

## 8. 3D Print the Exoskeleton parts: Doors

---

T [teslarcs.com/assembly-manuals/cybertruck/4-13-3d-print-the-cybertruck-parts/8-3d-print-the-exoskeleton-parts-doors/](https://teslarcs.com/assembly-manuals/cybertruck/4-13-3d-print-the-cybertruck-parts/8-3d-print-the-exoskeleton-parts-doors/)



Difficulty

**Moderate**



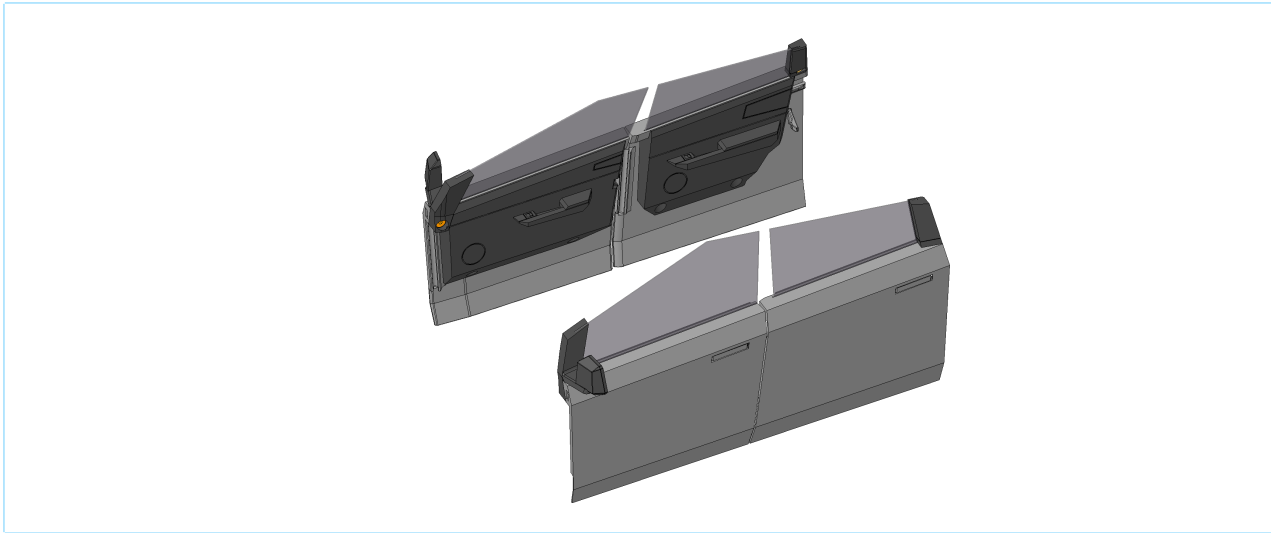
Steps

9



Get entire manual as PDF

Downloading soon



### **Step 1: Important information!**

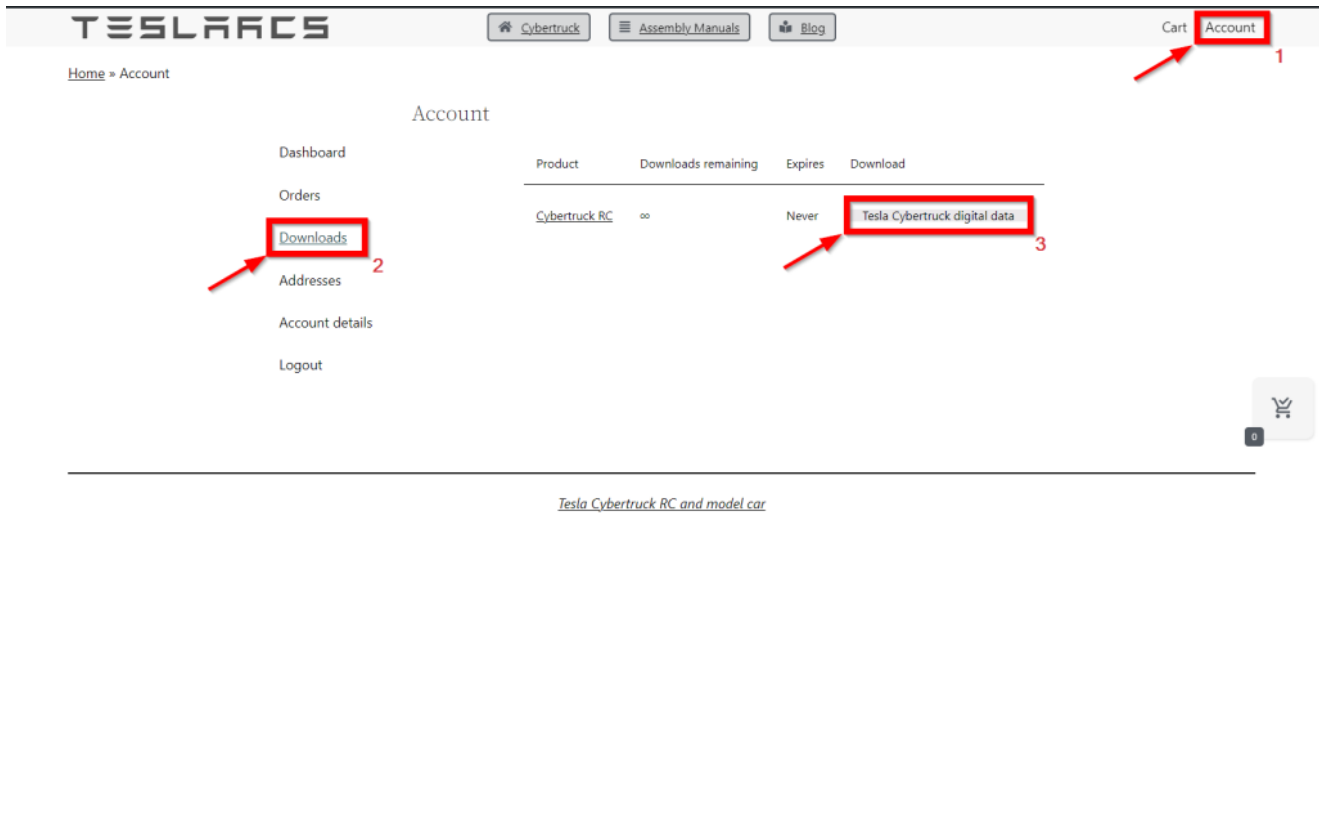
---

#### **Important Information / Downloadable Files:**

If you purchased the Cybertruck digital data from our [Shop](#) than you will be able to download from your [Account](#):

- All **.stl** files,  
(which contain the Cybertruck 3D geometry),
- PrusaSilcer **.3mf** files,  
(which contain the 3D Printing orientations and printing settings),

- and **.gcode** files for *Prusa Mini* and *Prusa Mk3S+*.  
(which contain the necessary information for the 3D printer to print the geometry)



### Important Information / Slicer software:

Our suggestion for 3D Printing slicer software:

The Freeware Prusa Slicer last stable version: <https://help.prusa3d.com/downloads>

*Alternative 3D Printing slicer:*

Any other slicer what you like, but than you should check the basic 3D Printing parameters from our manual in this and the next chapter.

### Important Information / 3D Printer:

Our suggestion for 3D Printer:

Prusa Mk3s+: <https://www.prusa3d.com/product/original-prusa-i3-mk3s-kit-3>

*Alternative 3D Printer:*

- Prusa Mini: <https://www.prusa3d.com/product/original-prusa-mini-kit-2/>
- Any other FDM 3D Printer, with 180×180 build plate at least



## Step 2: EX\_DOOR\_HANDLE

---

### Printing files:

- 2X EX\_DOOR\_HANDLE\_L
- 2X EX\_DOOR\_HANDLE\_R

### Printing parameters:

- **Filament material:** PLA
- **Color:** Silver ●

- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 2 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 2 piece

Print settings for Prusa Mini printer:

