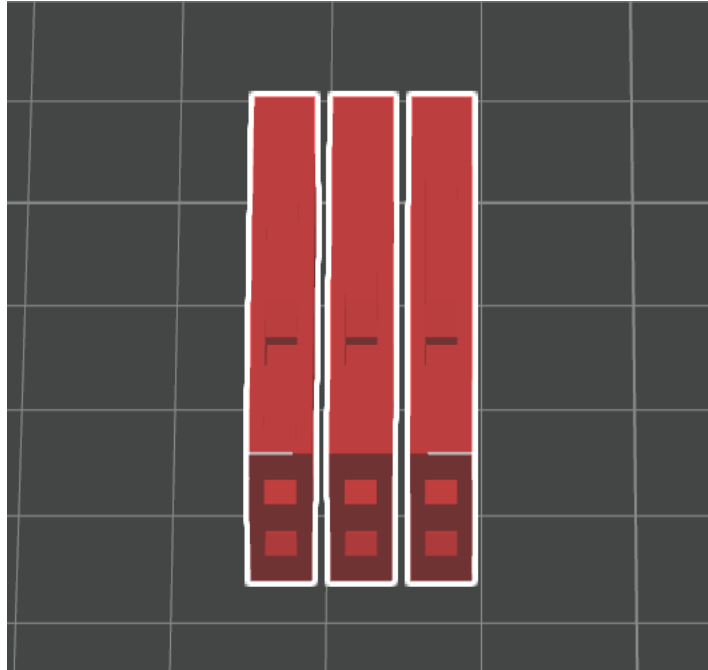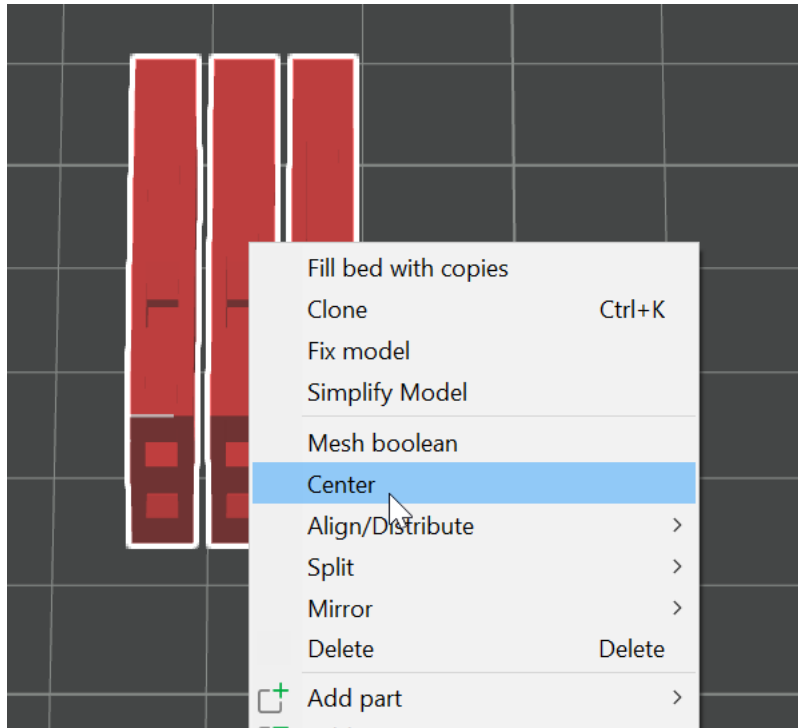Instructions for whistle stacking using the "ironing" function (Bambu Studio)

1. Position the whistle on its narrowest side.
2. Group your whistles to make sure you won't exceed 64 objects. For the A1 Mini using the Nano bitonal whistle, this is three.
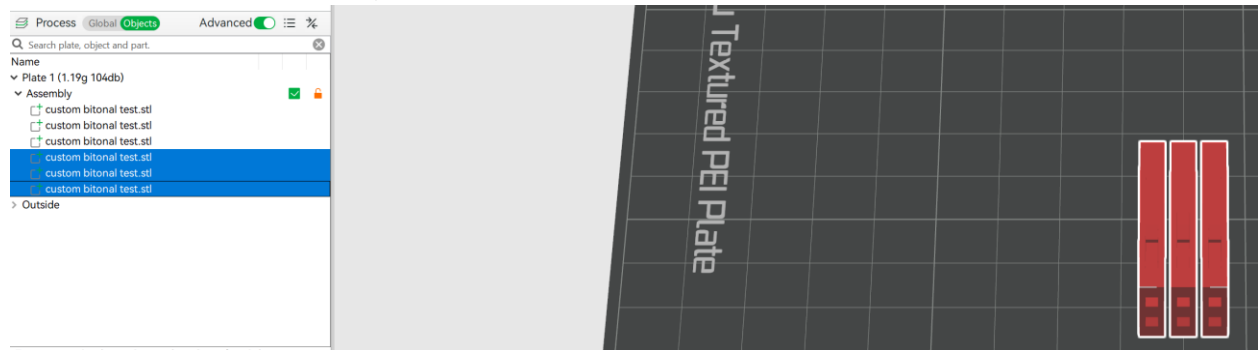
   a.

