TUTORIAL

If you have any more questions, contact me on my Instagram @simonauhrova3d, WhatsApp +420728674536 or email simonauhrova3d@gmail.com

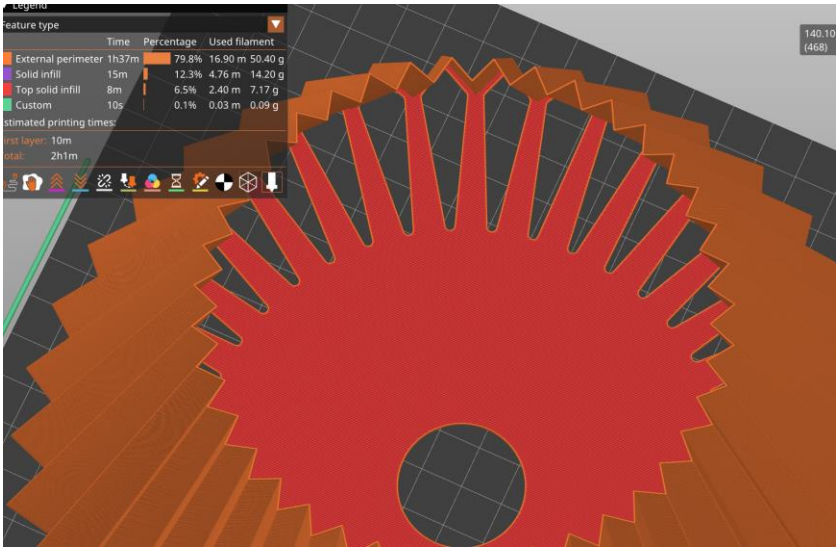
VASE MODE

Vase mode is a printing mode, that allows you to archieve smooth and seamless, time saving, single wall prints, that makes it ideal choice for a lampshade. To turn on this mode, go to print settings in your slicer and look for a VASE MODE or SPIRALISE OUTER CONTOUR keywords. Turn this mode on.

The issue of a vase mode can be a too thin and brittle shell. You can solve this by using larger diameter nozzle or use a standard 0.4 mm nozzle, but set a LINE WIDTH (EXTRUSION WIDTH) to 0.6 mm.

