

Printing tips (General)

- Print core and mold/flap separately
- Assemble by hammering the core into the flaps
- Print using brim for better bed adhesion
- Do not use rafts or skirts
- Use a slow feed rate and tune starting from 25-30 mm/sec
- Avoid fast printing or changing printing speeds
- Disable retraction
- Add as many wall perimeters as possible for stronger pieces

	Main Material	Core
TPU Flap (OpenFlap)	TPU	PLA or PETG
Silicone Flap (OpenMold)	TPU (for mold)	PLA or PETG
Silicone Wheel (OpenMold)	PLA or PETG (for mold)	PLA or PETG

See [☰ OpenFlap/Mold Ordering Resources](#) for recommended filament!