Feature type	Time	Percentage	Used filament
Perimeter	2m	18.5%	0.16 m 0.47 g
External perimeter	4m	30.8%	0.17 m 0.52 g
Internal infill	47s	6.0%	0.04 m 0.11 g
Solid infill	4m	32.2%	0.19 m 0.56 g
Top solid infill	37s	4.8%	0.03 m 0.07 g
Bridge infill	21s	2.8%	0.01 m 0.04 g
Skirt/brim	17s	2.3%	0.02 m 0.05 g
Custom	20s	2.6%	0.02 m 0.05 g

Estimated printing times:  
First layer: 1m  
Total: 13m

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa MINI & MINI+  
Supports: None  
Infill: 15%  
Brim:

Name	Editing
ex_door_handle_l_v1	
Instance 1	
Instance 2	
ex_door_handle_r_v1	
Instance 1	
Instance 2	

Group manipulation

	X	Y	Z	mm
Translate	0	0	0	
Rotate	0	0	0	°
Scale	100	100	100	%
Size	59.75	22.74	3.23	mm

Sliced Info  
Used Filament (g) 1.87 (202.87)  
Used Filament (m) 0.63  
Used Filament (mm<sup>3</sup>) 1507.14  
Cost 0.07  
Estimated printing time: 13m  
- normal mode  
- stealth mode

Print settings for Prusa i3 MK3 printer:

Feature type	Time	Percentage	Used filament
Perimeter	2m	17.0%	0.16 m 0.47 g
External perimeter	5m	34.0%	0.17 m 0.52 g
Internal infill	50s	6.9%	0.04 m 0.11 g
Solid infill	4m	31.7%	0.19 m 0.56 g
Top solid infill	39s	4.8%	0.03 m 0.07 g
Bridge infill	22s	2.7%	0.01 m 0.04 g
Skirt/brim	16s	2.0%	0.02 m 0.05 g
Custom	14s	1.7%	0.02 m 0.05 g

Estimated printing times:  
First layer: 1m  
Total: 14m

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa i3 MK3S & MK3S+  
Supports: None  
Infill: 15%  
Brim:

Name	Editing
ex_door_handle_l_v1	
Instance 1	
Instance 2	
ex_door_handle_r_v1	
Instance 1	
Instance 2	

Sliced Info  
Used Filament (g) 1.88 (202.88)  
Used Filament (m) 0.63  
Used Filament (mm<sup>3</sup>) 1515.56  
Cost 0.07  
Estimated printing time: 14m  
- normal mode  
- stealth mode

## **Step 3: EX\_FRONT\_DOOR\_PANEL**

---

### **Printing files:**

- 1X EX\_FRONT\_DOOR\_PANEL\_L
- 1X EX\_FRONT\_DOOR\_PANEL\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Black 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 59 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