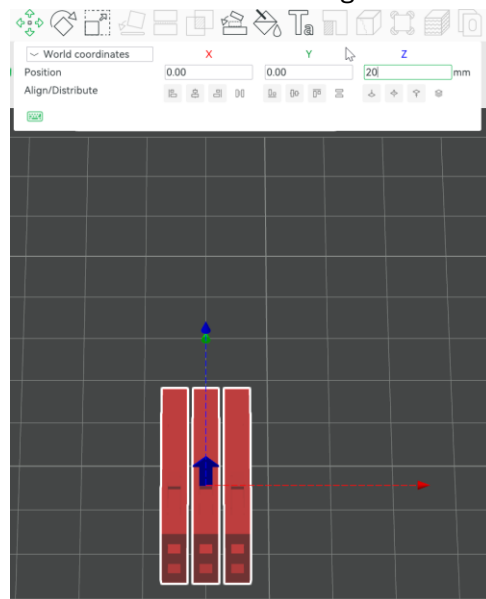3. Center the group from the right click menu

   a.

4. Copy and paste the group, then center it as well
5. Select all objects and merge them.

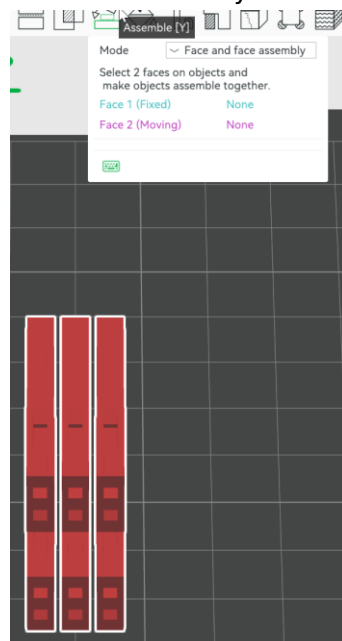6. Select three whistles from the left objects menu.

   a.

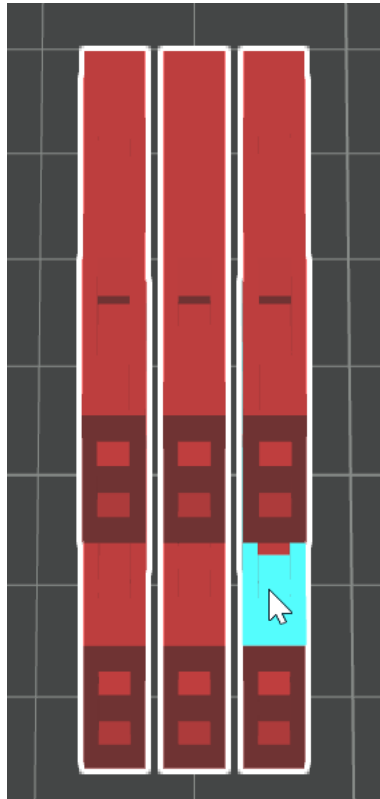7. Move them in the Z direction enough to distinctly separate the two sets.

   a.

8. Select the entire assembly and select the "Assembly" option in the toolbar
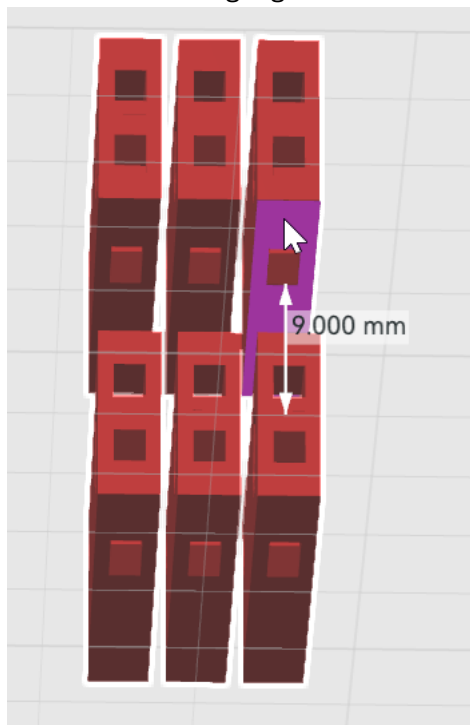

   a.

