

P2S Toolbox XL with

This toolbox from Lars Melzer is really nice. I had to modify it a little bit so I could print it with a 0.6mm nozzle. While doing that, increasing objects heights etc, I also made the bambulab logo a bit smaller and aligned it with the P2S Toolbox text.

Original:

“

There are many boxes for printer accessories - but this one is mine ?

The H2D / H2S / P2S XL tool and accessory box combines modern design with maximum functionality. It offers a clever solution for neat and stylish storage of the included tools, small parts, and accessories.

There is space for the accessories in their original blister packaging, which comes with the H2D / H2S / P2S. Additionally, I have a layer for six hotends, three silicone socks, and an extra small compartment.

<https://makerworld.com/en/models/1403748-h2-p2-xl-tool-and-accessory-box-snaplock-box?from=search#profileId-1456243>

My version is available here as an attachment.

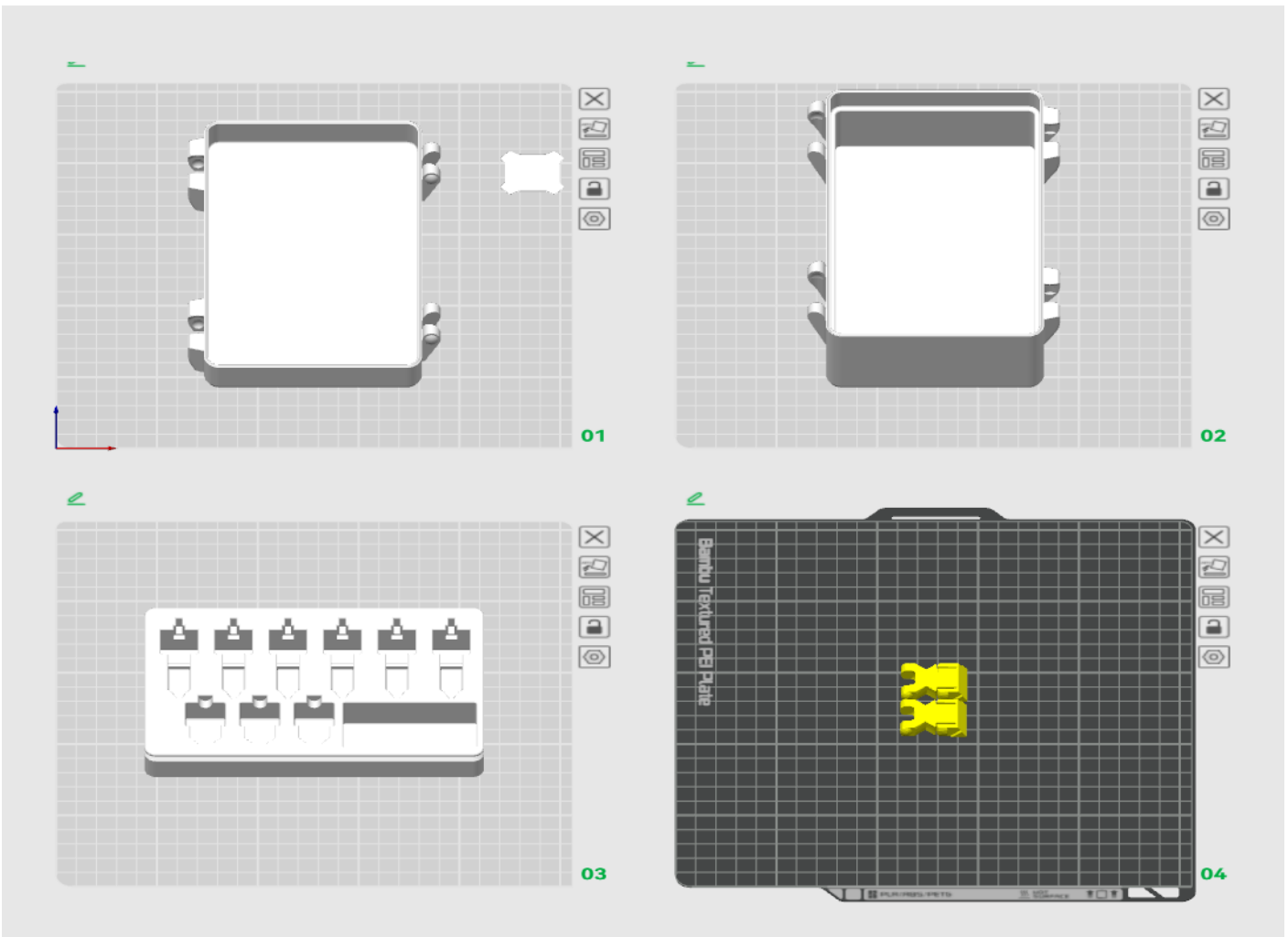
[P2S+Toolbox+XL+multiple+print+plates+for+0_6mm+nozzle.zip](#)