Print settings for Prusa Mini:

Feature type	Time	Percentage	Used filament
Perimeter	1h22m	24.1%	6.27 m 18.71 g
External perimeter	2h0m	35.2%	6.60 m 19.68 g
Overhang perimeter	15s	0.1%	0.01 m 0.03 g
Internal infill	1h8m	19.9%	3.40 m 10.15 g
Solid infill	48m	14.1%	2.49 m 7.44 g
Top solid infill	14m	4.2%	0.62 m 1.86 g
Bridge infill	8m	2.3%	0.33 m 1.00 g
Skirt/Brim	20s	0.1%	0.02 m 0.05 g
Custom	20s	0.1%	0.02 m 0.05 g

Estimated printing times:  
First layer: 3m  
Total: 5h42m

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa MINI & MINI+  
Supports: None  
Infill: 15%  
Brim:

Sliced Info:  
Used Filament (g) (including spool): 58.98 (259.98)  
Used Filament (m): 19.77  
Used Filament (mm<sup>3</sup>): 47561.81  
Cost: 2.14  
Estimated printing time: - normal mode: 5h42m

Print settings for Prusa i3 MK3:

Feature type	Time	Percentage	Used filament
Perimeter	1h17m	21.3%	6.27 m 18.71 g
External perimeter	2h20m	38.6%	6.60 m 19.68 g
Overhang perimeter	16s	0.1%	0.01 m 0.03 g
Internal infill	1h11m	19.6%	3.40 m 10.15 g
Solid infill	51m	14.1%	2.49 m 7.44 g
Top solid infill	15m	4.1%	0.62 m 1.86 g
Bridge infill	8m	2.2%	0.33 m 1.00 g
Skirt/Brim	19s	0.1%	0.02 m 0.05 g
Custom	13s	0.1%	0.02 m 0.05 g

Estimated printing times (Normal mode):  
First layer: 2m  
Total: 6h3m  
[Show stealth mode](#)

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa i3 MK3S & MK3S+  
Supports: None  
Infill: 15%  
Brim:

Sliced Info:  
Used Filament (g) (including spool): 58.99 (259.99)  
Used Filament (m): 19.78  
Used Filament (mm<sup>3</sup>): 47570.22  
Cost: 2.14  
Estimated printing time: - normal mode: 6h3m  
- stealth mode: 6h3m

## **Step 4: EX\_SIDE\_MIRROR and EX\_A2\_PILLAR\_SUPPORT**

---

### **Printing files:**

- 1X EX\_SIDE\_MIRROR\_L
- 1X EX\_SIDE\_MIRROR\_R
- 1X EX\_A2\_PILLAR\_SUPPORT\_L
- 1X EX\_A2\_PILLAR\_SUPPORT\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Black 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 8 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 4 x 1 piece

PrusaSlicer 2.5.0 based on Slic3r

Print settings: Simple Advanced Expert

Print settings: 0.20mm QUALITY (modified)

Filament: Prusament PLA

Printer: Original Prusa MINI & MINI+

Supports: None

Infill: 15% Brim:

Name	Editing
ex_side_mirror_l_v1	<input type="checkbox"/>
ex_side_mirror_r_v1	<input type="checkbox"/>
ex_x2_pillar_support_L_v1	<input type="checkbox"/>
ex_x2_pillar_support_r_v1	<input type="checkbox"/>

Group manipulation

	X	Y	Z	
Translate:	0	0	0	mm
Rotate:	0	0	0	°
Scale:	100	100	100	%
Size:	67.1	66.89	11.27	mm

Sliced Info

Used Filament (g) 7.63 (208.63)  
 (including spool)

Used Filament (m) 2.56

Used Filament (mm<sup>3</sup>) 6149.90

Cost 0.28

Estimated printing time:  
 - normal mode 51m

Export G-code

Feature type Time Percentage Used filament

Perimeter	10m	20.1%	0.57 m 1.71 g
External perimeter	15m	25.6%	0.78 m 2.34 g
Overhang perimeter	3s	0.1%	0.00 m 0.01 g
Internal infill	5m	10.5%	0.27 m 0.79 g
Solid infill	15m	28.6%	0.68 m 2.03 g
Top solid infill	2m	4.5%	0.10 m 0.31 g
Bridge infill	3m	5.9%	0.11 m 0.32 g
Skirt/Brim	25s	0.8%	0.02 m 0.06 g
Custom	20s	0.7%	0.02 m 0.05 g

Estimated printing times:

First layer: 2m  
 Total: 51m

View Feature type Show Options

59138

PrusaSlicer 2.5.0 based on Slic3r

Print settings: Simple Advanced Expert

Print settings: 0.20mm QUALITY (modified)

Filament: Prusament PLA

Printer: Original Prusa i3 MK3S & MK3S+

Supports: None

Infill: 15% Brim:

Name	Editing
ex_side_mirror_l_v1	<input type="checkbox"/>
ex_side_mirror_r_v1	<input type="checkbox"/>
ex_x2_pillar_support_L_v1	<input type="checkbox"/>
ex_x2_pillar_support_r_v1	<input type="checkbox"/>

Sliced Info

Used Filament (g) 7.64 (208.64)  
 (including spool)

