

BAMBU LAB H2D AND H2S D3P RISER

PRINTING AND ASSEMBLY INSTRUCTIONS

PLEASE READ BEFORE STARTING

MODEL

These instructions are for the Bambu lab H2D-H2S D3P Riser.

VERSIONS

I may improve or modify certain aspects of the design. When I do I will indicate it in the model description and add a date to the uploaded files. It is a good idea to review the model files prior to printing to ensure you have the latest version.

IMPORTANT – PRINT SETTINGS

I upload a print setting files for all my models. The print settings has the parts positioned for correct printing

EACH BUILD PLATE HAS THE TYPE OF SUPPORT REQUIRED INDICATED ON THE BUILD PLATE DESCRIPTION (TREE AUTO, TREE MANUAL OR NO SUPPORT).

I strongly recommended you use my print setting file. If not, I will not be able to assist you if there is an issue when printing. From experience, many of the issues with printing my models are on account of users not using my print settings.

3D PRINT SETTINGS

I use the following settings and materials to print this model:

Infill % : 15% (no need for more)

Nozzle diameter: 0.4 mm

Layer height: 0.2 mm standard

Material: I am often asked the question about the riser deforming when using PLA when printing ABS or ASA. I prefer PLA since it cheaper to purchase and easier to print. I print all my risers in PLA but I seldom print in ASA or ABS. I have some users that printed in PETG and some in ABS. Both will also work providing your printer can maintain tolerances. PETG may be preferable if you intend on printing higher temp materials on a regular basis.

ASSEMBLY

My models are designed with tight tolerances. [Some light tapping may be needed for assembly.](#)

PROCEED SLOWLY. DOVETAIL JOINTS TIGHTEN AS THE PARTS MOVE FURTHER APART. IF THE JOINT GET VERY TIGHT VERIFY IF THE PARTS MOVED APART. IF SO, YOU WILL NEED TO TAP SLIGHTLY TO GET THE PARTS CLOSER TOGETHER. THIS IS OFTEN THE CASE WITH THE MAIN CABINET DOVETAIL JOINTS.

LID OPENING

The laser uses hall sensors to detect if the lid is closed. There are magnets embedded in the front right and rear left of the lid (not all models). You can see their location if you look at the magnets on the lid. If you do not use the laser then a simple fix is to disable "door opening" on the printer (printer settings - print options - uncheck "door opening").

However, this will not work with the laser. To use the laser, you can embed in the foam gasket where the lid rests two 2x5 mm (approx) magnets in the position where the lid magnets are positioned (front right and rear left - but validate for your model as I have the H2D and there is only a magnet on the front right).

I uploaded a printable STL to use as a template to locate the position of the magnets on the front right.

DISCOUNT CODES FOR PRINTER AND FILAMENT

I am in the process of obtaining discount codes from various manufacturers. Unlike many affiliate links these give discounts on purchases and are more difficult to obtain. In my requests I ask that they give me the codes with the most discounts for users even if it means a smaller commission.

Presently I have the following discounts codes available. They may not work with some discounted items.

\$10 off orders over \$100 | code: **Darren3dPrint10**

\$20 off orders over \$200 | code: **Darren3dPrint20**

\$30 off orders over \$400 | code: **Darren3dPrint30**

This can be used for any order worldwide.

Creality

\$60 off certain printers orders (K2 Pro and K2 Plus) | Coupon code: **Darren**

The code is limited to certain geographic regions.

