



About STEMFIE Essentials

👉 stemfie.org/essentials 👉

This ZIP file contains various commonly used STEMFIE parts in different sizes nestled into compact build plates measuring less than 140x140x140 mm (5 ½ inches squared), which fits comfortably in most 3D printers' build volume.

Start by importing each .3mf file into your 3D printer's slicing software. All components are oriented to 3D-print optimally **without support structures**. Please ensure a flat, clean build plate and calibrate it well.

I recommend PLA or PETG material for making STEMFIE parts. Your slicer's default medium print settings will yield good results. In addition, the following printing settings are good references for printing STEMFIE parts.

- **Material:** PLA filament
- **Layer height:** 0.2 mm
- **Perimeters (shells):** 3
- **Top solid layer count:** 4
- **Bottom solid layer count:** 3
- **Infill:** 15%
- **Generic print speed:** 50 mm/s
- **No support structures**

For more information about the STEMFIE project and to download the complete range of parts, please visit <https://stemfie.org/download>. Please follow STEMFIE on [X.com/Stemfie3D](https://www.x.com/Stemfie3D), [Instagram.com/Stemfie3D](https://www.instagram.com/Stemfie3D), [Facebook.com/Stemfie3D](https://www.facebook.com/Stemfie3D) and [Telegram](https://www.telegram.com).

STEMFIE is a **free and open-source** educational toy! So have fun 3D-printing lots of parts and inventing your project builds!

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