Used Filament (m) 2.56

Used Filament (mm<sup>3</sup>) 6158.32

Cost 0.28

Estimated printing time:  
 - normal mode 55m  
 - stealth mode 55m

Export G-code

Feature type Time Percentage Used filament

Perimeter	10m	18.5%	0.57 m 1.71 g
External perimeter	18m	32.2%	0.78 m 2.34 g
Overhang perimeter	3s	0.1%	0.00 m 0.01 g
Internal infill	6m	10.5%	0.27 m 0.79 g
Solid infill	16m	28.4%	0.68 m 2.03 g
Top solid infill	2m	4.3%	0.10 m 0.31 g
Bridge infill	3m	4.8%	0.11 m 0.32 g
Skirt/Brim	23s	0.7%	0.02 m 0.06 g
Custom	13s	0.4%	0.02 m 0.06 g

Estimated printing times:

First layer: 2m  
 Total: 55m

View Feature type Show Options

60351



## **Step 5: EX\_SIDE\_MIRROR\_GLASS**

---

### **Printing files:**

- 1X EX\_SIDE\_MIRROR\_GLASS\_L
- 1X EX\_SIDE\_MIRROR\_GLASS\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Transparent   
(Alternative: White )
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 1 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

Print settings for PrusaSlicer 2.5.0 based on Slic3r. The interface shows a 3D model of a Prusa Mini case with a grid overlay. The print settings are configured for Prusament PLA filament on an Original Prusa MINI & MINI+ printer. The print quality is set to 0.20mm. The estimated printing time is 3m.

Feature type	Time	Percentage	Used filament
Perimeter	15s	8.4%	0.02 m 0.05 g
External perimeter	22s	12.3%	0.02 m 0.05 g
Solid infill	1m	43.3%	0.08 m 0.25 g
Top solid infill	22s	12.2%	0.02 m 0.06 g
Skirt/brim	22s	12.4%	0.02 m 0.06 g
Custom	20s	11.4%	0.02 m 0.05 g

Estimated printing times:  
First layer: 1m  
Total: 3m

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa MINI & MINI+  
Supports: None  
Infill: 15%  
Brim:

Name	Editing
ex_side_mirror_glass_l_v1	<input type="checkbox"/>
ex_side_mirror_glass_r_v1	<input type="checkbox"/>

Sliced Info:  
Used Filament (g) (including spool): 0.52 (201.53)  
Used Filament (m): 0.18  
Used Filament (mm<sup>3</sup>): 421.66  
Cost: 0.02  
Estimated printing time:  
- normal mode: 3m

Export G-code

Print settings for PrusaSlicer 2.5.0 based on Slic3r. The interface shows a 3D model of a Prusa i3 Mk3 case with a grid overlay. The print settings are configured for Prusament PLA filament on an Original Prusa i3 MK3S & MK3S+ printer. The print quality is set to 0.20mm. The estimated printing time is 3m.

Feature type	Time	Percentage	Used filament
Perimeter	14s	8.2%	0.02 m 0.05 g
External perimeter	25s	14.6%	0.02 m 0.05 g
Solid infill	1m	44.8%	0.08 m 0.25 g
Top solid infill	22s	12.6%	0.02 m 0.06 g
Skirt/brim	21s	11.9%	0.02 m 0.06 g
Custom	13s	7.9%	0.02 m 0.06 g

Estimated printing times:  
First layer: 1m  
Total: 3m

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa i3 MK3S & MK3S+  
Supports: None  
Infill: 15%  
Brim:

Name	Editing
ex_side_mirror_glass_l_v1	<input type="checkbox"/>
ex_side_mirror_glass_r_v1	<input type="checkbox"/>

Sliced Info:  
Used Filament (g) (including spool): 0.53 (201.53)  
Used Filament (m): 0.18  
Used Filament (mm<sup>3</sup>): 430.08  
Cost: 0.02  
Estimated printing time:  
- normal mode: 3m  
- stealth mode: 3m

Export G-code

## **Step 6: EX\_FRONT\_DOOR**

---

### **Printing files:**

- 1X EX\_FRONT\_DOOR\_L
- 1X EX\_FRONT\_DOOR\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Silver 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 66 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

Print settings for PrusaSlicer 2.5.0 based on Slic3r. The interface shows a 3D model of a door component on a Prusa Mini printer bed. The print settings are configured for 0.20mm QUALITY (modified) using Prusament PLA filament on an Original Prusa Mini & MINI+ printer. The estimated printing time is 6h14m.

Feature type	Time	Percentage	Used filament
Perimeter	1h34m	25.1%	7.12 m 21.25 g
External perimeter	2h21m	37.7%	7.45 m 22.23 g
Overhang perimeter	21s	0.1%	0.02 m 0.05 g
Internal infill	1h21m	21.7%	4.55 m 13.58 g
Solid infill	42m	11.2%	2.22 m 6.62 g
Top solid infill	8m	2.0%	0.32 m 0.96 g
Bridge infill	7m	1.9%	0.31 m 0.91 g
Skirt/Brim	33s	0.2%	0.03 m 0.09 g
Custom	21s	0.1%	0.02 m 0.05 g

Estimated printing times:  
First layer: 5m  
Total: 6h14m

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa Mini & MINI+  
Supports: None  
Infill: 15%  
Brim:

Name	Editing
ex_front_door_Lv1	
ex_front_door_rv1	

Group manipulation

	X	Y	Z	
Translate:	0	0	0	mm
Rotate:	0	0	0	°
Scale:	100	100	100	%
Size:	37.2	124.49	87.93	mm

Sliced Info  
Used Filament (g) (including spool): 65.75 (266.75)  
Used Filament (m): 22.04  
Used Filament (mm<sup>3</sup>): 53022.17  
Cost: 2.39  
Estimated printing time:  
- normal mode: 6h14m  
- stealth mode: 6h20m

Export G-code

Print settings for PrusaSlicer 2.5.0 based on Slic3r. The interface shows a 3D model of a door component on a Prusa i3 MK3 printer bed. The print settings are configured for 0.20mm QUALITY (modified) using Prusament PLA filament on an Original Prusa i3 MK3S & MK3S+ printer. The estimated printing time is 6h33m in normal mode and 6h40m in stealth mode.

Feature type	Time	Percentage	Used filament
Perimeter	1h27m	22.1%	7.12 m 21.25 g
External perimeter	2h45m	41.9%	7.45 m 22.23 g
Overhang perimeter	21s	0.1%	0.02 m 0.05 g
Internal infill	1h22m	20.9%	4.55 m 13.58 g
Solid infill	44m	11.1%	2.22 m 6.62 g
Top solid infill	8m	2.0%	0.32 m 0.96 g
Bridge infill	7m	1.8%	0.31 m 0.91 g
Skirt/Brim	31s	0.1%	0.05 m 0.09 g
Custom	13s	0.1%	0.02 m 0.06 g

Estimated printing times (Normal mode):  
First layer: 5m  
Total: 6h33m  
[Show stealth mode](#)

Print settings:  
Print settings: 0.20mm QUALITY (modified)  
Filament: Prusament PLA  
Printer: Original Prusa i3 MK3S & MK3S+  
Supports: None  
Infill: 15%  
Brim:

Name	Editing
ex_front_door_Lv1	
ex_front_door_rv1	

Sliced Info  
Used Filament (g) (including spool): 65.76 (266.76)  
Used Filament (m): 22.05  
Used Filament (mm<sup>3</sup>): 53030.59  
Cost: 2.39  
Estimated printing time:  
- normal mode: 6h33m  
- stealth mode: 6h40m

Export G-code

## **Step 7: EX\_REAR\_DOOR\_PANEL**

---

### **Printing files:**

- 1X EX\_REAR\_DOOR\_PANEL\_L
- 1X EX\_REAR\_DOOR\_PANEL\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Black 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 49 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

Print settings for PrusaMini printer:

Feature type	Time	Percentage	Used filament
Perimeter	1h13m	24.4%	5.12 m 15.28 g
External perimeter	1h39m	32.9%	5.15 m 15.36 g
Overhang perimeter	15s	0.1%	0.01 m 0.03 g
Internal infill	1h8m	22.6%	3.30 m 9.84 g
Solid infill	48m	15.9%	2.28 m 6.80 g
Top solid infill	6m	2.1%	0.27 m 0.81 g
Bridge infill	5m	1.8%	0.21 m 0.64 g
Skirt/Brim	19s	0.1%	0.02 m 0.05 g
Custom	21s	0.1%	0.02 m 0.05 g

Estimated printing times:  
 First layer: 3m  
 Total: 5h0m

Print settings:  
 Print settings: 0.20mm QUALITY (modified)  
 Filament: Prusament PLA  
 Printer: Original Prusa MINI & MINI+  
 Supports: None  
 Infill: 15%  
 Brims:

Sliced Info:  
 Used Filament (g) 48.87 (249.87)  
 Used Filament (m) 16.39  
 Used Filament (mm<sup>3</sup>) 39413.09  
 Cost 1.77  
 Estimated printing time: - normal mode 5h0m

Print settings for Prusa i3 MK3 printer:

Feature type	Time	Percentage	Used filament
Perimeter	1h0m	21.7%	5.12 m 15.28 g
External perimeter	1h54m	36.0%	5.15 m 15.36 g
Overhang perimeter	15s	0.1%	0.01 m 0.03 g
Internal infill	1h11m	22.4%	3.30 m 9.84 g
Solid infill	51m	15.9%	2.28 m 6.80 g
Top solid infill	7m	2.1%	0.27 m 0.81 g
Bridge infill	5m	1.7%	0.21 m 0.64 g
Skirt/Brim	18s	0.1%	0.02 m 0.05 g
Custom	14s	0.1%	0.02 m 0.05 g

Estimated printing times (Normal mode):  
 First layer: 3m  
 Total: 5h17m  
 Show stealth mode

Print settings:  
 Print settings: 0.20mm QUALITY (modified)  
 Filament: Prusament PLA  
 Printer: Original Prusa i3 MK3S & MK3S+  
 Supports: None  
 Infill: 15%  
 Brims:

Group manipulation:  
 Translate: X: 0, Y: 0, Z: 0 mm  
 Rotate: X: 0, Y: 0, Z: 0 °  
 Scale: X: 100, Y: 100, Z: 100 %  
 Size: 46.23 x 79.04 x 84.76 mm

Sliced Info:  
 Used Filament (g) 48.88 (249.88)  
 Used Filament (m) 16.39  
 Used Filament (mm<sup>3</sup>) 39421.50  
 Cost 1.77  
 Estimated printing time: - normal mode 5h17m  
 - stealth mode 5h19m

## **Step 8: EX\_REAR\_DOOR**

---

### **Printing files:**

- 1X EX\_REAR\_DOOR\_L
- 1X EX\_REAR\_DOOR\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Silver 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 68 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

Print settings for PrusaSlicer 2.5.0 based on Slic3r. The interface shows a 3D model of a door assembly on a black base labeled "ORIGINAL PRUSA MINI". The print settings are configured for a Prusament PLA filament on an Original Prusa MINI & MINI+ printer. The print quality is set to 0.20mm QUALITY (modified). The infill is set to 15%. The estimated printing time is 6h27m.