| Filament | Model | Flushed | Tower | Total |
|----------|---------------------|------------------|------------------|----------------------|
| ■ 1 | 95.00 m 283.36 g | 0.09 m 0.26 g | 0.04 m 0.11 g | 95.13 m 283.72 g |
| ■ 2 | 0.31 m 0.92 g | 0.05 m 0.14 g | 0.03 m 0.09 g | 0.38 m 1.14 g |
| ■ 3 | 4.52 m 13.47 g | 0.19 m 0.56 g | 0.05 m 0.15 g | 4.75 m 14.18 g |
| Total | 99.83 m 297.74 g | 0.32 m 0.96 g | 0.11 m 0.34 g | 100.27 m 299.05 g |

Total cost: 8.97

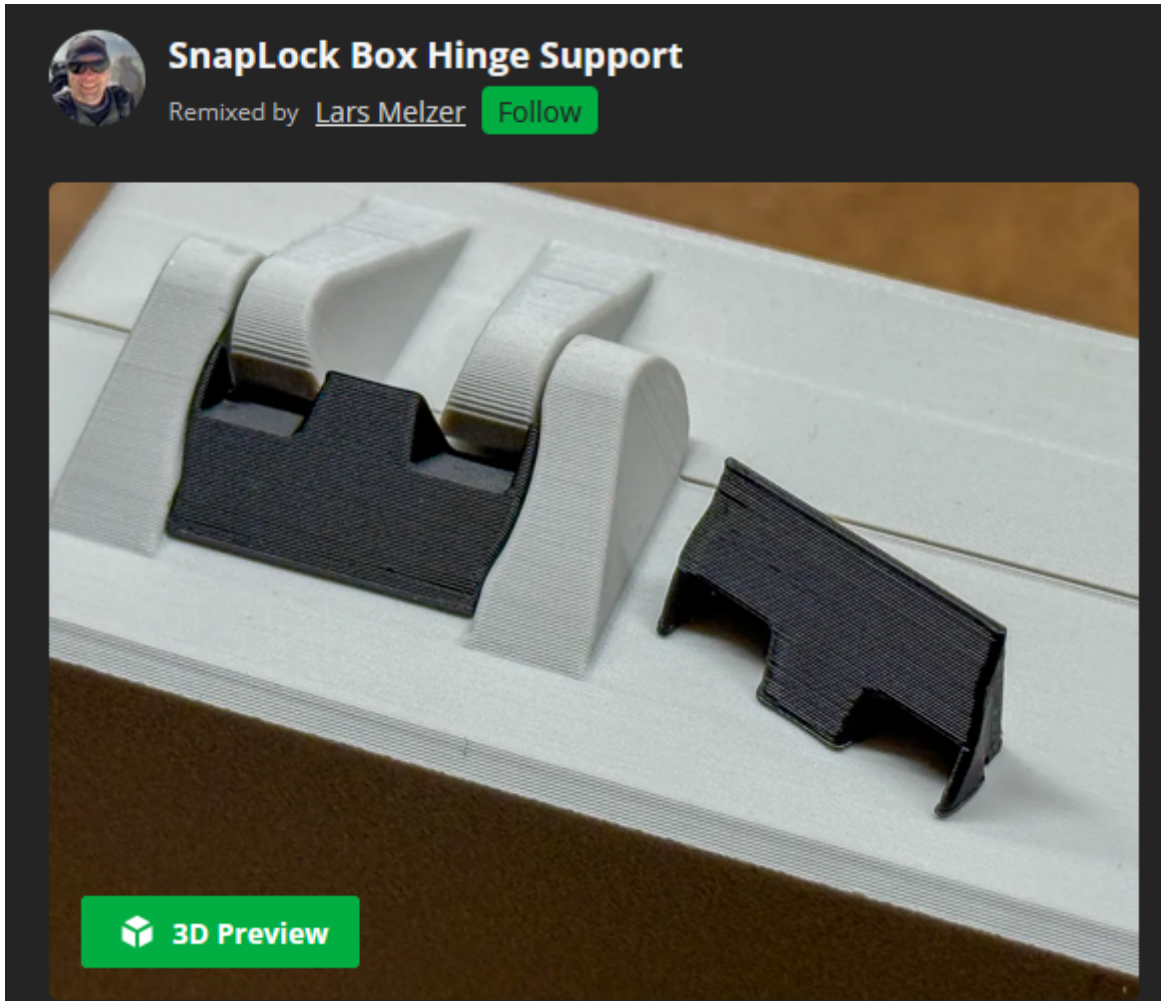
Time Estimation

| | |
|---------|--------|
| Plate 1 | 1h48m |
| Plate 2 | 2h50m |
| Plate 3 | 2h42m |
| Plate 4 | 17m51s |
| Total | 7h38m |



Improvement

Maybe I should print a pair of these???



Changes to the print profile

Things not visible have not been changed

Quality

Process **Global** Objects Advanced ☰ 🔍

↻ 📄 🔍



Quality Strength Speed Support Others



☰ **Layer height**

| | | |
|----------------------|-------------------------------------|----|
| Layer height | <input type="text" value="0.24"/> | mm |
| Initial layer height | ↻ <input type="text" value="0.24"/> | mm |


☰ **Line width**


Strength

Process **Global** Objects Advanced  

↻  


Quality **Strength** Speed Support Others

 **Walls**

Wall loops 

Embedding the wall into the infill

Detect thin wall

 **Top/bottom shells**

Top surface pattern

Top shell layers

Top shell thickness mm

Top paint penetration layers


Bottom surface pattern


Bottom shell layers

Bottom shell thickness mm


Bottom paint penetration layers

Internal solid infill pattern

 **Sparse infill**

Sparse infill density  %

Fill multiline

Sparse infill pattern 

Length of sparse infill anchor

