FLOWLIS Stackable Jewelry Tray Set

A soft, organic take on everyday organization.
FLOWLIS trays are designed to store jewelry, keys, or small essentials.

Press the bottom insert firmly into the frame until it clicks into place — no glue needed.

Perfect as:

- Jewelry trays (rings, earrings, bracelets)
- Key trays for entryways
- Catch-all trays for everyday essentials

Each tray consists of:

- A **frame (outer shell) - 2 heights**
- A **click-in grid insert (bottom)**

Dimensions

- **Outer diameter:** 155 mm
- **Low version height:** 32 mm
- **Tall version height:** 47 mm

Materials (as shown)

- Bambulab Matte PLA **Dark Brown**
- Bambulab Matte PLA **Latte Brown**
- Bambulab Matte PLA **Dark Chocolate**
- Bambulab Matte PLA **Bone White**
- Bambulab Matte PLA **Desert Tan**

Important – Read Before Printing

To achieve the exact look shown in the photos (especially the textured exterior and visible grid bottom), **specific slicer settings and modifiers are required**.

✔ A detailed PDF with full setup instructions is included
✔ BambuLab-ready profiles are also provided

Following these settings is essential for the final result.

Printing Instructions

Global Settings

- **Layer height:** 0.2 mm
- **Infill:** 10% Gyroid

- **Only one wall on top surfaces:** Disabled

Infill Insert (Grid Bottom)

These settings intentionally expose the infill pattern to create the grid look.

- **Wall loops:** 6
- **Infill:**25%
  - Pattern: *Cross Hatch* or *Gyroid*
- **Top shell layers:** 0
- **Bottom shell layers:** 0

➡ This allows the infill to remain visible and functional.

Frame Settings (Texture / Fuzzy Skin)

The frames use **fuzzy skin** to create a soft, ceramic-like texture - applied only to selected areas.

To ensure proper stacking, the **bottom surface remains smooth** using modifiers.

How to apply modifiers:

1. Import Frame_low or Frame_tall into your slicer
2. Right-click the object → **Add Modifier**
3. Load:
   - Modifier_low or
   - Modifier_tall
4. In the **Objects tab**, select the modifier part
5. Apply fuzzy skin settings to the modifier only

Fuzzy Skin Settings:

- **Type:** Contour
- **Point Distance:** 0.4 mm
- **Thickness:** 0.5 mm

Need Help?

If you're struggling to get the settings right, feel free to reach out.

Send me:

- Your **printer type**
- Your **slicer**

I'll gladly help you dial everything in.

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Join the Community:

https://discord.gg/XsUfZeGGnM