COMMON ISSUE

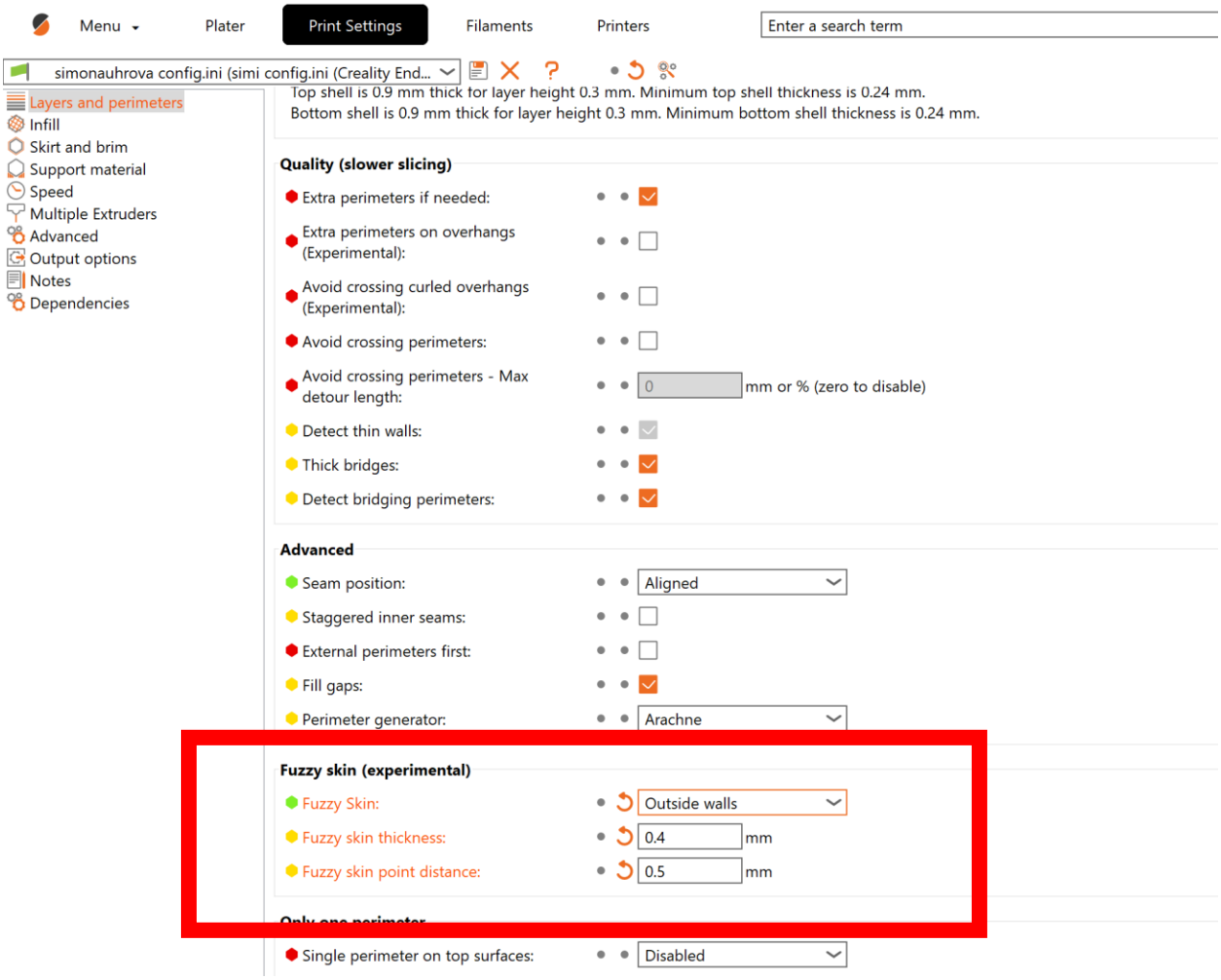
Once you slice your model in vase mode, you should still be able to see the openings in the bottom like this.



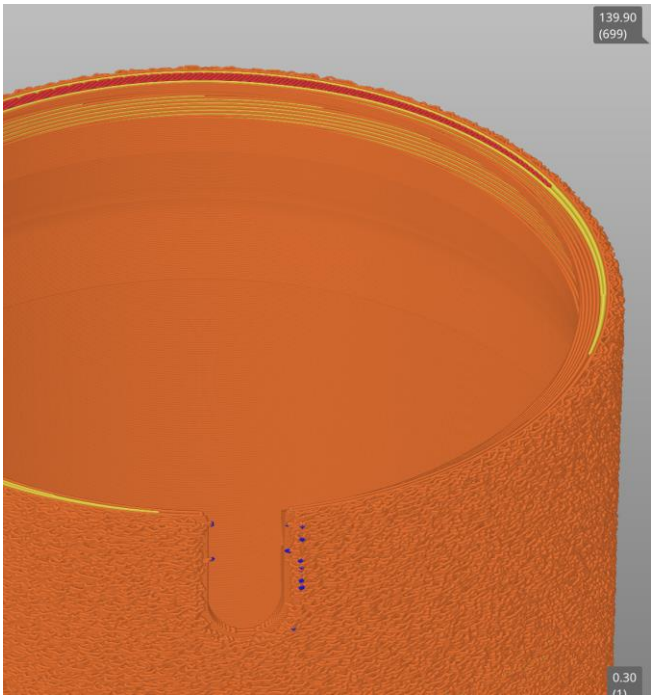
In some slicers, the holes disappear after slicing the model in vase mode. This is unfortunately caused by some of the slicers algorithms and only solution here is to use a different slicer. I successfully tested the model in Prusa slicer and Creality slicer. Cura slicer is known to not work.