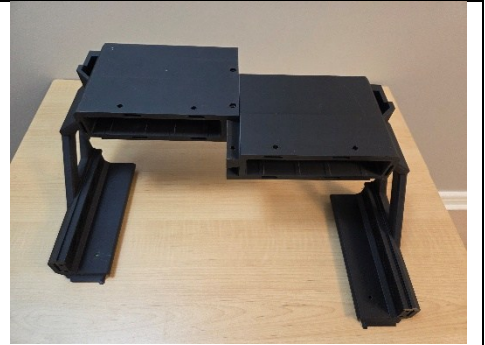
ASSEMBLY PHOTOS



1. Slide the two rear parts together



2. Slide them together until flush. Some light tapping may be required



3. Slide the middle parts together



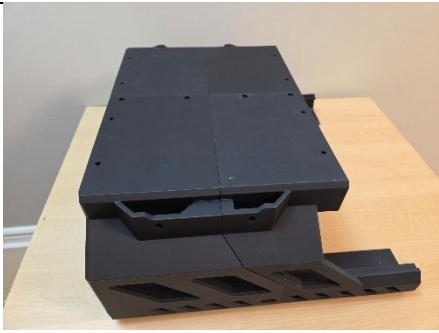
4. Slide them together until flush. Some light tapping may be required



5. Rear to middle pins.



6. Insert on each side of the rear parts as shown.



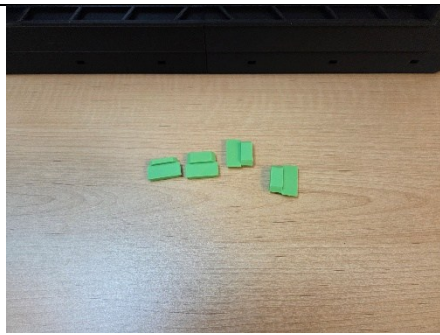
7. Slide the rear and middle parts together until flush. Ensure the bottom and top joints line up.



8. Dovetail pins



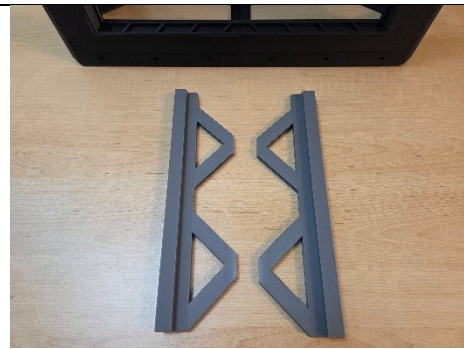
9. Insert the dovetail pins and tap them until flush



