

STELLA-1.2 3D print parts - Main								
Ver		20251012						
Line	Required, Recommended, Optional	Item	Filename	Printer settings	Filament Mass, g	Print time, h	Color	Notes
Visible Pieces								
1	Required	Lower Housing	S1.2 Lower Housing - no supports	0.2mm layers, pause at 7.0mm to insert nut	75	7	1 color, any	
2	Required	Upper Housing	S1.2 Upper Housing - no supports	0.2mm layers, color change at 0.8mm and 1.6mm	28	3	2 colors - main, accent, main	
3	Required	GPS window	S12 GPS window	0.1mm layers, color change at 0.4 and 0.8 and 1.5	1.2	0.3	3 colors - main, transparent, accent, main	
4	Required	Record Window	S12 REC window	0.1mm layers, color change at 0.4 and 0.8 and 1.5	0.8	0.3	3 colors - main, transparent, accent, main	
5	Required	Tail Lights window	S12 tail lights window	0.1mm layers, color change at 0.4 and 0.8 and 1.5	0.4	0.3	3 colors - main, transparent, accent, main	
6	Required	SD Card Swing Door	S12 sd card swing door	0.2 mm layers	1	0.5	1 color, solid	
7	Optional	UID Side Tag	UID side tag	0.1 mm layers	1.2	0.1	2 colors - main, accent	
Internal Pieces								
1	Required	Qwiic Buzzer Retainer	S12 qwiic buzzer retainer	0.2mm layers	0.5	0.15	any, not seen	
2	Required	Clock Spacer	S12 clock spacer	0.2mm layers	1	0.1	any, not seen	
3	Optional	Battery Space	S12 battery spacer	0.2mm layers	4	0L75	any, not seen	
4	Optional	Aux Sensor Retainer	S12 aux sensor retainer	0.2mm layers	0.4	0.1	any, not seen	
instrument build platform and parts								
1	Recommended	Assembly Fixture	S12 assembly fixture	0.2mm layers, with supports on build plate	84	7.5	any, not seen	custom made work platform for protoboard
2	Recommended	SD Card Alignment Fixture	S12 sdcard alignment fixture	0.2mm layers	1.5	0.1	any, not seen	attach to assembly board when soldering SD card breakout
3	Required	Coupler Alignment Flats (main board)	S12 magnet coupler alignment fixture for main body w flats	0.2mm layers	3	0.4	any , not seen	use when soldering couplers on main protoboard (black filament not recommended as it's hard to see with couplers)