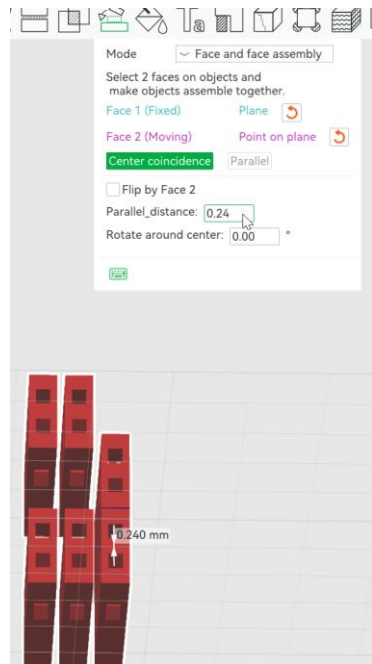9. Highlight and click the top of the bottom whistle (it will be blue)

a.

10. Rotate the selection so you can see the bottom of the top whistles and highlight the one directly above the blue highlighted one.
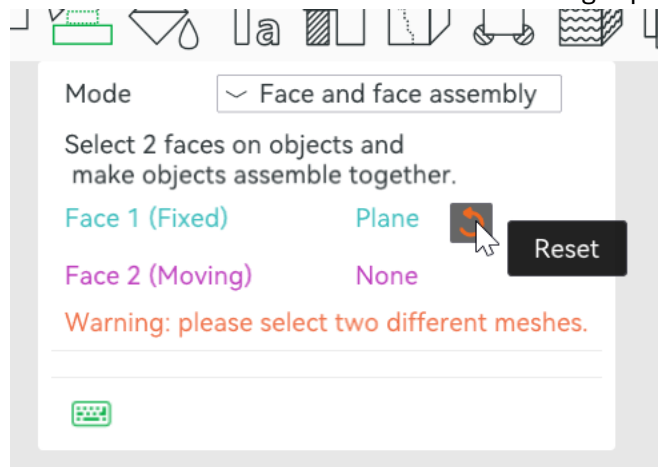

9.000 mm

a.

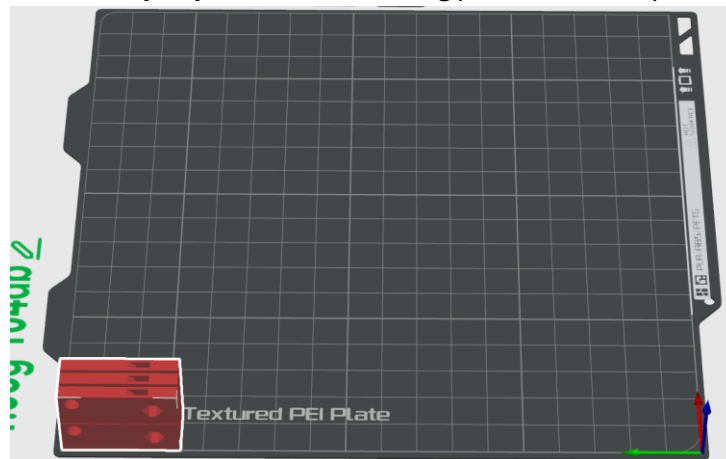11. Change the "Parallel_distance" to your slice thickness

a.

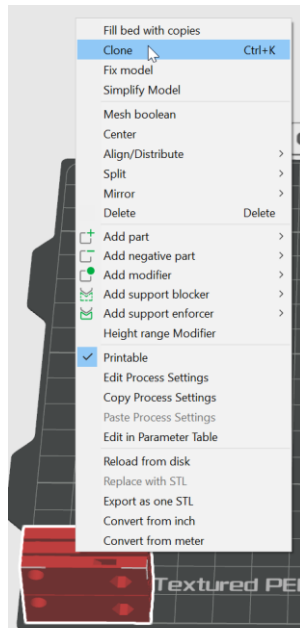12. Click the reset button for both the "Fixed" and "Moving" options

a.