10. Lid holders



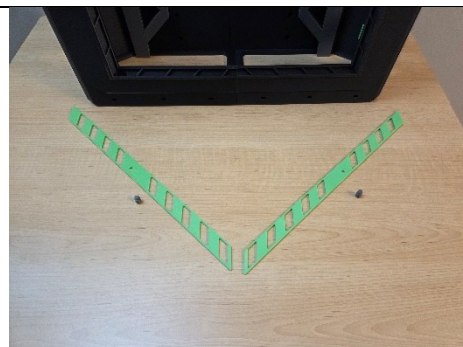
11. Insert the lid holders as shown



12. Build plate holders



13. Build plate holders.
Stops go at the back.
Insert as shown.



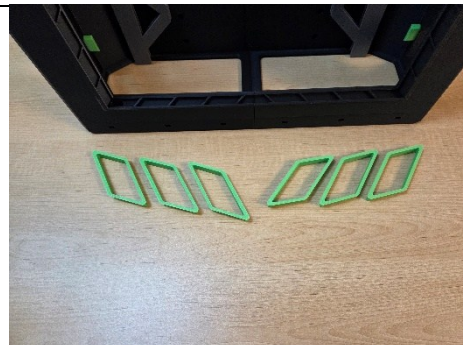
14. Right and left vent inserts



15. Insert the vent insert as shown. The larger end goes at the back



16. Thread in the screw.
Threading is easier if you
break in the thread
before inserting.



17. Side inserts



18. Install as shown



19. Drawer stops



20. Insert in the notch on each
rear piece



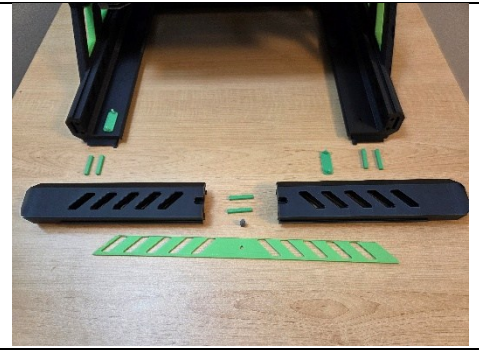
21. Front frame



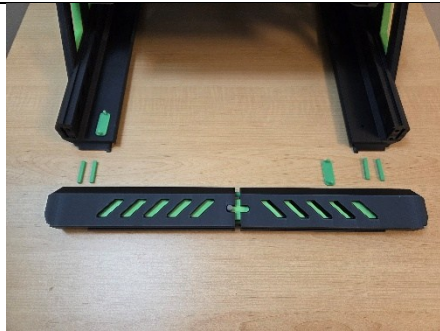
22. Front infill. Slide the two front infills together



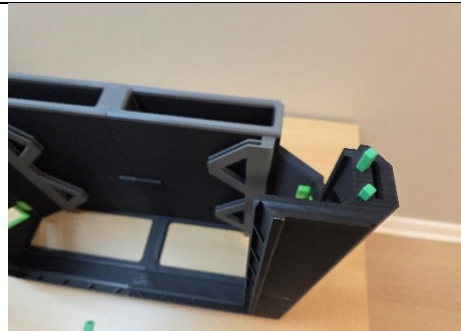
23. Install as shown



24. Front parts.



25. Insert the 2 front pins, the front vent insert and thread on the screw



26. Insert the 2 pins on each middle part.



27. Install the front part as shown



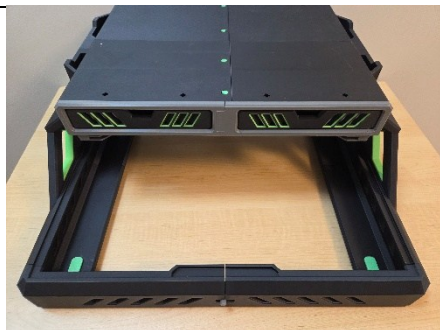
28. Install the connector on each inside corner



29. Drawers



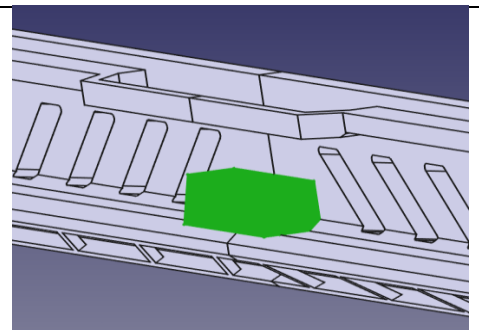
30. Install the drawer face on the drawer