Feature type	Time	Percentage	Used filament
Perimeter	1h42m	26.4%	7.35 m 21.92 g
External perimeter	2h24m	37.2%	7.69 m 22.93 g
Overhang perimeter	19s	0.1%	0.02 m 0.05 g
Internal infill	1h28m	22.6%	4.84 m 14.43 g
Solid infill	39m	10.0%	2.02 m 6.02 g
Top solid infill	8m	2.1%	0.33 m 0.99 g
Bridge infill	6m	1.5%	0.25 m 0.75 g
Skirt/Brim	30s	0.1%	0.03 m 0.08 g
Custom	21s	0.1%	0.02 m 0.05 g

Name	Editing
ex_rear_door_lv1	
ex_rear_door_r_v1	

World coordinates	X	Y	Z	mm
Position:	101.85	89.02	44.03	
Rotate:	0	0	0	°

Scale factors	X	Y	Z	%
Size:	100	100	100	
Inches:	14.8	122.5	93.93	mm

Info: Size: 14.80 x 122.50 x 93.93 Volume: 38167.89  
 Facets: 13468 (1 shell)  
 No errors detected

Sliced Info: Used Filament (g) 67.23 (268.23)  
 Used Filament (m) 22.54  
 Used Filament (mm<sup>3</sup>) 54217.27  
 Cost 2.44  
 Estimated printing time: - normal mode 6h27m

Print settings for PrusaSlicer 2.5.0 based on Slic3r. The interface shows a 3D model of a door assembly on a black base labeled "ORIGINAL PRUSA i3 MK3 by Josef Prusa". The print settings are configured for a Prusament PLA filament on an Original Prusa i3 MK3S & MK3S+ printer. The print quality is set to 0.20mm QUALITY (modified). The infill is set to 15%. The estimated printing time is 6h48m in normal mode and 6h55m in stealth mode.

Feature type	Time	Percentage	Used filament
Perimeter	1h35m	23.2%	7.35 m 21.92 g
External perimeter	2h49m	41.5%	7.69 m 22.93 g
Overhang perimeter	19s	0.1%	0.02 m 0.05 g
Internal infill	1h29m	21.8%	4.84 m 14.43 g
Solid infill	40m	9.8%	2.02 m 6.02 g
Top solid infill	8m	2.0%	0.33 m 0.99 g
Bridge infill	6m	1.5%	0.25 m 0.75 g
Skirt/Brim	28s	0.1%	0.03 m 0.08 g
Custom	14s	0.1%	0.02 m 0.06 g

Name	Editing
ex_rear_door_lv1	
ex_rear_door_r_v1	

World coordinates	X	Y	Z	mm
Translate:	0	0	0	
Rotate:	0	0	0	°

Scale factors	X	Y	Z	%
Size:	100	100	100	
Inches:	38.91	124.33	93.93	mm

Info: Size: 38.91 x 124.33 x 93.93 Volume: 38167.89  
 Facets: 13468 (1 shell)  
 No errors detected

Sliced Info: Used Filament (g) 67.24 (268.24)  
 Used Filament (m) 22.54  
 Used Filament (mm<sup>3</sup>) 54225.69  
 Cost 2.44  
 Estimated printing time: - normal mode 6h48m  
 - stealth mode 6h55m

## **Step 9: EX\_C\_PILLAR\_SUPPORT**

---

### **Printing files:**

- 1X EX\_C\_PILLAR\_SUPPORT\_L
- 1X EX\_C\_PILLAR\_SUPPORT\_R

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Black 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 4 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

Print settings: 0.20mm QUALITY (modified)  
 Filament: Prusament PLA  
 Printer: Original Prusa MINI & MINI+  
 Supports: None  
 Infill: 15%  
 Brims:

Name	Editing
ex_c_pillar_support_r_v1	
ex_c_pillar_support_l_v1	

**Sliced Info**  
 Used Filament (g) 3.14 (204.14)  
 Used Filament (m) 1.05  
 Used Filament (mm<sup>3</sup>) 2532.46  
 Cost 0.11  
 Estimated printing time: - normal mode 22m

Export G-code

Feature type	Time	Percentage	Used filament
Perimeter	5m	24.1%	0.27 m 0.81 g
External perimeter	7m	31.0%	0.32 m 0.95 g
Overhang perimeter	1s	0.1%	0.00 m 0.00 g
Internal infill	2m	9.9%	0.10 m 0.30 g
Solid infill	5m	24.0%	0.26 m 0.78 g
Top solid infill	1m	4.6%	0.04 m 0.11 g
Bridge infill	38s	2.9%	0.03 m 0.08 g
Skirt/Brim	23s	1.8%	0.02 m 0.06 g
Custom	20s	1.6%	0.02 m 0.05 g

