

# 3D Printed Enclosure Guide

Brought to you by Soberton, Inc.

This information is to be taken as guidance only. For additional questions or concerns regarding 3D printed enclosures please contact [Bodhe@Soberton.com](mailto:Bodhe@Soberton.com).

We are providing these files so you can test our speakers in your prototype, on a bench, etc. The STL file is ready to print. You can also modify the design as you'd like by using the provided step file. The parts will perform best if printed with a powder (SLS, MJF) or resin-based (SLA) system. They will work with a filament-based (FDM) system as well. If using a filament-based system, we recommend you use soluble support if available.

Most enclosures have a locating flange on both sides as well as a wider flange used to secure the enclosure in place with screws.

There are several different styles of enclosures we provide depending on the part. Most have a slip fit for the speaker to sit in the enclosure. Because all 3D printers have different tolerances, we can't guarantee a perfect press fit. Therefore, the holes are slightly oversized to make sure the speakers fit even if your print comes out undersized. We recommend a dab of glue to secure your speaker if it sits too loosely in the enclosure. In the case of speakers with double sided tape, just peel the liner and stick your speaker to the underside of the top lid. This is all explained in the "how to assemble" document that will download with your geometry file.

## Frequently Asked Questions

How do I get my part 3D printed?

- Does your company have a 3D printer?
  - If so, simply give the person in charge of the printer the STL file and tell them the units are in millimeters.
  - If not, we recommend you contact a service bureau such as Protolabs to get your part printed.

Can I edit the STL before printing?

- STL files are difficult to edit. We provide you the step file in addition to the STL should you like to make changes before printing.

What settings should I use for my filament based (FDM) printer?

- If using non-soluble support, we recommend a maximum .2mm (.008") layer height printed at a 45° angle if your part has overhangs. A .1mm (.004") layer height will work even better.
- If using soluble support, .2mm (.008") up to .4mm (.016") layer height will give good results when printed vertically.