



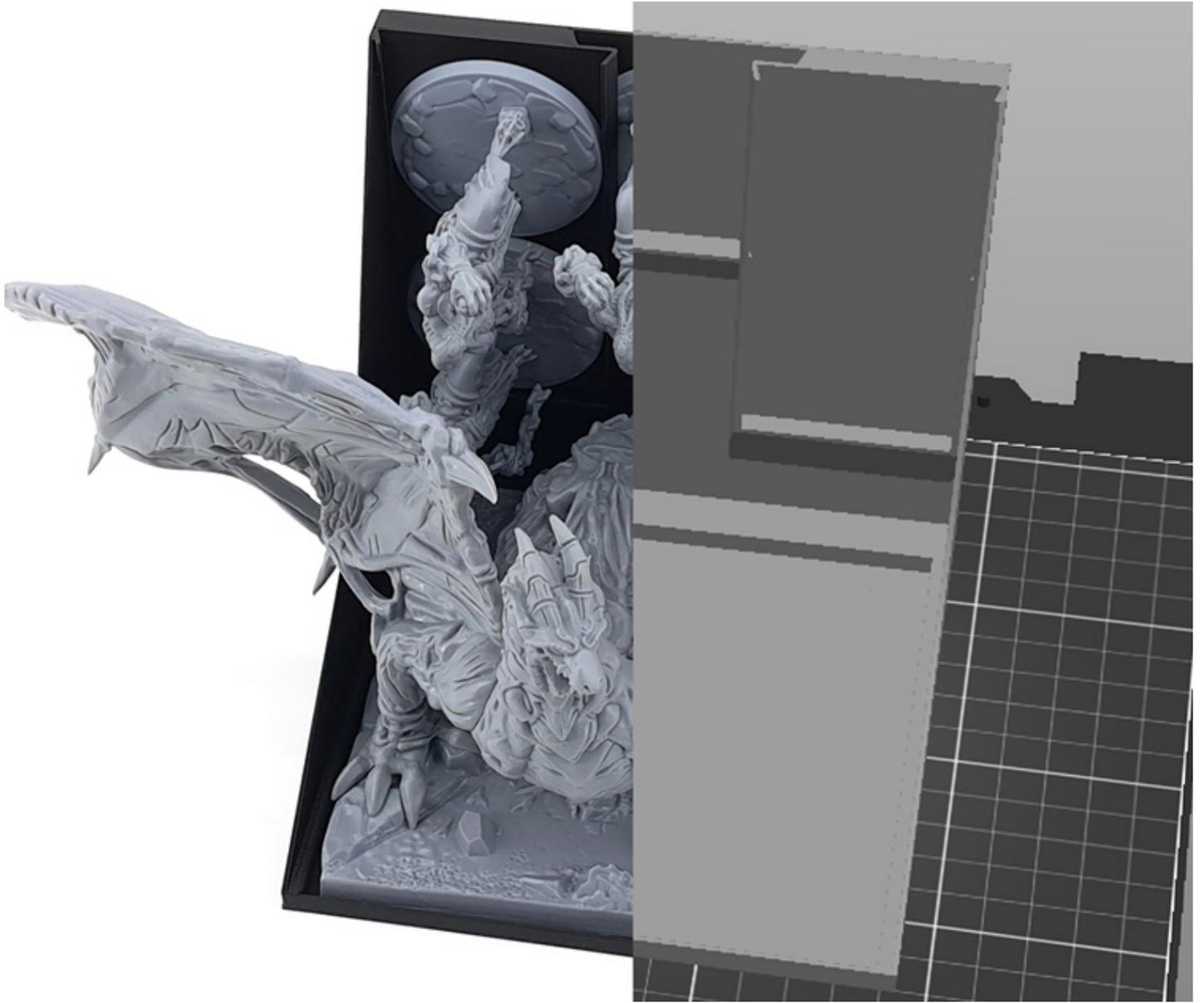
Tinkering Paws

BOARD GAME INSERTS



Discordant Stars

a Twilight Imperium: Fourth Edition Fan Expansion



See page **3** on how to
set up your insert...

... see page **10** on how to
set up your 3D printer ...

... or click here for a
[video instruction!](#)





List of Contents

1. 34 Faction Boxes
2. 1 System Tiles Box
3. 1 Token Box
4. 3 Card Boxes with Dividers

All boxes are marked with a code (M1, M2, etc.) on their bottom.





Faction Box **F1**

Each Faction Box **F1** holds all the game materials of the faction shown on the lid:
Command, Control and faction-specific Tokens, Starting Planet, Technology, Promissory Note, Leader and Mech Unit Cards.





System Tiles Box **ST1** Token Box **T1**

System Tiles Box **ST1** holds all System Tiles.
Token Box **T1** holds the few tokens that
are not faction-specific.





Card Boxes

Card Boxes **C1** (2x) hold the small cards.
Card Box **C2** holds the big cards.





Component Storage 2

Proceed with Card Boxes **C1** (2x) & **C2** and Token Box **T1**.





Component Storage 3

Then add System Tiles Box **ST1**.



How to print your digital files 1/2

General Settings

- **Nozzle Diameter: 0.4mm**
- **Filament: PLA**
- **Nozzle Temperature: 210 – 220 °C**
- **Height of first layer: 0.2 mm**
- **Height of other layers: 0.2 – 0.3 mm**
- **Number of perimeters: 2**
- **Infill: 20 %**
- **Supports: None**

File Information:

Every file needs to be printed once, except the filename says otherwise:

CS1x4.stl – print this part **four times**.

Print card dividers with a color change **after** 0.8 mm. This can be done with most slicers and does not require a multi-material printer.

All STL-files are already orientated correctly to print them.

Faction Lid Information:

Faction Lids require a color change **within** the first layer.

This can be done without a multi-material 3D printer, but it requires some adjustments. Make sure to read the next page!



How to print your digital files 2/2

How to print the Faction Lids

Add a second extruder in your slicer software. Add „M600“ as a Tool Change G-Code and assign the preferred colors to each part. These steps are valid for Prusa Slicer and might differ in other slicers

Additional Settings for Faction Box Lids

- **First Layer Extrusion Width: 0.35 mm**
- **Infill/perimeters overlap: 30%**
- **Elephant foot compensation 0.05 mm (or smaller)**

If you have trouble printing the faction icons and the following option is available in your slicer, try it:

- **Perimeter Generator: Arachne**

Available files

The files for the lids are available in three options:

- **Separate lid and icon for each faction**
- **One file with all lids and one file with all icon**
- **A single file with all lids and icons**

Cut/split the files if necessary and place the icons correctly „under“ the lids.

For questions or feedback visit www.tinkeringpaws.de

or write an email to info@tinkeringpaws.de