Estimated printing times:  
 First layer: 1m  
 Total: 22m

Print settings: 0.20mm QUALITY (modified)  
 Filament: Prusament PLA  
 Printer: Original Prusa i3 MK3S & MK3S+  
 Supports: None  
 Infill: 15%  
 Brims:

Name	Editing
ex_c_pillar_support_r_v1	

**Sliced Info**  
 Used Filament (g) 3.14 (204.14)  
 Used Filament (m) 1.05  
 Used Filament (mm<sup>3</sup>) 2532.46  
 Cost 0.11  
 Estimated printing time: - normal mode 22m

Export G-code

Feature type	Time	Percentage	Used filament
Perimeter	6m	23.3%	0.27 m 0.81 g
External perimeter	8m	33.3%	0.32 m 0.95 g
Overhang perimeter	1s	0.1%	0.00 m 0.00 g
Internal infill	2m	9.8%	0.10 m 0.30 g
Solid infill	6m	23.5%	0.26 m 0.78 g
Top solid infill	1m	4.6%	0.04 m 0.11 g
Bridge infill	39s	2.8%	0.03 m 0.08 g
Skirt/Brim	22s	1.6%	0.02 m 0.06 g
Custom	13s	1.0%	0.02 m 0.06 g

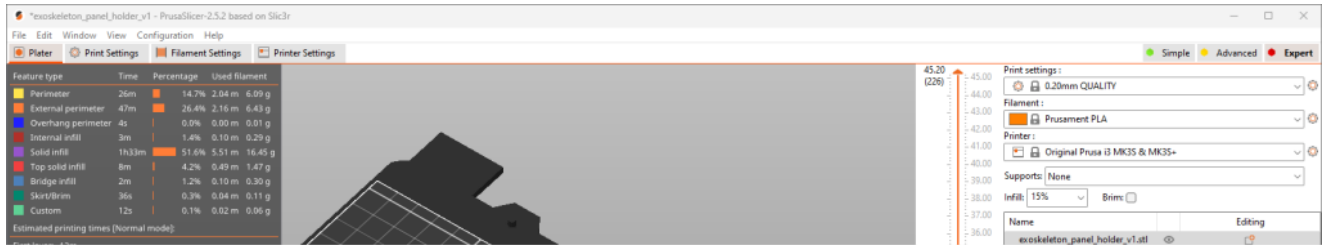
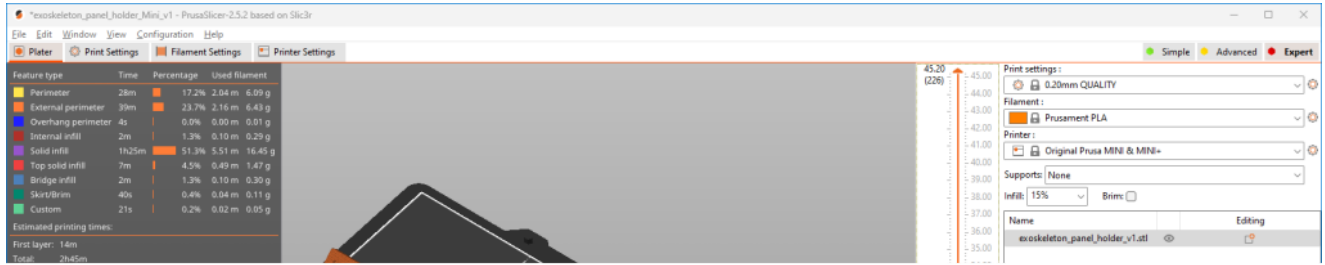
Estimated printing times:  
 First layer: 1m

## **Step 10: EX Panel Holder**

---

### **Printing parameters:**

- **Filament material:** PLA
- **Color:** Black 
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 32 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 1 piece