13. Repeat this process for the rest of the rest of the whistles.

14. Move the assembly to your desired starting position on the plate
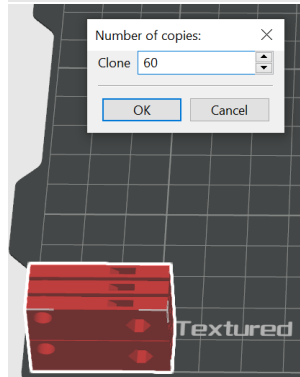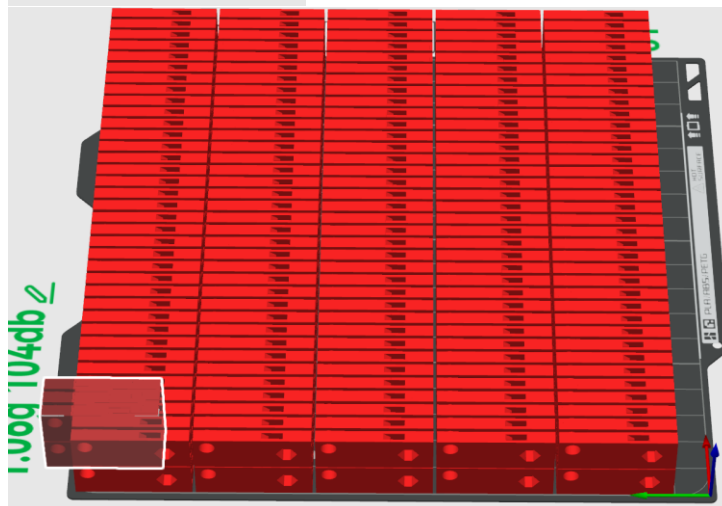

a.

15. Select "Clone" from the right click menu and enter the number needed to fill the plate. If you don't know, just enter a large number, the ones that exceed the plate boundary will stack next to the original object and can be deleted. For this model on the mini, this is 59 (total of 60 objects). I will enter 60 to demonstrate the ending layout.
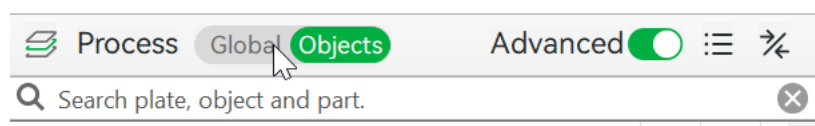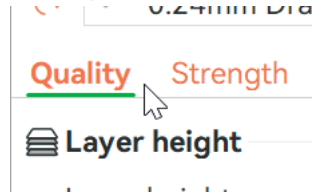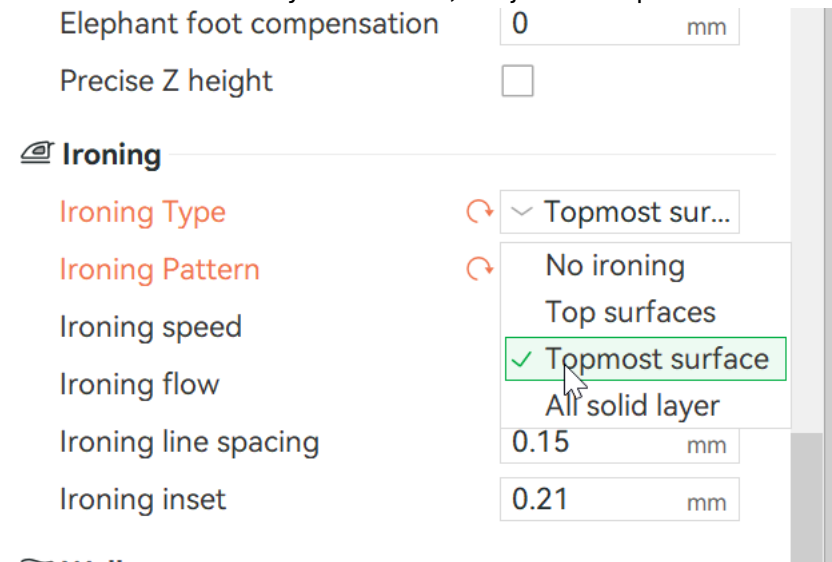
a.

b.

c.

     d. Adding more layers needs to be done one at a time using this same process.

16. Change the tool display from "Objects" to "Global"

    a.

17. Select "Quality"

    a.

18. Scroll down to "Ironing" and on the dropdown menu select "Topmost surface" ("Top surfaces" will have it iron every flat surface, not just the top of each whistle)

    a.

19. I change the ironing pattern to concentric but I don't know how much this helps on time, I choose it because it does increase speed when choses for printing surfaces.