Speed

↻ * 0.24mm Balanced Quality @BBL P2S 0.6 nozzle 📄 🔍

Quality Strength **Speed** Support Others



🔗 **Initial layer speed**




Initial layer mm/s
Initial layer infill mm/s

🔗 **Other layers speed**


Outer wall mm/s
Inner wall mm/s
Small perimeters mm/s or %
Small perimeter threshold mm
Sparse infill mm/s
Internal solid infill mm/s
Vertical shell speed mm/s or %
Top surface mm/s
Slow down for overhangs
 mm/s 10%

Support

Process Global Objects Advanced  

Quality Strength Speed **Support** Others

 **Support**

Enable support

Type

Style

Threshold angle °

On build plate only

Support critical regions only

Remove small overhangs

Others

Process **Global** Objects Advanced ☰ 🔗

↻ 📄 🔍

Quality Strength Speed Support **Others**

📄 Bed adhesion

| | |
|-----------------|---------------------------------------|
| Skirt loops | <input type="text" value="0"/> |
| Skirt height | <input type="text" value="1"/> layers |
| Brim type | <input type="text" value="Auto"/> |
| Brim width | <input type="text" value="5"/> mm |
| Brim-object gap | <input type="text" value="0.1"/> mm |

📄 Prime tower

| | |
|---------------|--------------------------------------|
| Enable | <input checked="" type="checkbox"/> |
| Skip points | <input checked="" type="checkbox"/> |
| Internal ribs | <input type="checkbox"/> |
| Width | ↻ <input type="text" value="25"/> mm |
| Max speed | <input type="text" value="90"/> mm/s |
| Brim width | <input type="text" value="Auto"/> mm |
| Infill gap | <input type="text" value="150"/> % |
| Rib wall | <input checked="" type="checkbox"/> |

Revision #3

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