

PRINT GUIDE

Coin-Reinforced Hat Brim Bottle Opener Clip

Print & assembly guide, embedding a coin mid-print for rigidity

This guide walks you through printing the hat brim bottle opener clip with a coin embedded inside it. A manual pause partway through the print lets you drop a dime into an exposed pocket, then the following layers close over it and lock it in place, no adhesive needed.

WHAT YOU'LL NEED

- **1 dime**, Canadian or American, either works
- **Standard PLA filament**, any brand
- Printer with **manual pause / layer-pause** capability
- **Pliers**, optional, for support removal

PRINT STEPS

- 1 Orient the model on the bed**
Place the model with the opener face down on the bed and the clip flipped up on top. This lines up a clean, flat layer partway through the print, exactly where the pause happens.
- 2 Turn on supports**
The clip has a large overhang and needs support to print cleanly. Honeycomb auto-supports were used, any support style that covers the overhang works.
- 3 Set a manual pause at layer 34**
Before slicing, add a manual pause at layer 34. This is where the coin pocket sits fully exposed and flat.
- 4 Drop the dime into the pocket**
When the printer pauses, drop the dime in flat, fully seated in the exposed pocket.
- 5 Resume the print**
The next layers close over the coin and lock it in place, no adhesive needed.
- 6 Remove supports**
After printing, use pliers to remove supports from the hard-to-reach areas of the clip if needed.

PRINT SETTINGS

- **Layer height:** 0.16mm, 0.2mm first layer
- **Infill:** 15–20%, grid
- **Perimeters:** 2
- **Supports:** Honeycomb, auto-generated
- **Print time:** ~1h 37m at 20% infill with full supports