31. Install the drawers

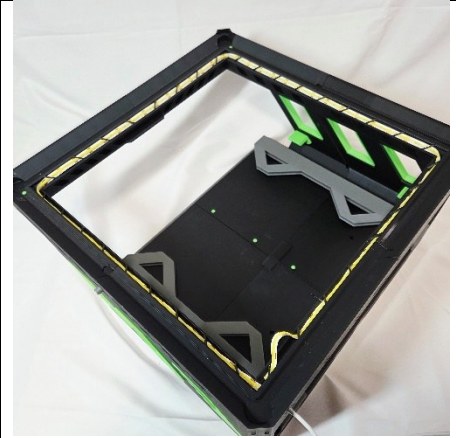


32. AMS stops. Install the 4 AMS stops as shown



33. Install the front to front clip

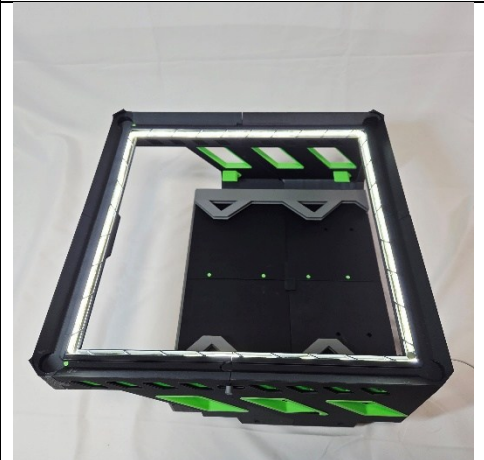
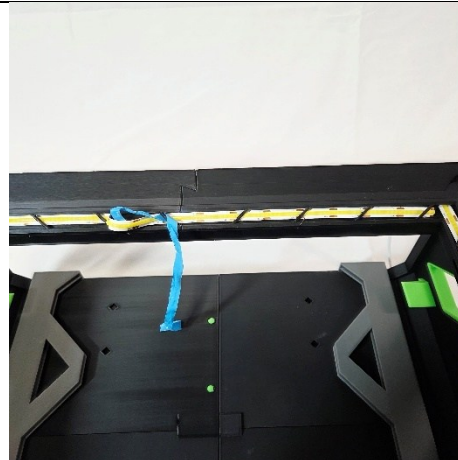
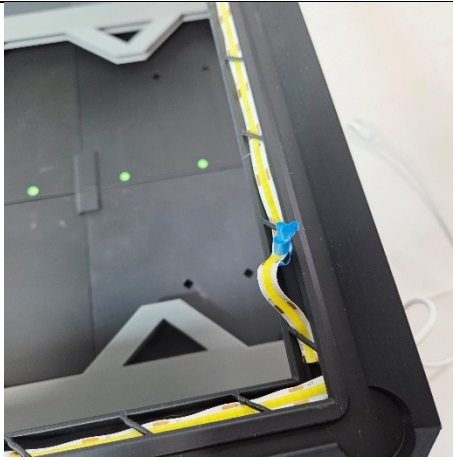
LED INSTALLATION



1. LED installation – I recommend COB leds – 5V with USB connector. 2m length is sufficient. (available on Amazon in multiple colors). Look for one with a long USB to LED cable.

2. Insert the LED through the rear LED cutout and thread the LED around the inner base of the riser.

3. Remove a small section of the adhesive backing at the end of the LED COB cable and press to glue the led COB in place.



4. Push the led cable to form a bulge and pull back on the adhesive backing. Pull back on the led cable to stick it in place. Grab the blue backing on the other side of the cross-support and pull it through (needle nose pliers help).

5. Repeat all around.

6. Test the Led lighting

OPTIONS

Some components are optional:

1. AMS Stop-drawer stop: This part not only acts as a stop for the AMS but also limits the drawer movement so it does not go all the way out. It replaces the AMS stop part.
2. Small Pins. There may be some variance in size due to filament etc. These pins have a slightly smaller diameter to make installation easier.

ADD-ONS

There are a number of add-ons available for the D3D riser and more will be added. I will add links to the add-ons on the D3D riser model page and will update these as more add-ons are added.

INTELLECTUAL PROPERTY

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A PATENT HAS BEEN FILED FOR THE D3D RISER DESIGN AND IT IS PATENT PENDING.

I thank you for your understanding.

TROUBLESHOOTING

All parts and the assembly have been tested multiple times (both printing and assembly).

- Make sure your build properly cleaned and free of grease and oils before printing. This is the cause of adhesion.
- Make sure you use my print profiles/settings (the .3mf file that has multiple plates with all the parts) and that you enable support as indicated for each build plate on the build plate description.
- Filament and printer will affect tolerances however all should fit. If unsure proceed slowly and cautiously.
- If there are any changes I list them in a changelog on the model page. Please have a look at it prior to printing in the event there are any changes.

I am available to assist with any issues with this model.

The best way to reach me is through Facebook messenger – my user name is “**Darren 3d print**”.

Lastly, I wish to thank you for your support and hope that you enjoy the model.