FUZZY SKIN

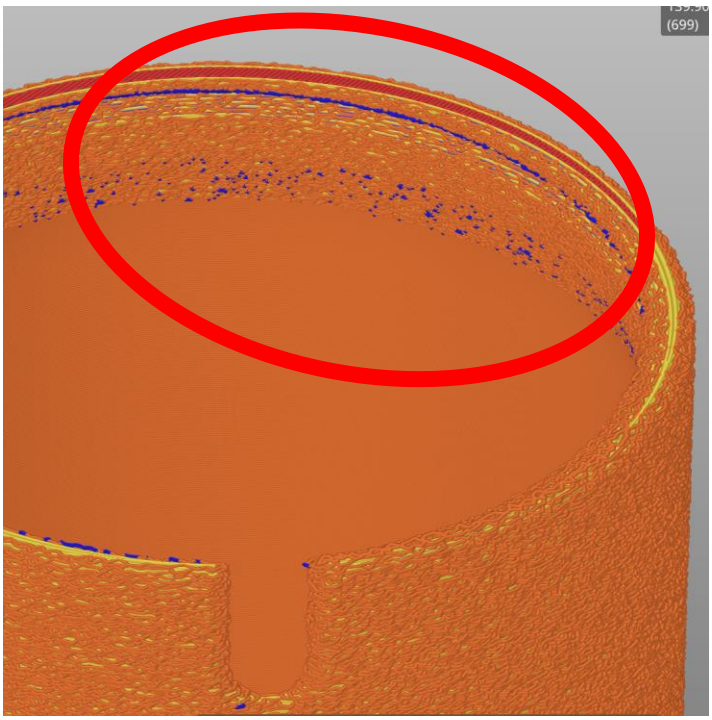
Fuzzy skin is a slicer function that creates a textured surface effect on printed models. Should be included in most of the slicers. I will show this on an example in Prusa slicer. Set the fuzzy skin on OUTSIDE WALLS ONLY.



Once you slice model, you should get a result similar to this:



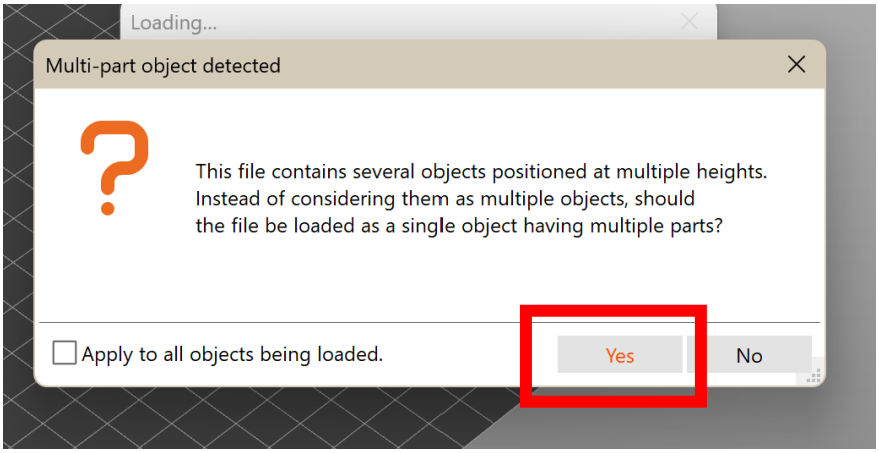
However, due to the algorithm, the fuzzy skin appears also in the thread and the inner ring, which would prevent the thread from running smoothly:



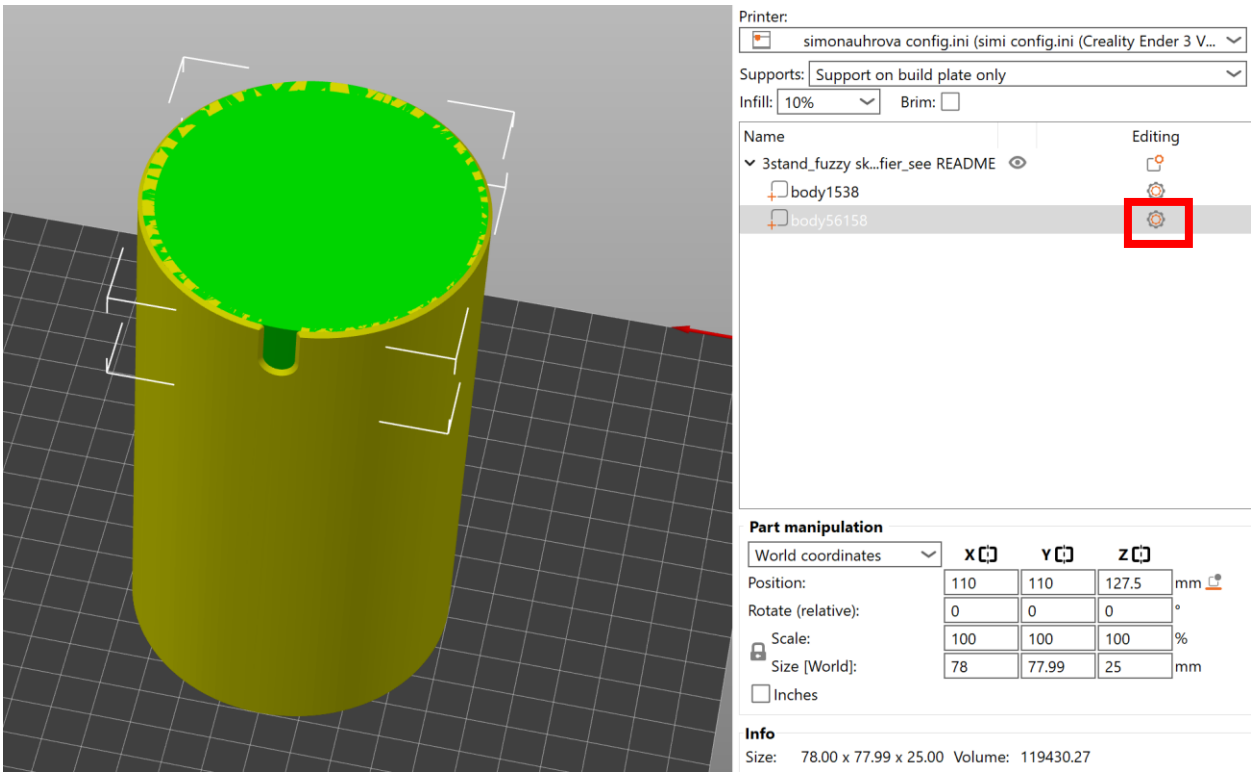
HERE IS THE SOLUTION:

Import a file Stand_fuzzy_skin in your slicer.

