

Printing Guide:

LeafLock

Please read the following pages carefully to get a successful first print on any printer

Bambu 3MF file + recommended settings included!

(erase what ever parts you don't need; duplicate the ones you need)

A Troubleshooting section is at the end of this file.



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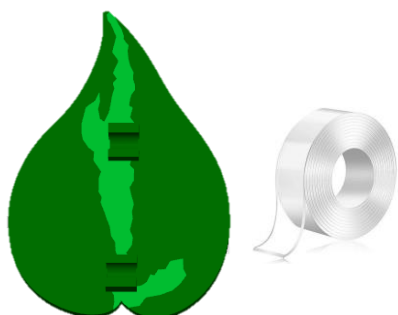
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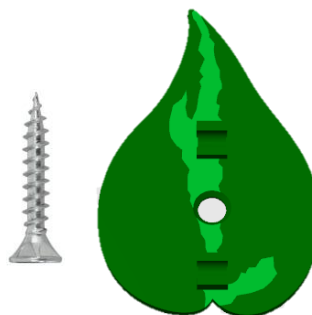
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Every leaf shape has 2 wall mount options:

double sided tape

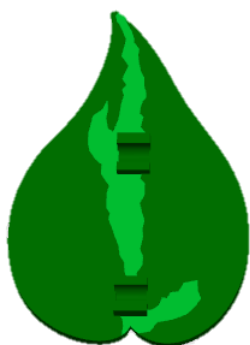


screws

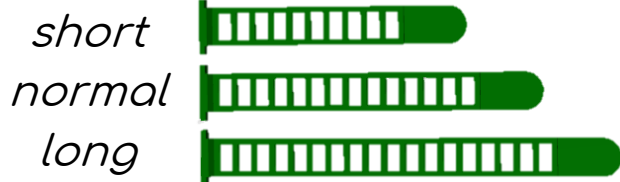


Just choose your leaf shape and select the
“fix” type + right accessory

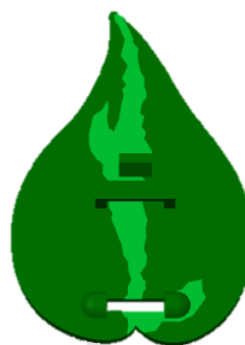
Clip



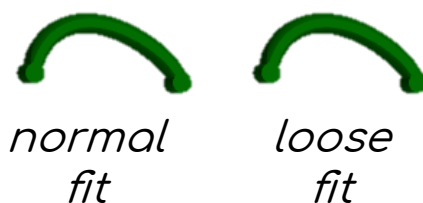
+



Cable



+



If you don't have a multi-material system you can use the "manual filament swap" files for the philodendron version. *Otherwise skip this page.*

- You should add a pause at the beginning of layer 6 (1,2mm)

I have added a Bambu/Orca 3MF file which already has this included!



If you need this for any other slicer, quickly search on Youtube "manual filament swap + *Your Slicer Name*"

This should be very easy to add in any software.

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General Settings:

Important, use a build plate with good adhesion like a clean PEI Plate, "SuperTack" (not for TPU!) or similar.

Recommended Leaf settings:

- Wall generator: "Arachne"
- Top layers min. 2, Bottom layers min. 5
- Top & bottom surface pattern "Concentric"
- Turn off supports
- Turn on "ironing"
 - Ironing pattern: Rectilinear
 - Ironing Linespacing: 0,1 mm
 - Ironing flow: $\approx 17\%$ (*filament dependent*)
 - Ironing speed: 40 mm/s

If you don't use ironing, use the monotonic top pattern!

Recommended Clip settings:

- Wall generator: "Arachne"
- 3 walls, 0% infill
- 3 top and bottom layers
- Top and bottom surface pattern "Concentric"
- Turn on "ironing" for the topmost layer
(*same settings as above*)

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Recommended Cable settings

- Use TPU shore hardness 95A or higher

Dry filament and flow calibration is important here

- Wall generator “Classic”

Don't have the right green TPU? Help with a green permanent marker.

Advanced users:

Leaf:

Use adaptive layer height upwards of the “leaf pattern” for better looking round shapes

To do this for multiple objects at once:

- Select all objects
 - Right click and merge
 - edit adaptive layer height how ever you want
 - You can also add the following ironing modifier for all models at once this way.
- Only add the ironing for the “leaf patter” with a height modifier from 0-1,5 mm, to save time.
 - Apply gap fill select “Top and Bottom surfaces” (Orca only)

Cable:

- Disable z-hop (bad with TPU)
- 0,39 mm linewidth on the first layer and all walls
- Use “print by object” (great for TPU)

If you have trouble with the overhangs on any of the models, try setting your fan speed to 100% and reduce the overhang and bridge speed.

Trouble Shooting:



My print is warping:

- 99% of the time this is due to bad bed adhesion /oil on the plate from you hands

-> Clean your bed with a fresh sponge and dish soap for 1 min. Then rinse it off with lots of warm water. Then don't touch the plate again.

The clip doesn't fit:

Print the "loose fit" version or make the clip just slightly smaller (0,1-0,2mm)

Some leaf part broke:

- Print warmer (+10°C) and slower (50-100 mm/s)

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Used Colors / Filament

I highly recommend using matte & pastel colors.
Here is what Filament I use for my pictures:

- [Matte Dark Green](#) -
- [Grass Green](#) -
- [Glow Green](#) -
- [Overture Green TPU](#) -

*Affiliate links included.
I may earn a small commission,
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Size Guide:

Printing at smaller sizes is not recommended.

Printing at **bigger sizes**:

This should work without any problems, just make sure to resize the clip/cabel parts accordingly.

You want more leaf variation?

play around with the different philodendron coloring options.

For example; one side half light green, the other dark green.



If you share you creation on Instagram, then tag me @factorian_designs and I will share your post as well.

Thank you for your support and happy printing !

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