

Print Guide

Ogee Bell lampshade with E27 fitter

2026-08-28 - tailored to this model

YOUR MODEL

Model summary

SHADE	Ogee Bell - 132 mm tall, O 78 bottom / O 136 top
WALL	1.6 mm watertight shell
FITTER	E27 (40 mm bore), 3 x Straight spokes, at bottom
RING HEIGHT	12 mm
LAYER HEIGHT	0.2 mm (5 layers per mm)

OPTION A - RECOMMENDED

Combined STL in Vase mode (one piece)

The whole lamp prints as a single spiralized piece. This works because the fitter sits at the BOTTOM: the slicer prints the first stretch fully solid (covering the bulb-holder ring), then switches to the single-wall vase spiral for the shade above - automatically.

CALCULATED FOR THIS MODEL

Bottom shell layers = 12 mm / 0.2 mm = 60 layers

At 0.2 mm layer height, 5 layers make 1 mm - so the 12 mm bulb-holder ring needs 60 solid bottom layers. Above layer 60, Orca continues in vase mode by itself.

Slicer settings (Orca / Bambu / Prusa / Cura)

FILE	lamp_combined.stl
MODE	Vase mode ON (Orca: "Spiral vase" - Cura: "Spiralize Outer")
BOTTOM SHELL LAYERS	60 (= ring 12 mm / 0.2 mm layer)
TOP SHELL LAYERS	0
SPARSE INFILL	0 %
SUPPORTS	None - the fitter web sits flat on the plate
BOTTOM SURFACE	100 % density, Monotonic

WHY THIS WORKS

In vase mode the slicer still prints "Bottom shell layers" as fully solid layers before starting the spiral. Setting them to the exact height of the bulb-holder ring makes the whole fitter print solid, and the shade above prints as a clean single-wall spiral. No supports, no seams, one continuous print.

OPTION B**Separate parts (best surface quality)****Shade - watertight shell**

MODE	Normal (Spiralize OFF)
WALLS / PERIMETERS	2
TOP SHELL LAYERS	0
BOTTOM SHELL LAYERS	0 (open bottom)
SPARSE INFILL	0 %
SUPPORTS	None

Fitter - bulb holder

MODE	Normal (never vase for a LONE fitter)
WALLS / PERIMETERS	3-4 (or 2 walls + 20 % infill)
TOP / BOTTOM LAYERS	3 / 3
SUPPORTS	None (designed flat)
SPOKE THICKNESS	4 mm = ~20 layers

VASE MODE AND THE LONE FITTER

A fitter printed ON ITS OWN must use normal mode - in vase mode a flat solid only prints its first few layers. Vase mode is fine for the COMBINED file (Option A), because there the fitter is covered by the solid bottom layers.

FINISH**Assembly & safety**

1. If printed separately: drop the fitter into the shade opening - the shade rests on its rim.
2. Thread the lamp socket through the hub ring and secure with the socket ring.
3. Fit an LED bulb (LED only - incandescent and halogen run far too hot for printed plastic).
4. Keep 30 mm or more between bulb and wall. Prefer PETG near any warmth.
5. Use rated lamp hardware - the printed fitter carries the shade, not the electricity.