



## Litho Keychain



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## Summary

This is a 2 part keychain with a litho-picture of your loves and friends.

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Hi Friends,

This is a little keychain with a lithophane.

### The first part is to get the lithophane

Go to <https://tool.itslitho.com/> or your favourite site and load the picture of your choice up.

Use

- shape circle
- diameter 4cm
- min thick 0,8mm
- max thick 3,2mm
- frame thickness 2,5mm
- frame depth 3,4mm
- leave the rest by default
- you can increase the quality if you want

download the litho and load it in your slicer.

I have an example for you as .stl file ( its my lovely dog Lucky:-) ).

### **Second part is to print the lithophane**

- Its important to print it with no infill. Just increase the number of perimeters/walls to get a solid body ( I use 10 )
- I use the support on build plate only function and a brim and if you dont print too fast you should have no problems
- I printed with 0,1mm layerheight

### **The last part is to print the frame an get the two parts together**

I printed the frame with the same settings as the litho

- I recommend to disable the thick bridges function
- You need a printpause at layer 41 (by layerheight 0,1mm ; firstlayerheight 0,28mm)

If the print is paused, put the litho in the frame.

Dont push too hard, it should have only a little friction with the frame so it dont move.

The Top of both parts should now be even.

Then resume the print.

I printed the frame with Silk Pla+ to get a metallic touch.

Thats all :)

I hope you enjoy this little project.

## **Model files**

**litho\_keychain\_frame.stl**



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**litho\_keychain\_lucky.stl**



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