

Perfectly Angled Fish

3D MODEL DESCRIPTION

Maybe being that deep in the ocean scrambles you up.

- This STL file is recommended for FDM Printers!
- 3D Printing Time Based on **Ender 3**: 01 Day 06 Hours 01 Minute (will vary accord to you printer model)
- Approximately Height: 9,0 cm
- You will need 6 **M3-20mm Screw** - [Amazon](#) / [Aliexpress](#)

3D PRINT FILE SETTINGS (FOR 0.4 MM NOZZLE)

- **Line Width/ Nozzle:** 0.4 mm
- **First Layer Line Width:** 0.48 mm / 120%
- **Average Speed:** 20mm/s (First Layer) / 50mm/s (All the other layers) | 20 mm/s (First Layer) / 500 mm/s (All the other layers on Bambu Lab)
- **Recommended Initial Layer Height:** 0.16 mm
- **Recommended Layer Height:** 0.16 mm
- **Recommended Perimeters/ Walls:** 3.
- **Recommended Infill (%):** 10% (Gyroid)
- **Needs Support:** No.
- **Build Plate Adhesion:** Brim.

The parameters above are recommendations made by our staff; if you prefer, you can adapt them according to your preferences.

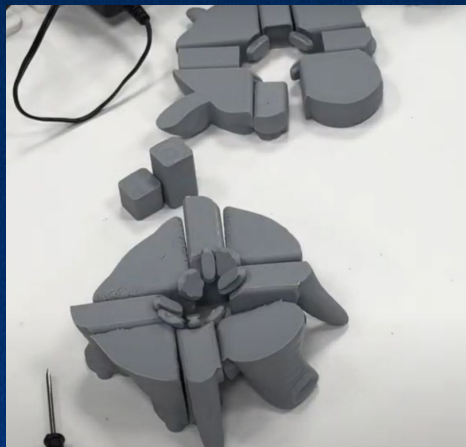
Happy Printing!

3D MODEL ASSEMBLY MECHANISM 3X3

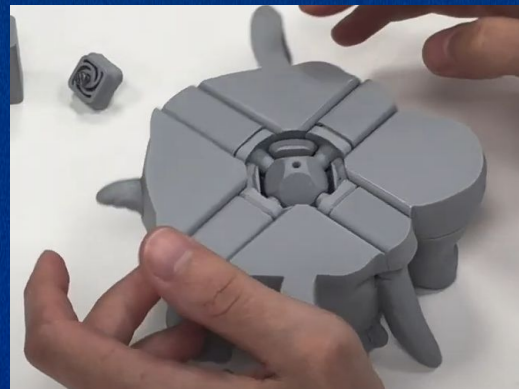
Set aside the Core piece, the Center pieces and the specified screws. Screw 5 Center pieces to the Core, leaving one without screws for easier assembly.



Organize the remaining pieces following the reference image to form the shape of the cube you chose.

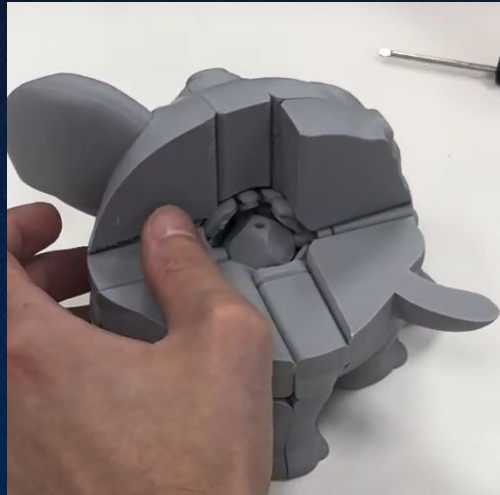


Fit the Edges inside the cube between the Centers, and the Corners between the Edges to form a base layer and a central layer.

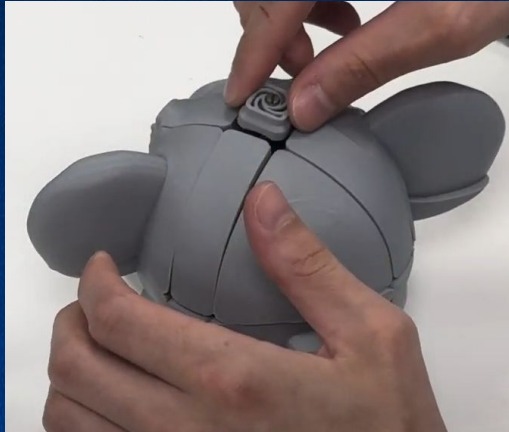


3D MODEL ASSEMBLY MECHANISM 3X3

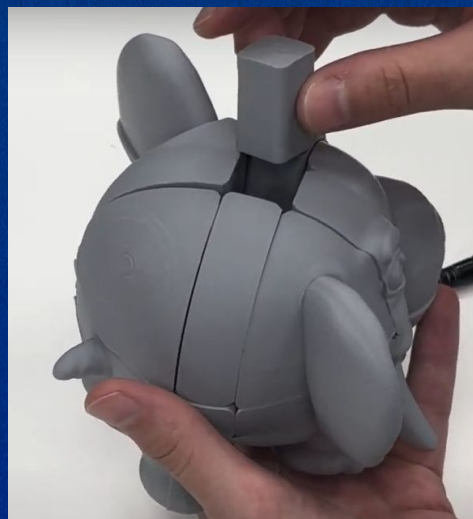
Turn the cube with the unscrewed side up and place the remaining Corners and Edges following the reference pictures. For easier finishing, leave an Edge to fit as the last step.



Screw the Center piece that was left unscrewed on step one to finish the mechanism assembly. Tight or loose the screws for better movement.



Lastly, fit the lids on their designed places, pressuring them against the cube.



3D MODEL ASSEMBLY

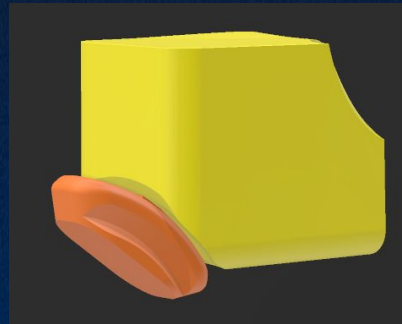
For the assembly of the **3x3 mechanism**, you'll need:

12x Edge Lock

6x Center

1x Core

Glue the 12 Edge Locks to the designed pieces, according to the following picture.



For the cube under the mechanism's assembly, set aside the parts for the inferior part. These are the ones names **A1_Bottom** up until **A9_Bottom**.



Then, set aside the center parts, which are the **A1_Center** to **A8_Center**.



Lastly, set aside the pieces that will form the top, which are A1_Top to A9_Top.