## Step 11: EX\_Panel\_Text

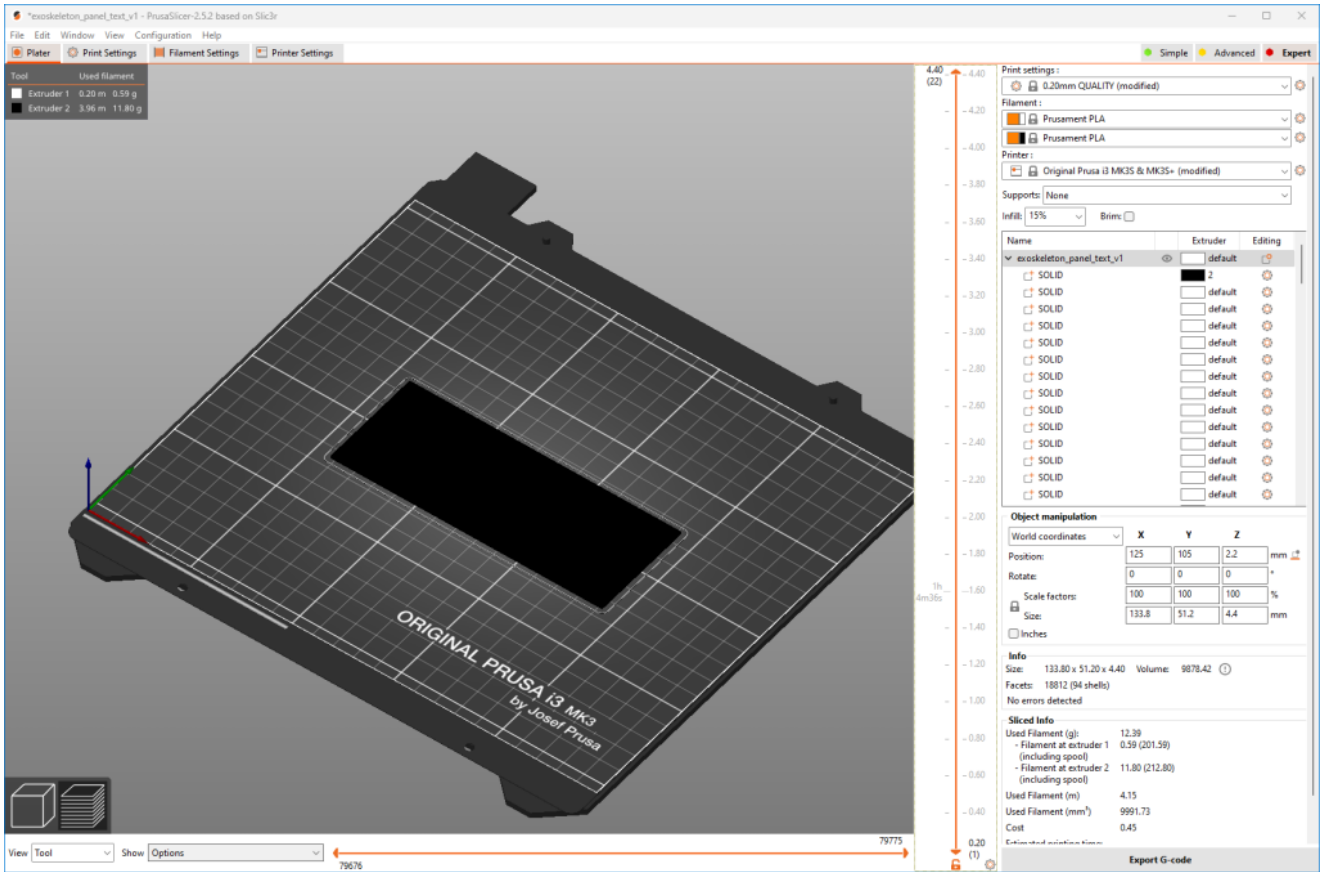
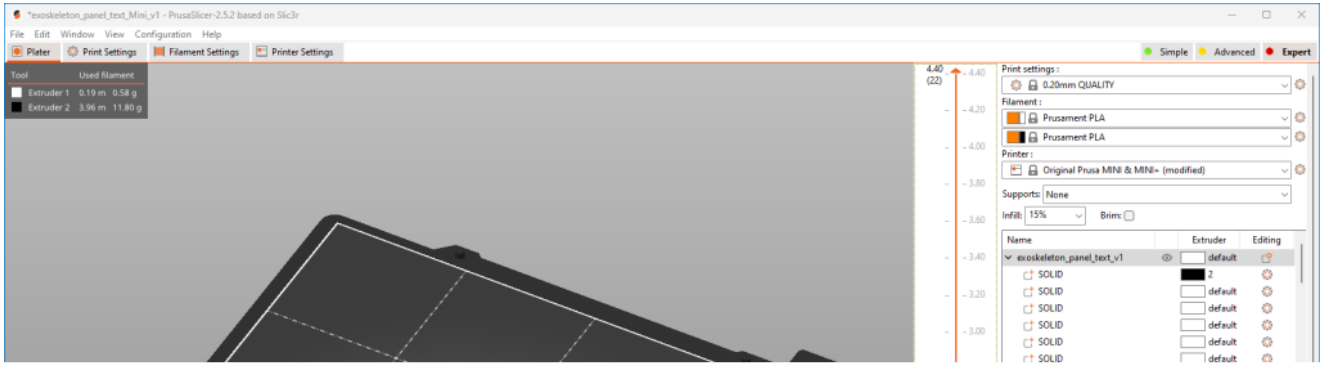
## Printing parameters:

- **Filament material:** PLA
- **Color:** Black and White
- **Layer height:** 0,2 mm
- **Support:** no
- **Infill:** 15%
  
- **Filament weight:** ca. 13 g
- **Prusa Mini compatible:** Yes
- **Quantity:** 2 x 1 piece

## Multi-Color Printing:

- 1. Layer: 0 – 0,2mm: White →Filament change to Black
- 2. Layer: 0,2 – 0,4 mm: Black →Filament change to White
- 3. Layer: 0,4 – 0,6 mm: White →Filament change to Black
- Other layers: Black

**Use the downloaded .3mf, or .gcode files for the proper multi color settings!**



## 2 responses to “8. 3D Print the Exoskeleton parts: Doors”

1. I think there is a typo in EX\_Panel\_Text.  
RDW should become RWD.

Is it also possible to make the text a little wider or bolder. Not everything is equally readable with me.

[Log in to Reply](#)

Ooooh. You are absolutely right! It will be fixed soon.

[Log in to Reply](#)

## Leave a Reply

---

You must be [logged in](#) to post a comment.

By continuing to browse this site, you agree to our [use of cookies](#).