



Talking Molten Snowman



Daniel Vitanza

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Summary

Molten snowman with sign to decorate your table.



7.38 hrs



5 pcs



0.20 mm



0.40 mm



PET



67 g



Prusa
MK3/S/S+

[Seasonal designs](#) > [Winter & Christmas & New Year's](#)

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1. Introduction

This melting snowman is a nice decoration to add to your christmas and winter set. He holds a sign in his hand like Wile E. Coyotte to express his despair ;)

Several signs ara available, including the famous “Minchia !” for my Italian compatriots.

Feel free to ask me for other signs or custom accesories.

2. Revision History

Version	Description	Date
A.1	<ul style="list-style-type: none"> Initial Release 	14/12/20
A.2	<ul style="list-style-type: none"> Improve Body print parameters for a better quality. Rotate right arm to 15° for better readability from above. 	16/12/20
A.3	<ul style="list-style-type: none"> Add picture Increase thickness of open scarf for better printability. 	29/06/20

3. Printing Instructions

1. Body

- PETG or PLA.
- Layer Height: 0,2
- Min 4 perimeters
- No Support
- Min 30% infill
- Infill Pattern: gyroid (safest choice according to my several tests with this model)
- Enforce min layer thickness to 0.1 and max to 0.2
- Use variable layer height: adaptive with quality=0,3 and smooth with radius=8
- Seam Position: Rear
- Solid infill every 10 layers.

2. Panel/Sign

- PETG or PLA.
- Layer Height: 0,2
- Min 2 perimeters
- No Support
- Min 15% infill
- Infill Pattern: doesn't matter
- Ironing on topmost surface (to smooth the letters)
- Color change @ 2,40mm

3. Glasses and Nose

- PETG or PLA.
- Layer Height: 0,2
- Min 2 perimeters
- No Support
- Min 15% infill
- Infill Pattern: doesn't matter
- Brim: 2mm outer, 0,3-0,4 gaps (optional but can help)
- For the Nose only: Print 2 instances, 3cm apart. This will improve cooling. Just use the best one. Or put two noses to your snowman if you really want ;p

4. Other Parts

- PETG or PLA.
- Layer Height: 0,2
- Min 2 perimeters
- No Support except for the "OpenScarf"
- Min 15% infill
- Infill Pattern: doesn't matter

4. Materials for Assembly (BOM)

- The printed parts
- A bit of glue (cyanoacrylate)

5. Manufacturing and Assembly Instructions

1. Just download the relevant files and print them according to my advices.
2. Clean the parts: remove stringing residues, burrs, brims, etc. But be careful, some parts are fragile (I broke some glasses during my tests just by removing them too quickly from the bed - wait for complete cooling and use a scraper).
3. Assemble the parts by clicking them into their positioned holes/cuts on the body. Use a bit of glue to secure them if needed.

5. Notes

- G-code file only made for MK3S+. The file contains some custom lines to add a pre-heating before the printing to avoid oozing during the mesh bed levelling. And a timer at the end of the print to buzz a sound once the parts has cooled down.
- Do not use the g-code file on other machines than MK3S+ ! In any case, I recommend you to slice the .stp files by yourself to make your own g-code files.

Have a nice print !

Last note! I've spent quite a lot of time designing, iterating and prototyping on all my models. Therefore, if you enjoy them, please don't forget to like+download and then rate them, so that I can earn so prusaments to continue ;)

Model files



Step Files

14 files

button.step

eye.step

glasses.step

hat.step

nose.step

mouth.step

panel-minchia.step

panel-hot.step

left-eyebrow.step

right-eyebrow.step

right-arm.step

left-arm.step

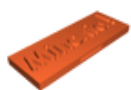
bodypredetermined.step

open-scarf.step



3mf Files

5 files



panel-minchia.3mf



black-parts.3mf



nose.3mf



bodypredetermined.3mf



open-scarf.3mf

Print files



panel-minchia.gcode

PET 0.40 mm 0.20 mm 0.12 hrs 1 g Prusa MK3/S/S+



black-parts.gcode

PET 0.40 mm 0.20 mm 0.40 hrs 2 g Prusa MK3/S/S+

nose.gcode



PET 0.40 mm 0.20 mm 0.07 hrs 1 g Prusa MK3/S/S+

bodypredetermined.gcode



PET 0.40 mm 0.20 mm 6.20 hrs 60 g Prusa MK3/S/S+

open-scarf.gcode



PET 0.40 mm 0.20 mm 0.59 hrs 3 g Prusa MK3/S/S+

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