. It is completely hollow on the bottom to print faster and for sand compaction. The torso is a bit lower near the shoulders and taller towards the legs.
3. **Leg Mold** - This is basically the same as the Torso, but goes below it.
4. **Arm Mold** - Containing the iconic grabbing hands of the character. The images and the 3mf are shown with two arms, BUT it is the same part, so you can print it just once and move around. Again, it is hollow towards the hand to allow a window into the sand. This mold is printed in one direction and flipped to use.

## Printing:

Printing should be pretty straightforward. Here are a few tips that helped me print them.

- The STLs are oriented correctly in Z, a 3mf is provided, I have an X1C and printed in PETG.
- If printing in PETG, slow it down a bit. I changed the max flow to 7 mm<sup>3</sup>/s.
- No supports are needed. I used a good PEI plate with PETG so I did not need brims. If you are unsure about adhesion with your plate/filament combination, allow brims (the torso and legs may need brims the most).

## The Pictures Above:

- The photograph and the model render show the mold from below. To use in the beach, you would press the head and the arms cavities into the sand.
- One of the pictures shows a print configuration divided in two plates. Although with a build plate big enough you could potentially get away with just two prints.

## Going Forward:

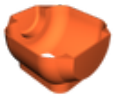
- I am lucky enough to live near the beach, but unlucky enough that because of my work I really can't go to test this.
- Please feel free to print in any material and give me feedback. I could change a few things here and there to make it more enjoyable.

## Model files



**Block Man STLs (head,torso, legs, arm)**

4 files



### block\_character\_head.stl

☐ Block Man Head correct printing direction



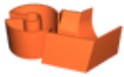
### block\_character\_torso.stl

☐ Block Man Torso



### block\_character\_legs.stl

☐ Block Man Leg



### block\_character\_arm.stl

☐ Block Man Arm (you can use same arm on both sides)



## Block Man 3MF (X1C PETG filament)

1 file



### block\_man\_beach.3mf

☐ 3mf for Bambu Lab X1C (the bambu stuio is a fork of Prusa Slicer)

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