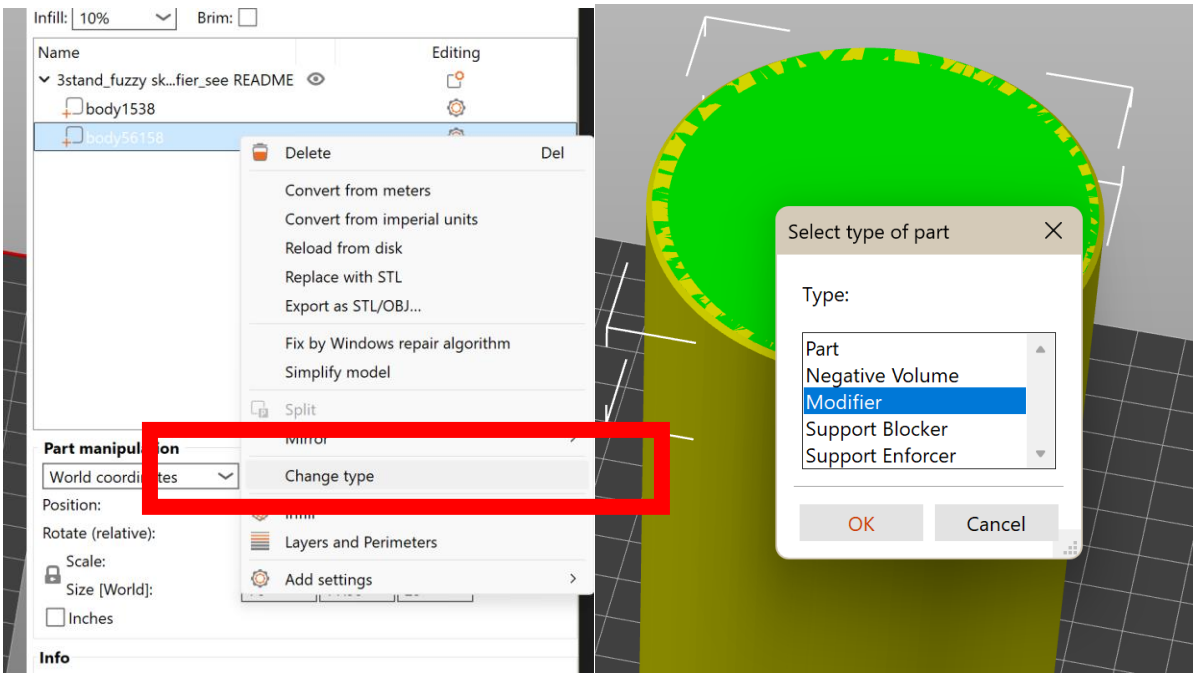
Select yes if asked to load as a single object with multiple parts.



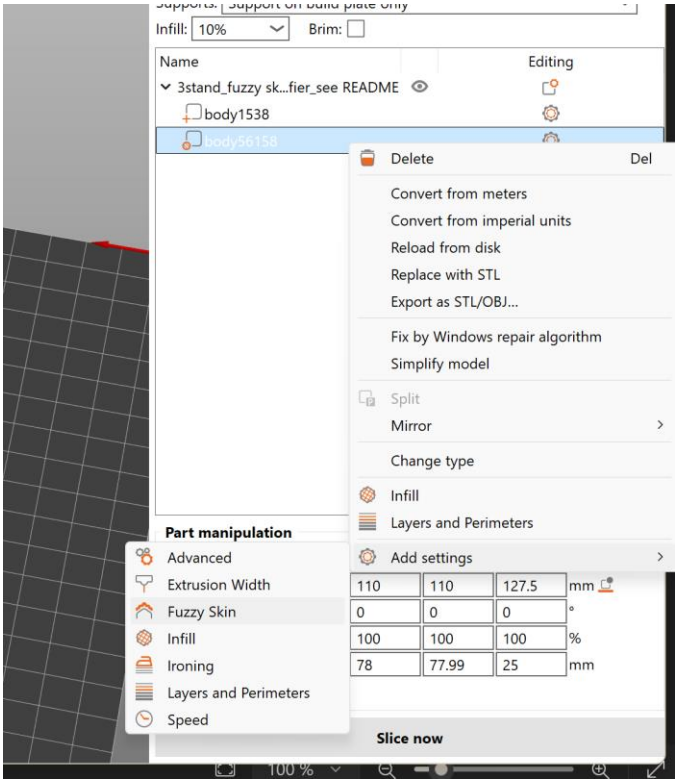
In the menu, you can see that the part has 2 bodies. Select the inside cylinder part (green in the picture) and click on the small settings icon next to it.



Click on change type and change the type to MODIFIER.



Once changed, click again on the settings icon and select ADD SETTINGS and then FUZZY SKIN.



Now add Fuzzy skin and click on the modifier body. In the bottom, change fuzzy skin to NONE:

