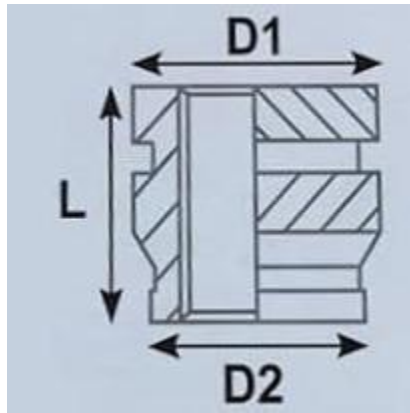
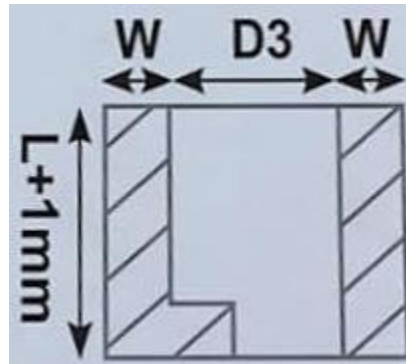


PART DESIGN FOR 3DP HEAT SET INSERT HEAT PRESSING MACHINE

The holes must be designed for the heat set insert size you are using. You need the hole diameter (D3) to be smaller than the knurled part of the inserts diameter (D1). The chart below gives the suggested dimensions for the inserts we stock in the kit. The depth of the hole should be 1mm deeper than the length (L) of the insert to account for expanding plastic. The solid walls surrounding the hole (W) should be a minimum thickness. Use a modifier in the BambuStudio software to make the area surrounding the hole print in solid infill.



Threaded Insert Dimensions



Hole with Wall Dimensions

Size	D1	D2	D3	W
M2	3.0	2.8	2.9	1.3
M2.5	4.0	3.2	3.3	1.6
M3	4.2	3.9	4.0	1.6
M4	5.0	4.6	4.7	2.1
M5	7.0	6.2	6.3	2.6
M6	8.0	7.2	7.3	2.6
1/4-20	8.0	7.2	7.3	2.6
M8	10	8.9	9.0	3.2

For more tips on 3D printing visit our website FAQ at BU.EDU/EPIC/3DP

For help with BambuStudio visit their website at WIKI.BAMBULAB.COM