



# HueForge Stained Glass Butterfly 1

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VIEW IN BROWSER

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## Summary

Stained-glass butterfly from the WIKI article, [https://hueforge.wiki/index.php/Stained\\_Glass](https://hueforge.wiki/index.php/Stained_Glass).

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I wrote a WIKI article to explain my “stained-glass” process and used this butterfly as an example. To complete the cycle, I am posting the resulting model here. The article is [Stained Glass - HueForge Wiki](#).

The model, like all of my stained-glass models, is in TWO parts. The first part has just the blues and black of the foreground. The second part blanks out the blues and provides the reds and yellows for the background. Both parts have very thin base layers, so special care is needed to remove them from the print bed. It is probably best to cool them completely before trying.

When joining the two parts be sparing with the adhesive, especially in the lighter parts. The adhesive will change the colors if it is not behind the darkest parts. I just used some around the darker parts and around the edges to keep the glue from showing. If spread thin and uniformly, it should not show too much.

## Part 1

Project: Butterfly1\_Part\_1.hfp

Print at 100% infill with a layer height of 0.08mm with a base layer of 0.16mm

The Model is 150x146.67mm in size

You may print at higher layer heights below the Min Depth of 0.16mm

The Max Depth is 1mm and the Actual Depth is 1.1mm

Filaments Used:

PLA Polymaker Natural TD1 Transmission Distance: 35

PLA Overture Blue Transmission Distance: 4.2

PLA HueForge Navy Blue 2.2 Transmission Distance: 4

PLA PolyLite Black Transmission Distance: 0.3

This print uses 4 unique filaments

Swap Instructions:

Start with Natural TD1

At layer #2 (0.24mm) swap to Blue

At layer #10 (0.88mm) swap to Navy Blue 2.2

At layer #12 (1.04mm) swap to Black for the rest.

## Part 2

Project: Butterfly1\_Part\_2.hfp

Print at 100% infill with a layer height of 0.08mm with a base layer of 0.16mm

The Model is 150x146.67mm in size

You may print at higher layer heights below the Min Depth of 0.16mm

The Max Depth is 1mm and the Actual Depth is 1.1mm

Filaments Used:

PLA Polymaker Natural TD1 Transmission Distance: 35

PLA PolyLite Lemon Yellow Transmission Distance: 6.5

PLA PolyTerra Army Red Transmission Distance: 0.3

PLA Overture Red Transmission Distance: 4.8

This print uses 4 unique filaments

Swap Instructions:

Start with Natural TD1

At layer #2 (0.24mm) swap to Lemon Yellow

At layer #5 (0.48mm) swap to Army Red

At layer #6 (0.56mm) swap to Red for the rest.

If substituting filaments, pick ones with the closest TD values. Use a Natural white, if possible. Otherwise, pick the one with a TD > 10 to minimize the color change it will cause.

## Model files



### butterfly1\_part\_2\_150x147.stl

☐ Part 2 - Red/Yellow (back)



### butterfly1\_part\_1\_150x147.stl

☐ Part 1 - Blues (front)

## Other files

### butterfly1\_part\_1\_describe.txt

☐ Filament swap description - Part 1

### butterfly1\_part\_2\_describe.txt

☐ Filament swap description - Part 2

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